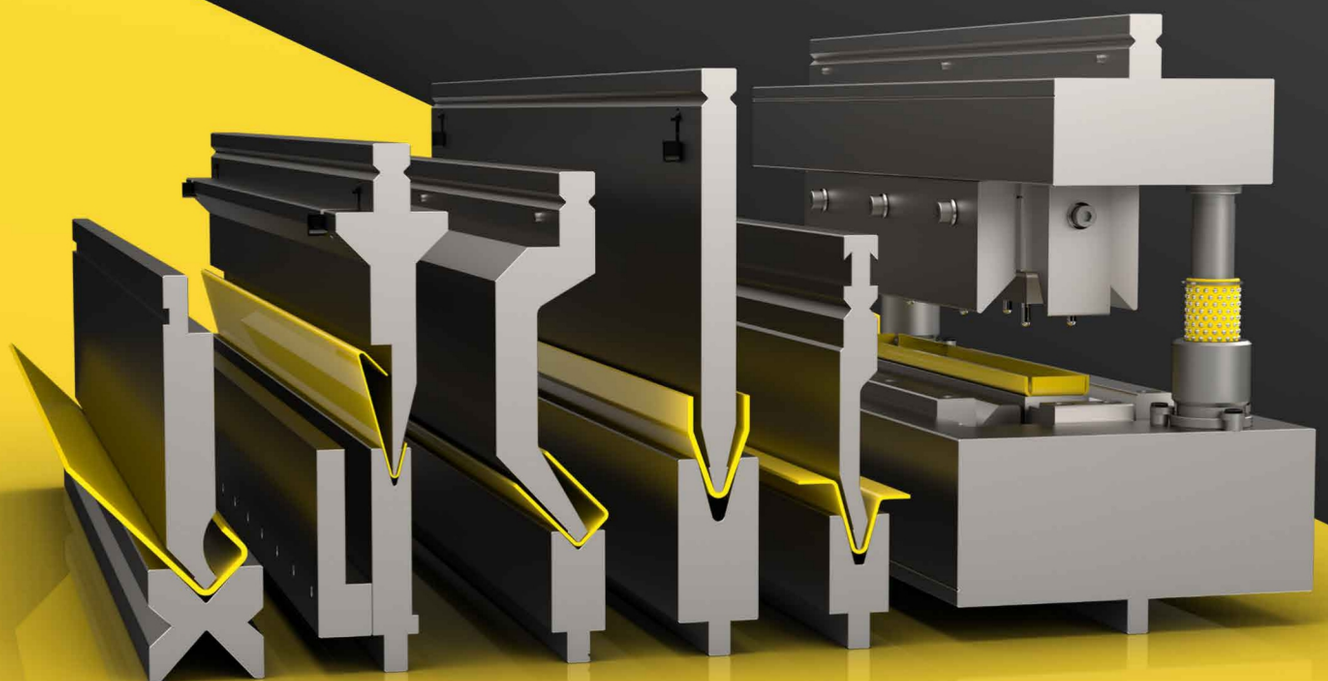
EDITION 14

ProgTools
Sweden AB

UKB®

PRESS BRAKE TOOLS



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EDITION 14

WWW.UKB-GMBH.COM

PRESS BRAKE TOOLS

UKB - UWE KRUMM GMBH

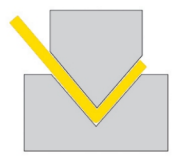
Tables of force

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



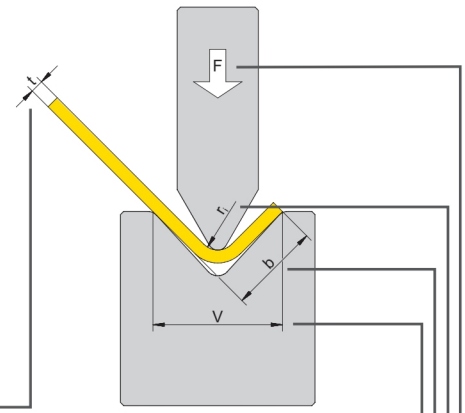


Table of force: needed force for 90° air bending, resistance R_m = 510 N/mm², mild steel

t (mm)	4	5	6	8	10	12	16	20	24	30	40	50	60	70	80	90	100	120	160	200	
	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, rusty or ungreased sheets increase the necessary pressing force considerably

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	
	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

UKB-Image



UKB-Special tools I



see chapter 12

UKB-Special tools II



see chapter 12

UKB-Press brake tool systems



see chapter 01 - 06

UKB-Modification of press brake tools



see chapter 18

UKB-Repair- and regrinding service



see chapter 19

UKB-System Corner Former



UKB-Adjustable dies



see chapter 11

UKB-Flattening tools



see chapter 01, 02, 04, 05

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



see chapter 07

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



see chapter 08

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



see chapter 09

UKB-UniBend and UKB-WingBend PLUS



see chapter 10

UKB-Mark free and mark reduced bending



see chapter 14

UKB-Press brake tool cabinets



see chapter 16

UKB-Accessories



see chapter 17

UKB-Protective film



see chapter 13

UKB-Vibro Hammer



see chapter 17

UKB-„SpeedGrip"



see chapter 01

YOUR PERSONAL UKB-CONTACT PERSONS

We are permanently available for you Monday to Friday from 7:30am to 5:00pm

	Phone	E-Mail
HEADQUARTER BURBACH	+49 (0) 27 36 / 44 42 - 0	post@ukb-gmbh.com
SALES		
Holger Oehm	+49 (0) 27 36 / 44 42 - 101	h.oehm@ukb-gmbh.de
Sabrina Otto-Neubert	+49 (0) 27 36 / 44 42 - 102	s.otto-neubert@ukb-gmbh.de
Frank Oberzaucher	+49 (0) 27 36 / 44 42 - 103	f.oberzaucher@ukb-gmbh.de
Katarzyna Trybanski	+49 (0) 27 36 / 44 42 - 105	k.trybanski@ukb-gmbh.de
Sabine Lieber	+49 (0) 27 36 / 44 42 - 106	s.lieber@ukb-gmbh.de
Isabell Kasteleiner	+49 (0) 27 36 / 44 42 - 109	i.kasteleiner@ukb-gmbh.de
Maren Möller-Klein	+49 (0) 27 36 / 44 42 - 111	m.moeller-klein@ukb-gmbh.de
Leif Möller	+49 (0) 27 36 / 44 42 - 113	l.moeller@ukb-gmbh.de
Diana Kasteleiner	+49 (0) 27 36 / 44 42 - 114	d.kasteleiner@ukb-gmbh.de
Debora Schäfer	+49 (0) 27 36 / 44 42 - 117	d.schaefer@ukb-gmbh.de
Leo Popovic	+49 (0) 27 36 / 44 42 - 119	l.popovic@ukb-gmbh.de
Leonit Bajrami	+49 (0) 27 36 / 44 42 - 120	l.bajrami@ukb-gmbh.de
TECHNICAL SALES		
Mayk Bohn	+49 (0) 27 36 / 44 42 - 201	m.bohn@ukb-gmbh.de
Gerald Manderbach	+49 (0) 27 36 / 44 42 - 202	g.manderbach@ukb-gmbh.de
Daniel Ströher	+49 (0) 27 36 / 44 42 - 205	d.stroeher@ukb-gmbh.de
René Wünsche	+49 (0) 27 36 / 44 42 - 207	r.wuensche@ukb-gmbh.de
Nils Kolb	+49 (0) 27 36 / 44 42 - 209	n.kolb@ukb-gmbh.de
Endrit Peci	+49 (0) 27 36 / 44 42 - 213	e.peci@ukb-gmbh.de
CONSTRUCTION / PRODUCTION PLANNING		
Dominik Enners	+49 (0) 27 36 / 44 42 - 204	d.enners@ukb-gmbh.de
Nick Zey	+49 (0) 27 36 / 44 42 - 206	n.zey@ukb-gmbh.de
Markus Oppermann	+49 (0) 27 36 / 44 42 - 208	m.oppermann@ukb-gmbh.de
Fabian Kretzer	+49 (0) 27 36 / 44 42 - 211	f.kretzer@ukb-gmbh.de
MANAGEMENT		
Jan Thomas Krumm, Managing Director	+49 (0) 27 36 / 44 42 - 203	jt.krumm@ukb-gmbh.de
Uwe Krumm, Managing Director	+49 (0) 27 36 / 44 42 - 300	u.krumm@ukb-gmbh.de
Sandra Meschkat, Authorized signatory	+49 (0) 27 36 / 44 42 - 107	s.meschkat@ukb-gmbh.de
Tim Frank, Authorized signatory	+49 (0) 27 36 / 44 42 - 104	t.frank@ukb-gmbh.de

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HIGH QUALITY PRESS BRAKE TOOLS & INDIVIDUAL SPECIAL TOOLS!

EXPERTISE & PROGRESS

As a family-owned company, we are proud of our independence. Since our founding in 1991, we have evolved from selling tools out of a garage into a full-service supplier of professional press brake tools and individual special tools. We offer a wide range of production capabilities, utilize the latest technologies, and continuously optimize our processes . Our greatest milestone came in 2022 with the move into our newly constructed company premises, set in open countryside in the town of Burbach. With 6,500 m² of production and storage space, along with an additional 1,500 m² of office and social areas, we are well-positioned to maintain our high level of customer support into the future. To further enhance our capabilities, the new facility has been equipped with additional state-of-the-art machinery to complement our existing equipment.



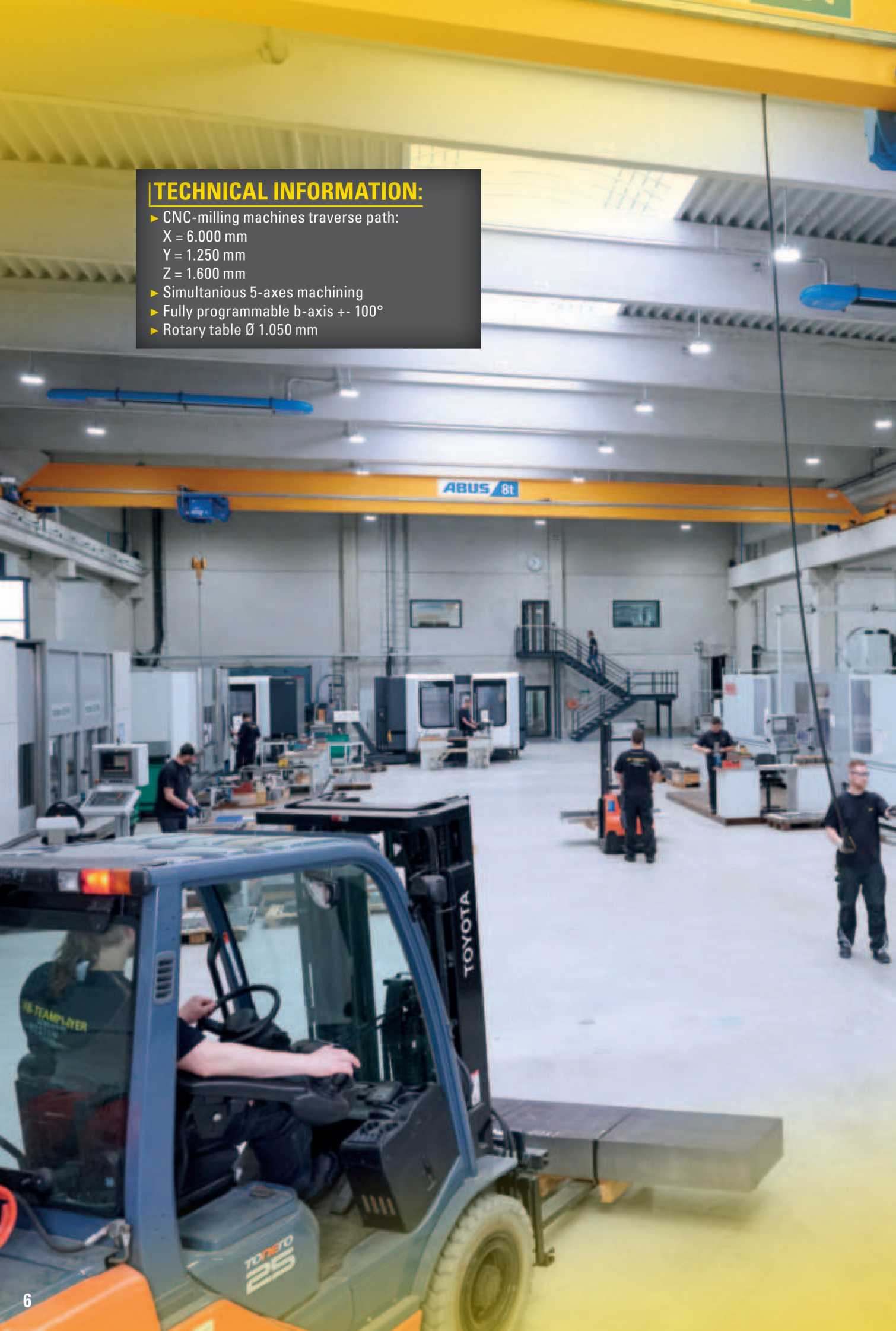
Our focus is on customer satisfaction We achieve this by delivering high-quality products, ensuring availability, and offering flexible service that allows us to provide tailored, individual solutions. This has been our philosophy for over 35 years — and it will continue to guide us in the future.



Management: Uwe Krumm, Tim Frank, Sandra Meschkat and Jan Thomas Krumm

UKB-UWE KRUMM GMBH

Headquarter Burbach / Germany



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 1.050 mm



CNC-MILLING SHOP

State-of-the-art CNC-milling machines



TECHNICAL INFORMATION:

- CNC-profile grinding machines traverse path:
  X = 6.000 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!



TECHNICAL SALES / CONSTRUCTION

Development and construction of
press brake tools and special tools!



FIELD SERVICE

Committed and close to the customer!



STOCK

Extensive range of tools
and fast availability!

PRESS BRAKE TOOLS
UKB-SYSTEM AMADA

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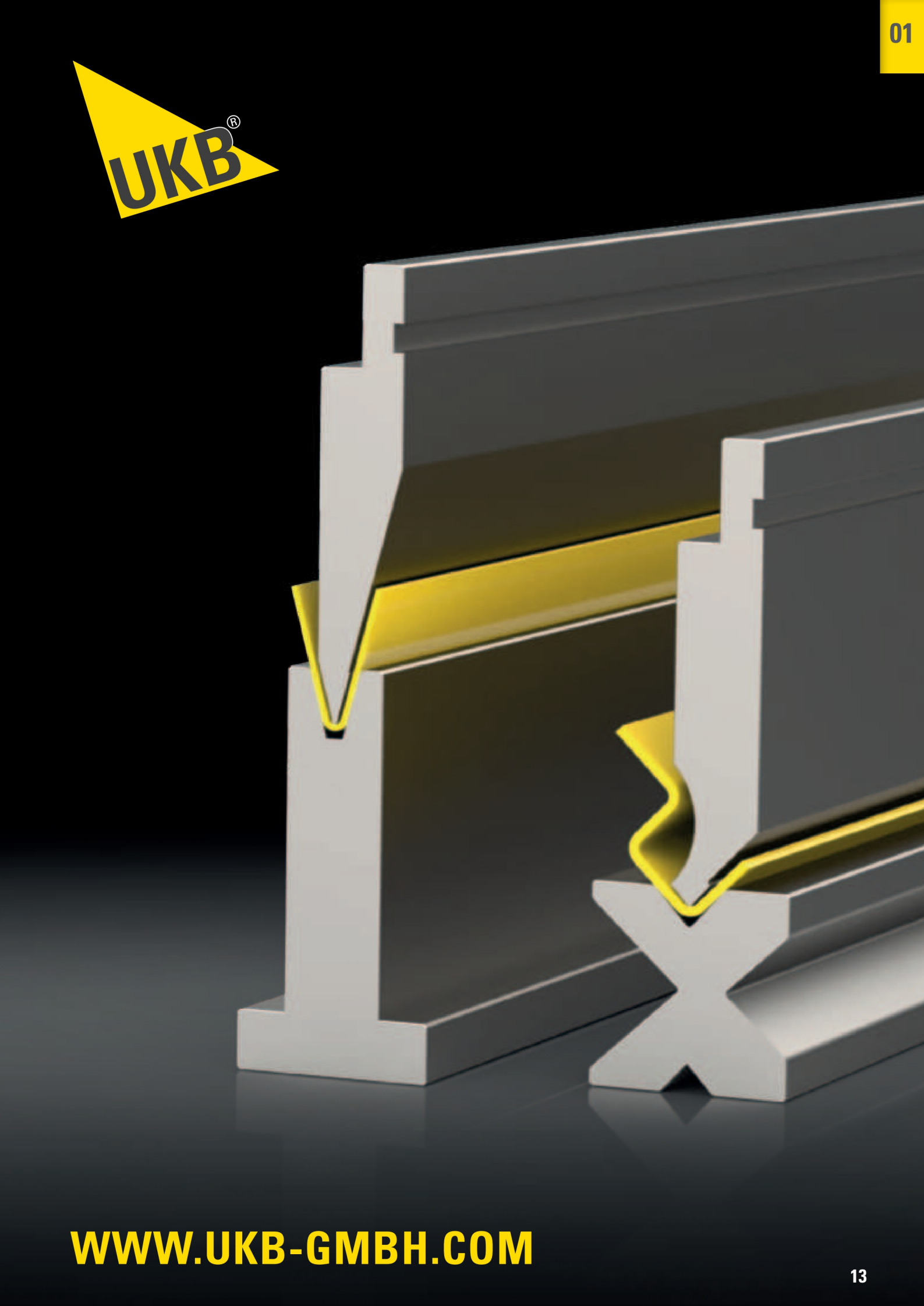

