

# EURO - SPEC

## PRESS BRAKE TOOLS

**Large stocks  
available for  
immediate  
despatch**

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**Special tools  
available  
by request**



**Fast 24-hour  
re-grinding  
service for  
shear blades**

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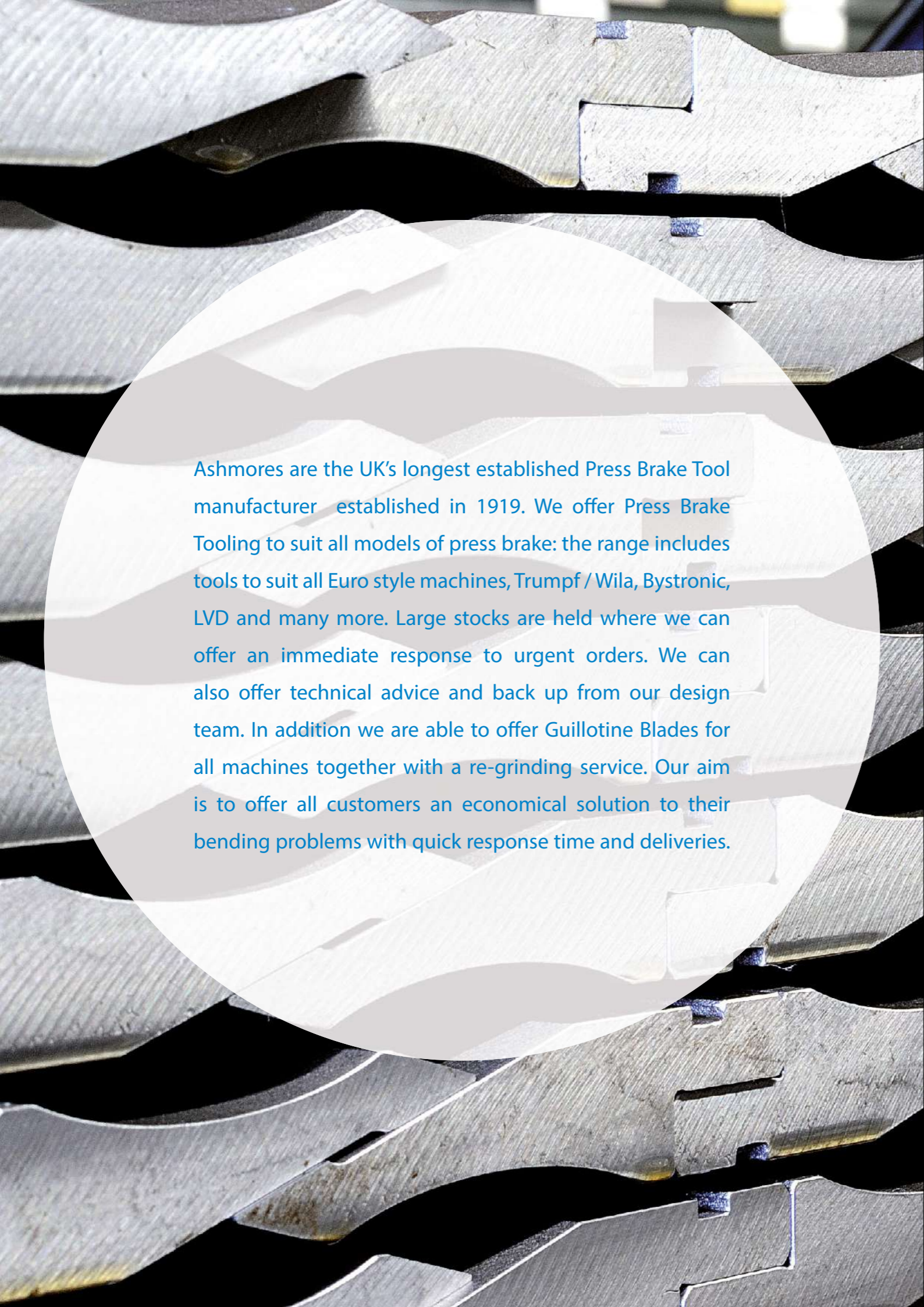
**Tooling to  
suit all types  
of machine**

# ASHMORES

THE UK'S LONGEST ESTABLISHED PRESS BRAKE TOOLING  
MANUFACTURER WITH OVER 90 YEARS EXPERIENCE

**Tel: 0121 557 1064 Fax: 0121 557 1085**

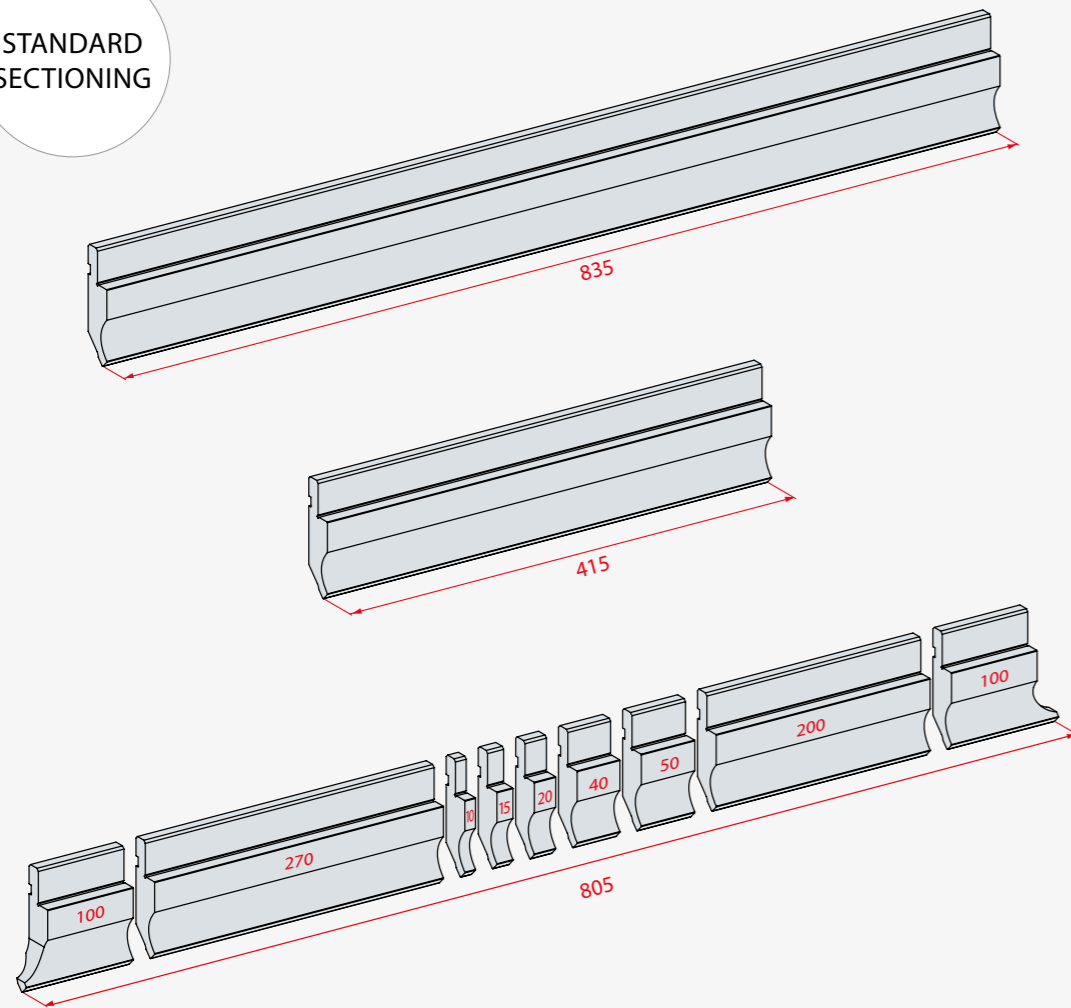
Email: [ashmores@pressbraketool.co.uk](mailto:ashmores@pressbraketool.co.uk) Website: [www.pressbraketool.co.uk](http://www.pressbraketool.co.uk)  
Lewis Street, Great Bridge, Tipton, West Midlands DY4 7EF.



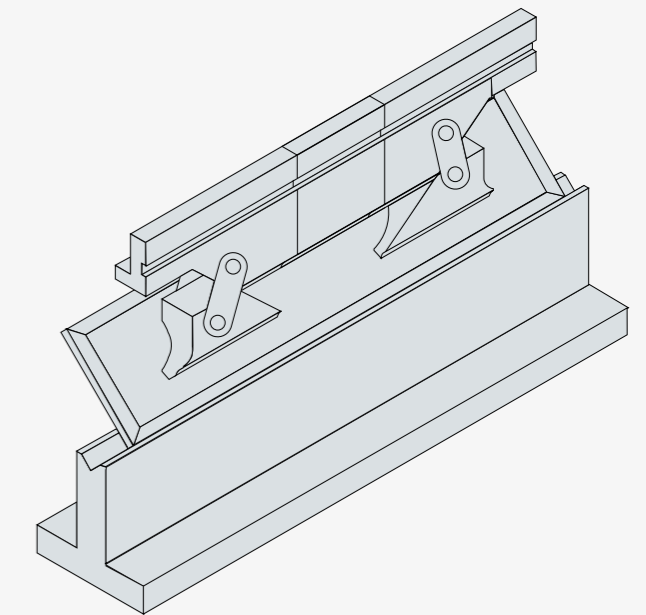
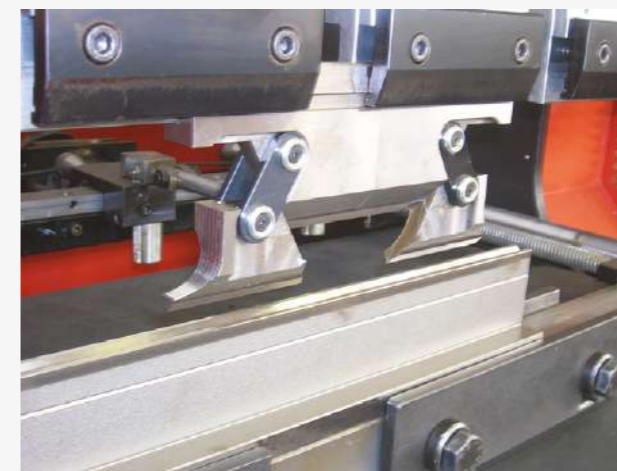
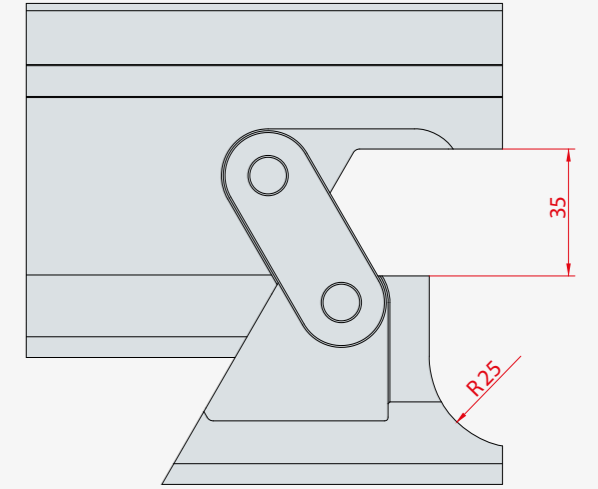
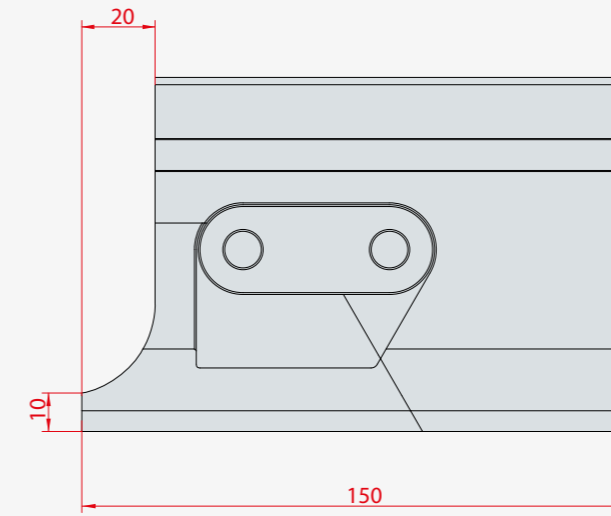
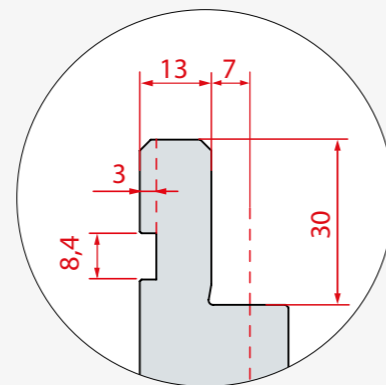
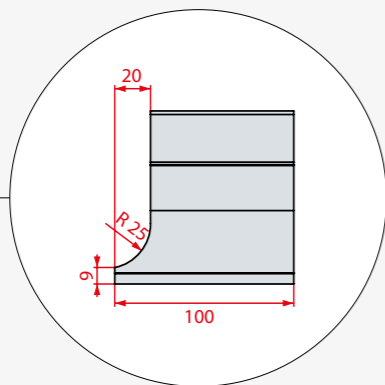
Ashmores are the UK's longest established Press Brake Tool manufacturer established in 1919. We offer Press Brake Tooling to suit all models of press brake: the range includes tools to suit all Euro style machines, Trumpf / Wila, Bystronic, LVD and many more. Large stocks are held where we can offer an immediate response to urgent orders. We can also offer technical advice and back up from our design team. In addition we are able to offer Guillotine Blades for all machines together with a re-grinding service. Our aim is to offer all customers an economical solution to their bending problems with quick response time and deliveries.

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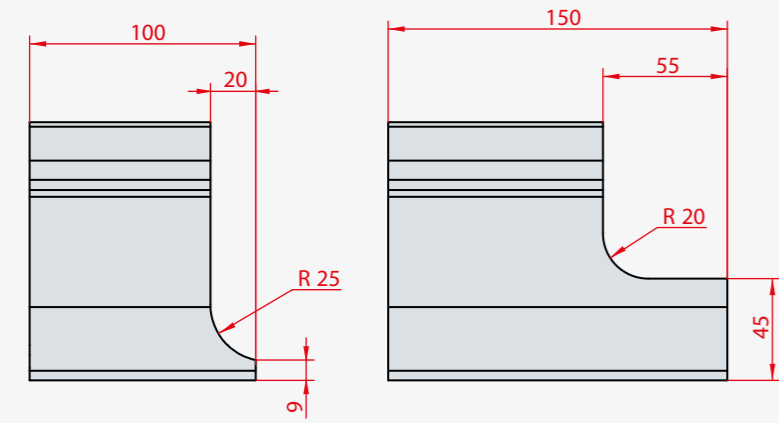
STANDARD SECTIONING



MILLED HORN



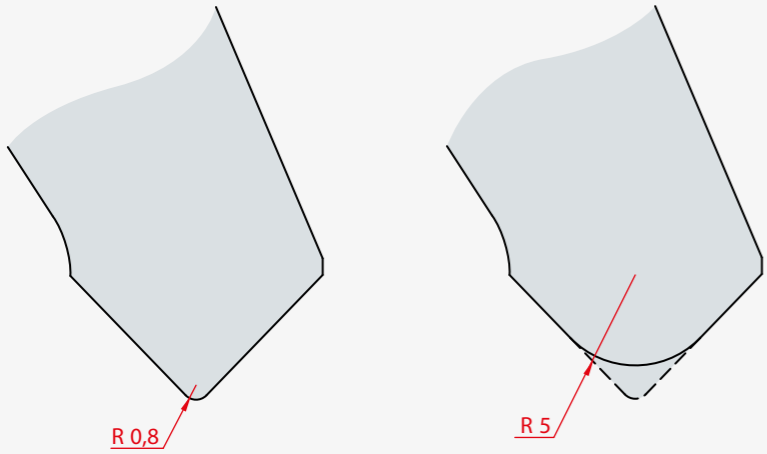
PUCH	MOVING HORNS
<b>A1010</b>	A1010S
<b>A1011</b>	A1011S
<b>A1064</b>	A1064S
<b>A1065</b>	A1065S
<b>A1047</b>	A1047S



SPECIAL HORNS

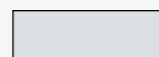




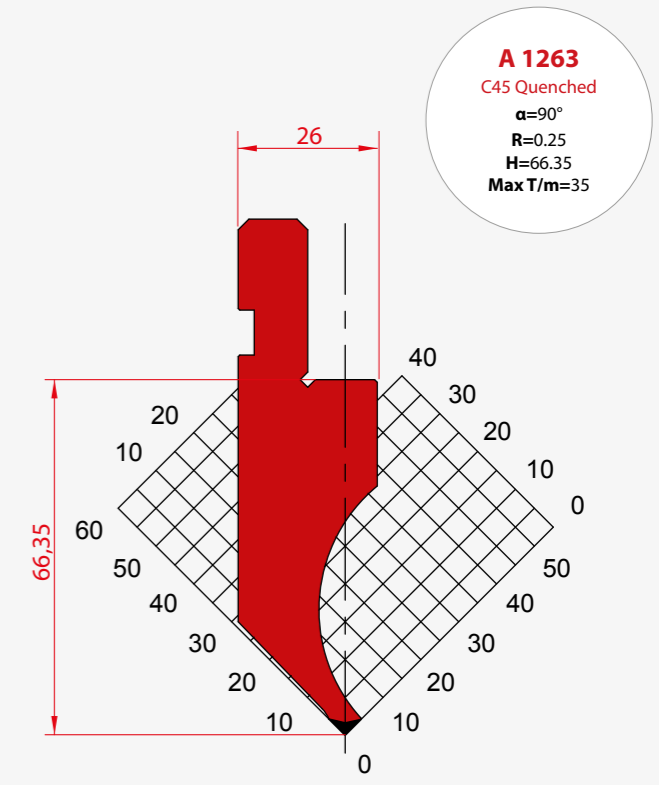
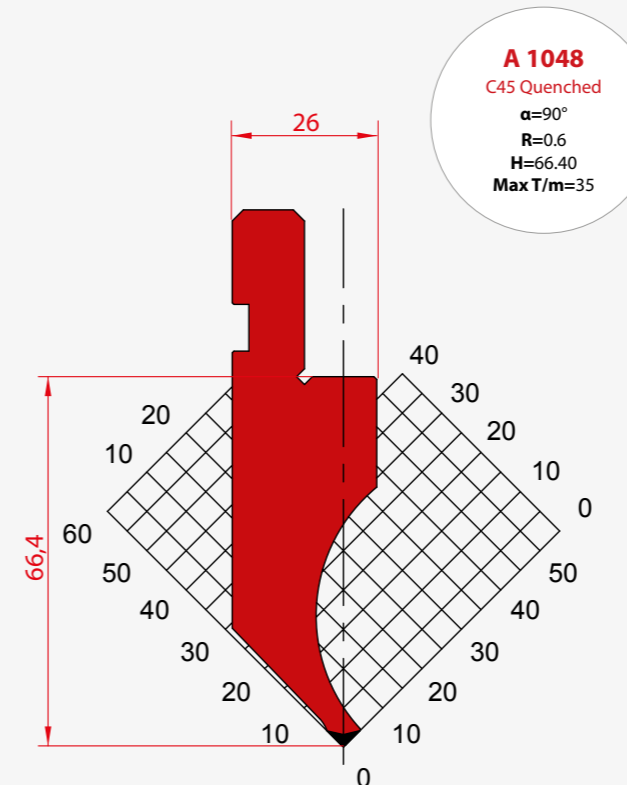
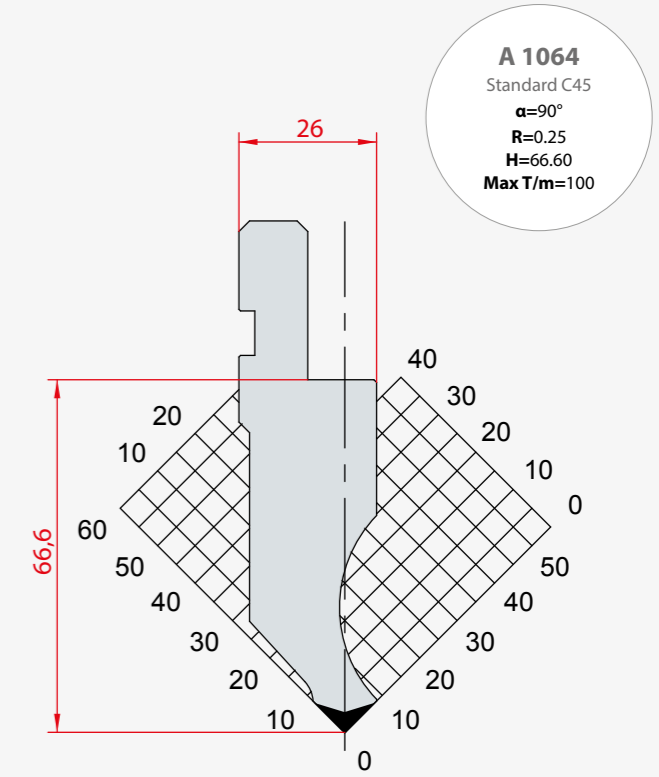
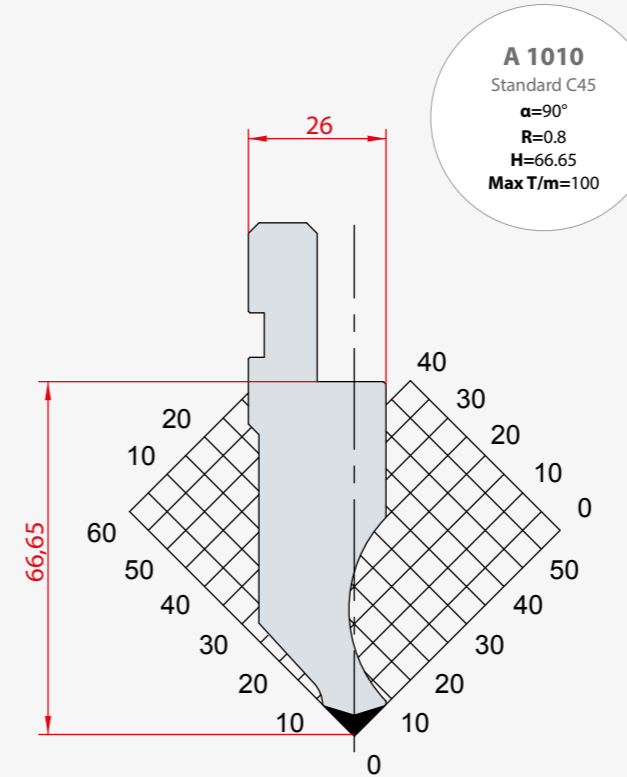
SPECIAL SEGMENTATION

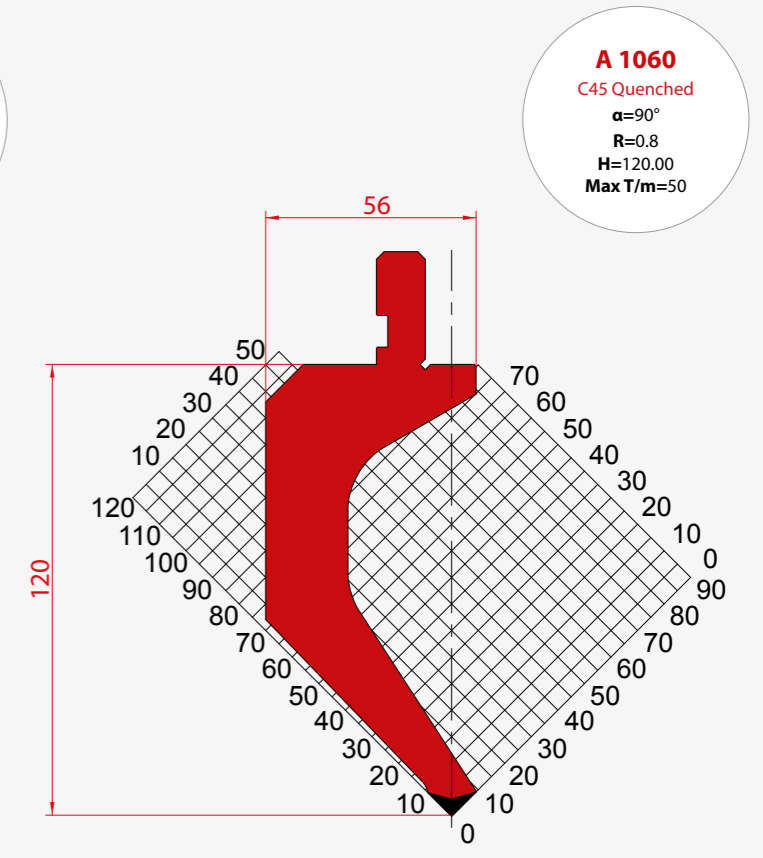
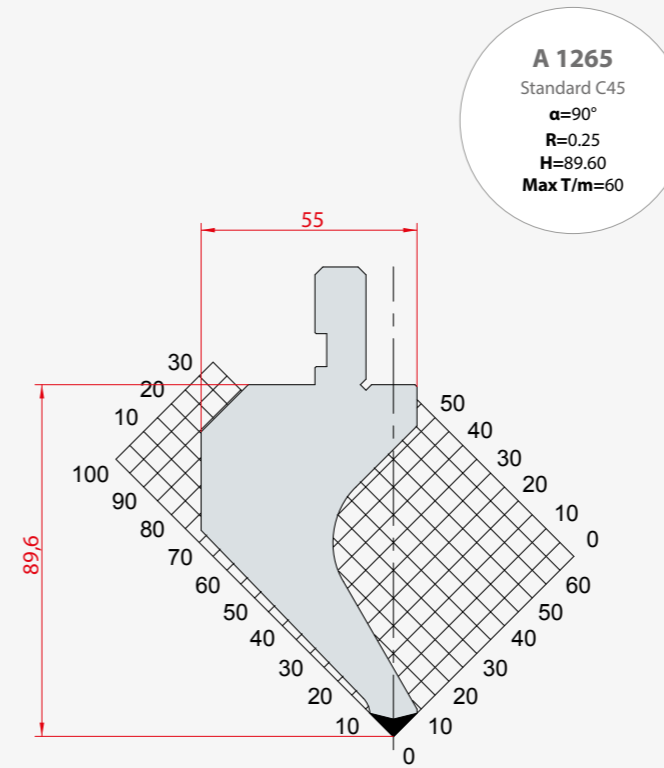
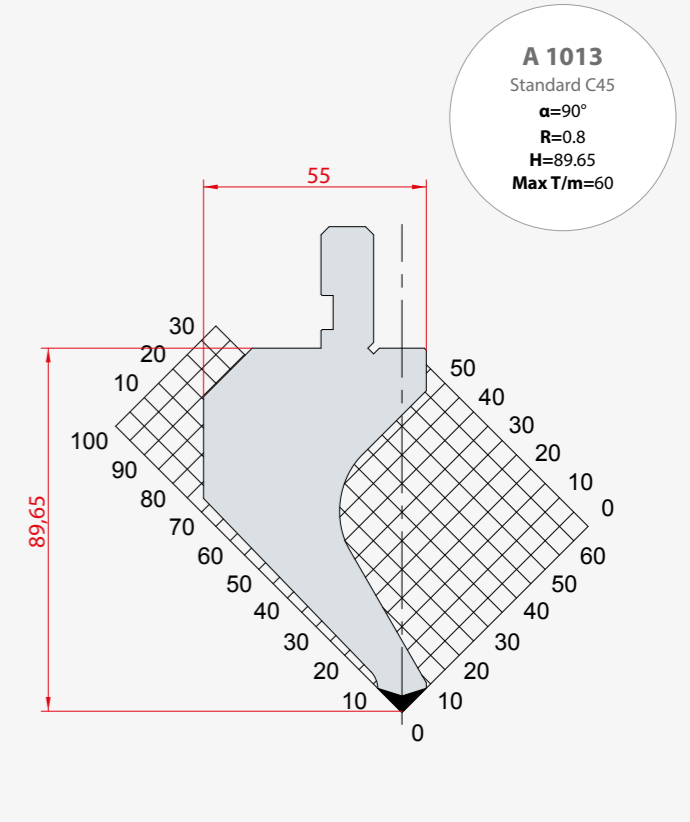
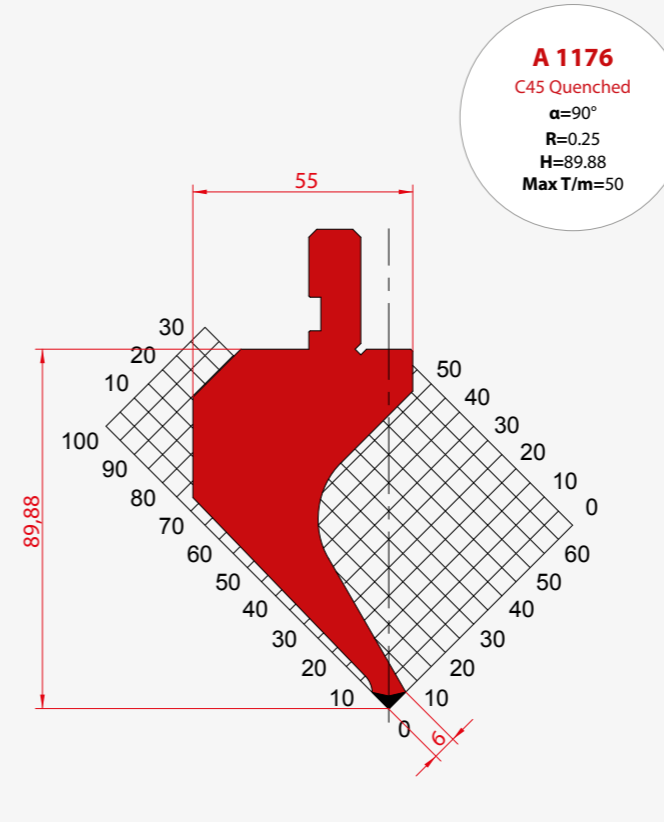
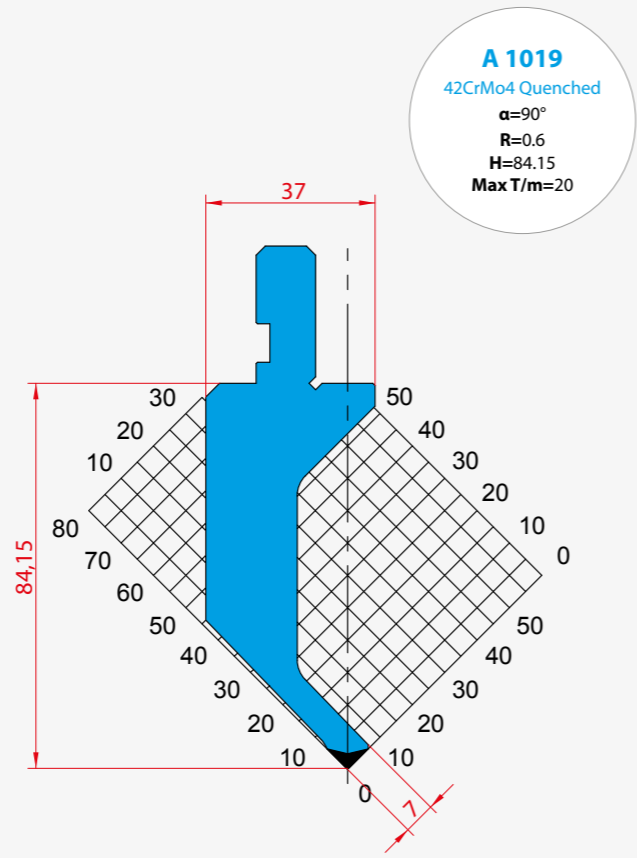
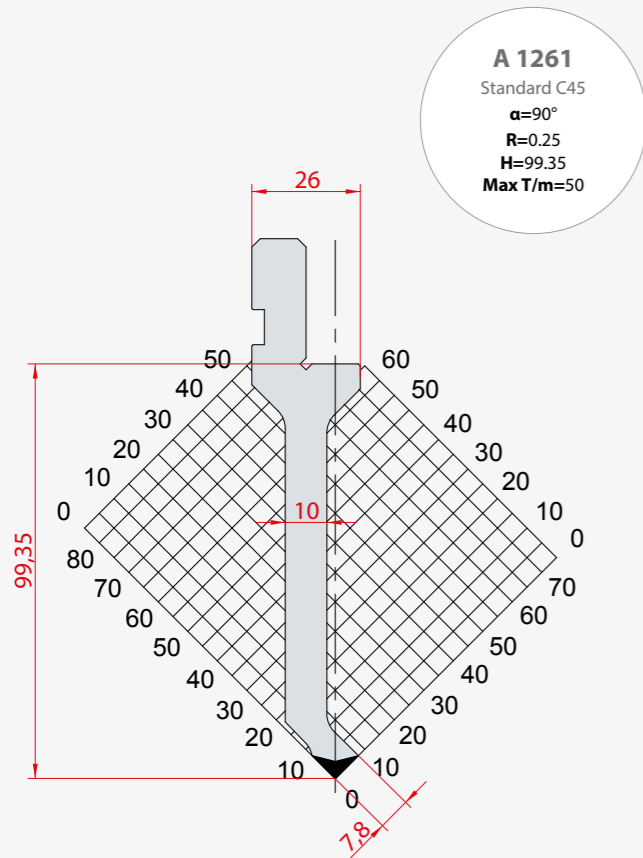
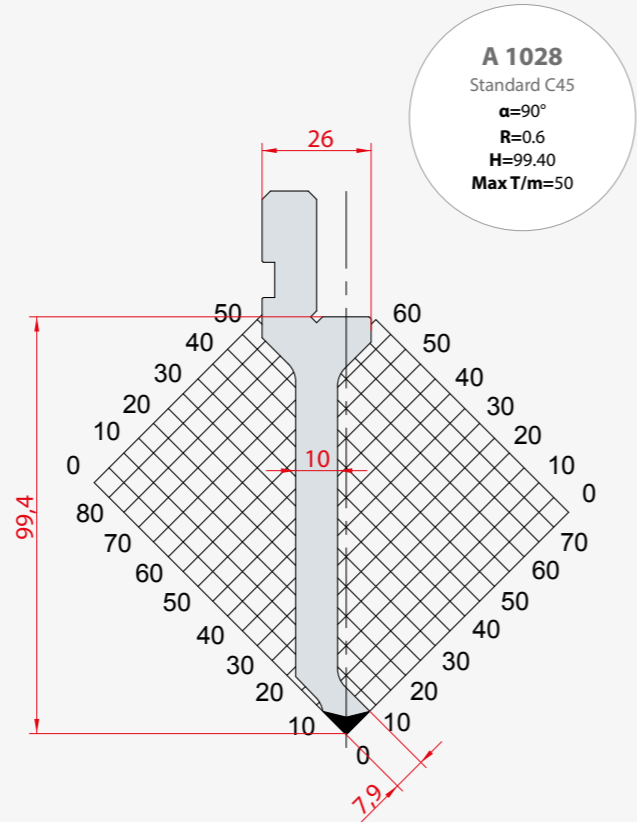
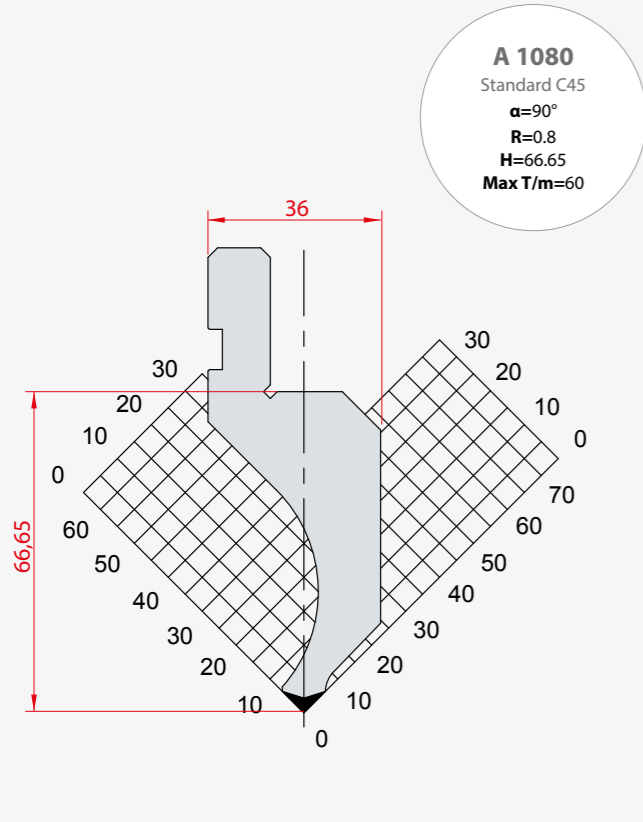


RADIUS MODIFICATION

MATERIAL TYPE :

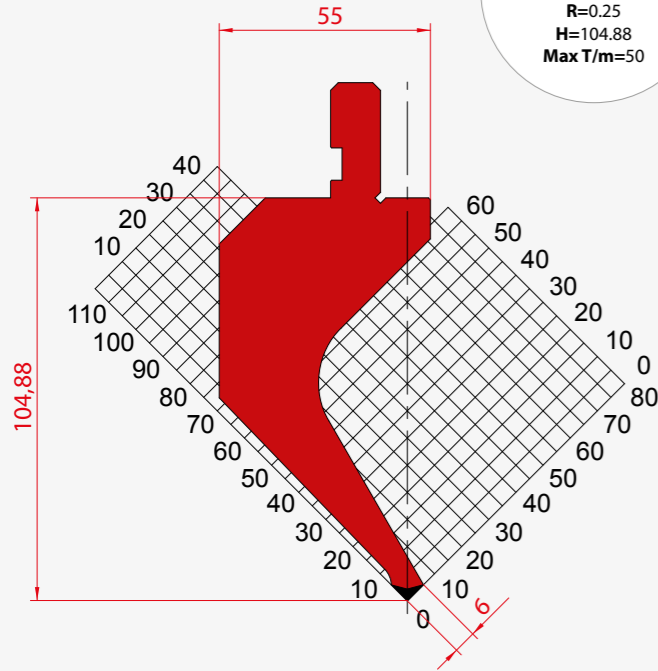
-  Standard C45
-  C45 Quenched
-  42CrMo4 Quenched





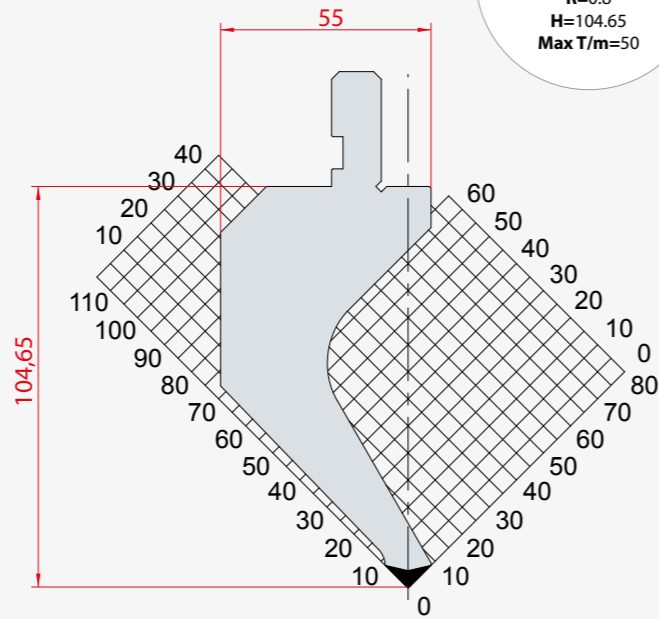
**A 1174**

C45 Quenched  
 $\alpha=90^\circ$   
R=0.25  
H=104.88  
Max T/m=50



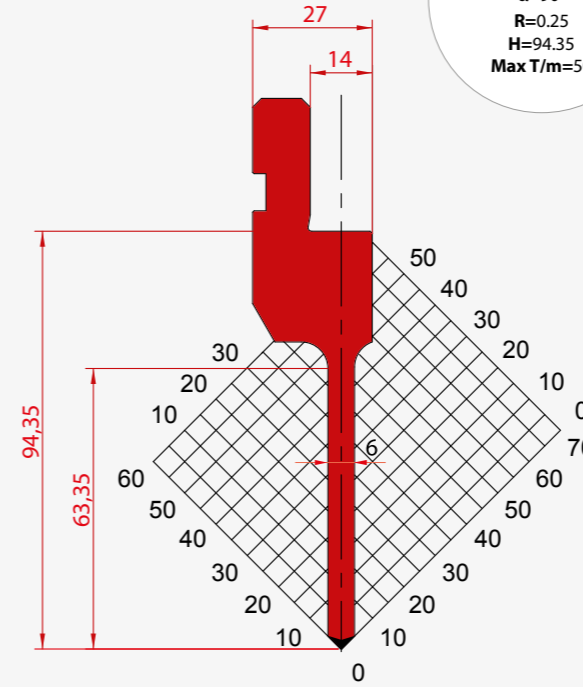
**A 1016**

Standard C45  
 $\alpha=90^\circ$   
R=0.8  
H=104.65  
Max T/m=50



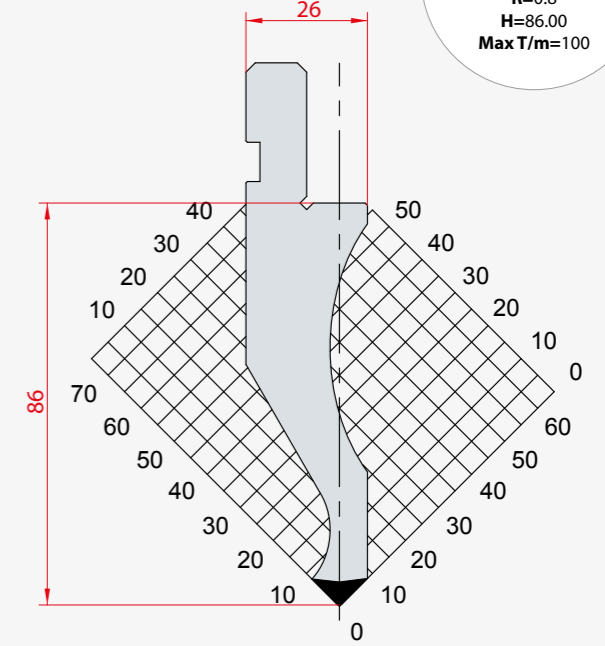
**A 1269**

C45 Quenched  
 $\alpha=90^\circ$   
R=0.25  
H=94.35  
Max T/m=50



**A 1021**

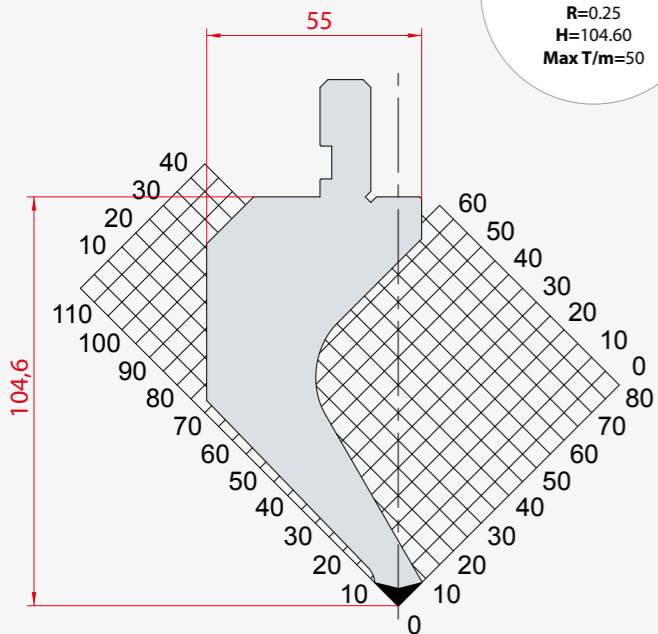
Standard C45  
 $\alpha=90^\circ$   
R=0.8  
H=86.00  
Max T/m=100



PUNCHES 88°

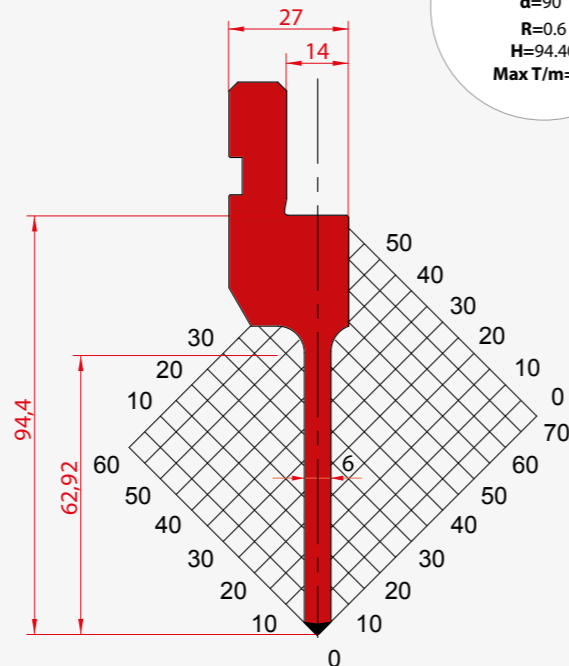
**A 1267**

Standard C45  
 $\alpha=90^\circ$   
R=0.25  
H=104.60  
Max T/m=50



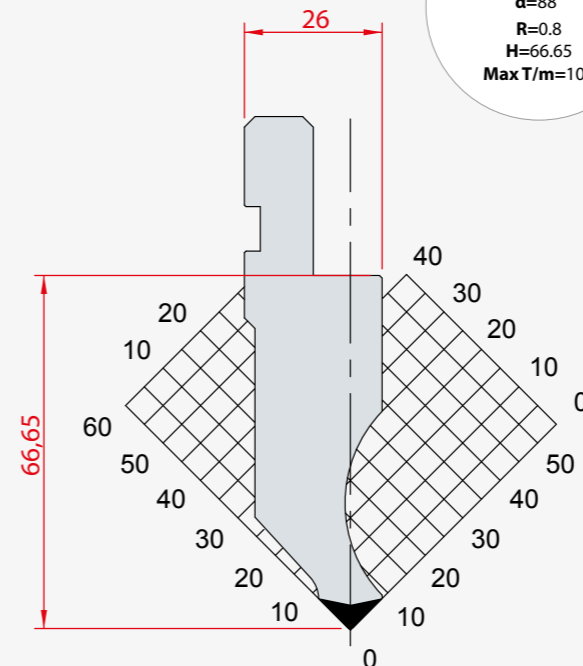
**A 1083**

C45 Quenched  
 $\alpha=90^\circ$   
R=0.6  
H=94.40  
Max T/m=50



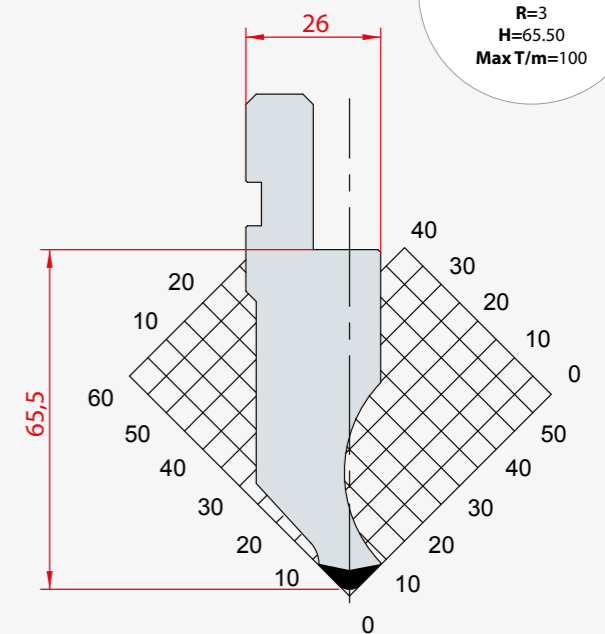
**A 1011**

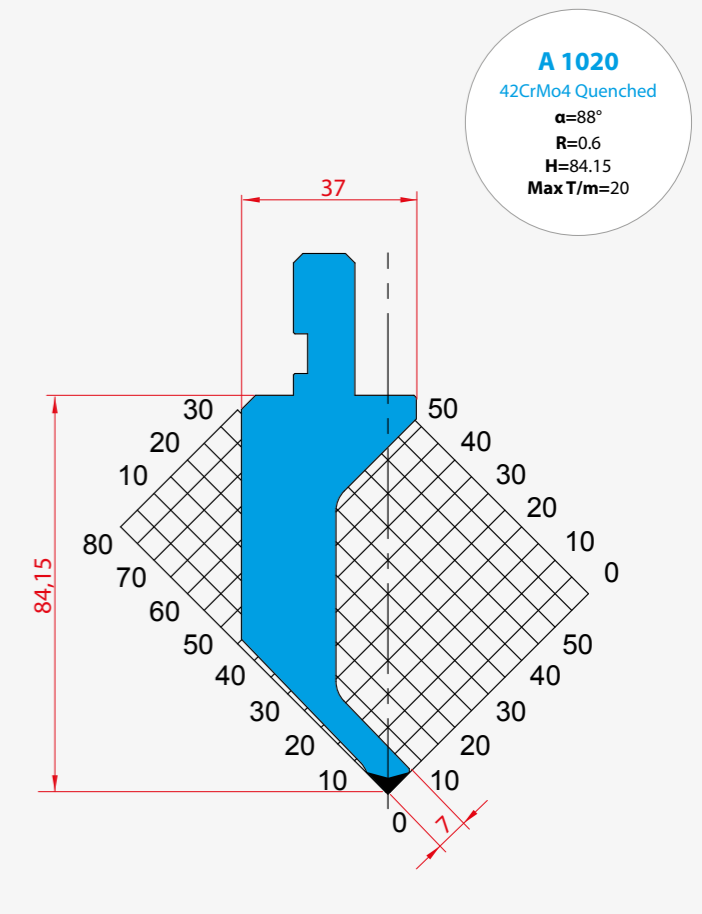
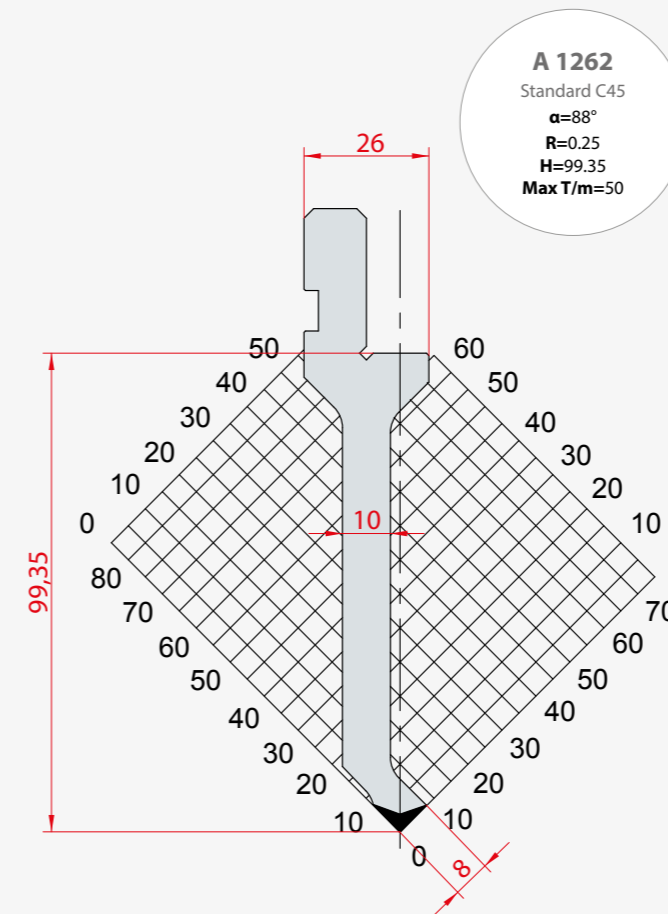
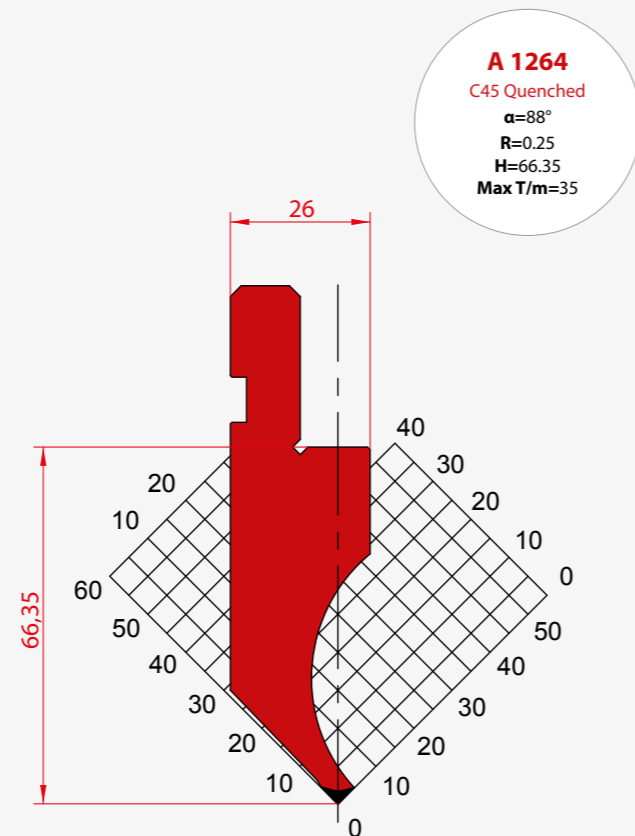
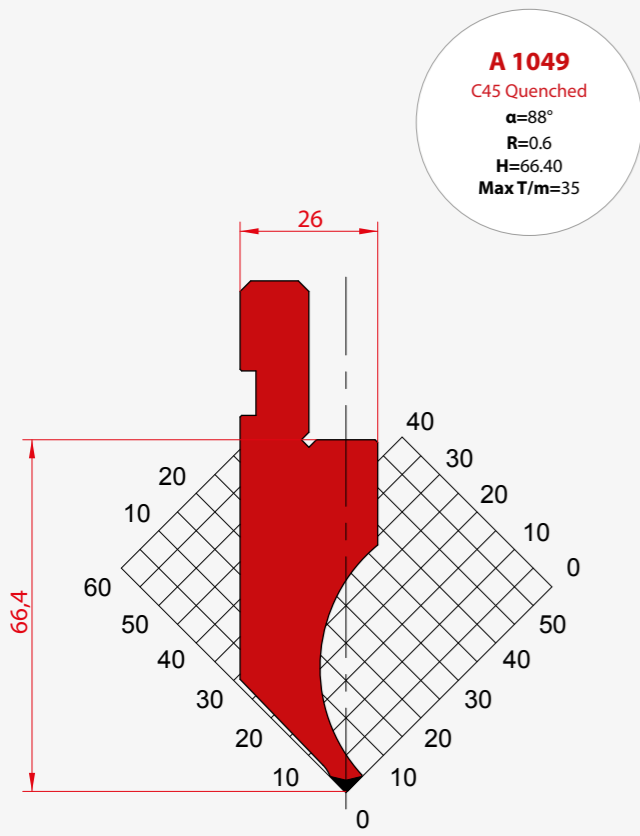
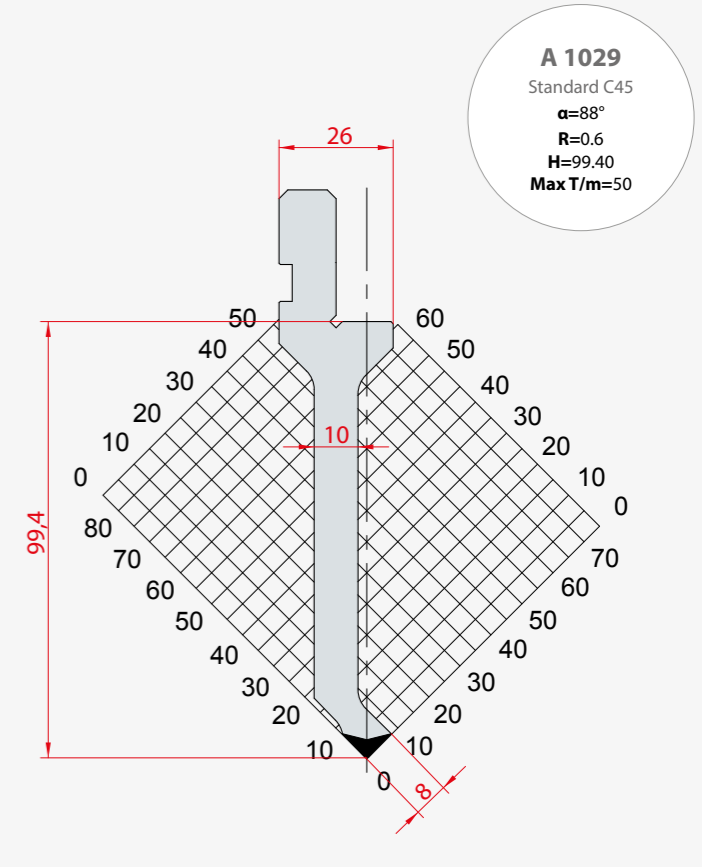
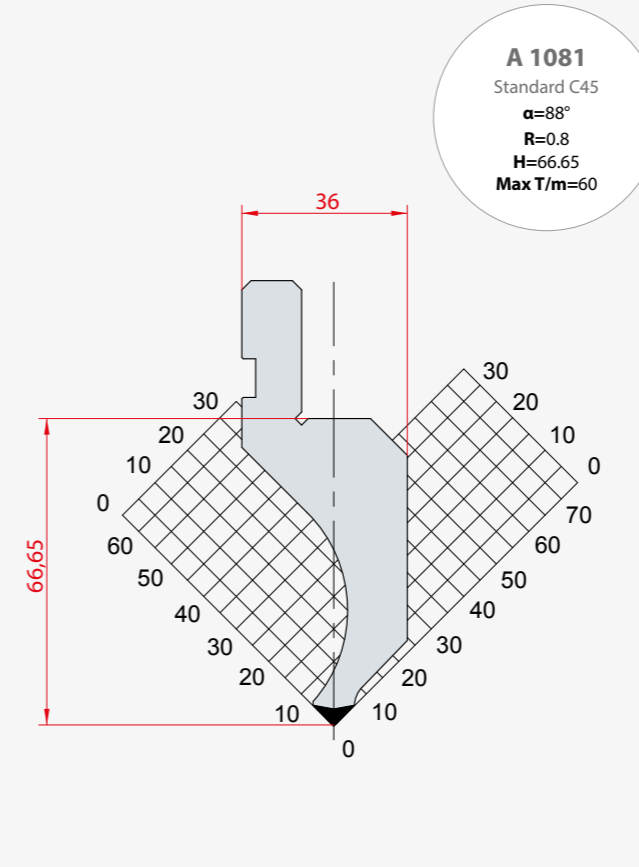
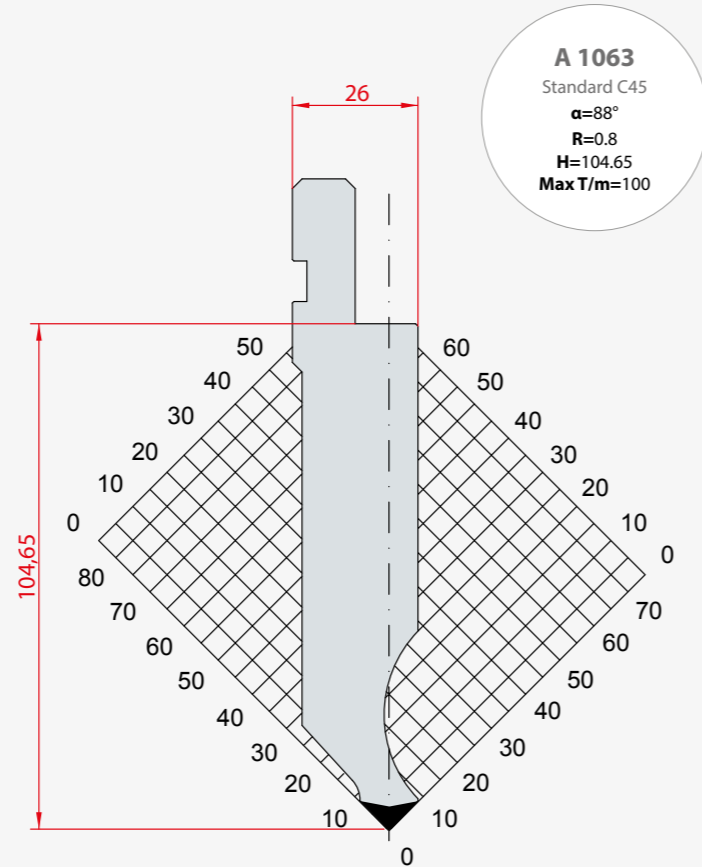
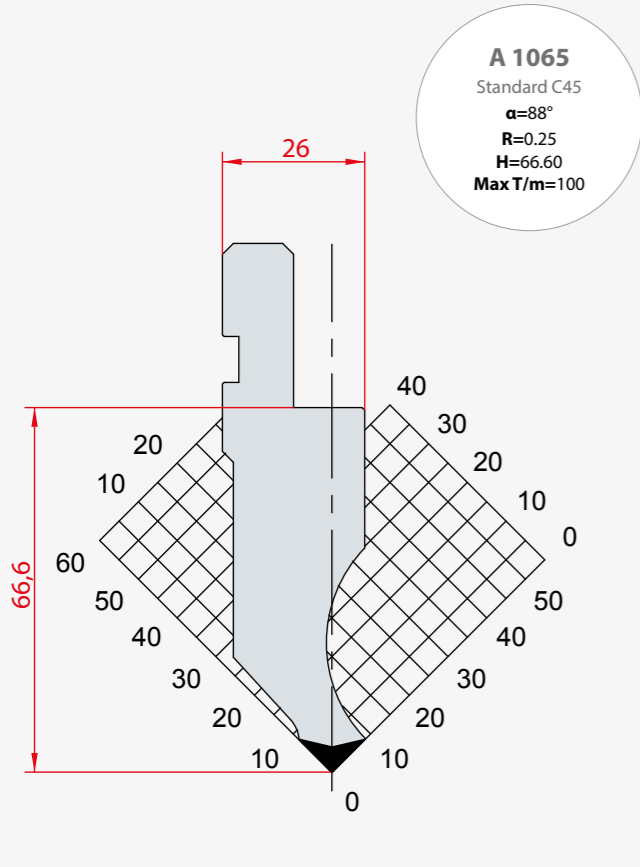
Standard C45  
 $\alpha=88^\circ$   
R=0.8  
H=66.65  
Max T/m=100



**A 1012**

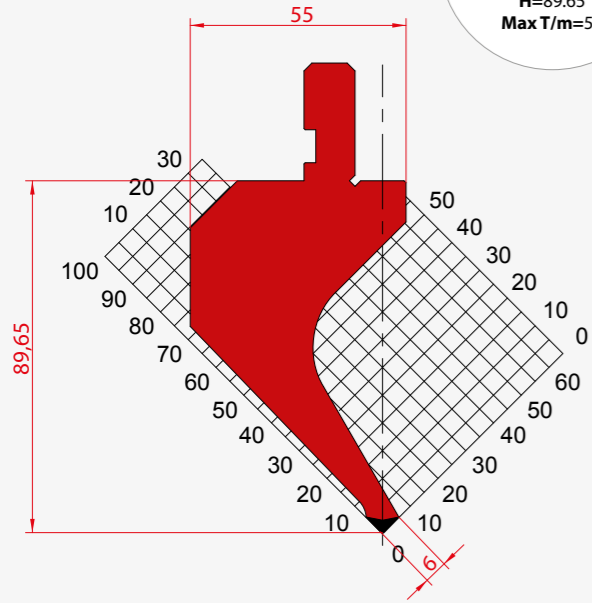
Standard C45  
 $\alpha=88^\circ$   
R=3  
H=65.50  
Max T/m=100





