

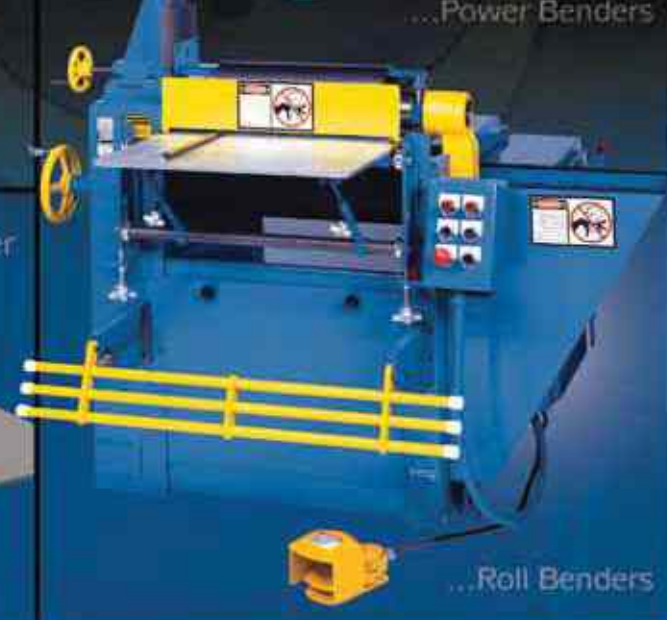
CE Tooling Source Catalog

METAL FABRICATION

Hand & Power Operated Machines for
Precise Metal Forming...



FLIP OVER
FOR THE ACROTECH CATALOG
OF PRODUCTS.



CE TOOLING, INC

DI-ACRO

Manufacturer & Distributor of Fab Tools and
Accessories. Allow us to quote your fab tool needs.
702 736-2958 x4 sales@CEtooling.com

MADE IN THE U.S.A.



COMPANY HISTORY

Di-Acro® Metal Fabrication Equipment

For more than sixty years, Di-Acro® Inc. has served the metalworking industry producing metal fabricating equipment. We've maintained the same traditional craftsmanship and quality on which our reputation was built,

and today we offer a complete line of precision products built on years of experience, to give you every tool you need for metal fabrication.

You'll find Di-Acro® Inc. equipment for punching, cutting, bending and shearing sheet metal. We've designed our tools to let you punch burr-free holes, maintain accurate bends, eliminate part distortion and minimize material waste. You'll find tooling and other metalworking supplies available through our company.

This catalog includes the Di-Acro® line of hand and power operated equipment. These machines have supported both industry and education for many years.

Di-Acro® fabricating machines are being constructed to rigid standards of material and assembly in the time-honored traditions of Di-Acro® craftsmanship. To all our customers, as always, we appreciate your business and value your loyalty and trust.



*All parts and components
used to manufacture Di-Acro®
machines are made entirely
in the U.S.A.*



>Benders

- HAND OPERATED BENDERS
- POWER OPERATED BENDERS
- BENDER TOOLING

>Roll Bending

- ONE PASS ROLL BENDING
- ROLL BENDING ACCESSORIES

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> Hand Operated Metal Forming Machines

- FINGER BRAKES
- SHEARS
- TAB NOTCHER
- ROD PARTER
- SLIP ROLLERS
- PUNCHING SYSTEM

BENDERS

Hand Operated Benders • Models 1 - 1A - 2 - 3 - 4

The **Di-Acro Bender** is a multi-purpose machine that quickly adapts to a variety of bending operations, whether prototype or production. The Hand Bender is available in four models with capabilities of bending up to 1" round mild steel bar with a radius of 0 - 12". The Model 4 Bender features a selectable ratchet drive mechanism for increased power when working with heavier materials.

STANDARD EQUIPMENT

Each Di-Acro Hand Bender includes:

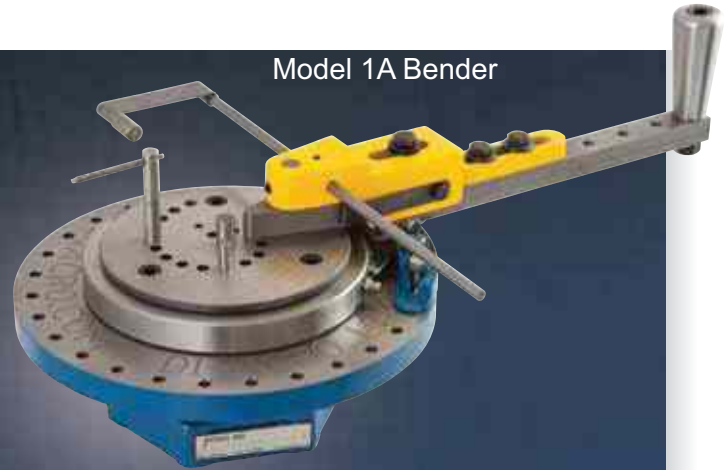
- > **Bend Locating Gauge** allows any number of parts to be identically duplicated.
- > **Angle Stop** precisely determines degree to bend.
- > **Locking Pin** securely clamps material to ensure safety and accuracy.
- > **Center Pin** provides one radius setup plus mount for additional tooling.
- > **Holding Pin** holds material in place to provide accurate bends.

OPTIONAL EQUIPMENT

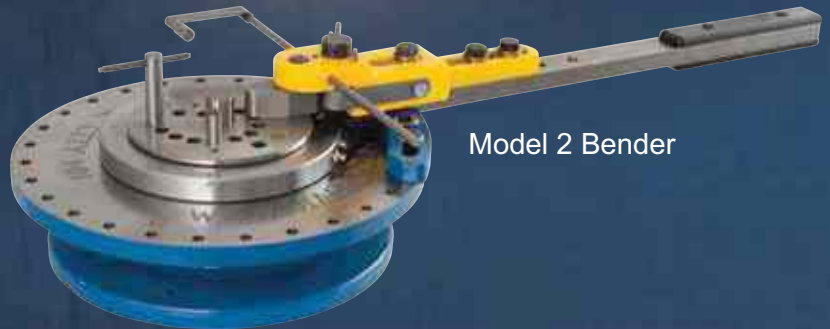
- > **Extension Handles** (Models 2 & 3 only).
- > **QuickLok Clamp** invaluable for production; quickly locks material securely in place and instantly releases for removal.
- > **Stand**- heavy duty with work shelf.
- > **Bend-R-Pak**- an assortment of commonly used tools; specially selected for each model of Di-Acro Bender. (see page 5).

