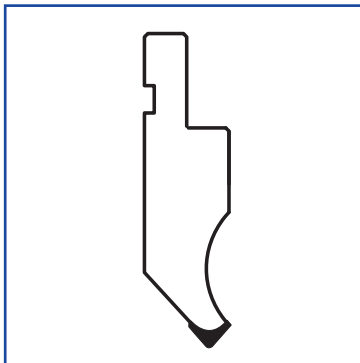
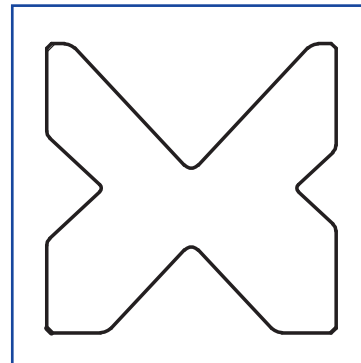
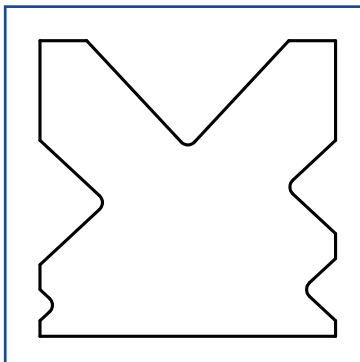
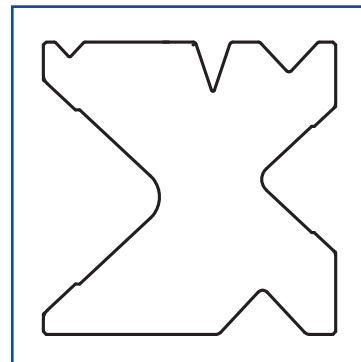


**STANDARD PRESSBRAKE TOOLING**

**GOOSE NECK TOP TOOL**

 EURO 1010/A/85/0.8  
 EURO 1010/A/85/0.8/105  
 40527  
 40528

**4 WAY VEE DIE BOTTOM TOOL**

 EURO 2009  
 1061  
 1062  
 1071  
 1081

**5 WAY VEE DIE BOTTOM TOOL**

 40529  
 40530  
 40531

**6 WAY VEE DIE BOTTOM TOOL**

 AB6 3-4  
 AB6 5-6  
 AB6 7-8  
 AB6 9-10  
 AB6 11-12  
 AB6 16

| MODEL  | GOOSE NECK         | TOP TOOL OVERALL | BOTTOM TOOL | BOTTOM TOOL  | BOTTOM TOOL              | BOTTOM TOOL  |
|--|--------------------|------------------|-------------|--------------|--------------------------|--------------|
|  | TOP TOOL REFERENCE | HEIGHT           | REFERENCE   | No. OF VEE'S | VEE SIZES                | OVERALL SIZE |
|  |                    | mm               |             |              | mm                       | mm           |
| <b>PBS CNC RANGE</b>                                       |                    |                  |             |              |                          |              |
| 1250/40 - 4100/160   | 1010/A/85/0.8      | 96.5             | 2009        | 4            | 16, 22, 35, 50           | 60 x 60      |
| 3100/200 - 4100/240  | 1010/A/85/0.8/105  | 135              | 2009        | 4            | 16, 22, 35, 50           | 60 x 60      |
| 3700/300, 4100/300   | 1010/A/85/0.8/105  | 135              | AB6 11-12   | 6            | 12, 15, 26, 50, 80, 125  | 145 x 145    |
| 3100/300   | 1010/A/85/0.8/105  | 135              | AB6 16      | 6            | 20, 25, 40, 80, 100, 170 | 200 x 200    |
| <b>PBXS CNC RANGE</b>                                      |                    |                  |             |              |                          |              |
| 1250/40 - 6100/160   | 1010/A/85/0.8      | 96.5             | 2009        | 4            | 16, 22, 35, 50           | 60 x 60      |
| 3100/120 - 6100/240  | 1010/A/85/0.8/105  | 135              | 2009        | 4            | 16, 22, 35, 50           | 60 x 60      |
| 3100/160, 3700/200, 4100/200, 6100/300                     | 1010/A/85/0.8/105  |                  | AB6 7-8     | 6            | 10, 12, 20, 30, 50, 80   | 100 x 100    |
| 3100/200, 3100/240, 3700/240, 3700/240, 4100/240, 6100/380 | 1010/A/85/0.8/105  |                  | AB6 9-10    | 6            | 12, 15, 26, 40, 60, 100  | 125 x 125    |
| 3700/300, 4100/300, 6100/440, 6100/500                     | 1010/A/85/0.8/105  | 135              | AB6 11-12   | 6            | 12, 15, 26, 50, 80, 125  | 145 x 145    |
| 3100/300, 4100/440, 6100/600                               | 1010/A/85/0.8/105  | 135              | AB6 16      | 6            | 20, 25, 40, 80, 100, 170 | 200 x 200    |
| <b>PBE NC RANGE</b>  |                    |                  |             |              |                          |              |
| 1250/30  | 1010/A/85/0.8      | 96.5             | 40531       | 5            | 6, 10, 12, 15, 30        | 60 x 60      |
| <b>PB NC RANGE</b>   |                    |                  |             |              |                          |              |
| 1250/40, 2100/40, 2600/60, 3100/90                         | 1010/A/85/0.8      | 96.5             | AB6 3-4     | 6            | 8, 10, 15, 20, 26, 40    | 70 x 70      |
| 2600/90, 3100/120, 3700/160, 4100/160                      | 1010/A/85/0.8      | 96.5             | AB6 5-6     | 6            | 10, 12, 16, 26, 40, 60   | 90 x 90      |
| 3100/160   | 1010/A/85/0.8      | 96.5             | AB6 7-8     | 6            | 10, 12, 20, 30, 50, 80   | 100 x 100    |
| 4100/200   | 1010/A/85/0.8/105  | 135              | AB6 7-8     | 6            | 10, 12, 20, 30, 50, 80   | 100 x 100    |
| 3100/200, 3700/200, 3700/240, 4100/240                     | 1010/A/85/0.8/105  | 135              | AB6 9-10    | 6            | 12, 15, 26, 40, 60, 100  | 125 x 125    |
| 3100/240, 4100/300   | 1010/A/85/0.8/105  | 135              | AB6 11-12   | 6            | 12, 15, 26, 50, 80, 125  | 145 x 145    |
| 3100/300   | 1010/A/85/0.8/105  | 135              | AB6 16      | 6            | 20, 25, 40, 80, 100, 170 | 200 x 200    |
| <b>PBH RANGE</b>   |                    |                  |             |              |                          |              |
| 1020/100, 1020/150   | 40527              | 190              | 40529       | 5            | 10, 20, 30, 40, 65       | 95 x 95      |
| 1520/100, 1520/150   | 40528              | 190              | 40530       | 5            | 10, 20, 30, 40, 65       | 95 x 95      |