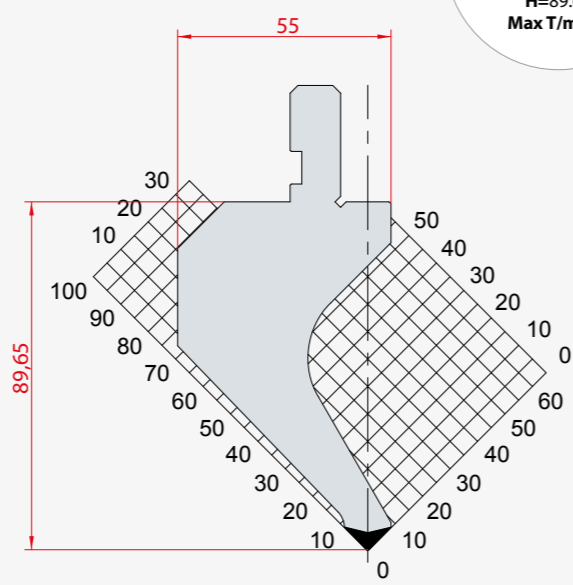
**A 1175**

C45 Quenched  
 $\alpha=88^\circ$   
R=0.8  
H=89.65  
Max T/m=50



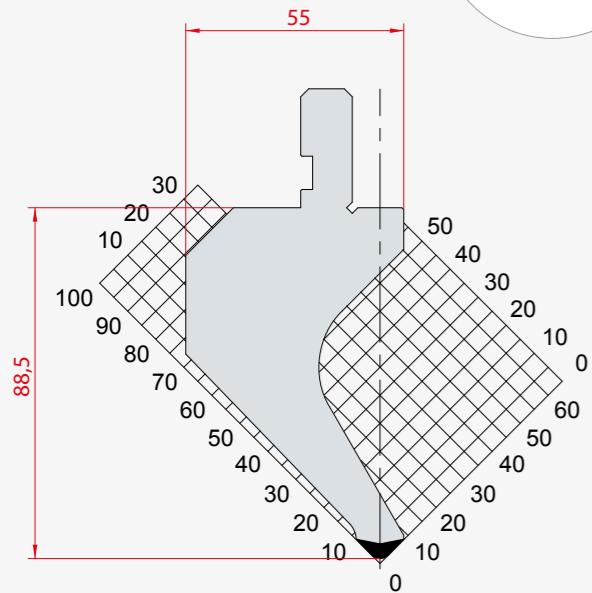
**A 1014**

Standard C45  
 $\alpha=88^\circ$   
R=0.8  
H=89.65  
Max T/m=60



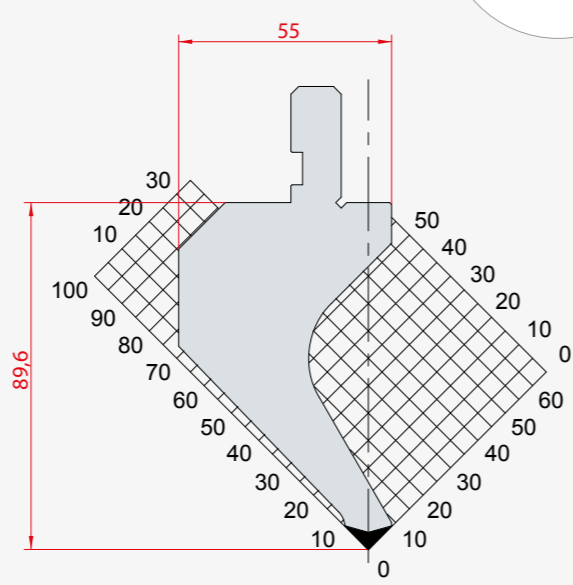
**A 1015**

Standard C45  
 $\alpha=88^\circ$   
R=3  
H=88.50  
Max T/m=60



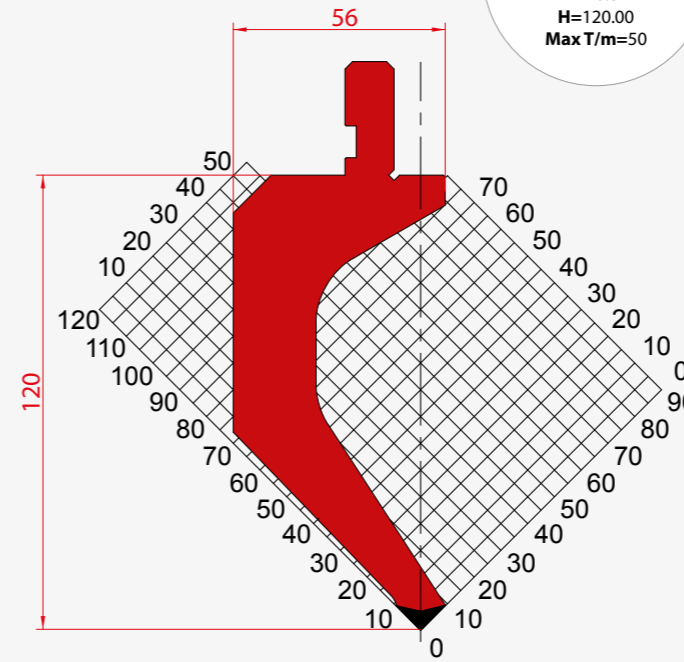
**A 1266**

Standard C45  
 $\alpha=88^\circ$   
R=0.25  
H=89.60  
Max T/m=60



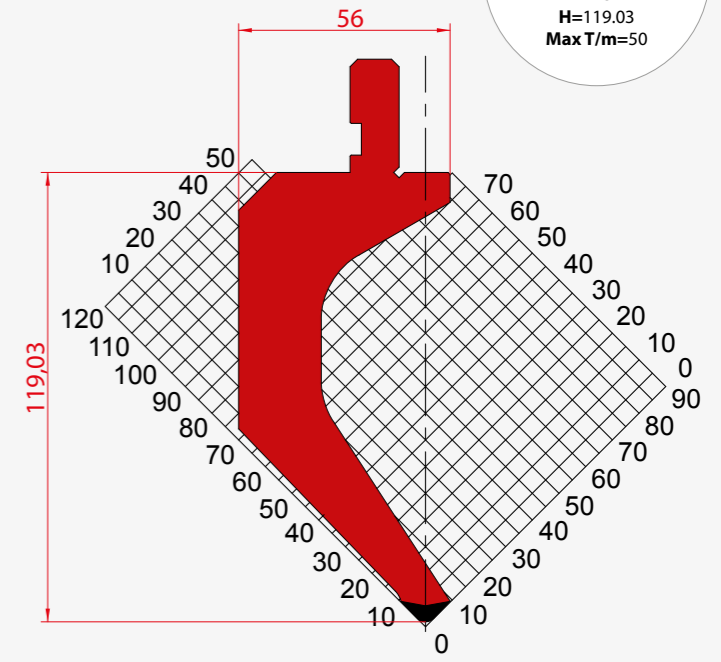
**A 1061**

C45 Quenched  
 $\alpha=88^\circ$   
R=0.8  
H=120.00  
Max T/m=50



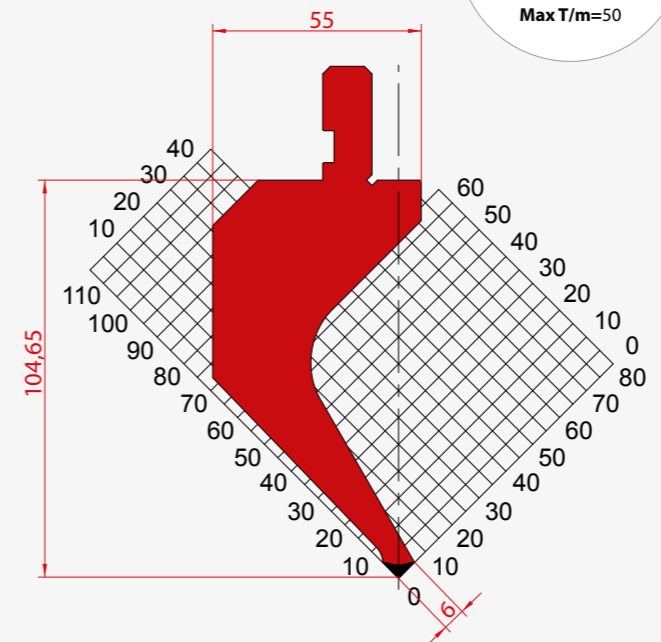
**A 1062**

C45 Quenched  
 $\alpha=88^\circ$   
R=3  
H=119.03  
Max T/m=50



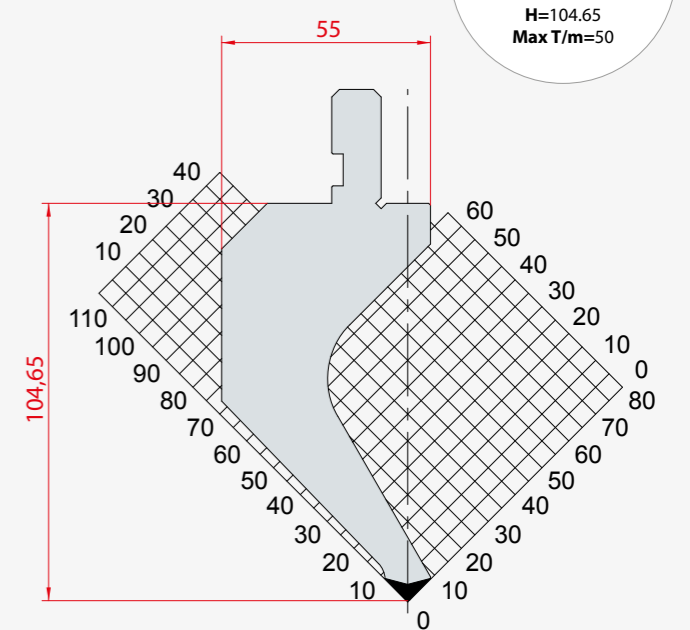
**A 1173**

C45 Quenched  
 $\alpha=88^\circ$   
R=0.8  
H=104.65  
Max T/m=50

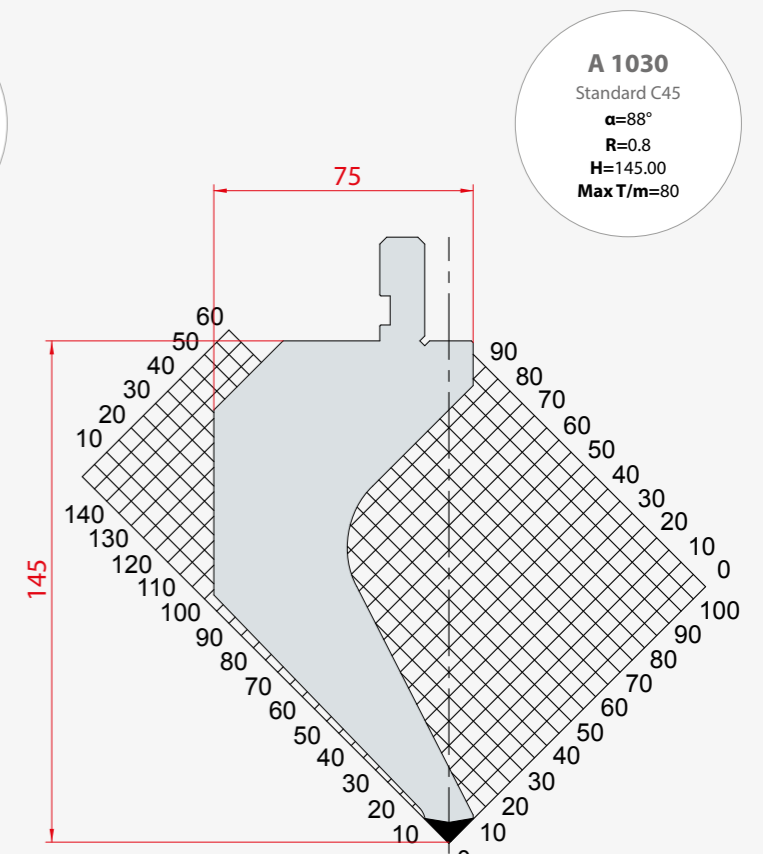
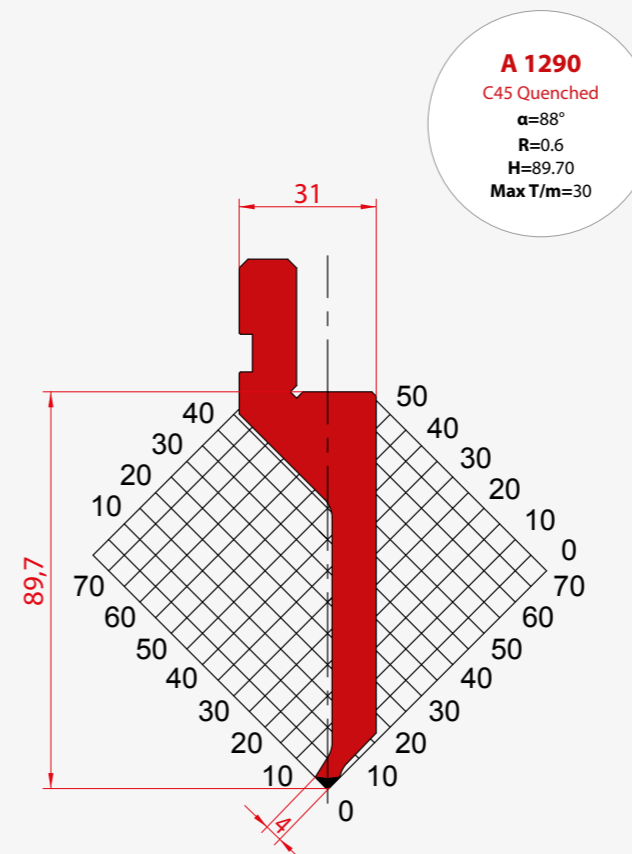
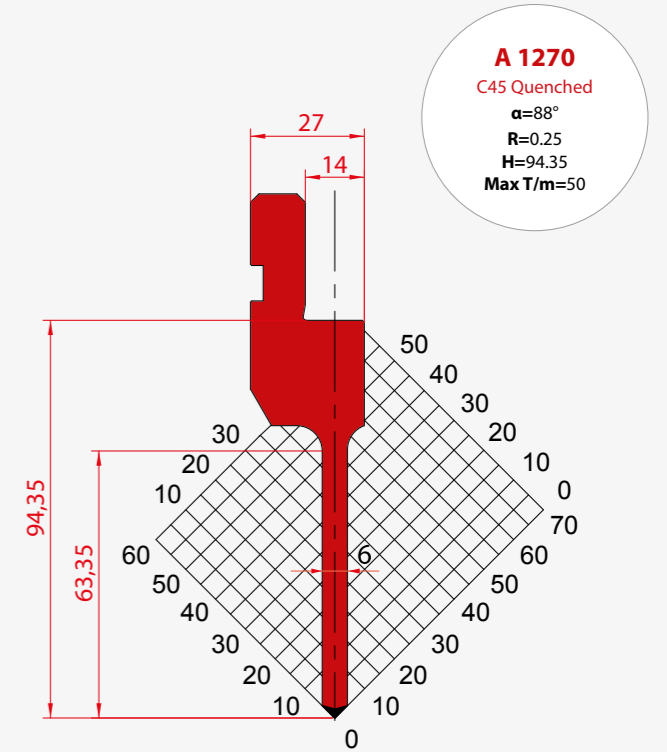
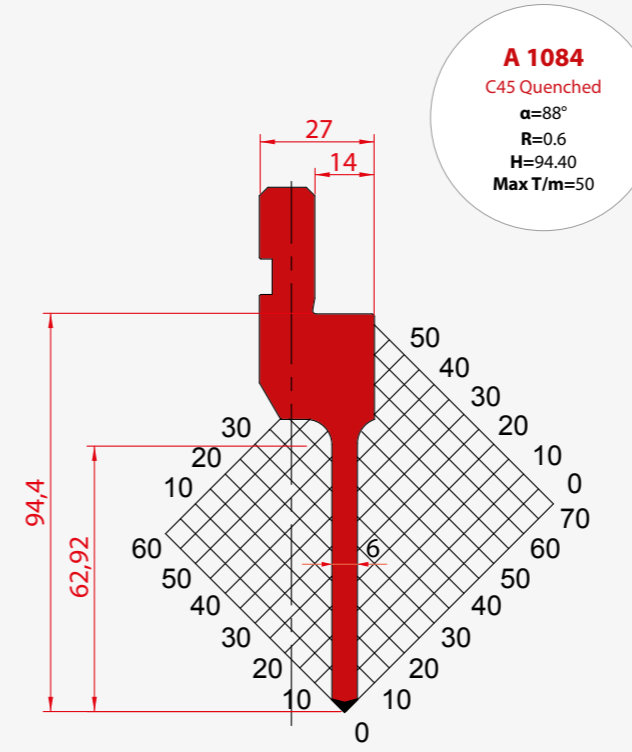
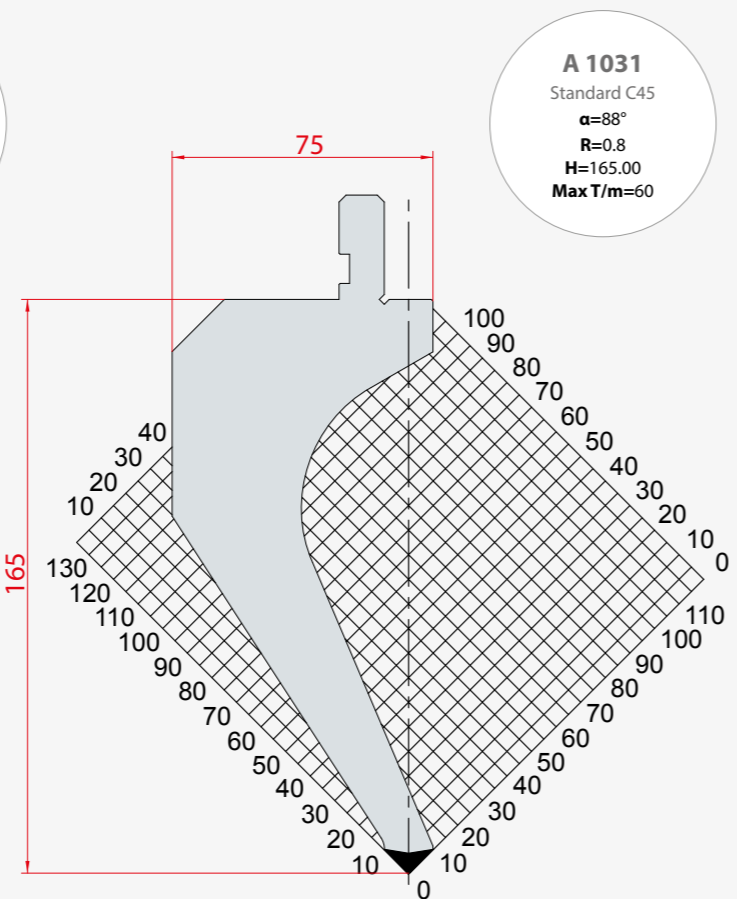
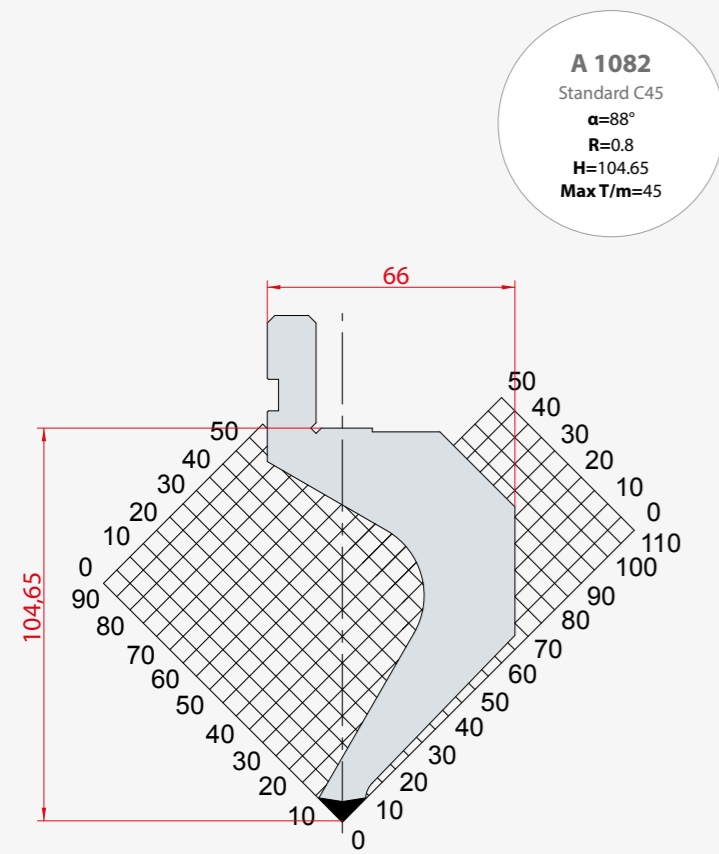
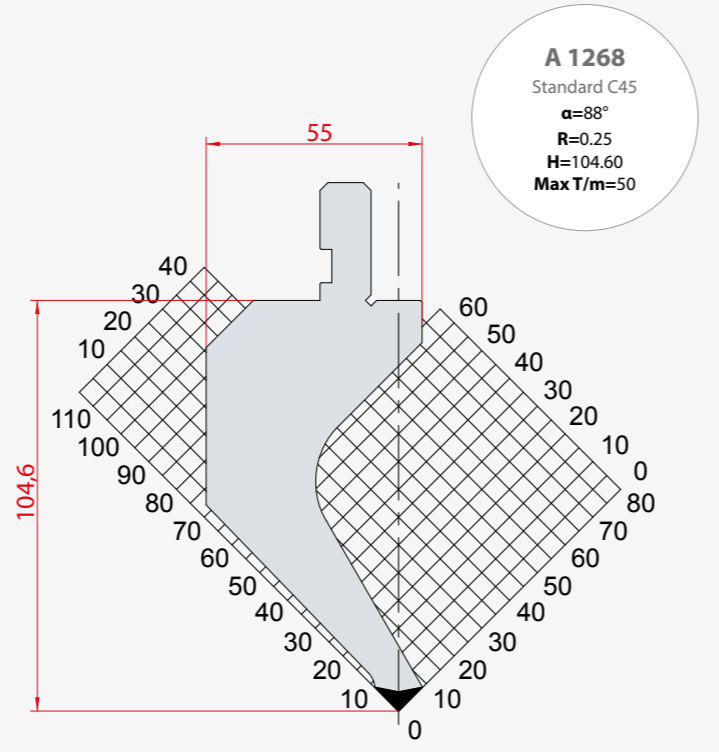
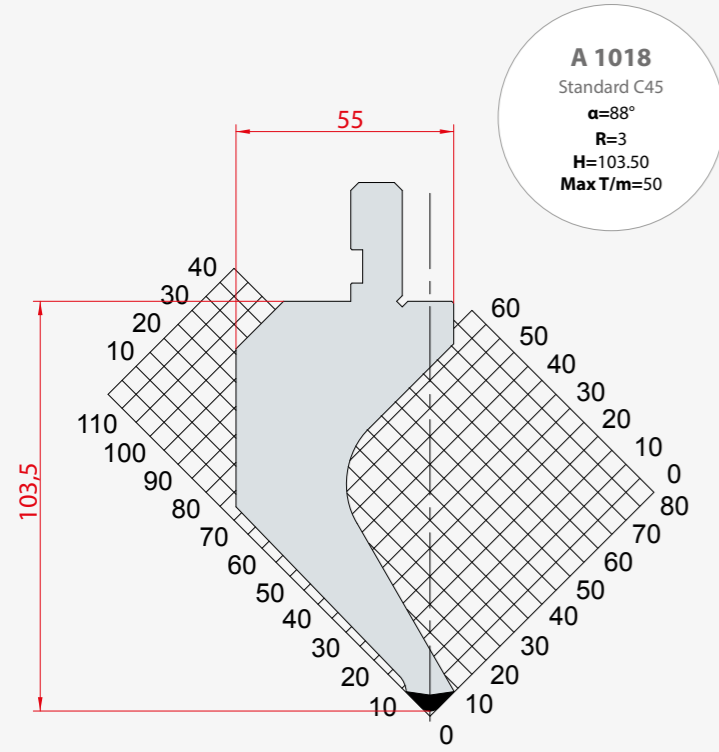


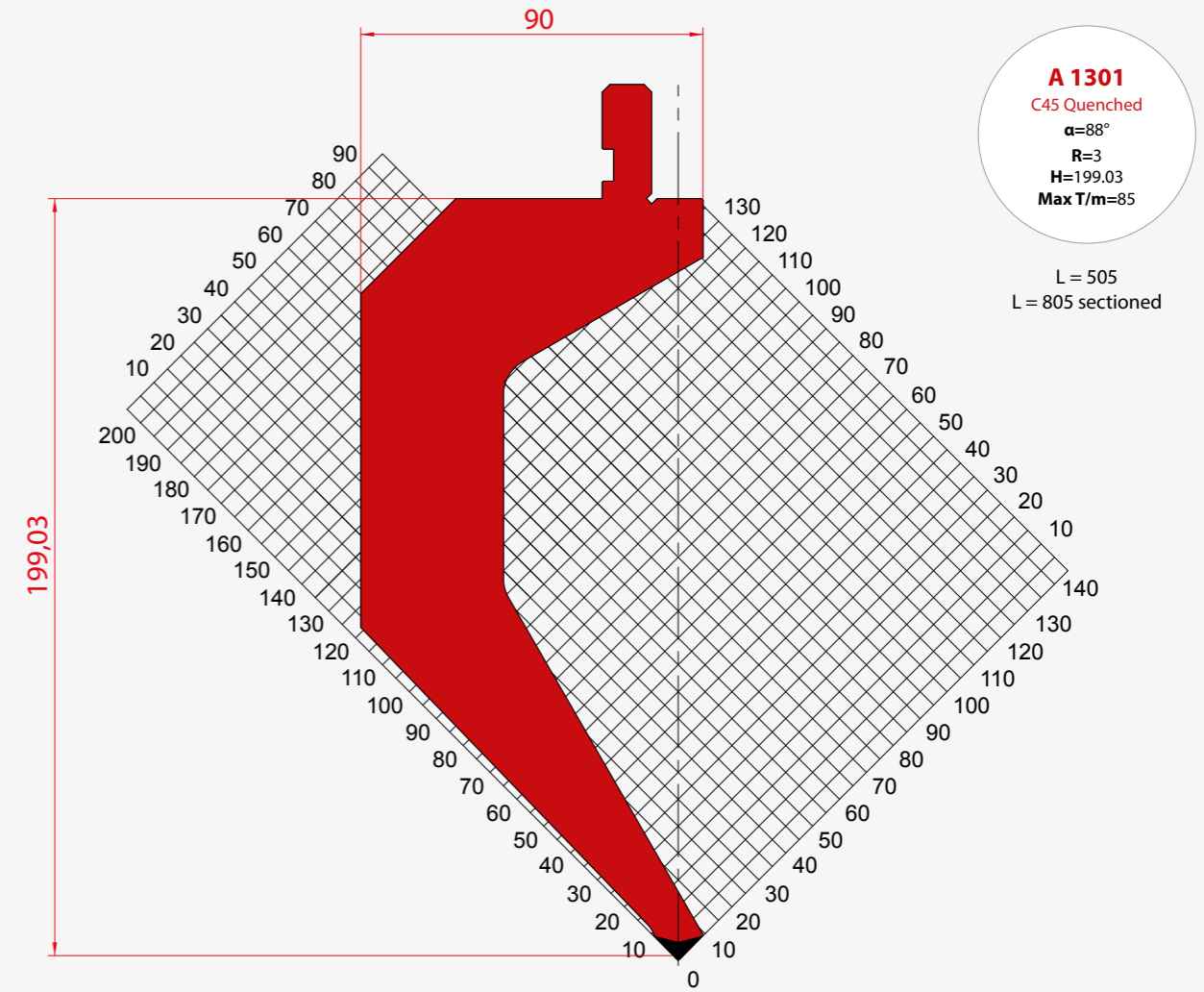
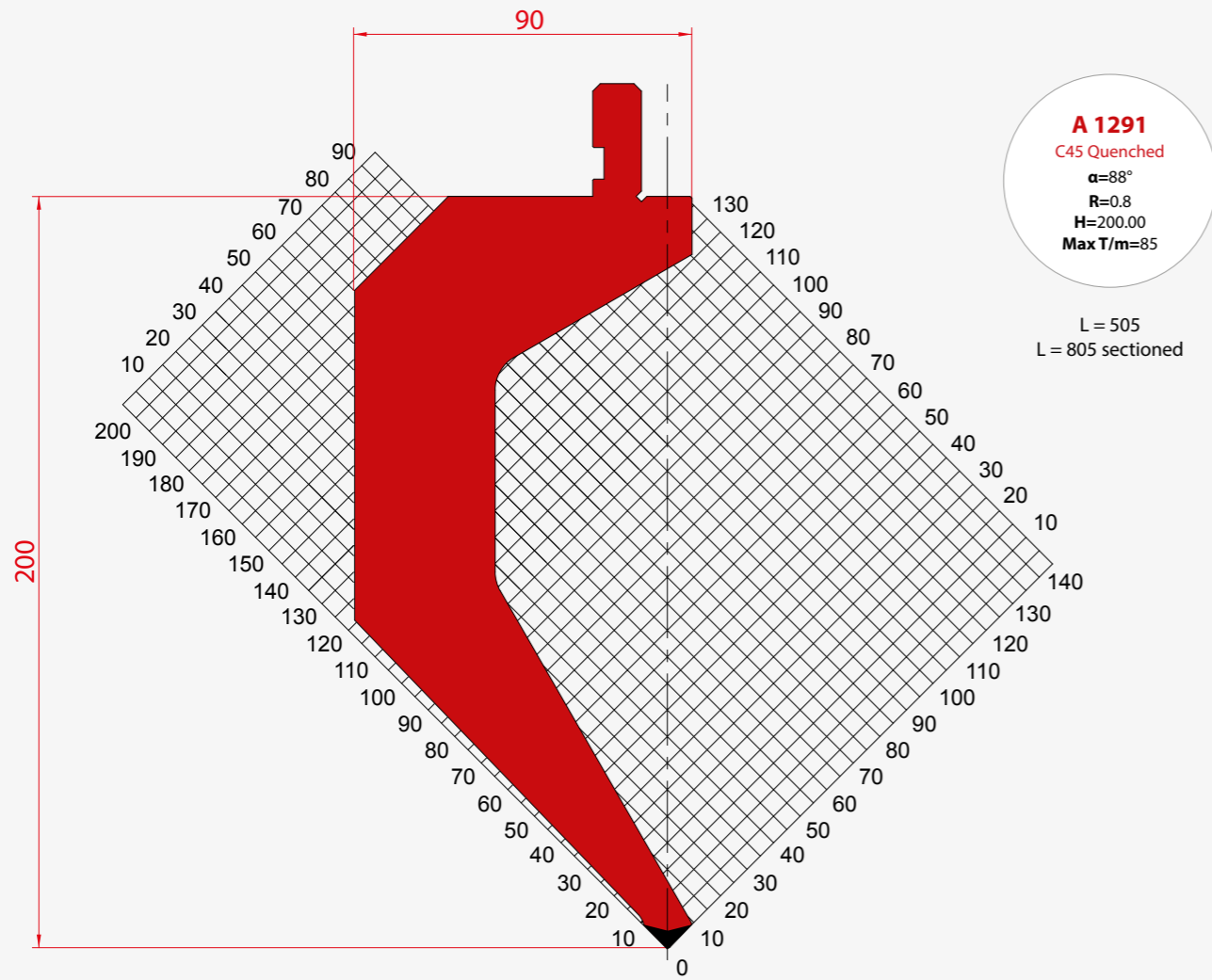
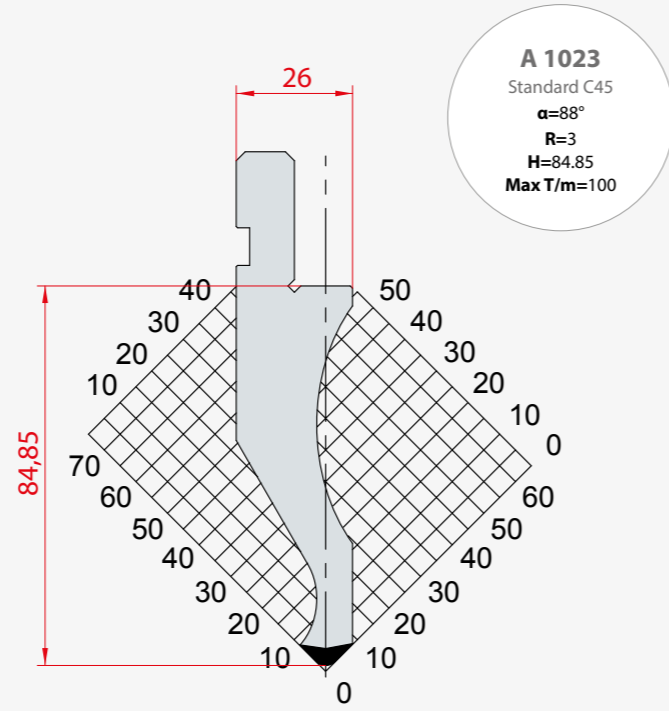
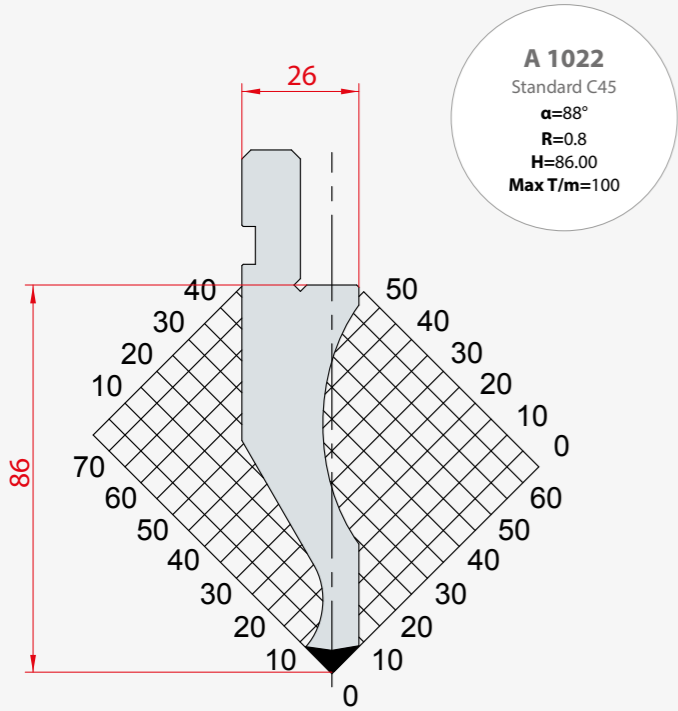
**A 1017**

Standard C45  
 $\alpha=88^\circ$   
R=0.8  
H=104.65  
Max T/m=50

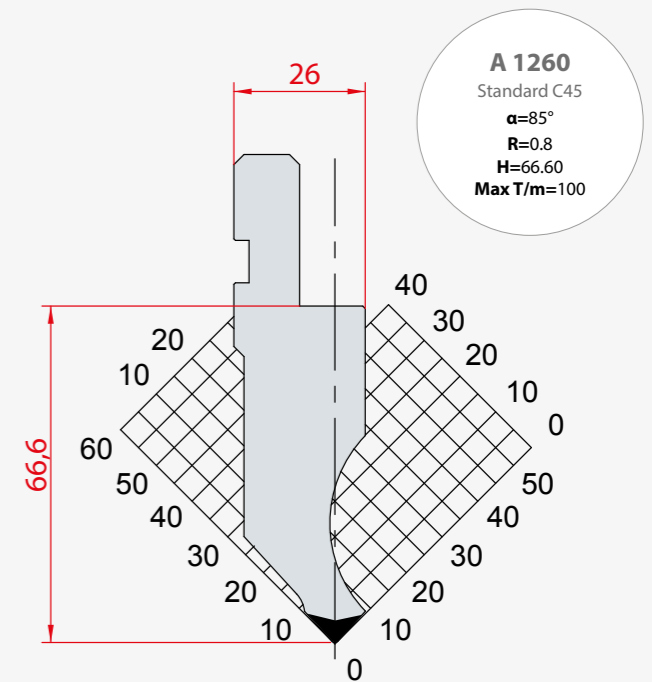
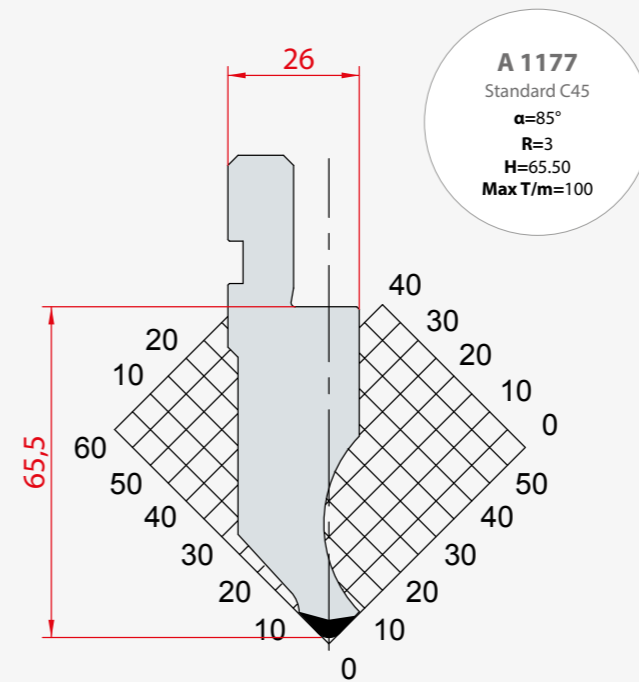


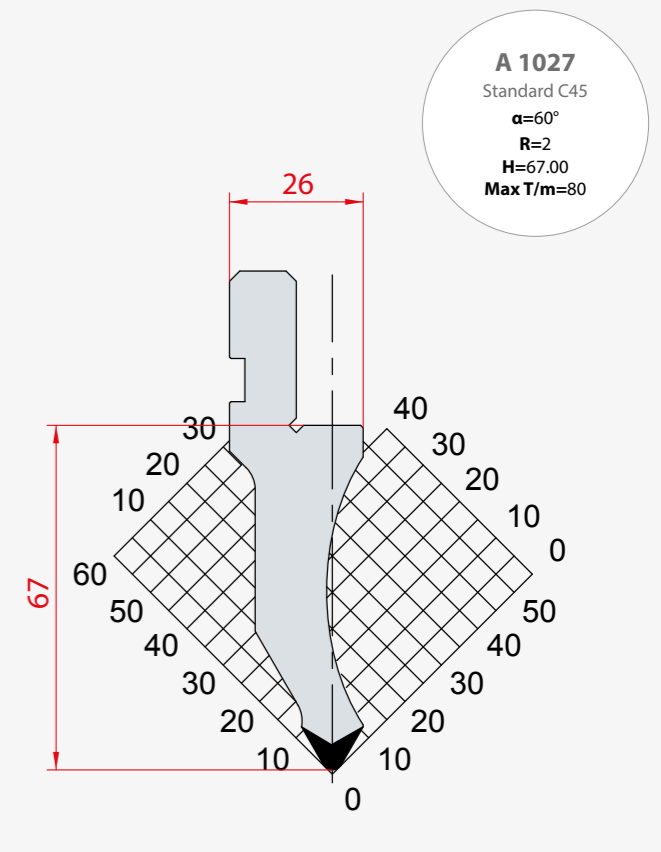
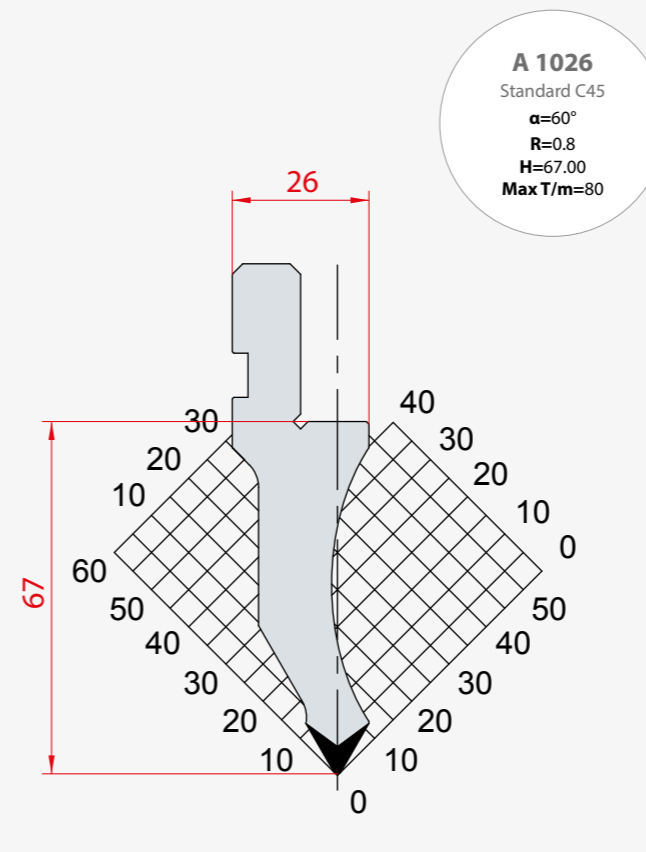
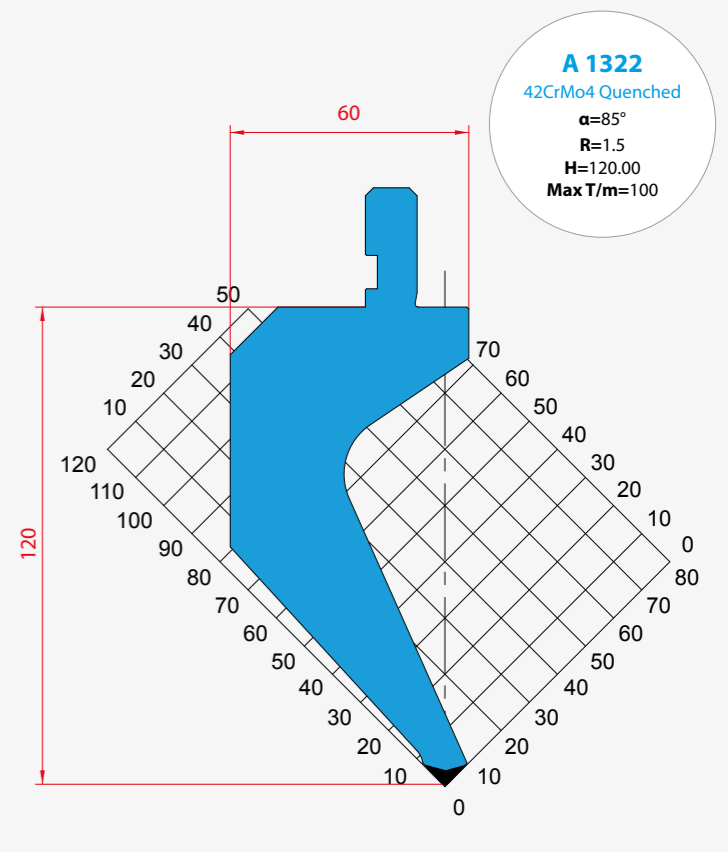
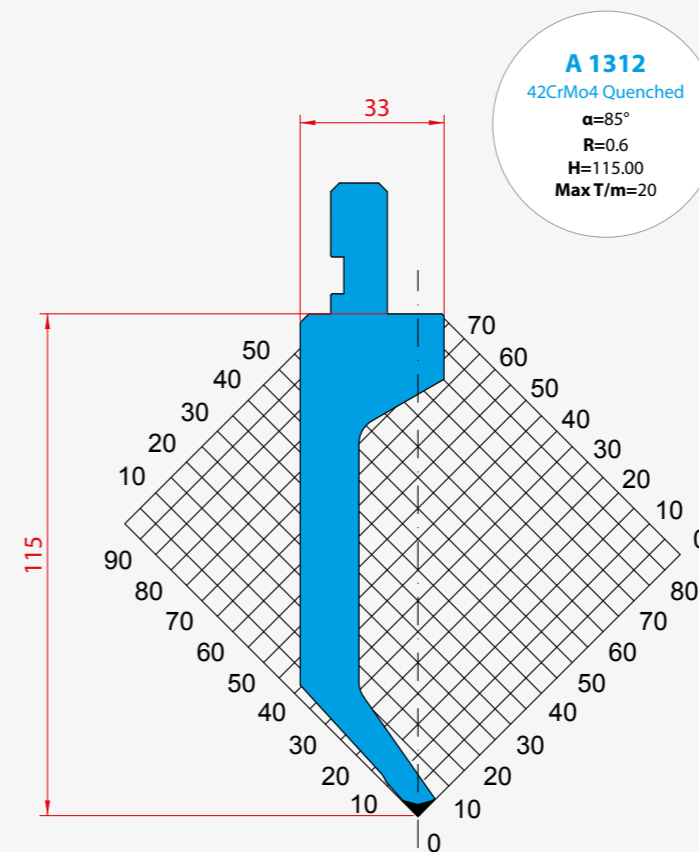
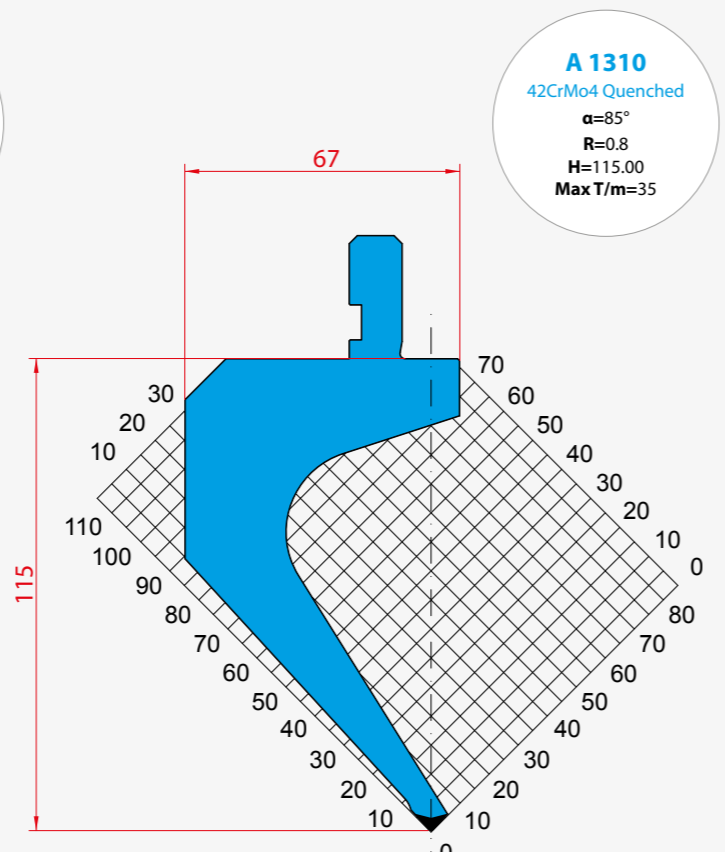
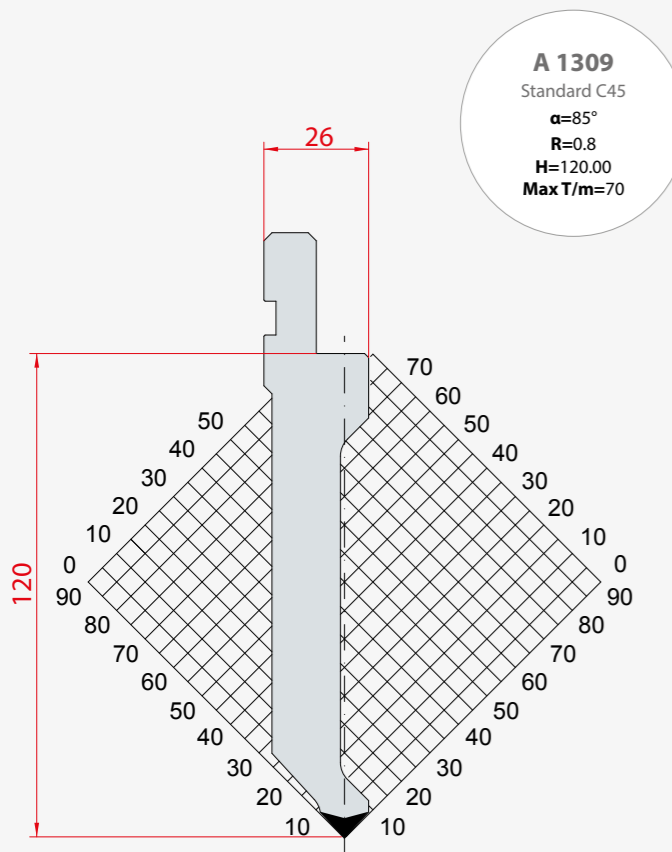
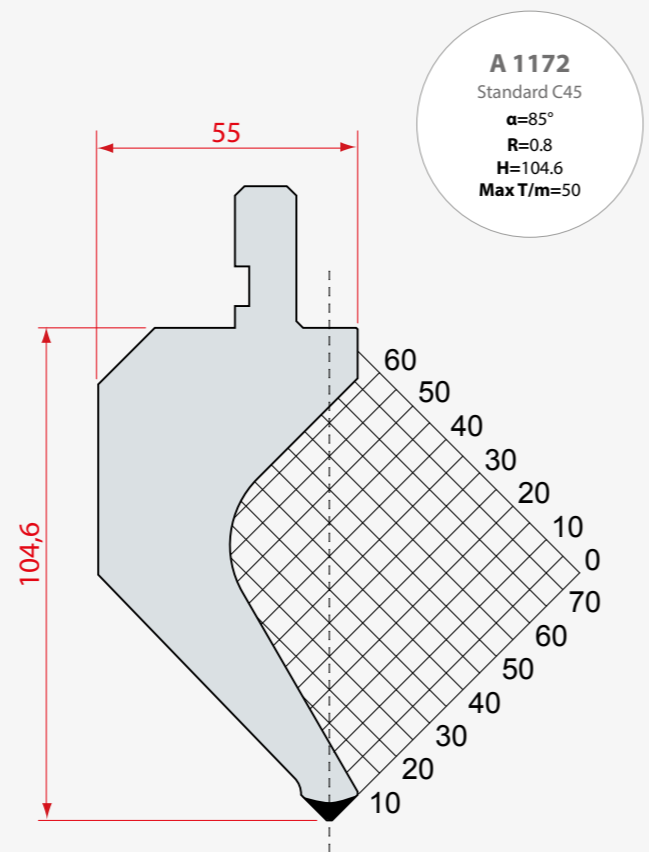
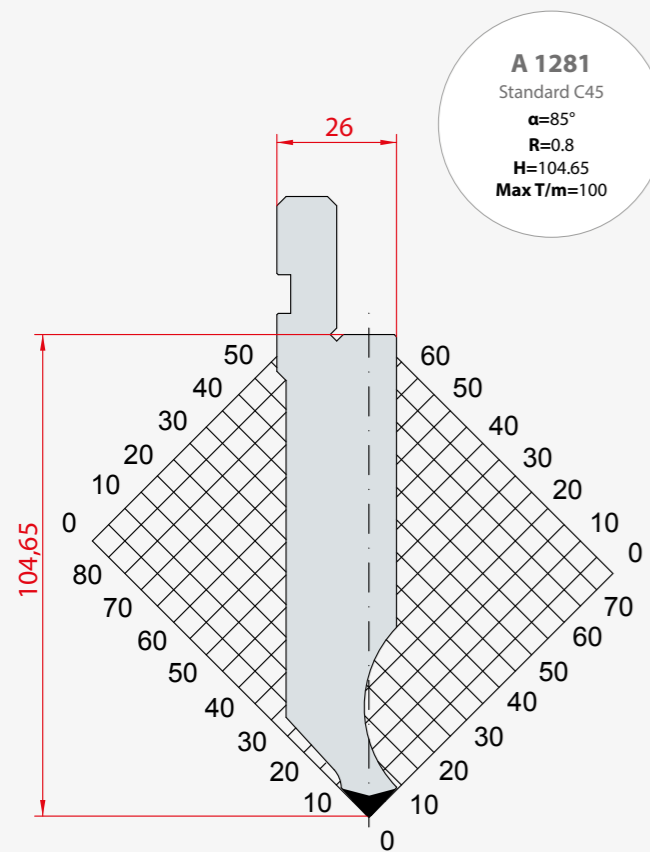






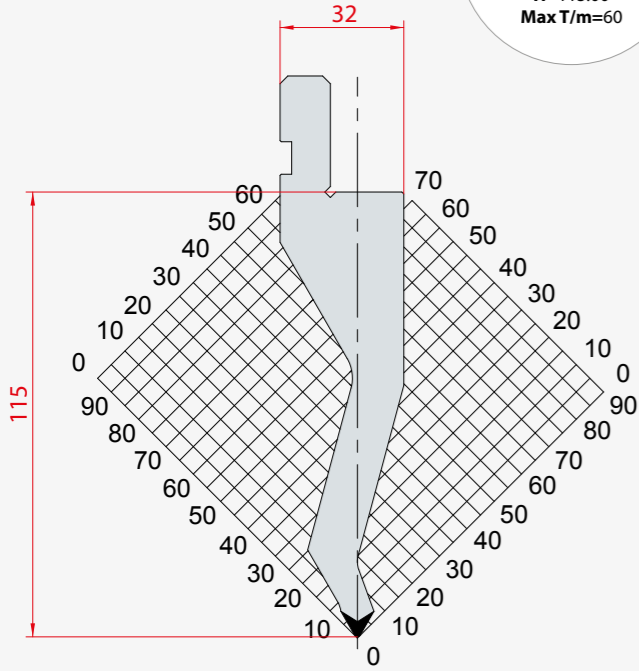
PUNCHES 85°





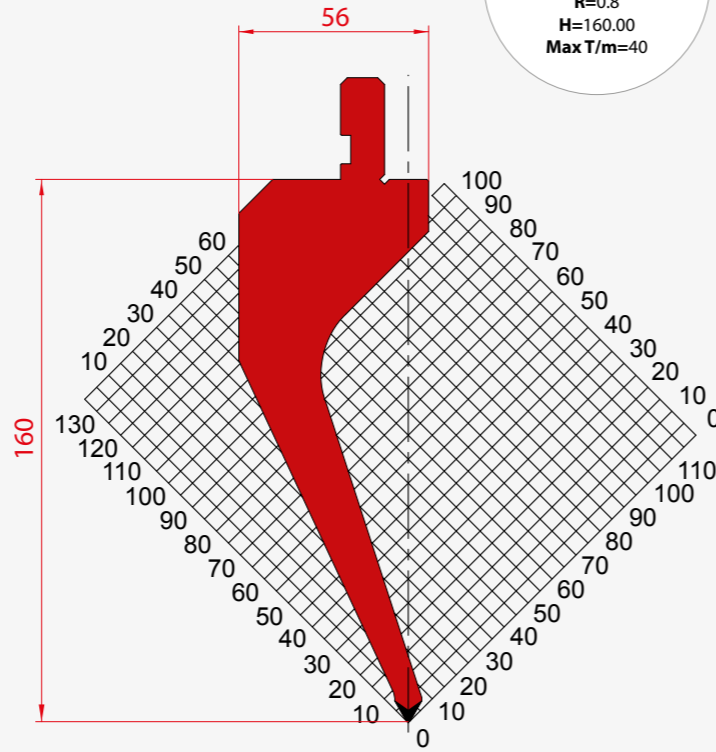
**A 1191**

Standard C45  
 $\alpha=60^\circ$   
R=0.8  
H=115.00  
Max T/m=60



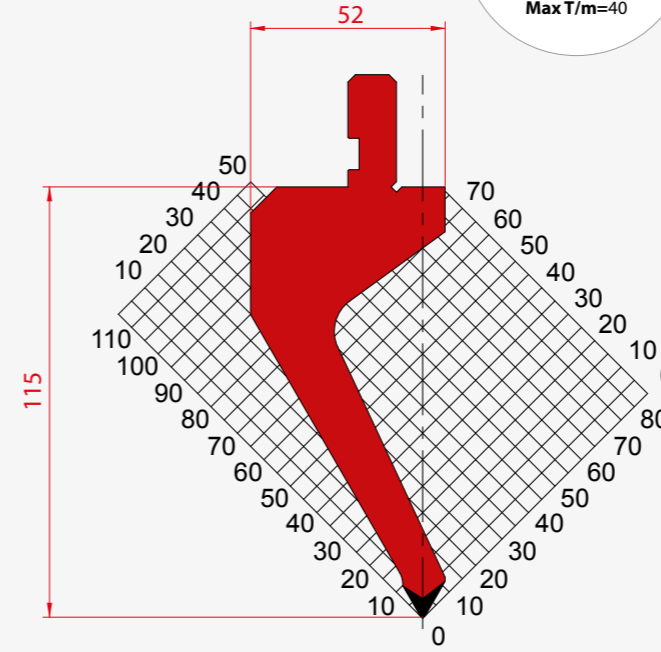
**A 1190**

C45 Quenched  
 $\alpha=60^\circ$   
R=0.8  
H=160.00  
Max T/m=40



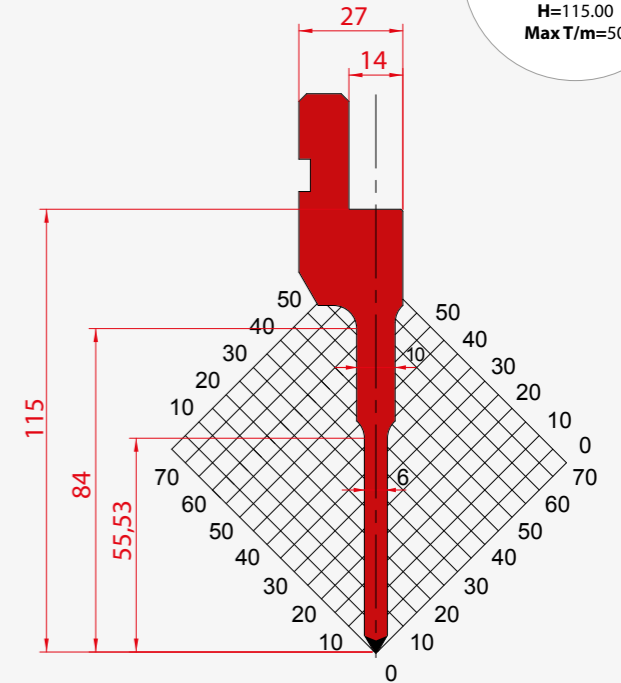
**A 1272**

C45 Quenched  
 $\alpha=60^\circ$   
R=0.8  
H=115.00  
Max T/m=40



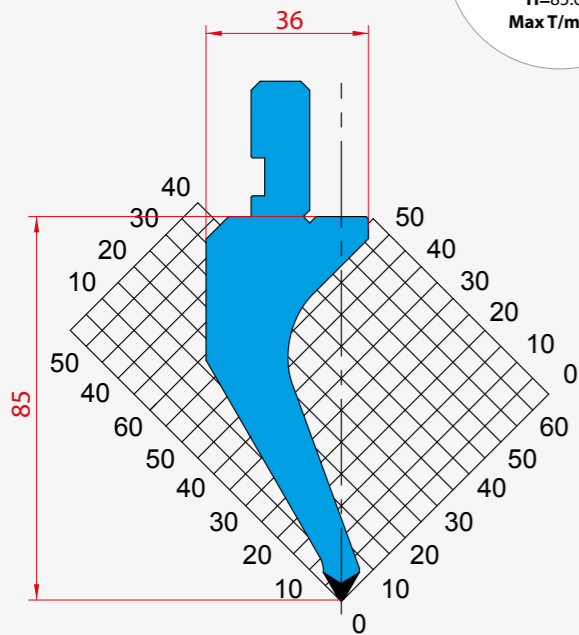
**A 1271**

C45 Quenched  
 $\alpha=60^\circ$   
R=0.8  
H=115.00  
Max T/m=50



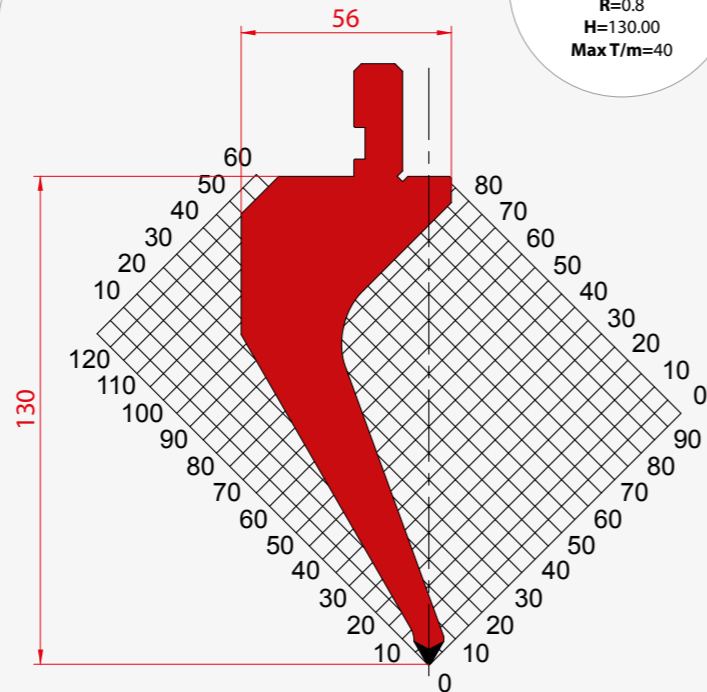
**A 1162**

42CrMo4 Quenched  
 $\alpha=60^\circ$   
R=0.8  
H=85.00  
Max T/m=40



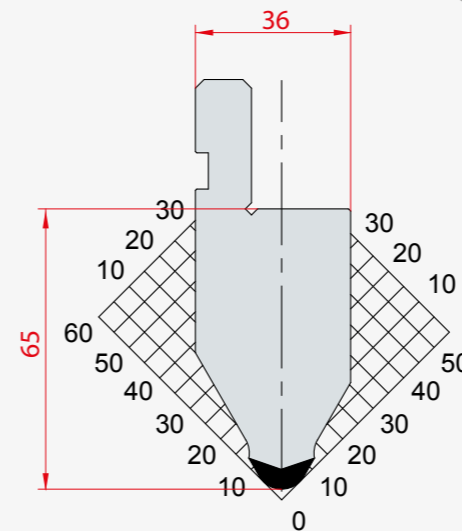
**A 1163**

C45 Quenched  
 $\alpha=60^\circ$   
R=0.8  
H=130.00  
Max T/m=40



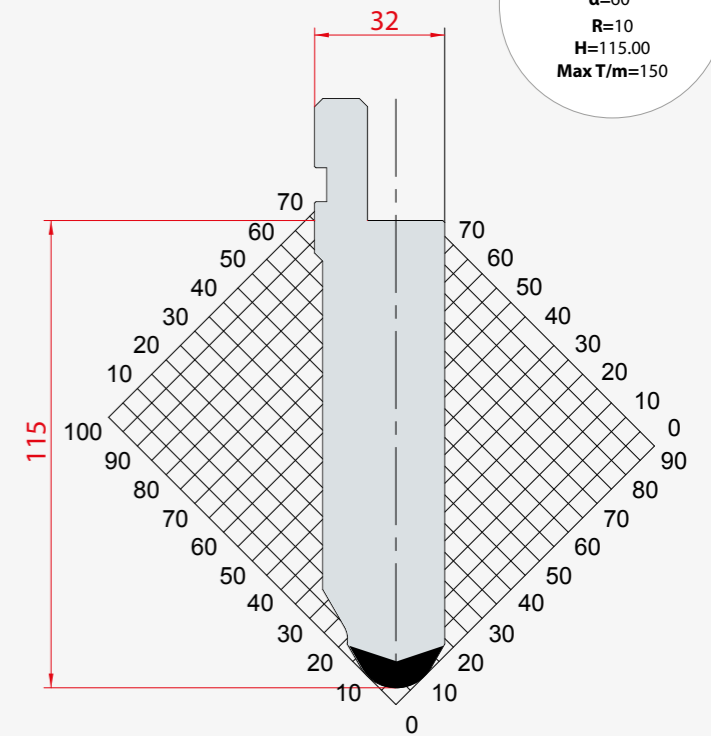
**A 1032**

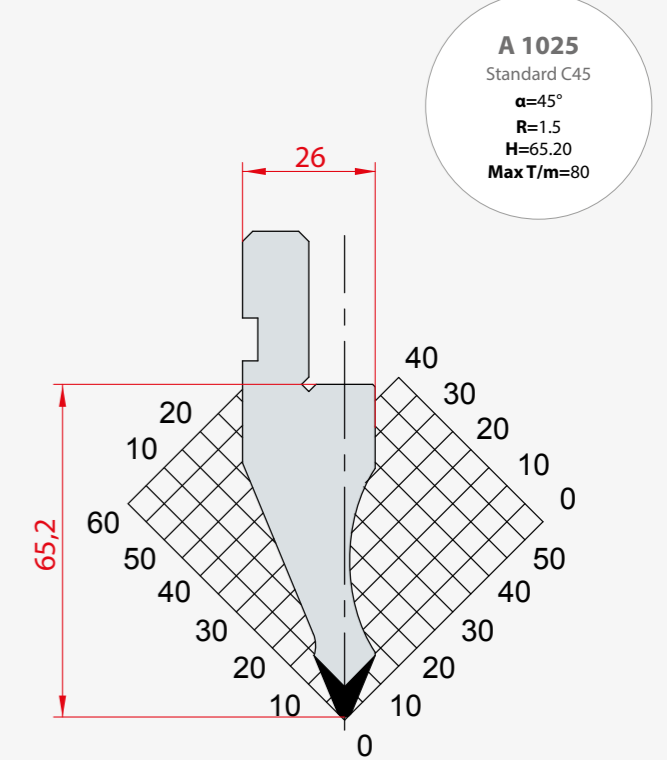
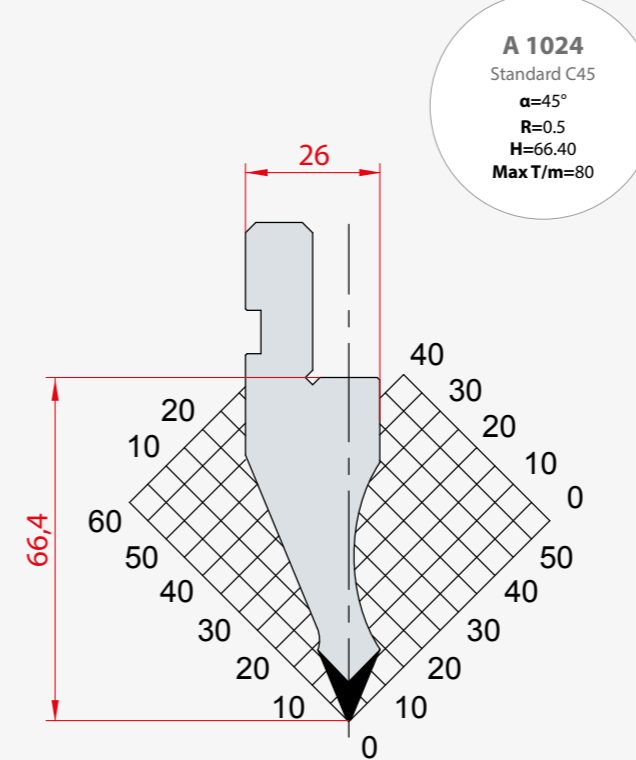
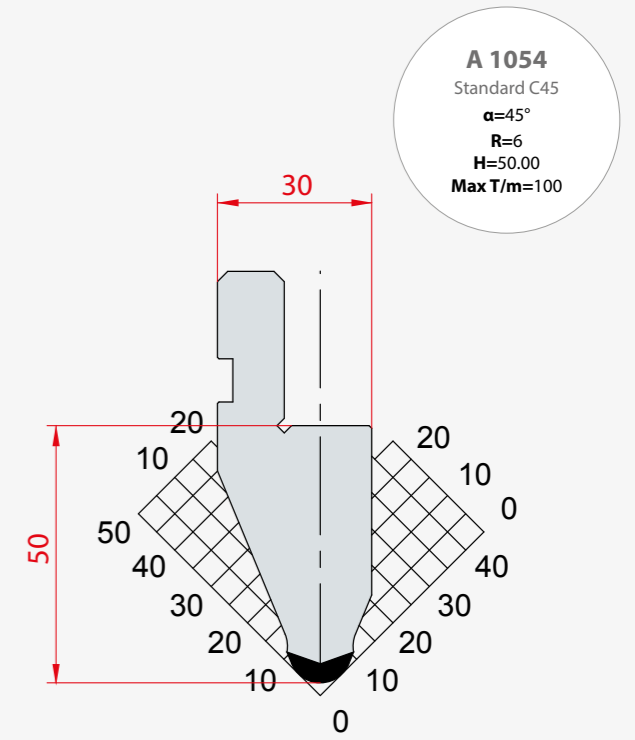
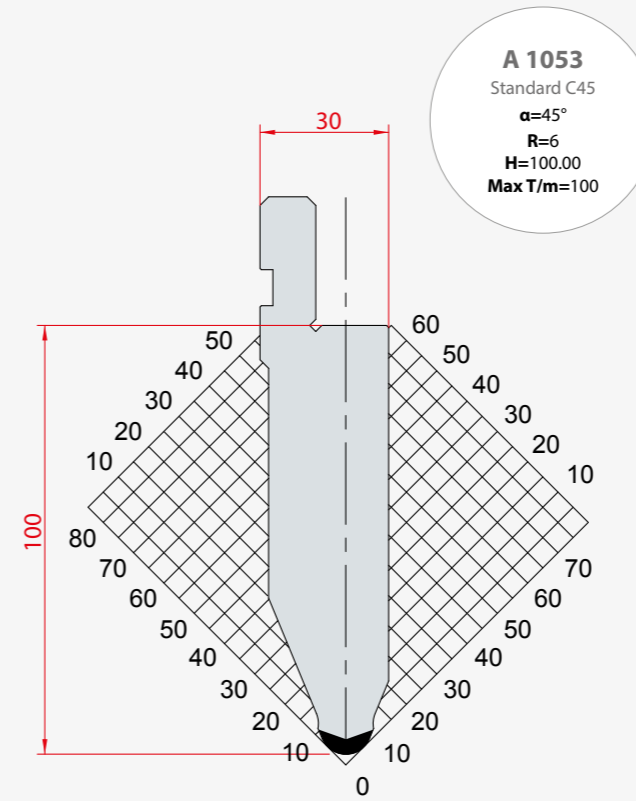
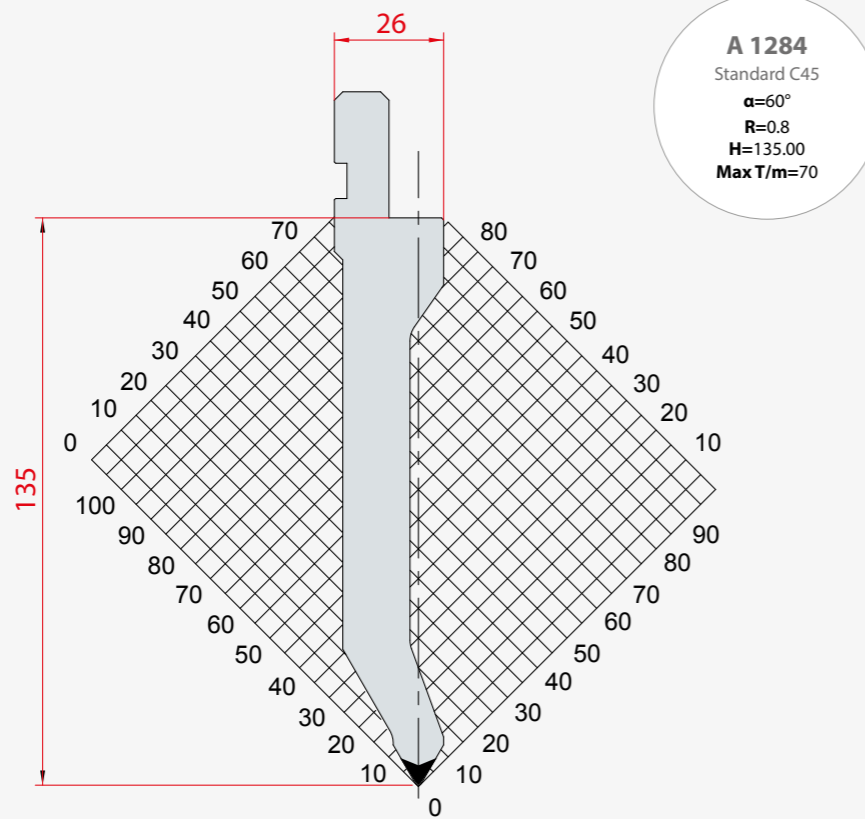
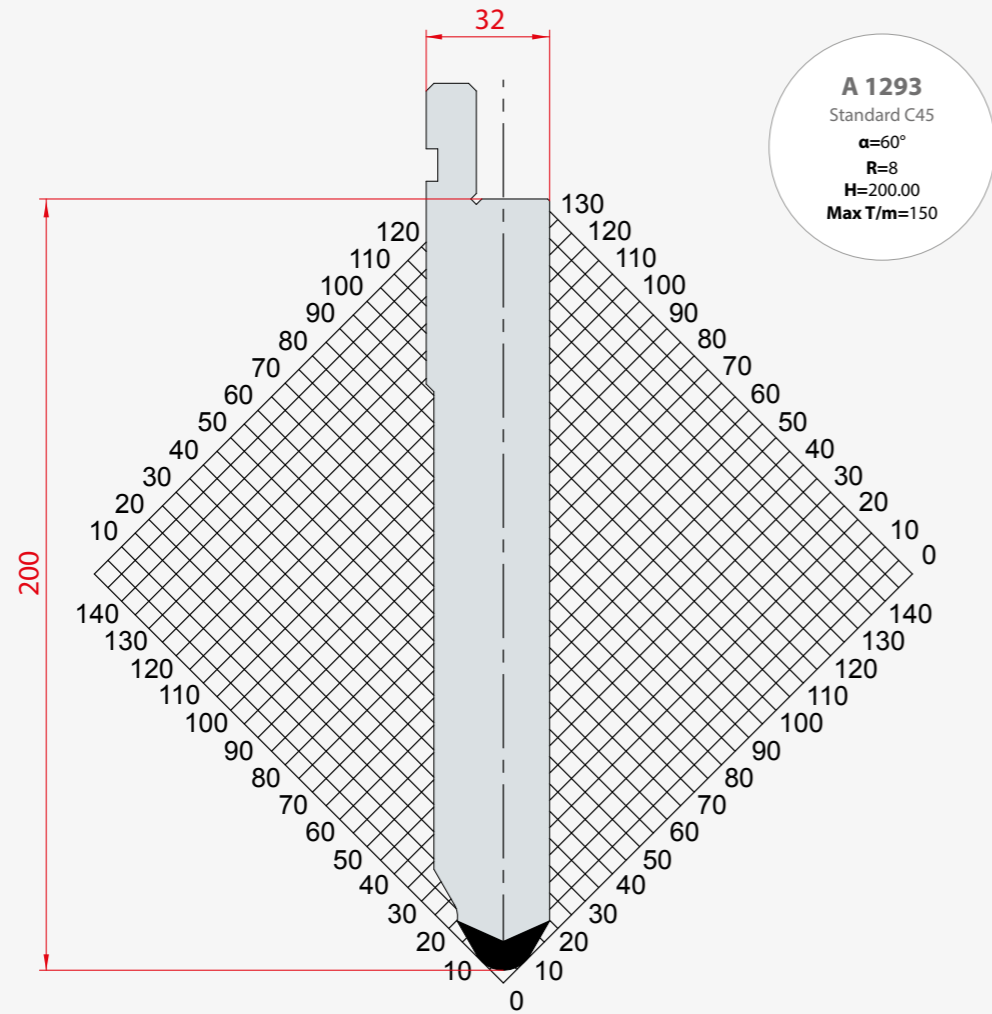
Standard C45  
 $\alpha=60^\circ$   
R=6  
H=65.00  
Max T/m=120