Model 1 Bender
(not shown)

Model 1A Bender



Model 2 Bender



Model 3 Bender

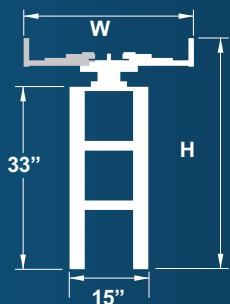


Model 4 Bender



Space requirements including optional floor stand:

	W" x H"
Model 1&1A:	32" x 43.25" (813mm x 1098mm)
Model 2:	56" x 42.25" (1422mm x 1073mm)
Model 3:	82" x 42.25" (2083mm x 1073mm)
Model 4:	78" x 42.25" (1781mm x 1073mm)



SPECIFICATIONS

Model	1	1A	2	3	4
Maximum radius capacity	2" (50.8mm)	6" (152.4mm)	9" (228.6mm)	12" (304.8mm)	12" (304.8mm)
Height of std. forming nose	.50" (12.7mm)	.75" (19.1mm)	1" (25.4)	1.5" (38.1)	1.5" (38.1)
Center pin hole diameter	.375" (9.525mm)	.5" (12.7)	1" (25.4)	1" (25.4)	1" (25.4)
Operating leverage	8" (203.2mm)	16" (406.4mm)	29" (736.6)	40" (1016)	40" (1016)

MATERIAL CAPACITIES

Model	1	1A	2	3	4
Round mild steel bar	.1875" (4.7625mm)	.3125" (7.9mm)	.5" (12.7mm)	.625" (15.9mm)	1" (25.4mm)
Square mild steel bar	.125" (3.175mm)	.25" (6.4mm)	.375" (9.5mm)	.5" (12.7mm)	.75" (19.1mm)
Steel tubing – 16 ga.	.3125" (7.9375mm)	.5" (12.7mm)	.75" (19.1mm)	1" (25.4mm)	1.25" (31.8mm)
Standard iron pipe	–	–	.3 IPS (9.5mm)	.5IPS (12.7mm)	1IPS (25.4mm)
Flat steel bar easy way	.125 x .75 (3.17x19.05)	.1875x1 (4.8x25.4)	.25x1.5 (6.4x38.1)	.25x2 (6.4x50.8)	.375x4 (9.5x101.6)
Flat steel bar hard way	.0625x.50 (1.5875x12.7)	.125x.50 (3.2x12.7)	.125x75 (3.2x19.1)	.125x1 (3.2x25.4)	.25x1 (6.4x25.4)
Machine shipping weight	22 lbs (10 kg)	60 lbs (27 kg)	90 lbs (41 kg)	220 lbs (27 kg)	270 lbs (27 kg)
Stand shipping weight	–	75 lbs (34 kg)	75 lbs (34 kg)	75 lbs (34 kg)	75 lbs (34 kg)

OPTIONAL BEND-R-PAK ASSORTMENTS FOR HAND AND POWER BENDERS

Bend-R-Pak 1	Bend-R-Pak 1A	Bend-R-Pak 2
.1875" radius pin;	.1875" radius pin	.1875" radius pin
.5" radius collar	.5" radius pin	1" radius collar
zero radius block	1" radius collar	1.75" radius collar
.5" square block	zero radius block	zero radius block
grooved radius collar–style B (.375" OD tubing to a 1" radius)	.625" radius pin	.6875" radius pin
clevis clamp .375" OD tubing	grooved radius collar–style B (.5" OD tubing to a 1.25" radius)	grooved radius collar (for .75" OD tubing to a 2" radius)
follow block for .375" OD tubing–6" length	clevis clamp for .5" OD tubing	clevis clamp for .75" OD tubing
forming roller	follow block for .5" OD tubing–6" length	follow block for .75" OD tubing–9" length
scroll collar	forming roller	forming roller
	scroll collar	scroll collar with scroll pin

Bend-R-Pak 3	Bend-R-Pak 4
.1875" radius pin	.1875" radius pin
1.5" radius collar	.625" radius pin
2.75" radius collar	2.75" radius collar
zero radius block	zero radius block
.625" radius pin	grooved radius collar (for .75" OD tubing to a 2" radius)
grooved radius collar (for .75" OD tubing to a 2" radius)	clevis clamp for .75" OD tubing
clevis clamp for .75" OD tubing	follow block for .75" OD tubing– 9" length
follow block for .75" OD tubing– 9" length	forming roller
forming roller	
scroll collar with scroll pin	

Typical bending capacity for all Di-Acro benders, (based on mild steel).

SOLID BAR– Smallest radius is equal to the diameter of the bar.

TUBING– Smallest centerline radius is equal to 2-1/2 times the tube diameter.

TYPICAL BENDS INCLUDE:

- CENTER EYE BENDING
- TUBE BENDING
- CHANNEL BENDING, FLANGES OUT
- EDGEWISE BENDING

TOOLING



Built Up Forming Nose
For forming wider materials with higher collars.



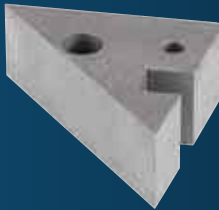
Quill Radius Pin Used with standard Locking Pin; for forming lighter material to a larger radius.



Shoulder Radius Pin Used with standard Locking Pin; for forming solid material to a larger radius.



Radius Block
- Used with standard Locking Pin; for forming solid material to a tight radius.



Grooved Forming Roller
- Used with Quick-Lok Clamp for forming larger radius in tubular stock.



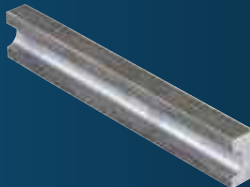
Radius Collar Style B - Used with standard Locking Pin; for forming solid material.



Forming Roller
Replaces Forming Nose to eliminate part marking or back up for Follow Block to reduce drag.



Follow Block
Used with Grooved Radius Collar for tube bending.



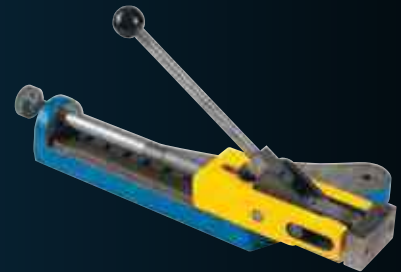
Clamp Block Used with Quick-Lok Clamp for tube bending.



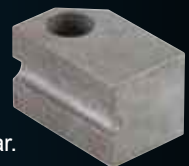
Groove Radius Collar Style A - Used with Quick-Lok Clamp, Clamp Block and Follow Block, or Grooved Forming Roller or Clevis Clamp for tube bending.



Quick-Lok Clamp - Recommended for use with Style A Radius Collar and Clamp Block for tube bending.



Swivel Clamp A simple clamping device for 1A Bender only with Style B Grooved Radius Collar.



Clevis Clamp A single clamping device used with Grooved Radius Collars.



POWER BENDER

Power Operated Benders • Model 6 and Model 8

The **Di-Acro Power Bender** is a hydraulically operated unit that can be configured for a variety of bending operations. The base machine is capable of accepting both Model 6 and Model 8 setups.



Model 6 Bender

- CENTER EYE BENDING
- TUBE BENDING
- CHANNEL BENDING, FLANGES OUT
- EDGEWISE BENDING

A wide range of standard tooling options are available for bending various shapes of tubing, angle, channel as well as flat stock, round stock and round tubing. Features four adjustable stops to allow bends with varying degrees to be progressively made. Modernized controls aid operator safety, improve reliability and provide programmable bends as a standard feature.

PLC controlled bending improves reliability, repeatability, and reduces set up time. The new control package includes an ergonomically positioned two-hand safety switch for added operator safety. An encoder and adjustable "home" position proximity switch provides manual/auto selection with a programmable function. Also included is a "real time" bend angle display and parts counter.

The Di-Acro power bender uses the proven and robust rack and pinion design to rotate the tooling head. The head is actuated with the larger, now standard 4" bore cylinder. The self-contained hydraulic power unit with larger 10 gallon reservoir provides additional cooling. A variable volume, pressure-compensated vane pump provides volume control for bending speed. A double solenoid directional valve replaces the manual valve for improved reliability and repeatability.

STANDARD EQUIPMENT

Angle control with 4 stops (not shown). <

Material length gauge (not shown). <

Electrical equipment conforms to JIC Electrical Standards for general purpose machine tools.

Hydraulic cylinder with 4" bore produces < 3,500 ft/lbs (4,745 joules) for higher capacity.

