





KARTA PRODUKTOWA



Digima multi-groove prism die for an AMADA press brake, TYPE 95x95x2000 mm, 100–125T

We are pleased to present a professional four-sided die (multi-groove prism) from Digima, designed for heavy-duty use on press brakes compatible with the Amada system. Following a detailed review of the technical documentation, we can confirm that the models designed for 100-tonne and 125-tonne machines are structurally identical. This means that the tool we offer guarantees the same precision and durability across both tonnage ranges, providing a versatile solution for advanced metalworking facilities.

The die features a four-sided design with a side length of 95 millimetres, which translates into exceptional rigidity and resistance to deformation under load. Thanks to its multi-slot design, the operator has a choice of different V-channel opening widths, enabling the machine to be quickly adapted to a specific task without the need for time-consuming changeovers. Each channel has been precision-finished by grinding to ensure repeatable bending angles along the entire 2000-millimetre length of the tool.

Compatible with the **PBH-100-2000, PBH-125-2000 and other presses of these dimensions**



Technical parameters and design specifications

Below is a detailed summary of the technical specifications for the multi-row die, compiled directly from the design documentation:

Overall and mounting dimensions:

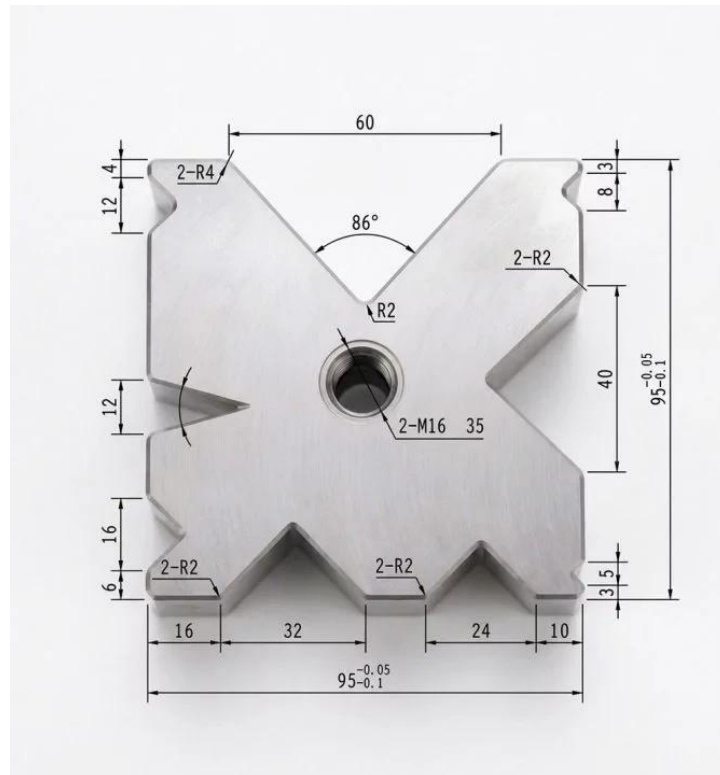
- **Total length of the tool:** 2000 millimetres.
- **Cross-section of the body:** a square with a side length of 95 millimetres.
- **Tolerance on the external dimension:** 95 millimetres, with a deviation ranging from minus 0.1 to minus 0.05 millimetres.
- **Clamping system:** the tool is fitted with two holes for M16 bolts, 35 millimetres deep, ensuring stable mounting in the press socket.

Geometry of working channels and V-grooves:

- **V-opening widths (selected channels):** the die offers a wide working range, including a large opening of 60 millimetres and smaller channels measuring 32 mm, 24 mm, 16 mm, 12 mm and 10 mm.
- **Bending angles:** for most grooves, the standard angle is 86 degrees. The die also features a specialised groove with an acute angle of 30 degrees.
- **Lead edge radii:** depending on the channel, working radii of R4 (for the largest groove) and R2 for the others have been used, which prevents the material from cracking during bending.
- **Processing undercuts:** relief channels (tool exits) measuring 2 by 2 millimetres have been machined

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into the bottoms of the working channels.



Standards of precision and finish

- **Manufacturing precision:** the error in parallelism and straightness of the die along its entire length does not exceed 0.05 millimetres.
- **End edge machining:** sharp edges at both ends of the die have been chamfered with a safe 5-on-45-degree chamfer.
- **Other roundings:** all radii not specified in the drawing are R 0.5 millimetres.
- **Body chamfering:** the outer edges of the tool are finished with a 1:45-degree chamfer at four points along the profile.

*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 how such a segment would look in reality