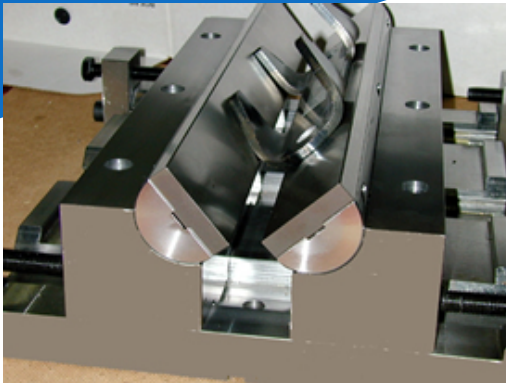




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Section 10p

SOURCE CATALOG FOR

Rolla-V Rotary Bending



CE TOOLING, INC.

Manufacturer & Distributor of Fab Tools and Accessories. Allow us to quote your tool needs.

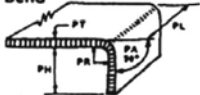
+1 702 736-2958 sales@cetooling.com

- Improve productivity – eliminate secondary operations
- Control distortion of holes and slots near bend lines
- Consistently form short or tapered flanges

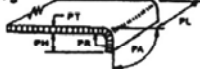
BEND TYPES

Specifiable by
CB# and Part Dims.

Square Bend
CB1



Short Leg
CB2



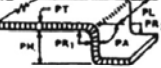
Over Square
CB3



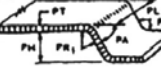
Under Square
CB4



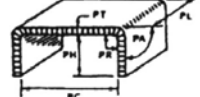
Zee Bend
CB5



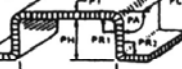
Open Zee
CB6



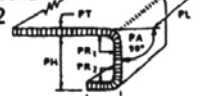
Channel Bend
CB7



Hat Bend
CB8



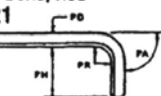
Return Bend
CB12



Large Radius Bend
CB13



Square Bend, Rod
CB21



Proven COST EFFECTIVE on these Applications:

1 MAR-FREE BENDING

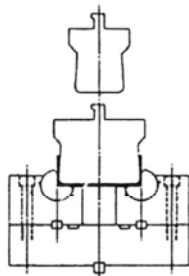
Most dies can be equipped with Delrin® rotors to bend pre-finished and stainless steels without tool marks.

2 BEND SHORT FLANGES

on the ends of large sheets with no part whip-up. Operators run more parts safely with less scrap...even on heavy gauge material.

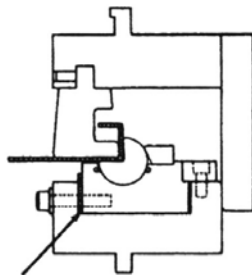
3 ONE-HIT CHANNEL DIES

Adjustable channel die shown.



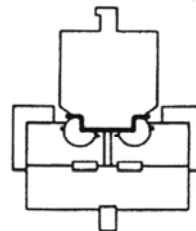
4 QUICK CHANGE DIES

Anvil sections easily changed in the press for special applications.



NOTE: Run different part thicknesses by shimming here.

5 HAT BENDS OR OFFSETS

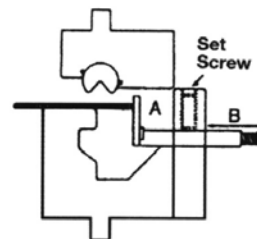


6 BUILT-IN GAGES

or specify clearances for automatic gages.

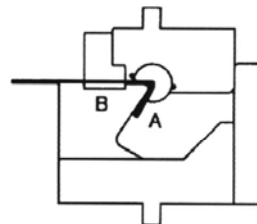
PELICO GAGE SHOWN

- A) Gage rotates as die closes, spring returns gage each time
B) Gage is adjustable.



7 COMPLETE HEMMING DIES

- A) Bend part to 120°
B) Flatten to 180°

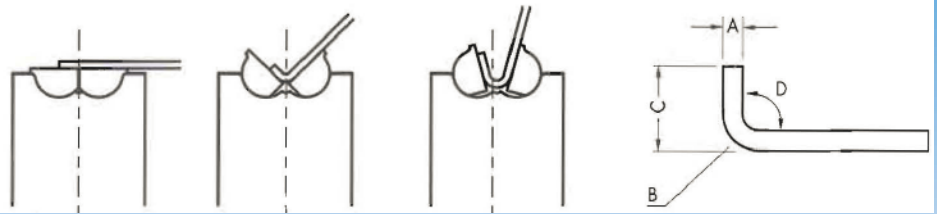


Let us quote your application

Families of parts are often satisfied with one die designed for your needs.