The following five pages detail the various types and technical drawings of the standard range of pressbrake tooling available from Selmach Machinery. Goose neck top tools are particularly useful for double bend 'U' shape brackets to avoid the leg from the first bend colliding with the top tool. The 35 degree tools are designed for over bending requirements as well as for the first stage bending for safe edge tooling. Segmented tooling allows for return bending and is necessary for box making after the corners have first been notched. The bull nose tooling is ideal for bending thicker materials as the tonnes per meter rating is very high. The chart below indicates the tonnage required for various bending operations and includes a quick calculation formula.

### Machine Features

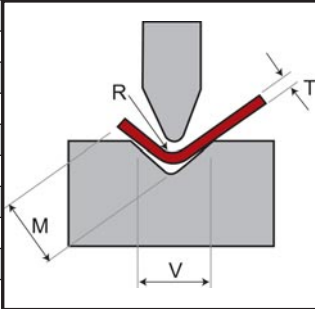
- Standard Euro style top & bottom tools
- Hemming tools for producing safe edges
- Joggle tools for small return bends
- Radius tools
- 835mm and 415mm sections
- Segmented top tools with horns for box folding
- Segmented bottom tools
- Bespoke tooling service
- Intermediates and security clamps



## TONNAGE CALCULATOR

T = Steel thickness (mm) R = Internal radius of bend (mm) M = Minimum return bend (mm) V = Bottom die Vee width (mm) L = Bending length (mm)

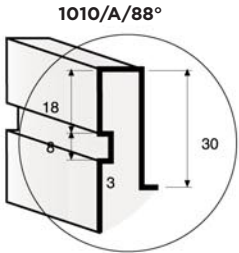
| T mm | 0.7 | 0.8 | 1   | 1.3 | 1.6 | 2  | 2.7 | 3  | 3.3 | 4  | 5  | 5.5 | 6.5 | 7  | 8  | 10 | 11 | 13  | 16  | 19  | 21  | 23  | 24.5 | 26  | 28  | 32  | 41  | 48  | R (mm) |       |
|------|-----|-----|-----|-----|-----|----|-----|----|-----|----|----|-----|-----|----|----|----|----|-----|-----|-----|-----|-----|------|-----|-----|-----|-----|-----|--------|-------|
|      | 2.8 | 3.5 | 4   | 6   | 7   | 9  | 11  | 13 | 14  | 17 | 22 | 24  | 28  | 31 | 35 | 42 | 49 | 56  | 70  | 80  | 90  | 100 | 105  | 110 | 130 | 140 | 170 | 200 | M (mm) |       |
|      | 4   | 5   | 6   | 8   | 10  | 12 | 15  | 18 | 20  | 25 | 30 | 35  | 40  | 45 | 50 | 60 | 70 | 80  | 100 | 120 | 130 | 140 | 150  | 160 | 180 | 200 | 250 | 300 | V (mm) |       |
| 0.5  | 4   | 3   | 2   | 2   |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 0.6  | 5   | 4   | 3.5 | 3   | 2   |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 0.8  |     | 8   | 7   | 5   | 4   | 2  |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 1.0  |     |     | 10  | 8   | 6   | 5  | 4   |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 1.2  |     |     |     | 10  | 8   | 6  | 5   | 4  |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 1.5  |     |     |     |     | 13  | 12 | 9   | 7  | 7   |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 1.8  |     |     |     |     |     | 16 | 13  | 11 | 10  | 8  |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 2.0  |     |     |     |     |     |    | 16  | 14 | 12  | 10 | 8  |     |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 2.5  |     |     |     |     |     |    |     | 21 | 20  | 15 | 12 | 11  |     |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 3.0  |     |     |     |     |     |    |     |    | 27  | 22 | 18 | 15  | 13  |    |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 3.5  |     |     |     |     |     |    |     |    |     | 29 | 24 | 21  | 18  | 16 |    |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 4.0  |     |     |     |     |     |    |     |    |     |    | 32 | 27  | 24  | 21 | 19 |    |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 4.5  |     |     |     |     |     |    |     |    |     |    |    | 35  | 30  | 27 | 24 | 20 |    |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 5.0  |     |     |     |     |     |    |     |    |     |    |    |     | 37  | 33 | 30 | 25 | 21 |     |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 6.0  |     |     |     |     |     |    |     |    |     |    |    |     |     | 48 | 43 | 36 | 31 | 27  |     |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 7.0  |     |     |     |     |     |    |     |    |     |    |    |     |     |    | 58 | 49 | 42 | 37  | 29  |     |     |     |      |     |     |     |     |     |        | Ton/m |
| 8.0  |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    | 64 | 55 | 48  | 42  | 32  |     |     |      |     |     |     |     |     |        | Ton/m |
| 10   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    | 85 | 75  | 60  | 50  | 46  |     |      |     |     |     |     |     |        | Ton/m |
| 12   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    | 107 | 86  | 72  | 66  | 61  |      |     |     |     |     |     |        | Ton/m |
| 13   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     | 101 | 84  | 76  | 72  | 67   |     |     |     |     |     |        | Ton/m |
| 14   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     | 98  | 90  | 84  | 78   | 73  |     |     |     |     |        | Ton/m |
| 15   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     | 103 | 96  | 90   | 84  | 75  |     |     |     |        | Ton/m |
| 16   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     | 109 | 102  | 95  | 85  | 76  |     |     |        | Ton/m |
| 18   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     | 129  | 120 | 107 | 97  | 77  |     |        | Ton/m |
| 20   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      | 149 | 132 | 119 | 95  | 80  |        | Ton/m |
| 25   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     | 207 | 186 | 149 | 124 |        | Ton/m |
| 30   |     |     |     |     |     |    |     |    |     |    |    |     |     |    |    |    |    |     |     |     |     |     |      |     |     | 268 | 215 | 179 |        | Ton/m |



