EDITION 12

ProgTools
Sweden AB

UKB®

PRESS BRAKE TOOLS

WWW.UKB-GMBH.COM

Tables of force

t Material thickness
F Force/pressure
V Die opening
b Shortest flange
r_i Inside radius
R_m Resistance

1) Air bending

2) Bottoming/coining
The force/pressure F for bottoming/coining is 3 up to 8 times higher than for air bending

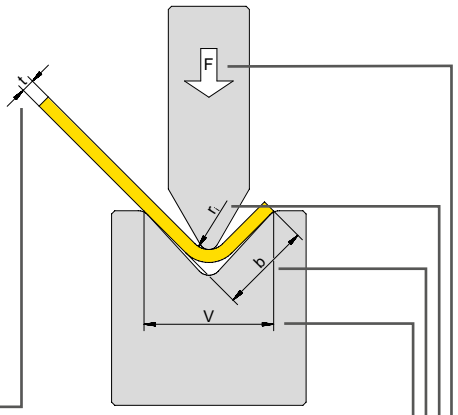


Table of force: needed force for 90° air bending, resistance R_m = 510 N/mm², mild steel

t (mm)	4	5	6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	160	200	V (mm)
	2,8	3,6	4,3	5,7	7,1	8,5	11	14	17	21	28	36	43	50	57	64	71	85,2	114	142	b (mm)
	0,6	0,8	0,9	1,3	1,6	1,9	2,5	3,1	3,8	4,7	6,3	7,8	9,4	11	13	14	15,6	18,8	25	31,3	r_i (mm)
0,5	48	36	28	20																	
0,75	126	92	72	49	37	30															
1	255	184	142	96	71	57	40														
1,25		319	243	162	120	94	65	50													
1,5			383	251	184	143	99	75	60												
1,75			564	366	266	206	140	105	84	64									F in kN/m		
2				510	367	283	191	143	113	86	61										
2,5					638	487	324	239	188	142	100	77	62								
3						765	502	367	287	214	149	114	92	77							
4								734	567	417	286	215	172	143	122						
5									974	708	478	357	283	234	199	173					
6											734	543	428	352	298	258	228				
8													834	679	571	492	431	345	245		
10															956	819	714	567	398	306	
12																	1087	857	597	455	
15																		1434	986	746	
20																				1428	

Scaled, rusted or not oiled up sheet metal will cause a much higher force.

Table of force: needed force for 90° air bending, resistance R_m = 700 N/mm², stainless steel

t (mm)	4	5	6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	160	200	V (mm)
	2,8	3,6	4,3	5,7	7,1	8,5	11	14	17	21	28	36	43	50	57	64	71	85,2	114	142	b (mm)
	0,6	0,8	0,9	1,3	1,6	1,9	2,5	3,1	3,8	4,7	6,3	7,8	9,4	11	13	14	15,6	18,8	25	31,3	r_i (mm)
0,5	66	49	39	27																	
0,75	172	126	98	68	51	41															
1		252	194	131	98	78	55														
1,25			334	222	164	129	90	68													
1,5			525	345	252	197	135	102	82												
1,75				502	364	283	193	145	115	88									F in kN/m		
2					504	389	263	196	156	118	84										
2,5						668	444	328	258	194	137	105	85								
3							689	504	394	294	205	156	126	105							
4									778	572	392	296	236	197	168						
5										972	656	490	389	321	273	238					
6												746	588	483	410	355	312				
8														933	784	675	591	473	336		
10																	980	778	547	420	
12																		1176	819	625	
15																				1024	

PRESS BRAKE TOOLS UKB-SYSTEM AMADA

PRESS BRAKE TOOLS UKB-SYSTEM TRUMPF

PRESS BRAKE TOOLS UKB-SYSTEM WILA

PRESS BRAKE TOOLS UKB-SYSTEM LVD

PRESS BRAKE TOOLS UKB-SYSTEM BYSTRONIC

PRESS BRAKE TOOLS UKB-SYSTEM EHT, UKB-SYSTEM WEINBRENNER AND OTHER SYSTEMS

UKB-HOLDERS FOR BLADES AND BLADES R 0,5 – 6,0

UKB-HOLDERS FOR RADIUS-TOOLS AND RADIUS-TOOLS R 7,0 – 50,0

UKB-Z-TOOL HOLDERS AND Z-TOOL INSERTS Z 1,0 – 15,0

UKB-UNIBEND AND UKB-WINGBEND PLUS

UKB-ADJUSTABLE DIES

UKB-SPECIAL TOOLS

UKB-PROTECTIVE FILM

UKB-MARK FREE AND MARK REDUCED BENDING

UKB-ADAPTORS

UKB-PRESS BRAKE TOOL CABINETS

UKB-ACCESSORIES

UKB-MODIFICATION OF PRESS BRAKE TOOLS

UKB-REPAIR- AND REGRINDING SERVICE

UKB-SHEAR BLADES

UKB-Videos

Image

UKB-Press brake tool systems

UKB-Special tools

UKB-Holders for blades and blades R 0,5 - 6,0

UKB-Holders for radius-tools and radius-tools R 7,0 – 50,0

UKB-Z-Tool holders and Z-Tool inserts Z 1,0 – 15,0

UKB-Clampings SWING / RAPID / CLARK

UKB-Flattening tools

UKB-UniBend and UKB-WingBend PLUS

UKB-Adjustable dies

UKB-Protective film

UKB-Mark free and mark reduced bending

UKB-Press brake tool cabinets

UKB-Accessories

UKB-Modification of press brake tools

UKB-Repair- and regrinding service

UKB®
OUR PRINCIPLE IS PERFECTION!

HIGH QUALITY PRESS BRAKE TOOLS & INDIVIDUAL SPECIAL TOOLS!

As a producer of press brake tools and special tools for almost 30 years we stand for precision, high quality, modern technology and first class know-how.
Working in close cooperation with you, we produce at our modern 5000m² facility high quality press brake tools for fast and economical work processes. Many items can be supplied immediately from our massive storage facility.

UKB GmbH was founded in 1991 and has grown into today's well established, owner-operated company, rooted in Siegerland. We are well known beyond european borders and very proud, to be your expierienced and competend partner for press brake tools. We constantly set new milestones to maintain our industry leading position and provide sustainable growth in our company, our products and our services.

EXPECT THE BEST!

UKB-UWE KRUMM GMBH

Headquarter Burbach / Germany

UKB

UKB-TEAMPLAYER

Qualified and motivated staff!

TECHNICAL INFORMATION:

- CNC-milling machines traverse path:
  X = 6.000 mm
  Y = 1.250 mm
  Z = 1.600 mm
- Simultanious 5-axes machining
- Fully programmable b-axis +- 100°
- Rotary table Ø 1050 mm

CNC-MILLING SHOP

State-of-the-art CNC-milling machines!

TECHNICAL INFORMATION:

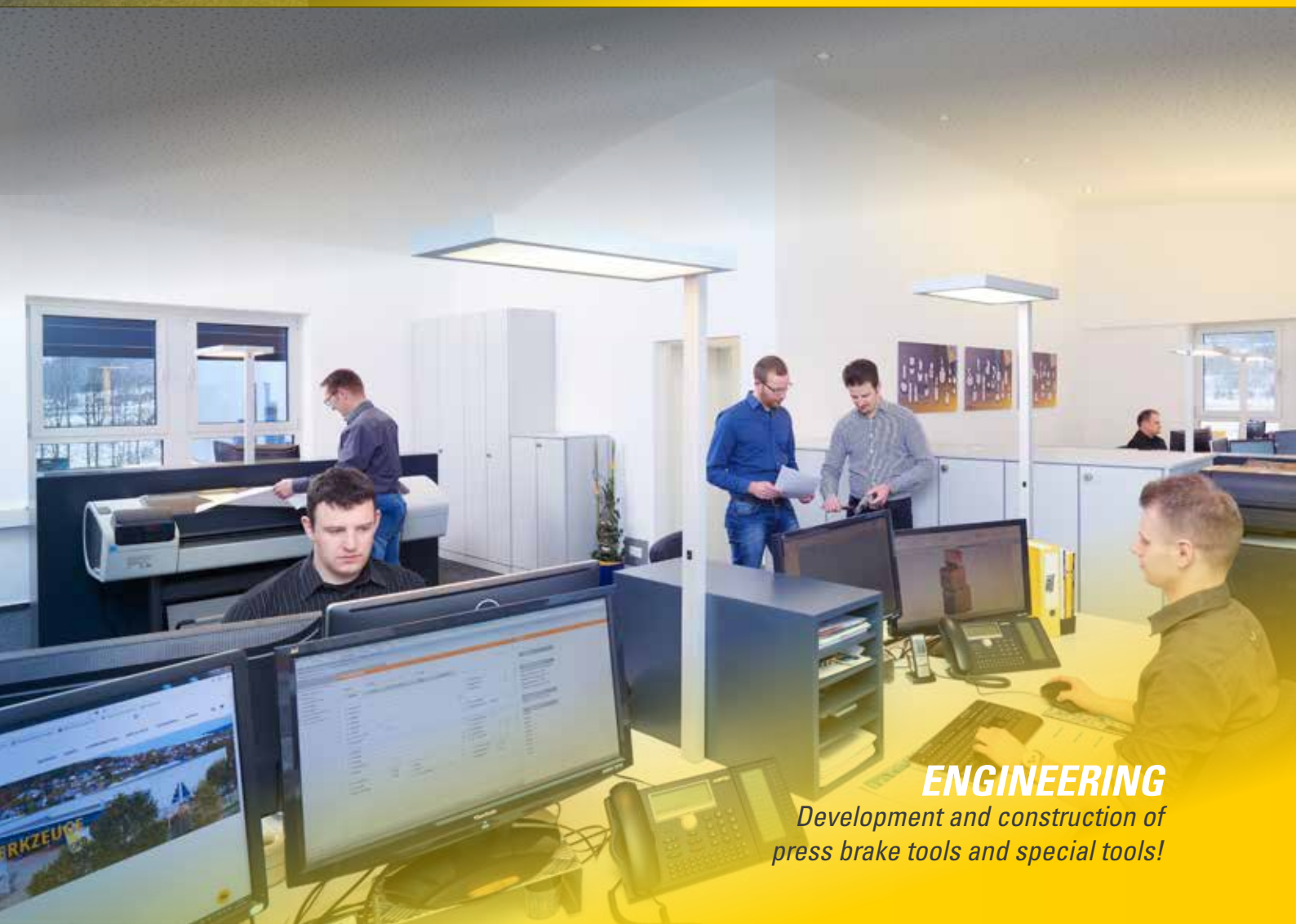
- CNC-profile grinding machines traverse path:
  X = 5.000 mm
  Y = 800 mm
  Z = 700 mm
- Profiling the grinding wheel (by CAM)
- Very high repeatability

CNC-GRINDING SHOP

Always up-to-date with the latest technology!

SALES

Qualified and customer-oriented!



ENGINEERING

Development and construction of press brake tools and special tools!

FIELD SERVICE

Committed and close to the customer!

STOCK

Extensive range of tools
fast availability!

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VU 0,55 x 152	200	10.323	146	11.311	146
VU 0,8 x 102	199	10.324	146	11.312	146
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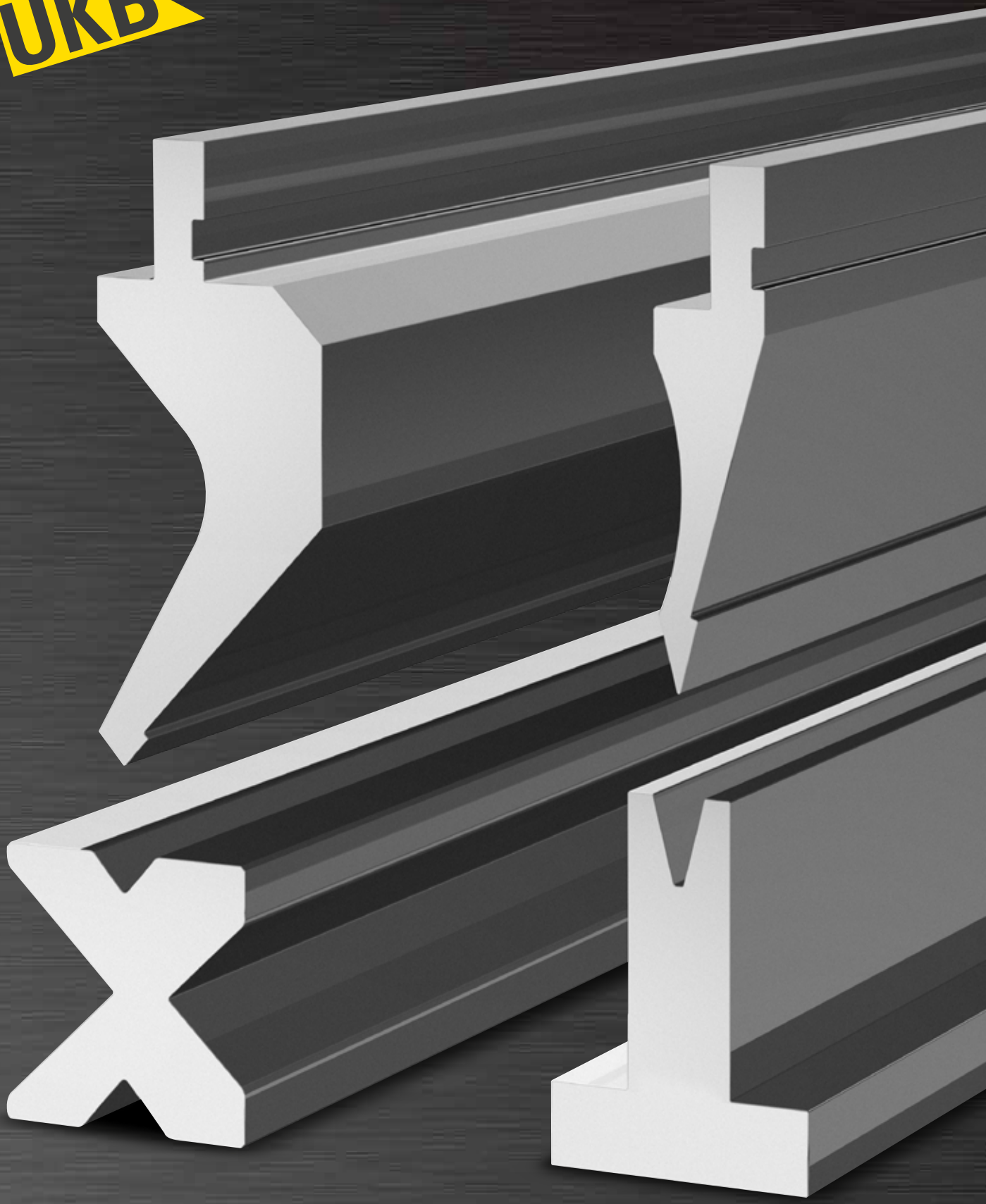
UKB®



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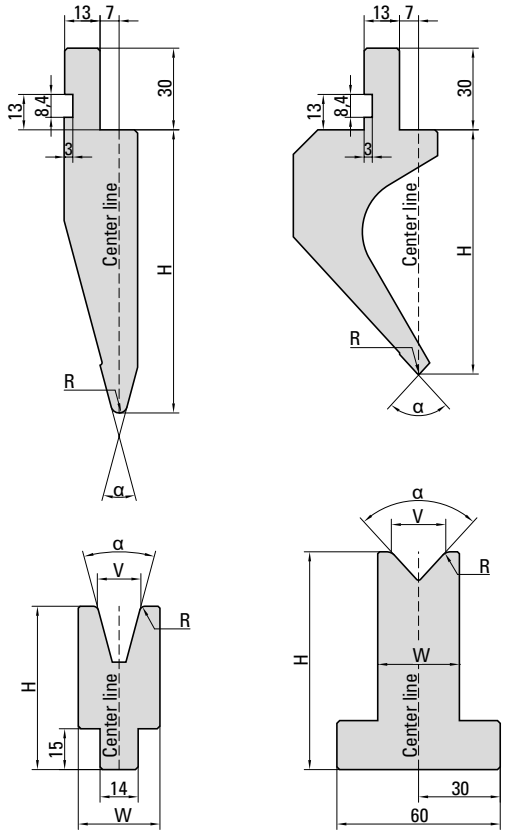
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, tempered to 800 – 850 N/mm²
  - C45, 650 – 800 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information



VIDEO

UKB-Press brake tool systems

UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** Press brake tools UKB-System Amada in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

Standard:	1 – 3 working days by parcel service or forwarder
Express:	DE 9:00, 10:30, 12:00am or 1 working day EU 1 working day
Direct courier:	According agreement

- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO

Image

UKB-SYSTEM AMADA EXPLANATION AND PUNCHES/TOP TOOLS

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Tool lengths

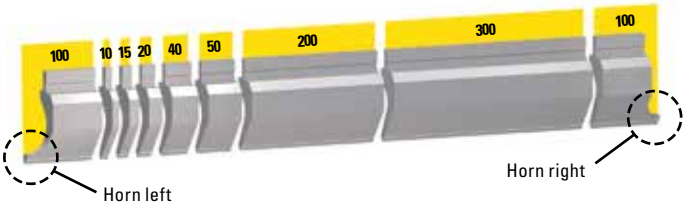
PUNCHES/TOP TOOLS

Length **835 mm**

Length **415 mm**

Length **835 mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 9 Segments, with horn extension left and right



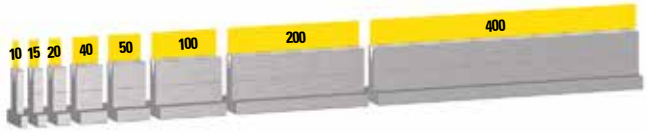
DIES

Length **835 mm**

Length **415 mm**

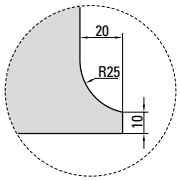
Length **835 mm sectionalized**

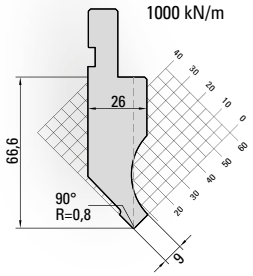
- Sectionalized dies are delivered as a complete set
- 8 Segments



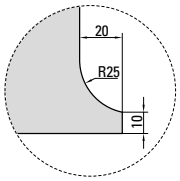
90° Punches/top tools

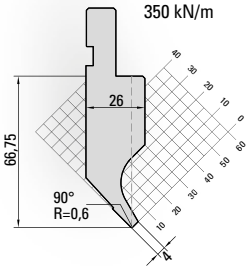
11.100		24h
835 mm	138,– €	11,0 kg
415 mm	82,– €	5,5 kg
835 mm sectionalized	242,– €	11,0 kg



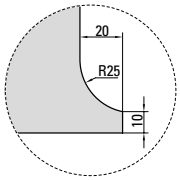


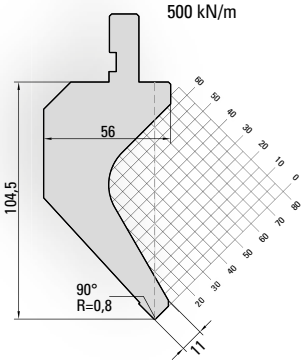
10.175		24h
835 mm	212,– €	10,5 kg
415 mm	120,– €	5,2 kg
835 mm sectionalized	330,– €	10,5 kg



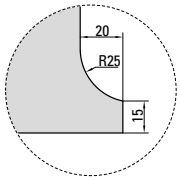


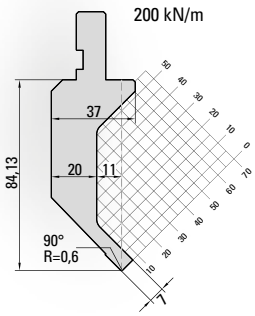
11.107		24h
835 mm	350,– €	23,0 kg
415 mm	194,– €	11,5 kg
835 mm sectionalized	496,– €	23,0 kg





10.150		24h
835 mm	466,– €	13,0 kg
415 mm	260,– €	6,5 kg
835 mm sectionalized	632,– €	13,0 kg





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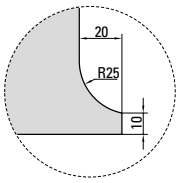
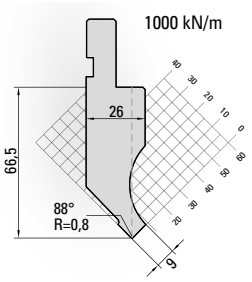
88° Punches/top tools

11.145 24h

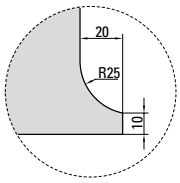
835 mm	138,– €	11,0 kg
415 mm	82,– €	5,5 kg
835 mm sectionalized	242,– €	11,0 kg

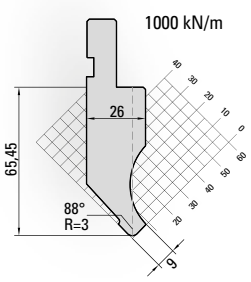




11.101 24h

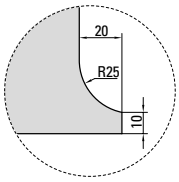
835 mm	138,– €	11,0 kg
415 mm	82,– €	5,5 kg
835 mm sectionalized	242,– €	11,0 kg

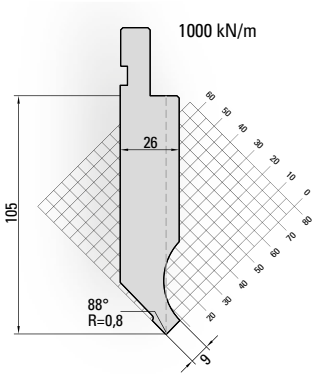




11.228 24h

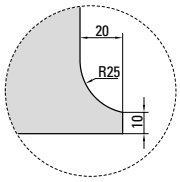
835 mm	262,– €	17,5 kg
415 mm	154,– €	8,7 kg
835 mm sectionalized	408,– €	17,5 kg

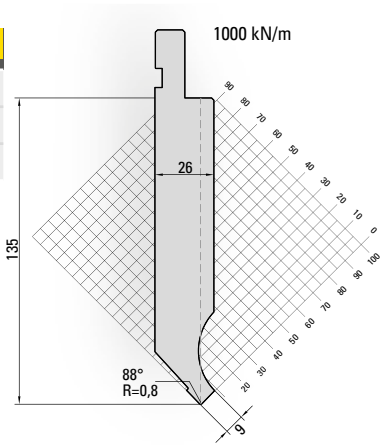




11.870 24h

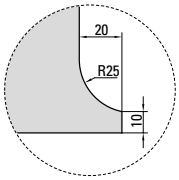
835 mm	360,– €	22,5 kg
415 mm	206,– €	11,2 kg
835 mm sectionalized	576,– €	22,5 kg

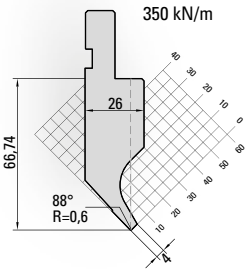




10.176 24h

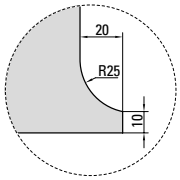
835 mm	212,– €	10,5 kg
415 mm	120,– €	5,2 kg
835 mm sectionalized	330,– €	10,5 kg

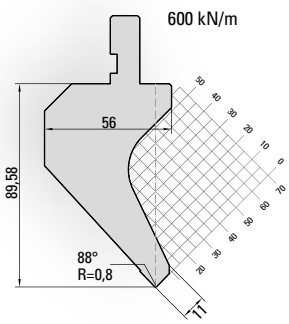




11.146 24h

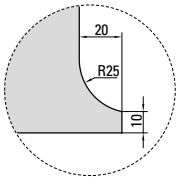
835 mm	294,– €	21,0 kg
415 mm	166,– €	10,5 kg
835 mm sectionalized	436,– €	21,0 kg

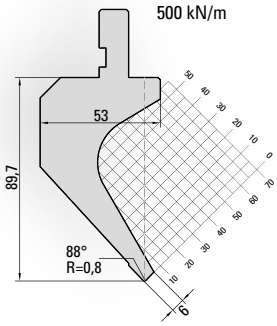




10.502 24h

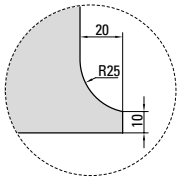
835 mm	378,– €	17,0 kg
415 mm	210,– €	8,5 kg
835 mm sectionalized	528,– €	17,0 kg

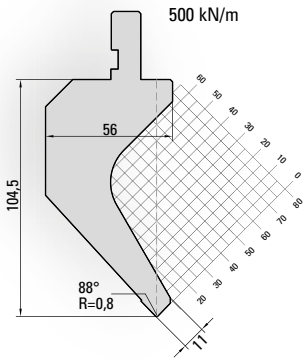




11.147 24h

835 mm	350,– €	23,0 kg
415 mm	194,– €	11,5 kg
835 mm sectionalized	496,– €	23,0 kg

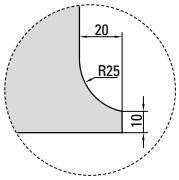


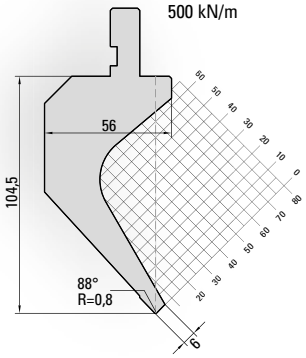


88° Punches/top tools

10.504 — 24h

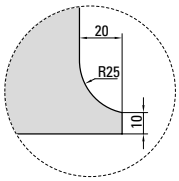
835 mm	394,– €	21,5 kg
415 mm	224,– €	10,7 kg
835 mm sectionalized	554,– €	21,5 kg

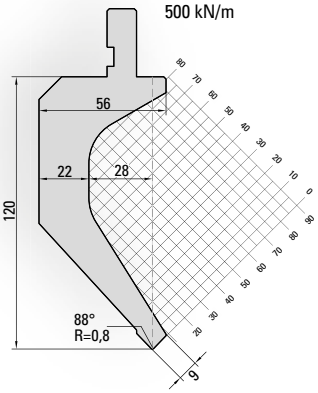




10.505 — 24h

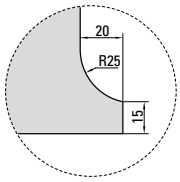
835 mm	708,– €	22,0 kg
415 mm	392,– €	11,0 kg
835 mm sectionalized	926,– €	22,0 kg

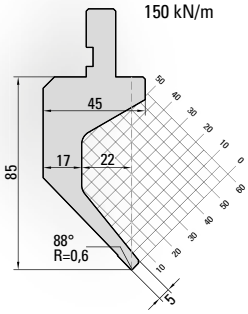




11.830 — 24h

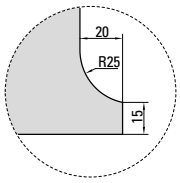
835 mm	530,– €	13,0 kg
415 mm	294,– €	6,5 kg
835 mm sectionalized	762,– €	13,0 kg

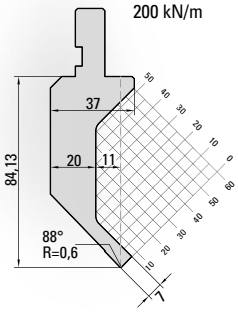




10.512 — 24h

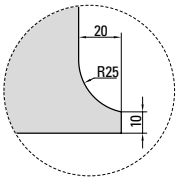
835 mm	466,– €	13,0 kg
415 mm	260,– €	6,5 kg
835 mm sectionalized	632,– €	13,0 kg

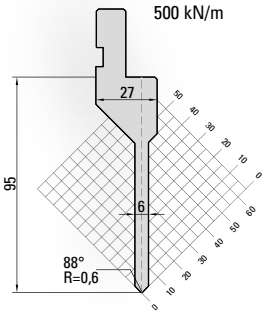




11.260 — 24h

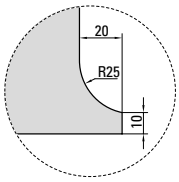
835 mm	348,– €	9,0 kg
415 mm	196,– €	4,5 kg
835 mm sectionalized	490,– €	9,0 kg

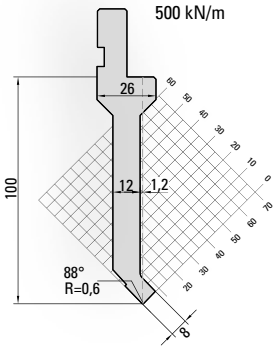




10.262 — 24h

835 mm	316,– €	11,5 kg
415 mm	180,– €	5,7 kg
835 mm sectionalized	458,– €	11,5 kg





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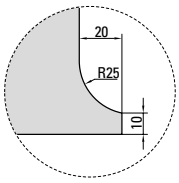
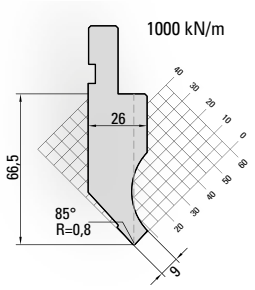
85° Punches/top tools

11.200 24h

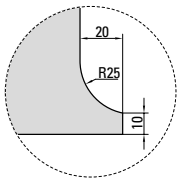
835 mm	138,– €	11,0 kg
415 mm	82,– €	5,5 kg
835 mm sectionalized	242,– €	11,0 kg

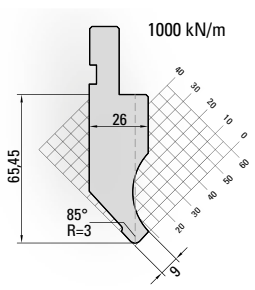




11.201 24h

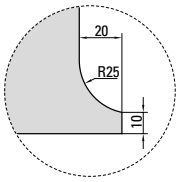
835 mm	138,– €	11,0 kg
415 mm	82,– €	5,5 kg
835 mm sectionalized	242,– €	11,0 kg

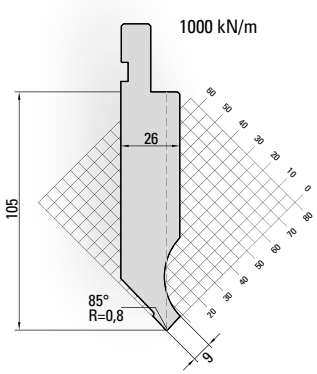




11.230 24h

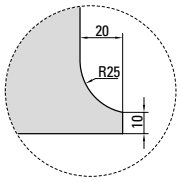
835 mm	262,– €	17,5 kg
415 mm	154,– €	8,7 kg
835 mm sectionalized	408,– €	17,5 kg

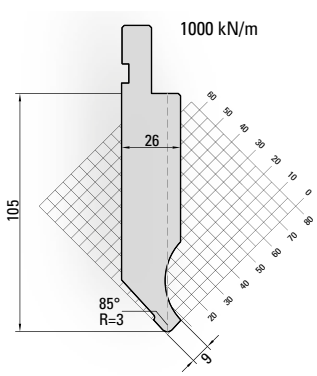




11.231 24h

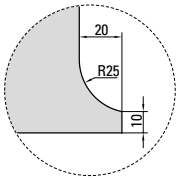
835 mm	262,– €	17,5 kg
415 mm	154,– €	8,7 kg
835 mm sectionalized	408,– €	17,5 kg

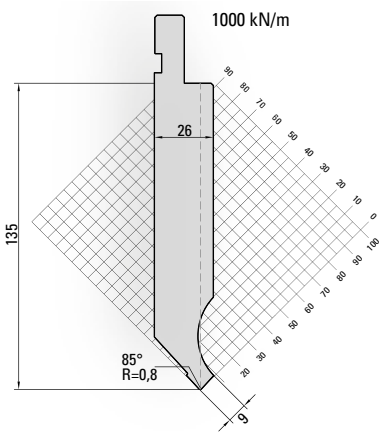




11.232 24h

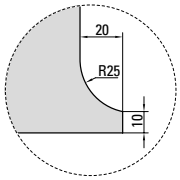
835 mm	360,– €	22,5 kg
415 mm	206,– €	11,2 kg
835 mm sectionalized	576,– €	22,5 kg

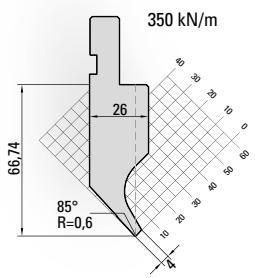




10.170 24h

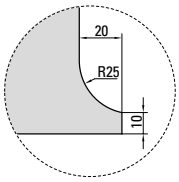
835 mm	212,– €	10,5 kg
415 mm	120,– €	5,2 kg
835 mm sectionalized	330,– €	10,5 kg

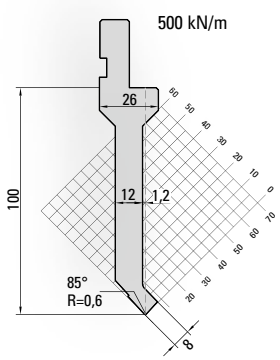




11.861 24h

835 mm	316,– €	11,5 kg
415 mm	180,– €	5,7 kg
835 mm sectionalized	458,– €	11,5 kg





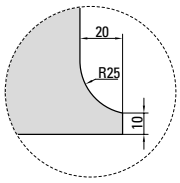
UKB-PRESS BRAKE TOOL CABINETS

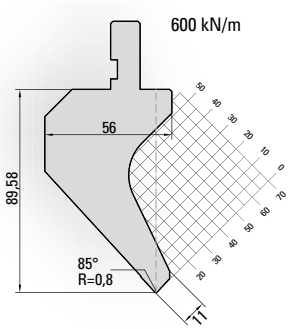
see chapter 16

85° Punches/top tools

11.660 — 24h

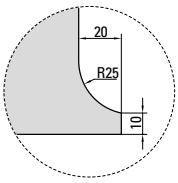
835 mm	294,– €	21,0 kg
415 mm	166,– €	10,5 kg
835 mm sectionalized	436,– €	21,0 kg

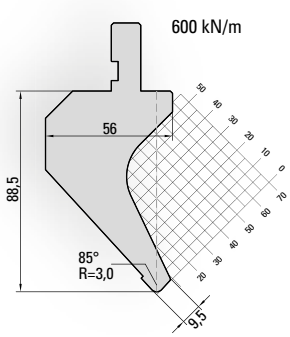




11.863 — 24h

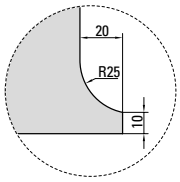
835 mm	294,– €	21,0 kg
415 mm	166,– €	10,5 kg
835 mm sectionalized	436,– €	21,0 kg

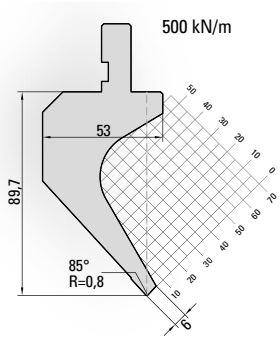




11.865 — 24h

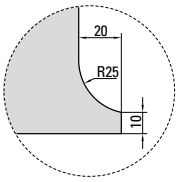
835 mm	378,– €	17,0 kg
415 mm	210,– €	8,5 kg
835 mm sectionalized	528,– €	17,0 kg

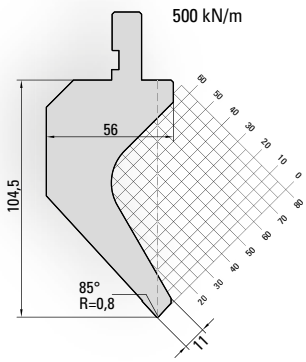




11.151 — 24h

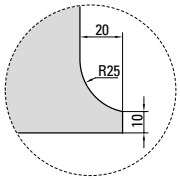
835 mm	350,– €	23,0 kg
415 mm	194,– €	11,5 kg
835 mm sectionalized	496,– €	23,0 kg

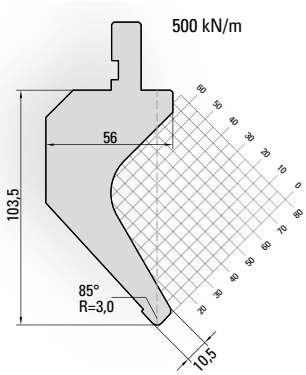




11.866 — 24h

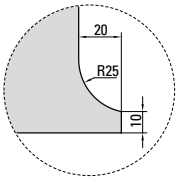
835 mm	350,– €	23,0 kg
415 mm	194,– €	11,5 kg
835 mm sectionalized	496,– €	23,0 kg

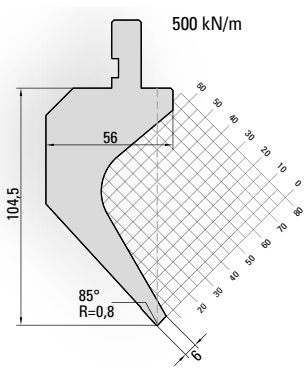




11.650 — 24h

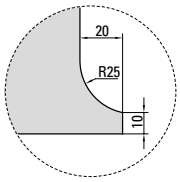
835 mm	394,– €	21,5 kg
415 mm	224,– €	10,7 kg
835 mm sectionalized	554,– €	21,5 kg

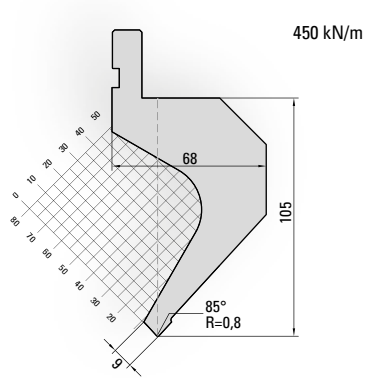




11.869 — 24h

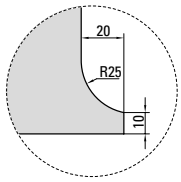
835 mm	720,– €	25,0 kg
415 mm	392,– €	12,5 kg
835 mm sectionalized	894,– €	25,0 kg

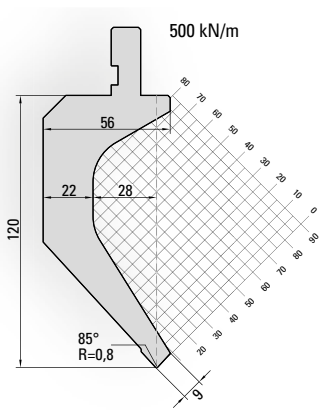




11.835 — 24h

835 mm	708,– €	22,0 kg
415 mm	392,– €	11,0 kg
835 mm sectionalized	926,– €	22,0 kg





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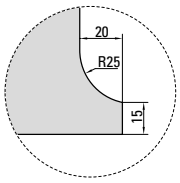
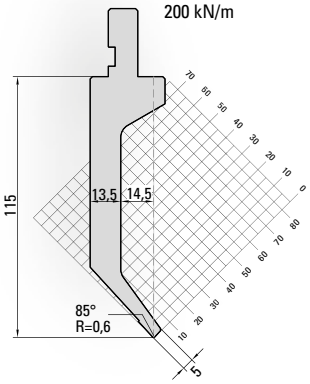
85° Punches/top tools

11.820 — 24h

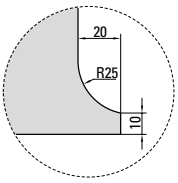
835 mm	594,– €	14,0 kg
415 mm	330,– €	7,0 kg
835 mm sectionalized	860,– €	14,0 kg

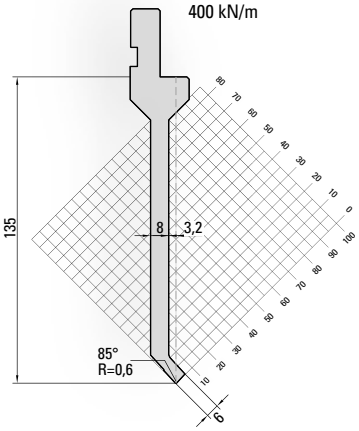




11.855 — 24h

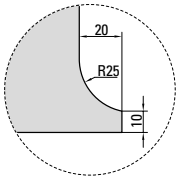
835 mm	464,– €	11,0 kg
415 mm	258,– €	5,5 kg
835 mm sectionalized	730,– €	11,0 kg

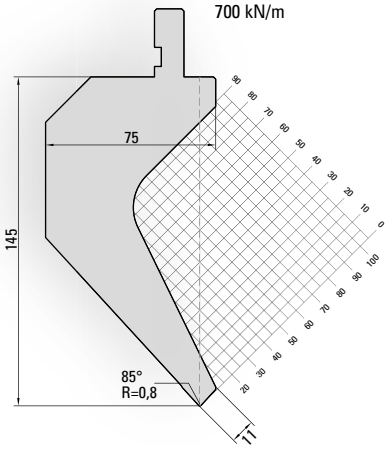




11.848 — 24h

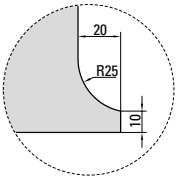
835 mm	844,– €	39,0 kg
415 mm	472,– €	19,5 kg
835 mm sectionalized	1.186,– €	39,0 kg

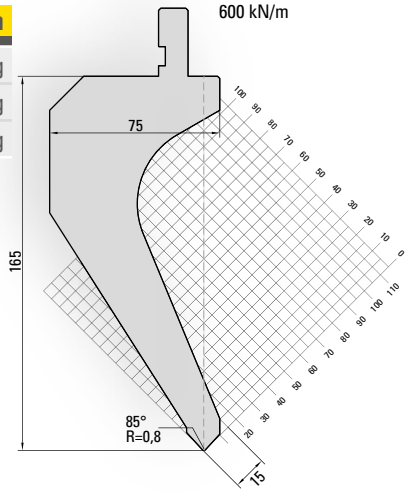




11.849 — 24h

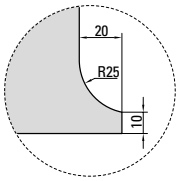
835 mm	1.036,– €	41,0 kg
415 mm	570,– €	20,5 kg
835 mm sectionalized	1.390,– €	41,0 kg

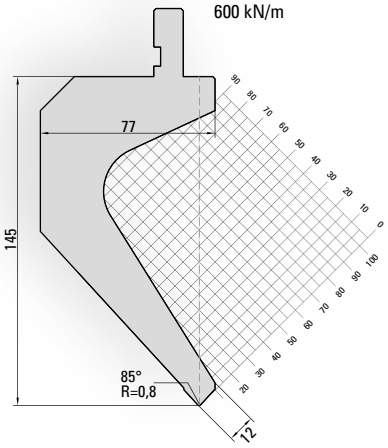




11.670 — 24h

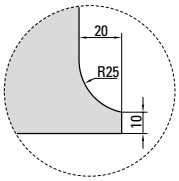
835 mm	1.018,– €	34,5 kg
415 mm	534,– €	17,3 kg
835 mm sectionalized	1.334,– €	34,5 kg

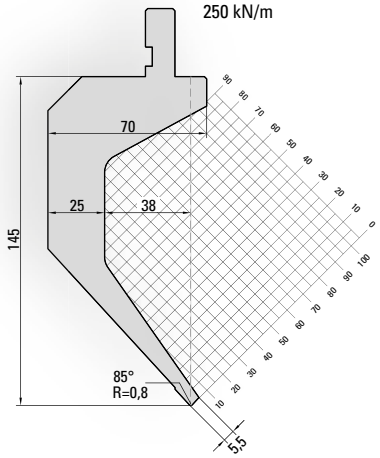




11.680 — 24h

835 mm	1.068,– €	27,6 kg
415 mm	574,– €	13,7 kg
835 mm sectionalized	1.414,– €	27,6 kg



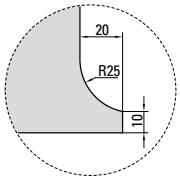


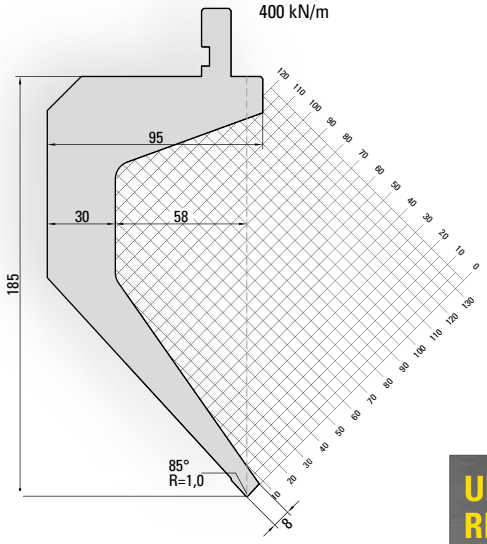
85° Punches/top tools

11.850 — 24h

505 mm	1.090,– €	26,0 kg
500 mm sectionalized	1.710,– €	25,7 kg

Length 500 mm sectionalized: 9 segments
(100, 20, 25, 30, 35, 40, 50, 100, 100)
Horn l. Horn r.

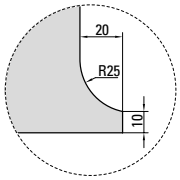


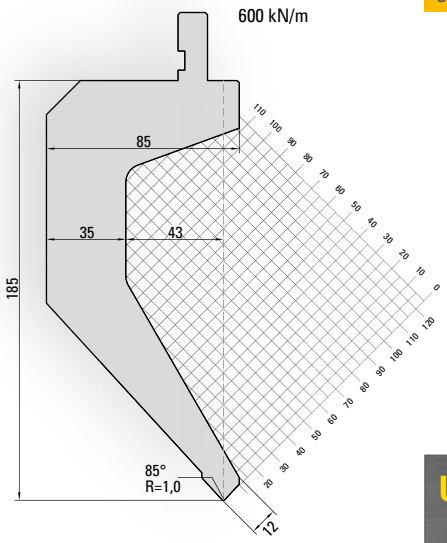


11.840 — 24h

505 mm	868,– €	29,5 kg
500 mm sectionalized	1.468,– €	29,2 kg

Length 500 mm sectionalized: 9 segments
(100, 20, 25, 30, 35, 40, 50, 100, 100)
Horn l. Horn r.

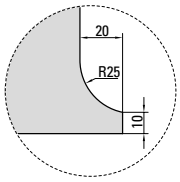


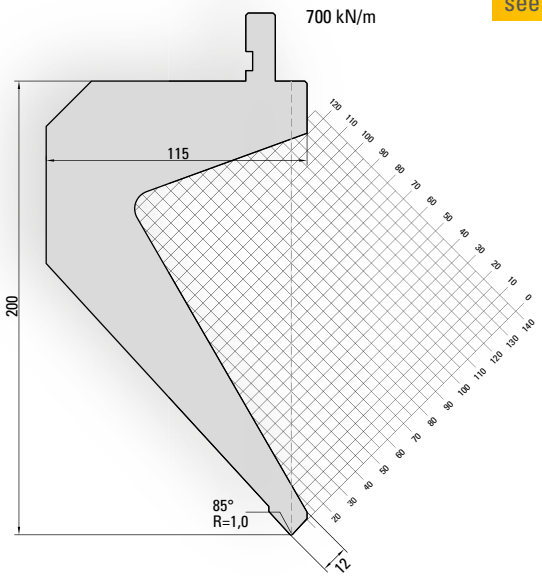


11.800 — 24h

505 mm	1.164,– €	40,0 kg
500 mm sectionalized	1.856,– €	39,6 kg

Length 500 mm sectionalized: 9 segments
(100, 20, 25, 30, 35, 40, 50, 100, 100)
Horn l. Horn r.





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90°/88°/85° Punch/top tool end pieces with movable horn extensions

90°

Model	Suitable for punch/top tool	α	R (mm)	H	kg	Price per pair left/right
40.112	11.100	90°	0,8	66,60	3,5	888,– €
40.120	10.175	90°	0,6	66,75	3,5	912,– €

Delivery time on request

88°

Model	Suitable for punch/top tool	α	R (mm)	H	kg	Price per pair left/right
40.113	11.145	88°	0,8	66,50	3,5	888,– €
40.115	11.101	88°	3,0	65,45	3,5	888,– €
40.121	10.176	88°	0,6	66,74	3,5	912,– €

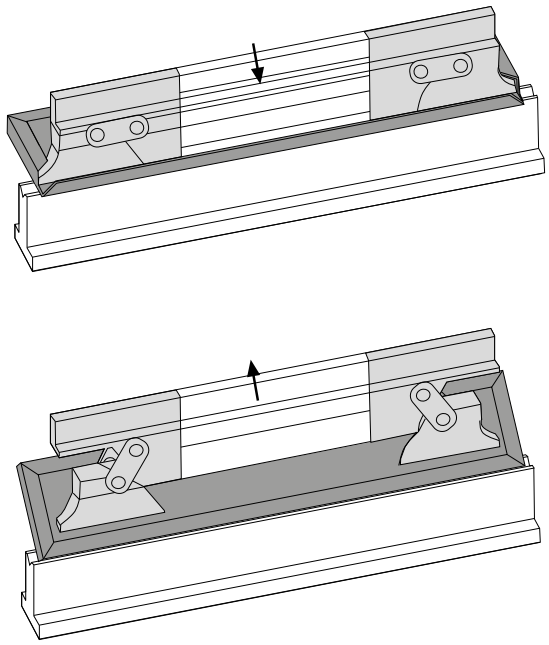
Delivery time on request

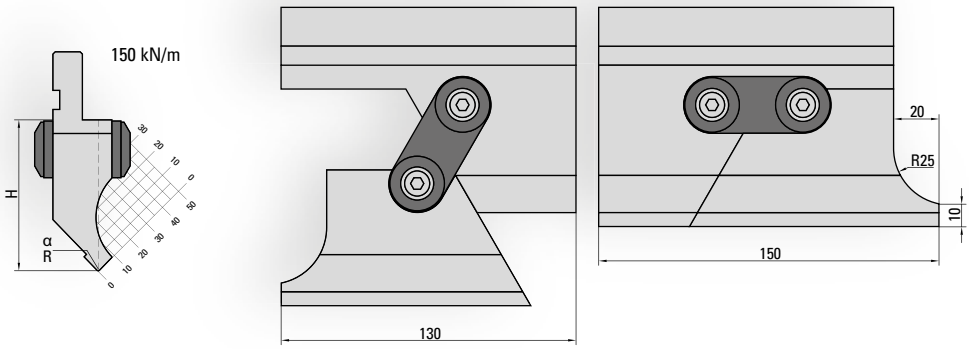
85°

Model	Suitable for punch/top tool	α	R (mm)	H	kg	Price per pair left/right
40.114	11.200	85°	0,8	66,50	3,5	888,– €
40.116	11.201	85°	3,0	65,45	3,5	888,– €
40.122	10.170	85°	0,6	66,74	3,5	912,– €

Delivery time on request

EXAMPLE OF USE





UKB-SYSTEM AMADA PUNCHES/TOP TOOLS

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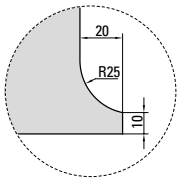
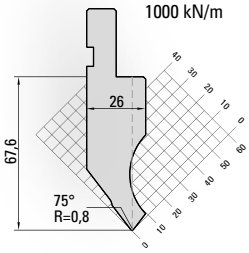
75° Punch/top tool

11.275		24h
835 mm	176,– €	11,0 kg
415 mm	100,– €	5,5 kg
835 mm sectionalized	286,– €	11,0 kg

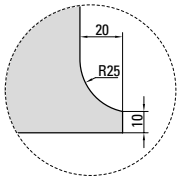


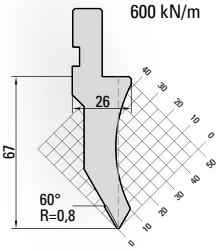


UKB-Z-TOOL HOLDERS AND Z-TOOL INSERTS Z 1,0 – 15,0
see chapter 09

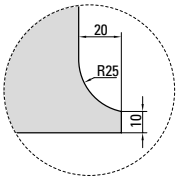
60° Punches/top tools

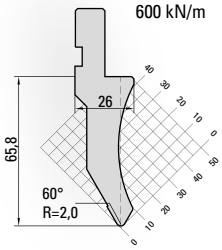
10.142		24h
835 mm	170,– €	9,0 kg
415 mm	100,– €	4,5 kg
835 mm sectionalized	282,– €	9,0 kg



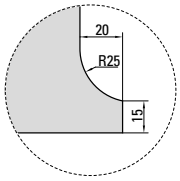


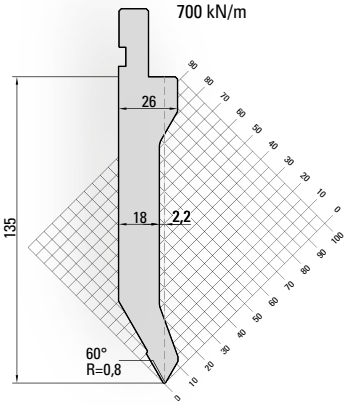
10.143		24h
835 mm	170,– €	9,0 kg
415 mm	100,– €	4,5 kg
835 mm sectionalized	282,– €	9,0 kg



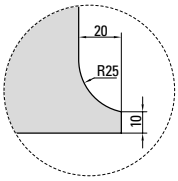


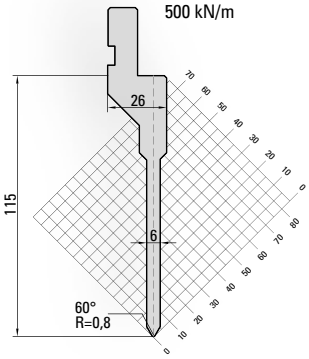
11.750		24h
835 mm	372,– €	18,0 kg
415 mm	212,– €	9,0 kg
835 mm sectionalized	548,– €	18,0 kg





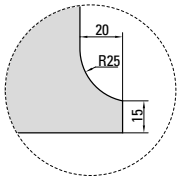
10.520		24h
835 mm	522,– €	9,5 kg
415 mm	294,– €	4,7 kg
835 mm sectionalized	682,– €	9,5 kg

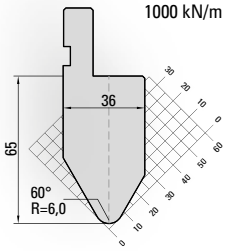




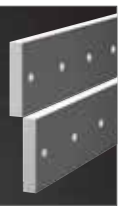
10.136		24h
835 mm	194,– €	14,0 kg
415 mm	112,– €	7,0 kg
835 mm sectionalized	314,– €	14,0 kg

1500 kN/m if the tool clamping has the corresponding load





UKB-SHEAR BLADES
see chapter 20



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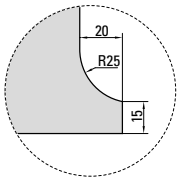
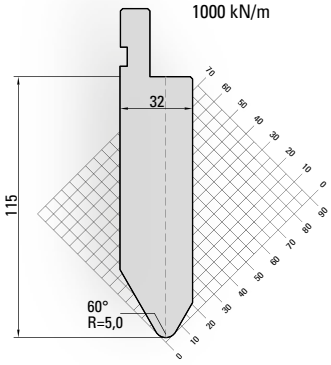
60° Punches/top tools

11.710 — 24h

835 mm	340,– €	24,5 kg
415 mm	192,– €	12,2 kg
835 mm sectionalized	506,– €	24,5 kg

1200 kN/m if the tool clamping has the corresponding load

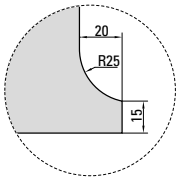


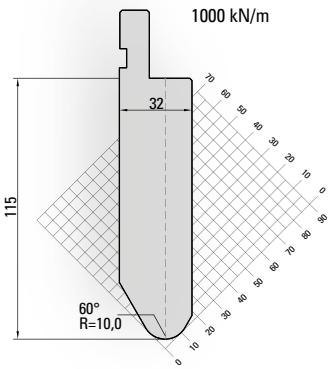


11.720 — 24h

835 mm	340,– €	25,0 kg
415 mm	192,– €	12,5 kg
835 mm sectionalized	506,– €	25,0 kg

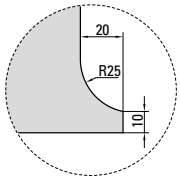
1200 kN/m if the tool clamping has the corresponding load

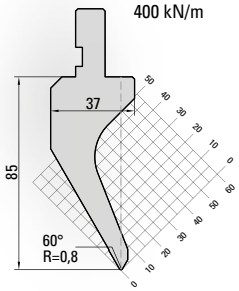




10.516 — 24h

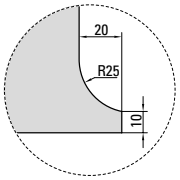
835 mm	418,– €	12,0 kg
415 mm	234,– €	6,0 kg
835 mm sectionalized	554,– €	12,0 kg

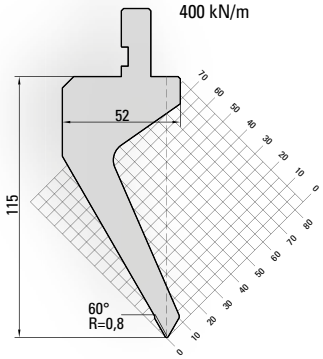




10.500 — 24h

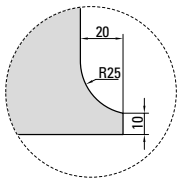
835 mm	588,– €	19,5 kg
415 mm	324,– €	9,7 kg
835 mm sectionalized	766,– €	19,5 kg

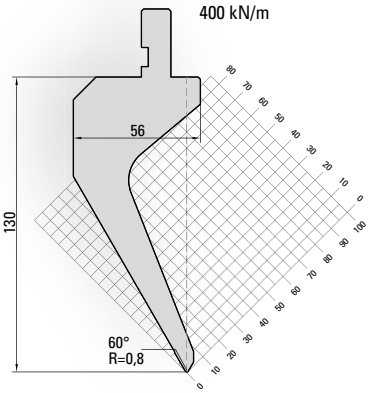




10.506 — 24h

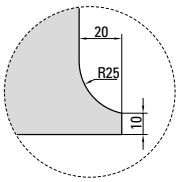
835 mm	754,– €	22,5 kg
415 mm	410,– €	11,2 kg
835 mm sectionalized	954,– €	22,5 kg

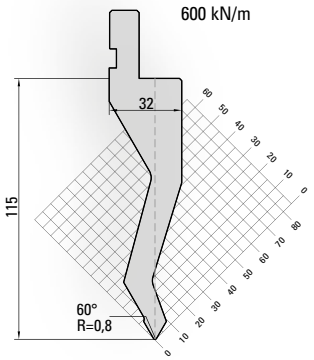




10.510 — 24h

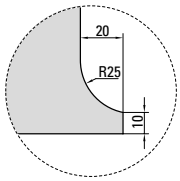
835 mm	442,– €	15,0 kg
415 mm	244,– €	7,5 kg
835 mm sectionalized	600,– €	15,0 kg

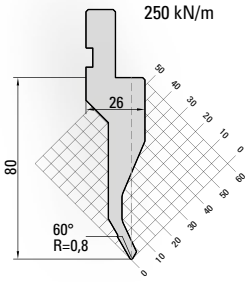


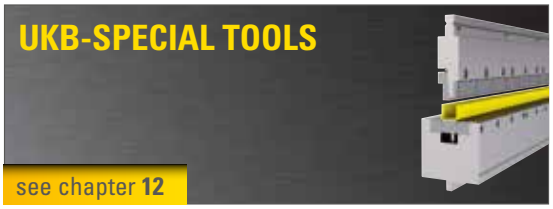


10.517 — 24h

835 mm	412,– €	9,0 kg
415 mm	228,– €	4,5 kg
835 mm sectionalized	558,– €	9,0 kg







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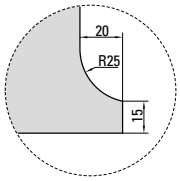
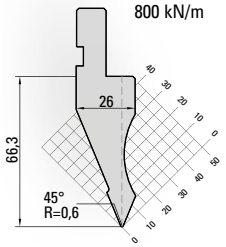
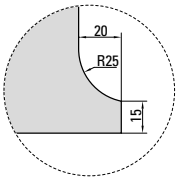
45° Punches/top tools

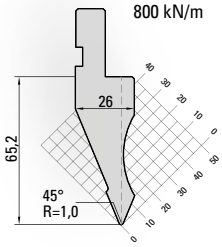
11.134		24h
835 mm	168,– €	9,5 kg
415 mm	98,– €	4,7 kg
835 mm sectionalized	278,– €	9,5 kg





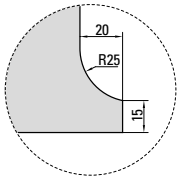
11.102		24h
835 mm	168,– €	9,5 kg
415 mm	98,– €	4,7 kg
835 mm sectionalized	276,– €	9,5 kg

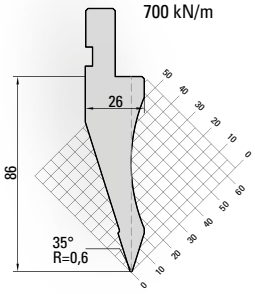




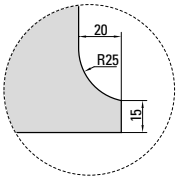
35° Punches/top tools

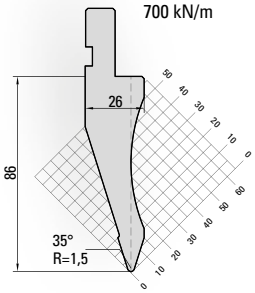
11.103		24h
835 mm	182,– €	11,5 kg
415 mm	108,– €	5,7 kg
835 mm sectionalized	306,– €	11,5 kg



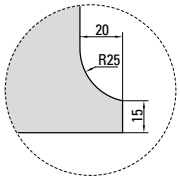


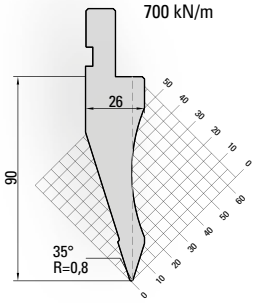
11.104		24h
835 mm	182,– €	11,5 kg
415 mm	108,– €	5,7 kg
835 mm sectionalized	306,– €	11,5 kg





11.600		24h
835 mm	186,– €	11,5 kg
415 mm	110,– €	5,7 kg
835 mm sectionalized	310,– €	11,5 kg





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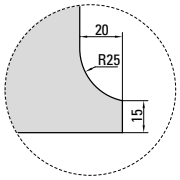
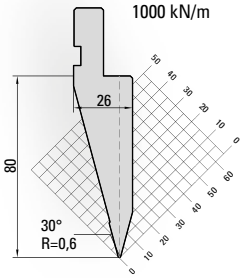
30° Punches/top tools

11.158 24h

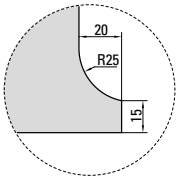
835 mm	202,– €	10,5 kg
415 mm	118,– €	5,2 kg
835 mm sectionalized	330,– €	10,5 kg

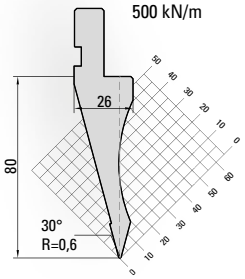




10.514 24h

835 mm	282,– €	9,0 kg
415 mm	164,– €	4,5 kg
835 mm sectionalized	420,– €	9,0 kg

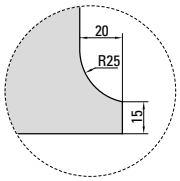


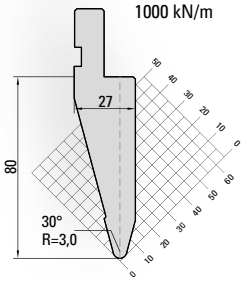


10.511 24h

835 mm	220,– €	12,5 kg
415 mm	128,– €	6,2 kg
835 mm sectionalized	348,– €	12,5 kg

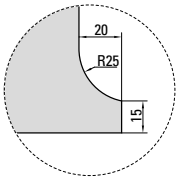
1200 kN/m if the tool clamping has the corresponding load

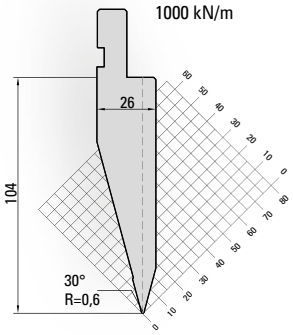




11.258 24h

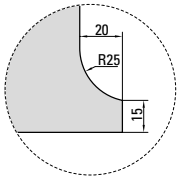
835 mm	292,– €	15,5 kg
415 mm	168,– €	7,7 kg
835 mm sectionalized	444,– €	15,5 kg

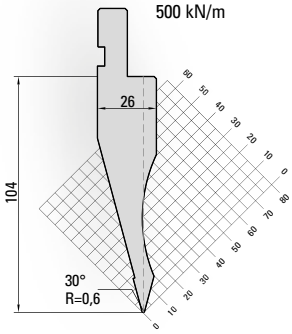




11.514 24h

835 mm	368,– €	14,0 kg
415 mm	212,– €	7,0 kg
835 mm sectionalized	540,– €	14,0 kg

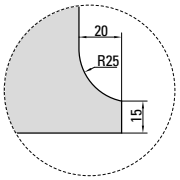


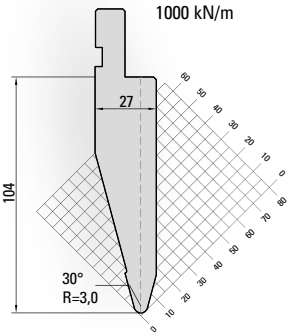


11.528 24h

835 mm	318,– €	16,5 kg
415 mm	182,– €	8,2 kg
835 mm sectionalized	486,– €	16,5 kg

1200 kN/m if the tool clamping has the corresponding load

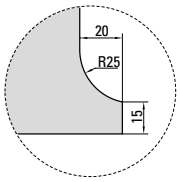


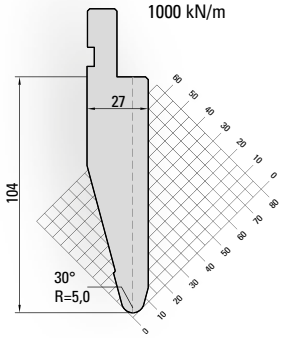


11.530 24h

835 mm	318,– €	17,0 kg
415 mm	182,– €	8,5 kg
835 mm sectionalized	486,– €	17,0 kg

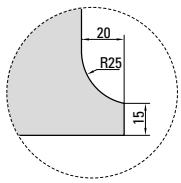
1200 kN/m if the tool clamping has the corresponding load

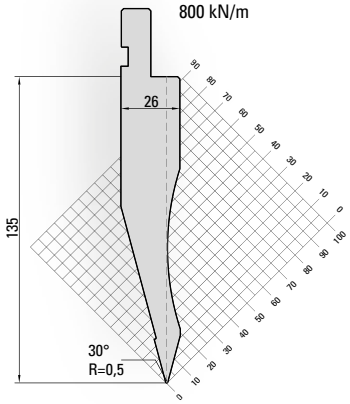




11.780 24h

835 mm	422,– €	18,5 kg
415 mm	238,– €	9,2 kg
835 mm sectionalized	600,– €	18,5 kg

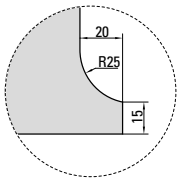


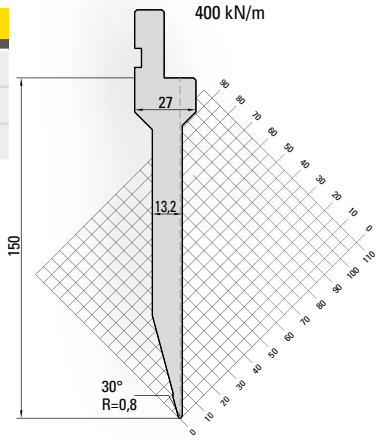


30° Punches/top tools

11.880 — 24h

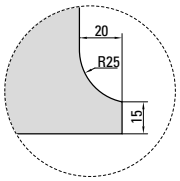
835 mm	464,– €	15,0 kg
415 mm	258,– €	7,5 kg
835 mm sectionalized	680,– €	15,0 kg

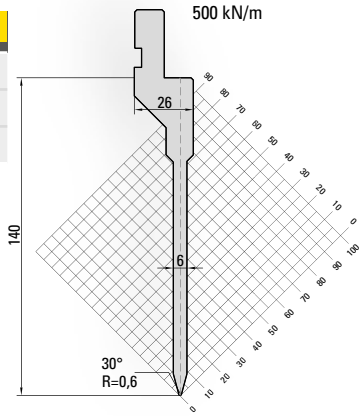




10.515 — 24h

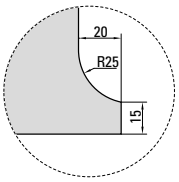
835 mm	748,– €	11,0 kg
415 mm	420,– €	5,5 kg
835 mm sectionalized	932,– €	11,0 kg

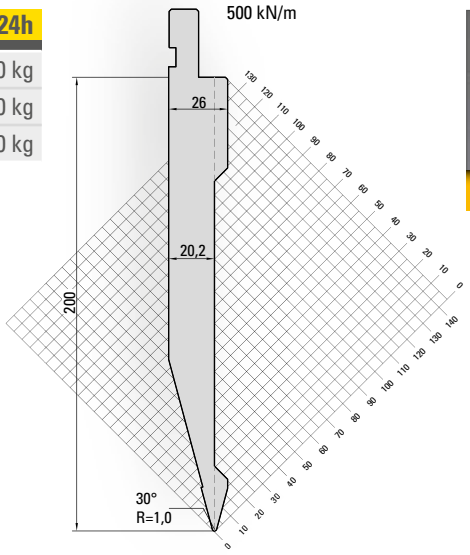




11.810 — 24h

835 mm	536,– €	26,0 kg
415 mm	316,– €	13,0 kg
835 mm sectionalized	790,– €	26,0 kg





UKB-FIELD SERVICE

- *Individual advice and sale*
- *Technical solutions for special bending tasks*
- *Test bending on-site or at the UKB-test center*
- *Pick up service for tools to rework*

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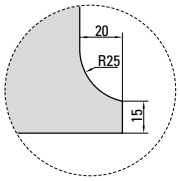
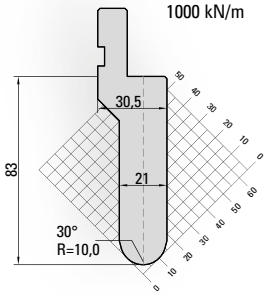
30° Punches/top tools

11.904		24h
835 mm	500,– €	14,4 kg
415 mm	276,– €	7,2 kg
835 mm sectionalized	660,– €	14,4 kg

Compatible to radius-tool holder 10.115 and radius-tool 10.311/11.311 (see page 143/146)

1500 kN/m if the tool clamping has the corresponding load

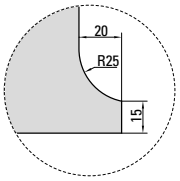


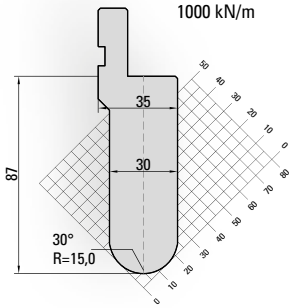


11.911		24h
835 mm	550,– €	19,2 kg
415 mm	300,– €	9,6 kg
835 mm sectionalized	710,– €	19,2 kg

Compatible to radius-tool holder 10.115 and radius-tool 10.311/11.311 (see page 143/146)

1500 kN/m if the tool clamping has the corresponding load

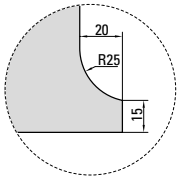


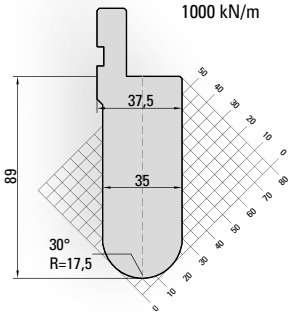


11.914		24h
835 mm	600,– €	22,0 kg
415 mm	324,– €	11,0 kg
835 mm sectionalized	760,– €	22,0 kg

Compatible to radius-tool holder 10.115 and radius-tool 10.311/11.311 (see page 143/146)

1500 kN/m if the tool clamping has the corresponding load

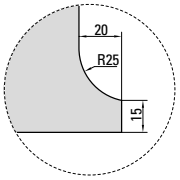


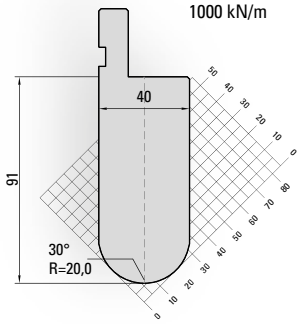


11.916		24h
835 mm	650,– €	25,0 kg
415 mm	350,– €	12,5 kg
835 mm sectionalized	810,– €	25,0 kg

Compatible to radius-tool holder 10.115 and radius-tool 10.311/11.311 (see page 143/146)

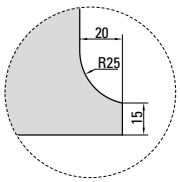
1500 kN/m if the tool clamping has the corresponding load

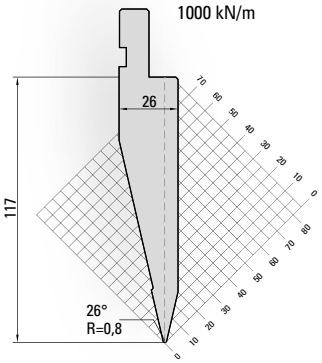




26° Punch/top tool

11.540		24h
835 mm	246,– €	16,5 kg
415 mm	148,– €	8,2 kg
835 mm sectionalized	416,– €	16,5 kg



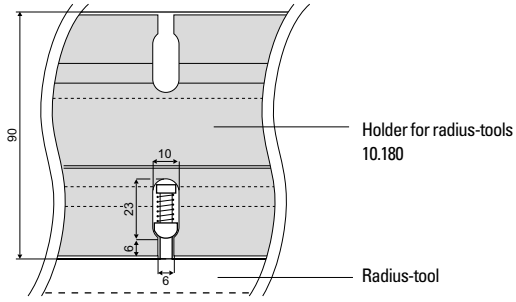


Holder for radius-tools and radius-tools R 3,0 – 6,5

ADVANTAGES

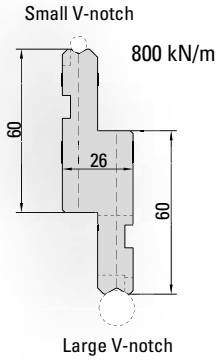
- Cost-saving: One holder for different radius-tools
- Easy handling
- No adjustment necessary
- High stability
- Flexible application through changeable radius-tools
- Sectionalized radius-tools on request

EXAMPLE OF USE



10.180		24h
830 mm	286,– €	9,0 kg
412 mm	172,– €	4,5 kg

Holder for radius-tools



VIDEO

UKB-Holders for radius-tools and radius-tools R 7,0 – 50,0

R 3,0 – 4,5 (24h)

R (mm)	Model	835 mm Price	835 mm Weight	415 mm Price	415 mm Weight
3,0	10.181	62,– €	0,20 kg	38,– €	0,10 kg
3,5	10.182	66,– €	0,25 kg	40,– €	0,12 kg
4,0	10.183	72,– €	0,35 kg	42,– €	0,17 kg
4,5	10.184	80,– €	0,50 kg	46,– €	0,25 kg

Usable on holder for radius-tools 10.180, small V-notch, radius-tools are not hardened

800 kN/m

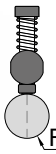
R3 - 4,5

UKB-HOLDERS FOR RADIUS-TOOLS AND RADIUS-TOOLS R 7,0 – 50,0
see chapter 08

R 5,0 – 6,5 (24h)

R (mm)	Model	835 mm Price	835 mm Weight	415 mm Price	415 mm Weight
5,0	10.185	82,– €	0,60 kg	48,– €	0,30 kg
5,5	10.186	88,– €	0,70 kg	50,– €	0,35 kg
6,0	10.187	94,– €	0,80 kg	54,– €	0,40 kg
6,5	10.188	102,– €	1,00 kg	58,– €	0,50 kg

Usable on holder for radius-tools 10.180, large V-notch, radius-tools are not hardened



800 kN/m

R5 - 6,5

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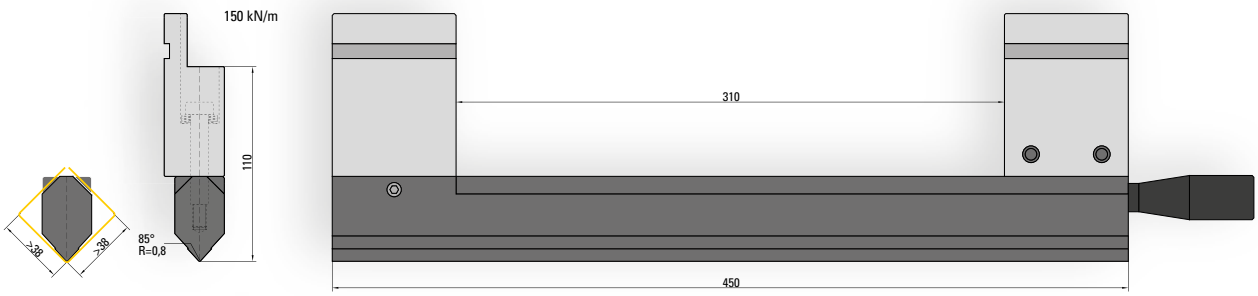
85° Window punch/top tool for closed boxes „Rotax®“

ADVANTAGES

- ▶ Bending of closed profiles
- ▶ High U-profiles
- ▶ Easy removal by opening the pivot arm

40.680	24h
872,– €	7,0 kg



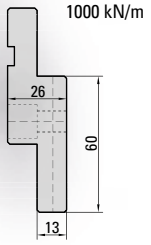
Individual production possible

Punch/top tool distance pieces

50.959 24h

150 mm	70,– €	1,8 kg

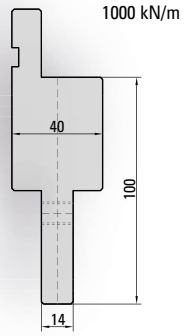
H = 60 mm
Heightening of the side flange about 35 mm
Needed clamp
see page 23



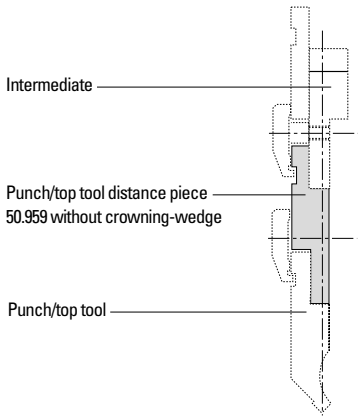
50.671 24h

150 mm	80,– €	3,6 kg

H = 100 mm
Heightening of the side flange about 70 mm
Needed clamp
see page 23

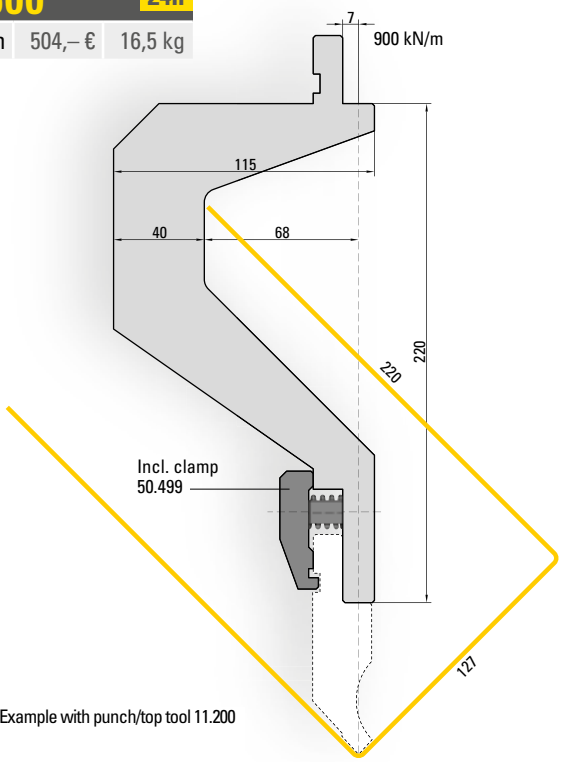


EXAMPLE OF USE



50.500 24h

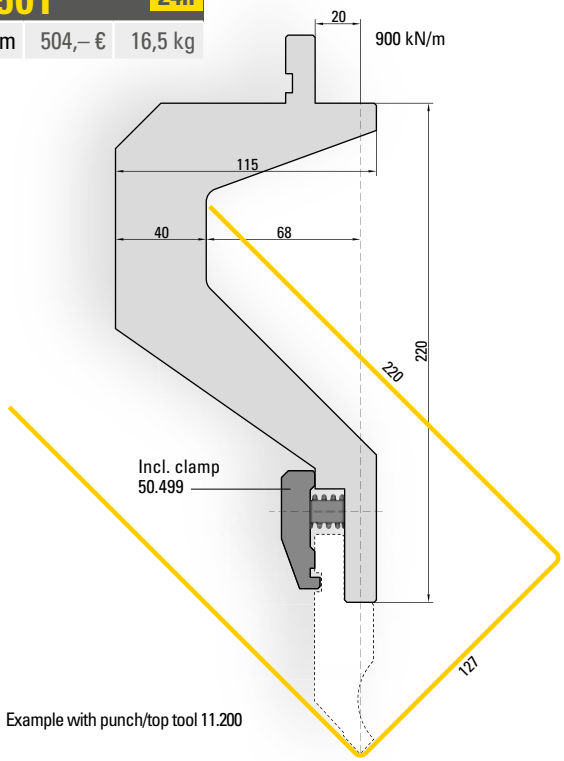
200 mm	504,– €	16,5 kg



Example with punch/top tool 11.200

50.501 24h

200 mm	504,– €	16,5 kg



Example with punch/top tool 11.200

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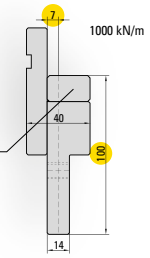
Intermediates L = 150 mm

50.666 24h

150 mm	80,– €	4,0 kg

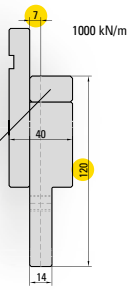
H = 100 mm
With crowning wedge



50.668 24h

150 mm	94,– €	4,0 kg

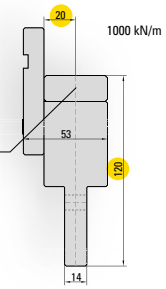
H = 120 mm
With crowning wedge



50.667 24h

150 mm	106,– €	5,0 kg

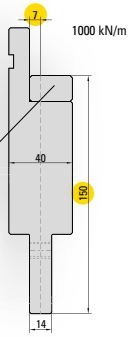
H = 120 mm
With crowning wedge



50.512 24h

150 mm	124,– €	6,3 kg

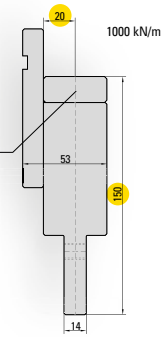
H = 150 mm
With crowning wedge



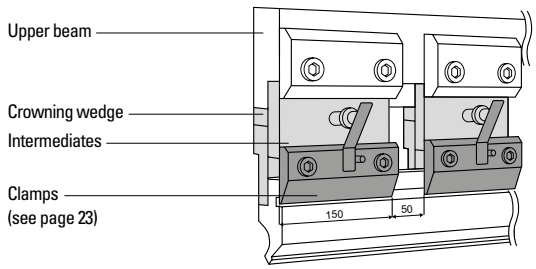
50.669 24h

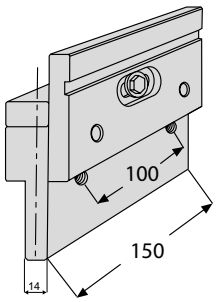
150 mm	134,– €	6,5 kg

H = 150 mm
With crowning wedge



EXAMPLE OF USE



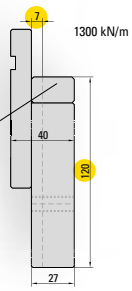


Intermediates „Heavy Duty“ L = 150 mm

50.674 24h

150 mm	94,– €	4,5 kg

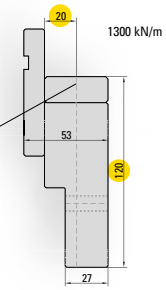
H = 120 mm
With crowning wedge



50.673 24h

150 mm	106,– €	5,5 kg

H = 120 mm
With crowning wedge



UKB-SYSTEM AMADA PUNCHES/TOP TOOLS

post@ukb-gmbh.com . www.ukb-gmbh.com

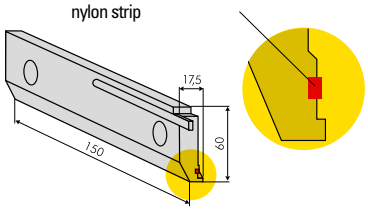
Clamps L = 150 mm

50.903 24h

150 mm	50,– €	0,7 kg

Mechanical fast clamp
Adjusted by eccentric lever

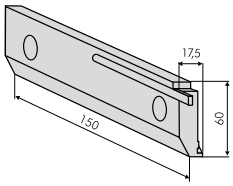
ADVANTAGE:
Improved clamping via nylon strip



50.900 24h

150 mm	44,– €	0,7 kg

Mechanical fast clamp
Adjusted by eccentric lever

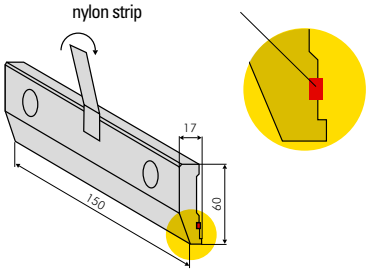


50.905 24h

150 mm	46,– €	1,0 kg

Mechanical fast clamp
Adjusted by handle

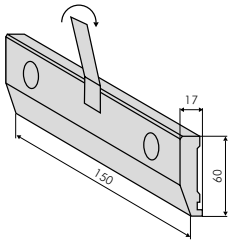
ADVANTAGE:
Improved clamping via nylon strip



50.551 24h

150 mm	40,– €	1,0 kg

Mechanical fast clamp
Adjusted by handle

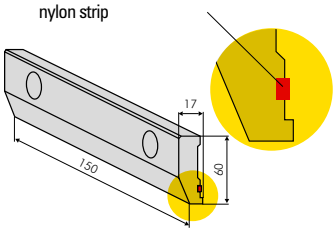


50.910 24h

150 mm	38,– €	0,8 kg

Clamp
Clamping by screws

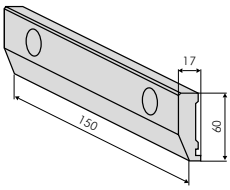
ADVANTAGE:
Improved clamping via nylon strip



50.571 24h

150 mm	32,– €	0,7 kg

Clamp
Clamping by screws

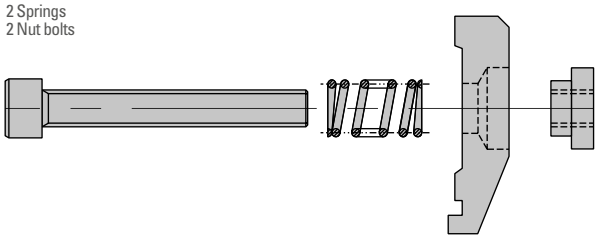


Clamp L = 150 mm for double-sided clamping

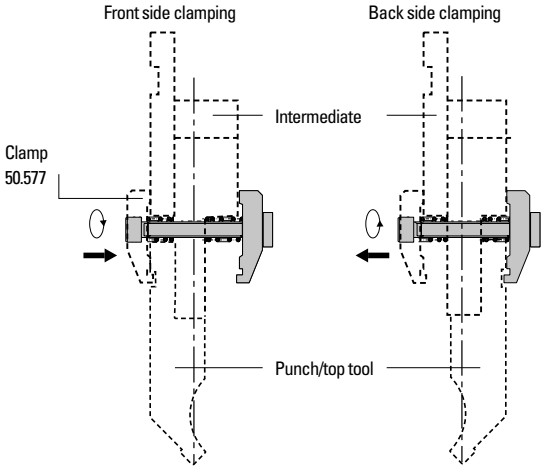
50.577 24h

150 mm	48,– €	1,5 kg

Set consist of:
Clamp 50.571
2 Screws
2 Springs
2 Nut bolts



EXAMPLE OF USE



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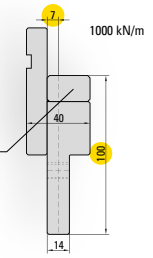
Intermediates L = 70 mm

50.705 24h

70 mm	76,– €	2,0 kg

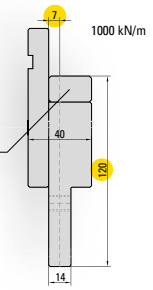
H = 100 mm
With crowning wedge



50.706 24h

70 mm	86,– €	2,0 kg

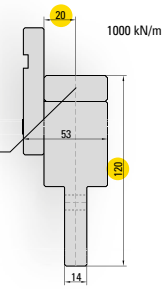
H = 120 mm
With crowning wedge



50.707 24h

70 mm	98,– €	2,5 kg

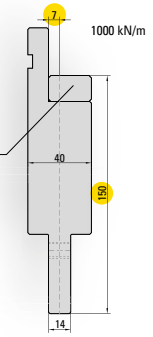
H = 120 mm
With crowning wedge



50.708 24h

70 mm	116,– €	3,0 kg

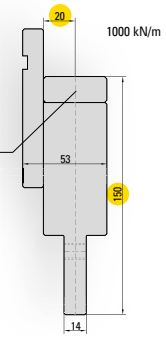
H = 150 mm
With crowning wedge



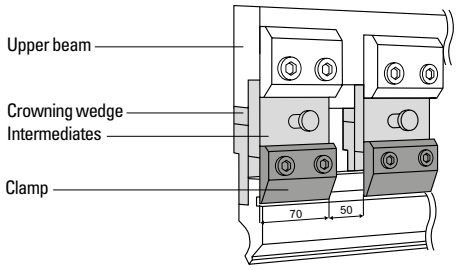
50.710 24h

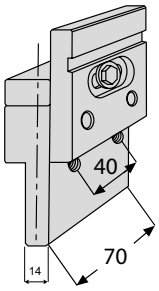
70 mm	126,– €	3,5 kg

H = 150 mm
With crowning wedge



EXAMPLE OF USE



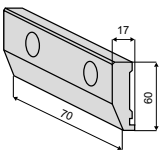


Clamp L = 70 mm

50.693 24h

70 mm	28,– €	0,4 kg

Clamp
Clamping by screws



FOLLOW US!