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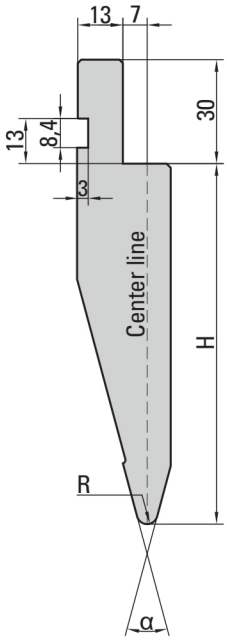
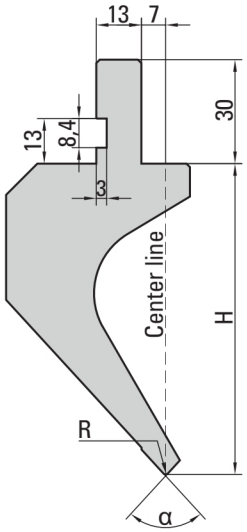
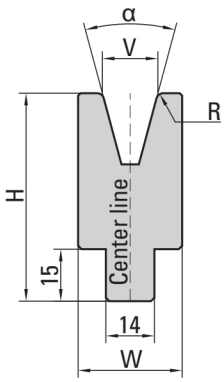
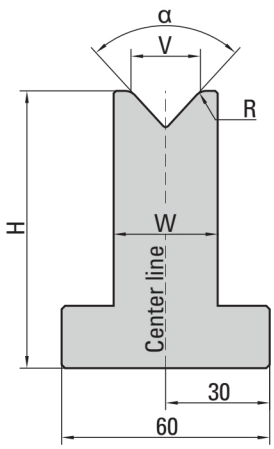
Quality and precision

- **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**
- **Tool marking** with all technical information









VIDEO

UKB-Press brake tool systems

UKB-ADVANTAGES

VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:	According agreement
Direct courier:	According agreement

- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Tool lengths

PUNCHES/TOP TOOLS

835 mm



415 mm



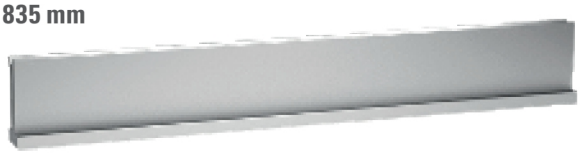
800 mm sectionalized



- 10 Segments, with horn extension left and right

DIES

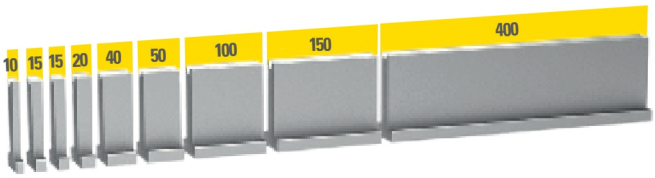
835 mm



415 mm

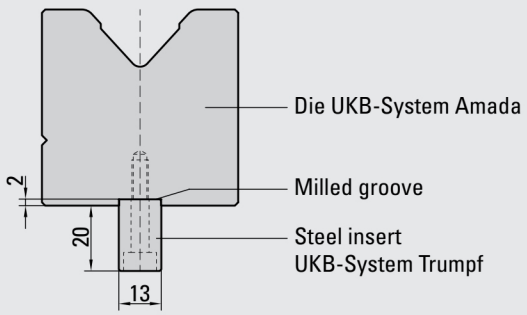


800 mm sectionalized



- 9 Segments

MODIFICATION OF DIES UKB-SYSTEM AMADA





VIDEO

UKB-Modification of press brake tools

UKB-INTERMEDIATES „SPEEDGRIP“

- Quick **vertical** tool change for punches/top tools UKB-System Amada - without modification
- Automatic clamping and centering
- Cost-effective, simple and quick retrofit of your press brake

PAGES 40-44



85° Punches/top tools

11.200

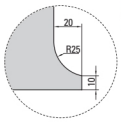
24h

1000 kN/m

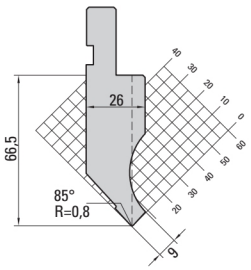
835 mm	11,1 kg	154,– €
415 mm	5,5 kg	92,– €
800 mm sectionalized	10,1 kg	260,– €

88° Punch/top tool 11.145 on request

SCAN TO SHOP







11.201

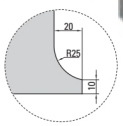
24h

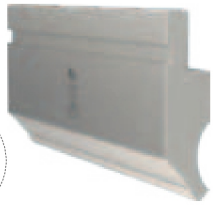
1000 kN/m

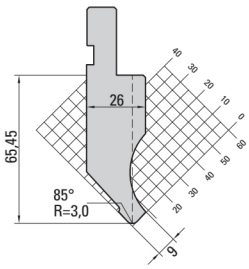
835 mm	11,0 kg	154,– €
415 mm	5,5 kg	92,– €
800 mm sectionalized	10,1 kg	260,– €

88° Punch/top tool 11.101 on request

SCAN TO SHOP







10.170

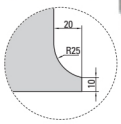
24h

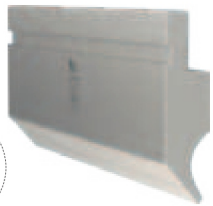
350 kN/m

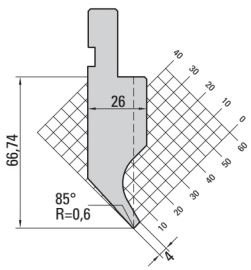
835 mm	10,6 kg	238,– €
415 mm	5,3 kg	136,– €
800 mm sectionalized	9,7 kg	362,– €

88° Punch/top tool 10.176 on request

SCAN TO SHOP







11.230

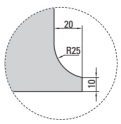
24h

1000 kN/m

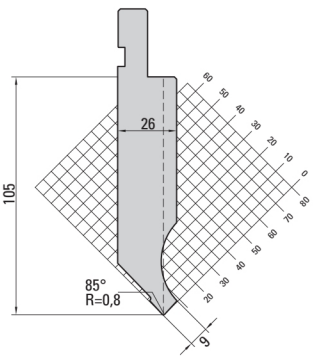
835 mm	17,7 kg	292,– €
415 mm	8,8 kg	170,– €
800 mm sectionalized	16,2 kg	440,– €

88° Punch/top tool 11.228 on request

SCAN TO SHOP







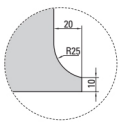
11.231

24h

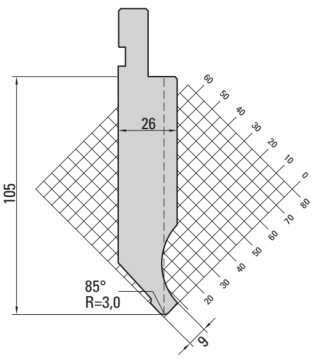
1000 kN/m

835 mm	17,7 kg	292,– €
415 mm	8,8 kg	170,– €
800 mm sectionalized	16,2 kg	440,– €

SCAN TO SHOP







11.232

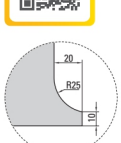
24h

1000 kN/m

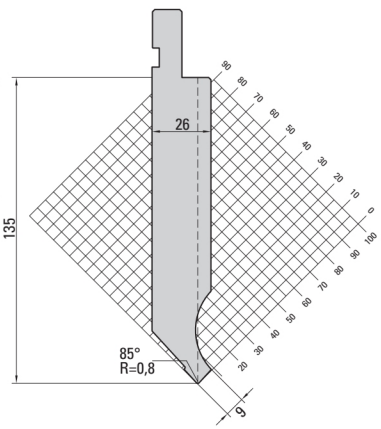
835 mm	22,8 kg	400,– €
415 mm	11,3 kg	230,– €
800 mm sectionalized	20,7 kg	630,– €

88° Punch/top tool 11.870 on request

SCAN TO SHOP





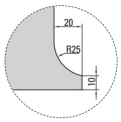


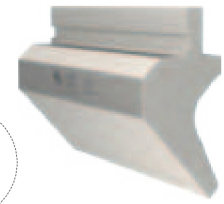
11.660 — 24h — 600 kN/m

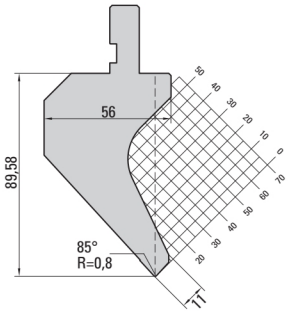
835 mm	20,9 kg	328,– €
415 mm	10,4 kg	186,– €
800 mm sectionalized	19,1 kg	478,– €

88° Punch/top tool 11.146 on request

SCAN TO SHOP



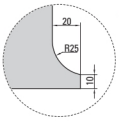


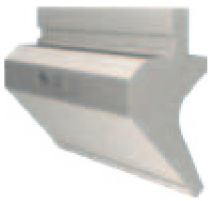


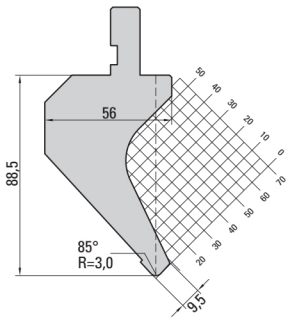
11.863 — 24h — 600 kN/m

835 mm	19,9 kg	328,– €
415 mm	9,9 kg	186,– €
800 mm sectionalized	18,2 kg	478,– €

SCAN TO SHOP





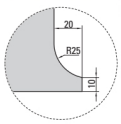


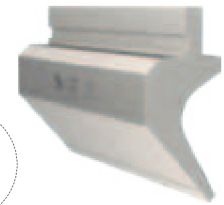
11.865 — 24h — 500 kN/m

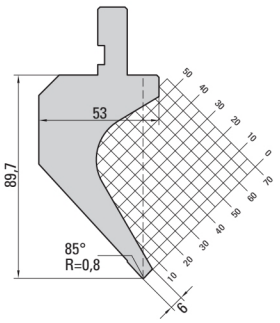
835 mm	16,9 kg	422,– €
415 mm	8,4 kg	236,– €
800 mm sectionalized	15,4 kg	580,– €

88° Punch/top tool 10.502 on request

SCAN TO SHOP





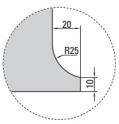


11.151 — 24h — 500 kN/m

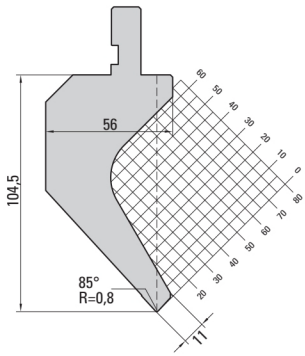
835 mm	22,5 kg	392,– €
415 mm	11,2 kg	218,– €
800 mm sectionalized	20,5 kg	546,– €

88° Punch/top tool 11.147 on request

SCAN TO SHOP



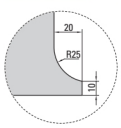




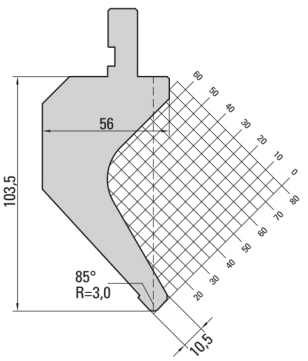
11.866 — 24h — 500 kN/m

835 mm	22,1 kg	392,– €
415 mm	11,0 kg	218,– €
800 mm sectionalized	20,2 kg	546,– €

SCAN TO SHOP







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toolsystems24.de
schanksysteme24.de

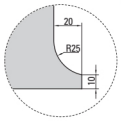
85° Punches/top tools

11.650 — 24h — 500 kN/m

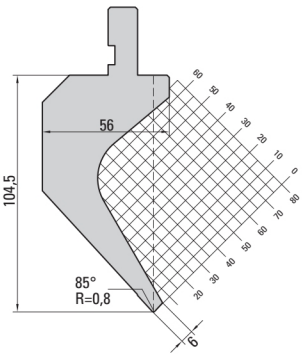
835 mm	20,3 kg	440,– €
415 mm	10,1 kg	250,– €
800 mm sectionalized	18,5 kg	608,– €

88° Punch/top tool 10.504 on request

SCAN TO SHOP



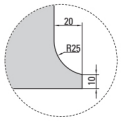


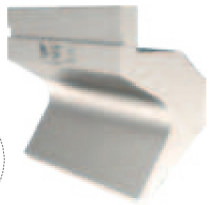


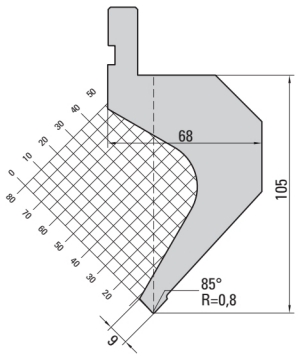
11.869 — 24h — 450 kN/m

835 mm	23,8 kg	804,– €
415 mm	11,8 kg	438,– €
800 mm sectionalized	21,6 kg	988,– €

SCAN TO SHOP





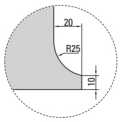


11.835 — 24h — 500 kN/m

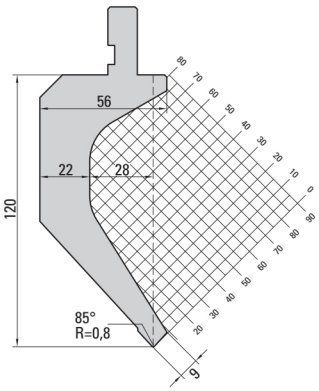
835 mm	21,4 kg	788,– €
415 mm	10,6 kg	436,– €
800 mm sectionalized	19,5 kg	1.020,– €

88° Punch/top tool 10.505 on request

SCAN TO SHOP





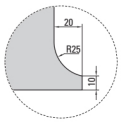


11.270 — 24h — 500 kN/m

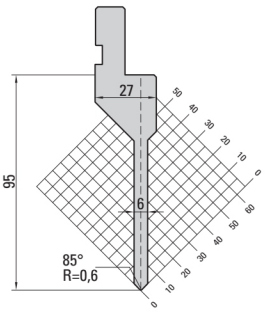
835 mm	9,1 kg	388,– €
415 mm	4,5 kg	220,– €
800 mm sectionalized	8,3 kg	532,– €

88° Punch/top tool 11.260 on request

SCAN TO SHOP







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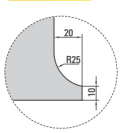
85° Punches/top tools

11.861 — 24h — 500 kN/m

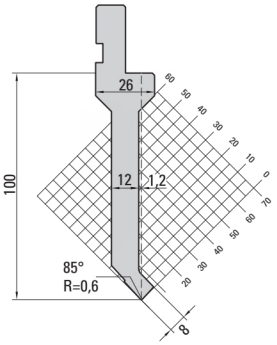
835 mm	10,5 kg	352,– €
415 mm	5,3 kg	200,– €
800 mm sectionalized	10,0 kg	498,– €

88° Punch/top tool 10.262 on request

SCAN TO SHOP



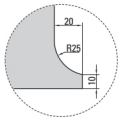




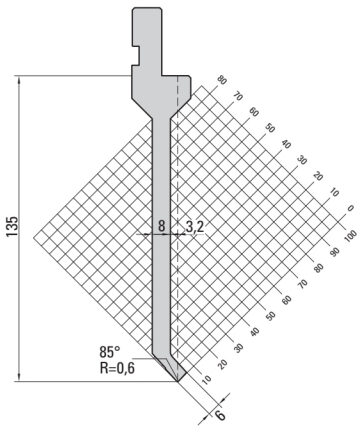
11.855 — 24h — 400 kN/m

835 mm	11,0 kg	516,– €
415 mm	5,5 kg	288,– €
800 mm sectionalized	10,1 kg	802,– €

