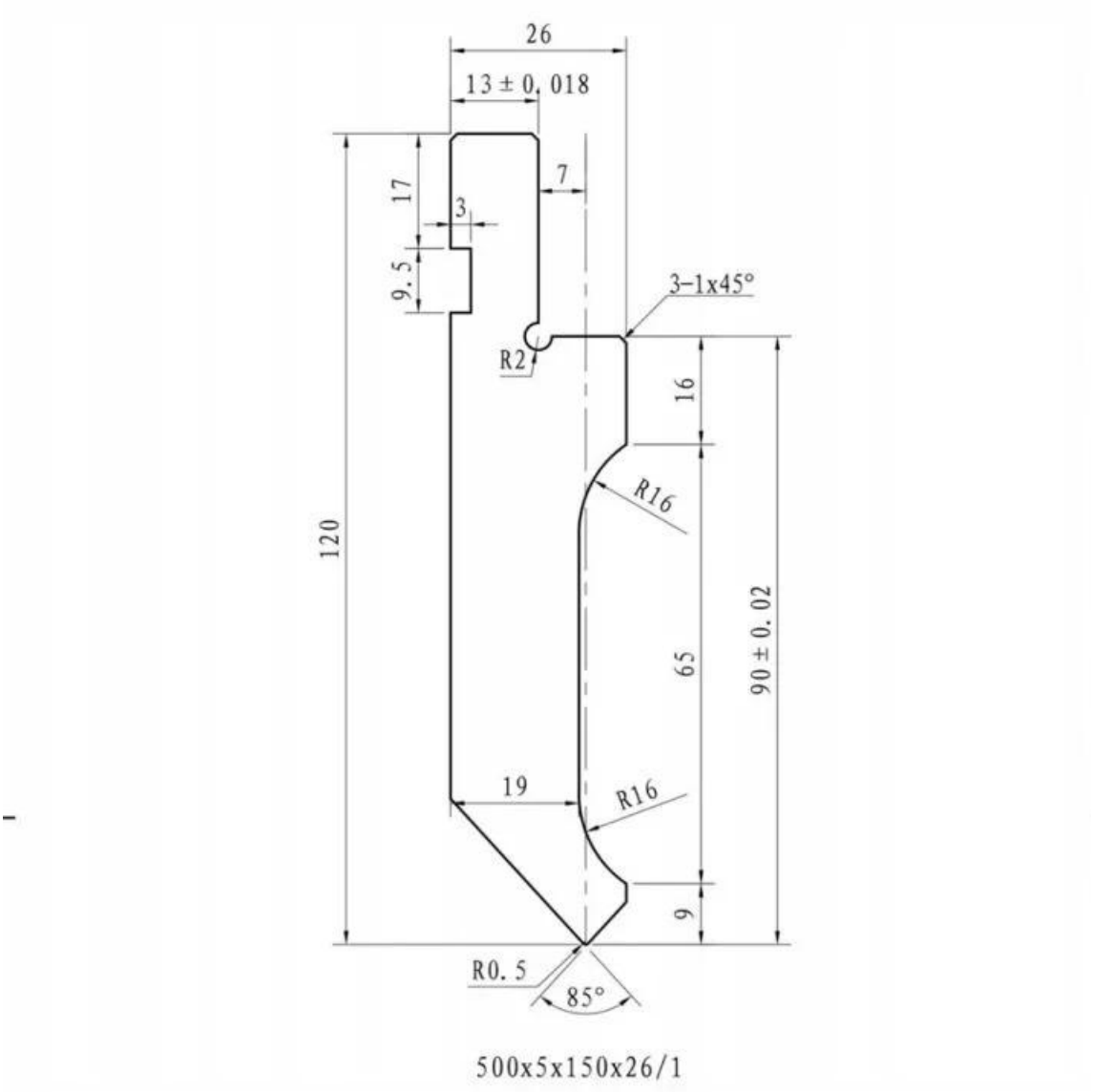
KARTA PRODUKTOWA

Digima die for the AMADA press brake, 500x120x26, 5 segments, L = 2500 mm, 40T



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Digima punch for AMADA press brake TYPE L = 2500x120x26, complete – comprising 5 segments of 500mm each

We present a technically advanced Digima upper die, designed for professional applications in the sheet metal forming industry. The tool has been designed to work with press brakes using the Amada mounting standard. The use of high-grade T8A tool steel guarantees excellent structural stability and resistance to fracture, even under high working pressures.