Intermediates „Swing“

ADVANTAGES

- Fast **vertical** tool change
- Compensation of the deflection via crowning wedge
- Big time-saving and therefore an essentially increased efficiency
- Automatic self-centering
- Easy and fast slide of the intermediates and punch/top tool adaptors possible
- Guaranteed exchangeability through highly precision grinding

VIDEO

UKB-Clampings
SWING / RAPID / CLARK

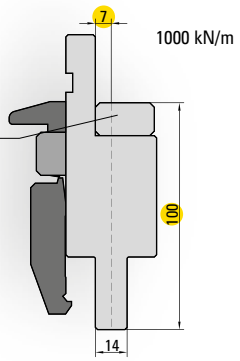
Quantity of the needed intermediates „Swing“
(Mounting distance 50 mm)

Length of the press brake (mm)	Quantity (pieces)
835	4
1.250	6
2.100	10
2.600	13
3.100	15
4.100	20

50.200 24h

150 mm	238,– €	6,0 kg

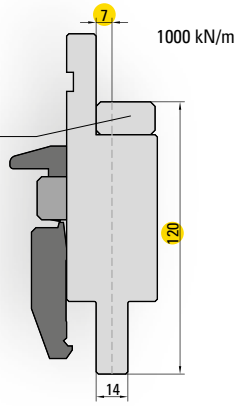
With crowning wedge
Incl. clamp



50.210 24h

150 mm	248,– €	7,0 kg

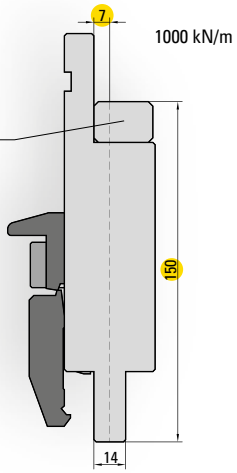
With crowning wedge
Incl. clamp



50.220 24h

150 mm	268,– €	8,5 kg

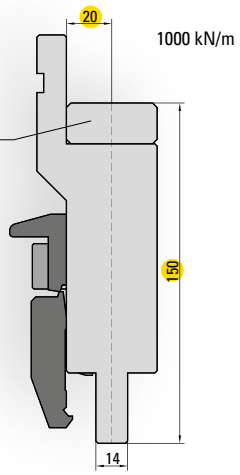
With crowning wedge
Incl. clamp



50.250 24h

150 mm	288,– €	9,0 kg

With crowning wedge
Incl. clamp



Punch/top tool mounted

Release screw, the punch/ top tool is secured from dropping out

Tip the punch/top tool

Take out the punch/top tool vertical

Phone +49 (0) 27 36 / 44 42 - 0 . Fax +49 (0) 27 36 / 44 42 - 22

Pneumatic clamping „RAPID®“

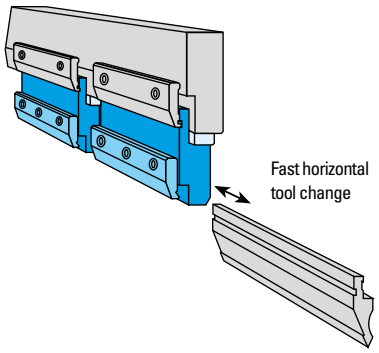
ADVANTAGES

- Cost-saving, easy and fast change of your press brake
- Fast **horizontal** tool change
- Big time-saving and therefore an essentially increased efficiency
- Automatic self-centering
- Guaranteed exchangeability through highly precision grinding
- Easy and fast slide of the pneumatic clamping possible
- Quick connector and hose fitting everywhere on the market available
- Press brake tools are secured from dropping out

VIDEO

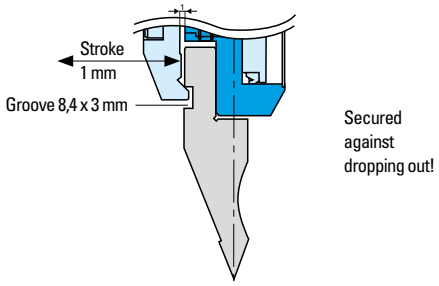
UKB-Clampings SWING / RAPID / CLARK

EXAMPLE OF USE

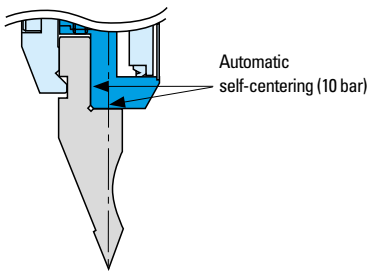


Punches/top tools UKB-System Amada are directly applicable

„RAPID®“ OPENED



„RAPID®“ CLOSED



Quantity of the needed clamping pieces
(Mounting distance 50 mm)

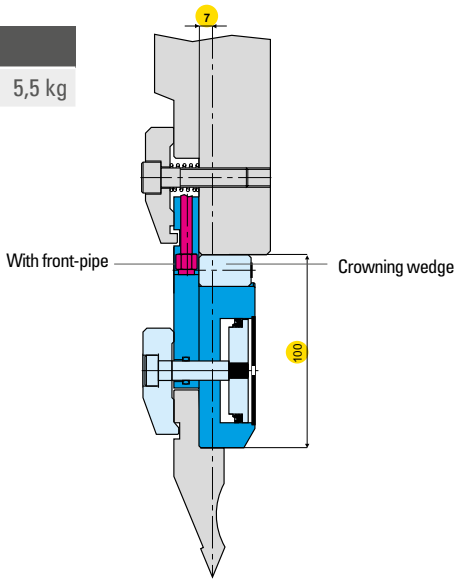
Length of the press brake (mm)	Quantity (pieces)
835	4
1.250	6
2.100	10
2.600	13
3.100	15
4.100	20

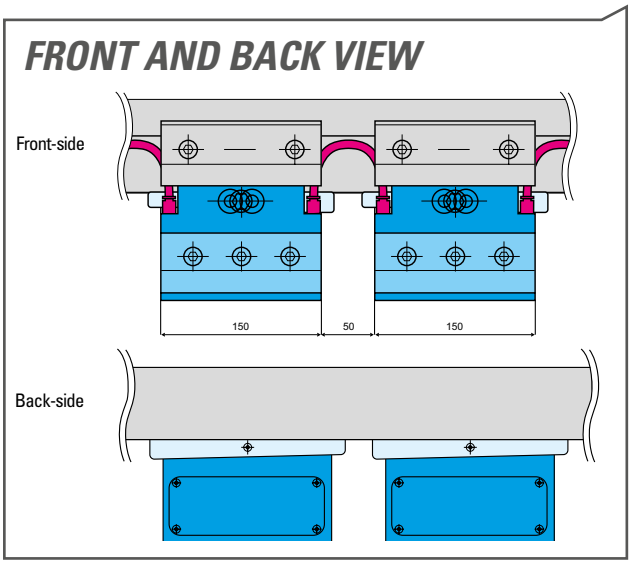
Pneumatic clamping „RAPID® “

50.820

150 mm	374,– €	5,5 kg

Delivery time on request

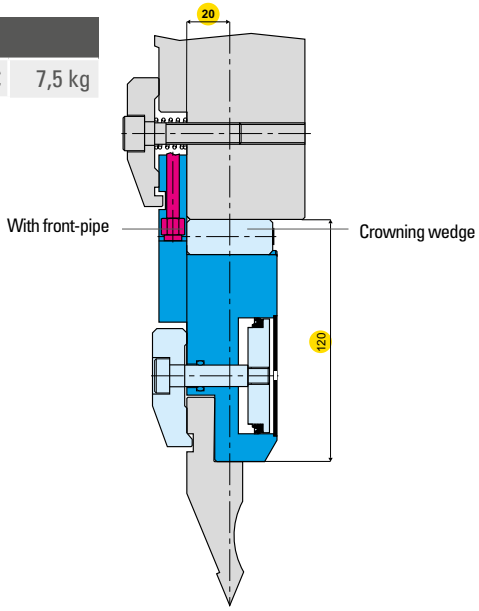




50.830

150 mm	396,– €	7,5 kg

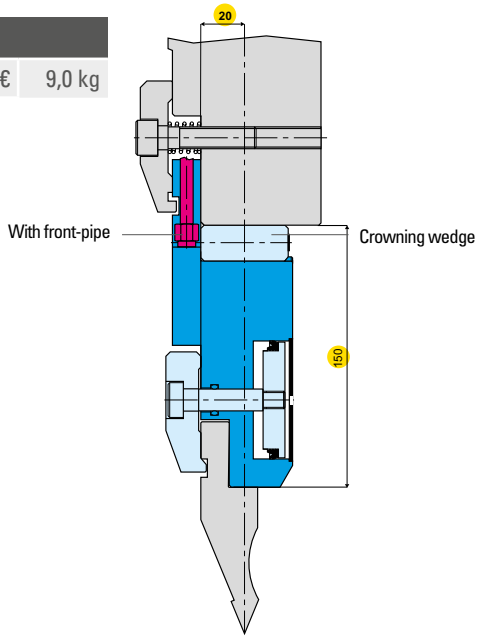
Delivery time on request



50.835

150 mm	420,– €	9,0 kg

Delivery time on request



Control unit for pneumatic clamping

50.650

Per piece	972,– €	10,0 kg

Delivery time on request

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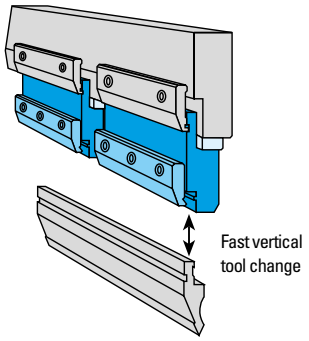
Pneumatic clamping „CLARK ®“

ADVANTAGES

- Cost-saving, easy and fast change of your press brake
- Fast **vertical** tool change
- Big time-saving and therefore an essentially increased efficiency
- Automatic self-centering
- Guaranteed exchangeability through highly precision grinding
- Easy and fast slide of the pneumatic clamping possible
- Quick connector and hose fitting everywhere on the market available
- Press brake tools are secured from dropping out

EXAMPLE OF USE

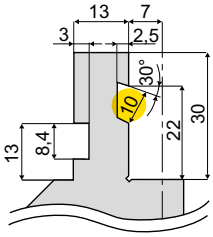


Punches/top tools UKB-System Amada are directly applicable by milling of an additional **groove 70.1050**

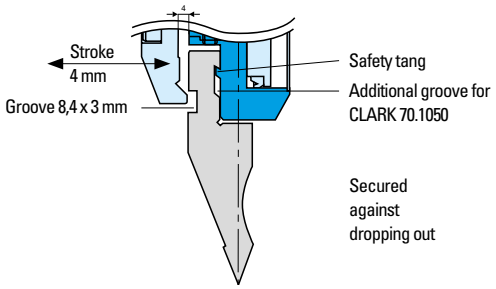
70.1050	
835 mm	55,– €
415 mm	40,– €
835 mm sectionalized	90,– €

Milling of the groove for CLARK in the punch/top tool

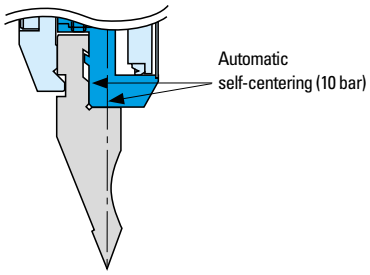
Delivery time 1-3 working days



„CLARK ®“ OPENED



„CLARK ®“ CLOSED



VIDEO

UKB-Clampings
SWING / RAPID / CLARK

Quantity of the needed clamping pieces
(Mounting distance 50 mm)

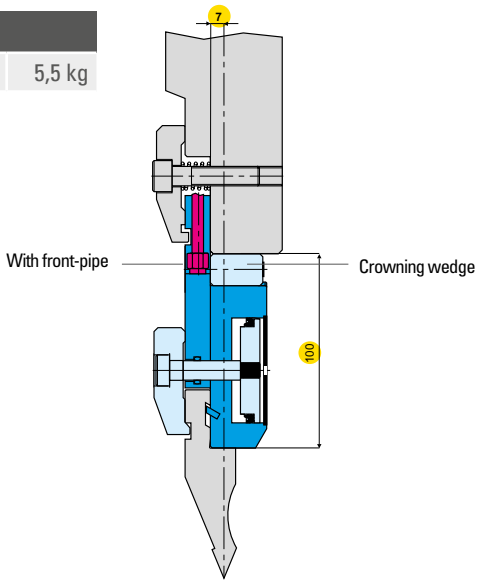
Length of the press brake (mm)	Quantity (pieces)
835	4
1.250	6
2.100	10
2.600	13
3.100	15
4.100	20

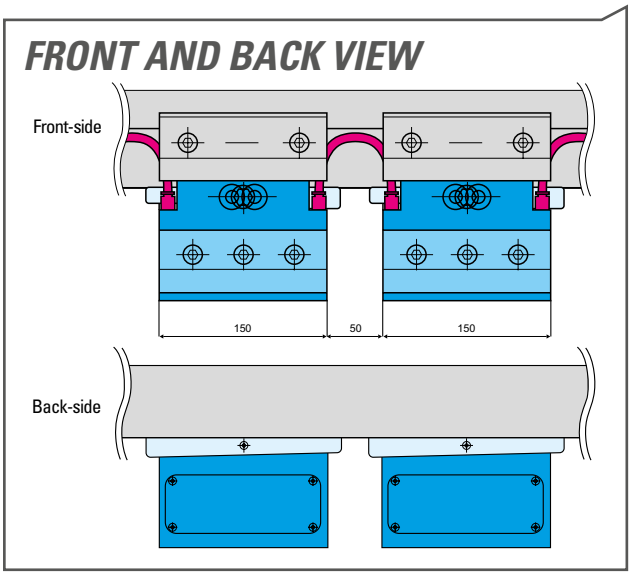
Pneumatic clamping „CLARK®“

50.635

150 mm	380,– €	5,5 kg

Delivery time on request

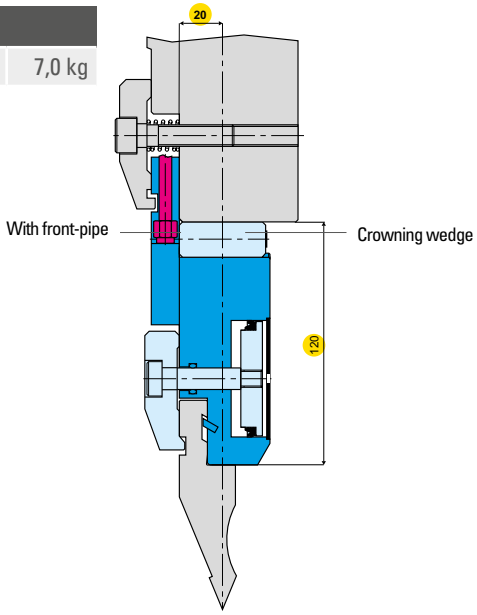




50.645

150 mm	402,– €	7,0 kg

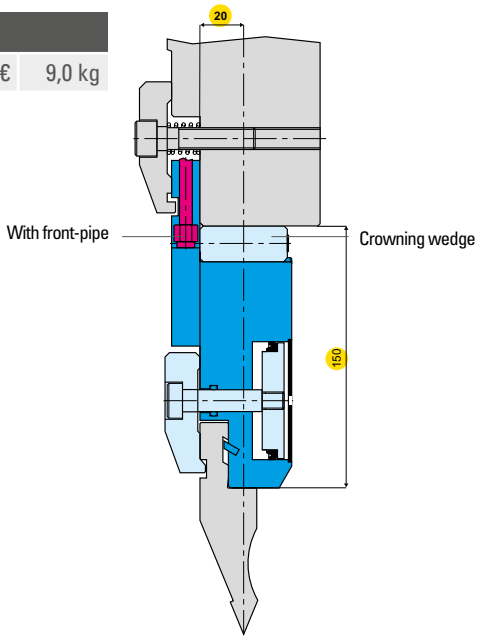
Delivery time on request



50.657

150 mm	122,– €	9,0 kg

Delivery time on request



Control unit for pneumatic clamping

50.650

Per piece	972,– €	10,0 kg

Delivery time on request

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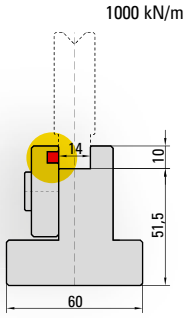
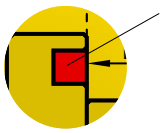
Die holder for centrical 1-V dies

22.010		24h
835 mm	404,– €	16,5 kg
415 mm	246,– €	8,2 kg

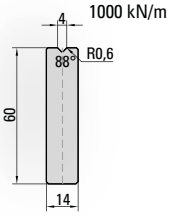
Die holder incl. clamp
with nylon-strip



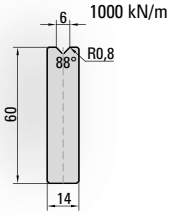


88° Centrical 1-V dies

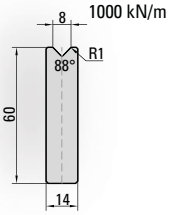
22.804		24h
835 mm	210,– €	5,5 kg
415 mm	128,– €	2,7 kg
835 mm sectionalized	336,– €	5,5 kg



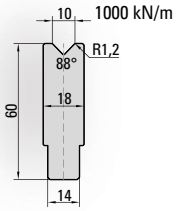
22.806		24h
835 mm	210,– €	5,4 kg
415 mm	128,– €	2,7 kg
835 mm sectionalized	336,– €	5,4 kg



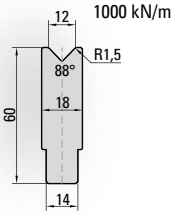
22.808		24h
835 mm	210,– €	5,4 kg
415 mm	128,– €	2,7 kg
835 mm sectionalized	336,– €	5,4 kg



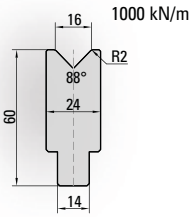
22.810		24h
835 mm	210,– €	6,5 kg
415 mm	128,– €	3,2 kg
835 mm sectionalized	336,– €	6,5 kg



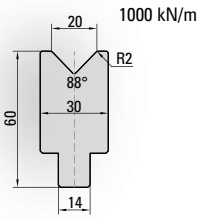
22.812		24h
835 mm	216,– €	6,4 kg
415 mm	130,– €	3,2 kg
835 mm sectionalized	342,– €	6,4 kg



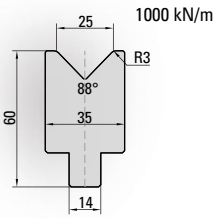
22.816		24h
835 mm	236,– €	8,0 kg
415 mm	140,– €	4,0 kg
835 mm sectionalized	368,– €	8,0 kg



22.820		24h
835 mm	254,– €	9,5 kg
415 mm	148,– €	4,7 kg
835 mm sectionalized	386,– €	9,5 kg



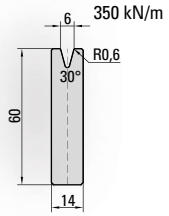
22.825		24h
835 mm	270,– €	10,6 kg
415 mm	158,– €	5,3 kg
835 mm sectionalized	402,– €	10,6 kg



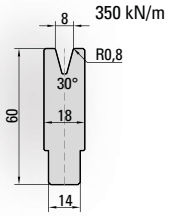
30° Centrical 1-V dies

UKB-MODIFICATION OF PRESS BRAKE TOOLS
see chapter 18

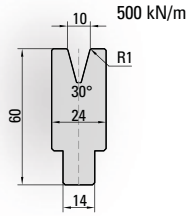
22.306		24h
835 mm	268,– €	5,3 kg
415 mm	156,– €	2,6 kg
835 mm sectionalized	396,– €	5,3 kg



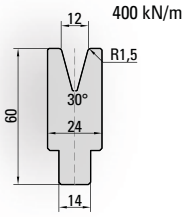
22.308		24h
835 mm	268,– €	6,3 kg
415 mm	156,– €	3,1 kg
835 mm sectionalized	396,– €	6,3 kg



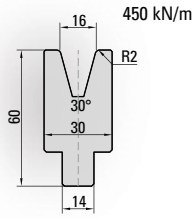
22.310		24h
835 mm	268,– €	7,8 kg
415 mm	156,– €	3,9 kg
835 mm sectionalized	396,– €	7,8 kg



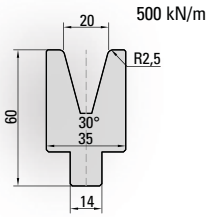
22.312		24h
835 mm	278,– €	7,6 kg
415 mm	162,– €	3,8 kg
835 mm sectionalized	412,– €	7,6 kg



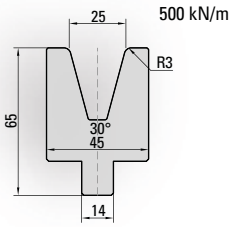
22.316		24h
835 mm	300,– €	8,8 kg
415 mm	174,– €	4,4 kg
835 mm sectionalized	436,– €	8,8 kg



22.320		24h
835 mm	316,– €	9,4 kg
415 mm	182,– €	4,7 kg
835 mm sectionalized	454,– €	9,4 kg

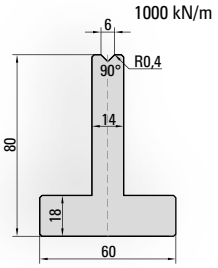


22.325		24h
835 mm	334,– €	12,7 kg
415 mm	190,– €	6,3 kg
835 mm sectionalized	476,– €	12,7 kg

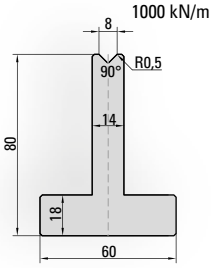


90° T-dies, H = 80 mm

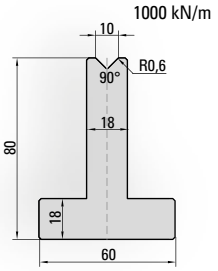
20.243		24h
835 mm	250,– €	12,6 kg
415 mm	148,– €	6,3 kg
835 mm sectionalized	376,– €	12,6 kg



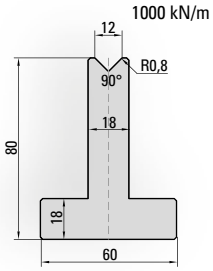
20.258		24h
835 mm	250,– €	12,6 kg
415 mm	148,– €	6,3 kg
835 mm sectionalized	376,– €	12,6 kg



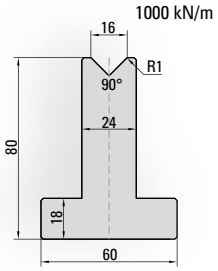
20.244		24h
835 mm	250,– €	14,2 kg
415 mm	148,– €	7,1 kg
835 mm sectionalized	376,– €	14,2 kg



20.245		24h
835 mm	250,– €	15,0 kg
415 mm	148,– €	7,5 kg
835 mm sectionalized	376,– €	15,0 kg



20.246		24h
835 mm	250,– €	17,5 kg
415 mm	148,– €	8,7 kg
835 mm sectionalized	376,– €	17,5 kg



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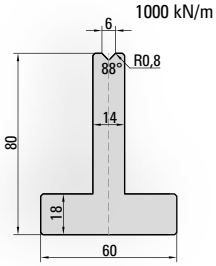
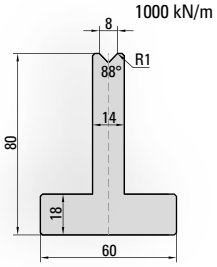
88° T-dies, H = 80 mm

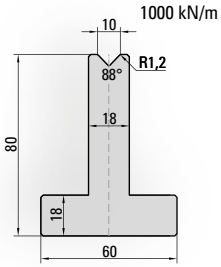
20.806		24h
835 mm	250,– €	12,6 kg
415 mm	148,– €	6,3 kg
835 mm sectionalized	376,– €	12,6 kg



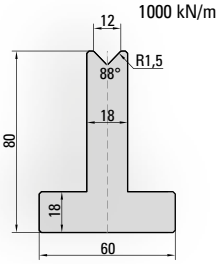
20.808		24h
835 mm	250,– €	12,6 kg
415 mm	148,– €	6,3 kg
835 mm sectionalized	376,– €	12,6 kg



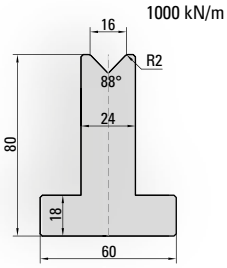
20.810		24h
835 mm	250,– €	14,2 kg
415 mm	148,– €	7,1 kg
835 mm sectionalized	376,– €	14,2 kg



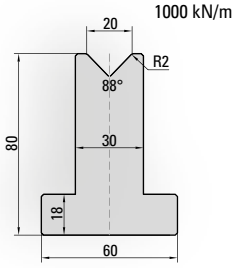
20.371		24h
835 mm	250,– €	14,1 kg
415 mm	148,– €	7,0 kg
835 mm sectionalized	376,– €	14,1 kg



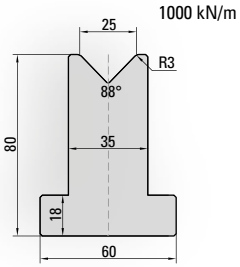
20.327		24h
835 mm	250,– €	16,4 kg
415 mm	148,– €	8,2 kg
835 mm sectionalized	376,– €	16,4 kg



20.310		24h
835 mm	250,– €	18,6 kg
415 mm	148,– €	9,3 kg
835 mm sectionalized	376,– €	18,6 kg



20.309		24h
835 mm	250,– €	20,2 kg
415 mm	148,– €	10,1 kg
835 mm sectionalized	376,– €	20,2 kg



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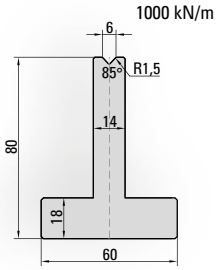
85° T-dies, H = 80 mm

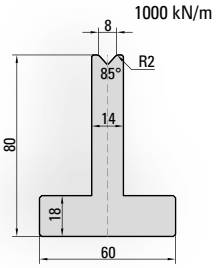
20.506 — 24h

835 mm	250,– €	12,6 kg
415 mm	148,– €	6,3 kg
835 mm sectionalized	376,– €	12,6 kg



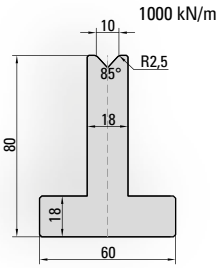
20.508 — 24h

835 mm	250,– €	12,6 kg
415 mm	148,– €	6,3 kg
835 mm sectionalized	376,– €	12,6 kg



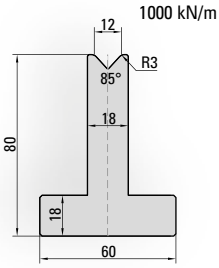
20.510 — 24h

835 mm	250,– €	14,2 kg
415 mm	148,– €	7,1 kg
835 mm sectionalized	376,– €	14,2 kg



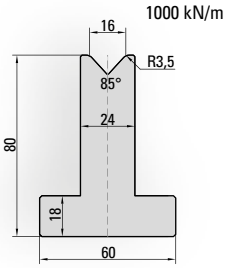
20.512 — 24h

835 mm	250,– €	14,1 kg
415 mm	148,– €	7,0 kg
835 mm sectionalized	376,– €	14,1 kg



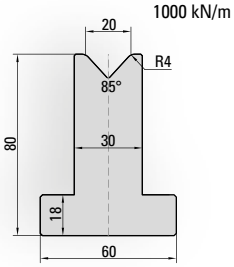
20.516 — 24h

835 mm	250,– €	16,4 kg
415 mm	148,– €	8,2 kg
835 mm sectionalized	376,– €	16,4 kg



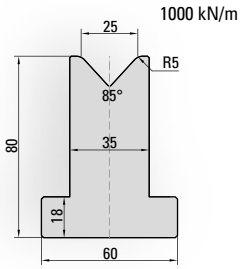
20.520 — 24h

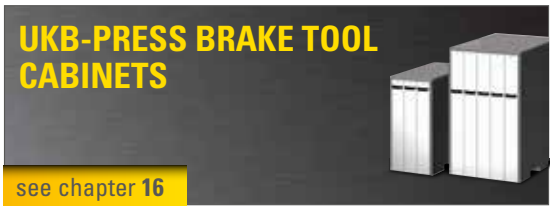
835 mm	250,– €	18,6 kg
415 mm	148,– €	9,3 kg
835 mm sectionalized	376,– €	18,6 kg



20.525 — 24h

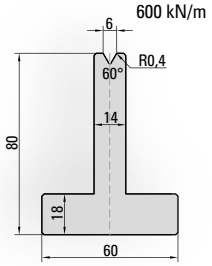
835 mm	250,– €	20,2 kg
415 mm	148,– €	10,1 kg
835 mm sectionalized	376,– €	20,2 kg



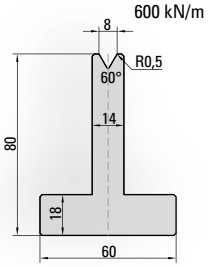


60° T-dies, H = 80 mm

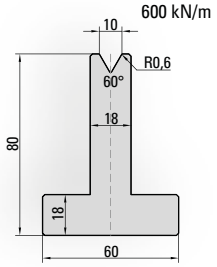
20.297		24h
835 mm	272,– €	13,0 kg
415 mm	158,– €	6,5 kg
835 mm sectionalized	398,– €	13,0 kg



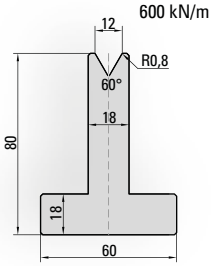
20.298		24h
835 mm	272,– €	13,0 kg
415 mm	158,– €	6,5 kg
835 mm sectionalized	398,– €	13,0 kg



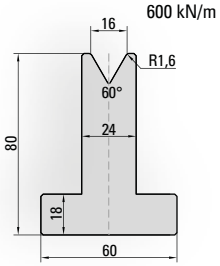
20.299		24h
835 mm	272,– €	15,0 kg
415 mm	158,– €	7,5 kg
835 mm sectionalized	398,– €	15,0 kg



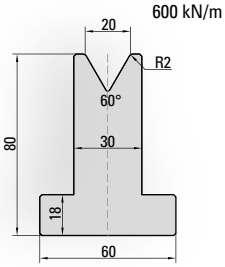
20.300		24h
835 mm	272,– €	15,0 kg
415 mm	158,– €	7,5 kg
835 mm sectionalized	398,– €	15,0 kg



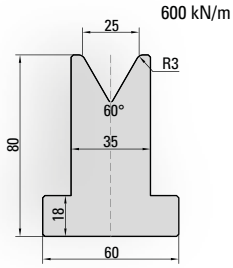
20.301		24h
835 mm	272,– €	17,5 kg
415 mm	158,– €	8,7 kg
835 mm sectionalized	398,– €	17,5 kg



20.308		24h
835 mm	272,– €	18,1 kg
415 mm	158,– €	9,0 kg
835 mm sectionalized	398,– €	18,1 kg



20.311		24h
835 mm	272,– €	19,5 kg
415 mm	158,– €	9,7 kg
835 mm sectionalized	398,– €	19,5 kg



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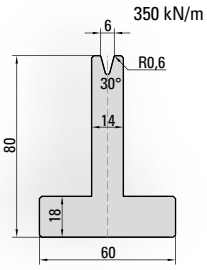
30° T-dies, H = 80 mm

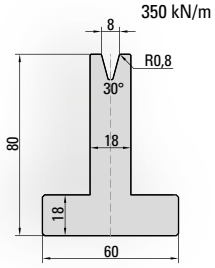
20.317 — 24h

835 mm	302,– €	12,5 kg
415 mm	174,– €	6,2 kg
835 mm sectionalized	430,– €	12,5 kg



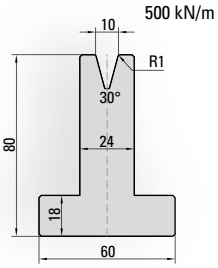
20.318 — 24h

835 mm	302,– €	14,0 kg
415 mm	174,– €	7,0 kg
835 mm sectionalized	430,– €	14,0 kg



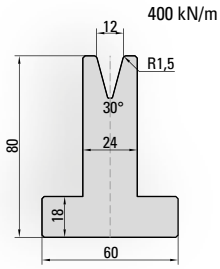
20.319 — 24h

835 mm	302,– €	16,2 kg
415 mm	174,– €	8,1 kg
835 mm sectionalized	430,– €	16,2 kg



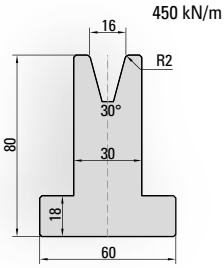
20.320 — 24h

835 mm	302,– €	15,9 kg
415 mm	174,– €	7,9 kg
835 mm sectionalized	430,– €	15,9 kg



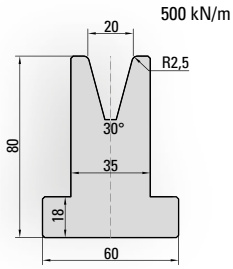
20.321 — 24h

835 mm	302,– €	17,8 kg
415 mm	174,– €	8,9 kg
835 mm sectionalized	430,– €	17,8 kg



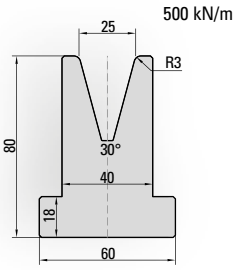
20.322 — 24h

835 mm	302,– €	19,0 kg
415 mm	174,– €	9,5 kg
835 mm sectionalized	430,– €	19,0 kg



20.323 — 24h

835 mm	302,– €	19,6 kg
415 mm	174,– €	9,8 kg
835 mm sectionalized	430,– €	19,6 kg

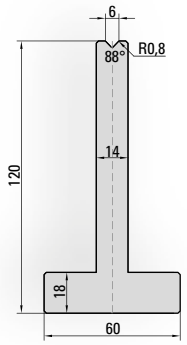


88° T-dies, H = 120 mm

21.806 — 24h

835 mm	406,– €	16,5 kg
415 mm	230,– €	8,2 kg
835 mm sectionalized	550,– €	16,5 kg

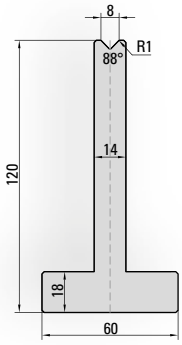
1000 kN/m



21.808 — 24h

835 mm	406,– €	16,5 kg
415 mm	230,– €	8,2 kg
835 mm sectionalized	550,– €	16,5 kg

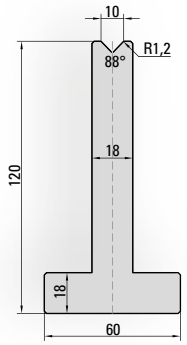
1000 kN/m



21.810 — 24h

835 mm	406,– €	19,0 kg
415 mm	230,– €	9,5 kg
835 mm sectionalized	550,– €	19,0 kg

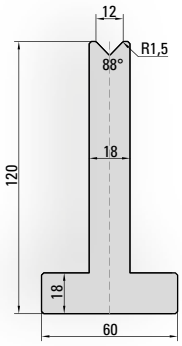
1000 kN/m



20.382 — 24h

835 mm	406,– €	18,8 kg
415 mm	230,– €	9,4 kg
835 mm sectionalized	550,– €	18,8 kg

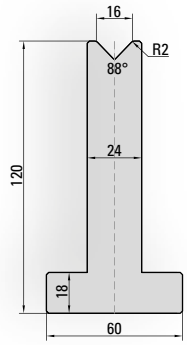
1000 kN/m



20.383 — 24h

835 mm	406,– €	22,7 kg
415 mm	230,– €	11,3 kg
835 mm sectionalized	550,– €	22,7 kg

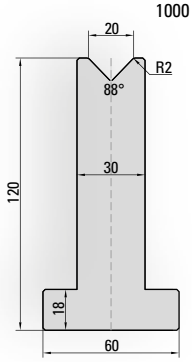
1000 kN/m



20.384 — 24h

835 mm	406,– €	26,4 kg
415 mm	230,– €	13,2 kg
835 mm sectionalized	550,– €	26,4 kg

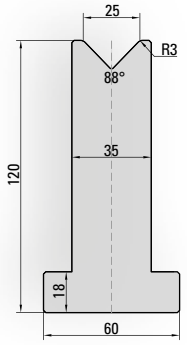
1000 kN/m



20.385 — 24h

835 mm	406,– €	29,4 kg
415 mm	230,– €	14,7 kg
835 mm sectionalized	550,– €	29,4 kg

1000 kN/m



UKB-Z-TOOL HOLDERS
AND Z-TOOL INSERTS
Z 1,0 – 15,0
see chapter 09

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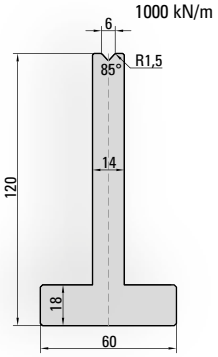
85° T-dies, H = 120 mm

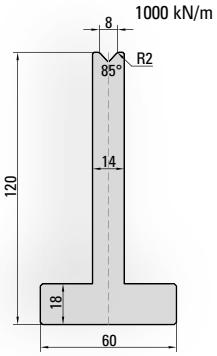
21.506 — 24h

835 mm	406,– €	16,5 kg
415 mm	230,– €	8,2 kg
835 mm sectionalized	550,– €	16,5 kg



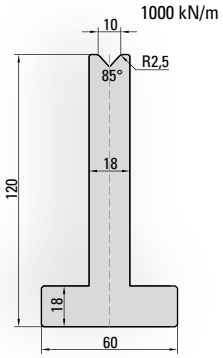
21.508 — 24h

835 mm	406,– €	16,5 kg
415 mm	230,– €	8,2 kg
835 mm sectionalized	550,– €	16,5 kg



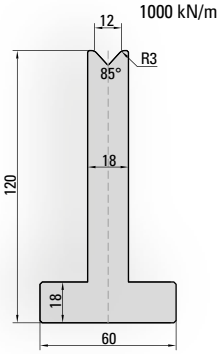
21.510 — 24h

835 mm	406,– €	19,0 kg
415 mm	230,– €	9,5 kg
835 mm sectionalized	550,– €	19,0 kg



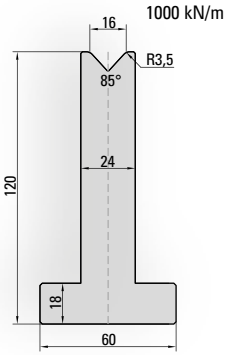
21.512 — 24h

835 mm	406,– €	18,8 kg
415 mm	230,– €	9,4 kg
835 mm sectionalized	550,– €	18,8 kg



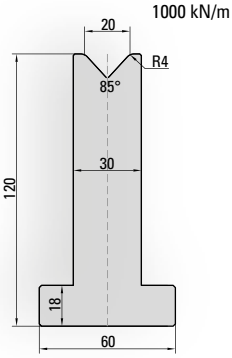
21.516 — 24h

835 mm	406,– €	22,7 kg
415 mm	230,– €	11,3 kg
835 mm sectionalized	550,– €	22,7 kg



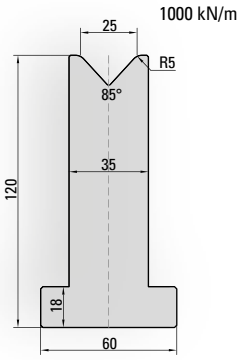
21.520 — 24h

835 mm	406,– €	26,4 kg
415 mm	230,– €	13,2 kg
835 mm sectionalized	550,– €	26,4 kg



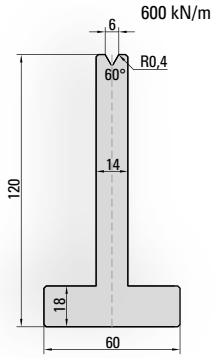
21.525 — 24h

835 mm	406,– €	29,4 kg
415 mm	230,– €	14,7 kg
835 mm sectionalized	550,– €	29,4 kg

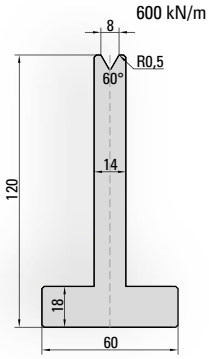


60° T-dies, H = 120 mm

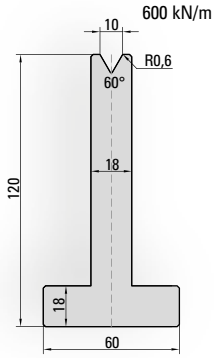
20.386		24h
835 mm	422,– €	16,3 kg
415 mm	236,– €	8,1 kg
835 mm sectionalized	568,– €	16,3 kg



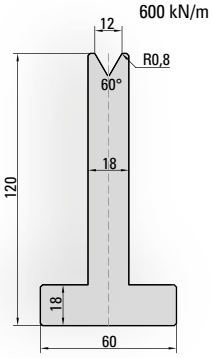
20.387		24h
835 mm	422,– €	16,2 kg
415 mm	236,– €	8,1 kg
835 mm sectionalized	568,– €	16,2 kg



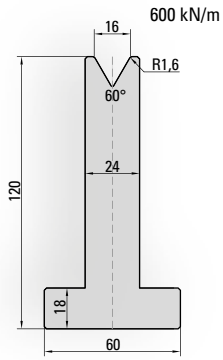
20.388		24h
835 mm	422,– €	18,8 kg
415 mm	236,– €	9,4 kg
835 mm sectionalized	568,– €	18,8 kg



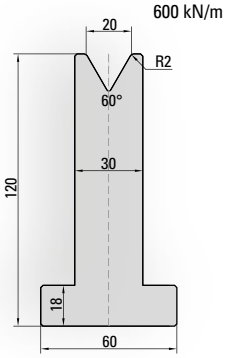
20.389		24h
835 mm	422,– €	18,7 kg
415 mm	236,– €	9,3 kg
835 mm sectionalized	568,– €	18,7 kg



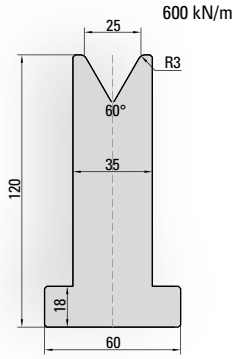
20.390		24h
835 mm	422,– €	22,4 kg
415 mm	236,– €	11,2 kg
835 mm sectionalized	568,– €	22,4 kg



20.391		24h
835 mm	422,– €	26,0 kg
415 mm	236,– €	13,0 kg
835 mm sectionalized	568,– €	26,0 kg



20.392		24h
835 mm	422,– €	28,7 kg
415 mm	236,– €	14,3 kg
835 mm sectionalized	568,– €	28,7 kg



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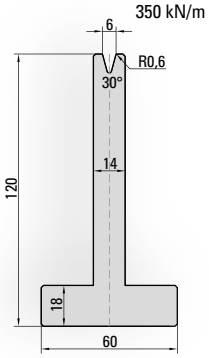
30° T-dies, H = 120 mm

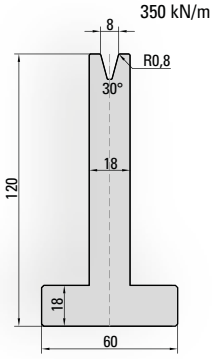
20.351 — 24h

835 mm	452,– €	16,2 kg
415 mm	252,– €	8,1 kg
835 mm sectionalized	596,– €	16,2 kg



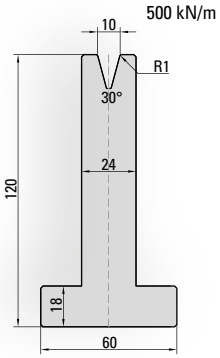
20.352 — 24h

835 mm	452,– €	18,7 kg
415 mm	252,– €	9,3 kg
835 mm sectionalized	596,– €	18,7 kg



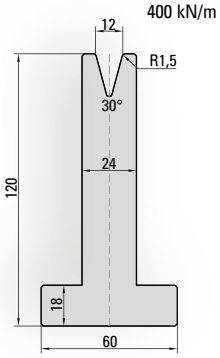
20.353 — 24h

835 mm	452,– €	22,5 kg
415 mm	252,– €	11,2 kg
835 mm sectionalized	596,– €	22,5 kg



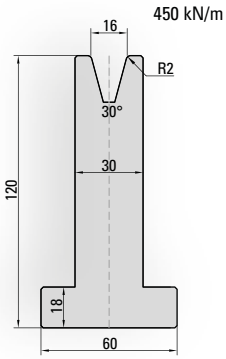
20.354 — 24h

835 mm	452,– €	22,2 kg
415 mm	252,– €	11,1 kg
835 mm sectionalized	596,– €	22,2 kg



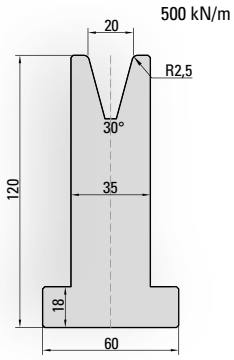
20.401 — 24h

835 mm	452,– €	25,7 kg
415 mm	252,– €	12,8 kg
835 mm sectionalized	596,– €	25,7 kg



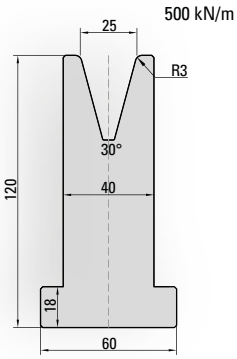
20.402 — 24h

835 mm	452,– €	28,0 kg
415 mm	252,– €	14,0 kg
835 mm sectionalized	596,– €	28,0 kg



20.403 — 24h

835 mm	452,– €	30,0 kg
415 mm	252,– €	15,0 kg
835 mm sectionalized	596,– €	30,0 kg



UKB-HOLDERS FOR BLADES AND BLADES R 0,5 – 6,0

see chapter 07

UKB-SYSTEM AMADA DIES

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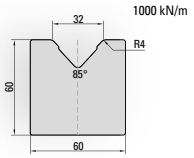
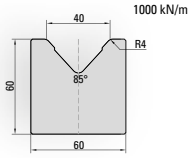
85° 1-V dies

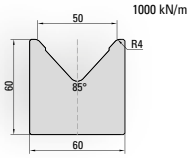
20.210		24h
835 mm	200,– €	22,0 kg
415 mm	118,– €	11,0 kg
835 mm sectionalized	358,– €	22,0 kg



20.211		24h
835 mm	200,– €	21,0 kg
415 mm	118,– €	10,5 kg
835 mm sectionalized	358,– €	21,0 kg

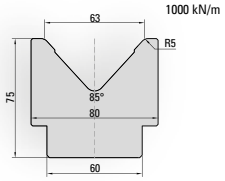


20.212		24h
835 mm	200,– €	19,0 kg
415 mm	118,– €	9,5 kg
835 mm sectionalized	358,– €	19,0 kg



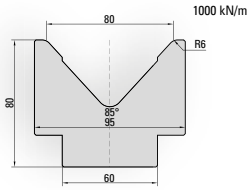
20.213		24h
835 mm	320,– €	29,0 kg
415 mm	188,– €	14,5 kg
835 mm sectionalized	554,– €	29,0 kg

1200 kN/m if the tool clamping has the corresponding load



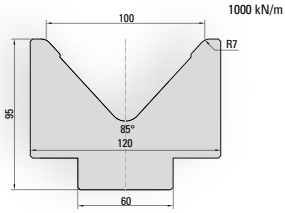
20.214		24h
835 mm	396,– €	33,2 kg
415 mm	234,– €	16,6 kg
835 mm sectionalized	676,– €	33,2 kg

1200 kN/m if the tool clamping has the corresponding load



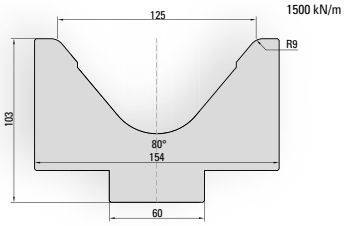
20.215		24h
835 mm	460,– €	50,0 kg
415 mm	274,– €	25,0 kg
835 mm sectionalized	780,– €	50,0 kg

1500 kN/m if the tool clamping has the corresponding load

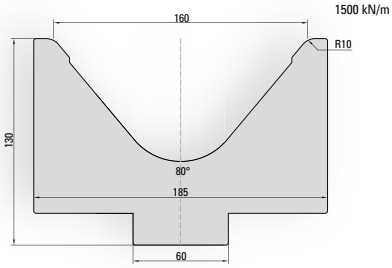


80° 1-V dies

21.125		24h
415 mm	356,– €	31,0 kg
200 mm	200,– €	15,0 kg

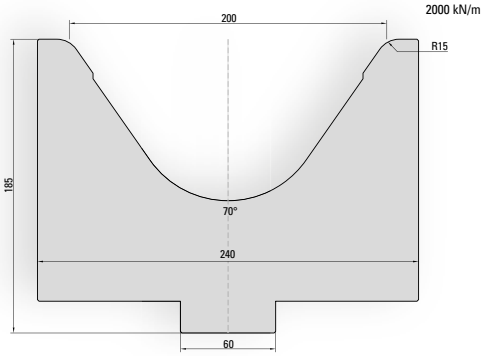


21.160		24h
415 mm	480,– €	46,5 kg
200 mm	270,– €	22,4 kg



70° 1-V die

21.200		24h
415 mm	988,– €	88,0 kg
200 mm	550,– €	42,5 kg



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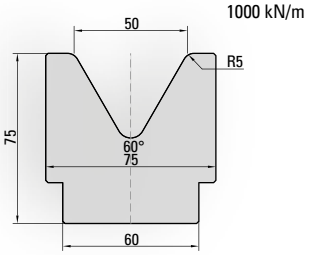
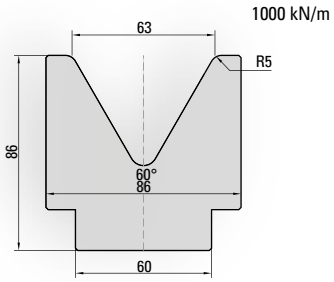
60° 1-V dies

20.650		24h
835 mm	484,– €	27,5 kg
415 mm	274,– €	13,7 kg
835 mm sectionalized	714,– €	27,5 kg

1200 kN/m if the tool clamping has the corresponding load

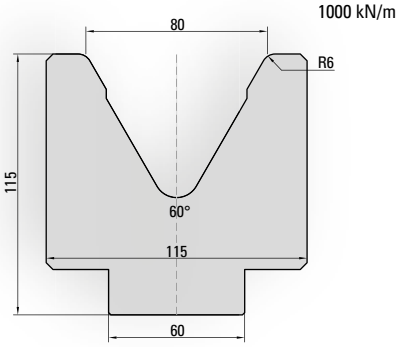


20.370		24h
835 mm	576,– €	34,3 kg
415 mm	326,– €	17,1 kg
835 mm sectionalized	848,– €	34,3 kg

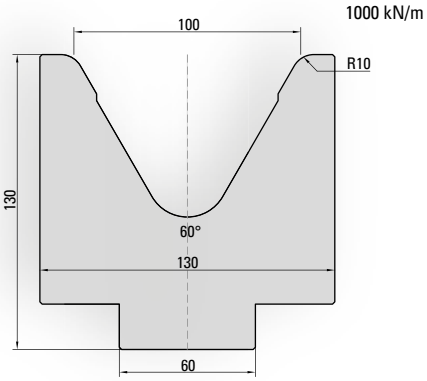


20.680		24h
835 mm	820,– €	60,0 kg
415 mm	478,– €	30,0 kg
835 mm sectionalized	1.228,– €	60,0 kg

1200 kN/m if the tool clamping has the corresponding load

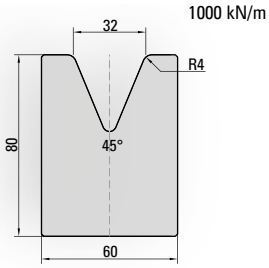


20.610		24h
415 mm	514,– €	37,0 kg
835 mm sectionalized	1.440,– €	74,0 kg

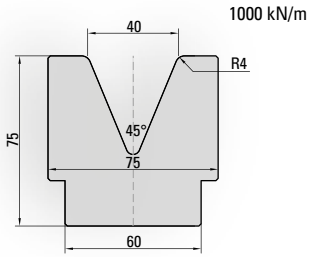


45° 1-V dies

20.484		24h
835 mm	272,– €	27,5 kg
415 mm	164,– €	13,7 kg
835 mm sectionalized	440,– €	27,5 kg

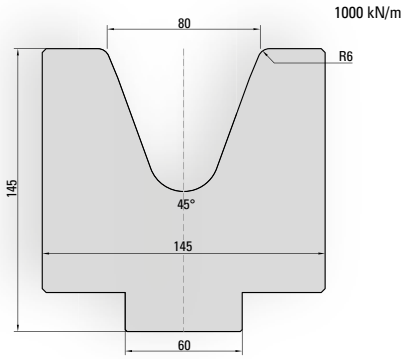


20.440		24h
835 mm	384,– €	28,5 kg
415 mm	224,– €	14,2 kg
835 mm sectionalized	614,– €	28,5 kg



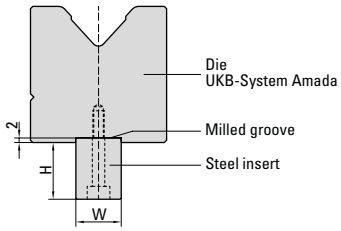
20.380		24h
415 mm	584,– €	50,0 kg
200 mm	360,– €	24,0 kg

1500 kN/m if the tool clamping has the corresponding load



MODIFICATION EXAMPLE

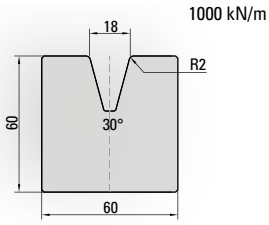
By mounting a steel insert (page 246) dies UKB-System Amada can also be used in other clampings.



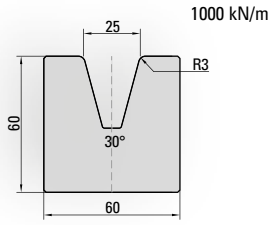
30° 1-V dies

20.494		24h
835 mm	228,– €	22,0 kg
415 mm	132,– €	11,0 kg
835 mm sectionalized	372,– €	22,0 kg

1200 kN/m if the tool clamping has the corresponding load



20.325		24h
835 mm	268,– €	20,1 kg
415 mm	150,– €	10,0 kg
835 mm sectionalized	416,– €	20,1 kg



UKB-SYSTEM AMADA DIES

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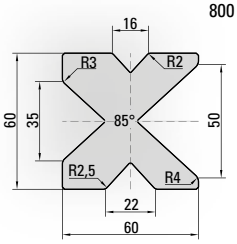
Die blocks

21.207 — 24h

800 kN/m

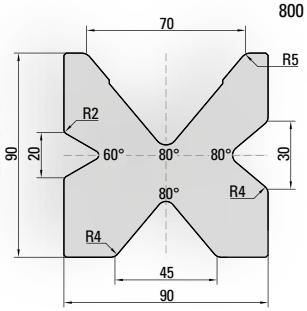
835 mm	260,– €	15,5 kg
415 mm	156,– €	7,7 kg
835 mm sectionalized	424,– €	15,5 kg



28.820 — 24h

800 kN/m

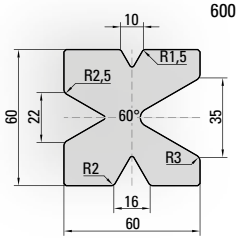
835 mm	594,– €	36,0 kg
415 mm	346,– €	18,0 kg
835 mm sectionalized	1.036,– €	36,0 kg



20.350 — 24h

600 kN/m

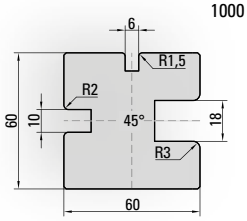
835 mm	362,– €	17,8 kg
415 mm	206,– €	8,9 kg
835 mm sectionalized	528,– €	17,8 kg



21.209 — 24h

1000 kN/m

835 mm	246,– €	20,0 kg
415 mm	148,– €	10,0 kg
835 mm sectionalized	422,– €	20,0 kg

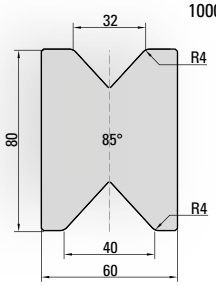


20.820 — 24h

1000 kN/m

835 mm	330,– €	27,0 kg
415 mm	192,– €	13,5 kg
835 mm sectionalized	590,– €	27,0 kg

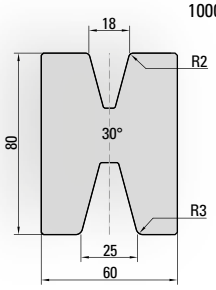
1500 kN/m if the tool clamping has the corresponding load



20.830 — 24h

1000 kN/m

835 mm	392,– €	26,0 kg
415 mm	222,– €	13,0 kg
835 mm sectionalized	652,– €	26,0 kg



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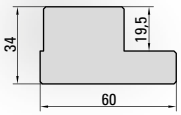
Die holders

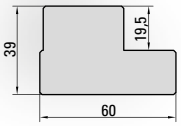
1000 kN/m

20.200		24h
835 mm	154,– €	9,3 kg
415 mm	88,– €	4,6 kg



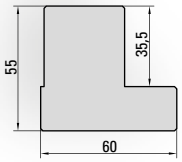
1000 kN/m

20.316		24h
835 mm	160,– €	11,5 kg
415 mm	92,– €	5,7 kg



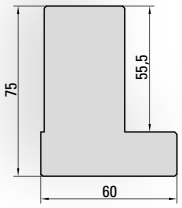
1000 kN/m

20.201		24h
835 mm	174,– €	14,2 kg
415 mm	100,– €	7,1 kg



1000 kN/m

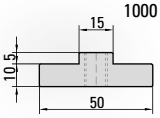
20.306		24h
835 mm	214,– €	18,9 kg
415 mm	122,– €	9,4 kg



Die holders for centrical 2-V dies

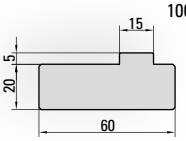
1000 kN/m

20.287		24h
835 mm	140,– €	4,0 kg
415 mm	82,– €	2,0 kg



1000 kN/m

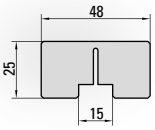
20.400		24h
835 mm	194,– €	8,3 kg
415 mm	110,– €	4,1 kg



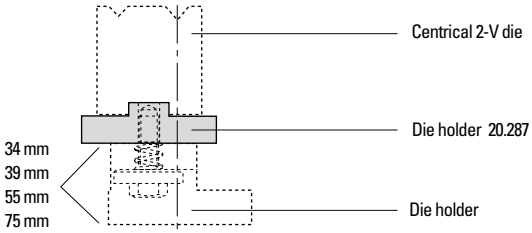
Clamping piece for centrical 2-V dies

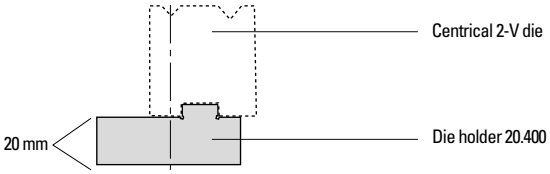
20.336		24h
Per piece	24,– €	0,2 kg

Clamping piece to fix small centrical 2-V dies on the die holder 20.287 and 20.400



EXAMPLE OF USE





To use on press brakes with lower daylight

UKB-SYSTEM AMADA DIES

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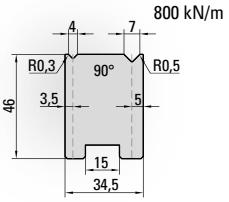
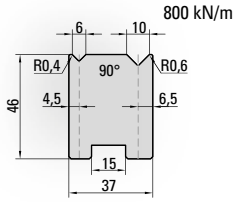
90° Centrical 2-V dies

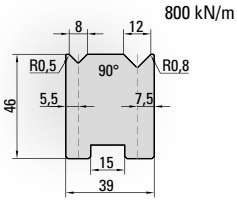
20.275		24h
835 mm	212,– €	9,5 kg
415 mm	122,– €	4,7 kg
835 mm sectionalized	354,– €	9,5 kg



20.276		24h
835 mm	212,– €	10,0 kg
415 mm	122,– €	5,0 kg
835 mm sectionalized	354,– €	10,0 kg

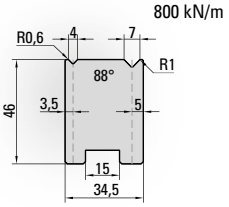


20.277		24h
835 mm	212,– €	10,5 kg
415 mm	122,– €	5,2 kg
835 mm sectionalized	354,– €	10,5 kg

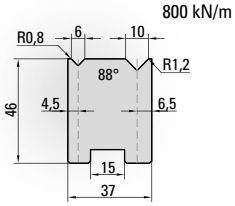


88° Centrical 2-V dies

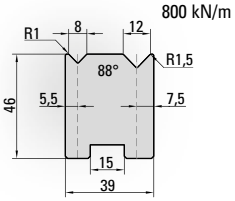
21.275		24h
835 mm	212,– €	9,5 kg
415 mm	122,– €	4,7 kg
835 mm sectionalized	354,– €	9,5 kg



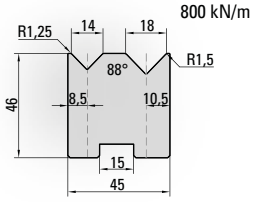
21.276		24h
835 mm	212,– €	10,0 kg
415 mm	122,– €	5,0 kg
835 mm sectionalized	354,– €	10,0 kg



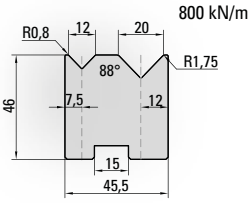
20.339		24h
835 mm	212,– €	10,8 kg
415 mm	122,– €	5,4 kg
835 mm sectionalized	354,– €	10,8 kg



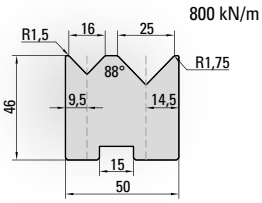
20.278		24h
835 mm	214,– €	12,0 kg
415 mm	126,– €	6,0 kg
835 mm sectionalized	358,– €	12,0 kg



20.279		24h
835 mm	214,– €	12,0 kg
415 mm	126,– €	6,0 kg
835 mm sectionalized	358,– €	12,0 kg



20.280		24h
835 mm	218,– €	13,0 kg
415 mm	128,– €	6,5 kg
835 mm sectionalized	362,– €	13,0 kg



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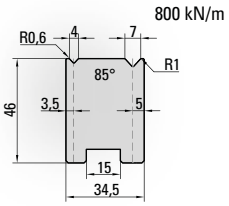
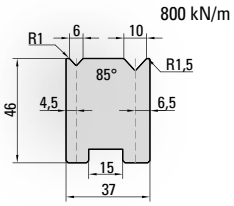
85° Centrical 2-V dies

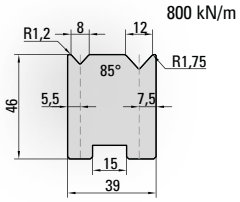
20.344		24h
835 mm	212,– €	9,5 kg
415 mm	122,– €	4,7 kg
835 mm sectionalized	365,– €	9,5 kg



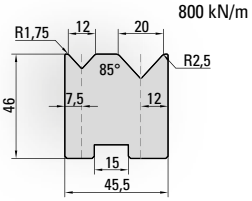
20.345		24h
835 mm	212,– €	10,0 kg
415 mm	122,– €	5,0 kg
835 mm sectionalized	354,– €	10,0 kg



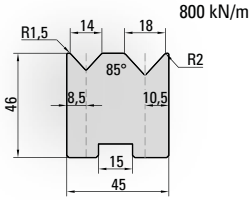
20.346		24h
835 mm	212,– €	10,5 kg
415 mm	122,– €	5,3 kg
835 mm sectionalized	354,– €	10,5 kg



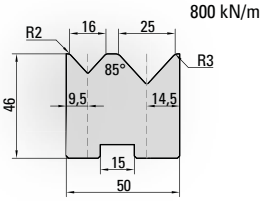
20.347		24h
835 mm	214,– €	12,0 kg
415 mm	126,– €	6,0 kg
835 mm sectionalized	358,– €	12,0 kg



20.349		24h
835 mm	214,– €	12,0 kg
415 mm	126,– €	6,0 kg
835 mm sectionalized	358,– €	12,0 kg

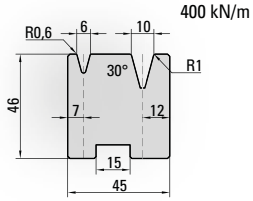


20.348		24h
835 mm	218,– €	13,0 kg
415 mm	128,– €	6,5 kg
835 mm sectionalized	362,– €	13,0 kg

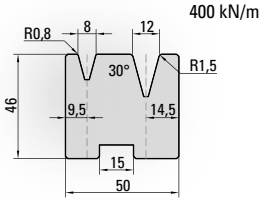


30° Centrical 2-V dies

20.438		24h
835 mm	288,– €	12,5 kg
415 mm	168,– €	6,2 kg
835 mm sectionalized	436,– €	12,5 kg



20.478		24h
835 mm	288,– €	13,0 kg
415 mm	168,– €	6,5 kg
835 mm sectionalized	436,– €	13,0 kg



UKB-FIELD SERVICE

- *Individual advice and sale*
- *Technical solutions for special bending tasks*
- *Test bending on-site or at the UKB-test center*
- *Pick up service for tools to rework*

UKB-SYSTEM AMADA DIES

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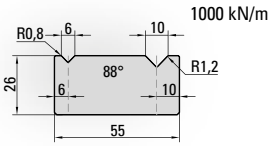
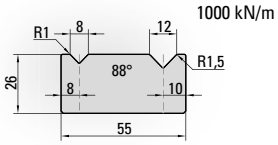
88° 2-V dies

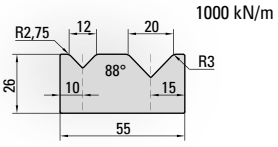
21.202		24h
835 mm	134,– €	9,0 kg
415 mm	80,– €	4,5 kg



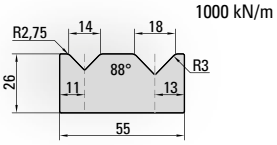
20.338		24h
835 mm	134,– €	9,0 kg
415 mm	80,– €	4,5 kg



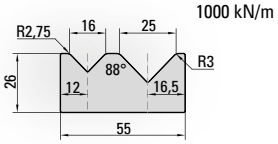
20.204		24h
835 mm	134,– €	8,5 kg
415 mm	80,– €	4,2 kg



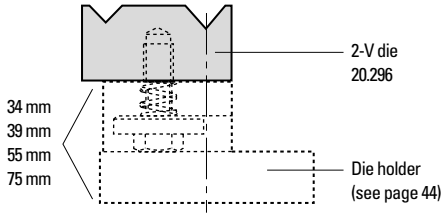
20.296		24h
835 mm	134,– €	9,0 kg
415 mm	80,– €	4,5 kg



20.205		24h
835 mm	134,– €	8,0 kg
415 mm	80,– €	4,0 kg

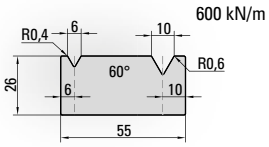


EXAMPLE OF USE

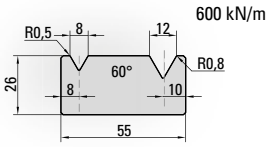


60° 2-V dies

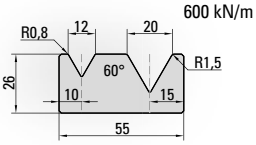
20.235		24h
835 mm	166,– €	9,0 kg
415 mm	98,– €	4,5 kg



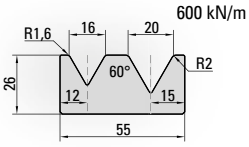
20.229		24h
835 mm	166,– €	8,5 kg
415 mm	98,– €	4,2 kg



20.230		24h
835 mm	166,– €	8,0 kg
415 mm	98,– €	4,0 kg

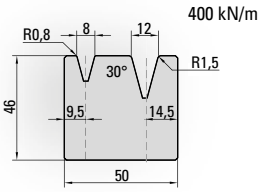


20.267		24h
835 mm	166,– €	7,5 kg
415 mm	98,– €	3,7 kg



30° 2-V die

20.418		24h
835 mm	274,– €	13,5 kg
415 mm	160,– €	6,7 kg



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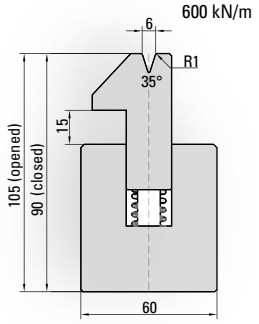
Spring-loaded flattening dies

20.264 24h

835 mm	566,– €	30,5 kg
415 mm	340,– €	15,2 kg

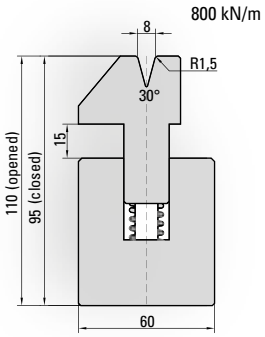
Max. 1,0 mm material thickness
R_m = 400 N/mm²



20.303 24h

835 mm	620,– €	33,0 kg
415 mm	374,– €	16,5 kg

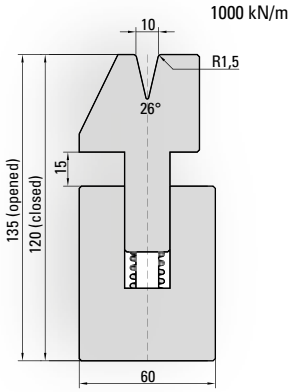
Max. 1,5 mm material thickness
R_m = 400 N/mm²



20.231 24h

835 mm	694,– €	41,5 kg
415 mm	428,– €	20,7 kg

Max. 2,0 mm material thickness
R_m = 400 N/mm²



20.305 24h

835 mm	818,– €	43,5 kg
415 mm	502,– €	21,7 kg

Max. 3,0 mm material thickness
R_m = 400 N/mm²

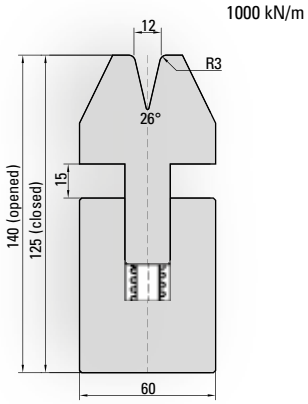


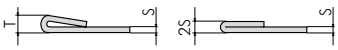
Table of force for flattening

Material: R_m = 400 N/mm² (St)

S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	9	3,0	23	1,2
0,8	12	3,0	32	1,6
1,0	15	3,5	40	2,0
1,25	17	3,5	50	2,5
1,5	22	4,6	63	3,0
2,0	30	5,5	80	4,0
2,5	55	6,5	90	5,0
3,0	70	8,0	100	6,0

Material: R_m = 700 N/mm² (VA)

S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	15	3,0	35	1,2
0,8	20	3,0	50	1,6
1,0	25	3,5	60	2,0
1,25	26	3,5	80	2,5
1,5	38	4,6	95	3,0
2,0	50	5,5	130	4,0



Pneumatic flattening dies

ADVANTAGES

- Faster bending through 15 mm less stroke
- More precise bending
- Less attrition
- Connectable to existing free control-output I/0

VIDEO

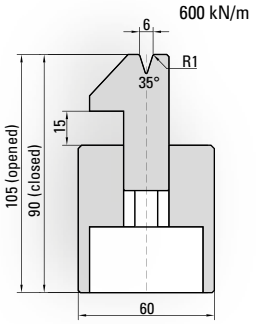
UKB-Flattening tools

21.264

835 mm	958,– €	30,5 kg
415 mm	736,– €	15,2 kg

Max. 1,0 mm material thickness
R_m = 400 N/mm²

Delivery time on request

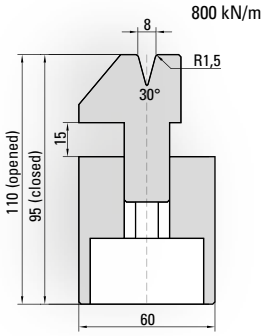


21.303

835 mm	1.034,– €	33,0 kg
415 mm	792,– €	16,5 kg

Max. 1,5 mm material thickness
R_m = 400 N/mm²

Delivery time on request

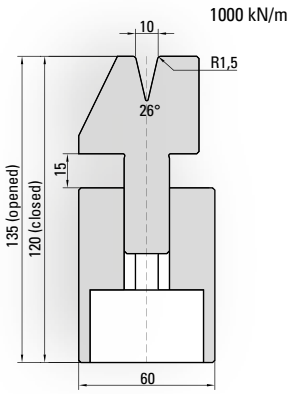


21.231

835 mm	1.094,– €	41,5 kg
415 mm	840,– €	20,7 kg

Max. 2,0 mm material thickness
R_m = 400 N/mm²

Delivery time on request

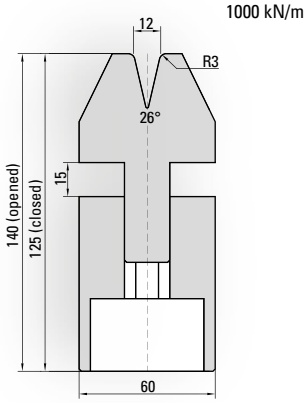


21.305

835 mm	1.236,– €	43,5 kg
415 mm	928,– €	21,7 kg

Max. 3,0 mm material thickness
R_m = 400 N/mm²

Delivery time on request



50.720

Per piece	240,– €	3,5 kg

Accessory kit for pneumatic flattening dies consist of pressure-reducing valve and 12/24V electromagnetic valve

Delivery time on request

UKB-SPECIAL TOOLS

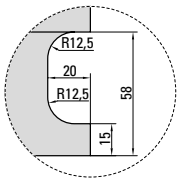
see chapter 12

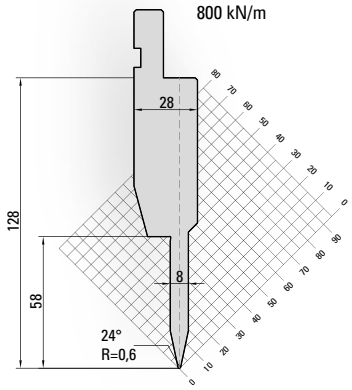
Phone +49 (0) 27 36 / 44 42 - 0 . Fax +49 (0) 27 36 / 44 42 - 22

Flattening punches/top tools and flattening dies

11.550 — 24h

835 mm	580,– €	17,5 kg
415 mm	336,– €	8,7 kg
835 mm sectionalized	884,– €	17,5 kg

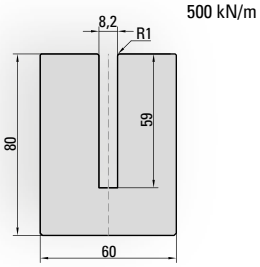




20.550 — 24h

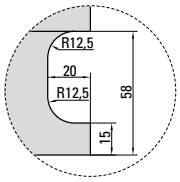
835 mm	420,– €	28,5 kg
415 mm	240,– €	14,2 kg
835 mm sectionalized	680,– €	28,5 kg

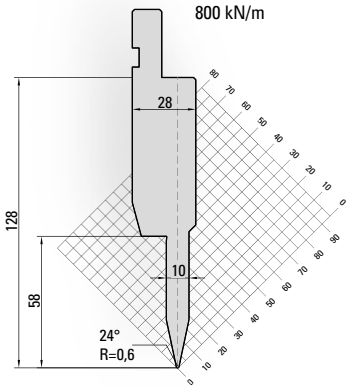
Max. 1,2 mm material thickness
R_m = 400 N/mm²



11.554 — 24h

835 mm	580,– €	18,2 kg
415 mm	336,– €	9,1 kg
835 mm sectionalized	884,– €	18,2 kg

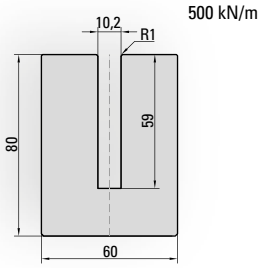




20.554 — 24h

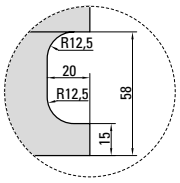
835 mm	420,– €	27,6 kg
415 mm	240,– €	13,8 kg
835 mm sectionalized	680,– €	27,6 kg

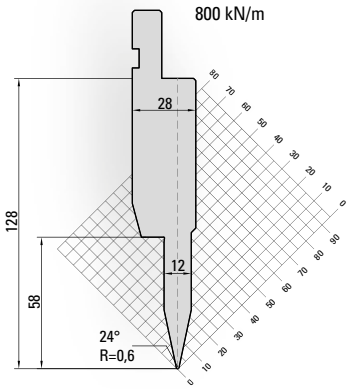
Max. 1,8 mm material thickness
R_m = 400 N/mm²



11.560 — 24h

835 mm	580,– €	18,6 kg
415 mm	336,– €	9,3 kg
835 mm sectionalized	884,– €	18,6 kg

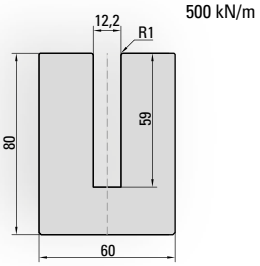




20.560 — 24h

835 mm	420,– €	26,8 kg
415 mm	240,– €	13,4 kg
835 mm sectionalized	680,– €	26,8 kg

Max. 2,5 mm material thickness
R_m = 400 N/mm²



EXAMPLE OF USE

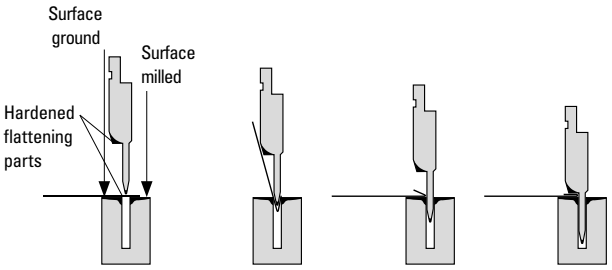


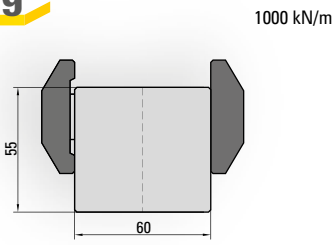
Table of force for flattening see page 48

VIDEO

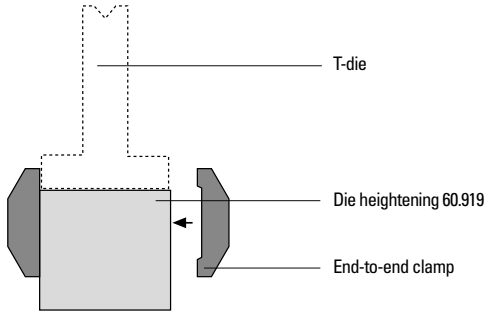
UKB-Flattening tools

Die heightening

60.919		24h
835 mm	242,– €	29,0 kg
415 mm	152,– €	14,5 kg



EXAMPLE OF USE



UKB-Regrinding service

The regrinding of your press brake tools, we carry out professional, precise, fast and cost-saving.
Make do and mend!

Before

After

UKB-Repair service

Before regrinding, we weld on material for breakouts, damaged areas or deformations!

Weld on of a damaged tool (MAG welding process)

WIG welding process

Further information see chapter 19 or visit www.ukb-gmbh.com!

PRESS BRAKE TOOLS UKB-SYSTEM TRUMPF

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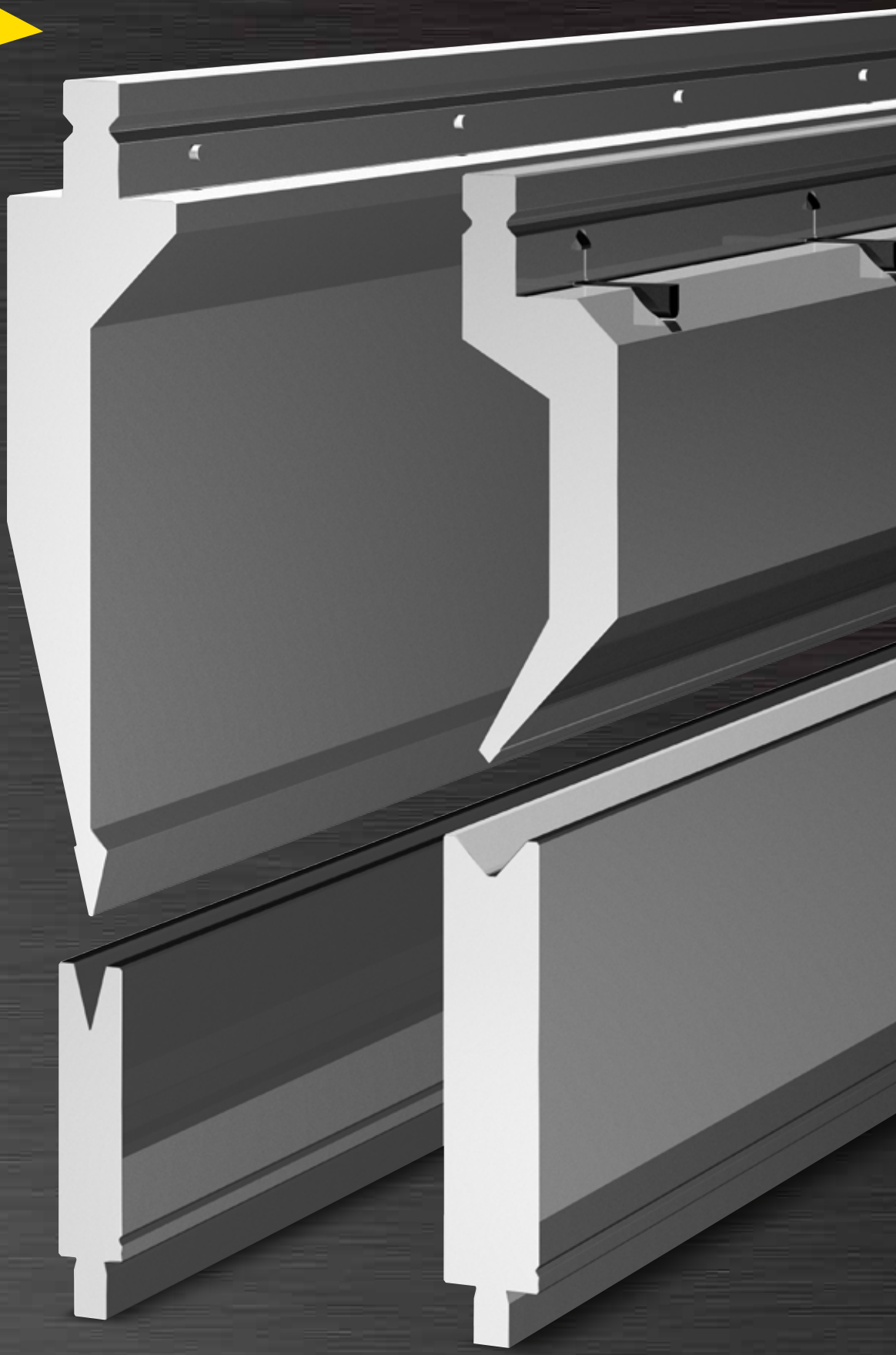
FOLLOW US!