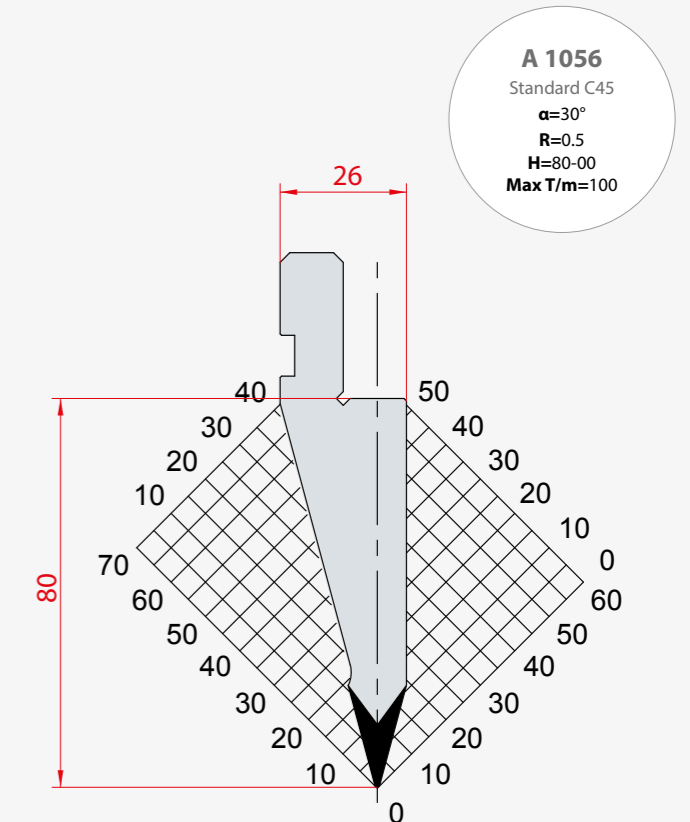
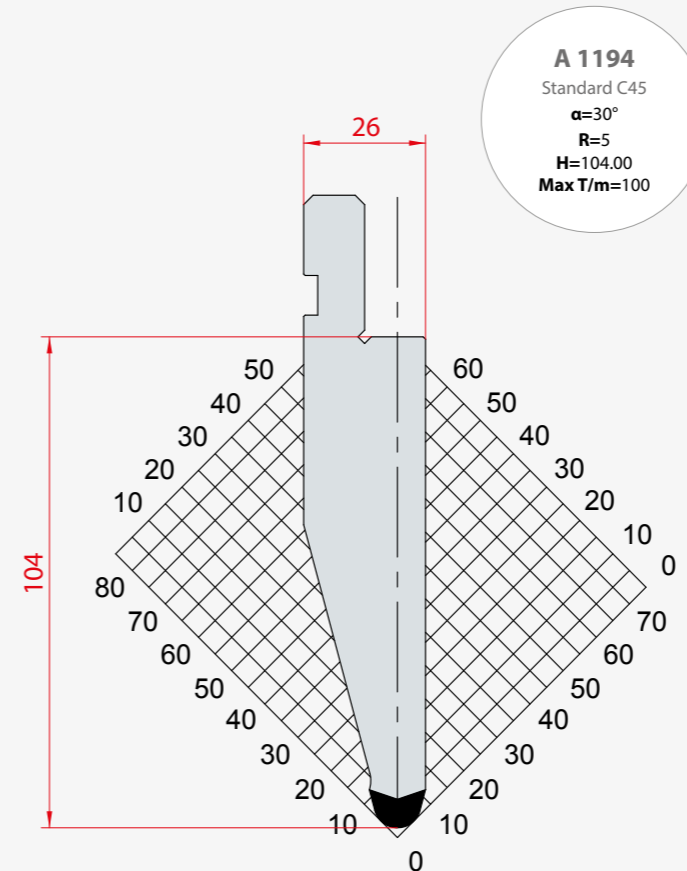
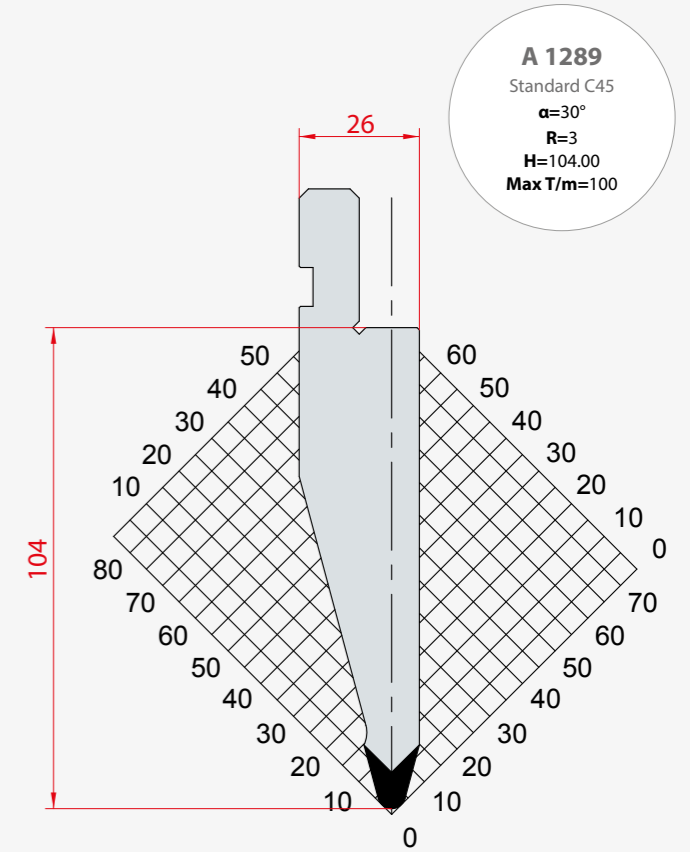
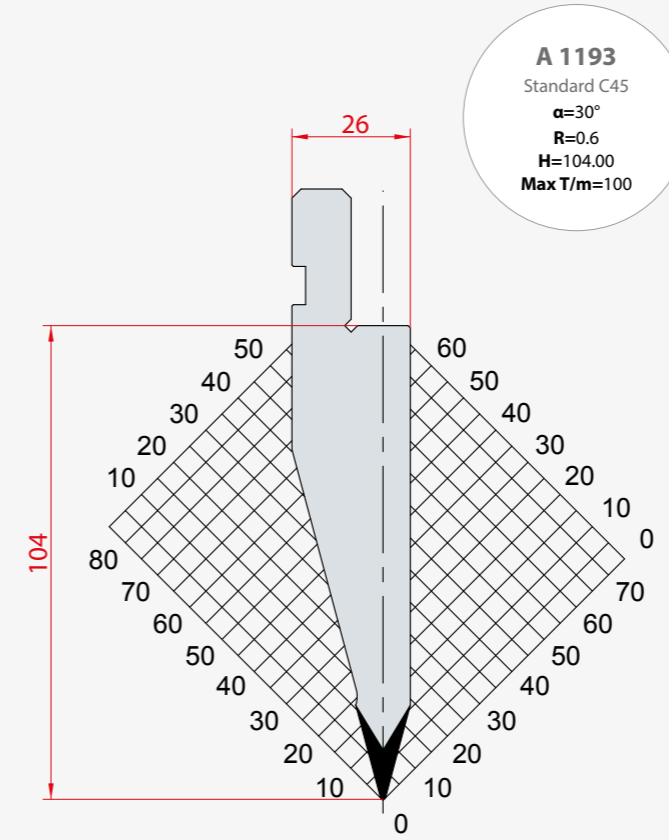
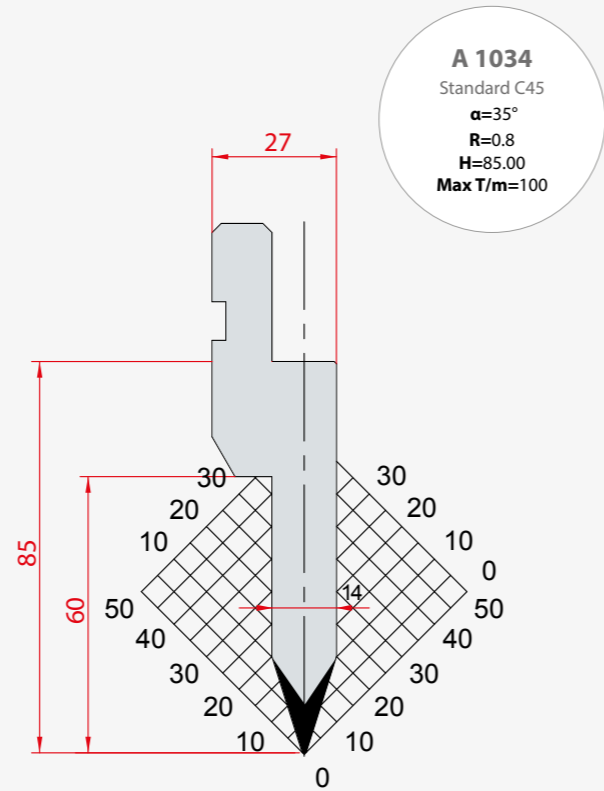
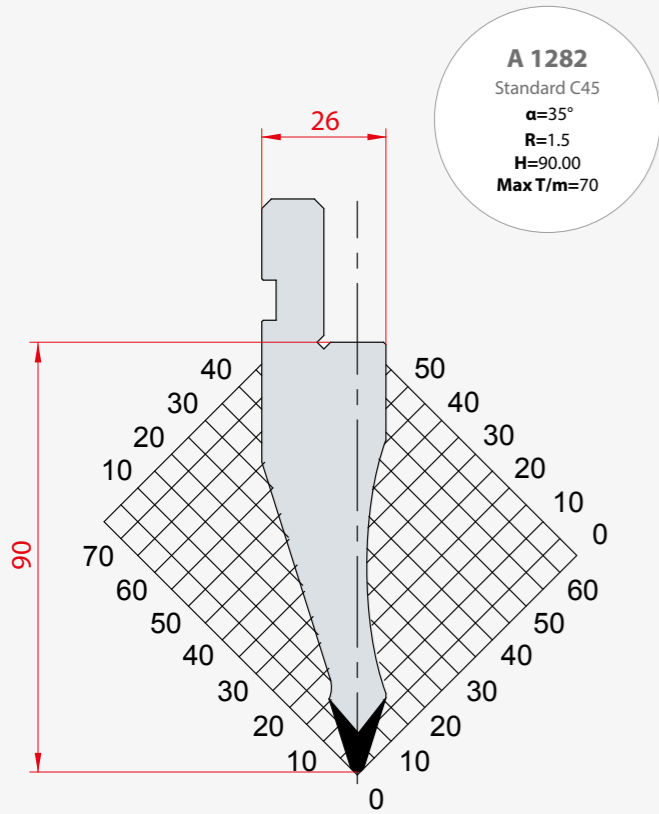
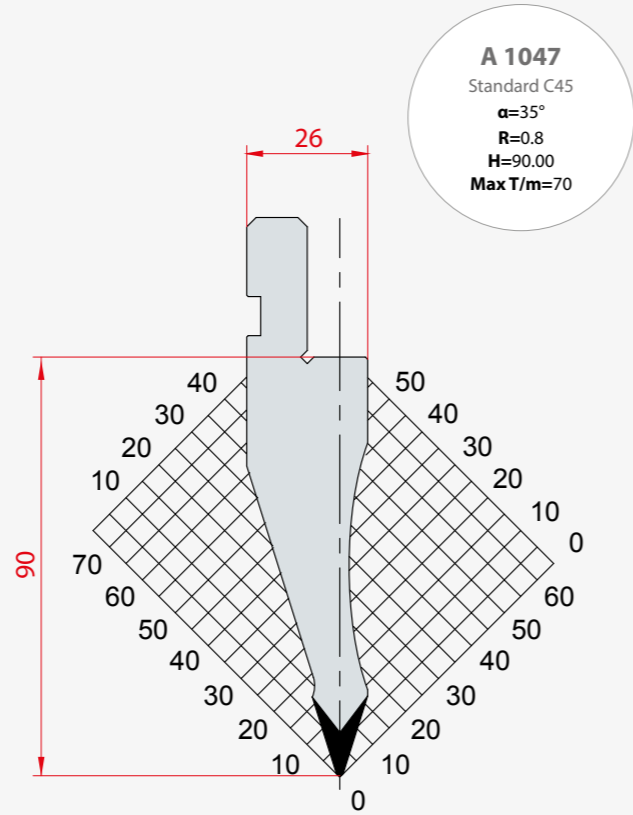
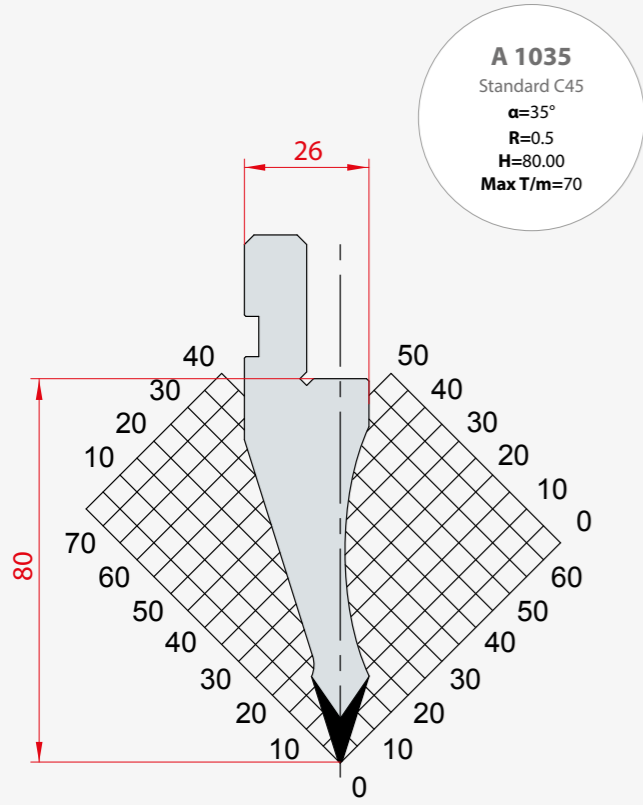


**A 1283**

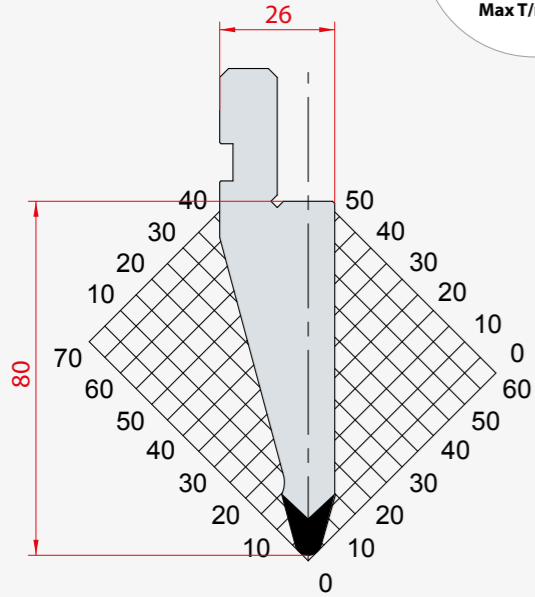
Standard C45  
 $\alpha=60^\circ$   
R=10  
H=115.00  
Max T/m=150



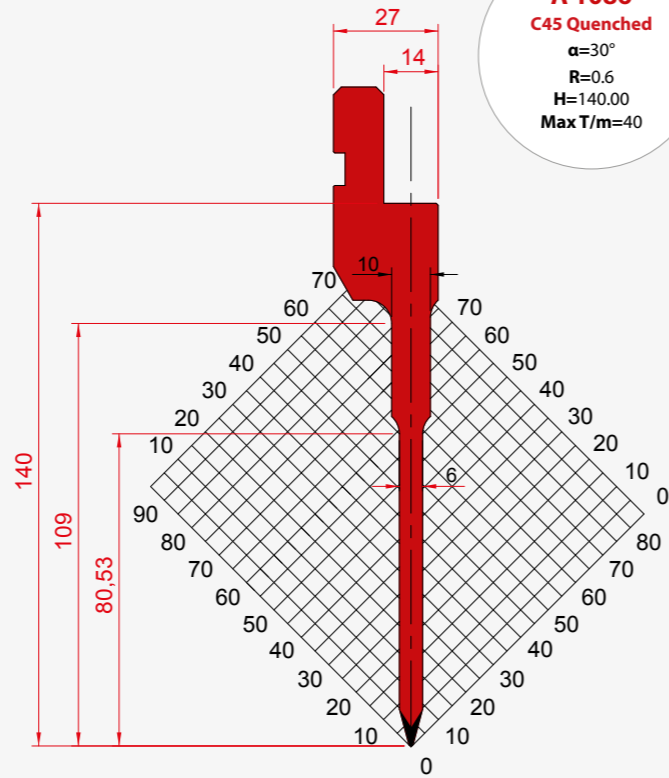




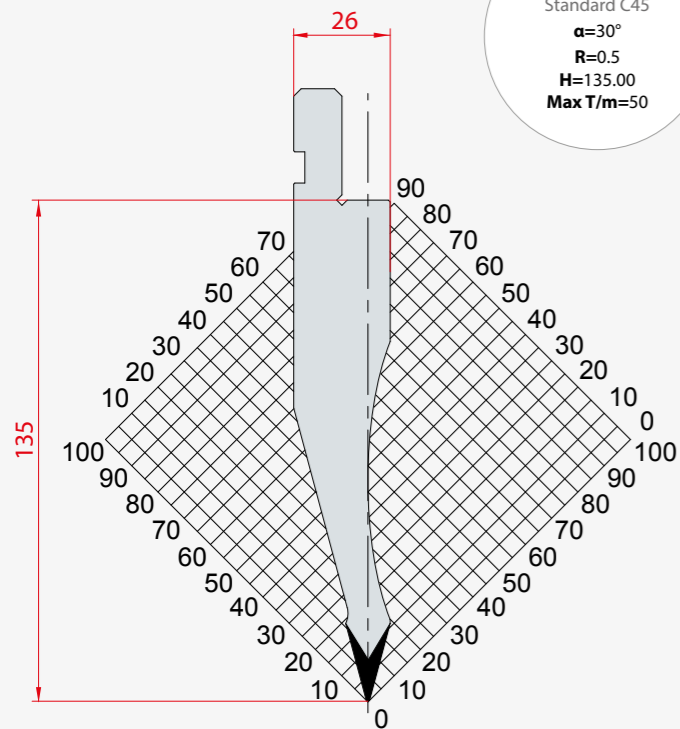
**A 1057**  
Standard C45  
 $\alpha=30^\circ$   
R=3  
H=80.00  
Max T/m=100



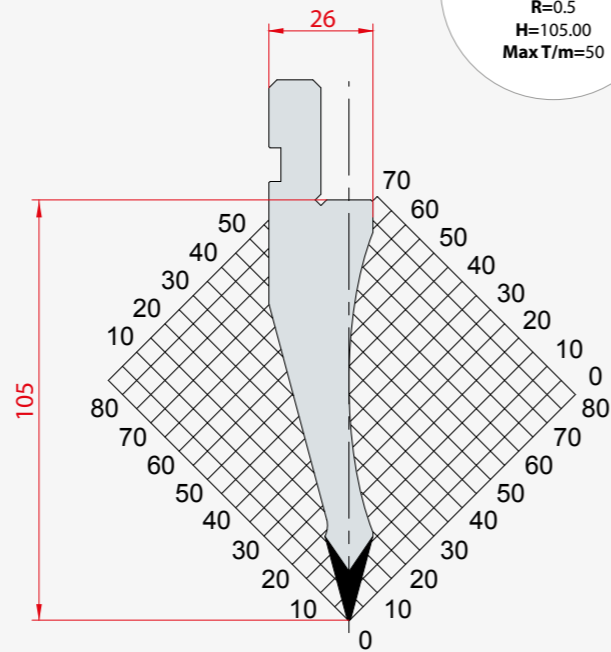
**A 1086**  
C45 Quenched  
 $\alpha=30^\circ$   
R=0.6  
H=140.00  
Max T/m=40



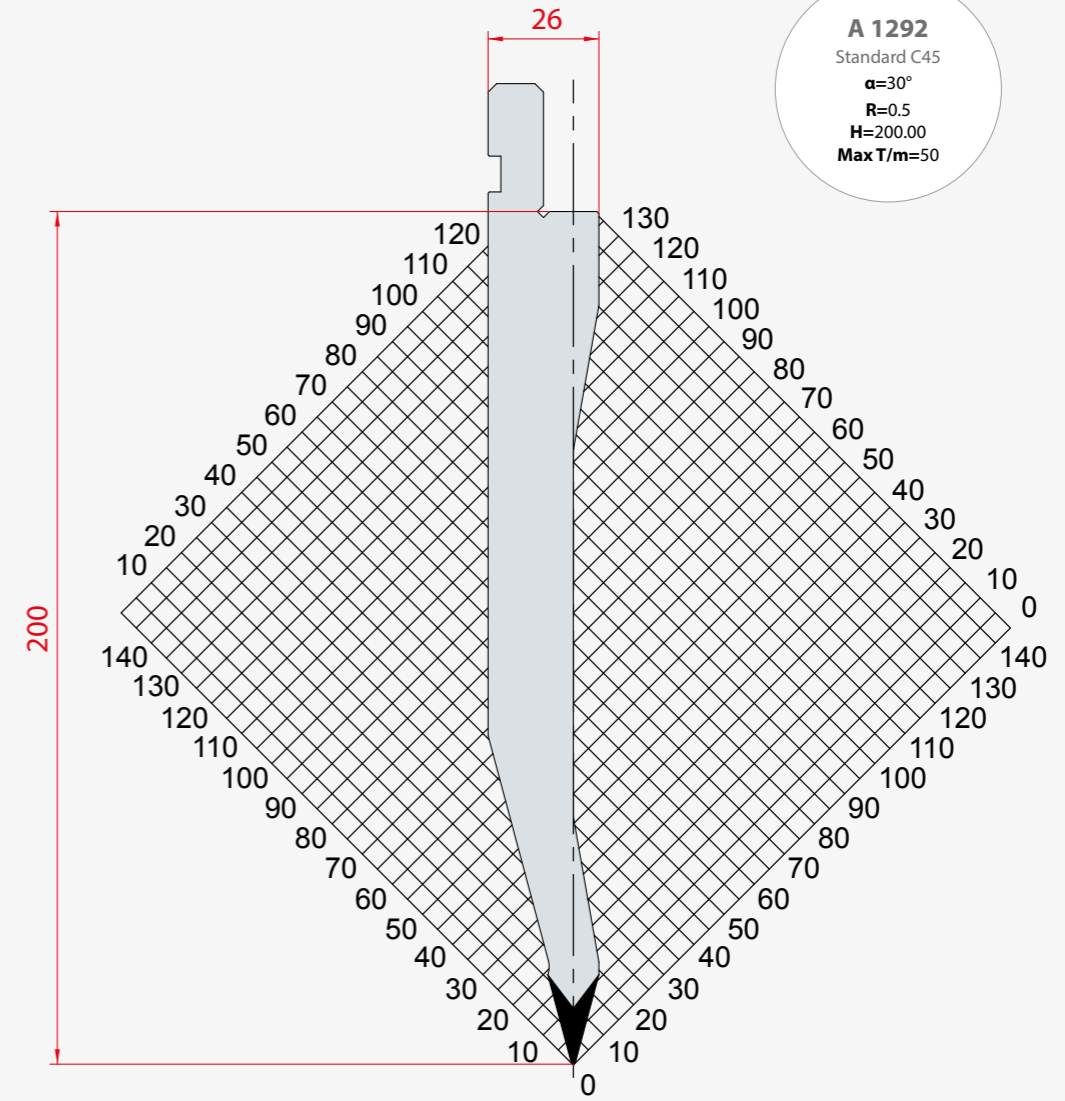
**A 1052**  
Standard C45  
 $\alpha=30^\circ$   
R=0.5  
H=135.00  
Max T/m=50



**A 1055**  
Standard C45  
 $\alpha=30^\circ$   
R=0.5  
H=105.00  
Max T/m=50

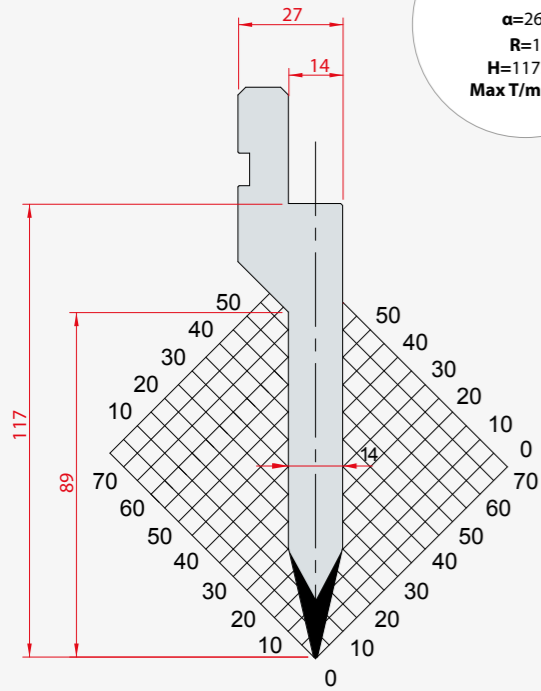


**A 1292**  
Standard C45  
 $\alpha=30^\circ$   
R=0.5  
H=200.00  
Max T/m=50



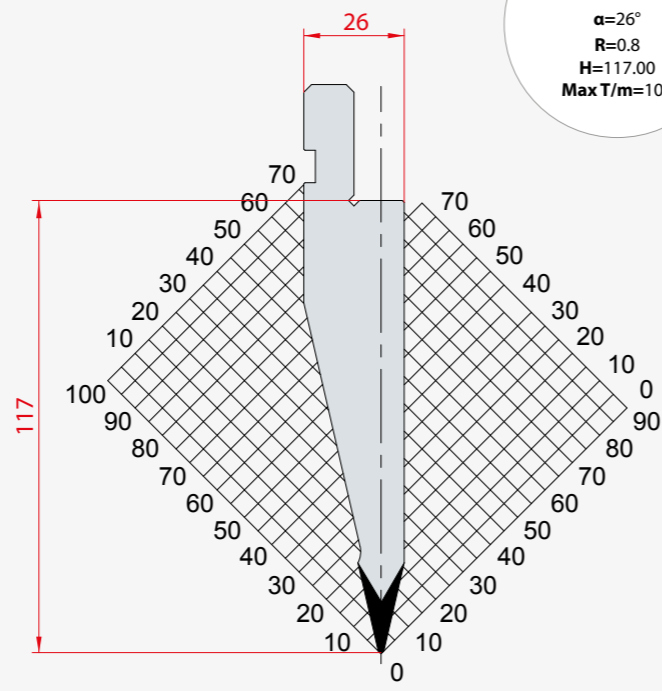
**A 1033**

Standard C45  
 $\alpha=26^\circ$   
R=1  
H=117.00  
Max T/m=100



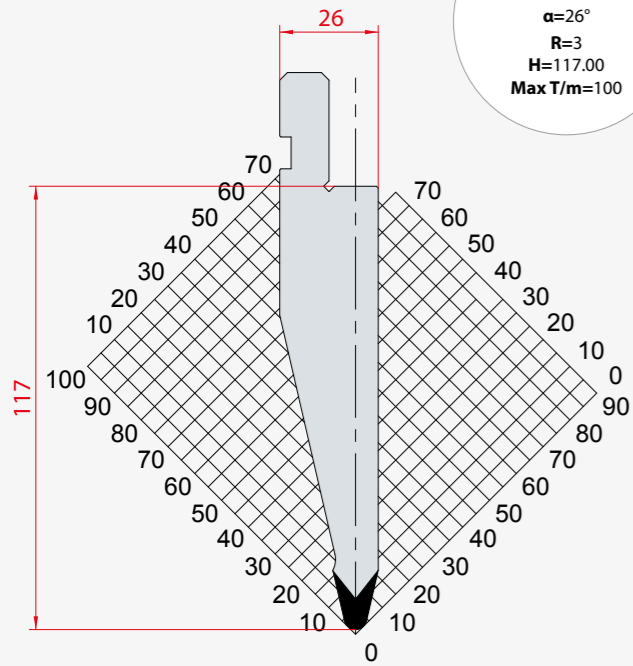
**A 1178**

Standard C45  
 $\alpha=26^\circ$   
R=0.8  
H=117.00  
Max T/m=100



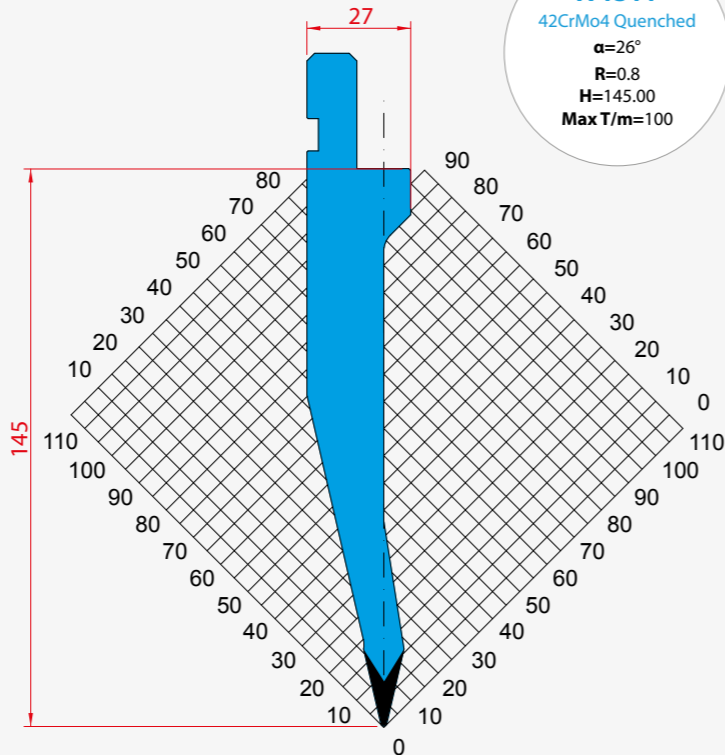
**A 1192**

Standard C45  
 $\alpha=26^\circ$   
R=3  
H=117.00  
Max T/m=100

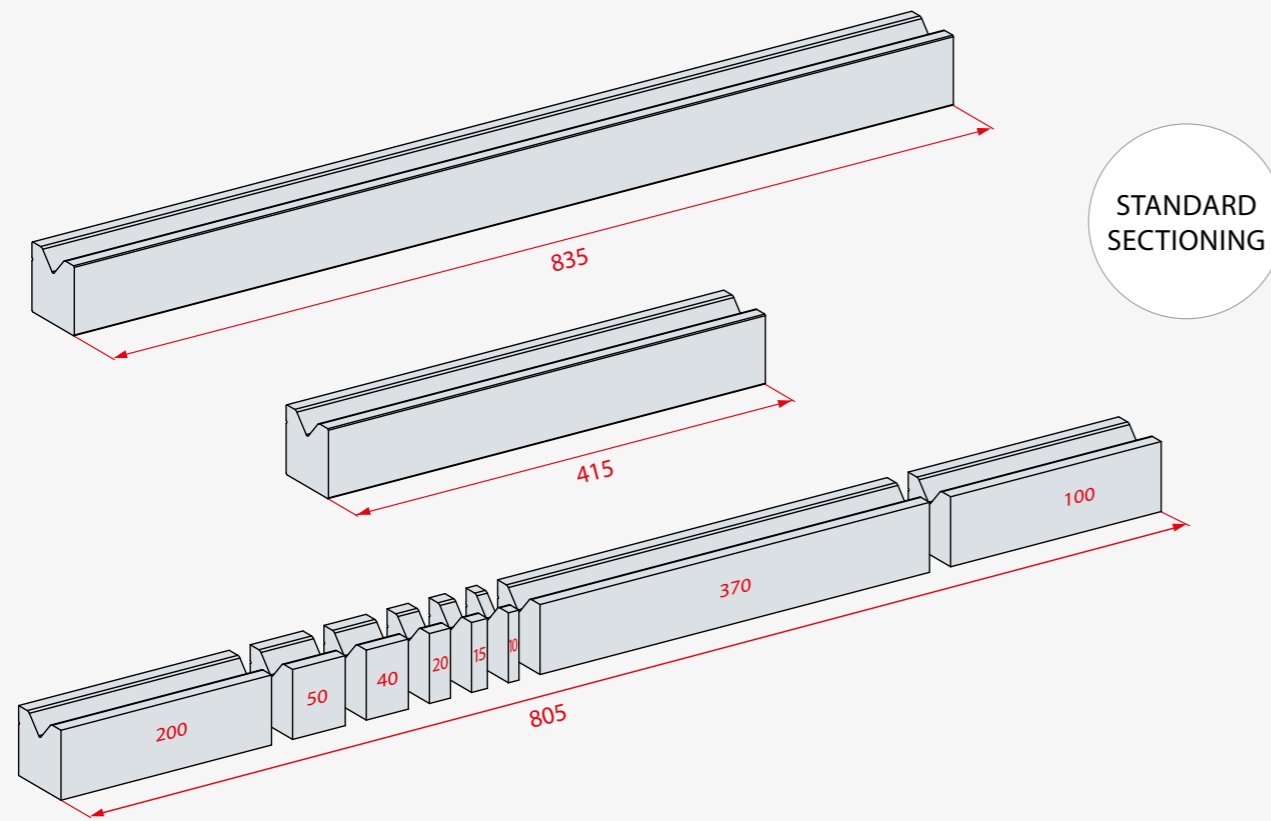


**A 1311**

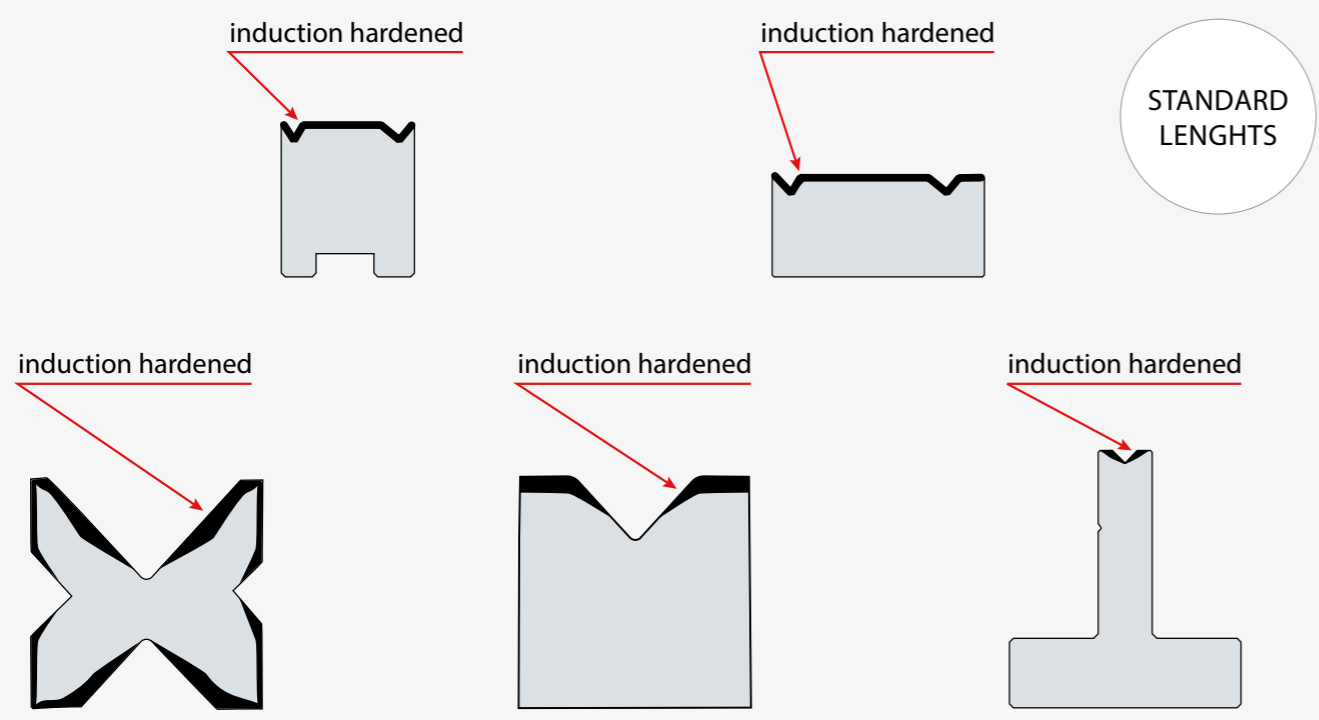
42CrMo4 Quenched  
 $\alpha=26^\circ$   
R=0.8  
H=145.00  
Max T/m=100







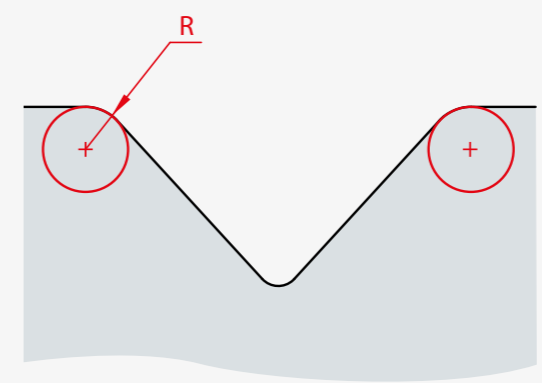
STANDARD SECTIONING



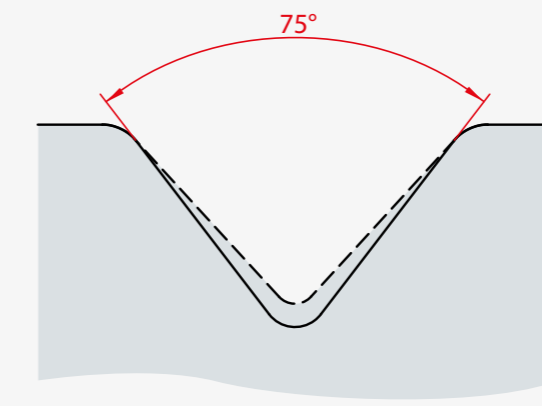
STANDARD LENGTHS



SPECIAL SEGMENTATION



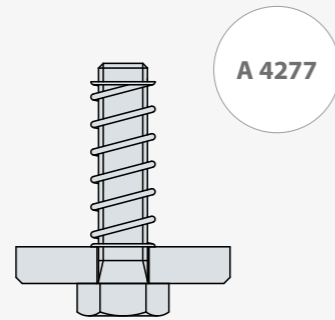
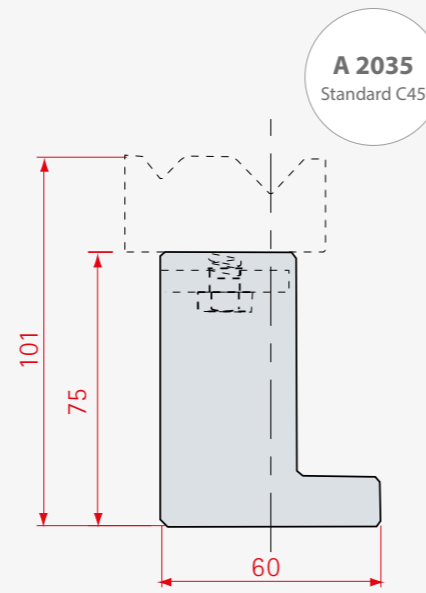
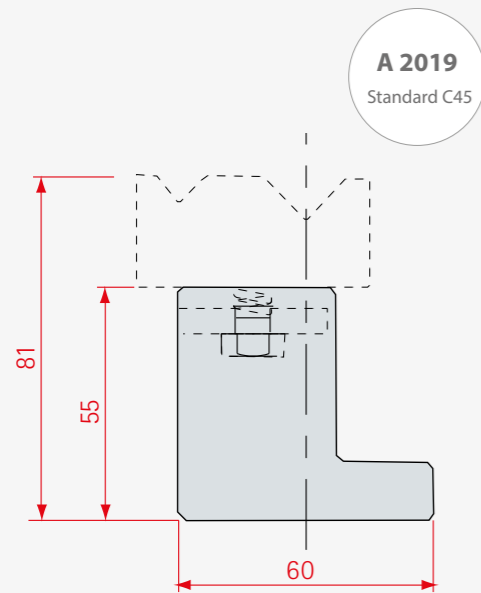
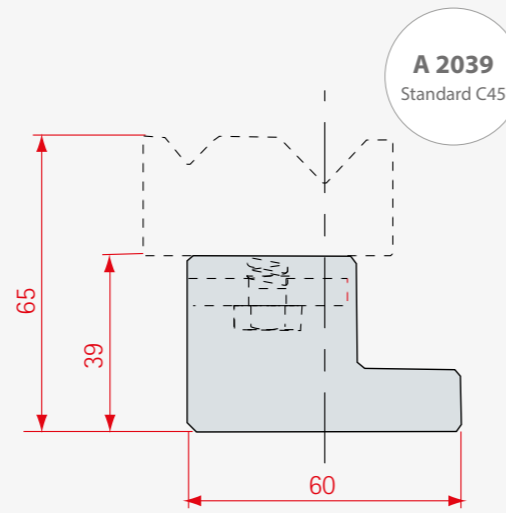
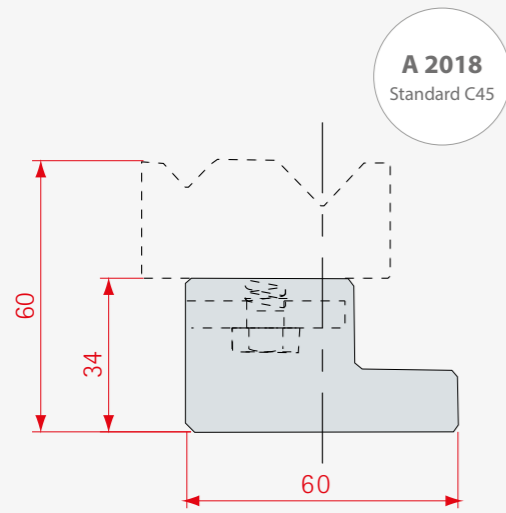
RADIUS MODIFICATION



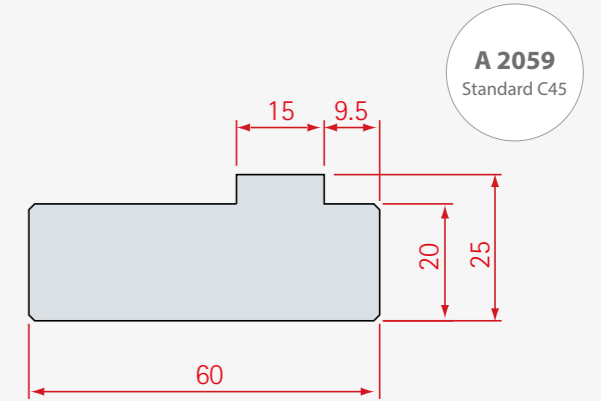
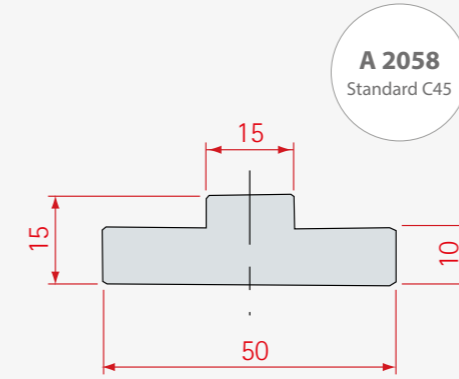
ANGLE MODIFICATION

MATERIAL TYPE :

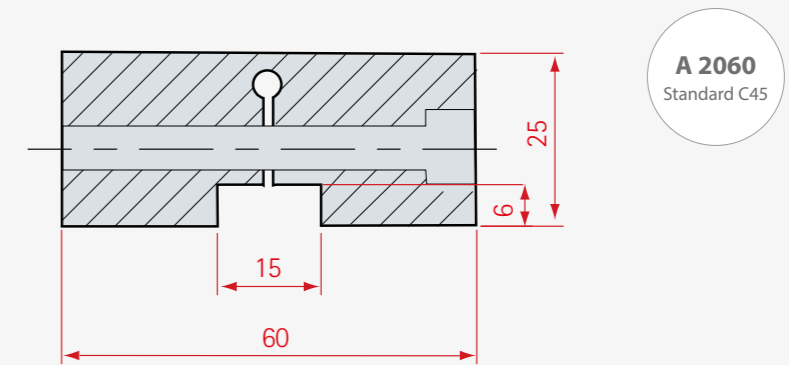
- Standard C45
- C45 Quenched
- 42CrMo4 Quenched



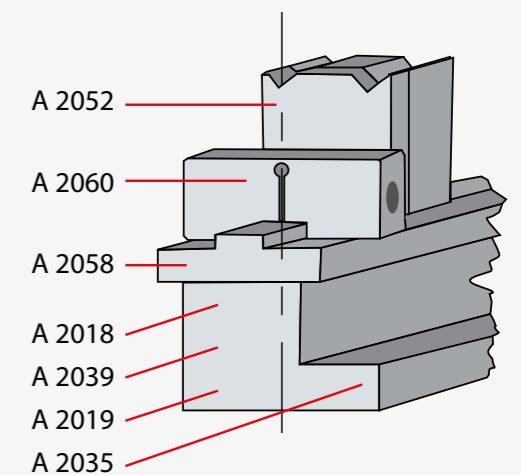
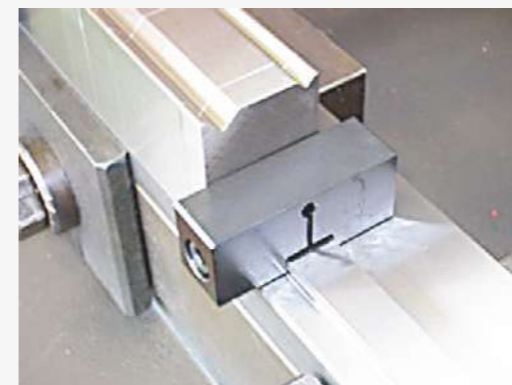
SPRING + WASCHER + SCREW



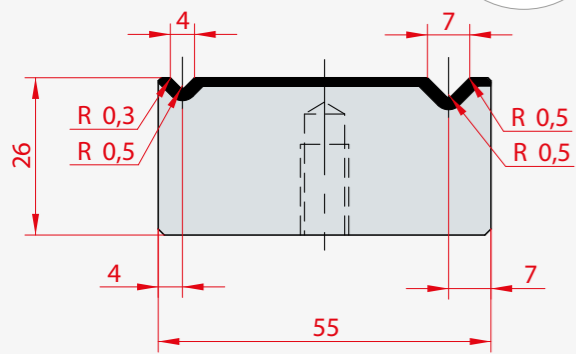
FIXED BAR FOR SELF-CENTERING DIES



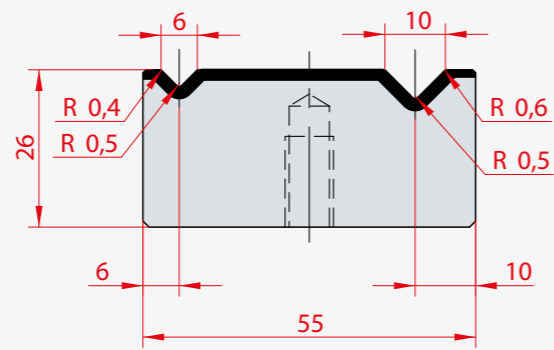
ASSEMBLY EXAMPLE



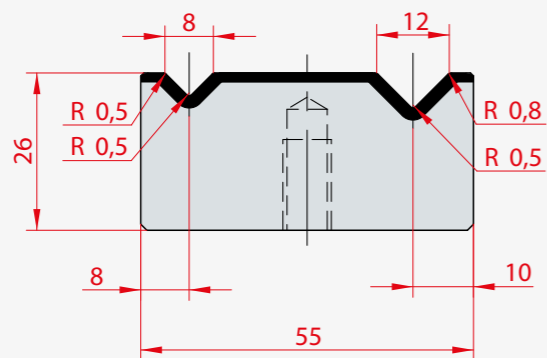
**A 2010**  
Standard C45  
Max T/m=100



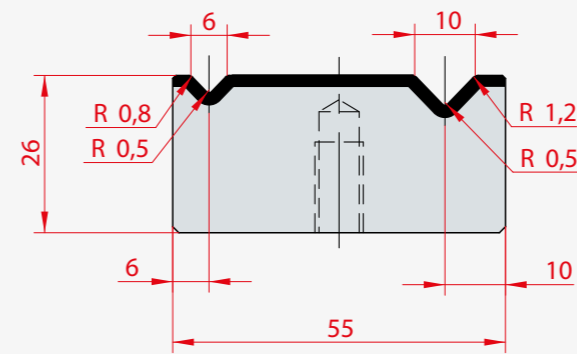
**A 2011**  
Standard C45  
Max T/m=100



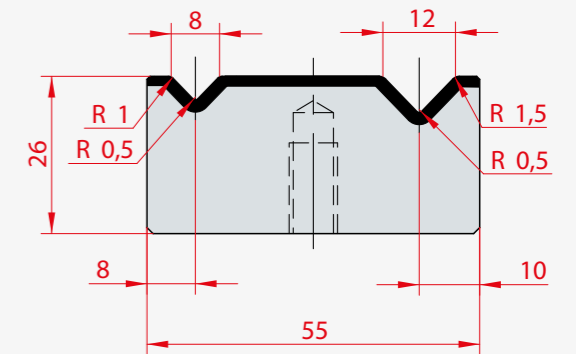
**A 2012**  
Standard C45  
Max T/m=100



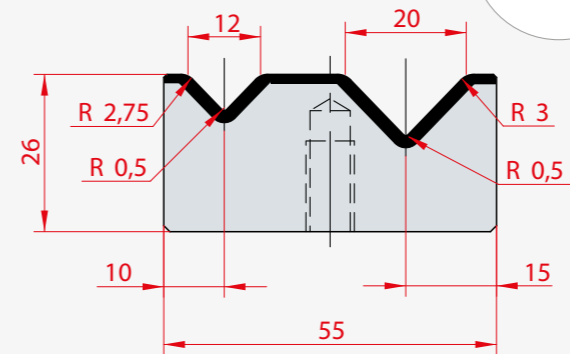
**A 2046**  
Standard C45  
Max T/m=100



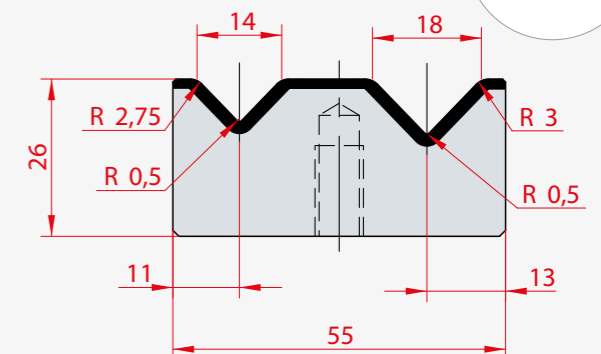
**A 2041**  
Standard C45  
Max T/m=100



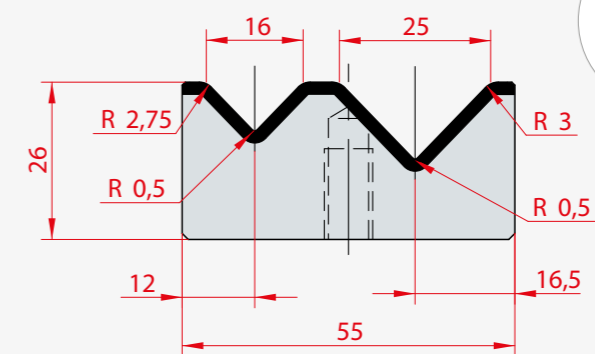
**A 2013**  
Standard C45  
Max T/m=100



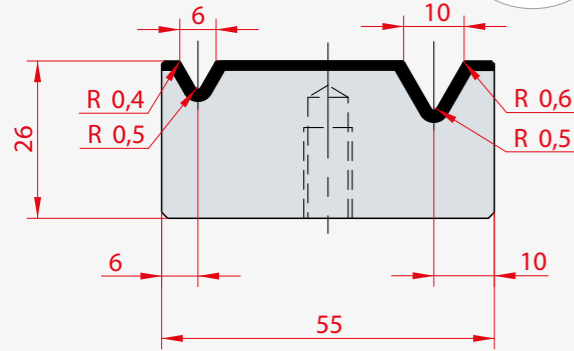
**A 2032**  
Standard C45  
Max T/m=100



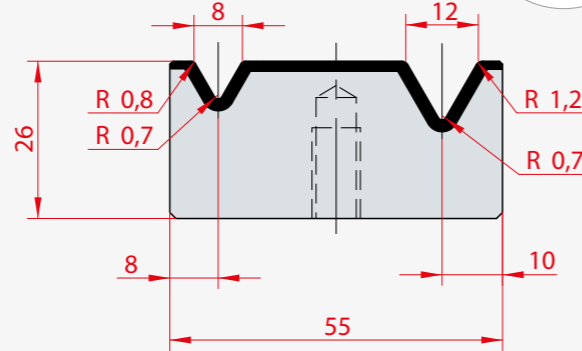
**A 2014**  
Standard C45  
Max T/m=100



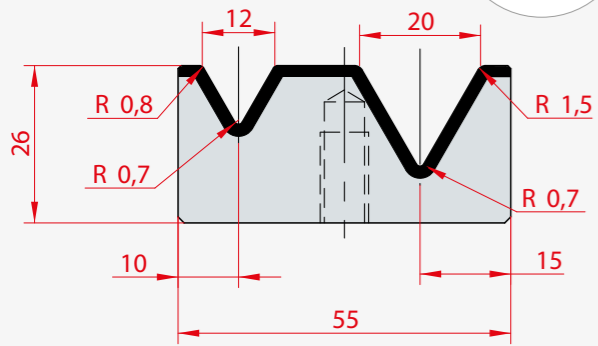
**A 2015**  
Standard C45  
Max T/m=60



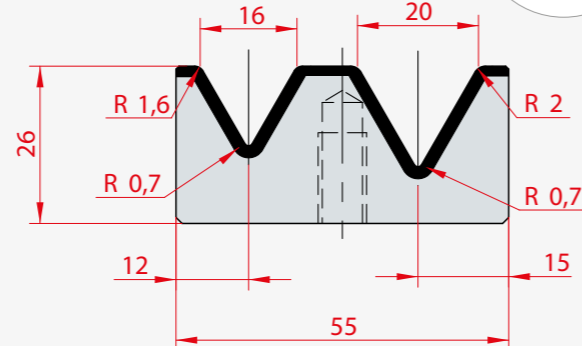
**A 2016**  
Standard C45  
Max T/m=60



**A 2033**  
Standard C45  
Max T/m=60

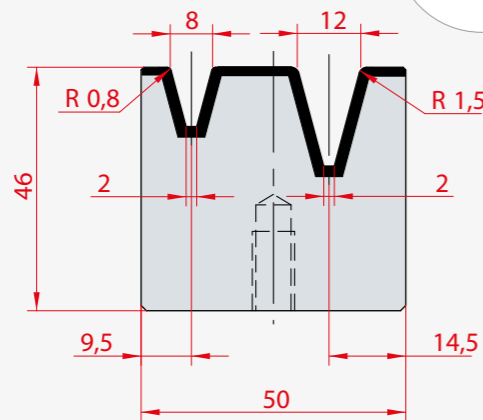


**A 2017**  
Standard C45  
Max T/m=60

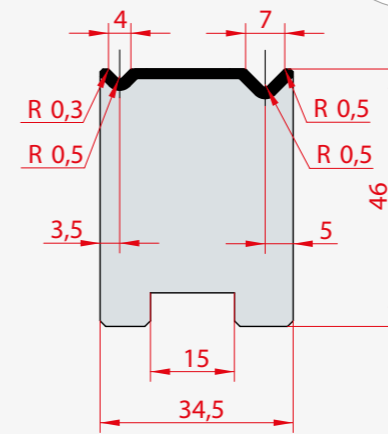


2V DIES 30°

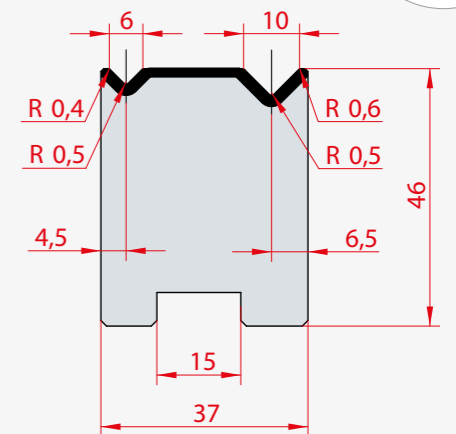
**A 2047**  
Standard C45  
Max T/m=40



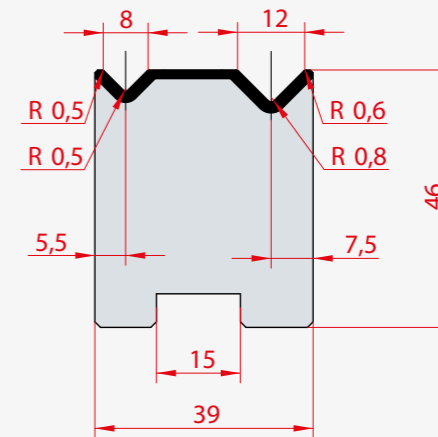
**A 2048**  
Standard C45  
Max T/m=80



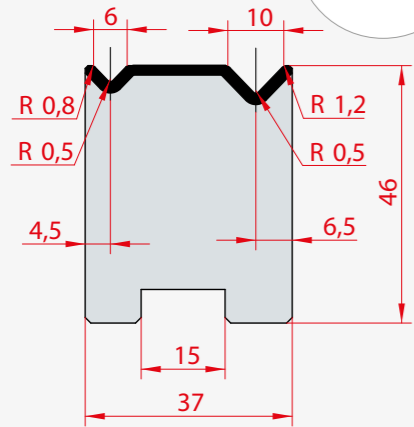
**A 2049**  
Standard C45  
Max T/m=80



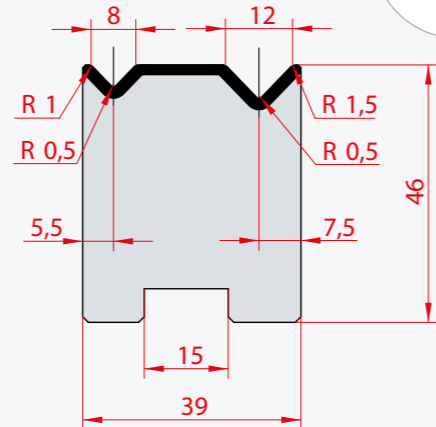
**A 2051**  
Standard C45  
Max T/m=100



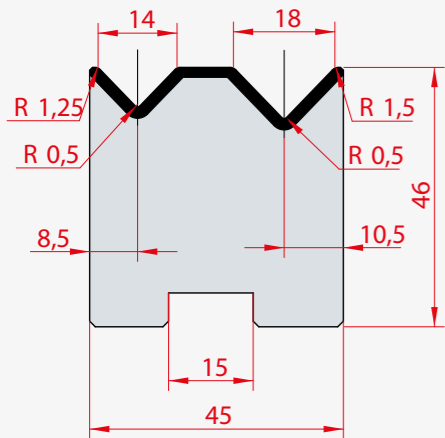
**A 2050**  
Standard C45  
Max T/m=80



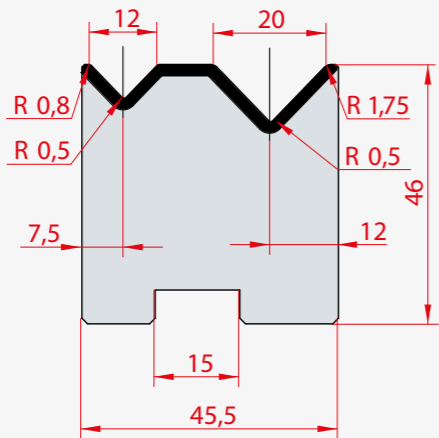
**A 2052**  
Standard C45  
Max T/m=80



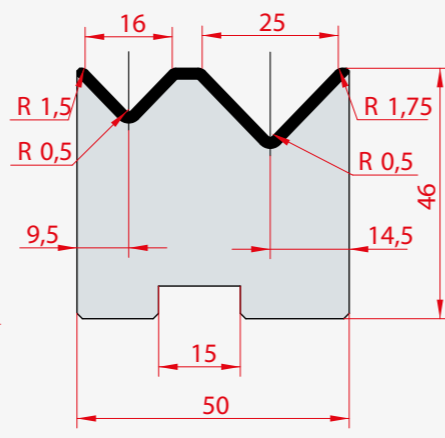
**A 2053**  
Standard C45  
Max T/m=80



**A 2054**  
Standard C45  
Max T/m=80

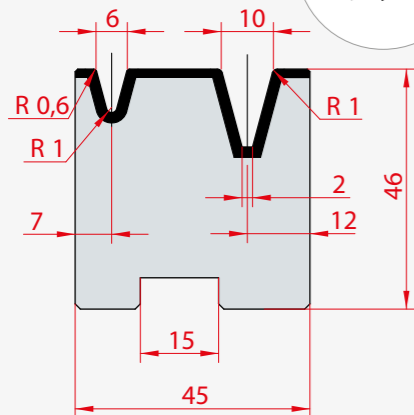


**A 2055**  
Standard C45  
Max T/m=80

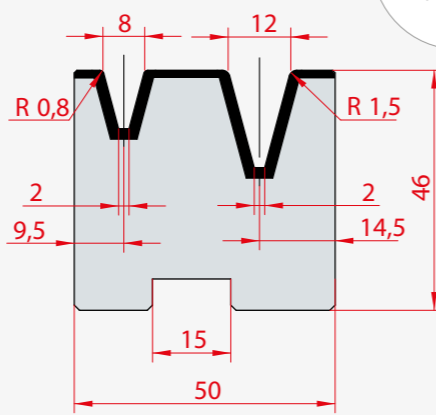


2V SELF-CENTERING DIES 30°

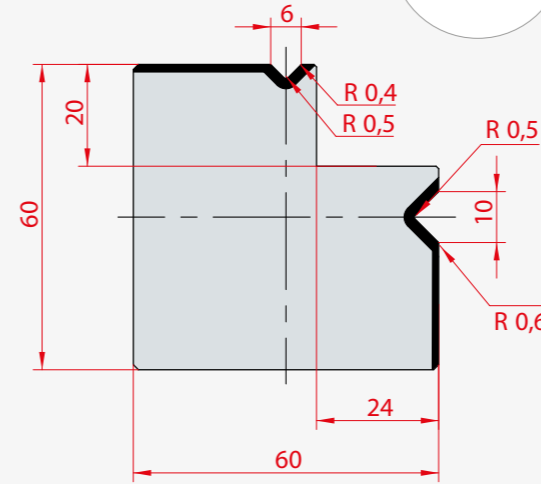
**A 2057**  
Standard C45  
Max T/m=40



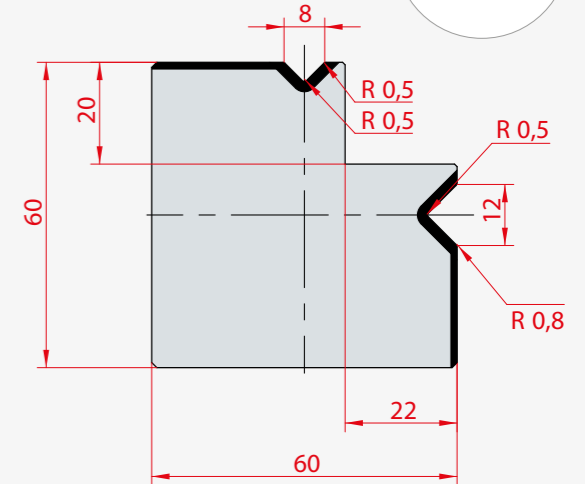
**A 2056**  
Standard C45  
Max T/m=40



**A 2028**  
Standard C45  
Max T/m=80

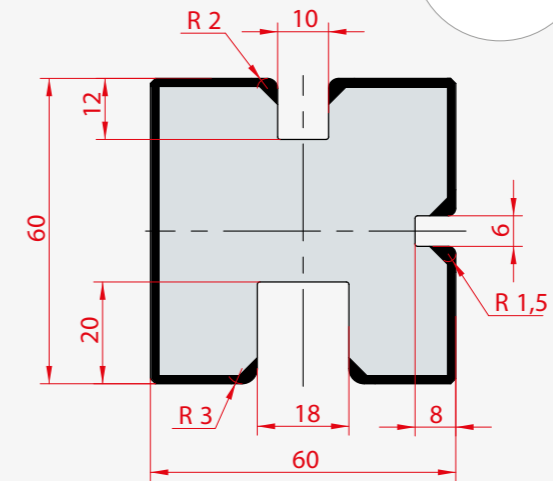


**A 2029**  
Standard C45  
Max T/m=80

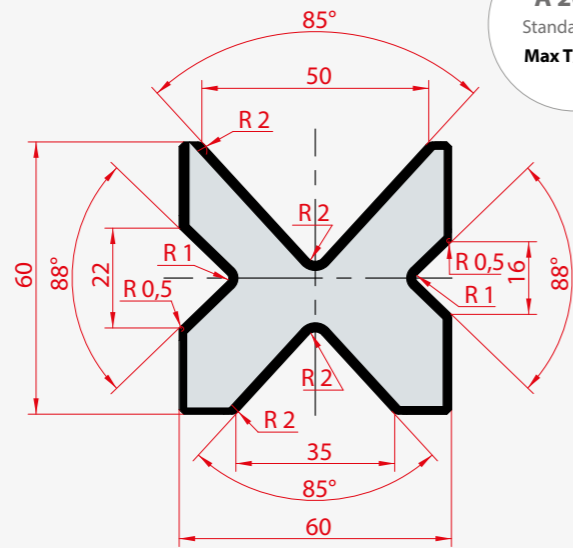


3U DIES

**A 2031**  
Standard C45  
Max T/m=100

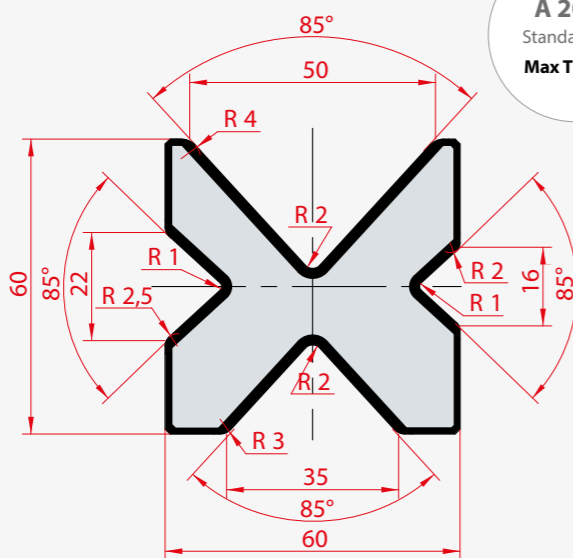


85°  
88°



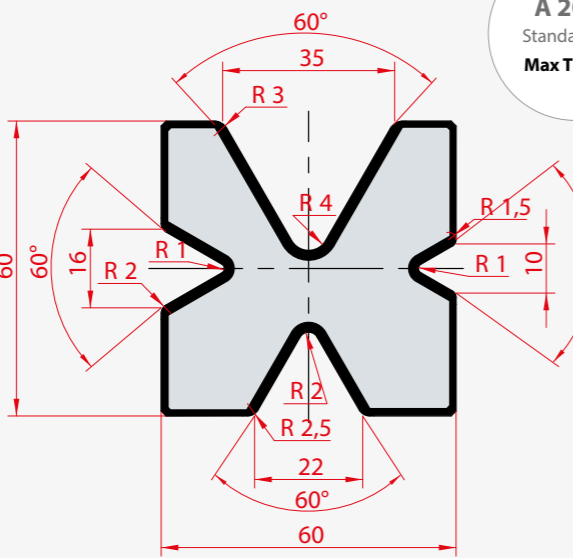
**A 2030**  
Standard C45  
Max T/m=80

85°

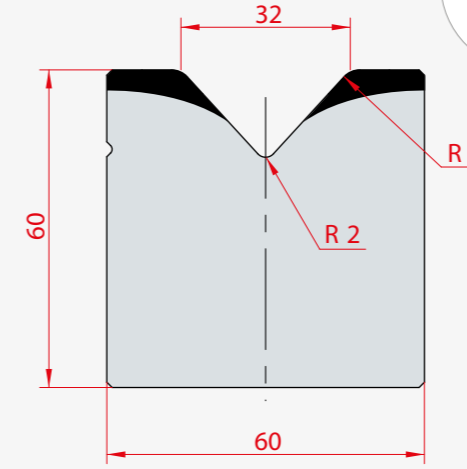


**A 2067**  
Standard C45  
Max T/m=80

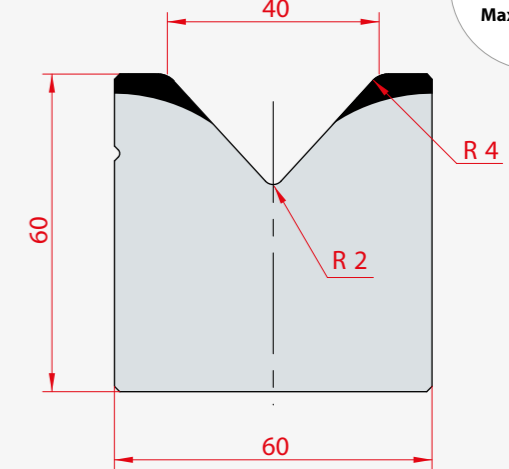
60°



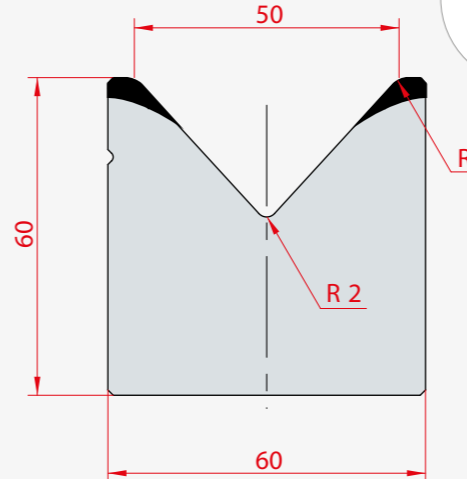
**A 2034**  
Standard C45  
Max T/m=60



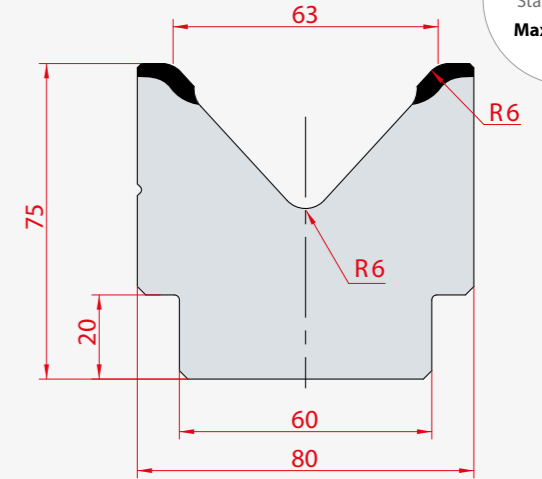
**A 2020**  
Standard C45  
Max T/m=100



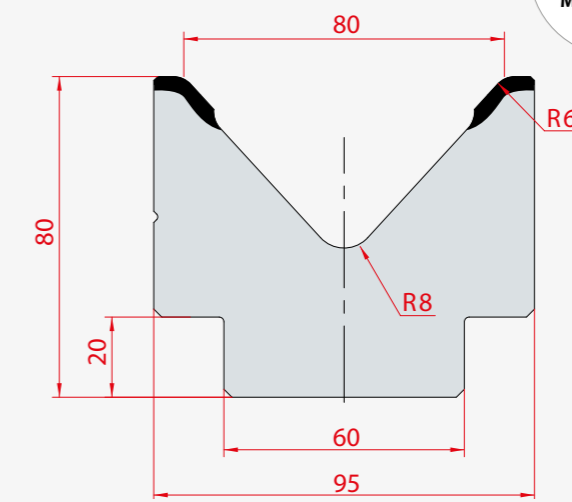
**A 2021**  
Standard C45  
Max T/m=100



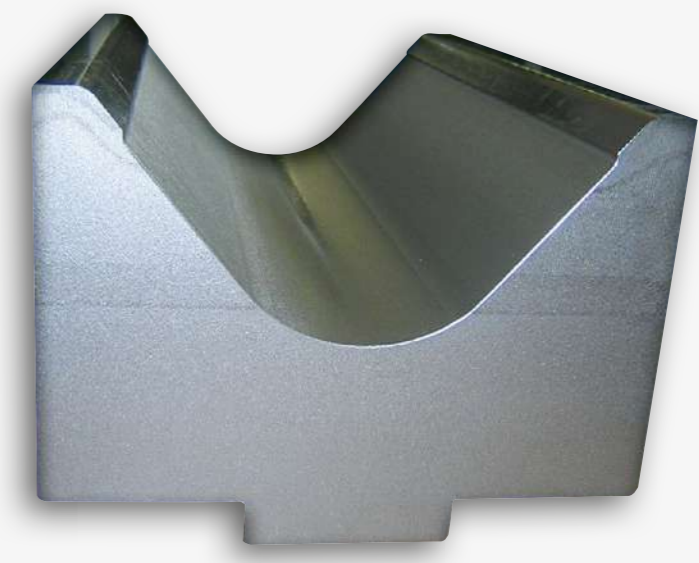
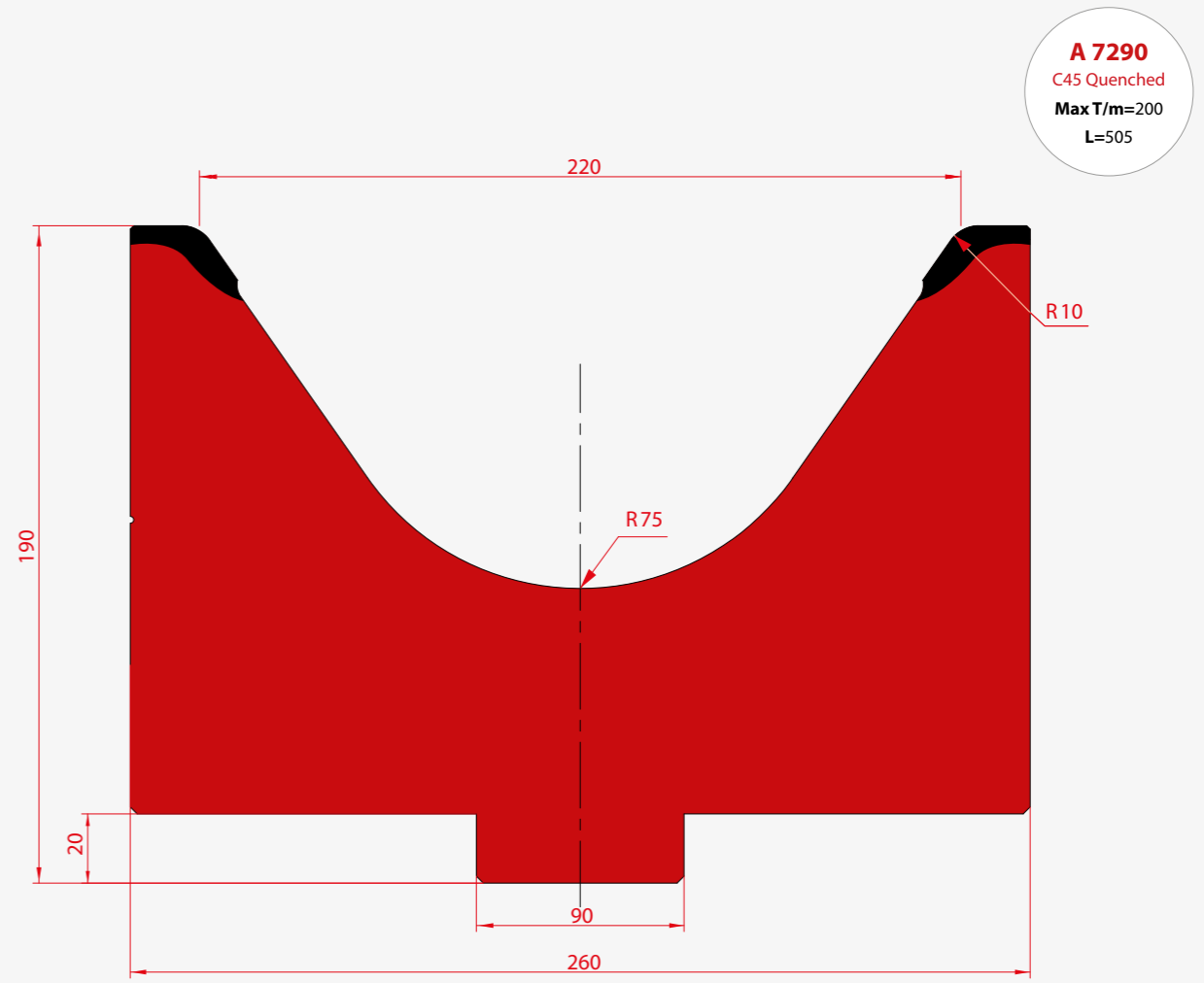
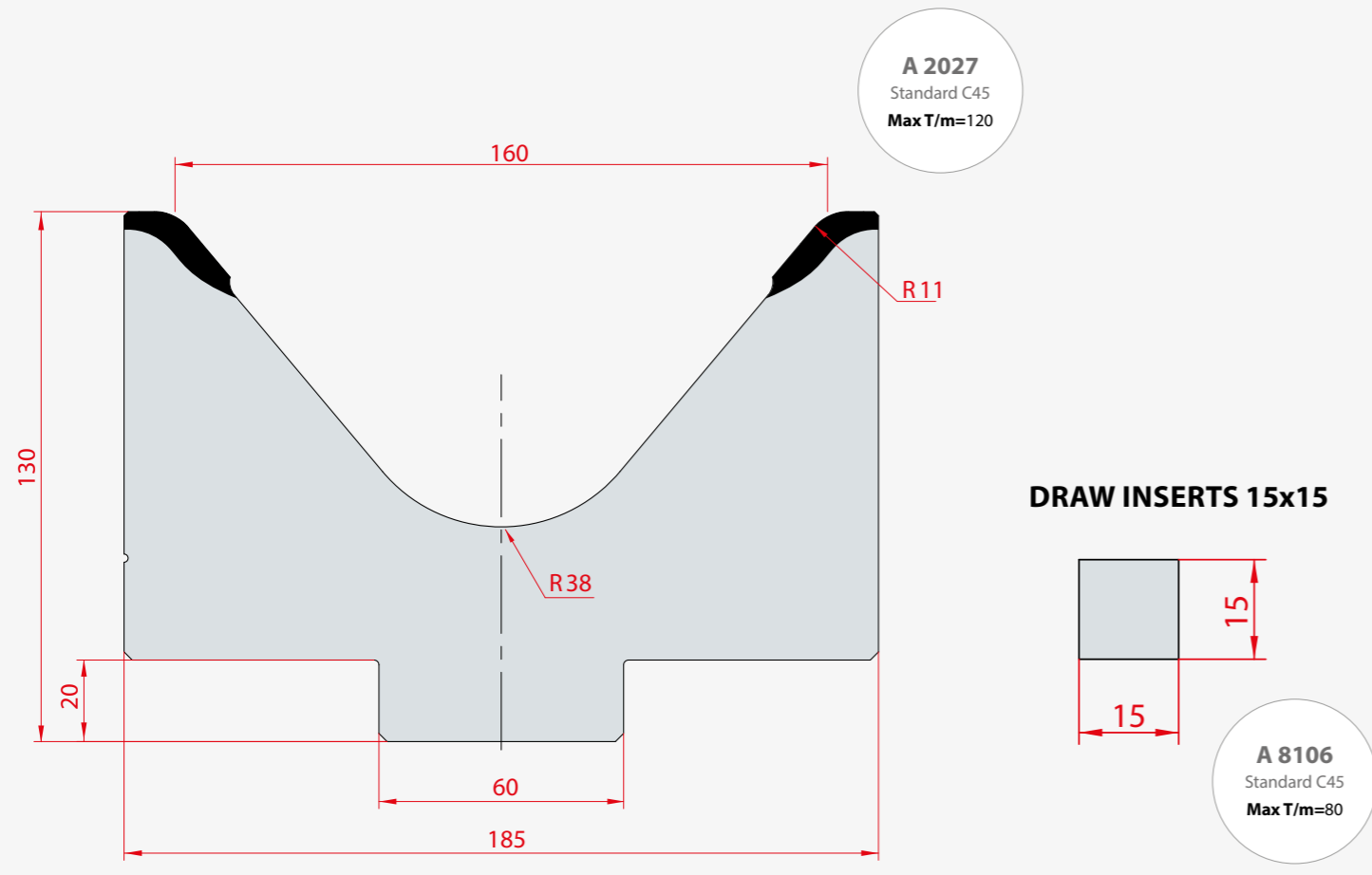
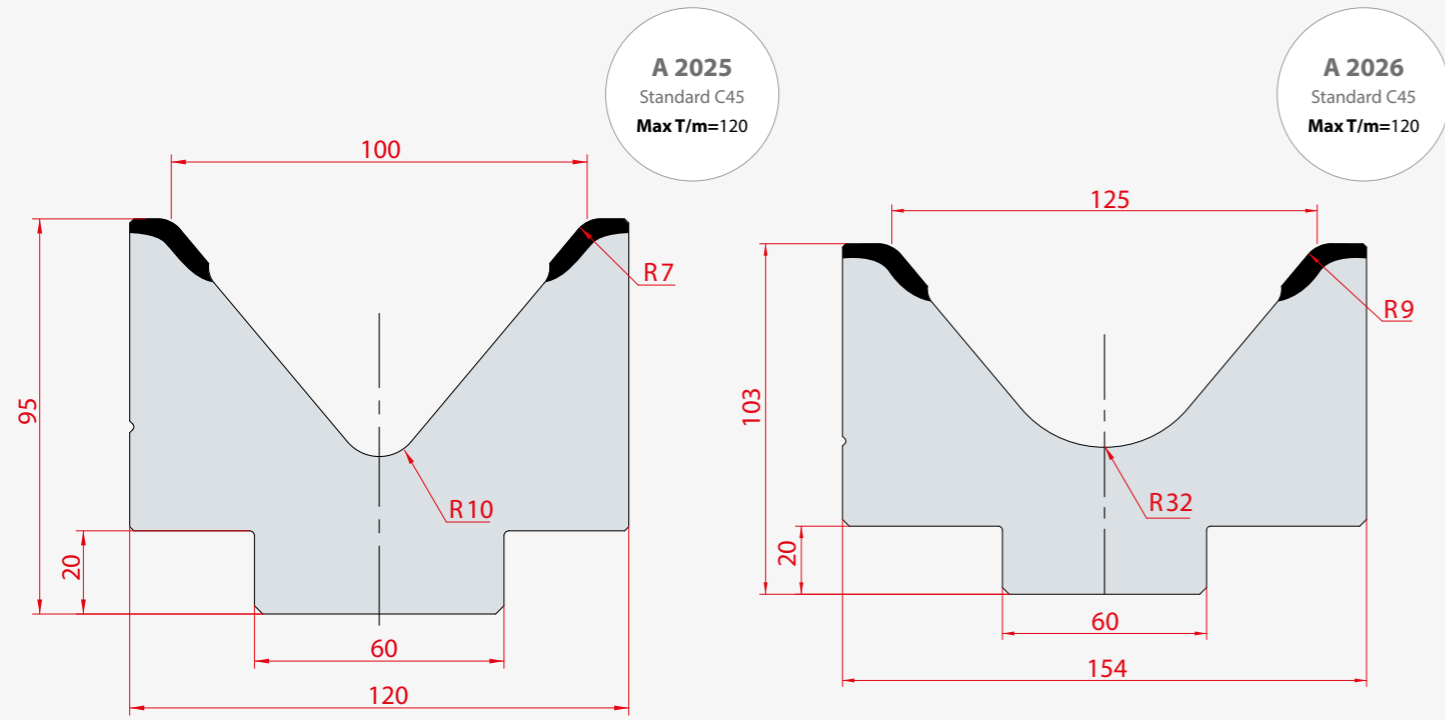
**A 2022**  
Standard C45  
Max T/m=80