OPTIONAL EQUIPMENT

Optional tooling shown on page 5. <

SPECIFICATIONS

Model	6 Power	8 Power
Maximum radius capacity	9" (229mm)	24" (610mm)
Maximum degree of bend	280°	360°
Hydraulic pressure	1,000 psi (70kg/cm ²)	1,200 psi (70kg/cm ²)
Motor	3 hp.	3 hp.
Wiring (specify)	208, 230, 460 volts, 3 phase, 60 Hz	208, 230, 460 volts, 3 phase, 60 Hz
Torque (4" cylinder)	3,500 ft. lbs. (4745 joules)	3,500 ft. lbs. (4745 joules)
Machine shipping weight	1,150 lbs / 522 kg	1,150 lbs / 522 kg
Material Capabilities		
Round mild steel bar	.625" (16mm)	1" (25.4mm)
Steel tubing – 16 ga.	1.25" OD (32mm)	1.5" OD (38mm)
Standard iron pipe	.75" IPS (14mm)	.1" IPS (42mm)
Flat steel bar (easy way)	.25" x 2" (6mm x 51mm)	.375" x 4" (9mm x 101mm)
Flat steel bar (hard way)	.25" x 1" (6mm x 25mm)	.375" x 1" (9mm x 25mm)

NO 6 BENDER SETUP

Model 6 Setup - For bending **TUBING, ANGLE AND CHANNEL** Includes clamps and pressure roller assembly as basic tooling for tube bending.



Crush Bend Tooling can be designed for both 6 POWER and 8 POWER benders.

No. 6 Bender Tooling

- > **Standard Grooved Radius Collar** For bending round tubing. Used with Clamp Block and Follow Block.
- > **Crush Bend Tooling For Round and Square Tubing** - Crush bend tooling is used primarily for bending thin wall tubing to a tight radius. If it is not necessary for the formed section to retain its original shape, such as in structural components, the tubing can be purposely distorted with this tooling. The "crush" on the inside radius adds more strength to the bend, as well as allowing a tight radius with controlled distortion in the bend area.



Standard Grooved Collar for bending round tubing. Used with Clamp Block and Follow Block.



Optional bender tooling can be found on page 5 & 6.



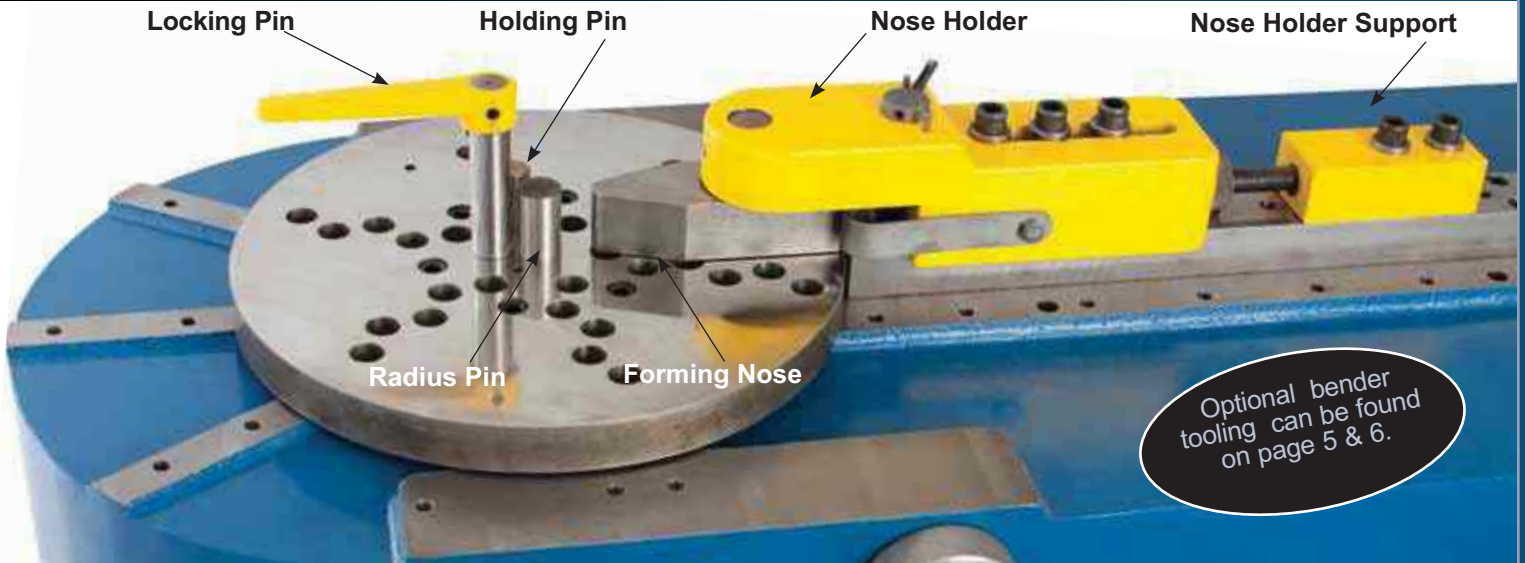
Space requirements:

W" x D" x H"

Model 6 & 8: 54.5" x 21.75" x 40"
(1384mm x 552mm x 1016mm)

NO 8 BENDER SETUP

Model 8 Setup - For bending **SOLID STOCK**. Especially suitable for bending **eyebolts with centered or off-centered eye bends in one operation.**



No. 8 Bender Tooling

- > **Built Up Forming Nose** -Forms wider materials with special high collars.
- > **Radius Block** -For forming solid materials to a tight radius. Requires a standard locking pin to hold material.
- > **Radius Collar** -Forms solid stock to larger radii. Requires standard locking pin to hold material.
- > **Forming Roller** -Replaces forming nose to eliminate part marking.
- > **Radius Pins** -Shoulder Radius Pin is used for forming solid materials to a larger radius. A Quill Radius pin is used for forming light material to a tight radius. Both pins require a standard locking pin to hold material in place.



Square Crush Bending Tooling.

FINGER BRAKES

Hand Operated Finger Brakes • Model 24 - Model 36

Di-Acro Finger Brakes add speed and precision to the forming of boxes, chassis and related shapes in sheet metal. Di-Acro Finger Brakes are adjustable to enable precision bending by compensating for material thickness and hardness. Box Fingers segments enable the operator to form boxes from 0.75" up to the full width capacity of the machine in increments as small as 0.25".

Finger Brakes are available in forming widths of 24" and 36".

STANDARD EQUIPMENT

> **Box Fingers (brake die steel).**

Model 24 includes:

- 2 box fingers @ 0.75"
- 2 box fingers @ 1.0"
- 2 box fingers @ 1.25"
- 2 box fingers @ 3.0"
- 2 box fingers @ 6.0"

Model 36 includes:

- 2 box fingers @ .75"
- 2 box fingers @ 1.0"
- 2 box fingers @ 1.25"
- 2 box fingers @ 3.0"
- 4 box fingers @ 6.0"