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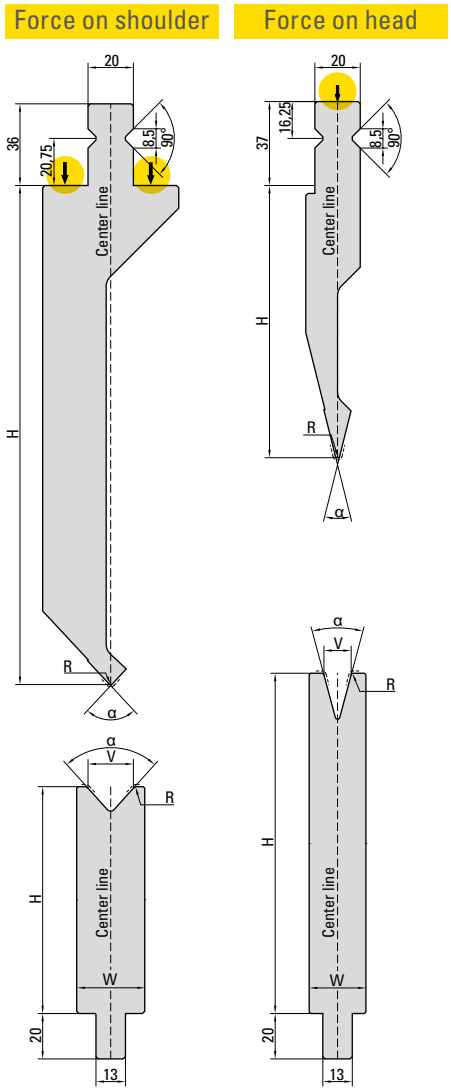
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, tempered to 800 – 850 N/mm²
  - C45, 650 – 800 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Punch/top tool clampings in two different models
  - Simple Clamp at segments < 12,5 kg
  - Safety Pin at segments > 12,5 kg
- Self centering
- Usable on both sides
- Tool marking with all technical information



UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** Press brake tools UKB-System Trumpf in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

  Standard: 1 – 3 working days by parcel service or forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

  Direct courier: According agreement
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

Tool lengths

PUNCHES/TOP TOOLS WITH SIMPLE CLAMP

Length **500 mm**

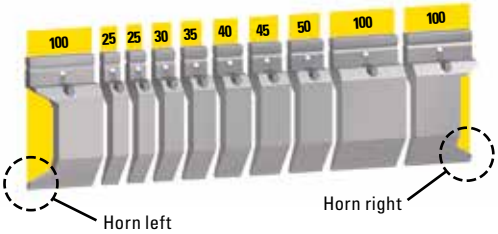
Length **300 mm**

Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments, with horn extension left and right



Simple Clamp

PUNCHES/TOP TOOLS WITH SAFETY PINS

Length **500 mm**

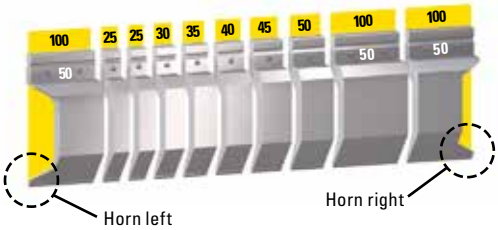
Length **300 mm**

Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments, with horn extension left and right



Safety pin

DIES

Length **500 mm**

Length **300 mm**

Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized dies are delivered as a complete set
- 9 Segments

UKB-INFO

Create your own individual tool lengths set for punches/top tools and dies!
Offers for sets 1050 / 2050 / 3050 / 4050 mm, contact us!

VIDEO

UKB-Press brake tool systems

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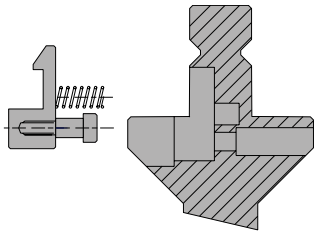
Simple Clamp

ADVANTAGES

- **Vertical** tool change for segments **up to 12,5 kg**
- Less set-up time
- Easy handling

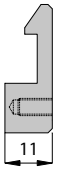
Set consists of screw, spring and Simple Clamp

Vertical tool change



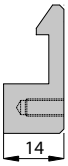
70.714		24h
Set	14,– €	0,012 kg

Suitable for punches/top tools
15.010 / 15.310 / 15.610



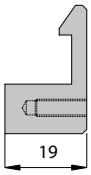
70.715		24h
Set	14,– €	0,014 kg

Suitable for punches/top tools
15.320 / 15.620



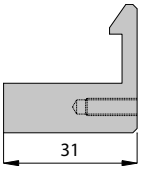
70.716		24h
Set	16,– €	0,016 kg

Suitable for punches/top tools
15.330 / 15.335 / 15.630 / 15.635
15.755 / 15.902 / 15.904 / 15.905



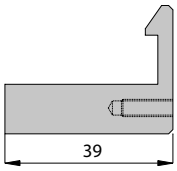
70.717		24h
Set	16,– €	0,023 kg

Suitable for punches/top tools
15.450 / 15.710 / 15.720
15.730 / 15.750 / 15.760



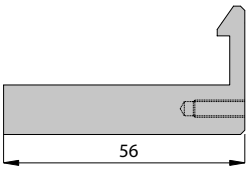
70.718		24h
Set	18,– €	0,027 kg

Suitable for punches/top tools
15.370 / 15.480 / 15.670 / 15.680



70.719		24h
Set	18,– €	0,038 kg

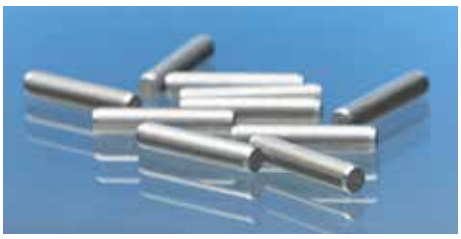
Suitable for punches/top tools
15.380 / 15.700 / 15.800



Safety pins

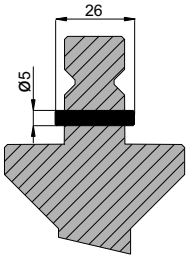
ADVANTAGES

- **Horizontal** tool change for segments **more than 12,5 kg**
- Favorable purchase price (in comparison with Simple Clamp)
- Hardened Safety pins on demand



Safety pins

Horizontal tool change



70.130		24h
10 pieces	3,50 €	0,16 kg

Hardened

70.140		24h
10 pieces	1,50 €	0,16 kg

Not hardened

Flexible modification

PUNCHES/TOP TOOLS

- Special cuttings
- Individual horn extensions
- Insertion of Simple Clamp
- Insertion of Safety pins
- Laser marking

VIDEO

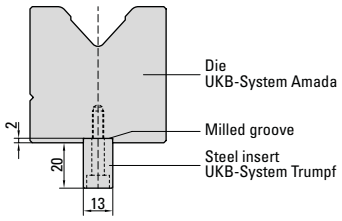
UKB-Modification of press brake tools

DIES

- Special cuttings
- Laser marking

Insertion of a steel insert

MODIFICATION EXAMPLE



By mounting a steel insert (page 246) dies UKB-System Amada (chapter 1) can also be used in a clamping UKB-System Trumpf.

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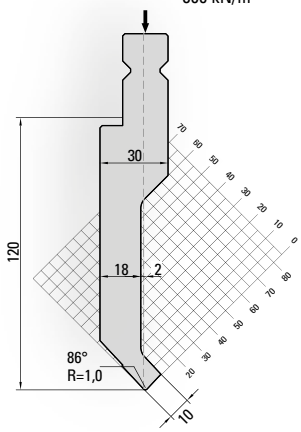
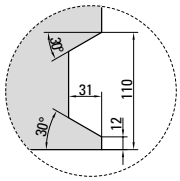
Punches/top tools H = 120 mm

15.330 24h

Simple Clamp		
500 mm	320,– €	12,0 kg
300 mm	254,– €	7,2 kg
200 mm	206,– €	4,8 kg
100 mm	118,– €	2,4 kg
550 mm sectionalized	722,– €	13,2 kg

800 kN/m





Further radii

R (mm)	H (mm)
0,5	119,8
2,0	119,2
2,5	119,0
3,0	118,8
4,0	118,2
5,0	117,7
6,0	117,2

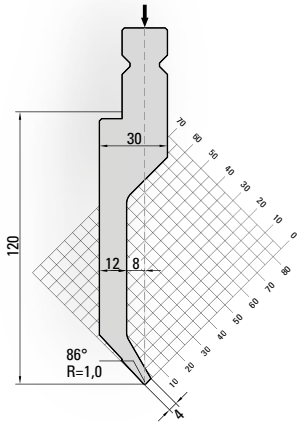
Prices and other radii on demand

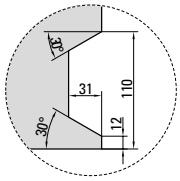
Delivery time 1–3 working days

15.335 24h

Simple Clamp		
500 mm	438,– €	9,9 kg
300 mm	328,– €	6,0 kg
200 mm	256,– €	4,0 kg
100 mm	146,– €	2,0 kg
550 mm sectionalized	830,– €	11,0 kg

300 kN/m





Further radii

R (mm)	H (mm)
0,5	119,8
2,0	119,2
2,5	119,0
3,0	118,8

Prices and other radii on demand

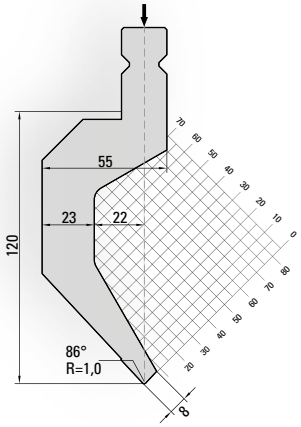
Delivery time 1–3 working days

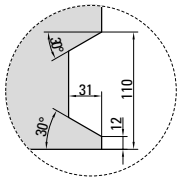
15.370 24h

Safety pins		
500 mm	470,– €	14,5 kg

Simple Clamp		
300 mm	382,– €	8,7 kg
200 mm	292,– €	5,8 kg
100 mm	160,– €	2,9 kg
550 mm sectionalized	902,– €	16,0 kg

800 kN/m





Further radii

R (mm)	H (mm)
0,5	119,8
2,0	119,2
2,5	119,0
3,0	118,7
4,0	118,3
5,0	117,8
6,0	117,3

Prices and other radii on demand

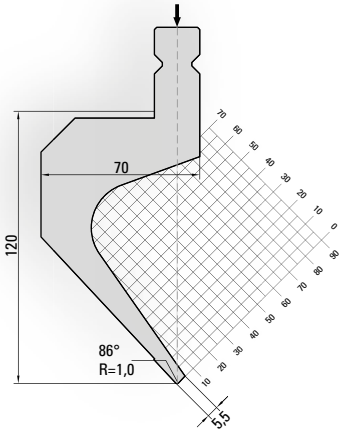
Delivery time 1–3 working days

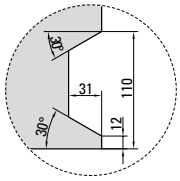
15.380 24h

Safety pins		
500 mm	676,– €	15,4 kg

Simple Clamp		
300 mm	496,– €	9,3 kg
200 mm	352,– €	6,2 kg
100 mm	198,– €	3,1 kg
550 mm sectionalized	1.226,– €	17,0 kg

250 kN/m





Further radii

R (mm)	H (mm)
0,5	119,8
2,0	119,2
2,5	119,0
3,0	118,7
4,0	118,3

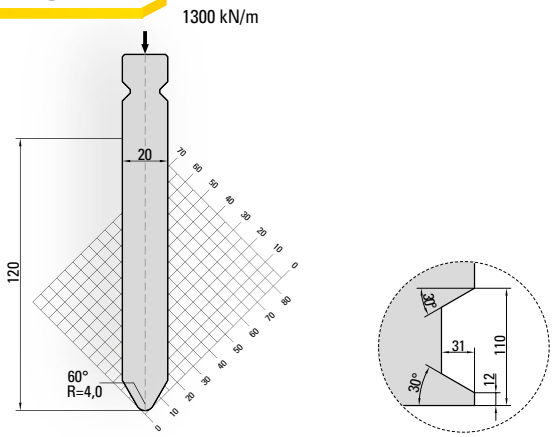
Prices and other radii on demand

Delivery time 1–3 working days

Punches/top tools H = 120 mm

15.310 24h

Simple Clamp		
500 mm	270,– €	12,0 kg
300 mm	220,– €	7,2 kg
200 mm	182,– €	4,8 kg
100 mm	106,– €	2,4 kg
550 mm sectionalized	632,– €	13,2 kg



Further radii

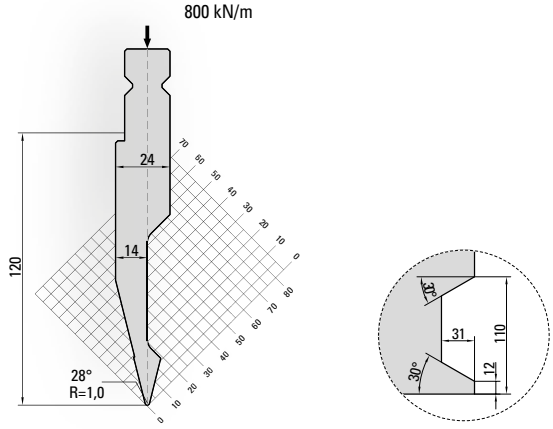
R (mm)	H (mm)
2,0	119,8
2,5	119,8
3,0	119,8
5,0	118,8
6,0	117,6

Prices and other radii on demand

Delivery time 1–3 working days

15.320 24h

Simple Clamp		
500 mm	316,– €	10,0 kg
300 mm	254,– €	6,0 kg
200 mm	206,– €	4,0 kg
100 mm	118,– €	2,0 kg
550 mm sectionalized	766,– €	11,0 kg



Further radii

R (mm)	H (mm)
0,5	119,8
2,0	116,0
2,5	114,4
3,0	112,8
4,0	109,8

Prices and other radii on demand

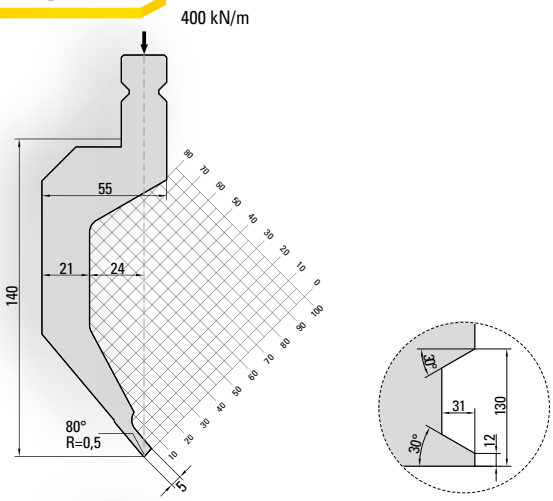
Delivery time 1–3 working days

Punches/top tools H = 140 mm

15.480 24h

Safety pins		
500 mm	666,– €	15,3 kg

Simple Clamp		
300 mm	458,– €	9,3 kg
200 mm	334,– €	6,2 kg
100 mm	184,– €	3,1 kg
550 mm sectionalized	1.116,– €	17,0 kg



Further radii

R (mm)	H (mm)
1,0	139,4
2,0	138,8
2,5	138,5
3,0	138,2

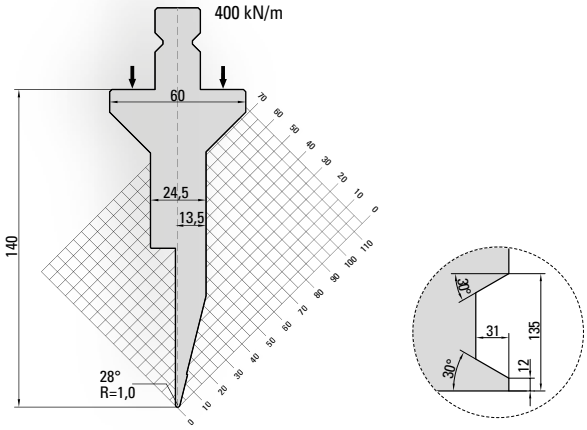
Prices and other radii on demand

Delivery time 1–3 working days

15.450 24h

Safety pins		
500 mm	592,– €	14,5 kg

Simple Clamp		
300 mm	470,– €	8,7 kg
200 mm	346,– €	5,8 kg
100 mm	186,– €	2,9 kg
550 mm sectionalized	1.238,– €	16,0 kg



Further radii

R (mm)	H (mm)
0,5	139,8

Prices and other radii on demand

Delivery time 1–3 working days

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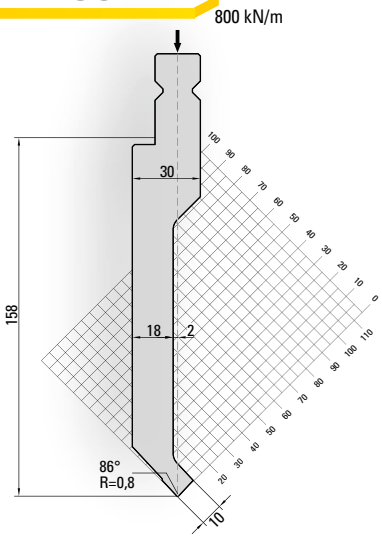
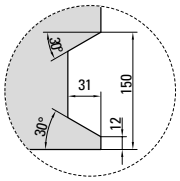
Punches/top tools H = 158 mm

15.630 24h

Safety pins		
500 mm	378,– €	15,0 kg

Simple Clamp		
300 mm	310,– €	9,0 kg
200 mm	250,– €	6,0 kg
100 mm	134,– €	3,0 kg
550 mm sectionalized	750,– €	16,5 kg





Further radii

R (mm)	H (mm)
0,5	157,8
1,0	157,6
2,0	157,2
2,5	157,0
3,0	156,7
4,0	156,3
5,0	155,8
6,0	155,3

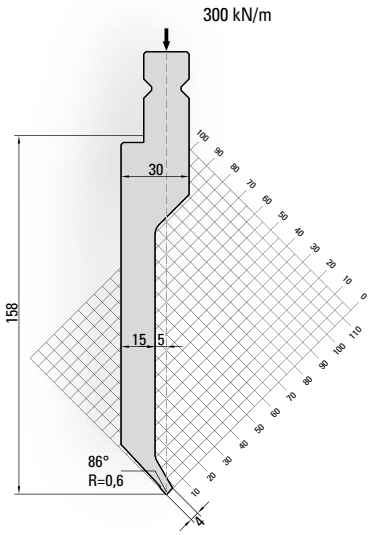
Prices and other radii on demand

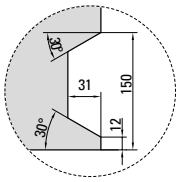
Delivery time 1–3 working days

15.635 24h

Safety pins		
500 mm	362,– €	13,5 kg

Simple Clamp		
300 mm	306,– €	8,1 kg
200 mm	240,– €	5,4 kg
100 mm	142,– €	2,7 kg
550 mm sectionalized	722,– €	14,9 kg





Further radii

R (mm)	H (mm)
0,5	157,8
1,0	157,6
2,0	157,2
2,5	157,0
3,0	156,7

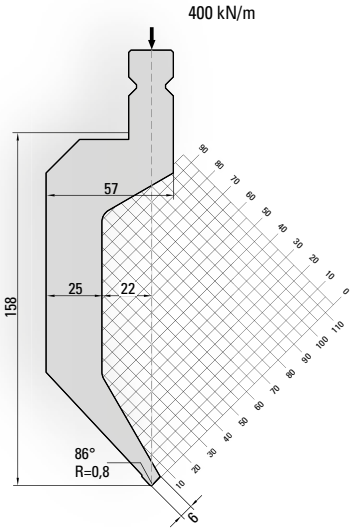
Prices and other radii on demand

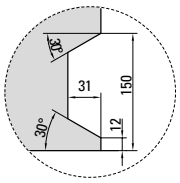
Delivery time 1–3 working days

15.670 24h

Safety pins		
500 mm	516,– €	19,0 kg

Simple Clamp		
300 mm	426,– €	11,4 kg
200 mm	342,– €	7,6 kg
100 mm	180,– €	3,8 kg
550 mm sectionalized	1.026,– €	20,9 kg





Further radii

R (mm)	H (mm)
0,5	157,8
1,0	157,6
2,0	157,2
2,5	157,0
3,0	156,7
4,0	156,3
5,0	155,8

Prices and other radii on demand

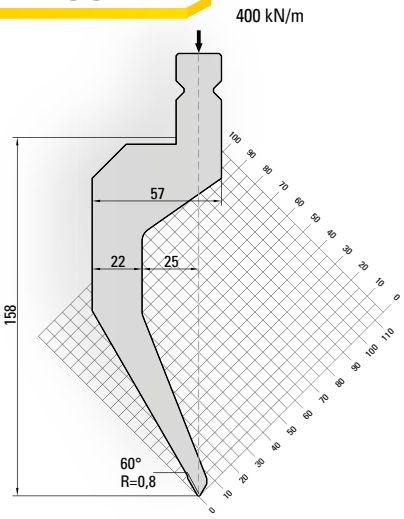
Delivery time 1–3 working days

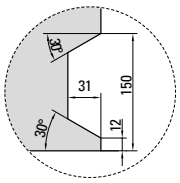
Punches/top tools H = 158 mm

15.680 24h

Safety pins		
500 mm	598,– €	17,5 kg

Simple Clamp		
300 mm	490,– €	10,5 kg
200 mm	394,– €	7,0 kg
100 mm	210,– €	3,5 kg
550 mm sectionalized	1.188,– €	19,3 kg





Further radii

R (mm)	H (mm)
0,5	157,8
1,0	157,4
2,0	156,4
2,5	155,9
3,0	155,4

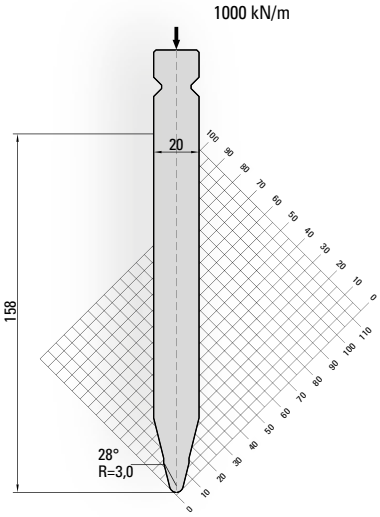
Prices and other radii on demand

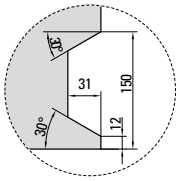
Delivery time 1–3 working days

15.610 24h

Safety pins		
500 mm	338,– €	14,0 kg

Simple Clamp		
300 mm	268,– €	8,4 kg
200 mm	222,– €	5,6 kg
100 mm	118,– €	2,8 kg
550 mm sectionalized	670,– €	15,4 kg





Further radii

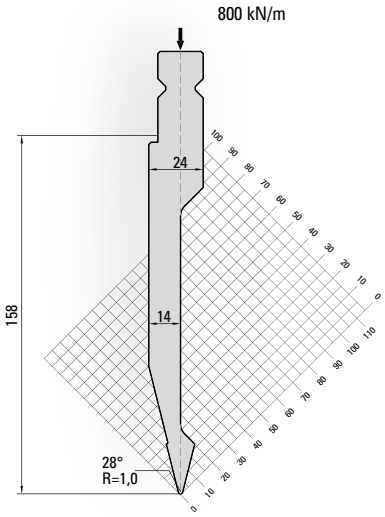
R (mm)	H (mm)
0,5	157,8
1,0	157,8
2,0	157,8
2,5	157,8
4,0	154,0
5,0	150,8

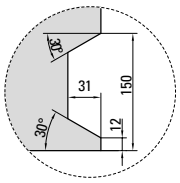
Prices and other radii on demand

Delivery time 1–3 working days

15.620 24h

Simple Clamp		
500 mm	366,– €	11,5 kg
300 mm	294,– €	6,9 kg
200 mm	242,– €	4,6 kg
100 mm	120,– €	2,3 kg
550 mm sectionalized	730,– €	12,7 kg





Further radii

R (mm)	H (mm)
0,5	157,8
2,0	154,0
2,5	152,4
3,0	150,8
4,0	147,8

Prices and other radii on demand

Delivery time 1–3 working days

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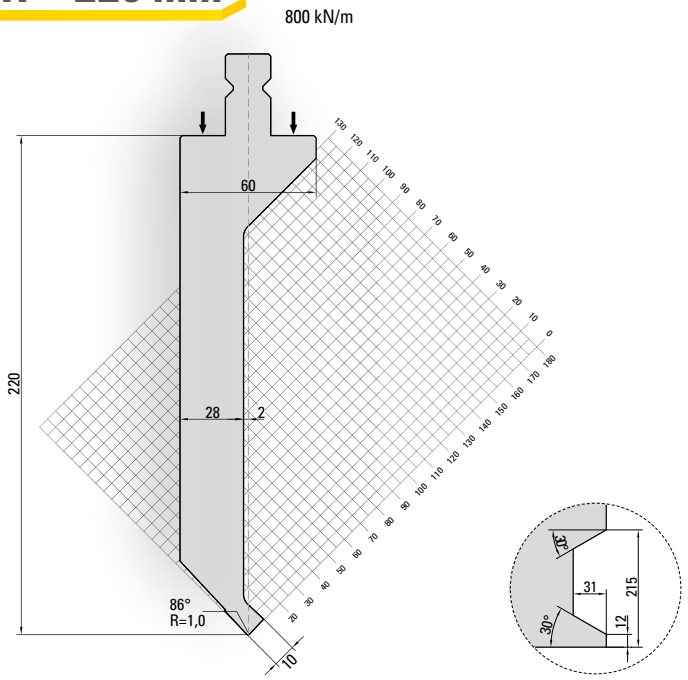
Punches/top tools H = 220 mm

15.710 24h

Safety pins		
500 mm	584,– €	28,5 kg
300 mm	432,– €	17,1 kg

Simple Clamp		
200 mm	378,– €	11,4 kg
100 mm	206,– €	5,7 kg
550 mm sectionalized	1.302,– €	31,4 kg



Further radii	
R (mm)	H (mm)
0,5	219,8
2,0	219,2
2,5	218,7
3,0	218,5
4,0	218,3
5,0	217,8
6,0	217,5

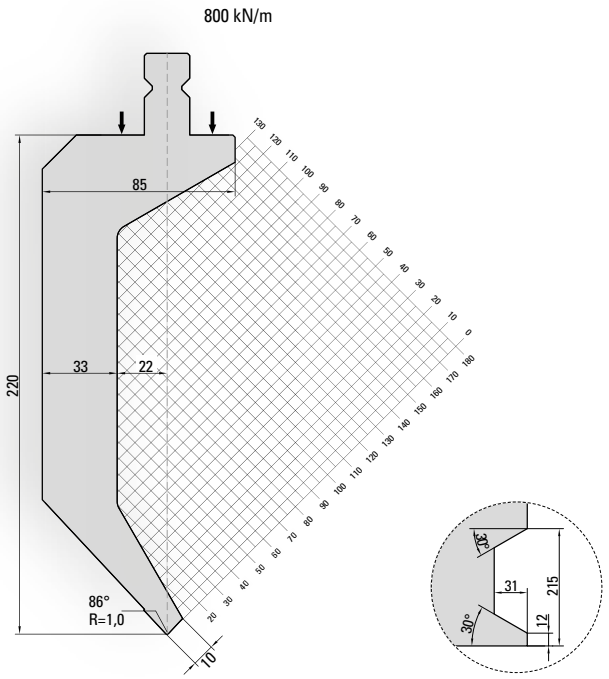
Prices and other radii on demand

Delivery time 1–3 working days

15.700 24h

Safety pins		
500 mm	780,– €	33,5 kg
300 mm	588,– €	20,1 kg
200 mm	396,– €	13,4 kg

Simple Clamp		
100 mm	246,– €	6,7 kg
550 mm sectionalized	1.582,– €	36,9 kg



Further radii	
R (mm)	H (mm)
0,5	219,8
2,0	219,2
2,5	218,7
3,0	218,5
4,0	218,3
5,0	217,8
6,0	217,5

Prices and other radii on demand

Delivery time 1–3 working days

UKB-INFO

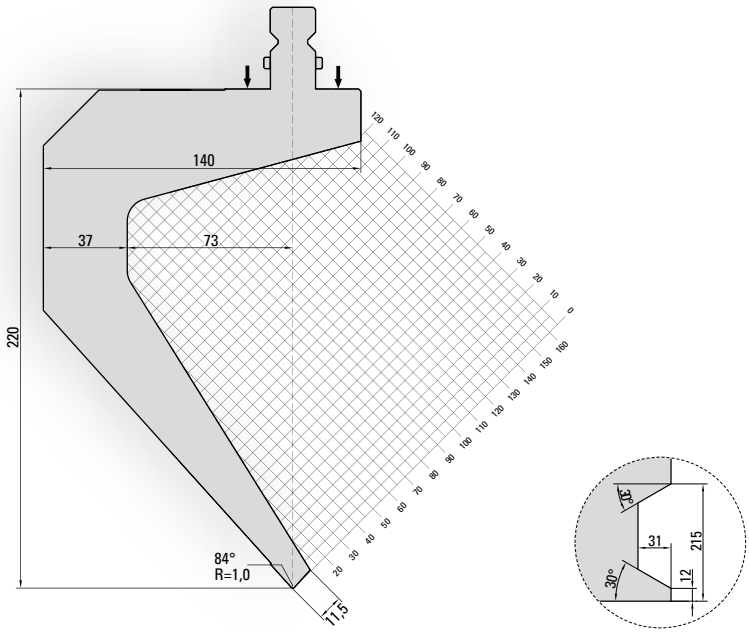
Punches/top tools UKB-System WILA type I (chapter 3) and UKB-System LVD type I (chapter 4) can also be used in a clamping ÚKB-System Trumpf!

Punches/top tools H = 220 mm

15.790 24h

Safety pins		
200 mm	694,– €	17,6 kg
100 mm	392,– €	8,8 kg
550 mm sectionalized	2.512,– €	48,4 kg

600 kN/m



Further radii

R (mm)	H (mm)
0,5	219,8
2,0	219,2
2,5	218,7
3,0	218,5
4,0	218,3
5,0	217,8
6,0	217,5

Prices and other radii on demand

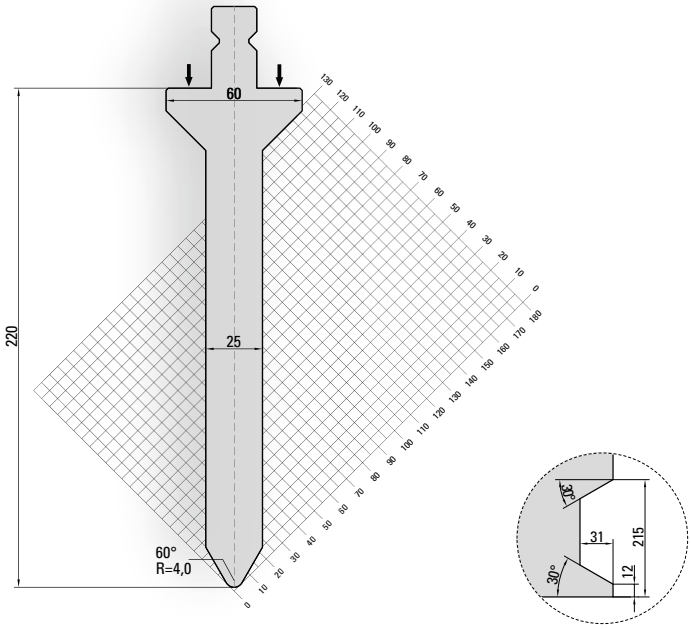
Delivery time 1–3 working days

15.730 24h

Safety pins		
500 mm	584,– €	26,0 kg
300 mm	436,– €	15,6 kg

Simple Clamp		
200 mm	378,– €	10,4 kg
100 mm	206,– €	5,2 kg
550 mm sectionalized	1.302,– €	28,6 kg

1300 kN/m



Further radii

R (mm)	H (mm)
2,0	219,8
2,5	219,8
3,0	219,8
5,0	218,6
6,0	217,6

Prices and other radii on demand

Delivery time 1–3 working days

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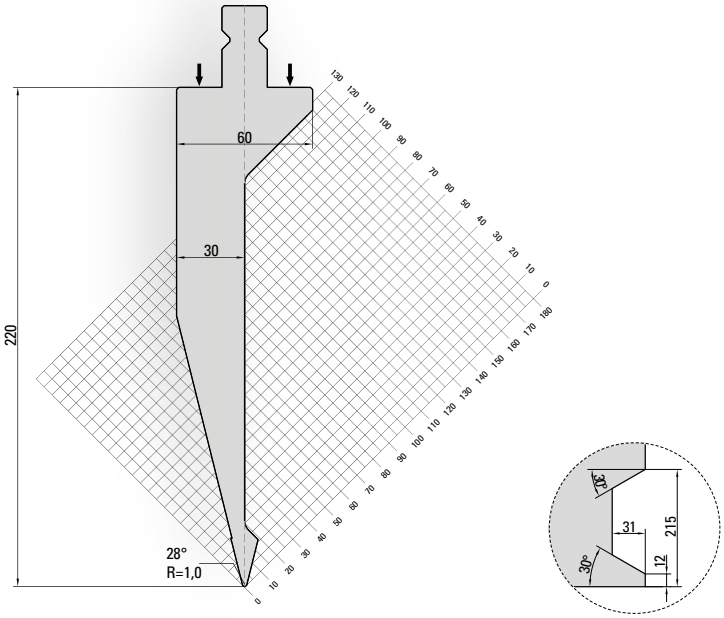
Punch/top tool H = 220 mm

800 kN/m

15.720 24h

Safety pins		
500 mm	602,– €	25,0 kg
300 mm	444,– €	15,0 kg

Simple Clamp		
200 mm	386,– €	10,0 kg
100 mm	208,– €	5,0 kg
550 mm sectionalized	1.396,– €	27,5 kg



Further radii

R (mm)	H (mm)
0,5	219,8
2,0	216,0
2,5	214,0
3,0	212,8
4,0	209,8

Prices and other radii on demand

Delivery time 1–3 working days

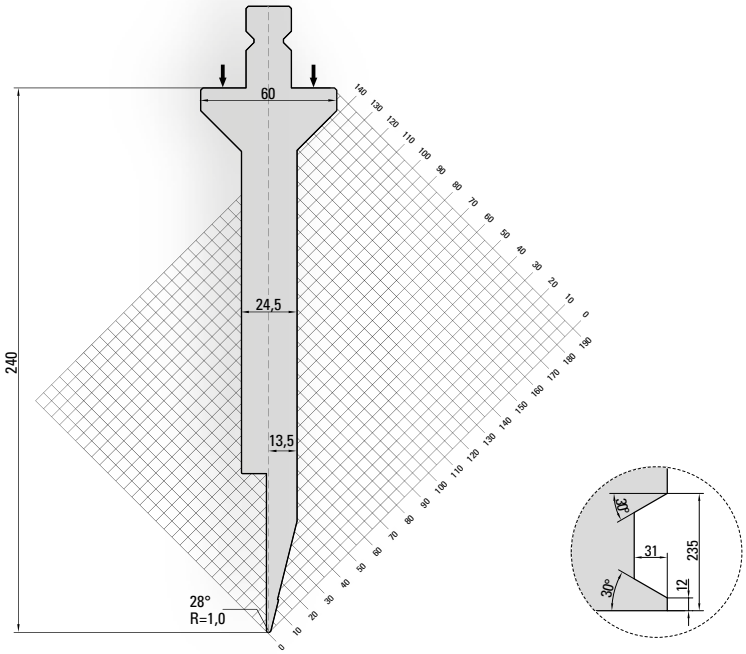
Punch/top tool H = 240 mm

400 kN/m

15.750 24h

Safety pins		
500 mm	710,– €	24,0 kg
300 mm	528,– €	14,4 kg

Simple Clamp		
200 mm	440,– €	9,6 kg
100 mm	234,– €	4,8 kg
550 mm sectionalized	1.530,– €	26,4 kg



Further radii

R (mm)	H (mm)
0,5	239,8

Prices and other radii on demand

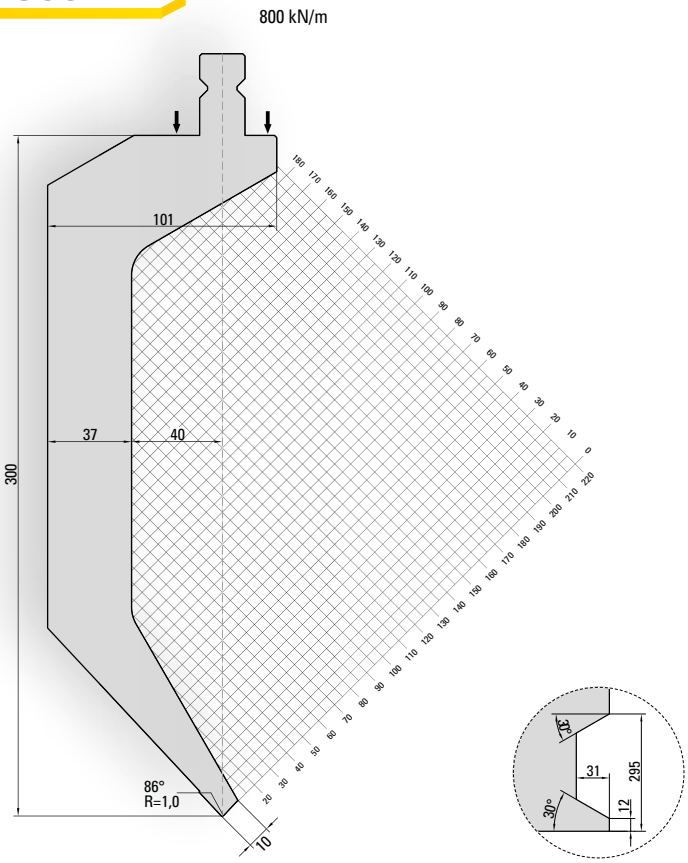
Delivery time 1–3 working days

Punch/top tool H = 300 mm

15.800 24h

Safety pins		
200 mm	584,– €	19,6 kg

Simple Clamp		
100 mm	364,– €	9,8 kg
550 mm sectionalized	2.478,– €	53,9 kg



Further radii	
R (mm)	H (mm)
0,5	299,8
2,0	299,2
2,5	298,7
3,0	298,5
4,0	298,3
5,0	297,8
6,0	297,5

Prices and other radii on demand

Delivery time 1–3 working days

UKB-INFO

Punches/top tools UKB-System WILA type I (chapter 3) and UKB-System LVD type I (chapter 4) can also be used in a clamping UKB-System Trumpf!

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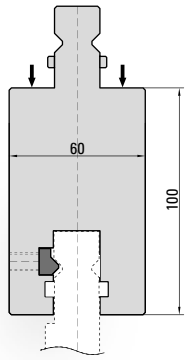
Punch/top tool distance pieces, H = 100 mm

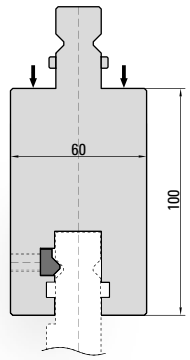
50.410		24h
Safety pins		
150 mm	272,– €	6,9 kg

1000 kN/m



50.415		24h
Safety pins		
50 mm	194,– €	2,3 kg

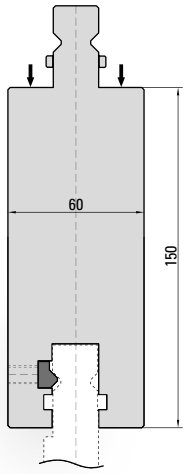
1000 kN/m



Punch/top tool distance pieces, H = 150 mm

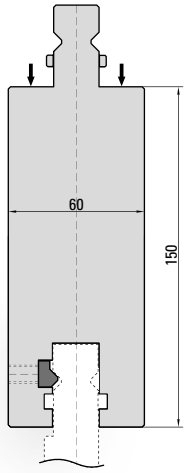
50.440		24h
Safety pins		
150 mm	340,– €	10,5 kg

1000 kN/m



50.445		24h
Safety pins		
50 mm	256,– €	3,5 kg

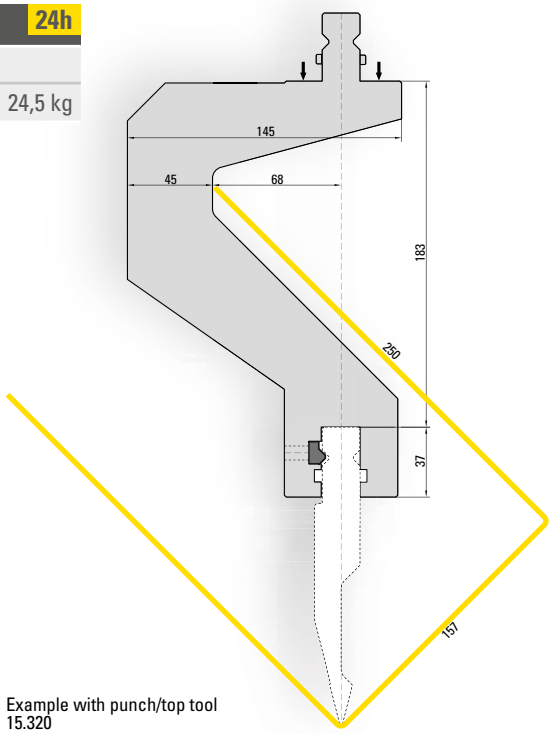
1000 kN/m



Punch/top tool distance piece, H = 220 mm

50.503		24h
Safety pins		
200 mm	702,– €	24,5 kg

900 kN/m



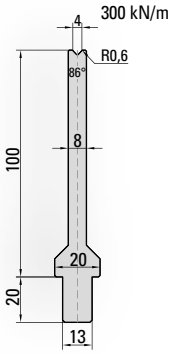
Example with punch/top tool 15.320

UKB-PRESS BRAKE TOOL CABINETS

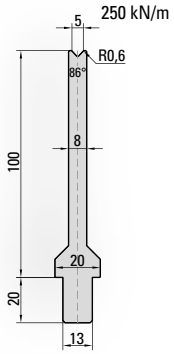
see chapter 16

86° Dies, H = 100 mm

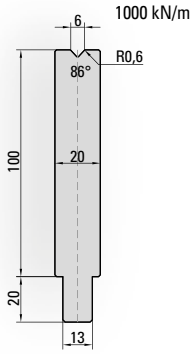
25.100		24h
500 mm	294,– €	4,5 kg
300 mm	216,– €	2,7 kg
200 mm	156,– €	1,8 kg
100 mm	94,– €	0,9 kg
550 mm sectionalized	496,– €	5,0 kg



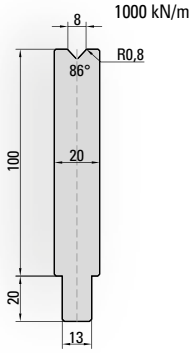
25.350		24h
500 mm	244,– €	4,5 kg
300 mm	174,– €	2,7 kg
200 mm	122,– €	1,8 kg
100 mm	72,– €	0,9 kg
550 mm sectionalized	456,– €	5,0 kg



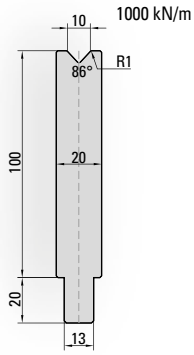
25.101		24h
500 mm	162,– €	9,0 kg
300 mm	122,– €	5,4 kg
200 mm	92,– €	3,6 kg
100 mm	64,– €	1,8 kg
550 mm sectionalized	374,– €	9,9 kg



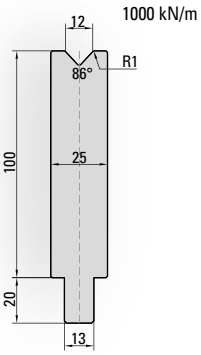
25.102		24h
500 mm	162,– €	9,0 kg
300 mm	122,– €	5,4 kg
200 mm	92,– €	3,6 kg
100 mm	64,– €	1,8 kg
550 mm sectionalized	374,– €	9,9 kg



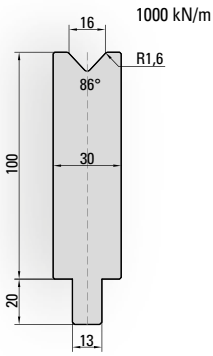
25.103		24h
500 mm	162,– €	9,0 kg
300 mm	122,– €	5,4 kg
200 mm	92,– €	3,6 kg
100 mm	64,– €	1,8 kg
550 mm sectionalized	374,– €	9,9 kg



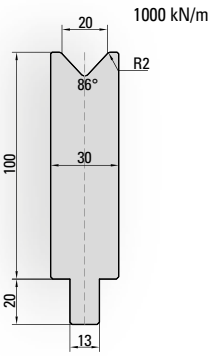
25.104		24h
500 mm	174,– €	10,5 kg
300 mm	130,– €	6,3 kg
200 mm	98,– €	4,2 kg
100 mm	66,– €	2,1 kg
550 mm sectionalized	392,– €	11,6 kg



25.105		24h
500 mm	188,– €	12,5 kg
300 mm	138,– €	7,5 kg
200 mm	106,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	412,– €	13,8 kg



25.106		24h
500 mm	204,– €	12,5 kg
300 mm	152,– €	7,5 kg
200 mm	112,– €	5,0 kg
100 mm	74,– €	2,5 kg
550 mm sectionalized	426,– €	13,8 kg



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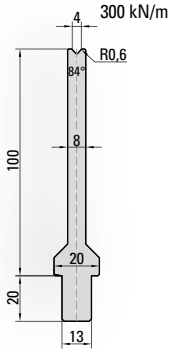
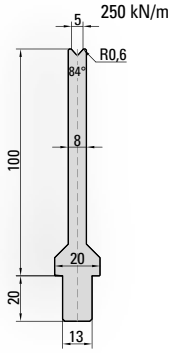
84° Dies, H = 100 mm

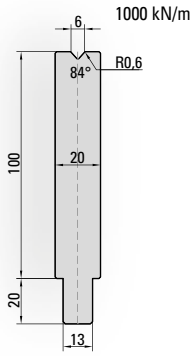
25.200		24h
500 mm	294,– €	4,5 kg
300 mm	208,– €	2,7 kg
200 mm	150,– €	1,8 kg
100 mm	94,– €	0,9 kg
550 mm sectionalized	496,– €	5,0 kg



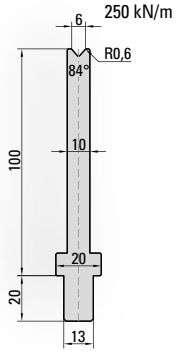
25.300		24h
500 mm	244,– €	4,5 kg
300 mm	174,– €	2,7 kg
200 mm	122,– €	1,8 kg
100 mm	72,– €	0,9 kg
550 mm sectionalized	456,– €	5,0 kg



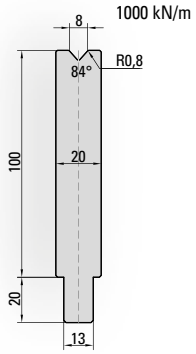
25.201		24h
500 mm	162,– €	9,0 kg
300 mm	122,– €	5,4 kg
200 mm	92,– €	3,6 kg
100 mm	64,– €	1,8 kg
550 mm sectionalized	374,– €	9,9 kg



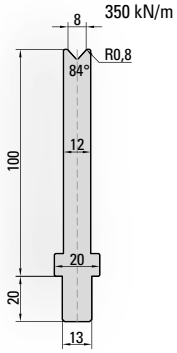
25.301		24h
500 mm	244,– €	5,5 kg
300 mm	174,– €	3,3 kg
200 mm	122,– €	2,2 kg
100 mm	72,– €	1,1 kg
550 mm sectionalized	456,– €	6,0 kg



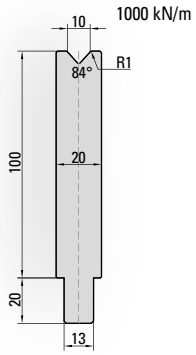
25.202		24h
500 mm	162,– €	9,0 kg
300 mm	122,– €	5,4 kg
200 mm	92,– €	3,6 kg
100 mm	64,– €	1,8 kg
550 mm sectionalized	374,– €	9,9 kg



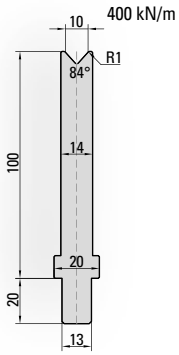
25.302		24h
500 mm	244,– €	6,0 kg
300 mm	174,– €	3,6 kg
200 mm	122,– €	2,4 kg
100 mm	72,– €	1,2 kg
550 mm sectionalized	456,– €	6,6 kg



25.203		24h
500 mm	162,– €	9,0 kg
300 mm	122,– €	5,4 kg
200 mm	92,– €	3,6 kg
100 mm	64,– €	1,8 kg
550 mm sectionalized	374,– €	9,9 kg

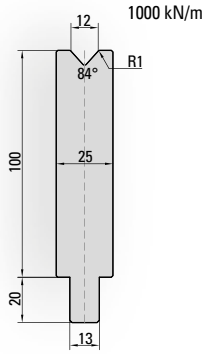


25.303		24h
500 mm	244,– €	6,5 kg
300 mm	174,– €	3,9 kg
200 mm	122,– €	2,6 kg
100 mm	72,– €	1,3 kg
550 mm sectionalized	456,– €	7,2 kg

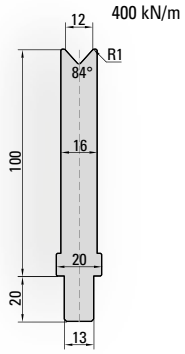


84° Dies, H = 100 mm

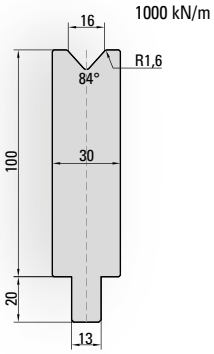
25.204		24h
500 mm	174,– €	10,5 kg
300 mm	130,– €	6,3 kg
200 mm	98,– €	4,2 kg
100 mm	66,– €	2,1 kg
550 mm sectionalized	392,– €	11,6 kg



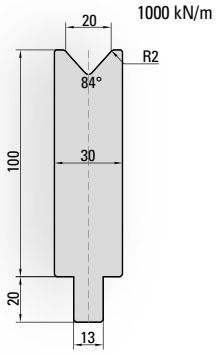
25.304		24h
500 mm	244,– €	7,0 kg
300 mm	174,– €	4,2 kg
200 mm	122,– €	2,8 kg
100 mm	72,– €	1,4 kg
550 mm sectionalized	456,– €	7,7 kg



25.205		24h
500 mm	188,– €	12,5 kg
300 mm	138,– €	7,5 kg
200 mm	106,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	412,– €	13,8 kg

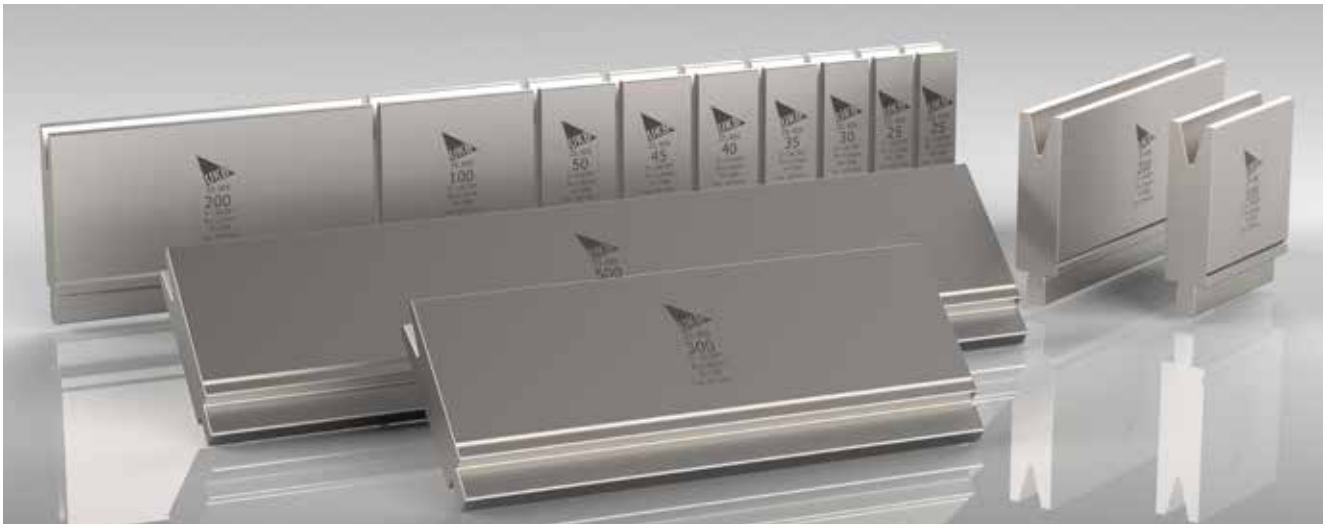


25.206		24h
500 mm	204,– €	12,5 kg
300 mm	152,– €	7,5 kg
200 mm	114,– €	5,0 kg
100 mm	74,– €	2,5 kg
550 mm sectionalized	426,– €	13,8 kg



UKB-Z-TOOL HOLDERS AND Z-TOOL INSERTS Z 1,0 – 15,0

see chapter 09



Tool lengths UKB-System Trumpf

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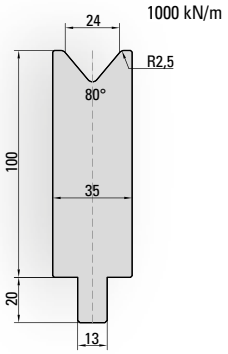
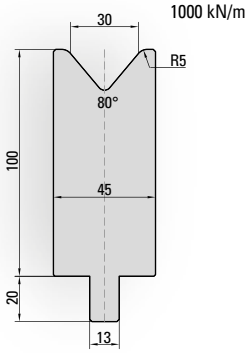
80° Dies, H = 100 mm

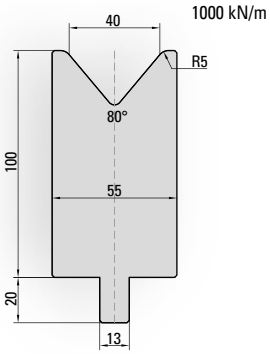
25.207		24h
500 mm	218,– €	14,0 kg
300 mm	160,– €	8,4 kg
200 mm	118,– €	5,6 kg
100 mm	78,– €	2,8 kg
550 mm sectionalized	446,– €	15,4 kg



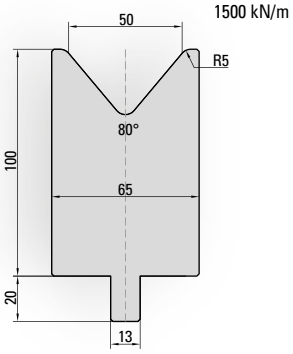
25.208		24h
500 mm	264,– €	17,5 kg
300 mm	192,– €	10,5 kg
200 mm	140,– €	7,0 kg
100 mm	90,– €	3,5 kg
550 mm sectionalized	502,– €	19,3 kg



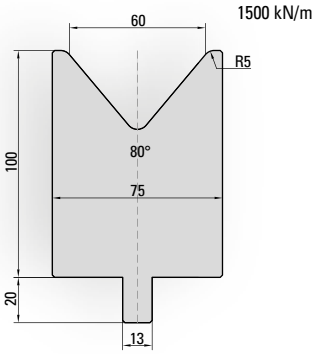
25.209		24h
500 mm	284,– €	20,5 kg
300 mm	210,– €	12,3 kg
200 mm	150,– €	8,2 kg
100 mm	96,– €	4,1 kg
550 mm sectionalized	528,– €	22,6 kg



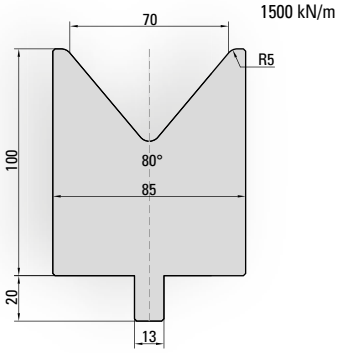
25.210		24h
500 mm	356,– €	23,0 kg
300 mm	250,– €	13,8 kg
200 mm	184,– €	9,2 kg
100 mm	116,– €	4,6 kg
550 mm sectionalized	634,– €	25,3 kg



25.111		24h
500 mm	410,– €	26,0 kg
300 mm	292,– €	15,6 kg
200 mm	210,– €	10,4 kg
100 mm	128,– €	5,2 kg
550 mm sectionalized	670,– €	28,6 kg

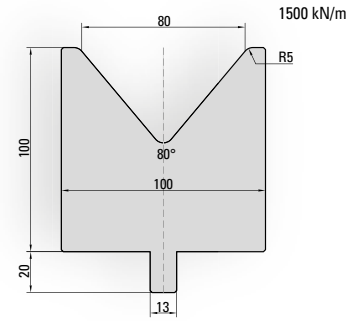


25.112		24h
500 mm	452,– €	28,0 kg
300 mm	316,– €	16,8 kg
200 mm	228,– €	11,2 kg
100 mm	140,– €	5,6 kg
550 mm sectionalized	754,– €	30,8 kg



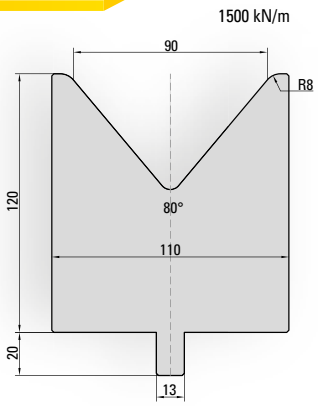
80° Die, H = 100 mm

25.113		24h
500 mm	488,– €	32,0 kg
300 mm	340,– €	19,2 kg
200 mm	244,– €	12,8 kg
100 mm	146,– €	6,4 kg
550 mm sectionalized	782,– €	35,2 kg

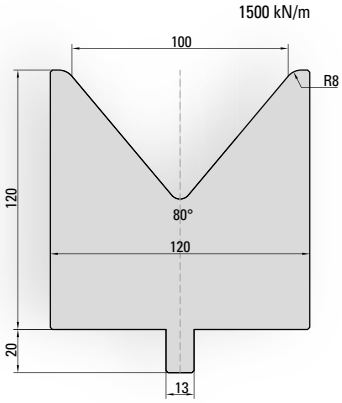


80° Dies, H = 120 mm

25.114		24h
500 mm	582,– €	42,5 kg
300 mm	402,– €	25,5 kg
200 mm	288,– €	17,0 kg
100 mm	198,– €	8,5 kg
550 mm sectionalized	960,– €	46,8 kg

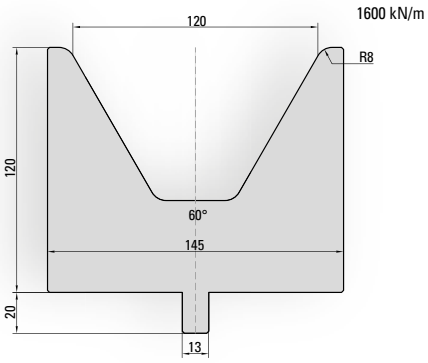


25.115		24h
500 mm	626,– €	44,5 kg
300 mm	420,– €	26,7 kg
200 mm	310,– €	17,8 kg
100 mm	214,– €	8,9 kg
550 mm sectionalized	1.152,– €	49,0 kg



60° Die, H = 120 mm

25.116		24h
500 mm	812,– €	45,5 kg
300 mm	564,– €	27,3 kg
200 mm	410,– €	18,2 kg
100 mm	268,– €	9,1 kg
550 mm sectionalized	1.412,– €	50,0 kg



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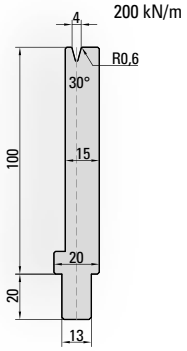
30° Dies, H = 100 mm

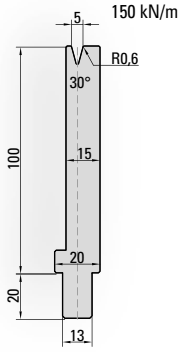
25.400		24h
500 mm	262,– €	7,0 kg
300 mm	190,– €	4,2 kg
200 mm	138,– €	2,8 kg
100 mm	86,– €	1,4 kg
550 mm sectionalized	470,– €	7,7 kg

60.120



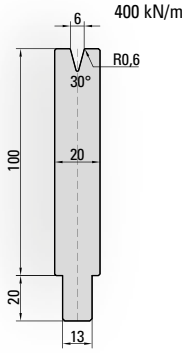
25.500		24h
500 mm	278,– €	7,0 kg
300 mm	206,– €	4,2 kg
200 mm	144,– €	2,8 kg
100 mm	82,– €	1,4 kg
550 mm sectionalized	484,– €	7,7 kg

60.120



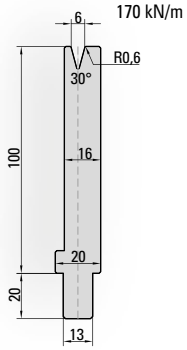
25.401		24h
500 mm	222,– €	9,0 kg
300 mm	164,– €	5,4 kg
200 mm	120,– €	3,6 kg
100 mm	78,– €	1,8 kg
550 mm sectionalized	438,– €	9,9 kg

60.120



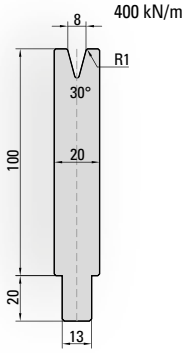
25.501		24h
500 mm	278,– €	7,5 kg
300 mm	206,– €	4,5 kg
200 mm	144,– €	3,0 kg
100 mm	82,– €	1,5 kg
550 mm sectionalized	484,– €	8,3 kg

60.120



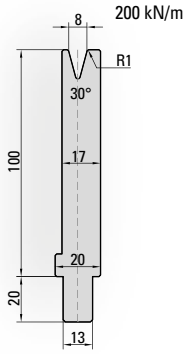
25.402		24h
500 mm	222,– €	9,0 kg
300 mm	164,– €	5,4 kg
200 mm	120,– €	3,6 kg
100 mm	78,– €	1,8 kg
550 mm sectionalized	438,– €	9,9 kg

60.120



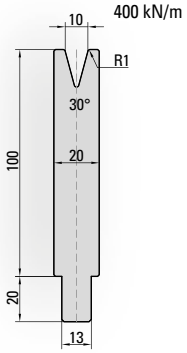
25.502		24h
500 mm	278,– €	7,5 kg
300 mm	206,– €	4,5 kg
200 mm	144,– €	3,0 kg
100 mm	82,– €	1,5 kg
550 mm sectionalized	484,– €	8,3 kg

60.120



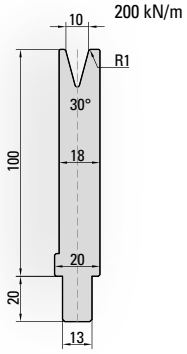
25.403		24h
500 mm	222,– €	9,0 kg
300 mm	164,– €	5,4 kg
200 mm	120,– €	3,6 kg
100 mm	78,– €	1,8 kg
550 mm sectionalized	438,– €	9,9 kg

60.120



25.503		24h
500 mm	278,– €	8,0 kg
300 mm	206,– €	4,8 kg
200 mm	144,– €	3,2 kg
100 mm	82,– €	1,6 kg
550 mm sectionalized	484,– €	8,8 kg

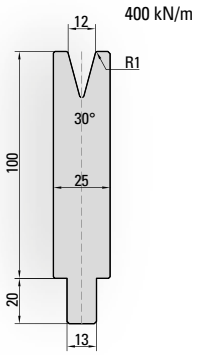
60.120



30° Dies, H = 100 mm

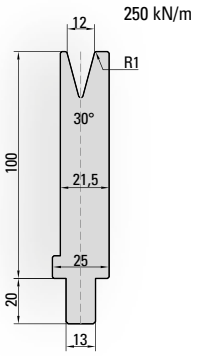
25.404		24h
500 mm	232,– €	10,0 kg
300 mm	170,– €	6,0 kg
200 mm	126,– €	4,0 kg
100 mm	82,– €	2,0 kg
550 mm sectionalized	454,– €	11,0 kg

+ 60.120



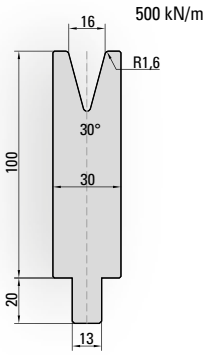
25.504		24h
500 mm	288,– €	9,0 kg
300 mm	216,– €	5,4 kg
200 mm	156,– €	3,6 kg
100 mm	88,– €	1,8 kg
550 mm sectionalized	504,– €	9,9 kg

+ 60.120

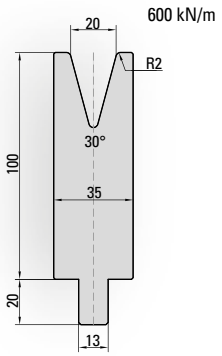


25.405		24h
500 mm	246,– €	12,0 kg
300 mm	180,– €	7,2 kg
200 mm	132,– €	4,8 kg
100 mm	86,– €	2,4 kg
550 mm sectionalized	478,– €	13,2 kg

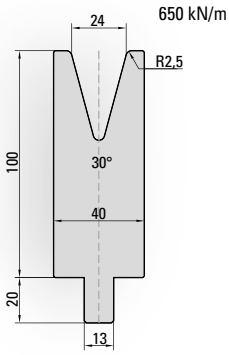
+ 60.120



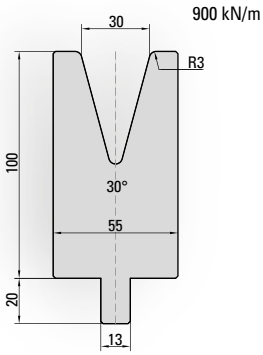
25.406		24h
500 mm	266,– €	13,0 kg
300 mm	194,– €	7,8 kg
200 mm	140,– €	5,2 kg
100 mm	90,– €	2,6 kg
550 mm sectionalized	498,– €	14,3 kg



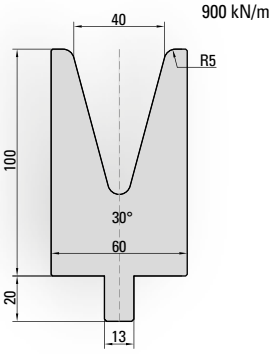
25.407		24h
500 mm	286,– €	14,5 kg
300 mm	206,– €	8,7 kg
200 mm	152,– €	5,8 kg
100 mm	96,– €	2,9 kg
550 mm sectionalized	526,– €	16,0 kg



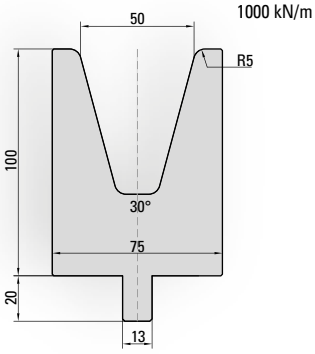
25.408		24h
500 mm	374,– €	19,0 kg
300 mm	274,– €	11,4 kg
200 mm	196,– €	7,6 kg
100 mm	118,– €	3,8 kg
550 mm sectionalized	620,– €	20,9 kg



25.409		24h
500 mm	468,– €	18,5 kg
300 mm	328,– €	11,1 kg
200 mm	242,– €	7,4 kg
100 mm	156,– €	3,7 kg
550 mm sectionalized	826,– €	20,4 kg



25.410		24h
500 mm	738,– €	21,5 kg
300 mm	492,– €	12,9 kg
200 mm	346,– €	8,6 kg
100 mm	198,– €	4,3 kg
550 mm sectionalized	1.230,– €	23,7 kg



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30° Dies, H = 100 mm, R = 3,0

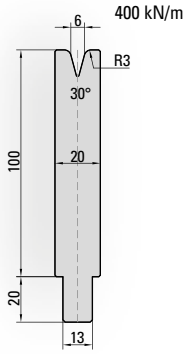
ADVANTAGES

- ▶ Reduces marks on bended sheets
- ▶ Applicable for foil-coated sheets

25.421 — 24h

500 mm	222,– €	9,0 kg
300 mm	164,– €	5,4 kg
200 mm	120,– €	3,6 kg
100 mm	78,– €	1,8 kg
550 mm sectionalized	438,– €	9,9 kg

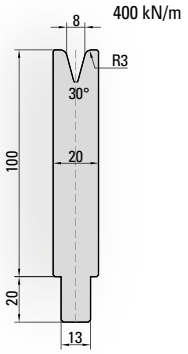
60.120



25.422 — 24h

500 mm	222,– €	9,0 kg
300 mm	164,– €	5,4 kg
200 mm	120,– €	3,6 kg
100 mm	78,– €	1,8 kg
550 mm sectionalized	438,– €	9,9 kg

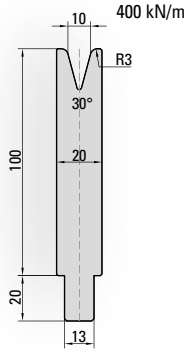
60.120



25.423 — 24h

500 mm	222,– €	8,5 kg
300 mm	164,– €	5,1 kg
200 mm	120,– €	3,4 kg
100 mm	78,– €	1,7 kg
550 mm sectionalized	438,– €	9,4 kg

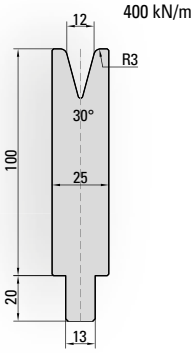
60.120



25.424 — 24h

500 mm	232,– €	10,0 kg
300 mm	170,– €	6,0 kg
200 mm	126,– €	4,0 kg
100 mm	82,– €	2,0 kg
550 mm sectionalized	454,– €	11,0 kg

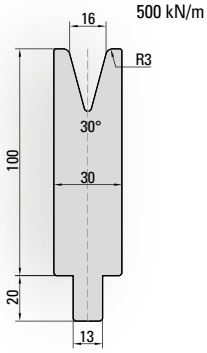
60.120



25.425 — 24h

500 mm	246,– €	12,0 kg
300 mm	180,– €	7,2 kg
200 mm	132,– €	4,8 kg
100 mm	86,– €	2,4 kg
550 mm sectionalized	478,– €	13,2 kg

60.120



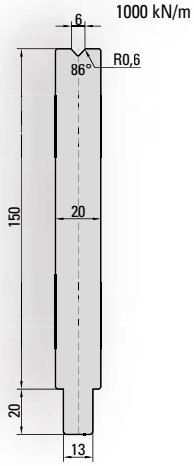
Drill hole 70.800 in 30° die 25.402

UKB-INFO 60.120

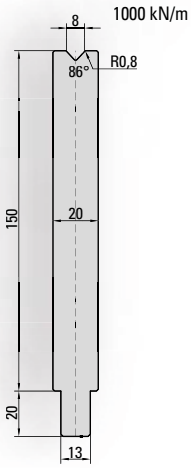
Dies with this symbol can be used with an additional drill hole 70.800 with screwable flattening die 60.120 - further information see page 79!

86° Dies, H = 150 mm

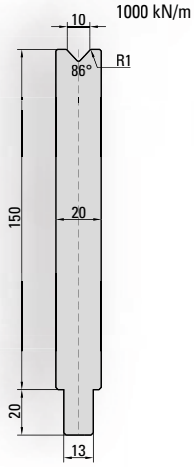
25.601		24h
500 mm	174,– €	12,5 kg
300 mm	128,– €	7,5 kg
200 mm	100,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	422,– €	13,8 kg



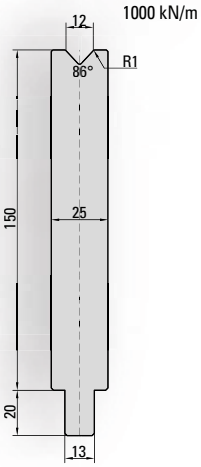
25.602		24h
500 mm	174,– €	12,5 kg
300 mm	128,– €	7,5 kg
200 mm	100,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	422,– €	13,8 kg



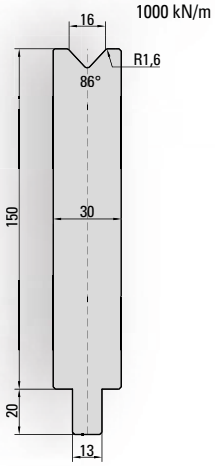
25.603		24h
500 mm	174,– €	12,5 kg
300 mm	128,– €	7,5 kg
200 mm	100,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	422,– €	13,8 kg



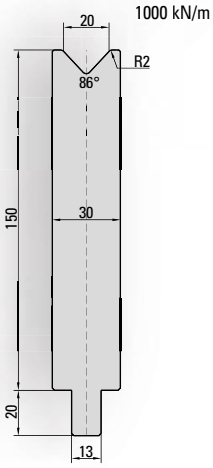
25.604		24h
500 mm	194,– €	15,5 kg
300 mm	142,– €	9,3 kg
200 mm	110,– €	6,2 kg
100 mm	76,– €	3,1 kg
550 mm sectionalized	452,– €	17,1 kg



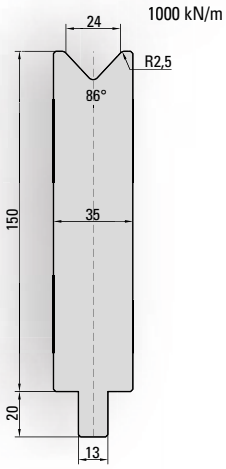
25.605		24h
500 mm	210,– €	18,0 kg
300 mm	152,– €	10,8 kg
200 mm	118,– €	7,2 kg
100 mm	82,– €	3,6 kg
550 mm sectionalized	474,– €	19,8 kg



25.606		24h
500 mm	220,– €	18,0 kg
300 mm	160,– €	10,8 kg
200 mm	122,– €	7,2 kg
100 mm	84,– €	3,6 kg
550 mm sectionalized	484,– €	19,8 kg



25.607		24h
500 mm	240,– €	21,0 kg
300 mm	176,– €	12,6 kg
200 mm	130,– €	8,4 kg
100 mm	90,– €	4,2 kg
550 mm sectionalized	514,– €	23,1 kg



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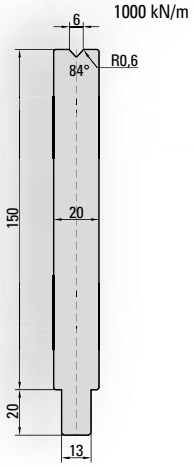
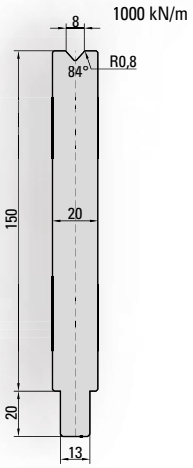
84° Dies, H = 150 mm

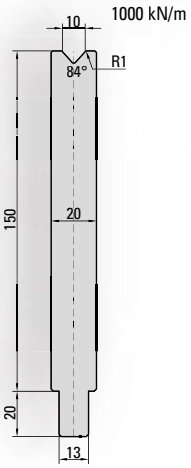
25.621		24h
500 mm	174,– €	12,5 kg
300 mm	128,– €	7,5 kg
200 mm	100,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	422,– €	13,8 kg



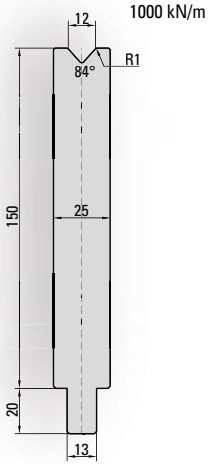
25.622		24h
500 mm	174,– €	12,5 kg
300 mm	128,– €	7,5 kg
200 mm	100,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	422,– €	13,8 kg



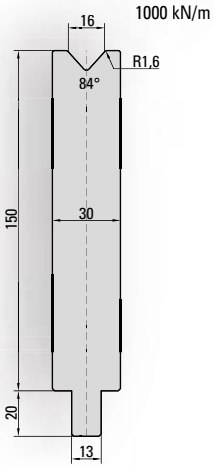
25.623		24h
500 mm	174,– €	12,5 kg
300 mm	128,– €	7,5 kg
200 mm	100,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	422,– €	13,8 kg



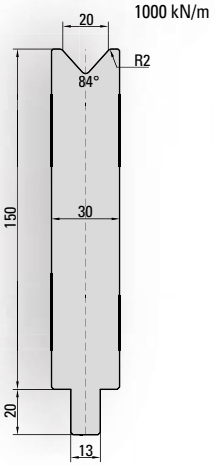
25.624		24h
500 mm	194,– €	15,5 kg
300 mm	142,– €	9,3 kg
200 mm	110,– €	6,2 kg
100 mm	76,– €	3,1 kg
550 mm sectionalized	452,– €	17,1 kg



25.625		24h
500 mm	210,– €	18,0 kg
300 mm	152,– €	10,8 kg
200 mm	118,– €	7,2 kg
100 mm	82,– €	3,6 kg
550 mm sectionalized	474,– €	19,8 kg

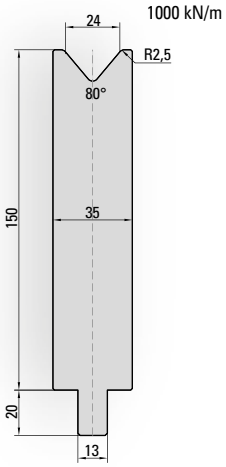


25.626		24h
500 mm	220,– €	18,0 kg
300 mm	160,– €	10,8 kg
200 mm	122,– €	7,2 kg
100 mm	84,– €	3,6 kg
550 mm sectionalized	484,– €	19,8 kg

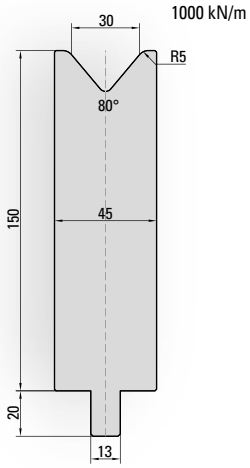


80° Dies, H = 150 mm

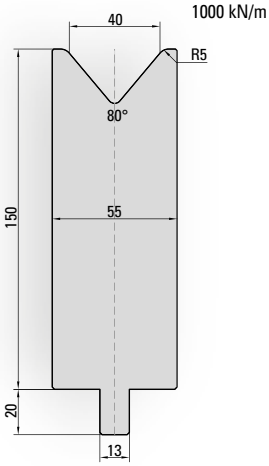
25.627		24h
500 mm	246,– €	21,0 kg
300 mm	178,– €	12,6 kg
200 mm	132,– €	8,4 kg
100 mm	90,– €	4,2 kg
550 mm sectionalized	520,– €	23,1 kg



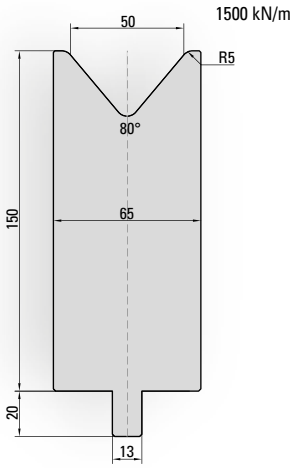
25.628		24h
500 mm	296,– €	26,0 kg
300 mm	212,– €	15,6 kg
200 mm	160,– €	10,4 kg
100 mm	108,– €	5,2 kg
550 mm sectionalized	610,– €	28,6 kg



25.629		24h
500 mm	378,– €	31,0 kg
300 mm	270,– €	18,6 kg
200 mm	200,– €	12,4 kg
100 mm	130,– €	6,2 kg
550 mm sectionalized	712,– €	34,1 kg



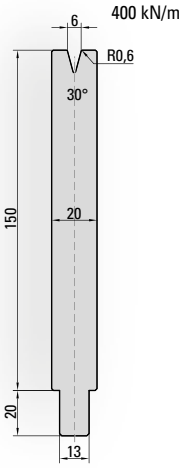
25.630		24h
500 mm	500,– €	36,0 kg
300 mm	358,– €	21,6 kg
200 mm	262,– €	14,4 kg
100 mm	162,– €	7,2 kg
550 mm sectionalized	866,– €	39,6 kg



30° Dies, H = 150 mm

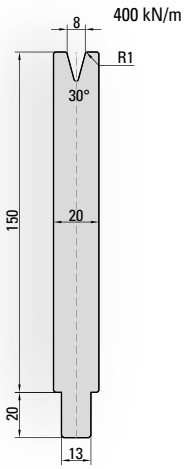
25.901		24h
500 mm	246,– €	12,5 kg
300 mm	178,– €	7,5 kg
200 mm	132,– €	5,0 kg
100 mm	90,– €	2,5 kg
550 mm sectionalized	508,– €	13,8 kg

60.130



25.902		24h
500 mm	246,– €	12,5 kg
300 mm	178,– €	7,5 kg
200 mm	132,– €	5,0 kg
100 mm	90,– €	2,5 kg
550 mm sectionalized	508,– €	13,8 kg

60.130



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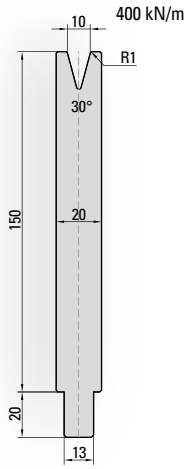
30° Dies, H = 150 mm

25.903 — 24h

500 mm	246,– €	12,5 kg
300 mm	178,– €	7,5 kg
200 mm	132,– €	5,0 kg
100 mm	90,– €	2,5 kg
550 mm sectionalized	508,– €	13,8 kg

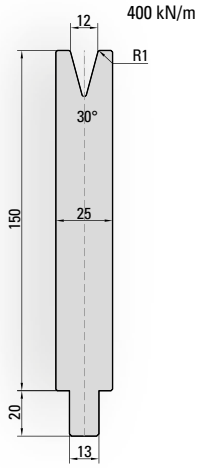
60.130



25.904 — 24h

500 mm	256,– €	15,0 kg
300 mm	184,– €	9,0 kg
200 mm	138,– €	6,0 kg
100 mm	94,– €	3,0 kg
550 mm sectionalized	530,– €	16,5 kg

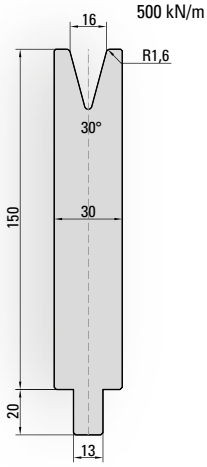
60.130



25.905 — 24h

500 mm	276,– €	17,5 kg
300 mm	200,– €	10,5 kg
200 mm	152,– €	7,0 kg
100 mm	98,– €	3,5 kg
550 mm sectionalized	556,– €	19,3 kg

60.130

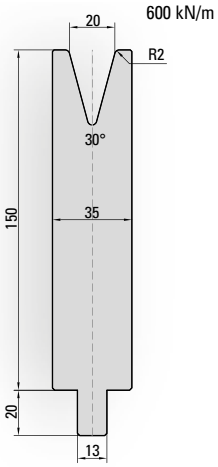


UKB-INFO 60.130

Dies with this symbol can be used with an additional drill hole 70.810 with screwable flattening die 60.130 - further information see page 79!