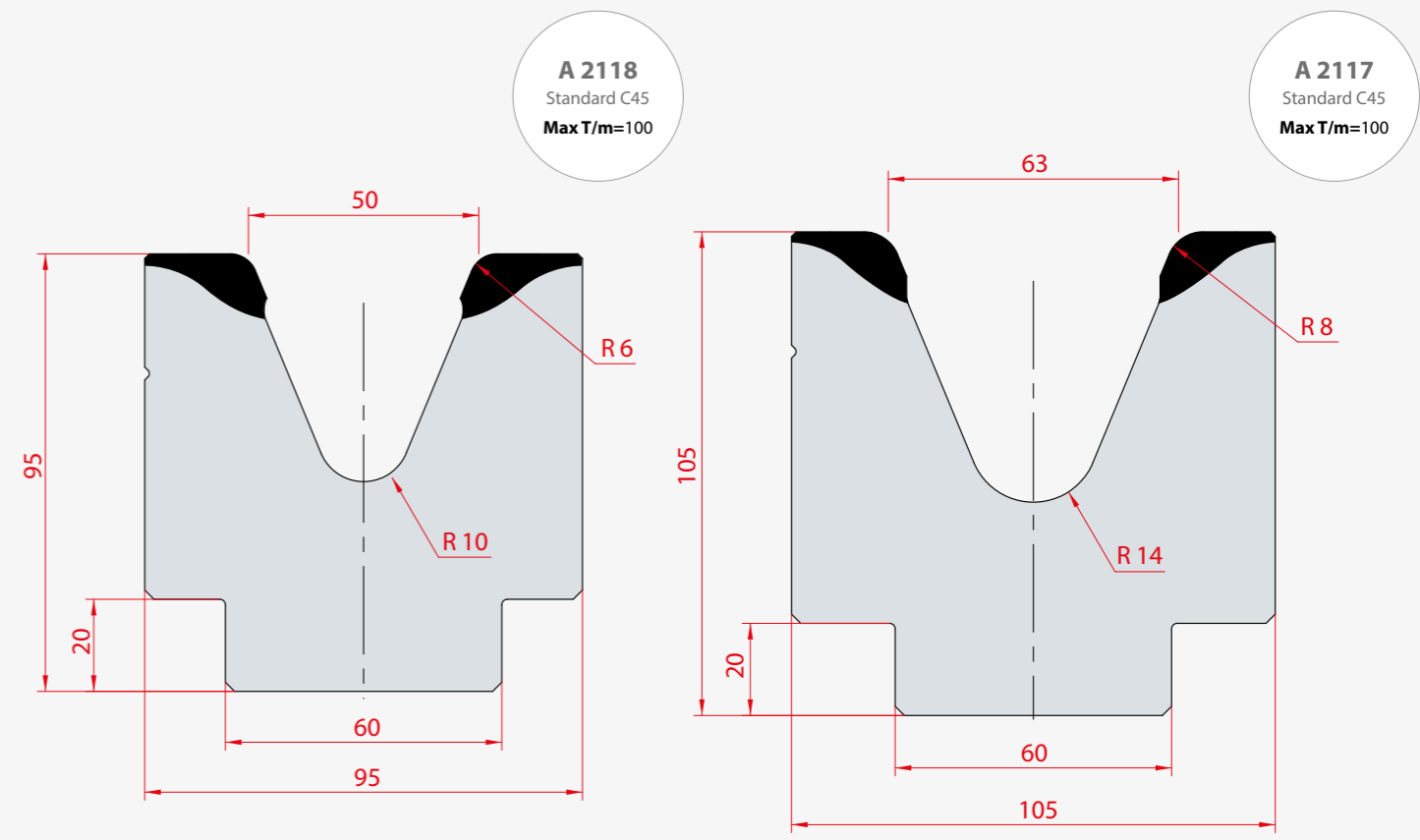
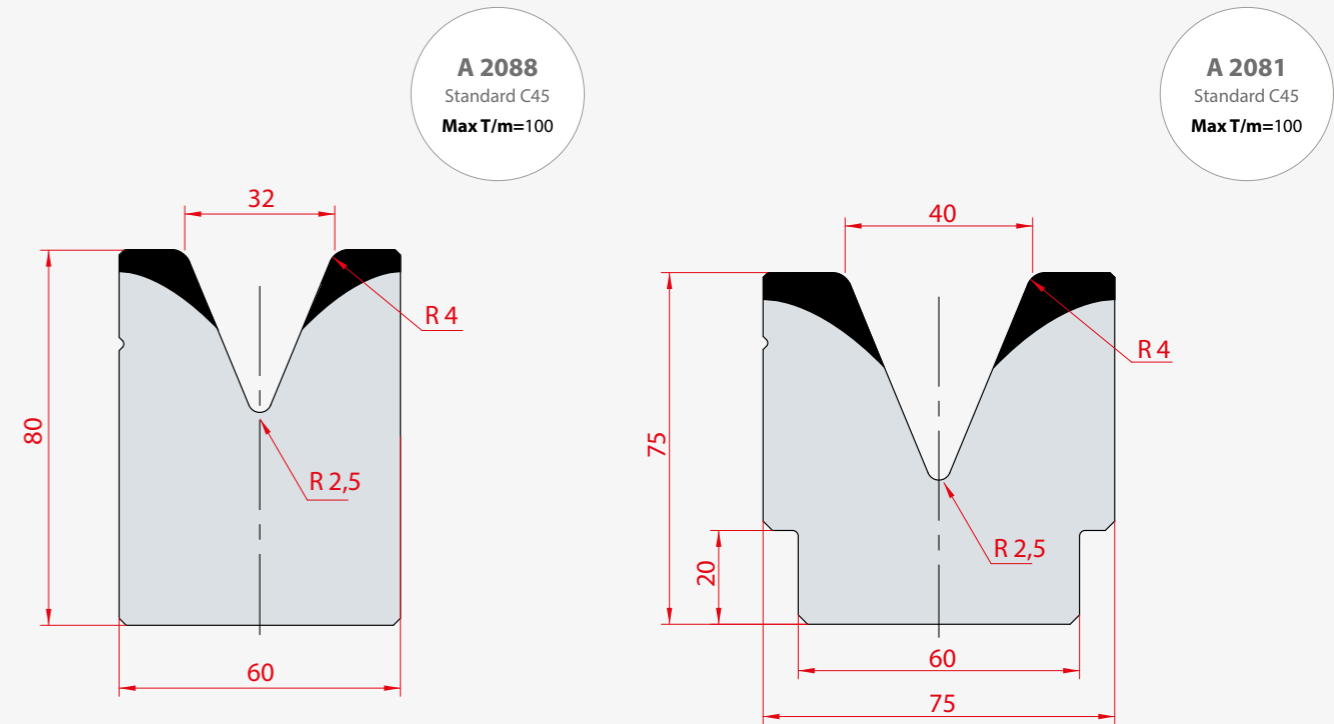
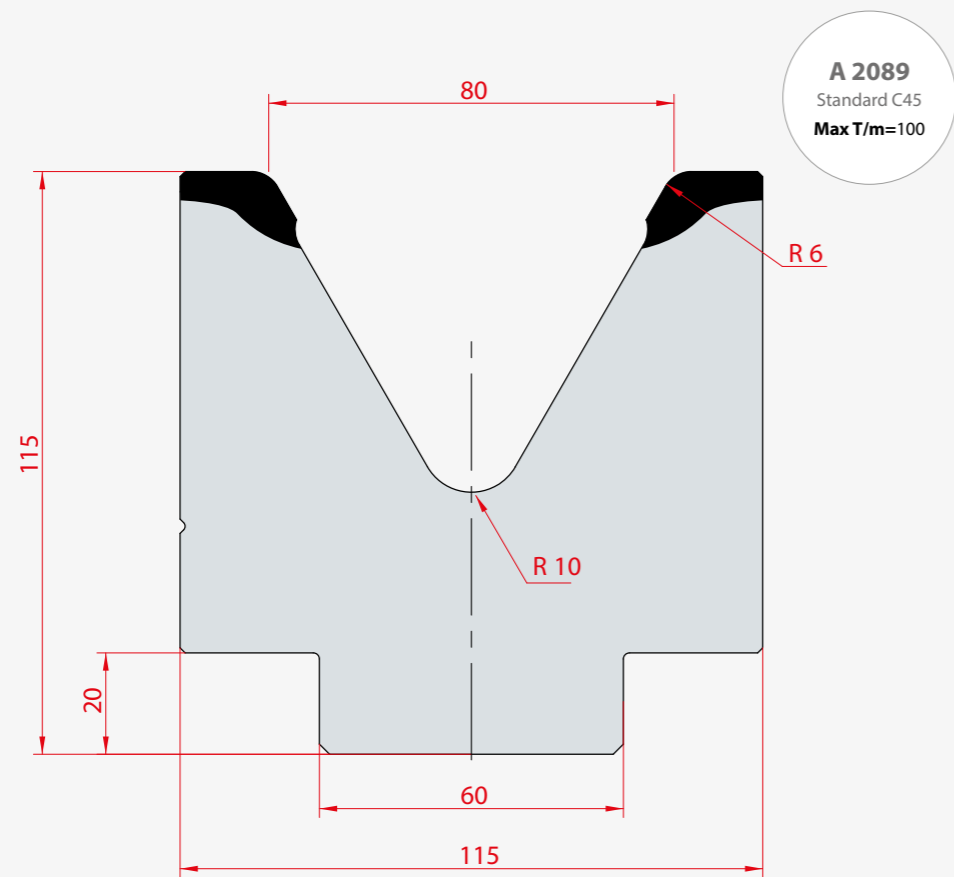
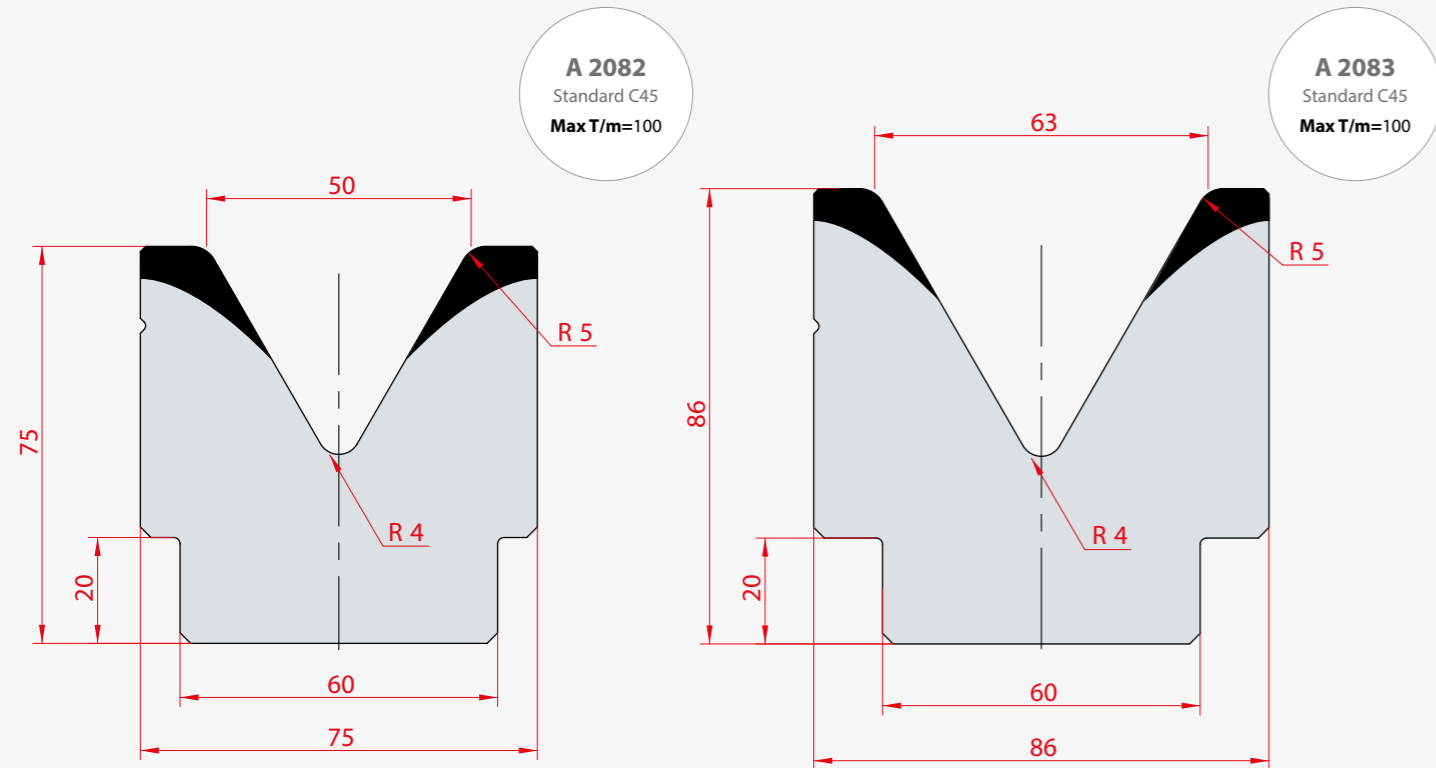


**A 2023**  
Standard C45  
Max T/m=100

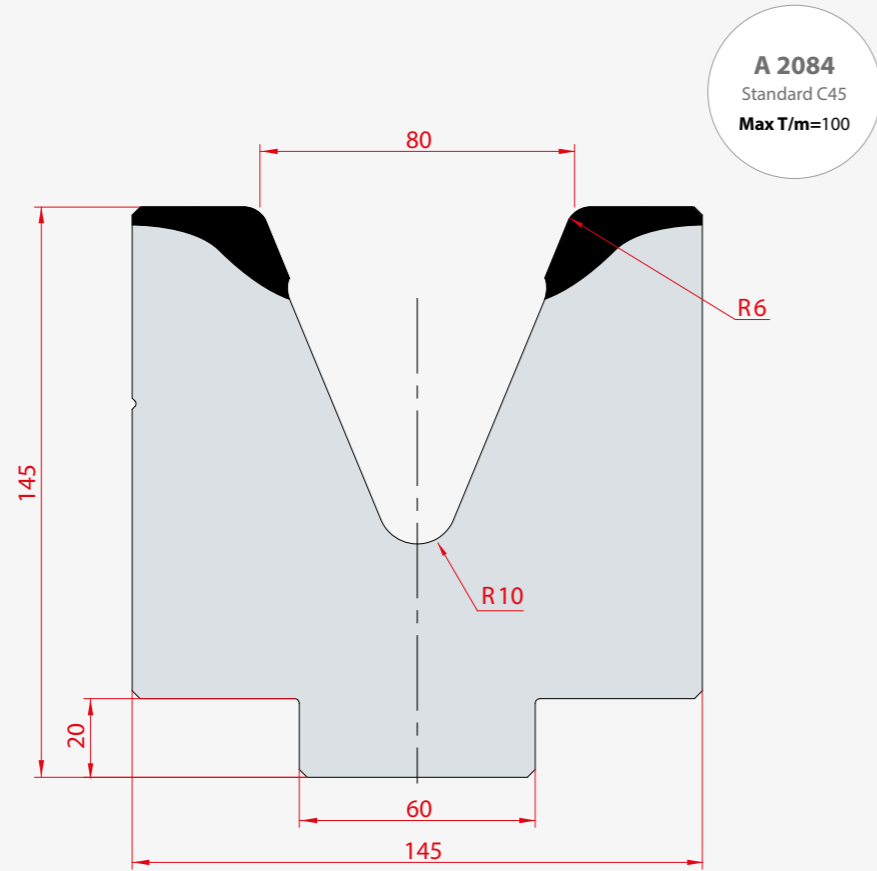


**A 2024**  
Standard C45  
Max T/m=100

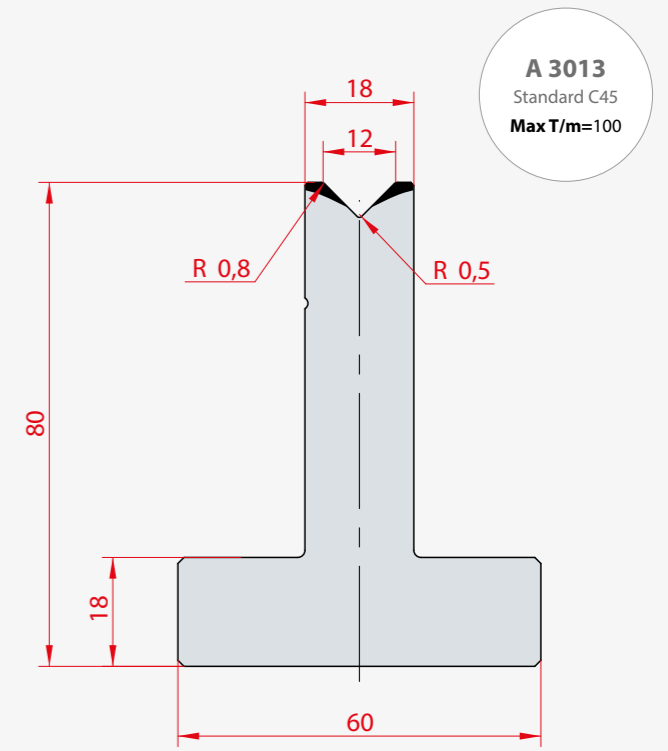
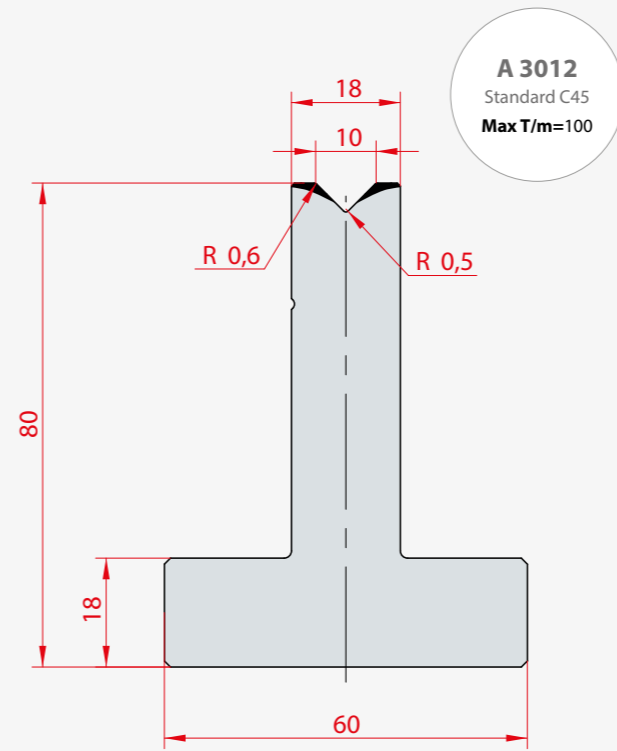
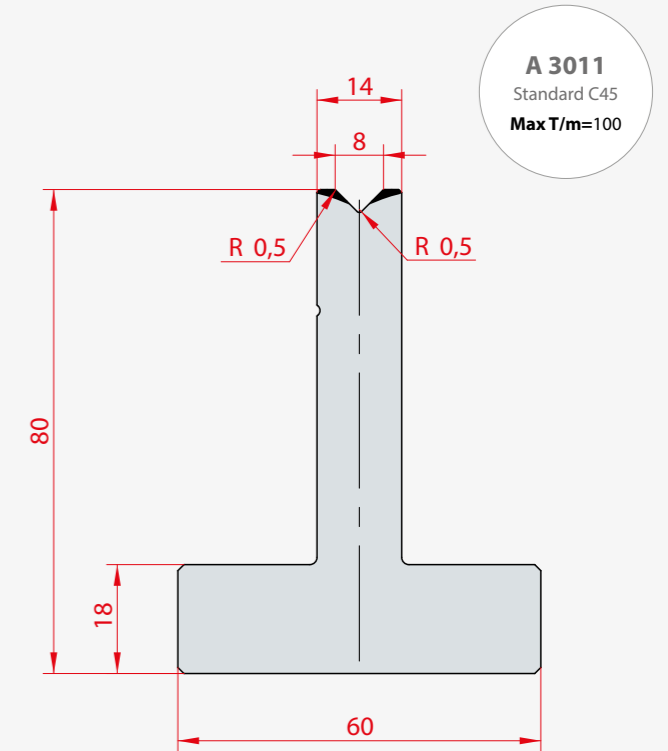
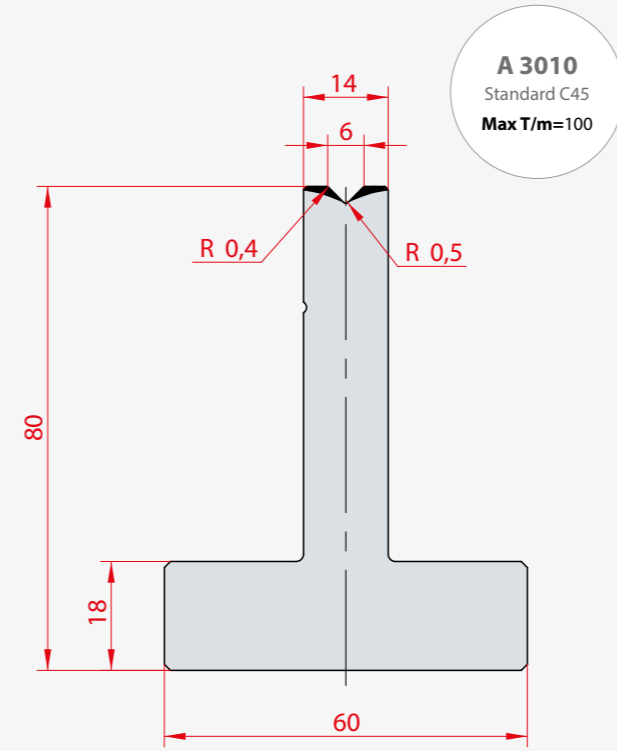
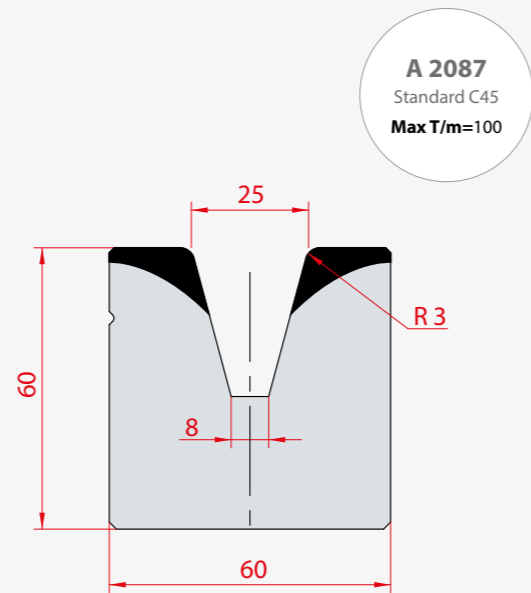
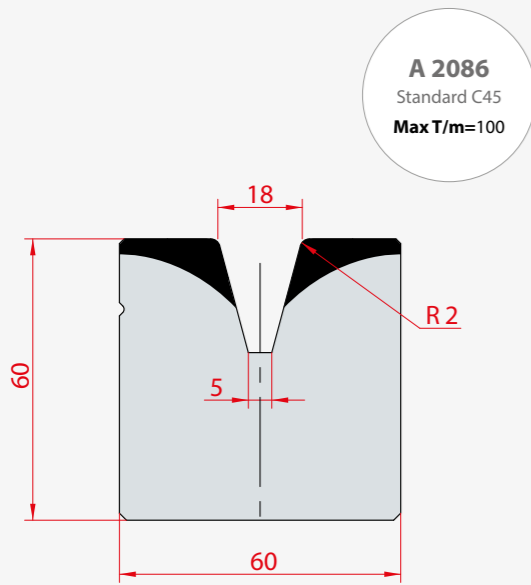


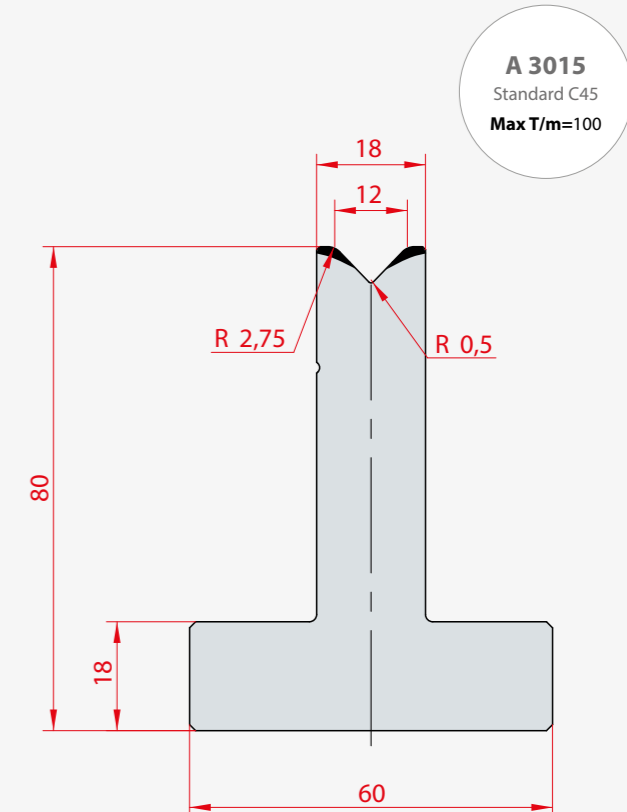
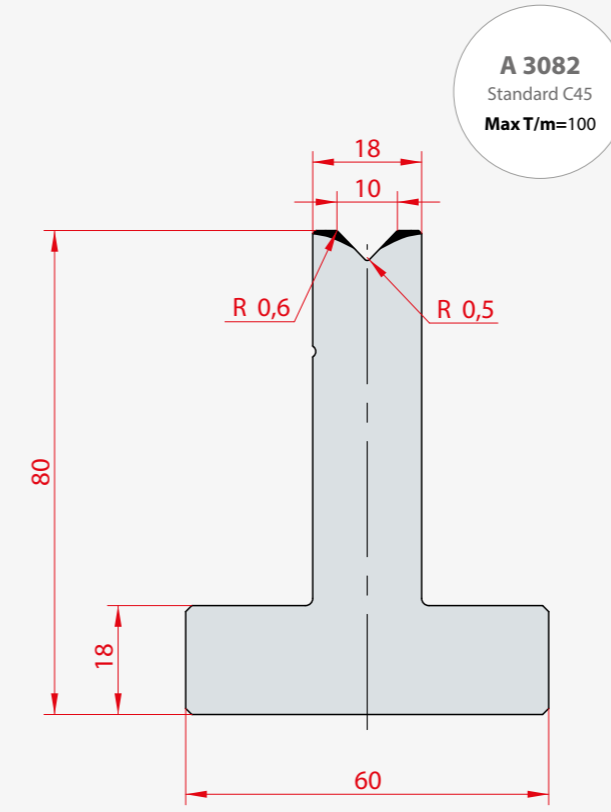
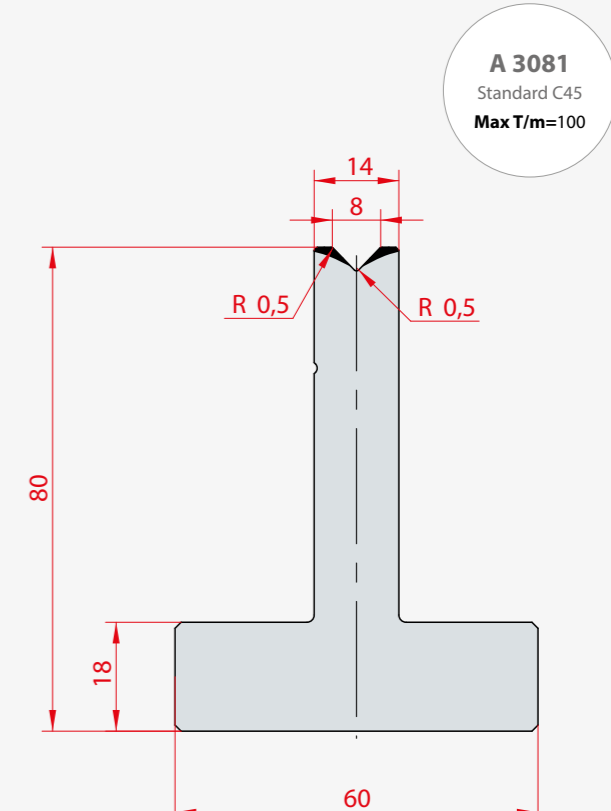
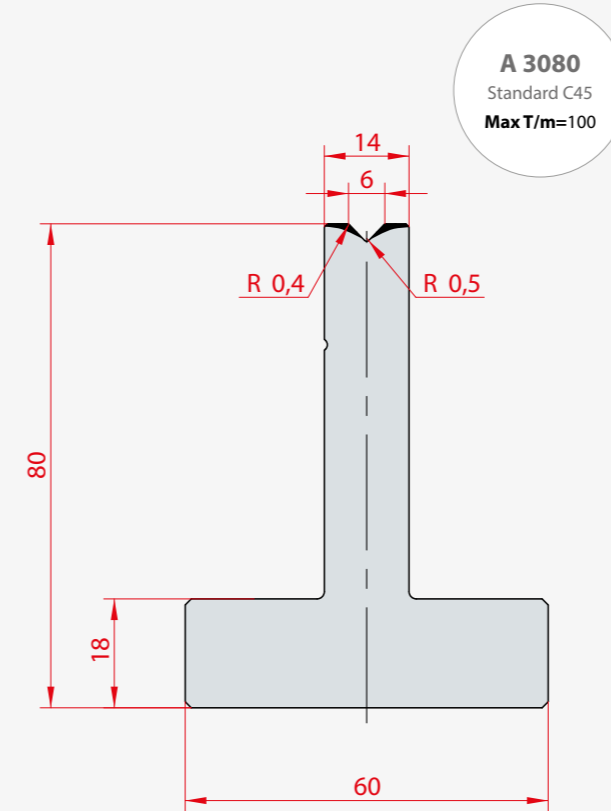
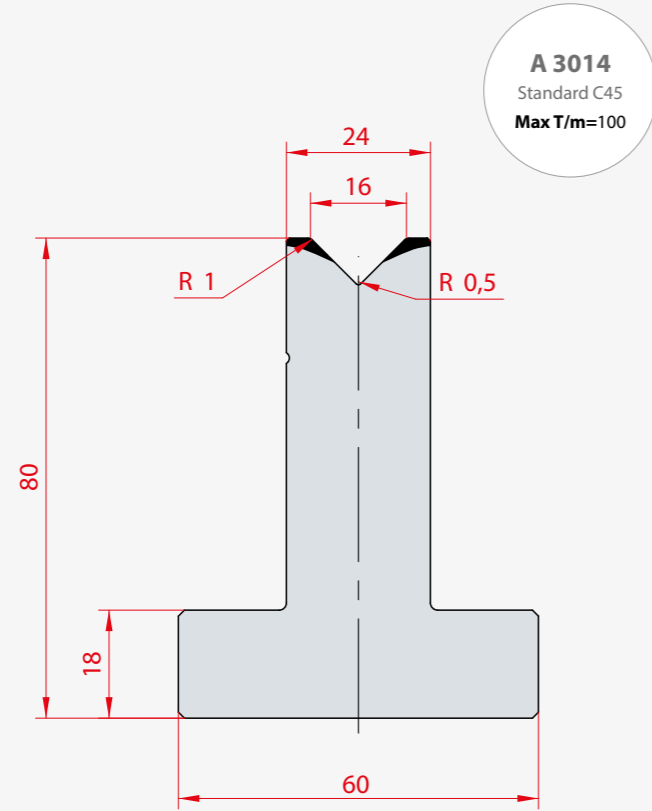


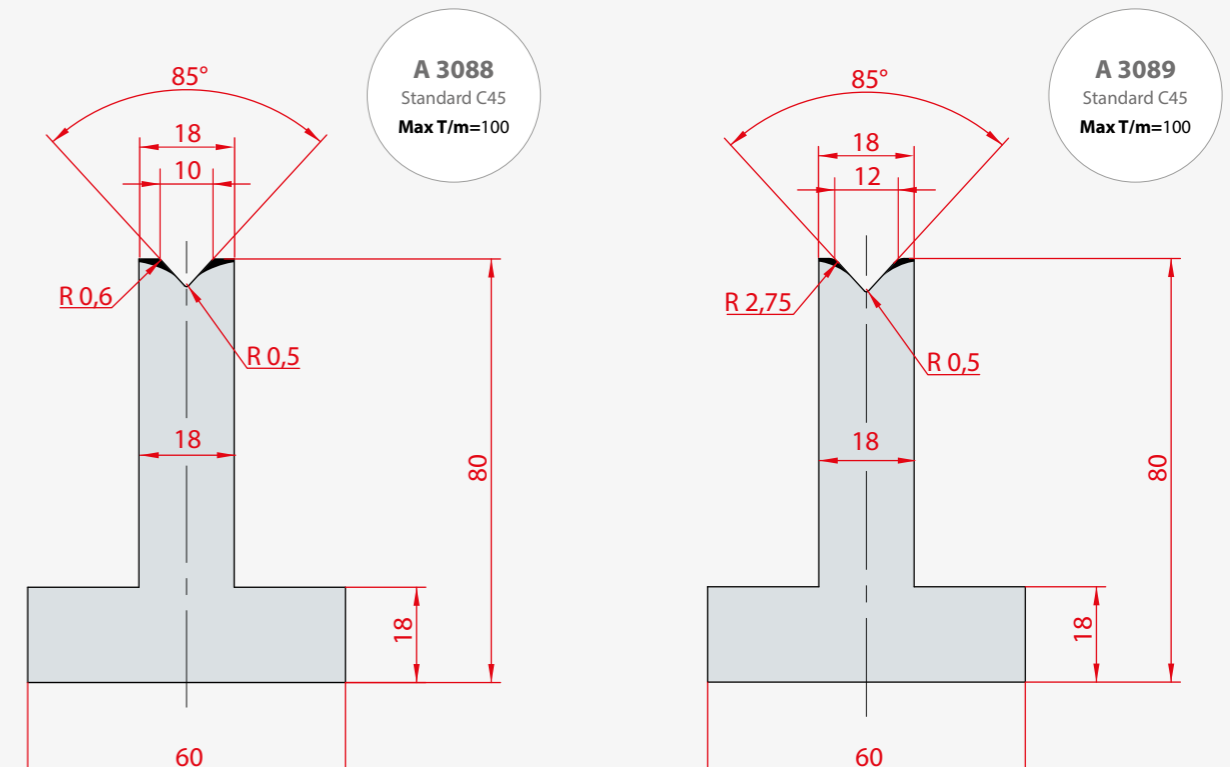
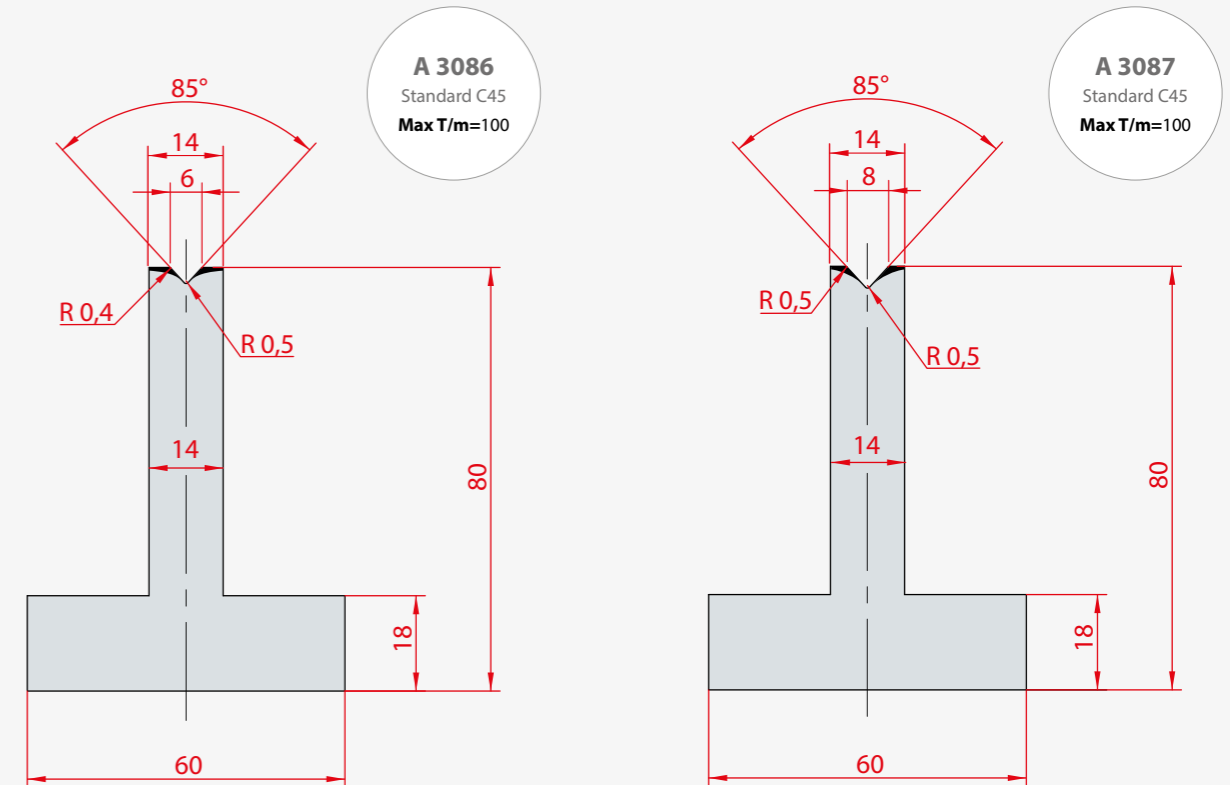
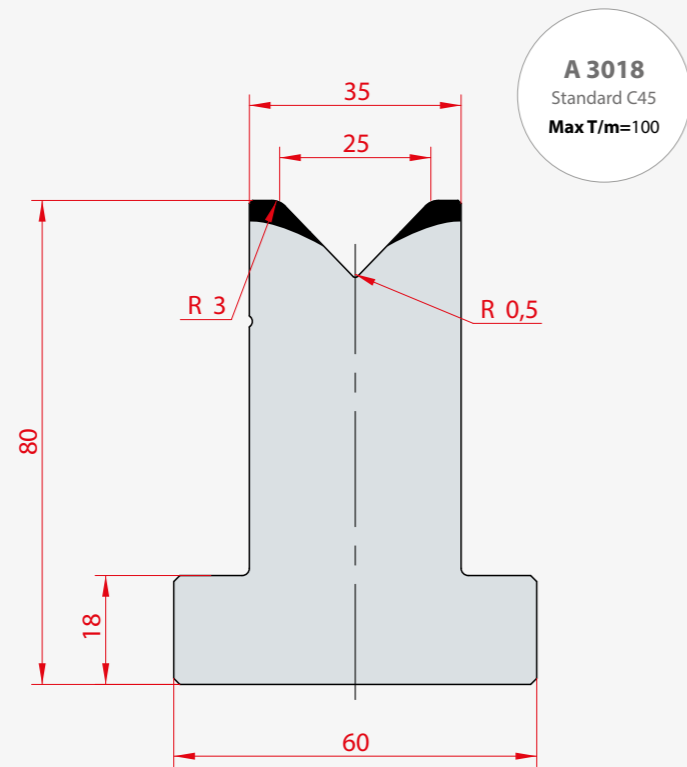
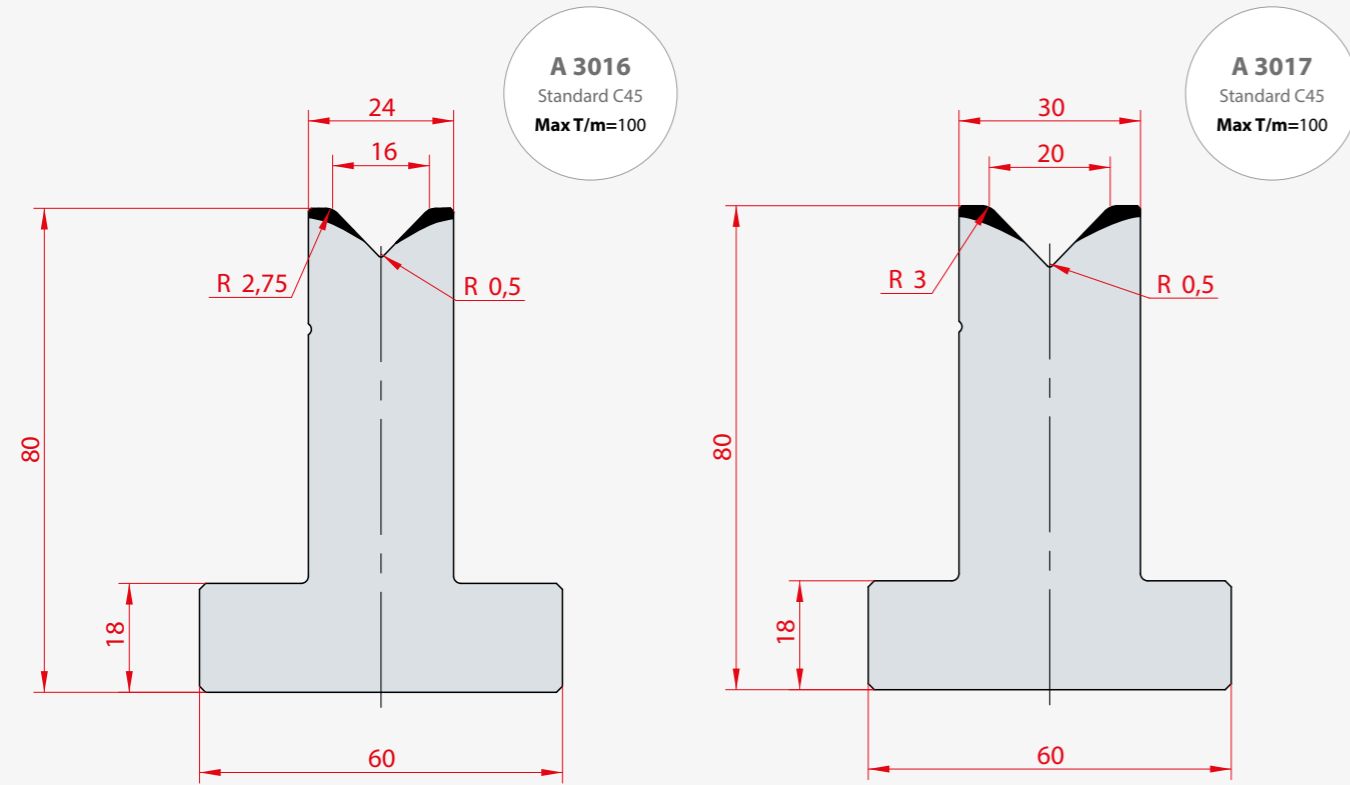




1V DIES 30°

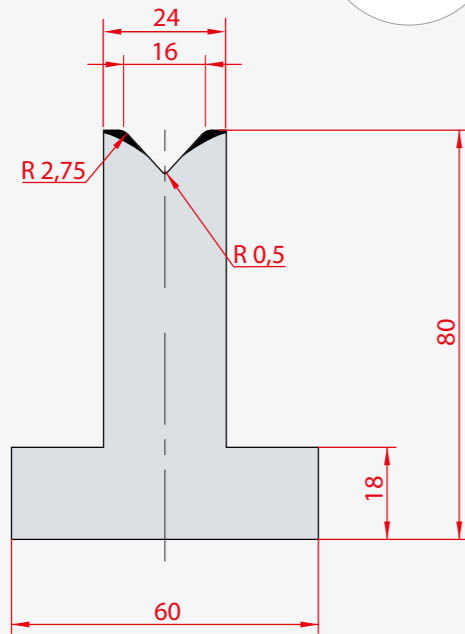






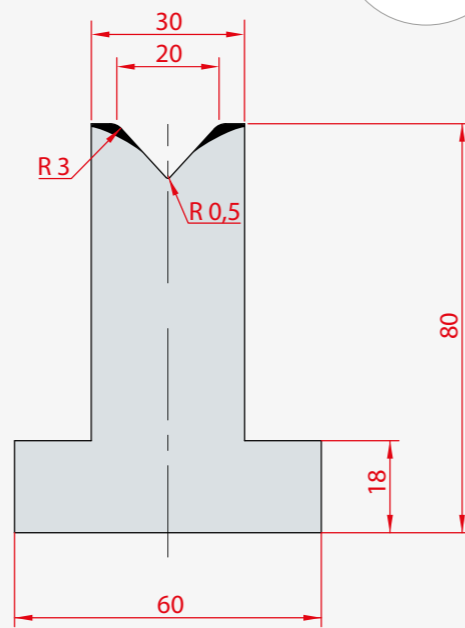
**A 3090**

Standard C45  
Max T/m=100



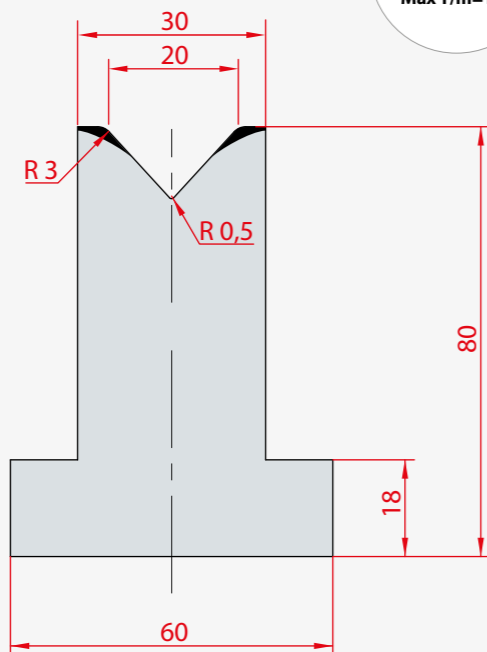
**A 3091**

Standard C45  
Max T/m=100



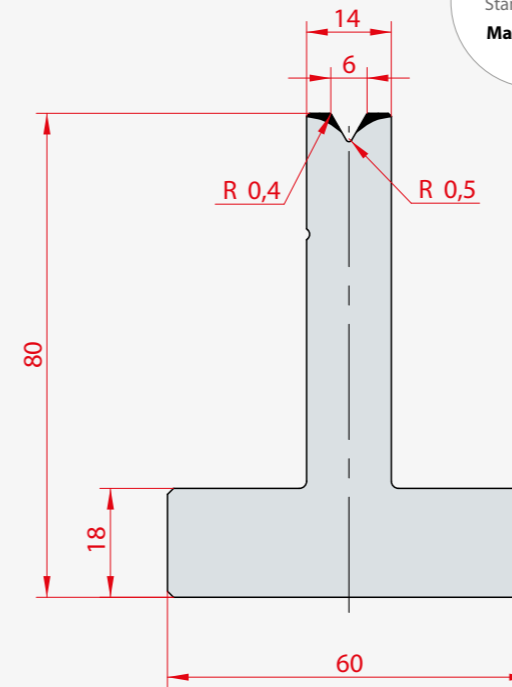
**A 3092**

Standard C45  
Max T/m=100



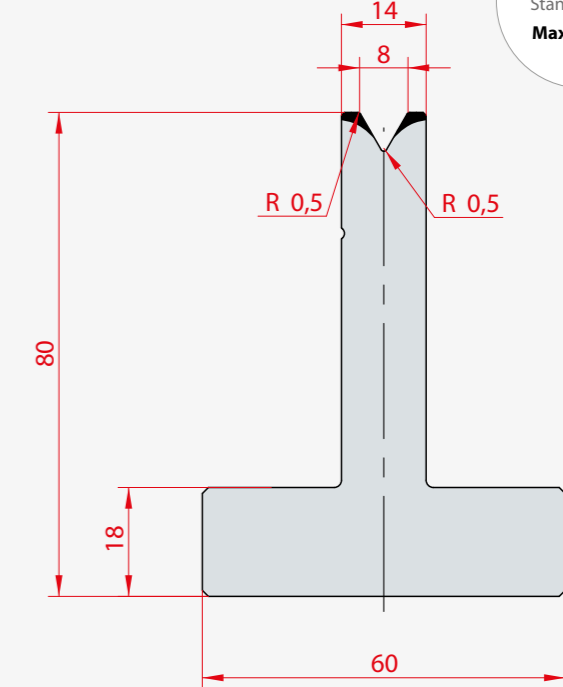
**A 3019**

Standard C45  
Max T/m=60



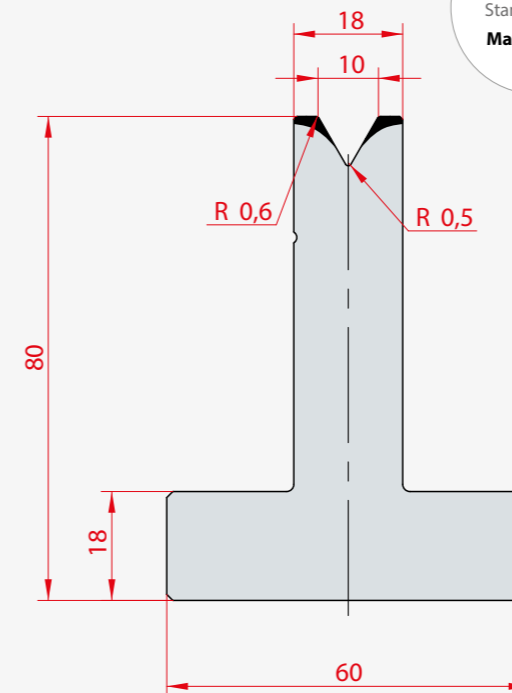
**A 3020**

Standard C45  
Max T/m=60



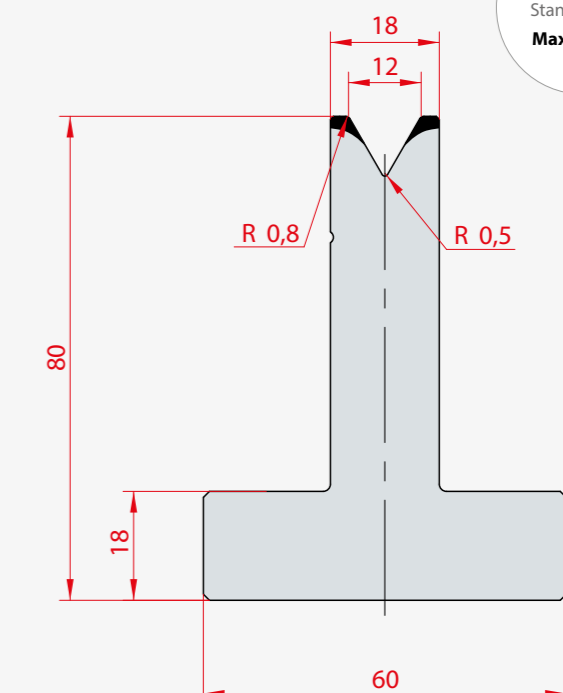
**A 3021**

Standard C45  
Max T/m=60



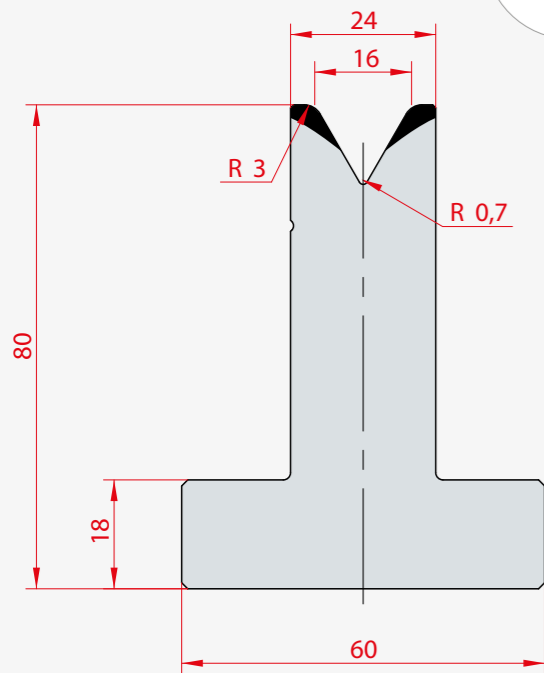
**A 3022**

Standard C45  
Max T/m=75



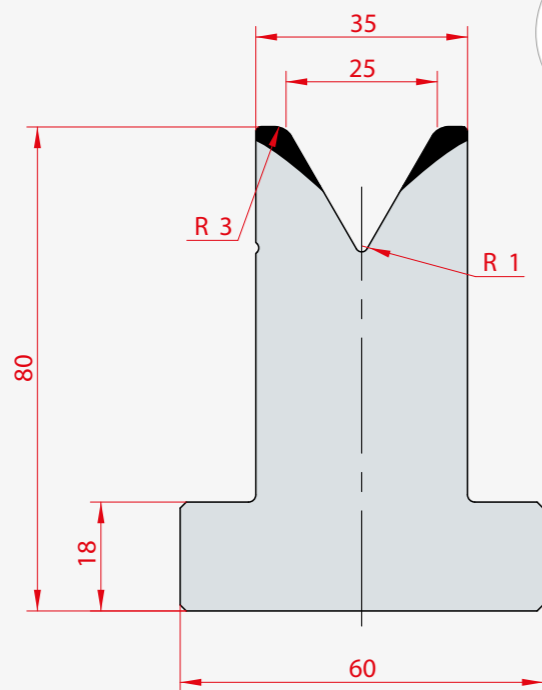
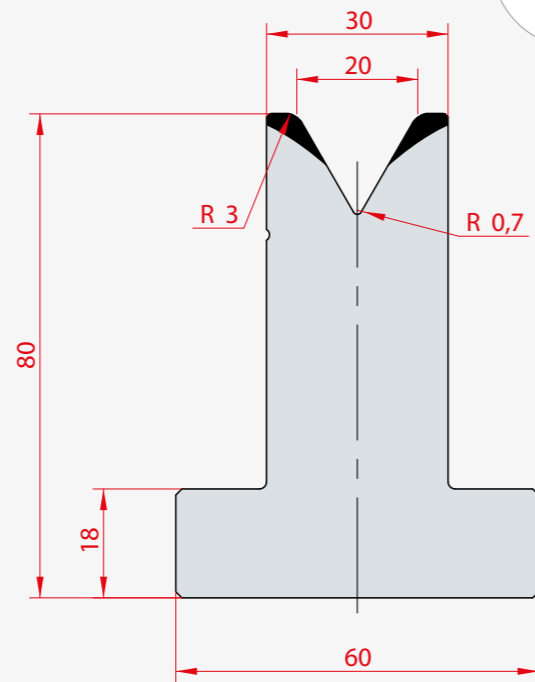
**A 3023**

Standard C45  
Max T/m=70



**A 3024**

Standard C45  
Max T/m=65

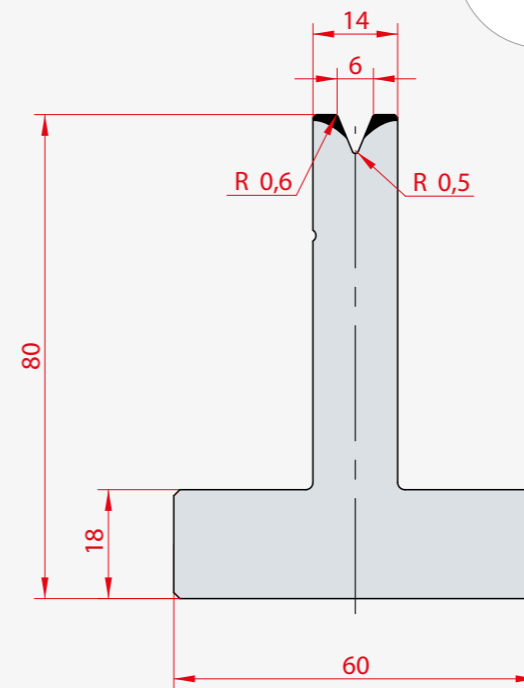


**A 3025**

Standard C45  
Max T/m=60

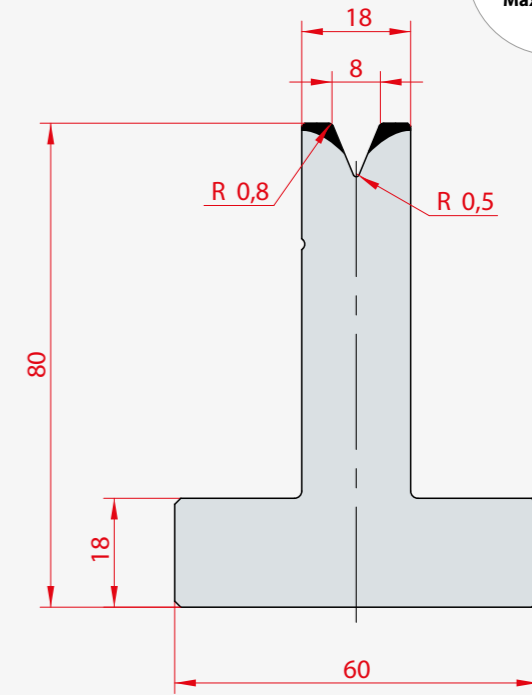
**A 3026**

Standard C45  
Max T/m=50



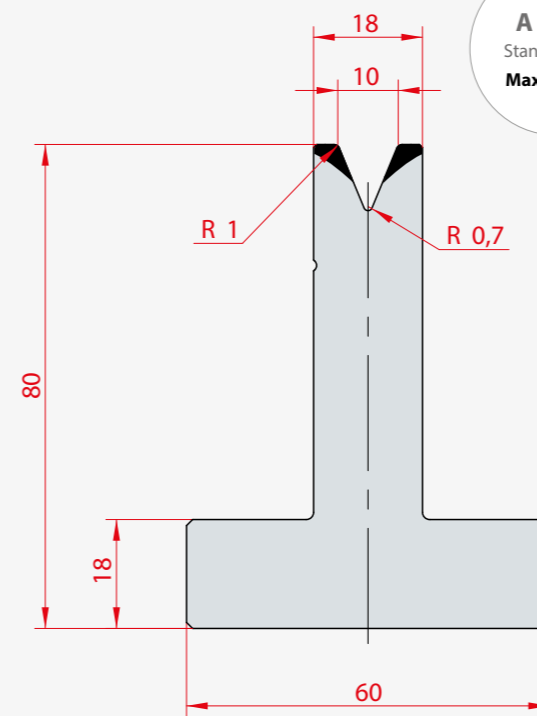
**A 3027**

Standard C45  
Max T/m=50



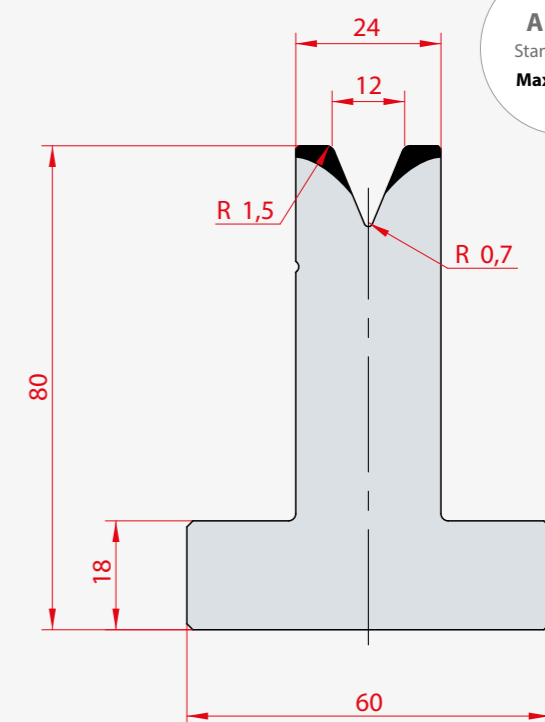
**A 3028**

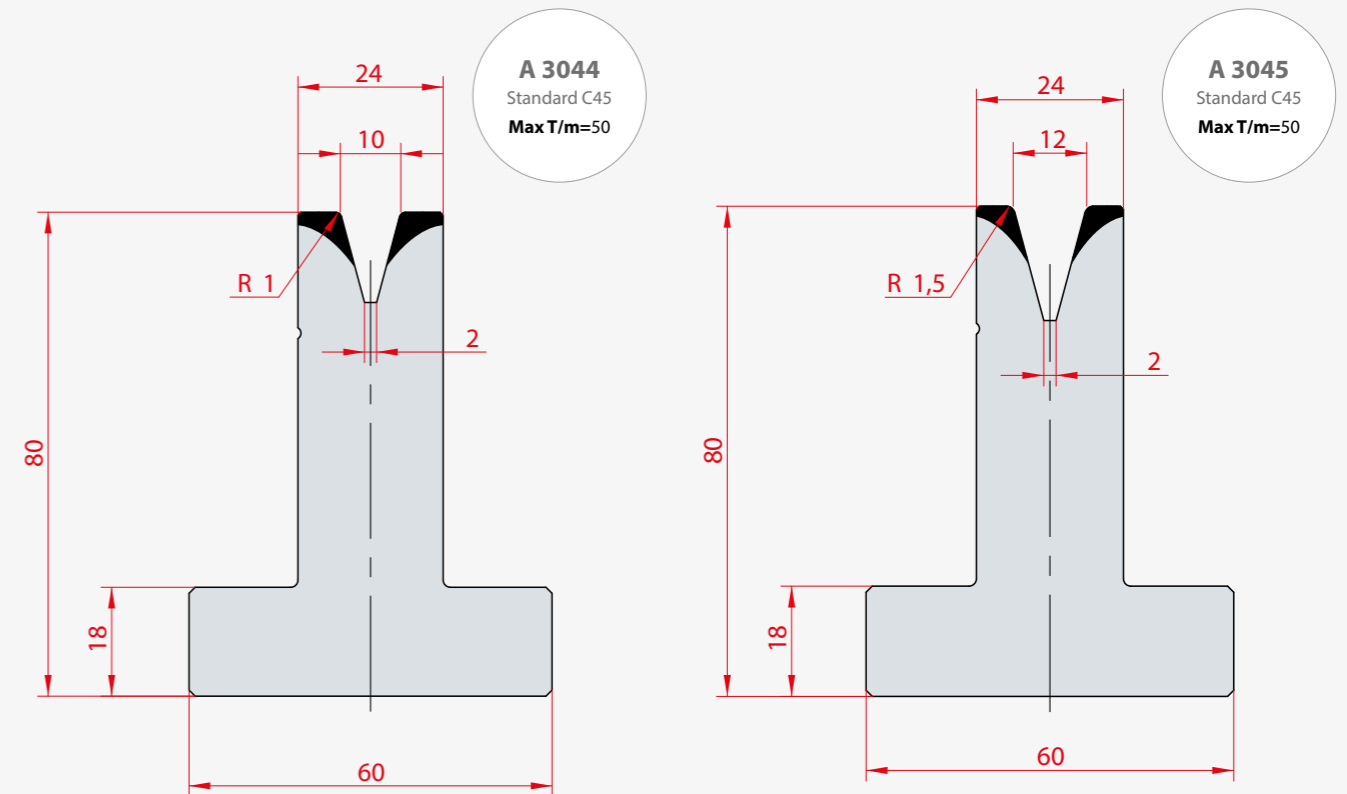
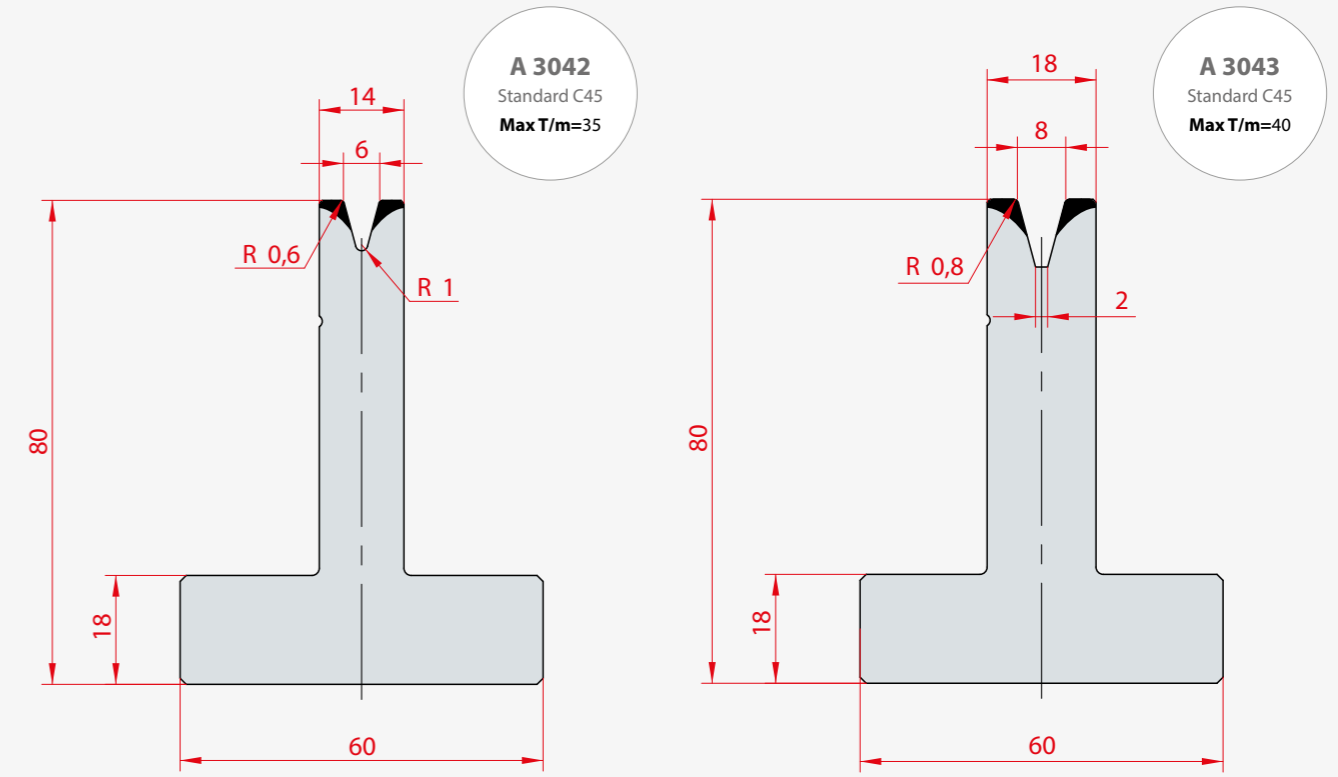
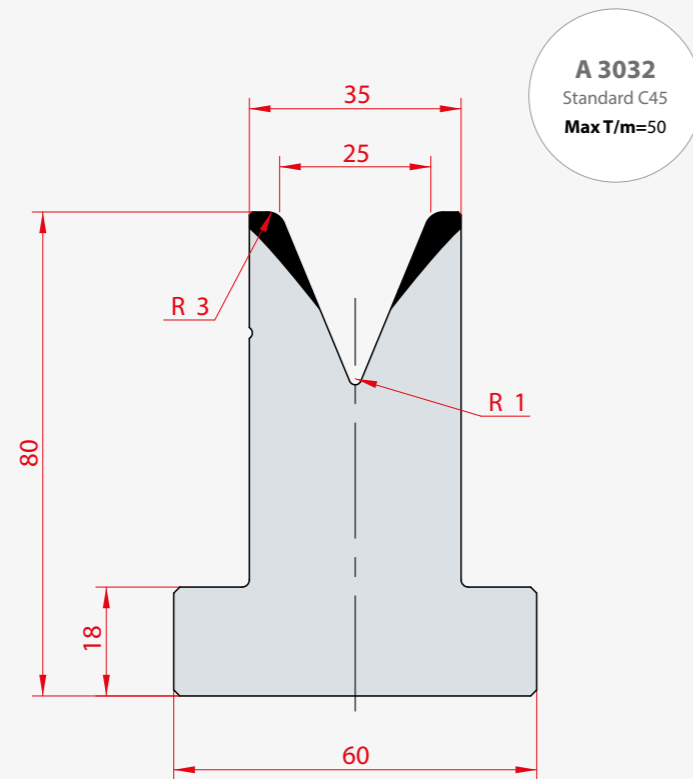
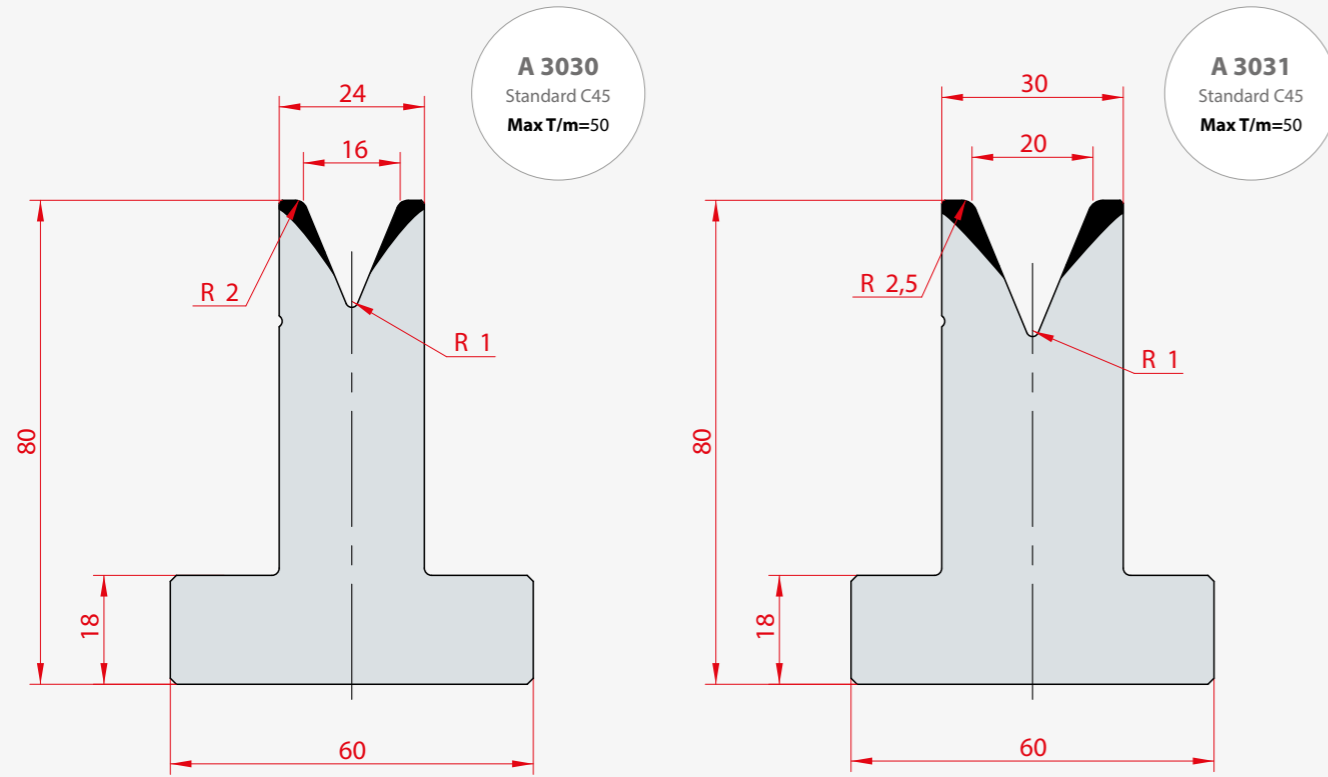
Standard C45  
Max T/m=50