> **Two adjustable stops that control angle bend.**

> **Micro back gauge.**

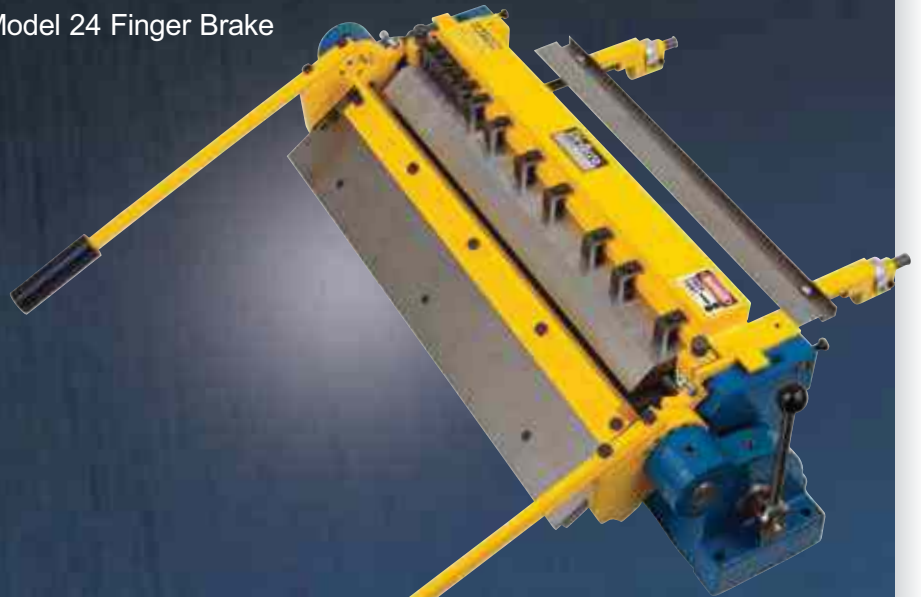
> **Zero radius of standard fingers.**

Call for quote on 1/16" and 1/8" radius fingers

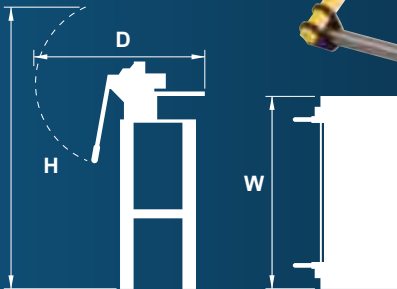
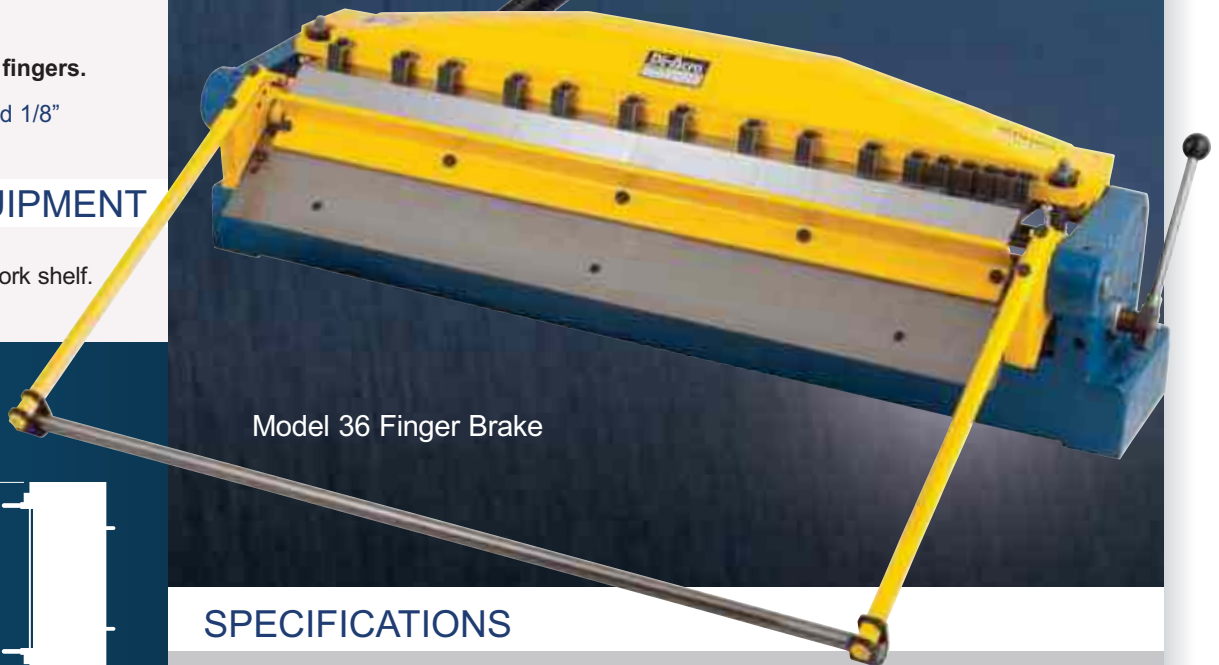
OPTIONAL EQUIPMENT

> **Stand-** heavy duty with work shelf.

Model 24 Finger Brake



Model 36 Finger Brake



Space requirements including optional floor stand:

W" x D" x H"

Model 24: 38" x 37" x 60"
(965mm x 940mm x 1524mm)

Model 36: 49" x 38" x 47"
(1245mm x 965mm x 1194mm)

SPECIFICATIONS

Model	24	36
Maximum capacity, mild steel	16 ga. (1.5mm)	16 ga. (1.5mm)
Maximum forming width	24" (609.6mm)	36" (914.4mm)
Clearance through top opening	1" (25.4mm)	—
Maximum depth of box or pan	3" (76.2mm)	3" (76.2mm)
Minimum reverse bend	.25" (6.4mm)	.25" (6.4mm)
Maximum angle bend (one operation)	135°	135°
Maximum back gauge adjustment	24" (609.6mm)	24" (609.6mm)
Machine shipping weight	325 lbs / 147 kg	470 lbs / 213 kg
Stand shipping weight	100 lbs / 45 kg	140 lbs / 63 kg

HAND SHEARS

Hand Operated Shears Model 12 - Model 24

Di-Acro Hand Shears offer precision shearing at an economical price. They utilize overdriven leverage and are ideal for precision fabricating of smaller parts.

Model 12 Hand Shear



Model 24
Hand Shear



Hand Shears are available in cutting widths of 12" and 24".

STANDARD EQUIPMENT

Both models include:

Combination material hold-down bar and safety guard.

Side squaring gauge and reversible protractor gauge.

Micro back gauge.

Adjustable stops for blade control when slitting or notching.

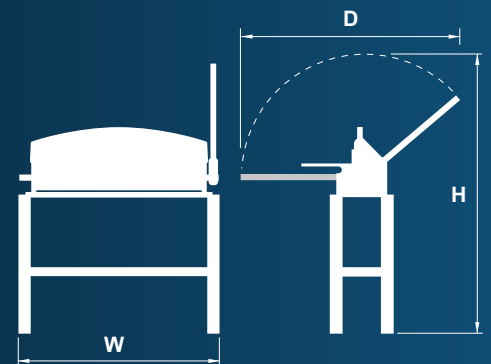
Set of four-edged HCHC tool steel blades.

Ruled steel guides and adjustable protractor gauge for squaring and mitering.

Two blade stops for slitting operations.

OPTIONAL EQUIPMENT

Stand- heavy duty with work shelf.