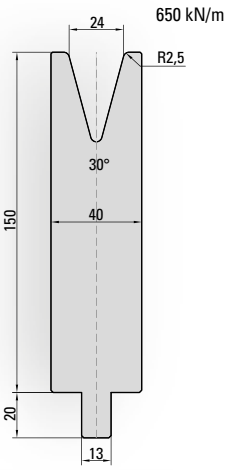
25.906 — 24h

500 mm	294,– €	20,0 kg
300 mm	212,– €	12,0 kg
200 mm	158,– €	8,0 kg
100 mm	104,– €	4,0 kg
550 mm sectionalized	580,– €	22,0 kg



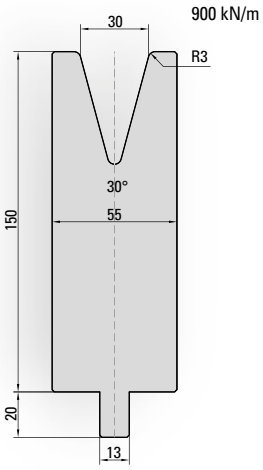
25.907 — 24h

500 mm	308,– €	22,5 kg
300 mm	222,– €	13,5 kg
200 mm	166,– €	9,0 kg
100 mm	108,– €	4,5 kg
550 mm sectionalized	606,– €	24,8 kg



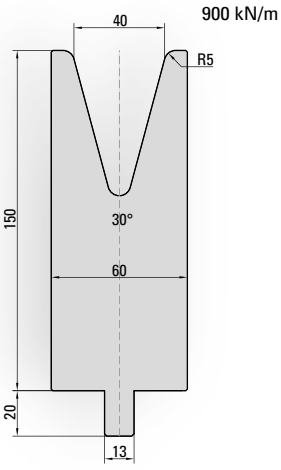
25.908 — 24h

500 mm	460,– €	30,0 kg
300 mm	330,– €	18,0 kg
200 mm	240,– €	12,0 kg
100 mm	152,– €	6,0 kg
550 mm sectionalized	814,– €	33,0 kg



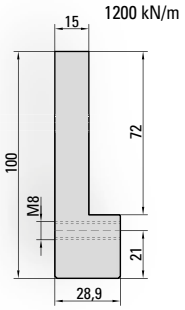
25.909 — 24h

500 mm	560,– €	30,0 kg
300 mm	406,– €	18,0 kg
200 mm	292,– €	12,0 kg
100 mm	176,– €	6,0 kg
550 mm sectionalized	916,– €	33,0 kg

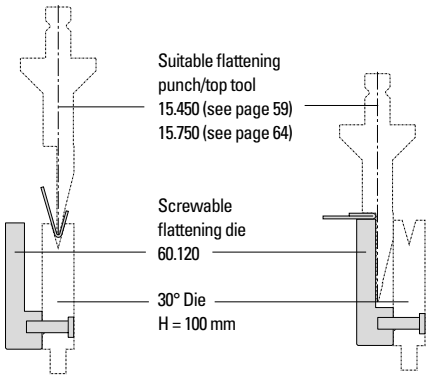


Screwable flattening die H = 100 mm

60.120		24h
500 mm	294,– €	7,5 kg
300 mm	226,– €	4,5 kg
200 mm	168,– €	3,0 kg
100 mm	98,– €	1,5 kg
550 mm sectionalized	490,– €	8,3 kg



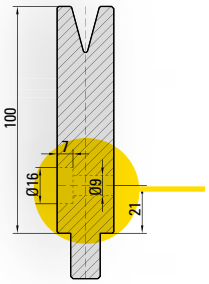
EXAMPLE OF USE



Only usable with i-axis displacement

70.800	
500 mm	26,– €
300 mm	22,– €
200 mm	18,– €
100 mm	12,– €
550 mm sectionalized	54,– €

Delivery time 1–3 working days



Drill hole in the die for the use of screwable flattening die 60.120

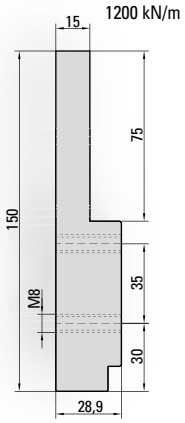
UKB-INFO

60.120

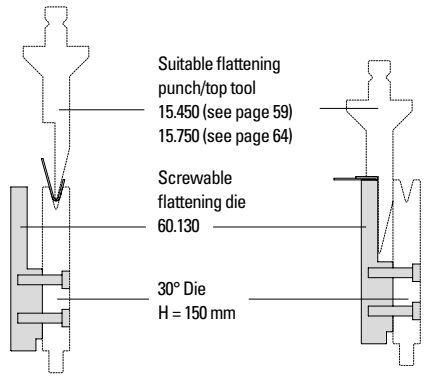
Suitable 30° dies H = 100 mm
see page 72 – 74

Screwable flattening die H = 150 mm

60.130		24h
500 mm	392,– €	13,0 kg
300 mm	274,– €	7,8 kg
200 mm	206,– €	5,2 kg
100 mm	128,– €	2,6 kg
550 mm sectionalized	636,– €	14,3 kg



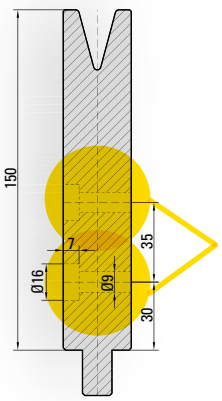
EXAMPLE OF USE



Only usable with i-axis displacement

70.810	
500 mm	44,– €
300 mm	38,– €
200 mm	28,– €
100 mm	18,– €
550 mm sectionalized	84,– €

Delivery time 1–3 working days



Drill holes in the die for the use of screwable flattening die 60.130

UKB-INFO

60.130

Suitable 30° dies H = 150 mm
see page 77 – 78

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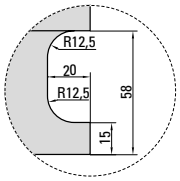
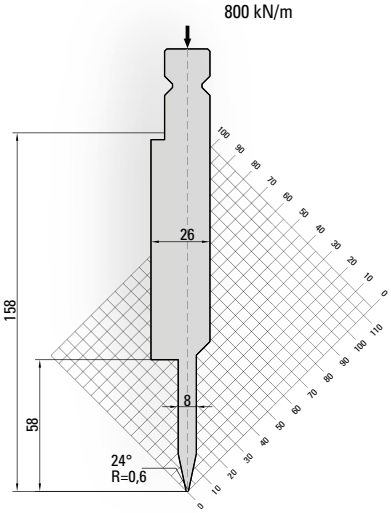
Flattening punches/top tools and flattening dies

15.902 24h

Safety pins		
500 mm	442,– €	14,0 kg

Simple Clamp		
300 mm	392,– €	8,4 kg
200 mm	296,– €	5,6 kg
100 mm	158,– €	2,8 kg
550 mm sectionalized	1.118,– €	15,4 kg

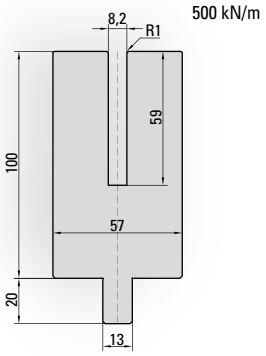




25.992 24h

500 mm	444,– €	21,5 kg
300 mm	326,– €	12,9 kg
200 mm	232,– €	8,6 kg
100 mm	138,– €	4,3 kg
550 mm sectionalized	758,– €	23,6 kg

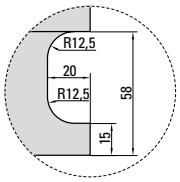
Max. 1,2 mm material thickness
R_m = 400 N/mm²

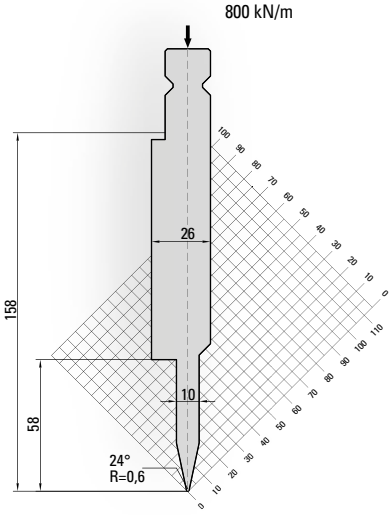


15.904 24h

Safety pins		
500 mm	442,– €	14,5 kg

Simple Clamp		
300 mm	392,– €	8,7 kg
200 mm	296,– €	5,8 kg
100 mm	158,– €	2,9 kg
550 mm sectionalized	1.118,– €	16,0 kg

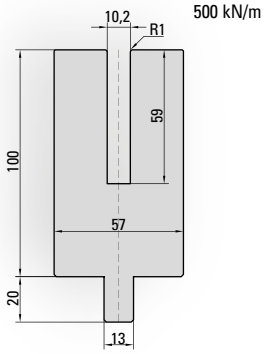




25.994 24h

500 mm	444,– €	21,0 kg
300 mm	326,– €	12,6 kg
200 mm	232,– €	8,4 kg
100 mm	138,– €	4,2 kg
550 mm sectionalized	758,– €	23,1 kg

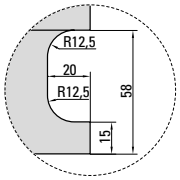
Max. 1,8 mm material thickness
R_m = 400 N/mm²

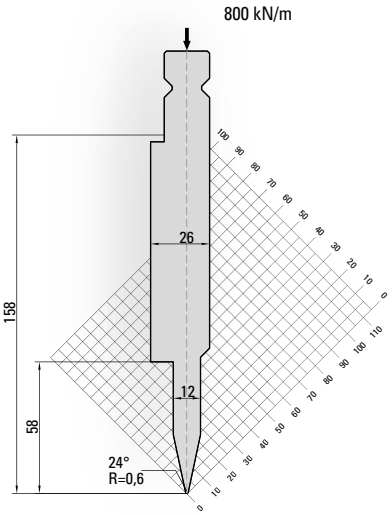


15.905 24h

Safety pins		
500 mm	442,– €	15,0 kg

Simple Clamp		
300 mm	392,– €	9,0 kg
200 mm	296,– €	6,0 kg
100 mm	158,– €	3,0 kg
550 mm sectionalized	1.118,– €	16,5 kg

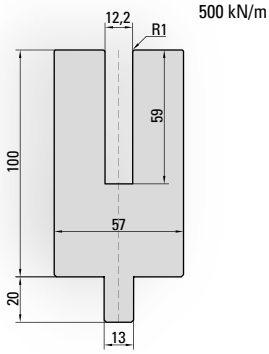




25.995 24h

500 mm	444,– €	20,5 kg
300 mm	326,– €	12,3 kg
200 mm	232,– €	8,2 kg
100 mm	138,– €	4,1 kg
550 mm sectionalized	758,– €	22,6 kg

Max. 2,5 mm material thickness
R_m = 400 N/mm²



Flattening punches/top tools and flattening dies

EXAMPLE OF USE

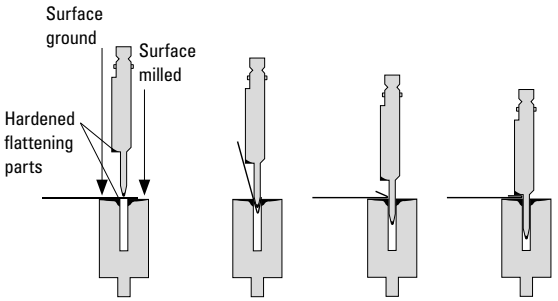


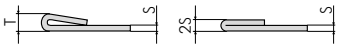
Table of force for flattening

Material: R_m = 400 N/mm² (St)

S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	9	3,0	23	1,2
0,8	12	3,0	32	1,6
1,0	15	3,5	40	2,0
1,25	17	3,5	50	2,5
1,5	22	4,6	63	3,0
2,0	30	5,5	80	4,0
2,5	55	6,5	90	5,0
3,0	70	8,0	100	6,0

Material: R_m = 700 N/mm² (VA)

S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	15	3,0	35	1,2
0,8	20	3,0	50	1,6
1,0	25	3,5	60	2,0
1,25	26	3,5	80	2,5
1,5	38	4,6	95	3,0
2,0	50	5,5	130	4,0



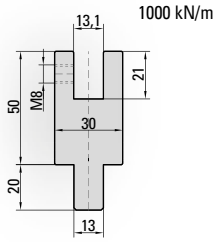
VIDEO

UKB-Press brake tool systems

Die heightenings

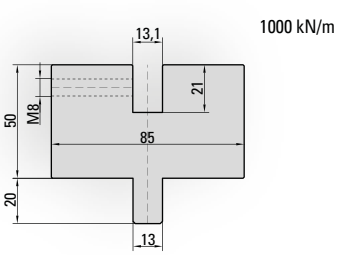
60.960 24h

500 mm	310,– €	5,8 kg



60.965 24h

500 mm	358,– €	16,6 kg



UKB-FIELD SERVICE

- *Individual advice and sale*
- *Technical solutions for special bending tasks*
- *Test bending on-site or at the UKB-test center*
- *Pick up service for tools to rework*

PRESS BRAKE TOOLS UKB-SYSTEM WILA

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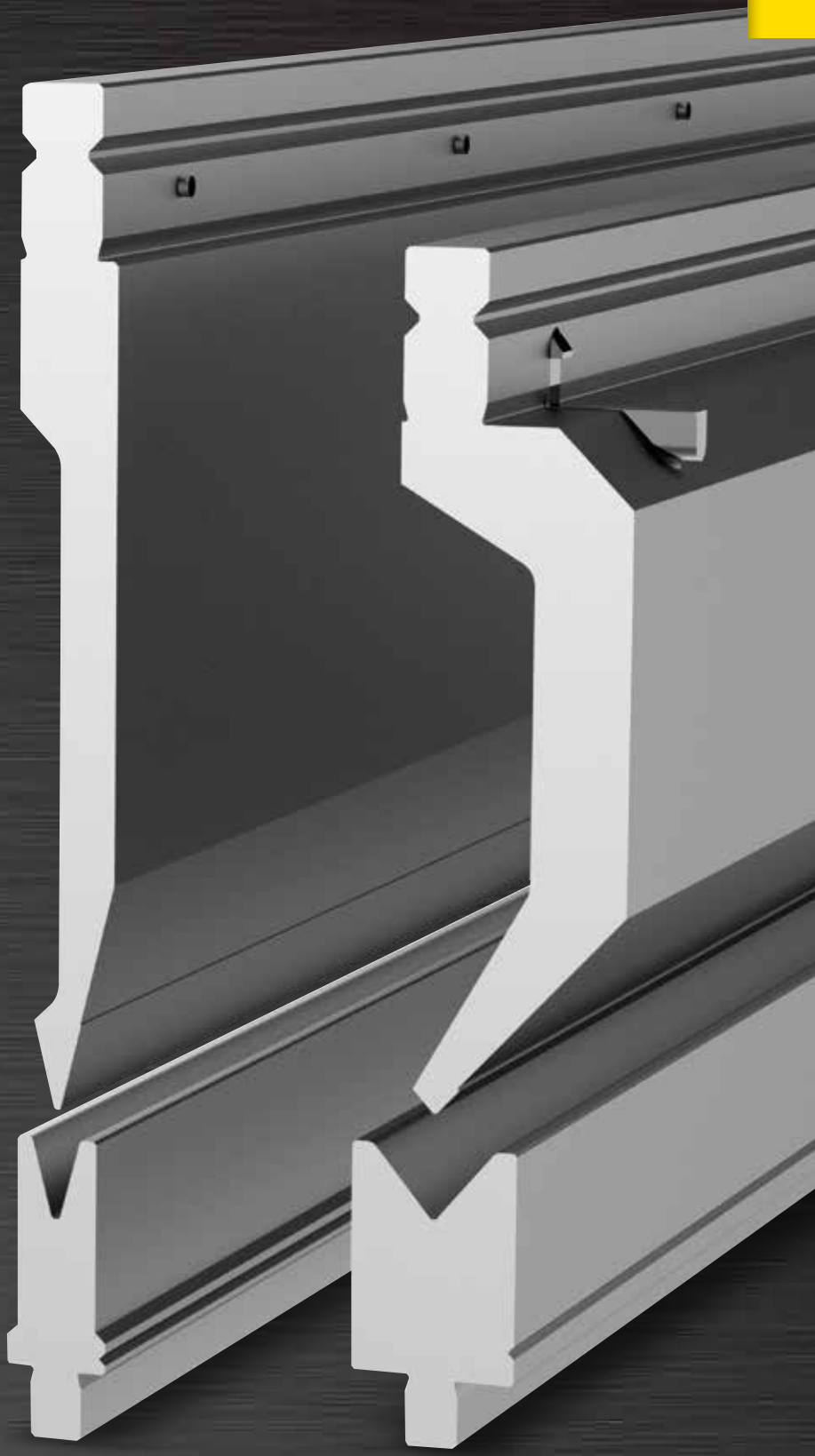
Dies

86° Dies, H = 55 mm 93

80° Dies, H = 55/65 mm 94

30° Dies, H = 55 mm 95

FOLLOW US!



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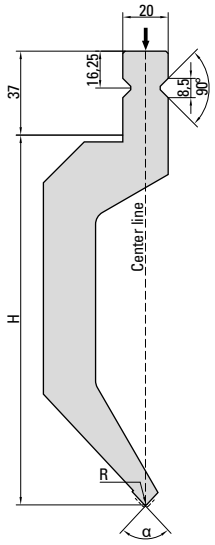
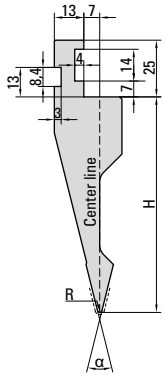
Quality and precision

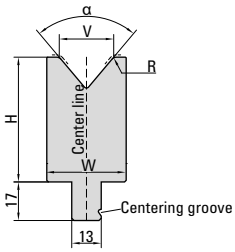
- ▶ Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, tempered to 800 – 850 N/mm²
  - C45, 650 – 800 N/mm²
- ▶ Bending radius/intake radii hardened up to 52 – 55 HRC
- ▶ Precision ground
- ▶ Guaranteed exchangeability and parallelism
- ▶ Punch/top tool clampings Wila type I in two different models
  - Simple Clamp at segments < 12,5 kg
  - Safety pin at segments > 12,5 kg
- ▶ Punch/top tool clampings Wila type I
  - Self centering
  - Usable on both sides
- ▶ Tool marking with all technical information

Wila type I



Wila type II





UKB-CONTACT PARTNER

You will find your personal contact partner at
www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- ▶ **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- ▶ **Delivery time:** Press brake tools UKB-System Wila in **24 h**
- ▶ **Shipping:** Orders placed before 4:00pm on the same working day
- ▶ **Delivery service:**

Standard:	1 – 3 working days by parcel service or forwarder
Express:	DE 9:00, 10:30, 12:00am or 1 working day EU 1 working day
Direct courier:	According agreement

- ▶ **Package:** Ecologically sensitive and safe - with self recycled packing material
- ▶ **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

Tool lengths

PUNCHES/TOP TOOLS WITH SIMPLE CLAMP

Length **515 mm**

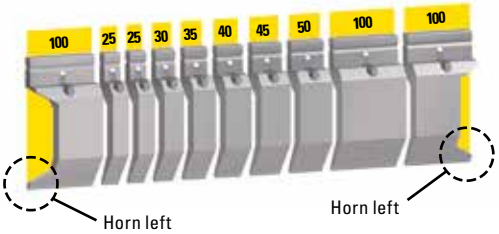
Length **300 mm**

Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments with horn extension left and right



Simple Clamp

PUNCHES/TOP TOOLS WITH SAFETY PINS

Length **515 mm**

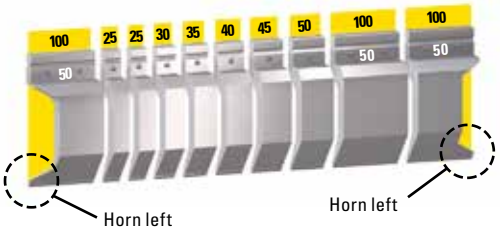
Length **300 mm**

Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments with horn extension left and right



Safety pin

DIES

Length **515 mm**

Length **300 mm**

Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized dies are delivered as a complete set
- 9 Segments

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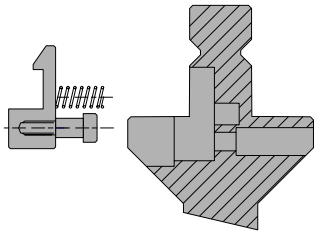
Simple Clamp

ADVANTAGES

- **Vertical** tool change for segments **up to 12,5 kg**
- Less set-up time
- Easy handling

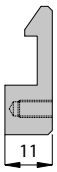
Set consists of screw, spring and Simple Clamp

Vertical tool change



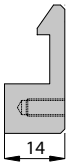
70.714		24h
Set	14,– €	0,012 kg

Suitable for punches/top tools
19.034 / 19.024



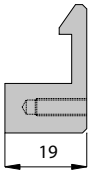
70.715		24h
Set	14,– €	0,014 kg

Suitable for punches/top tools
19.031 / 19.021 / 19.224



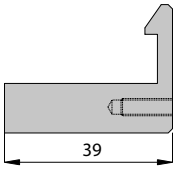
70.716		24h
Set	16,– €	0,016 kg

Suitable for punches/top tools
19.032 / 19.022



70.718		24h
Set	18,– €	0,027 kg

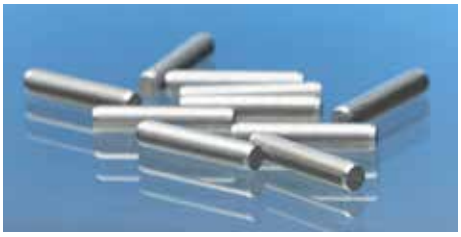
Suitable for punches/top tools
19.033 / 19.233 / 19.023 / 19.226



Safety pins

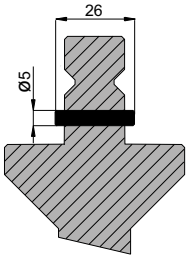
ADVANTAGES

- **Horizontal** tool change for segments **more than 12,5 kg**
- Favorable purchase price (in comparison with Simple Clamp)
- Hardened Safety pins on demand



Safety pins

Horizontal tool change



70.130		24h
10 Pieces	3,50 €	0,16 kg

Hardened

70.140		24h
10 Pieces	1,50 €	0,16 kg

Not hardened

Flexible modification

PUNCHES/TOP TOOLS

- Special cuttings
- Individual horn extensions
- Insertion of Simple Clamp
- Insertion of Safety pins
- Laser marking

VIDEO

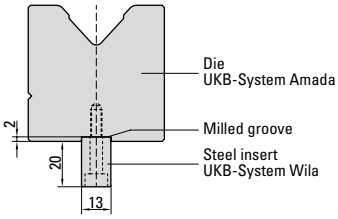
UKB-Modification of press brake tools

DIES

- Special cuttings
- Laser marking

Insertion of a steel insert

MODIFICATION EXAMPLE



By mounting a steel insert (page 246) dies UKB-System Amada can be used also in a clamping UKB-System Wila.

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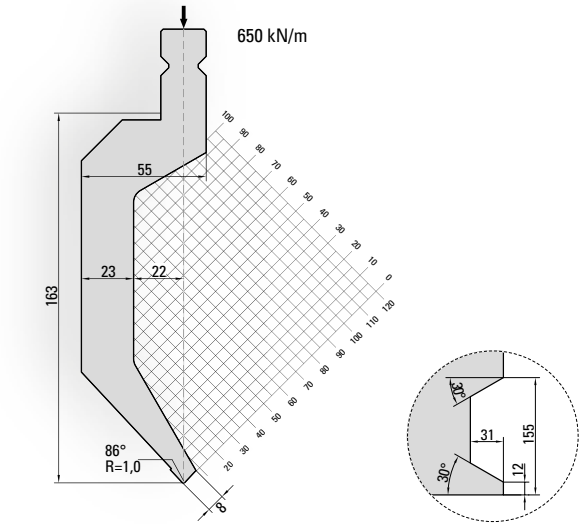
Punches/top tools Wila type I, H = 163 mm

19.023 24h

Safety pins		
515 mm	558,– €	19,1 kg

Simple Clamp		
300 mm	462,– €	11,1 kg
200 mm	370,– €	7,4 kg
100 mm	190,– €	3,7 kg
550 mm sectionalized	1.052,– €	20,4 kg



Further radii

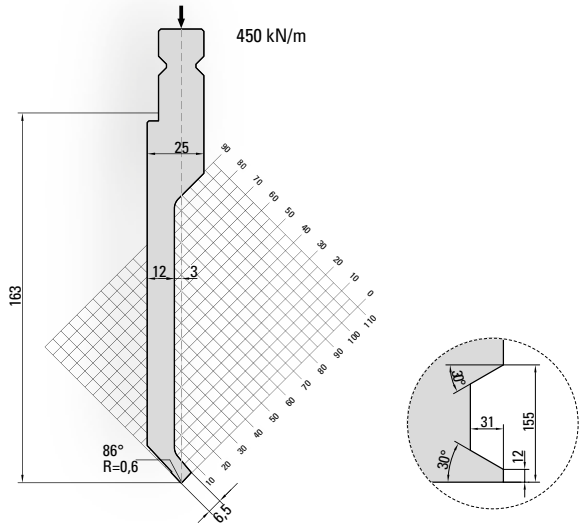
R (mm)	H (mm)
0,5	162,8
2,0	162,2
2,5	162,0
3,0	161,7
4,0	161,3
5,0	160,8
6,0	160,3

Prices and other radii on demand

Delivery time 1–3 working days

19.224 24h

Simple Clamp		
515 mm	392,– €	12,2 kg
300 mm	330,– €	7,1 kg
200 mm	260,– €	4,7 kg
100 mm	150,– €	2,4 kg
550 mm sectionalized	740,– €	13,0 kg



Further radii

R (mm)	H (mm)
1,0	162,4
2,0	162,0
2,5	161,7
3,0	161,5
4,0	161,0
5,0	160,6

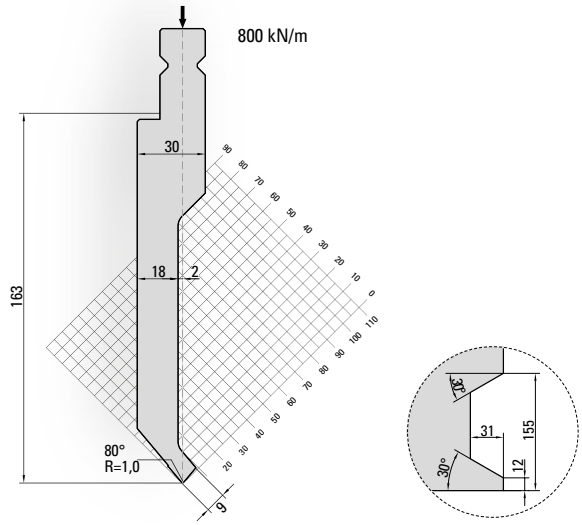
Prices and other radii on demand

Delivery time 1–3 working days

19.022 24h

Safety pins		
515 mm	408,– €	16,0 kg

Simple Clamp		
300 mm	336,– €	9,3 kg
200 mm	270,– €	6,2 kg
100 mm	140,– €	3,1 kg
550 mm sectionalized	770,– €	17,1 kg



Further radii

R (mm)	H (mm)
0,5	162,8
2,0	162,2
2,5	161,9
3,0	161,6
4,0	161,1
5,0	160,5
6,0	160,0

Prices and other radii on demand

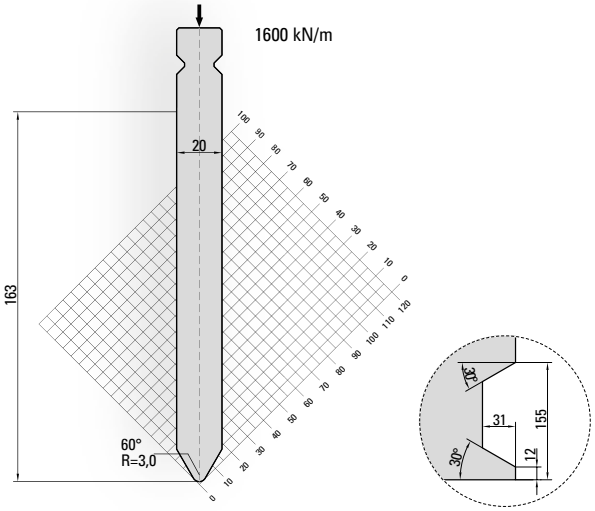
Delivery time 1–3 working days

Punches/top tools Wila type I, H = 163 mm

19.024 24h

Safety pins		
515 mm	366,– €	16,0 kg

Simple Clamp		
300 mm	290,– €	9,3 kg
200 mm	240,– €	6,2 kg
100 mm	124,– €	3,1 kg
550 mm sectionalized	688,– €	17,1 kg



Further radii

R (mm)	H (mm)
1,0	162,8
2,0	162,8
2,5	162,8
4,0	161,6
5,0	160,6
6,0	159,6

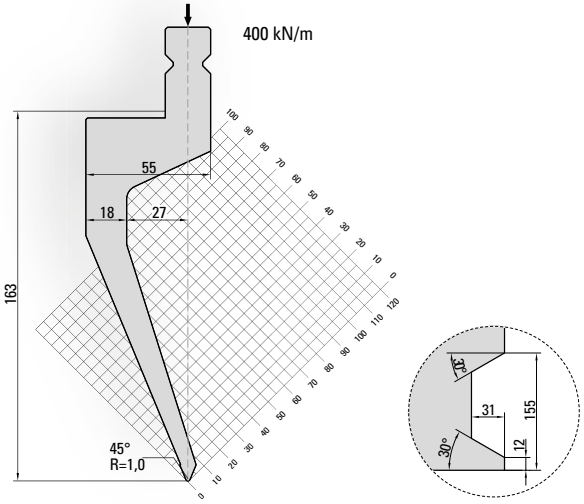
Prices and other radii on demand

Delivery time 1–3 working days

19.226 24h

Safety pins		
515 mm	646,– €	15,5 kg

Simple Clamp		
300 mm	530,– €	9,0 kg
200 mm	426,– €	6,0 kg
100 mm	220,– €	3,0 kg
550 mm sectionalized	1.218,– €	16,5 kg



Further radii

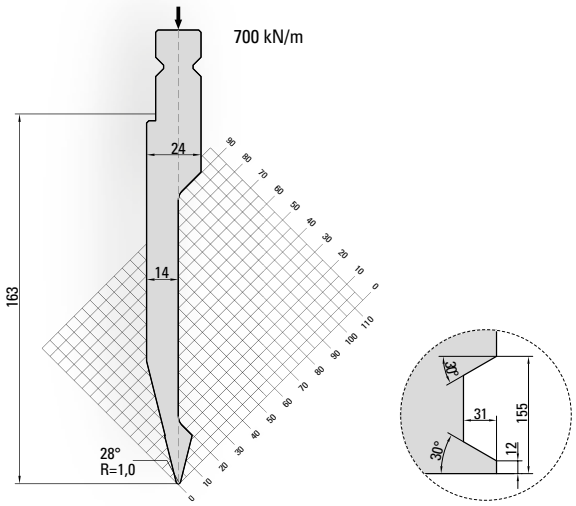
R (mm)	H (mm)
0,5	162,8
2,0	160,8
2,5	159,2

Prices and other radii on demand

Delivery time 1–3 working days

19.021 24h

Simple Clamp		
515 mm	396,– €	12,4 kg
300 mm	318,– €	7,2 kg
200 mm	262,– €	4,8 kg
100 mm	136,– €	2,4 kg
550 mm sectionalized	748,– €	13,2 kg



Further radii

R (mm)	H (mm)
0,5	162,8
2,0	159,0
2,5	157,4
3,0	155,8
4,0	152,8

Prices and other radii on demand

Delivery time 1–3 working days

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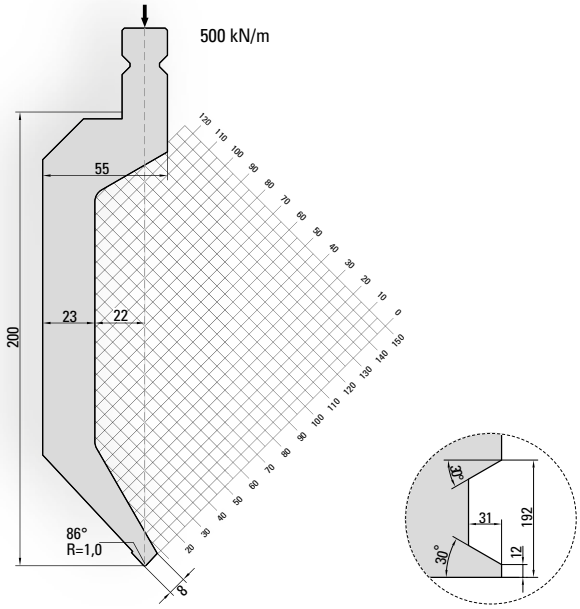
Punches/top tools Wila type I, H = 200 mm

19.033 24h

Safety pins		
515 mm	604,– €	22,7 kg
300 mm	368,– €	13,2 kg

Simple Clamp		
200 mm	398,– €	8,8 kg
100 mm	206,– €	4,4 kg
550 mm sectionalized	1.138,– €	24,2 kg



Further radii	
R (mm)	H (mm)
0,5	199,8
2,0	199,2
2,5	199,0
3,0	198,7
4,0	198,3
5,0	197,8
6,0	197,3

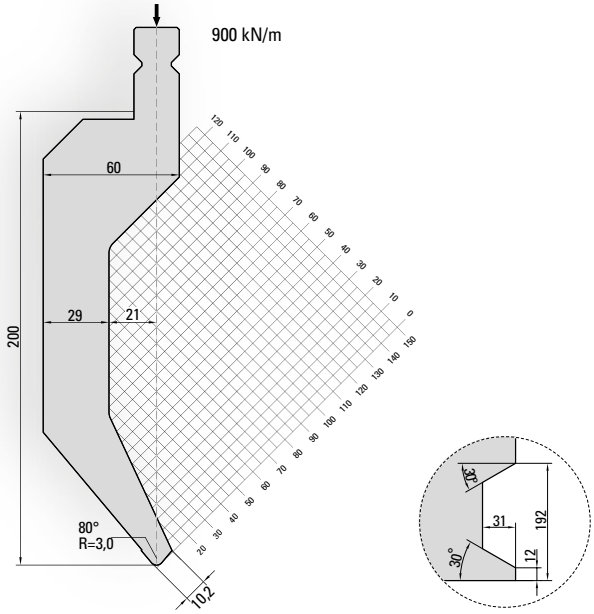
Prices and other radii on demand

Delivery time 1–3 working days

19.233 24h

Safety pins		
515 mm	676,– €	28,9 kg
300 mm	434,– €	16,8 kg

Simple Clamp		
200 mm	364,– €	11,2 kg
100 mm	208,– €	5,6 kg
550 mm sectionalized	1.274,– €	30,9 kg



Further radii	
R (mm)	H (mm)
2,0	199,8
2,5	199,8
4,0	199,1
5,0	198,5
6,0	198,0

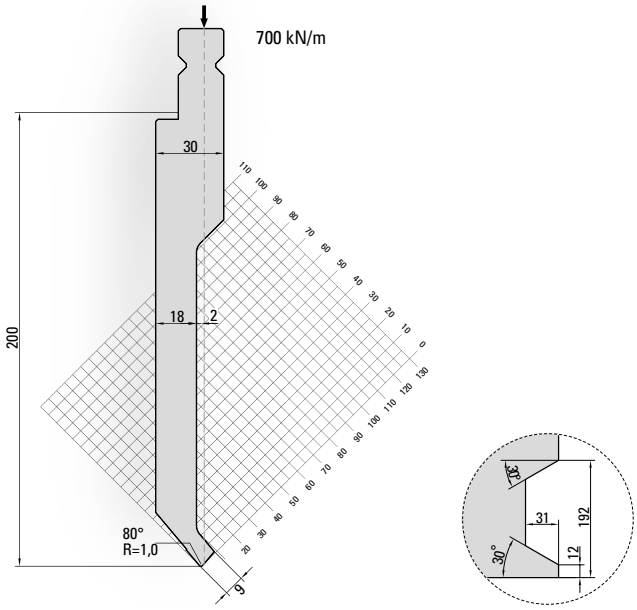
Prices and other radii on demand

Delivery time 1–3 working days

19.032 24h

Safety pins		
515 mm	440,– €	19,6 kg

Simple Clamp		
300 mm	364,– €	11,4 kg
200 mm	292,– €	7,6 kg
100 mm	150,– €	3,8 kg
550 mm sectionalized	830,– €	20,9 kg



Further radii	
R (mm)	H (mm)
0,5	199,8
2,0	199,2
2,5	198,9
3,0	198,6
4,0	198,1
5,0	197,5
6,0	197,0

Prices and other radii on demand

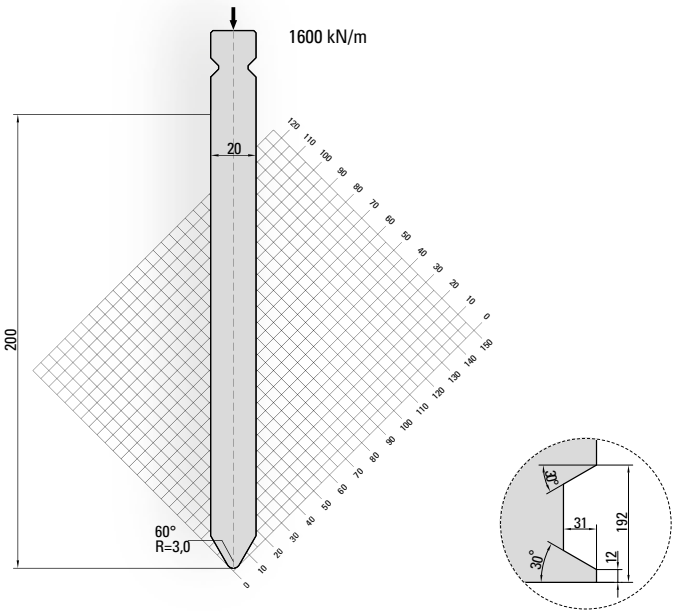
Delivery time 1–3 working days

Punches/top tools Wila type I, H = 200 mm

19.034 24h

Safety pins		
515 mm	394,– €	19,0 kg

Simple Clamp		
300 mm	326,– €	11,1 kg
200 mm	260,– €	7,4 kg
100 mm	134,– €	3,7 kg
550 mm sectionalized	742,– €	20,4 kg



Further radii

R (mm)	H (mm)
1,0	199,8
2,0	199,8
2,5	199,8
4,0	198,6
5,0	197,6
6,0	196,6

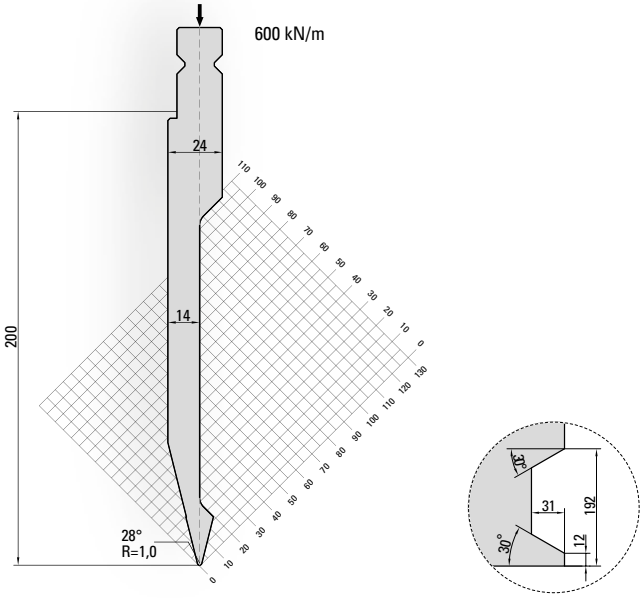
Prices and other radii on demand

Delivery time 1–3 working days

19.031 24h

Safety pins		
515 mm	428,– €	15,0 kg

Simple Clamp		
300 mm	354,– €	8,7 kg
200 mm	282,– €	5,8 kg
100 mm	146,– €	2,9 kg
550 mm sectionalized	806,– €	16,0 kg



Further radii

R (mm)	H (mm)
0,5	199,8
2,0	196,0
2,5	194,4
3,0	192,8
4,0	189,8

Prices and other radii on demand

Delivery time 1–3 working days

UKB-INFO

Punches/top tools UKB-System Trumpf (chapter 2) and UKB-System LVD type I (chapter 4) can also be used in a clamping UKB-System Wila!

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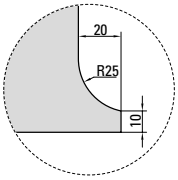
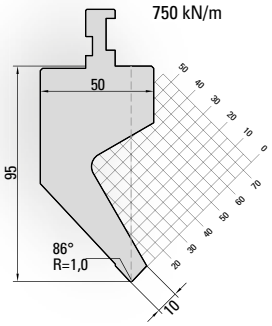
Punches/top tools Wila type II, H = 95/175 mm

14.040 — 24h

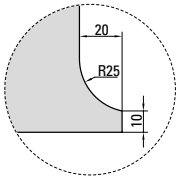
500 mm	284,– €	12,5 kg
300 mm	194,– €	7,5 kg
200 mm	130,– €	5,0 kg
100 mm	72,– €	2,5 kg
550 mm sectionalized	508,– €	13,8 kg

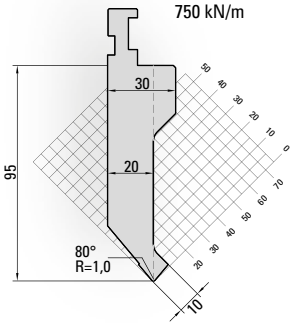




14.020 — 24h

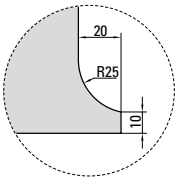
500 mm	216,– €	9,0 kg
300 mm	158,– €	5,4 kg
200 mm	108,– €	3,6 kg
100 mm	60,– €	1,8 kg
550 mm sectionalized	414,– €	9,9 kg

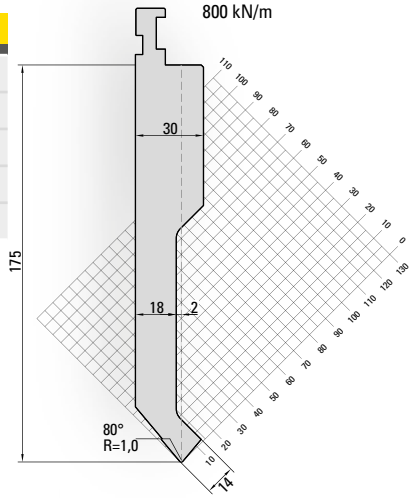




14.060 — 24h

500 mm	340,– €	17,0 kg
300 mm	246,– €	10,2 kg
200 mm	170,– €	6,8 kg
100 mm	94,– €	3,4 kg
550 mm sectionalized	706,– €	18,7 kg

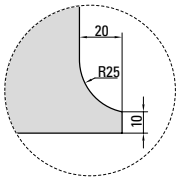


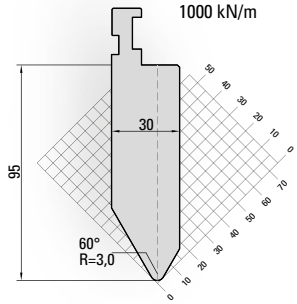


14.010 — 24h

500 mm	184,– €	11,0 kg
300 mm	130,– €	6,6 kg
200 mm	92,– €	4,4 kg
100 mm	50,– €	2,2 kg
550 mm sectionalized	380,– €	12,1 kg

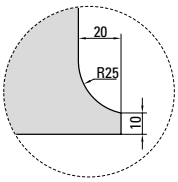
1500 kN/m if the tool clamping has the corresponding load

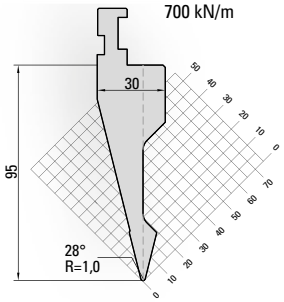




14.030 — 24h

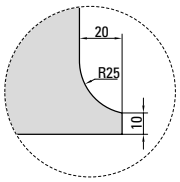
500 mm	248,– €	7,0 kg
300 mm	184,– €	4,2 kg
200 mm	126,– €	2,8 kg
100 mm	66,– €	1,4 kg
550 mm sectionalized	448,– €	7,7 kg

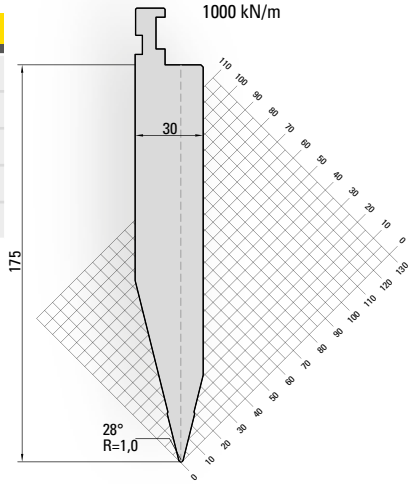




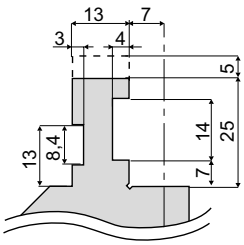
14.050 — 24h

500 mm	368,– €	18,0 kg
300 mm	266,– €	10,8 kg
200 mm	184,– €	7,2 kg
100 mm	104,– €	3,6 kg
550 mm sectionalized	782,– €	19,8 kg





MODIFICATION OF CLAMPING UKB-SYSTEM AMADA

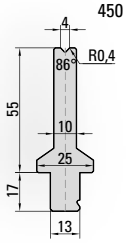


By milling an additional groove and shortening of the head (page 240) punches/top tools UKB-System Amada (chapter 1) can also be used in a clamping UKB-System Wila type II.

86° Dies H = 55 mm

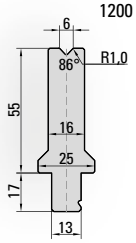
29.524		24h
515 mm	240,– €	3,6 kg
300 mm	208,– €	2,1 kg
200 mm	162,– €	1,4 kg
100 mm	82,– €	0,7 kg
550 mm sectionalized	436,– €	3,9 kg

450 kN/m



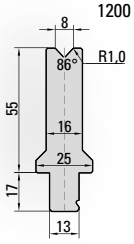
29.521		24h
515 mm	230,– €	4,6 kg
300 mm	196,– €	2,7 kg
200 mm	154,– €	1,8 kg
100 mm	80,– €	0,9 kg
550 mm sectionalized	414,– €	5,0 kg

1200 kN/m



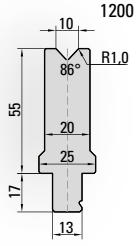
29.510		24h
515 mm	230,– €	4,6 kg
300 mm	196,– €	2,7kg
200 mm	154,– €	1,8 kg
100 mm	80,– €	0,9 kg
550 mm sectionalized	414,– €	5,0 kg

1200 kN/m



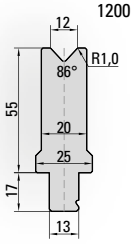
29.522		24h
515 mm	230,– €	5,7 kg
300 mm	196,– €	3,3 kg
200 mm	154,– €	2,2 kg
100 mm	80,– €	1,1 kg
550 mm sectionalized	414,– €	6,0 kg

1200 kN/m



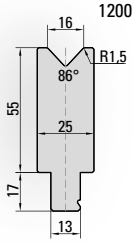
29.511		24h
515 mm	230,– €	5,2 kg
300 mm	196,– €	3,0 kg
200 mm	154,– €	2,0 kg
100 mm	80,– €	1,0 kg
550 mm sectionalized	414,– €	5,5 kg

1200 kN/m



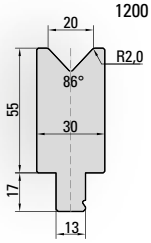
29.512		24h
515 mm	228,– €	6,2 kg
300 mm	196,– €	3,6 kg
200 mm	154,– €	2,4 kg
100 mm	80,– €	1,2 kg
550 mm sectionalized	414,– €	6,6 kg

1200 kN/m



29.523		24h
515 mm	236,– €	7,2 kg
300 mm	204,– €	4,2 kg
200 mm	160,– €	2,8 kg
100 mm	82,– €	1,4 kg
550 mm sectionalized	432,– €	7,7 kg

1200 kN/m



UKB-INFO

More dies height 55 mm see UKB-System Bystronic (chapter 5)

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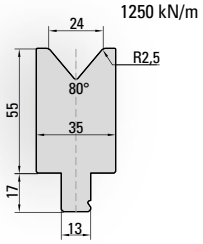
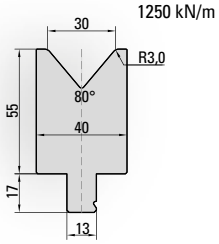
80° Dies, H = 55/65 mm

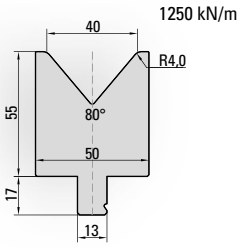
29.513		24h
515 mm	242,– €	8,2 kg
300 mm	208,– €	4,8 kg
200 mm	162,– €	3,2 kg
100 mm	84,– €	1,6 kg
550 mm sectionalized	438,– €	8,8 kg



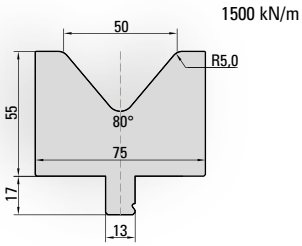
29.514		24h
515 mm	268,– €	8,8kg
300 mm	230,– €	5,1 kg
200 mm	180,– €	3,4 kg
100 mm	94,– €	1,7 kg
550 mm sectionalized	486,– €	9,3 kg



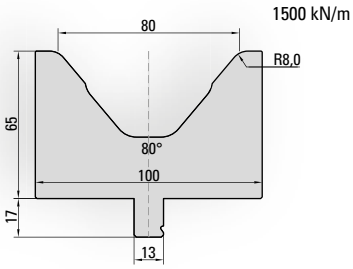
29.515		24h
515 mm	292,– €	10,3 kg
300 mm	250,– €	6,0 kg
200 mm	196,– €	4,0 kg
100 mm	102,– €	2,0 kg
550 mm sectionalized	530,– €	11,0 kg



29.535		24h
515 mm	348,– €	14,9 kg
300 mm	300,– €	8,7 kg
200 mm	234,– €	5,8 kg
100 mm	122,– €	2,9 kg
550 mm sectionalized	634,– €	15,9 kg



29.517		24h
515 mm	594,– €	19,6 kg
300 mm	386,– €	11,4 kg
200 mm	304,– €	7,6 kg
100 mm	138,– €	3,8 kg
550 mm sectionalized	772,– €	20,9kg



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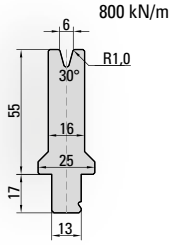
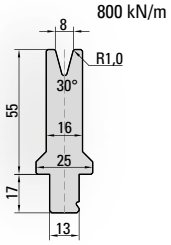
30° Dies, H = 55 mm

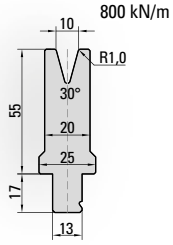
29.561		24h
515 mm	230,– €	4,6 kg
300 mm	196,– €	2,7 kg
200 mm	154,– €	1,8 kg
100 mm	80,– €	0,9 kg
550 mm sectionalized	414,– €	5,0 kg



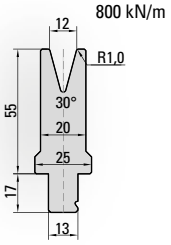
29.551		24h
515 mm	230,– €	4,6 kg
300 mm	196,– €	2,7 kg
200 mm	154,– €	1,8 kg
100 mm	80,– €	0,9 kg
550 mm sectionalized	414,– €	5,0 kg



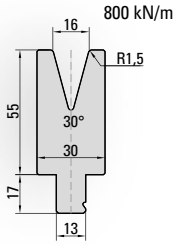
29.562		24h
515 mm	230,– €	5,2 kg
300 mm	196,– €	3,0 kg
200 mm	154,– €	2,0 kg
100 mm	80,– €	1,0 kg
550 mm sectionalized	414,– €	5,5 kg



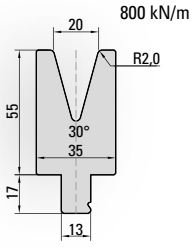
29.552		24h
515 mm	230,– €	5,2 kg
300 mm	196,– €	3,0 kg
200 mm	154,– €	2,0 kg
100 mm	80,– €	1,0 kg
550 mm sectionalized	414,– €	5,5 kg



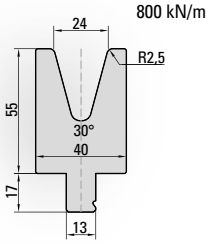
29.553		24h
515 mm	236,– €	6,7 kg
300 mm	204,– €	3,9 kg
200 mm	160,– €	2,6 kg
100 mm	82,– €	1,3 kg
550 mm sectionalized	432,– €	7,2 kg



29.563		24h
515 mm	250,– €	7,2 kg
300 mm	216,– €	4,2 kg
200 mm	168,– €	2,8 kg
100 mm	86,– €	1,4 kg
550 mm sectionalized	452,– €	7,7 kg



29.554		24h
515 mm	266,– €	7,7 kg
300 mm	226,– €	4,5 kg
200 mm	178,– €	3,0 kg
100 mm	92,– €	1,5 kg
550 mm sectionalized	482,– €	8,3 kg



UKB-INFO

Dies UKB-System Trumpf (chapter 2) and UKB-System Bystronic (chapter 5) can also be used in a clamping UKB-System Wila!

PRESS BRAKE TOOLS UKB-SYSTEM LVD

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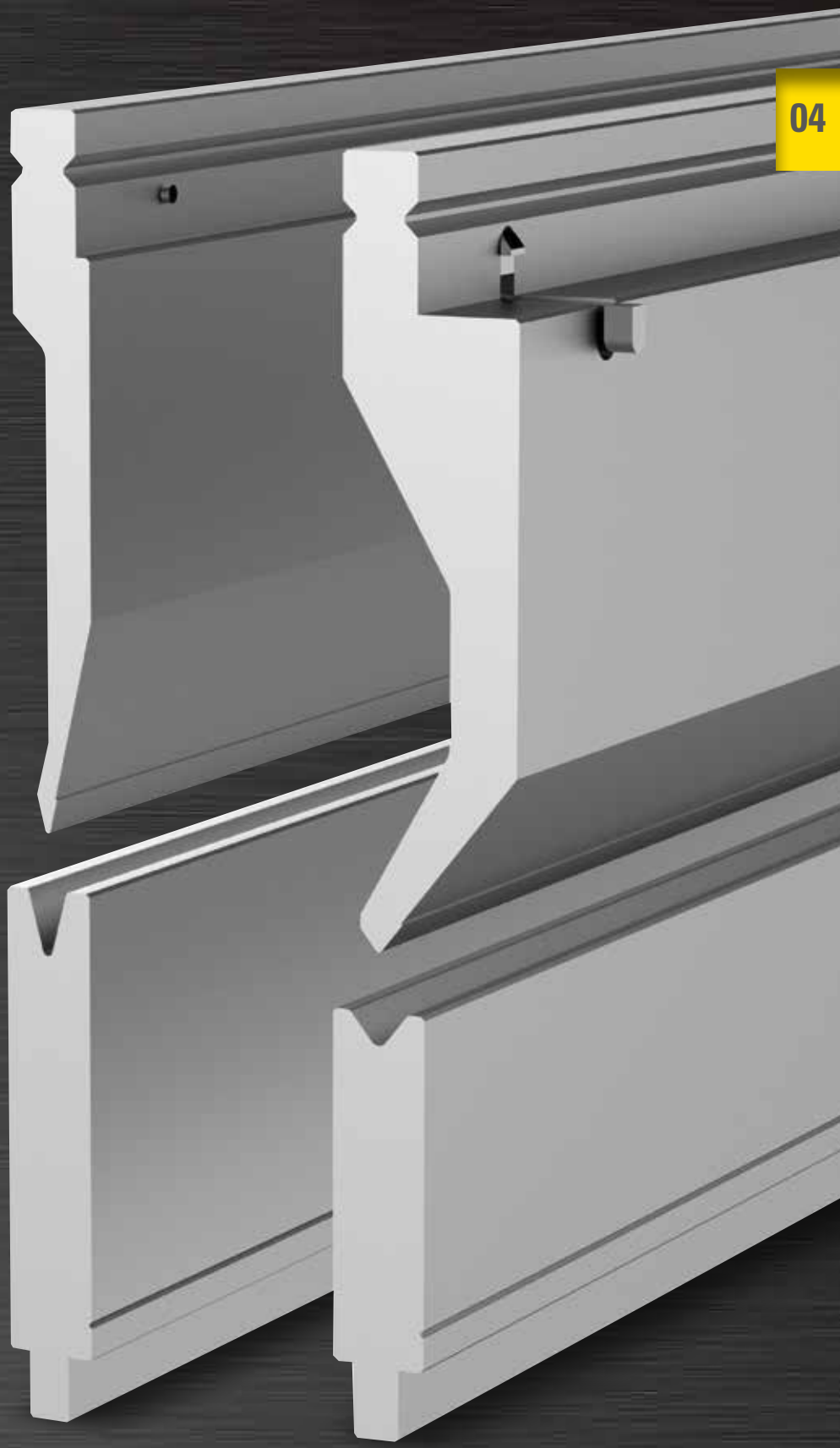

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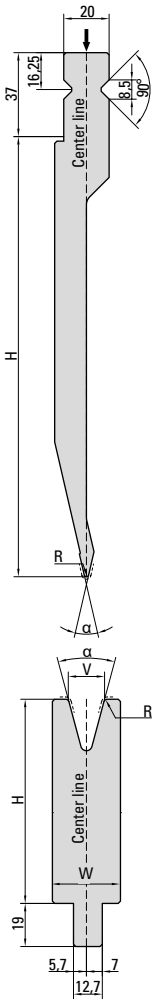
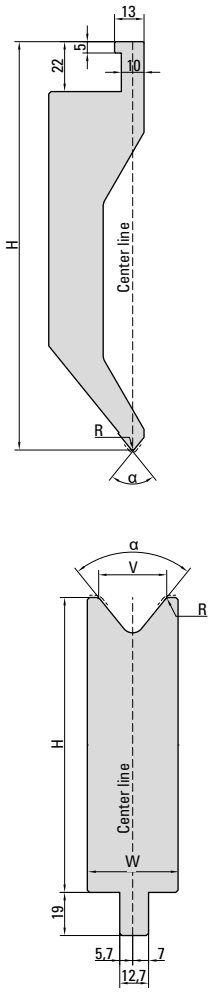
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, tempered to 800 – 850 N/mm²
  - C45, 650 – 800 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Punch/top tool clampings LVD type I in two different models
  - Simple Clamp at segments < 12,5 kg
  - Safety pin at segments > 12,5 kg
- Punch/top tool clampings LVD type I
  - Self centering
  - Usable on both sides
- Tool marking with all technical information

LVD type I



LVD type II



UKB-CONTACT PARTNER

You will find your personal contact partner at
www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** Press brake tools UKB-System LVD in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

  Standard: 1 – 3 working days by parcel service or forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

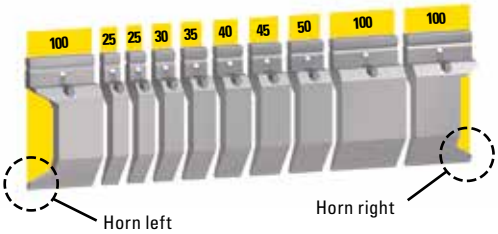
  Direct courier: According agreement
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

Tool lengths

PUNCHES/TOP TOOLS LVD TYPE I WITH SIMPLE CLAMP

Length **510 mm**



Length **550mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments with horn extension left and right

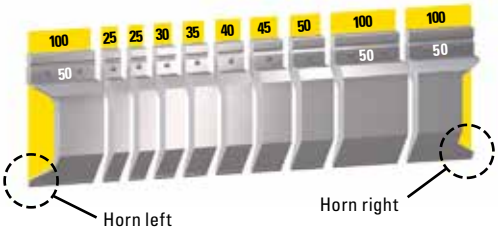
UKB-INFO

These lengths are also supplied with punches/top tools UKB-System LVD type II

Simple Clamp

PUNCHES/TOP TOOLS LVD TYPE I WITH SAFETY PINS

Length **510 mm**



Length **550mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments with horn extension left and right

Safety pin

DIES

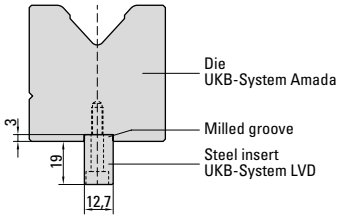
Length **510 mm**

Length **550mm sectionalized**

- Sectionalized dies are delivered as a complete set
- 9 Segments

Insertion of a steel insert

MOUNTING EXAMPLE



By mounting a steel insert (page 246) dies UKB-System Amada can also be used in clampings UKB-System LVD.

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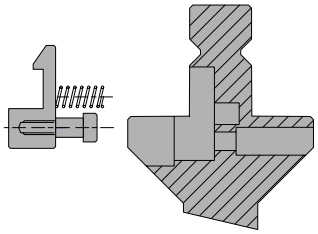
Simple Clamp

ADVANTAGES

- **Vertical** tool change for segments **up to 12,5 kg**
- Less set-up time
- Easy handling

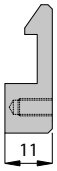
Set consists of screw, spring and Simple Clamp

Vertical tool change



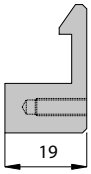
70.714		24h
Set	14,– €	0,012 kg

Suitable for punches/top tools
16.204 / 16.209



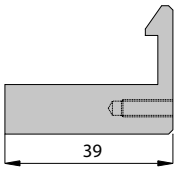
70.716		24h
Set	16,– €	0,016 kg

Suitable for punches/top tools
16.201 / 16.202 / 16.203
16.206 / 16.207 / 16.208



70.718		24h
Set	18,– €	0,027 kg

Suitable for punches/top tools
16.200 / 16.205



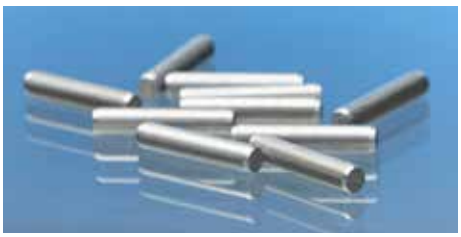
VIDEO

UKB-Press brake tool systems

Safety pins

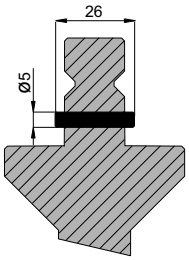
ADVANTAGES

- **Horizontal** tool change for segments **more than 12,5 kg**
- Favorable purchase price (in comparison with Simple Clamp)
- Hardened Safety pins on demand



Safety pins

Horizontal tool change



70.130		24h
10 pieces	3,50 €	0,16 kg

Hardened

70.140		24h
10 pieces	1,50 €	0,16 kg

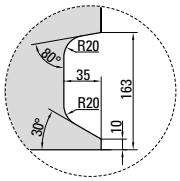
Not hardened

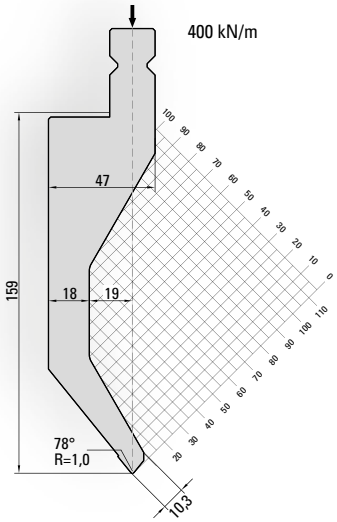
Punches/top tools LVD type I, H = 159 mm

16.200 24h

Safety pins		
510 mm	530,– €	19,0 kg

Simple Clamp		
550 mm sectionalized	1.150,– €	20,6 kg

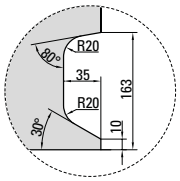


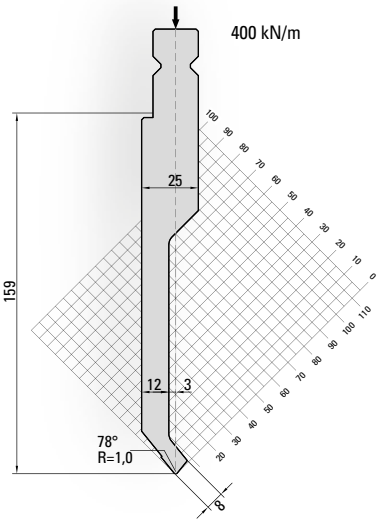


16.201 24h

Safety pins		
510 mm	438,– €	15,1 kg

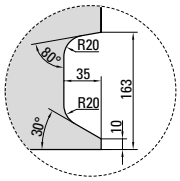
Simple Clamp		
550 mm sectionalized	1.022,– €	16,3 kg

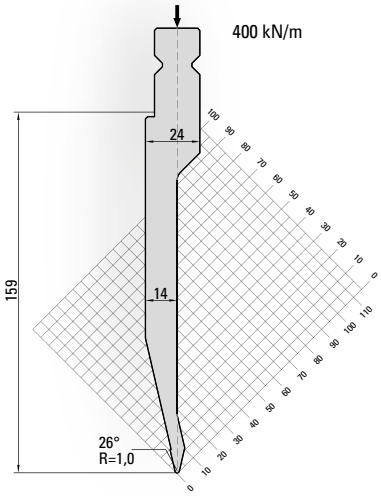




16.202 24h

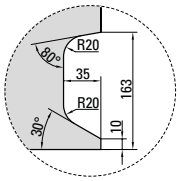
Simple Clamp		
510 mm	432,– €	11,5 kg
550 mm sectionalized	1.076,– €	12,4 kg

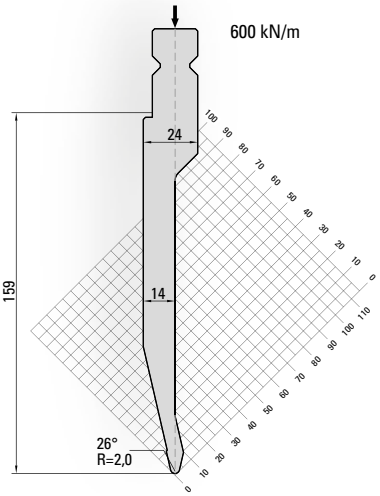




16.203 24h

Simple Clamp		
510 mm	432,– €	11,6 kg
550 mm sectionalized	1.076,– €	12,5 kg

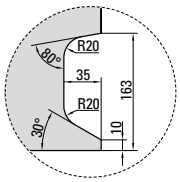


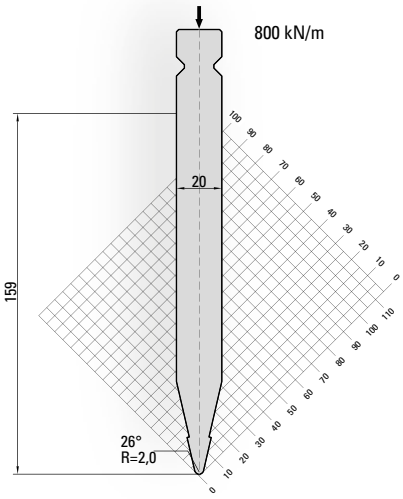


16.204 24h

Safety pins		
510 mm	402,– €	14,1 kg

Simple Clamp		
550 mm sectionalized	994,– €	15,2 kg





UKB-INFO

Punches/top tools UKB-System Trumpf (chapter 2) and UKB-System Wila type I (chapter 3) can also be used in a clamping UKB-System LVD!

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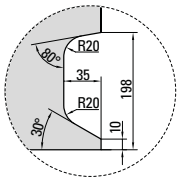
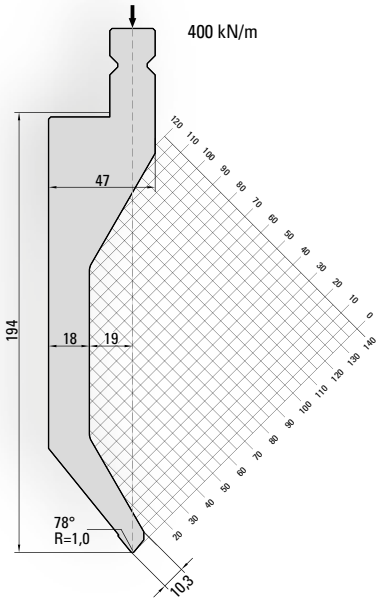
Punches/top tools LVD type I, H = 194 mm

16.205 24h

Safety pins		
510 mm	672,– €	22,4 kg

Simple Clamp		
550 mm sectionalized	1.506,– €	24,2 kg

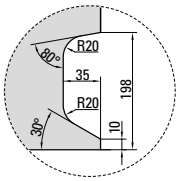


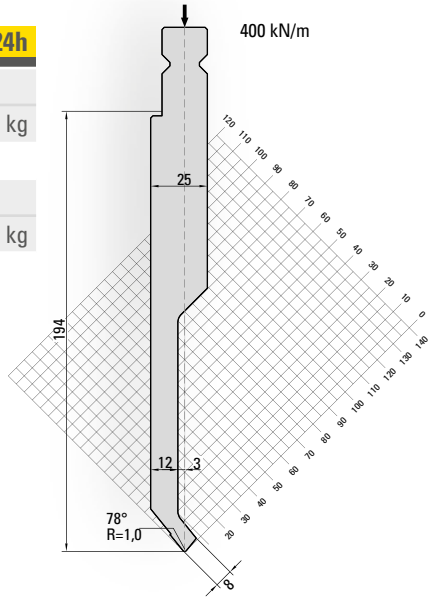


16.206 24h

Safety pins		
510 mm	556,– €	18,6 kg

Simple Clamp		
550 mm sectionalized	1.168,– €	20,0 kg

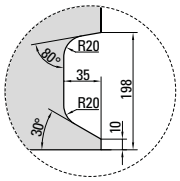


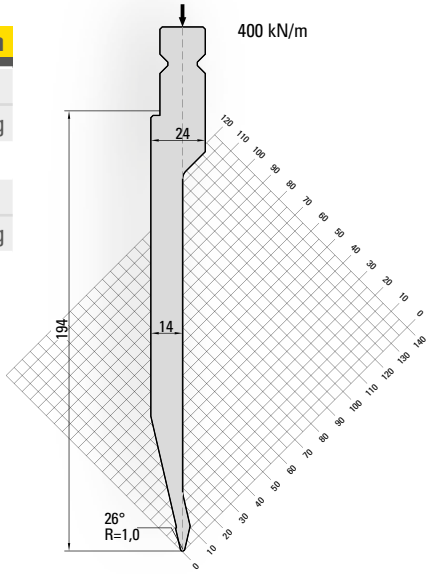


16.207 24h

Safety pins		
510 mm	524,– €	13,5 kg

Simple Clamp		
550 mm sectionalized	1.232,– €	14,6 kg

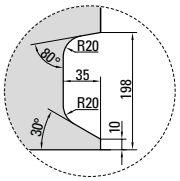


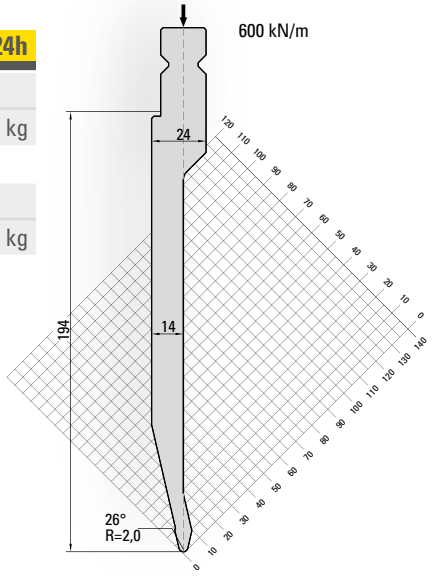


16.208 24h

Safety pins		
510 mm	524,– €	13,6 kg

Simple Clamp		
550 mm sectionalized	1.232,– €	14,7 kg

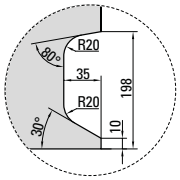


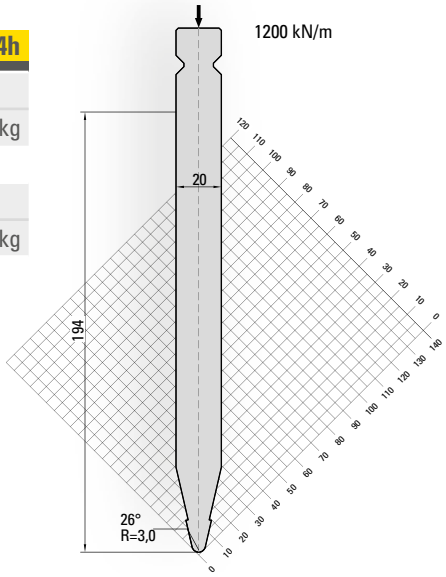


16.209 24h

Safety pins		
510 mm	470,– €	17,1 kg

Simple Clamp		
550 mm sectionalized	1.122,– €	18,5 kg

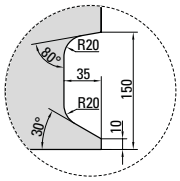


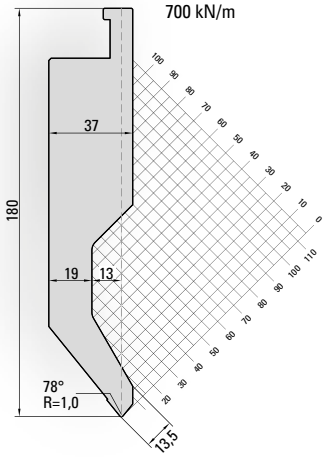


Punches/top tools LVD type II, H = 180 mm

16.500 24h

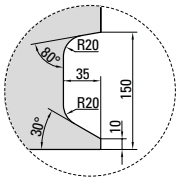
510 mm	382,– €	17,7 kg
550 mm sectionalized	630,– €	19,2 kg

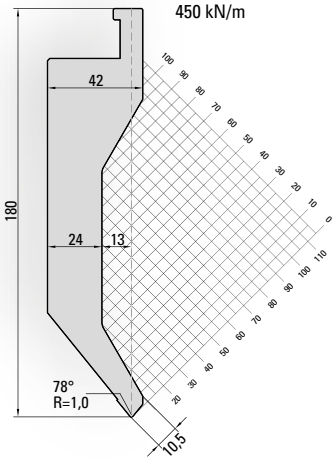




16.510 24h

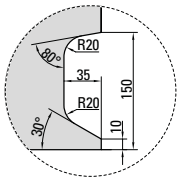
510 mm	408,– €	16,8 kg
550 mm sectionalized	660,– €	18,2 kg

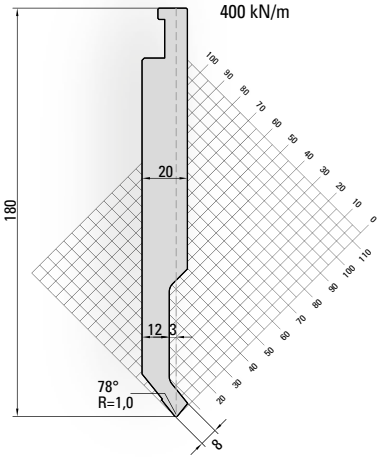




16.520 24h

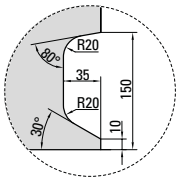
510 mm	298,– €	11,5 kg
550 mm sectionalized	534,– €	12,4 kg

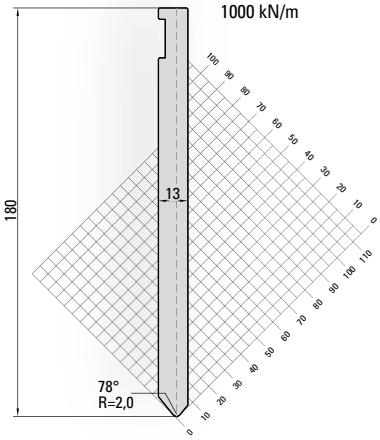




16.540 24h

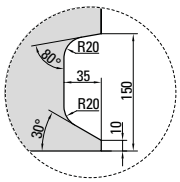
510 mm	254,– €	9,1 kg
550 mm sectionalized	482,– €	9,8 kg

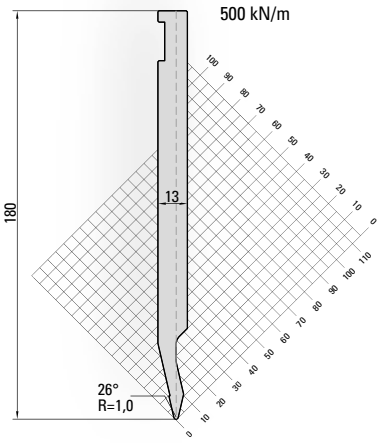




16.530 24h

510 mm	276,– €	8,0 kg
550 mm sectionalized	504,– €	8,7 kg





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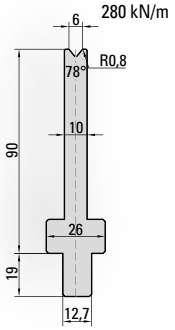
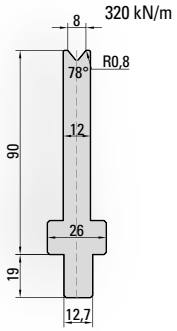
78° Dies, H = 90 mm

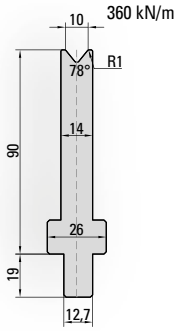
26.211		24h
510 mm	266,– €	5,4 kg
550 mm sectionalized	478,– €	5,8 kg



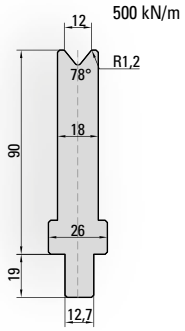
26.212		24h
510 mm	266,– €	6,0 kg
550 mm sectionalized	478,– €	6,5 kg



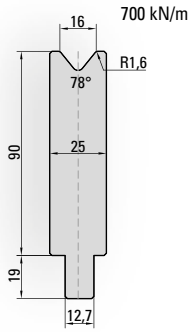
26.213		24h
510 mm	266,– €	6,5 kg
550 mm sectionalized	478,– €	7,1 kg



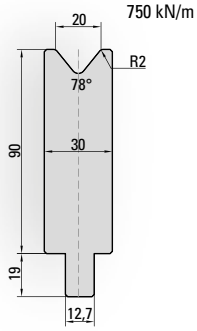
26.214		24h
510 mm	266,– €	7,7 kg
550 mm sectionalized	478,– €	8,3 kg



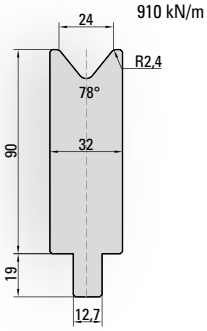
26.215		24h
510 mm	266,– €	9,6 kg
550 mm sectionalized	478,– €	10,4 kg



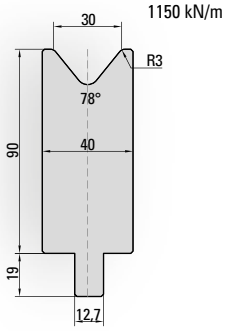
26.216		24h
510 mm	266,– €	11,2 kg
550 mm sectionalized	478,– €	12,1 kg



26.217		24h
510 mm	274,– €	11,7 kg
550 mm sectionalized	480,– €	12,7 kg

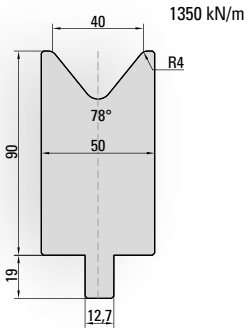


26.218		24h
510 mm	318,– €	14,2 kg
550 mm sectionalized	530,– €	15,4 kg

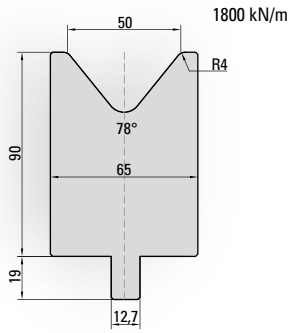


78° Dies, H = 90 mm

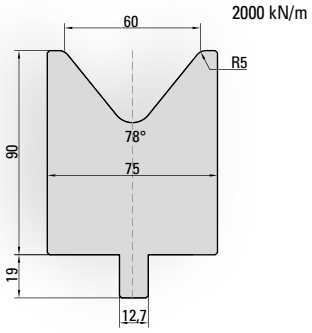
26.219		24h
510 mm	346,– €	17,0 kg
550 mm sectionalized	558,– €	18,3 kg



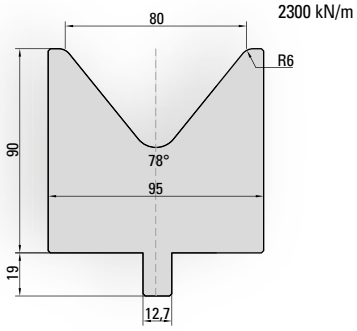
26.220		24h
510 mm	390,– €	21,3 kg
550 mm sectionalized	602,– €	23,0 kg



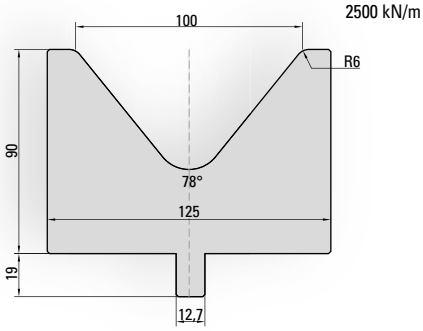
26.221		24h
510 mm	442,– €	23,6 kg
550 mm sectionalized	690,– €	25,4 kg



26.222		24h
510 mm	552,– €	27,3 kg
550 mm sectionalized	862,– €	29,5 kg

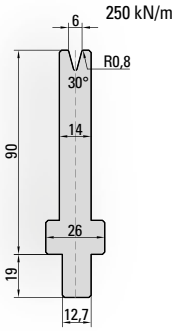


26.223		24h
510 mm	738,– €	33,9 kg
550 mm sectionalized	1.318,– €	36,5 kg

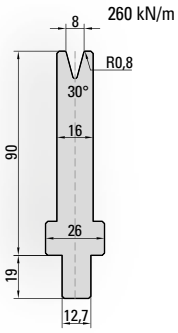


30° Dies, H = 90 mm

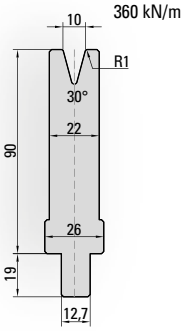
26.200		24h
510 mm	300,– €	6,5 kg
550 mm sectionalized	512,– €	7,1 kg



26.201		24h
510 mm	300,– €	7,0 kg
550 mm sectionalized	512,– €	7,6 kg



26.202		24h
510 mm	300,– €	8,7 kg
550 mm sectionalized	512,– €	9,4 kg



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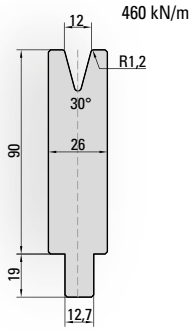
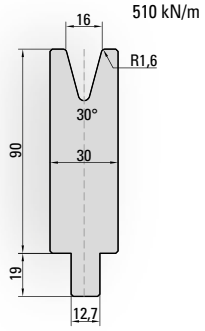
30° Dies, H = 90 mm

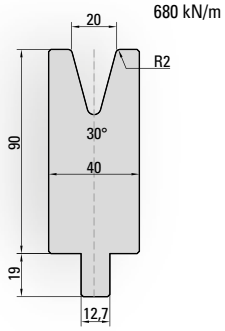
26.203		24h
510 mm	310,– €	10,2 kg
550 mm sectionalized	522,– €	11,0 kg



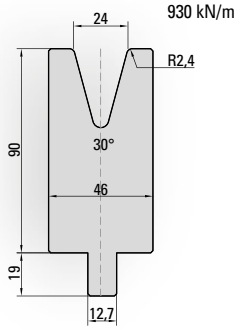
26.204		24h
510 mm	318,– €	10,8 kg
550 mm sectionalized	530,– €	11,7 kg



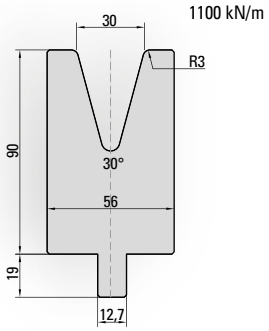
26.205		24h
510 mm	326,– €	13,9 kg
550 mm sectionalized	540,– €	15,0 kg



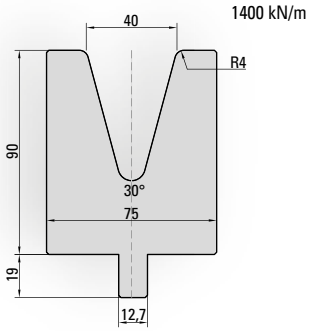
26.206		24h
510 mm	342,– €	15,5 kg
550 mm sectionalized	556,– €	16,7 kg



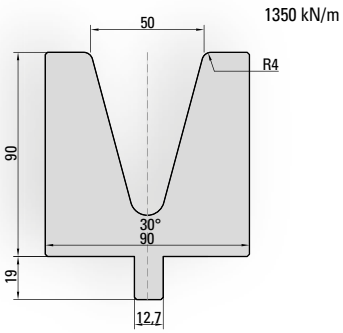
26.207		24h
510 mm	546,– €	17,9 kg
550 mm sectionalized	838,– €	19,3 kg



26.208		24h
510 mm	620,– €	22,3 kg
550 mm sectionalized	922,– €	24,1 kg

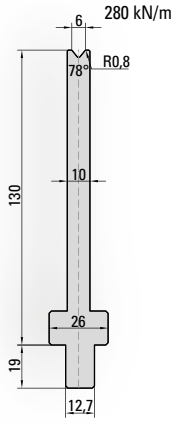


26.209		24h
510 mm	708,– €	24,5 kg
550 mm sectionalized	1.218,– €	26,5 kg

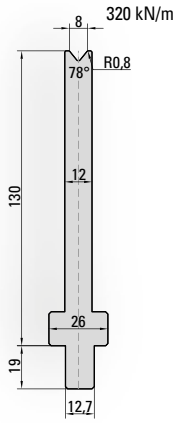


78° Dies, H = 130 mm

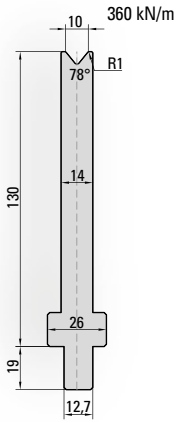
26.262		24h
510 mm	328,– €	7,0 kg
550 mm sectionalized	558,– €	7,6 kg



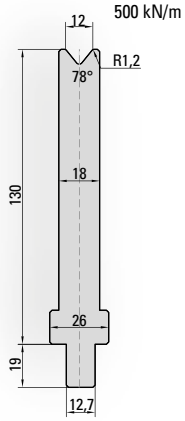
26.263		24h
510 mm	328,– €	7,9 kg
550 mm sectionalized	558,– €	8,5 kg



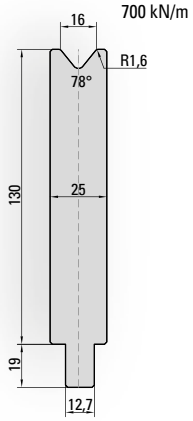
26.264		24h
510 mm	328,– €	8,8 kg
550 mm sectionalized	558,– €	9,5 kg



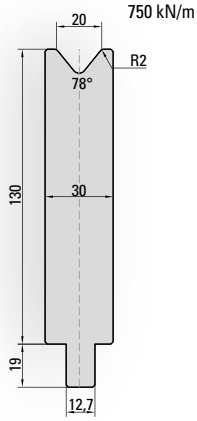
26.265		24h
510 mm	328,– €	10,6 kg
550 mm sectionalized	558,– €	11,4 kg



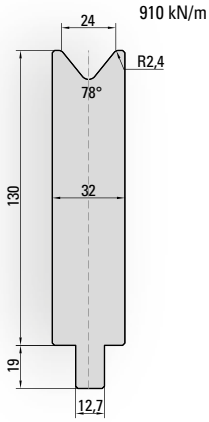
26.266		24h
510 mm	334,– €	13,6 kg
550 mm sectionalized	556,– €	14,7 kg



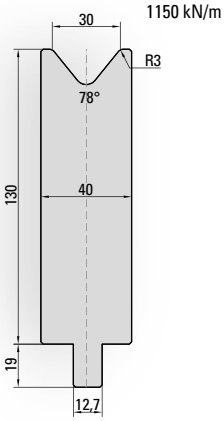
26.267		24h
510 mm	342,– €	16,0 kg
550 mm sectionalized	564,– €	17,3 kg



26.268		24h
510 mm	352,– €	16,8 kg
550 mm sectionalized	574,– €	18,2 kg



26.269		24h
510 mm	372,– €	20,6 kg
550 mm sectionalized	602,– €	22,2 kg



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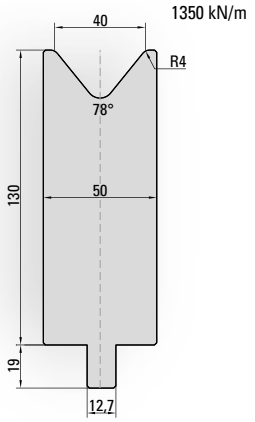
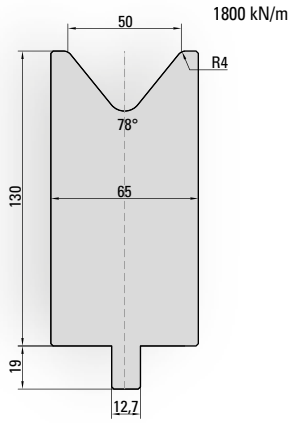
78° Dies, H = 130 mm

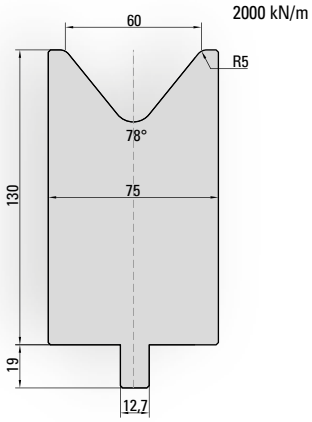
26.270		24h
510 mm	416,– €	25,0 kg
550 mm sectionalized	690,– €	26,9 kg



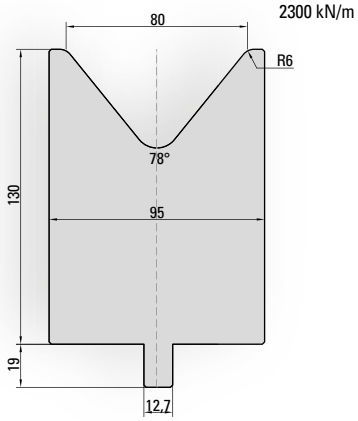
26.271		24h
510 mm	460,– €	31,7 kg
550 mm sectionalized	796,– €	34,2 kg



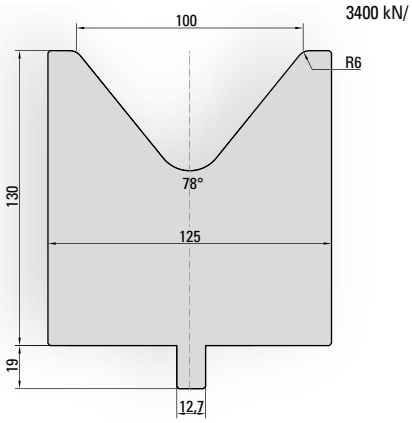
26.272		24h
510 mm	530,– €	35,6 kg
550 mm sectionalized	946,– €	38,4 kg



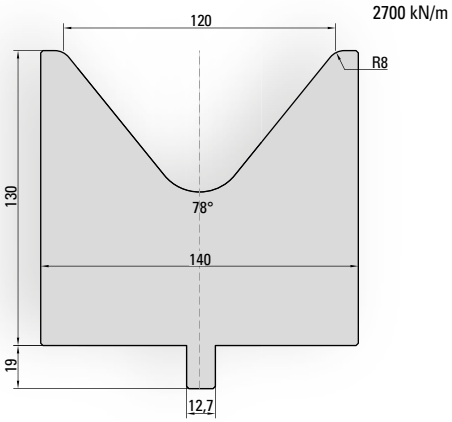
26.273		24h
510 mm	670,– €	42,5 kg
550 mm sectionalized	1.124,– €	45,9 kg



26.274		24h
510 mm	888,– €	53,9 kg
550 mm sectionalized	1.328,– €	58,1 kg

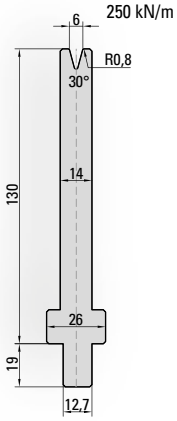


26.275		24h
510 mm	968,– €	56,5 kg
550 mm sectionalized	1.556,– €	60,9 kg



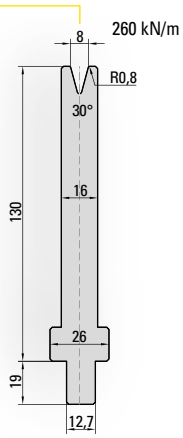
30° Dies, H = 130 mm

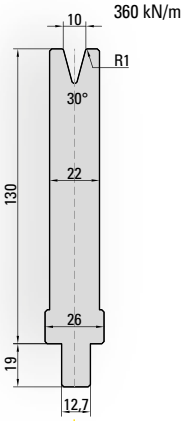
26.250		24h
510 mm	354,– €	8,8 kg
550 mm sectionalized	618,– €	9,5 kg



26.251		24h
510 mm	354,– €	9,6 kg
550 mm sectionalized	618,– €	10,3 kg

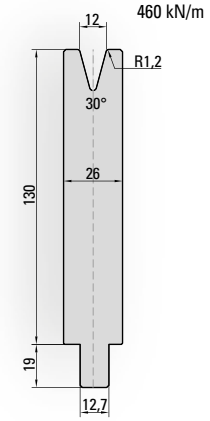
26.252		24h
510 mm	354,– €	12,2 kg
550 mm sectionalized	618,– €	13,2 kg



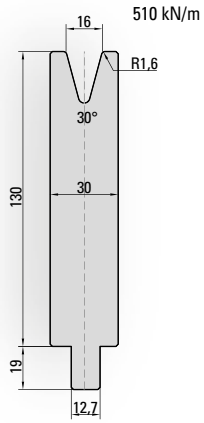


30° Dies, H = 130 mm

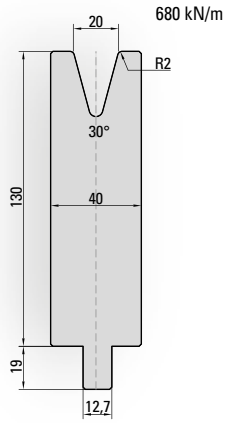
26.253		24h
510 mm	362,– €	14,4 kg
550 mm sectionalized	628,– €	15,5 kg



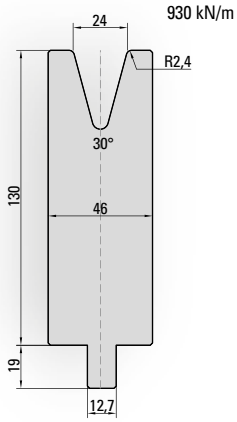
26.254		24h
510 mm	360,– €	15,6 kg
550 mm sectionalized	616,– €	16,8 kg



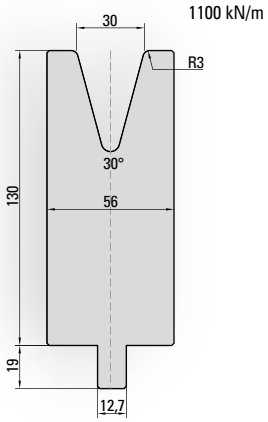
26.255		24h
510 mm	368,– €	20,3 kg
550 mm sectionalized	624,– €	22,0 kg



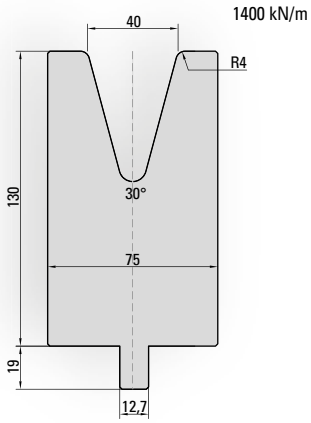
26.256		24h
510 mm	402,– €	22,8 kg
550 mm sectionalized	752,– €	24,6 kg



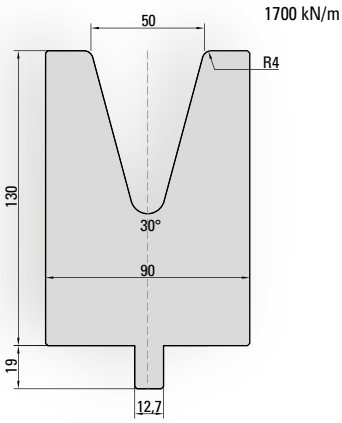
26.257		24h
510 mm	556,– €	26,8 kg
550 mm sectionalized	988,– €	29,0 kg



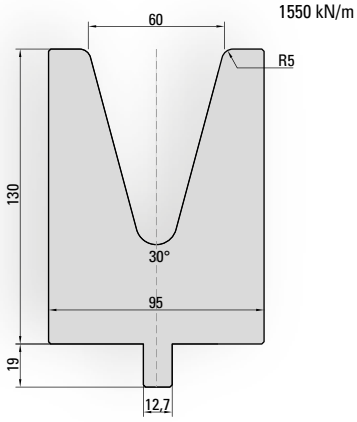
26.258		24h
510 mm	610,– €	34,3 kg
550 mm sectionalized	1.086,– €	37,0 kg



26.259		24h
510 mm	838,– €	39,9 kg
550 mm sectionalized	1.426,– €	42,0 kg



26.260		24h
510 mm	968,– €	37,6 kg
550 mm sectionalized	1.586,– €	40,6 kg



PRESS BRAKE TOOLS UKB-SYSTEM BYSTRONIC

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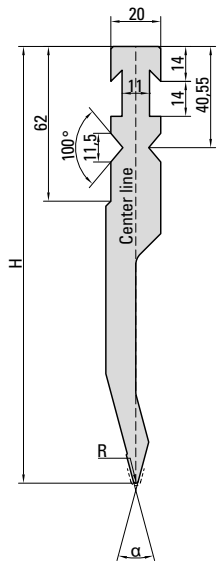
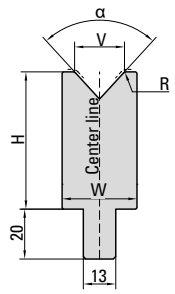
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, 650 – 800 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information





UKB-CONTACT PARTNER

You will find your personal contact partner at
www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** Press brake tools UKB-System Bystronic in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

  Standard: 1 – 3 working days by parcel service or forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

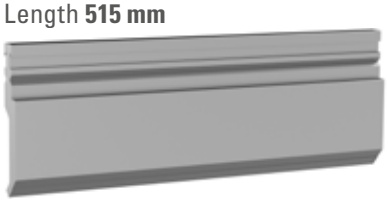
  Direct courier: According agreement
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

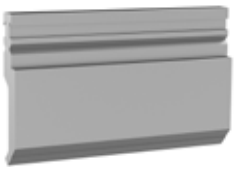
Tool lengths

PUNCHES/TOP TOOLS

Length **515 mm**



Length **300 mm**

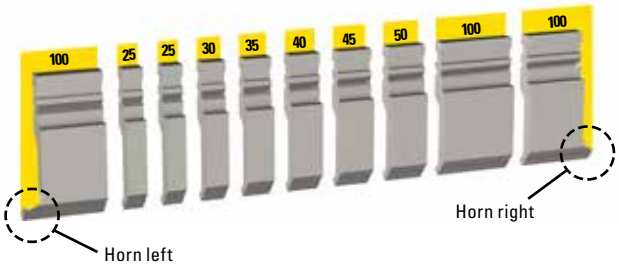


Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized punches/top tools are delivered as a complete set
- 10 Segments, with horn extension left and right



DIES

Length **515 mm**

Length **300 mm**

Length **200 mm**

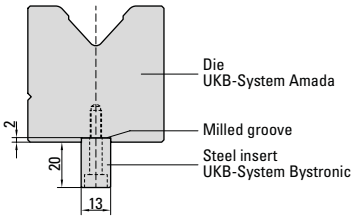
Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized dies are delivered as a complete set
- 9 Segments

Insertion of a steel insert

MODIFICATION EXAMPLE



By mounting a steel insert (page 246) dies UKB-System Amada (chapter 1) can also be used in a clamping UKB-System Bystronic.