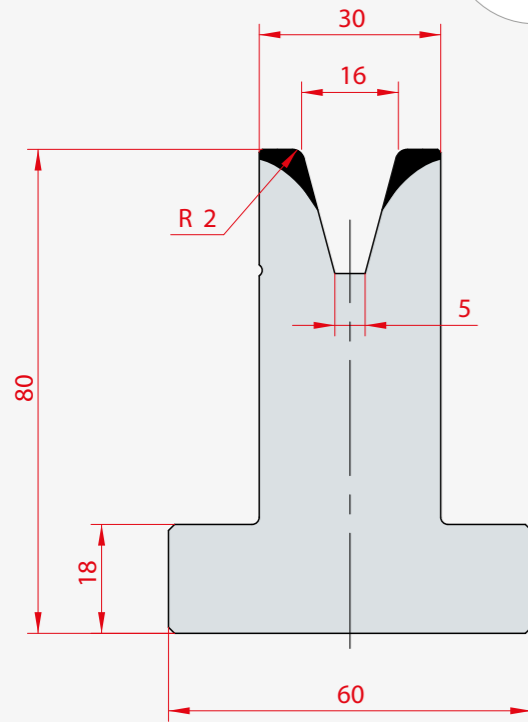
**A 3029**

Standard C45  
Max T/m=50

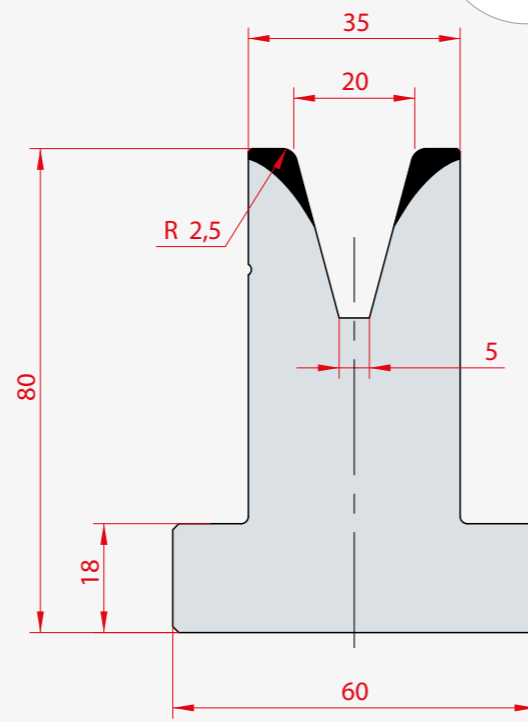




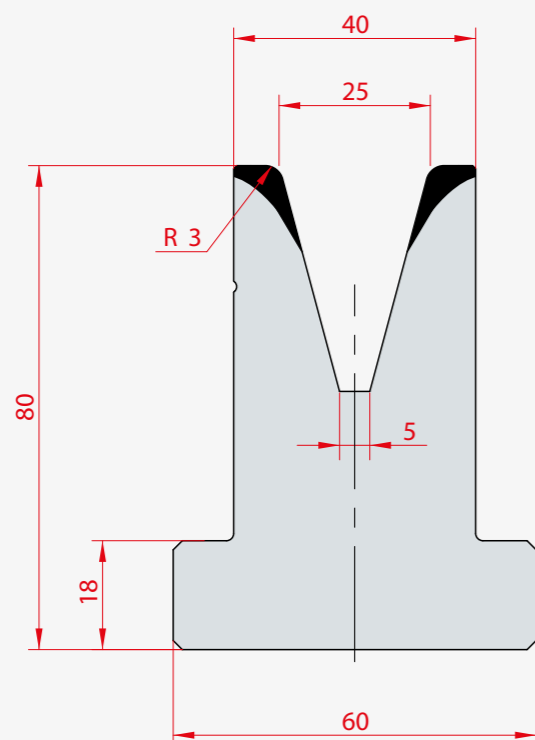
**A 3046**  
Standard C45  
Max T/m=50



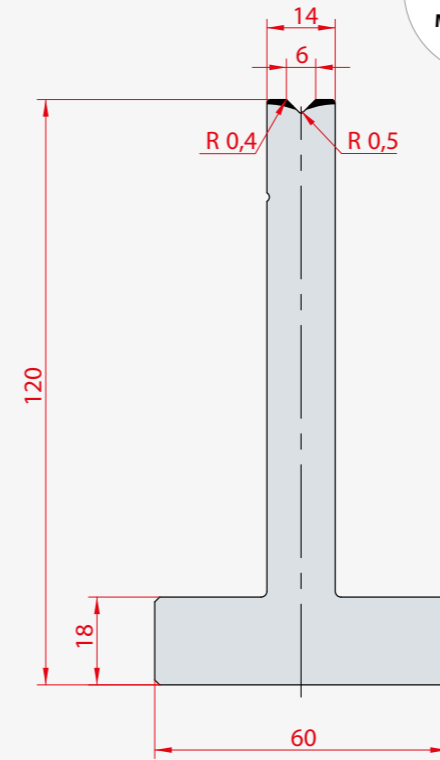
**A 3047**  
Standard C45  
Max T/m=55



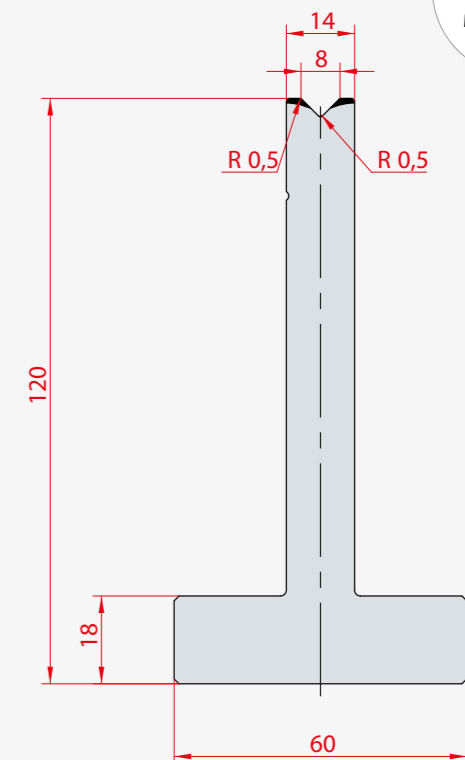
**A 3048**  
Standard C45  
Max T/m=55



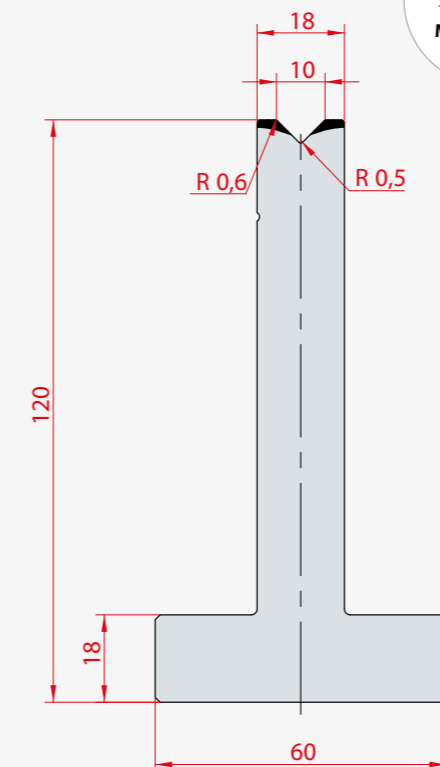
**A 3050**  
Standard C45  
Max T/m=100



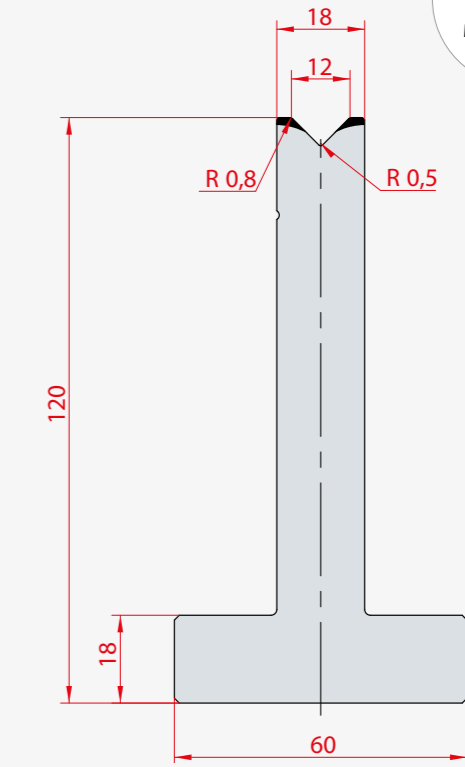
**A 3051**  
Standard C45  
Max T/m=100

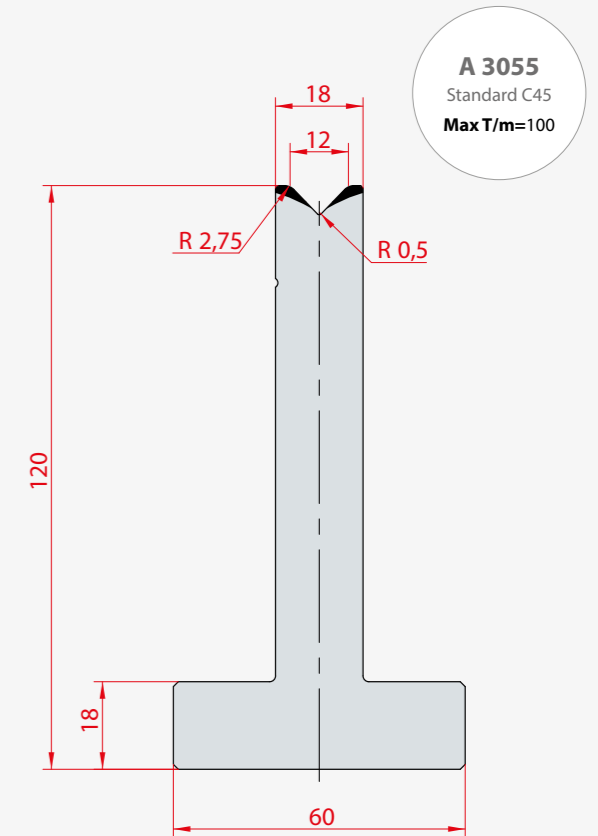
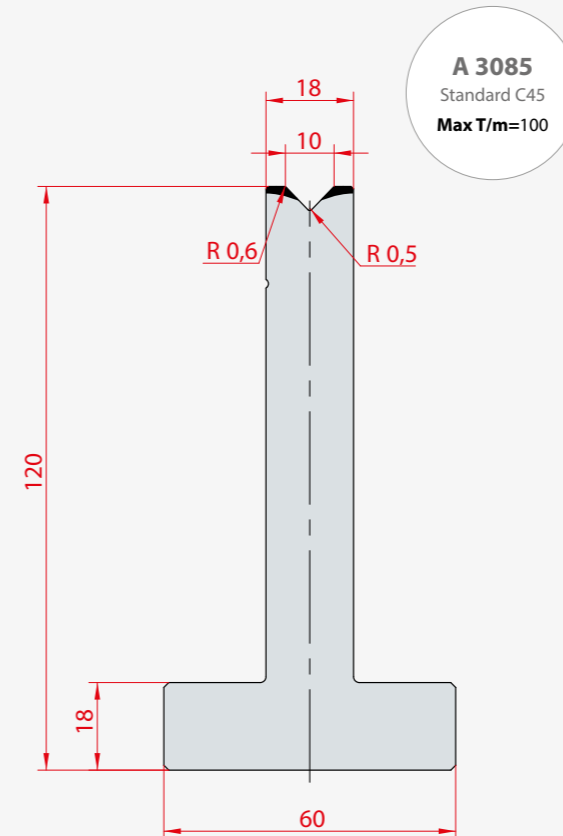
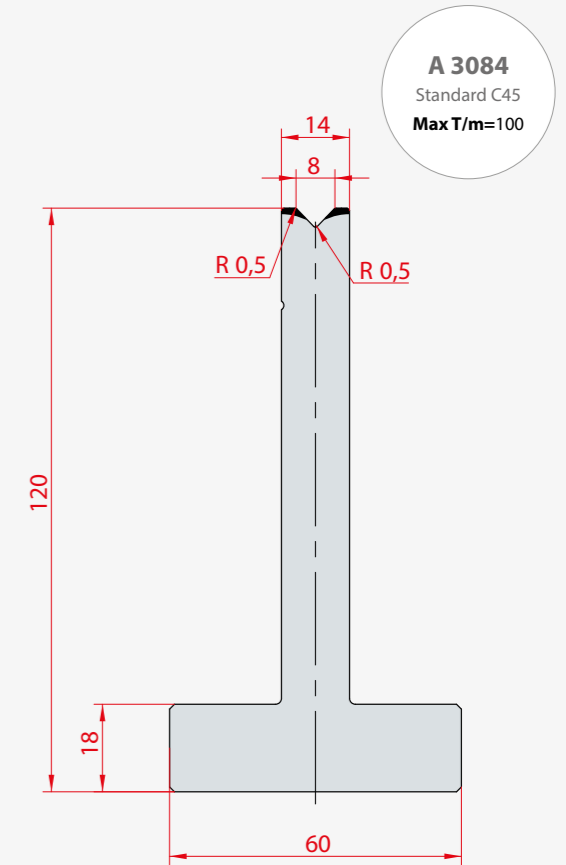
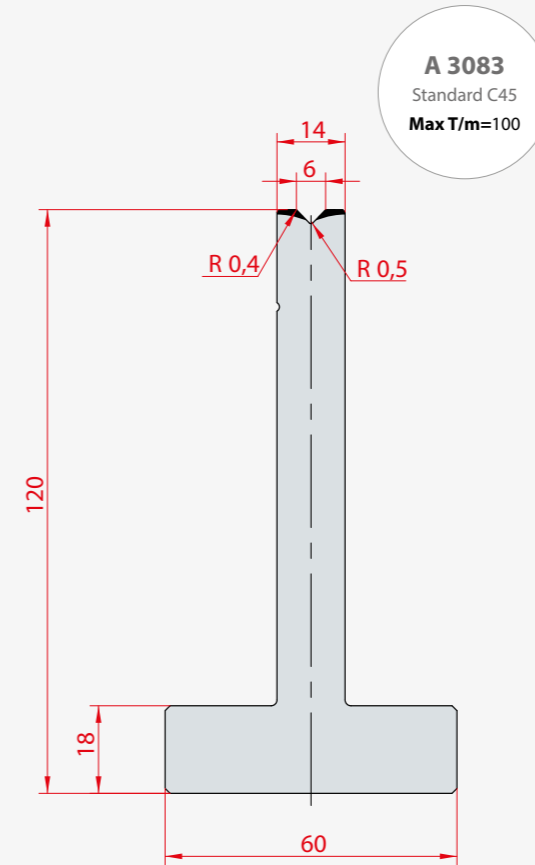
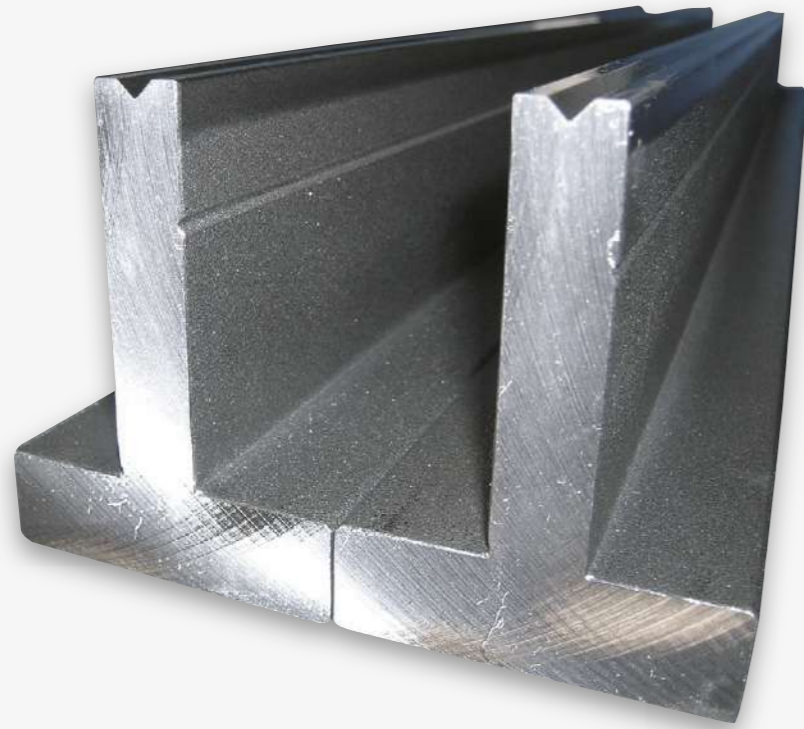
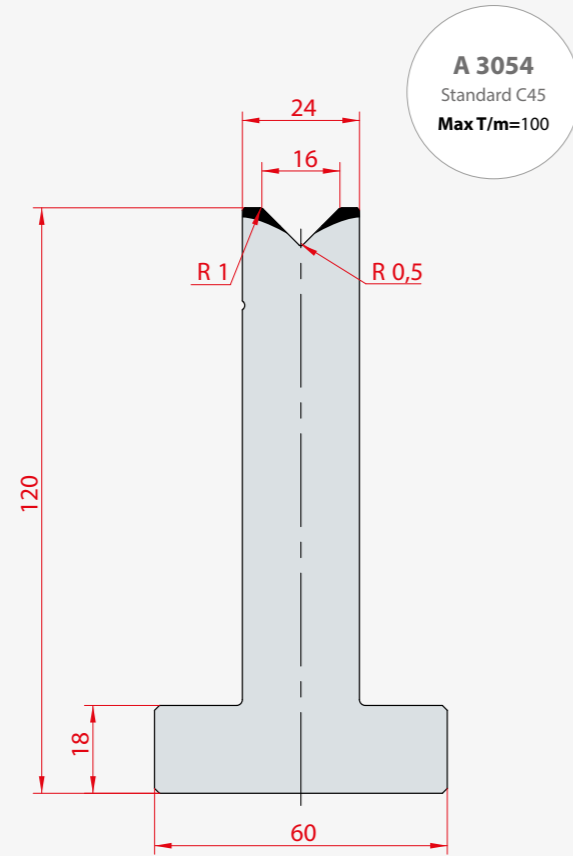


**A 3052**  
Standard C45  
Max T/m=100

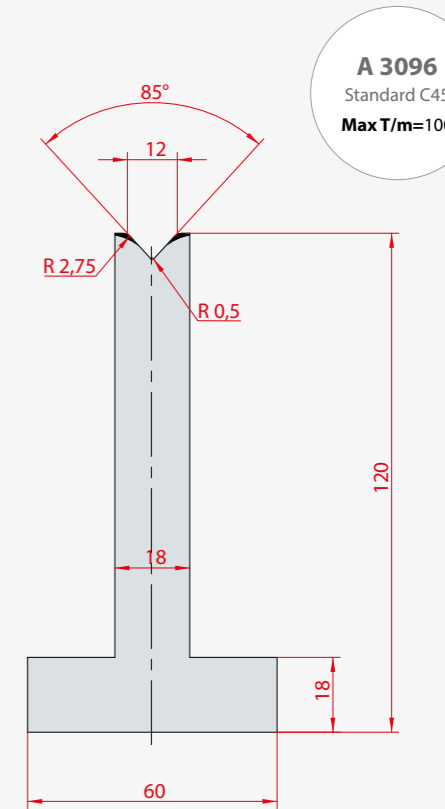
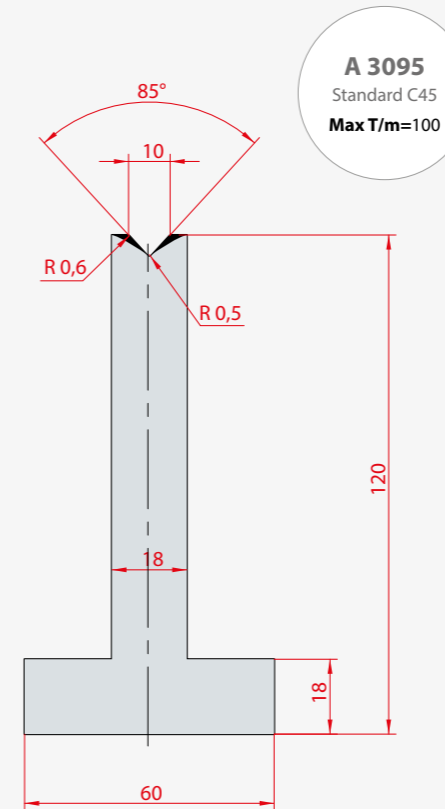
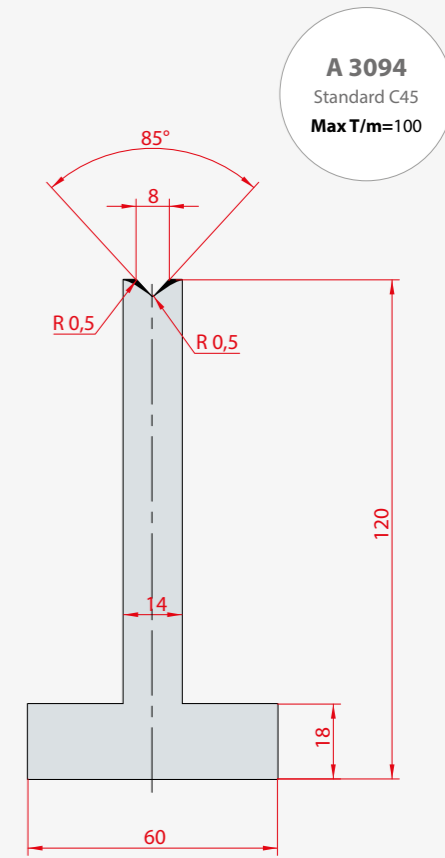
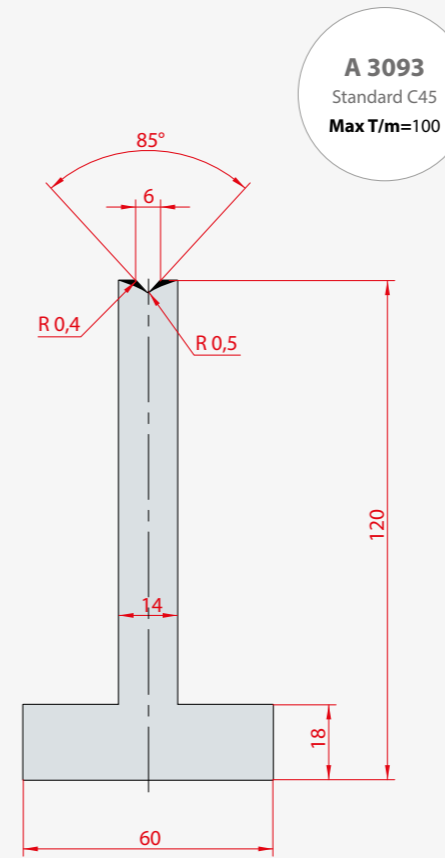
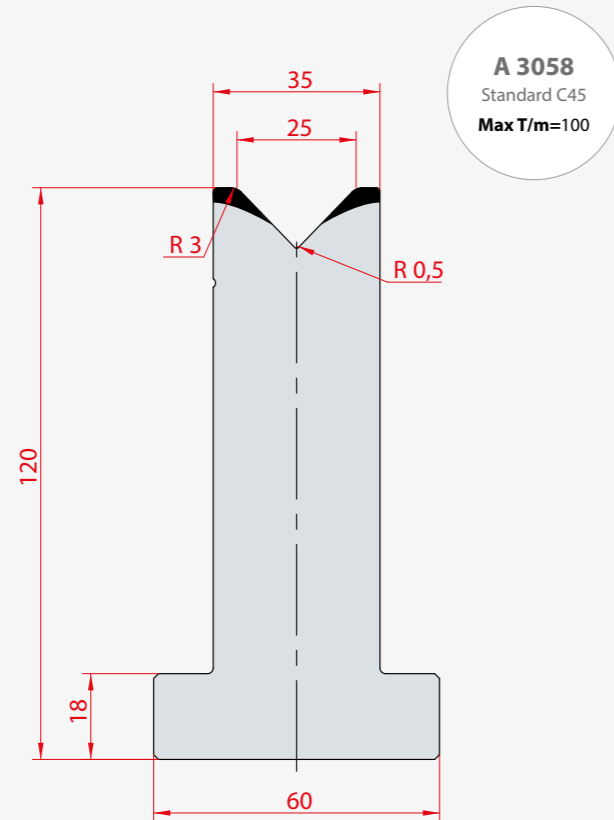
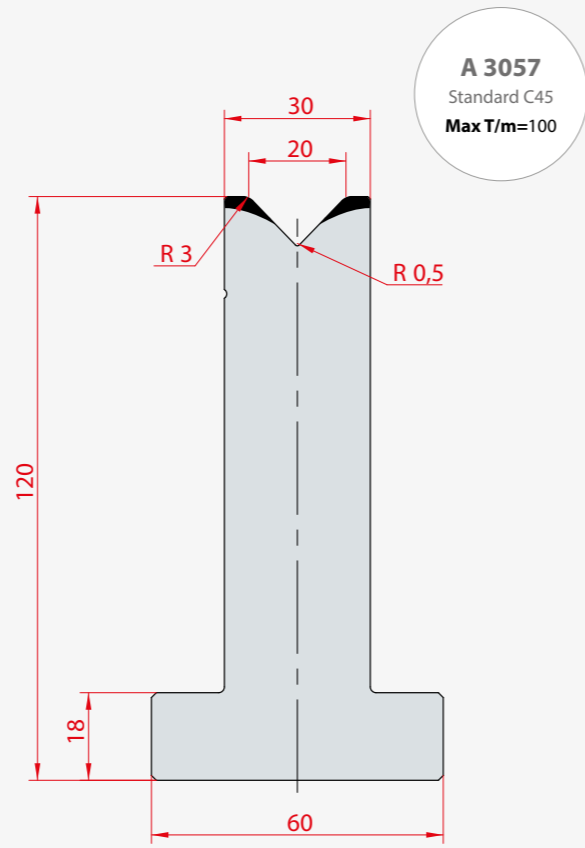
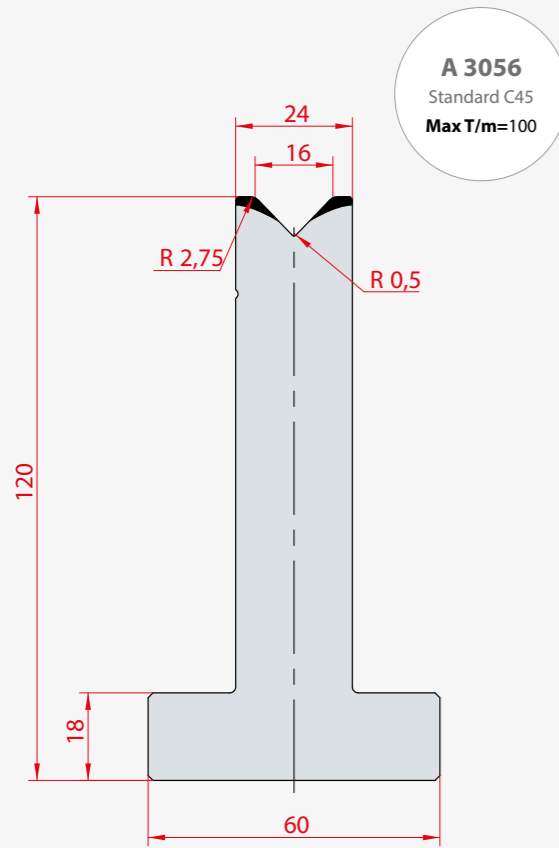


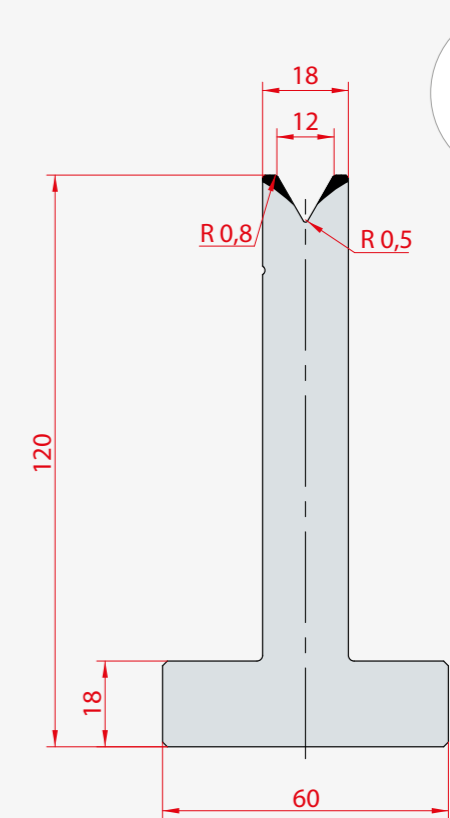
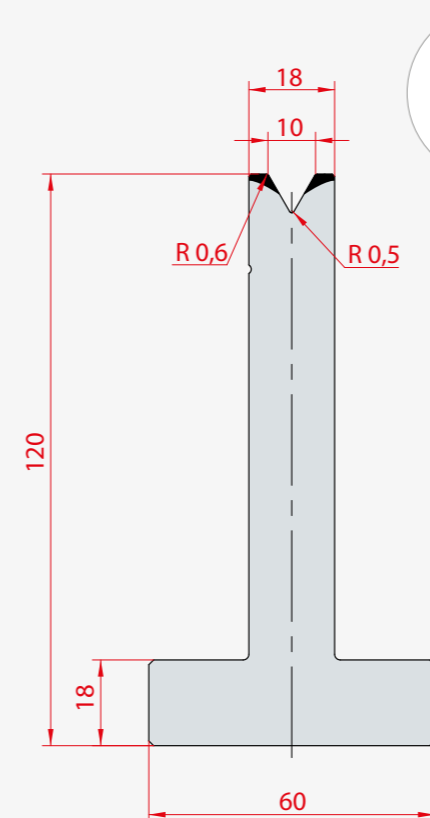
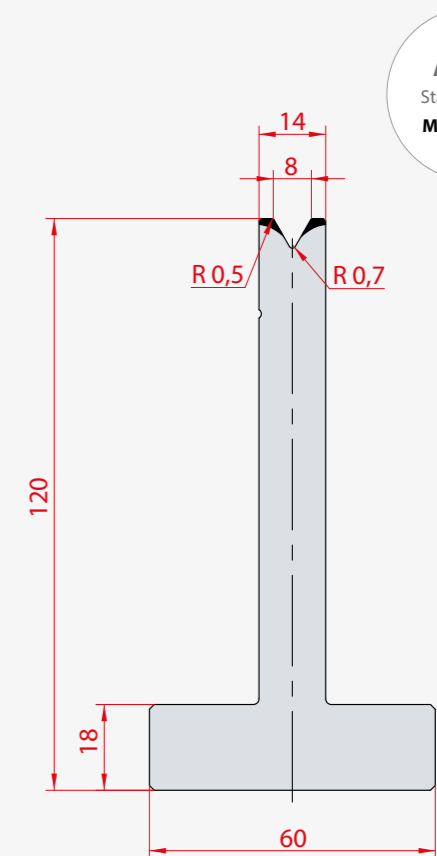
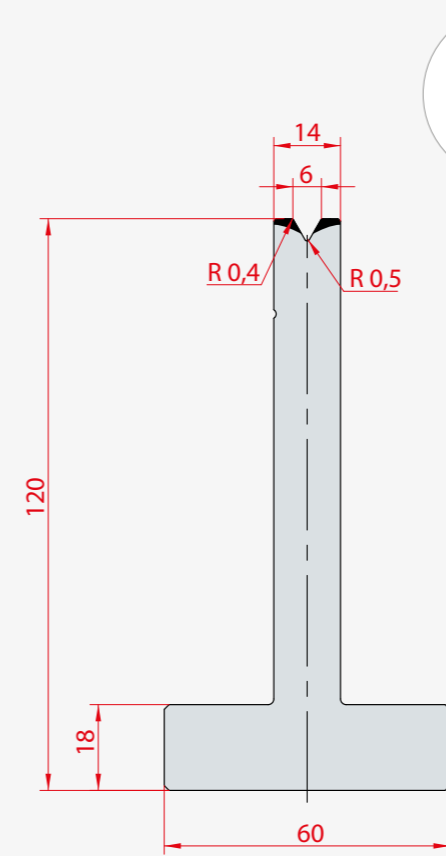
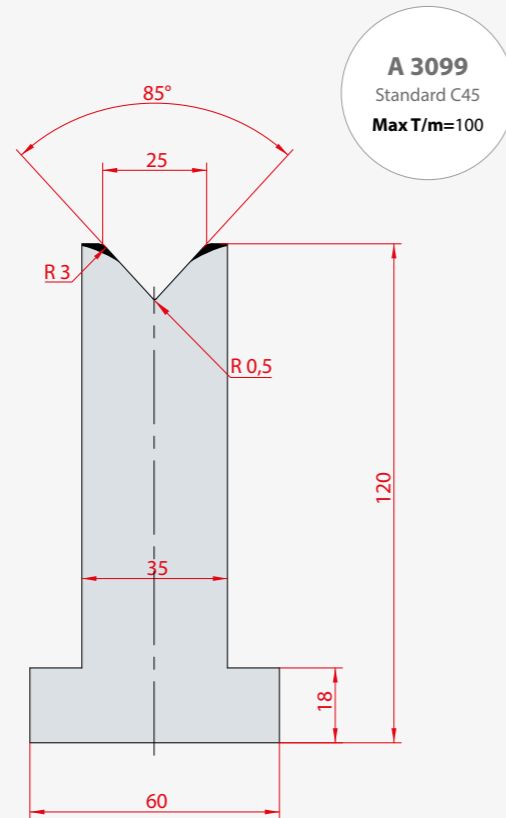
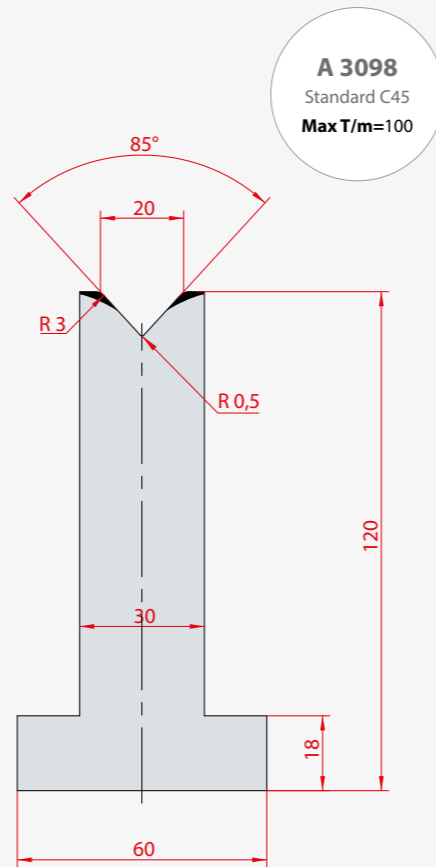
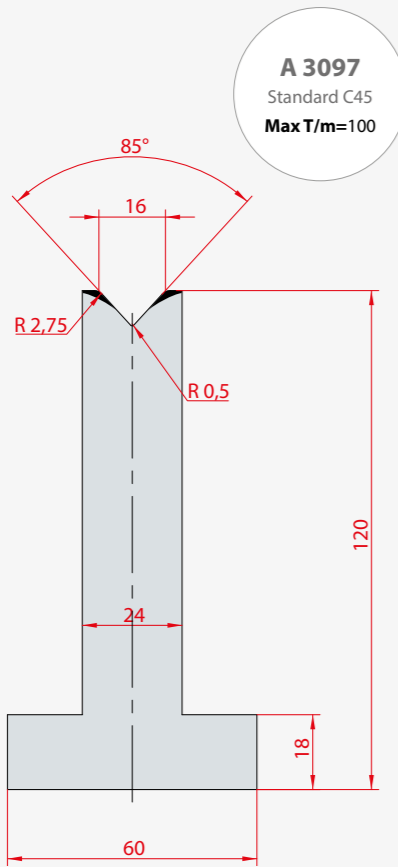
**A 3053**  
Standard C45  
Max T/m=100

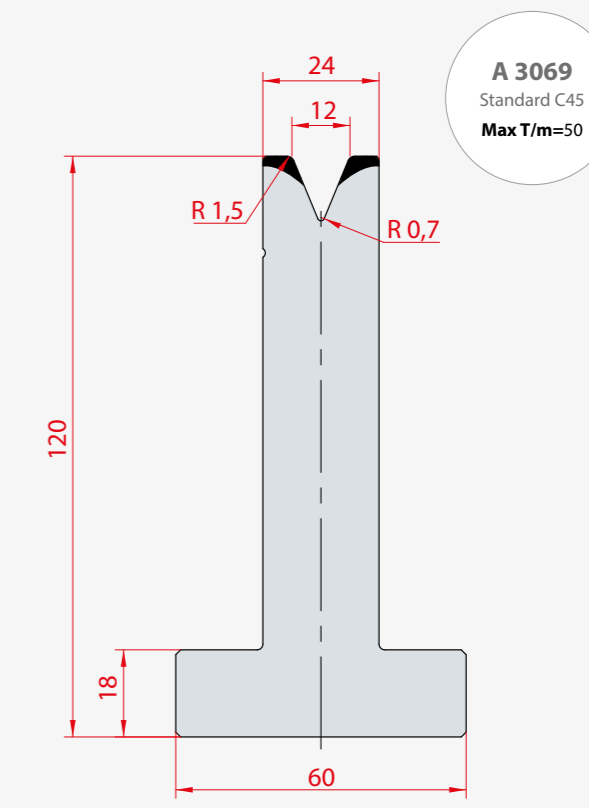
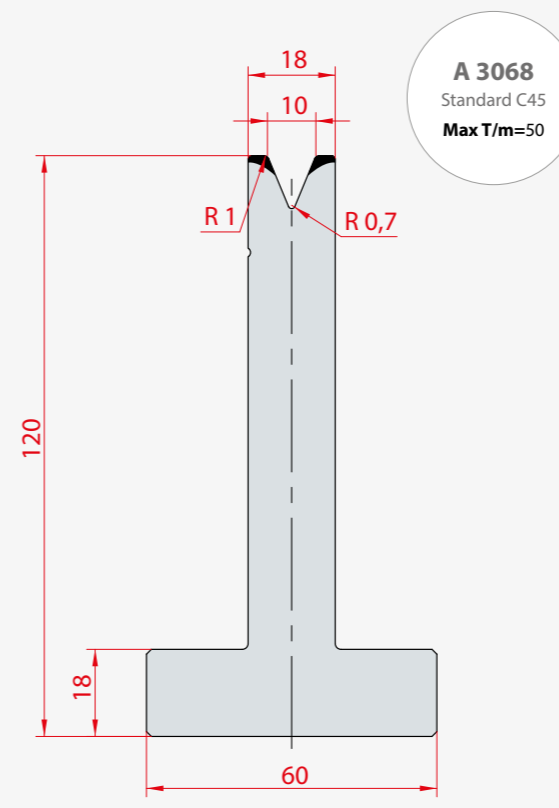
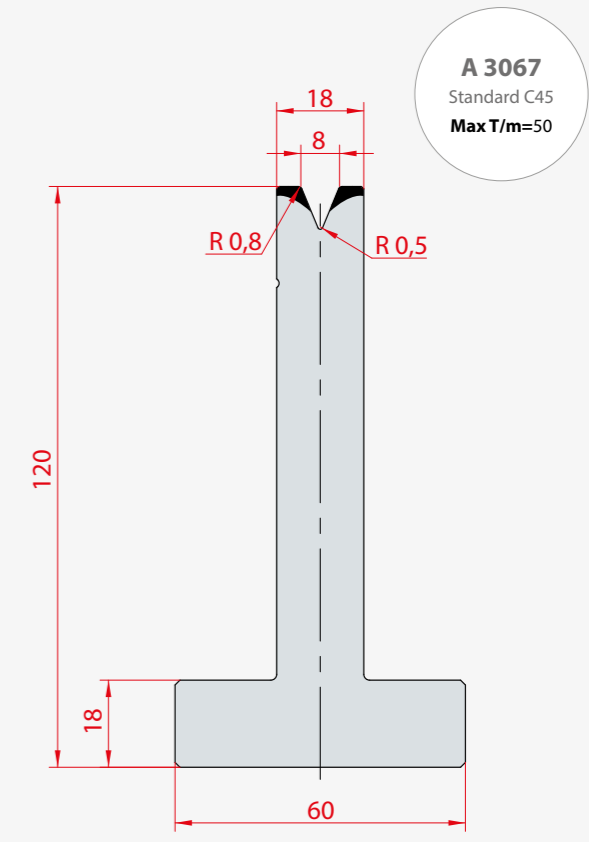
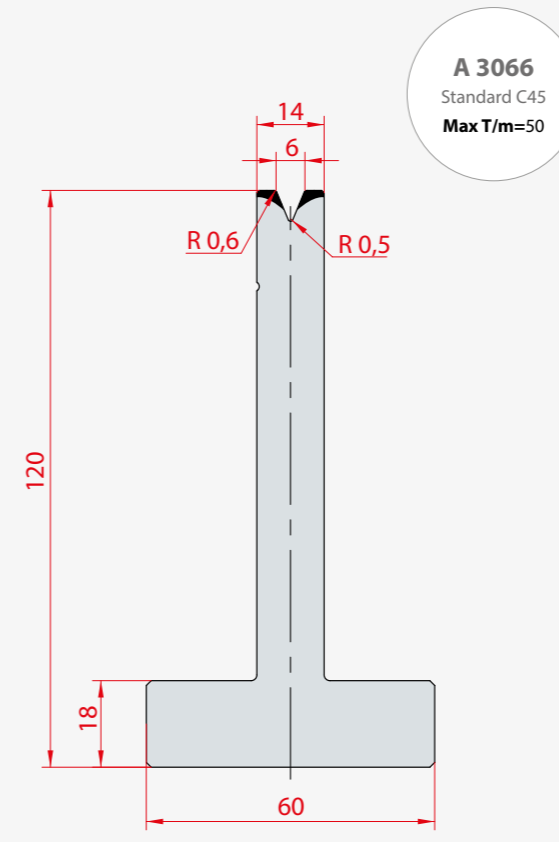
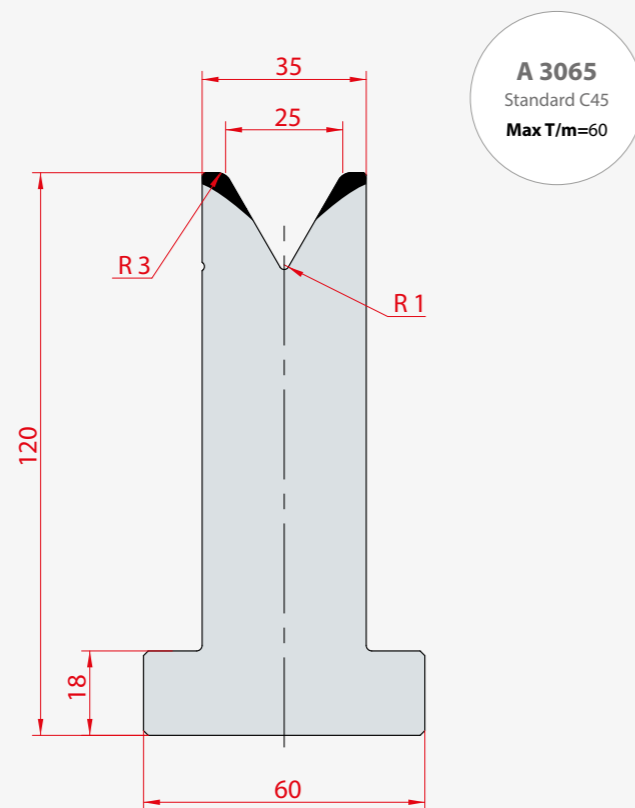
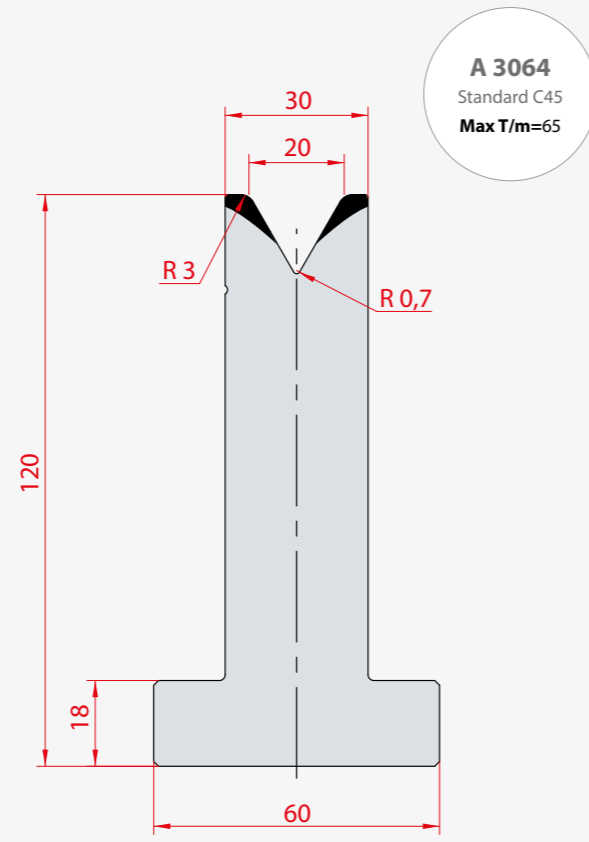
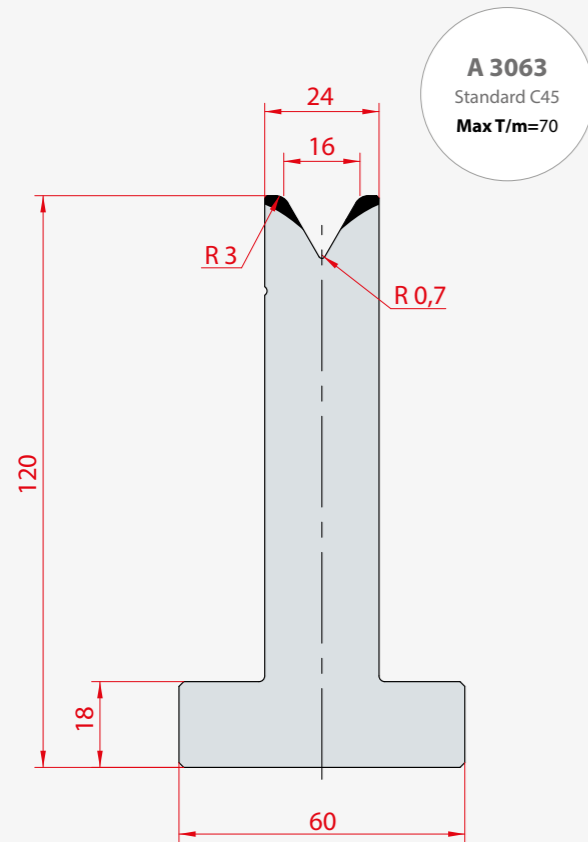


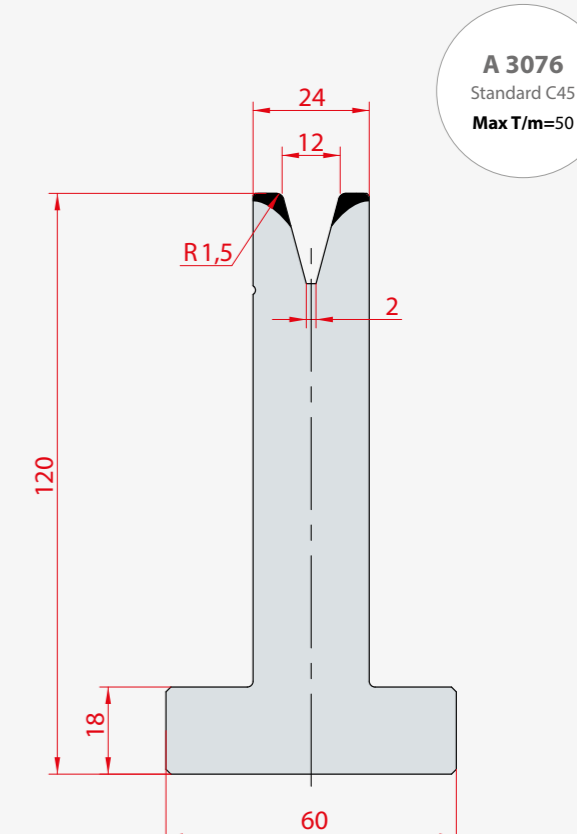
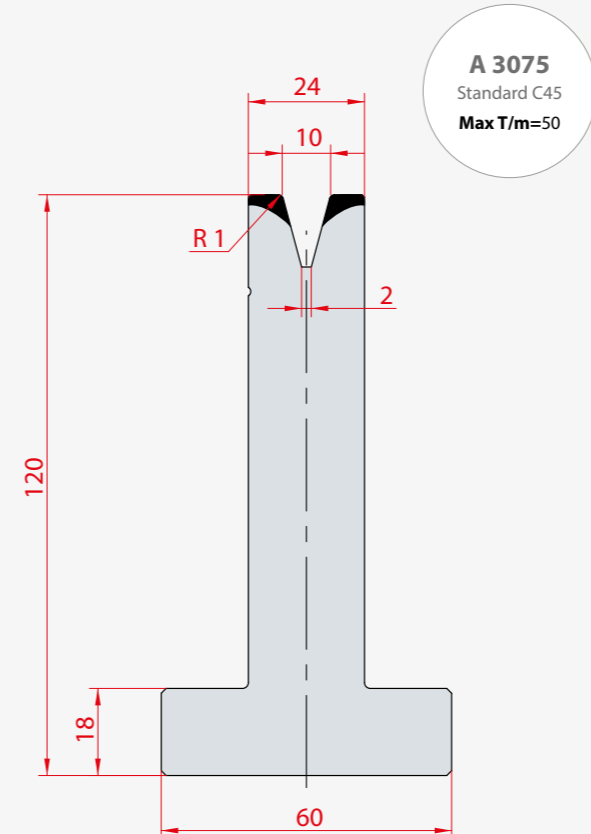
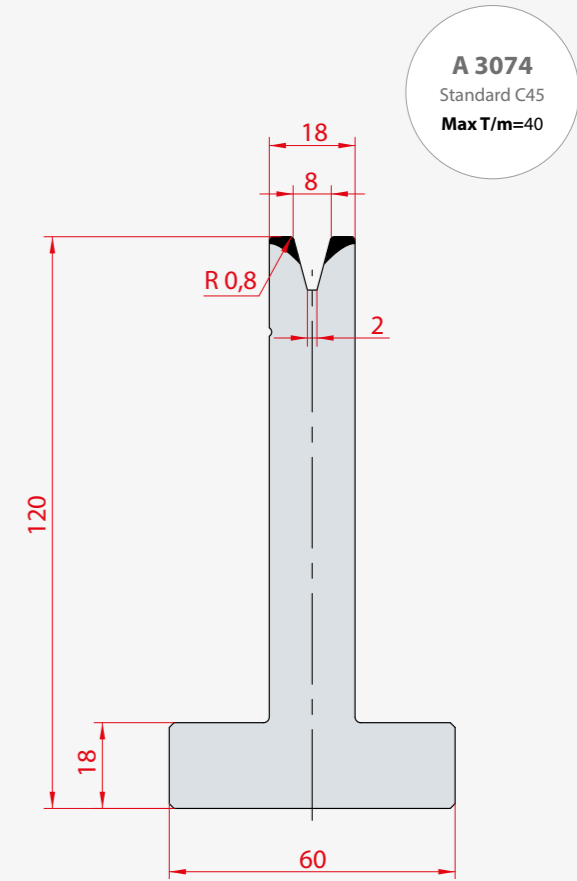
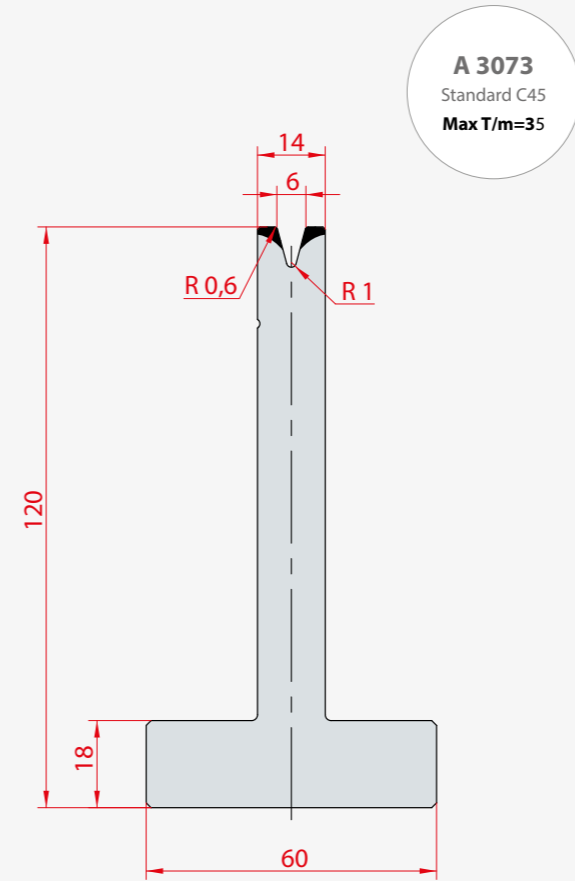
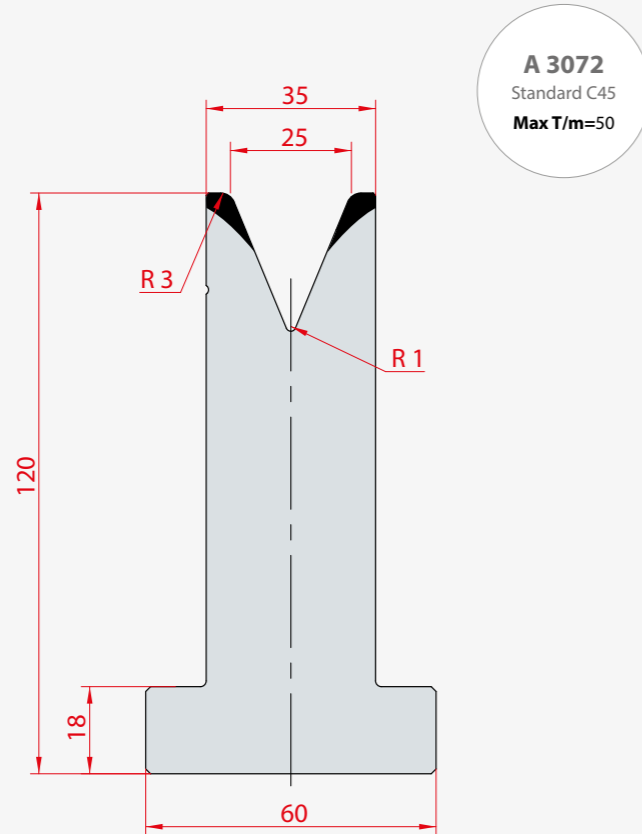
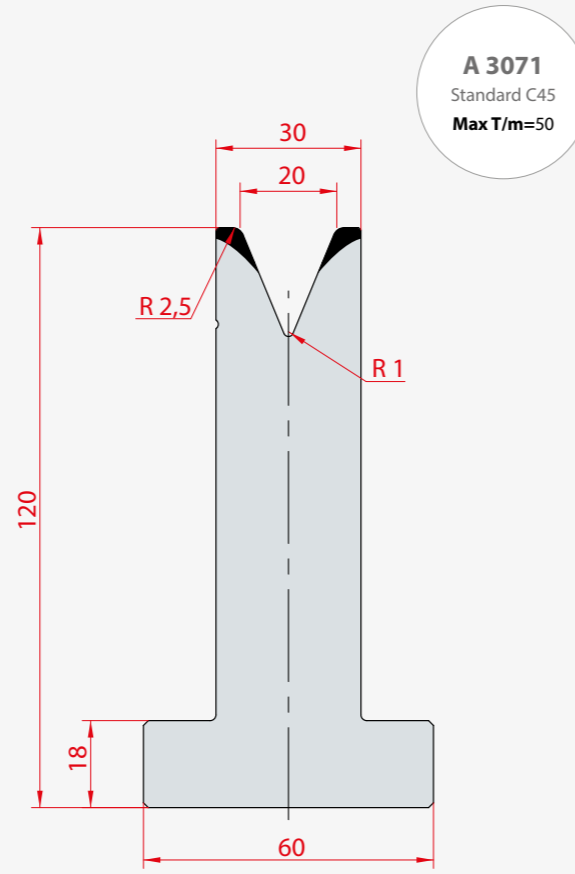
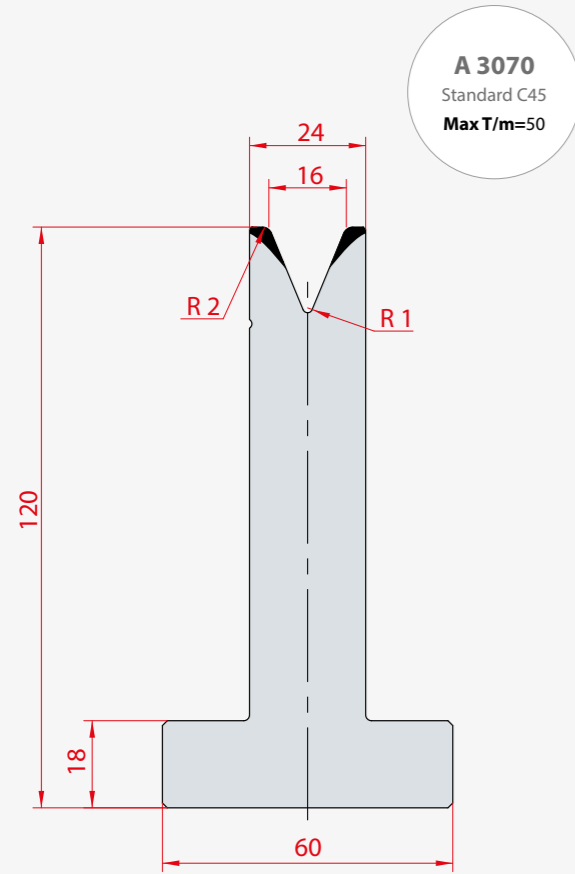


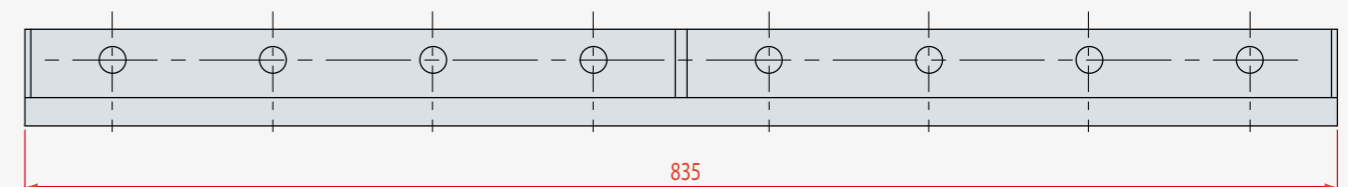
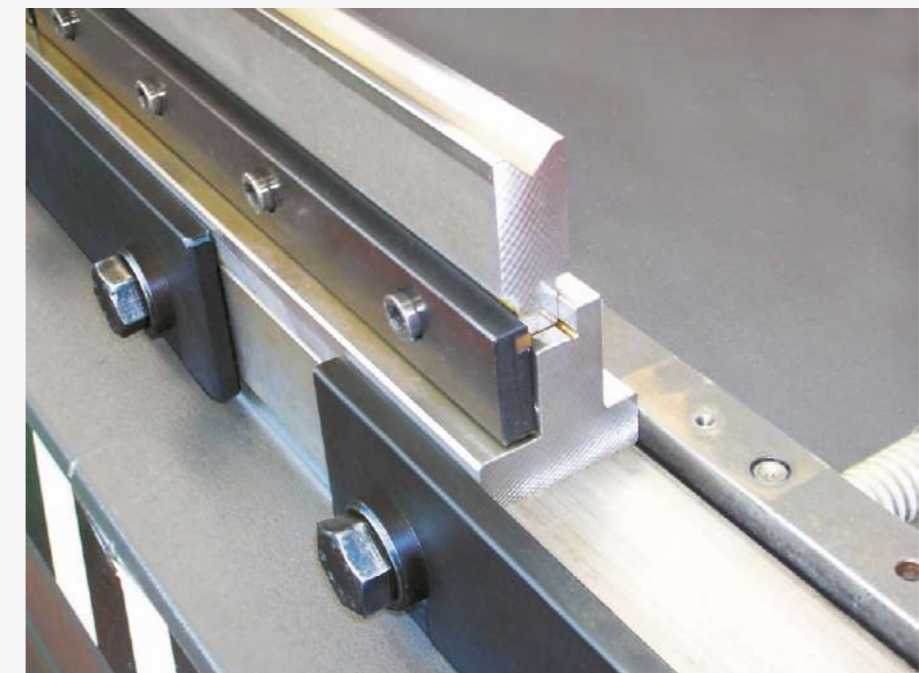
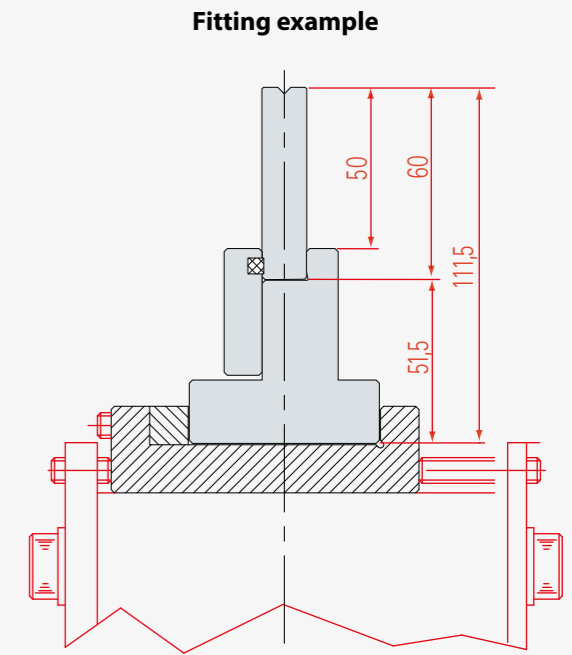
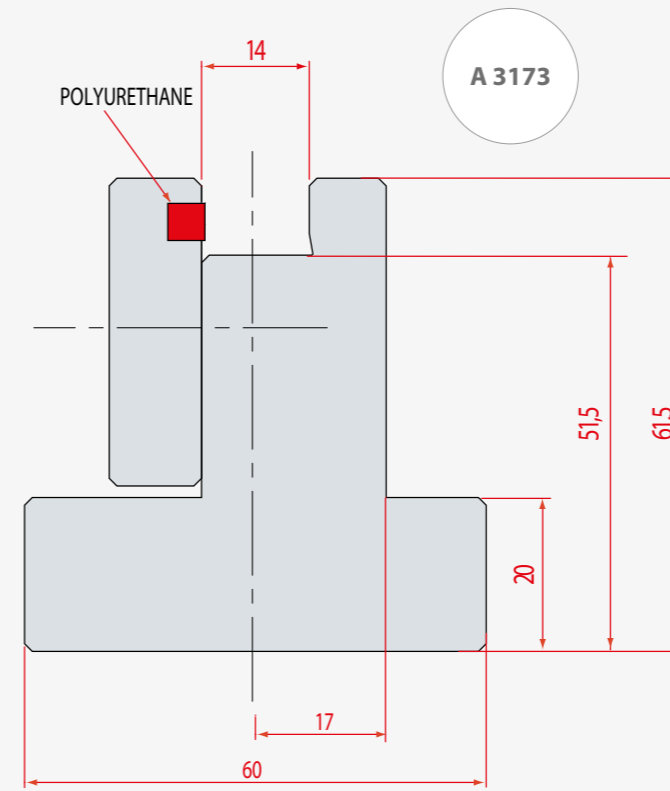
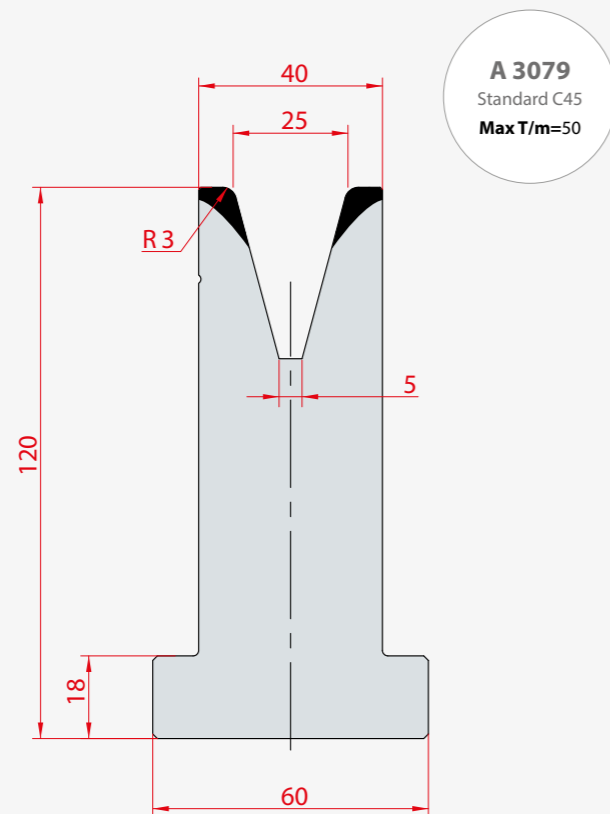
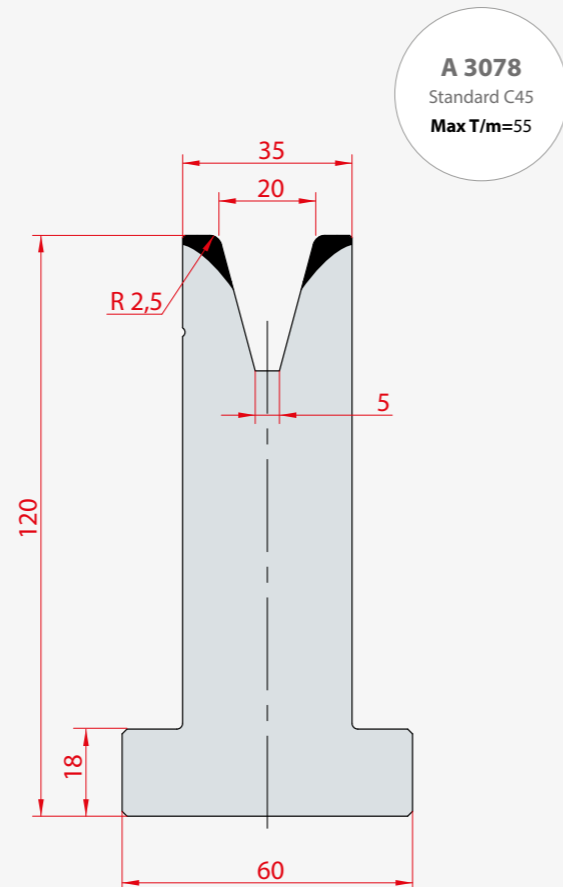
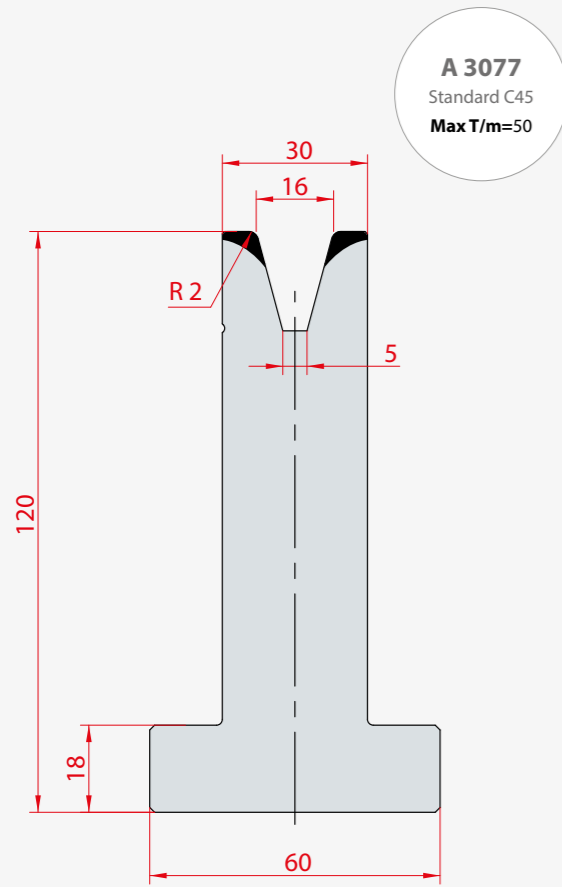