SCAN TO SHOP



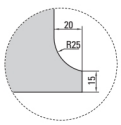




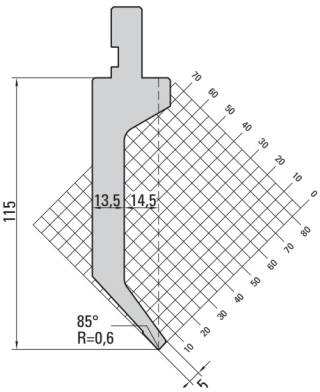
11.820 — 24h — 200 kN/m

835 mm	13,7 kg	660,– €
415 mm	6,8 kg	368,– €
800 mm sectionalized	12,5 kg	948,– €

SCAN TO SHOP







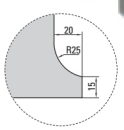
UKB-INTERMEDIATES „SPEEDGRIP“
PAGES 40 - 44

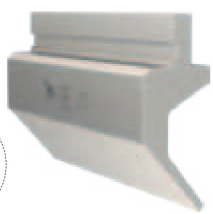


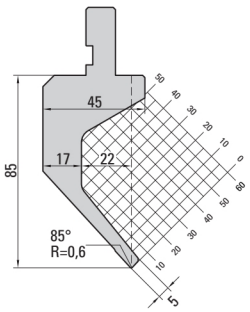
11.831 — 24h — 120 kN/m

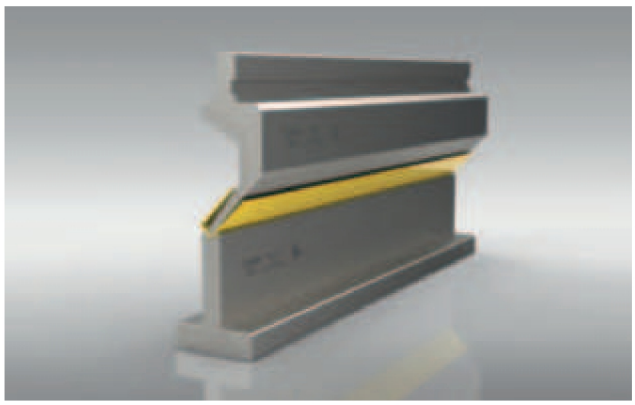
835 mm	12,8 kg	590,– €
415 mm	6,4 kg	328,– €
800 mm sectionalized	11,9 kg	836,– €

SCAN TO SHOP







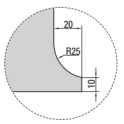


85° Punches/top tools

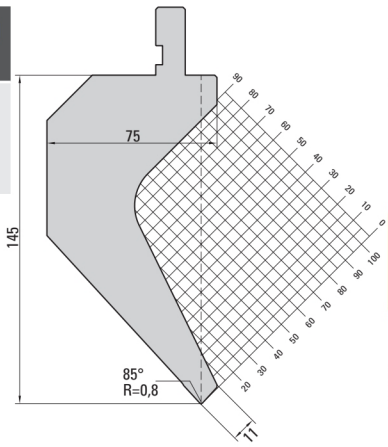
11.848 — 24h — 700 kN/m

835 mm	39,3 kg	942,– €
415 mm	19,5 kg	526,– €
800 mm sectionalized	35,3 kg	1.312,– €

SCAN TO SHOP



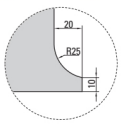




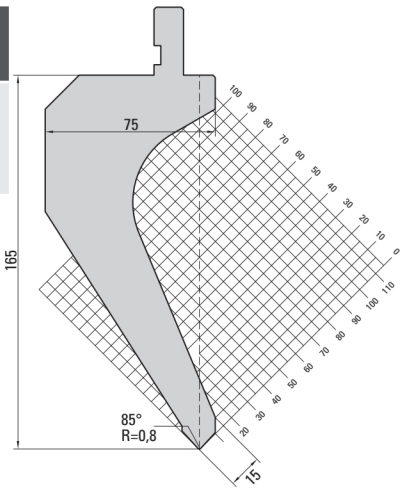
11.849 — 24h — 600 kN/m

835 mm	41,1 kg	1.156,– €
415 mm	20,4 kg	634,– €
800 mm sectionalized	38,1 kg	1.540,– €

SCAN TO SHOP



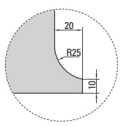




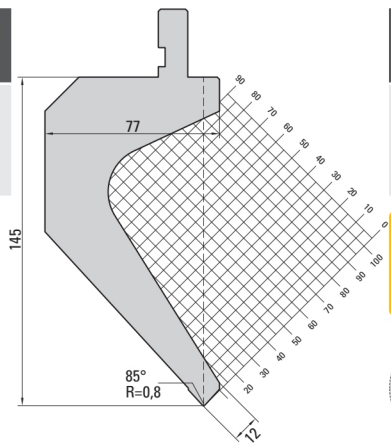
11.670 — 24h — 600 kN/m

835 mm	34,8 kg	1.136,– €
415 mm	17,3 kg	596,– €
800 mm sectionalized	31,7 kg	1.478,– €

SCAN TO SHOP



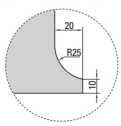




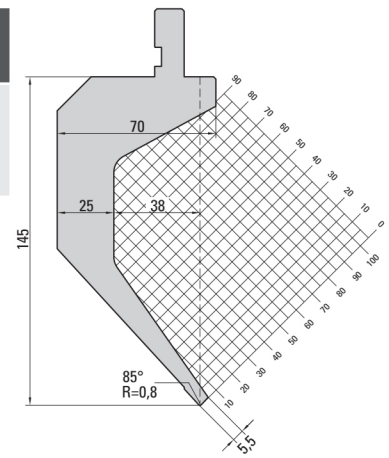
11.680 — 24h — 250 kN/m

835 mm	27,7 kg	1.190,– €
415 mm	13,8 kg	640,– €
800 mm sectionalized	25,3 kg	1.566,– €

SCAN TO SHOP







UKB-FIELD SERVICE

- Individual advice and sale
- Test bending in your house or at the UKB-Test Center
- Tool demonstrations
- Pick up service for tools to rework

CHAPTER 19



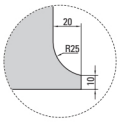
85° Punches/top tools

11.840 — 24h — 600 kN/m

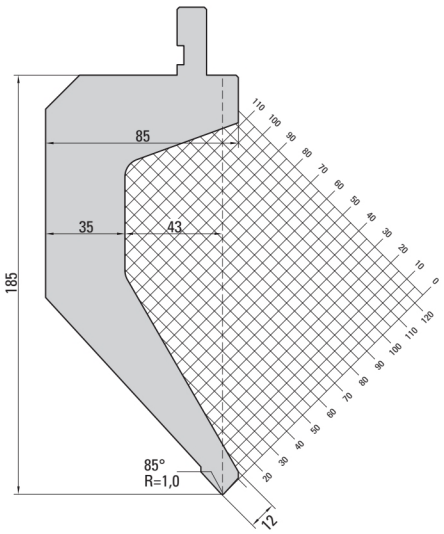
505 mm	29,5 kg	966,– €
500 mm sectionalized	27,2 kg	1.636,– €

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

SCAN TO SHOP





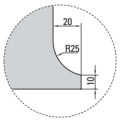


11.850 — 24h — 400 kN/m

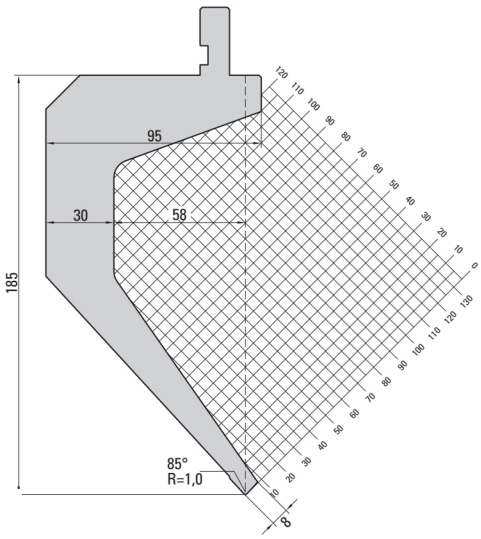
505 mm	25,4 kg	1.212,– €
500 mm sectionalized	23,6 kg	1.904,– €

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

SCAN TO SHOP





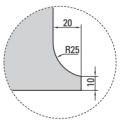


11.800 — 24h — 700 kN/m

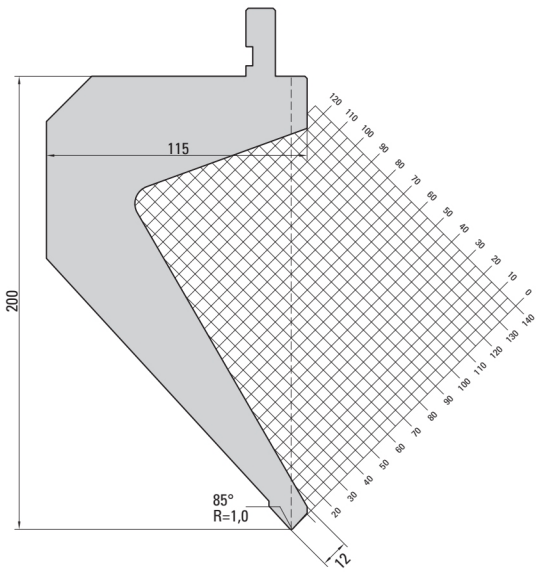
505 mm	39,5 kg	1.298,– €
500 mm sectionalized	36,5 kg	2.068,– €

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

SCAN TO SHOP







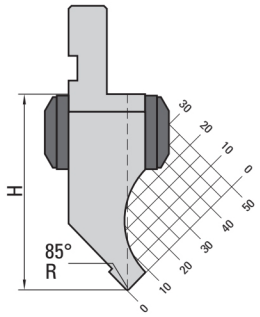
85° Punch/top tool end pieces with movable horn extensions

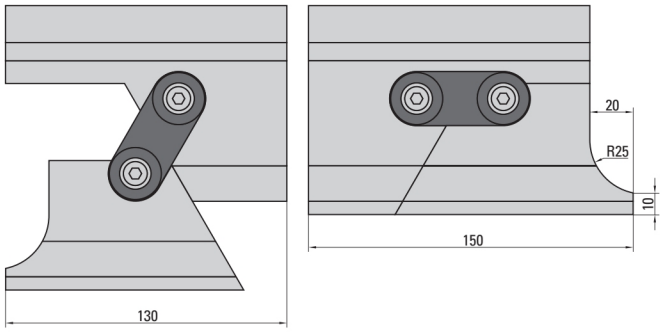
85°					24h 150 kN/m
Model	Suitable for punch/top tool	R (mm)	H	kg	Price per pair left/right
40.114	11.200	0,8	66,50	3,5	990,– €
40.116	11.201	3,0	65,45	3,5	990,– €
40.122	10.170	0,6	66,74	3,5	1.016,– €

SCAN TO SHOP

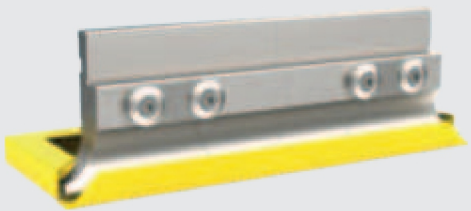
ADVANTAGES

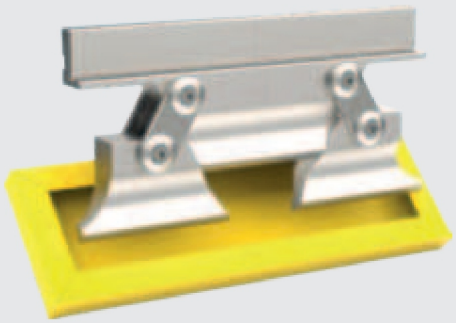
- **Easy and quick** bending of boxes
- **Easy removal** of the finished profile
- **Compatible** with punches/top tools (see table)
- **Individual production** possible





EXAMPLE OF USE









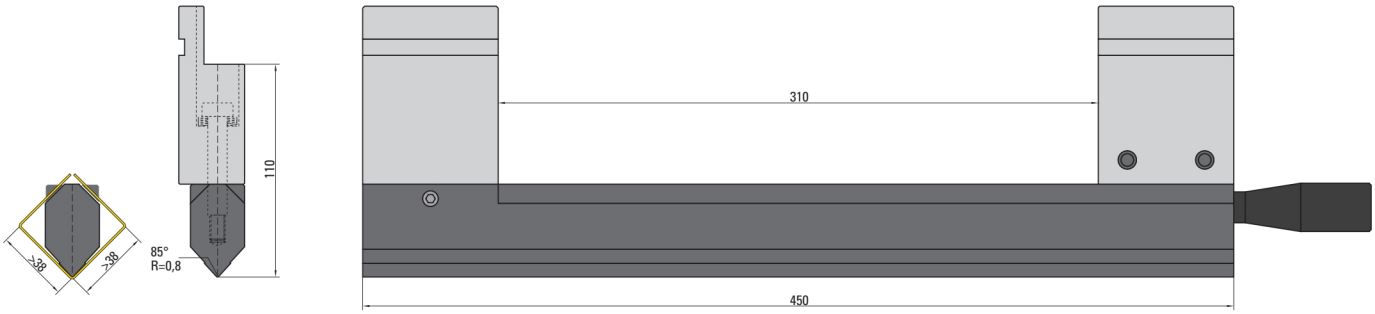
85° Window punch/top tool for closed boxes „Rotax®“

40.680		24h 150 kN/m
450 mm	7,0 kg	972,– €

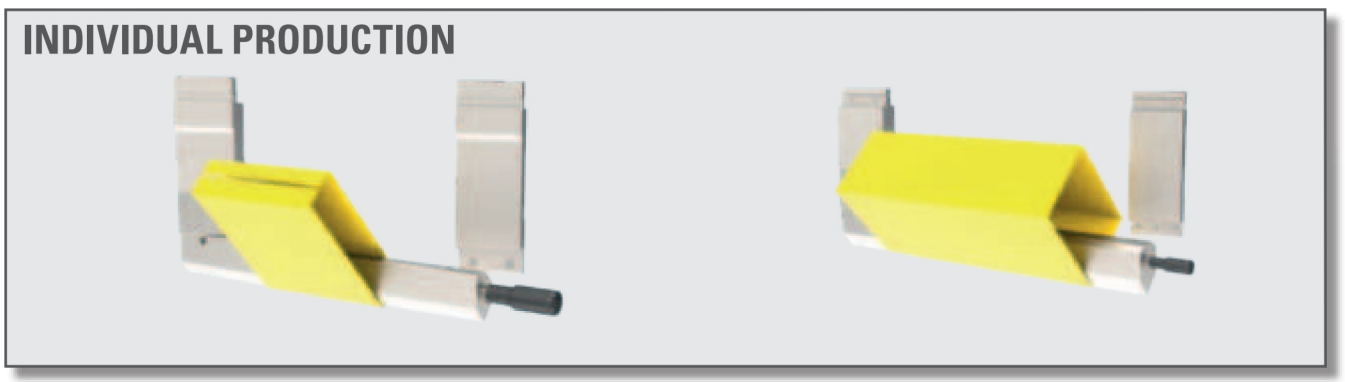
SCAN TO SHOP

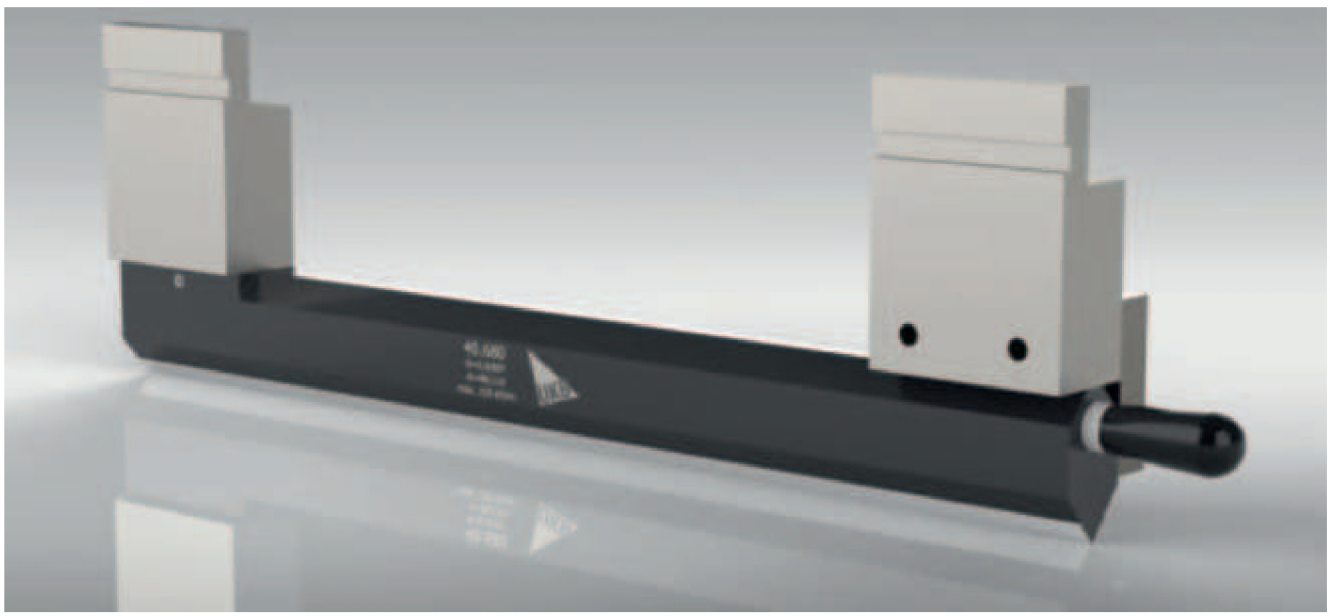
ADVANTAGES

- Bending of **closed profiles**
- Bending of **high U-profiles**
- **Easy removal** by opening the pivot arm
- **Individual production** possible