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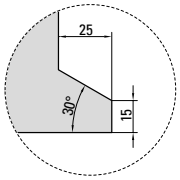
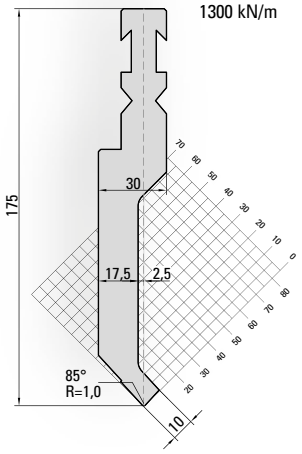
Punches/top tools H = 175 mm

14.150 24h

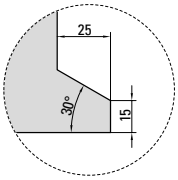
515 mm	450,– €	12,5 kg
300 mm	288,– €	7,2 kg
200 mm	210,– €	4,8 kg
100 mm	116,– €	2,4 kg
550 mm sectionalized	868,– €	13,4 kg

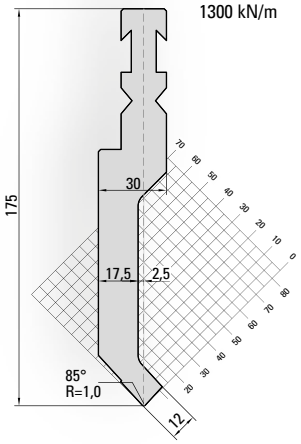




14.151 24h

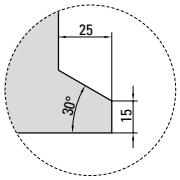
515 mm	450,– €	12,6 kg
300 mm	288,– €	7,3 kg
200 mm	210,– €	5,0 kg
100 mm	116,– €	2,4 kg
550 mm sectionalized	868,– €	13,4 kg

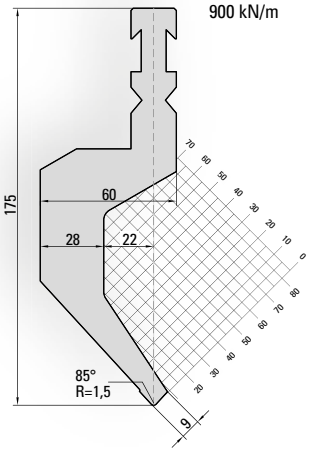




14.152 24h

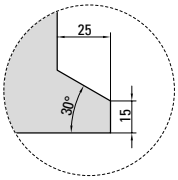
515 mm	688,– €	16,6 kg
300 mm	442,– €	9,7 kg
200 mm	324,– €	6,5 kg
100 mm	178,– €	3,2 kg
550 mm sectionalized	1.148,– €	17,8 kg

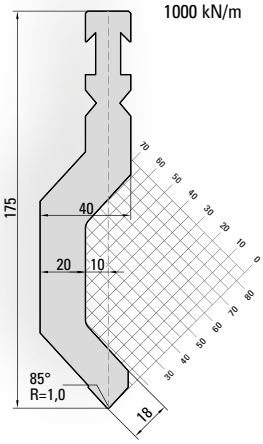




14.156 24h

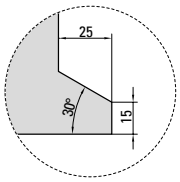
515 mm	638,– €	14,0 kg
300 mm	410,– €	8,2 kg
200 mm	300,– €	5,0 kg
100 mm	166,– €	2,7 kg
550 mm sectionalized	1.088,– €	15,0 kg

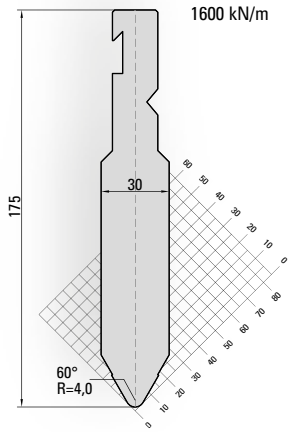




14.157 24h

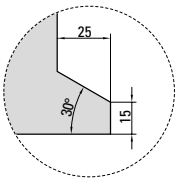
515 mm	440,– €	17,0 kg
300 mm	282,– €	10,0 kg
200 mm	206,– €	6,6 kg
100 mm	114,– €	3,3 kg
550 mm sectionalized	818,– €	18,2 kg

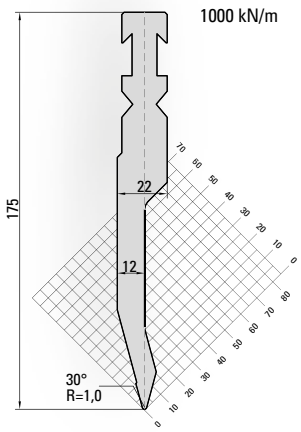




14.153 24h

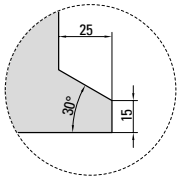
515 mm	470,– €	9,7 kg
300 mm	300,– €	5,7 kg
200 mm	220,– €	3,8 kg
100 mm	122,– €	1,9 kg
550 mm sectionalized	888,– €	10,4 kg

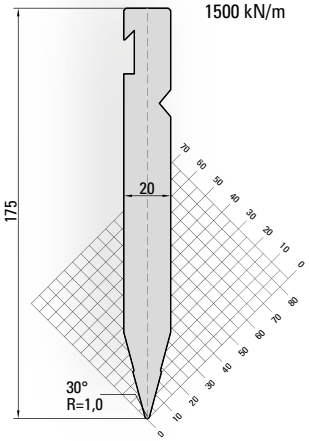




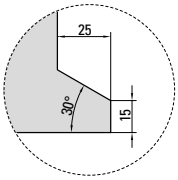
Punches/top tools H = 175 mm

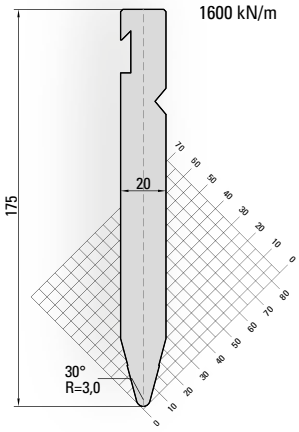
14.154		24h
515 mm	380,– €	12,4 kg
300 mm	242,– €	7,2 kg
200 mm	178,– €	4,8 kg
100 mm	98,– €	2,4 kg
550 mm sectionalized	758,– €	13,2 kg





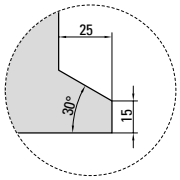
14.155		24h
515 mm	380,– €	12,8 kg
300 mm	242,– €	7,5 kg
200 mm	178,– €	5,0 kg
100 mm	98,– €	2,5 kg
550 mm sectionalized	758,– €	13,7 kg

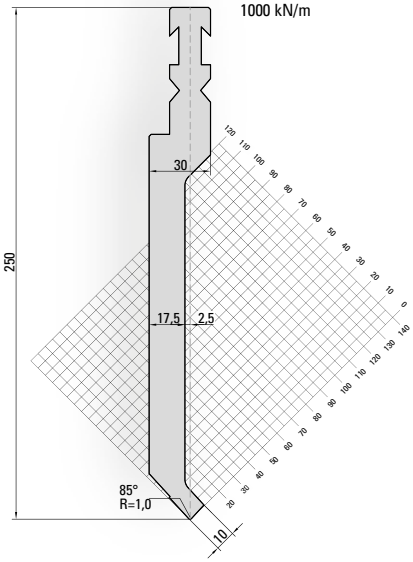




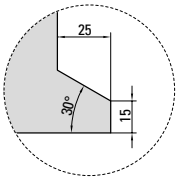
Punches/top tools H = 250 mm

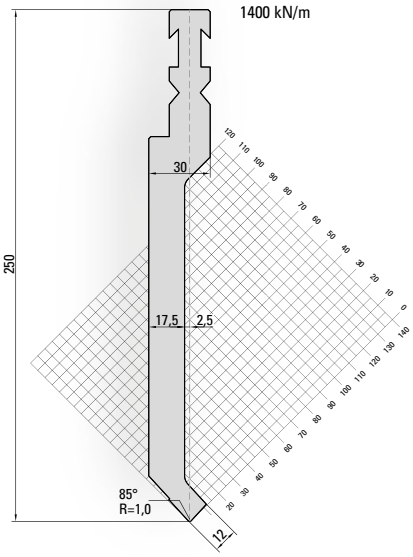
14.158		24h
515 mm	628,– €	17,8 kg
300 mm	404,– €	10,4 kg
200 mm	296,– €	7,0 kg
100 mm	164,– €	3,5 kg
550 mm sectionalized	1.138,– €	19,0 kg



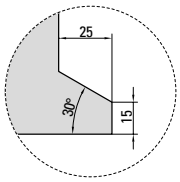


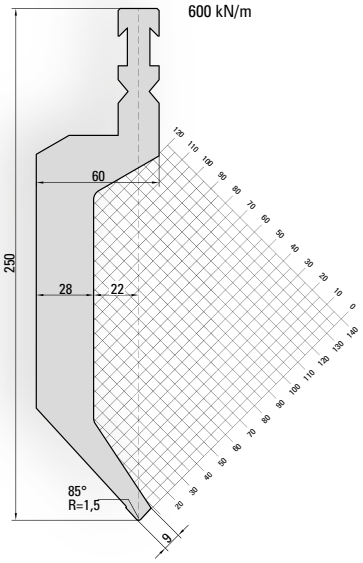
14.159		24h
515 mm	628,– €	18,0 kg
300 mm	404,– €	10,4 kg
200 mm	296,– €	7,0 kg
100 mm	164,– €	3,5 kg
550 mm sectionalized	1.138,– €	19,1 kg



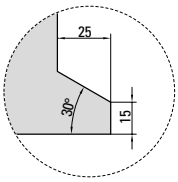


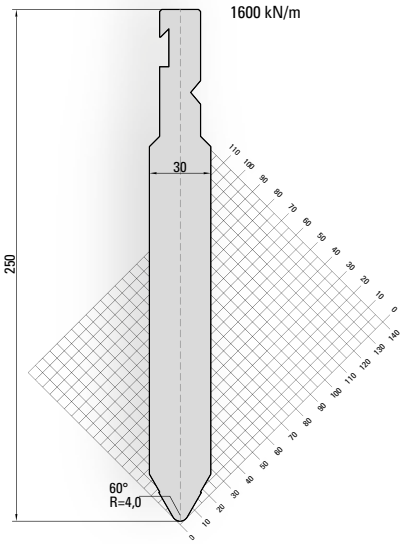
14.160		24h
515 mm	978,– €	25,0 kg
300 mm	626,– €	14,6 kg
200 mm	460,– €	9,8 kg
100 mm	252,– €	4,9 kg
550 mm sectionalized	1.526,– €	26,8 kg





14.165		24h
515 mm	618,– €	26,1 kg
300 mm	396,– €	15,2 kg
200 mm	290,– €	10,0 kg
100 mm	160,– €	5,0 kg
550 mm sectionalized	1.098,– €	27,9 kg





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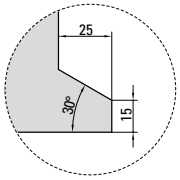
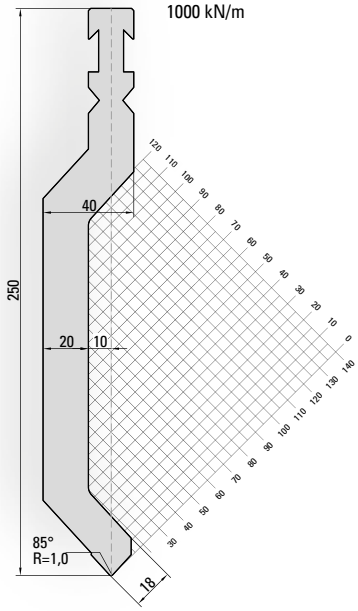
Punches/top tools H = 250 mm

14.164 24h

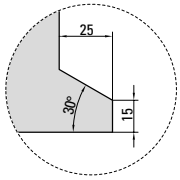
515 mm	928,– €	20,1 kg
300 mm	596,– €	11,7 kg
200 mm	436,– €	7,8 kg
100 mm	240,– €	3,9 kg
550 mm sectionalized	1.426,– €	21,5 kg

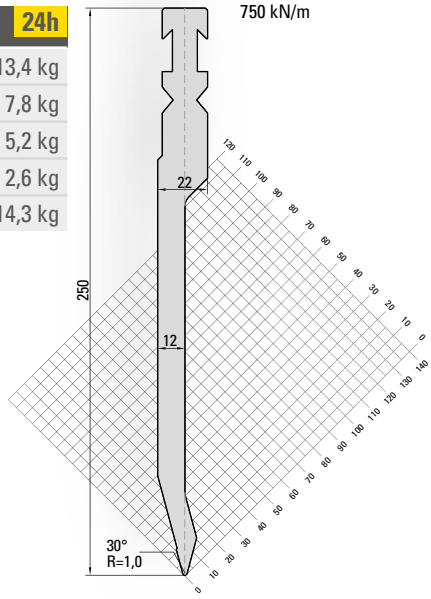




14.161 24h

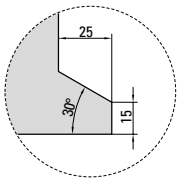
515 mm	530,– €	13,4 kg
300 mm	340,– €	7,8 kg
200 mm	248,– €	5,2 kg
100 mm	138,– €	2,6 kg
550 mm sectionalized	958,– €	14,3 kg

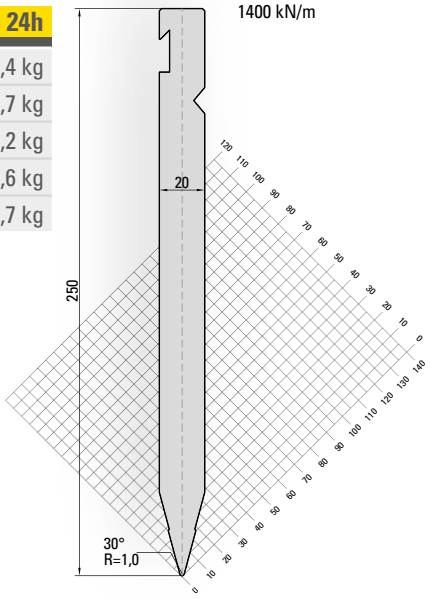




14.162 24h

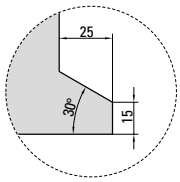
515 mm	490,– €	18,4 kg
300 mm	314,– €	10,7 kg
200 mm	230,– €	7,2 kg
100 mm	126,– €	3,6 kg
550 mm sectionalized	918,– €	19,7 kg

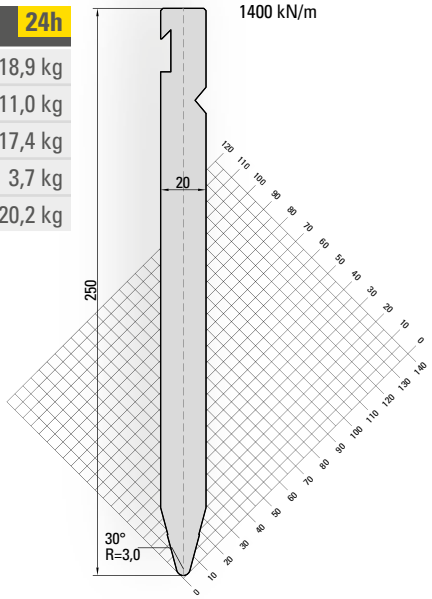




14.163 24h

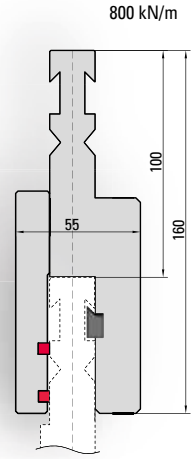
515 mm	490,– €	18,9 kg
300 mm	314,– €	11,0 kg
200 mm	230,– €	17,4 kg
100 mm	126,– €	3,7 kg
550 mm sectionalized	918,– €	20,2 kg



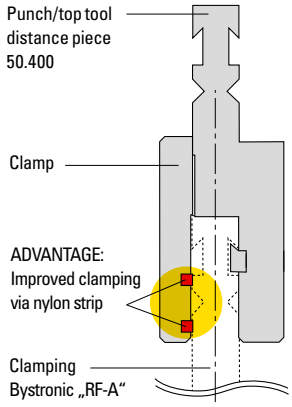


Punch/top tool distance piece

50.400		24h
150 mm	308,– €	6,0 kg



EXAMPLE OF USE



UKB-Regrinding service

The regrinding of your press brake tools, we carry out professional, precise, fast and cost-saving.
Make do and mend!

Before

After

UKB-Repair service

Before regrinding, we weld on material for breakouts, damaged areas or deformations!

Weld on of a damaged tool (MAG welding process)

WIG welding process

Further information see chapter 19 or visit www.ukb-gmbh.com!

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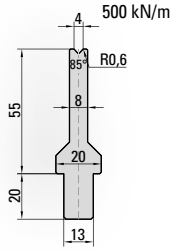
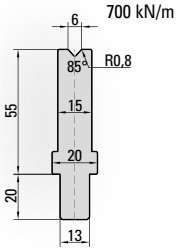
85° Dies, H = 55 mm

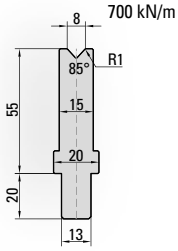
24.100		24h
515 mm	208,– €	3,6 kg
300 mm	142,– €	2,1 kg
200 mm	98,– €	1,4 kg
100 mm	56,– €	0,7 kg
550 mm sectionalized	392,– €	3,8 kg



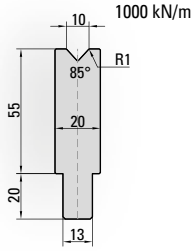
24.101		24h
515 mm	196,– €	4,6 kg
300 mm	136,– €	2,7 kg
200 mm	94,– €	1,8 kg
100 mm	48,– €	0,9 kg
550 mm sectionalized	382,– €	5,0 kg



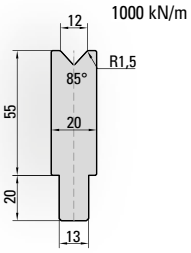
24.102		24h
515 mm	196,– €	4,6 kg
300 mm	136,– €	2,7 kg
200 mm	94,– €	1,8 kg
100 mm	48,– €	0,9 kg
550 mm sectionalized	382,– €	5,0 kg



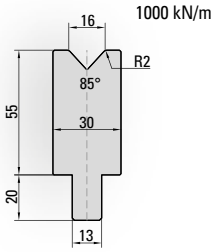
24.104		24h
515 mm	142,– €	5,7 kg
300 mm	106,– €	3,3 kg
200 mm	74,– €	2,2 kg
100 mm	42,– €	1,1 kg
550 mm sectionalized	304,– €	6,1 kg



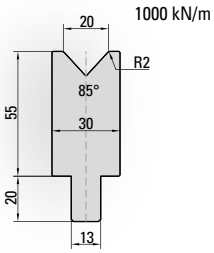
24.106		24h
515 mm	142,– €	5,7 kg
300 mm	106,– €	3,3 kg
200 mm	74,– €	2,2 kg
100 mm	42,– €	1,1 kg
550 mm sectionalized	304,– €	6,1 kg



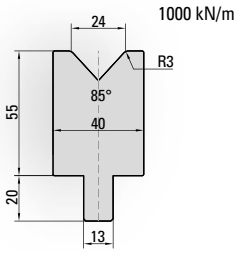
24.108		24h
515 mm	158,– €	7,7 kg
300 mm	114,– €	4,5 kg
200 mm	80,– €	3,0 kg
100 mm	46,– €	1,5 kg
550 mm sectionalized	326,– €	8,3 kg



24.109		24h
515 mm	164,– €	7,7 kg
300 mm	118,– €	4,5 kg
200 mm	82,– €	3,0 kg
100 mm	46,– €	1,5 kg
550 mm sectionalized	332,– €	8,3 kg



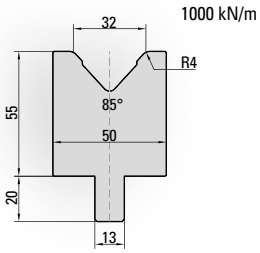
24.110		24h
515 mm	186,– €	9,8 kg
300 mm	132,– €	5,7 kg
200 mm	100,– €	3,8 kg
100 mm	68,– €	1,9 kg
550 mm sectionalized	382,– €	10,5 kg



85° Dies, H = 55 mm

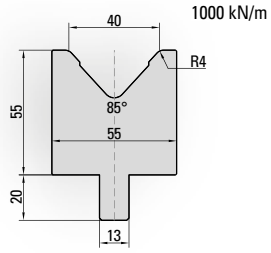
24.011		24h
515 mm	214,– €	10,8 kg
300 mm	156,– €	6,3 kg
200 mm	106,– €	4,2 kg
100 mm	60,– €	2,1 kg
550 mm sectionalized	422,– €	11,5 kg

1200 kN/m if the tool clamping has the corresponding load



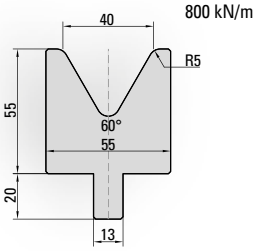
24.012		24h
515 mm	230,– €	11,1 kg
300 mm	166,– €	6,6 kg
200 mm	112,– €	4,4 kg
100 mm	64,– €	2,2 kg
550 mm sectionalized	448,– €	12,1 kg

1200 kN/m if the tool clamping has the corresponding load



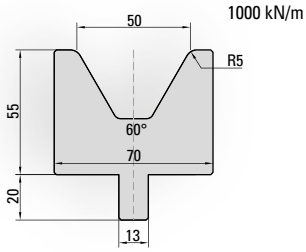
60° Dies, H = 55 mm

24.040		24h
515 mm	310,– €	10,3 kg
300 mm	160,– €	6,0 kg
200 mm	106,– €	4,0 kg
100 mm	60,– €	2,0 kg
550 mm sectionalized	444,– €	11,0 kg



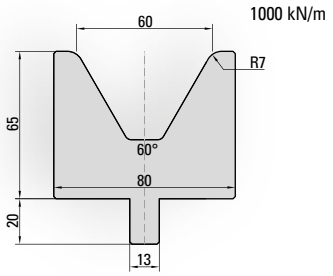
24.050		24h
515 mm	342,– €	12,7 kg
300 mm	208,– €	7,5 kg
200 mm	138,– €	5,0 kg
100 mm	76,– €	2,5 kg
550 mm sectionalized	528,– €	13,8 kg

1200 kN/m if the tool clamping has the corresponding load



60° Die, H = 65 mm

24.060		24h
515 mm	384,– €	16,0 kg
300 mm	268,– €	9,3 kg
200 mm	182,– €	6,2 kg
100 mm	96,– €	3,1 kg
550 mm sectionalized	650,– €	17,0 kg



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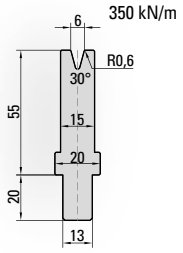
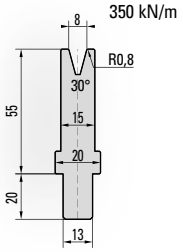
30° Dies, H = 55 mm

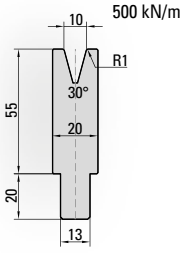
24.013		24h
515 mm	202,– €	4,1 kg
300 mm	150,– €	2,4 kg
200 mm	102,– €	1,6 kg
100 mm	54,– €	0,8 kg
550 mm sectionalized	348,– €	4,4 kg



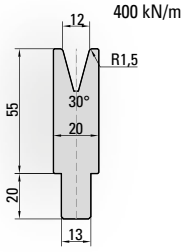
24.014		24h
515 mm	202,– €	4,1 kg
300 mm	150,– €	2,4 kg
200 mm	102,– €	1,6 kg
100 mm	54,– €	0,8 kg
550 mm sectionalized	348,– €	4,4 kg



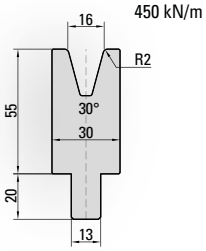
24.015		24h
515 mm	198,– €	5,1 kg
300 mm	144,– €	3,0 kg
200 mm	96,– €	2,0 kg
100 mm	52,– €	1,0 kg
550 mm sectionalized	342,– €	5,5 kg



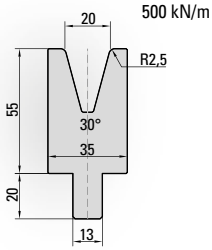
24.016		24h
515 mm	198,– €	5,1 kg
300 mm	144,– €	3,0 kg
200 mm	96,– €	2,0 kg
100 mm	52,– €	1,0 kg
550 mm sectionalized	342,– €	5,5 kg



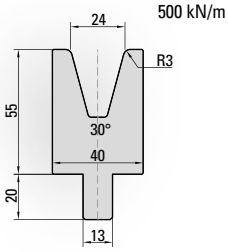
24.017		24h
515 mm	208,– €	7,0 kg
300 mm	150,– €	4,2 kg
200 mm	102,– €	2,8 kg
100 mm	54,– €	1,4 kg
550 mm sectionalized	352,– €	7,7 kg



24.019		24h
515 mm	214,– €	7,2 kg
300 mm	156,– €	4,2 kg
200 mm	106,– €	2,8 kg
100 mm	60,– €	1,4 kg
550 mm sectionalized	384,– €	7,7 kg

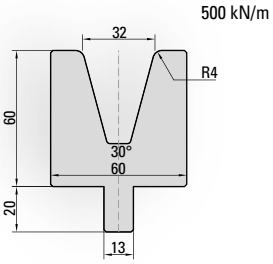


24.018		24h
515 mm	230,– €	8,0 kg
300 mm	166,– €	4,8 kg
200 mm	118,– €	3,2 kg
100 mm	64,– €	1,6 kg
550 mm sectionalized	406,– €	8,8 kg



30° Die, H = 60 mm

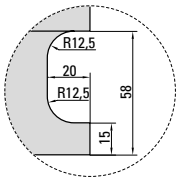
24.035		24h
515 mm	316,– €	11,8 kg
300 mm	230,– €	6,9 kg
200 mm	156,– €	4,6 kg
100 mm	82,– €	2,3 kg
550 mm sectionalized	566,– €	12,7 kg

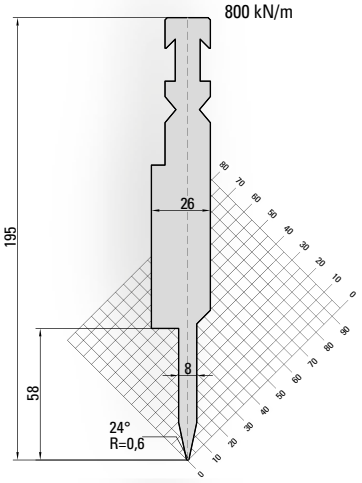


Flattening punches/top tools and flattening dies

14.908 — 24h

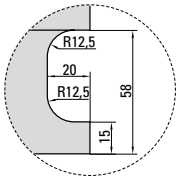
500 mm	524,– €	13,0 kg
300 mm	376,– €	7,8 kg
200 mm	252,– €	5,2 kg
100 mm	128,– €	2,6 kg
550 mm sectionalized	1.018,– €	14,3 kg

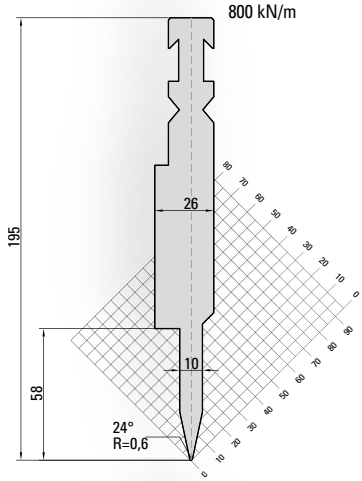




14.910 — 24h

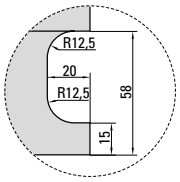
500 mm	524,– €	13,5 kg
300 mm	376,– €	8,1 kg
200 mm	252,– €	5,4 kg
100 mm	128,– €	2,7 kg
550 mm sectionalized	1.018,– €	14,9 kg

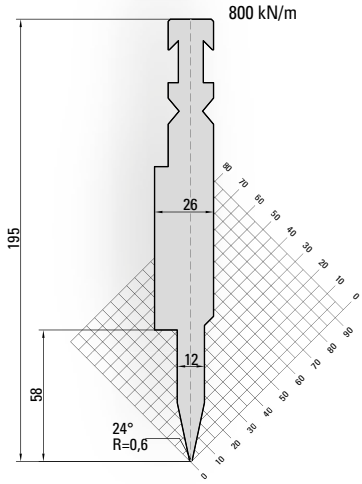




14.912 — 24h

500 mm	524,– €	14,0 kg
300 mm	376,– €	8,4 kg
200 mm	252,– €	5,6 kg
100 mm	128,– €	2,8 kg
550 mm sectionalized	1.018,– €	15,4 kg

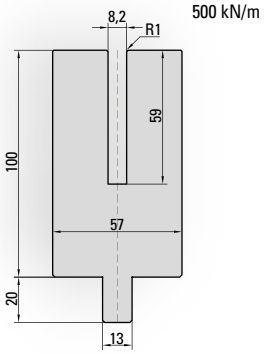




25.992 — 24h

500 mm	444,– €	21,5 kg
300 mm	326,– €	12,9 kg
200 mm	232,– €	8,6 kg
100 mm	138,– €	4,3 kg
550 mm sectionalized	758,– €	23,6 kg

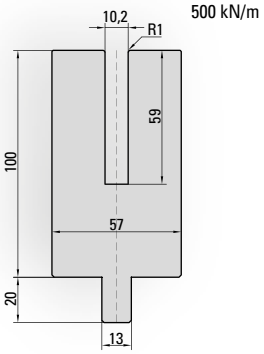
Max. 1,2 mm material thickness
R_m = 400 N/mm²



25.994 — 24h

500 mm	444,– €	21,0 kg
300 mm	326,– €	12,6 kg
200 mm	232,– €	8,4 kg
100 mm	138,– €	4,2 kg
550 mm sectionalized	758,– €	23,1 kg

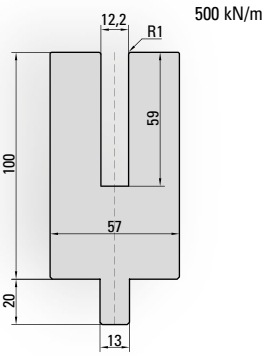
Max. 1,8 mm material thickness
R_m = 400 N/mm²



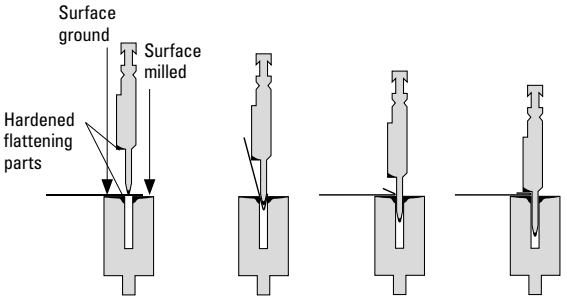
25.995 — 24h

500 mm	444,– €	20,5 kg
300 mm	326,– €	12,3 kg
200 mm	232,– €	8,2 kg
100 mm	138,– €	4,1 kg
550 mm sectionalized	758,– €	22,6 kg

Max. 2,5 mm material thickness
R_m = 400 N/mm²



EXAMPLE OF USE



VIDEO

UKB-Flattening punches/top tools

PRESS BRAKE TOOLS UKB-SYSTEM EHT, UKB-SYSTEM WEINBRENNER AND OTHER SYSTEMS

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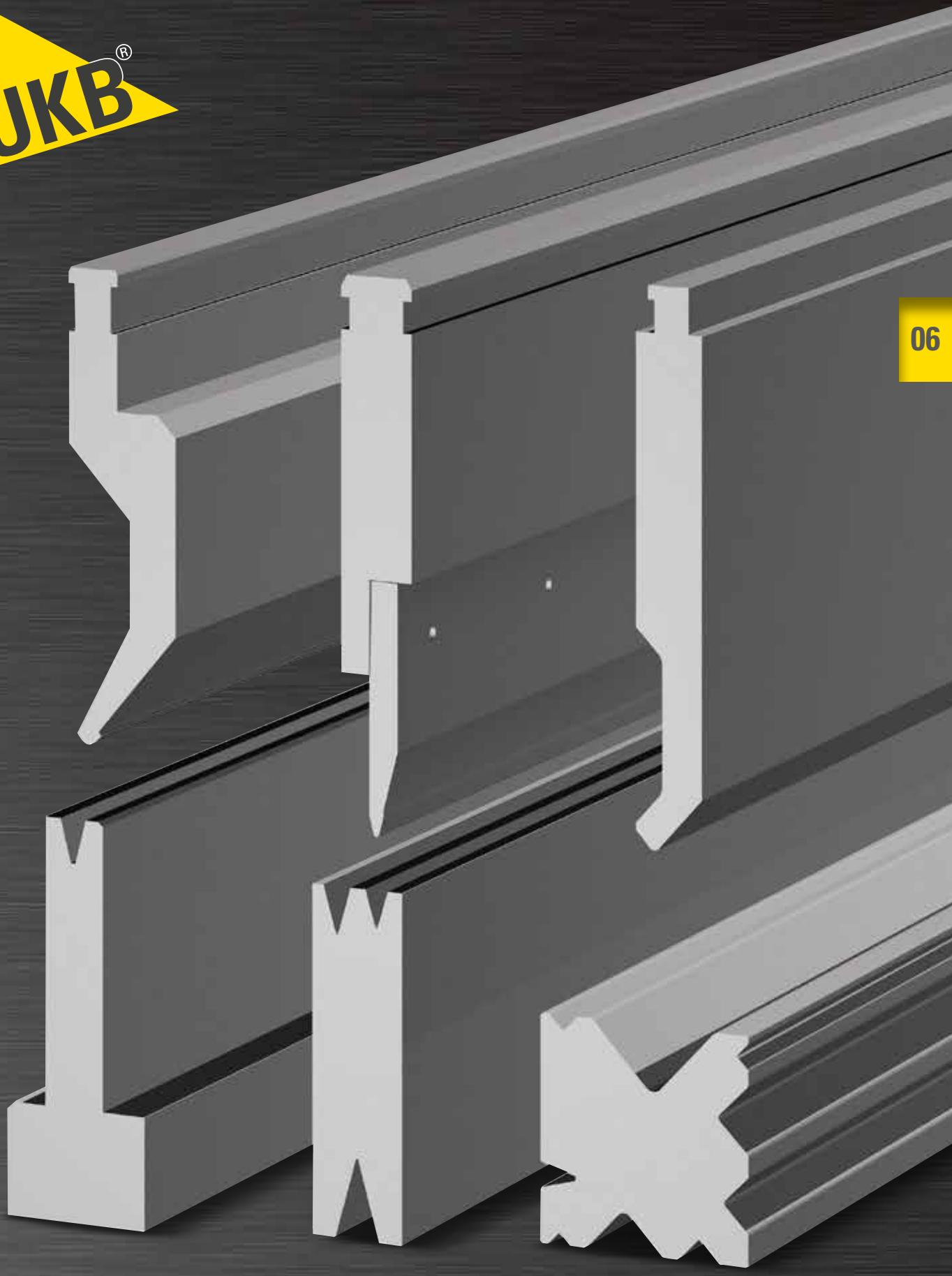

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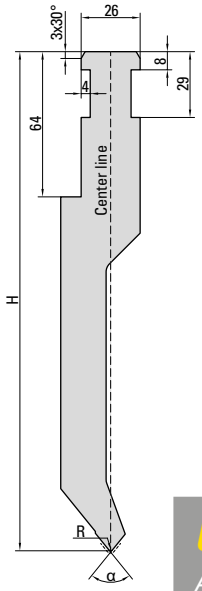
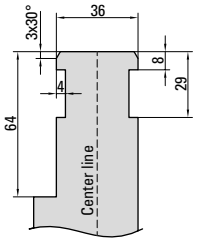
Quality and precision

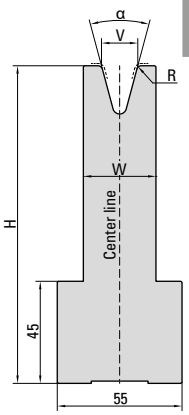
- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, tempered to 800 – 850 N/mm²
  - C45, 650 – 800 N/mm²
  - 1.2312, tempered to 950 – 1100 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information
- Individual production according to your specification

26 mm clamping:



36 mm clamping:





UKB-INFO

All punches/top tools and dies are examples! We produce individually according to your specifications!

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You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

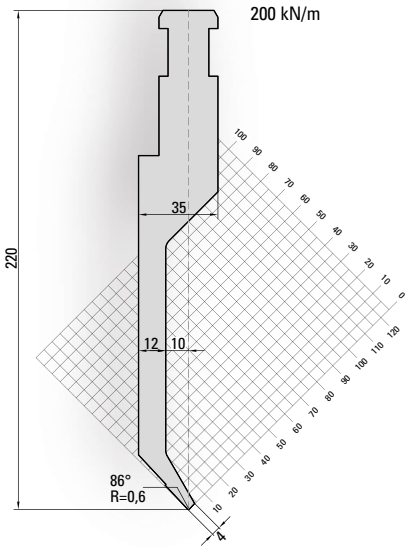
UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** On request
- **Full-service:** Construction, development, production
- **Production possibilities:** Up to 6000 mm tool length
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

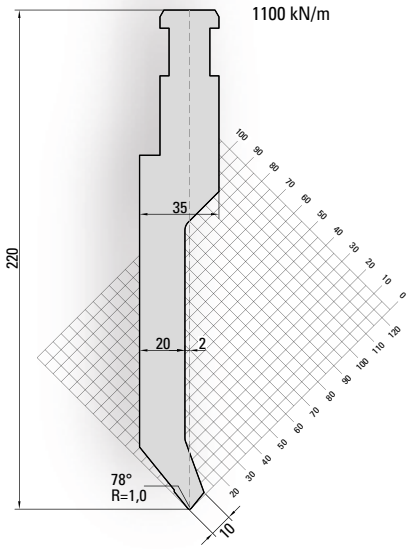
VIDEO
Image

86° Punch/top tool

17.100
Delivery time on request

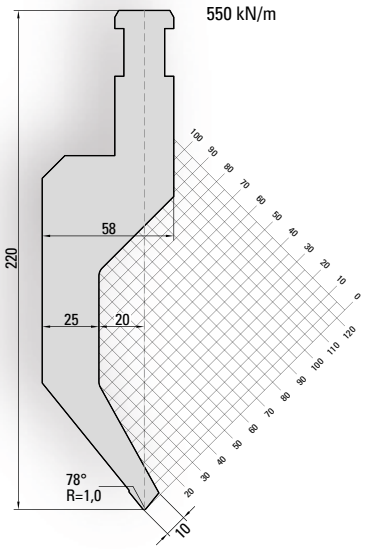


17.110
Delivery time on request

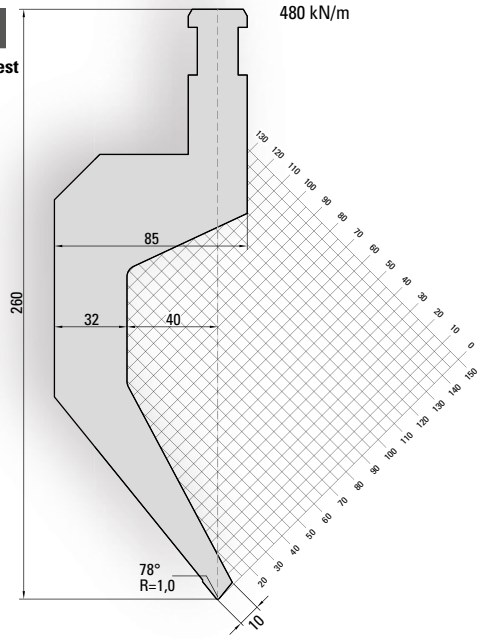


78° Punches/top tools

17.120
Delivery time on request

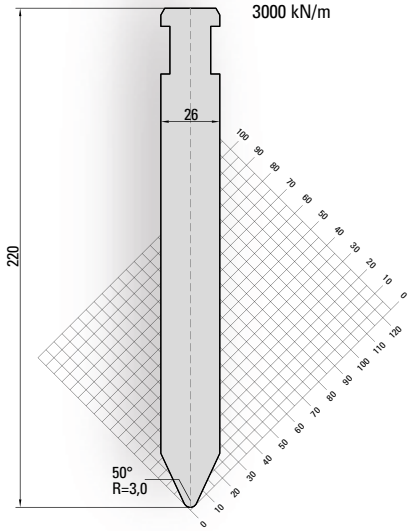


17.130
Delivery time on request



50° Punch/top tool

17.180
Delivery time on request



26° Punch/top tool

17.140
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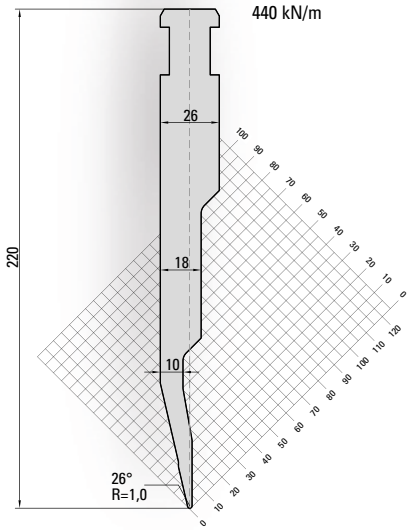

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Holder for blade with changeable blades

17.150

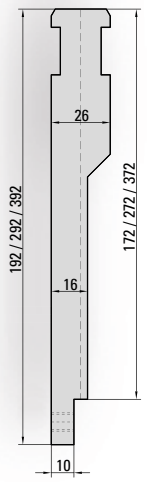
H = 172 mm
Holder for blade with
hardened flattening part
Delivery time on request

17.151

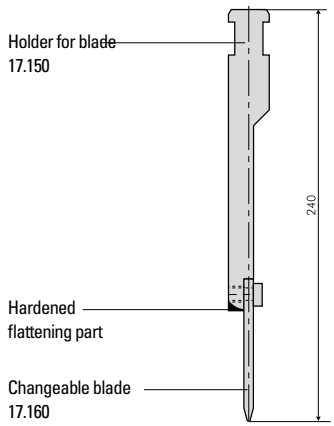
H = 272 mm
Holder for blade with
hardened flattening part
Delivery time on request

17.152

H = 372 mm
Holder for blade with
hardened flattening part
Delivery time on request

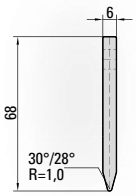


EXAMPLE OF USE



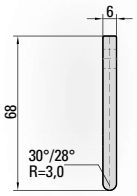
17.160

Changeable blade
Delivery time on request



17.170

Changeable blade
Delivery time on request



UKB-HOLDERS FOR BLADES AND BLADES R 0,5 – 6,0

see chapter **07**

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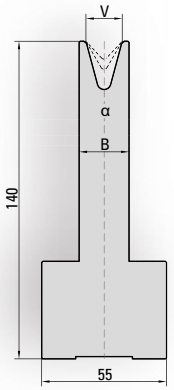
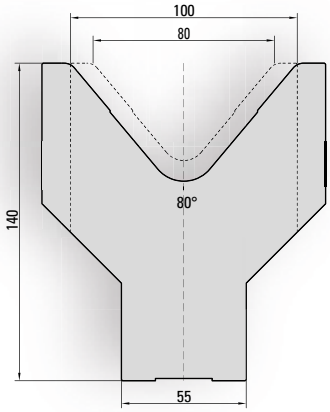
Dies

27.010
Delivery time on request

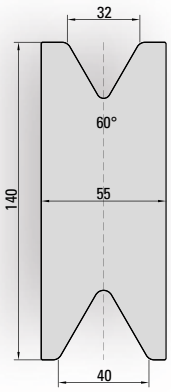


27.030
Delivery time on request



UKB-INFO
Dies with 13 mm clamping see
UKB-System Trumpf (chapter 2)
UKB-System Wila (chapter 3)
UKB-System Bystronic (chapter 5)

27.040
Delivery time on request



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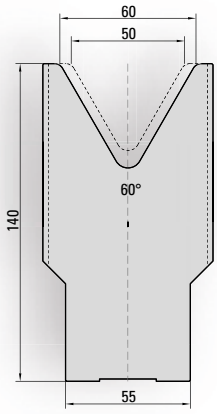

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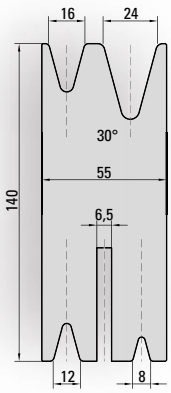
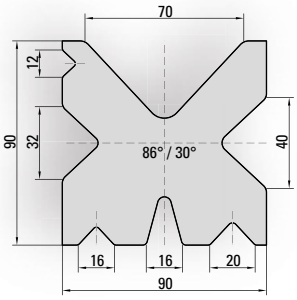


27.080
Delivery time on request



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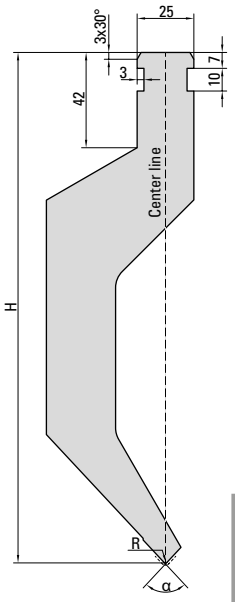
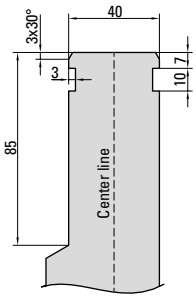
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, tempered to 800 – 850 N/mm²
  - C45, 650 – 800 N/mm²
  - 1.2312, tempered to 950 – 1100 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information
- Individual production according to your specification

25 mm clamping:

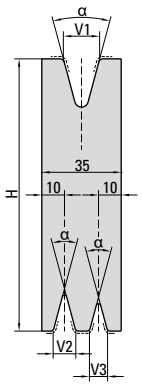


40 mm clamping:



UKB-INFO

All punches/top tools and dies are examples! We produce individually according to your specifications!



UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

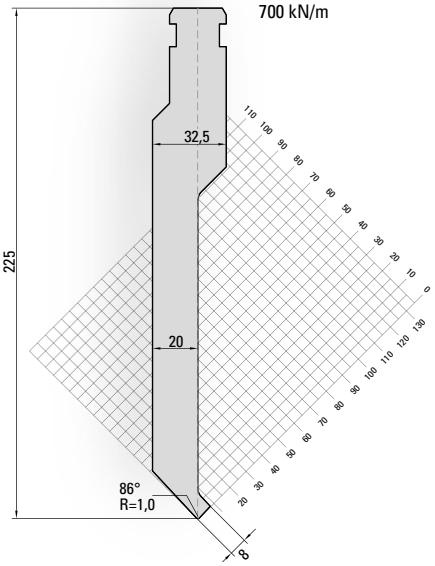
UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** On request
- **Full-service:** Construction, development, production
- **Production possibilities:** Up to 6000 mm tool length
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

Punches/top tools

17.500
Delivery time on request



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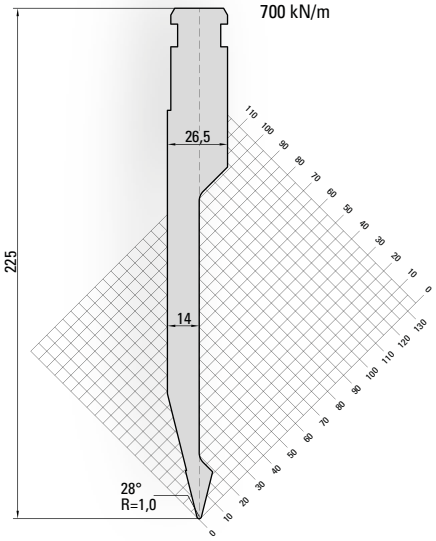
Delivery time on request



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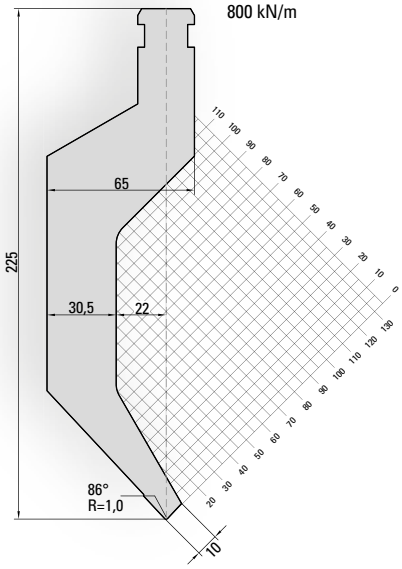
Delivery time on request



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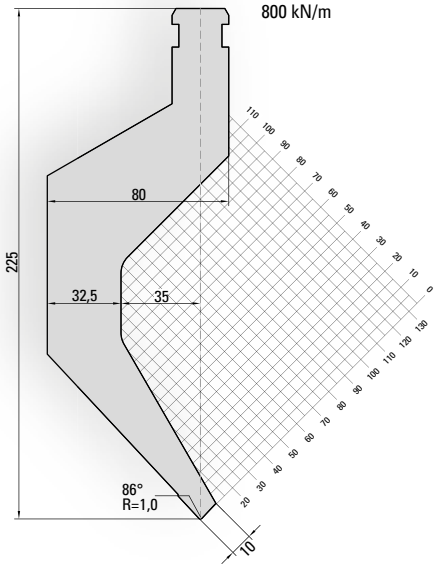
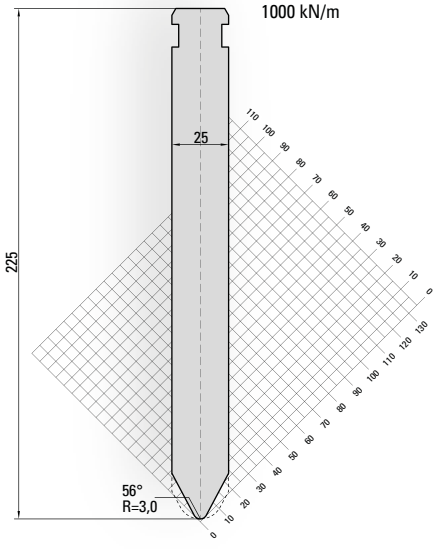


Holder for blade with changeable blade

17.560
Delivery time on request



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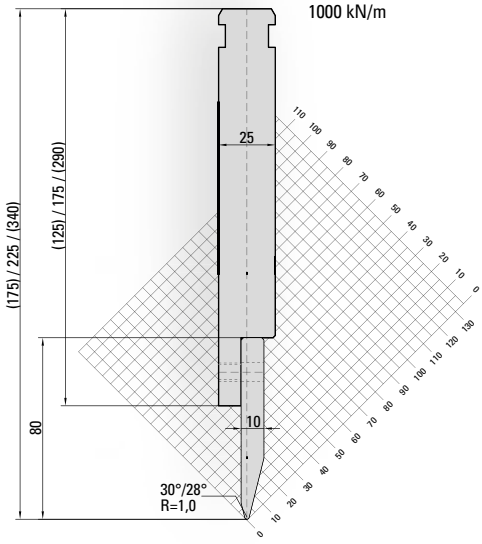

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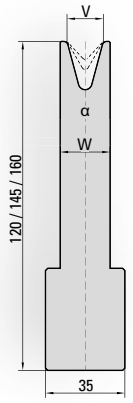
Dies

27.200

Delivery time on request



27.210

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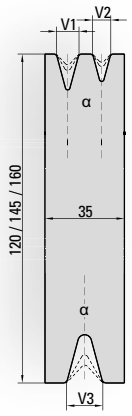

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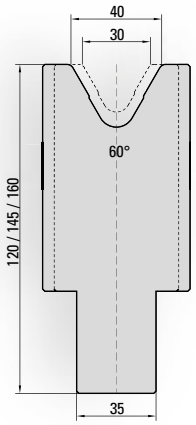

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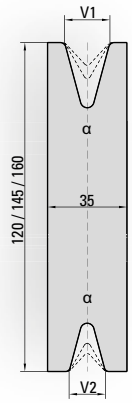

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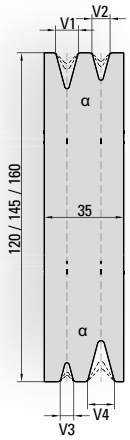
Delivery time on request



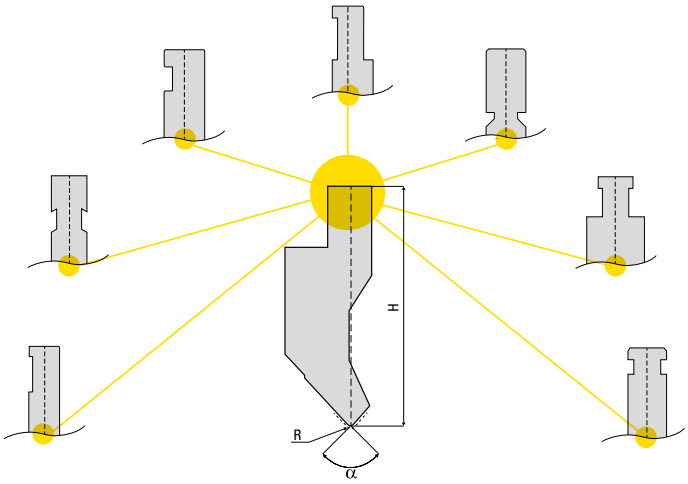
UKB-INFO

By mounting a steel insert dies UKB-System Amada (chapter 1) can also be used in a clamping UKB-System Weinbrenner!

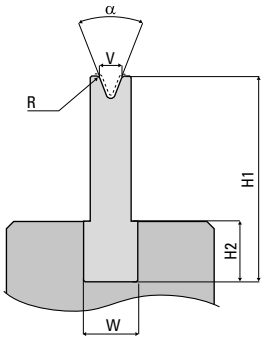
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, tempered to 800 – 850 N/mm²
  - C45, 650 – 800 N/mm²
  - 1.2312, tempered to 950 – 1100 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information
- Individual production according to your specification

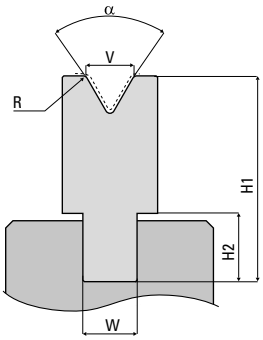
Examples punch/top tool clampings



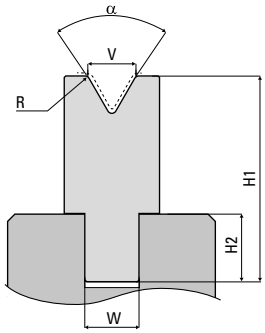
Examples of die clampings



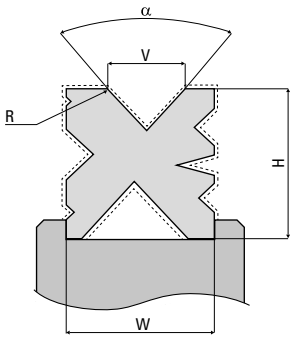
Force on the base



Force on the base



Force on shoulder



Clamping multi-V-die

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** On request
- **Full-service:** Construction, development, production
- **Production possibilities:** Up to 6000 mm tool length
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

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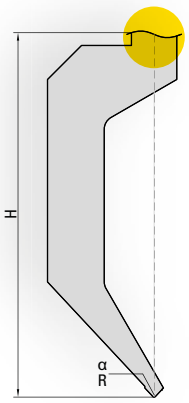
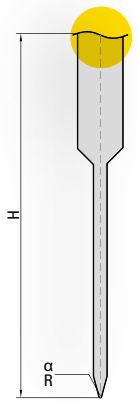
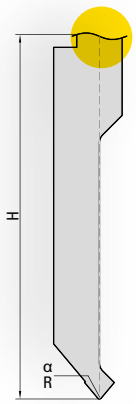
Examples punches/top tools



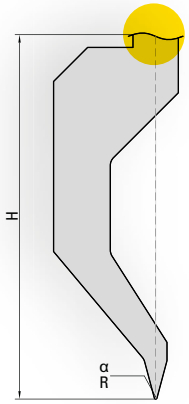
Example 1



Example 2



Example 3



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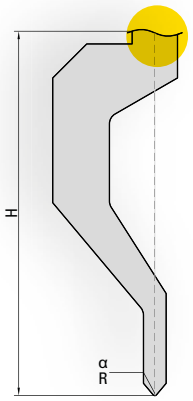
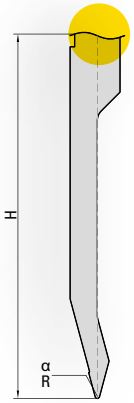


Example 5



Example 6

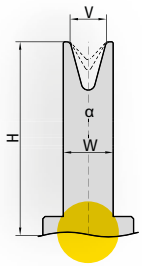
UKB-INFO

All punches/top tools and dies are examples! We produce individually according to your specifications!

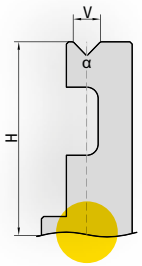
VIDEO

UKB-Press brake tool systems

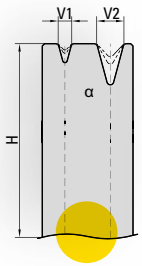
Examples dies



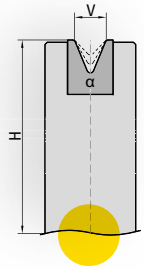
Example 1



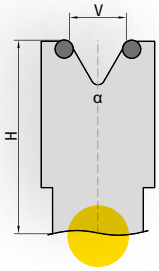
Example 2



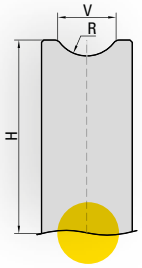
Example 3



Example 4



Example 5



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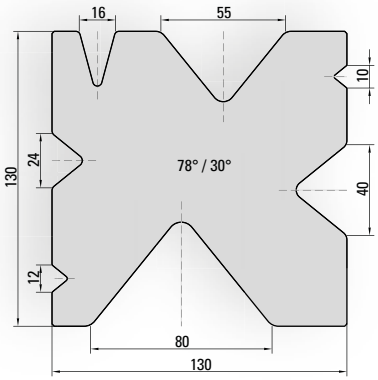

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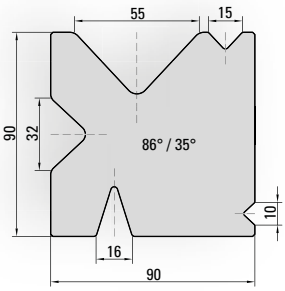
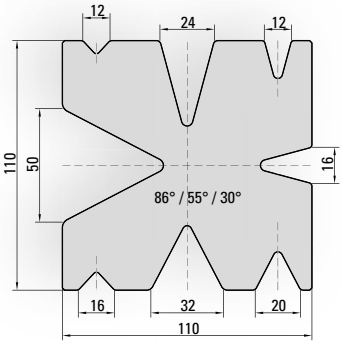
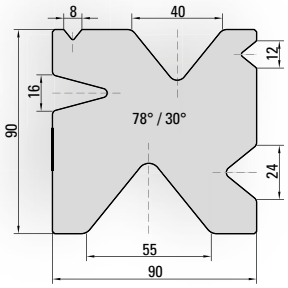


Example 8



Example 9



Example 10

UKB-HOLDERS FOR BLADES AND BLADES R 0,5 – 6,0

Explanation . . . . . 136 – 137
Holders for blades . . . . . 138 – 139
Blades R 0,5 – 6,0 139

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UKB-HOLDERS FOR BLADES AND BLADES R 0,5 – 6,0

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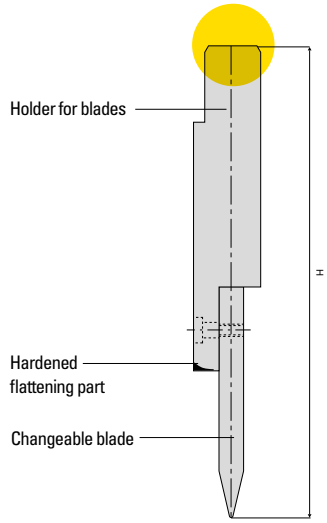
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, 650 – 800 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information

EXAMPLE OF USE



Product advantages

- Cost-saving: One holder for different blades
- Flexible application by changeable blades R 0,5 – R 6,0
- Fast and easy change of the blades
- Holder for blades with hardened flattening part

UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** UKB-Holders for blades and blades R 0,5 – 6,0 in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

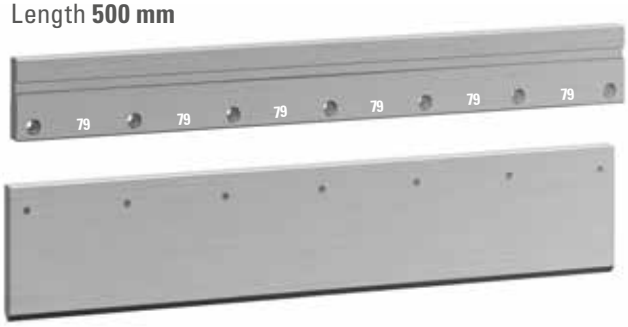
Standard:	1 – 3 working days by parcel service or forwarder
Express:	DE 9:00, 10:30, 12:00am or 1 working day EU 1 working day
Direct courier:	According agreement

- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

Tool lengths

Length **500 mm**



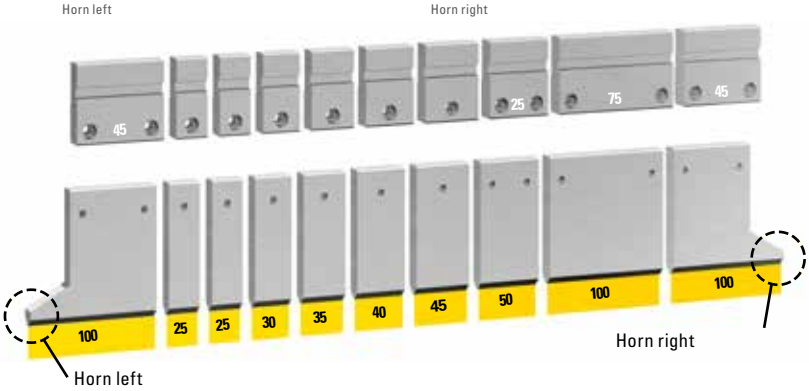
Length **300 mm**

Length **200 mm**

Length **100 mm**

Length **550 mm sectionalized**

- Sectionalized holders for blades are delivered as a complete set
- 10 Segments
  (100, 25, 25, 30, 35, 40, 45, 50, 100, 100)



VIDEO

UKB-Holders for blades and blades R 0,5 – 6,0

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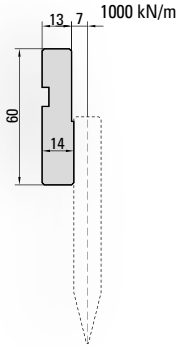
Holders for blades

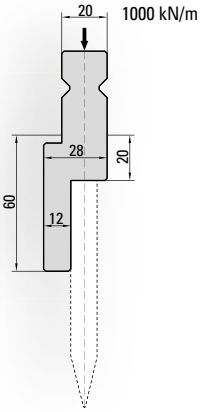
UKB-SYSTEM AMADA

10.400		24h
500 mm	110,– €	3,0 kg
300 mm	80,– €	1,8 kg
200 mm	60,– €	1,2 kg
100 mm	38,– €	0,6 kg
488 mm sectionalized	206,– €	2,9 kg

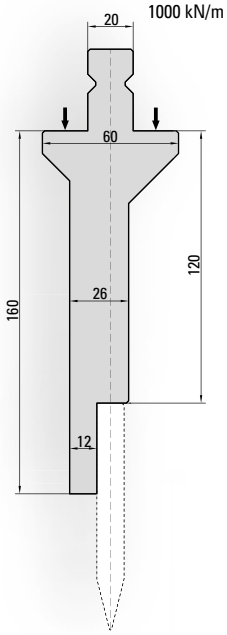


UKB-SYSTEMS TRUMPF/WILA/LVD

15.755		24h
Simple Clamp		
500 mm	330,– €	6,7 kg
300 mm	264,– €	4,0 kg
200 mm	180,– €	2,7 kg
100 mm	94,– €	1,4 kg
550 mm sectionalized	800,– €	7,4 kg

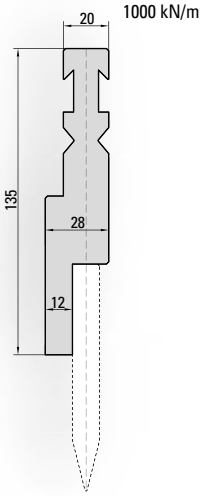


15.760		24h
Safety pins		
500 mm	630,– €	19,5 kg
300 mm	460,– €	11,7 kg
Simple Clamp		
200 mm	368,– €	7,8 kg
100 mm	208,– €	3,9 kg
550 mm sectionalized	1.362,– €	21,5 kg



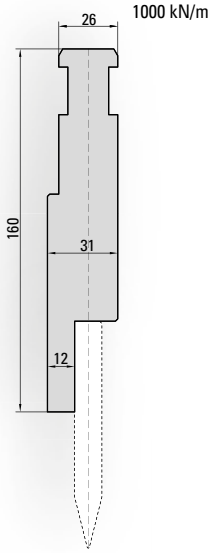
UKB-SYSTEM BYSTRONIC

14.282		24h
500 mm	394,– €	7,0 kg
300 mm	314,– €	4,2 kg
200 mm	216,– €	2,8 kg
100 mm	116,– €	1,4 kg
550 mm sectionalized	786,– €	7,7 kg



UKB-SYSTEM EHT

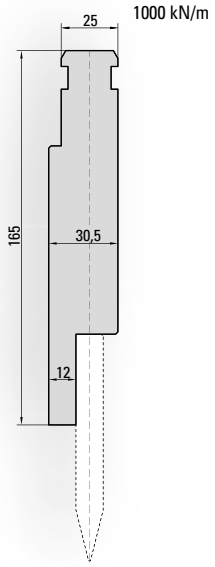
17.070		24h
500 mm	404,– €	15,0 kg
300 mm	268,– €	9,0 kg
200 mm	186,– €	6,0 kg
100 mm	120,– €	3,0 kg
550 mm sectionalized	828,– €	16,5 kg



Holders for blades

UKB-SYSTEM WEINBRENNER

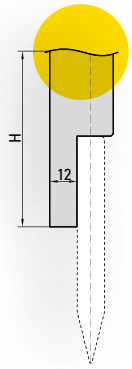
17.570		24h
500 mm	408,– €	15,5 kg
300 mm	326,– €	9,3 kg
200 mm	224,– €	6,2 kg
100 mm	120,– €	3,1 kg
550 mm sectionalized	834,–€	17,0 kg



OTHER SYSTEMS

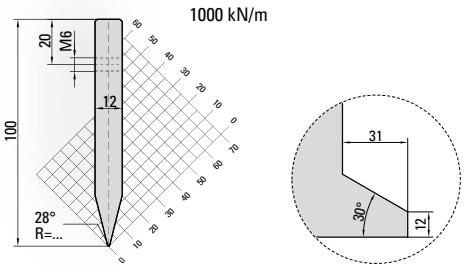
Holder for blades with individual clamping, suitable for your press brake

Delivery time on reqest



Blades R 0,5 – 6,0

28°						24h
Model	R (mm)	500 mm Price	300 mm Price	200 mm Price	100 mm Price	550 mm sect. Price
15.761	0,5	136,– €	108,– €	78,– €	46,– €	240,– €
15.763	1,0	136,– €	108,– €	78,– €	46,– €	240,– €
15.762	1,5	136,– €	108,– €	78,– €	46,– €	240,– €
15.765	2,0	136,– €	108,– €	78,– €	46,– €	240,– €
15.764	2,5	136,– €	108,– €	78,– €	46,– €	240,– €
15.766	3,0	136,– €	108,– €	78,– €	46,– €	240,– €
15.767	4,0	136,– €	108,– €	78,– €	46,– €	240,– €
15.768	5,0	136,– €	108,– €	78,– €	46,– €	240,– €
15.769	6,0	136,– €	108,– €	78,– €	46,– €	240,– €
Weight		4,5 kg	2,7 kg	1,8 kg	0,9 kg	5,0 kg



UKB-HOLDERS FOR RADIUS-TOOLS AND RADIUS-TOOLS R 7,0 – 50,0

Explanation 142
Holders for radius-tools . . . . . 143 – 145
Radius-tools R 7,0 – 50,0 . . . . . .146 – 147
Flattening-tool 146

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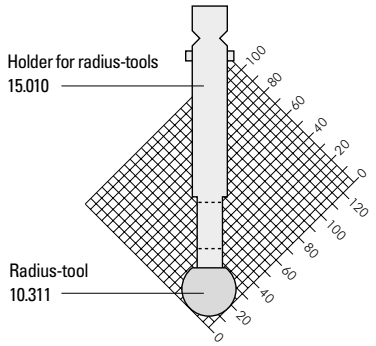
Quality and precision

- Optimum materials
  - 42 CrMo4, tempered to 1100 – 1200 N/mm²
  - C45, 650 – 800 N/mm²
- Radius-tools in two different models:
  - Hardened up to 60 HRC
  - Not hardened
- Precision ground
- Guaranteed exchangebility and parallelism
- Tool marking with all technical information

EXAMPLE OF USE



Product advantages

- Cost-saving: One holder for different radius-tools
- Easy handling
- No adjustment necessary for R 12,5 – 50,0
- High stability
- Flexible application through changeable radius-tools
- Sectionalized radius-tools on request

UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** UKB-Holders for radius-tools and radius-tools in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

Standard:	1 – 3 working days by parcel service or forwarder
Express:	DE 9:00, 10:30, 12:00am or 1 working day EU 1 working day
Direct courier:	According agreement

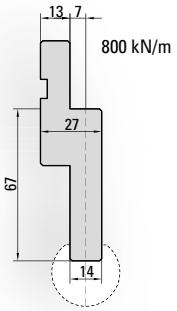
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

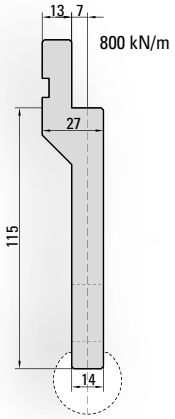
Holders for radius-tools

UKB-SYSTEM AMADA

10.115		24h
830 mm	178,– €	10,0 kg
412 mm	102,– €	5,0 kg



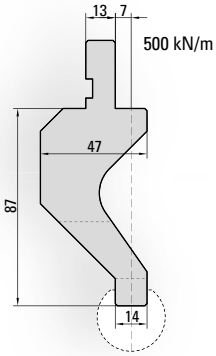
10.116		24h
830 mm	278,– €	14,0 kg
412 mm	156,– €	7,0 kg



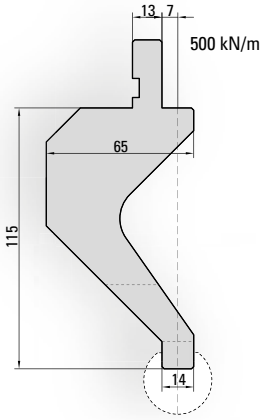
UKB-INFO

UKB-Holders for radius-tools and radius-tools R 3,0 - 6,5
see page 19

10.190		24h
830 mm	440,– €	16,0 kg
412 mm	246,– €	8,0 kg



10.191		24h
830 mm	586,– €	26,0 kg
412 mm	330,– €	13,0 kg



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Holders for radius-tools

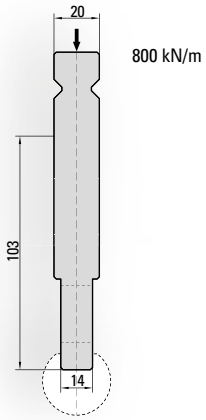
UKB-SYSTEMS TRUMPF/WILA/LVD

15.010 24h

Safety pins		
830 mm	298,– €	16,0 kg
412 mm	176,– €	8,0 kg

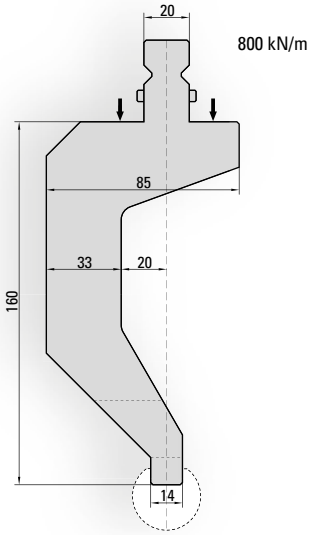
Simple Clamp		
412 mm	236,– €	8,0 kg

You should not exceed the weight of 12,5 kg incl. the radius tool



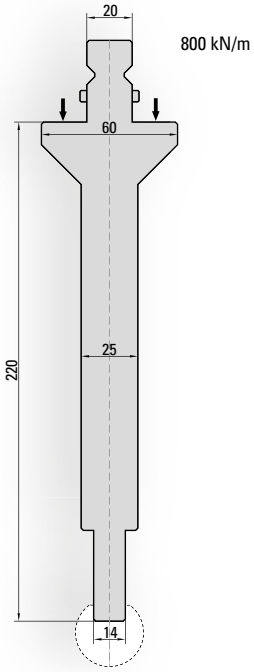
15.014 24h

Safety pins		
830 mm	898,– €	47,0 kg
412 mm	500,– €	23,5 kg



15.018 24h

Safety pins		
830 mm	750,– €	41,0 kg
412 mm	400,– €	20,5 kg



UKB-FIELD SERVICE

- *Individual advice and sale*
- *Technical solutions for special bending tasks*
- *Test bending on-site or at the UKB-test center*
- *Pick up service for tools to rework*

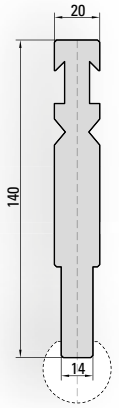
VIDEO

UKB-Holders for radius-tools and radius-tools R 7,0 – 50,0

Holders for radius-tools

UKB-SYSTEM BYSTRONIC

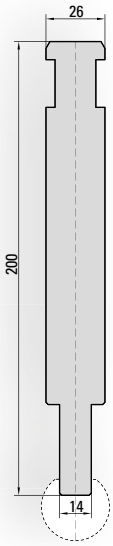
14.252		24h
830 mm	318,– €	15,5 kg
412 mm	186,– €	7,8 kg



800 kN/m

UKB-SYSTEM EHT

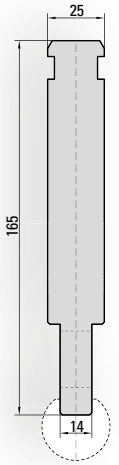
17.010		24h
830 mm	424,– €	28,2 kg
412 mm	244,– €	14,1 kg



800 kN/m

UKB-SYSTEM WEINBRENNER

17.510		24h
830 mm	372,– €	22,6 kg
412 mm	212,– €	11,3 kg

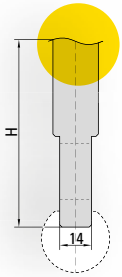


800 kN/m

OTHER SYSTEMS

Holder for radius tools with individual clamping, suitable for your press brake

Delivery time on request



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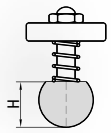
Radius-tools R 7,0 – 50,0

R 7,0 – 12,0

24h

R (mm)	H (mm)	Model	835 mm		415 mm		Model	835 mm		415 mm	
			Price	Weight	Price	Weight		Price	Weight	Price	Weight
7,0	11,5	10.300	68,– €	0,90 kg	42,– €	0,45 kg	11.300	160,– €	0,90 kg	96,– €	0,45 kg
7,5	11,5	10.301	68,– €	1,00 kg	42,– €	0,50 kg	11.301	166,– €	1,00 kg	98,– €	0,50 kg
8,0	13,0	10.302	68,– €	1,20 kg	42,– €	0,60 kg	11.302	170,– €	1,20 kg	100,– €	0,60 kg
9,0	16,0	10.303	74,– €	1,60 kg	44,– €	0,80 kg	11.303	180,– €	1,60 kg	106,– €	0,80 kg
10,0	16,0	10.304	60,– €	2,00 kg	38,– €	1,00 kg	11.304	190,– €	2,00 kg	110,– €	1,00 kg
11,0	16,0	10.305	88,– €	2,10 kg	52,– €	1,05 kg	11.305	200,– €	2,10 kg	116,– €	1,05 kg
11,5	19,0	10.306	88,– €	2,50 kg	52,– €	1,25 kg	11.306	206,– €	2,50 kg	120,– €	1,25 kg
12,0	20,0	10.307	88,– €	2,70 kg	52,– €	1,35 kg	11.307	210,– €	2,70 kg	120,– €	1,35 kg
		C45	Radius-tools not hardened				42CrMo4	Radius-tools hardened up to 60 HRC			

800 kN/m



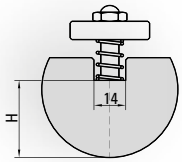
R=7,0 - 12,0

R 12,5 – 50,0

24h

R (mm)	H (mm)	Model	835 mm		415 mm		Model	835 mm		415 mm	
			Price	Weight	Price	Weight		Price	Weight	Price	Weight
12,5	16,0	10.308	98,– €	3,30 kg	58,– €	1,65 kg	11.308	214,– €	3,30 kg	128,– €	1,65 kg
13,0	17,0	10.309	98,– €	3,50 kg	58,– €	1,75 kg	11.309	220,– €	3,50 kg	130,– €	1,75 kg
14,0	19,0	10.310	98,– €	3,80 kg	58,– €	1,90 kg	11.310	230,– €	3,80 kg	134,– €	1,90 kg
15,0	20,0	10.311	82,– €	5,00 kg	50,– €	2,50 kg	11.311	240,– €	5,00 kg	140,– €	2,50 kg
16,0	21,0	10.312	116,– €	5,10 kg	68,– €	2,55 kg	11.312	250,– €	5,10 kg	144,– €	2,55 kg
17,0	21,5	10.313	116,– €	5,80 kg	68,– €	2,90 kg	11.313	260,– €	5,80 kg	150,– €	2,90 kg
17,5	22,0	10.314	98,– €	6,00 kg	64,– €	3,00 kg	11.314	266,– €	6,00 kg	158,– €	3,00 kg
19,0	25,0	10.315	124,– €	6,30 kg	76,– €	3,15 kg	11.315	280,– €	6,30 kg	166,– €	3,15 kg
20,0	24,0	10.316	118,– €	6,80 kg	74,– €	3,40 kg	11.316	290,– €	6,80 kg	170,– €	3,40 kg
22,5	25,0	10.317	144,– €	8,00 kg	86,– €	4,00 kg	11.317	320,– €	8,00 kg	186,– €	4,00 kg
25,0	29,0	10.318	118,– €	10,00 kg	82,– €	5,00 kg	11.318	350,– €	10,00 kg	200,– €	5,00 kg
27,5	34,0	10.319	164,– €	12,50 kg	98,– €	6,25 kg	11.319	380,– €	12,50 kg	220,– €	6,25 kg
30,0	34,0	10.320	162,– €	13,50 kg	102,– €	6,75 kg	11.320	440,– €	13,50 kg	250,– €	6,75 kg
35,0	45,0	10.321	246,– €	21,00 kg	146,–€	10,50 kg	11.321	470,– €	21,00 kg	266,–€	10,50 kg
40,0	45,0	10.322	286,– €	24,00 kg	170,–€	12,00 kg	11.322	620,– €	24,00 kg	340,–€	12,00 kg
45,0	50,0	10.323	330,– €	29,50 kg	202,–€	14,75 kg	11.323	680,– €	29,50 kg	380,–€	14,75 kg
50,0	54,0	10.324	354,– €	34,50 kg	220,–€	17,25 kg	11.324	720,– €	34,50 kg	410,–€	17,25 kg
		C45	Radius-tools not hardened				42CrMo4	Radius-tools hardened up to 60 HRC			

800 kN/m



R=12,5 - 50,0

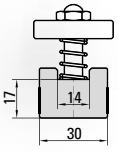
Flattening-tool

10.325

24h

835 mm	102,– €	4,00 kg
415 mm	60,– €	2,00 kg

800 kN/m



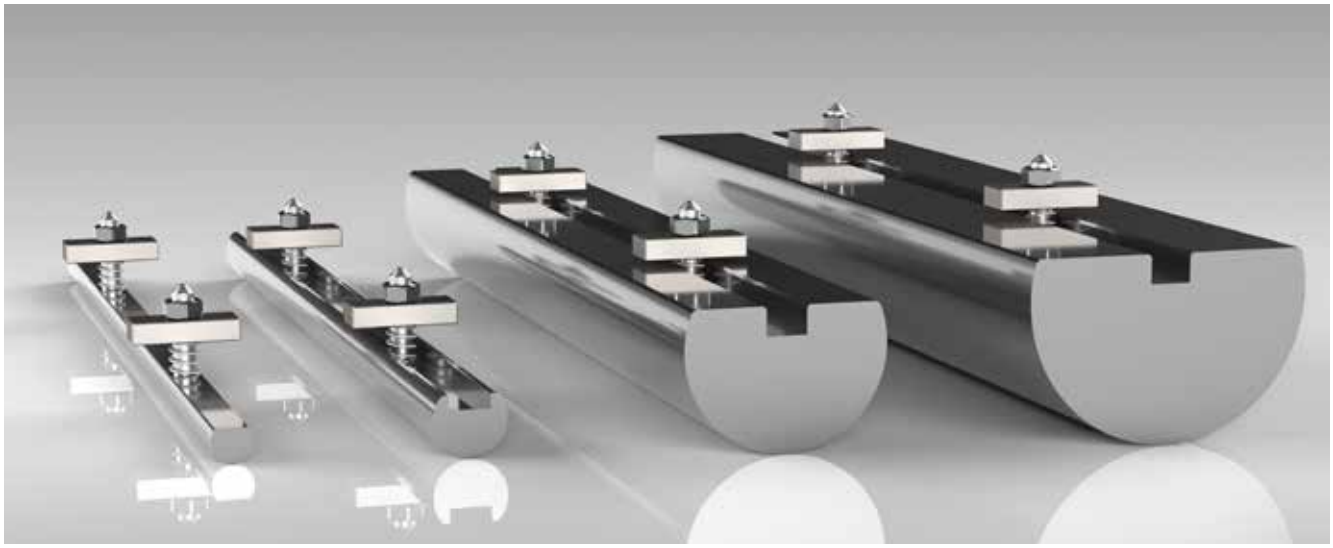
VIDEO

UKB-Holders for radius-tools and radius-tools R 7,0 – 50,0

Radius-tools R 7,0 – 50,0

UKB-TEST BENDING

Determination of the radius with your sample sheets in your or our house!