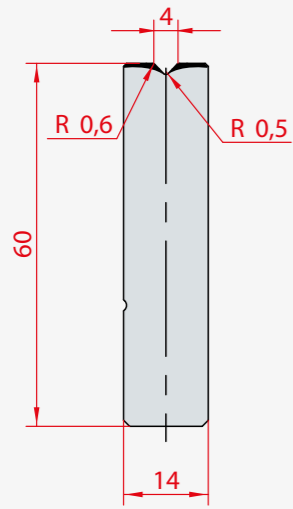




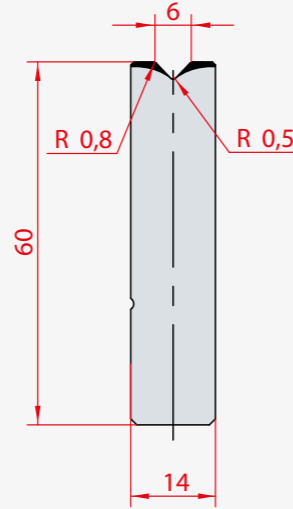




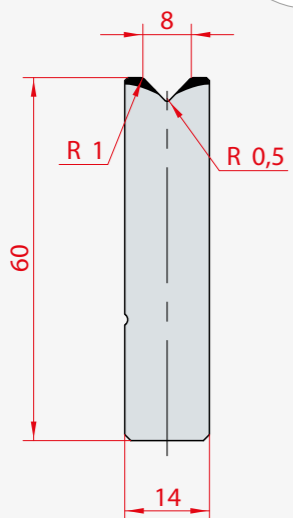
**A 3158**  
Standard C45  
Max T/m=100



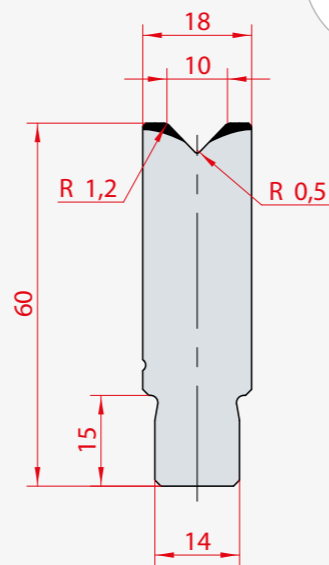
**A 3159**  
Standard C45  
Max T/m=100



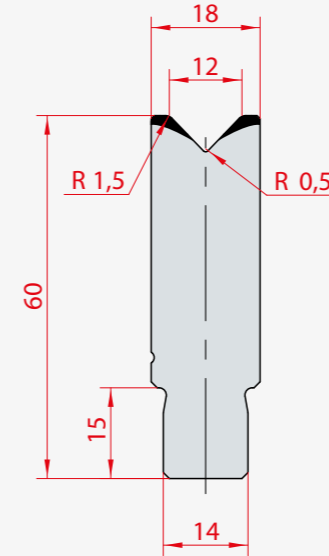
**A 3160**  
Standard C45  
Max T/m=100



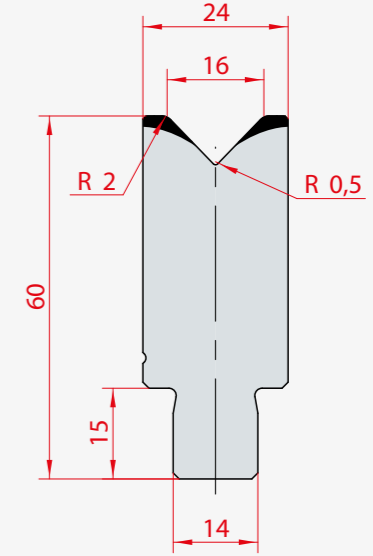
**A 3161**  
Standard C45  
Max T/m=100



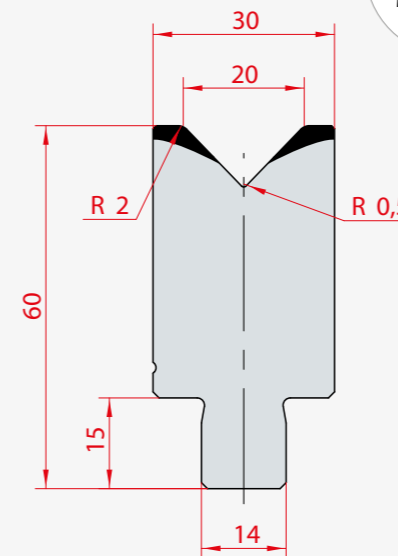
**A 3162**  
Standard C45  
Max T/m=100



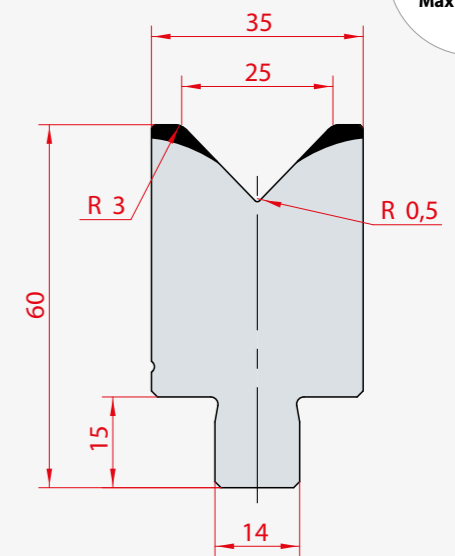
**A 3163**  
Standard C45  
Max T/m=100



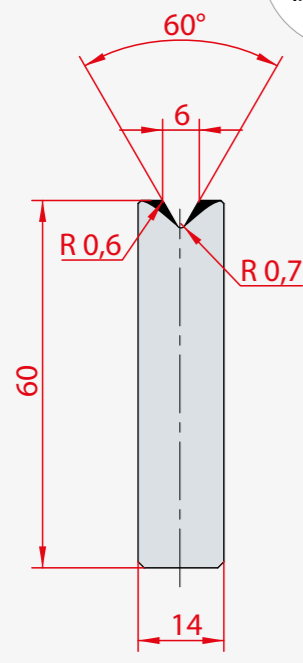
**A 3164**  
Standard C45  
Max T/m=100



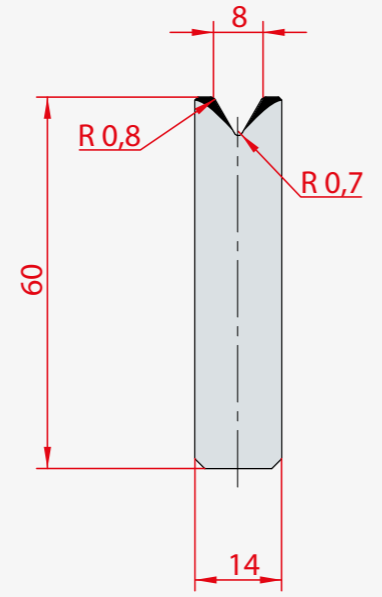
**A 3165**  
Standard C45  
Max T/m=100



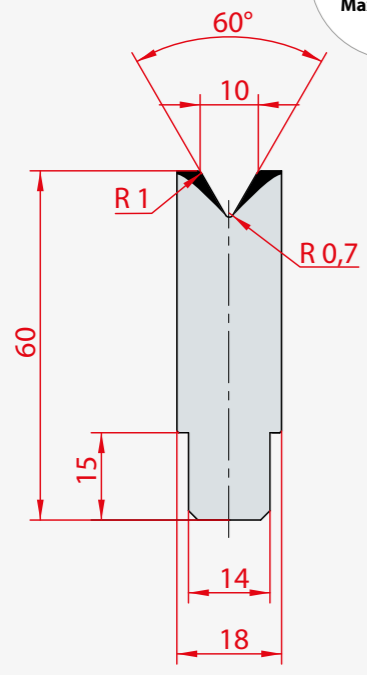
**A 3193**  
Standard C45  
Max T/m=100



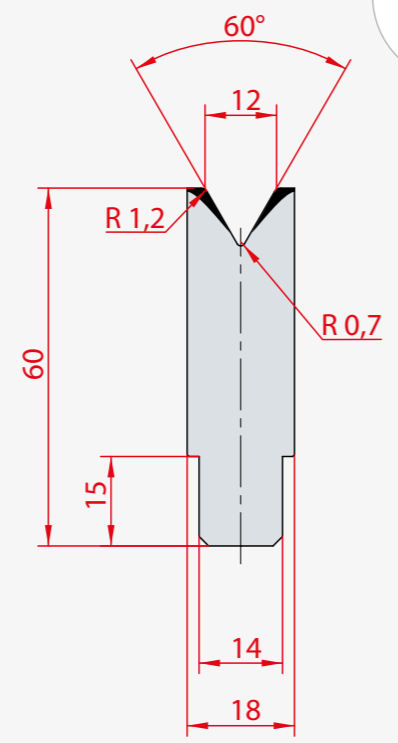
**A 3194**  
Standard C45  
Max T/m=100



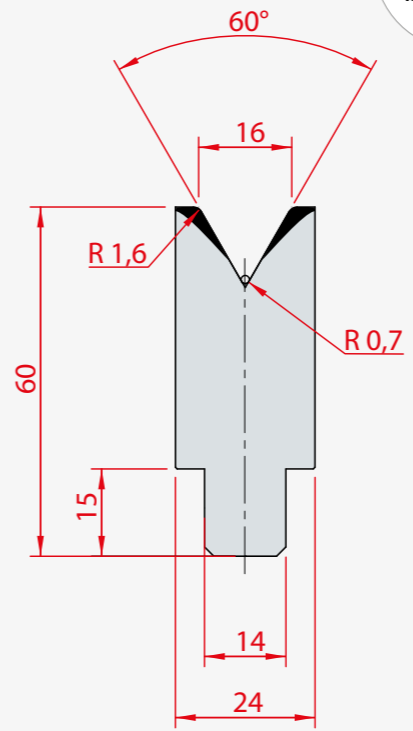
**A 3195**  
Standard C45  
Max T/m=100



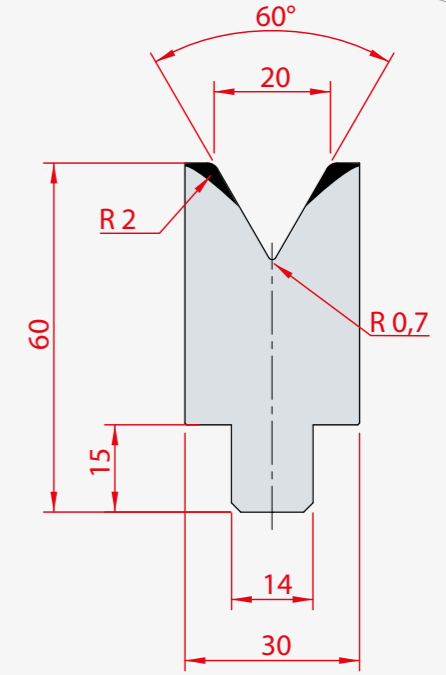
**A 3196**  
Standard C45  
Max T/m=100



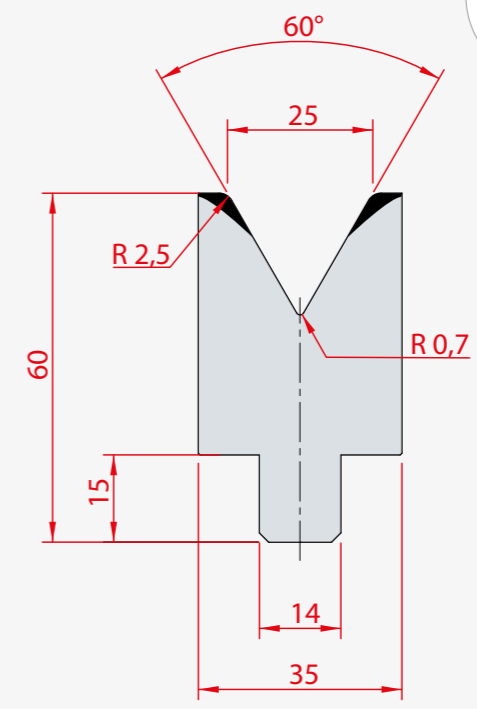
**A 3197**  
Standard C45  
Max T/m=100



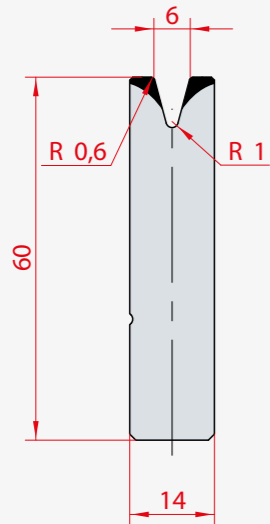
**A 3198**  
Standard C45  
Max T/m=100



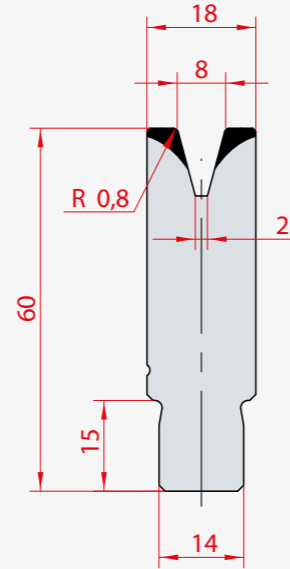
**A 3199**  
Standard C45  
Max T/m=100



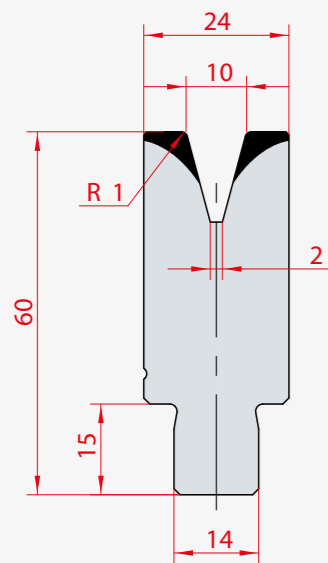
**A 3166**  
Standard C45  
Max T/m=35



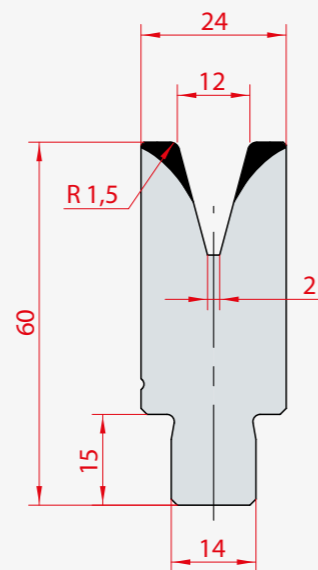
**A 3167**  
Standard C45  
Max T/m=40



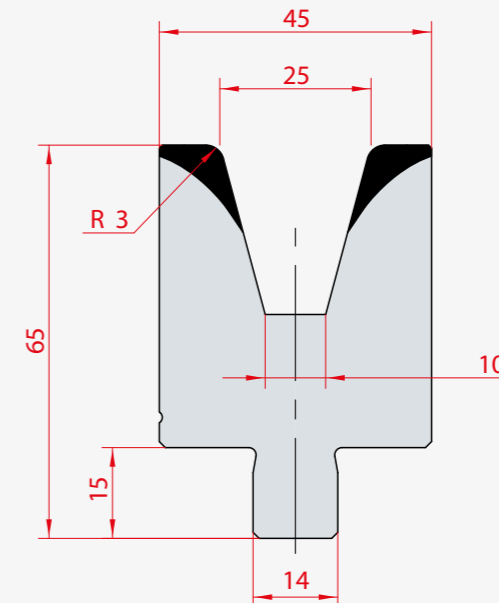
**A 3168**  
Standard C45  
Max T/m=50



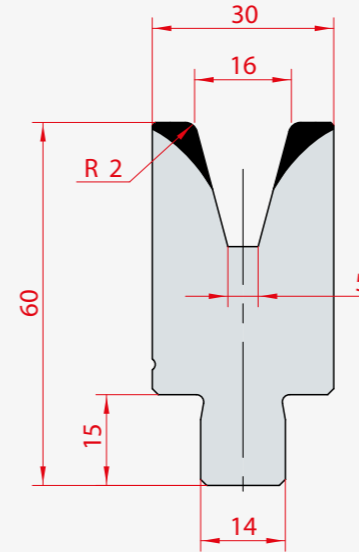
**A 3169**  
Standard C45  
Max T/m=50



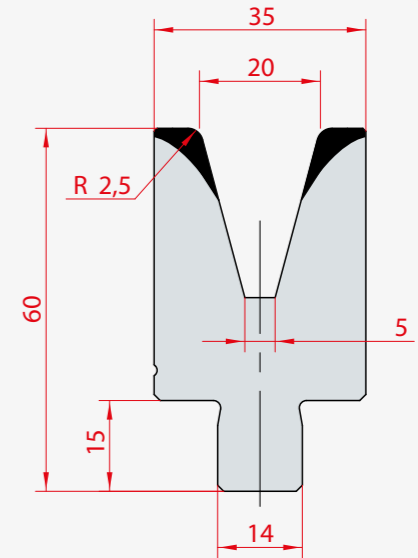
**A 3172**  
Standard C45  
Max T/m=55



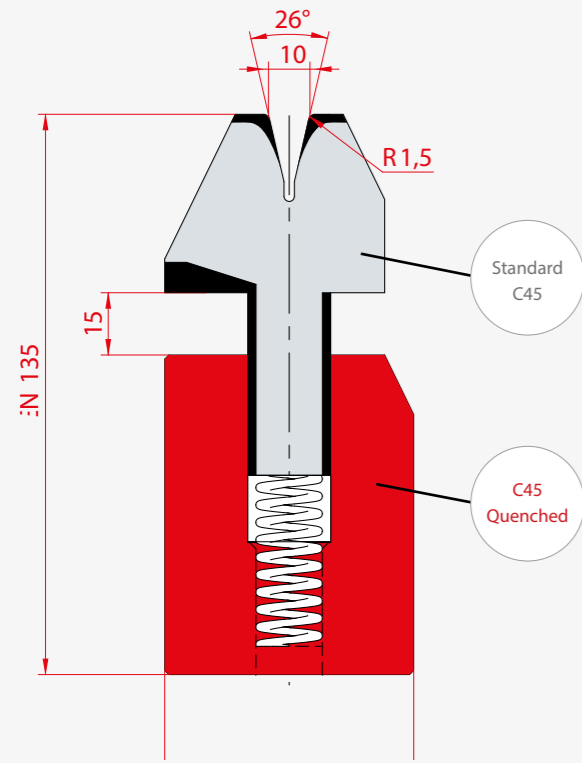
**A 3170**  
Standard C45  
Max T/m=50



**A 3171**  
Standard C45  
Max T/m=55



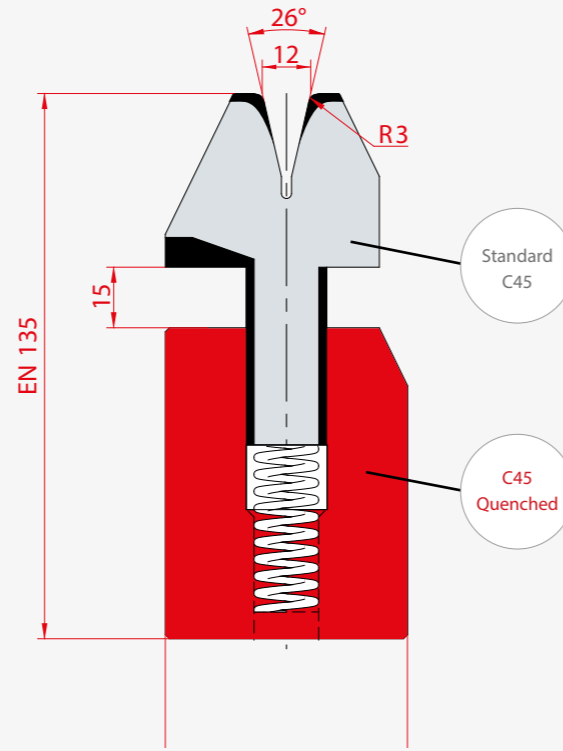




**A 3038**

Max T/m=100

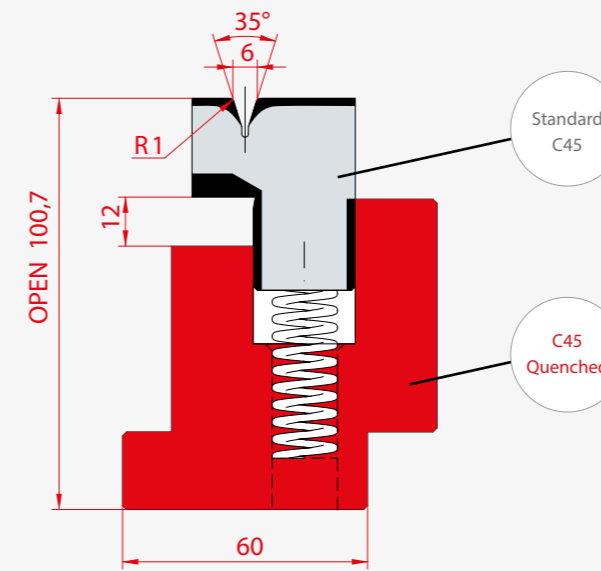
Sheet thickness : from 1,5 to 2,5 mm



**A 3040**

Max T/m=100

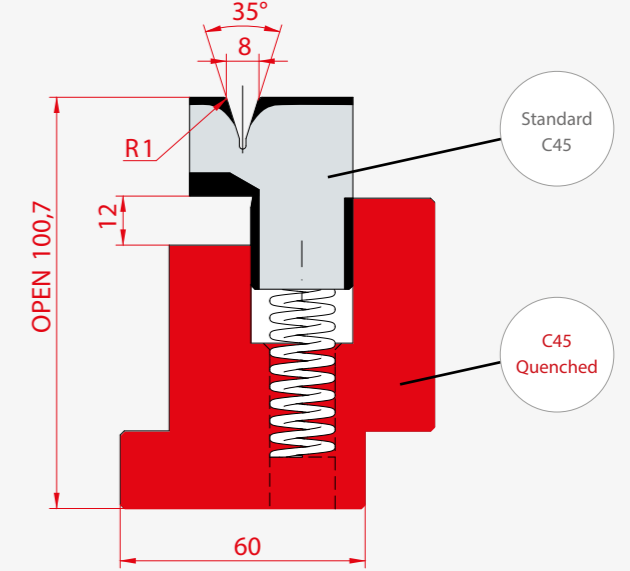
Sheet thickness : from 1,5 to 3,0 mm



**A 3037/6**

Max T/m=60

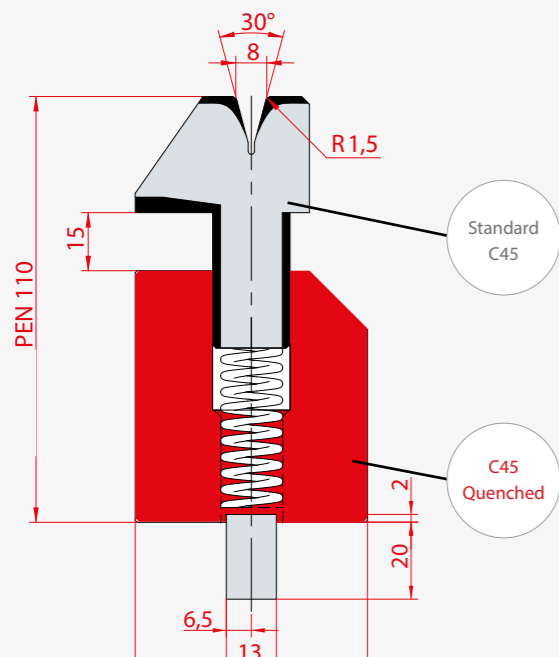
Sheet thickness : max 1,0 mm



**A 3037/8**

Max T/m=60

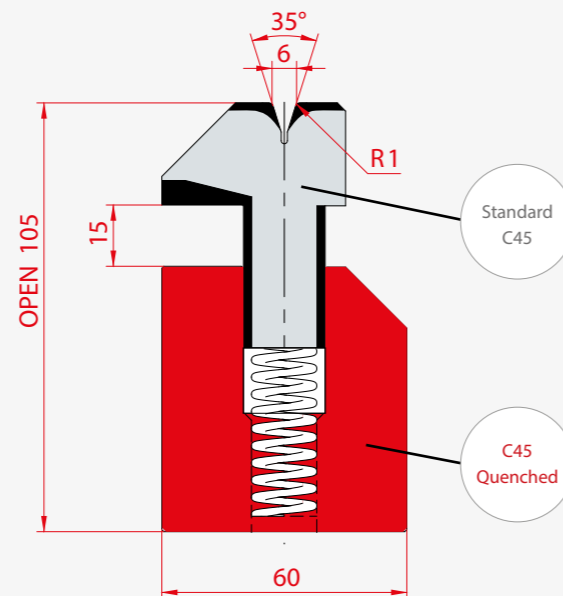
Sheet thickness : max 1,2 mm



**A 3041**

Max T/m=80

Sheet thickness : max 1,5 mm



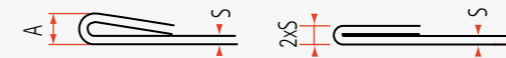
**A 3039**

Max T/m=80

Sheet thickness : max 1,0 mm

**Bending chart**

Mild Steel R.45 Kg/mm<sup>2</sup>



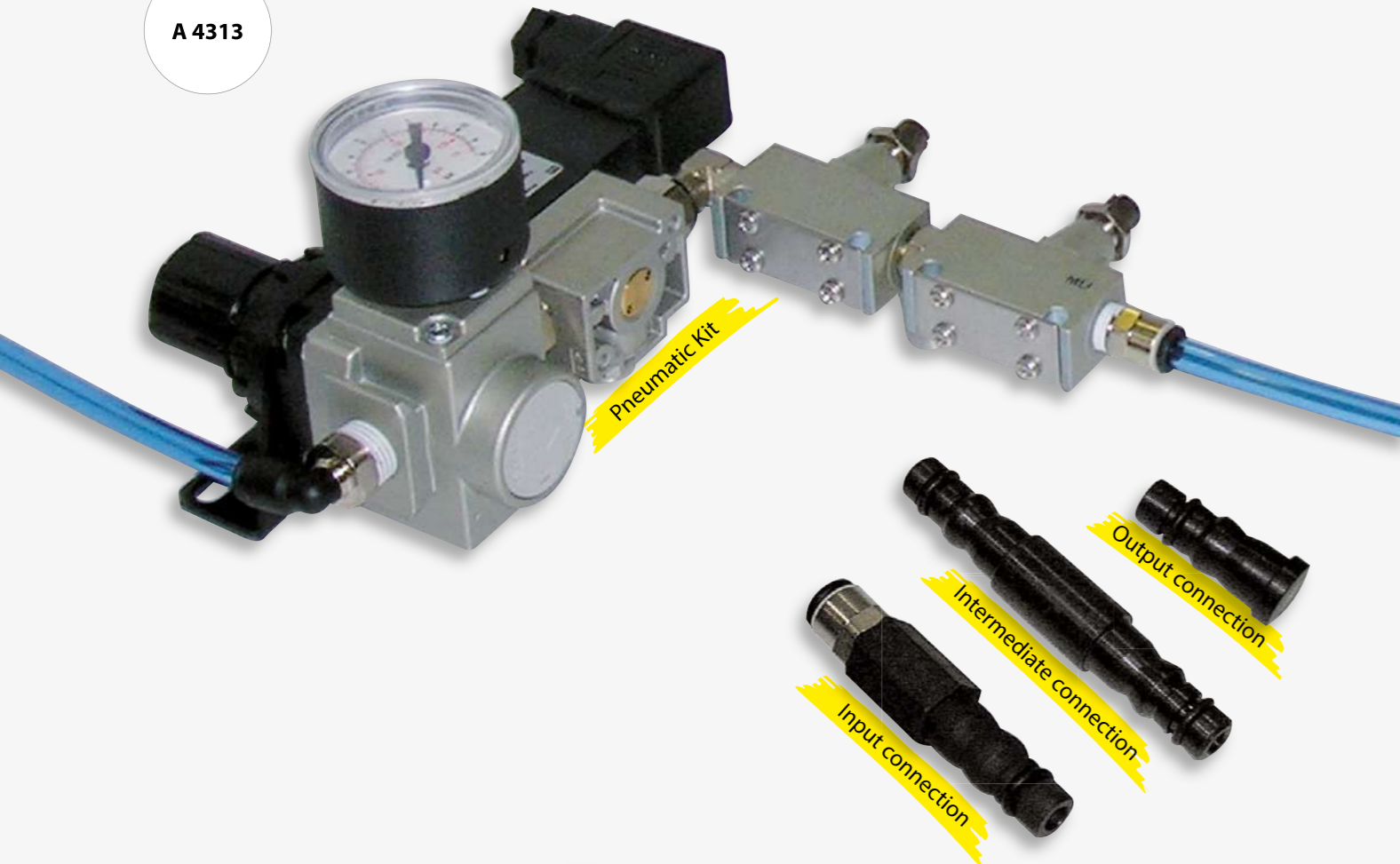
S mm	A mm	Ton /M	2xS	Ton /M
0,6	3	9	1,2	23
0,8	3	12	1,6	32
1	3,5	15	2	40
1,25	3,5	17	2,5	50
1,5	4,6	22	3	63
2	5,5	30	4	80
2,5	6,5	55	5	90
3	8	70	6	100

Stainless Steel R.70 Kg/mm<sup>2</sup>

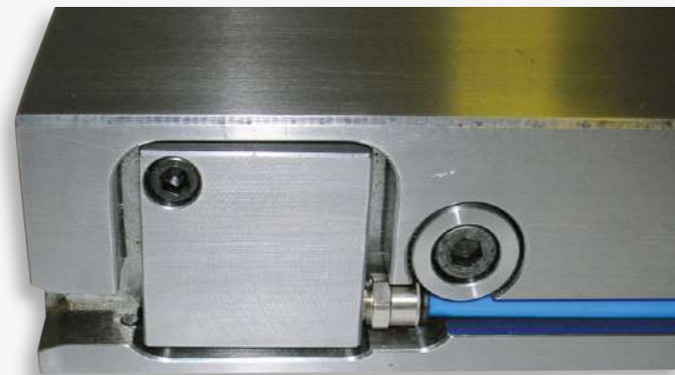


S mm	A mm	Ton /M	2xS	Ton /M
0,6	3	15	1,2	35
0,8	3	20	1,6	50
1	3,5	25	2	60
1,25	3,5	26	2,5	80
1,5	4,6	38	3	95
2	5,5	50	4	130

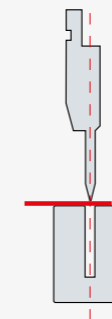
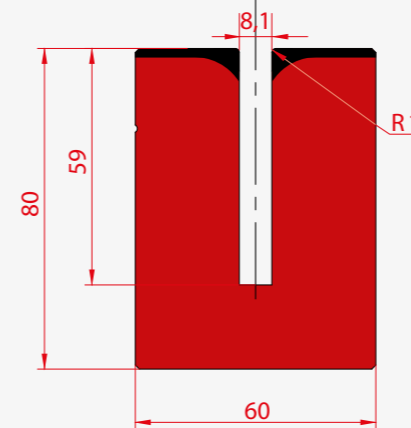
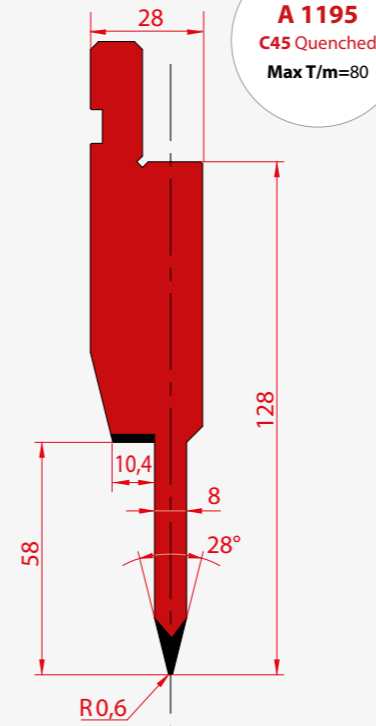
A 4313



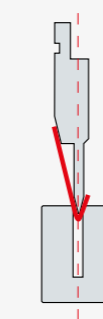
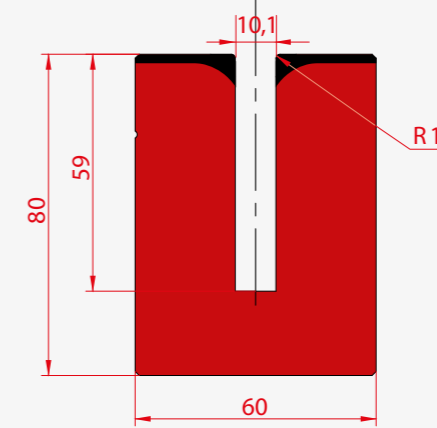
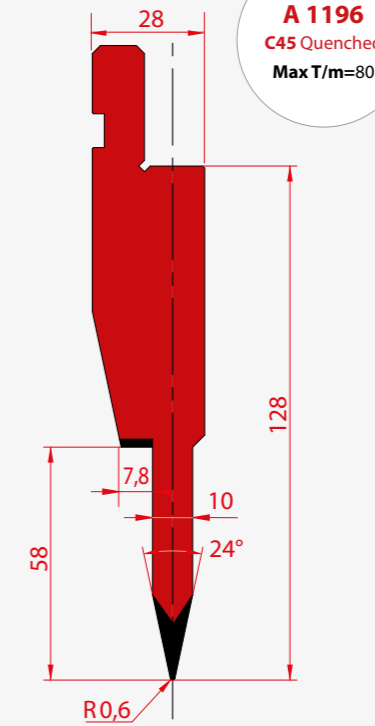
	V	A	R	H <sub>open</sub>	Max T/M
3038 PN	10	26°	1,5	135	100
3039 PN	6	35°	1	105	80
3040 PN	12	26°	3	135	100
3041 PN	8	30°	1,5	110	80



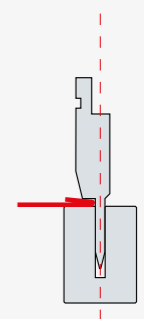
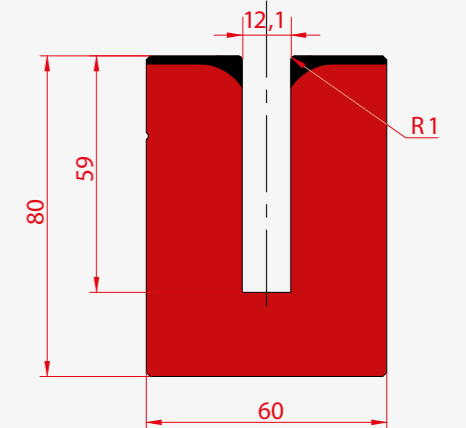
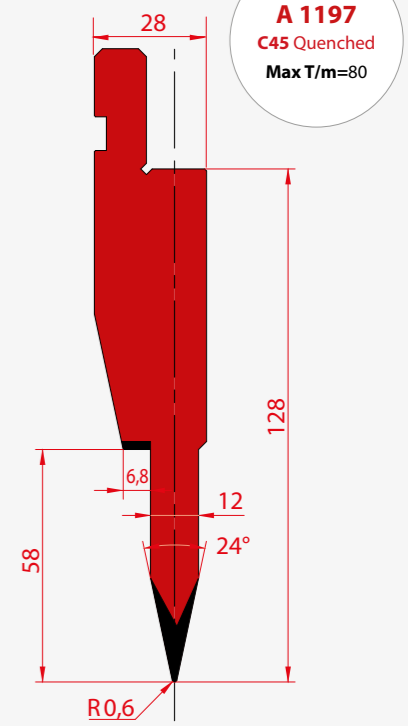
max sheet thickness  
mild steel 1,2 mm



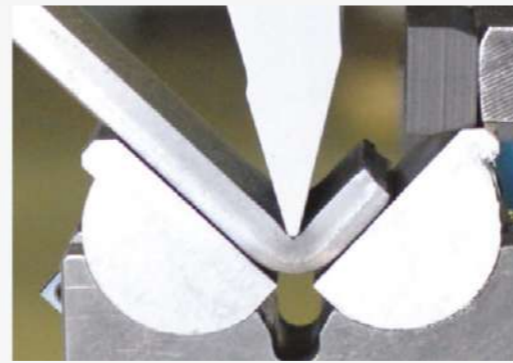
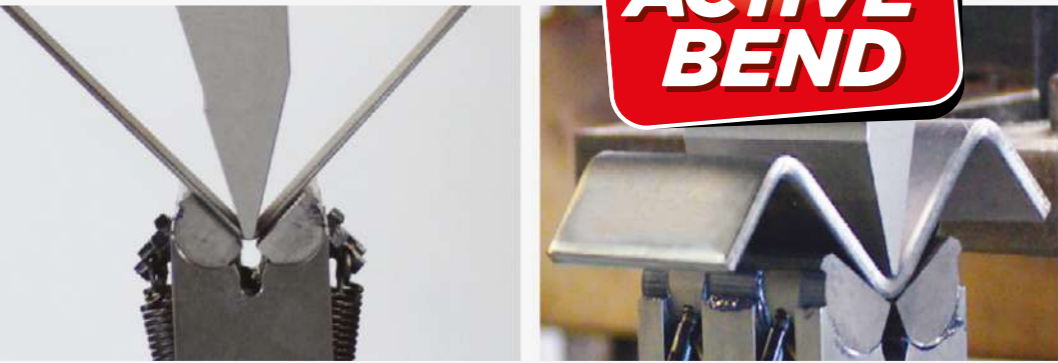
max sheet thickness  
mild steel 1,5 mm



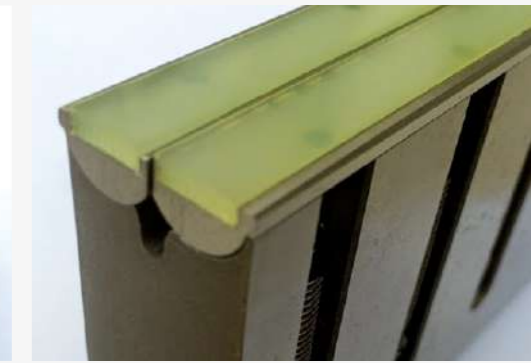
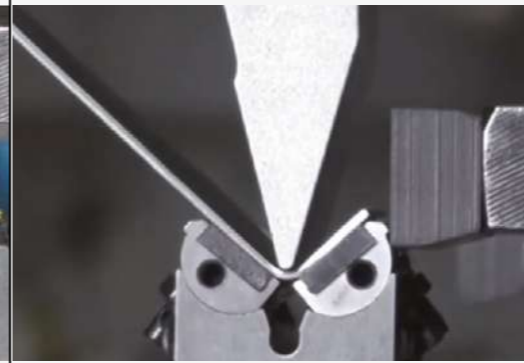
max sheet thickness  
mild steel 1,5 mm



**ACTIVE BEND**



**ACTIVE BEND**  
**PREMIUM**



**NEW TECHNOLOGY FOR HIGH QUALITY RESULTS**

Active Bend provides advantages that the standard dies can't perform:

- 40° acute bending
- narrow minimum edges
- no strain with perforated sheets

**THE ULTIMATE SOLUTION FOR AVOID BENDING MARKS**

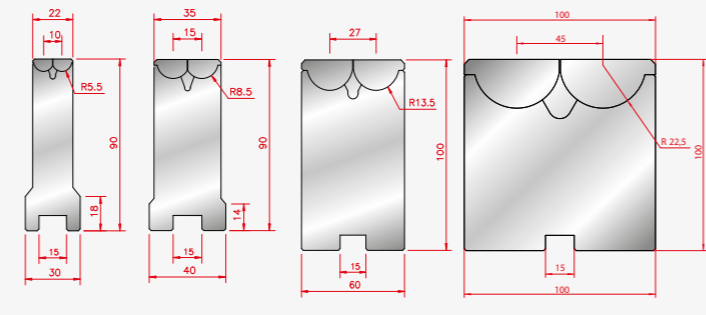
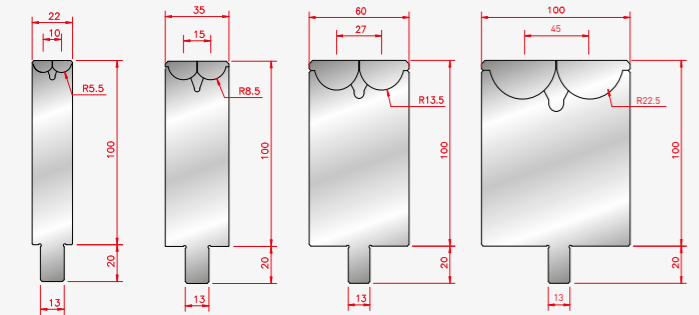
Active Bend PREMIUM is our brand new patented system that allows you to get superior bending results avoiding any marks on your sheet metal.

**- reduction of bending mark**  
**- 40° acute bending**

**- no die mark bending**  
**- 40° acute bending**

**WILA-TRUMPF**

**AMADA-PROMECAM RAIL**

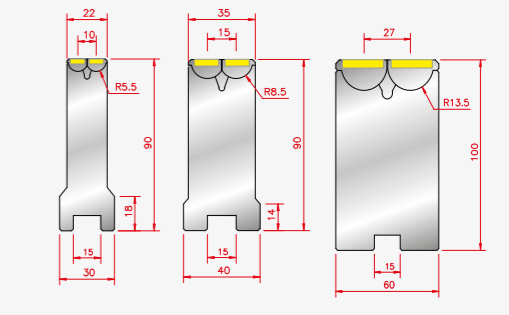
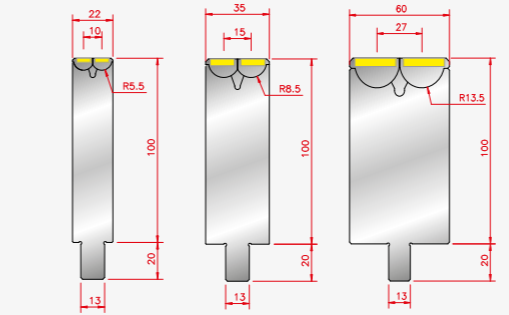


**3300 (AB-200)**   **3301 (AB-300)**   **3302 (AB-600)**   **3312 (AB-1000)**

**3303 (AB-200)**   **3304 (AB-300)**   **3305 (AB-600)**   **3313 (AB-1000)**

**WILA-TRUMPF**

**AMADA-PROMECAM RAIL**

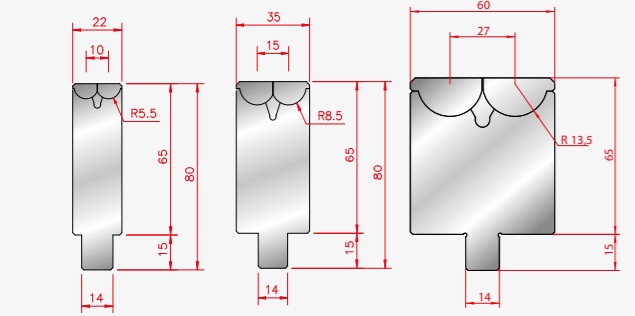


**3300P (AB-200)**   **3301P (AB-300)**   **3302P (AB-600)**

**3303P (AB-200)**   **3304P (AB-300)**   **3305P (AB-600)**

**AMADA-PROMECAM**

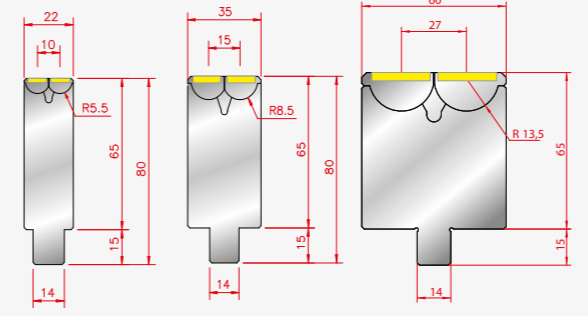
MODEL	LENGTH (MM)
AB200	50
	100
	200
	500
	15, 20, 25, 30
AB300	50
	100
	200
	500
	15, 20, 25, 30
AB450	50
	100
	200
	500
	50
AB600	50
	100
	200
	500
	200
AB1000	200



**3306 (AB-200)**   **3307 (AB-300)**   **3308 (AB-450)**

**AMADA-PROMECAM**

MODEL	LENGTH (mm)
AB200P	50
	100
	200
	500
	50
AB300P	50
	100
	200
	500
	50
AB450P	50
	100
	200
	500
	50
AB600P	50
	100
	200
	500
	500



**3306P (AB-200)**   **3307P (AB-300)**   **3308P (AB-450)**

## ACTIVE BEND / ACTIVE BEND PREMIUM

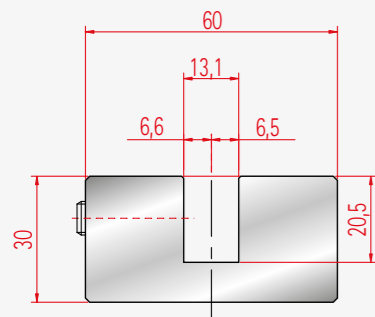


Active Bend and Active Bend Premium dies allow you to bend different sheet metal thickness as reported on the chart below. Values are expressed in millimeters (mm).

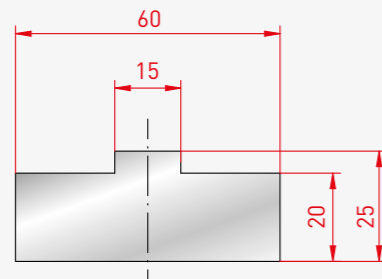
MODEL	Max Load T/m
AB200	100
AB300	130
AB450	150
AB600	200
AB1000	220

Bending range ( thickness - mm )					
Material type	SB200	SB300	SB450	SB600	SB1000
Mild Steel	0,5 - 2,3	1,0 - 3,2	1,2 - 4,5	1,2 - 6,0	2,3 - 10,0
Stainless Steel	0,5 - 2,0	1,0 - 3,0	1,2 - 4,0	1,2 - 5,0	2,0 - 6,0
Aluminium	0,5 - 2,0	1,0 - 3,0	2,3 - 4,5	2,5 - 6,0	2,5 - 10,0

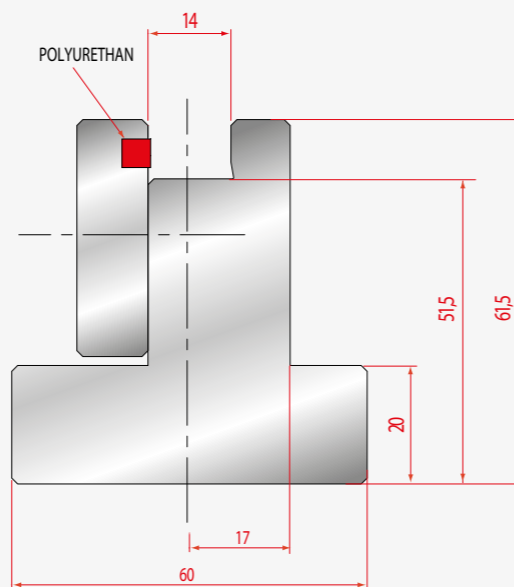
## ACTIVE BEND DIE HOLDERS



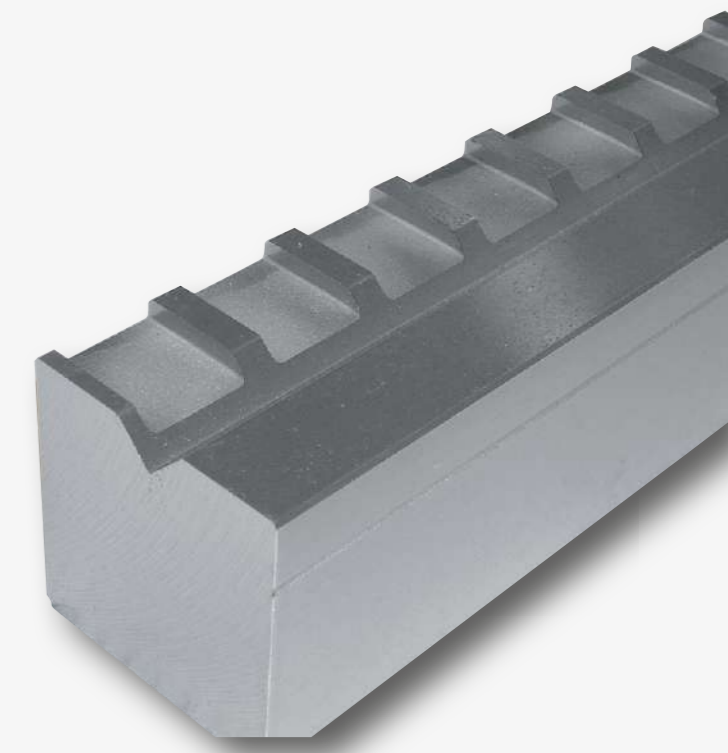
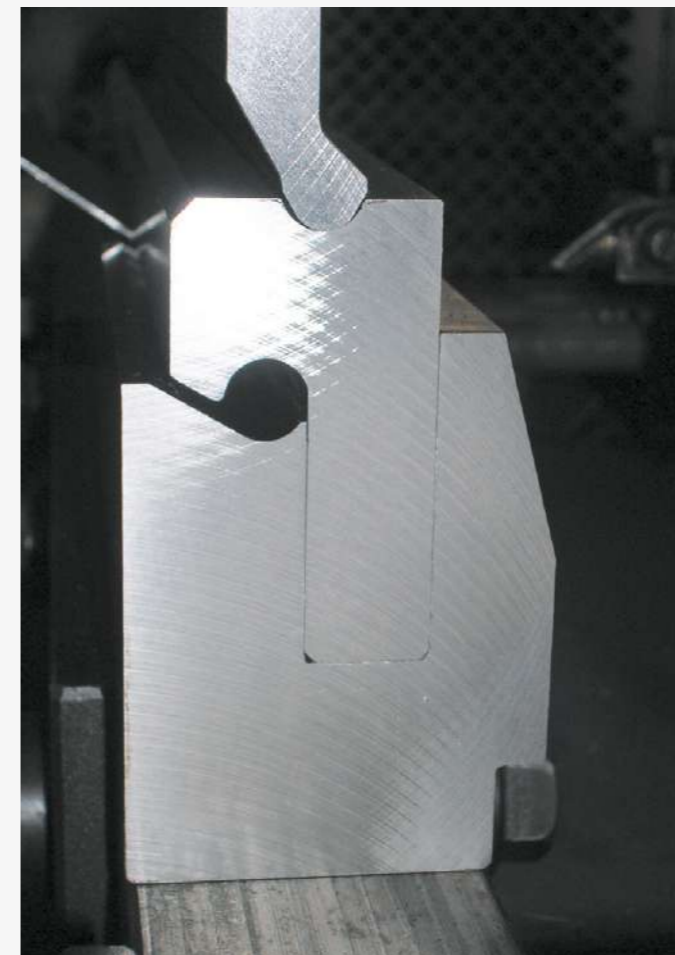
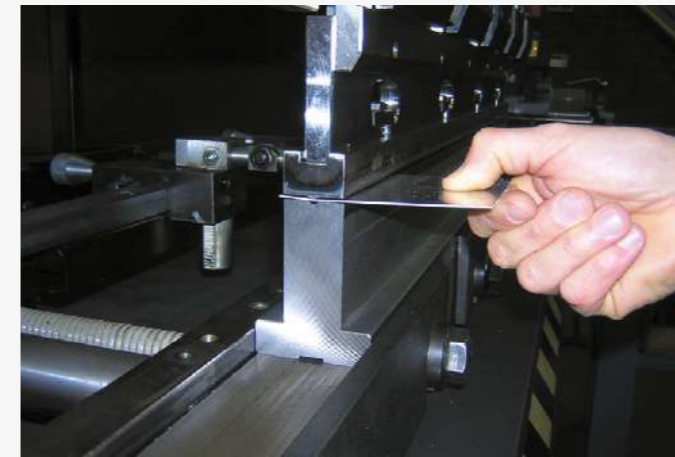
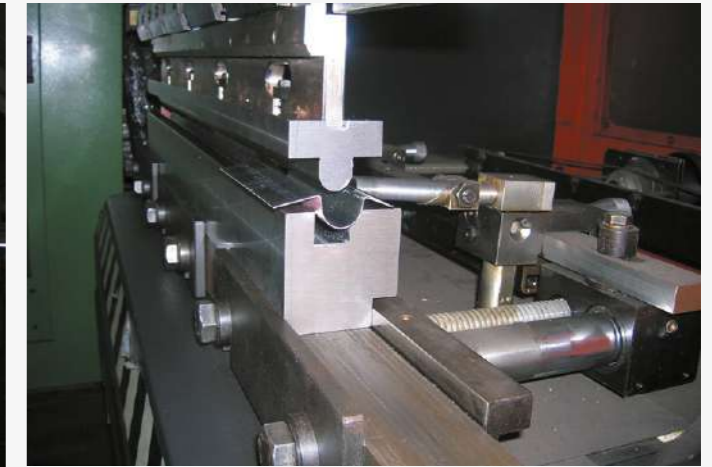
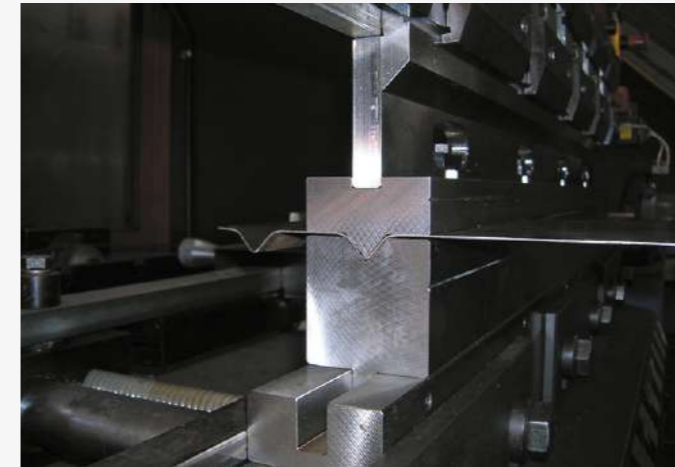
4301

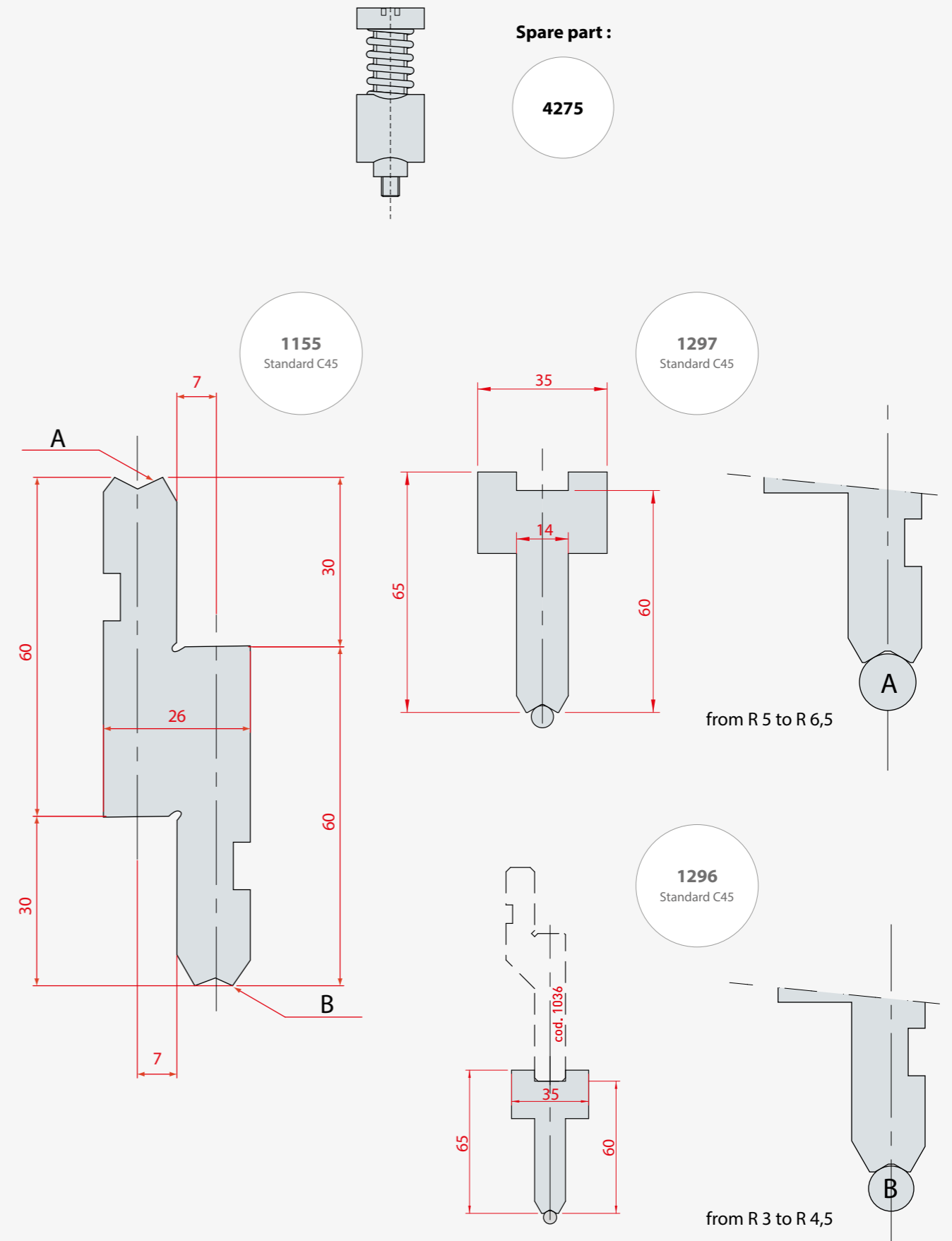
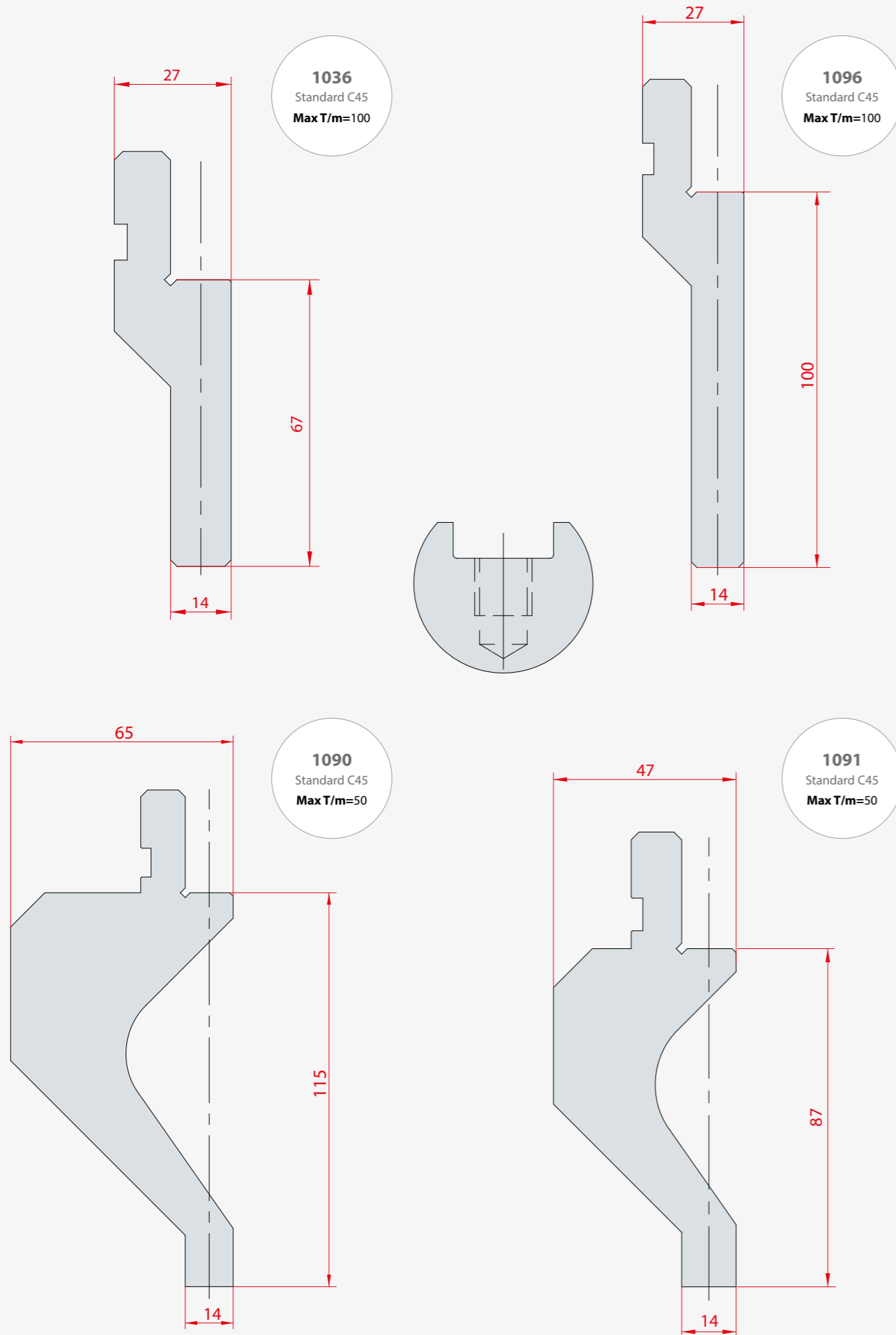


4310

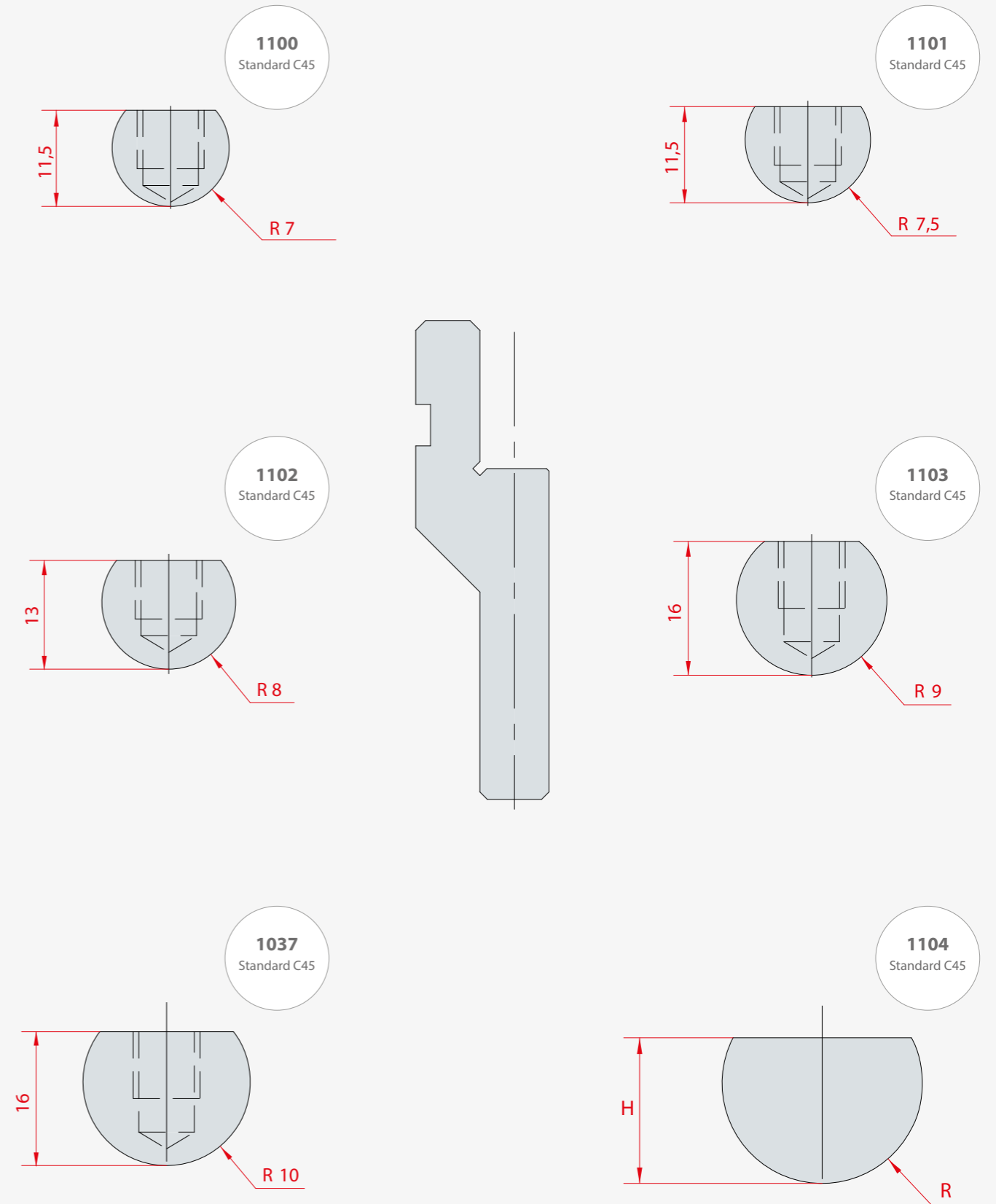
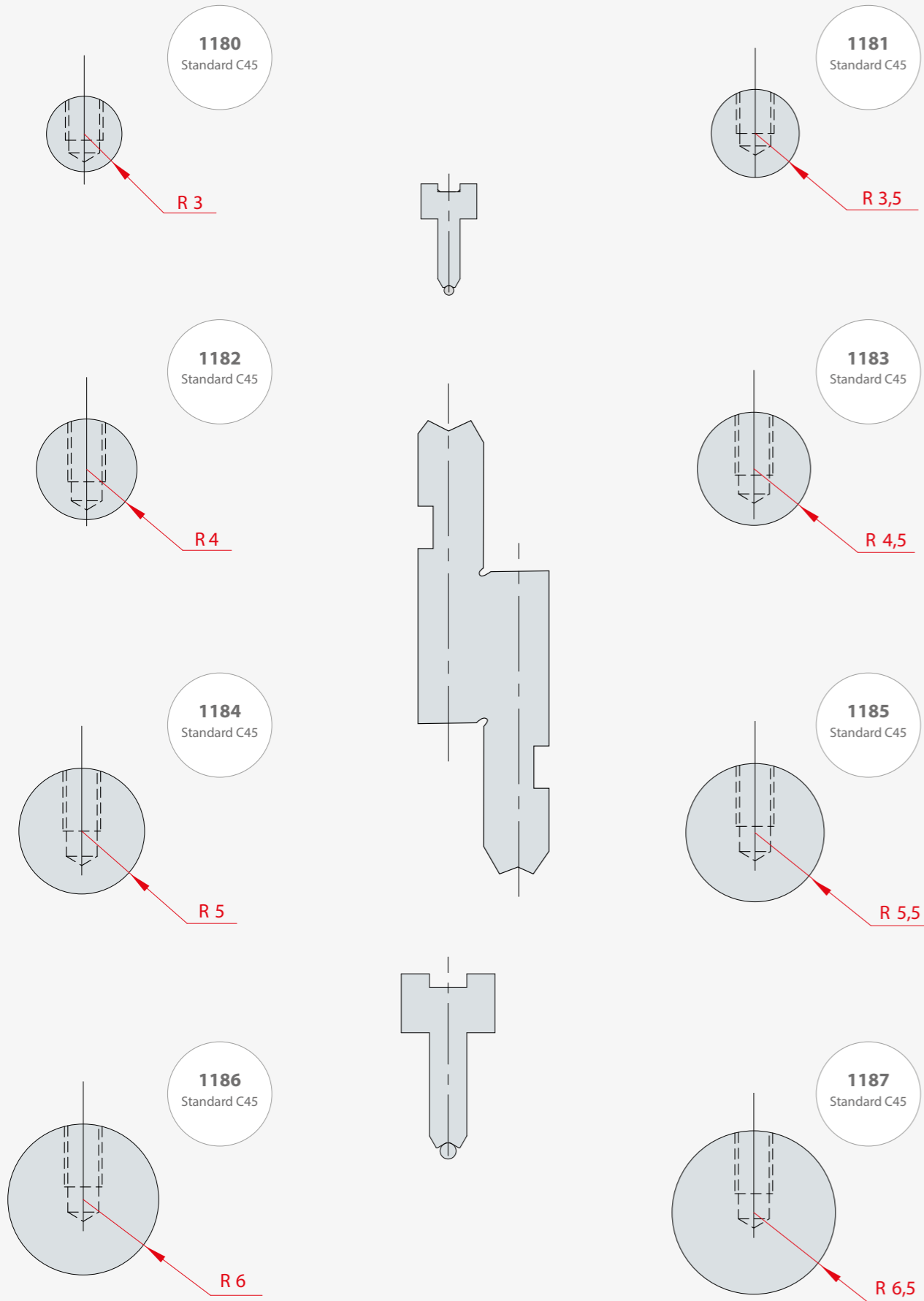