INDIVIDUAL PRODUCTION





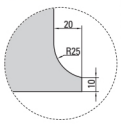
60° Punches/top tools

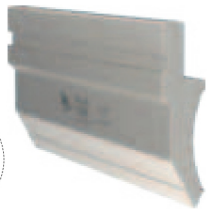
10.142

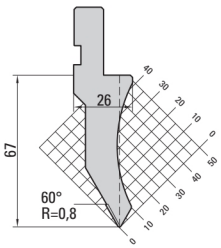
24h
600 kN/m

835 mm	8,8 kg	192,– €
415 mm	4,3 kg	112,– €
800 mm sectionalized	7,9 kg	306,– €

SCAN TO SHOP





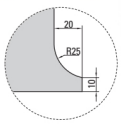


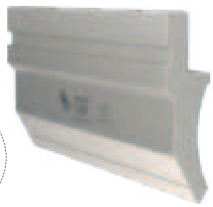
10.143

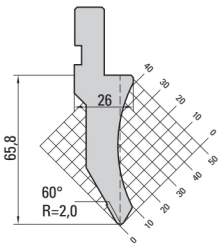
24h
600 kN/m

835 mm	8,8 kg	192,– €
415 mm	4,3 kg	112,– €
800 mm sectionalized	7,9 kg	306,– €

SCAN TO SHOP





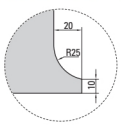


10.516

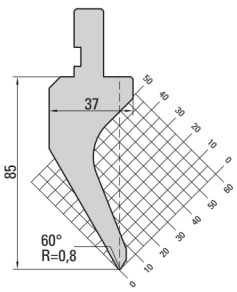
24h
400 kN/m

835 mm	12,5 kg	468,– €
415 mm	6,2 kg	260,– €
800 mm sectionalized	11,6 kg	606,– €

SCAN TO SHOP





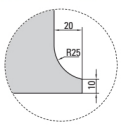


10.500

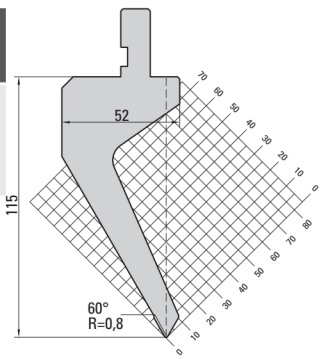
24h
400 kN/m

835 mm	19,6 kg	656,– €
415 mm	9,7 kg	360,– €
800 mm sectionalized	17,8 kg	844,– €

SCAN TO SHOP





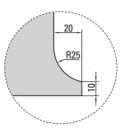


10.506

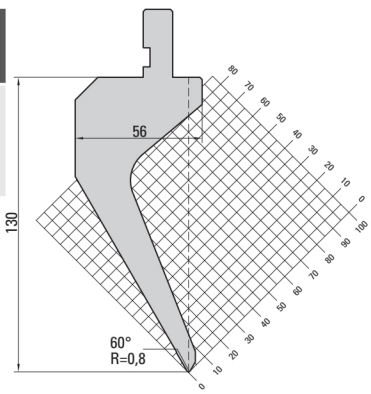
24h
400 kN/m

835 mm	22,4 kg	840,– €
415 mm	11,1 kg	456,– €
800 mm sectionalized	20,4 kg	1.052,– €

SCAN TO SHOP





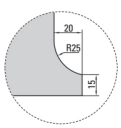


11.750

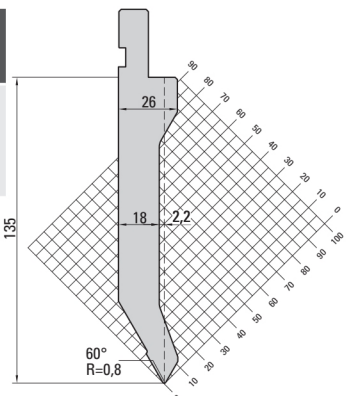
24h
700 kN/m

835 mm	18,3 kg	414,– €
415 mm	9,1 kg	236,– €
800 mm sectionalized	16,7 kg	600,– €

SCAN TO SHOP







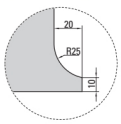
60° Punches/top tools

10.520

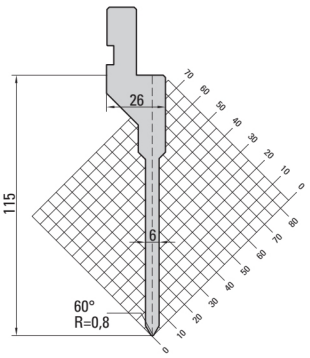
24h
500 kN/m

835 mm	9,6 kg	582,– €
415 mm	4,8 kg	328,– €
800 mm sectionalized	8,8 kg	748,– €

SCAN TO SHOP







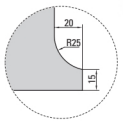
10.136

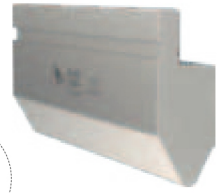
24h
1000 kN/m

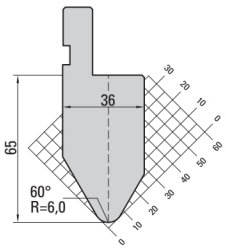
835 mm	15,3 kg	218,– €
415 mm	7,6 kg	124,– €
800 mm sectionalized	14,0 kg	340,– €

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

SCAN TO SHOP







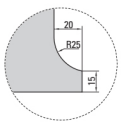
11.710

24h
1000 kN/m

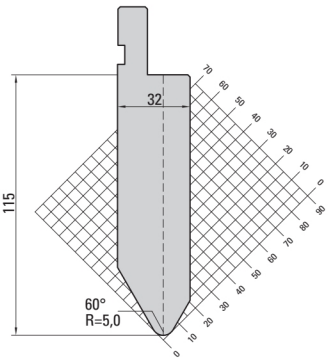
835 mm	24,4 kg	378,– €
415 mm	12,1 kg	214,– €
800 mm sectionalized	22,3 kg	552,– €

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

SCAN TO SHOP







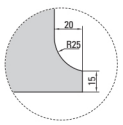
11.720

24h
1000 kN/m

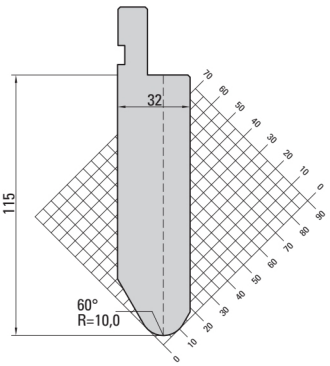
835 mm	25,2 kg	378,– €
415 mm	12,5 kg	214,– €
800 mm sectionalized	23,0 kg	552,– €

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

SCAN TO SHOP





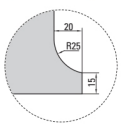


11.730

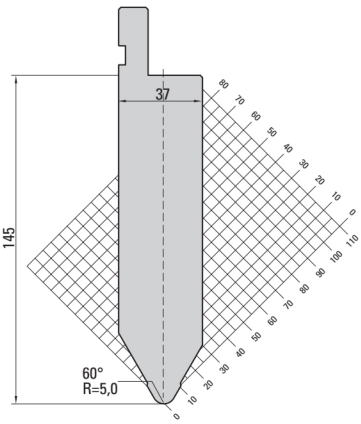
24h
1600 kN/m

835 mm	34,5 kg	508,– €
415 mm	17,1 kg	278,– €
800 mm sectionalized	33,0 kg	746,– €

SCAN TO SHOP





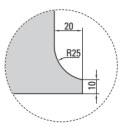


10.510

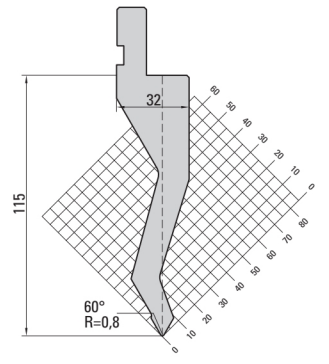
24h
600 kN/m

835 mm	14,9 kg	492,– €
415 mm	7,4 kg	272,– €
800 mm sectionalized	13,6 kg	658,– €

SCAN TO SHOP



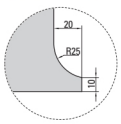




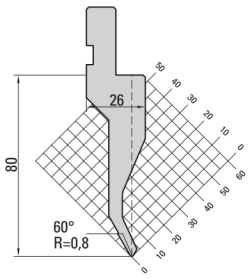
60° Punch/top tool

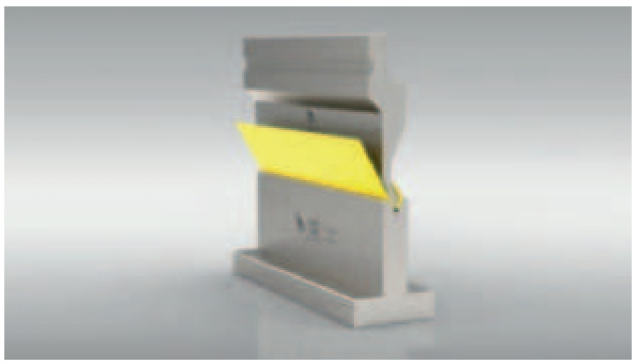
10.517		24h 250 kN/m
835 mm	9,0 kg	460,– €
415 mm	4,5 kg	254,– €
800 mm sectionalized	8,3 kg	610,– €

SCAN TO SHOP





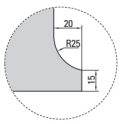




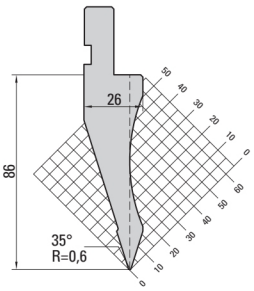
35° Punches/top tools

11.103		24h 700 kN/m
835 mm	10,9 kg	202,– €
415 mm	5,4 kg	120,– €
800 mm sectionalized	9,9 kg	330,– €

SCAN TO SHOP

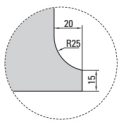




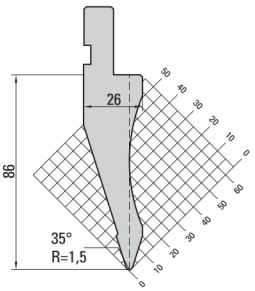


11.104		24h 700 kN/m
835 mm	11,2 kg	202,– €
415 mm	5,6 kg	120,– €
800 mm sectionalized	10,3 kg	330,– €

SCAN TO SHOP

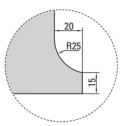




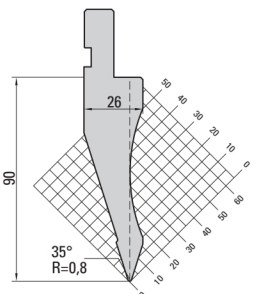


11.600		24h 700 kN/m
835 mm	11,7 kg	208,– €
415 mm	5,8 kg	124,– €
800 mm sectionalized	10,9 kg	336 ,– €

SCAN TO SHOP







UKB-REPAIR- AND REGRINDING SERVICE
CHAPTER 19



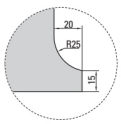
30° Punches/top tools

11.158

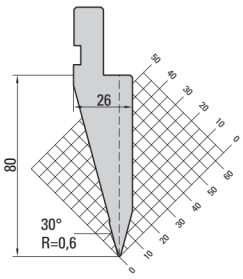
24h
1000 kN/m

835 mm	10,6 kg	224,– €
415 mm	5,3 kg	132,– €
800 mm sectionalized	9,7 kg	356,– €

SCAN TO SHOP





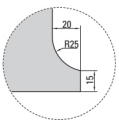


10.514

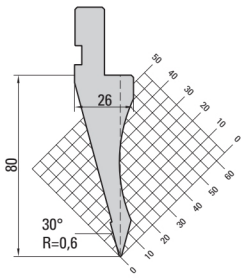
24h
500 kN/m

835 mm	9,1 kg	314,– €
415 mm	4,5 kg	182,– €
800 mm sectionalized	8,3 kg	456,– €

SCAN TO SHOP







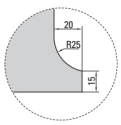
10.511

24h
1000 kN/m

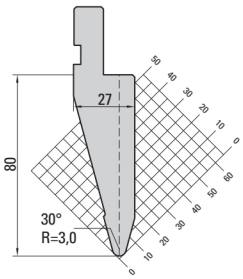
835 mm	12,0 kg	244,– €
415 mm	6,0 kg	142,– €
800 mm sectionalized	11,0 kg	376,– €

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

SCAN TO SHOP





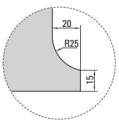


11.258

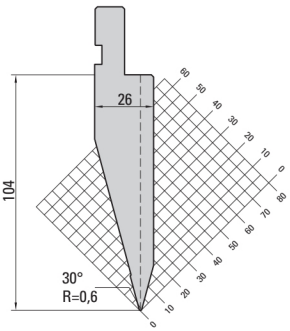
24h
1000 kN/m

835 mm	14,7 kg	324,– €
415 mm	7,3 kg	188,– €
800 mm sectionalized	13,4 kg	484,– €

SCAN TO SHOP





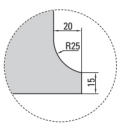


11.514

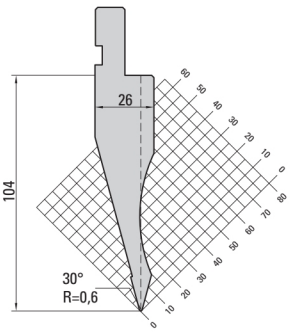
24h
500 kN/m

835 mm	13,2 kg	410,– €
415 mm	6,6 kg	236,– €
800 mm sectionalized	12,1 kg	590,– €

SCAN TO SHOP







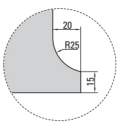
11.528

24h
1000 kN/m

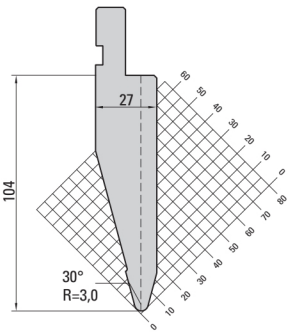
835 mm	16,3 kg	354,– €
415 mm	8,1 kg	202,– €
800 mm sectionalized	14,9 kg	530,– €

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

SCAN TO SHOP







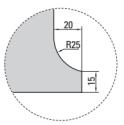
30° Punches/top tools

11.530 — 24h — 1000 kN/m

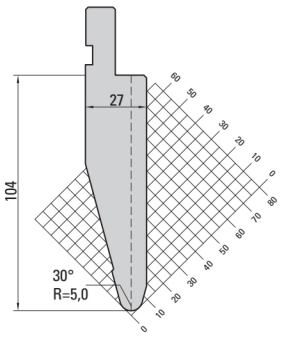
835 mm	17,0 kg	354,– €
415 mm	8,5 kg	202,– €
800 mm sectionalized	15,6 kg	530,– €

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

SCAN TO SHOP



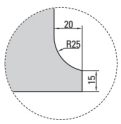




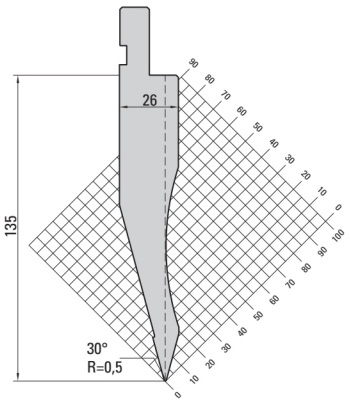
11.780 — 24h — 800 kN/m

835 mm	18,4 kg	470,– €
415 mm	9,1 kg	266,– €
800 mm sectionalized	16,7 kg	656,– €