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UKB-Z-TOOL HOLDES AND Z-TOOL INSERTS Z 1,0 – 15,0

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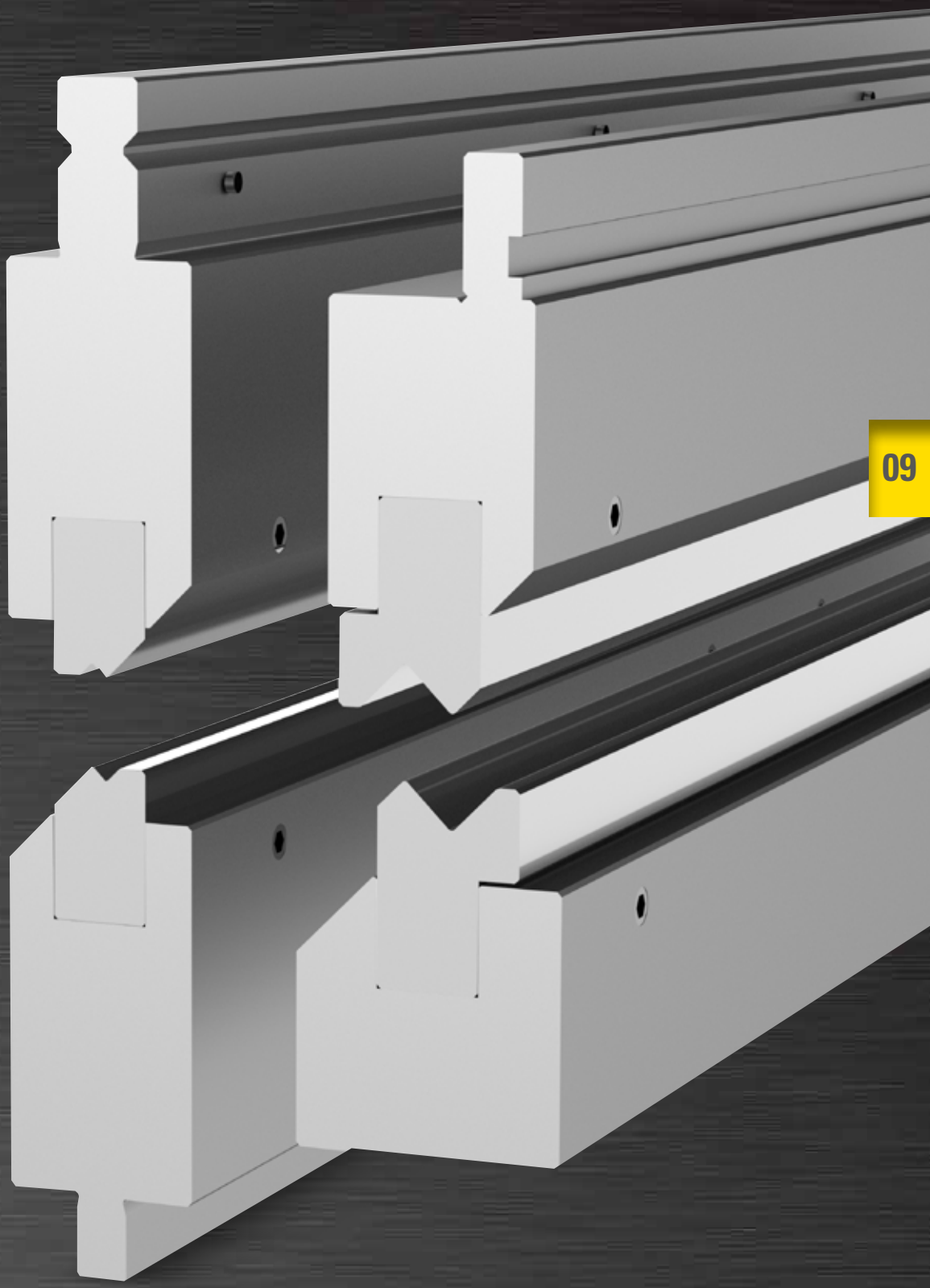

09

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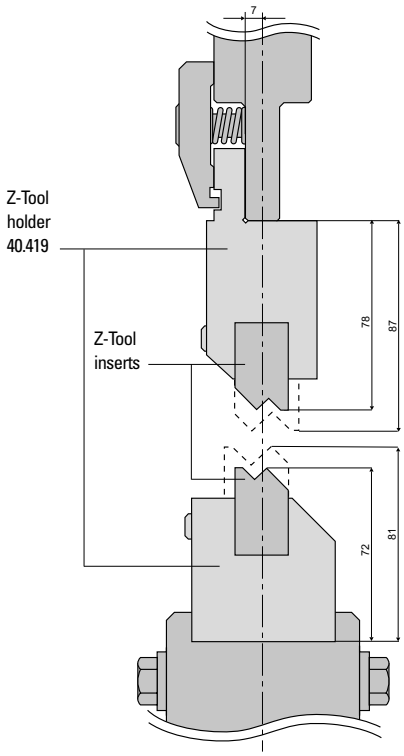
Quality and precision

- Optimum materials
  - C45, 650 – 800 N/mm²
- Bending radius/intake radii hardened up to 52 – 55 HRC
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information

Product advantages

- Cost-saving: One holder for different Z-Tool tool inserts
- Z-Tool holders and Z-Tool inserts Z 1,0 – 15,0 are each delivered as a set
- Flexible application by changeable Z-Tool inserts Z 1,0 – 15,0
- No adjustment necessary
- Short Z-bending in one stroke
- Z-bending with long flanges possible
- Sectionalized Z-Tools on request

EXAMPLE OF USE



Z-Tool inserts are fixed by M8 grub screws in the Z-Tool holders.

UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** UKB-Z-Tool holders and Z-Tool inserts Z 1,0 – 15,0 in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

  Standard: 1 – 3 working days by parcel service or forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

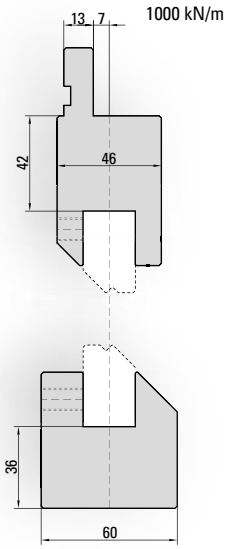
  Direct courier: According agreement
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

Z-Tool holders

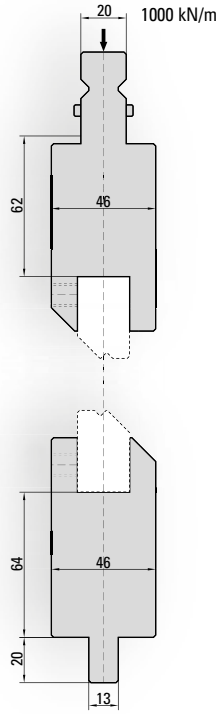
UKB-SYSTEM AMADA

40.419		24h
835 mm	738,– €	37,4 kg
415 mm	414,– €	18,7 kg



UKB-SYSTEMS TRUMPF/WILA

15.050		24h
Safety pins		
835 mm	1.050,– €	50,0 kg
415 mm	574,– €	25,0 kg

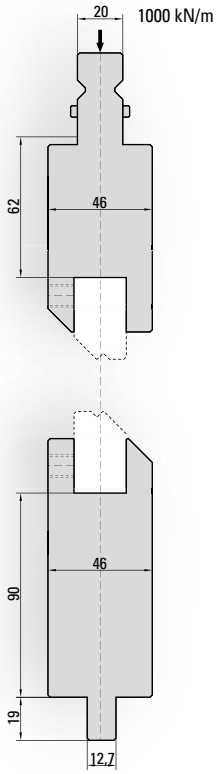


VIDEO

UKB-Z-Tool holders
and Z-Tool inserts
Z 1,0 – 15,0

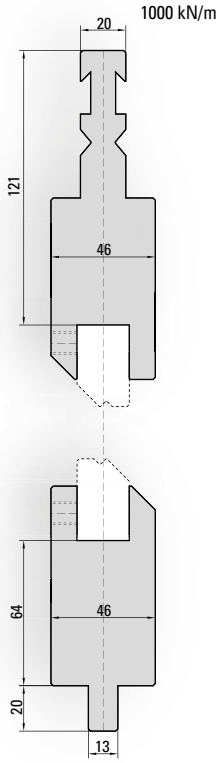
UKB-SYSTEM LVD

16.060		24h
Safety pins		
835 mm	1.248,– €	60,0 kg
415 mm	650,– €	30,0 kg



UKB-SYSTEM BYSTRONIC

14.080		24h
835 mm	1.330,– €	53,0 kg
415 mm	718,– €	26,5 kg



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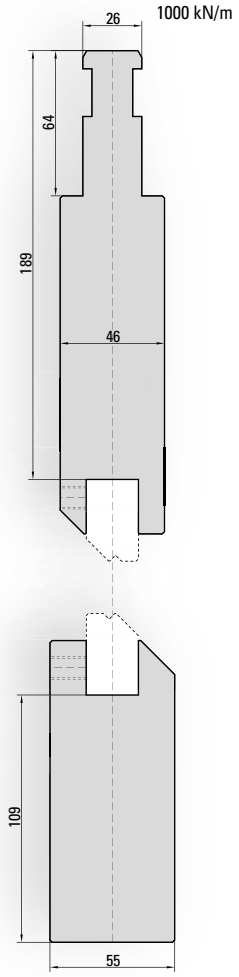
Z-Tool holders

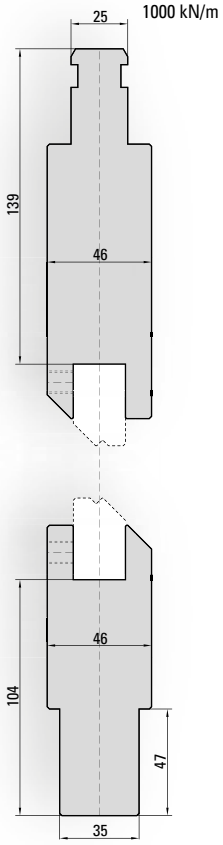
UKB-SYSTEM EHT

17.050		24h
415 mm	640,– €	46,8 kg



UKB-SYSTEM WEINBRENNER

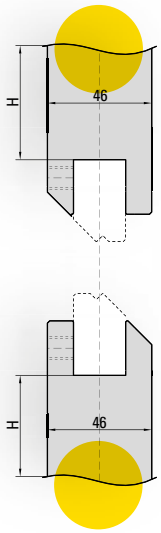
17.550		24h
415 mm	622,– €	35,0 kg



OTHER SYSTEMS

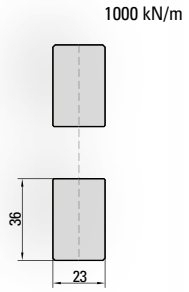
Z-Tool holder with individual clamping, suitable for your press brake

Delivery time on request



Flattening insert

40.500		24h
835 mm	250,– €	10,0 kg
415 mm	140,– €	5,0 kg

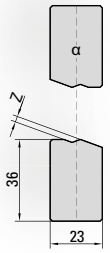


Z-Tool inserts Z 1,0 – 15,0

Z 1,0 – 2,5 — 24h

Model	α	Z (mm)	835 mm Price	415 mm Price
40.510	160°	1,0	374,– €	206,– €
40.515	160°	1,5	374,– €	206,– €
40.520	150°	2,0	374,– €	206,– €
40.525	140°	2,5	374,– €	206,– €
Weight			10,0 kg	5,0 kg

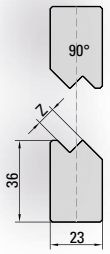
1000 kN/m



Z 1,0 – 8,0 — 24h

Model	α	Z (mm)	835 mm Price	415 mm Price
40.511	90°	1,0	374,– €	206,– €
40.516	90°	1,5	374,– €	206,– €
40.521	90°	2,0	374,– €	206,– €
40.526	90°	2,5	374,– €	206,– €
40.530	90°	3,0	374,– €	206,– €
40.535	90°	3,5	374,– €	206,– €
40.540	90°	4,0	374,– €	206,– €
40.545	90°	4,5	374,– €	206,– €
40.550	90°	5,0	374,– €	206,– €
40.555	90°	5,5	374,– €	206,– €
40.560	90°	6,0	374,– €	206,– €
40.565	90°	6,5	374,– €	206,– €
40.570	90°	7,0	374,– €	206,– €
40.575	90°	7,5	374,– €	206,– €
40.580	90°	8,0	374,– €	206,– €
Weight			10,0 kg	5,0 kg

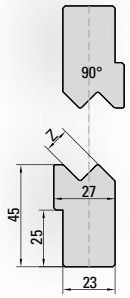
1000 kN/m



Z 8,5 – 12,0 — 24h

Model	α	Z (mm)	835 mm Price	415 mm Price
40.585	90°	8,5	416,– €	230,– €
40.590	90°	9,0	416,– €	230,– €
40.610	90°	10,0	416,– €	230,– €
40.611	90°	11,0	416,– €	230,– €
40.612	90°	12,0	416,– €	230,– €
Weight			13,5 kg	6,7 kg

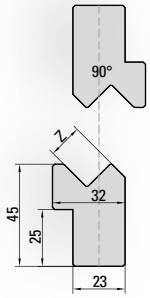
1000 kN/m



Z 13,0 – 15,0 — 24h

Model	α	Z (mm)	835 mm Price	415 mm Price
40.613	90°	13,0	416,– €	230,– €
40.614	90°	14,0	416,– €	230,– €
40.615	90°	15,0	416,– €	230,– €
Weight			14,5 kg	7,3 kg

1000 kN/m



UKB-UNIBEND AND UKB-WINGBEND PLUS

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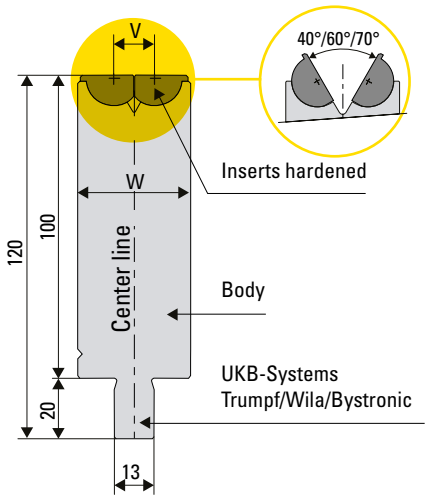
Quality and precision

- Optimum materials
- Hardened according to the operation purpose
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information



Product advantages

- Reduces bending marks on sheets
- Short flanges with minimal marking
- Holes close to the bending line without deformation
- Ideal for diagonal and tapered bending
- Repeatability for punched sheets with steady flanges and exact angles
- Bulb and chequered plates with minimal marking at the visible surface
- No damage of the foil while bending laminated sheets
- Less tool change

UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** Dies UKB-UniBend in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

  Standard: 1 – 3 working days by parcel service or forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

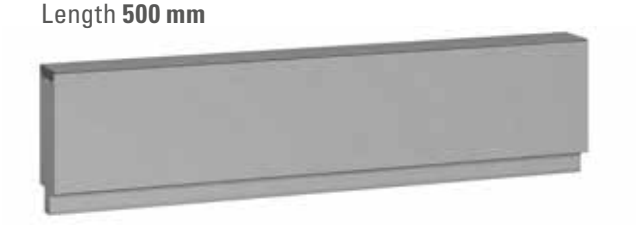
  Direct courier: According agreement
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

Tool lengths

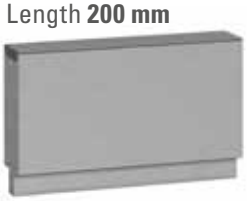
DIES

Length **500 mm**



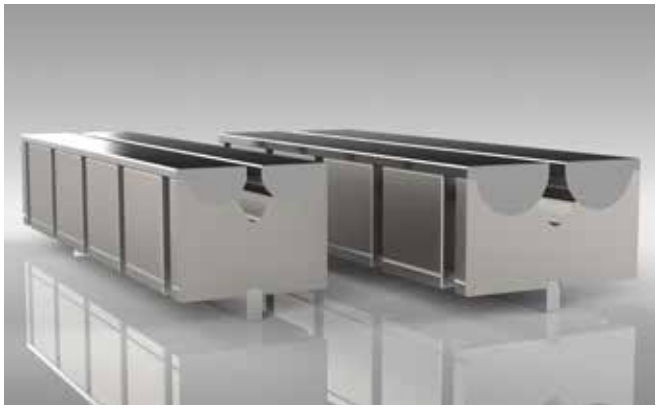
Length **300 mm**

Length **200 mm**



Length **100 mm**

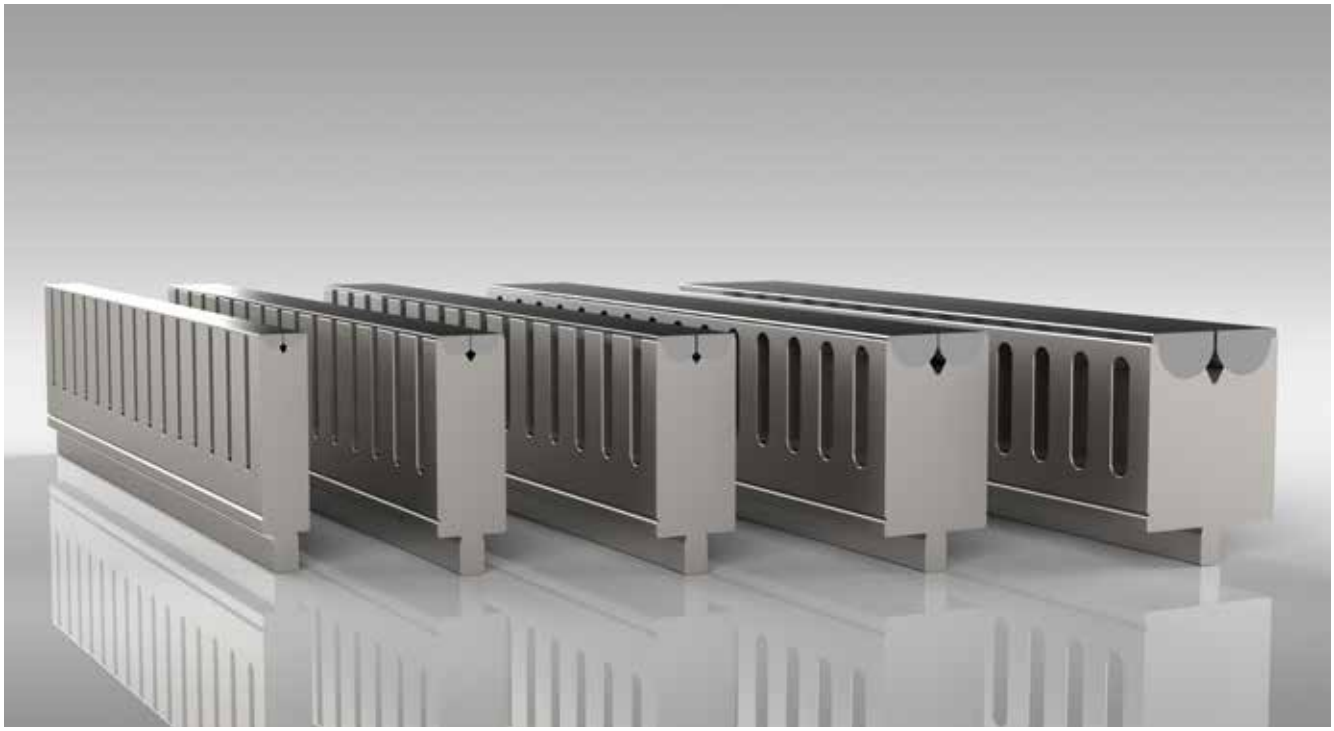
Length **50 mm**



Dies UniBend 29.600 and 29.850

VIDEO

UKB-UniBend and UKB-WingBend PLUS



Dies UniBend 29.000, 29.100, 29.150, 29.200 and 29.300

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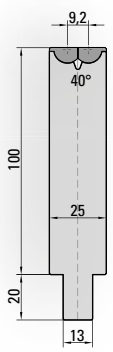
Dies UniBend

29.000 — 24h

500 mm	1.580,– €	10,0 kg
300 mm	1.150,– €	6,0 kg
200 mm	862,– €	4,0 kg
100 mm	576,– €	2,0 kg
50 mm	384,– €	1,0 kg

Recommended material thicknesses:
R_m = 450 N/mm² max. 2,0 mm
R_m = 700 N/mm² max. 1,5 mm

1000 kN/m

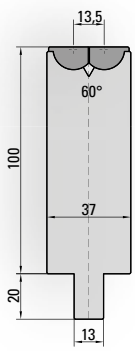


29.100 — 24h

500 mm	1.724,– €	14,0 kg
300 mm	1.294,– €	8,4 kg
200 mm	958,– €	5,6 kg
100 mm	622,– €	2,8 kg
50 mm	432,– €	1,4 kg

Recommended material thicknesses:
R_m = 450 N/mm² max. 3,0 mm
R_m = 700 N/mm² max. 2,0 mm

1300 kN/m

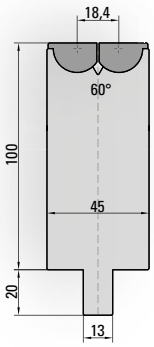


29.150 — 24h

500 mm	1.940,– €	15,0 kg
300 mm	1.484,– €	9,0 kg
200 mm	1.102,– €	6,0 kg
100 mm	694,– €	3,0 kg
50 mm	456,– €	1,5 kg

Recommended material thicknesses:
R_m = 450 N/mm² max. 4,0 mm
R_m = 700 N/mm² max. 3,0 mm

1500 kN/m

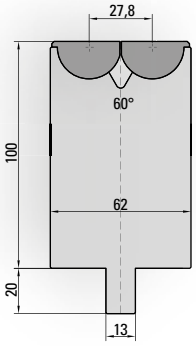


29.200 — 24h

500 mm	2.156,– €	22,5 kg
300 mm	1.676,– €	13,5 kg
200 mm	1.246,– €	9,0 kg
100 mm	766,– €	4,5 kg
50 mm	480,– €	2,3 kg

Recommended material thicknesses:
R_m = 450 N/mm² max. 5,0 mm
R_m = 700 N/mm² max. 4,0 mm

1700 kN/m

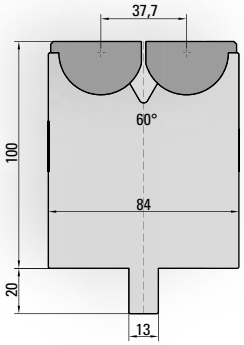


29.300 — 24h

500 mm	2.490,– €	29,0 kg
300 mm	1.868,– €	17,4 kg
200 mm	1.342,– €	11,6 kg
100 mm	862,– €	5,8 kg
50 mm	594,– €	2,9 kg

Recommended material thicknesses:
R_m = 450 N/mm² max. 6,0 mm
R_m = 700 N/mm² max. 5,0 mm

2000 kN/m

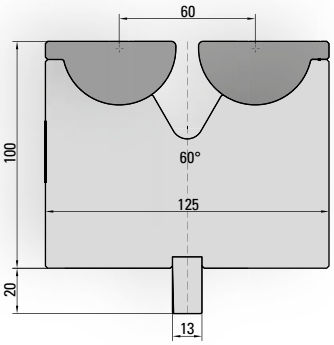


29.600 — 24h

500 mm	3.048,– €	45,3 kg
300 mm	2.312,– €	27,2 kg
200 mm	1.746,– €	18,2 kg

Recommended material thicknesses:
R_m = 450 N/mm² max. 8,0 mm
R_m = 700 N/mm² max. 6,0 mm

2000 kN/m

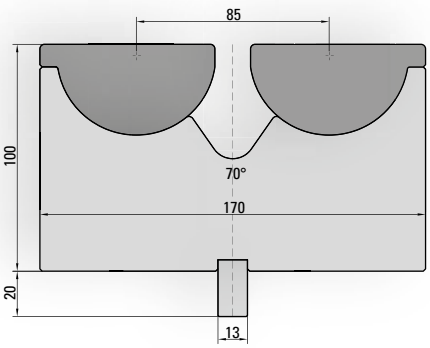


29.850 — 24h

500 mm	3.486,– €	61,5 kg
300 mm	2.630,– €	36,8 kg
200 mm	1.944,– €	24,6 kg

Recommended material thicknesses:
R_m = 450 N/mm² max. 12,0 mm
R_m = 700 N/mm² max. 10,0 mm

2500 kN/m



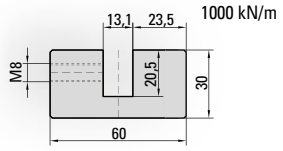
UKB-TEST BENDING

First test bending - then order!
Free of charge - with your sample sheets in your or our house!

Die adaptors

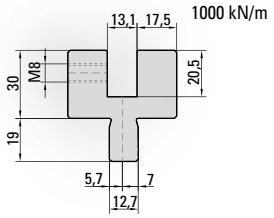
60.910		24h
1000 mm	208,– €	15,0 kg
500 mm	120,– €	7,5 kg

UKB-System Amada➔
UKB-Systems Trumpf/Wila/Bystronic



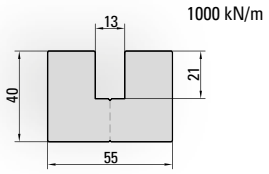
60.935		24h
1000 mm	378,– €	11,0 kg
500 mm	208,– €	5,5 kg

UKB-System LVD➔
UKB-Systems Trumpf/Wila/Bystronic



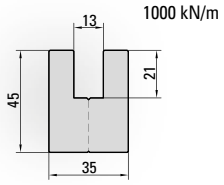
60.940		24h
500 mm	248,– €	7,5 kg

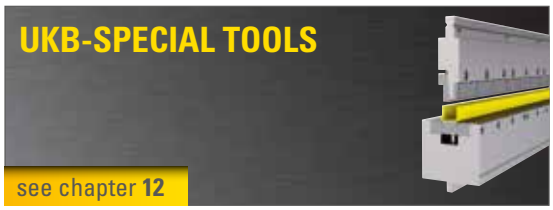
UKB-System EHT➔
UKB-Systems Trumpf/Wila/Bystronic



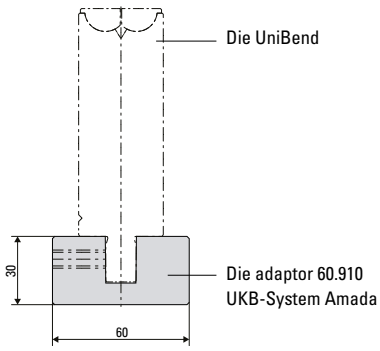
60.950		24h
500 mm	230,– €	4,5 kg

UKB-System Weinbrenner ➔
UKB-Systems Trumpf/Wila/Bystronic





EXAMPLE OF USE



Lubricating grease

40.629	24h
100 ml	26,– €

For lubrication of UniBend dies

Phone +49 (0) 27 36 / 44 42 - 0 . Fax +49 (0) 27 36 / 44 42 - 22

Technical data

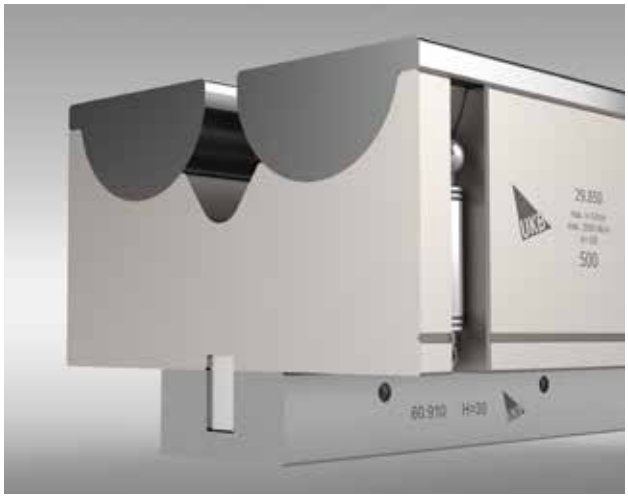
Table of force: Tensile strength R_m = 450 N/mm², bending angle 90°

Model	29.000	29.100	29.150	29.200	29.300	29.600	29.850
Radius of the punch/top tool	R 1,0	R 1,0	R 1,0	R 1,0	R 1,0	R 6,0	R 10,0
Material thickness 0,5 mm	30	30	20				
Material thickness 1,0 mm	100	60	40	30			
Material thickness 1,5 mm	240	130	90	50			
Material thickness 2,0 mm	530	260	150	100	80		
Material thickness 2,5 mm		460	270	160	130		
Material thickness 3,0 mm		770	510	270	180		
Material thickness 4,0 mm			970	530	400		
Material thickness 5,0 mm				880	660	210	
Material thickness 6,0 mm					1050	580	
Material thickness 8,0 mm						1310	720
Material thickness 10,0 mm							1350
Material thickness 12,0 mm							1630

Reference value for minimum flange: mild steel

Model	29.000		29.100	29.150		29.200		29.300		29.600		29.850	
Radius of the punch/top tool	R 0,5	R 1,0	R 1,0	R 1,0	R 3,0	R 1,0	R 4,0	R 1,0	R 4,0	R 4,0	R 6,0	R 6,0	R 10,0
Material thickness 0,5 mm	4,6	4,7	5,6	10,0	10,4								
Material thickness 1,0 mm	5,3	5,3	6,8	10,1	10,5	15,6	16,0						
Material thickness 1,5 mm	5,6	5,7	7,6	10,6	11,0	16,0	16,6						
Material thickness 2,0 mm	5,9	6,1	8,0	10,8	11,2	16,3	17,8	19,4	19,5				
Material thickness 2,5 mm			8,2	11,1	11,5	16,4	17,9	19,8	20,0				
Material thickness 3,0 mm			8,3	11,4	11,9	16,5	18,5	20,6	20,6				
Material thickness 4,0 mm				13,1	13,5	16,8	18,7	21,1	21,2				
Material thickness 5,0 mm						17,0	19,3	22,0	22,0	40,4	40,6		
Material thickness 6,0 mm								23,4	23,2	41,0	41,2		
Material thickness 8,0 mm										42,4	43,0	54,8	55,0
Material thickness 10,0 mm												55,7	56,3
Material thickness 12,0 mm												57,3	57,5

Table of force and reference values for stainless steel and aluminium on our Website: www.ukb-gmbh.com or please phone us: Phone +49 (0) 27 36 / 44 42 - 0



Die UniBend 29.850 and die adaptor 60.910

Die UniBend 29.150 and die adaptor 60.910

Die UniBend VARIO

ADDITIONAL PRODUCT ADVANTAGES UNIBEND VARIO

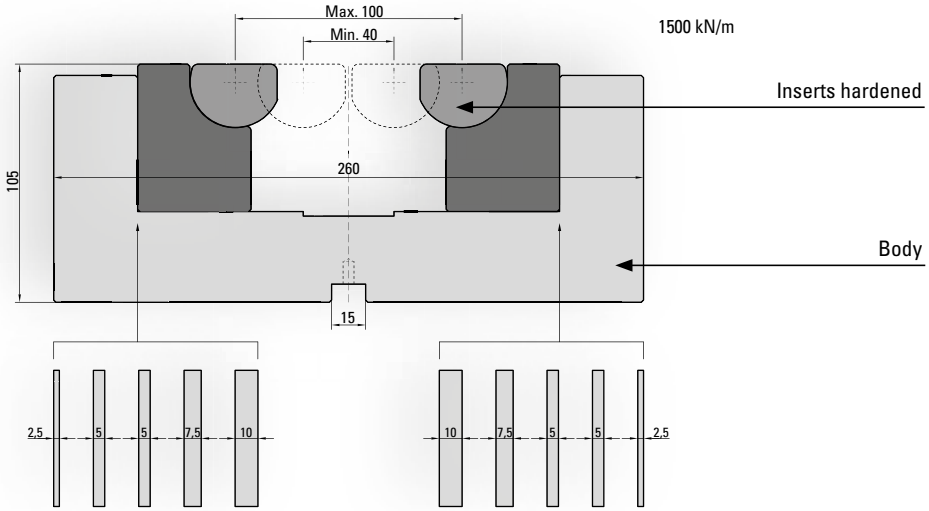
- Flexible adjustable V-openings
  - V = 40 – 100 mm
- Die width fast and easy adjustable, by changing strips, in 5 mm steps

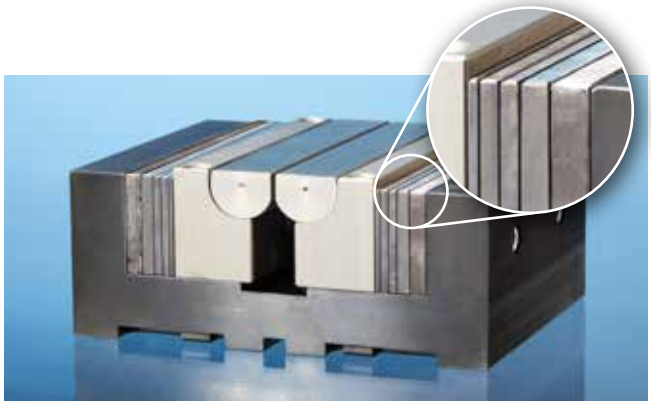
VIDEO

UKB-UniBend and UKB-WingBend PLUS

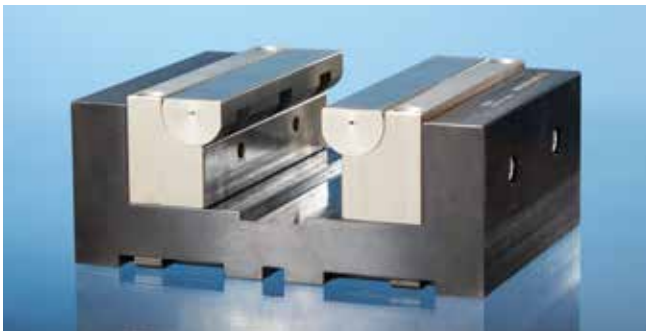
62.094		24h
200 mm	2.850,– €	40,0 kg

Die UniBend VARIO including inserts type flat and strips in a set:
Width = 2 x each 2,5/5/5/7,5/10
max. 12,0 mm material thickness





Strips inserted, V = 40 mm



Without strips, V = 100 mm

Bending results with UniBend VARIO

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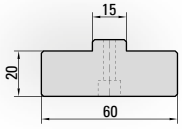
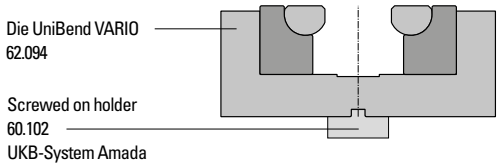
Die holders

UKB-SYSTEM AMADA

60.102		24h
198 mm	82,– €	2,0 kg

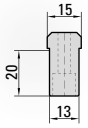


EXAMPLE OF USE



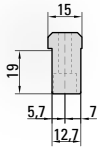
UKB-SYSTEMS TRUMPF/WILA/BYSTRONIC

60.103		24h
198 mm	52,– €	0,6 kg



UKB-SYSTEM LVD

60.105		24h
198 mm	58,– €	0,6 kg



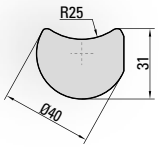
UKB-INFO

More die holders available!
Prices and delivery times on request!

Changeable inserts

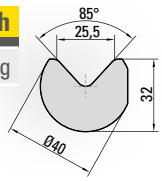
62.181		24h
200 mm	260,– €	1,5 kg

Insert type concave for 62.094
Price per piece



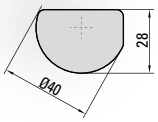
62.182		24h
200 mm	260,– €	1,5 kg

Insert type V for 62.094
Price per piece

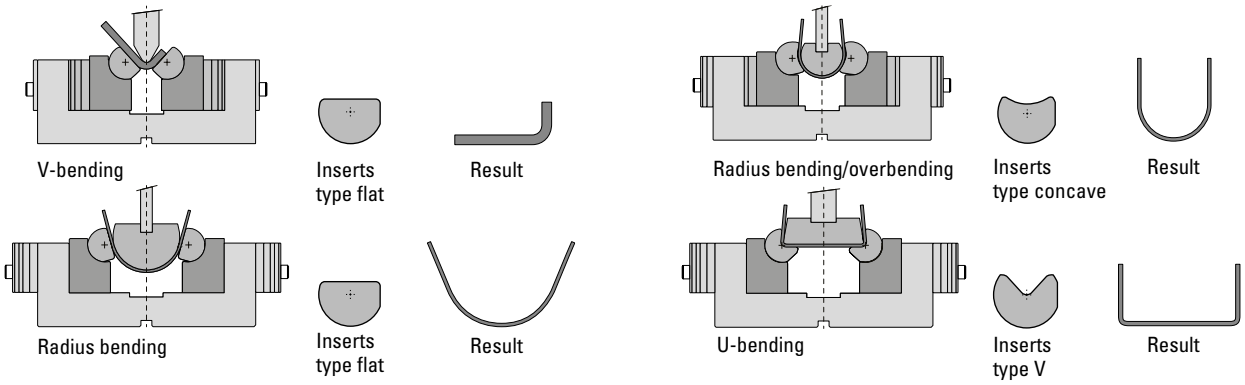


62.183		24h
200 mm	210,– €	1,5 kg

Insert type flat for 62.094
Price per piece



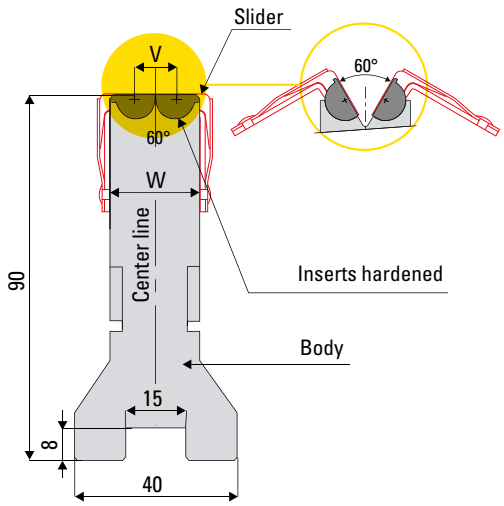
EXAMPLES OF USE



Quality and precision

- Optimum materials
- Hardened according to the operation purpose
- Precision ground
- Guaranteed exchangeability and parallelism
- Tool marking with all technical information

WingBend PLUS



Product advantages

- Avoids bending marks on sheets via Slider
- Short flanges with minimal marking
- Holes close to the bending line without deformation
- Ideal for diagonal and tapered bending
- Repeatability for punched sheets with steady flanges and exact angles
- Bulb and chequered plates with minimal marking at the visible surface
- No tool contamination while bending galvanized material or aluminium
- No reworking of workpieces necessary
- Increased product quality
- Less tool change

UKB-CONTACT PARTNER

You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** Dies UKB-WingBend PLUS in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

  Standard: 1 – 3 working days by parcel service or forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

  Direct courier: According agreement
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO
Image

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Tool lengths

DIES

Length **500 mm**

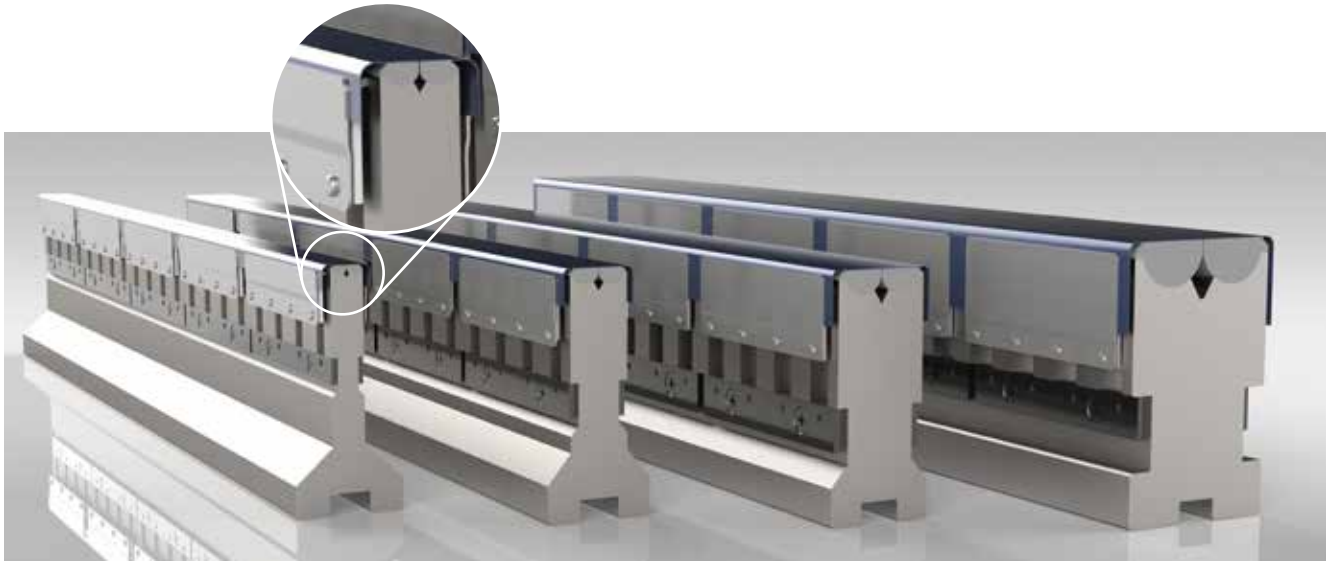
Length **200 mm**

Length **100 mm**

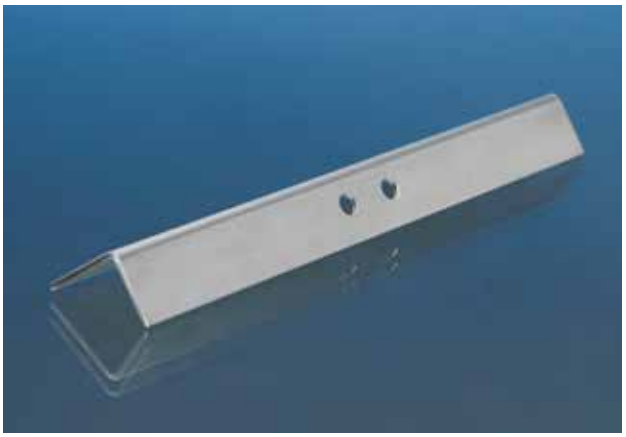
Length **50 mm**

Length **90 mm sectionalized**

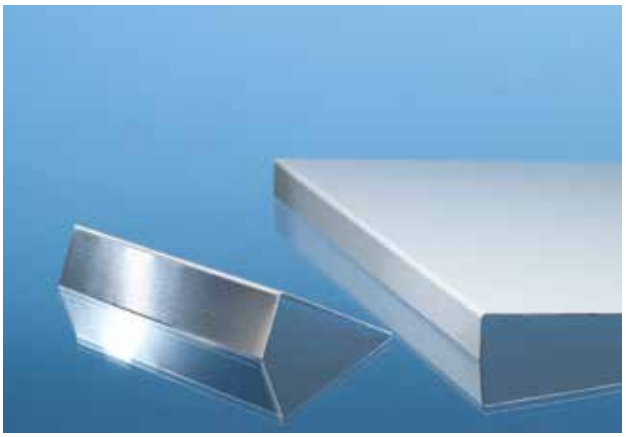
- Sectionalized dies are delivered as a complete set
- 4 Segments



Dies WingBend PLUS 62.120, 62.230, 62.350 and 62.650s (incl. Slider)



Holes near the bending line without deformation possible

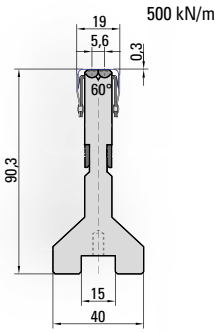


Anodized aluminium and polished stainless steel sheet with no visible bending marks on the surface

Dies WingBend PLUS

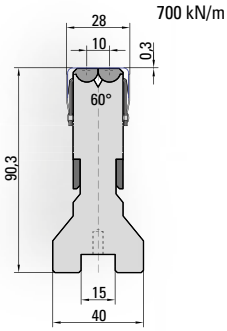
62.120		24h
500 mm	1.780,– €	5,5 kg
200 mm	892,– €	2,2 kg
100 mm	642,– €	1,1 kg
50 mm	350,– €	0,6 kg
90 mm sectionalized	1.402,– €	1,0 kg

Incl. Slider in particular tool length
Recommended material thicknesses:
R_m = 450 N/mm² max. 1,2 mm
R_m = 700 N/mm² max. 1,0 mm



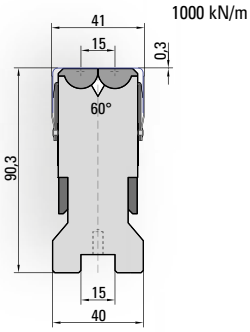
62.230		24h
500 mm	1.944,– €	8,0 kg
200 mm	918,– €	3,2 kg
100 mm	656,– €	1,6 kg
50 mm	370,– €	0,8 kg
90 mm sectionalized	1.474,– €	1,5 kg

Incl. Slider in particular tool length
Recommended material thicknesses:
R_m = 450 N/mm² max. 2,3 mm
R_m = 700 N/mm² max. 1,5 mm



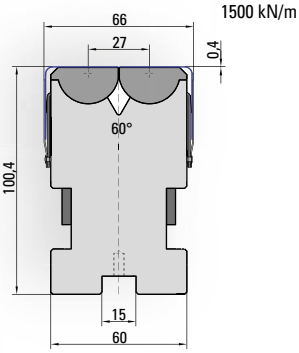
62.350		24h
500 mm	2.104,– €	8,8 kg
200 mm	1.184,– €	4,1 kg
100 mm	854,– €	2,1 kg
50 mm	462,– €	1,1 kg

Incl. Slider in particular tool length
Recommended material thicknesses:
R_m = 450 N/mm² max. 3,5 mm
R_m = 700 N/mm² max. 2,5 mm



62.650s		24h
500 mm	3.010,– €	18,0 kg
200 mm	1.250,– €	7,2 kg
100 mm	880,– €	3,6 kg
50 mm	486,– €	1,8 kg

Incl. Slider in particular tool length
Recommended material thicknesses:
R_m = 450 N/mm² max. 6,5 mm
R_m = 700 N/mm² max. 4,0 mm



UKB-TEST BENDING

First test bending - then order!
Free of charge - with your sample sheets in your or our house!

VIDEO

UKB-UniBend and UKB-WingBend PLUS

Lubricating grease

40.629	24h
100 ml	26,– €

For lubrication of WingBend PLUS dies

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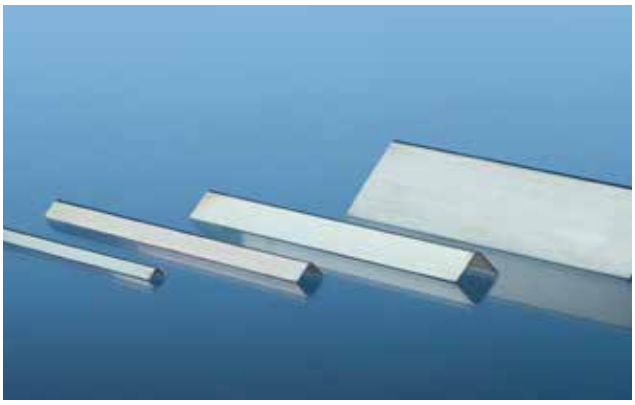
Slider for WingBend PLUS

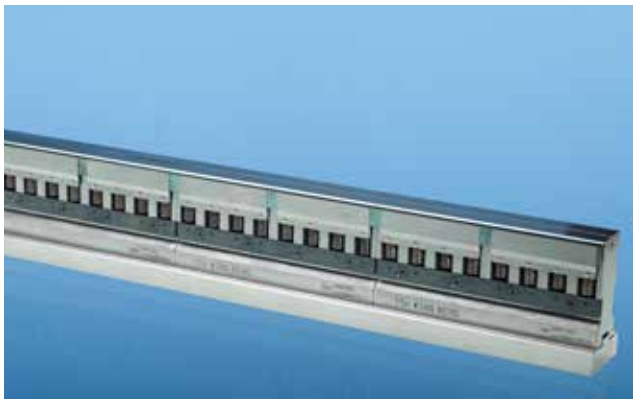
- Avoids bending marks on sheets
- Continously slider in favoured lengths up to 2000/3000 mm available
- Slider for model 62.120 up to a length of 2000 mm available in one piece
- Slider for models 62.230, 62.350, 62.650s up to a length of 3000 mm available in one piece

UKB-INFO

Prices on request or visit www.ukb-gmbh.com



Slider for WingBend PLUS



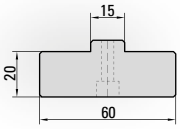
Dies WingBend PLUS with continously Slider

Die holders

UKB-SYSTEM AMADA

60.102		24h
499 mm	140,– €	5,2 kg
198 mm	82,– €	2,0 kg
98 mm	54,– €	1,0 kg
48 mm	38,– €	0,5 kg
90 mm sectionalized	130,– €	0,9 kg

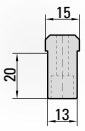
Screwed on holder



UKB-SYSTEMS TRUMPF/WILA/BYSTRONIC

60.103		24h
499 mm	120,– €	1,5 kg
198 mm	52,– €	0,6 kg
98 mm	46,– €	0,3 kg
48 mm	44,– €	0,2 kg
90 mm sectionalized	136,– €	0,3 kg

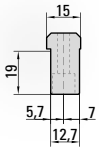
Screwed on holder



UKB-SYSTEM LVD

60.105		24h
496 mm	120,– €	1,5 kg
198 mm	58,– €	0,6 kg
98 mm	52,– €	0,3 kg
48 mm	46,– €	0,2 kg
90 mm sectionalized	154,– €	0,3 kg

Screwed on holder



UKB-INFO

More die holders available!
Prices and delivery times on request!

Technical data

Table of force: Tensile strength R_m = 450 N/mm², bending angle 90°

Model	62.120		62.230			62.350			62.650s			
Radius of the punch/top tool	R 0,2	R 1,0	R 0,2	R 1,0	R 3,0	R 0,2	R 1,0	R 3,0	R 1,0	R 3,0	R 5,0	R 10,0
Material thickness 0,3 mm	40	50	40	50	50							
Material thickness 0,5 mm	50	60	50	50	50	40	40	40	100	100	100	220
Material thickness 0,8 mm	100	130	70	80	90	40	50	50	100	110	130	230
Material thickness 1,0 mm	150	190	80	100	130	60	60	70	120	120	140	250
Material thickness 1,2 mm	240	300	110	140	180	70	70	80	120	120	150	270
Material thickness 1,6 mm			200	220	250	120	130	140	120	130	160	280
Material thickness 2,0 mm			300	330		190	200	220	130	140	160	360
Material thickness 2,3 mm			400	420		240	240	260	140	150	190	390
Material thickness 2,6 mm						340	360	470	190	200	240	510
Material thickness 3,2 mm						550	660		270	280	310	
Material thickness 4,0 mm									430	440	510	
Material thickness 4,6 mm									530	540	660	
Material thickness 6,0 mm									1000	1070		

Reference value for minimum flange: Mild steel

Model	62.120		62.230		62.350	62.650s	
Radius of the punch/top tool	R 0,5	R 1,0	R 0,5	R 1,0	R 1,0	R 1,0	R 4,0
Material thickness 0,5 mm	2,7	2,9					
Material thickness 0,8 mm	3,2	3,4	4,7	4,9	5,6		
Material thickness 1,0 mm	3,5	3,6	5,4	5,5	7,1	7,7	7,2
Material thickness 1,5 mm			6,0	6,1	8,1	8,2	9,2
Material thickness 2,0 mm			6,4	6,6	8,3	10,4	10,9
Material thickness 2,5 mm					8,9	11,7	12,3
Material thickness 3,0 mm					9,4	13,3	13,9
Material thickness 4,0 mm						15,1	15,8
Material thickness 5,0 mm						16,1	16,3

Table of force and reference values for stainless steel and aluminium on our Website: www.ukb-gmbh.com or give us a call: Phone +49 27 36 / 44 42 - 0

The comparison: Bending results with WingBend PLUS and standard-V-die

UKB-ADJUSTABLE DIES

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Dust protection film 173

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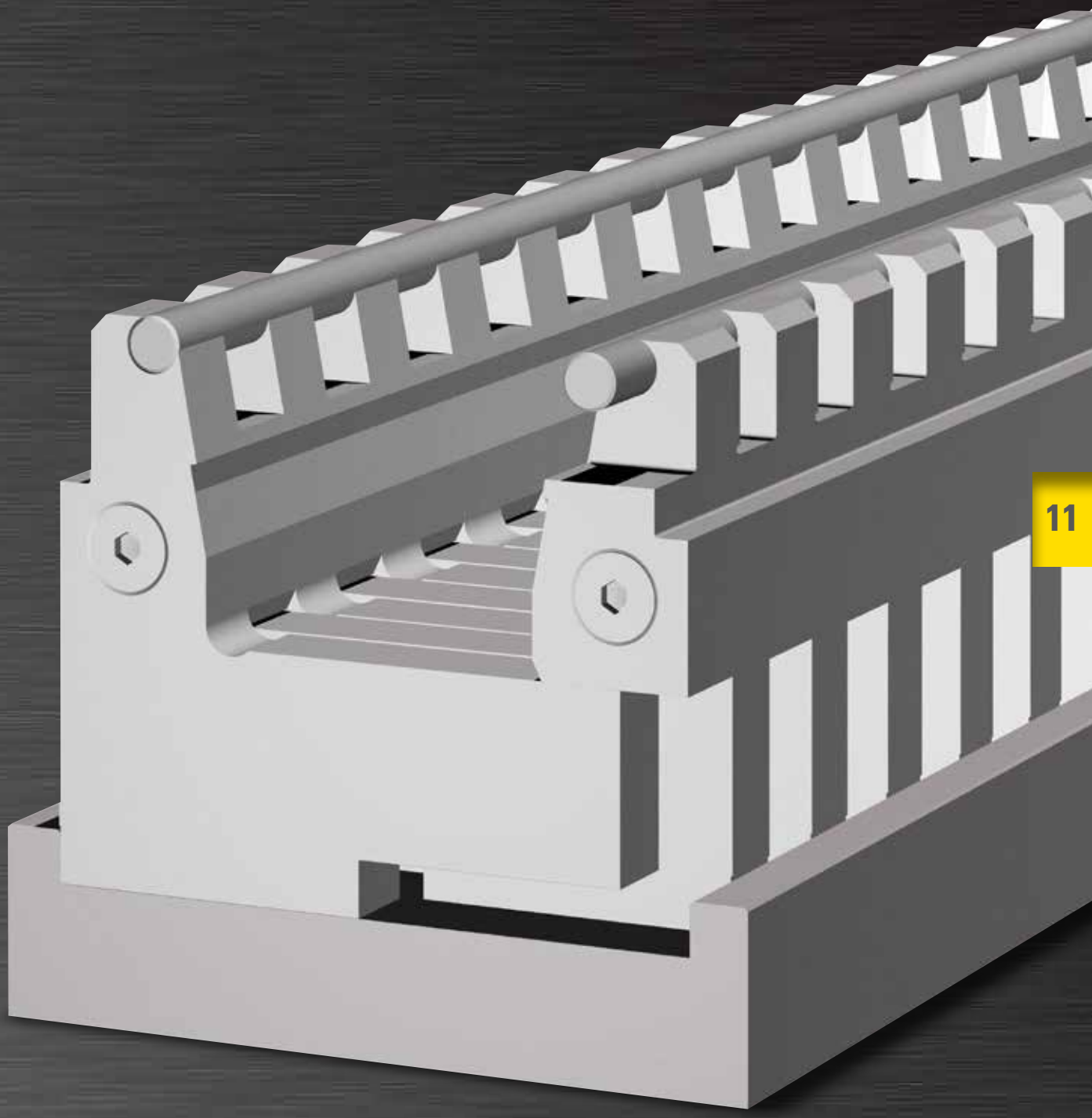

11

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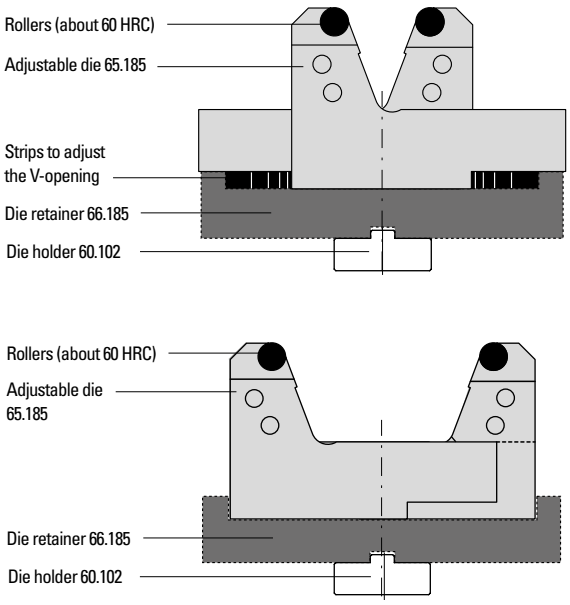
Quality and precision

- Optimum materials
- Precision ground
- Guaranteed exchangeability and parallelism

EXAMPLE OF USE

Minimum and maximum V-opening



Product advantages

- Variable adjustable V-openigs
  - V = 25 – 125 mm
  - V = 65 – 185 mm
  - V = 120 – 300 mm
  - V = 150 – 400 mm
- V-openings fast and easy adjustable via change of the strips
- Less setup time through less die changes
- Usable for materials with high resistance
- Through rotating and hardened rollers (about 60 HRC):
  - Mark reduced bending
  - Less press capacity needed (up to 30% less)
  - High lifetime
- Minimum maintenance costs through changeable components
- Via die holder directly applicable on all press brakes

VIDEO

UKB-Adjustable dies

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Delivery time:** UKB-Adjustable dies in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

  Standard: 1 – 3 working days by parcel service or forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

  Direct courier: According agreement
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO

Image

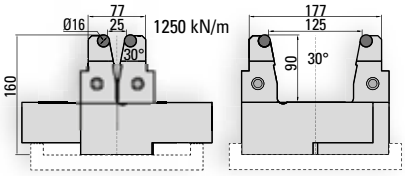
Adjustable dies

65.125 24h

Length	Price	Weight
250 mm	748,– €	34,0 kg
500 mm	1.372,– €	64,0 kg
1000 mm	2.580,– €	125,0 kg

- **V = 25 –125 mm**
- α = max. 30°
- Radius of the rollers R = 8 mm
- Recommended material thickness: About 3 – 15 mm at a tensile strength R_m = 450 N/mm²

1250 kN/m max. at 90°

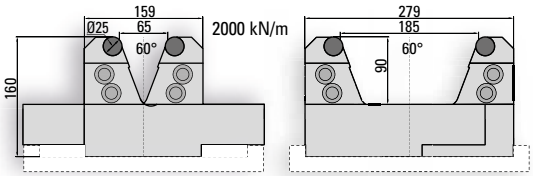


65.185 24h

Length	Price	Weight
250 mm	916,– €	44,0 kg
500 mm	1.716,– €	86,0 kg
1000 mm	3.202,– €	170,0 kg

- **V = 65 – 185 mm**
- α = max. 60°
- Radius of the rollers R = 12,5 mm
- Recommended material thickness: About 6 – 20 mm at a tensile strength R_m = 450 N/mm²

2000 kN/m max. at 90°

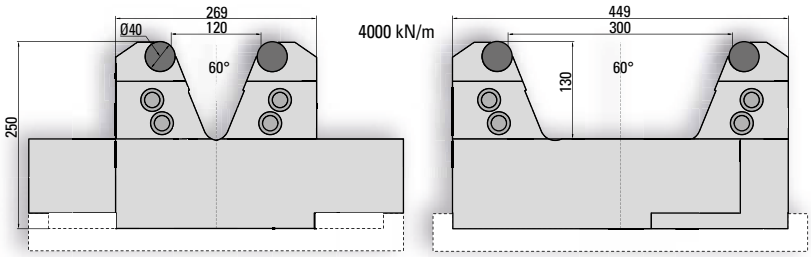


65.300 24h

Length	Price	Weight
600 mm	3.056,– €	360,0 kg

- **V = 120 – 300 mm**
- α = max. 60°
- Radius of the rollers R = 20 mm
- Recommended material thickness: About 8 – 30 mm at a tensile strength R_m = 450 N/mm²

4000 kN/m max. at 90°

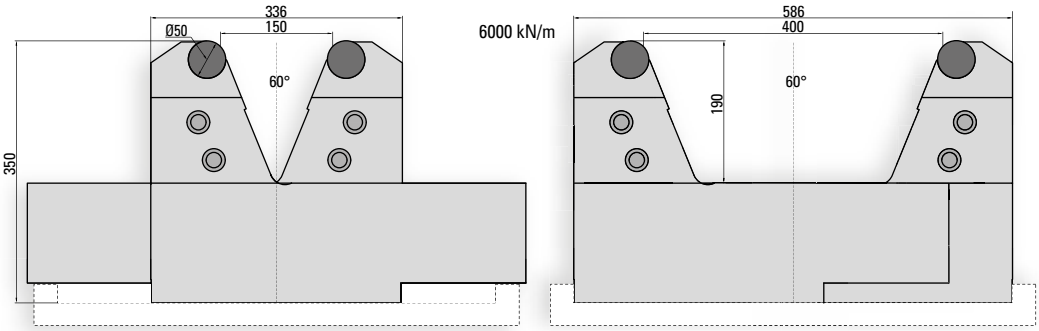


65.400 24h

Length	Price	Weight
600 mm	5.162,– €	560,0 kg

- **V = 150 – 400 mm**
- α = max. 60°
- Radius of the rollers R = 25 mm
- Recommended material thickness: About 10 – 50 mm at a tensile strength R_m = 450 N/mm²

6000 kN/m max. at 90°



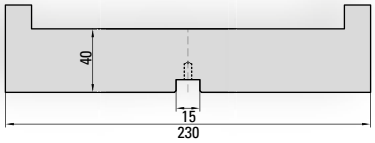
UKB-ADJUSTABLE DIES

Die retainers for adjustable dies 65.125 and 65.185

66.125 24h

500 mm	308,– €	38,0 kg

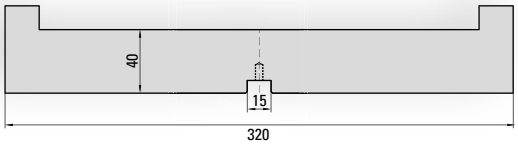
For Model 65.125



66.185 24h

500 mm	424,– €	53,0 kg

For Model 65.185



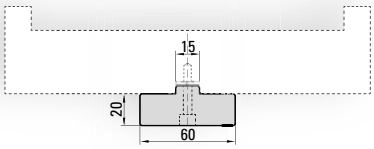
Die holders

UKB-SYSTEM AMADA

60.102 24h

499 mm	140,– €	5,2 kg

Srewed on die holder

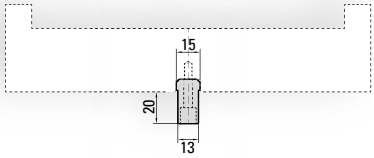


UKB-SYSTEMS TRUMPF/WILA/BYSTRONIC

60.103 24h

499 mm	120,– €	1,5 kg

Srewed on die holder

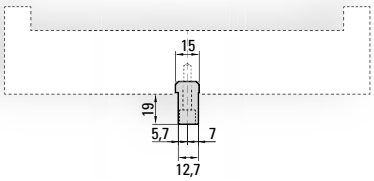


UKB-SYSTEM LVD

60.105 24h

496 mm	120,– €	1,5 kg

Srewed on die holder



UKB-TEST BENDING

First test bending - then order!
Free of charge - with your sample sheets in your or our house!

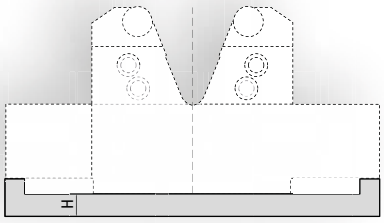
UKB-INFO

Die holders UKB-System EHT, UKB-System Weinbrenner and other Systems available!
Prices and delivery times on request!

Individual die retainer for adjustable dies 65.300 and 65.400

Individual die retainer after your specifications suitable for your press brake

Delivery time on request

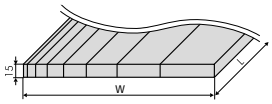


Strips to adjust the V-opening width

66.000 H = 15 24h

Length (L)	Price	Weight
500 mm	140,– €	21,0 kg

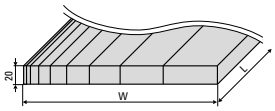
For model 65.125 and 65.185
Strips in a set:
Width = 2 x each 2/5/10/15/20/30/40/50 mm



66.000 H = 20

Length (L)	Price	Weight
600 mm	232,– €	45,0 kg

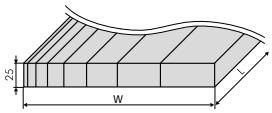
For model 65.300
Strips in a set:
Width = 2 x each 2/5/10/15/20/30/40/50/60 mm
Delivery time on request

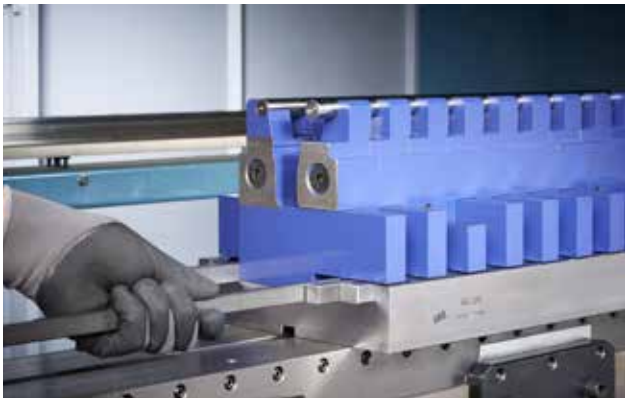


66.000 H = 25

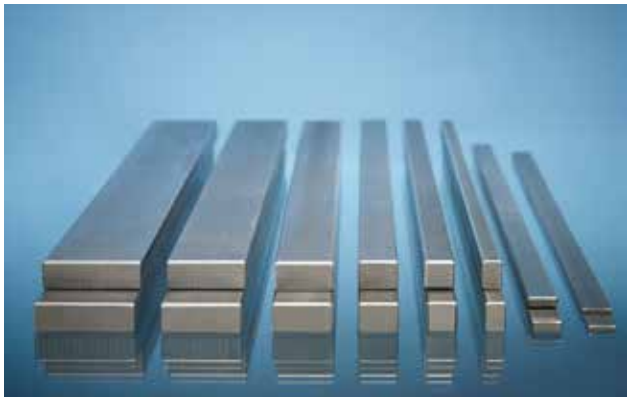
Length (L)	Price	Weight
600 mm	270,– €	55,0 kg

For model 65.400
Strips in a set:
Width = 2 x each 5/10/15/20/30/40/50/60 mm
Delivery time on request





Variable adjustable V-openings



Strips to adjust the V-openings

UKB-INFO

Other lengths up to 3000 mm available.
Prices and delivery times on request!

Dust protection film

PRODUCT ADVANTAGES

- ▶ Protects the inside of the die
- ▶ No blockade of the die through tinder, dust, etc.
- ▶ Adjustment via hook-and-loop tape

UKB-INFO

The use of the dust protection film is recommended!

Dust protection film 24h

Model	For Model	Length	Price	Weight
67.125	65.125	5 m	86,– €	1,0 kg
67.185	65.185	5 m	92,– €	1,0 kg
67.300	65.300	5 m	102,– €	1,0 kg
67.400	65.400	5 m	112,– €	1,0 kg

UKB-SPECIAL TOOLS

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Louvre tools 190
Beading tools for long beadings 191
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Radius embossing tools 193
Trapezoidal bending tools 194
Flattening tools 195

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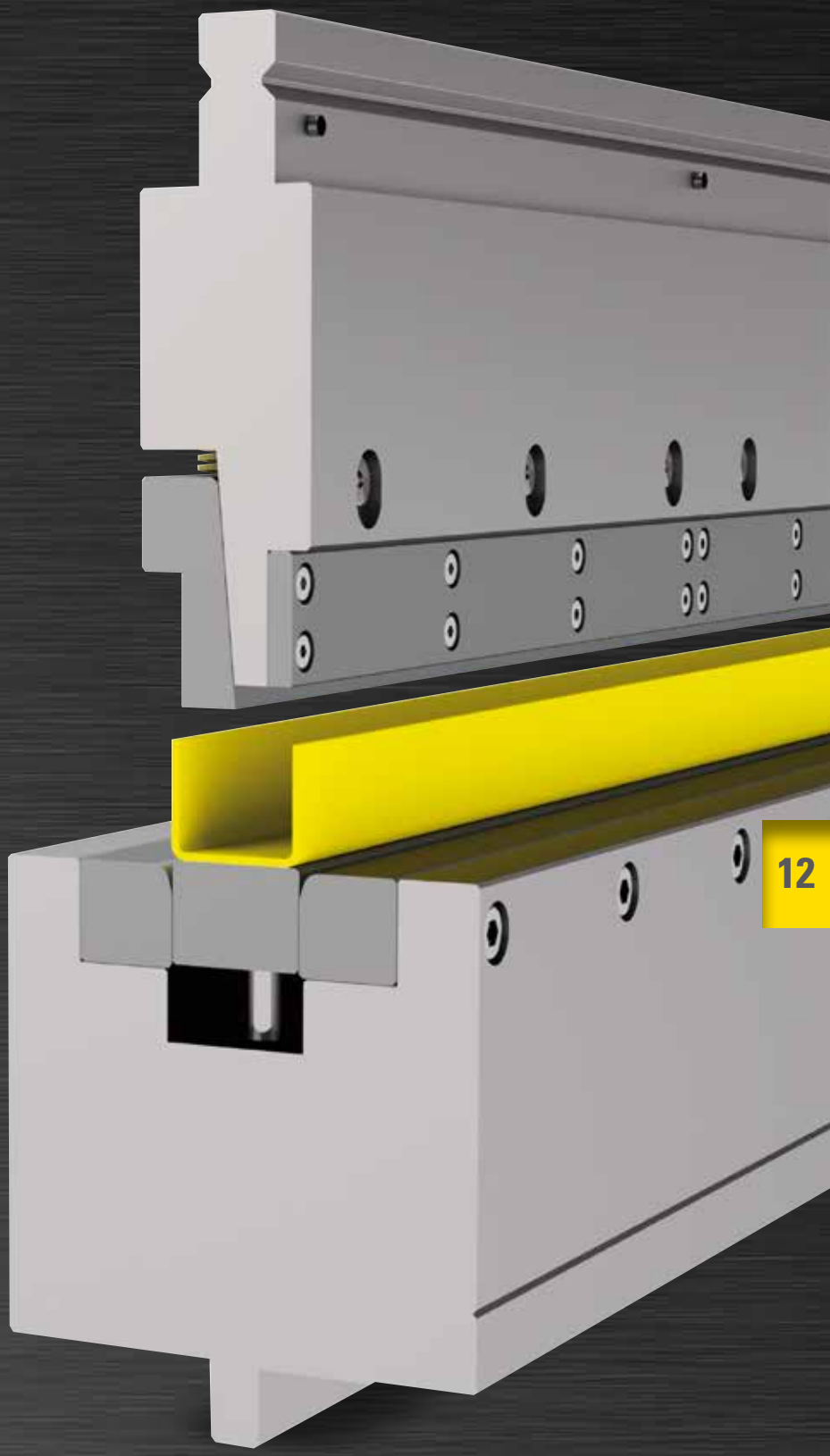

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Quality and precision

- Use of optimum materials, hardened according to the operation purpose, polished and coated
- Surfaces ground or fine milled
- Use of pneumatic and electronic components possible
- Technical documentation
- Extensive quality tests
- Tool marking with all technical information

VIDEO

UKB-Special tools

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- **Full service:** Construction, development, production
- **Machinery:** State of the art CNC-machining centers
- **Production possibilities:** Up to 6000 mm tool length
- **Know-How:** Well-trained experts for special tools
- **Technical equipment:** Latest CAD/CAM Software
- **Test bending:** Functional test in accordance with your sample sheets
- **Package:** Ecologically sensitive and safe - with self recycled packing material
- **Payment terms:** 10 Days 3% cash-discount, 30 days net

VIDEO

Image

Quality and precision

Due to permanent investments in the latest production technology we develop individual tool solutions for the most demanding applications. Individual customer support is at the center of all projects at UKB. From consultation and development, through construction and production until delivery – everything is done in-house.
The UKB-teamplayers want you to be fascinated, not just satisfied.

Following a short extract of our special tool portfolio:

- **U-bending tools**
- **Z-Tools**
- **Two-station tools**
- **Hinge tools**
- **Beading tools**
- **Louvre tools**
- **Beading tools for long beadings**
- **Embossing-tools**
- **Trapezoidal bending tools**
- **Flattening tools**

The perfect special tool for your application – Challenge us!

UKB-CONTACT PARTNER

You will find your personal contact partner at
www.ukb-gmbh.de/en/contact/contact-persons

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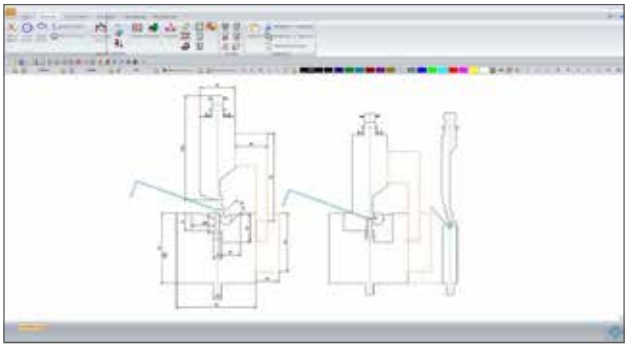
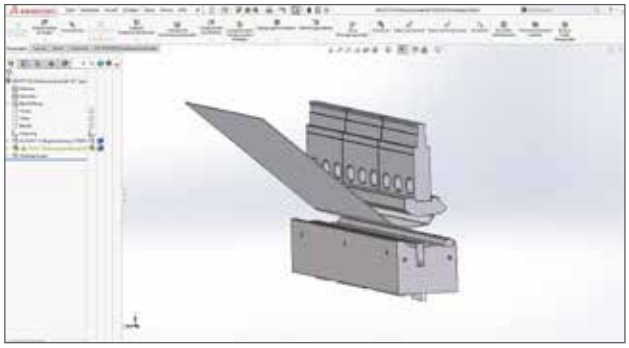
UKB-Full service for special tools

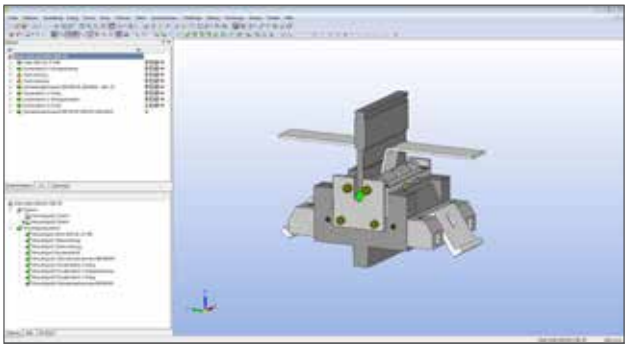
CONSTRUCTION AND DEVELOPMENT



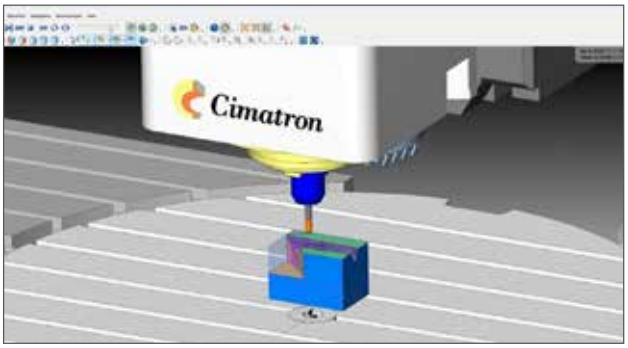
Software MEGACAD 2D/3D



Software SolidWorks 3D



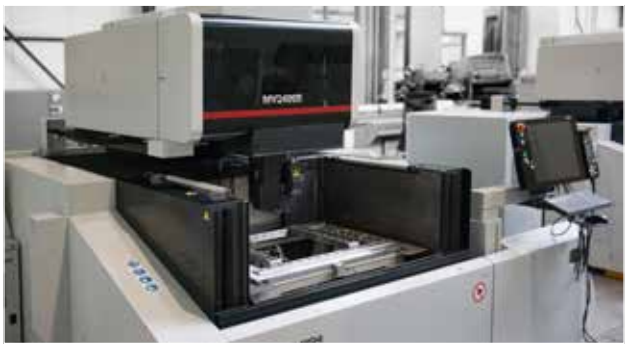
Software CIMATRON 3D



Software CIMATRON 3D NC programming

After receiving the order the offered concept will be specified and will be presented to you by a drawing for acceptance/model. After the approval we prepare the production plans and drawings.

WIRE ERODING



TECHNICAL INFORMATION:

- 2 Wire eroding machines
- Traverse path:
  X = 600 mm
  Y = 400 mm
  Z = 300 mm

To determine the optimum bending contour, a sample tool will be produced. After sampling took place this contour will be transmitted to the serial tool.

UKB-Full service for special tools

CNC-MILLING

TECHNICAL INFORMATION:

- 18 CNC-milling machines
- Traverse path:
  X = 6.000 mm
  Y = 1.250 mm
  Z = 1.600 mm
- Simultaneous 5-axis processing
- Fully programmable b-axis +- 100°
- Rotary table Ø1050 mm

The components are machined according to the production drawing on our CNC-milling machines.
Using 5-axis processing even complex tool contours can be produced.
With the latest machines to the best results!

CNC-GRINDING

TECHNICAL INFORMATION:

- 5 CNC-profile grinding machines
- 2 CNC-flat grinding machines
- Traverse path:
  X = 5.000 mm
  Y = 800 mm
  Z = 700 mm

The bending contour and the active surfaces of the special tool will be precision ground.
For precise tasks we are perfectly equipped!

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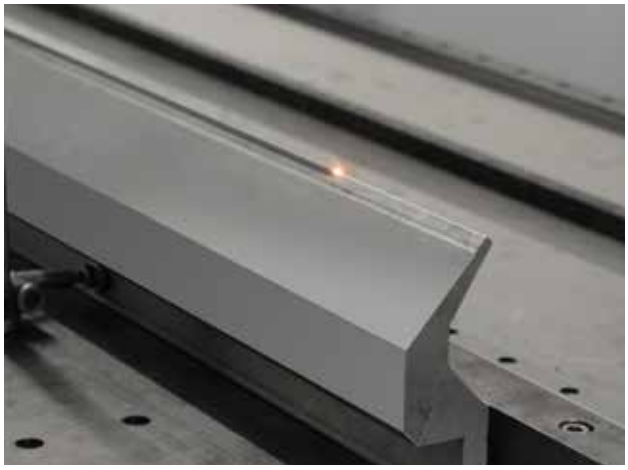
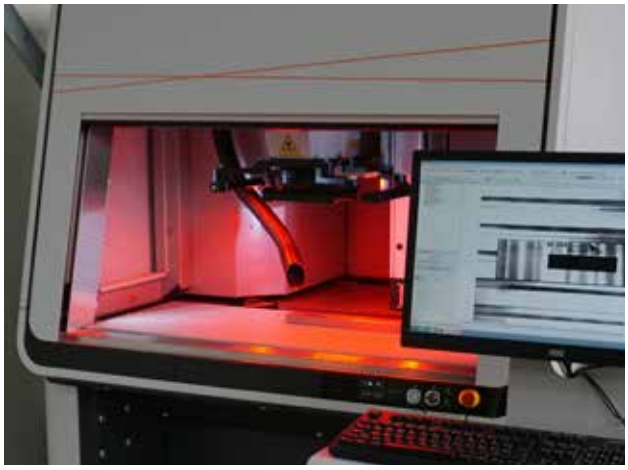
UKB-Full service for special tools

LASER HARDENING



In accordance to the purpose, the tools will be laser hardened, through hardened or nitrated.

LASER MARKING



Customer-specific marking such as internal tool-numbers, can be realised flexible.

ASSEMBLY OF THE SPECIAL TOOL

The single componets will be assembled and aligned to each other.

UKB-Full service for special tools

TEST BENDING

Finally the functional test will be done with your sample sheets.
Test bendings will be performed on our press brake (L = 4050 mm, press force 3200 kN) at the UKB-test center.

QUALITY CHECK

The complete production process is accompanied by continuous quality controls, such as 3D-measuring and hardening tests.