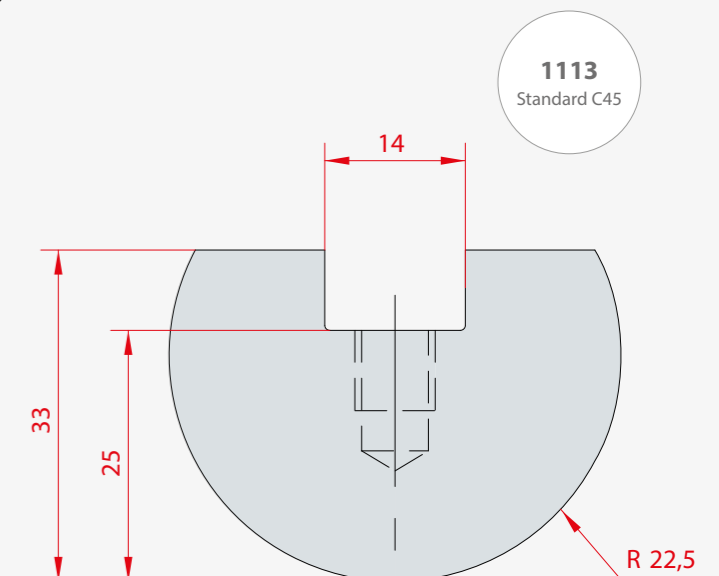
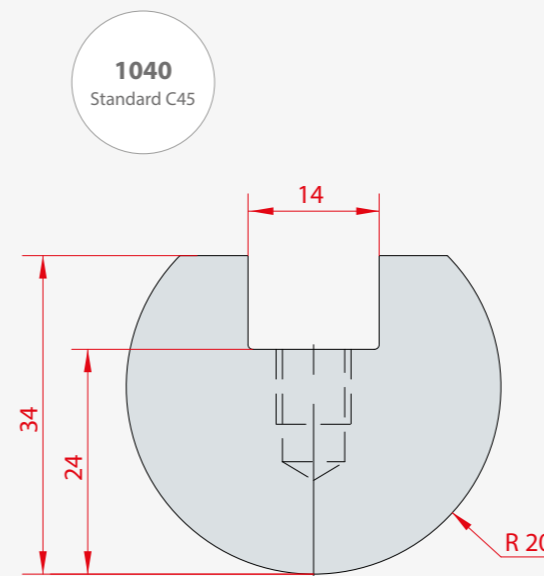
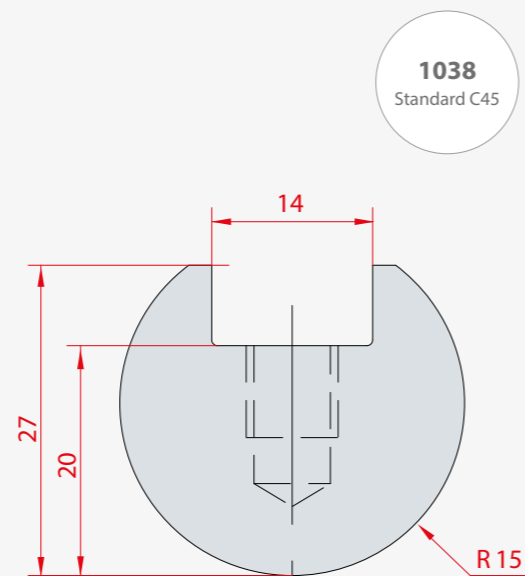
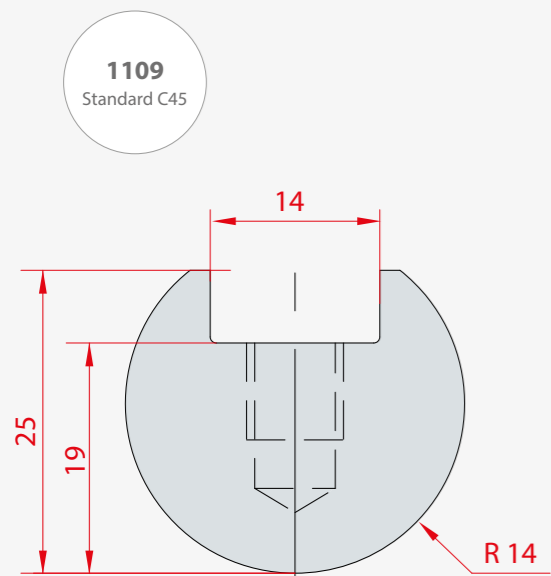
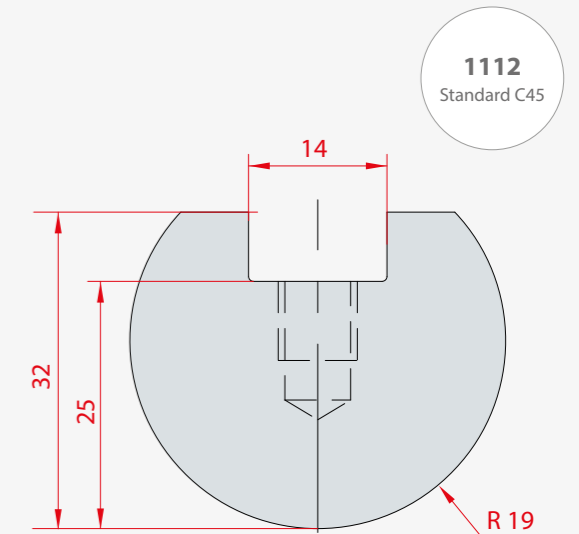
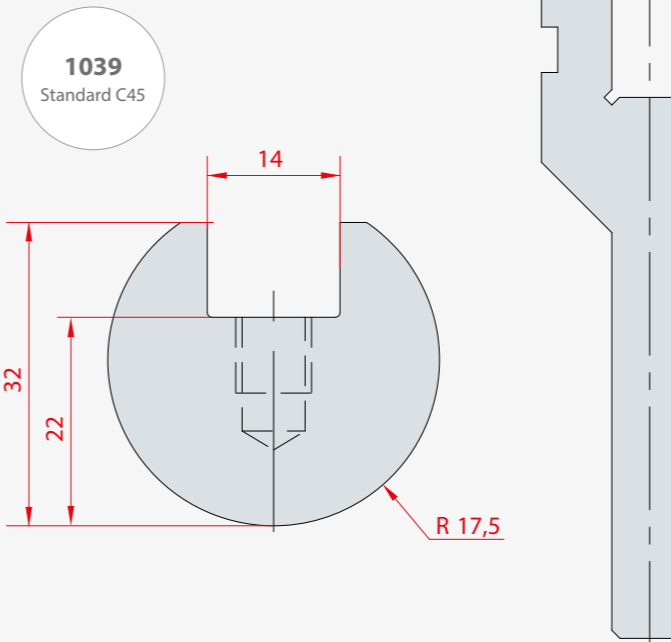
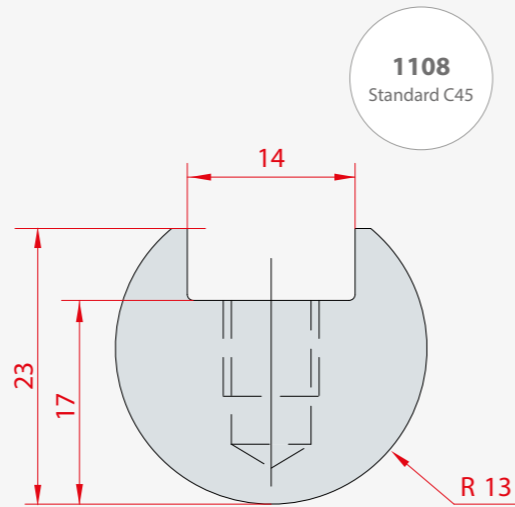
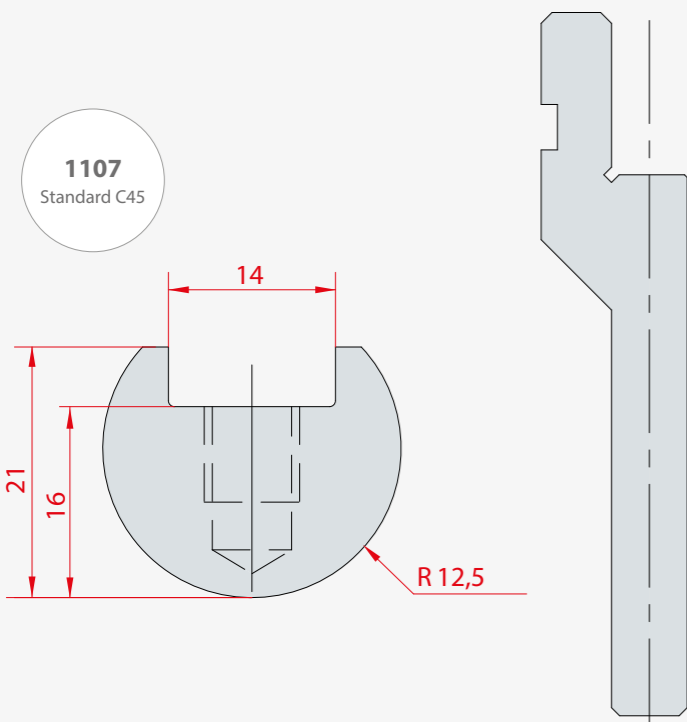
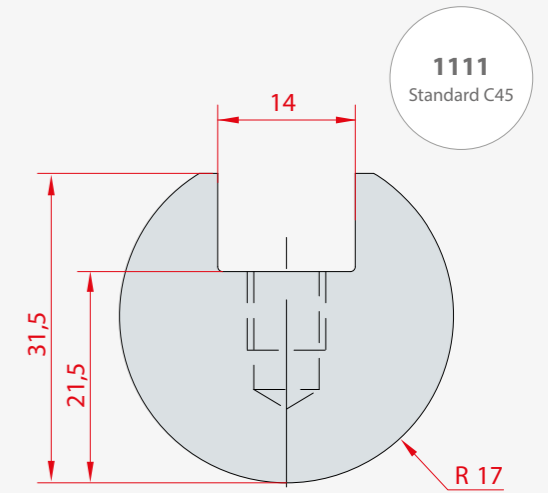
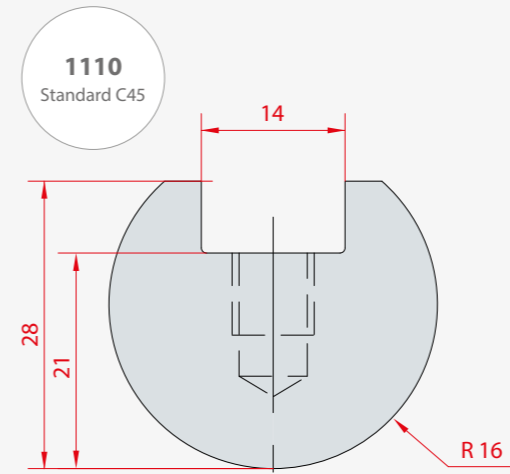
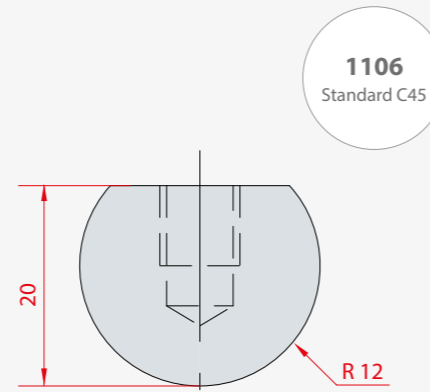
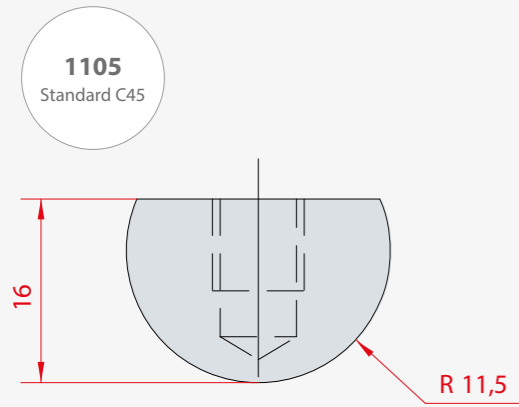
3173

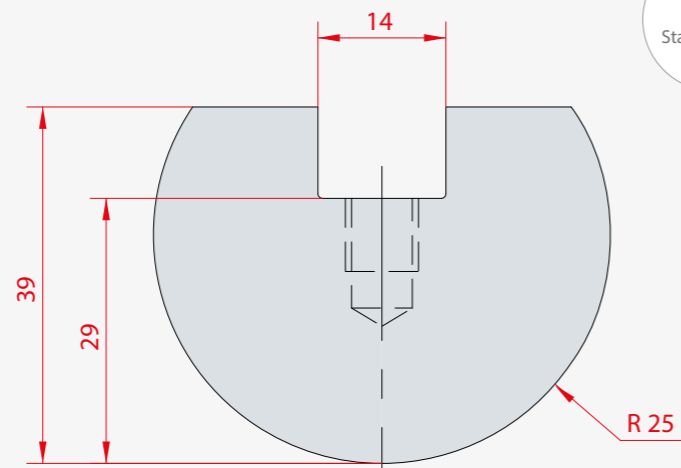




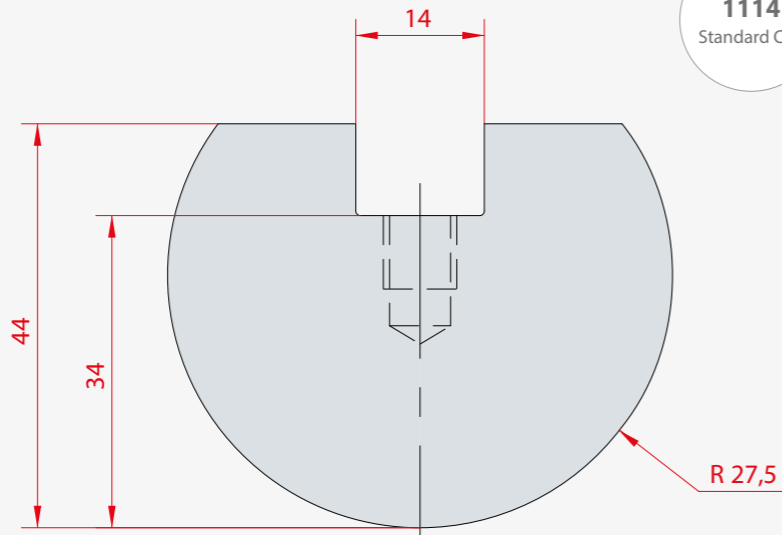
ONLY FOR HOLDERS 1155 - 1296 - 1297



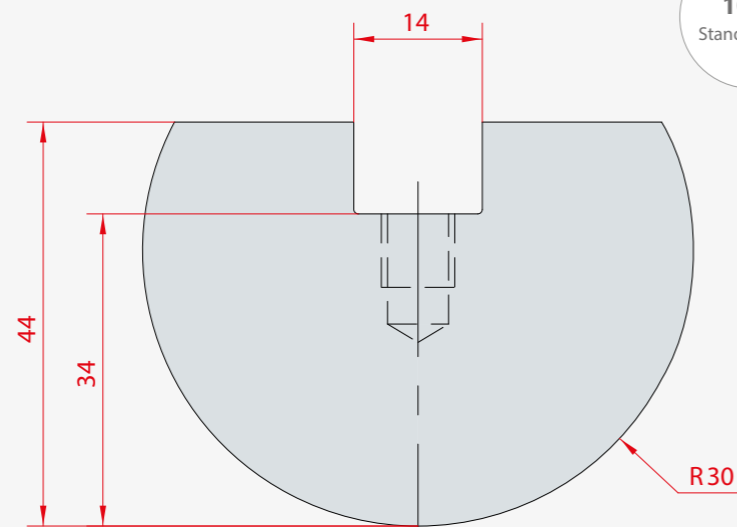




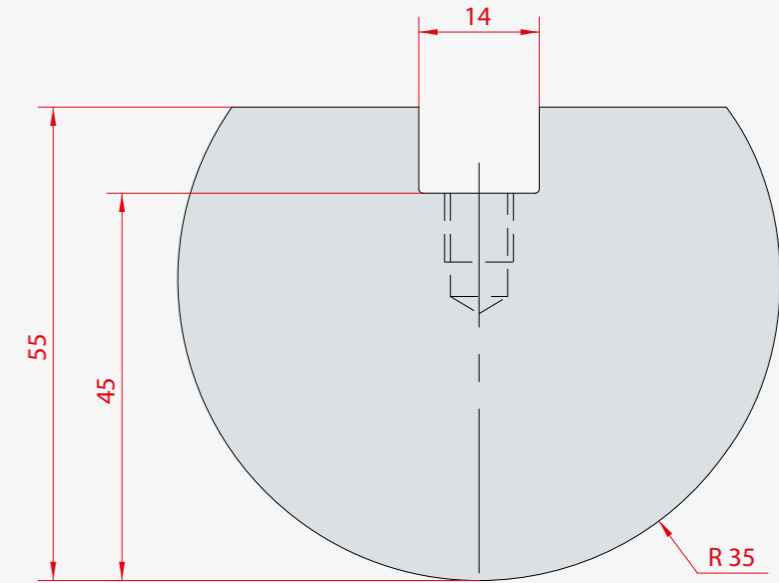
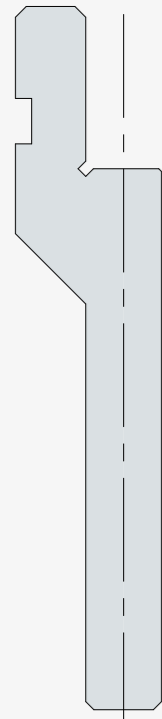
1041  
Standard C45



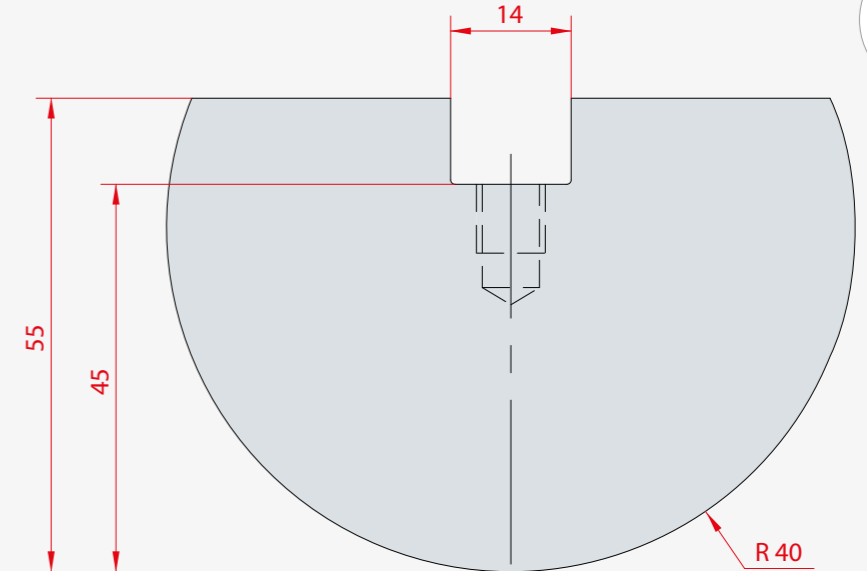
1114  
Standard C45



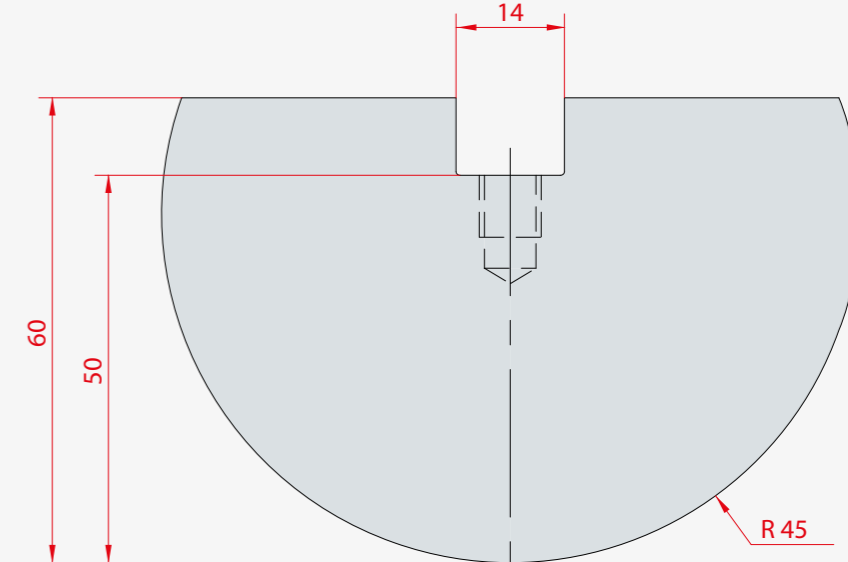
1042  
Standard C45



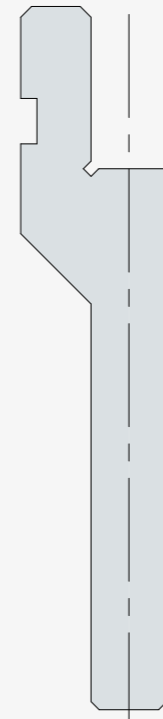
1115  
Standard C45



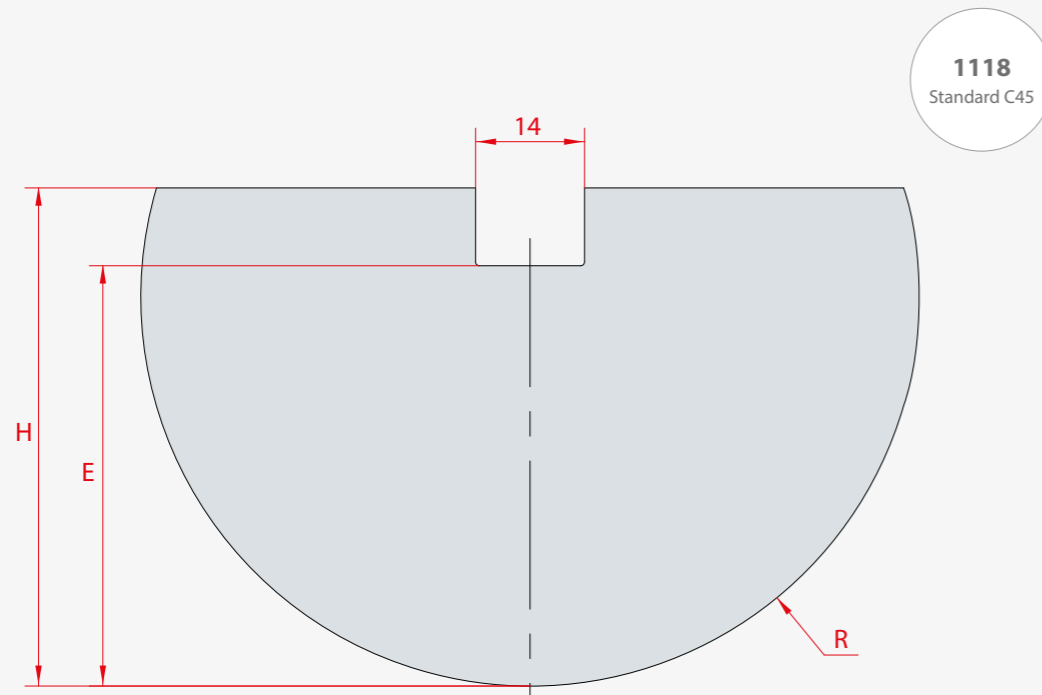
1116  
Standard C45



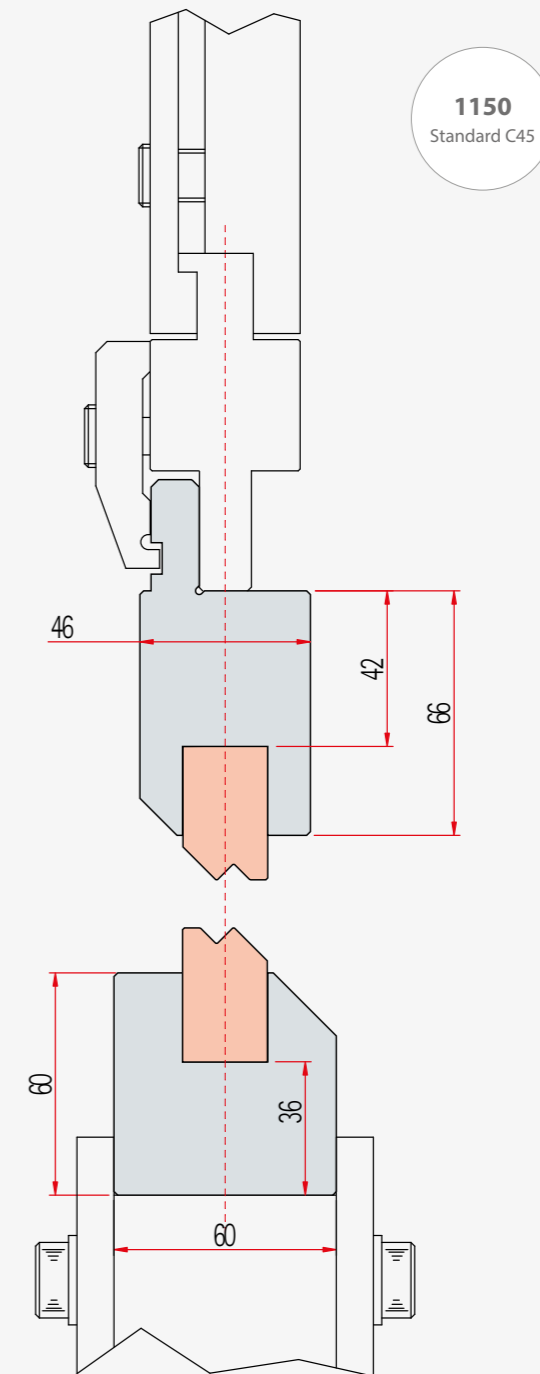
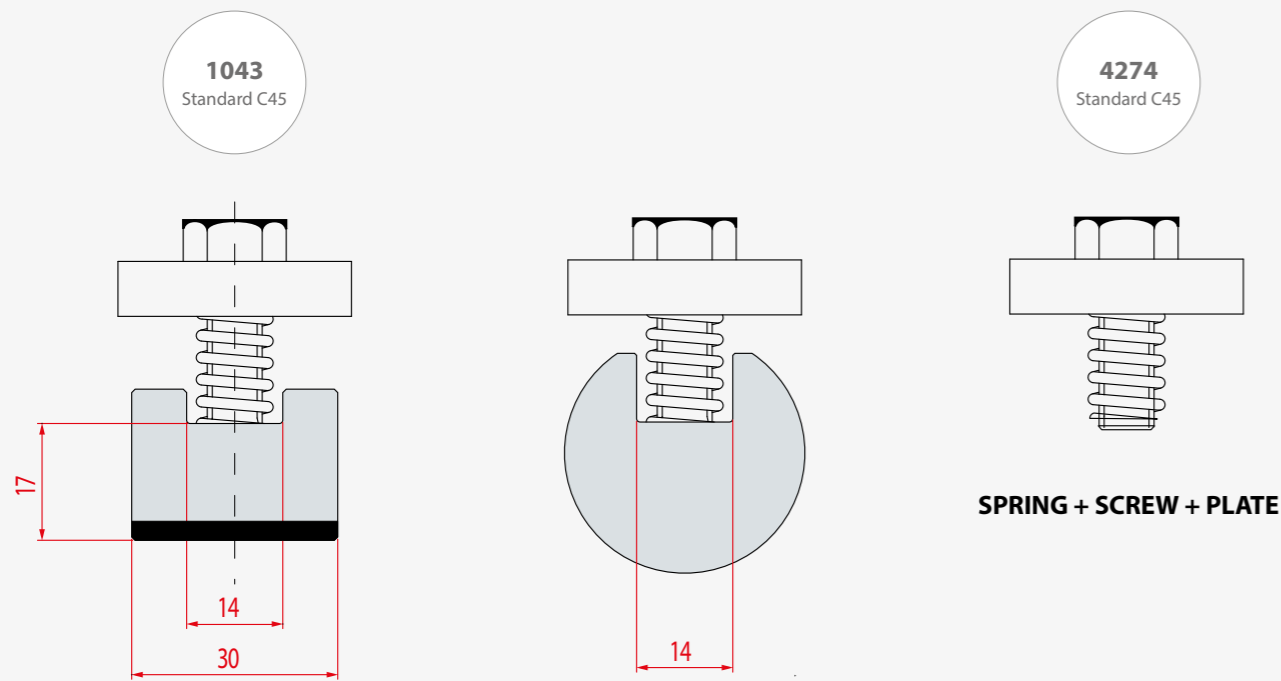
1117  
Standard C45





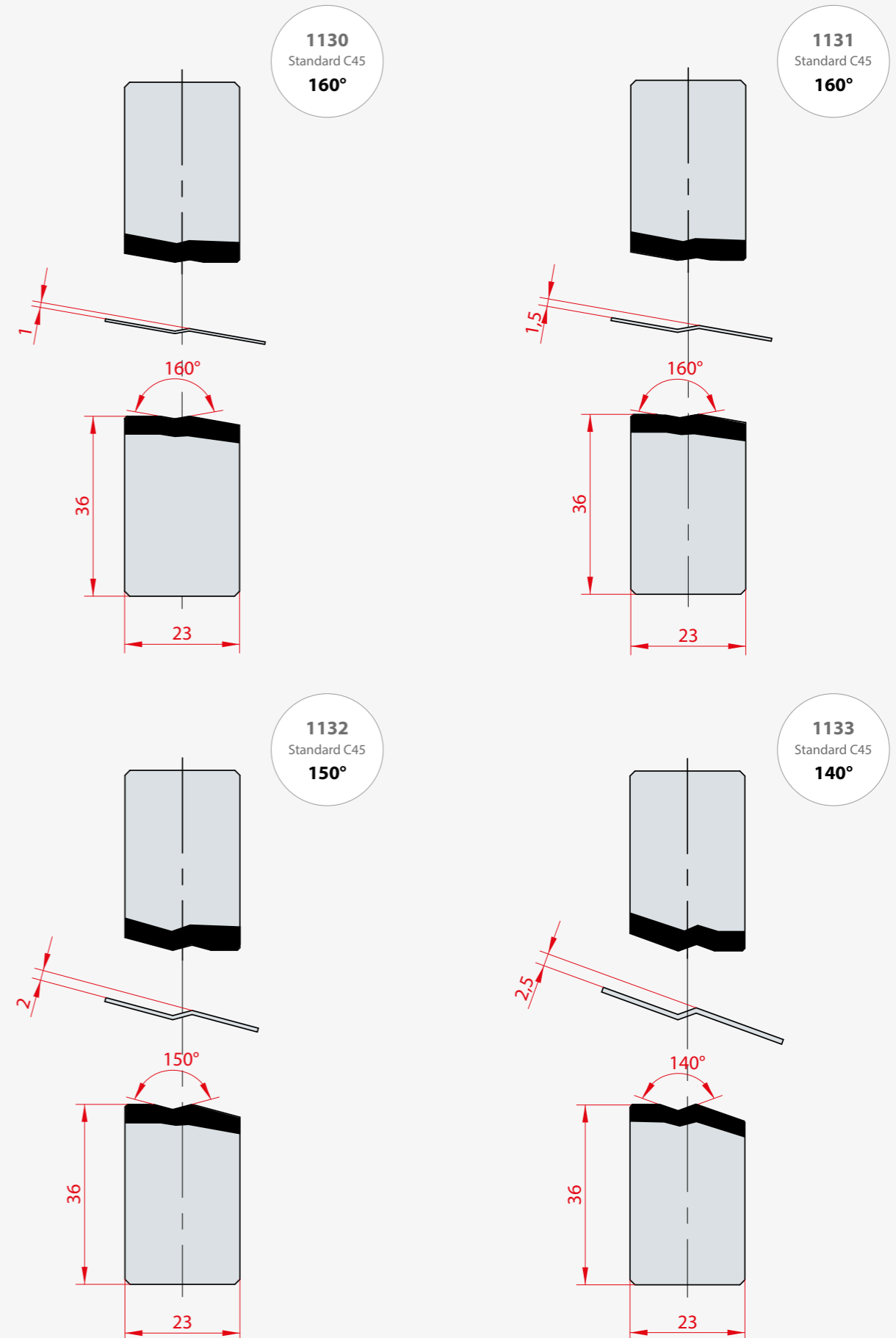


FLATTENING INSERT AND ACCESSORIES

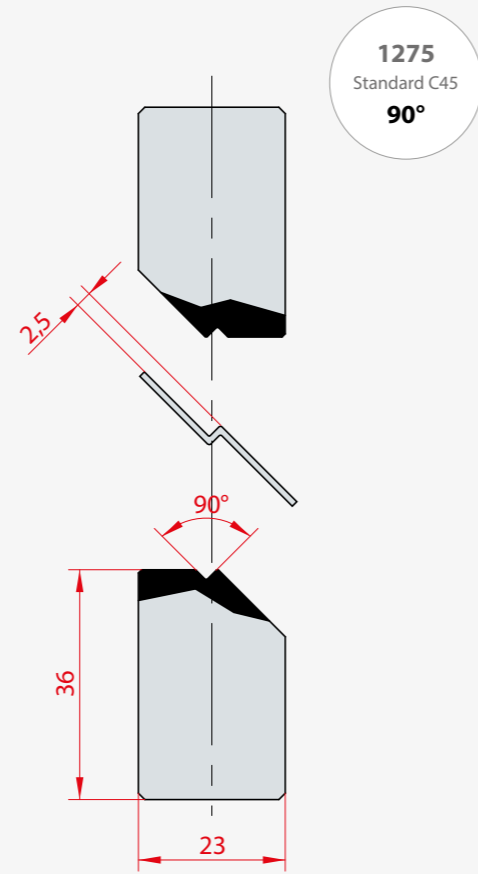
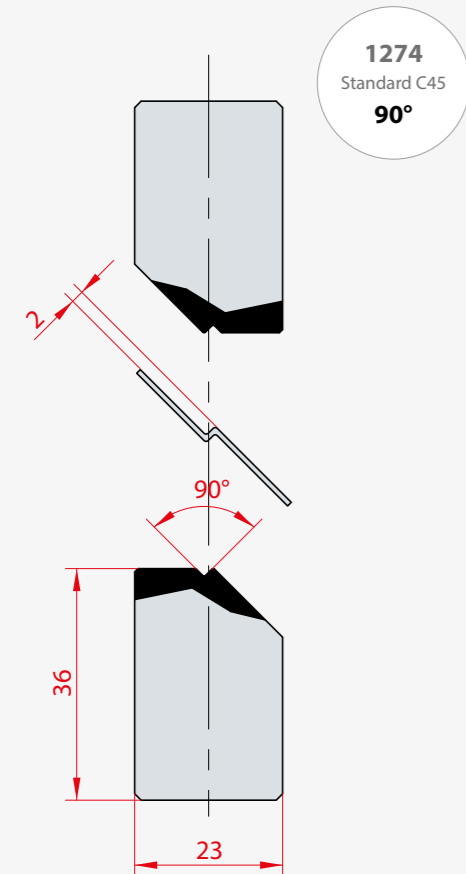
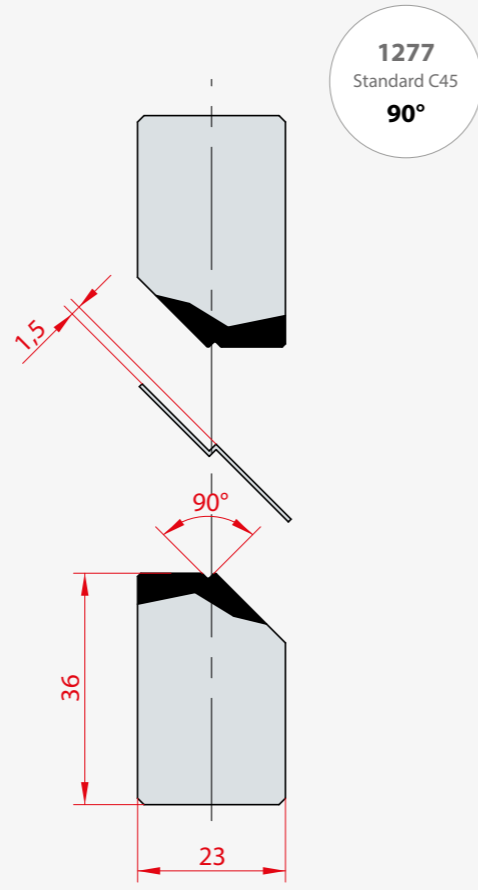
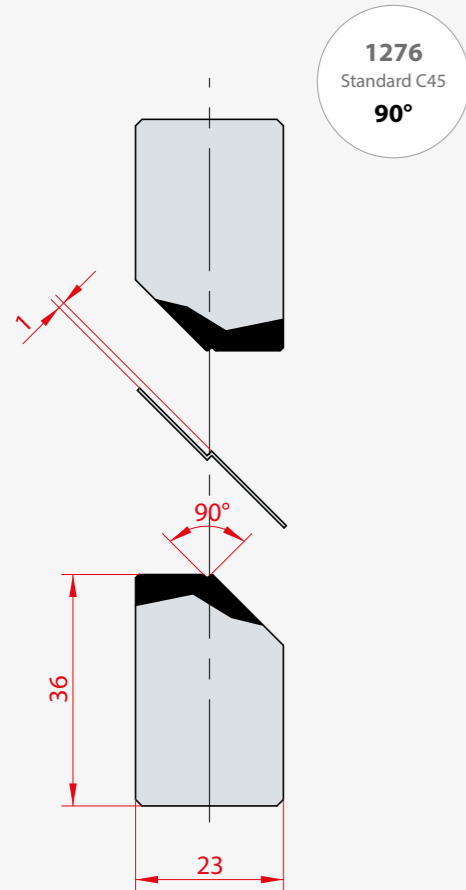


CODE	Z	DEGREES	MAX SHEET THICKNESS
1130	1	160°	0,5 mm
1276	1	90°	0,5 mm
1131	1,5	160°	0,6 mm
1277	1,5	90°	0,6 mm
1132	2	150°	0,8 mm
1274	2	90°	0,8 mm
1133	2,5	140°	1,0 mm
1275	2,5	90°	1,0 mm
1134	3	90°	1,0 mm
1135	3,5	90°	1,2 mm
1136	4	90°	1,2 mm
1137	4,5	90°	1,5 mm
1138	5	90°	1,5 mm
1139	5,5	90°	1,5 mm
1140	6	90°	1,5 mm
1141	6,5	90°	1,5 mm
1142	7	90°	2,0 mm
1143	7,5	90°	2,0 mm
1144	8	90°	2,5 mm
1145	9	90°	2,5 mm
1146	10	90°	3,0 mm
1147	11	90°	3,0 mm
1148	12	90°	3,0 mm
1278	13	90°	3,0 mm
1279	14	90°	3,0 mm
1280	15	90°	3,0 mm

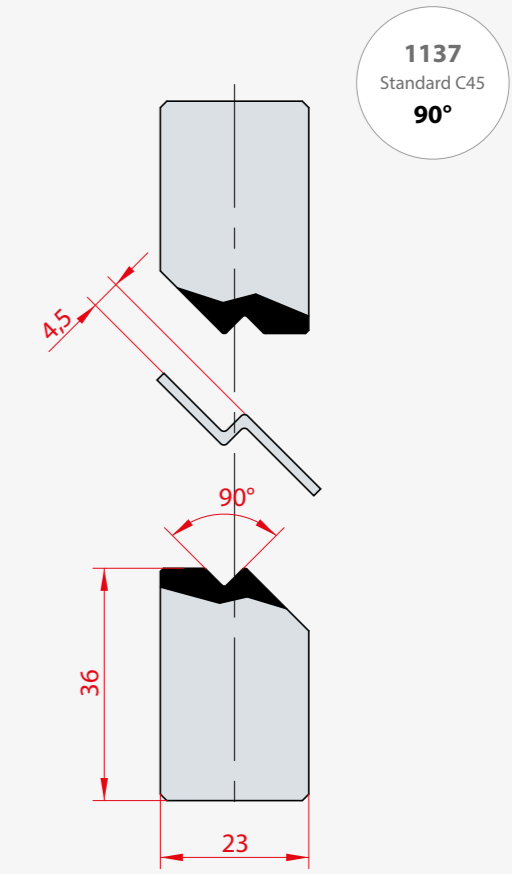
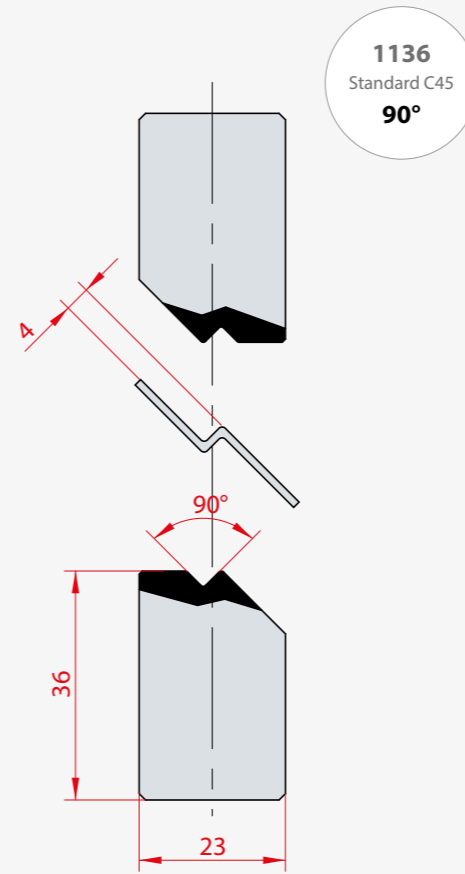
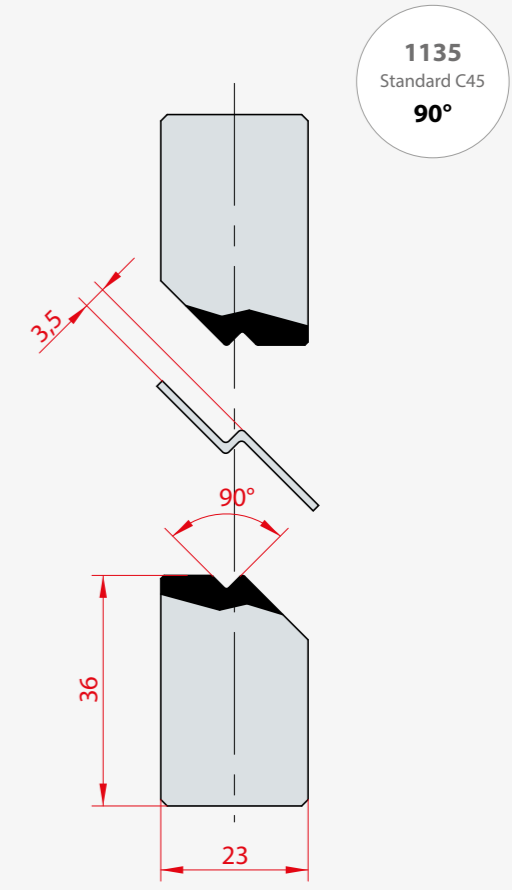
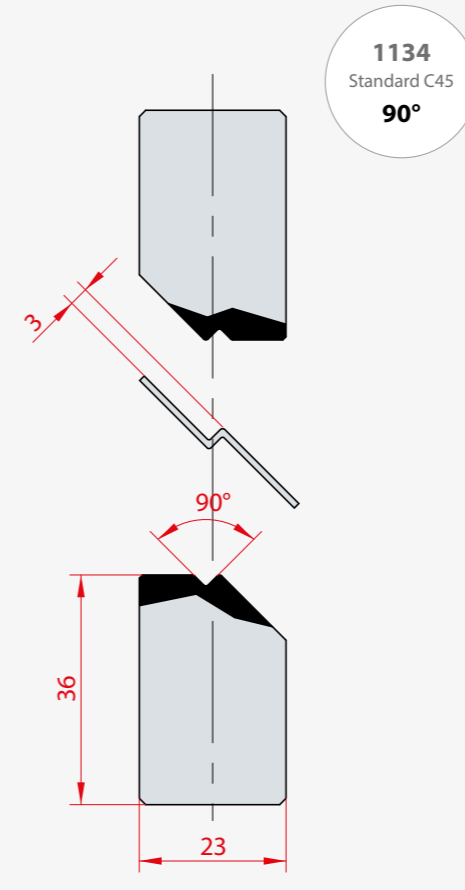
To choose the right joggle tool based on the sheet thickness, please see the chart on page 96



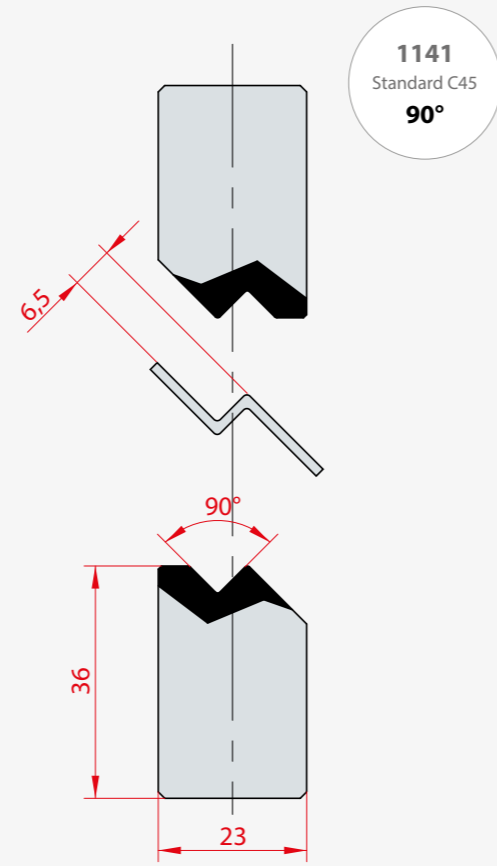
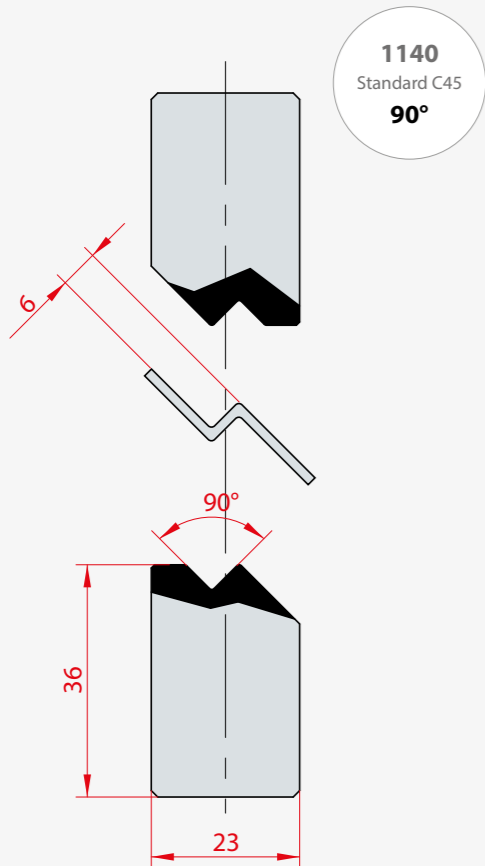
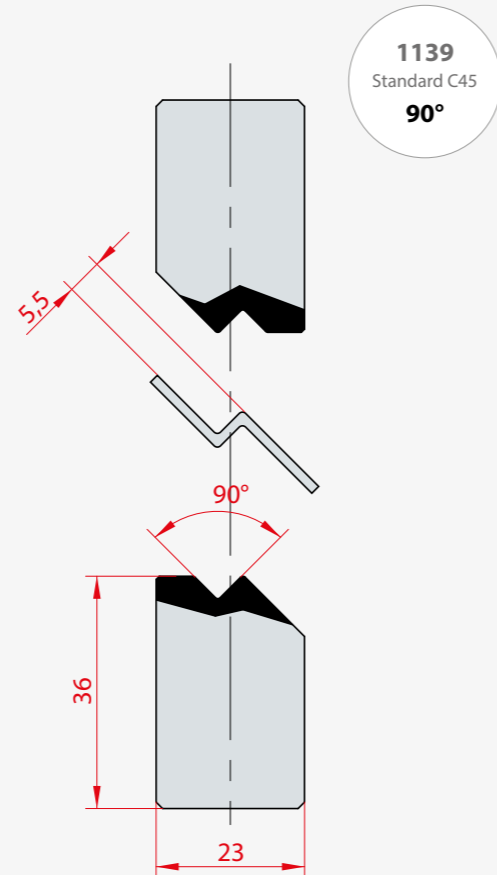
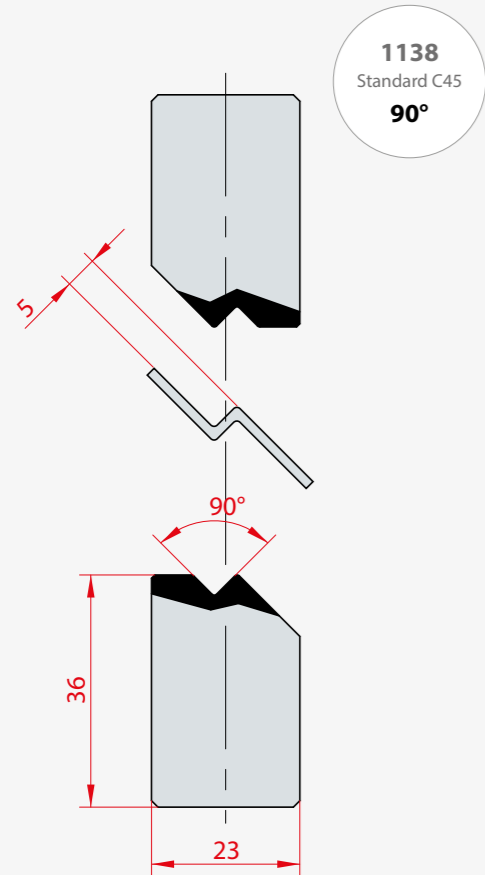
To choose the right joggle tool based on the sheet thickness, please see the chart on page 96



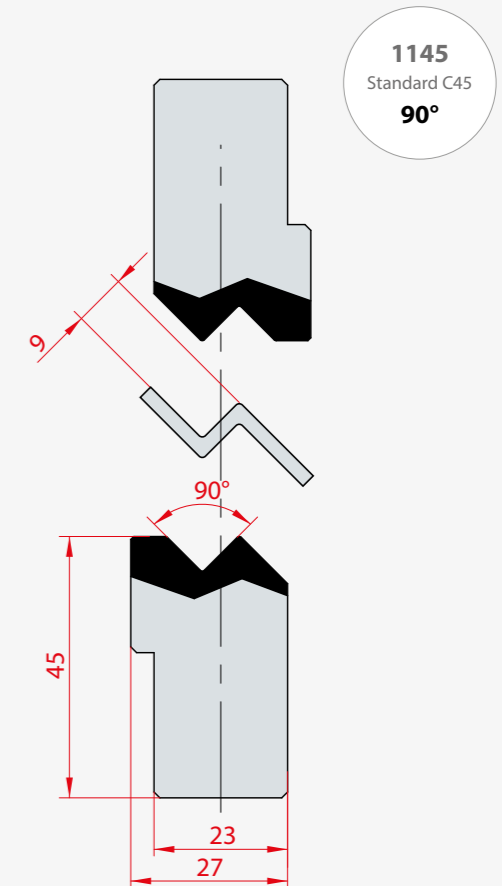
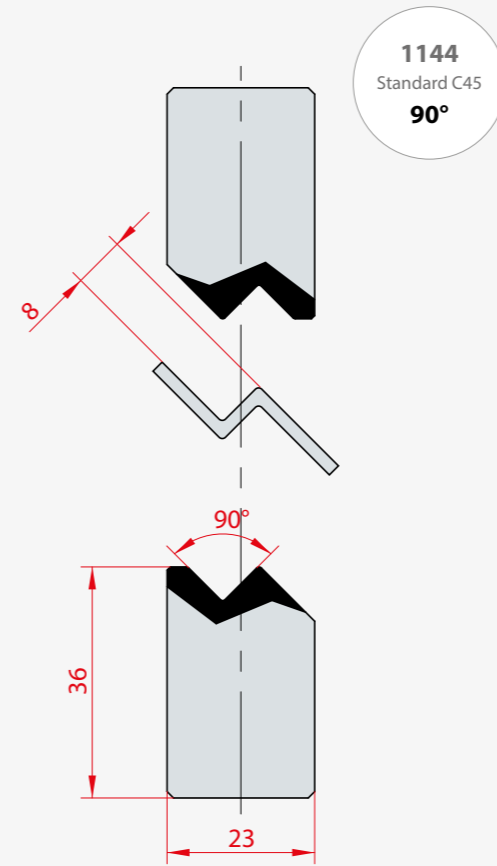
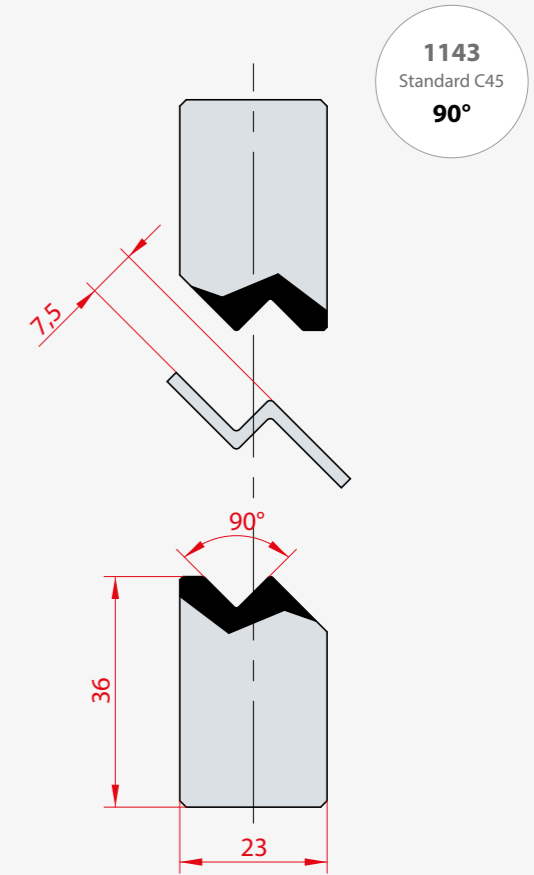
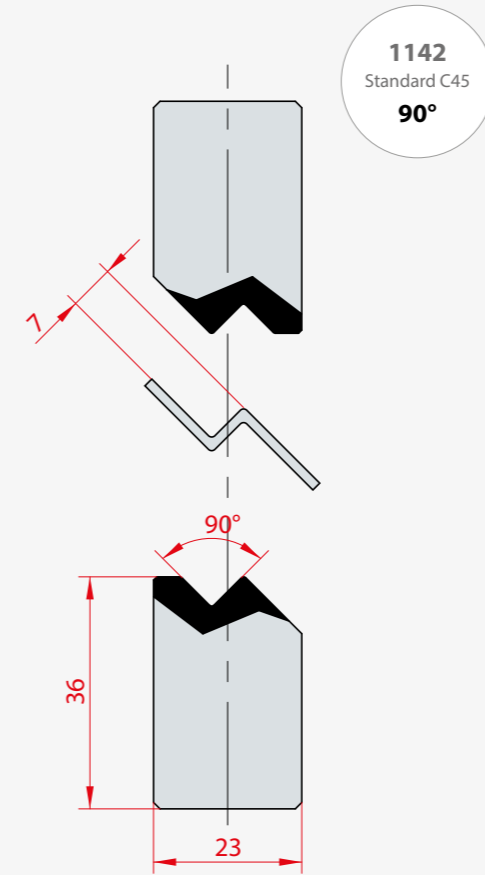
To choose the right joggle tool based on the sheet thickness, please see the chart on page 96



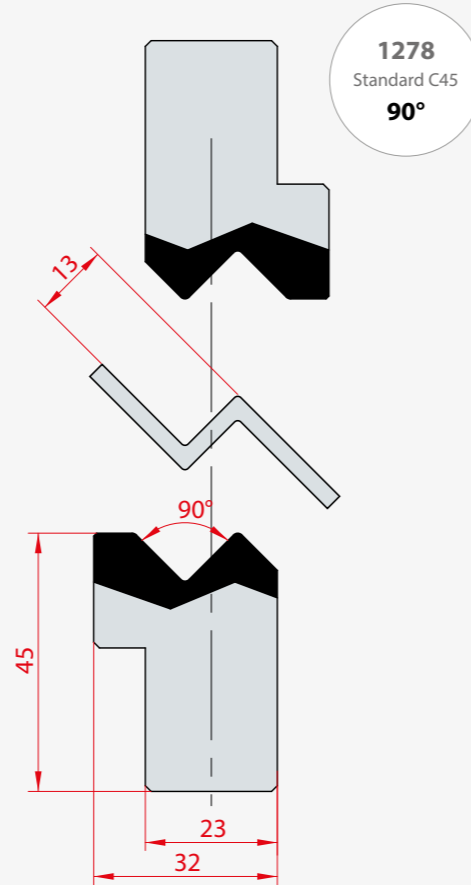
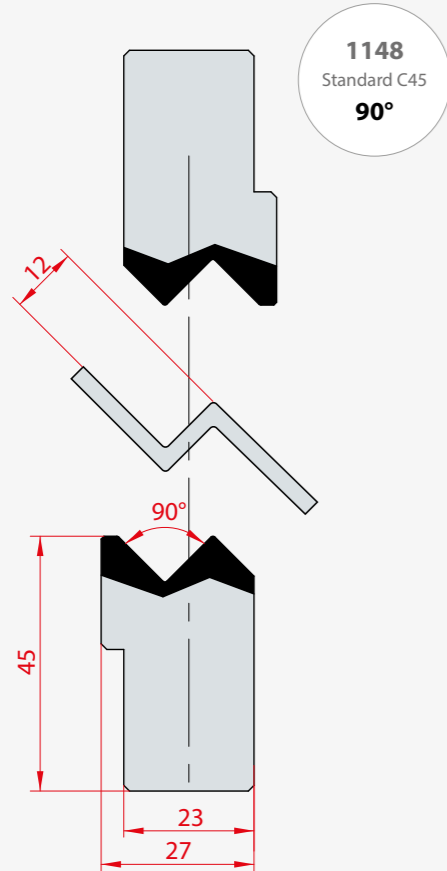
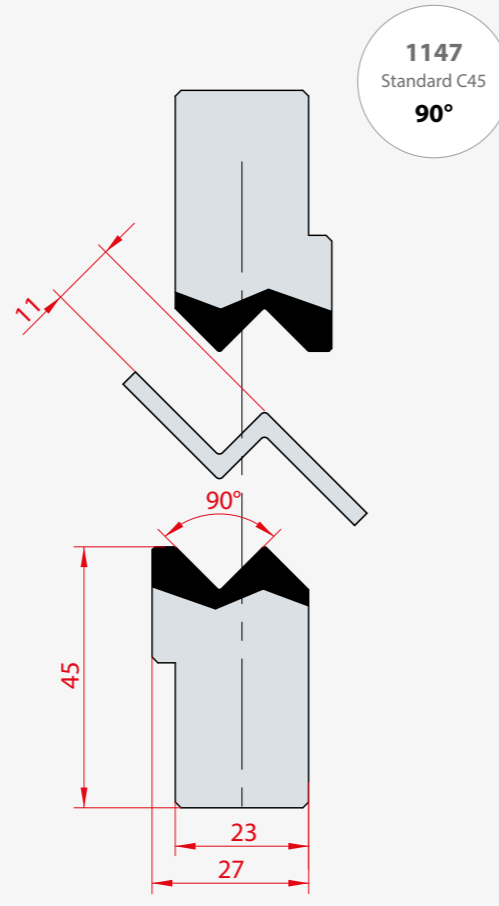
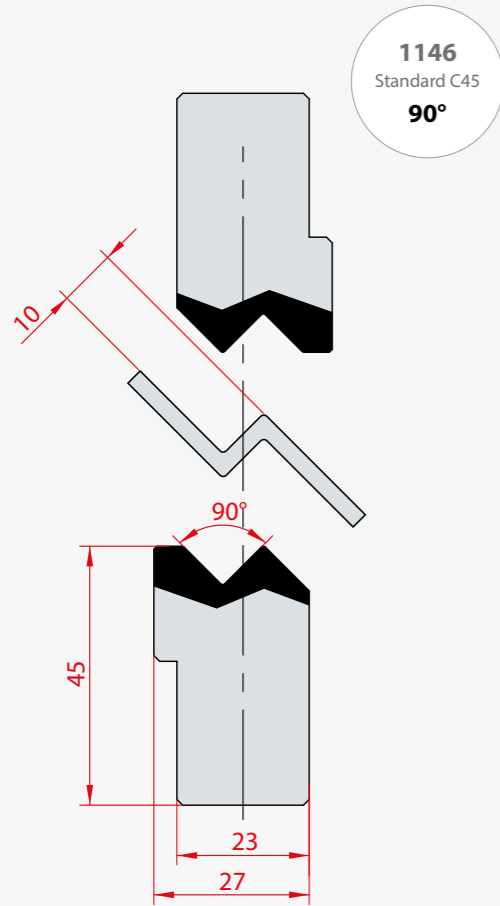
To choose the right joggle tool based on the sheet thickness, please see the chart on page 96



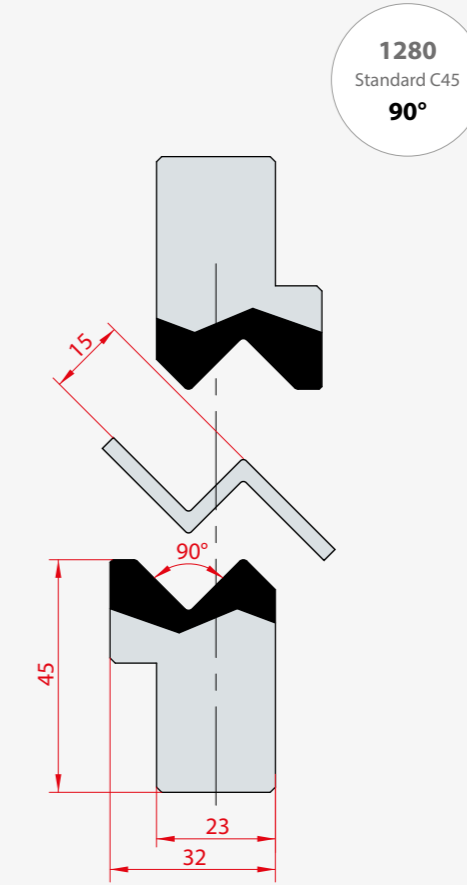
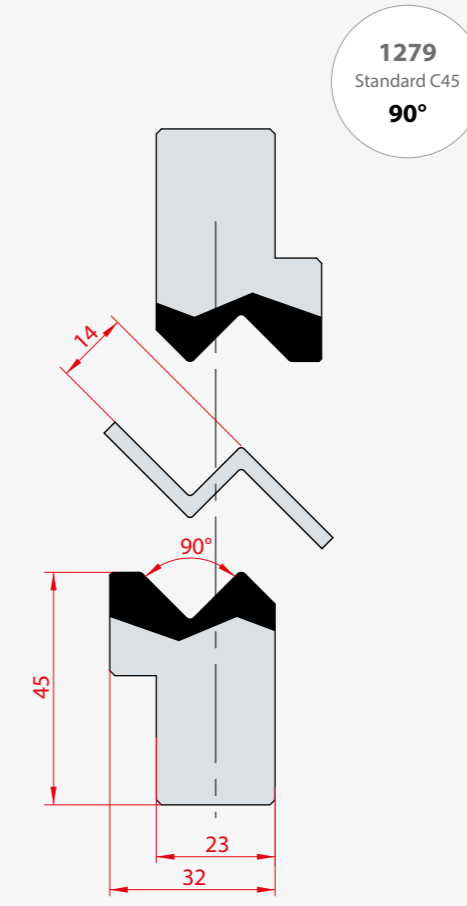
To choose the right joggle tool based on the sheet thickness, please see the chart on page 96



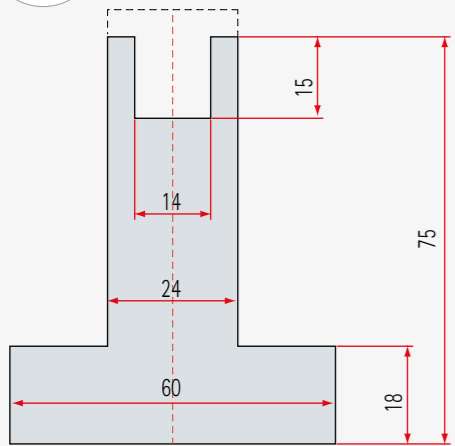
To choose the right joggle tool based on the sheet thickness, please see the chart on page 96



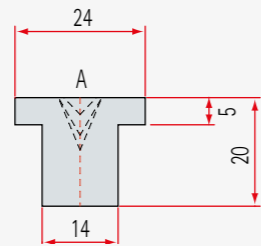
To choose the right joggle tool based on the sheet thickness, please see the chart on page 96



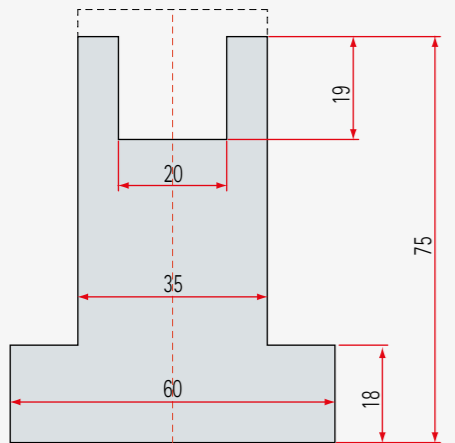
2109



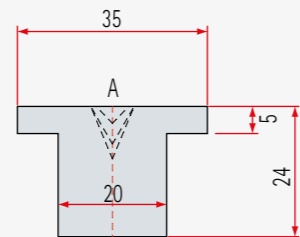
2112			
A	V		
88°	6	8	10
60°	6	8	10
45°	6	8	10
30°	6	8	



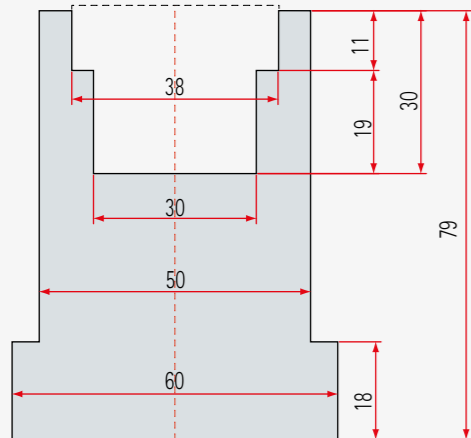
2110



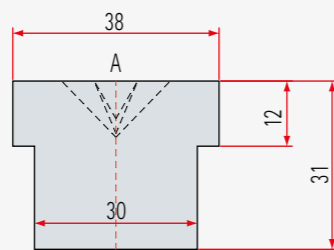
2113					
A	V				
88°	6	8	10	12	16
60°	6	8	10	12	16
45°	6	8	10	12	
30°	6	8	10		



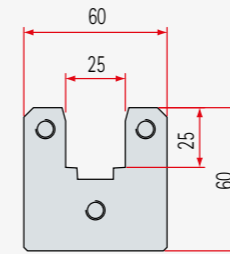
2111



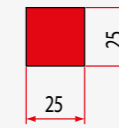
2114							
A	V						
88°	6	8	10	12	16	20	25
60°	6	8	10	12	16	20	
45°	6	8	10	12	16	20	
30°	6	8	10	12	16		



2036

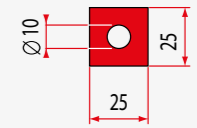


2101

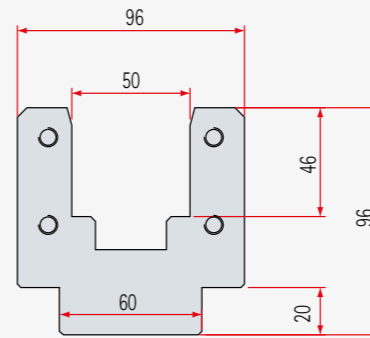


92 shore

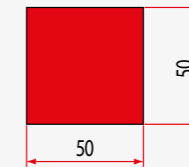
2105



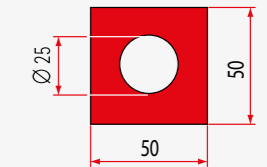
2037



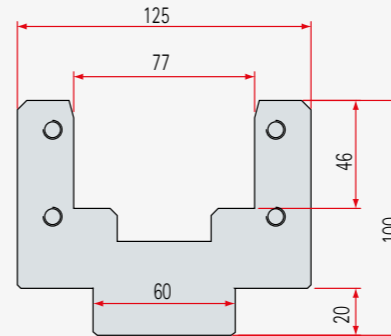
2102



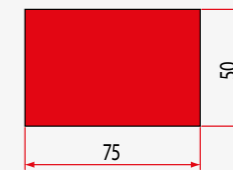
2106



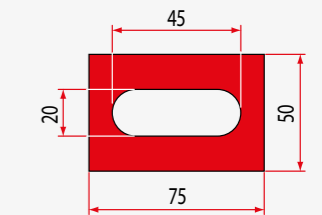
2038



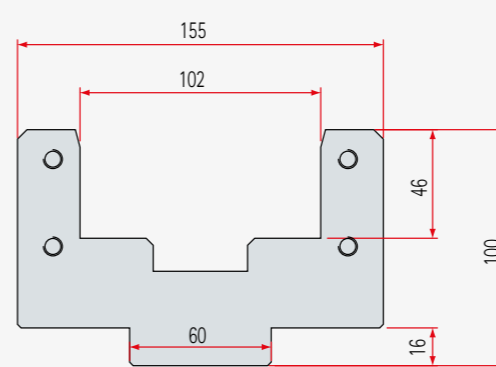
2103



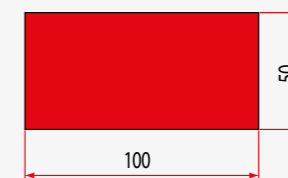
2107



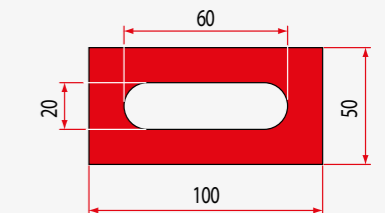
2040



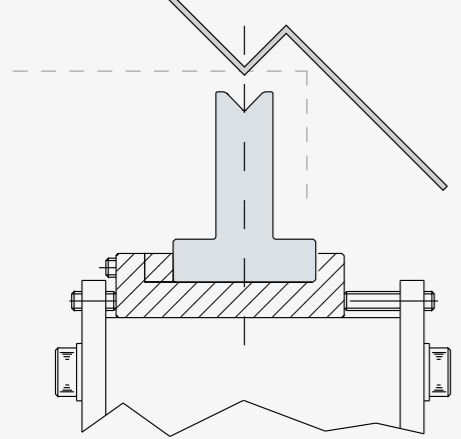
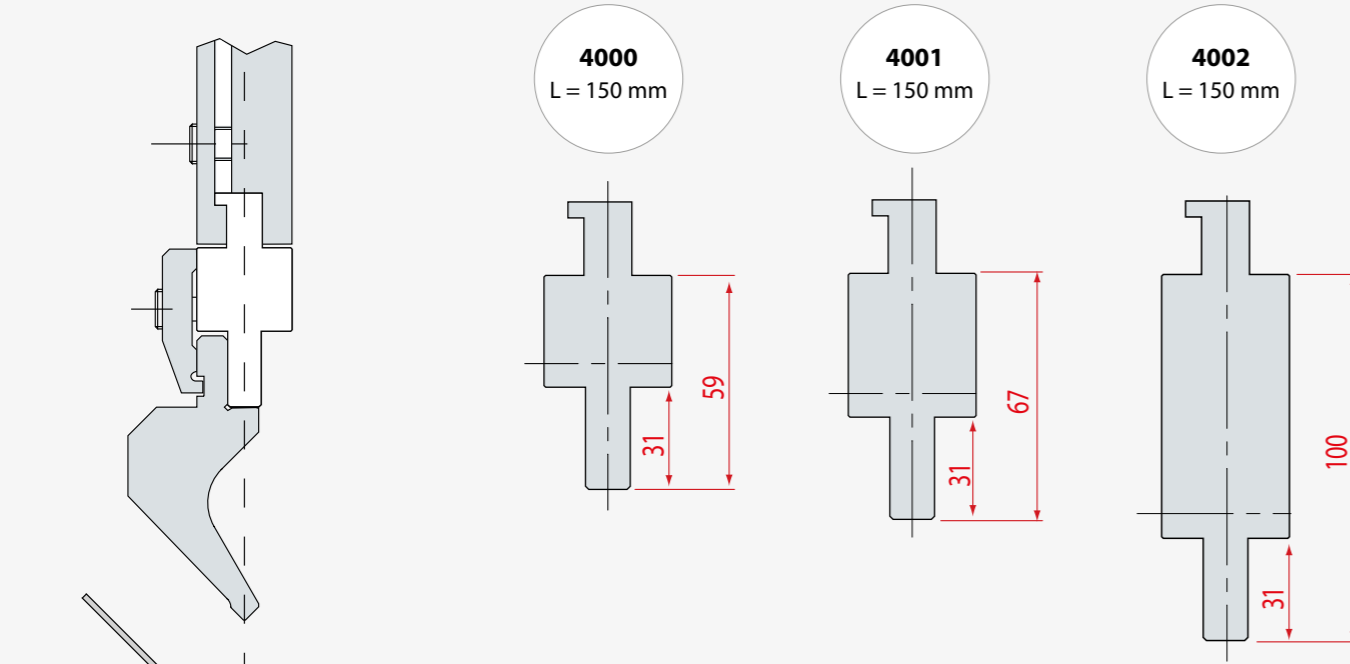
2104



2108



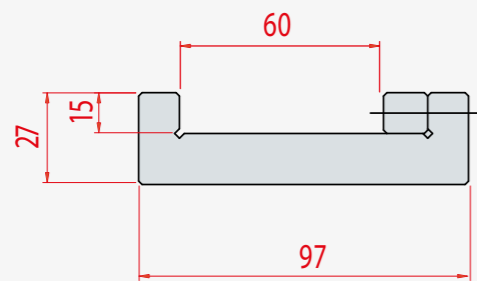
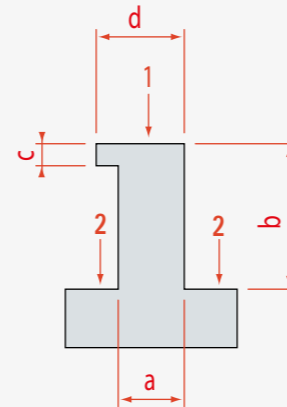
FOR ANY TYPE OF PRESS BRAKE



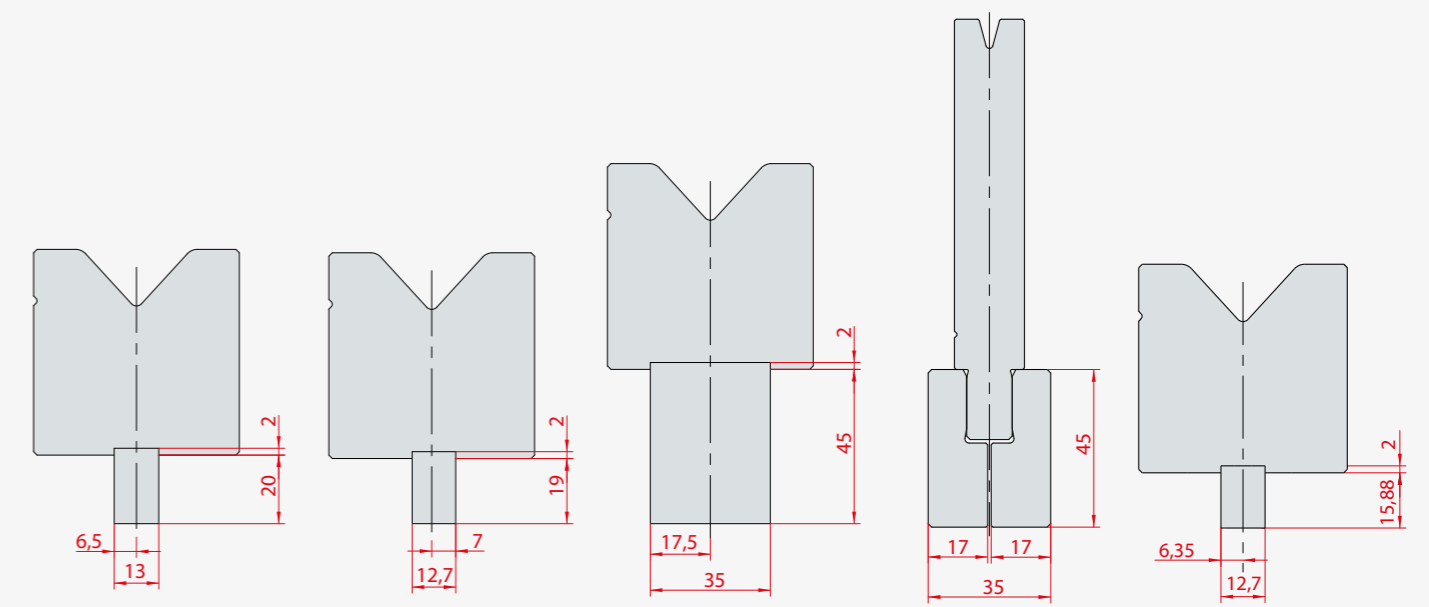
Minimum order n. 5 intermediates

Please mark contact points and pressure points.