The set, with a total length of 2,500 mm, consists of five precision-machined segments, each 500 mm long, allowing the length of the bending line to be optimally adjusted to current production requirements. Each segment has undergone a rigorous high-frequency induction hardening process on the working edge, achieving a hardness of HRC 45 ± 2 degrees. Achieving such high hardness in the area of direct contact with the material significantly extends the tool's service life and ensures the repeatability of bending angles throughout its entire operational life. Precise grinding of the base surfaces and the 85-degree working edge ensures the highest quality bends without the risk of damaging the sheet metal surface.

Compatible with the **PBH-40-2500 press and others of these dimensions**

Detailed technical specifications and design requirements

Below is a complete summary of the punch's technical parameters, compiled on the basis of the design drawing and material specification:

Geometric and working dimensions:

- **Total tool height**: 120 millimetres.
- **Functional height (from the bending axis to the base plane)**: 90 plus or minus 0.02 millimetres.
- **Overall width of the punch**: 26 millimetres.
- **Body width at the working constriction**: 19 millimetres.
- **Apex angle of the cutting edge**: 85 degrees.
- **Radius of curvature of the working part (nose)**: R 0.5 millimetres.

Mounting and profile parameters:

- **Standard upper mounting dimension**: 13 plus or minus 0.018 millimetres.
- **Dimensions of the retaining slot**: height 9.5 millimetres with a cut-in depth of 3 millimetres.
- **Socket positioning**: distance of 17 millimetres from the upper edge to the socket plane and an axial offset of 7 millimetres.
- **Design radii**: radius R 2 at the socket and body profile radii of R 16.
- **Edge finish**: a 1-to-45-degree chamfer applied at three points on the profile.
- **Vertical section heights**: upper straight section 16 millimetres, middle side section 65 millimetres and lower foot 9 millimetres high.

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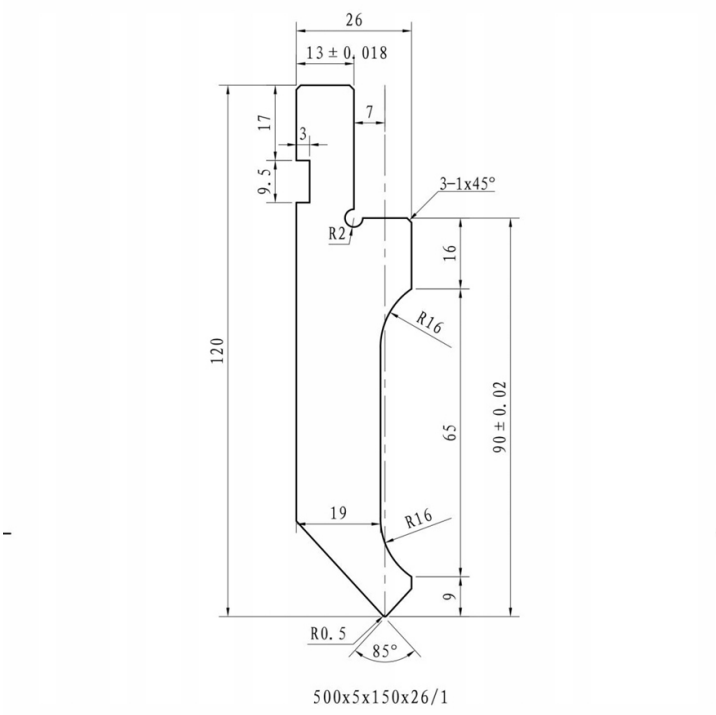

Accuracy and machining standards:

- **Heat treatment**: high-frequency hardening of the working part to a hardness of HRC 45 plus or minus 2 degrees.
- **Joint accuracy**: misalignment at segment joints when operating in a group less than or equal to 0.05 millimetres.
- **Geometric tolerances**: error in tool parallelism and perpendicularity less than or equal to 0.05 millimetres.
- **End finish**: the front edges of the segments (excluding the cutting edge) are finished to a radius of R

0.5.

- **Working length of the set**: L equals 500 millimetres times 5 pieces.

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