Space requirements including optional floor stand:

W" x D" x H"

Model 12: 24" x 45" x 69"
(609.6mm x 1143mm x 1760.6mm)

Model 24: 33" x 45.25" x 71"
(838mm x 965mm x 1803mm)

SPECIFICATIONS

Model	12	24
Maximum capacity, mild steel	16 ga. (1.5mm)	16 ga. (1.5mm)
Maximum shearing width	12" (304.8mm)	24" (609.6mm)
Range of back gauge	12" (304.5mm)	12" (304.5mm)
Machine shipping weight	168 lbs / 76 kg	290 lbs / 132 kg
Stand shipping weight	100 lbs / 45 kg	140 lbs / 63 kg

NOTCHER/ROD PARTER

Hand Operated Tab Notcher Model No.2

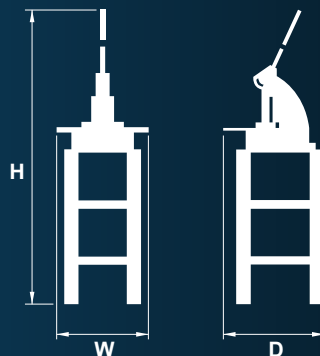
The **Di-Acro Tab Notcher** provides an economical means for cutting notches up to 6" x 6" in 16 gauge mild steel. The machine offers adjustable upper and lower blades for making tabs or regular notches. Tabs up to one inch are provided for adjustment. In chassis production, overlapping tabs can be easily spot-welded to produce finished boxes.

STANDARD EQUIPMENT

- > 12" x 24" work table with adjustable scales.
- > Adjustable self-squaring gauges.
- > HCHC steel notcher blades with reversible cutting edges.

OPTIONAL EQUIPMENT

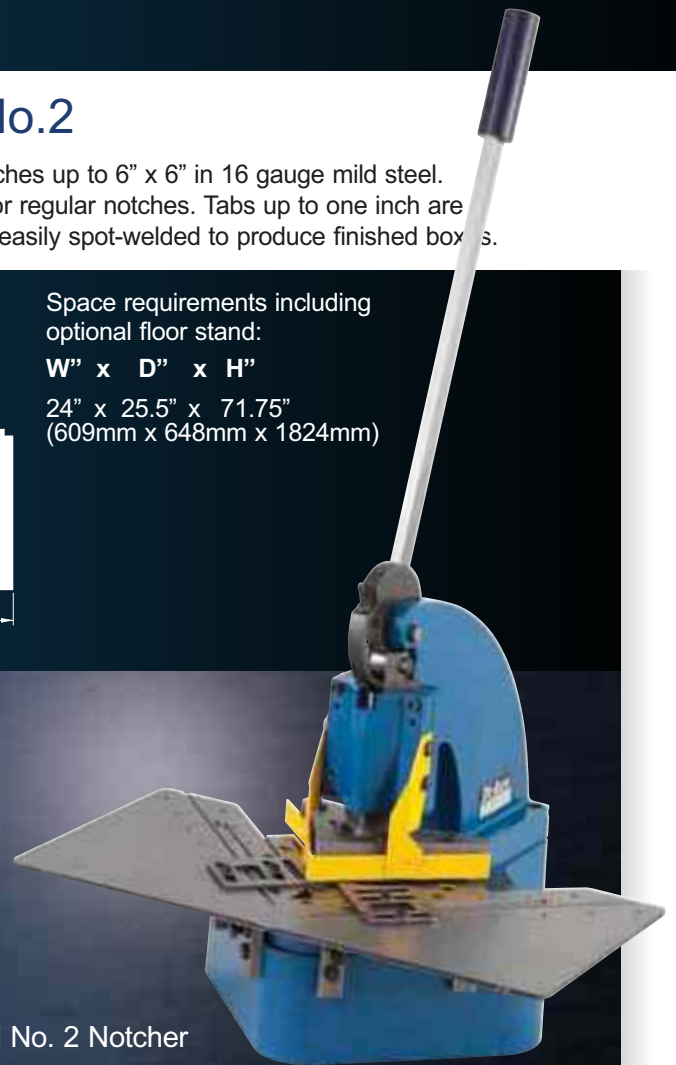
- > Stand- heavy duty with work shelf.



Space requirements including optional floor stand:

W" x D" x H"

24" x 25.5" x 71.75"
(609mm x 648mm x 1824mm)



Model No. 2 Notcher

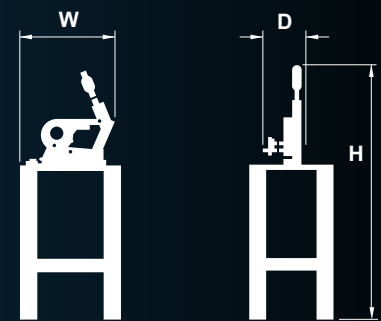
SPECIFICATIONS

Model No. 2	
Maximum capacity, mild steel	16 ga. (1.5mm)
Maximum 90° notch; one operation	6" x 6" (152mm x 152mm)
Maximum tab	1" (25.4mm)
Tonnage	4 lbs. (3.6 kg)
Stroke of ram	.625" (16mm)
Machine shipping weight	265 lbs / 120 kg
Stand shipping weight	70 lbs / 32 kg

Hand Operated Rod Parter Model No.2

The **Di-Acro Rod Parter** is a simple and efficient tool for cutting bar stock. This precision machine actually "parts off" rather than cuts, employing a combination shearing-breaking action. This operation leaves material burr-free, and with no further processing required. Hard materials such as cold rolled steel and hard aluminum offer the best "parting" action. Properly hardened and ground alloy steel cutting heads assure a high degree of accuracy. Heads are reversible for double service, easily removed for sharpening and easily replaced. The Di-Acro Parter has 9 holes from .125" to .0625" increments. All holes are .005" oversize.

Heads are reversible for double service, easily removed for sharpening and easily replaced. The Di-Acro Parter has 9 holes from .125" to .0625" increments. All holes are .005" oversize.



Space requirements including optional floor stand:

W" x D" x H"

16" x 32" x 75"
(406mm x 813mm x 1905mm)

STANDARD EQUIPMENT

- > Two standard cutting dies.

OPTIONAL EQUIPMENT

- > **Special heads** -.015" oversized for cutting hot rolled, hex, square and rectangular stock.
- > **Stand**- heavy duty with work shelf.

SPECIFICATIONS

Model No. 2	
Maximum capacity, CRS bar	.625" (16mm)
Cutting head thickness	1" (25.4mm)
Machine shipping weight	65 lbs / 29.5 kg
Stand shipping weight	60 lbs / 27 kg

Model No. 2 Rod Parter



SLIP ROLLERS

Hand Operated Slip Rollers • Model 12 - Model 24

Di-Acro Slip Rollers feature a cam-actuated idler roller which permits the operator to locate bends at any point along a sheet of material with straight sections on one or both ends. The idler roller always returns to its present position, allowing duplication with a high degree of accuracy. Calibrated rear roller indicators enable the operator to quickly adjust the machine when changing from one rolling size to another. Small circles, approximately the same diameter as the forming rolls, can be produced in one operation. Circles of any larger diameter can be formatted in just two passes through the rolls.



Model 12 Slip Roller

Model 24 Slip Roller

STANDARD EQUIPMENT

Both models include:

Calibrated rear roll indicators enable the operator to quickly adjust the idler roll to any previous setting.

Rollers are made from TGP Steel.

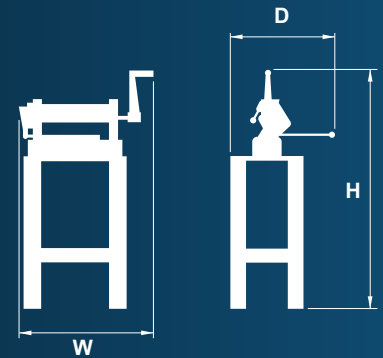
OPTIONAL EQUIPMENT

Stand- heavy duty with work shelf.

