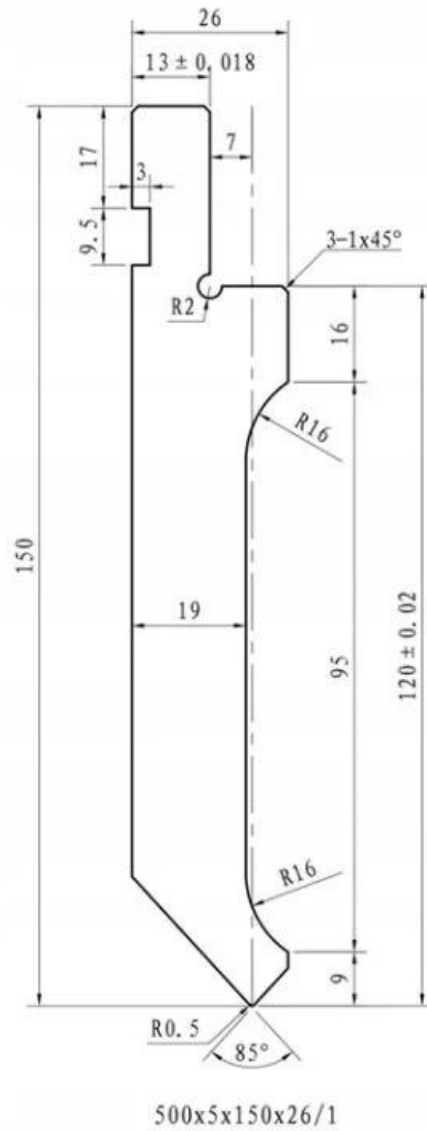


KARTA PRODUKTOWA

Digima die for the AMADA 500x150x26 5s L 2500mm press brake, 100–125T



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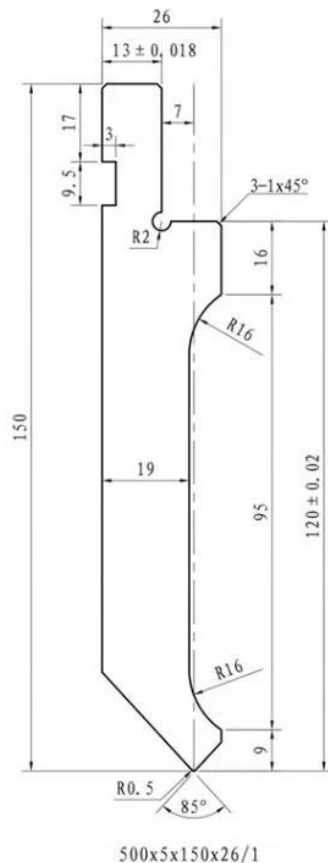
Digima die for an AMADA press brake, TYPE 500x150x26, 5 segments, L=2500mm, pressure: choice of 100T or 125T

We are pleased to present a high-quality Digima top die, designed for the precise bending of sheet metal on press brakes using the Amada clamping system. This tool is exceptionally versatile, being fully compatible with machines with working pressures of both 100 tonnes and 125 tonnes. It is manufactured from high-grade T8A tool steel, ensuring excellent structural stability and resistance to fracture under high loads.

The set, with a total length of 2,500 millimetres, consists of five precision-machined segments, each 500 millimetres long. A key factor in enhancing the punch's durability is the high-frequency induction hardening process applied to the working edge, which has achieved a hardness of HRC 45 $\pm$ 2 degrees. As a result, the punch tip retains its original geometry throughout thousands of bending cycles, ensuring perfect angle repeatability. The precision-ground tip, with an angle of 85 degrees and a radius of R 0.5 millimetres,



enables bends of the highest aesthetic quality.



Below is a complete summary of the stamp's technical data, taken directly from the design documentation:

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- **Edge chamfering:** type 1 chamfer at 45 degrees, applied at three points on the profile.
- **Vertical sections of the profile:** a straight upper section of 16 millimetres, a side section 95 millimetres long and a lower flange 9 millimetres high.
- **Tolerances:** tool parallelism and perpendicularity error less than or equal to 0.05 millimetres.
- **Joint accuracy:** error at segment joints less than or equal to 0.05 millimetres.
- **End edge finish:** the edges at the section joints (excluding the cutting edge) are rounded to a radius of R 0.5 millimetres.



Manufacturing standards and tolerances

- **Heat treatment:** high-frequency hardening of the cutting edge to a hardness of HRC 45 ± 2 degrees.
- **Fitting accuracy:** the error at segment joints when operating as a set (group interchangeability) is less than or equal to 0.05 millimetres.
- **Geometric tolerances:** the tool's parallelism and perpendicularity errors are maintained within limits of 0.05 millimetres or less.
- **End-face finish:** all edges at section joints, except for the cutting edge, are rounded to a radius of R 0.5 millimetres.
- **Set configuration:** total length 2500 mm, comprising 5 segments of 500 millimetres each.

*The photographs are for illustrative purposes only; the main image shows the cross-sectional shape of the tool as depicted in the technical drawing (without indicating the length), whilst the side view provides an example of what such a segment would look like in reality