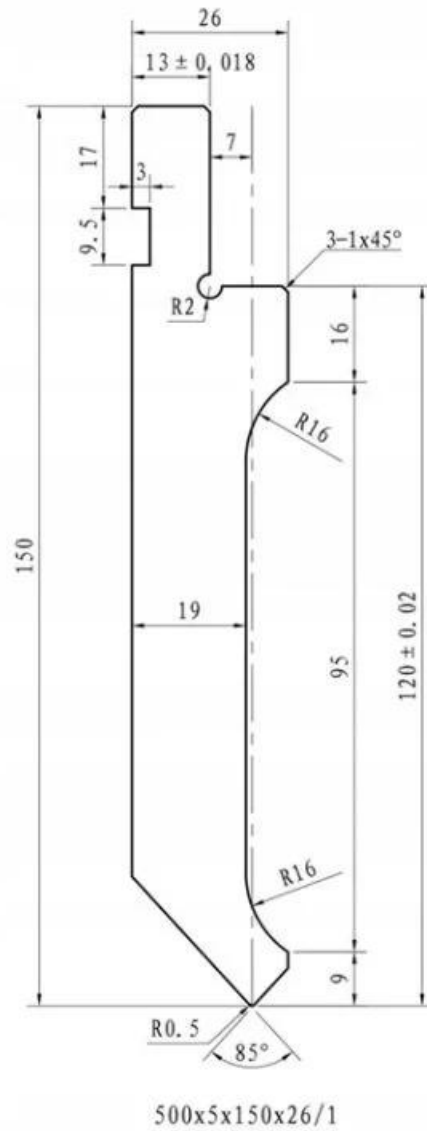


KARTA PRODUKTOWA

Digima die for the AMADA press brake, 500x150x26, 5 segments, L = 2500 mm, 160T



KARTA PRODUKTOWA



Digima die for an AMADA press brake, TYPE 500x150x26, 5 segments, L=2500mm, pressure: 160T

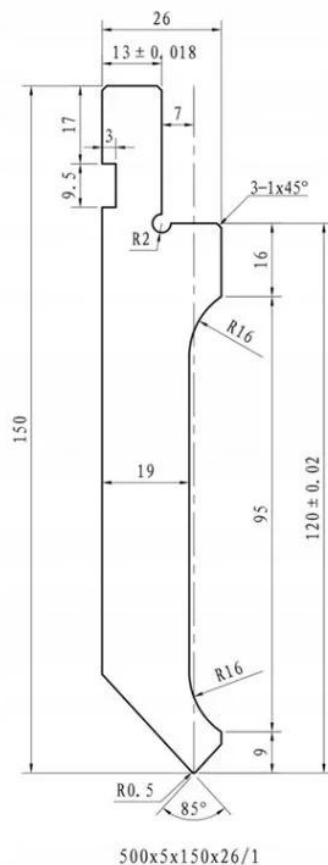
We are pleased to present a high-quality Digima upper die, designed for the precise bending of sheet metal on press brakes using the Amada clamping system. This tool is exceptionally versatile and is fully compatible with machines with a working pressure of 160 tonnes. It is manufactured from high-grade 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,

KARTA PRODUKTOWA

enables bends of the highest aesthetic quality.

Compatible with the **PBH-160x2500 press and others of similar dimensions**



Full technical specifications and design parameters

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

- **Assembly length:** 2,500 millimetres (5 segments of 500 millimetres each).
- **Total height of the tool:** 150 millimetres.
- **Operating 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 clamping dimension:** 13 ± 0.018 millimetres.
- **Punch cutting edge angle:** 85 degrees.
- **Rounding radius of the working nose:** 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.

KARTA PRODUKTOWA

- **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 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