800-345-0583

www.diacro.com

Fax: 651-345-3759



Space requirements including optional floor stand:

W" x D" x H"

Model 12: 25" x 22" x 58"
(635mm x 559mm x 1473mm)

Model 24: 34" x 22" x 58"
(864mm x 559mm x 1473mm)

SPECIFICATIONS

Model	12	24
Maximum capacity, mild steel	16 ga. (1.5mm)	20 ga. (.9mm)
Maximum forming width	12" (304.8mm)	24" (609.6mm)
Diameter rolls	2" (50.8mm)	2" (50.8mm)
Minimum radius	1" (25.4mm)	1" (25.4mm)
Maximum radius	no limit	no limit
Machine shipping weight	116 lbs / 53 kg	170 lbs / 77 kg
Stand shipping weight	90 lbs / 41 kg	95 lbs / 43 kg

PUNCHING SYSTEM

Hand Operated Punching System Model No.2

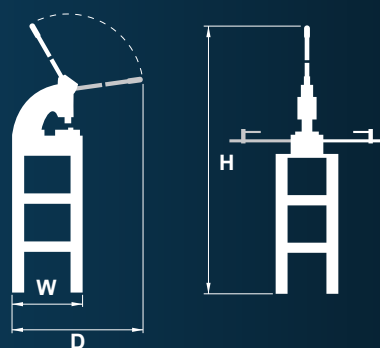
The **Di-Acro Model No. 2 Punching System** covers all your basic punching needs. This single station machine punches holes of various shapes and sizes up to 1.5" in 16 gauge mild steel. Adjustable side and back gauges allow precision gauging for exact duplication.

STANDARD EQUIPMENT

- > **Stripper arm and plates.**
- > **Punch holder** for punches with .5" diameter shank.
- > **Style "C" die holder with "A & B" adapter.**
- > **Side and back gauges.**

OPTIONAL EQUIPMENT

- > **A, B, C, D or E die holders.**
- > **Stand**- heavy duty with work shelf.



Space requirements including optional floor stand:

W" x D" x H"

16" x 32" x 75"
(406mm x 813mm x 1905mm)



Model No. 2 Punching System

SPECIFICATIONS

Model No. 2	
Maximum punch capacity	1.5" (38mm) diam. in 16 ga. (1.5mm) m.s.
Maximum punch size	4" (101.6mm)
Tonnage	4 lbs. (3.6 kg)
Throat depth	12" (304.8mm)
Throat height	3" (76mm)
Stroke of ram	.625" (15.9mm)
Diameter hole in ram	1" (25.4mm)
Machine shipping weight	350 lbs / 159 kg
Stand shipping weight	95 lbs / 43 kg

Punch Tooling – 901 Series

Di-Acro Punches and Dies will accommodate W.A. Whitney presses that use No. 2 and 28 Whitney tooling. The 901 Series also fits Roper Whitney presses that utilize No. 8 and 28 tooling. This series will comply with many types of punching equipment of other manufacturers.

Di-Acro Single Station Punches & Dies

Di-Acro single station tools are designed for use in Di-Acro single station punch presses No. 1 and No. 2.

Twin Shear - All punches requiring more than 4 tons to punch 16 gauge mild steel (13/16" round or equivalent irregular size) are ground with twin shear. Twin shear reduces necessary power about 50%. Punches 13/16" or larger are also available without twin shear. Consult our factory for pricing.

Center Point - All single station punches from 1/8" and up are provided with a centering point. This feature is best suited for accurate layout work or hole location. Additional charge to remove center point.

Clearance - Single station punches and dies are provided with a standard clearance of .007" - .008" (15% of 16 ga. material). Smaller clearances can be supplied at an additional cost.

Blanking Dies - In operations where the slug must be retained, Di-Acro can furnish the punch and die set to your specifications. For blanking, the punch is ground flat.

Di-Acro Single Station Punches are manufactured in two styles:

Punch No. 2 - Made to a maximum of 1/2" round, or a shape that is within the perimeter of 1/2".

Punch No. 4 - Made to a maximum of 1/2" to a maximum of 4" round, or a shape that is within the perimeter of 4" diameter.

Di-Acro Punches and Dies are available for Adjustable Die Sets and also for Hand or Powered Turret Punch Presses.

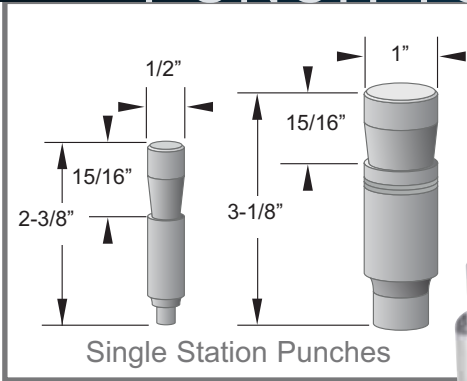
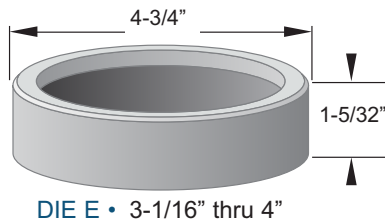
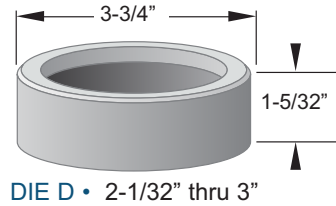
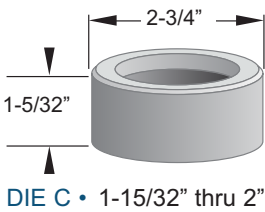
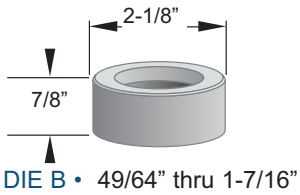
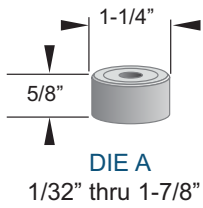
A Punch Pak for the No. 12 and 18 Hand Turret Punch Press is also available:

Pak Part Number 902802-000 includes the following sizes:

1/16", 1/8", 5/32", 3/16", 7/32", 1/4", 5/16", 3/8", 7/16", 1/2", 5/8", 3/4", 13/16", 7/8", 15/16", 1", 1-1/4" and 1-1/2" diameter.

PUNCH TOOLING

Single Station Dies

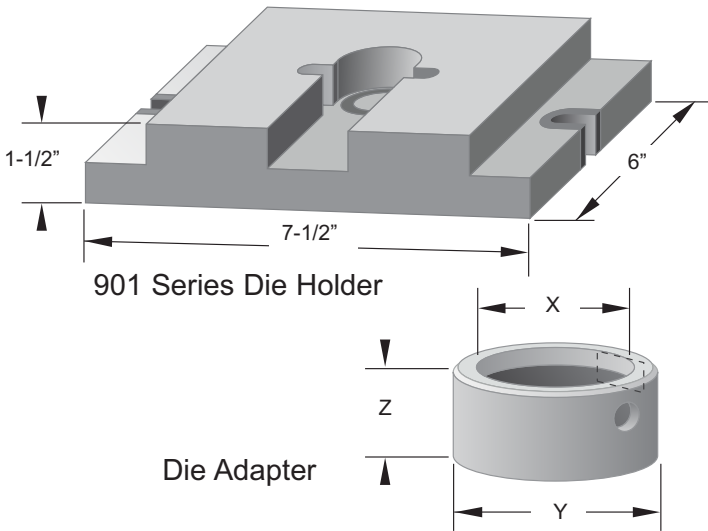


Single Station Punch Paks - 901 Series Punch paks are assortments of commonly-used punches and dies stored in plastic containers. These punch paks eliminate production delays and save lost time looking for the right sizes or having to order special.



