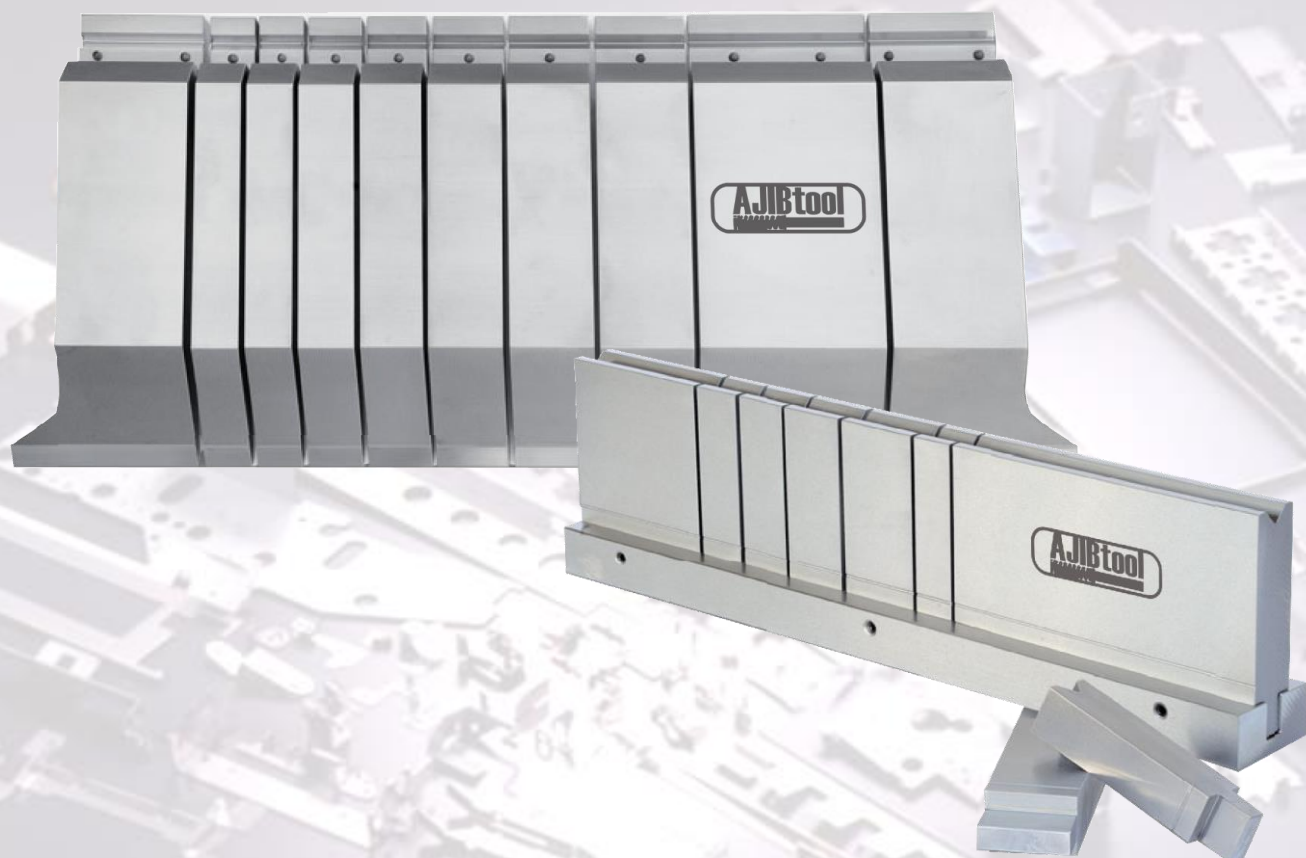


## PRESSBRAKE AND SHEARING TOOL



### Available for machine

- Amada
- Murata
- Trumpf
- Salvagnini
- Prima Power
- Euromax
- LVD
- Yawei Nishinbo
- Nishinbo
- Ermaksan
- Tailift
- JFY
- HACO
- etc