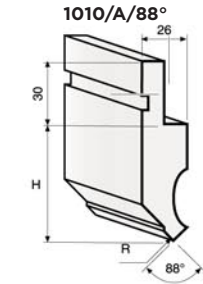
**TONNAGE CALCULATOR**

$$\text{Tonnes} = \frac{1.42 \times S \times T^2 \times L}{1000 \times V}$$

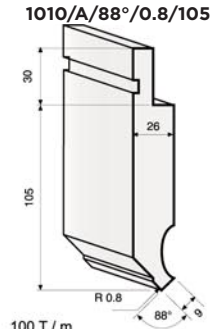
S = Tensile Strength (kg/mm<sup>2</sup>)  
Mild Steel = 45  
Stainless Steel = 60  
Aluminium = 30



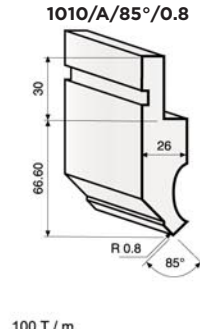
R = 0.2 mm / H = 66.90  
R = 0.8 mm / H = 66.60  
R = 1.5 mm / H = 65.90  
R = 2.3 mm / H = 65.60  
R = 3 mm / H = 65.25



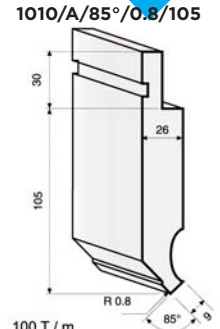
100 T / m



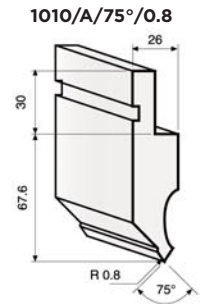
100 T / m



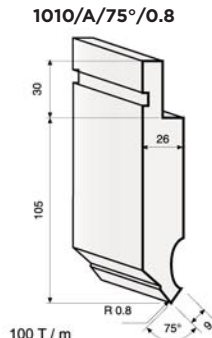
100 T / m



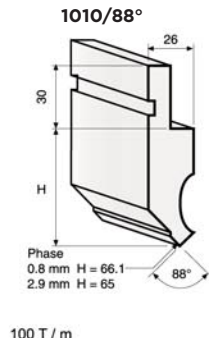
100 T / m



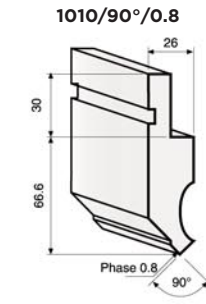
100 T / m



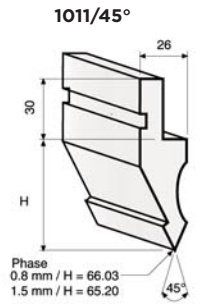
100 T / m



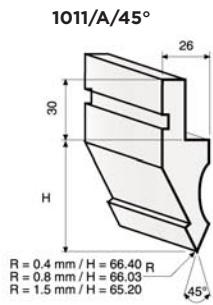
100 T / m



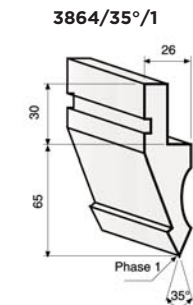
100 T / m



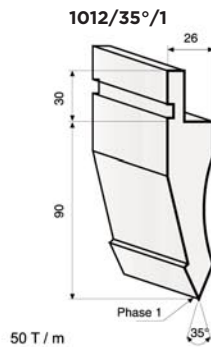
70 T / m



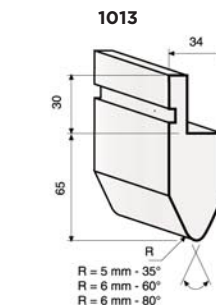
70 T / m



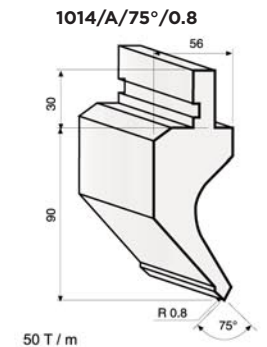
50 T / m



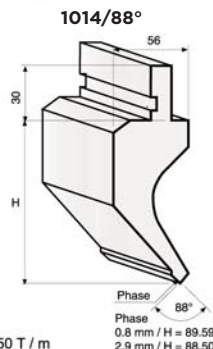
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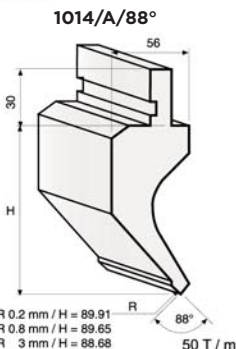
100 T / m