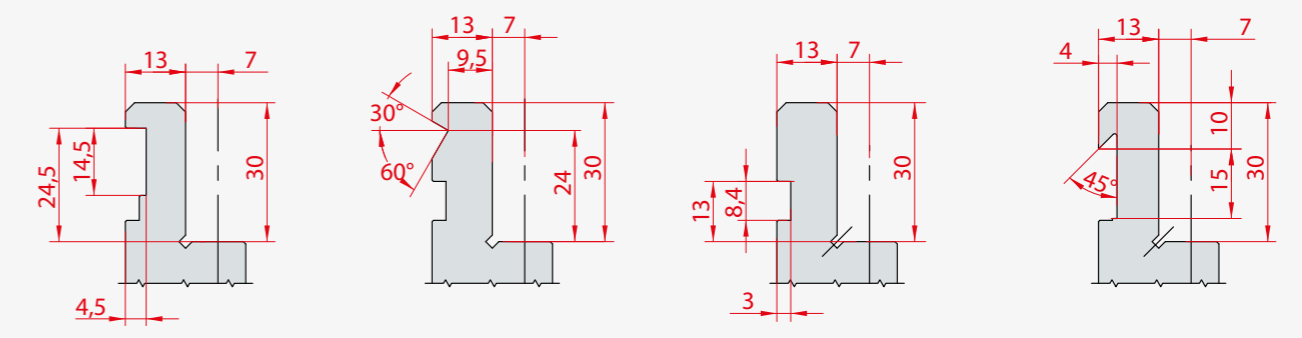
a =	1	2
b =		
c =		
d =		



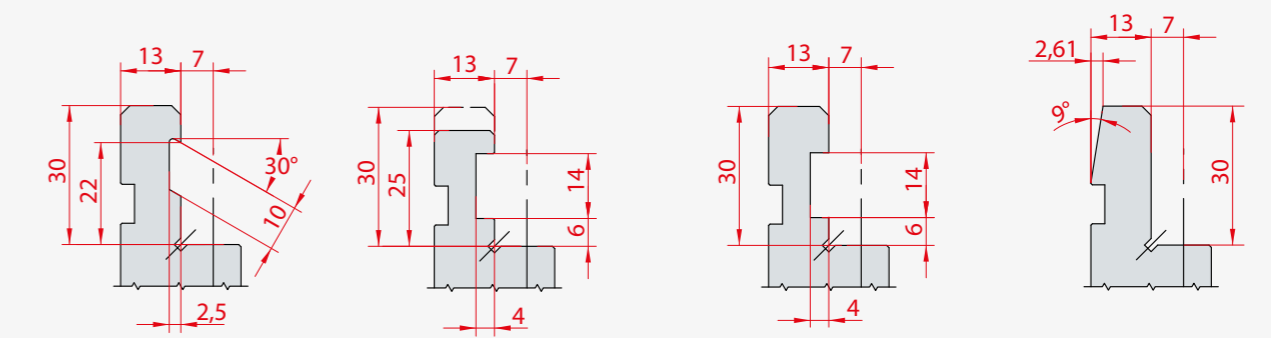
CODE	LENGTHS
9010	2100 mm
9011	2600 mm
9012	3100 mm
9013	4100 mm



BYSTRONIC-TRUMPF 8100    LVD 8101    WEINBRENNER 8102    WEINBRENNER 8105    AMERICAN 8107



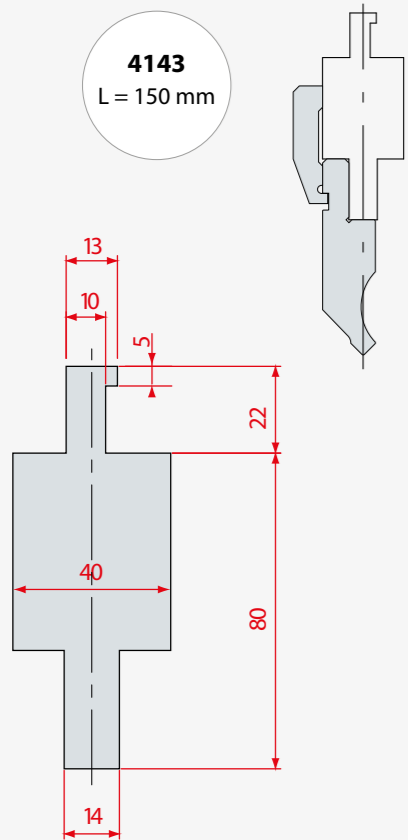
BARRETTA 8010    BMB 8011    AMADA-PROMECAM 8012    GASPARINI 8013



TEDA 8014    EURO BYSTRONIC 8016    BYSTRONIC 8017    ONE TOUCH 8020

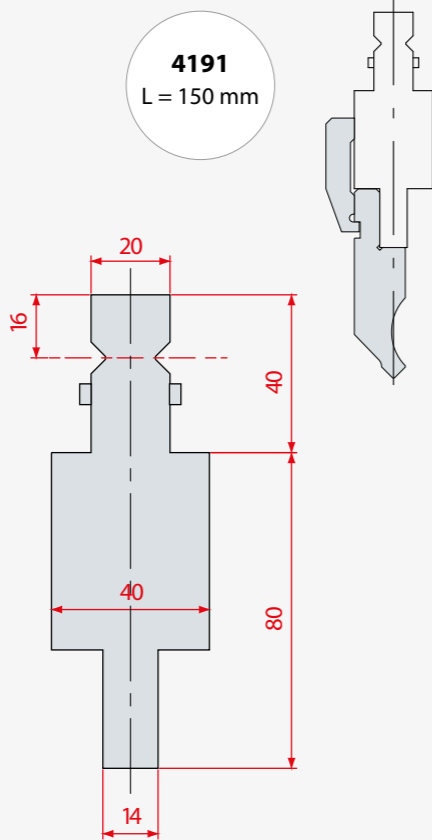
LVD

4143  
L = 150 mm



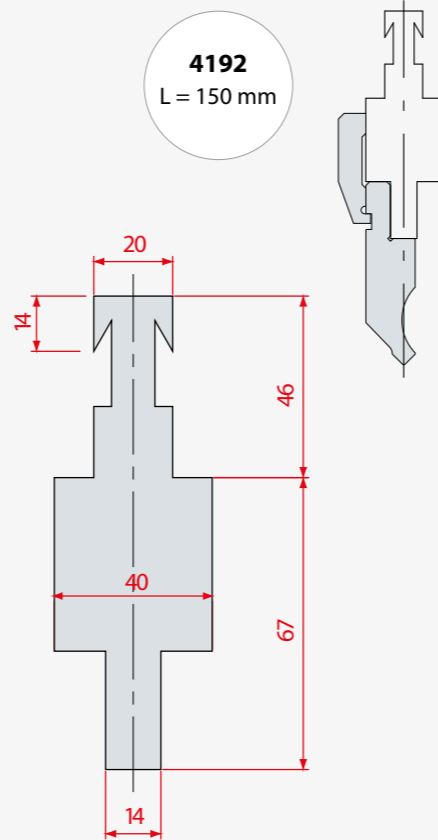
WILA/TRUMPF

4191  
L = 150 mm



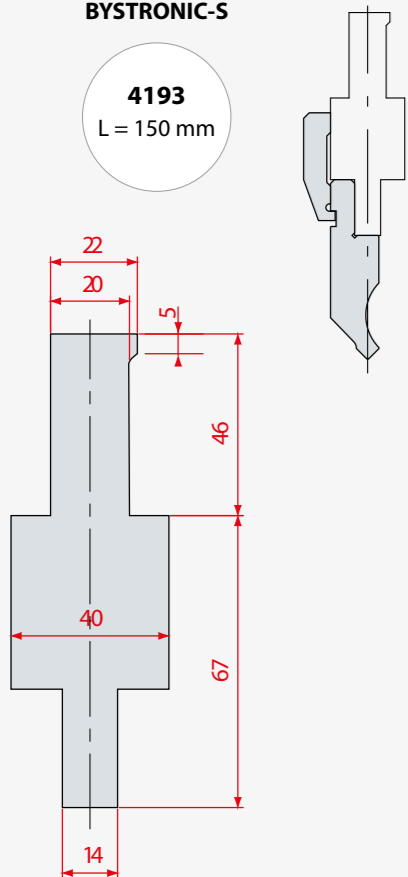
BYSTRONIC-R

4192  
L = 150 mm



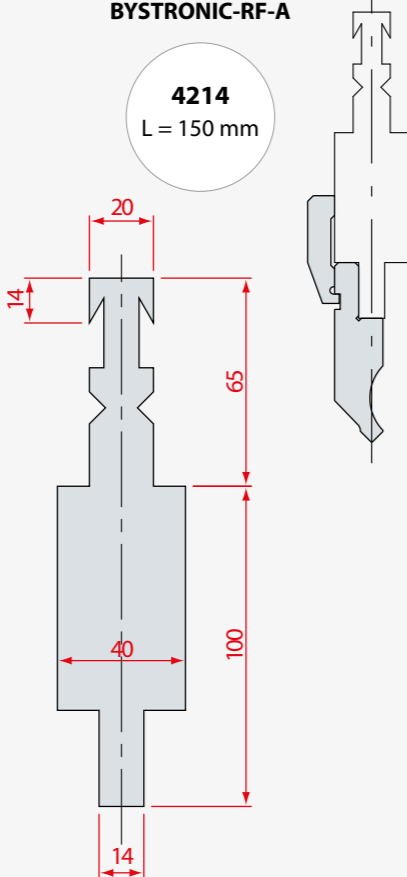
BYSTRONIC-S

4193  
L = 150 mm



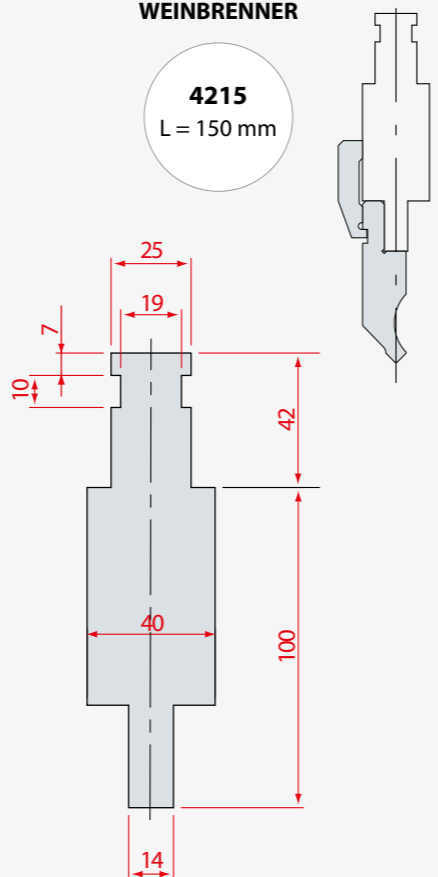
BYSTRONIC-RF-A

4214  
L = 150 mm



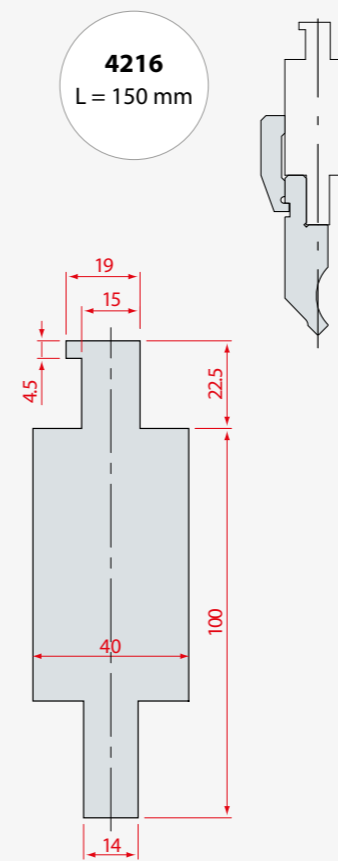
WEINBRENNER

4215  
L = 150 mm



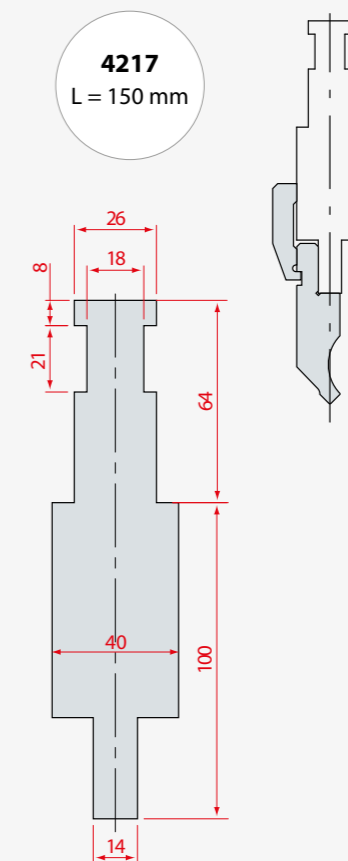
CBC

4216  
L = 150 mm



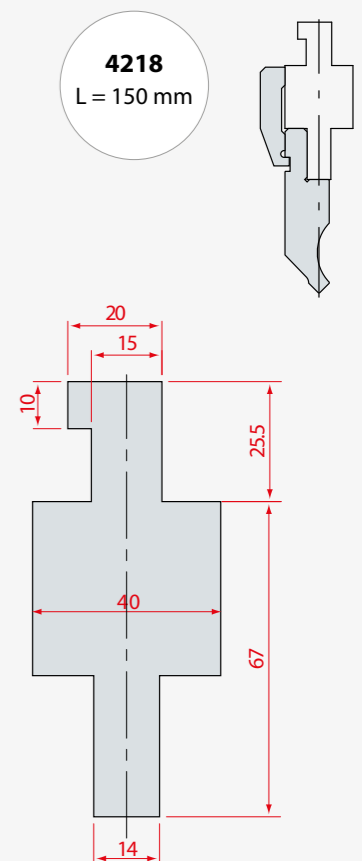
EHT

4217  
L = 150 mm



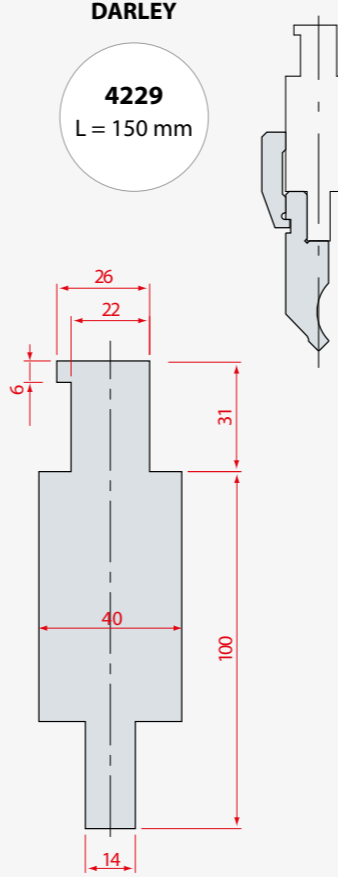
DURMAZLAR

4218  
L = 150 mm



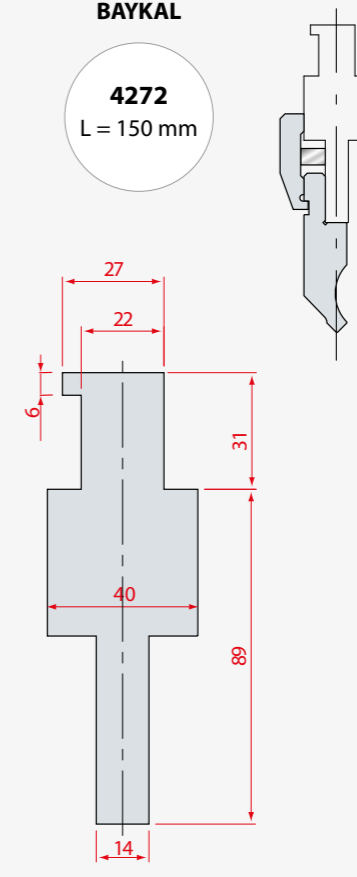
DARLEY

4229  
L = 150 mm



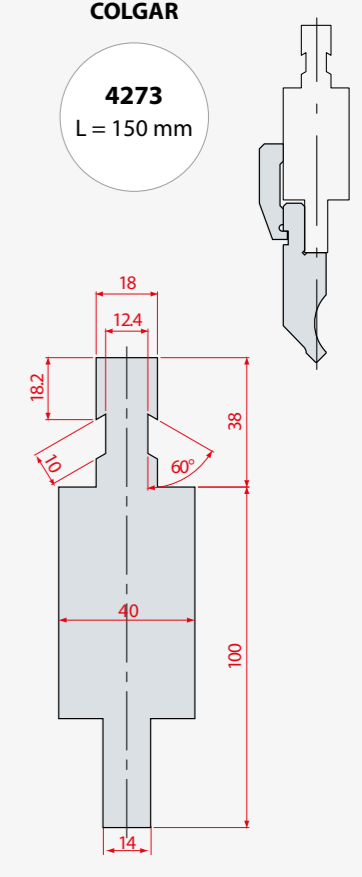
BAYKAL

4272  
L = 150 mm

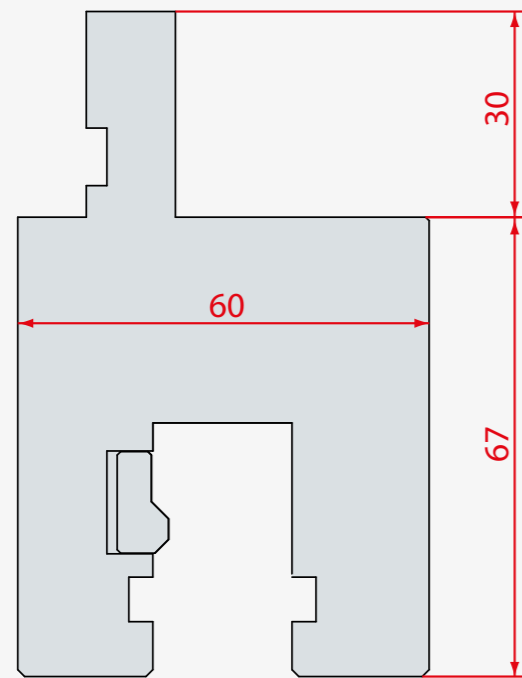


COLGAR

4273  
L = 150 mm







ADAPTOR  
AMADA/TRUMPF

**4362**  
H = 67 mm  
L = 150 mm



ES CLAMP PN

Patented and pneumatic intermediate es clamp pn model for promecam style tooling.

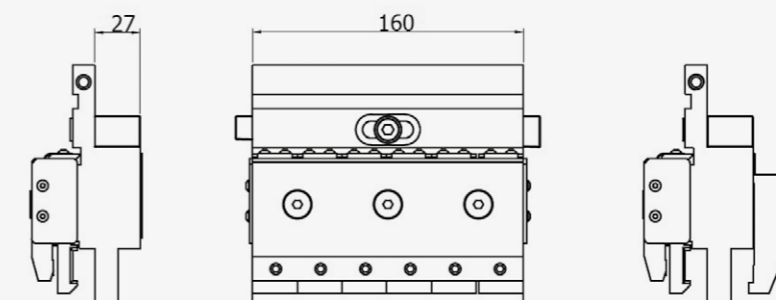


SPECIFICS

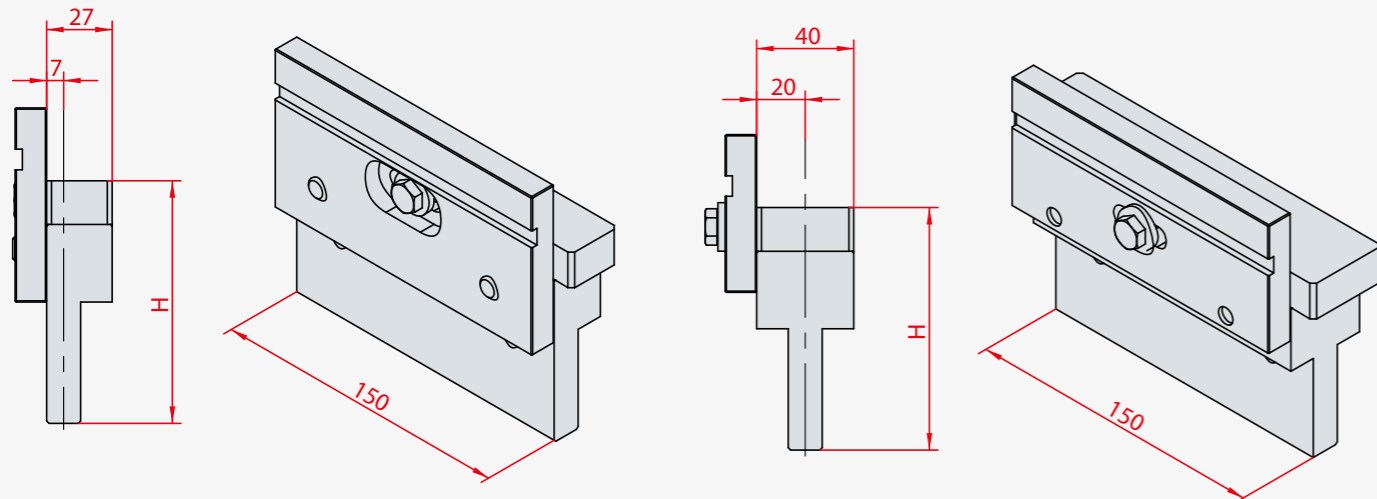
- Easy to install
- The system does not require any modification to the press brake or tooling
- Front insertion
- Fall-protection system
- Self-alignment of top tools
- Pneumatic clamping
- Possibility to remove the clamps easily
- Available in different heights
- Rear tool holder with manual closure included

CODE	HEIGHT ( mm )
4369	110
4370	150
4371	200
4372	250
4373	300
4374	400
4375	500

OPTIONAL	
4376	Rear tool holder with pneumatic closure
4377	Pneumatic Kit



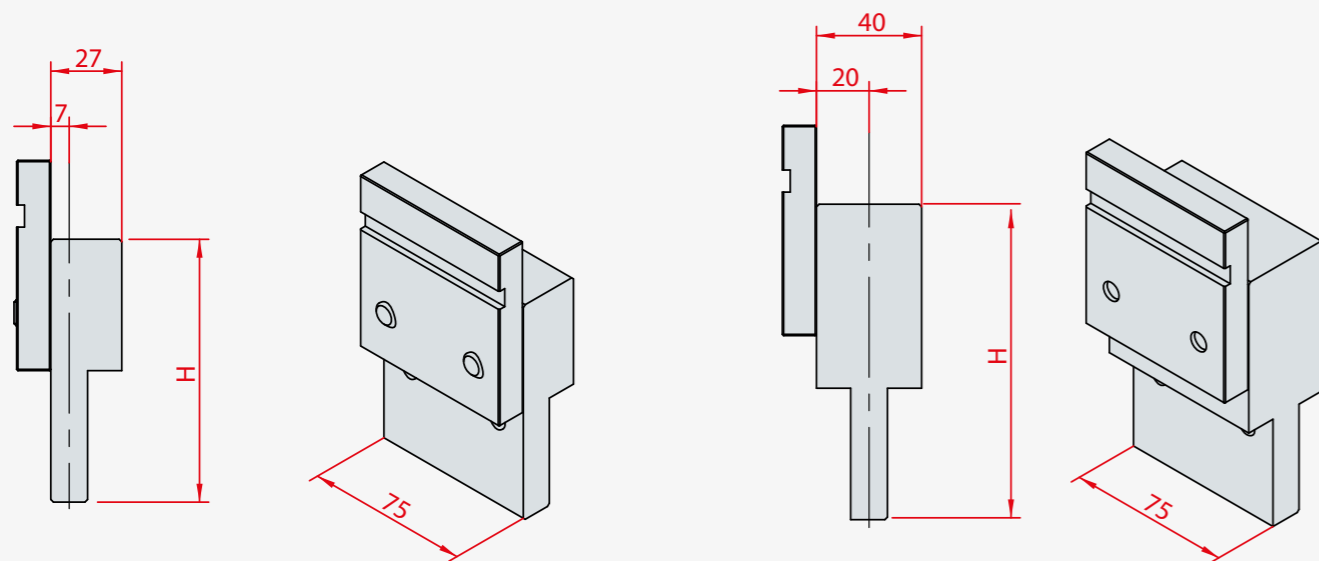
Subject to availability, intermediates could be provided :  
 a) with a solid body and wedge  
 b) as a bolted construction with a bolted tang and body



4221	H = 100 mm
4222	H = 120 mm
4223	H = 150 mm

4224	H = 100 mm
4225	H = 120 mm

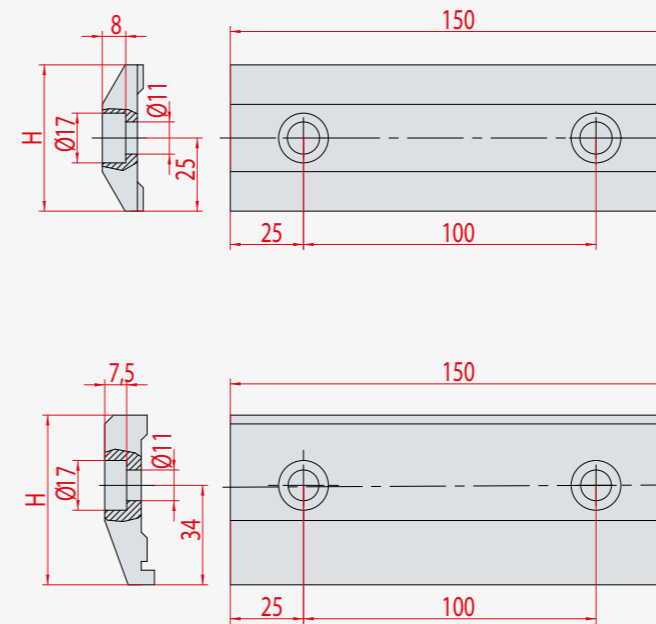
FIXED INTERMEDIATES



4226	H = 100 mm
4227	H = 150 mm

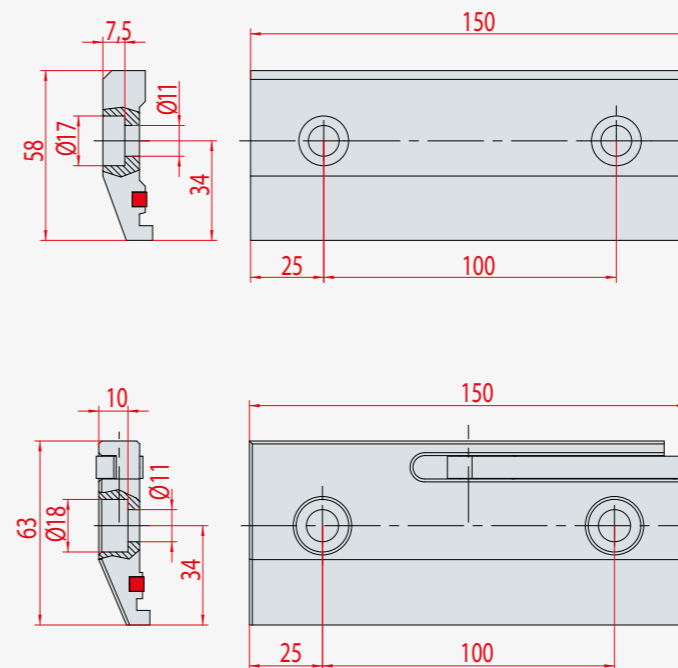
4228	H = 120 mm
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Screws included only with the purchase of the intermediates



4016	H = 50 mm
5013	H = 43 mm

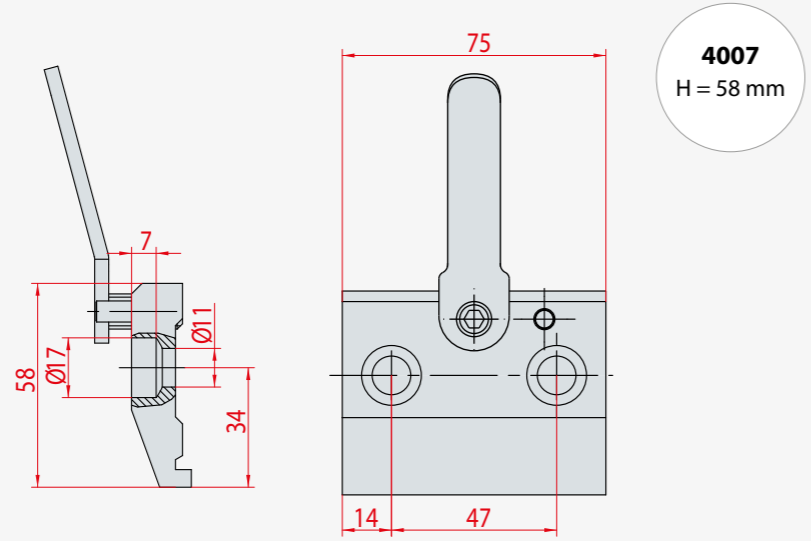
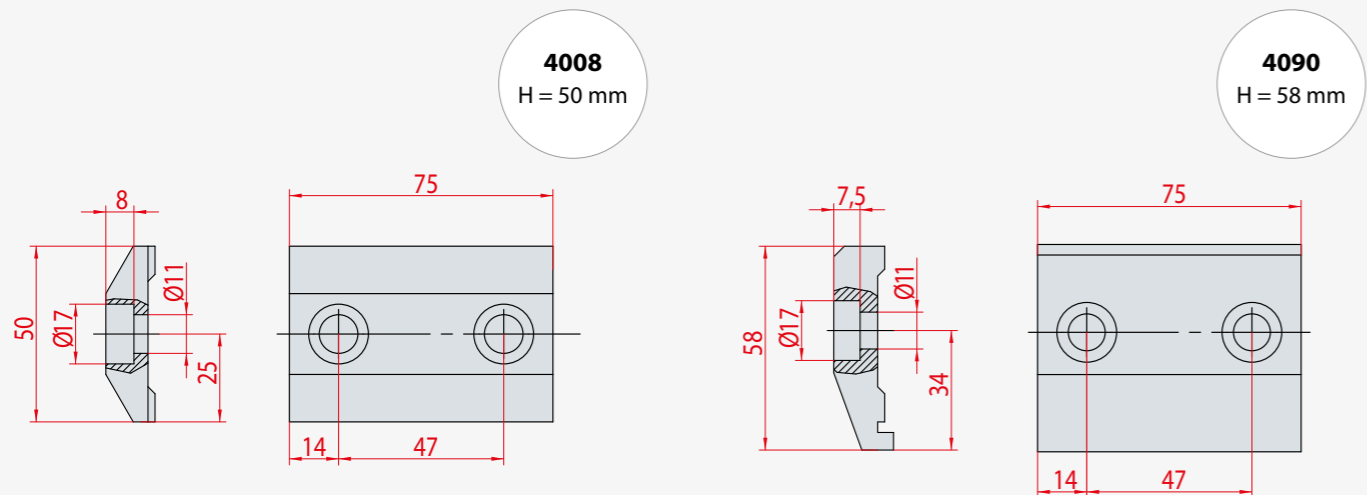
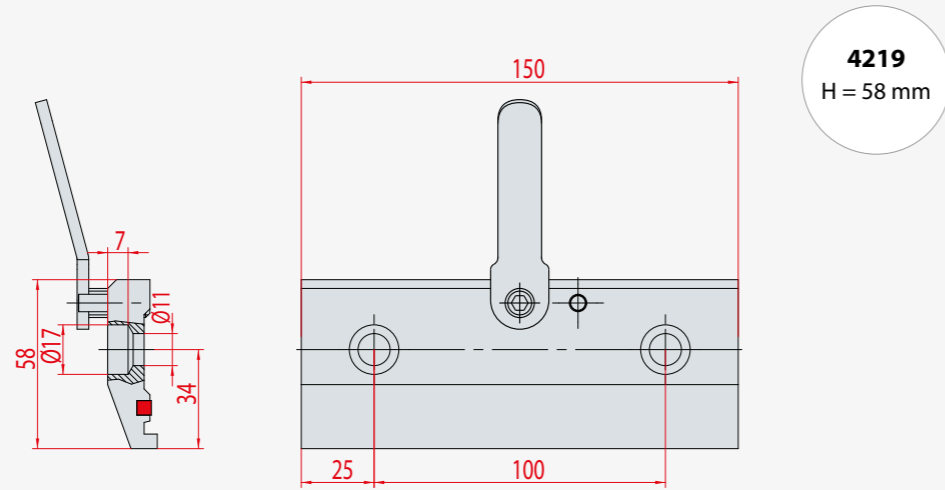
4020	H = 58 mm
5012	H = 52 mm



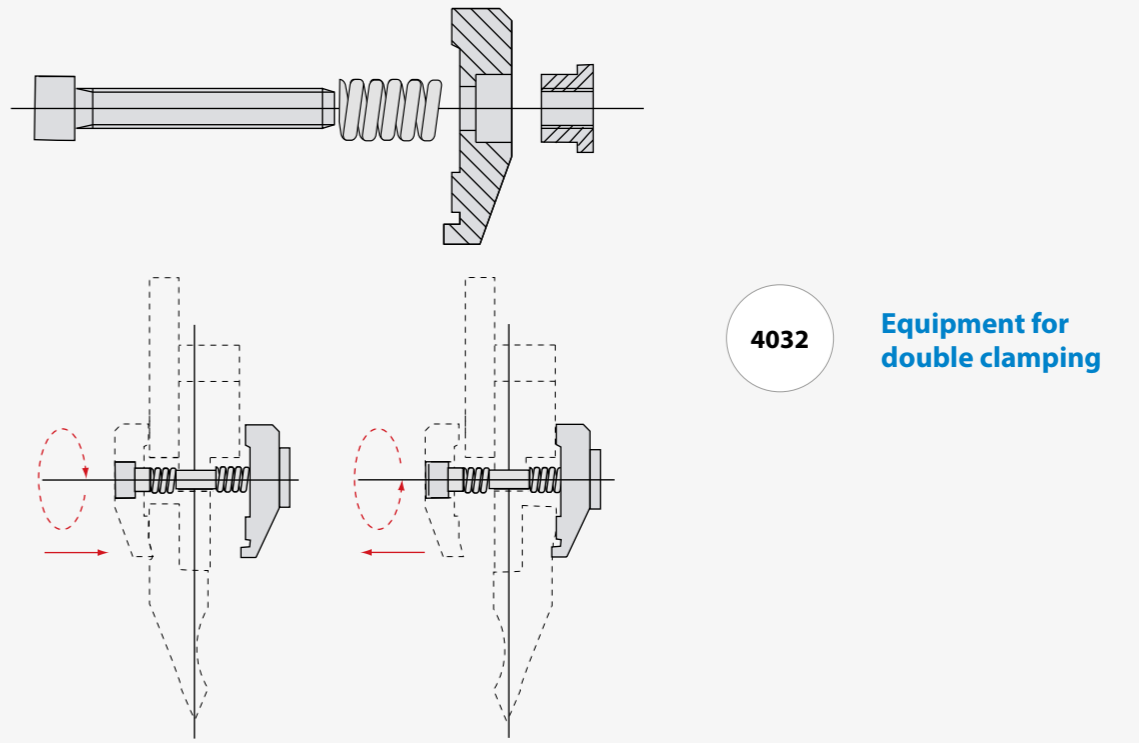
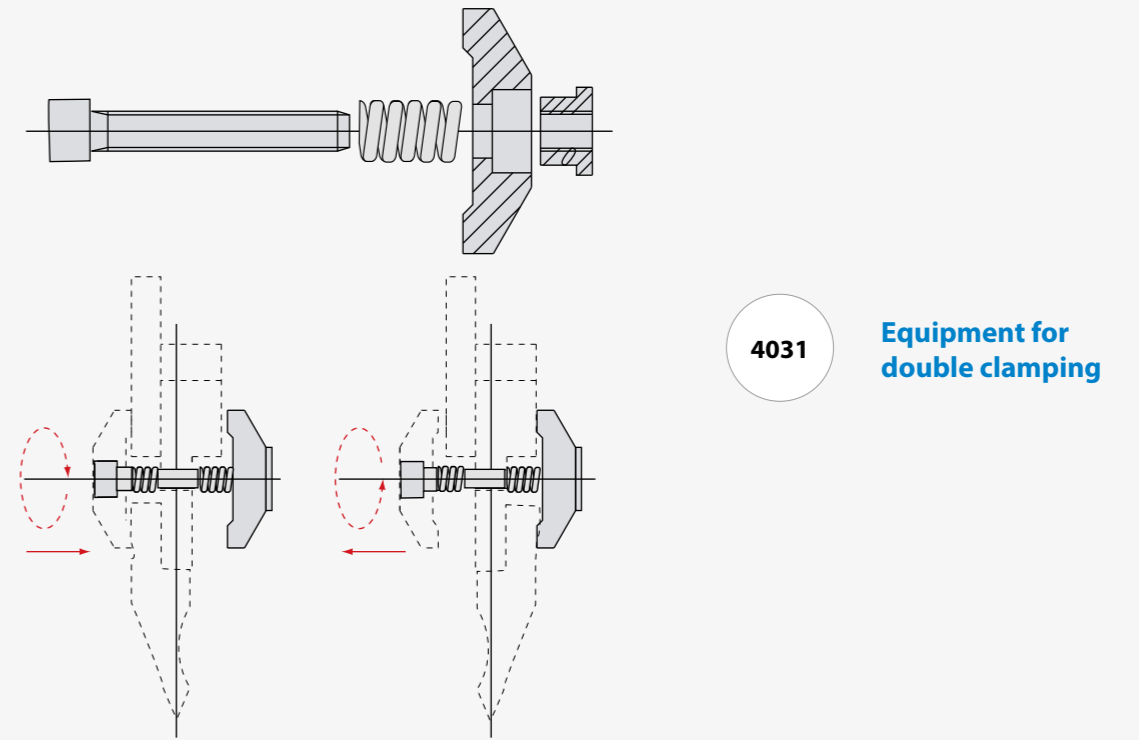
4199	H = 58 mm
------	-----------

4220	H = 63 mm
------	-----------

Screws included only with the purchase of the intermediates



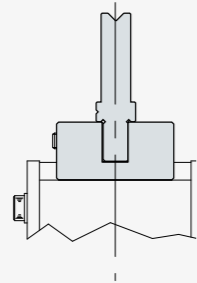
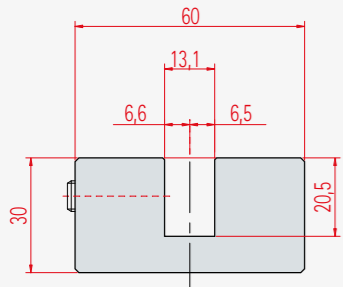
Screws included only with the purchase of the intermediates



AMADA-BYSTRONIC / TRUMPF

**4301**

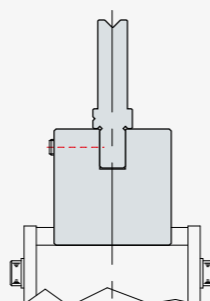
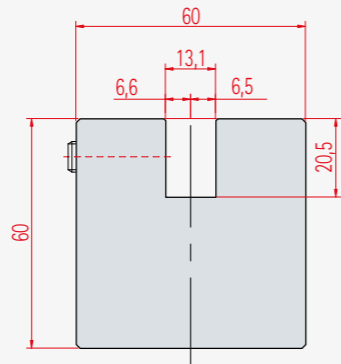
L = 1000 mm  
L = 500 mm



AMADA-BYSTRONIC / TRUMPF

**4302**

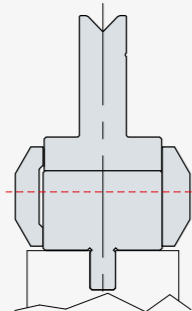
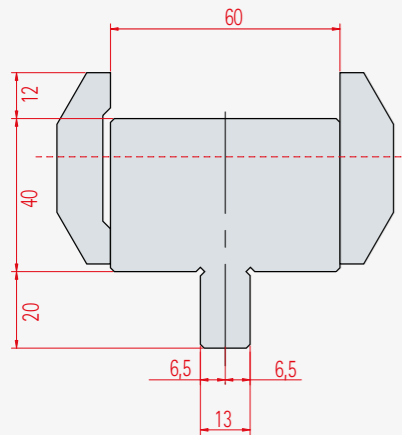
L = 1000 mm  
L = 500 mm



BYSTRONIC / TRUMPF-AMADA

**4303**

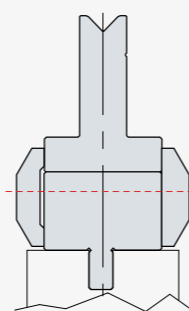
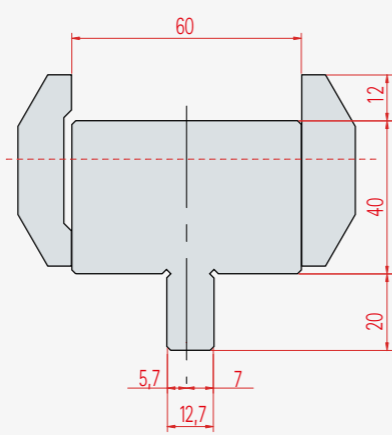
L = 835 mm  
L = 415 mm



LVD - AMADA

**4304**

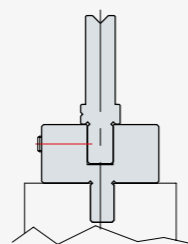
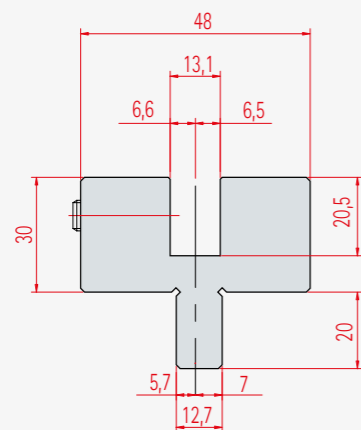
L = 835 mm  
L = 415 mm



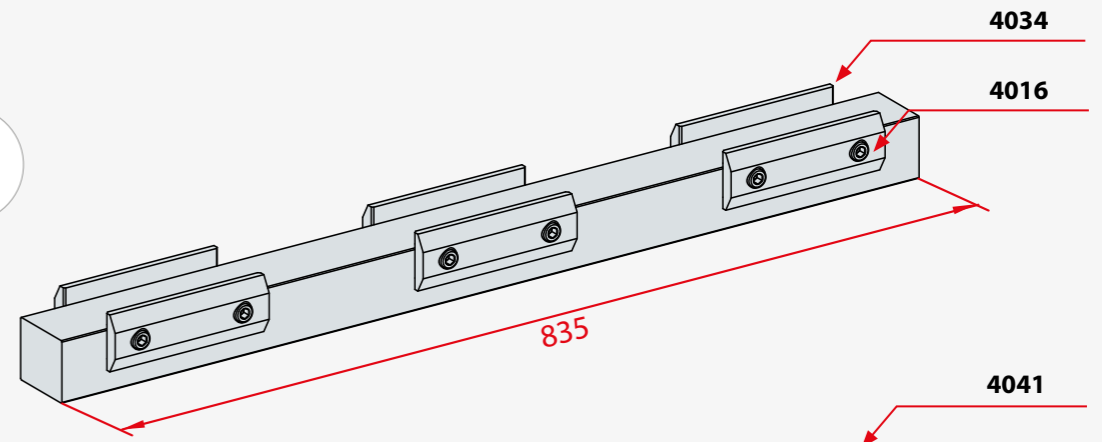
LDV-BYSTRONIC / TRUMPF

**4305**

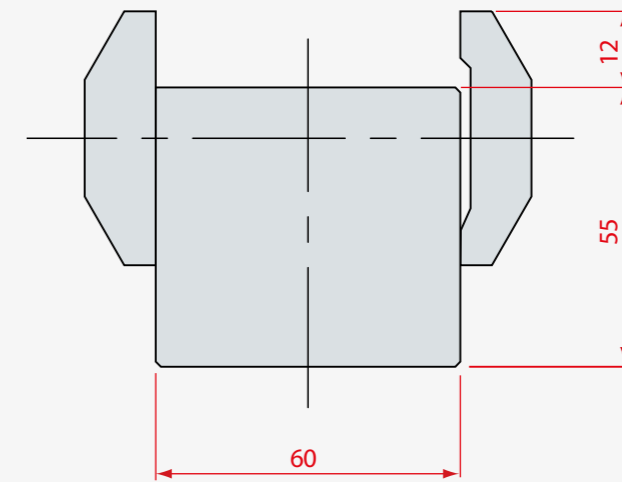
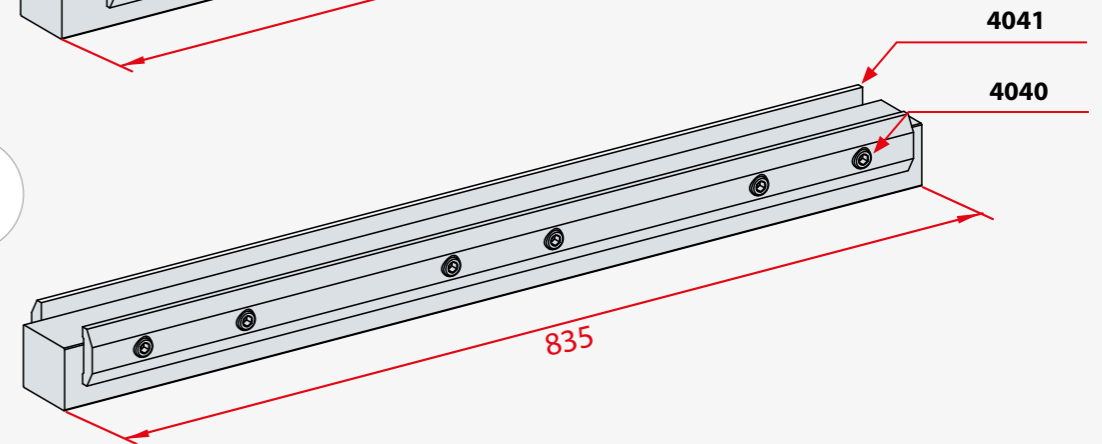
L = 1000 mm  
L = 500 mm



**4033**



**4050**



Lower adaptor AMADA

Lower adaptor AMADA

**4033**  
L = 835 mm

**4050**  
L = 835 mm



4309

COUPLE OF TIGHTENERS

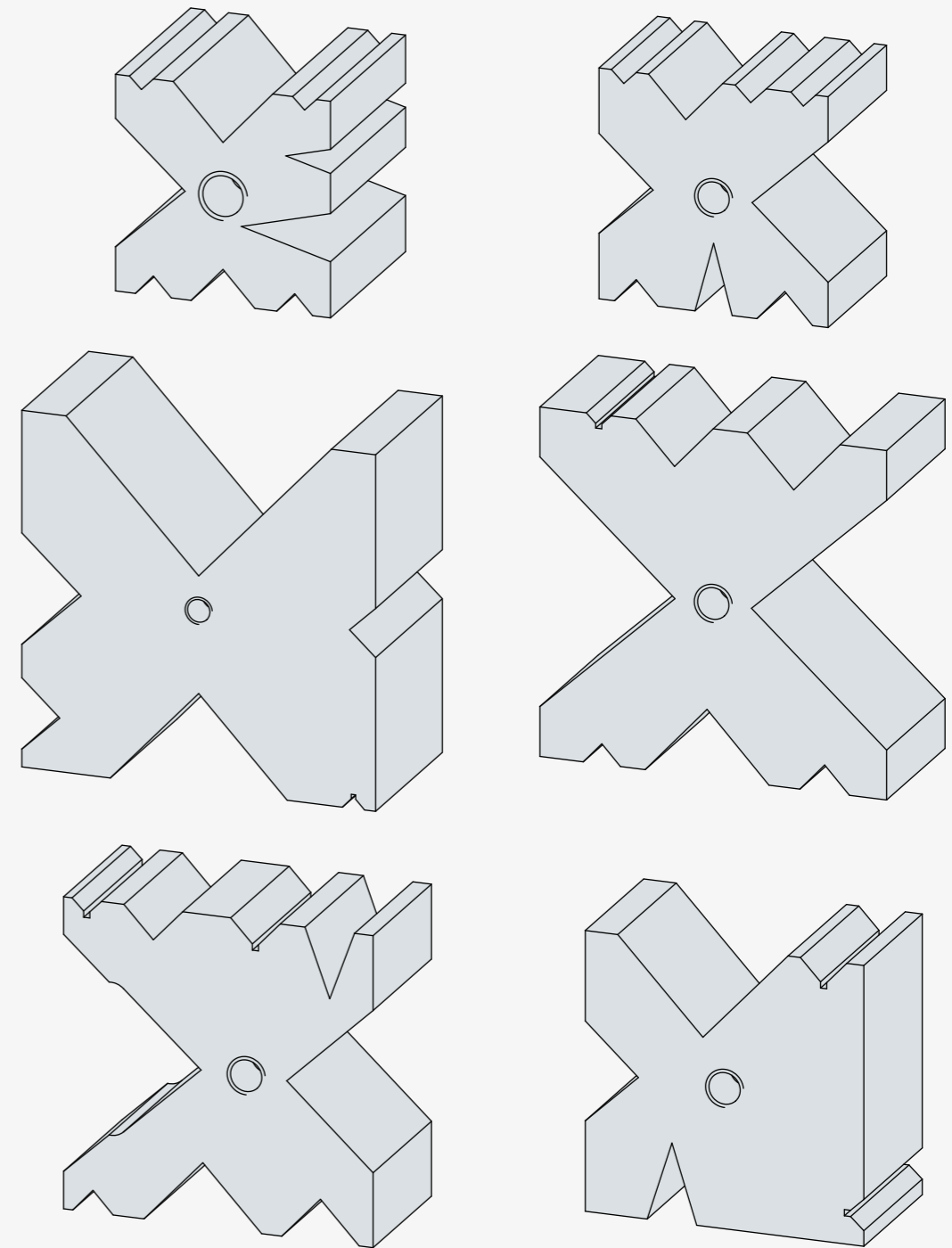


FILM OF POLYURETHANE ANTISCRATCH 150 X 0,6 OF THICKNESS

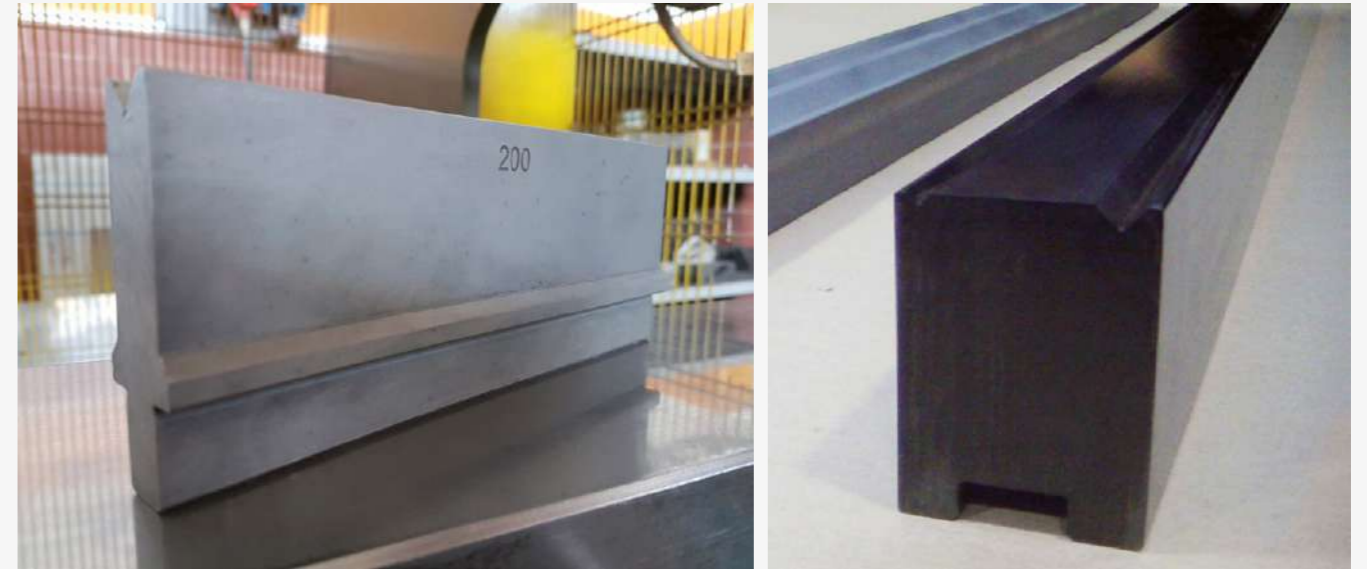
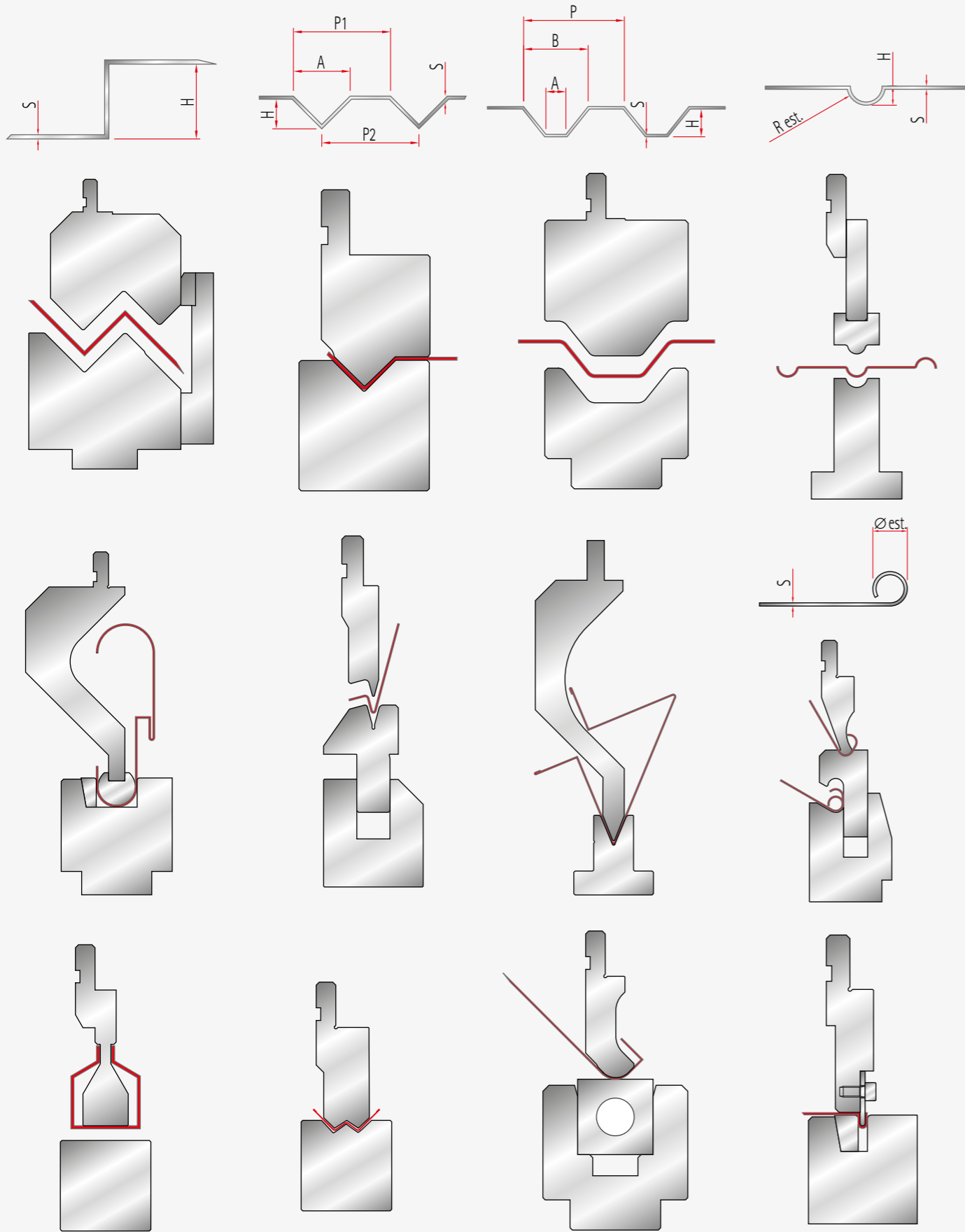


Left Hand Model

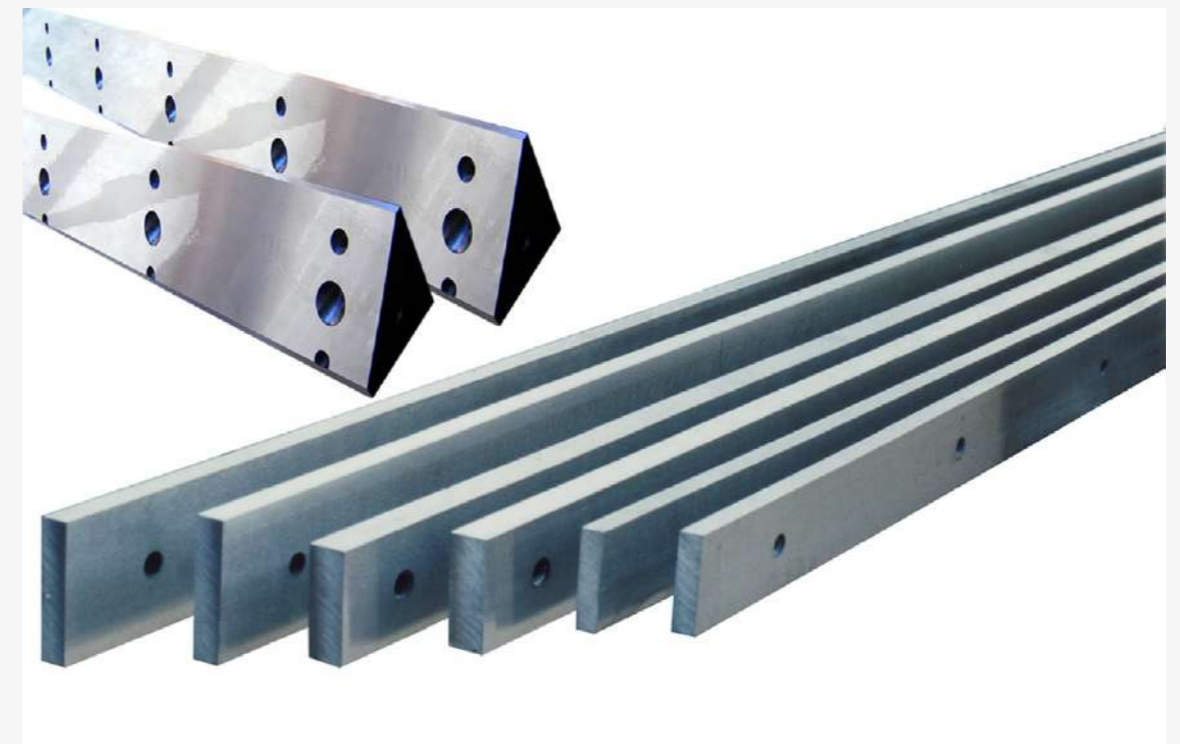
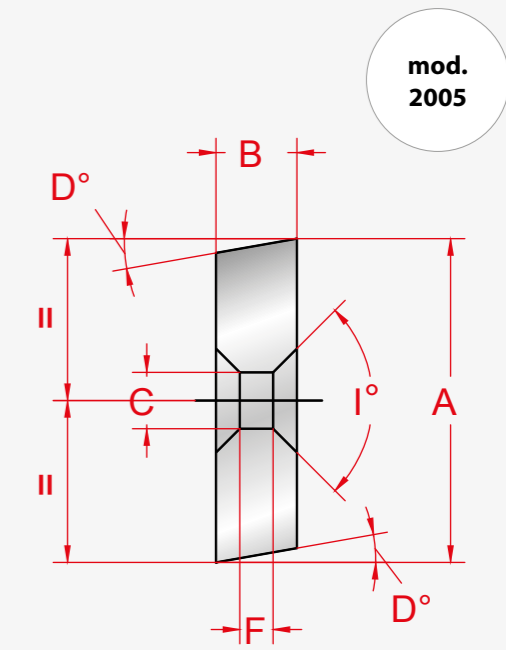
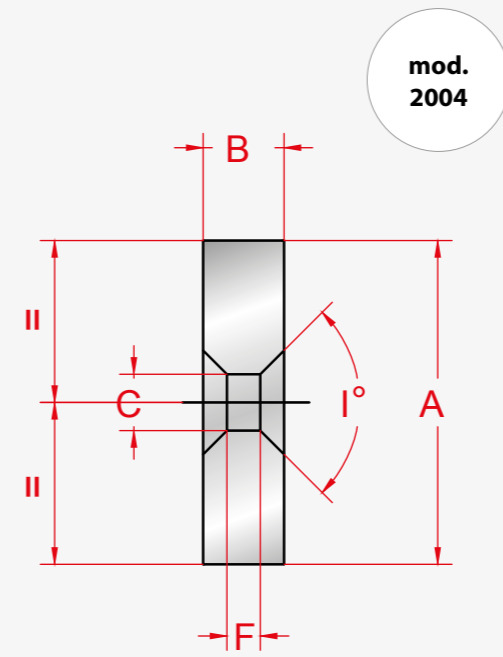
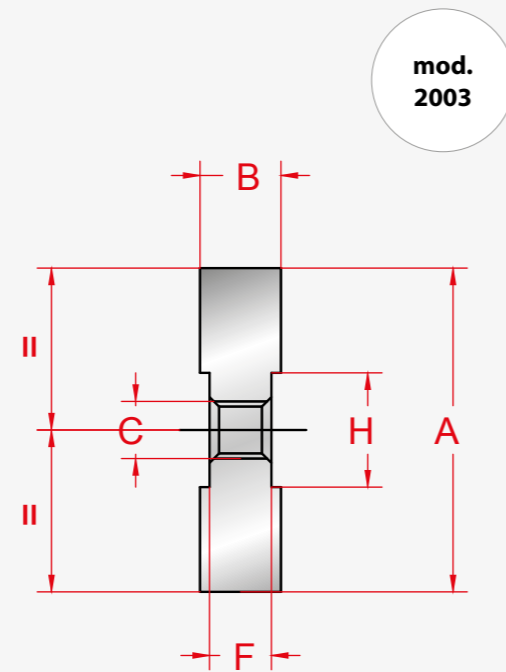
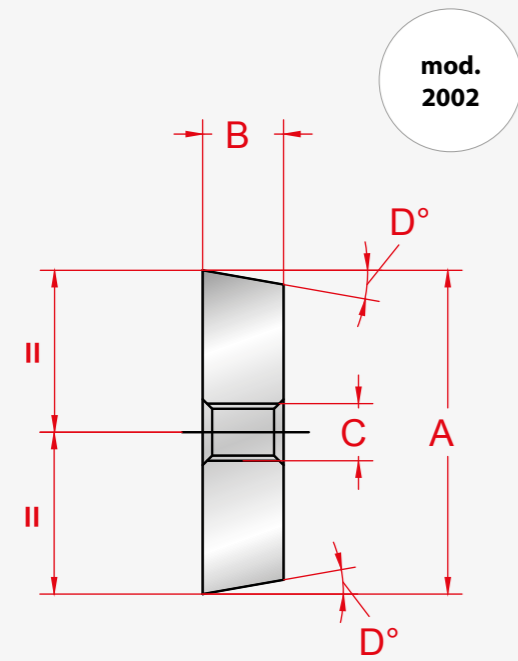
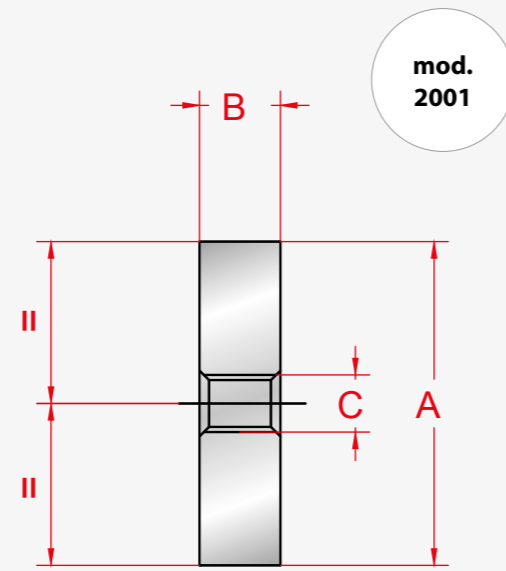
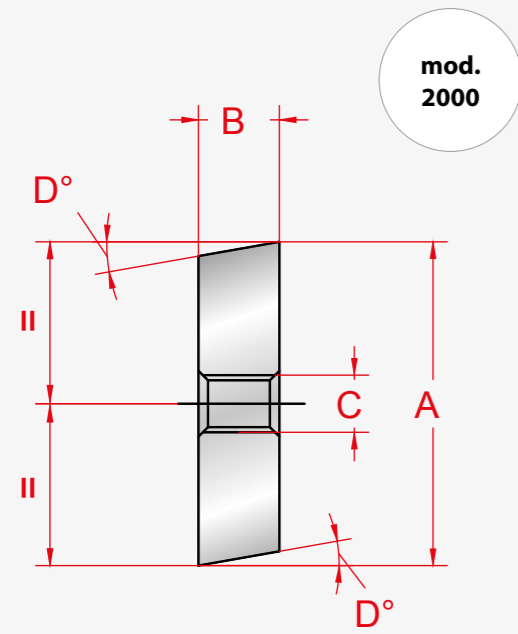
Right Hand Model



Material:	Working:	Length (mm):
1.2312	Hardened	2000
C45	Quenched-nitrided	3000
42CrM04	Planed	4000
	Ground	6000
		8000



- 8201
**Phosphating treatment** (anti rust)
  
- 8205
**Nitriding treatment** (anti seize for galvanized sheet metals)
  
- 8202
**Phosphating + nitriding treatment**  
 (antiseize and antitrust for galvanized sheet metals)





ASHMORES PRESS BRAKE TOOLING LTD		ANGLE a							
		90	88	86	60	45	35	30	26
REQUEST RADIUS	1	0,08	0,09	0,09	0,2	0,32	0,47	0,57	0,69
	1,5	0,29	0,31	0,33	0,7	1,13	1,63	2	2,41
	2	0,5	0,53	0,56	1,2	1,94	2,79	3,44	
	2,5	0,7	0,75	0,79	1,7	2,74			
	3	0,91	0,97	1,03	2,2				
	3,5	1,12	1,19	1,26	2,7				
	4	1,33	1,41	1,49					
	4,5	1,53	1,63	1,73					
	5	1,74	1,85	1,96					
	5,5	1,95	2,07	2,19					
6	2,15	2,29	2,42						
STARTING RADIUS: 0.8									



Standard color: **FULL BLACK**



CODE	STYLE	DRAWERS	LENGTH (MM)
<b>ACARM0NE0003</b>	Amada	3	835
<b>ACARM1NE0003</b>	Trumpf / Wila / Bystronic / LVD	3	1100
<b>ACARM2NE0003</b>	Trumpf / Wila / Bystronic / LVD	3	550



CODE	STYLE	DRAWERS	LENGTH (MM)
<b>ACARM0NE0004</b>	Amada	4	835
<b>ACARM1NE0004</b>	Trumpf / Wila / Bystronic / LVD	4	1100
<b>ACARM2NE0004</b>	Trumpf / Wila / Bystronic / LVD	4	550



CODE	STYLE	DRAWERS	LENGTH (MM)
<b>ACARM0NE0005</b>	Amada	5	835
<b>ACARM1NE0005</b>	Trumpf / Wila / Bystronic / LVD	5	1100
<b>ACARM2NE0005</b>	Trumpf / Wila / Bystronic / LVD	5	550

Standard color: **FULL BLACK**



CODE	STYLE	SHELVES	LENGTH (MM)
<b>CARRELLO0005</b>	Mobile trolley for Amada tools	5	835

# ASHMORES PRESS BRAKE TOOLING LTD

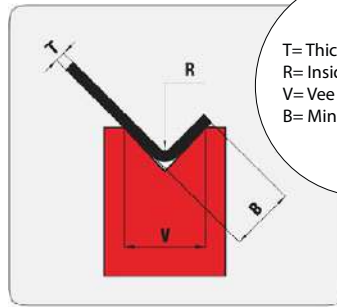
Tel: 0121 557 1064 Fax: 0121 557 1085

Email: ashmores@pressbraketool.co.uk Website: www.pressbraketool.co.uk

Lewis Street, Great Bridge, Tipton, West Midlands DY4 7EF.

T:Email: ashmores@pressbraketool.co.uk

## Bending / Tonnage Charts



T	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	320	400	V		
	4	5.5	7	8.5	11	14	17.5	22	28	35	45	55	71	89	113	140	175	226	350	B		
	1	1.3	1.6	2	2.6	3.3	4	5	6.5	8	10	13	16	20	26	32	41	53	83	R		
0.8	7	5	4																		F=T/m	
1	11	8	7	6																		
1.2	16	12	10	8	6																	
1.5		17	15	13	9	8																
2			27	22	17	13	11															
2.5				35	26	21	17	13														
3					38	30	24	19	15													
4						54	42	34	27	21												
5							67	52	42	33	26											
6								75	60	48	38	30										
7									66	52	41	34										
8										86	69	53	43									
9											86	68	54	44								
10												105	85	67	53							
12													120	95	76	60						
15														150	120	95	75					
18															174	137	110	88				
20																170	135	108	85			
25																	210	170	130	105		

For Aluminium Multiply answer by 0.6  
For Stainless steel Multiply answer by 1.6