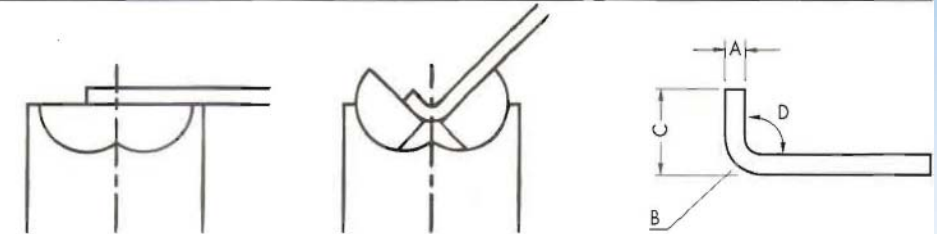
Model 1

- A. Maximum material thickness: 2mm (.079")
- B. Maximum outside radius: 4.5mm (.177")
- C. Minimum outside leg length: 4.7mm (.185")
- D. Maximum bend angle*: 30°
- E. Tonnage capacity 100 t/m (35 tons/foot)



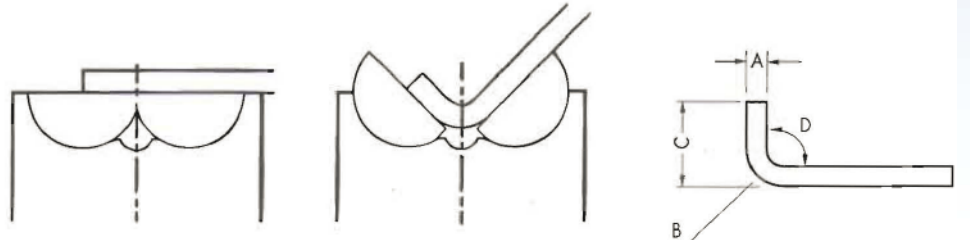
Model 2

- A. Maximum material thickness: 4.0mm (.157")
- B. Maximum outside radius: 8.5mm (.335")
- C. Minimum outside leg length: 8.7mm (.343")
- D. Maximum bend angle*: 45°
- E. Tonnage capacity 150 t/m (50 tons/foot)



Model 3

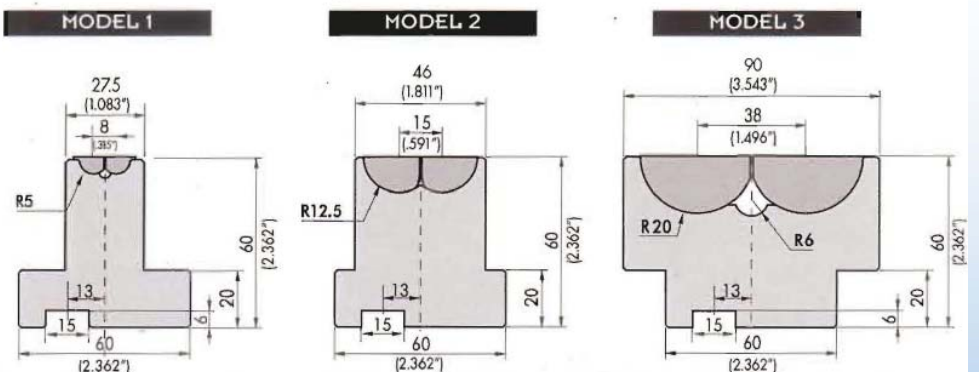
- A. Maximum material thickness: 8.0mm (.315")
- B. Maximum outside radius: 23mm (.906")
- C. Minimum outside leg length: 24.3mm (.957")
- D. Maximum bend angle*: 75° *
- E. Tonnage capacity 250 t/m (84 tons/foot)



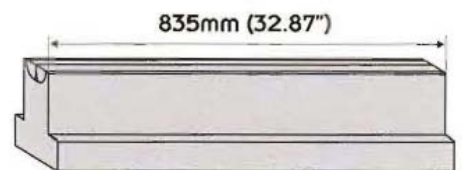
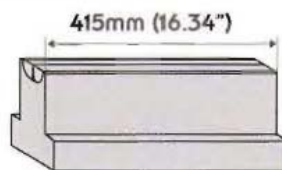
*Maximum bend angles may vary depending on punch tip radius and material thickness. Smaller angles are possible subject to condition. (please contact your sales representative).