Punch Pak No. 1 - Contains 30 sizes of round punches and dies, 3/64" through 1/2" in increments of 1/64".
Catalog Part Number..... 901802-001

Punch Pak No. 2 - Contains 8 rounds, in sizes 1/16" through 1/2" in increments of 1/16"; 12 rounds, in sizes 1/2" through 2" in increments of 1/8"; 4 squares, in 1/2", 5/8", 3/4" and 1".
Catalog Part Number..... 901802-002



Di-Acro Die Holders The die holder is mounted on either the No. 1 or No. 2 Di-Acro punch press, and is available in sizes to accommodate the five die styles. Certain die holders with large inside diameters will utilize dies with a smaller outside diameter if fitted with the proper adapter.

Die Holder Style	Catalog Part No.	Bore in Holder	Accommodates Die Style
A	8140150-270	1-1/4"	A
B	8240150-270	2-1/8"	B
C	8040150-270	2-3/4"	C
D	8340150-270	3-3/4"	D
E	8440150-270	4-3/4"	E

Die Holder Style	Catalog Part No.	X	Y	Z	Fits Die Holder
A	8040150-375	1-1/4"	2-3/4"	1-5/32"	C
B	8000150-375	2-1/8"	2-3/4"	1-5/32"	C

Strippers

Stocked in 90A Durometer



Di-Acro 902 Series Strippers are designed for direct use in Di-Acro Hand Turret Punches, as well as the VT-19P, VT-19S, and VT-19 NC equipped with 903 style Turrets.

Station	I.D.	Part No.	Price
A	3/8"	902-1508001	\$11.30
A	3/4"	902-1508002	11.80
B	1"	902-1508003	16.20
B	1-1/2"	902-1508004	16.20
A	5/8"	902-1508005	13.20
A	3/4"	902-1508006	13.20
B	1"	902-1508007	18.70
B	1-1/2"	902-1508008	18.70

Di-Acro 906 Series Strippers are manufactured specifically for the VT-19P, VT-19S, and VT-19 NC and the VT-36 NC equipped with the 906 style Turrets.

Station	I.D.	Part No.	Price
B	3/8"	906-1508001	\$11.30
B	3/4"	906-1508002	11.80
C	3/8"	906-1508003	16.20
C	3/4"	906-1508004	16.20
C	1"	906-1508005	13.20
D	1-3/8"	906-1508006	13.20
E-F	2-1/4"	906-1508007	23.65

ROLL BENDING

Roll Bending Machines

Acrotech/Di-Acro also manufactures a line of One Pass Roll Bending Machines. If you have large-volume needs for complete or partial cylinders with little or no flats on the ends, our machines will produce your parts quickly and cleanly. This includes polished materials containing large cutouts or perforations!

If you rolled parts sporadically or in small quantities, Acrotech/Di-Acro will custom roll them for you!

For a quote, contact one of our machine engineers or inquire at:

www.acrotechinc.com • www.diacro.com

If you would like to see our machines in action, call us for a DVD or check out the video on our web site!



The Benefits of "One Pass" Two Roll Bending Machines

Cylinders in one pass!

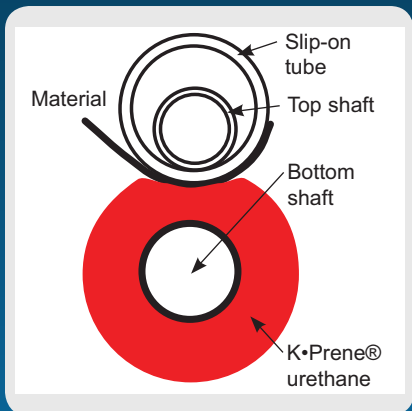
- > **Roll parts with a minimum of flat on the leading and trailing ends** for easier welding and better looking parts.
- > **Increase production** and lower costs because there is no preforming required.
- > **Roll perforated and other difficult materials** without fluting or kinking. Roll prefinished materials (stainless, aluminum, prepaint, etc.) without damaging parts.
- > **Easy set up and operations** with excellent repeatability and quick tooling changes.
- > **Auto loading.**
- > **Additional operator protection** (light curtains).
- > **Special Hi alloy snap** for larger diameter to length ratios.

The Two Roll Principle

Under pressure, the top steel roll acts as a rotary punch penetrating the bottom roll. The bottom roll, a steel shaft coated with **K•Prene® urethane** acts as a female die, wrapping the material around the top roll.

Rotation of both rolls produces accurate

curving and rolling of complete or partial cylinders in one pass!



Our smaller **models the 1212, 1618, and 1824** are built to meet the demands of production involving small, light gauge parts. Pneumatic lock-up is standard on all models for increased productivity. 120V 1PH standard wiring simplifies installation. 220 or 440V 3PH wiring is also available.

ROLL BENDING

SPECIFICATIONS

Model	Capacity mild steel		Working length of rolls		Diameter of top roll		Diameter of bottom roll		Rolling speed f.p.m.		
	Std.	Metric	Std.	Metric	Std.	Metric	Std.	Metric	hp.		
1212	12 ga.	2.7mm	30" 762mm	3-1/2"	88.9mm	9"	229mm	22	670.6	CMPM	1.0
1618	16 ga.	1.5mm	30" 762mm	3-1/2"	88.9mm	6"	152mm	15	457.2	CMPM	1.0
1824	18 ga.	1.2mm	30" 762mm	3-1/2"	88.9mm	6"	152mm	15	457.2	CMPM	1.0
LD-1418	14 ga.	1.9mm	18" 457mm	3-1/2"	88.9mm	9"	229mm	23.2	707.1	CMPM	1.5
LD-1118	11 ga.	3.1mm	18" 457mm	4"	102mm	9"	229mm	23.2	707.1	CMPM	1.5
LD-1224	12 ga.	2.7mm	24" 610mm	4"	102mm	9"	229mm	23.2	707.1	CMPM	1.5
LD-31618	3/16"	4.8mm	18" 457mm	5"	127mm	9"	229mm	19.8	603.5	CMPM	3.0
LD-1024	10 ga.	3.4mm	24" 610mm	5"	127mm	9"	229mm	19.8	603.5	CMPM	3.0
LD-1230	12 ga.	2.7mm	30" 762mm	5"	127mm	9"	229mm	23.2	707.1	CMPM	1.5
HD-31624	3/16"	4.8mm	24" 610mm	6"	152mm	12"	305mm	16.0	487.7	CMPM	5.0
HD-1030	10 ga.	3.4mm	30" 762mm	6"	152mm	12"	305mm	19.5	594.4	CMPM	3.0
HD-1236	12 ga.	2.7mm	36" 914mm	6"	152mm	12"	305mm	19.5	594.4	CMPM	3.0
HD-31630	3/16"	4.8mm	30" 762mm	7"	178mm	12"	305mm	16.0	487.7	CMPM	5.0
HD-1036	10 ga.	3.4mm	36" 914mm	7"	178mm	12"	305mm	16.0	487.7	CMPM	5.0
HD-1248	12 ga.	2.7mm	48" 1220mm	7"	178mm	12"	305mm	19.5	594.4	CMPM	3.0
HD-31636	3/16"	4.8mm	36" 914mm	8"	203mm	12"	305mm	16.0	487.7	CMPM	5.0
HD-1048	10 ga.	3.4mm	48" 1220mm	8"	203mm	12"	305mm	16.0	487.7	CMPM	5.0
HD-1160	11 ga.	3.1mm	60" 1520mm	8"	203mm	12"	305mm	16.0	487.7	CMPM	5.0
HD-1672	16 ga.	1.5mm	72" 1830mm	8"	203mm	12"	305mm	22.9	698.0	CMPM	1.5
V-1006	10 ga.	3.4mm	6" 152mm	4"	102mm	8"	203mm	22.0	6.68	CMPM	0.75

Every model in Acrotech/Di-Acro's unique line of Two Roll Bending Machines is designed and built for production and precision. These machines will roll a variety of materials and configurations into cylinders with virtually no flats on the ends!