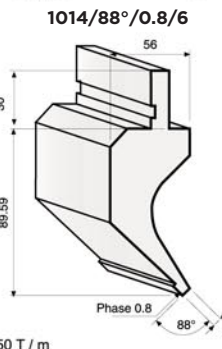
50 T / m



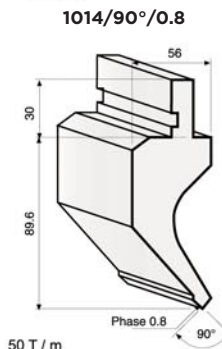
50 T / m



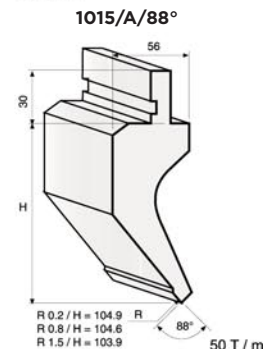
50 T / m



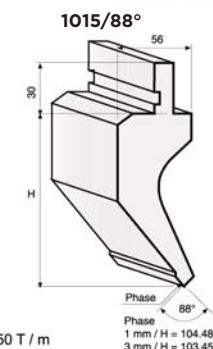
50 T / m



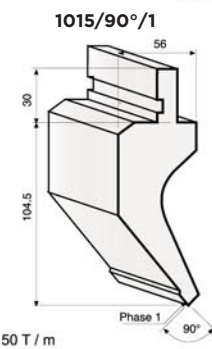
50 T / m



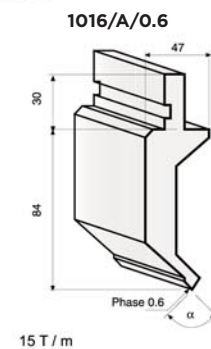
50 T / m



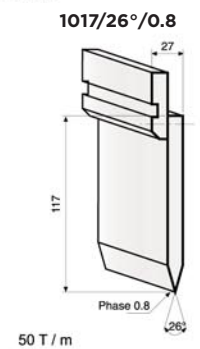
50 T / m



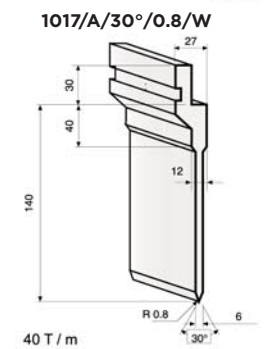
50 T / m



15 T / m

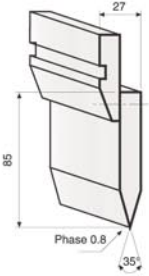


50 T / m



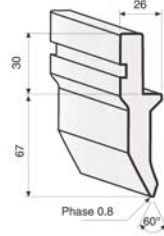
40 T / m

1017/35°/0.8



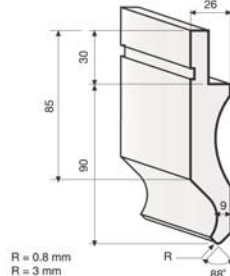
50 T / m

1018/60°/0.8



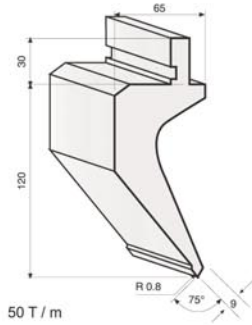
50 T / m

1019/A/88°



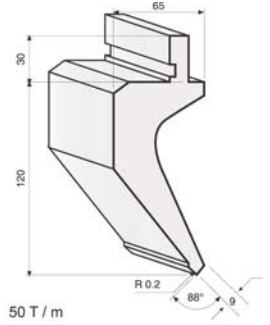
50 T / m

1020/A/75°/0.8



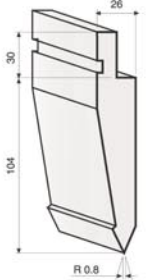
50 T / m

1020/A/88°/0.2



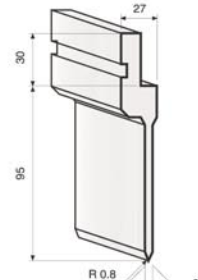
50 T / m

1021/A/30°/0.8



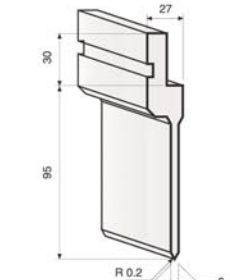
100 T / m

1022/A/75°/0.8



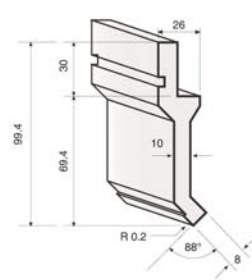
50 T / m

1022/A/88°/0.2



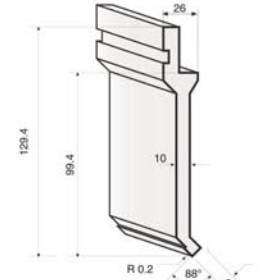
50 T / m

1023/A/88°/0.2