SCAN TO SHOP



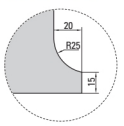




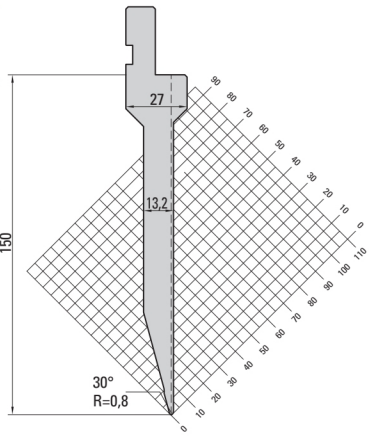
11.880 — 24h — 400 kN/m

835 mm	15,3 kg	516,– €
415 mm	7,6 kg	288,– €
800 mm sectionalized	13,9 kg	746,– €

SCAN TO SHOP



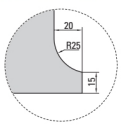




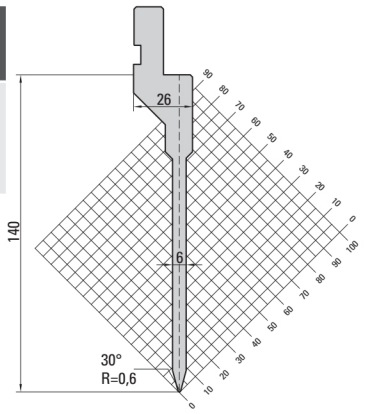
10.515 — 24h — 500 kN/m

835 mm	10,5 kg	834,– €
415 mm	5,2 kg	468,– €
800 mm sectionalized	9,6 kg	1.026,– €

SCAN TO SHOP



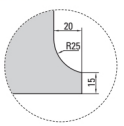




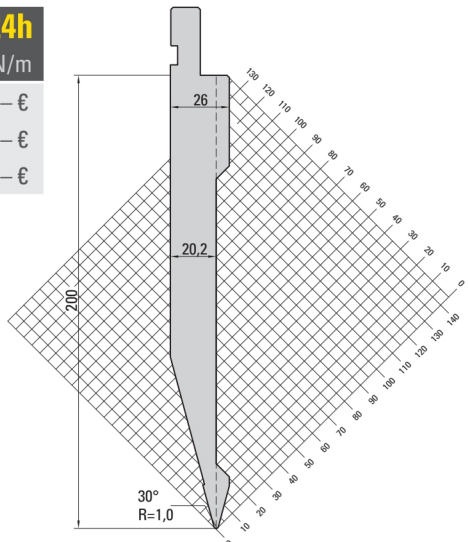
11.810 — 24h — 500 kN/m

835 mm	26,4 kg	598,– €
415 mm	13,1 kg	352,– €
800 mm sectionalized	24,0 kg	866,– €

SCAN TO SHOP







UKB-HOLDERS FOR BLADES AND BLADES R 0,5 – 6,0
CHAPTER 07



30° Punches/top tools

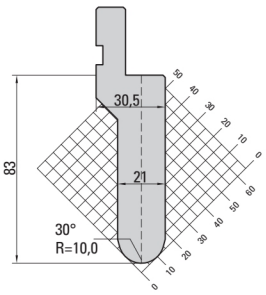
11.904

24h
1000 kN/m

835 mm	14,4 kg	558,– €
415 mm	7,2 kg	308,– €
800 mm sectionalized	13,3 kg	726,– €

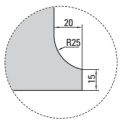
Compatible to radius-tool holder 10.115 and radius-tool 10.304/11.304 (see pages 183/186)

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



SCAN TO SHOP





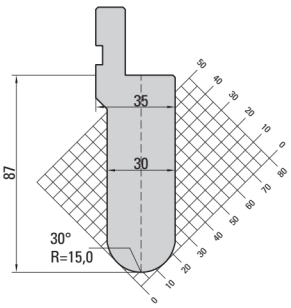
11.911

24h
1000 kN/m

835 mm	19,3 kg	614,– €
415 mm	9,6 kg	334,– €
800 mm sectionalized	17,8 kg	782,– €

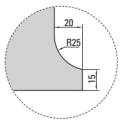
Compatible to radius-tool holder 10.115 and radius-tool 10.311/11.311 (see pages 183/186)

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



SCAN TO SHOP





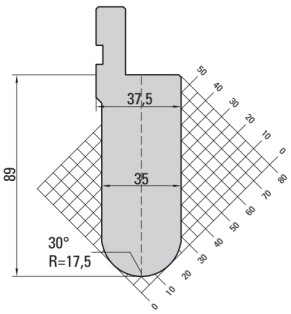
11.914

24h
1000 kN/m

835 mm	22,1 kg	670,– €
415 mm	11,0 kg	362,– €
800 mm sectionalized	20,3 kg	836,– €

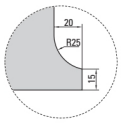
Compatible to radius-tool holder 10.115 and radius-tool 10.314/11.314 (see pages 183/186)

2000 kN/m if the tool clamping has the corresponding load



SCAN TO SHOP





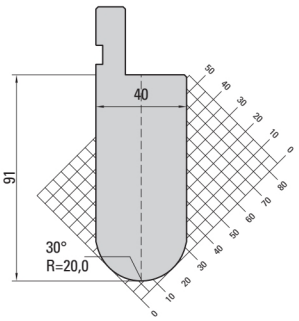
11.916

24h
1000 kN/m

835 mm	25,3 kg	726,– €
415 mm	12,6 kg	390,– €
800 mm sectionalized	23,3 kg	892,– €

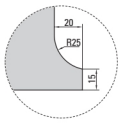
Compatible to radius-tool holder 10.115 and radius-tool 10.316/11.316 (see pages 183/186)

2000 kN/m if the tool clamping has the corresponding load



SCAN TO SHOP





26° Punches/top tools

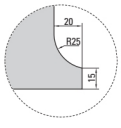
11.540

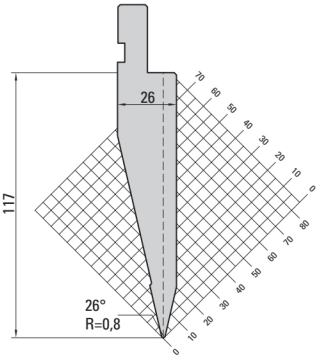
24h
1000 kN/m

835 mm	16,0 kg	274,– €
415 mm	8,0 kg	164,– €
800 mm sectionalized	14,7 kg	450,– €

SCAN TO SHOP







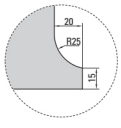
11.545

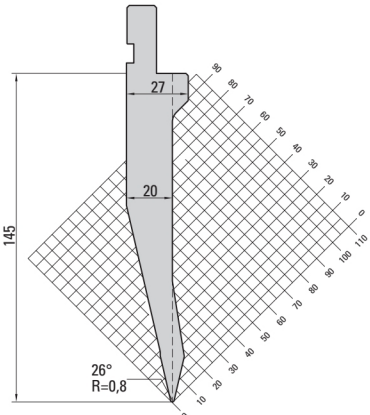
24h
950 kN/m

835 mm	17,7 kg	554,– €
415 mm	8,8 kg	298,– €
800 mm sectionalized	16,4 kg	812,– €

SCAN TO SHOP







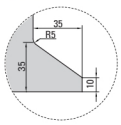
86° Punches/top tools „Fixed Height“ H = 120 mm

12.022

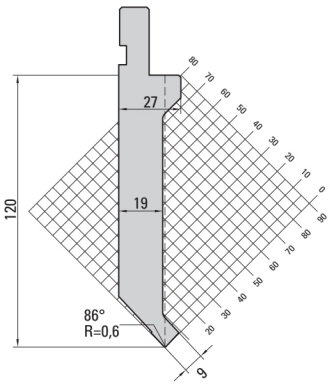
24h
1000 kN/m

835 mm	17,3 kg	348,– €
415 mm	8,6 kg	198,– €
800 mm sectionalized	16,0 kg	480,– €

SCAN TO SHOP





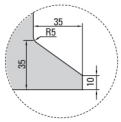


12.023

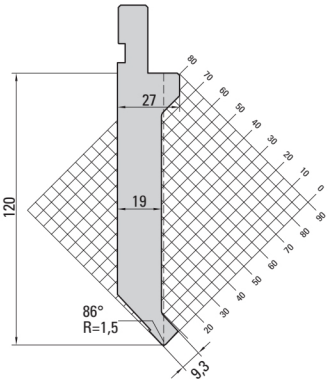
24h
1000 kN/m

835 mm	17,3 kg	348,– €
415 mm	8,6 kg	198,– €
800 mm sectionalized	16,0 kg	480,– €

SCAN TO SHOP





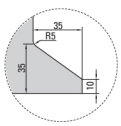


12.024

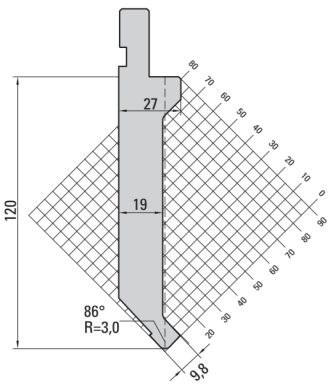
24h
1000 kN/m

835 mm	17,3 kg	348,– €
415 mm	8,6 kg	198,– €
800 mm sectionalized	16,1 kg	480,– €

SCAN TO SHOP





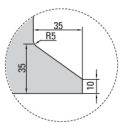


12.027

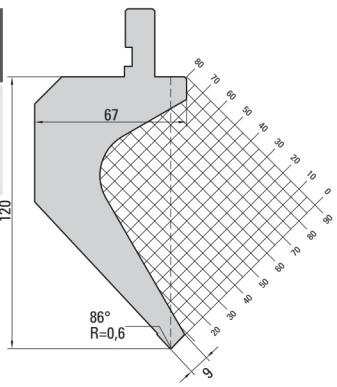
24h
500 kN/m

835 mm	26,5 kg	782,– €
415 mm	13,2 kg	430,– €
800 mm sectionalized	24,6 kg	1.032,– €

SCAN TO SHOP





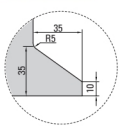


12.028

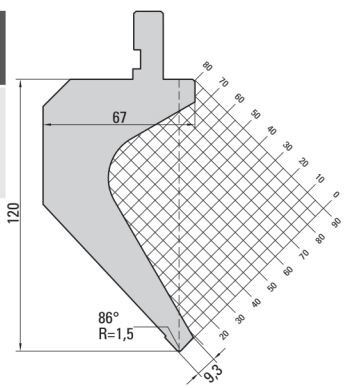
24h
500 kN/m

835 mm	26,6 kg	782,– €
415 mm	13,2 kg	430,– €
800 mm sectionalized	24,2 kg	1.032,– €

SCAN TO SHOP





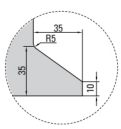


12.029

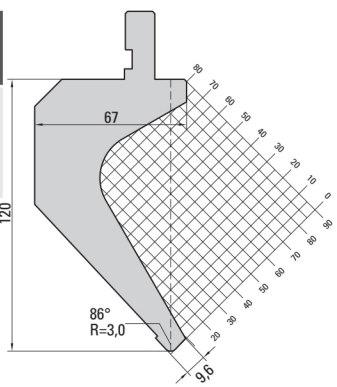
24h
500 kN/m

835 mm	26,6 kg	782,– €
415 mm	13,2 kg	430,– €
800 mm sectionalized	24,2 kg	1.032,– €

SCAN TO SHOP





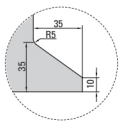


86° Punches/top tools „Fixed Height“ H = 120 mm

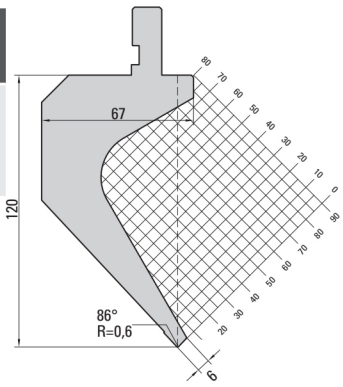
12.035 — 24h — 450 kN/m

835 mm	24,8 kg	792,– €
415 mm	12,3 kg	440,– €
800 mm sectionalized	23,0 kg	1.050,– €

SCAN TO SHOP



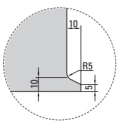




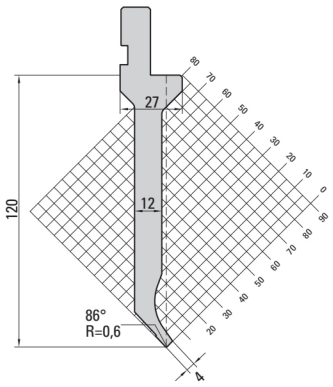
12.037 — 24h — 300 kN/m

835 mm	12,1 kg	440,– €
415 mm	6,0 kg	238,– €
800 mm sectionalized	11,2 kg	564,– €

SCAN TO SHOP



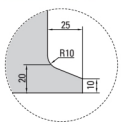




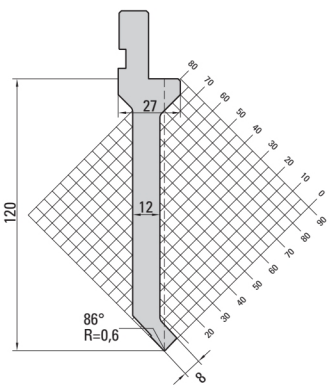
12.032 — 24h — 500 kN/m

835 mm	12,6 kg	388,– €
415 mm	6,3 kg	220,– €
800 mm sectionalized	11,7 kg	524,– €

SCAN TO SHOP



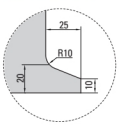




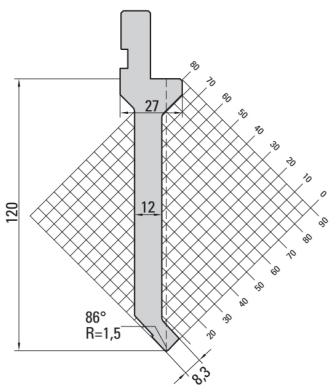
12.033 — 24h — 500 kN/m

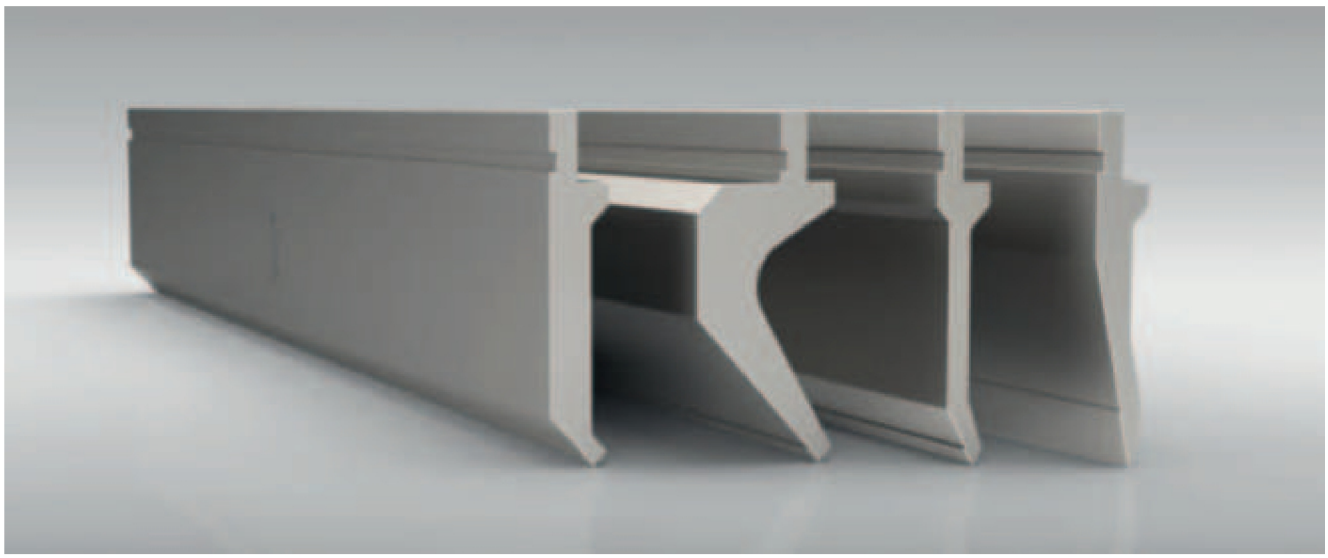
835 mm	12,6 kg	388,– €
415 mm	6,3 kg	220,– €
800 mm sectionalized	11,7 kg	524,– €