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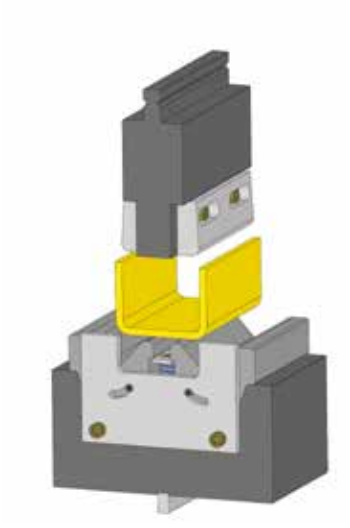
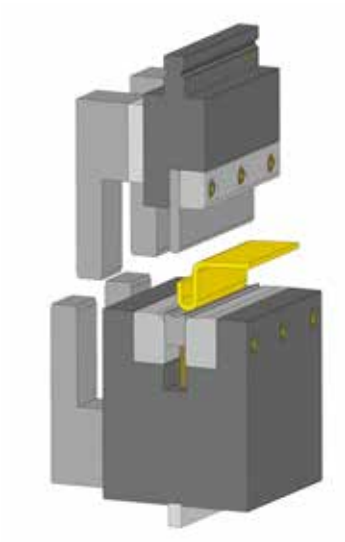
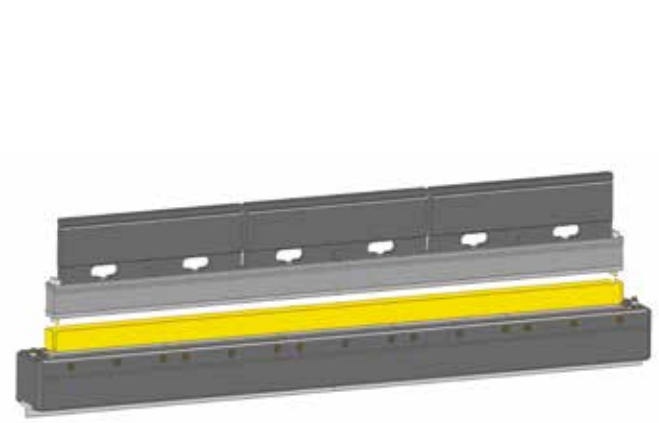
3D-models special tools



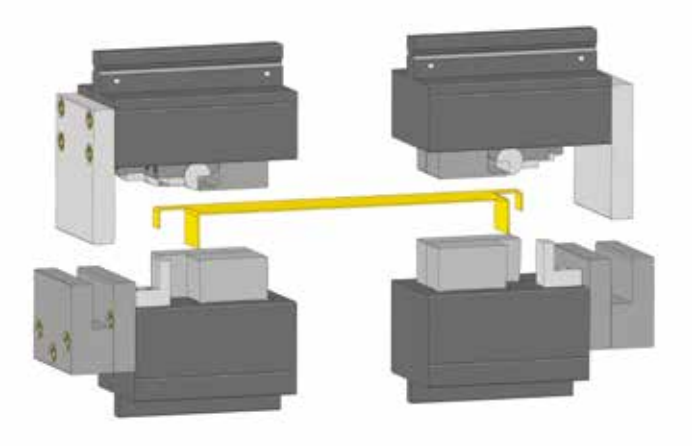
U-bending tool with rotating rollers



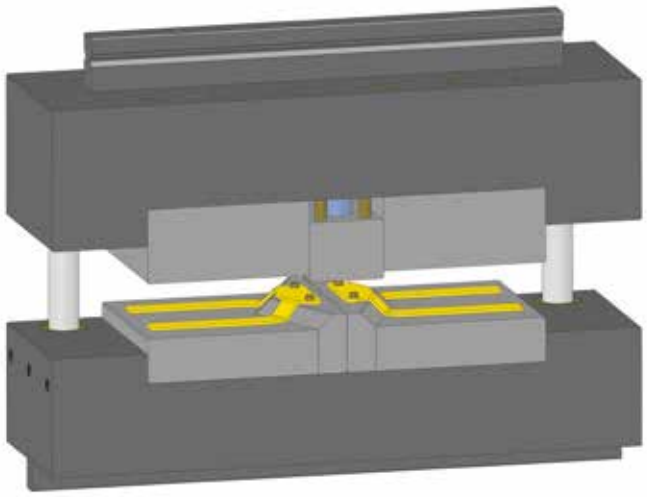
U-bending tool with back guide



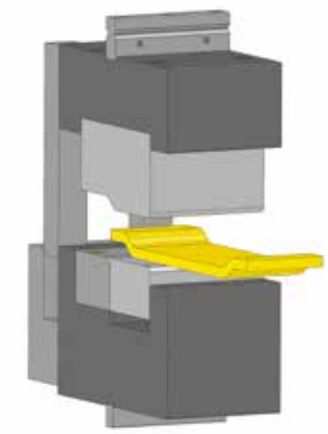
U-bending tools for all sided bending in one stroke



Forming tool with spring loaded hold-down device and rotating rollers to produce four 90° bendings in one stroke

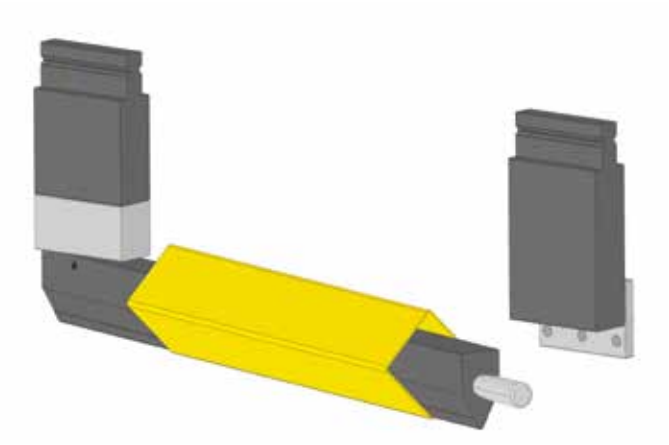


Pillar guided Z-embossing tool with spring loaded hold-down device - two parts in one stroke

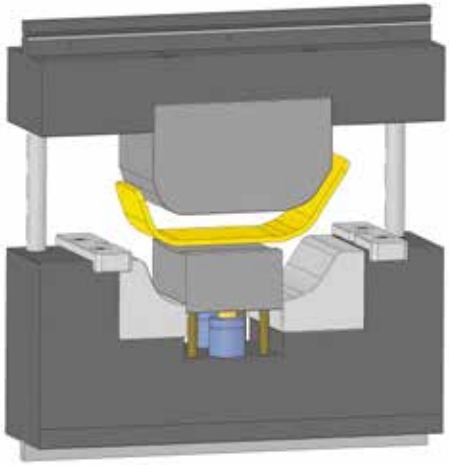


Z-embossing tool with back guide

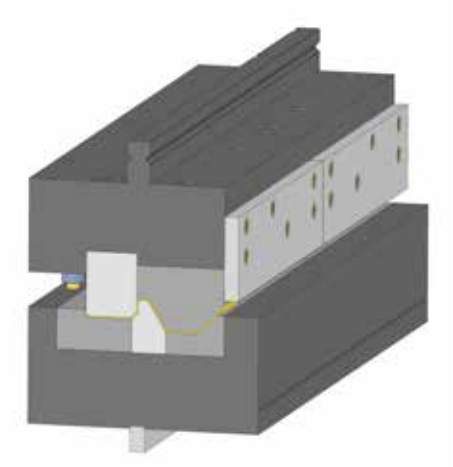
3D-models special tools



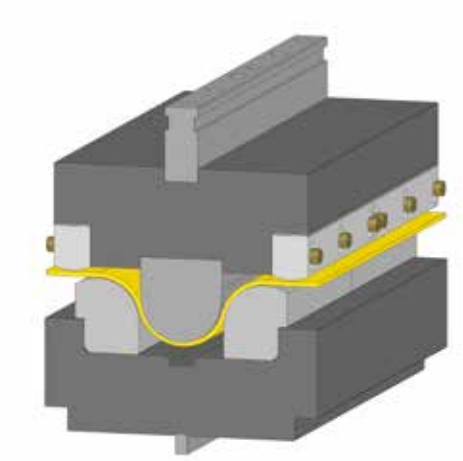
Special Rotax for production
of closed profiles



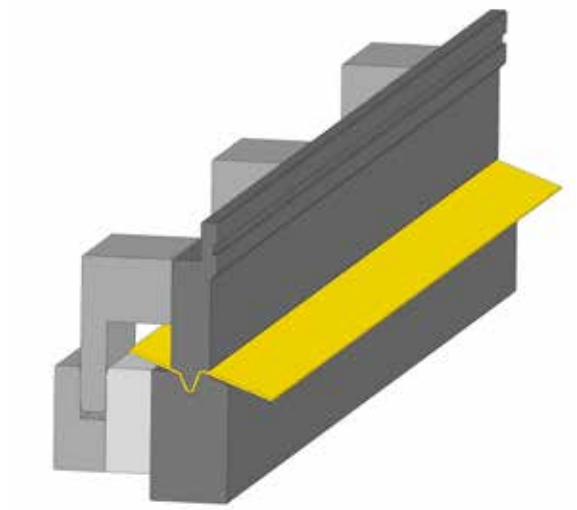
Pillar guided tool for bending
two different radii in one stroke



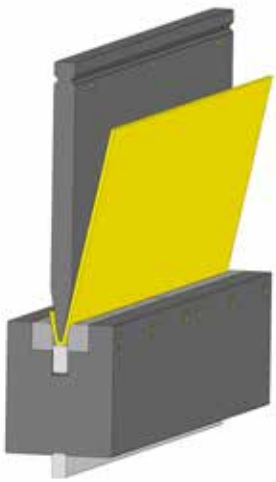
Multiple embossing tool



Round beading tool with
adjustable bending strips



Embossing toll with back guide
for asymmetrical V-contour



Tool for 20° profile with
spring loaded ejector

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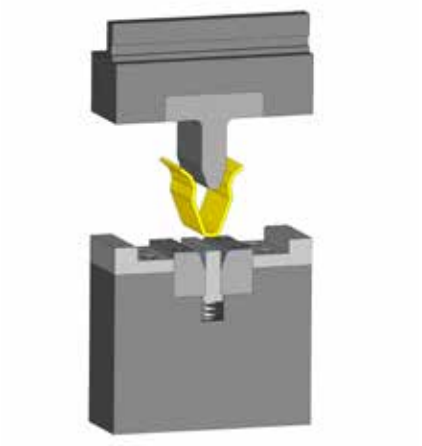
3D-models special tools

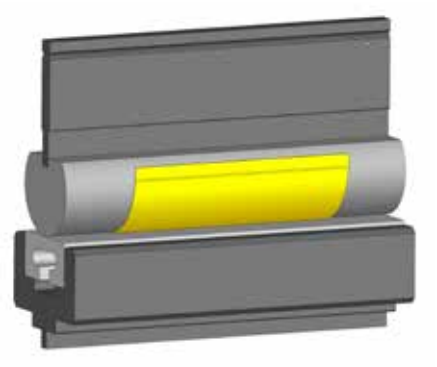
Two-station tool for V-profile production

Station 1: Embossing tool with lateral guide

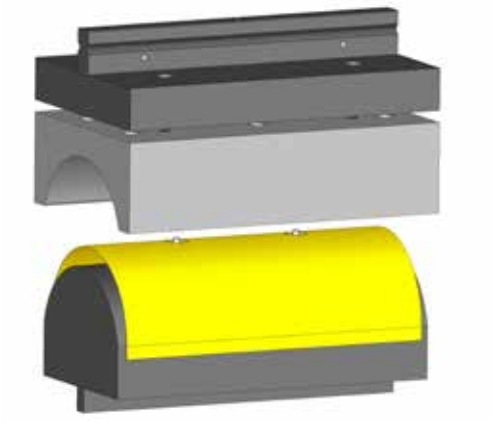


Station 2: U-bending tool with spring loaded ejector

Two-station tool for case cover production

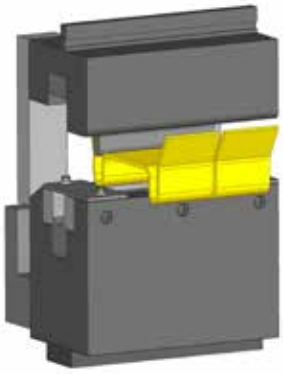


Station 1: Radius tool with PU-insert
for mark free bending of a 180° radius

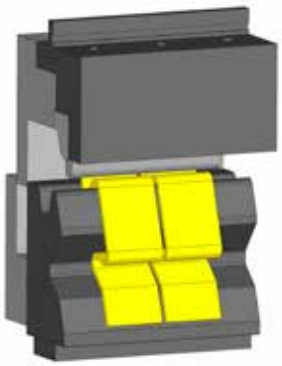


Station 2: Calibration tool with inserted embossing-stamps
for embossing two depressions in the radius at the same time

Two-station tool for production of a holder



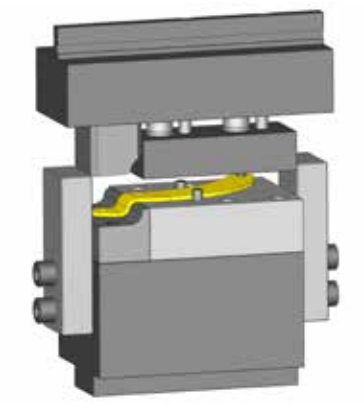
Station 1: U-bending tool with back guide
and spring loaded ejector



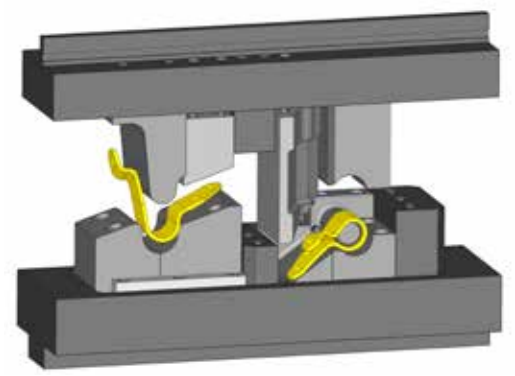
Station 2: V-embossing tool with back guide,
adjusted to the prior U-bending

3D-models special tools

Two-station tool for clamp production

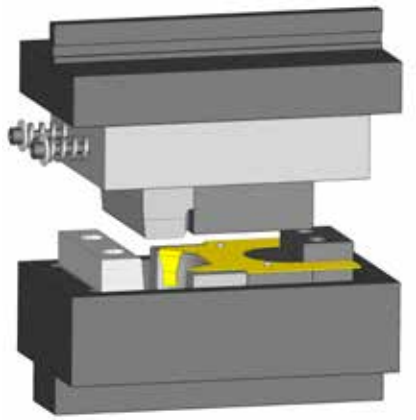


Station 1: Z-embossing tool for clamp shaping with spring loaded hold-down device and lateral support

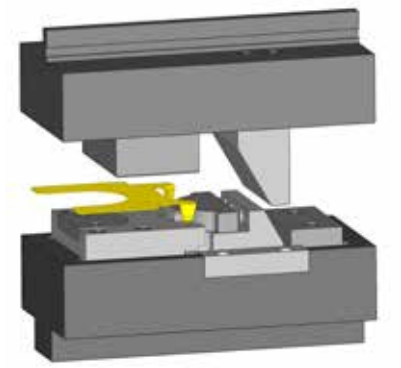


Station 2: Tool for embossing a radius (left) and roll into a clamp shape (right), with spring loaded hold-down devices and integrated supports

Two-station tool for production of a holding plate



Station 1: Embossing tool for two 90° flanges with 3D-contour



Station 2: Bending tool for folding of two short straps at the already bended flanges with the help of movable gate valves

VIDEO

UKB-Special tools

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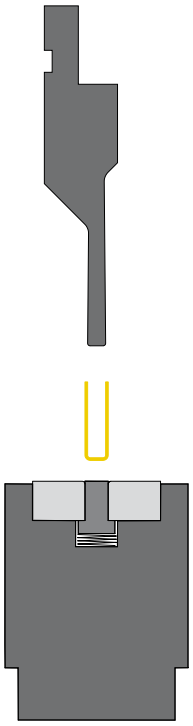
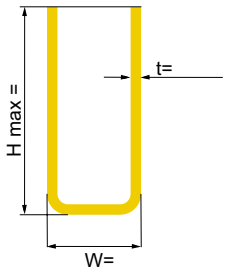
U-bending tools

ADVANTAGES

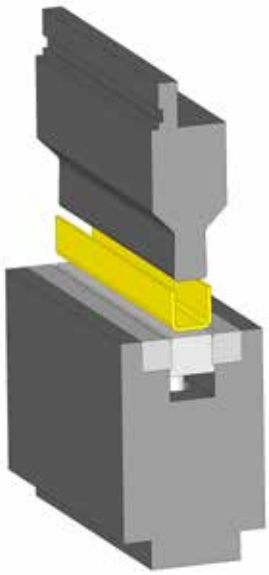
- Production in one step
- Easy removal of the profiles
- Small inside measurements with high flanges of the profiles possible
- Process stability
- Reducing of marks through spring loaded ejector
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets





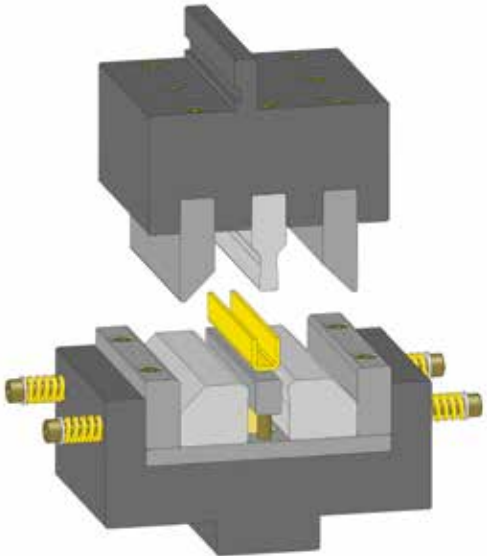
Examples for U-bending tools

- Other shapes and layouts are manufactured individually according to your specifications



U-bending tool with wide inner dimensions

U-bending tool with small inner dimension and cut-out for 90° bend

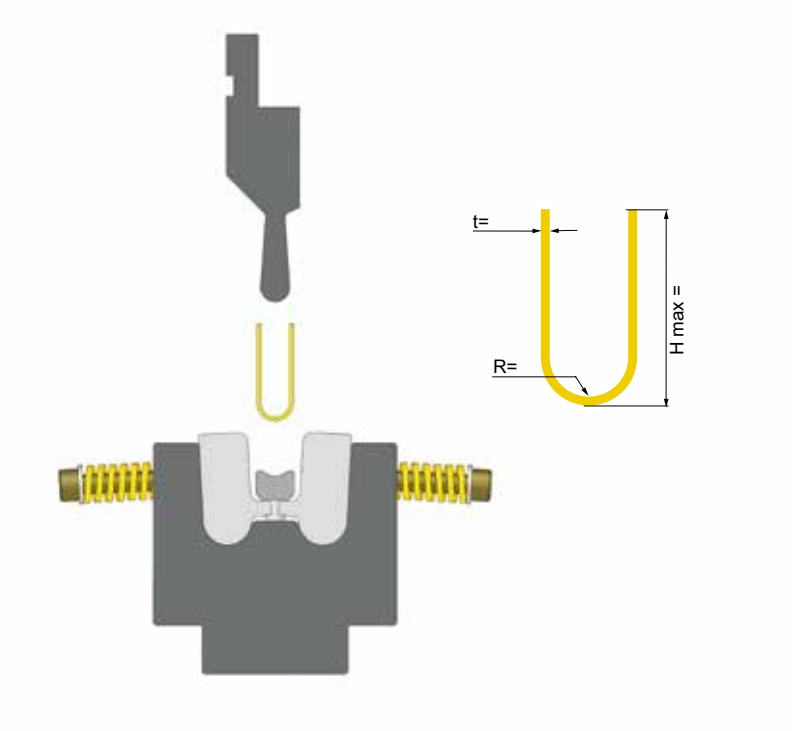


U-bending tool with gate valve technology, to compensate the spring-back of the material

U-bending tools with movable bending strips

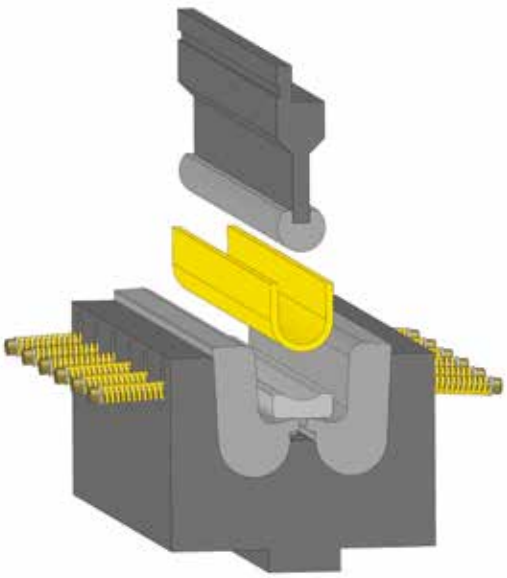
ADVANTAGES

- Production in one step
- Easy removal of the profiles
- Small inside measurements with high flanges of the profiles possible
- Process stability
- Movable bending strips to compansate the spring-back of the profiles
- Reducing of marks through spring loaded ejector or counterholder
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

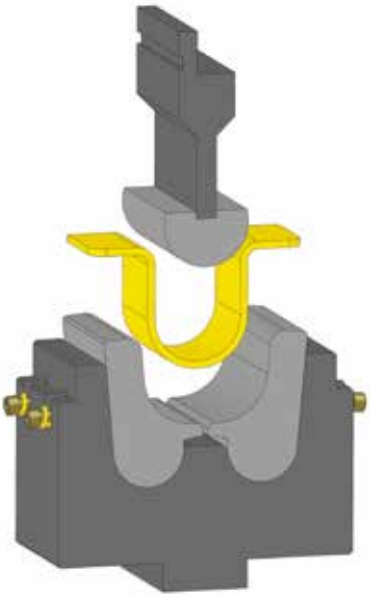


Examples for U-bending tools with movable bending strips

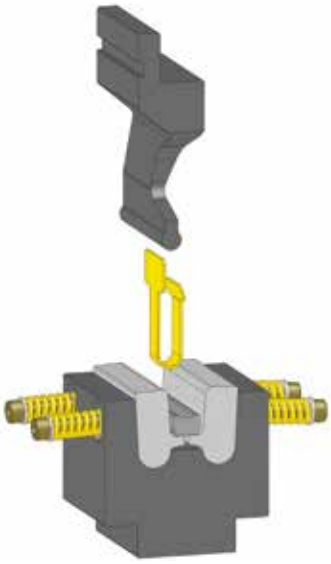
- Other shapes and layouts are manufactured individually according to your specifications



U-bending tool with strips
for overbending



U-bending tool with strips
for overbending
for big radius



U-bending tool with strips
for overbending
for small U-profile

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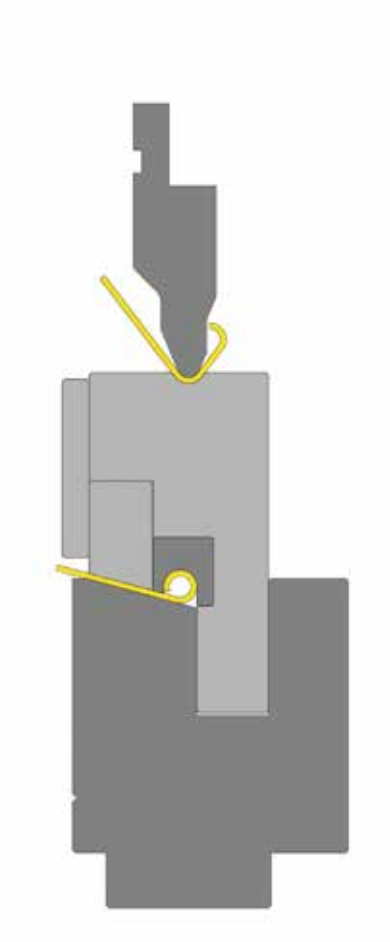
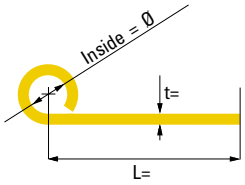
Hinge tools

ADVANTAGES

- Production in two or three strokes
- Reducing of marks through spring loaded hold-down-device
- Active components are hardened
- High repeatability through integrated backgauge
- Functional test and adjustment through test bends - with your sample sheets



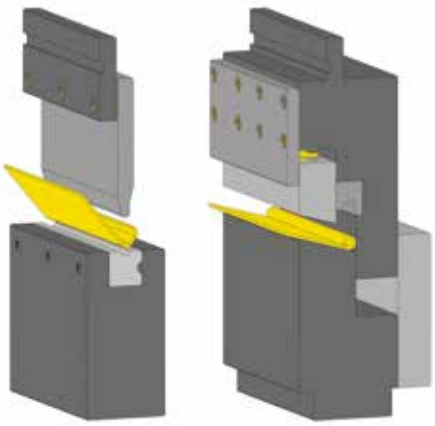


SUITABLE FOR

- Material thickness up to 4,0 mm
- minimum inside Ø:
  2,5 mm x material thickness for steel and aluminium
  3,0 mm x material thickness for stainless steel

Examples for hinge tools

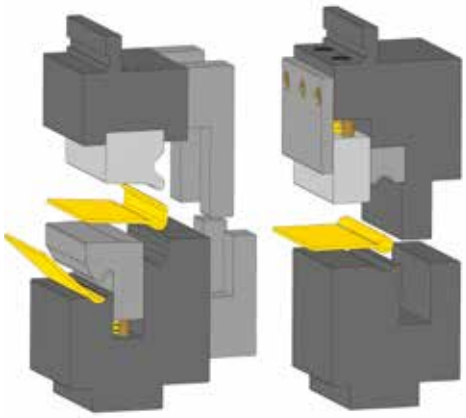
- Other shapes and layouts are manufactured individually according to your specifications



Two station hinge tool

Station 1:
Pre-bending of the profile in two strokes

Station 2:
Roll in the profile in one stroke



Pre-bending of the profile in two strokes

Station 1:
Pre-bending of the profile in two strokes

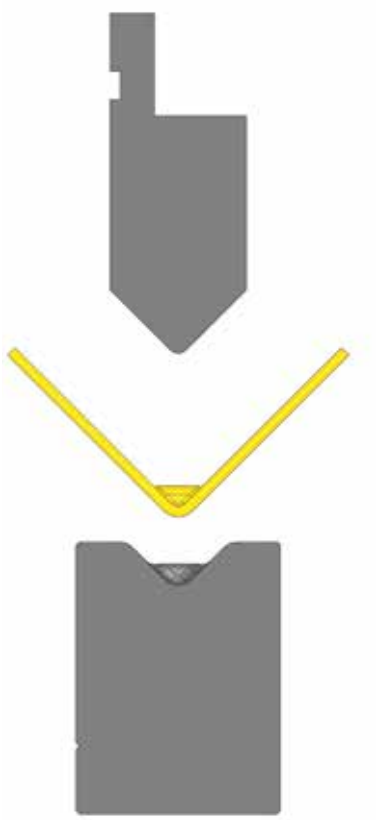
Station 2:
Roll in the profile in one stroke

Hinge tool for production in one station with two strokes

Beading tools

ADVANTAGES

- Production in one step
- All our constructions consider your materials resistance and yield stresses
- Transfer of freeform surfaces or 3D contours 1:1 from customer drawings or data sets
- Realization of the tools with integrated beadings adjusted to the sheet quality and thickness
- Design of angles, form and design of the beadings according to customer specification
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

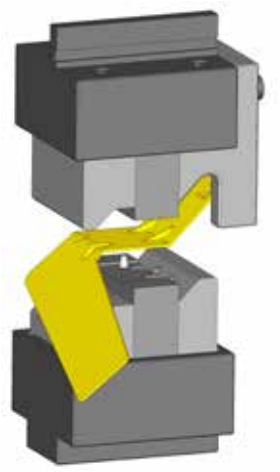


SUITABLE FOR

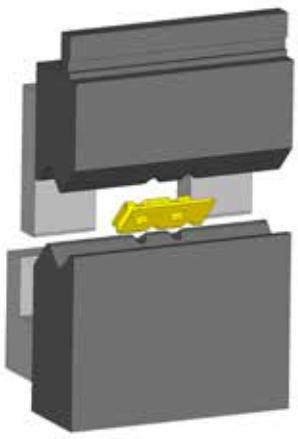
- Material thickness up to 5,0 mm
- All forms of beading independent of the bending angle

Examples for beading tools

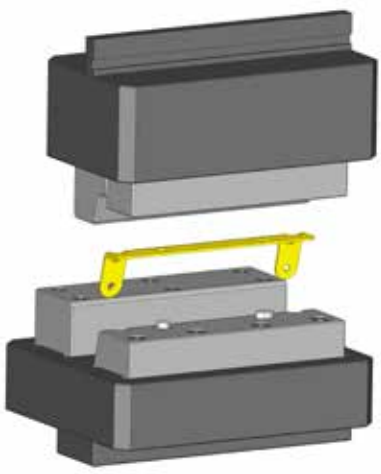
- Other shapes and layouts are manufactured individually according to your specifications



Special tool for Z-profile, guided and spring loaded, for four stiffening beads in one stroke



Special tool for Z-profile, back guided, for four stiffening beads in one stroke



Bead embossing tool for two beads near the bending line, with hold-down device and supports, in one stroke

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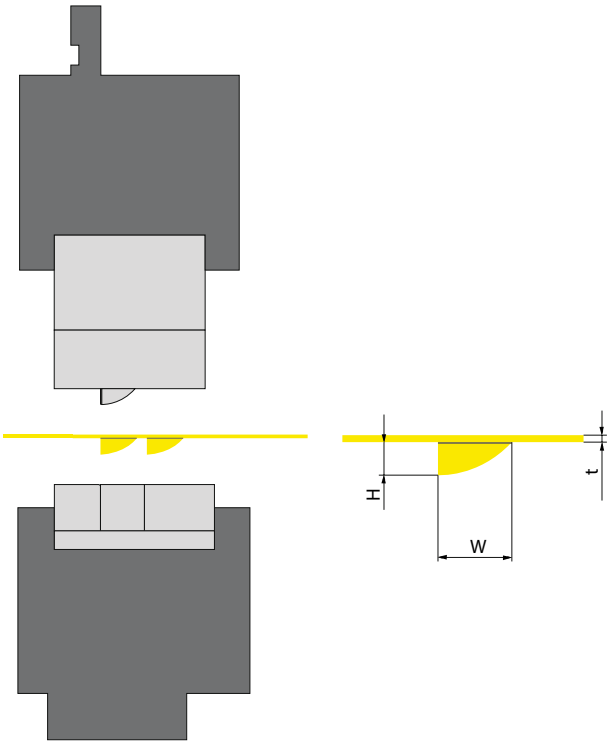
Louvre tools

ADVANTAGES

- Production in one stroke
- One tool suitable for different sheet thickness and materials
- Only minimum deformation of the sheet through spring loaded hold-down device
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

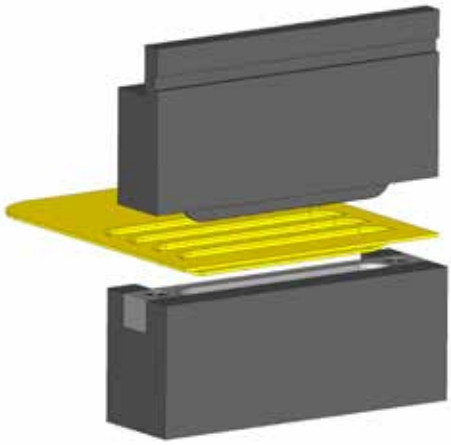


SUITABLE FOR

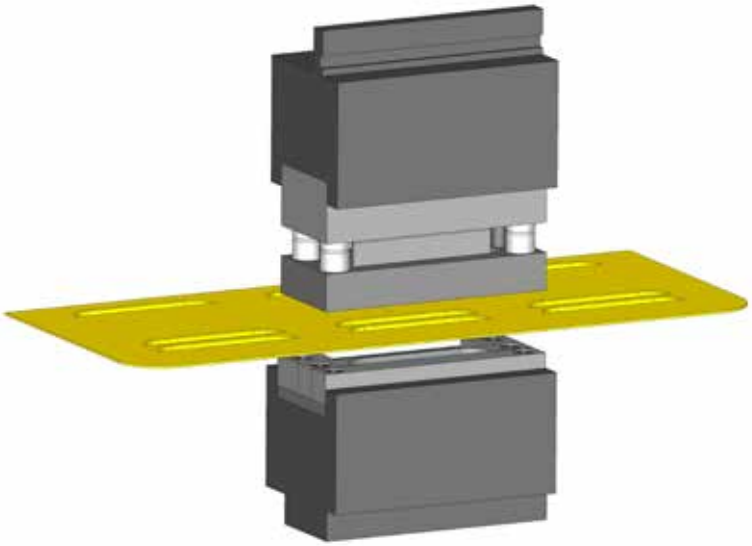
- Material thickness up to 4,0 mm
- Close-pitch adjacent air-slots

Examples for louvre tools

- Other shapes and layouts are manufactured individually according to your specifications



Louvre tool in simple design, without hold-down device

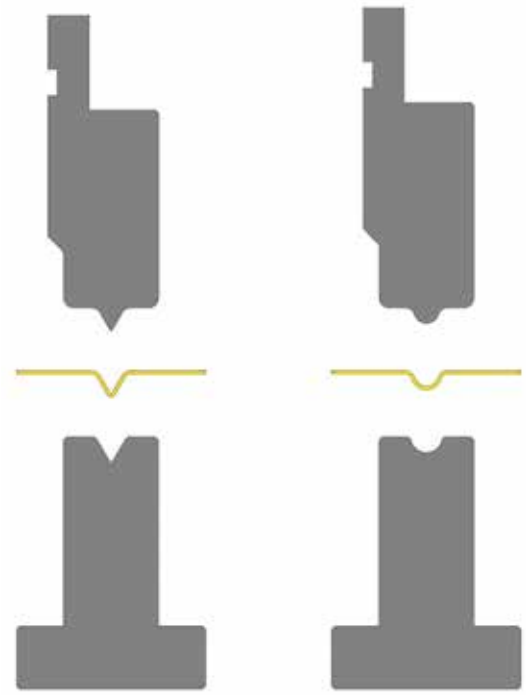


Louvre tool with spring loaded hold-down device, for minimum deformation of the sheet

Beading tools for long beadings

ADVANTAGES

- Production in one stroke
- One tool suitable for different sheet thickness and materials
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

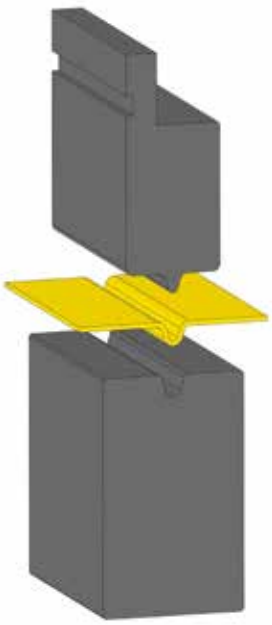


SUITABLE FOR

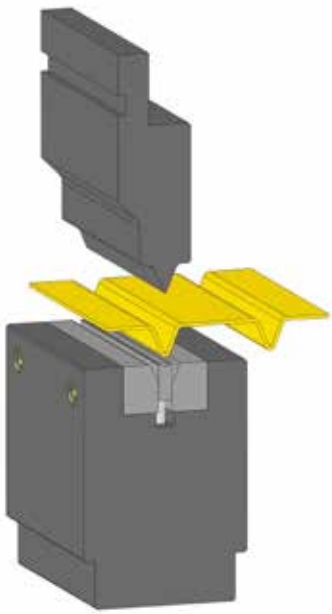
- Various material thicknesses, depending on the profile geometry and press force of your press brake

Tool for small round bead

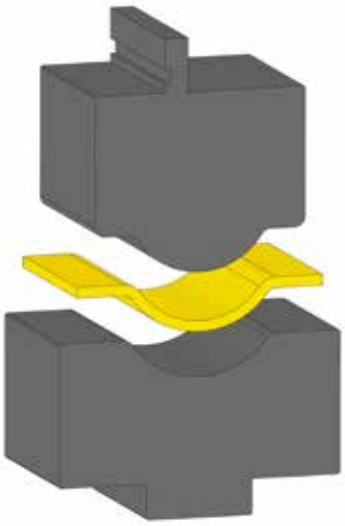
- Other shapes and layouts are manufactured individually according to your specifications



Tool for small round bead



Tool for long V-bead with spring loaded ejector



Tool for big round bead

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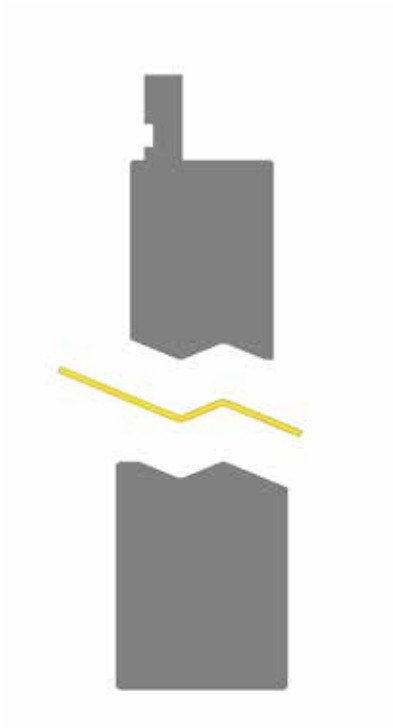
Z-bending tools

ADVANTAGES

- Production in one stroke
- One tool suitable for different sheet thicknesses and materials
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

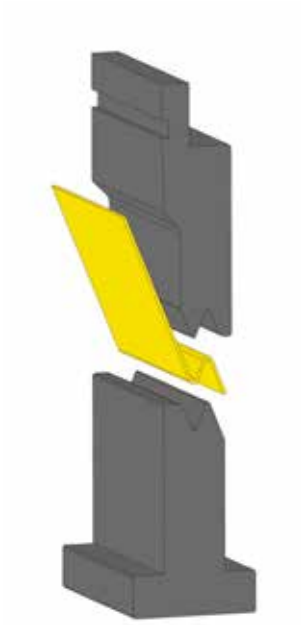


SUITABLE FOR

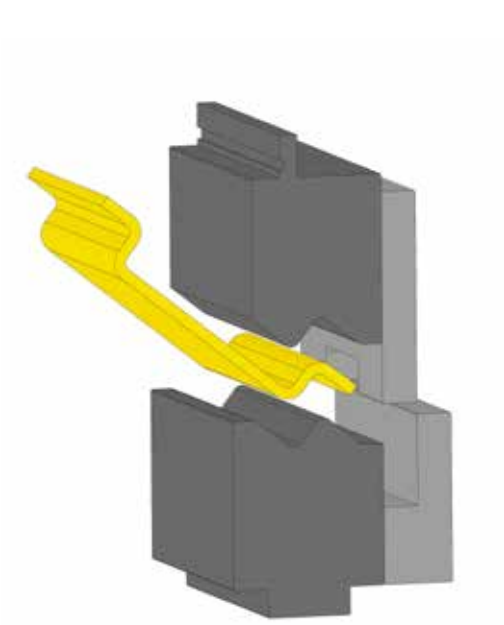
- Various material thicknesses, depending on the profile geometry and press force of your press brake

Examples for Z-bending tools

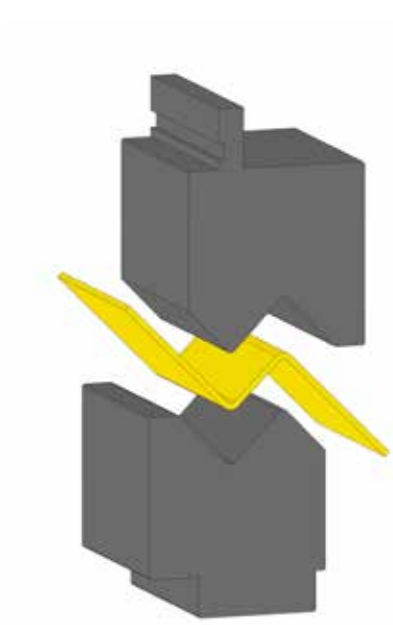
- Other shapes and layouts are manufactured individually according to your specifications



Z-bending tool
for thin materials
and sharp angles



Z-bending tool
with back guide for
thick materials



Z-bending tool
for big Z-step

Radius embossing tools

ADVANTAGES

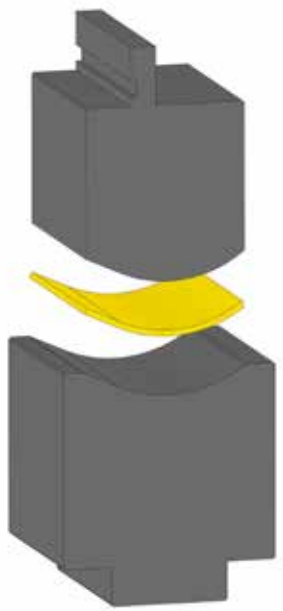
- Production in one stroke
- One tool suitable for different sheet thicknesses and materials
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

SUITABLE FOR

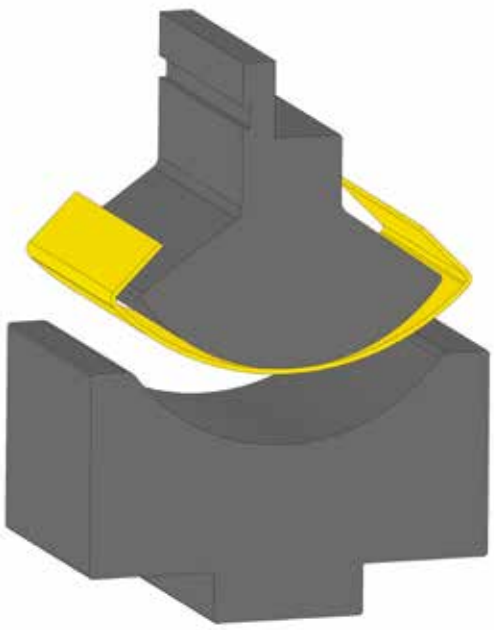
- Various material thicknesses, depending on the profile geometry and press force of your press brake

Examples for radius embossing tools

- Other shapes and layouts are manufactured individually according to your specifications



Radius embossing tool for radii with straight flanges



Radius embossing tool for big radii and prebended flanges

Double radius embossing tool

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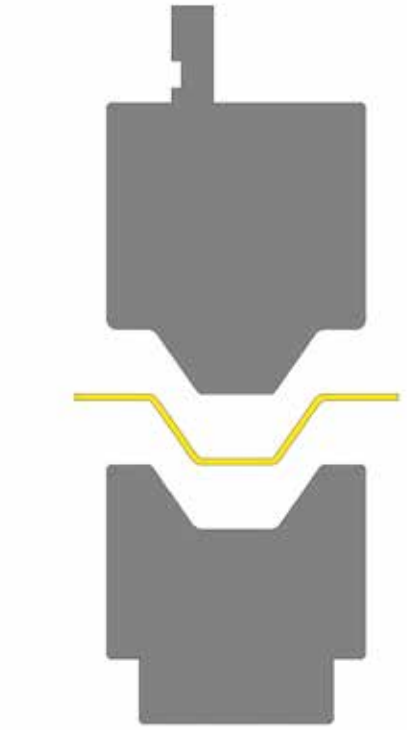
Trapezoidal bending tools



ADVANTAGES

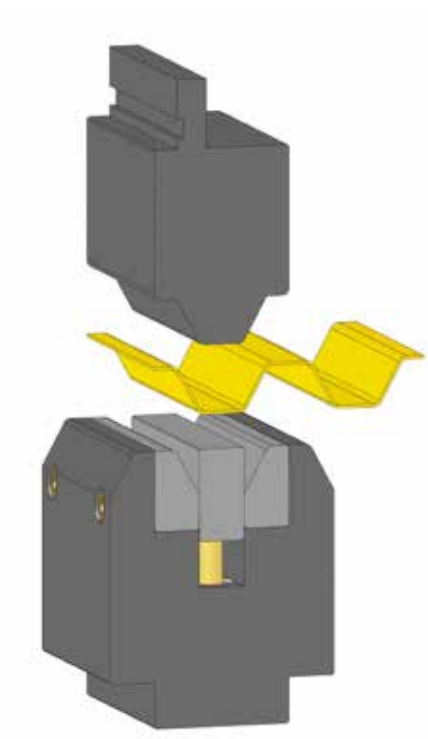
- Production in one stroke
- One tool suitable for different sheet thicknesses and materials
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

SUITABLE FOR

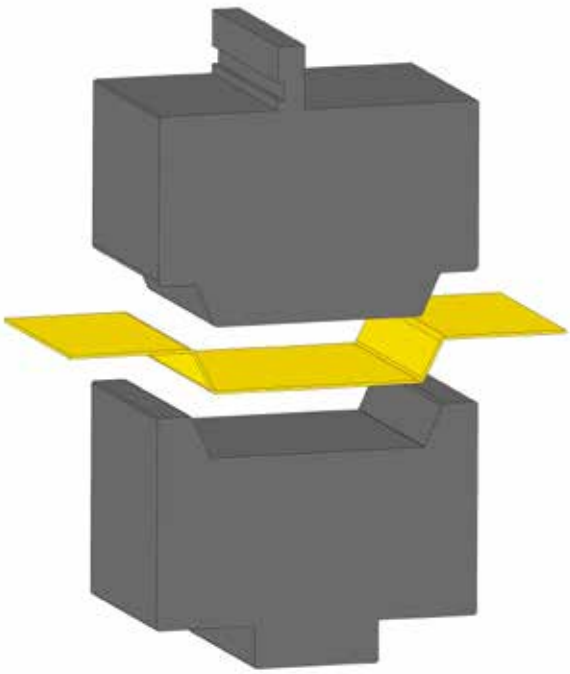
- Various material thicknesses, depending on the profile geometry and press force of your press brake

Examples for trapezoidal bending tools

- Other shapes and layouts are manufactured individually according to your specifications



Trapezoidal bending tool
with spring loaded ejector

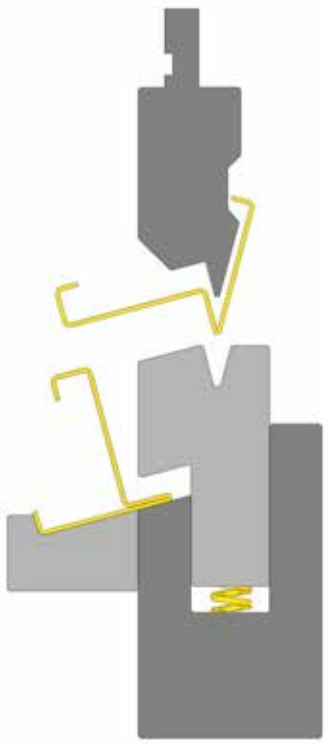


Trapezoidal bending tool
for big a profile

Flattening tools

ADVANTAGES

- Production of the flattening area in two strokes
- Active components are hardened
- Functional test and adjustment through test bends - with your sample sheets

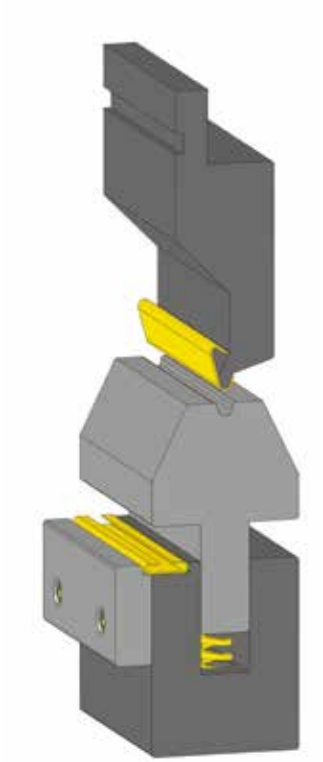


SUITABLE FOR

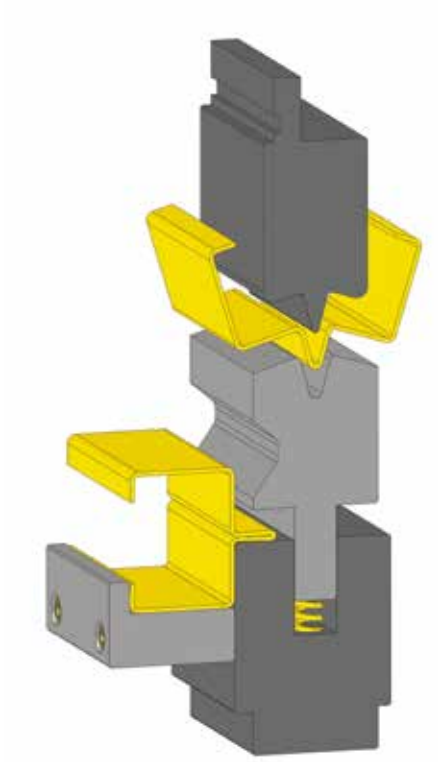
- Material thickness up to 3,0 mm

Examples for flattening tools

- Other shapes and layouts are manufactured individually according to your specifications



Flattening tool
for small C-profile



Flattening tool
for big C-profile and centered flattening

UKB-PROTECTIVE FILM

Protective film . . . . . 198 – 200
Holders for protective film . . . . . 200 – 201
Holder for protective film with steel insert. 201

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Protective film

PRODUCT ADVANTAGES

- ▶ Avoids bending marks on sheets
- ▶ Ideal for bending aluminium, stainless steel and painted surfaces
- ▶ No reworking of workpieces necessary
- ▶ No contamination of the bended parts
- ▶ Higher product quality
- ▶ Easy handling
- ▶ Applicable on all dies
- ▶ Less wearout of the protective film by correct use

VIDEO

UKB-Protective film

UKB-CONTACT PARTNER

You will find your personal contact partner at
www.ukb-gmbh.de/en/contact/contact-persons

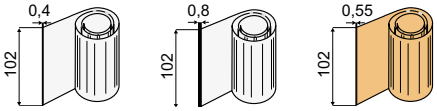
Bending result without protective film

Bending result with protective film

VU sample set

24h

5 m	Shore 95 A	VU 0,4 x 102	144,– €
5 m	Shore 95 A	VU 0,8 x 102	
5 m	Shore 60 A	VU 0,55 x 102	

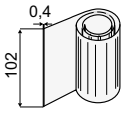


Protective film Shore 95 A

VU 0,4 x 102 — 24h

Roll		
30 m	192,– €	1,6 kg
15 m	120,– €	0,8 kg
5 m	48,– €	0,3 kg

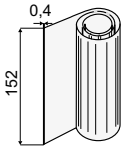
Box		
6 Rolls of 30 m each	922,– €	10,0 kg



VU 0,4 x 152 — 24h

Roll		
30 m	288,– €	2,4 kg
15 m	180,– €	1,2 kg
5 m	72,– €	0,4 kg

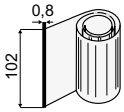
Box		
4 Rolls of 30 m each	922,– €	10,0 kg



VU 0,8 x 102 — 24h

Roll		
30 m	288,– €	3,2 kg
15 m	180,– €	1,6 kg
5 m	72,– €	0,6 kg

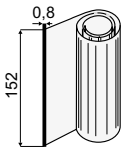
Box		
6 Rolls of 30 m each	1.382,– €	19,6 kg



VU 0,8 x 152 — 24h

Roll		
30 m	432,– €	4,6 kg
15 m	270,– €	2,3 kg
5 m	108,– €	0,8 kg

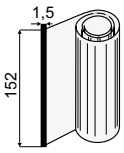
Box		
4 Rolls of 30 m each	1.382,– €	19,0 kg



VU 1,5 x 152 — 24h

Roll		
15 m	316,– €	4,4 kg
5 m	126,– €	1,5 kg

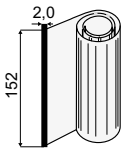
Box		
4 Rolls of 15 m each	1.008,– €	18,0 kg



VU 2,0 x 152 — 24h

Roll		
15 m	360,– €	6,6 kg
5 m	144,– €	2,2 kg

Box		
4 Rolls of 15 m each	1.152,– €	27,0 kg



UKB-PROTECTIVE FILM

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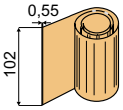
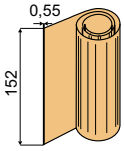
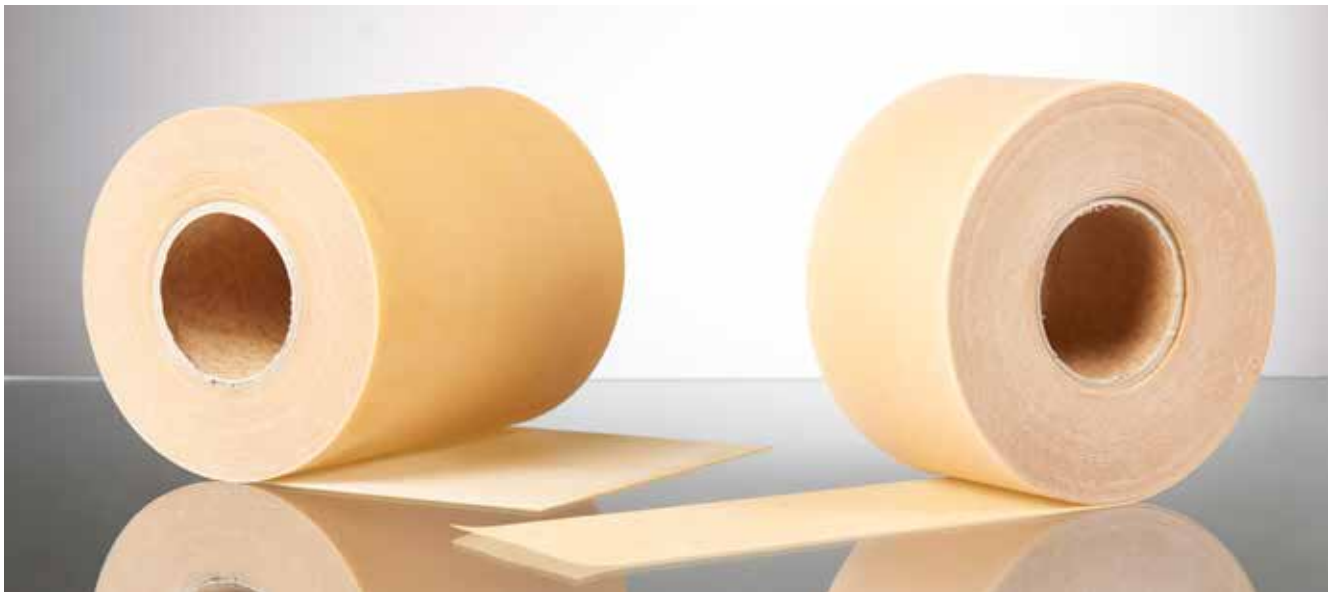
Protective film Shore 60 A

VU 0,55 x 102		24h
Roll		
30 m	288,– €	2,0 kg
15 m	180,– €	1,0 kg
5 m	72,– €	0,4 kg
Box		
6 Rolls of 30 m each	1.382,– €	12,4 kg



VU 0,55 x 152		24h
Roll		
30 m	432,– €	2,9 kg
15 m	270,– €	1,5 kg
5 m	108,– €	0,5 kg
Box		
4 Rolls of 30 m each	1.382,– €	12,0 kg

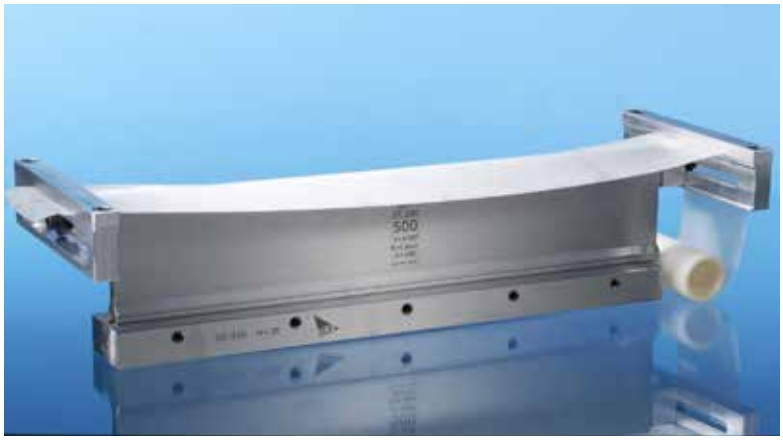




Holder for protective film

40.850		24h
per pair	190,– €	3,0 kg

for protective film up to 152 mm width



Mounted via magnets directly to the die

Holder for protective film

40.800		24h
per pair	508,– €	8,0 kg

for protective film up to 102 mm width

Holder for protective film for UKB-System Amada

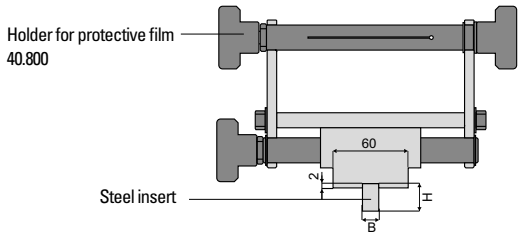
Holder for protective film with steel insert

System	Steel insert (B x H)	Price
Trumpf/Wila/Bystronic	13,0 x 22,0 mm	40,– €
EHT	55,0 x 47,0 mm	120,– €
LVD	12,7 x 21,0 mm	40,– €
Weinbrenner	35,0 x 47,0 mm	100,– €
Other Systems	B x H mm	On request

Delivery time 1–3 working days

Holder for protective film with steel insert for UKB-Systems Trumpf/Wila/Bystronic

APPLICATION EXAMPLE



By mounting a steel insert
the holder for protective film
can also be used on all die clampings.

UKB-MARK FREE AND UKB-MARK REDUCED BENDING

Composite dies 204
Holders for composite dies 205
PU-Holders and -inserts. . . . . 206 – 207

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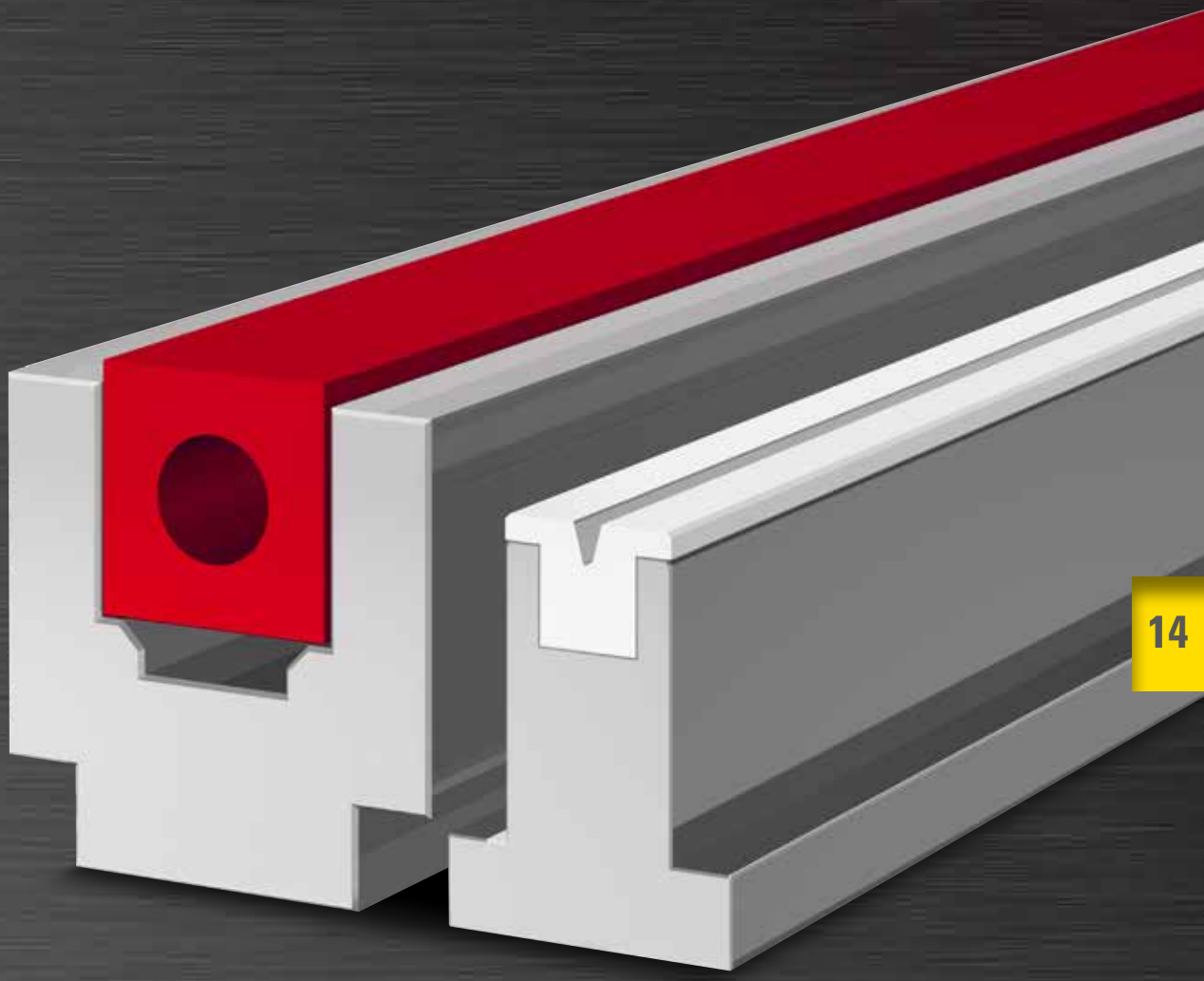

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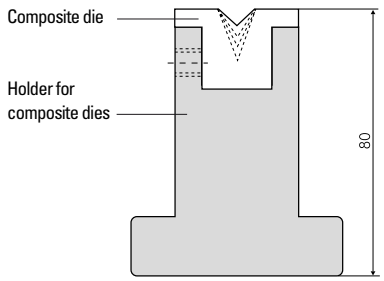
Composite dies

PRODUCT ADVANTAGES

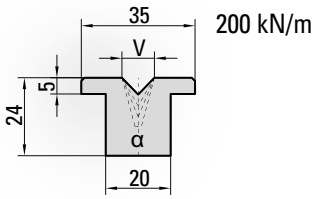
- Reduces marks on bended sheets
- Ideal for bending aluminium, stainless steel and painted surfaces
- No reworking of workpieces necessary
- No contamination of the bended parts
- Higher product quality
- Fast and easy change

EXAMPLE OF USE



32.... 24h

Model	α	V (mm)	835 mm Price	415 mm Price
32.806	88°	6,0	134,– €	78,– €
32.808	88°	8,0	134,– €	78,– €
32.810	88°	10,0	134,– €	78,– €
32.812	88°	12,0	134,– €	78,– €
32.816	88°	16,0	134,– €	78,– €
32.606	60°	6,0	134,– €	78,– €
32.608	60°	8,0	134,– €	78,– €
32.610	60°	10,0	134,– €	78,– €
32.612	60°	12,0	134,– €	78,– €
32.616	60°	16,0	134,– €	78,– €
32.406	45°	6,0	134,– €	78,– €
32.408	45°	8,0	134,– €	78,– €
32.410	45°	10,0	134,– €	78,– €
32.412	45°	12,0	134,– €	78,– €
32.306	30°	6,0	134,– €	78,– €
32.308	30°	8,0	134,– €	78,– €
32.310	30°	10,0	134,– €	78,– €
Weight			0,40 kg	0,20 kg



200 kN/m

UKB-CONTACT PARTNER

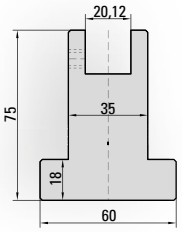
You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

Holders for composite dies

UKB-SYSTEM AMADA

22.002		24h
835 mm	314,– €	19,0 kg
415 mm	178,– €	9,5 kg
835 mm sectionalized	416,– €	19,0 kg

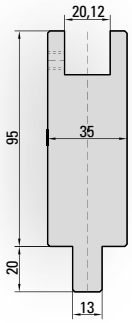
200 kN/m



UKB-SYSTEM TRUMPF

22.005		24h
835 mm	392,– €	19,3 kg
415 mm	220,– €	9,6 kg
835 mm sectionalized	522,– €	19,3 kg

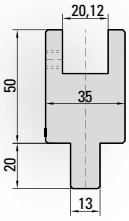
200 kN/m



UKB-SYSTEMS WILA/BYSTRONIC

22.004		24h
835 mm	300,– €	11,2 kg
415 mm	170,– €	5,6 kg
835 mm sectionalized	396,– €	11,2 kg

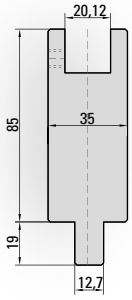
200 kN/m



UKB-SYSTEM LVD

26.005		24h
835 mm	400,– €	18,5 kg
415 mm	230,– €	9,2 kg
835 mm sectionalized	540,– €	18,5 kg

200 kN/m



VIDEO

UKB-Mark free and mark reduced bending

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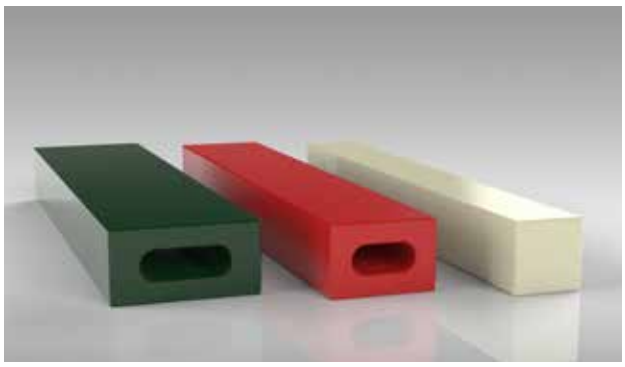
PU-Holders and inserts

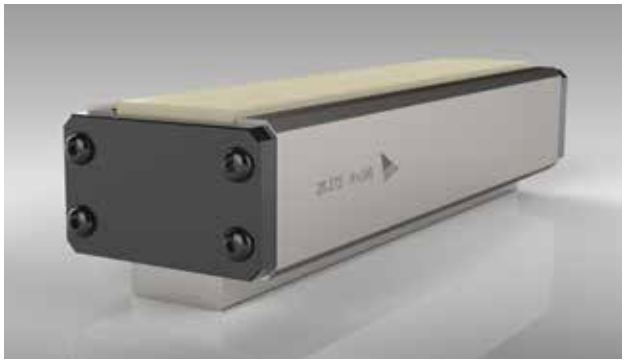
PRODUCT ADVANTAGES

- ▶ Avoids marks on bended sheets
- ▶ Ideal for bending aluminium, stainless steel and painted surfaces
- ▶ Suitable for V-, radius-, U-bending
- ▶ No reworking of workpieces necessary
- ▶ No contamination of the bended parts
- ▶ Higher product quality

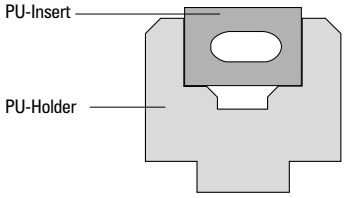
UKB-TEST BENDING

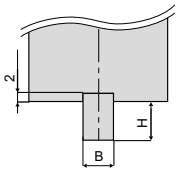
First test bending - then order!
Free of charge - with your sample sheets in your or our house!





EXAMPLE OF USE

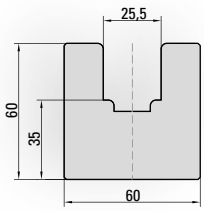




By mounting a steel insert (page 246) or using the UKB-Adaptors (page 216 - 219) PU-Holders UKB-System Amada can also be used on all other clampings.

UKB-SYSTEM AMADA

20.271		24h
835 mm	258,– €	19,2 kg
415 mm	152,– €	9,6 kg

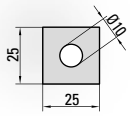


PU-Insert 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
34.180	80 A	42,– €	0,7 kg	28,– €	0,3 kg
34.190	90 A	42,– €	0,7 kg	28,– €	0,3 kg
34.195	95 A	42,– €	0,7 kg	28,– €	0,3 kg

PU-Insert with core hole 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
35.180	80 A	52,– €	0,6 kg	32,– €	0,3 kg
35.190	90 A	52,– €	0,6 kg	32,– €	0,3 kg
35.195	95 A	52,– €	0,6 kg	32,– €	0,3 kg

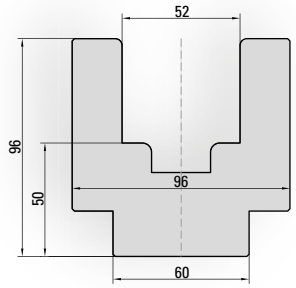


PU-Holders and -inserts

UKB-SYSTEM AMADA

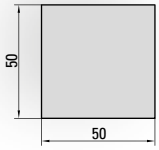
20.272 24h

835 mm	468,– €	39,3 kg
415 mm	258,– €	19,6 kg



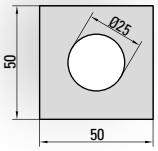
PU-Insert 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
34.280	80 A	120,– €	2,9 kg	68,– €	1,5 kg
34.290	90 A	120,– €	2,9 kg	68,– €	1,5 kg
34.295	95 A	120,– €	2,9 kg	68,– €	1,5 kg



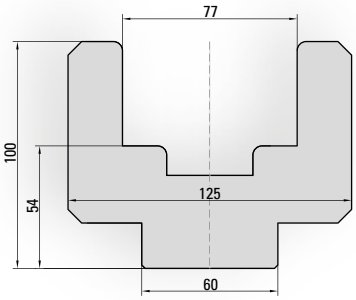
PU-Insert with core hole 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
35.280	80 A	150,– €	2,2 kg	82,– €	1,1 kg
35.290	90 A	150,– €	2,2 kg	82,– €	1,1 kg
35.295	95 A	150,– €	2,2 kg	82,– €	1,1 kg



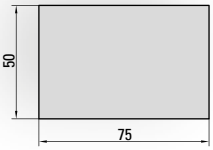
20.273 24h

835 mm	628,– €	48,2 kg
415 mm	360,– €	24,1 kg



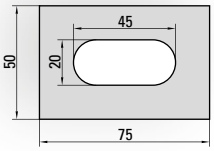
PU-Insert 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
34.380	80 A	184,– €	3,5 kg	102,– €	1,7 kg
34.390	90 A	184,– €	3,5 kg	102,– €	1,7 kg
34.395	95 A	184,– €	3,5 kg	102,– €	1,7 kg



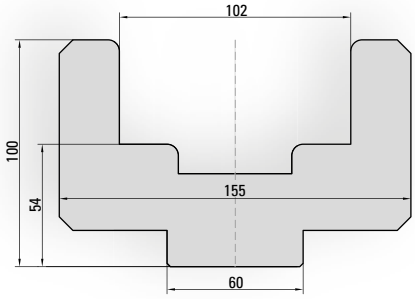
PU-Insert with core hole 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
35.380	80 A	276,– €	2,8 kg	150,– €	1,4 kg
35.390	90 A	276,– €	2,8 kg	150,– €	1,4 kg
35.395	95 A	276,– €	2,8 kg	150,– €	1,4 kg



20.274 24h

835 mm	732,– €	58,8 kg
415 mm	424,– €	29,4 kg

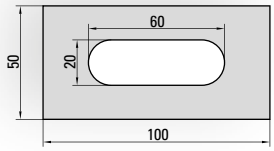


PU-Insert 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
34.480	80 A	200,– €	5,0 kg	114,– €	2,5 kg
34.490	90 A	200,– €	5,0 kg	114,– €	2,5 kg
34.495	95 A	200,– €	5,0 kg	114,– €	2,5 kg

PU-Insert with core hole 24h

Model	Shore	835 mm		415 mm	
		Price	Weight	Price	Weight
35.480	80 A	302,– €	4,0 kg	160,– €	2,0 kg
35.490	90 A	302,– €	4,0 kg	160,– €	2,0 kg
35.495	95 A	302,– €	4,0 kg	160,– €	2,0 kg



UKB-ADAPTORS

Punch/top tool adaptors
Punch/top tool adaptors ➔ UKB-System Amada . . . . . .210 – 212
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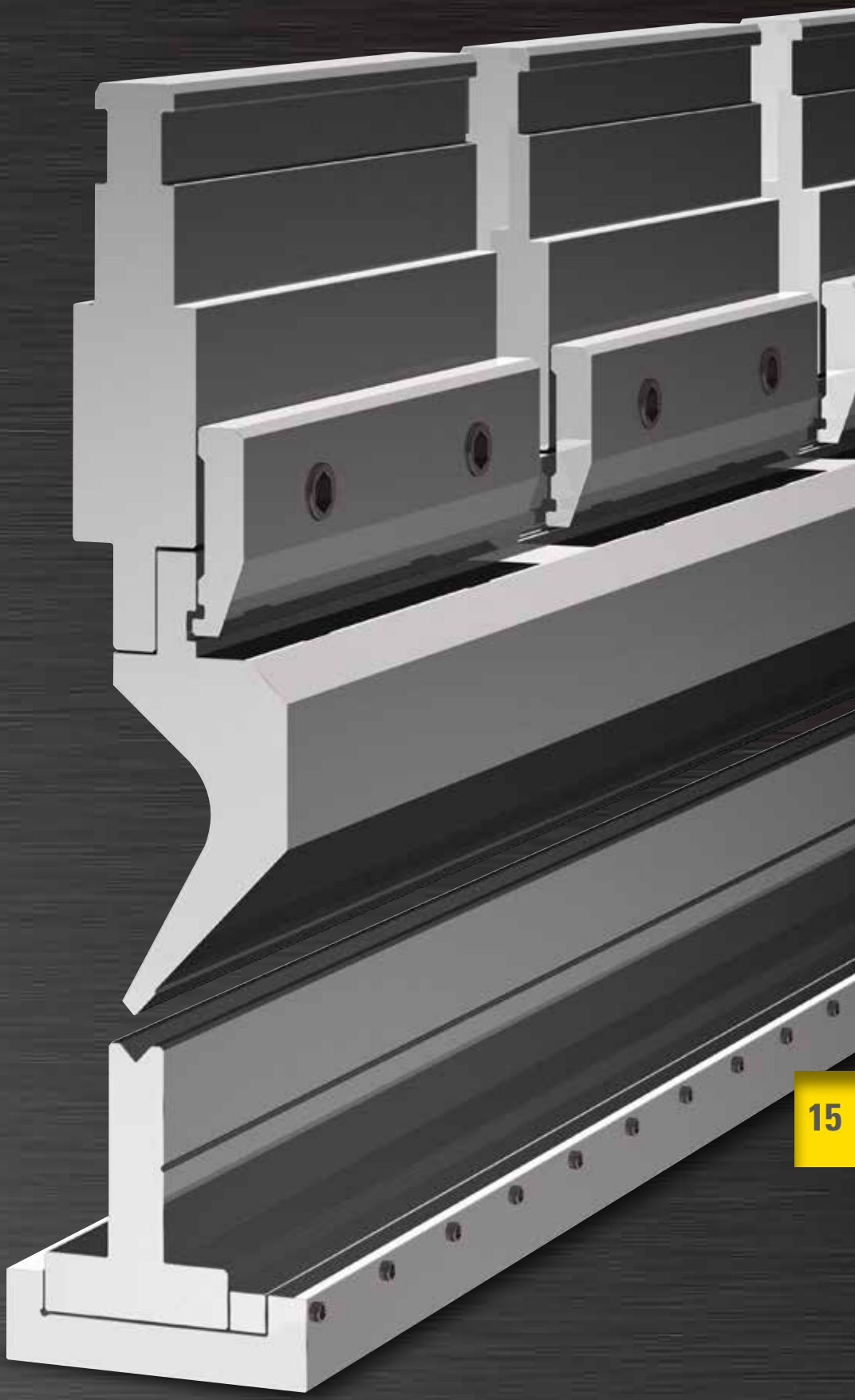

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Punch/top tool adaptors

PRODUCT ADVANTAGES

- Cost-saving, easy and quick change of your press brake via standard punch/top tool adaptors to our standard-tool systems
- Use the variety of the punches/top tools of our UKB-Systems
- Guaranteed exchangeability through highly precision grinding

Quantity of the needed punch/top tool adaptors
(Mounting distance 50 mm)

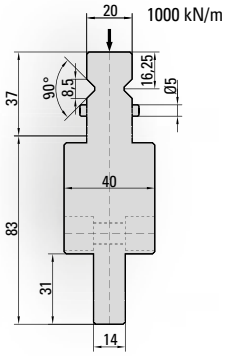
Length of the press brake (mm)	Quantity (pieces)
835	4
1.250	6
2.100	10
2.600	13
3.100	15
4.100	20

Punch/top tool adaptors ➔ UKB-System Amada

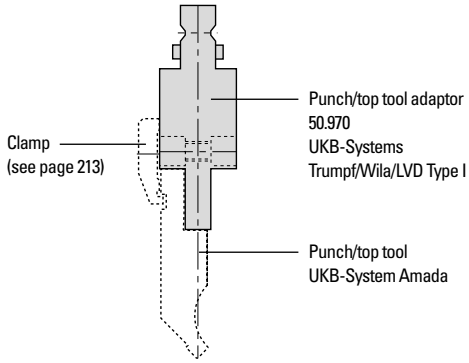
50.970 24h

150 mm	106,– €	4,0 kg

UKB-Systems Trumpf/Wila/LVD Type I➔ UKB-System Amada



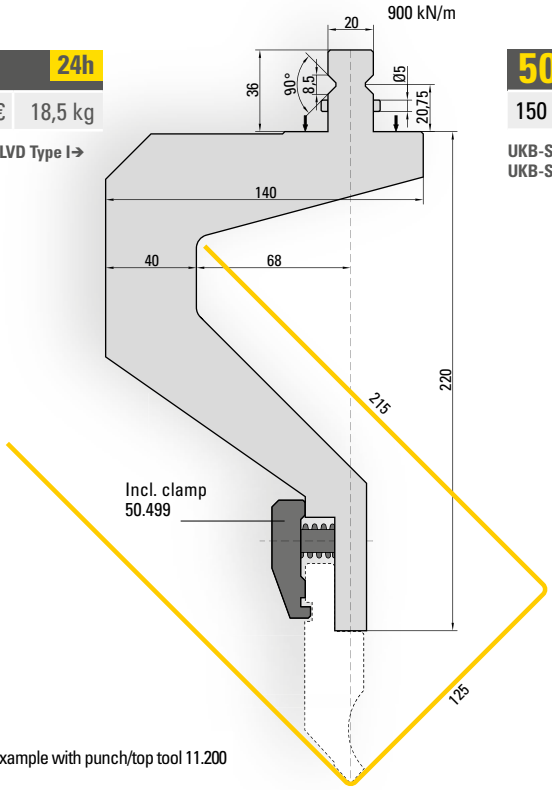
EXAMPLE OF USE



50.502 24h

200 mm	648,– €	18,5 kg

UKB-Systems Trumpf/Wila/LVD Type I➔ UKB-System Amada

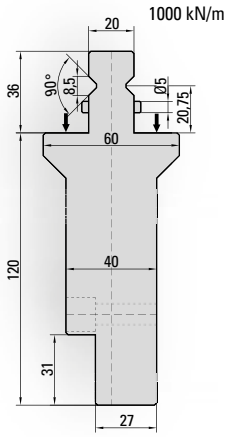


Example with punch/top tool 11.200

50.940 24h

150 mm	150,– €	6,2 kg

UKB-Systems Trumpf/Wila/LVD Type I➔ UKB-System Amada

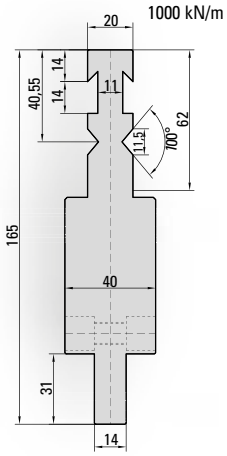


Punch/top tool adaptors ➔ UKB-System Amada

50.983 24h

150 mm	158,– €	5,0 kg

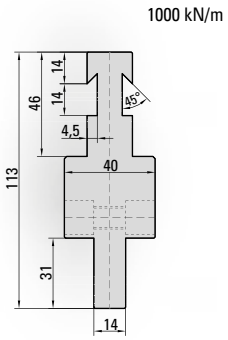
UKB-System Bystronic „RF-A“➔
UKB-System Amada



50.980 24h

150 mm	108,– €	3,2 kg

UKB-System Bystronic „R“➔
UKB-System Amada



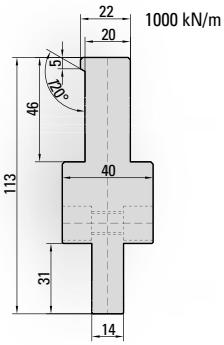
UKB-INFO

Needed clamps
see page 213!

50.981 24h

150 mm	106,– €	3,5 kg

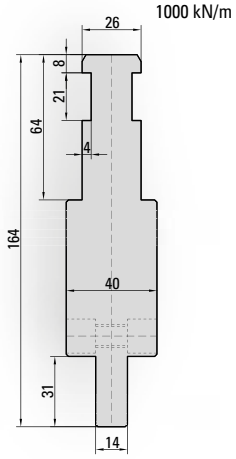
UKB-System Bystronic „S“➔
UKB-System Amada



50.991 24h

150 mm	130,– €	5,5 kg

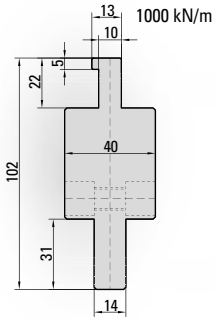
UKB-System EHT➔
UKB-System Amada



50.990 24h

150 mm	104,– €	3,0 kg

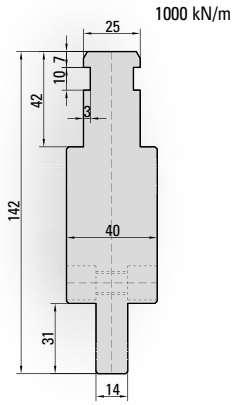
UKB-System LVD Type II ➔
UKB-System Amada



50.993 24h

150 mm	108,– €	4,9 kg

UKB-System Weinbrenner➔
UKB-System Amada



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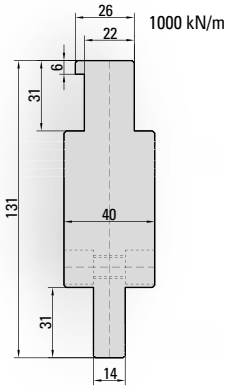
Punch/top tool adaptors ➔ UKB-System Amada

50.994 24h

150 mm	104,– €	4,6 kg

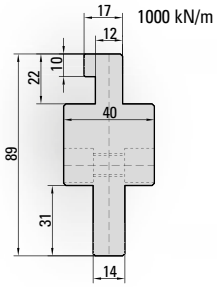
Darley ➔ UKB-System Amada



50.998 24h

150 mm	98,– €	2,7 kg

Haco ➔ UKB-System Amada



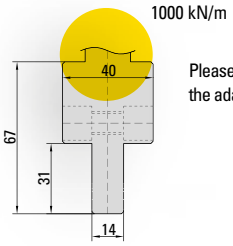
UKB-INFO

Needed clamps
see page 213!

810.000

150 mm	On request

Individual punch/top tool adaptors
Delivery time on reqest

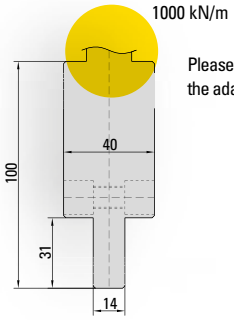


Please exactly measure the adaptor clamping!

820.000

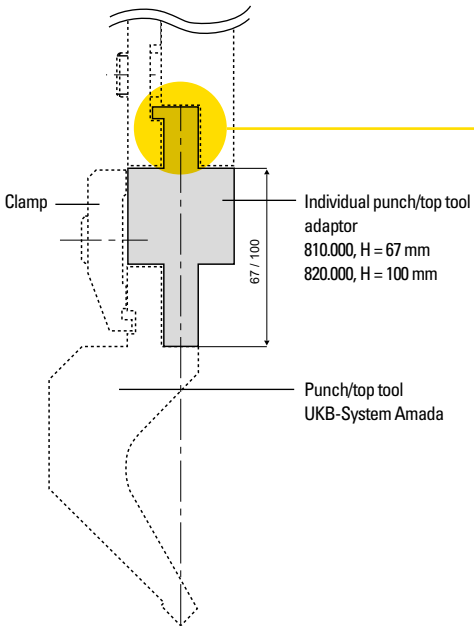
150 mm	On request

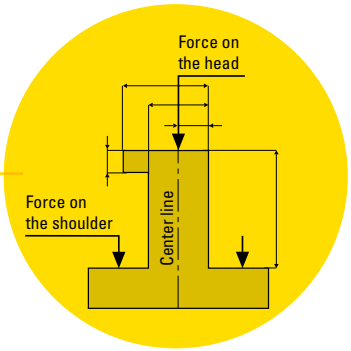
Individual punch/top tool adaptors
Delivery time on reqest



Please exactly measure the adaptor clamping!