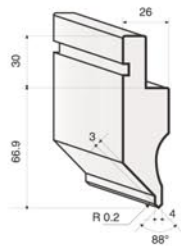
30 T / m

1024/A/88°/0.2



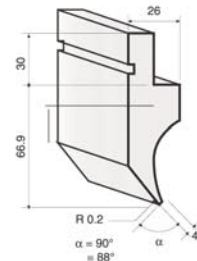
30 T / m

1025/A/88°/0.2



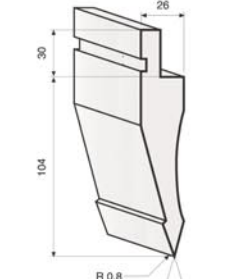
40 T / m

1026/A/0.2



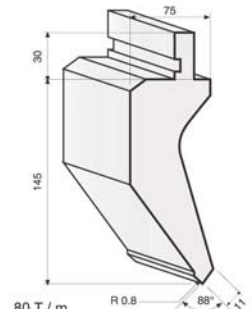
20 T / m

1027/A/30°/0.8



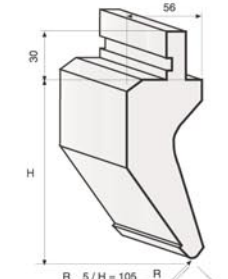
50 T / m

1028/A/88°/0.8



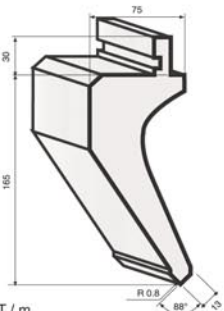
80 T / m

1029/A/85°



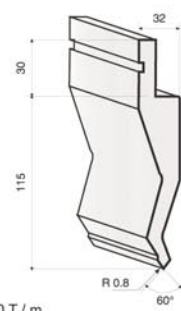
70 T / m

1030/A/88°/0.8



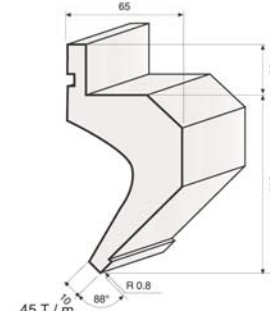
60 T / m

1031/A/60°/0.8



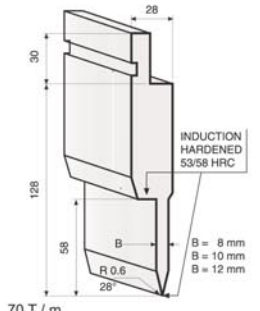
60 T / m

1032/A/88°/0.8



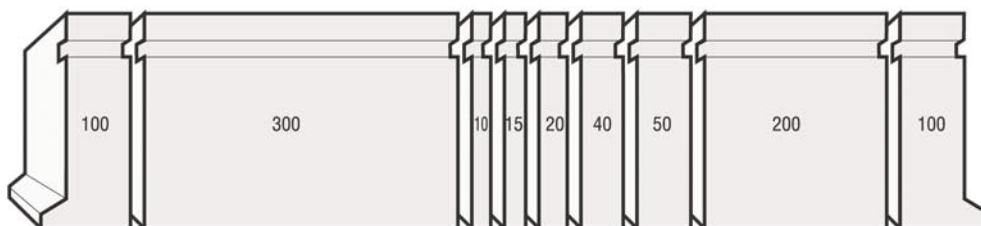
45 T / m

1033/A/28°/0.6



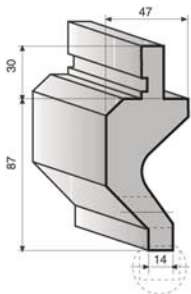
70 T / m

SECTIONS

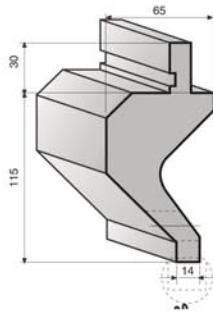




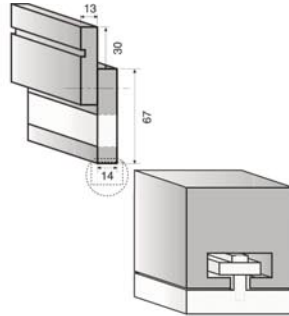
4003



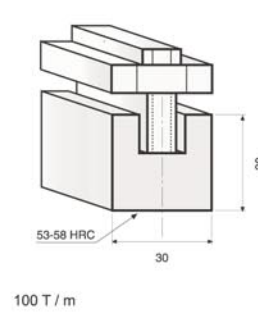
4004



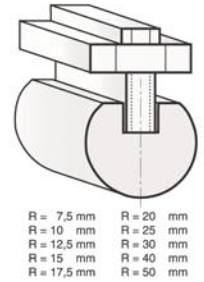
4005



4002



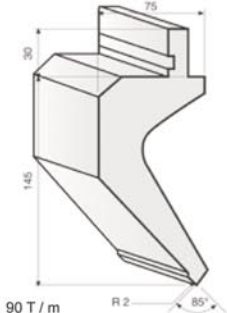
4009R



- R = 7,5 mm
- R = 10 mm
- R = 12,5 mm
- R = 15 mm
- R = 17,5 mm
- R = 20 mm
- R = 25 mm
- R = 30 mm
- R = 40 mm
- R = 50 mm