RVP60

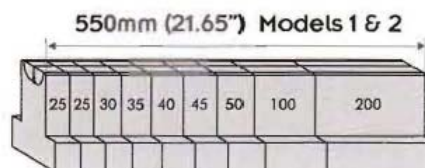
Suitable for most press brakes with Amada/European style fittings or any machine with a flat bed.



Standard lengths for RVP60

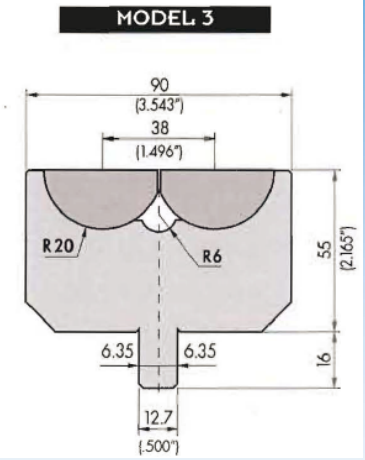
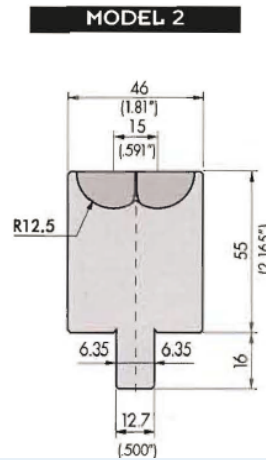
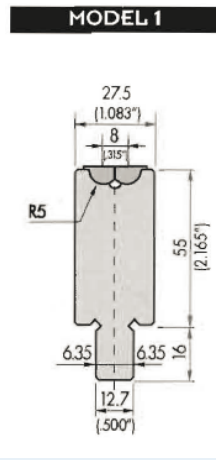


Sectionalized for RVP60



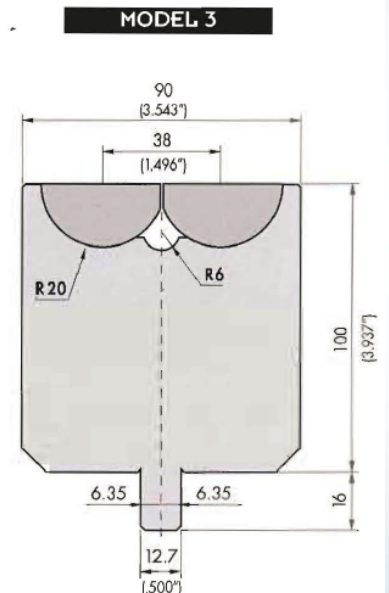
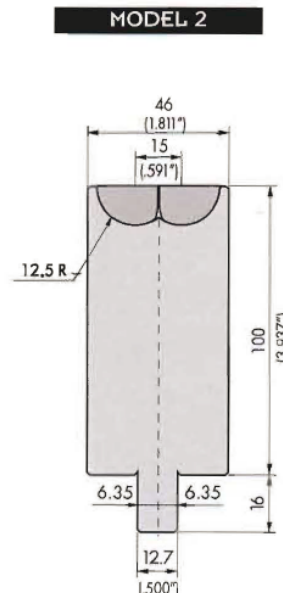
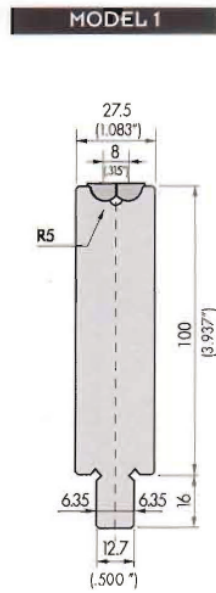
RVT55

Suitable for all press brakes with American style fittings or where the vee is centered above the tang.