SCAN TO SHOP









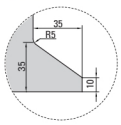
60° Punches/top tools „Fixed Height“ H = 120 mm

12.039

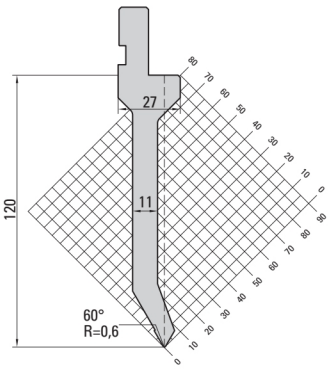
24h
700 kN/m

835 mm	12,2 kg	410,– €
415 mm	6,1 kg	234,– €
800 mm sectionalized	11,3 kg	554,– €

SCAN TO SHOP





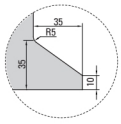


12.040

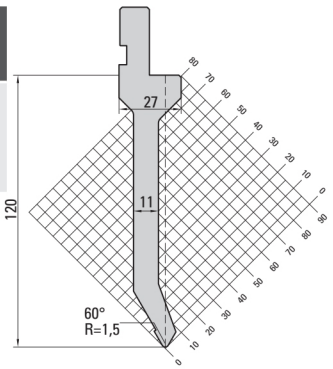
24h
700 kN/m

835 mm	12,3 kg	410,– €
415 mm	6,1 kg	234,– €
800 mm sectionalized	11,4 kg	554,– €

SCAN TO SHOP





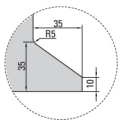


12.041

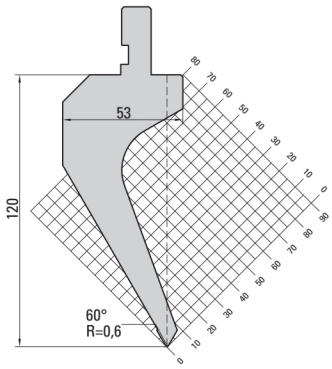
24h
700 kN/m

835 mm	20,9 kg	736,– €
415 mm	10,4 kg	410,– €
800 mm sectionalized	19,4 kg	936,– €

SCAN TO SHOP





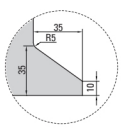


12.042

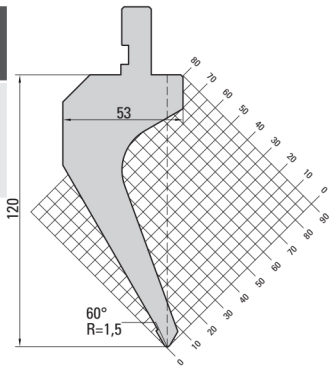
24h
700 kN/m

835 mm	21,0 kg	736,– €
415 mm	10,4 kg	410,– €
800 mm sectionalized	19,5 kg	936,– €

SCAN TO SHOP





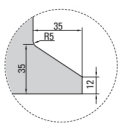


12.049

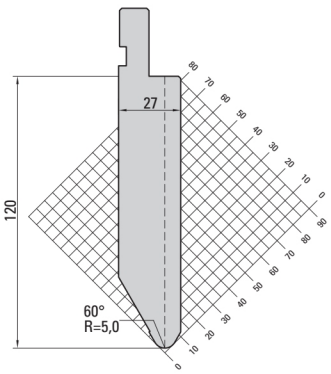
24h
1000 kN/m

835 mm	22,0 kg	392,– €
415 mm	10,9 kg	220,– €
800 mm sectionalized	20,4 kg	564,– €

SCAN TO SHOP





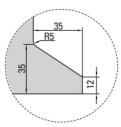


12.050

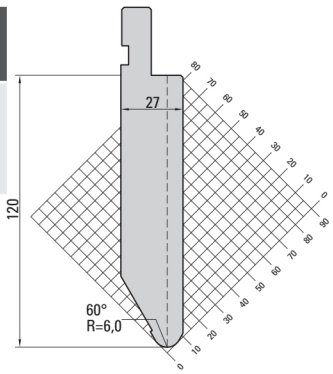
24h
1000 kN/m

835 mm	22,0 kg	392,– €
415 mm	10,9 kg	220,– €
800 mm sectionalized	20,4 kg	564,– €

SCAN TO SHOP





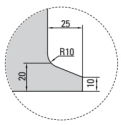


30° Punches/top tools „Fixed Height“ H = 120 mm

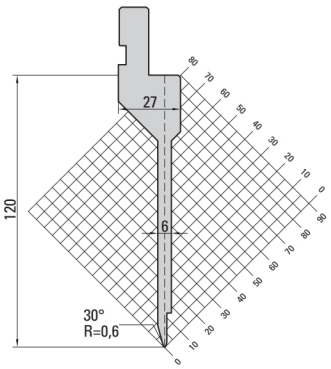
12.043 — 24h — 450 kN/m

835 mm	9,8 kg	496,– €
415 mm	4,9 kg	268,– €
800 mm sectionalized	9,1 kg	678,– €

SCAN TO SHOP



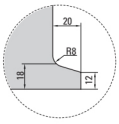




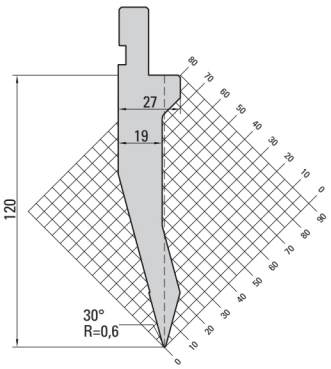
12.045 — 24h — 1000 kN/m

835 mm	14,8 kg	496,– €
415 mm	7,4 kg	296,– €
800 mm sectionalized	13,8 kg	726,– €

SCAN TO SHOP



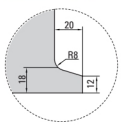




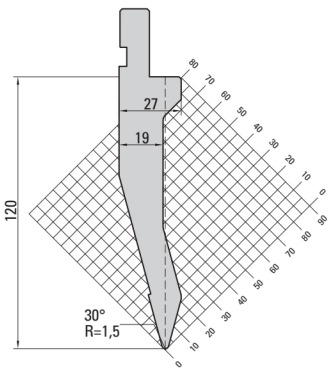
12.046 — 24h — 1000 kN/m

835 mm	15,0 kg	496,– €
415 mm	7,5 kg	296,– €
800 mm sectionalized	14,0 kg	726,– €

SCAN TO SHOP



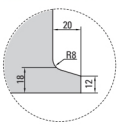




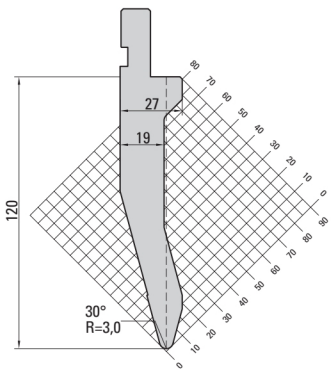
12.047 — 24h — 1000 kN/m

835 mm	16,0 kg	516,– €
415 mm	7,9 kg	306,– €
800 mm sectionalized	14,8 kg	744,– €

SCAN TO SHOP



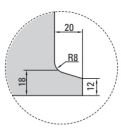




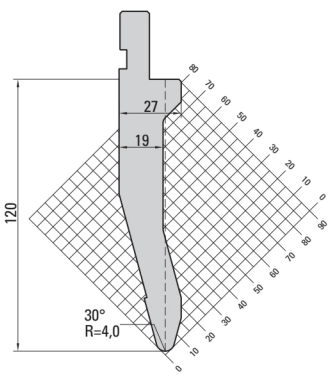
12.048 — 24h — 1000 kN/m

835 mm	16,1 kg	516,– €
415 mm	8,0 kg	306,– €
800 mm sectionalized	15,0 kg	744,– €

SCAN TO SHOP







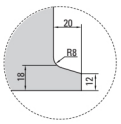
UKB-ACCESSORIES
CHAPTER 17



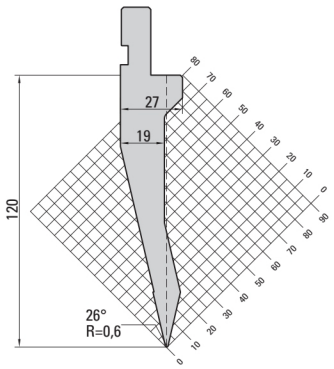
26° Punch/top tool „Fixed Height“ H = 120 mm

12.044		24h 1000 kN/m
835 mm	13,9 kg	496,– €
415 mm	6,9 kg	296,– €
800 mm sectionalized	12,9 kg	726,– €

SCAN TO SHOP







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- Special offers
- Deal of the week
- Demonstration tools & test tools
- Special and remaining stock
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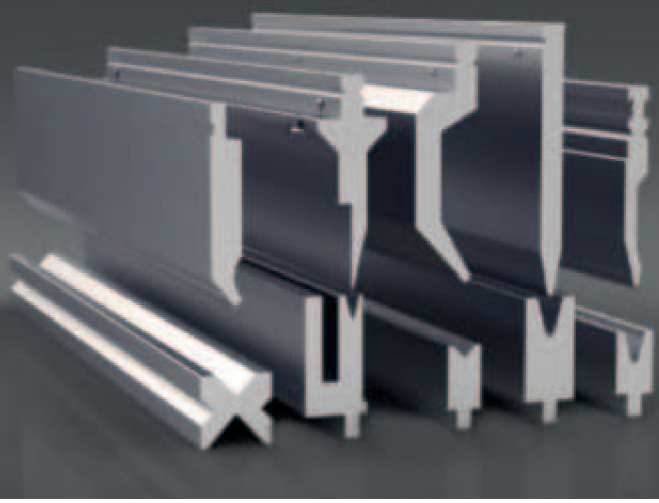
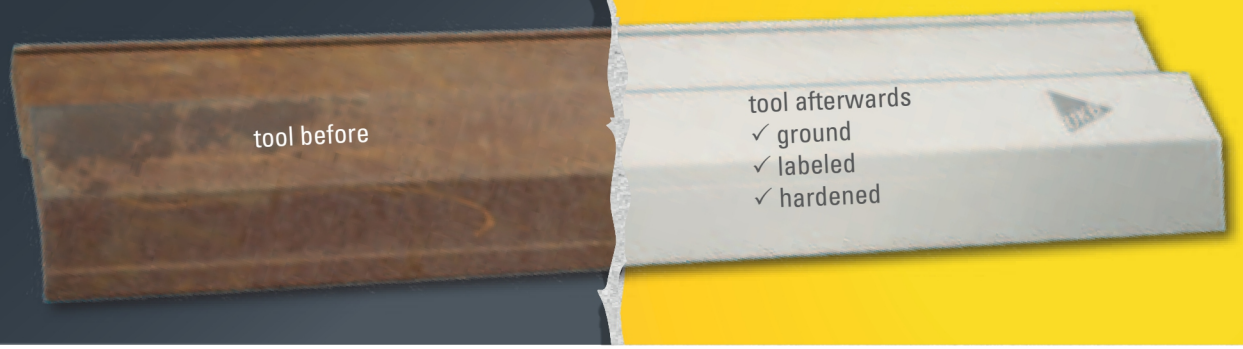


UKB-REPAIR AND REGRINDINGSERVICE

Old tools – precision-restored!

✓ precisely ✓ professionally
✓ inexpensive ✓ fast

1 working day
(according agreement)

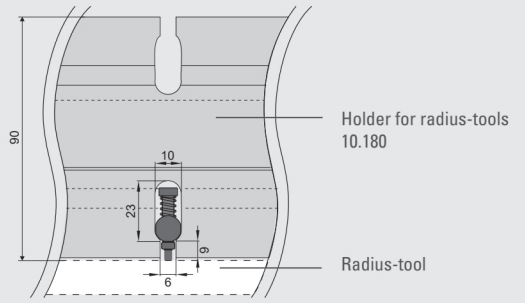


Holder for radius-tools and radius-tools R 3,0 – 6,5

Product advantages

- **Cost-saving:** One holder for different radius-tools
- **Flexible application:** Through changeable radius-tools
- **Efficient radius-tool change:** Simple and quick
- **No adjustment necessary**
- **High stability**
- **Sectionalized radius-tools** on request

EXAMPLE OF USE

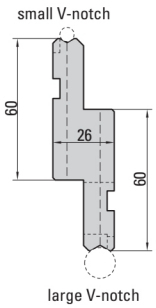


10.180		24h 800 kN/m
830 mm	9,7 kg	318,– €
412 mm	4,8 kg	192,– €

Holder for radius-tools

SCAN TO SHOP







R 3,0 – 4,5		24h 800 kN/m			
R (mm)	Model	835 mm		415 mm	
		Weight	Price	Weight	Price
3,0	10.181	0,2 kg	68,– €	0,1 kg	42,– €
3,5	10.182	0,2 kg	74,– €	0,1 kg	44,– €
4,0	10.183	0,3 kg	80,– €	0,2 kg	46,– €
4,5	10.184	0,5 kg	88,– €	0,2 kg	52,– €

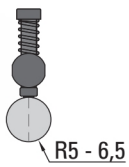


Radius-tools R 3,0 – 4,5 usable in small V-notch on holder for radius-tools 10.180

SCAN TO SHOP



R 5,0 – 6,5		24h 800 kN/m			
R (mm)	Model	835 mm		415 mm	
		Weight	Price	Weight	Price
5,0	10.185	0,6 kg	90,– €	0,3 kg	54,– €
5,5	10.186	0,7 kg	98,– €	0,3 kg	56,– €
6,0	10.187	0,8 kg	104,– €	0,4 kg	60,– €
6,5	10.188	1,0 kg	114,– €	0,5 kg	66,– €



Radius-tools R 5,0 – 6,5 usable in large V-notch on holder for radius-tools 10.180

SCAN TO SHOP



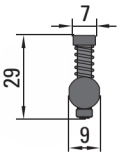
Mounting set for radius-tools

40.003		24h
Set	0,1 kg	10,– €

Mounting set for radius-tools R 3,0 – 6,5

SCAN TO SHOP







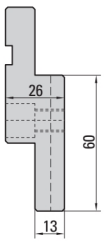
Punch/top tool distance pieces

50.959

24h
1000 kN/m

150 mm | 1,8 kg | 78,– €

H = 60 mm
Heightening of the side flange about 35 mm
Needed clamp see page 38



SCAN TO SHOP

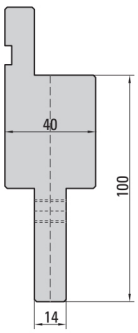


50.671

24h
1000 kN/m

150 mm | 3,7 kg | 90,– €

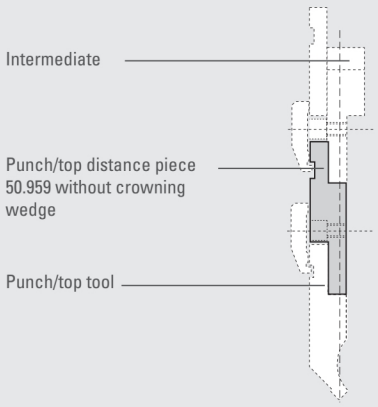
H = 100 mm
Heightening of the side flange about 70 mm
Needed clamp see page 38