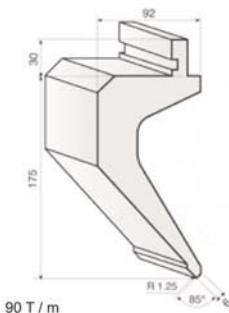
100 T / m

1034/A/85°/2



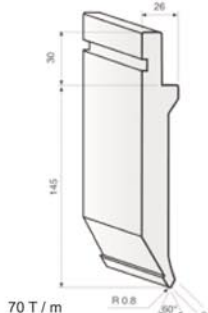
90 T / m

1035/A/85°/1.25



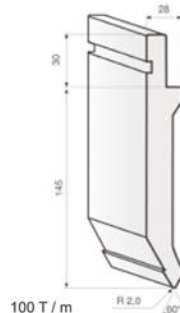
90 T / m

1036/A/60°/0.8



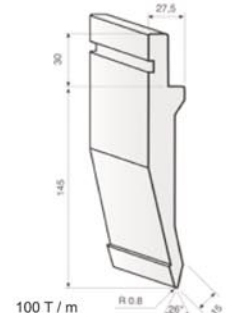
70 T / m

1037/A/60°/2



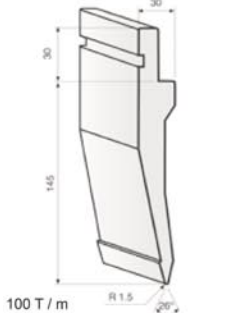
100 T / m

1038/A/26°/0.8



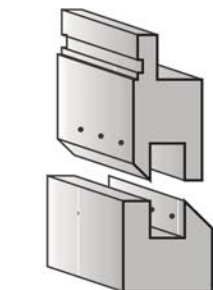
100 T / m

1039/A/26°/1.5



100 T / m

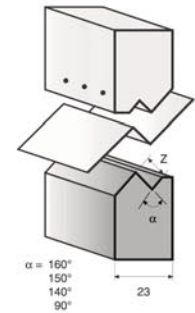
3006



100 T / m

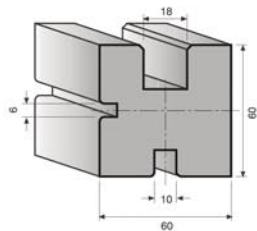
3007

| 3007 | Z (mm) | 3007 | Z (mm) |
|------|--------|------|--------|
| 160j | 1,0    | 90j  | 5,0    |
| 160j | 1,5    | 90j  | 5,5    |
| 150j | 2,0    | 90j  | 6,0    |
| 140j | 2,5    | 90j  | 6,5    |
| 90j  | 3,0    | 90j  | 7,0    |
| 90j  | 3,5    | 90j  | 7,5    |
| 90j  | 4,0    | 90j  | 8,0    |
| 90j  | 4,5    |      |        |



