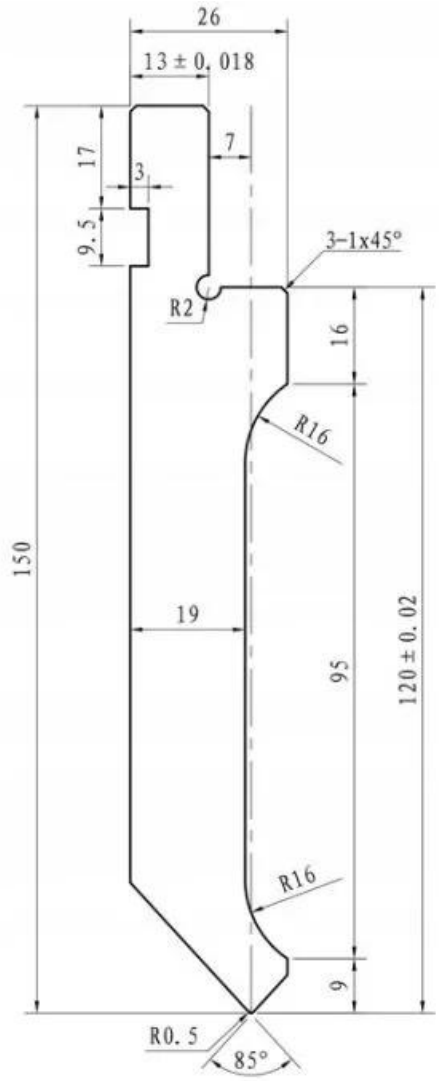
KARTA PRODUKTOWA

Digima die for the AMADA press brake 500x150x26, 4-segment, L 2000mm, 100–125T



500x4x150x26/1

KARTA PRODUKTOWA

Digima die for an AMADA press brake, TYPE 500x150x26, 4 segments, L=2000mm, pressure: choice of 100T or 125T

We are pleased to present a professional top die from Digima, designed for the precise bending of sheet metal on press brakes using the Amada clamping system. This tool has been developed with maximum versatility in mind – its technical specifications allow for trouble-free operation on both 100-tonne and 125-tonne machines. The die is made from high-grade T8A tool steel, which guarantees excellent dimensional stability and resistance to cracking during intensive industrial use.

The set, with a total length of 2000 mm, consists of four precision-machined segments, each 500 mm long. The key manufacturing process used in this model is high-frequency induction hardening of the working edge, which has achieved a hardness of HRC 45 ± 2 degrees. As a result, the punch nose retains its geometry throughout thousands of bending cycles, ensuring angle repeatability and minimising tool wear.

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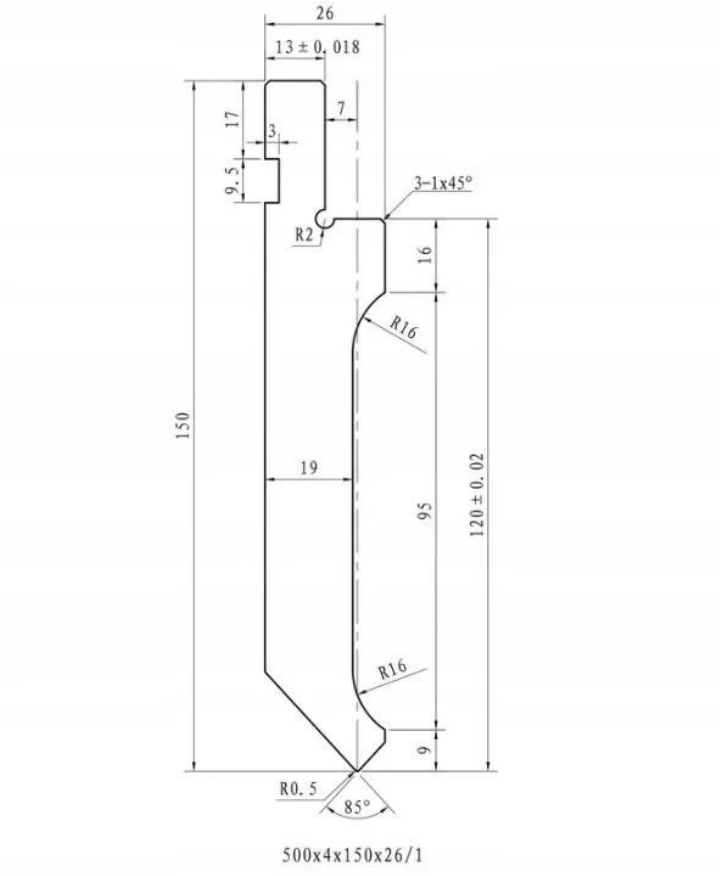
The precision-ground tip, with an 85-degree angle and a radius of R 0.5, enables bends of high aesthetic quality to be produced, without unnecessary material deformation.

Suitable for the **PBH-100x2000, PBH-125x2000 and other presses of similar dimensions**



Full technical specifications and design parameters

Below is a complete list of the stamp's technical specifications, compiled on the basis of the design drawing:

Punch Specifications:

- **Assembly length**: 2000 millimetres (4 segments of 500 millimetres each).
- **Total tool height**: 150 millimetres.
- **Working height (base plane to bending axis)**: 120 plus or minus 0.02 millimetres.
- **Overall width of the punch**: 26 millimetres.
- **Body width in the working section**: 19 millimetres.
- **Upper mounting dimension**: 13 ± 0.018 millimetres.
- **Punch cutting edge angle**: 85 degrees.

- **Radius of the working tip**: R 0.5 millimetres.
- **Dimensions of the safety recess**: height 9.5 millimetres with a cut-in depth of 3 millimetres.
- **Socket positioning**: 17 millimetres from the upper edge and an axial offset of 7 millimetres.
- **Design radii**: R 2 radius at the recess and R 16 radii on the body profile.
- **Edge chamfering**: type 1 chamfer at 45 degrees, applied at three points on the profile.
- **Vertical sections of the profile**: a straight upper section 16 millimetres long, 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 2000 mm, comprising 4 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