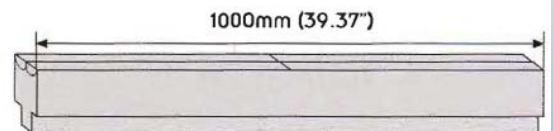
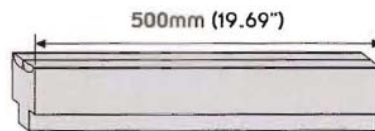


RVT100

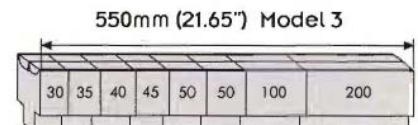
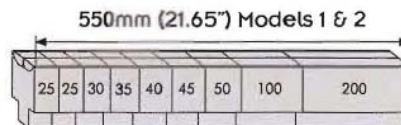
Suitable for all press brakes with American style fittings or where the vee is centered above the tang.



Standard lengths
for RVT55 & RVT100



Sectionalized
for RVT55 & RVT100



RVP3 and RVP4 Adjustable

The RVP3 and the RVP4 are infinitely adjustable to accommodate a wide range of metal thicknesses. As shown in these photos, cut-outs near the bend line and very short flanges are easily handled with little or no distortion.

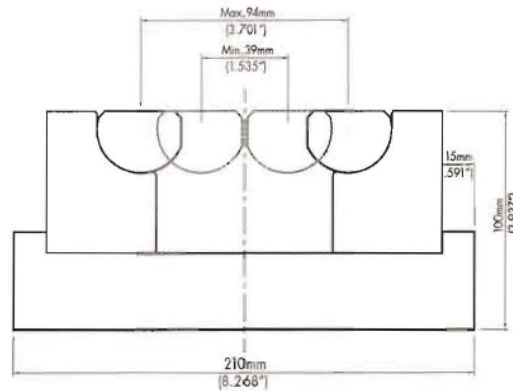
RVP3 Adjustable

Recommended material range = .036" - .500"

Maximum bend angle = 180°

Maximum outside radius at 90° = 1.378"

Standard lengths: 1000mm, 500mm, 200mm



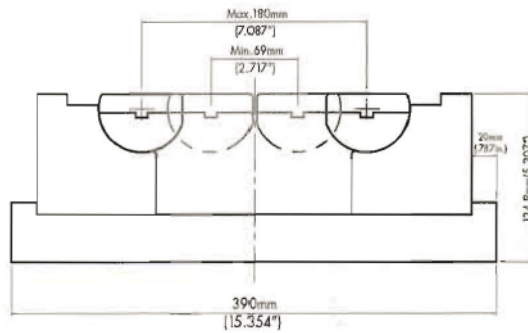
RVP4 Adjustable

Recommended material range = .036" - 1.125"

Maximum bend angle = 180°

Maximum outside radius at 90° = 4.331"