LD and HD Models

Designed for the production of larger, heavier gauge parts. The drop arm and the lower roll are positioned pneumatically on all LD machines and hydraulically on the HD models. Standard features adding to the productivity and safety of these machines include:

- 1) A digital readout that indicates roll position and allows for quick repeat set up.
- 2) A safety kneebars which can be easily activated to quickly shut down all mechanical operations.



Model V-1006

The model V-1006 has cantilevered rolls mounted in a vertical position. This unique design allows the parts to simply drop from the machine at the end of the rolling cycle, greatly increasing productivity. Its short, sturdy rolls are ideally suited for narrow parts such as clamps, brake bands, hole saws, light fixtures, etc.

800-345-0583

www.diacro.com

Fax: 651-345-3759

ACCESSORIES

Roll Bending Accessories

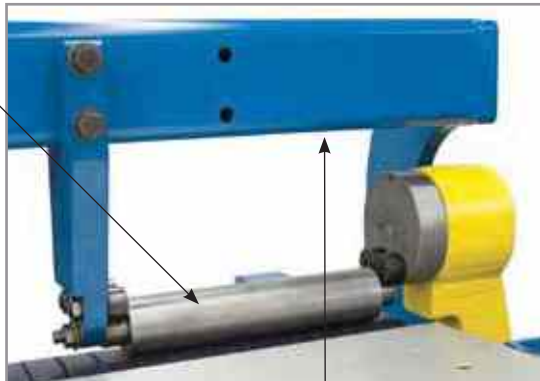


Slip-on tubes When the diameter required is larger than what the top shaft will produce, a slip-on-tube is used. The tubes are developed per part size and increase the forming diameter capability of the top shaft. Quickly change the tube by simply slipping them on and off the top shaft as needed.

Slip-on tube support This support mechanism prevents slip-on-tubes from pinching your rolled parts against the lower roll at the end of the cycle. It is adjustable to accommodate different tube sizes.

Part Ejectors For increased production, part ejectors and part feeders can be developed for most models.

Small shaft assemblies These are for the production of small diameter parts. There are several standard sizes and custom sizes are possible, depending on requirements.



Note: These shafts require the small OD mounting fixture.

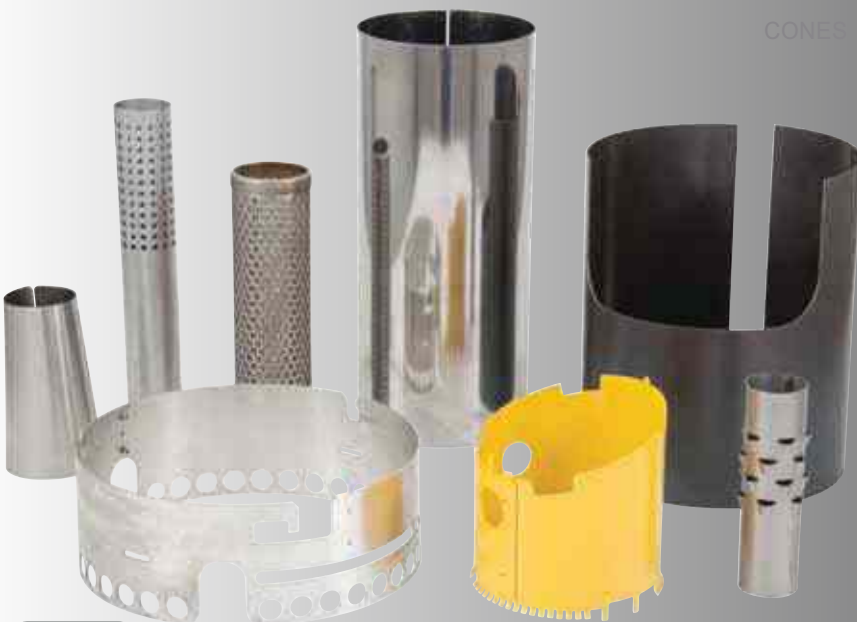


CONES • CUT-OUTS • FLANGES

PERFORATIONS • RIBS

POLISHED OR PRE-PAINTED

In addition to providing rolled samples, Acrotech/Di-Acro offers custom rolling services. We have several machines and a full selection of tooling readily available to provide quality rolled parts in a timely manner. You'll be surprised at how economical custom rolling can be with your One Pass rolling machine. Forget the scheduling headaches and pursue outsourcing your rolled product. Contact Acrotech/Di-Acro for a quotation today.



DI-ACRO POLICIES

Di-Acro Terms, Conditions & Ordering Information

To Order

Indicate the machine model number and quantity.
For machine owners with no manuals, please call us.
We'll be happy to supply one free-of-charge so that you may identify any parts or tooling required.

Terms

Net due 30 days with approved credit, C.O.D., Visa, Master Card, Discover or American Express.

Prices

Call for current machine pricing.
All prices are subject to change without notice.

Return Policy

Machines and tooling are subject to a 20% restock charge. Custom made machines or tooling are non-returnable.

To return, Di-Acro must be notified without 30 days of receipt of machine or tooling. All requests must be confirmed with Di-Acro® before returning. Di-Acro's liability is limited to the purchase price of the goods.

Di-Acro Warranty

Defective parts of a product manufactured by DI-ACRO will be replaced or repaired at no charge for twelve (12) months following delivery to the original purchaser. Labor is included for the first 90 days. This warranty becomes void when products have not been used according to instructions furnished by ACROTECH/DI-ACRO, nor does it cover any altered parts or unauthorized repairs. We cannot be responsible for the cost of repairs made or attempted outside of our factory. All warrant claims are made FOB our plant, providing such items(s) is returned freight prepaid to our plant for examination.

This warranty does not apply to parts, components, or systems not manufactured by DI-ACRO. These products are covered instead by the existing warranties, if any, of their manufacturers. Normal service items with a reasonable life expectancy of less than one year are warranted only to the extent of the reasonable life under normal use and service.

Authorization must be obtained from DI-ACRO before returning parts or equipment to the factory. DI-ACRO will satisfy this warranty by replacing the product or refunding the purchase price upon receipt and inspection of the product.

DI-ACRO's liability under this warranty shall not exceed the amount paid for the product.

THIS IS SOLE WARRANTY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, WHICH ARE HEREBY EXCLUDED, INCLUDING IN PARTICULAR ALL WARRANTIES OF MERCHANTABILITY, FITNESS OR ANY LOSS, DAMAGE OR EXPENSES DIRECTLY OR INDIRECTLY RELATED TO THE USE OF ITS PRODUCTS OR FROM ANY OTHER CAUSE OR FOR CONSEQUENTIAL DAMAGES INCLUDING, WITHOUT LIMITATION, LOSS OF TIME AND LOSS OF PRODUCTION.

IT IS EXPRESSLY UNDERSTOOD THAT DI-ACRO IS NOT RESPONSIBLE FOR DAMAGE OR INJURY CAUSED TO OTHER PRODUCTS, MACHINERY, PROPERTY OR PERSONS BY REASON OF THE USE OF ITS PRODUCTS.