



Technical drawing of a mechanical part, likely a flange or bracket, showing dimensions and tolerances. The part is symmetrical about a vertical centerline.

Key dimensions and features:

- Overall width: $85_{-0.1}^{+0.05}$
- Overall height: $85_{-0.1}^{+0.05}$
- Central hole: $\varnothing 16$ (M16), depth 35.
- Top horizontal segments: 4, 6, 30, 10, 5.
- Right vertical segments: 4, 3, 40, 8, 4.
- Bottom horizontal segments: 50, 4, 8.
- Left vertical segments: 8, 16, 7, 12, 12, 4.
- Angles: 30° (left side), $4 \times 45^\circ$ (bottom left corner).
- Radii: $2-R1$, $2-R1.5$, $R1$, $2-R2$.
- Section lines: A-A (top right), B-B (bottom right).

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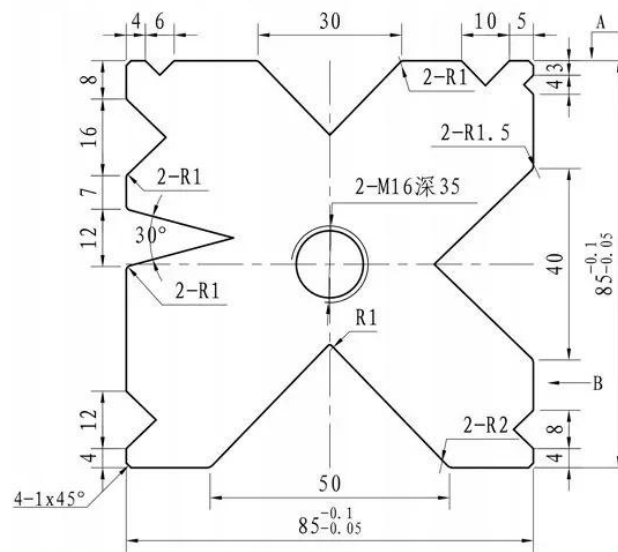


Digima multi-groove prism die for an AMADA 85x85x3200 80T press brake

We are pleased to present a professional lower die (multi-groove prism) from Digima, designed for advanced work on press brakes operating on the Amada system. This tool has been designed to operate at pressures of up to 80 tonnes, enabling precise processing of a wide range of materials, including thick sheet metal. Manufactured from high-grade T8A tool steel, it offers excellent compressive strength and a long service life for the cutting edges, even under intensive industrial use.

The die features a four-sided design with a side length of 85 millimetres, which translates into exceptional tool rigidity and resistance to deformation under load. Thanks to its multi-channel 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 retooling. Each channel has been precision-finished by grinding to ensure repeatable bending angles along the entire 3,200-millimetre length of the tool.

Compatible with the **PBH-80-3200 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 and installation dimensions:

- **Total length of the tool:** 3200 millimetres.
- **Cross-section of the body:** a square measuring 85 by 85 millimetres.
- **Lateral dimensional tolerance:** 85 millimetres with a permissible deviation of between minus 0.1 millimetres and minus 0.05 millimetres.
- **Clamping and positioning system:** the tool has two mounting sockets for M16 bolts, 35 millimetres deep.
- **Chamfering of the body edges:** 45-degree type 1 external longitudinal chamfers at four points along the profile.

Geometry of the working channels:

- **Opening widths of V-channels:** the die features various working grooves measuring 30 millimetres, 46 millimetres and 50 millimetres.
- **Groove opening angles:** the standard bending angle for unmarked grooves is 86 degrees.
- **Special angle:** one of the auxiliary channels has an opening angle of 30 degrees.
- **Working (lead) radii:** the channel edges are finished with specialised radii such as 2-R1, 2-R1.5, 2-R2 and a central radius of R1.
- **Manufacturing details:** relief undercuts (tool exits) measuring 2 by 2 millimetres have been applied at the bottom of the grooves.

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Quality requirements and tolerances

- **Geometric accuracy:** the error in parallelism and straightness of the die along its entire length is less than or equal to 0.05 millimetres.
- **Safety and assembly:** sharp edges at both ends of the die have been chamfered at 5 to 45 degrees.
- **Chamfering of external edges:** the tool body has 1:45-degree chamfers in four places.

*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