Standard lengths: 1000mm, 500mm, 200mm

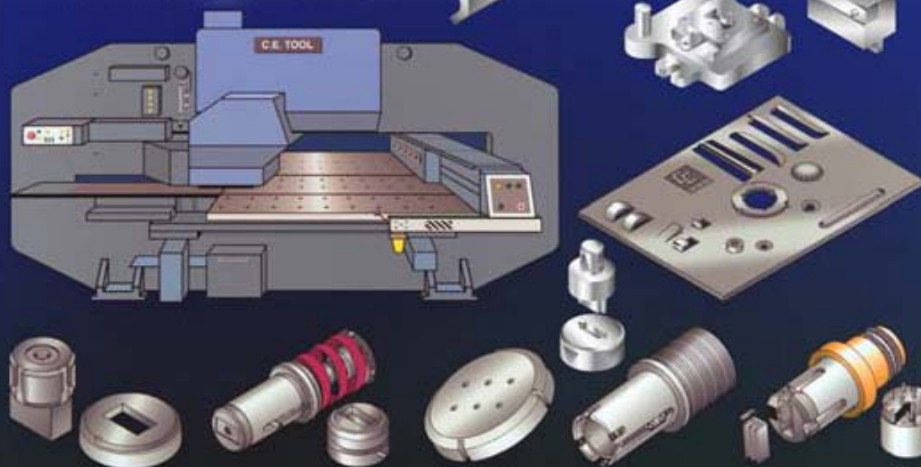


MINIMUM FLANGE GUIDELINES (Outside Dimension)*

MAT THICKNESS	MODEL 1	MODEL 2	MODEL 3	RVP3	RVP4
.039" (1mm)	.185" (4.7mm)	—	—	—	—
.063" (1.6mm)	.213" (5.4mm)	.343" (8.7mm)	—	—	—
.079" (2mm)	.220" (5.6mm)	.386" (9.8mm)	—	—	—
.118" (3mm)	—	.402" (10.2mm)	.957" (24.3mm)	—	—
.157" (4mm)	—	—	1.004" (25.5mm)	—	—
.197" (5mm)	—	—	1.043" (26.5mm)	1.102" (28mm)	—
.394" (10mm)	—	—	—	1.575" (40mm)	1.496" (38mm)
.787" (20mm)	—	—	—	—	3.543" (90mm)
1.181" (30mm)	—	—	—	—	4.724" (120mm)

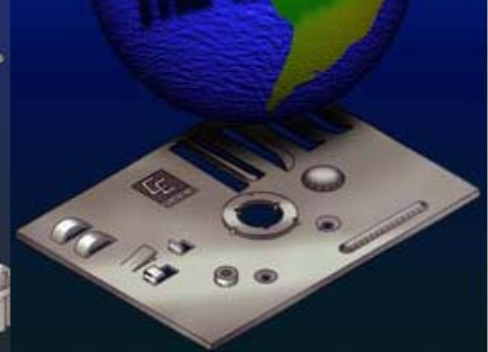
* These dimensions apply when forming Mild Steel and Aluminum. These dimensions increase when forming Stainless Steel.

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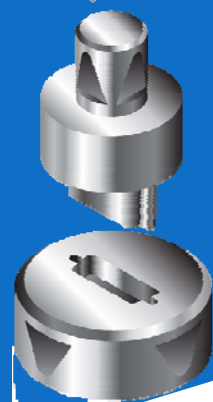
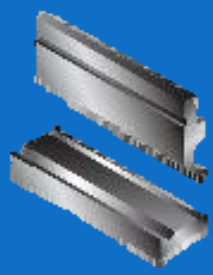
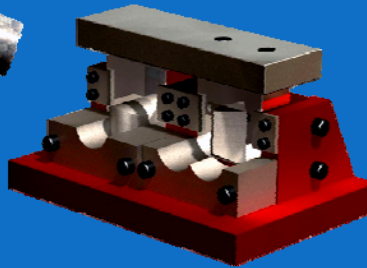
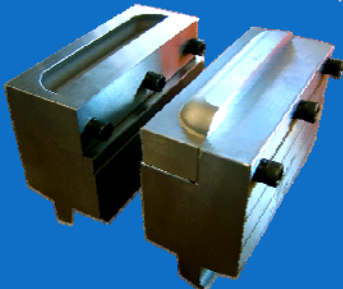
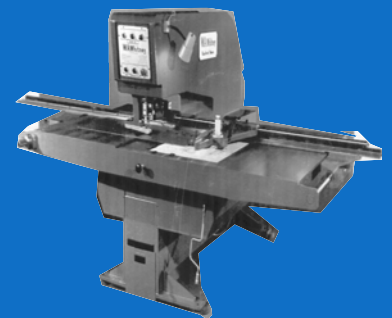
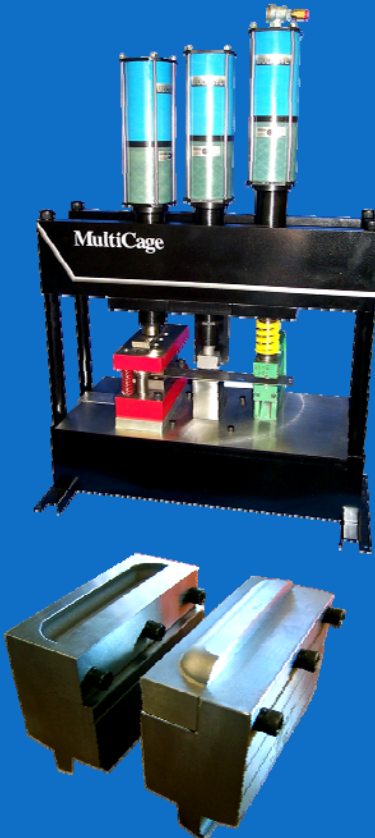
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