High Quality

High Performance

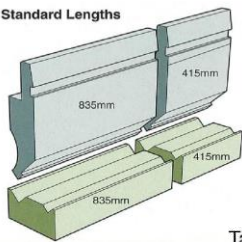
Long Lifetime

Reasonable Price

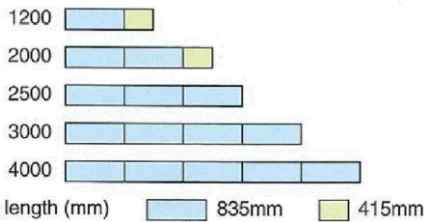
Design and Creation by : **ajipower**

# TECHNICAL DATA

## Standard Lengths



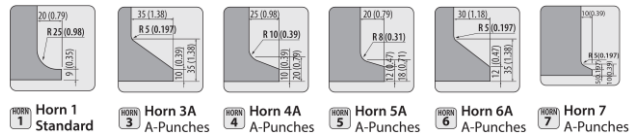
## Number of Tools to be Mounted



## Sectionalize



## Horn Type



Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm <sup>2</sup>	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC

Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN.**

## Punch-die combinations

**1 90° Bending**  
t: 0.4-3.2mm

**2 90° Deep Bending**  
t: 0.4-3.2mm

**3 90° Bending / Straight-sword type**  
t: 0.4-2.0mm

**4 90° Bending / Gooseneck type**  
t: 0.4-3.2mm

**5 90° Bending for Sash**  
t: 0.4-2.3mm

**6 90° Bending for thick material**  
t: 4-10mm

**7 90° Bending / Reversible dies**  
t: 0.4-4.0mm

**8 90° Bending / Straight-thick material for extra-thick material**  
t: 10-15mm

**9 R-Bending / Urethane Tooling**  
t: 0.4-3.2mm

**10 R-Bending / 2 step type**  
t: 1.2-1.5mm

**11 Acute-Angled Bending for thick material**  
t: 4-5mm

**12 Acute-Angled Bending by Air-bending**  
t: 0.4-2.3mm

**13 V & Hemming**  
t: 0.4-1.6mm

**14 Hemming (1st step)**  
t: 0.4-2.0mm

**15 Hemming (2nd step)**  
t: 0.4-2.0mm

**16 Hemming (1st step)**  
t: 2.3-3.5mm

**17 Hemming (2nd step with flange)**  
t: 0.4-3.2mm

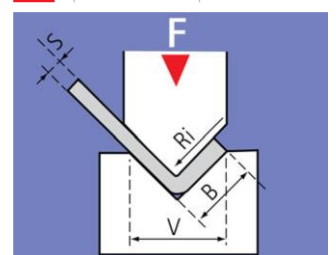
**18 Hemming / for high load**  
t: 0.4-3.2mm

**19 Small-radius bending / Replaceable-tip punches**  
t: 0.4-3.2mm

**20 Wing bend dies**  
t: 1.6-6.0mm

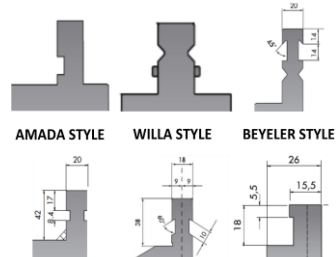
## Air bending force calculation

$$F = \frac{S^2 \times 2 \times R}{1.4 \times V} = \dots \text{ ton/m}$$

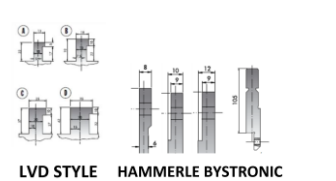


<b>S</b>	Sheet metal thickness - mm
<b>V</b>	V-opening
<b>F</b>	Force in T/m
<b>B</b>	Shortest edge
<b>Ri</b>	Inside radius
<b>R</b>	Aluminium 20-25 kg/mm <sup>2</sup>
<b>R</b>	Mild steel 40-45 kg/mm <sup>2</sup>
<b>R</b>	Stainless steel 65-70 kg/mm <sup>2</sup>

## HOLDER HEAD STYLE



## GASPARINI STYLE COLGAR STYLE COLY STYLE



## LVD STYLE HAMMERLE BYSTRONIC



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