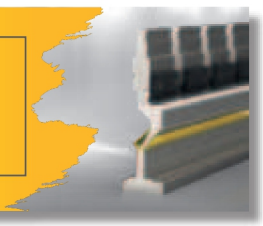
SCAN TO SHOP



EXAMPLE OF USE



UKB-ADAPTORS
CHAPTER 15



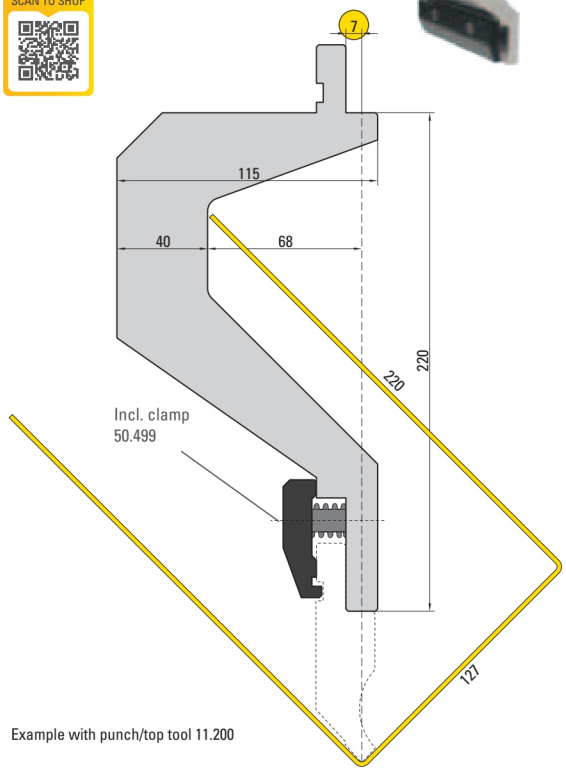
50.500

24h
900 kN/m

200 mm | 16,8 kg | 564,– €

SCAN TO SHOP





Example with punch/top tool 11.200

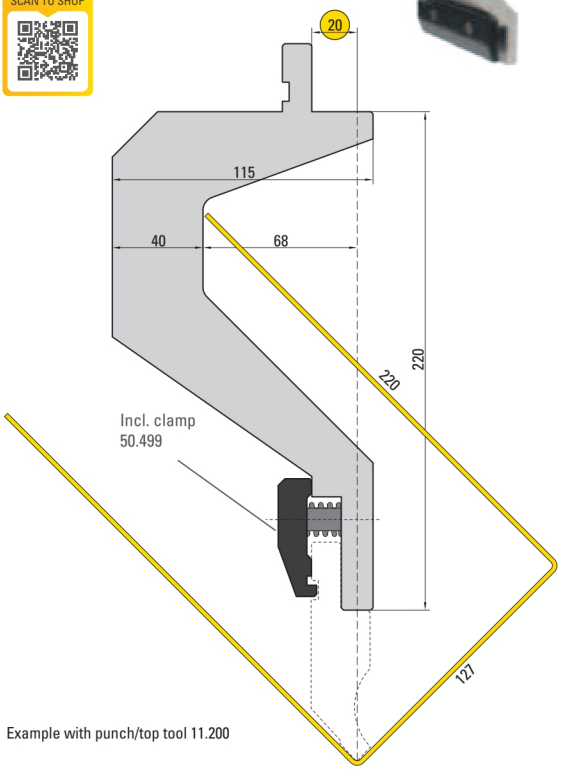
50.501

24h
900 kN/m

200 mm | 17,2 kg | 564,– €

SCAN TO SHOP





Example with punch/top tool 11.200

Intermediates L = 150 mm

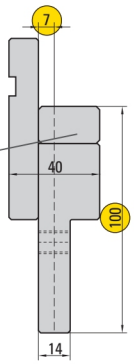
50.666 — 24h — 1000 kN/m

150 mm | 3,6 kg | 90,– €

H = 100 mm / with crowning wedge

SCAN TO SHOP





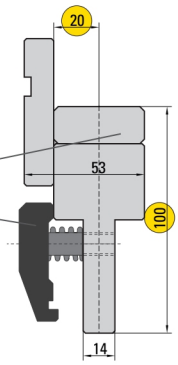
50.680 — 24h — 1000 kN/m

150 mm | 4,8 kg | 144,– €

H = 100 mm / with crowning wedge
incl. clamp 50.712

SCAN TO SHOP





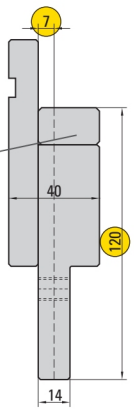
50.668 — 24h — 1000 kN/m

150 mm | 4,5 kg | 106,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





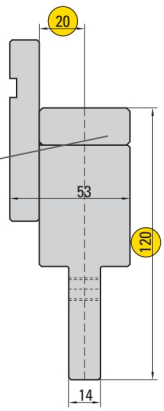
50.667 — 24h — 1000 kN/m

150 mm | 5,3 kg | 118,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





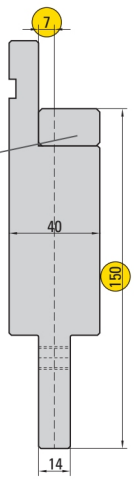
50.512 — 24h — 1000 kN/m

150 mm | 5,9 kg | 140,– €

H = 150 mm / with crowning wedge

SCAN TO SHOP





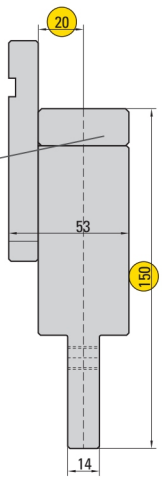
50.669 — 24h — 1000 kN/m

150 mm | 7,0 kg | 152,– €

H = 150 mm / with crowning wedge

SCAN TO SHOP





Intermediates „Heavy Duty“ L = 150 mm

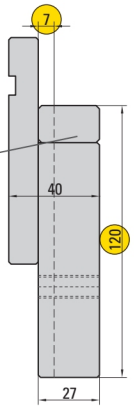
50.674 — 24h — 1300 kN/m

150 mm | 5,3 kg | 104,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





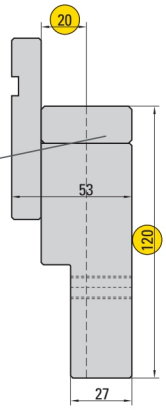
50.673 — 24h — 1300 kN/m

150 mm | 6,1 kg | 118,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





Clamps L = 150 mm

50.903 24h

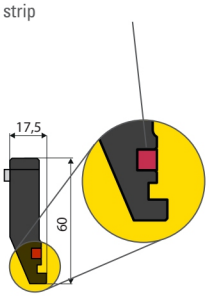
150 mm | 0,9 kg | 56,– €

Mechanical fast clamp
Adjusted by eccentric lever

SCAN TO SHOP



ADVANTAGE:
Improved clamping via nylon strip



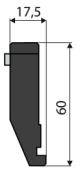
50.900 24h

150 mm | 0,9 kg | 48,– €

Mechanical fast clamp
Adjusted by eccentric lever

SCAN TO SHOP





50.905 24h

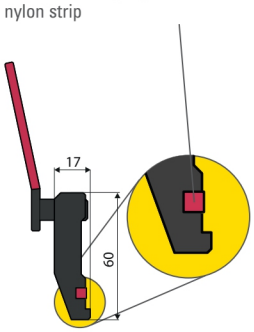
150 mm | 0,9 kg | 52,– €

Mechanical fast clamp
Adjusted by handle

SCAN TO SHOP



ADVANTAGE:
Improved clamping via nylon strip



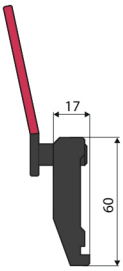
50.551 24h

150 mm | 0,9 kg | 44,– €

Mechanical fast clamp
Adjusted by handle

SCAN TO SHOP





50.910 24h

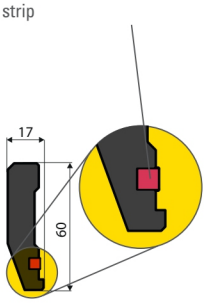
150 mm | 0,9 kg | 42,– €

Clamp
Clamping by screws

SCAN TO SHOP



ADVANTAGE:
Improved clamping via nylon strip



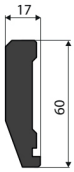
50.571 24h

150 mm | 0,9 kg | 34,– €

Clamp
Clamping by screws

SCAN TO SHOP





Clamp L = 150 mm for double-sided clamping

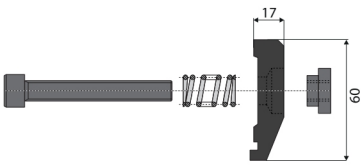
50.577 24h

150 mm | 1,8 kg | 54,– €

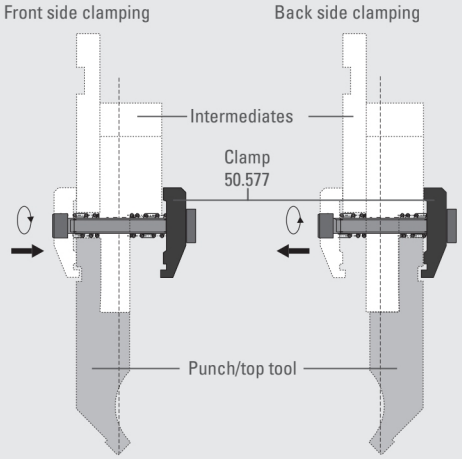
Set consist of:
Clamp 50.571
2 Screws
2 Springs
2 Nut bolts

SCAN TO SHOP





EXAMPLE OF USE



Intermediates L = 70 mm

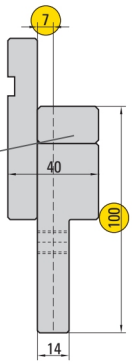
50.705 — 24h — 1000 kN/m

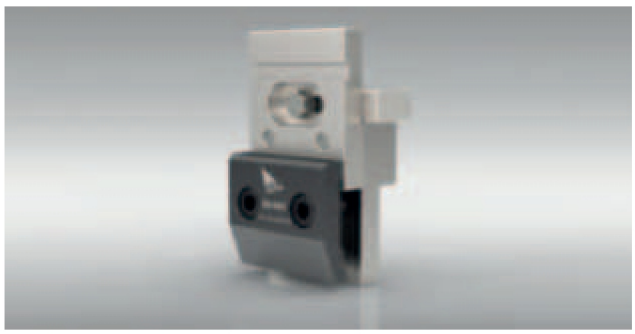
70 mm | 1,7 kg | 86,– €

H = 100 mm / with crowning wedge

SCAN TO SHOP







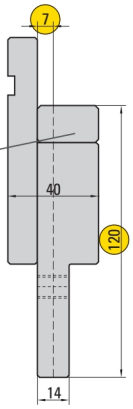
50.706 — 24h — 1000 kN/m

70 mm | 2,1 kg | 96,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





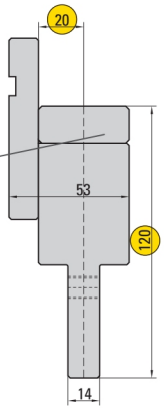
50.707 — 24h — 1000 kN/m

70 mm | 2,5 kg | 110,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





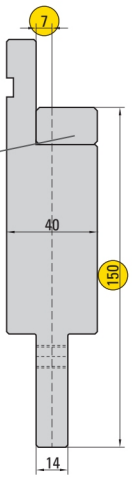
50.708 — 24h — 1000 kN/m

70 mm | 2,8 kg | 130,– €

H = 150 mm / with crowning wedge

SCAN TO SHOP





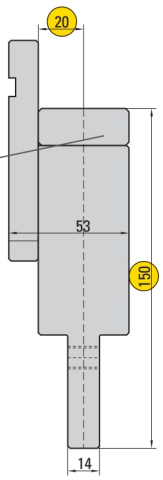
50.710 — 24h — 1000 kN/m

70 mm | 3,3 kg | 142,– €

H = 150 mm / with crowning wedge

SCAN TO SHOP





Clamp L = 70 mm

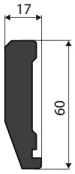
50.693 — 24h

70 mm | 0,4 kg | 30,– €

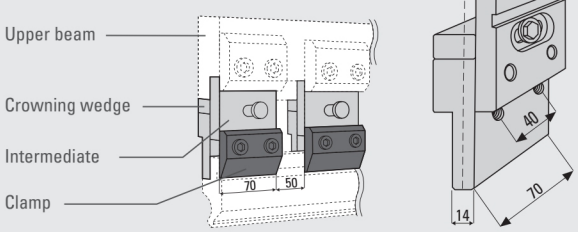
Clamp
Clamping by screws

SCAN TO SHOP





EXAMPLE OF USE



Intermediates „SpeedGrip“

Product advantages

- Quick **vertical** tool change
- **Automatic clamping and centering** with ergonomic lever
- **Cost-effective, simple and quick** retrofit of your press brake
- **Significant time savings** and thus substantially increased efficiency
- **Easy and quick** repositioning of intermediates possible
- Punches/top tools **secured against falling**

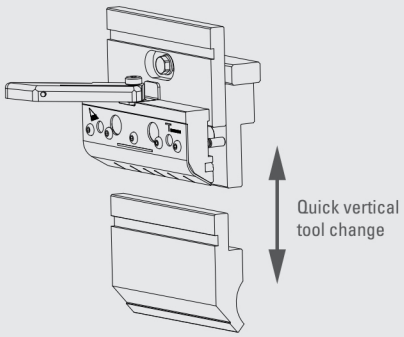
VIDEO

UKB-„SpeedGrip“



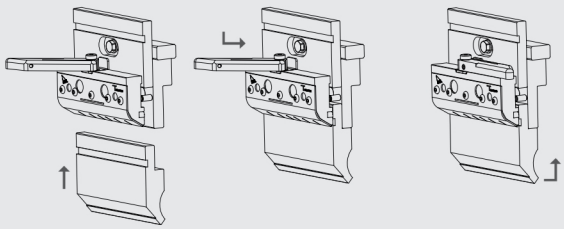


EXAMPLE OF USE



Punches/top tools UKB-System Amada
are directly applicable

„SPEEDGRIP“ CLOSED

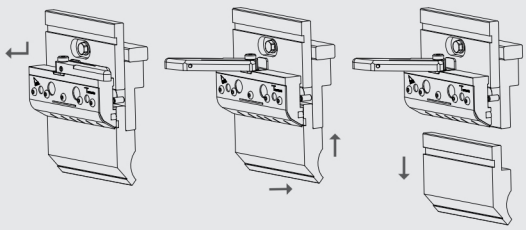


Insert punch/top tool

Punch/top tool is secured against falling

Punch/top tool is automatically clamped and centered

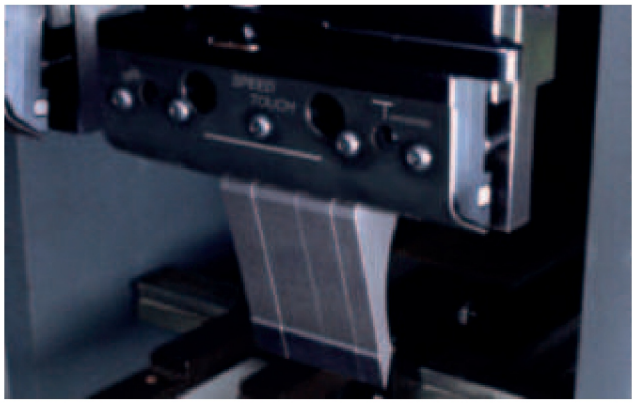
„SPEEDGRIP“ OPENED



Open lever

Lift the punch/top tool and push it backward

Take out the punch/top tool vertically



Intermediates „SpeedGrip“

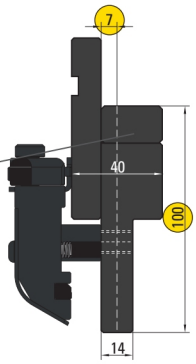
50.107 — 24h — 1000 kN/m

150 mm | 4,1 kg | 322,– €

H = 100 mm / with crowning wedge

SCAN TO SHOP





Quantity of the needed intermediates
(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

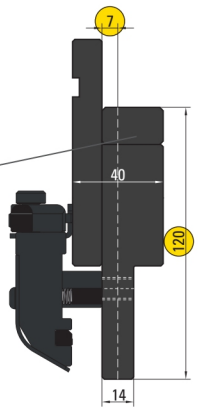
50.127 — 24h — 1000 kN/m

150 mm | 6,0 kg | 346,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





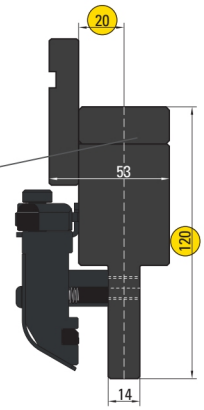
50.122 — 24h — 1000 kN/m

150 mm | 6,8 kg | 362,– €

H = 120 mm / with crowning wedge

SCAN TO SHOP





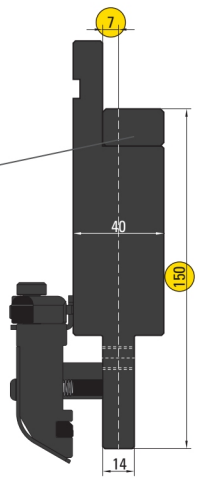
50.157 — 24h — 1000 kN/m

150 mm | 7,4 kg | 388,– €

H = 150 mm / with crowning wedge

SCAN TO SHOP





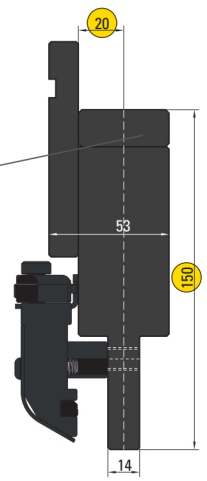
50.152 — 24h — 1000 kN/m

150 mm | 8,5 kg | 400,– €

H = 150 mm / with crowning wedge

SCAN TO SHOP





Clamp L = 150 mm for double-sided clamping

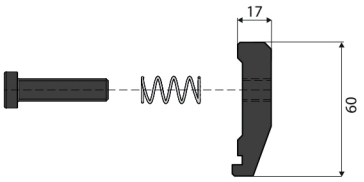
50.578 — 24h

150 mm | 1,8 kg | 48,– €



Set consist of:
Clamp
2 Screws
2 Springs

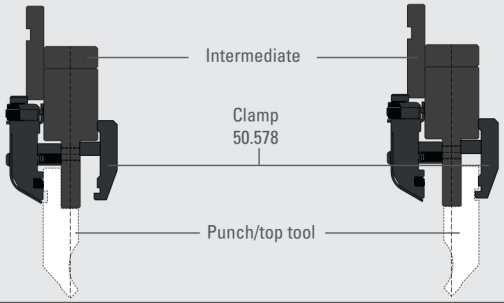
SCAN TO SHOP



EXAMPLE OF USE

Front side clamping by lever and vertical tool change

Back side clamping by screws and horizontal tool change



Intermediates „SpeedGrip DOUBLE“

Product advantages

- **Double-sided use**
- Quick **vertical** tool change
- **Automatic clamping and centering** with ergonomic lever
- **Cost-effective, simple and quick** retrofit of your press brake
- **Significant time savings** and thus substantially increased efficiency
- **Easy and quick** repositioning of intermediates possible
- Punches/top tools **secured against falling**

