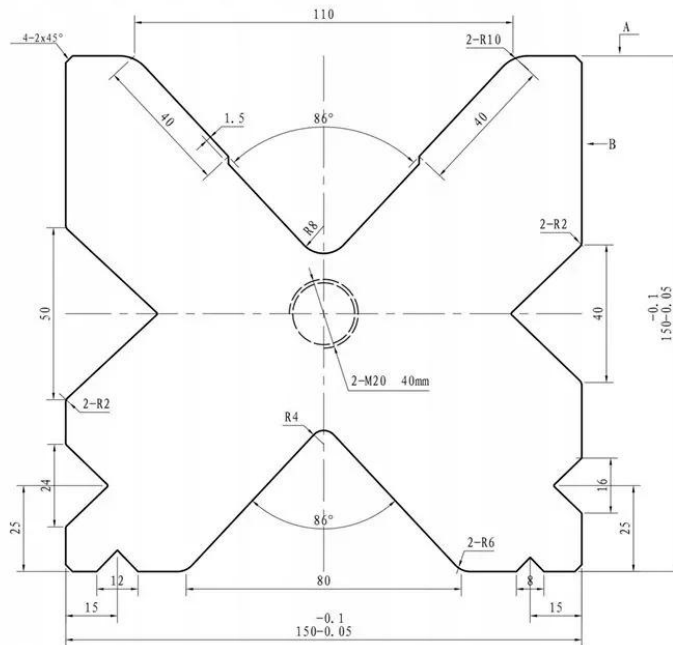






## KARTA PRODUKTOWA



### **Digima multi-groove prism die for an AMADA press brake, TYPE 150x150x4000 mm, 300T, M20**

We are pleased to present a professional Digima lower die with a four-sided design, engineered for heavy-duty use on press brakes utilising the Amada clamping system. This tool has been optimised for use with machines with a pressing force of up to 300 tonnes, enabling the precise bending of thick sheet metal whilst maintaining full process stability. Manufactured from high-grade T8A tool steel, it guarantees extreme resistance to compression and a long service life for the cutting edges, even during intensive industrial use.

The die features a universal multi-groove design with a cross-section of 150 by 150 millimetres, offering the operator access to a wide range of bending channels without the need to dismantle or replace the tool. The use of such a solid profile ensures excellent die rigidity, which directly translates into high angular repeatability and the elimination of tool deformation under high pressure. Each working channel has undergone precision grinding, which protects the surface of the material being bent and ensures a clean bend line along the entire length of 4,000 millimetres.

Compatible with the **PBH-300-4000 press and others 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 dimensions and tolerances of the body:

- **Total length of the tool:** 4000 millimetres.
- **Cross-sectional profile:** a square with a side length of 150 millimetres.
- **Tolerance on the external dimension:** 150 millimetres, with a deviation ranging from minus 0.1 millimetres to minus 0.05 millimetres.
- **Geometric precision:** the error in parallelism and straightness of the die along its entire length does not exceed 0.05 millimetres.

#### Geometry of bending channels and V-grooves:

- **Main upper channel:** a very wide opening measuring 110 millimetres, with internal sections 40 millimetres wide and fillet radii of R8 and R10. The opening angle is 86 degrees.
- **Main lower channel:** an opening 80 millimetres wide with a spread angle of 86 degrees. Edges finished with radii R4 and R6.
- **Set of left-hand side channels:** grooves with working widths of 50 millimetres and 25 millimetres.
- **Set of right-hand side channels:** grooves with working widths of 40 millimetres, 16 millimetres and 15 millimetres.

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- **Bending angles:** all standard V-channels have a gape angle of 86 degrees.
- **Edge finish:** working edges finished with specialised radii to protect the material from damage. All channel radii not shown in the drawing are R 0.5 millimetres.



### Installation details and finish specifications

- **Stabilisation system:** the die has two mounting holes for M20 bolts, 40 millimetres deep.
- **Final machining of the body:** sharp edges at both ends of the die have been safely rounded off with a wide 5 by 45-degree chamfer.
- **Finish of external edges:** a longitudinal external chamfer on the body, type 1 at 45 degrees, has been machined at four points along the profile.
- **Additional technical parameters:** relief channels measuring 2 by 2 millimetres have been machined in the bottoms of the working channels. All channel radii not marked on the drawing are R 0.5 millimetres.

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