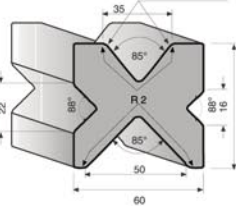
α = 160°  
150°  
140°  
90°

2008



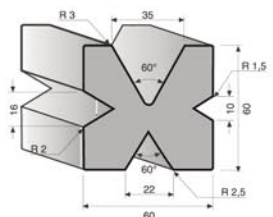
100 T / m

2009



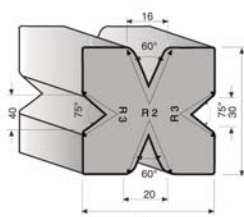
100 T / m

2009/60°



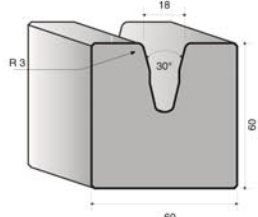
80 T / m

2009 SPEC



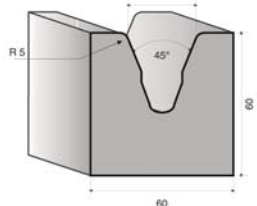
30 T / m

2011/A/18/30°



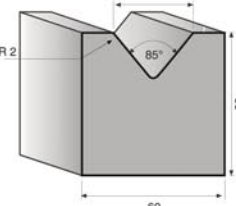
80 T / m

2011/A/32/45°



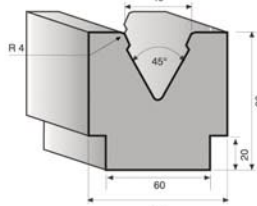
40 T / m

2011/32/85°



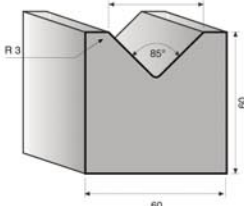
100 T / m

2011/40/45°



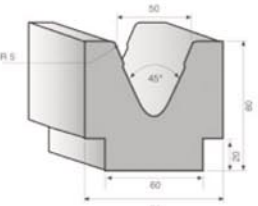
100 T / m

2011/40/85°



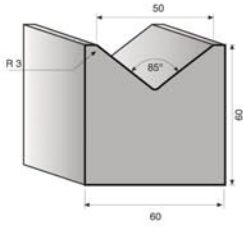
100 T / m

2011/50/45°



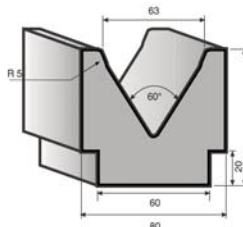
100 T / m

2011/50/85°



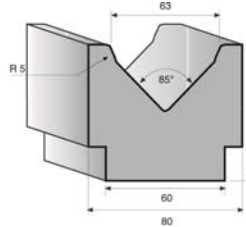
100 T / m

2011/63/60°



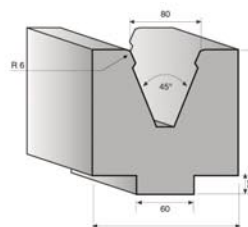
100 T / m

2011/A/63/85°



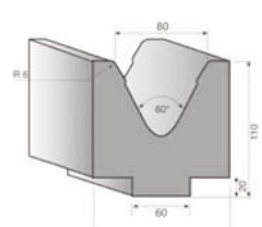
100 T / m

2011/80/45°



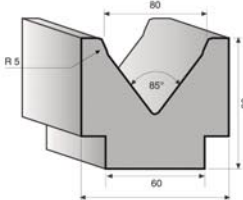
100 T / m

2011/80/60°



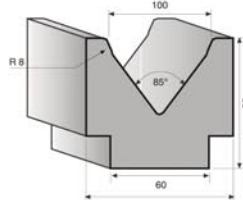
100 T / m

2011/80/85°



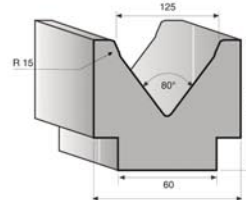
100 T / m

2011/100/85°



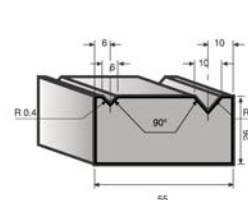
100 T / m

2011/125/80°



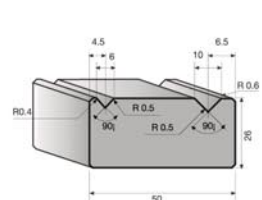
100 T / m

2012/90/88°



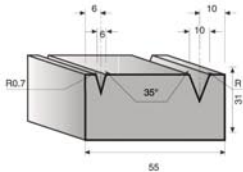
100 T / m

2012/60°



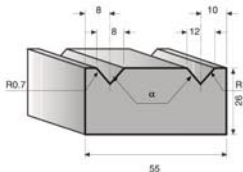
80 T / m

2012/35°



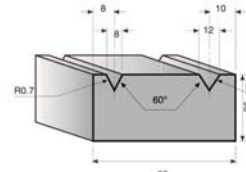
30 T / m

2013/90/88°



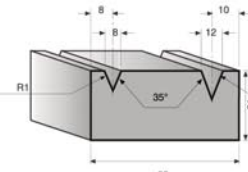
100 T / m

2013/60°



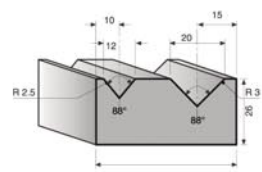
80 T / m

2013/35°



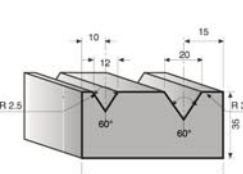
30 T / m

2014/88°



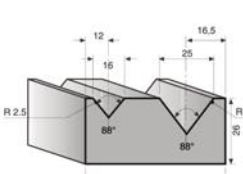
100 T / m

2014/60°