EXAMPLE OF USE





Adaptor clamping

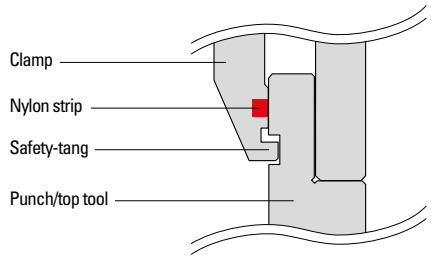
- ▶ Force on the head
- ▶ Force on the shoulder
- ▶ Center line
- ▶ Exact measurements

Clamps L = 150 mm

PRODUCT ADVANTAGES

- Fast **horizontal** tool change via fast clamping at: 50.551, 50.900, 50.903, 50.905
- Improved clamping via nylon strip at: 50.903, 50.905, 50.910

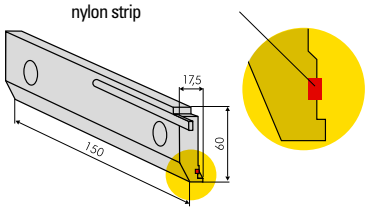
EXAMPLE OF USE



50.903		24h
150 mm	50,– €	0,7 kg

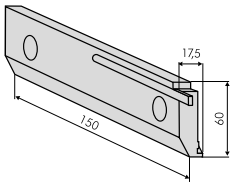
Mechanical fast clamp
Adjusted by eccentric lever

ADVANTAGE:
Improved clamping via nylon strip



50.900		24h
150 mm	44,– €	0,7 kg

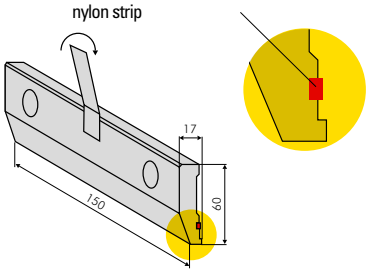
Mechanical fast clamp
Adjusted by eccentric lever



50.905		24h
150 mm	46,– €	1,0 kg

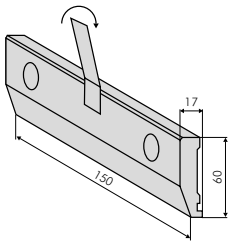
Mechanical fast clamp
Adjusted by handle

ADVANTAGE:
Improved clamping via nylon strip



50.551		24h
150 mm	40,– €	1,0 kg

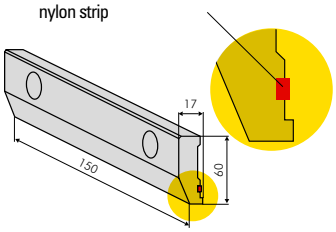
Mechanical fast clamp
Adjusted by handle



50.910		24h
150 mm	38,– €	0,8 kg

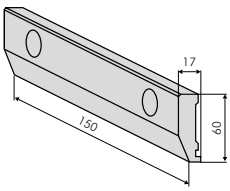
Clamp
Clamping by screws

ADVANTAGE:
Improved clamping via nylon strip



50.571		24h
150 mm	32,– €	0,7 kg

Clamp
Clamping by screws



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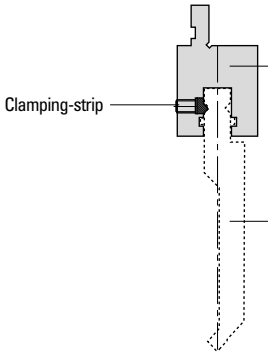
Punch/top tool adaptors ➔ UKB-Systems Trumpf/Wila/LVD

Quantity of the needed punch/top tool adaptors
(Mounting distance 50 mm)

Length of the press brake (mm)	Quantity (pieces)
835	4
1.250	6
2.100	10
2.600	13
3.100	15
4.100	20

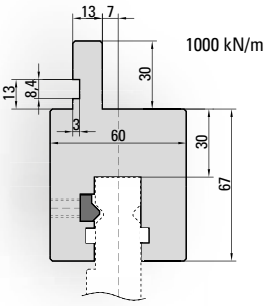
EXAMPLE OF USE



50.430 — 24h

150 mm	266,– €	4,0 kg

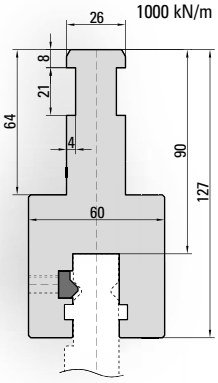
UKB-System Amada➔
UKB-Systems Trumpf/Wila/LVD Type I



50.450

150 mm	350,– €	5,0 kg

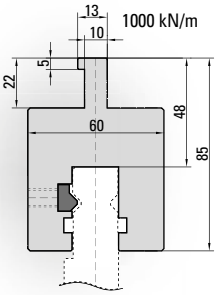
UKB-System EHT➔
UKB-Systems Trumpf/Wila/LVD Type I
Delivery time 1 - 2 working weeks



50.470

150 mm	328,– €	3,8 kg

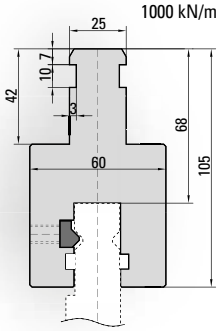
UKB-System LVD Type II ➔
UKB-Systems Trumpf/Wila/LVD Type I
Delivery time 1 - 2 working weeks



50.490

150 mm	348,– €	4,5 kg

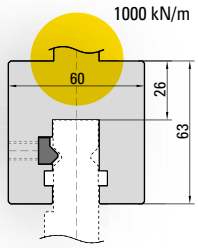
UKB-System Weinbrenner➔
UKB-Systems Trumpf/Wila/LVD Type I
Delivery time 1 - 2 working weeks



850.000

150 mm	On request

Individual punch/top tool adaptor
UKB-Systems Trumpf/Wila/LVD Type I
Delivery time on reqest

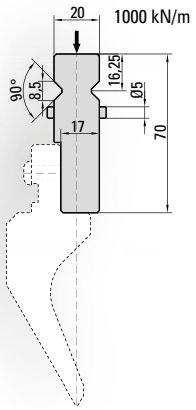


Please exactly measure the adaptor clamping!

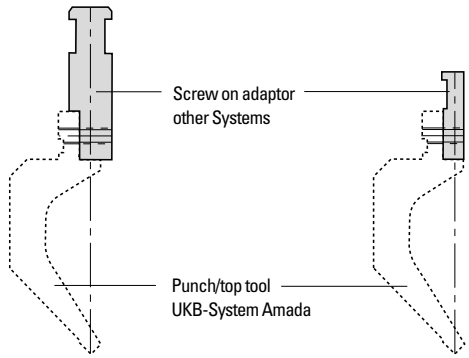
Screw on adaptor

50.965		24h
835 mm	230,– €	8,3 kg
415 mm	150,– €	4,2 kg
835 mm sectionalized	300,– €	8,3 kg

UKB-System Amada➔
UKB-Systems Trumpf/Wila/LVD Type I



EXAMPLE OF USE



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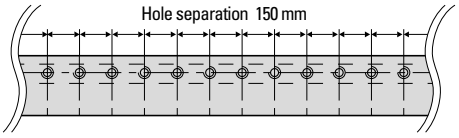
Die shoe adaptors UKB-System Amada

PRODUCT ADVANTAGES

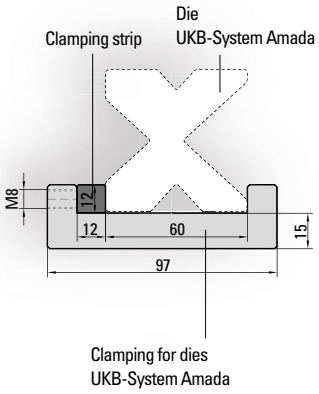
- Die shoe adaptor for 60 mm clamping width can be used on all press brakes with a flat table, to use dies **UKB-System Amada**
- Use the variety of the dies UKB-System Amada (see chapter 1)

EXAMPLE OF USE

M8 grub screw for a constant clamping of sectionalized dies UKB-System Amada with clamping strip

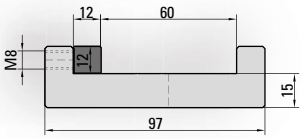


Front view



60.680 – 60.683 24h

Model	Length	Price	Weight
60.680	2100 mm	590,– €	31,0 kg
60.681	2600 mm	730,– €	38,0 kg
60.682	3100 mm	860,– €	45,5 kg
60.683	4100 mm	1.120,– €	60,0 kg



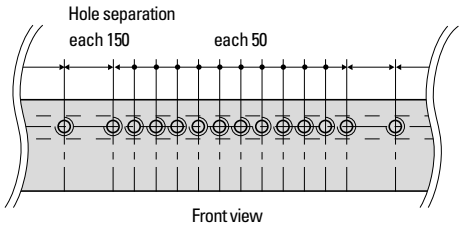
Die shoe adaptors UKB-Systems Trumpf/Wila/Bystronic

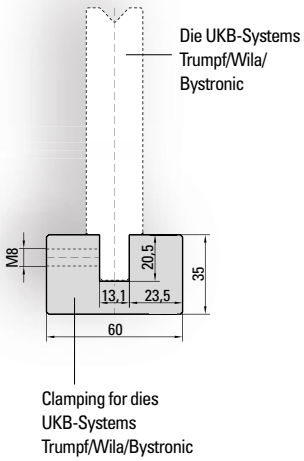
PRODUCT ADVANTAGES

- ▶ Die shoe adaptor for 13 x 20 mm clamping width can be used on all press brakes with a flat table, to use dies **UKB-System Trumpf/Wila/Bystronic**
- ▶ Use the variety of the dies
  UKB-System Trumpf (see chapter 2)
  UKB-System Wila (see chapter 3)
  UKB-System Bystronic (see chapter 5)

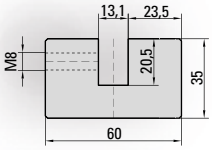
EXAMPLE OF USE

M8 grub screw for a constant clamping of sectionalized dies UKB-Systems Trumpf/Wila/Bystronic





60.901 – 60.904			24h
Model	Length	Price	Weight
60.901	2100 mm	590,– €	38,5 kg
60.902	2600 mm	730,– €	47,5 kg
60.903	3100 mm	860,– €	57,0 kg
60.904	4100 mm	1.120,–€	75,0 kg



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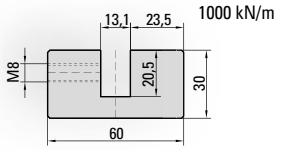
Die adaptors

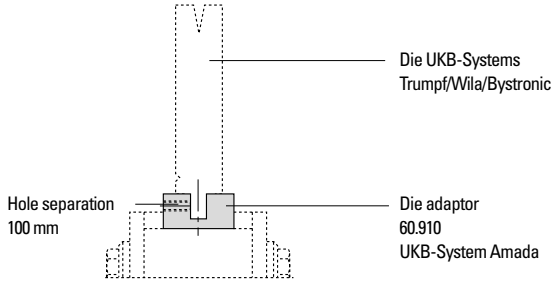
60.910 — 24h

1000 mm	208,– €	15,0 kg
500 mm	120,– €	7,5 kg

UKB-System Amada➔
UKB-Systems Trumpf/Wila/Bystronic



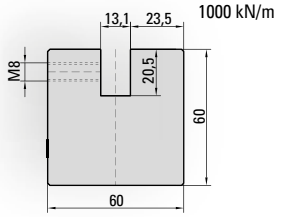
EXAMPLES OF USE

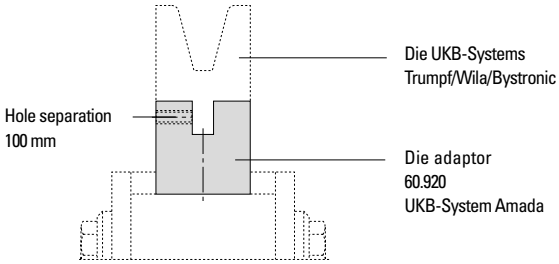


60.920 — 24h

1000 mm	246,– €	30,0 kg
500 mm	142,– €	15,0 kg

UKB-System Amada➔
UKB-Systems Trumpf/Wila/Bystronic

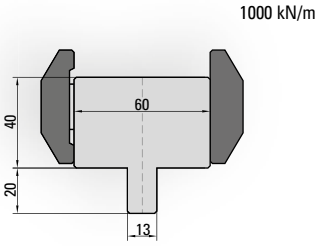


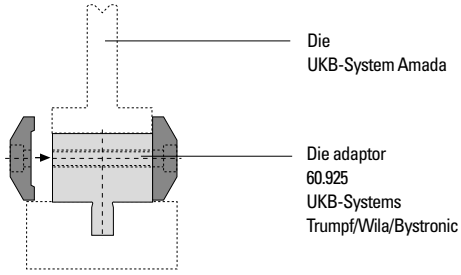


60.925 — 24h

835 mm	298,– €	25,0 kg
415 mm	180,– €	12,5 kg

UKB-Systems Trumpf/Wila/Bystronic➔
UKB-System Amada

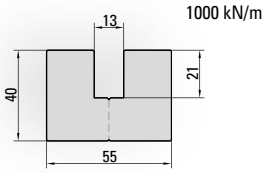


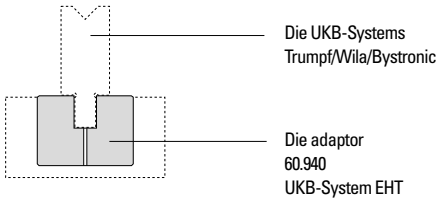


60.940 — 24h

500 mm	248,– €	7,5 kg

UKB-System EHT➔
UKB-Systems Trumpf/Wila/Bystronic

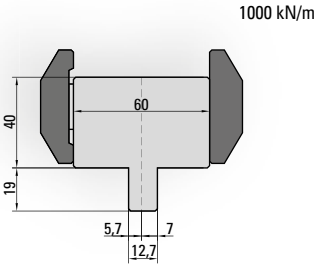


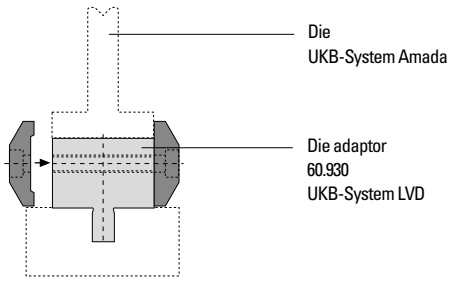


60.930 — 24h

835 mm	298,– €	25,0 kg
415 mm	180,– €	12,5 kg

UKB-System LVD➔
UKB-System Amada

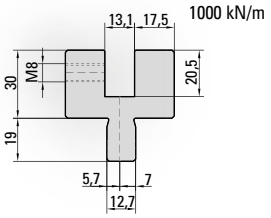




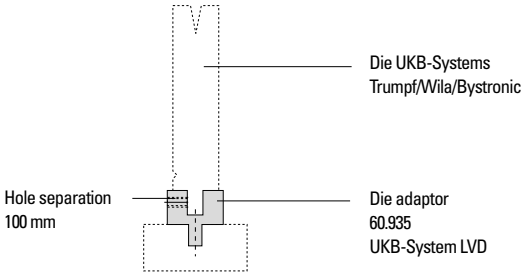
Die adaptors

60.935		24h
1000 mm	378,– €	11,0 kg
500 mm	208,– €	5,5 kg

UKB-System LVD➔
UKB-Systems Trumpf/Wila/Bystronic

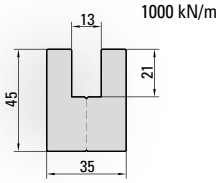


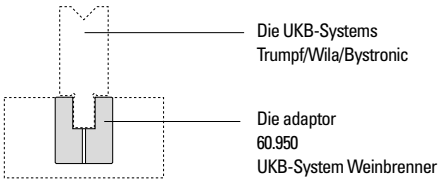
EXAMPLES OF USE



60.950		24h
500 mm	230,– €	4,5 kg

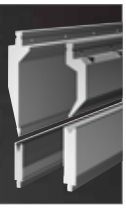
UKB-System Weinbrenner➔
UKB-Systems Trumpf/Wila/Bystronic





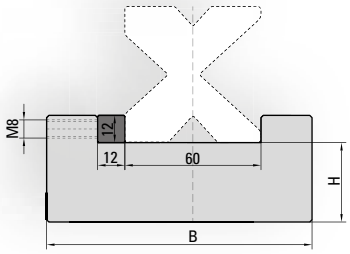
PRESS BRAKE TOOLS
UKB-SYSTEM TRUMPF

see chapter **02**

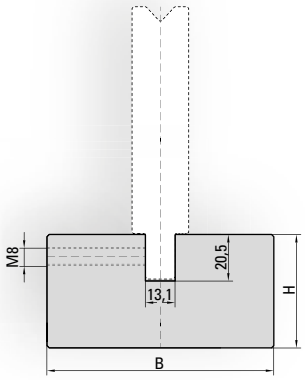


Individual die adaptors

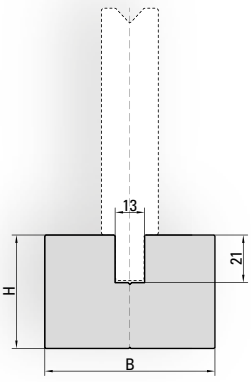
Individual die adaptor➔
UKB-System Amada
Die adaptor according to your specifications
suitable for your press brake
Delivery time on reqest



Individual die adaptor➔
UKB-Systems Trumpf/Wila/Bystronic
Die adaptor according to your specifications
suitable for your press brake
Delivery time on reqest



Individual die adaptor➔
UKB-Systems Trumpf/Wila/Bystronic
Die adaptor according to your specification
suitable for your press brake
Delivery time on reqest



UKB-PRESS BRAKE TOOL CABINETS

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Press brake tool cabinets

PRODUCT ADVANTAGES

- ▶ Tools are secured against damage and soiling
- ▶ Time-saving through quick access and easy handling
- ▶ Robust and strong construction
- ▶ Functional and practical

VIDEO

UKB-Press brake tool cabinets

UKB-CONTACT PARTNER

You will find your personal contact partner at
www.ukb-gmbh.de/en/contact/contact-persons

UKB-ADVANTAGES

- ▶ **Office hours:** From Monday to Friday from 7:30am to 6:00pm
- ▶ **Delivery time:** Press brake tool cabinets colour blue/white in **24 h**
- ▶ **Shipping:** Orders placed before 4:00pm on the same working day
- ▶ **Delivery service:**

  Standard: 1 – 3 working days by forwarder

  Express: DE 9:00, 10:30, 12:00am or 1 working day
  EU 1 working day

  Direct courier: According agreement
- ▶ **Package:** Ecologically sensitive and safe
- ▶ **Payment options:** 10 days 3% cash-discount, 30 days net

VIDEO

Image

Press brake tool cabinet equipment

- Powder-coated: Standard body blue (RAL 5010), drawers white (RAL 9016)
- Transport pockets for forklift or jacklift – for fast relocation when the cabinet is empty
- Height adjustable, galvanized shelves (spacing 50 mm)
- Lockable drawers

Flexible colour scheme

- Available in all RAL-colours

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Press brake tool cabinets UKB-System Amada

40.641 b

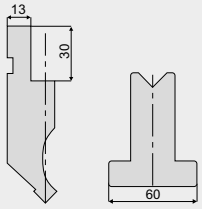
24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	1.326,– €

40.641 RAL

Colour	RAL colour on demand
Price	1.376,– €

Delivery time on reqest

Tools	
Equipment	3 Vertical drawers on casters with in total: - 12 Pair of shelves (92.681) for punches/top tools and dies L = 835 mm - 3 Pieces of shelves (92.682) for punches/top tools and dies L ≤ 835 mm - Possibilities to store accessories (Measuring devices, consumables, etc .)
Capacity	Up to 25 m of punches/top tools and dies
Dimensions	660 mm x 1240 mm x 1050 mm (W x H x D)
Weight	180 kg

40.651 b

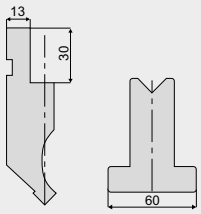
24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	1.798,– €

40.651 RAL

Colour	RAL colour on demand
Price	1.848,– €

Delivery time on reqest

Tools	
Equipment	5 Vertical drawers on casters with in total: - 20 Pair of shelves (92.681) for punches/top tools and dies L = 835 mm - 5 Pieces of shelves (92.682) for punches/top tools and dies L ≤ 835 mm - Possibilities to store accessories (Measuring devices, consumables, etc .)
Capacity	Up to 42 m of punches/top tools and dies
Dimensions	1040 mm x 1240 mm x 1050 mm (W x H x D)
Weight	270 kg

Press brake tool cabinets UKB-System Amada

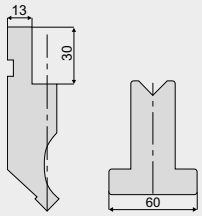
40.650 b — 24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	1.640,– €

40.650 RAL

Colour	RAL colour on demand
Price	1.690,– €

Delivery time on reqest

Tools	
Equipment	6 Fixed shelves with 8-15 storage places L ≤ 835 mm 1 Pull out drawer with 8-15 storage places
Capacity	Up to 47 m of punches/top tools and dies
Dimensions	900 mm x 1550 mm x 900 mm (W x H x D)
Weight	220 kg

Shelves UKB-System Amada

92.681 — 24h

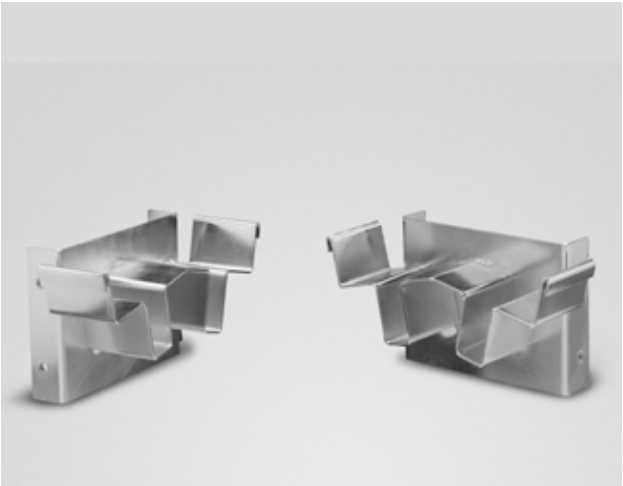
18,– €	1,8 kg

For punches/top tools and dies
with L = 835 mm
Capacity: 1,67 m

92.682 — 24h

44,– €	4,1 kg

For punches/top tools and dies
with L ≤ 835 mm
Capacity: 1,67 m



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Press brake tool cabinets UKB-Systems Trumpf/Wila/LVD/Bystronic

40.643 b

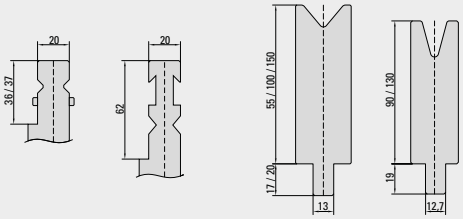
24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	1.862,– €

40.643 RAL

Colour	RAL colour on demand
Price	1.912,– €

Delivery time on reqest

Tools	
Equipment	3 Vertical drawers on casters with in total: - 5 Pieces of shelves (92.685) for punches/top tools L ≤ 1100 mm - 5 Pieces of shelves (92.686) for dies L ≤ 1100 mm incl. 36 pieces separating plates (92.689) - Possibilities to store accessories (Measuring devices, consumables, etc .)
Capacity	Up to 11 m punches/top tools and up to 16 m dies
Dimensions	660 mm x 1240 mm x 1350 mm (W x H x D)
Weight	230 kg

40.653 b

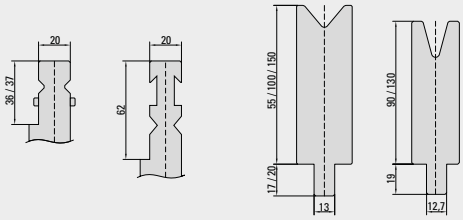
24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	2.378,– €

40.653 RAL

Colour	RAL colour on demand
Price	2.428,– €

Delivery time on reqest

Tools	
Equipment	5 Vertical drawers on casters with in total: - 9 Pieces of shelves (92.685) for punches/top tools L ≤ 1100 mm - 8 Pieces of shelves (92.686) for dies L ≤ 1100 mm incl. 48 pieces separating plates (92.689) - Possibilities to store accessories (Measuring devices, consumables, etc .)
Capacity	Up to 20 m punches/top tools and up to 26 m dies
Dimensions	1040 mm x 1240 mm x 1350 mm (W x H x D)
Weight	340 kg

Press brake tool cabinets UKB-Systems Trumpf/Wila/LVD/Bystronic

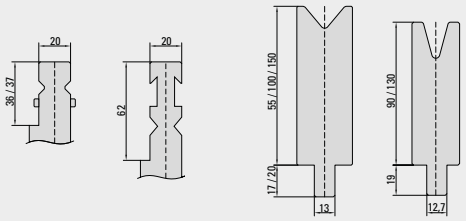
40.654 b — 24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	2.944,– €

40.654 RAL

Colour	RAL colour on demand
Price	2.994,– €

Delivery time on reqest

Tools	
Equipment	5 Vertical drawers on casters with in total: - 12 Pieces of shelves (92.685) for punches/top tools L ≤ 1100 mm - 10 Pieces of shelves (92.686) for dies L ≤ 1100 mm incl. 60 pieces separating plates (92.689) - Possibilities to store accessories (Measuring devices, consumables, etc .)
Capacity	Up to 26 m punches/top tools and up to 33 m dies
Dimensions	1040 mm x 1620 mm x 1350 mm (W x H x D)
Weight	410 kg

Shelves UKB-Systems Trumpf/Wila/LVD/Bystronic

92.685 — 24h

58,– €	5,2 kg

for punches/top tools with
L ≤ 1100 mm
Capacity: 2,2 m

92.686 — 24h

56,– €	5,2 kg

for dies with L ≤ 1100 mm
incl . 6 separating plates
Capacity: 3,3 m

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Press brake tool cabinets UKB-Systems EHT/Weinbrenner/other Systems

40.642 b

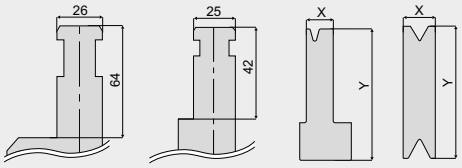
24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	1.852,– €

40.642 RAL

Colour	RAL colour on demand
Price	1.902,– €

Delivery time on reqest

Tools	
Equipment	3 Vertical drawers on casters with in total: - 9 Pieces of shelves (92.684) for punches/top tools and dies L ≤ 1100 mm - Possibilities to store accessories (Measuring devices, consumables, etc .)
Capacity	Up to 19 m of punches/top tools and dies
Dimensions	660 mm x 1240 mm x 1350 mm (W x H x D)
Weight	245 kg

40.652 b

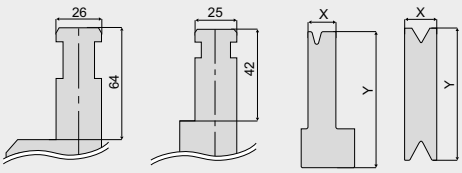
24h

Colour	Body blue (RAL 5010) drawers white (RAL 9016)
Price	2.276,– €

40.652 RAL

Colour	RAL colour on demand
Price	2.326,– €

Delivery time on reqest

Tools	
Equipment	5 Vertical drawers on casters with in total: - 15 Pieces of shelves (92.684) for punches/top tools and dies L ≤ 1100 mm - Possibilities to store accessories (Measuring devices, consumables, etc .)
Capacity	Up to 33 m of punches/top tools and dies
Dimensions	1040 mm x 1240 mm x 1350 mm (W x H x D)
Weight	370 kg

Shelves UKB-Systems EHT/Weinbrenner/other Systems

92.684	24h
52,– €	6,5 kg

For punches/top tools and dies
with L ≤ 1100 mm,
clamping flange individual
adjustable
Capacity: 3,3 m

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UKB-ACCESSORIES

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Squaring arms

PRODUCT ADVANTAGES

- ▶ Flexible and exact adjustable
- ▶ Angle infinitely variable (depending on the model)
- ▶ Stopper system for long, small and not square sheet metal parts

VIDEO

UKB-Accessories

Squaring arms 90°

40.720 24h

Per Piece	166,– €	1,5 kg

- ▶ Usable as a stop 90° left and right
- ▶ Fixation on the die by adjustable clamping
- ▶ Flexible applicable on all dies up to 60 mm width
- ▶ Light construction
- ▶ Dimensions: (H x W x D) about 80 x 125 x 320 mm

40.730 24h

Per Piece	186,– €	1,5 kg

- ▶ Usable as a stop 90° left and right
- ▶ Fixation on the die by adjustable clamping
- ▶ Flexible applicable on all dies up to 105 mm width
- ▶ Light construction
- ▶ Dimensions: (H x W x D) about 80 x 125 x 320 mm

40.660 24h

Per Piece	240,– €	3,0 kg

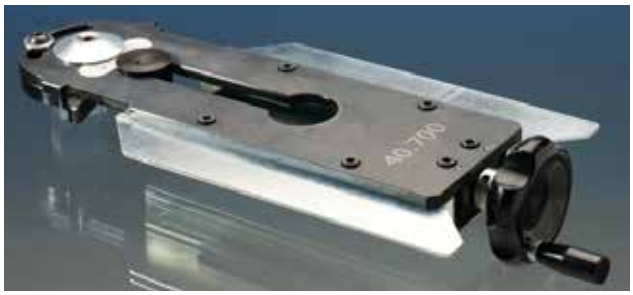
- ▶ Usable as a stop 90° left and right
- ▶ Fixation on the die by adjustable clamping
- ▶ Flexible applicable on all dies up to 60 mm width
- ▶ Light construction
- ▶ Dimensions: (H x W x D) about 70 x 170 x 335 mm

Adjustable squaring arm 60-120°

40.700 24h

Per Piece	302,– €	3,5 kg

- ▶ Stepless angle adjustment by 30° each
- ▶ Usable as a stop left and right
- ▶ Fixation on the die by adjustable clamping
- ▶ Flexible applicable on all dies up to 60 mm width
- ▶ Light construction
- ▶ Dimensions: (H x W x D) about 70 x 170 x 460 mm

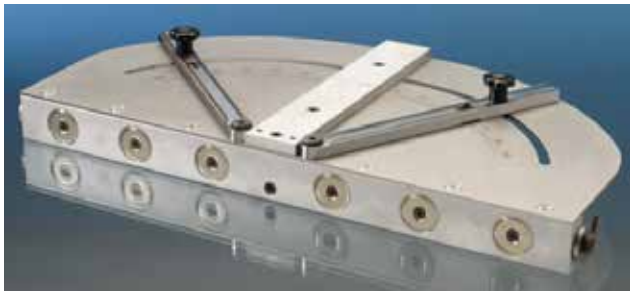


Magnetic, adjustable squaring arm 30-90°

40.750 24h

Per Piece	494,– €	5,5 kg

- ▶ Stepless angle adjustment by 60° each
- ▶ Usable as a stop left and right
- ▶ Magnetic fixing at the front side of the die
- ▶ No interruption of the optical safety divices
- ▶ Flexible applicable on all dies from 415 mm length
- ▶ Light construction
- ▶ Dimensions: (H x W x D) about 70 x 520 x 250 mm



Squaring arms

Squaring arms 0-90°

40.740 24h

Per Piece	228,– €	1,3 kg

- Stepless angle adjustment 90°
- Usable as a stop left
- Magnetic fixing at the front side of the die
- No interruption of the optical safety devices
- Flexible applicable on all dies from 130 mm length
- Light construction
- Dimensions: (H x W x D) about 50 x 130 x 190 mm

40.745 24h

Per Piece	228,– €	1,3 kg

- Stepless angle adjustment 90°
- Usable as a stop right
- Magnetic fixing at the front side of the die
- No interruption of the optical safety devices
- Flexible applicable on all dies from 130 mm length
- Light construction
- Dimensions: (H x W x D) about 50 x 130 x 190 mm

40.740+40.745 24h

1 Set	430,– €	2,60 kg

- Stepless angle adjustment 90°
- Usable as a stop left respectively right
- Magnetic fixing at the front side of the die
- No interruption of the optical safety devices
- Flexible applicable on all dies from 130 mm length
- Light construction
- Dimensions: (H x W x D) about 50 x 130 x 190 mm

Digital angle gauges

40.015 24h

Per Piece	56,– €	0,20 kg

- Length of the inside flange at 90°: approx 54 mm
- Flexible measuring zone: 360°
- Display accuracy: 0,1°
- Zero position in any position of the flanges possible
- Clamping in any position of the flanges possible
- Contact surface of the flanges magnetic
- Dimensions: (H x W x D) about 22 x 50 x 104 mm

40.016 24h

Per Piece	62,– €	0,32 kg

- Length of the inside flange at 90°: approx 177 mm
- Flexible measuring zone: 360°
- Display accuracy: 0,1°
- Zero position in any position of the flanges possible
- Clamping in any position of the flanges possible
- Contact surface of the flanges magnetic
- Dimensions: (H x W x D) about 22 x 50 x 227 mm

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Insertion tools

PRODUCT ADVANTAGES

- Insertion of threaded bolts and screw nuts from M3 up to M10 on your press brake possible without a special machine
- Different sizes of threaded bolts and screw nuts with short set up time applicable
- Build up of several tools next to each other possible
- Wear resistance though hardened body and activ components
- Pressure surface and active components ground to avoid marks on the sheets
- Clearly arranged storage in corresponding suitcase

VIDEO

UKB-Press brake tool systems

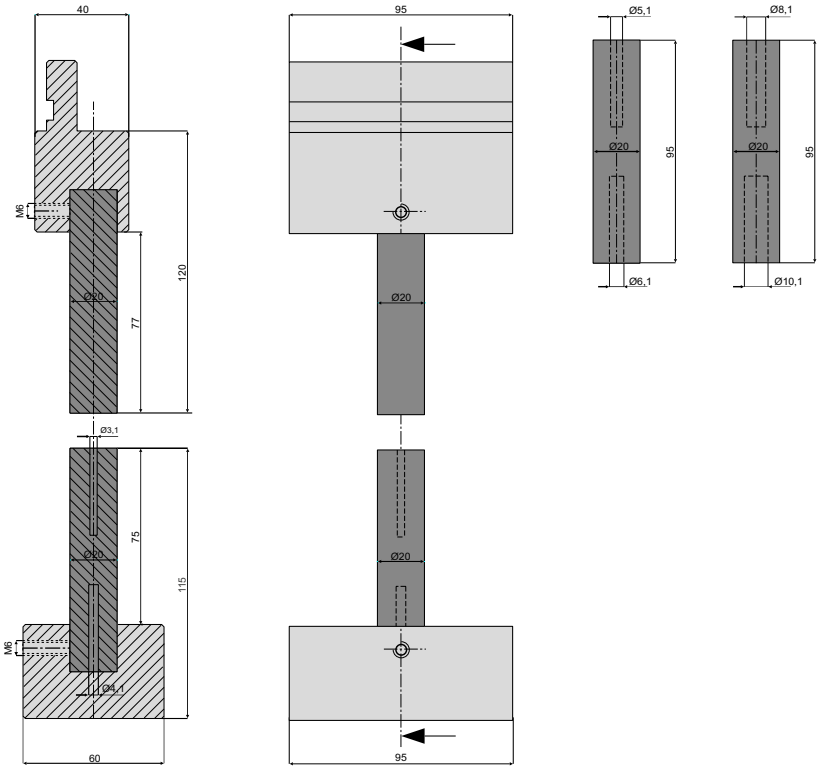
UKB-SYSTEM AMADA

40.950		24h
1 Set	836,– €	5,5 kg

Set consists of:
Punch/top tool holder
Die holder
4 Bolts
Tool case

UKB-INFO

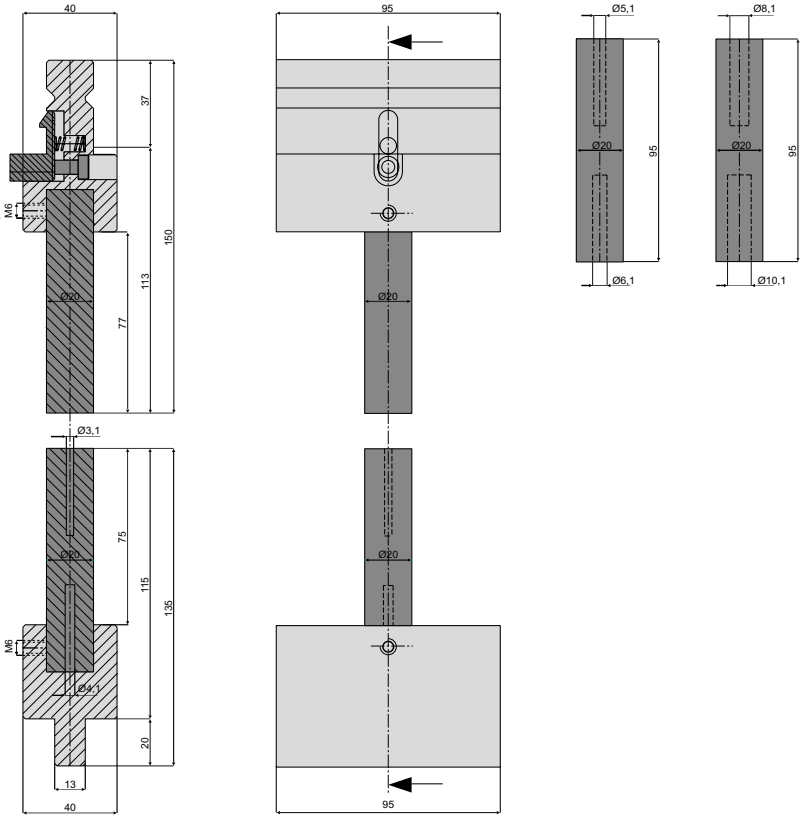
Via adaptor systems applicable on all other press brakes!



UKB-SYSTEMS TRUMPF/WILA

40.960		24h
1 Set	836,– €	5,2 kg

Set consists of:
Punch/top tool holder incl. Simple Clamp
Die holder
4 Bolts
Tool case



UKB-MODIFICATION OF PRESS BRAKE TOOLS

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Modification of press brake tools

Sometimes you have to make things fit!

Use our modification service for press brake tools:

Large stock of press brake tools

+

Flexible and individual modification

=

Fastest realisation of your demands!

According agreement within 1 working day!

High stock availability

Fast realisation of your demands

Modification department

Flexible modification

- Modification of clampings
- Special cuttings
- Individual horn extensions
- Change of radii and angles
- Cut-outs
- Beadings
- Windows
- Insertion of a steel insert
- Milling of a groove
- Laser marking
- Surface coating and refinement
- Insertion of drill holes

VIDEO

UKB-Modification of press brake tools

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Modification of clampings UKB-System Amada

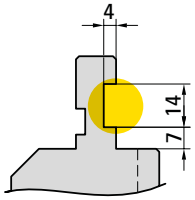
ADVANTAGES

- Punches/top tools UKB-System Amada via modifications applicable on other press brakes
- According agreement within 1 working day

Examples for modifications

70.501

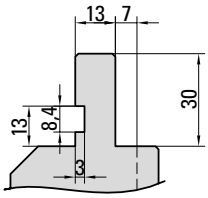
835 mm	30,– €
415 mm	20,– €
835 mm sectionalized	50,– €



Additional groove for:
- UKB-System Wila Type II

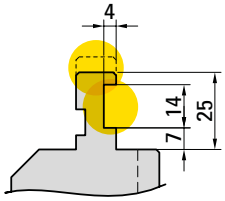
Delivery time 1 - 3 working days

CLAMPING UKB-SYSTEM AMADA



70.503

835 mm	60,– €
415 mm	45,– €
835 mm sectionalized	90,– €

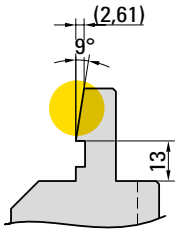


Additional groove and shortened head for:
- UKB-System Wila Type II

Delivery time 1 - 3 working days

70.504

835 mm	50,– €
415 mm	35,– €
835 mm sectionalized	70,– €

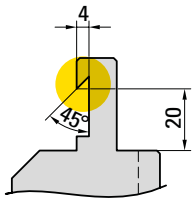


Clamping for:
- „Amada one touch“

Delivery time 1 - 3 working days

70.600

835 mm	55,– €
415 mm	40,– €
835 mm sectionalized	90,– €

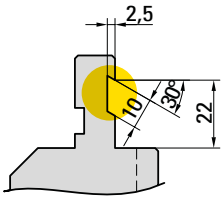


Modified groove for:
- Hydraulic clamping Gasparini

Delivery time 1 - 3 working days

70.1050

835 mm	55,– €
415 mm	40,– €
835 mm sectionalized	90,– €



Additional groove for:
- Pneumatic clamping „CLARK®“

Delivery time 1 - 3 working days

Special cuttings

ADVANTAGES

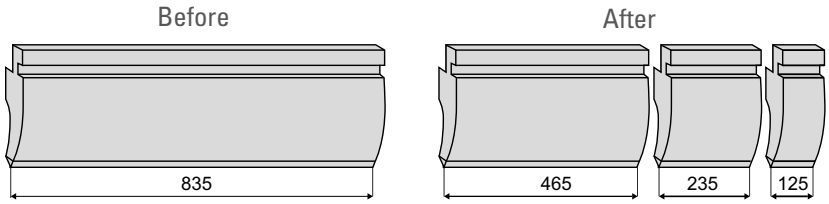
- Cost-saving, fast modification of all punches/top tools
- According agreement within 1 working day

Examples for modifications

70.000

Per piece	20,– up to 50,– €

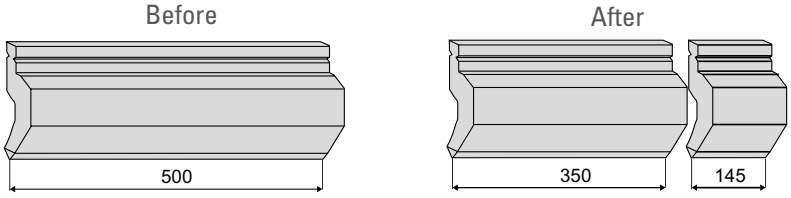
Delivery time 1 - 3 working days



70.000

Per piece	20,– up to 50,– €

Delivery time 1 - 3 working days



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Individual horn extensions

ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- According agreement within 1 working day

UKB-INFO

The maximum load could be reduced by modification!

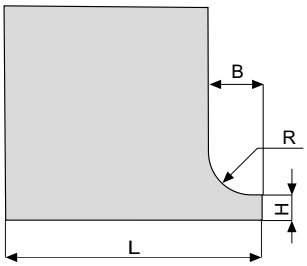
Examples for modifications

70.200

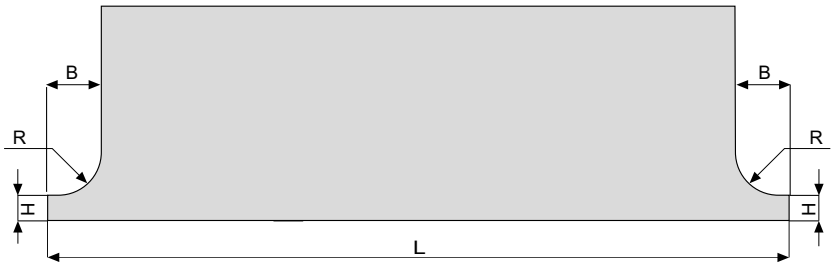
Per piece	30,– up to 50,– €

Delivery time 1 - 3 working days

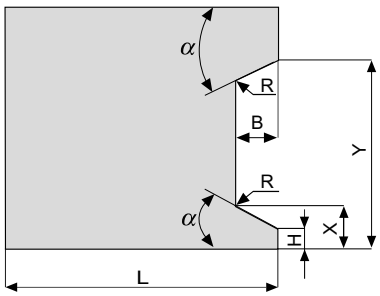
One-sided



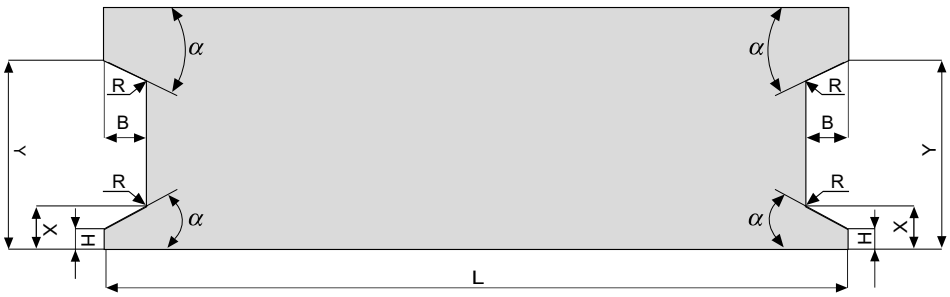
Left and right



One-sided



Left and right



Change of radii

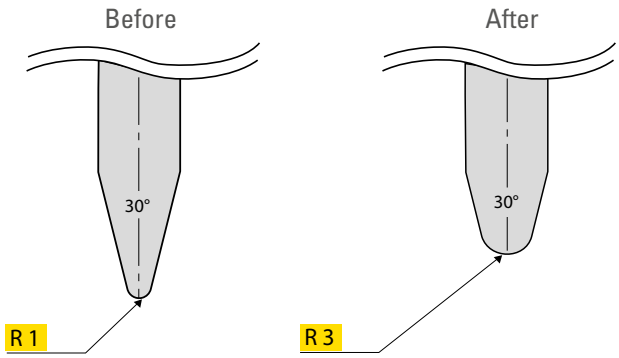
ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- Rehardening if necessary
- According agreement within 1 working day

70.100

Delivery time 1 - 3 working days

Example for modification



Change of angles

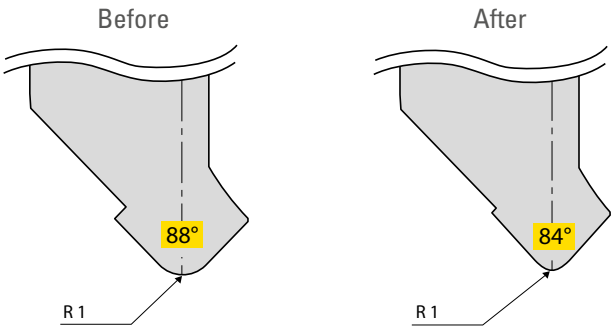
ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- Rehardening if necessary
- According agreement within 1 working day

70.100

Delivery time 1 - 3 working days

Example for modification



Change of radii and angles

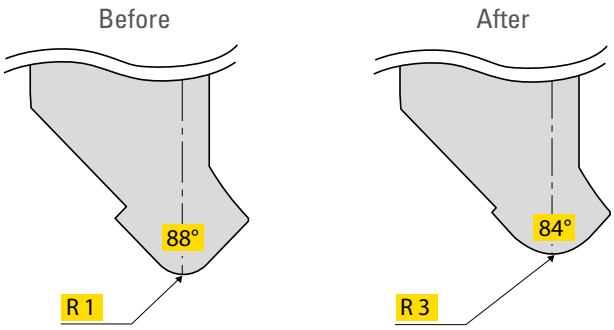
ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- Rehardening if necessary
- According agreement within 1 working day

70.100

Delivery time 1 - 3 working days

Example for modification



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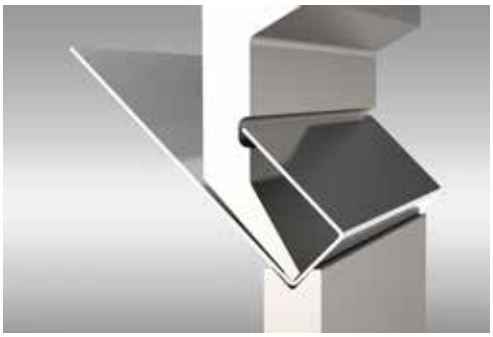
Cut-outs at punches/top tools

ADVANTAGES

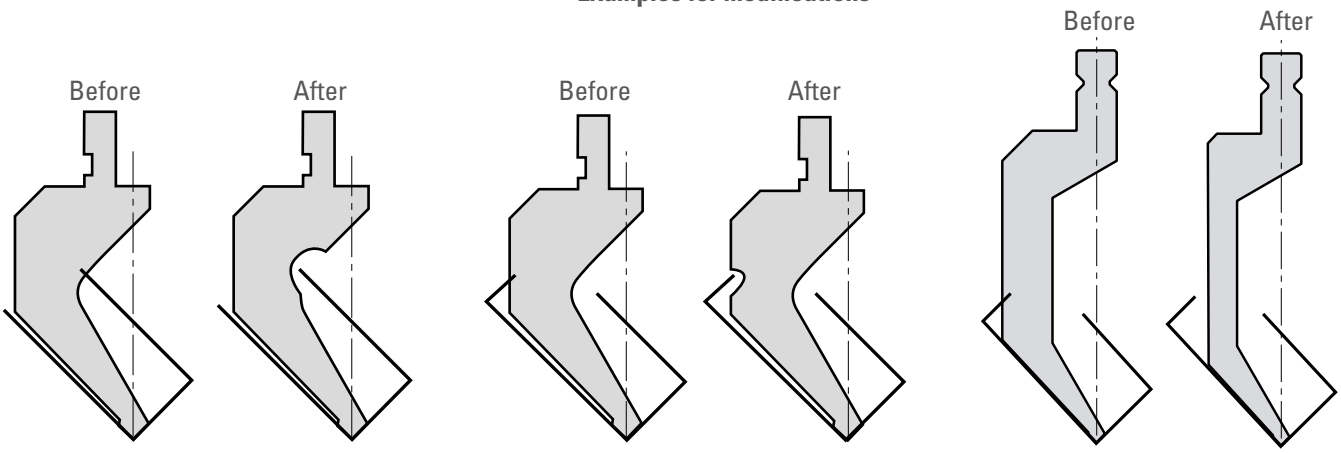
- Cost-saving, fast modification of all punches/top tools
- According agreement within 1 working day



Reworking of tools

Delivery time 1 - 3 working days

Examples for modifications



Beading in the bending

ADVANTAGES

- Cost-saving, fast modification of all punches/top tools

UKB-INFO

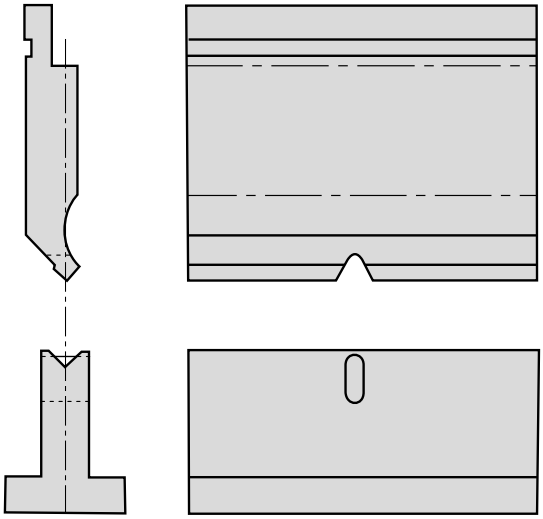
The maximum load could be reduced by modification!

Example for modification

70.102

Insertion of a bolt in the die and appropriate milling in the punch/top tool for beading in the bending.

Delivery time
1 - 2 working weeks



Windows for U-profiles

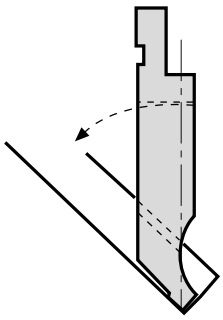
ADVANTAGES

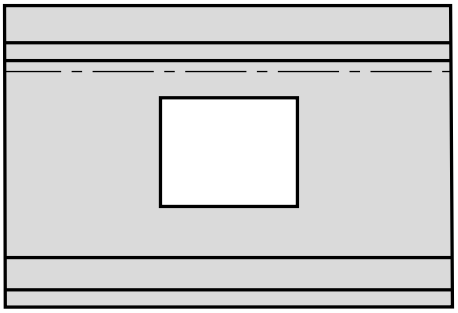
- Cost-saving, fast modification of all punches/top tools
- According agreement within 1 working day

Examples for modifications

Reworking of tools

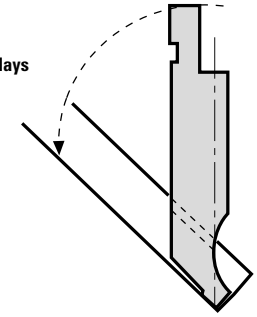
Delivery time 1 - 3 working days

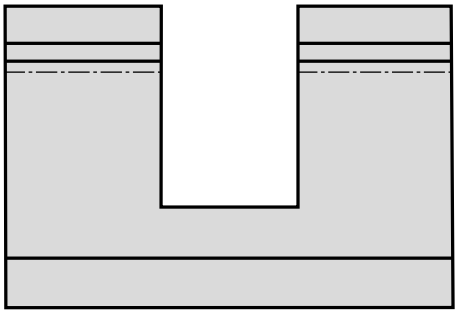




Reworking of tools

Delivery time 1 - 3 working days





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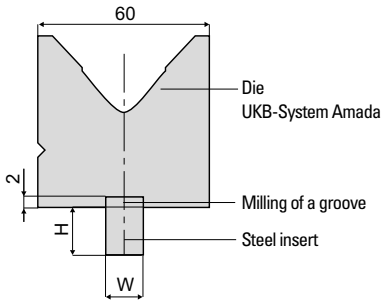
Insertion of a steel insert

ADVANTAGES

- Cost-saving and fast modification of dies UKB-System Amada for the use on other press brakes
- According agreement within 1 working day

MODIFICATION EXAMPLE



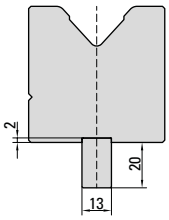
Examples for modifications

70.990

835 mm	60,– €
415 mm	40,– €
835 mm sectionalized	180,– €

Steel insert 13 x 22 mm
- UKB-Systems Trumpf/Wila/Bystronic

Delivery time 1 - 3 working days

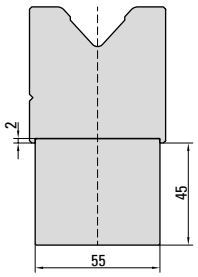


70.995

835 mm	210,– €
415 mm	130,– €
835 mm sectionalized	430,– €

Steel insert 55 x 47 mm
- UKB-System EHT

Delivery time 1 - 3 working days

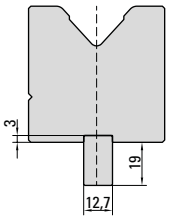


70.991

835 mm	60,– €
415 mm	40,– €
835 mm sectionalized	180,– €

Steel insert 12,7 x 21 mm
- UKB-System LVD

Delivery time 1 - 3 working days

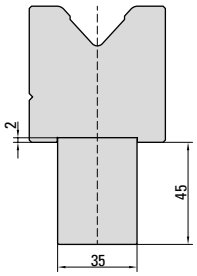


70.992

835 mm	180,– €
415 mm	110,– €
835 mm sectionalized	400,– €

Steel insert 35 x 47 mm
- UKB-System Weinbrenner

Delivery time 1 - 3 working days

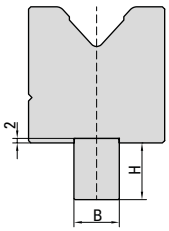


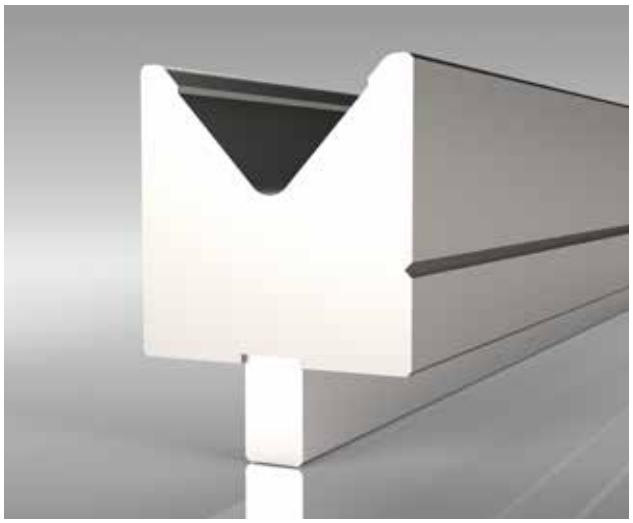
70.993

835 mm	On request
415 mm	On request
835 mm sectionalized	On request

Steel insert
for other Systems

Delivery time 1 - 3 working days



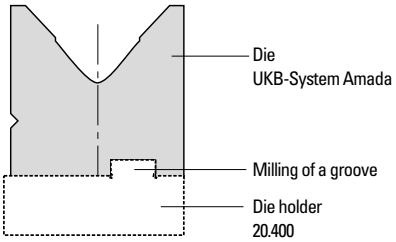


Milling of a groove

ADVANTAGES

- Cost-saving and fast modification of dies
- According agreement within 1 working day

MODIFICATION EXAMPLE

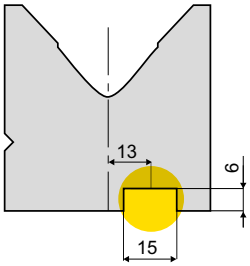


Examples for modifications

70.994	
835 mm	55,– €
415 mm	35,– €
835 mm sectionalized	80,– €

Groove for die holders UKB-System Amada 20.287 and 20.400 for centrical 2-V dies (see page 44)

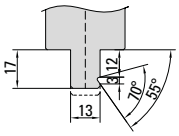
Delivery time 1 - 3 working days



70.900	
500/515 mm	40,– €
300 mm	30,– €
200 mm	25,– €
100 mm	20,– €
550 mm sectionalized	80,– €

Centering groove and shortened tang for dies UKB-Systems Trumpf/Wila/Bystronic

Delivery time 1 - 3 working days



Special cuttings

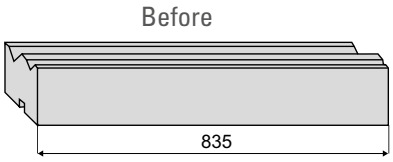
ADVANTAGES

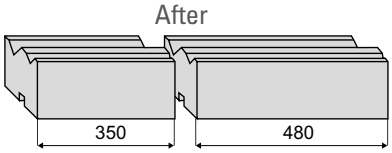
- Cost-saving, fast modification of all dies
- According agreement within 1 working day

Examples for modifications

70.000	
Per piece	20,– up to 50,– €

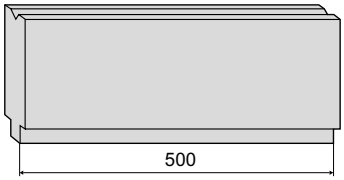
Delivery time 1 - 3 working days

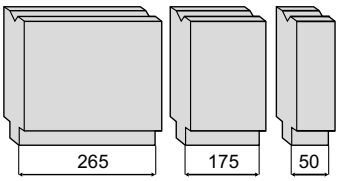




70.000	
Per piece	20,– up to 50,– €

Delivery time 1 - 3 working days





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Cut-outs at dies

ADVANTAGES

- Cost-saving, fast modification of all dies
- According agreement within 1 working day

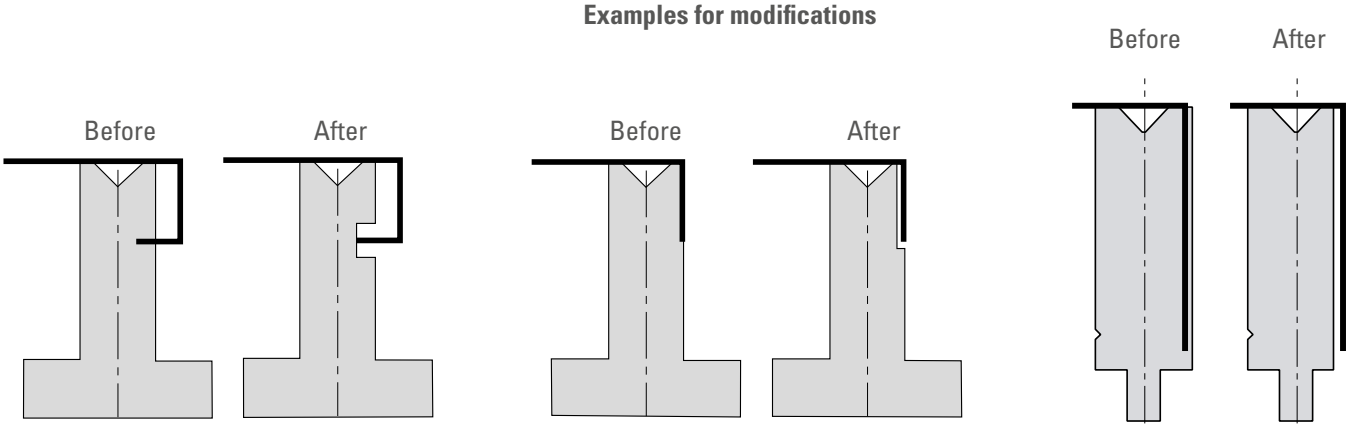
UKB-INFO

The maximum load could be reduced by modification!

Reworking of tools

Delivery time 1 - 3 working days

Examples for modifications



Individual horn extensions

ADVANTAGES

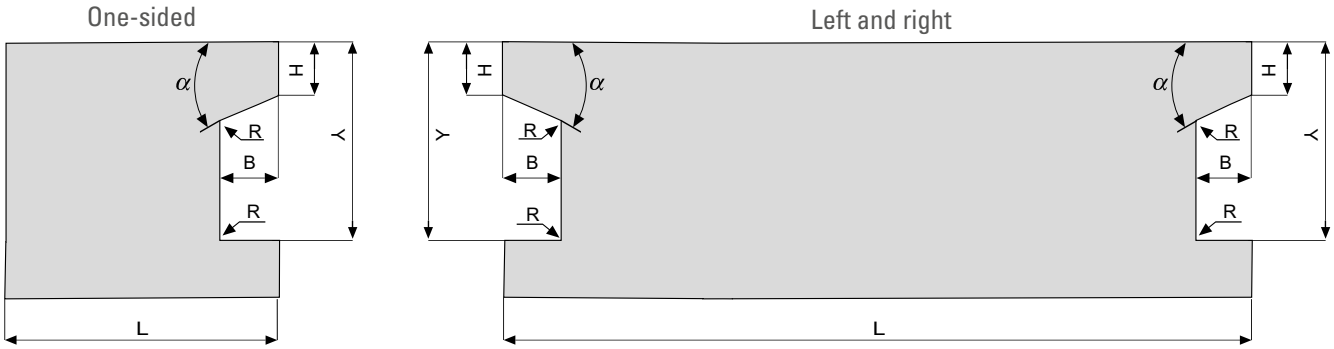
- Cost-saving, fast modification of all dies
- According agreement within 1 working day

Examples for modifications

70.200

Per piece	30,– up to 50,– €

Delivery time 1 - 3 working days



Change of the intake radii

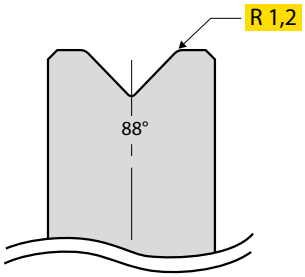
ADVANTAGES

- Cost-saving, fast modification of all dies
- Rehardening if necessary
- According agreement within 1 working day

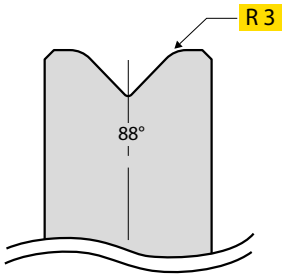
70.100
Delivery time 1 - 3 working days

Example for modification

Before



After



Change of angles

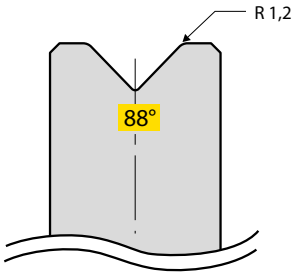
ADVANTAGES

- Cost-saving, fast modification of all dies
- Rehardening if necessary
- According agreement within 1 working day

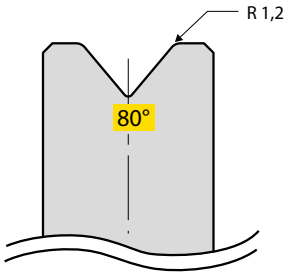
70.100
Delivery time 1 - 3 working days

Example for modification

Before



After



Change of intake radii and angles

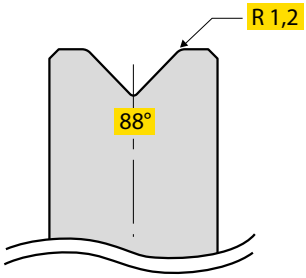
ADVANTAGES

- Cost-saving, fast modification of all dies
- Rehardening if necessary
- According agreement within 1 working day

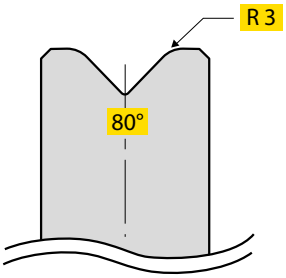
70.100
Delivery time 1 - 3 working days

Example for modification

Before



After



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Change of V-openings

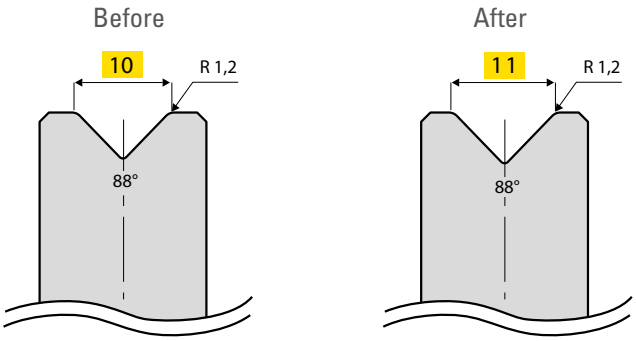
ADVANTAGES

- Cost-saving, fast modification of all dies
- Rehardening if necessary
- According agreement within 1 working day

70.100

Delivery time 1 - 3 working days

Example for modification



Laser marking

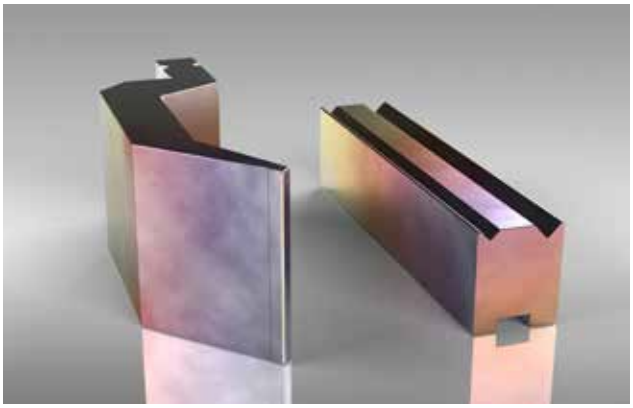
ADVANTAGES

- All important data at a glance
- Permanent, high contrast marking
- Individual marking possible

Surface coating and refinement

ADVANTAGES

- No tool contamination while bending zinc coated sheets and aluminium
- No ferritic infection at stainless steel
- Less friction coefficient
- Higher lifetime
- Non-corroding
- Minimised adhesion of material abrasion of the bended part



Insertion of drill holes in dies UKB-System Trumpf

ADVANTAGES

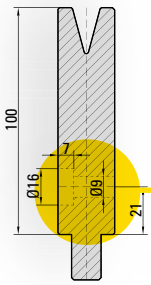
- Cost-saving and fast modification of the 30° dies UKB-System Trumpf for the use with screwable flattening dies 60.120 and 60.130
- According agreement within 1 working day

UKB-INFO

Suitable 30° dies H = 100 mm and H = 150 mm see pages 72 - 78

70.800	
500 mm	26,– €
300 mm	22,– €
200 mm	18,– €
100 mm	12,– €
550 mm sectionalized	54,– €

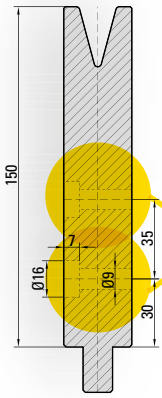
Delivery time 1 - 3 working days



Drill hole in the die for the use of screwable flattening die 60.120

70.810	
500 mm	44,– €
300 mm	38,– €
200 mm	28,– €
100 mm	18,– €
550 mm sectionalized	84,– €

Delivery time 1 - 3 working days



Drill holes in the die for the use of screwable flattening die 60.130

Sectionalized 30° die 25.402 UKB-System Trumpf incl. drill holes 70.800 and screwed on flattening die 60.120

UKB-REPAIR- AND REGRINDING SERVICE

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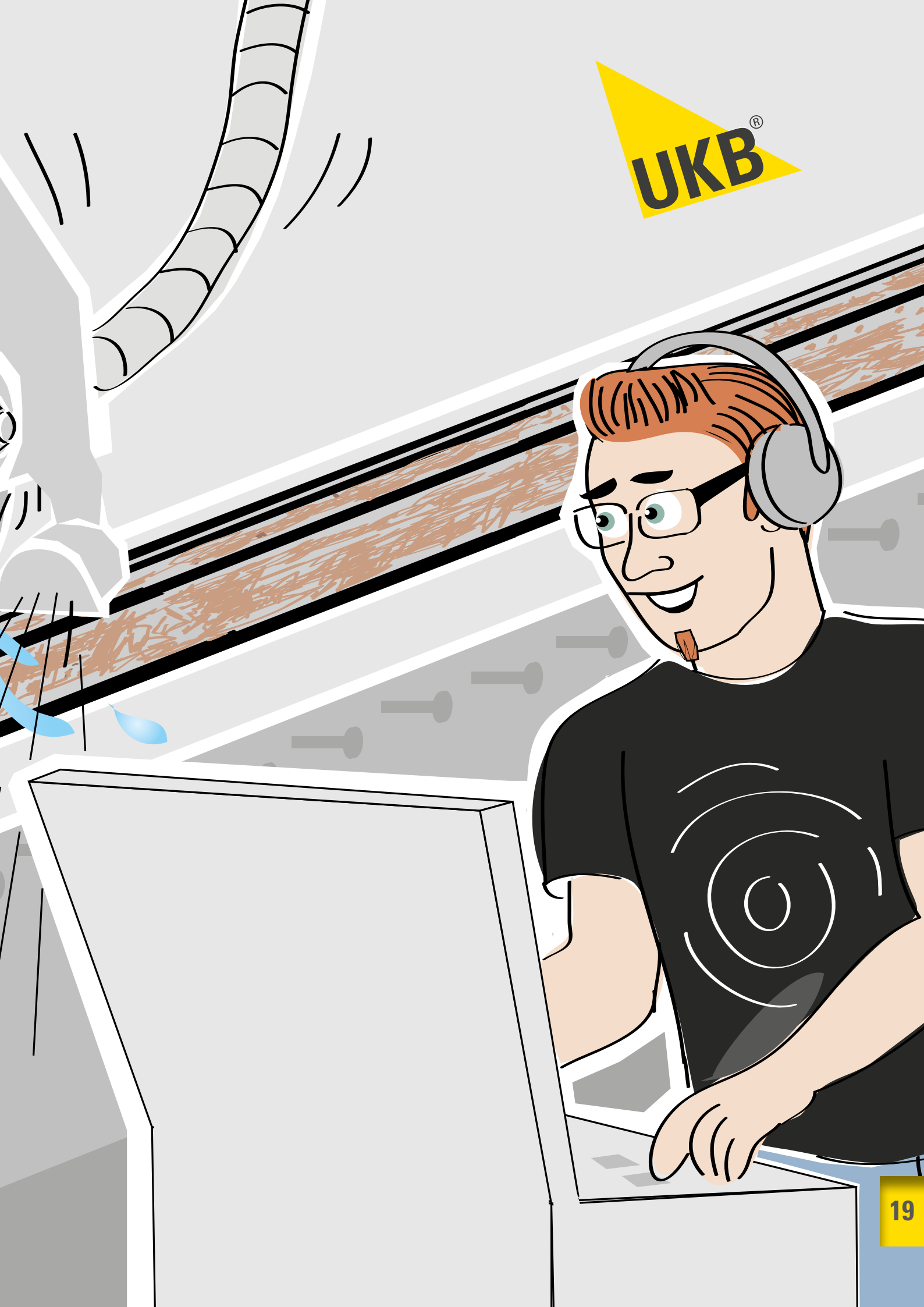
UKB-Holiday flat 256
UKB-Field service 257

FOLLOW US!

WWW.UKB-GMBH.COM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UKB-Regrinding service

Make do and mend!
The regrinding of your press brake tools, we carry out professional, precise, fast and cost-saving.
Our state-of-the-art CNC-profile grinding machines guarantee exact accuracy in shape, parallelism and repeatability.
Additional laser hardening will increase the life time and the wear resistance of your press brake tools.

Also use our fast service for regrinding of your machine tables, slide rails, shear blades (see chapter 20) and other workpieces.

ADVANTAGES

- Fast processing of tools from all manufacturers
- According agreement within 1 working day
- CNC-Profil grinding machines traverse path:
  X = 5.000 mm
  Y = 800 mm
  Z = 700 mm
- High repeatability (also at multiple clampings)
- UKB-Service: Bring your workpieces to our factory in Burbach and stay overnight in our holiday flat free of charge
- You can use our pick-up service

VIDEO

UKB-Repair-and regrinding service

UKB-CONTACT PARTNER

You will find your personal contact partner at
www.ukb-gmbh.de/en/contact/contact-persons

UKB-REPAIR- AND REGRINDING SERVICE

post@ukb-gmbh.com . www.ukb-gmbh.com

UKB-Regrinding service

CNC-Profile grinding machine Rosa Silver 50.9

Laser hardening machine Stiefelmeyer Vario

Tool before

Tool afterwards

UKB-Repair service

Do you have chippings and deformations at your press brake tools and a regrinding is not possible anymore?
Is the cutting out of the damaged part and a sectionalizing of the press brake tool not desired?
Is a new production to expensive?

Our solution: We WELD material on the damaged part before regrinding!
Please tell us, if possible, the raw material of your press brake tool,
to reach an optimum result of the reworking.

Weld on of a damaged tool (MAG welding)

WIG welding

Chipping

Welded on

Regrinded

UKB-HOLIDAY FLAT

We rework your workpieces - while you relax!

Is the delivery with a forwarder too complicated for you?
You can spare your tools only short-term?
Just bring them personally to us and use our special service:

Relax with a free stay in our holiday flat
- while we provide the services for you!

5 km away from UKB, in an area of outstanding natural beauty, you can enjoy a good time with your partner.

The community Burbach with about 14.500 residents in 9 city districts is located at an altidue between 310 to 617 meter, in the border triangle of Nordrhein Westfalen, Hessen and Rheinland Pfalz between Frankfurt, Dortmund and Cologne.

In the most well-wooded region of cental Europe, just a few kilometers from the city of Siegen, Burbach is the ideal starting point for a lot of activities:

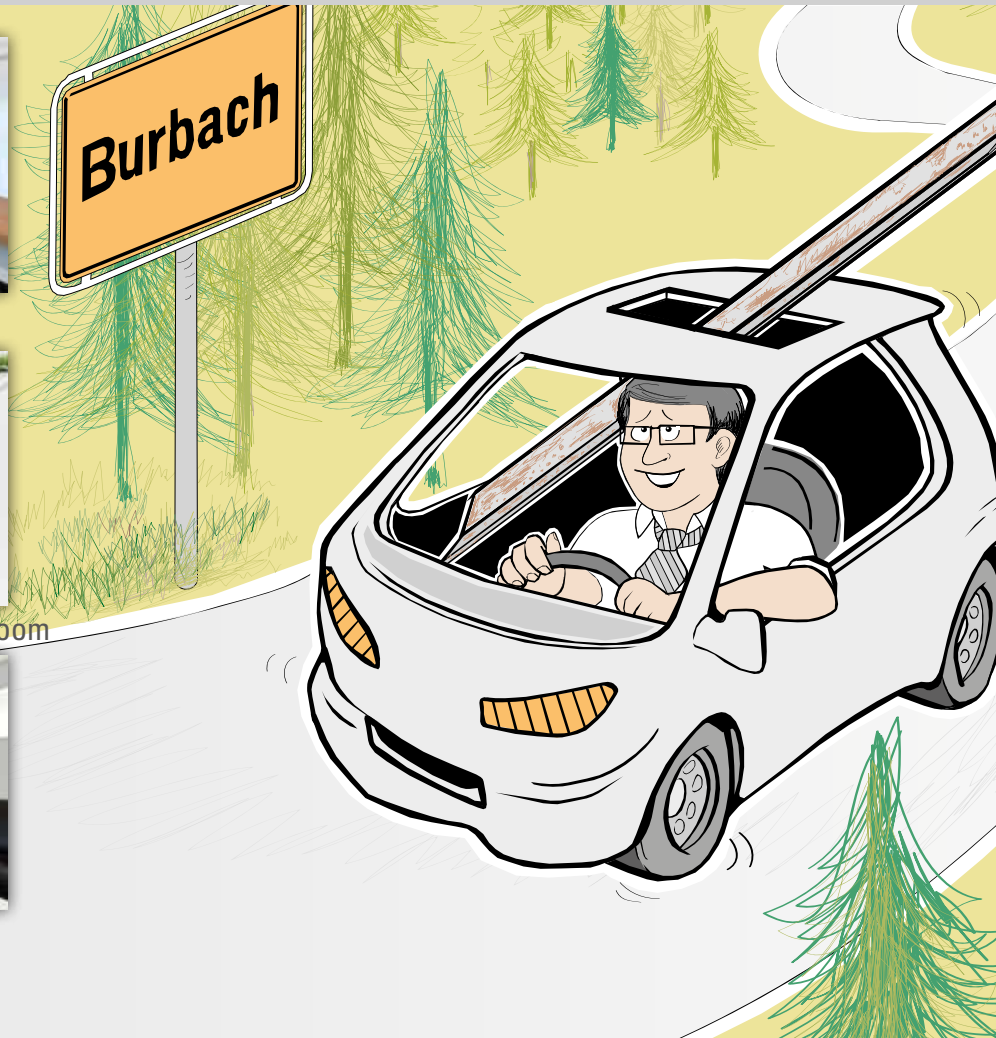
- Hiking, cycling, and e-bike riding in idyllic nature (e.g. Rothaarsteig, Westerwaldsteig and other trails)
- Numerous reservoirs and lakes with varied circular trails and offers for water sports
- Beautiful and historical communities and cities

Further information about the UKB-holiday flat can be found at www ukb-gmbh.com

Arrive relaxed and enjoy

Nice and comfortable double bedroom

Generous living room with kitchen
for self-catering



UKB-FIELD SERVICE

Committed and customer oriented!

Are you interested in our products and would you like individual advice on site?
Our field service staff will gladly visit you. Of course for you free of charge and without obligation.

Our tasks:

- Individual advice and sale
- Technical solutions for special bending tasks
- Test bending on-site
- Tool demonstrations
- Pick up service for tools to rework

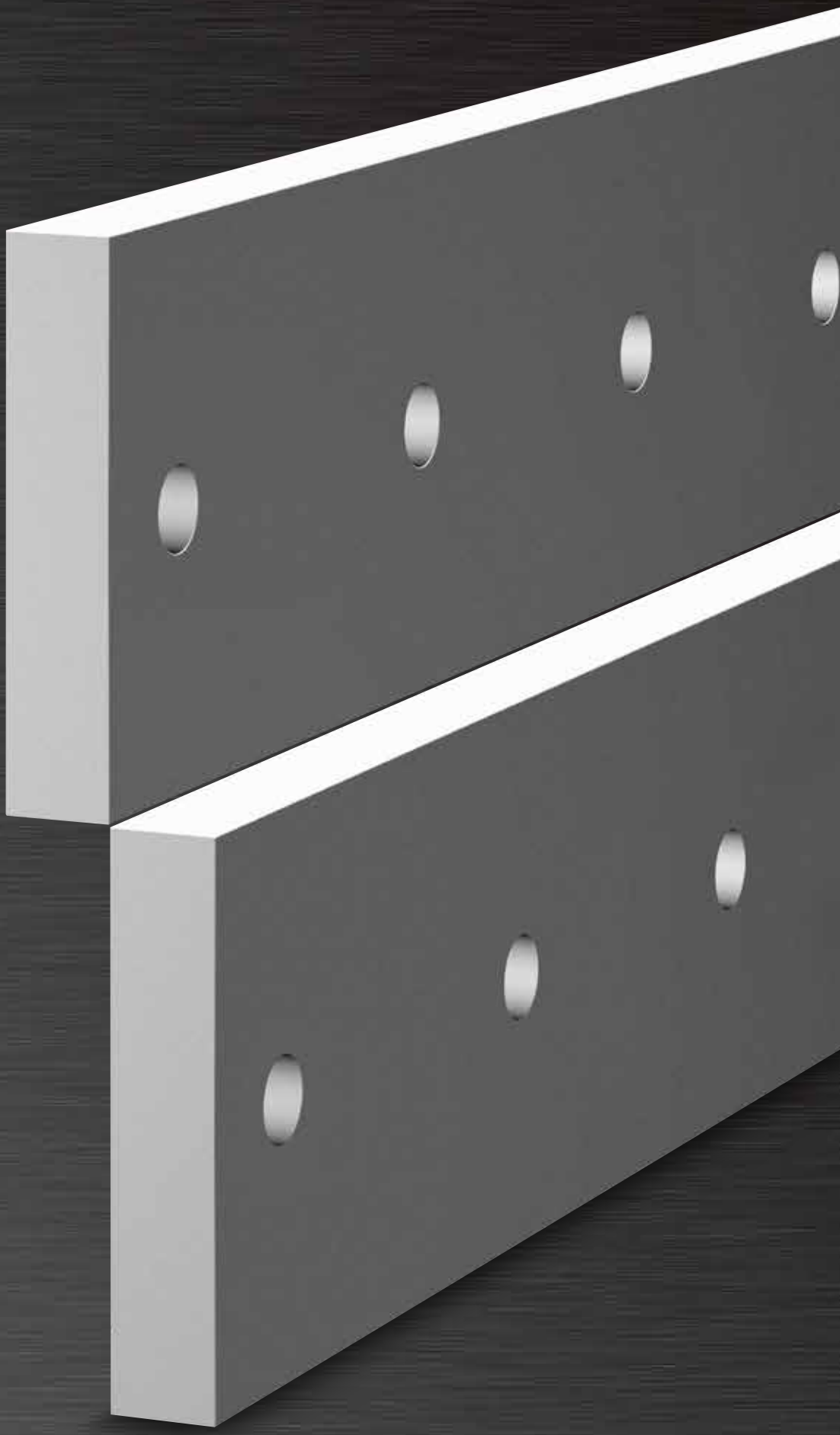
UKB-INFO

Make an appointment:
Your personal contact partner can be found at:
www.ukb-gmbh.de/en/contact/contact-persons
or contact us directly in our live chat

UKB-SHEAR BLADES

Production of shear blades 260
Regrinding of shear blades 261
Flat grinding 261

FOLLOW US!



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Production of shear blades

ADVANTAGES

For your shear we produce shear blades according to your specifications. The raw material of the blades is selected espacially for the use and the material that have to be cut.

- ▶ Up to 4.200 mm in one-piece
- ▶ 4-, 2- or 1 cutting edge
- ▶ With threaded hole or double sided countersink
- ▶ Use of alloyed and high-alloyed materials

Guillotine shear

Machine type/ manufacturer	

Your contact details

Company	
Street	
ZIP-code/Town	
Phone/fax	
E-Mail	
Contact person	

Standard tolerances

Hardeness	Height	Width	Parallelism
± 1HRc	± 0,5 mm	± 0,2 mm	± 0,03 mm

Kind of material/frequency

Aluminium	about	%
Mild steel	about	%
Stainless steel	about	%
Other materials	about	%

Material thickness/frequency

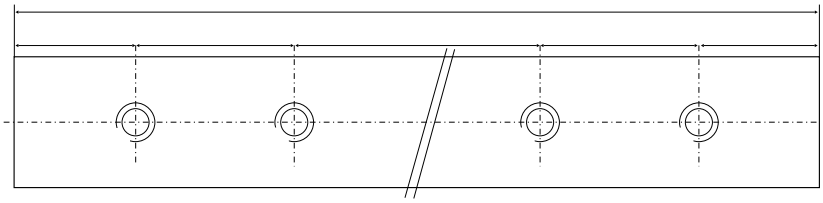
min. mat.-thickness	mm	about	%
Average mat.-thickness	mm	about	%
max. mat.-thickness	mm	about	%

Application frequency/day

By the hour	Yes	No
One-shift operation	Yes	No
Multi-shift operation	Yes	No

Quantity

Upper-blade	Pieces
Lower-blade	Pieces

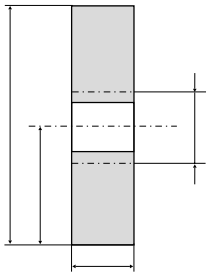


UKB-INFO

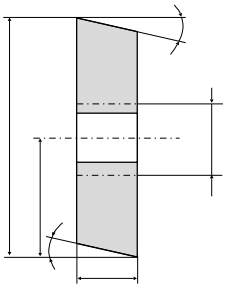
Copy this datasheet or download at www.ukb-gmbh.com
Simply fill in and send back!

Examples:

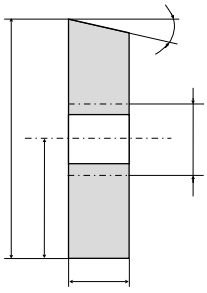
4 - Cutting edges with threaded hole



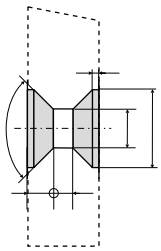
2 - Cutting edges with threaded hole



1 - Cutting edge with threaded hole



Double sided countersink



Regrinding of shear blades

- Delivery time: 1 working day (according agreement)
- Up to 5.000 mm in one-piece
- 4-, 2- or 1 cutting edge

Contact us!

UKB-CONTACT PARTNER

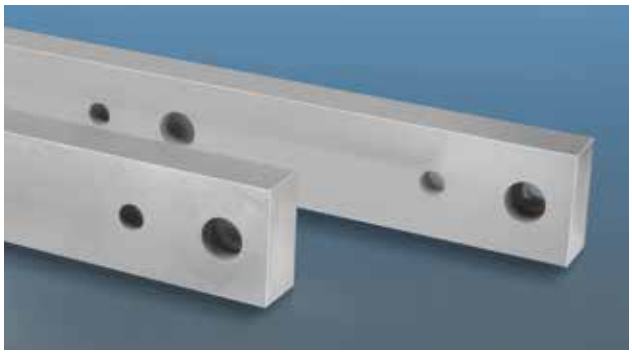
You will find your personal contact partner at www.ukb-gmbh.de/en/contact/contact-persons

Guiding price for regrinding

Length (mm)	Price per piece	Price per piece if minimum 2 blades have the same height and thickness
till 1.200	70,– €	50,– €
till 1.700	80,– €	60,– €
till 2.200	90,– €	70,– €
till 2.700	110,– €	85,– €
till 3.200	130,– €	105,– €
till 3.700	160,– €	130,– €
till 4.200	180,– €	150,– €
till 5.000	200,– €	170,– €

Guiding prices are valid for shear blades with general wear

Before



After

Flat grinding

Traverse path: X = 5.000 mm, Y = 800 mm, Z = 700 mm
With our flat grinding machines we realize face- and parallel grinding work fast and cost-saving.

Use this advantage for:

- Flat steel
- Slide rail
- Steel strips
- Machine tables
- Shear blades
- And many more

UKB–UWE KRUMM GMBH

1991
Founding the company UKB (Uwe and Jan Thomas Krumm)

1994
Constant staff growth

1996
New company building at Burbach´s industrial area

1999
Start with own special tool production

2003
Construction of a new storage facility

2008
Expansion of the production hall

2013
Biggest investment in its machinery since company foundation

2014
Expansion of the storage facility

2016
Celebrating the 25th anniversary of UKB

2017
New building for the field service department

2018
Takeover of the press brake tool section of company BR Tec Röschli

2019
Investment in six new CNC-machining centres

2020

Further investments in its machinery

Extract from terms and conditions

The following is only an extract from the full terms and conditions of UKB - Uwe Krumm GmbH

- All articles ex works, unpacked, duty unpaid
- UKB GmbH has the right to charge interest on late payments at 8% above the existing base rate for such time as the payment is overdue.
  For each dunning letter we charge 5,- Euro share of expenses
- Prices and technical data are subject to change without notice
- When publishing this catalogue all previous editions of the catalogue become invalid
- All prices exclude VAT
- The goods remain the property of UKB GmbH until payment is received in full
- Return of goods is only allowed after prior consultation with UKB GmbH
- The legal court for delivery and payment is Siegen, Germany
- Only our terms and conditions of business are valid
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- Full terms and conditions on request or see **www.ukb-gmbh.com**

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