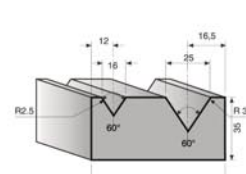
80 T / m

2015/88°



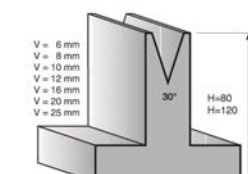
100 T / m

2015/60°



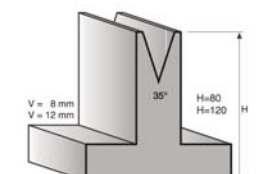
80 T / m

2030/30°



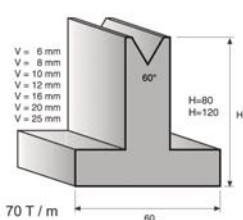
30 T / m

2035/35°



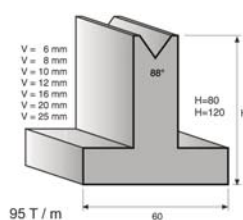
30 T / m

2060/60°



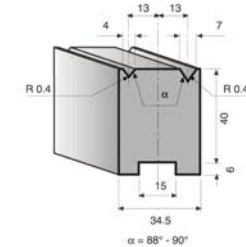
70 T / m

2088/88°



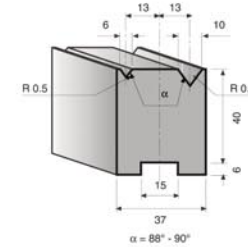
95 T / m

2019



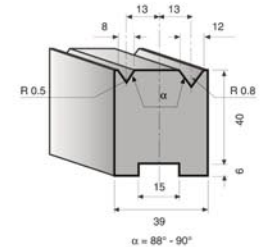
alpha = 88° - 90°

2020



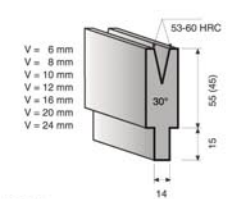
alpha = 88° - 90°

2021



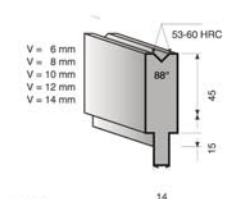
alpha = 88° - 90°

2130/A/30°



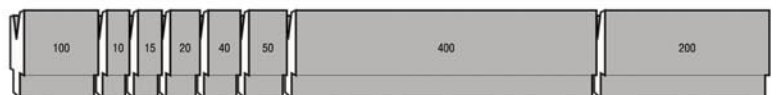
30 T / m

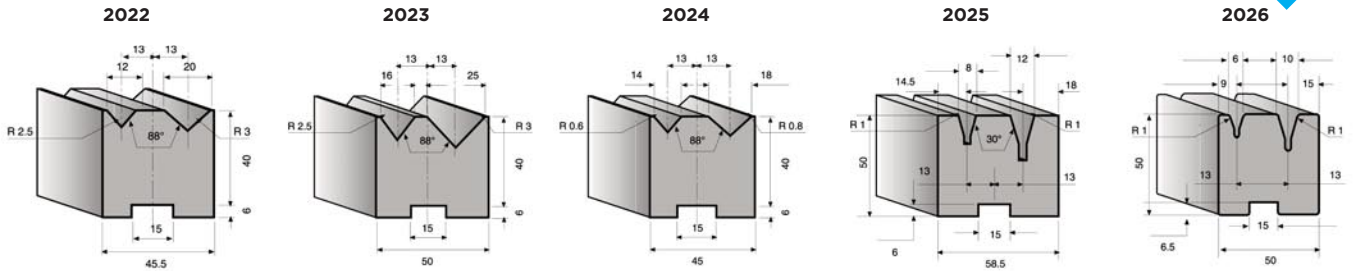
2188/A/88°



95 T / m

SECTIONS

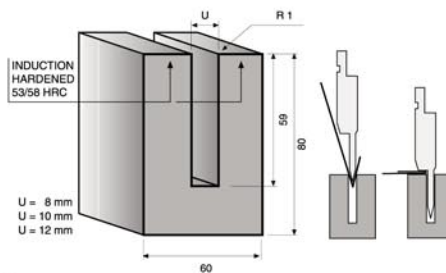




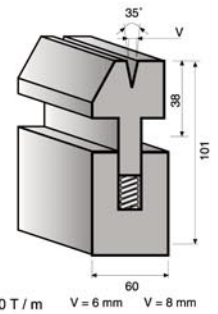
100 T / m  
**BENDING CHART°**  
Acc.R.45 Kg/mm<sup>2</sup>

| 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   |

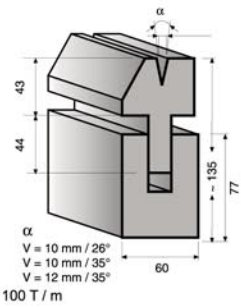
100 T / m  
30 T / m  
**3000**



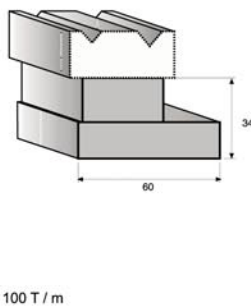
30 T / m  
**3001/35°/B**



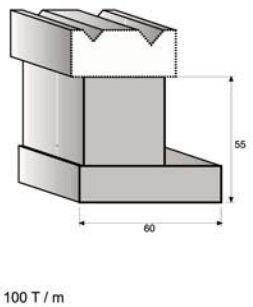
**3001**



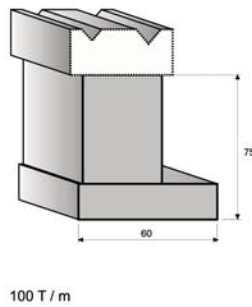
**4006**



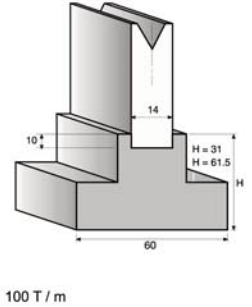
**4007**



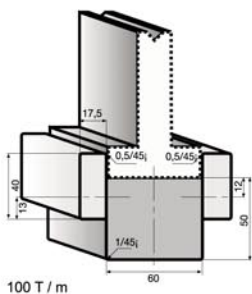
**4008**



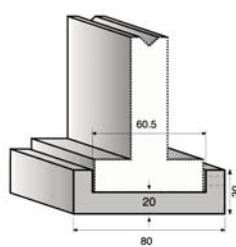
**4017**



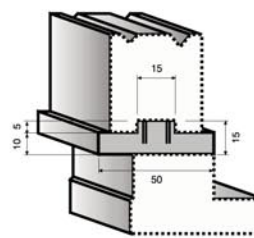
**4018**



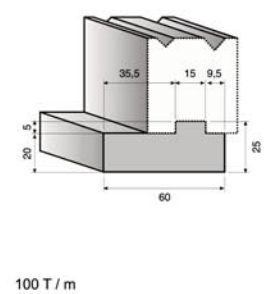
**4016**



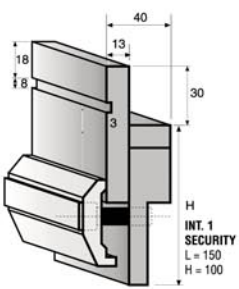
**4010**



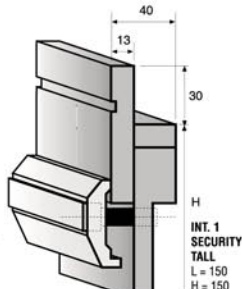
**4011**



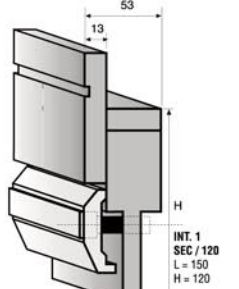
**Int1 Security**



**Int1 Security Tall**



**Int1 Security 120**



**Security Clamps**