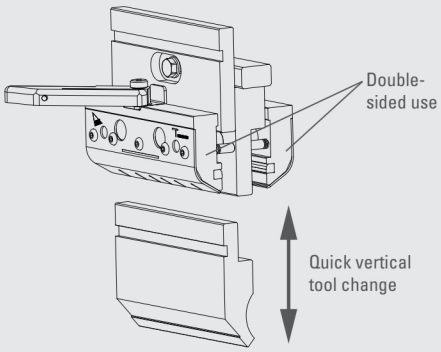
VIDEO

UKB-„SpeedGrip“



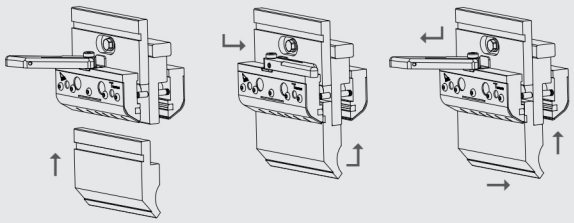


EXAMPLE OF USE



Punches/top tools UKB-System Amada
are directly applicable

„SPEEDGRIP DOUBLE“ FRONT SIDE

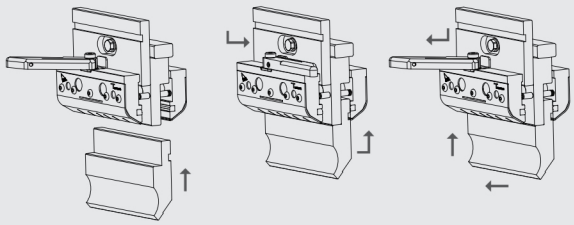


Insert punch/top tool and close the lever

Punch/top tool is automatically clamped and centered

Open the lever, lift the punch/top tool, push it backward, and take the punch/top tool vertically out

„SPEEDGRIP DOUBLE“ BACK SIDE



Rotate the punch/top tool 180°, insert it at the back side and close the lever

Punch/top tool is automatically clamped and centered

Open the lever, lift the punch/top tool, pull it forward, and take the punch/top tool vertically out

UKB GROUP

ukb-gmbh.de
toolsystems24.de
schanksysteme24.de

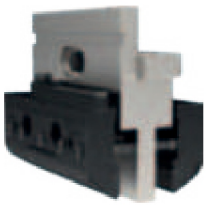
Intermediates „SpeedGrip DOUBLE“

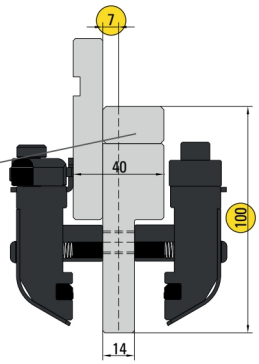
51.107 1000 kN/m

150 mm 6,7 kg 828,– €

H = 100 mm / with crowning wedge
Delivery time on request

SCAN TO SHOP





Quantity of the needed intermediates
(Mounting distance 50 mm)

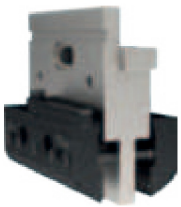
Length of the press brake (mm)	Quantity (pieces)
835	4
1.250	6
2.100	10
2.600	13
3.100	15
4.100	20

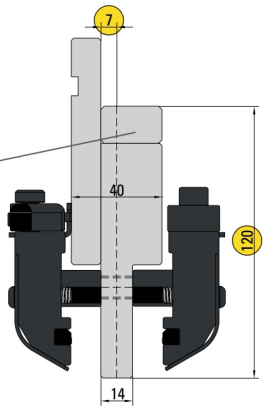
51.127 1000 kN/m

150 mm 7,6 kg 834,– €

H = 120 mm / with crowning wedge
Delivery time on request

SCAN TO SHOP



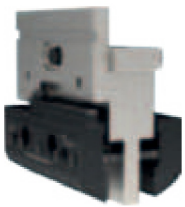


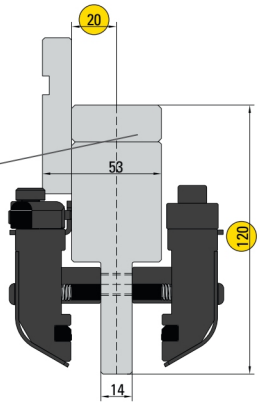
51.122 1000 kN/m

150 mm 8,4 kg 850,– €

H = 120 mm / with crowning wedge
Delivery time on request

SCAN TO SHOP





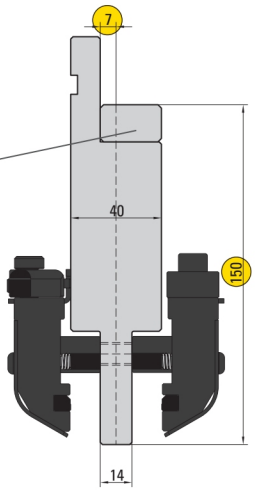
51.157 1000 kN/m

150 mm 9,0 kg 876,– €

H = 150 mm / with crowning wedge
Delivery time on request

SCAN TO SHOP



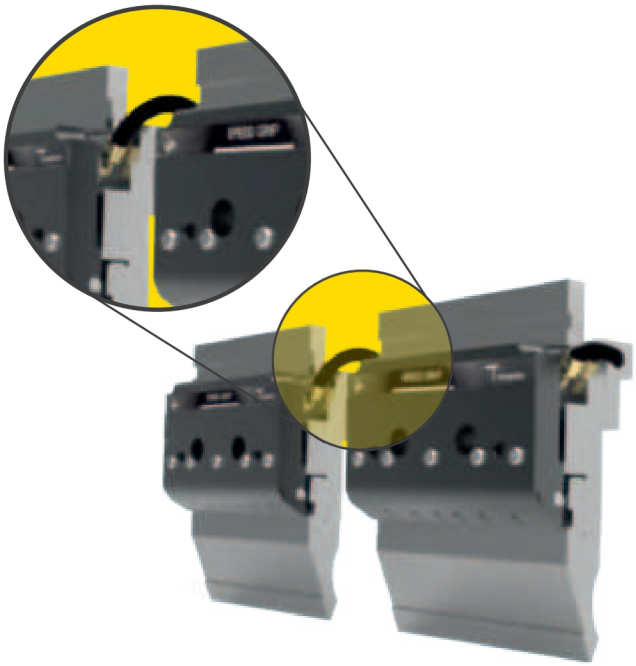




Pneumatic intermediates „SpeedGrip AIR“

Product advantages

- Quick **vertical** tool change
- **Pneumatic quick clamping system**
- **Cost-effective, simple and quick** retrofit of your press brake
- **Significant time savings** and thus substantially increased efficiency
- **Automatic clamping and centering**
- **Easy and quick** repositioning of intermediates possible
- Punches/top tools **secured against falling**



„SPEEDGRIP AIR“ FLEX

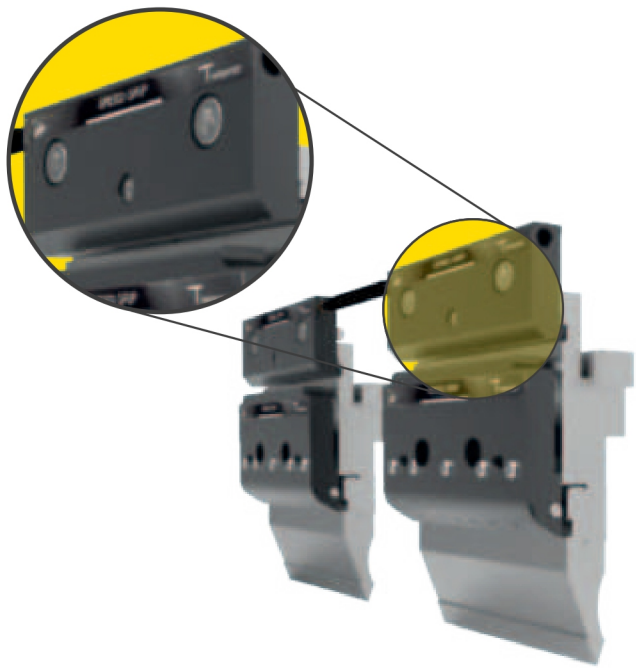
High-quality pneumatic quick-clamping system for vertical tool changes of UKB-System Amada tools – no modification required.

The air connection via flexible nylon hoses allows lateral repositioning of the intermediates.

Double-sided clamping can be achieved by using a non-pneumatic clamping device on the back side.

UKB-INFO

Prices and delivery times on request.
Please contact us!



„SPEEDGRIP AIR“ STAR

With the innovative STAR SYSTEM, you are choosing a forward-looking solution for flexible tool usage. The specially developed clamping is mounted directly on the press beam and transfers the compressed air to the intermediates – without any additional air connection.

Your advantage: Individual or multiple intermediates can be quickly and easily removed from the system at any time and in any position – without interrupting the pneumatic supply. This minimizes setup times and ensures maximum flexibility in daily operation.

UKB-INFO

Prices and delivery times on request.
Please contact us!

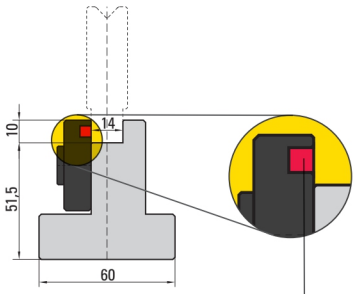
Die holder for centrical 1-V dies

22.010	24h 1000 kN/m	
835 mm	16,4 kg	454,– €
415 mm	8,1 kg	276,– €

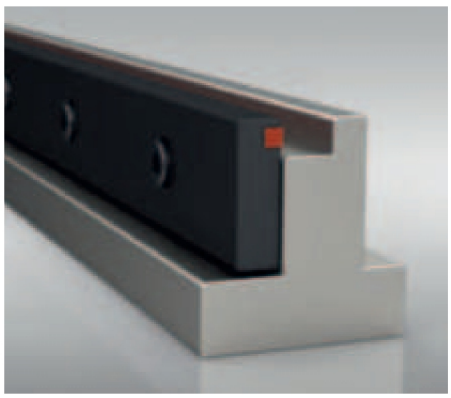
Die holder incl. clamp with nylon-strip

SCAN TO SHOP





ADVANTAGE:
Improved clamping via nylon strip

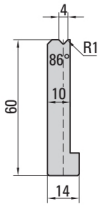


86° Centrical 1-V dies

22.904	24h 750 kN/m	
835 mm	4,1 kg	288,– €
415 mm	2,1 kg	168,– €
800 mm sectionalized	4,0 kg	418,– €

SCAN TO SHOP

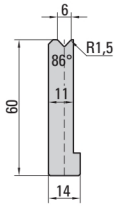




22.906	24h 800 kN/m	
835 mm	4,4 kg	288,– €
415 mm	2,2 kg	168,– €
800 mm sectionalized	4,3 kg	418,– €

SCAN TO SHOP

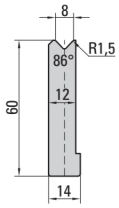




22.908	24h 900 kN/m	
835 mm	4,7 kg	288,– €
415 mm	2,3 kg	168,– €
800 mm sectionalized	4,5 kg	418,– €

SCAN TO SHOP

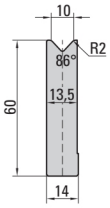




22.910	24h 1000 kN/m	
835 mm	5,2 kg	288,– €
415 mm	2,6 kg	168,– €
800 mm sectionalized	4,9 kg	418,– €

SCAN TO SHOP

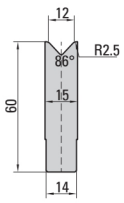




22.912	24h 1000 kN/m	
835 mm	5,6 kg	306,– €
415 mm	2,8 kg	176,– €
800 mm sectionalized	5,3 kg	446,– €

SCAN TO SHOP

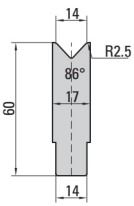




22.914	24h 1000 kN/m	
835 mm	6,1 kg	306,– €
415 mm	3,0 kg	176,– €
800 mm sectionalized	5,9 kg	446,– €

SCAN TO SHOP





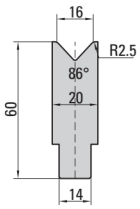
86° Centrical 1-V dies

22.916 — 24h — 1000 kN/m

835 mm	7,0 kg	316,– €
415 mm	3,5 kg	182,– €
800 mm sectionalized	6,7 kg	456,– €

SCAN TO SHOP



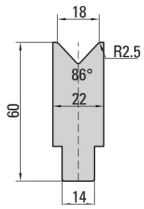


22.918 — 24h — 1000 kN/m

835 mm	7,6 kg	316,– €
415 mm	3,8 kg	182,– €
800 mm sectionalized	7,2 kg	456,– €

SCAN TO SHOP



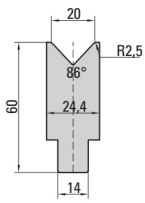


22.920 — 24h — 1000 kN/m

835 mm	8,2 kg	326,– €
415 mm	4,1 kg	186,– €
800 mm sectionalized	7,9 kg	464,– €

SCAN TO SHOP



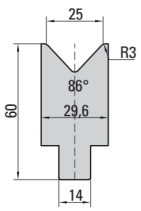


22.925 — 24h — 1000 kN/m

835 mm	9,5 kg	344,– €
415 mm	4,7 kg	196,– €
800 mm sectionalized	9,1 kg	484,– €

SCAN TO SHOP







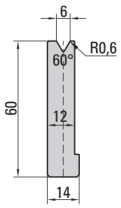
60° Centrical 1-V dies

22.606 — 24h — 380 kN/m

835 mm	4,7 kg	298,– €
415 mm	2,4 kg	174,– €
800 mm sectionalized	4,5 kg	430,– €

SCAN TO SHOP



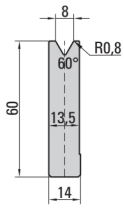


22.608 — 24h — 450 kN/m

835 mm	5,1 kg	298,– €
415 mm	2,5 kg	174,– €
800 mm sectionalized	4,9 kg	430,– €

SCAN TO SHOP



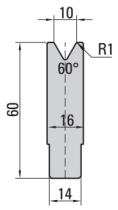


22.610 — 24h — 550 kN/m

835 mm	5,8 kg	298,– €
415 mm	2,9 kg	174,– €
800 mm sectionalized	5,5 kg	430,– €

SCAN TO SHOP



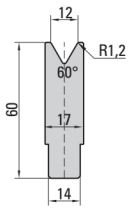


22.612 — 24h — 550 kN/m

835 mm	5,9 kg	310,– €
415 mm	3,0 kg	182,– €
800 mm sectionalized	5,7 kg	450,– €

SCAN TO SHOP



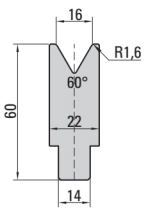


22.616 — 24h — 650 kN/m

835 mm	7,1 kg	334,– €
415 mm	3,5 kg	194,– €
800 mm sectionalized	6,8 kg	476,– €

SCAN TO SHOP



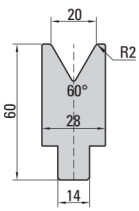


22.620 — 24h — 850 kN/m

835 mm	8,4 kg	352,– €
415 mm	4,2 kg	204,– €
800 mm sectionalized	8,1 kg	496,– €

SCAN TO SHOP



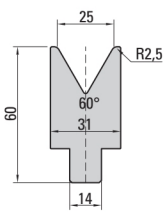


22.625 — 24h — 850 kN/m

835 mm	8,7 kg	374,– €
415 mm	4,3 kg	212,– €
800 mm sectionalized	8,3 kg	520,– €

SCAN TO SHOP





UKB-MODIFICATION OF PRESS BRAKE TOOLS
CHAPTER 18



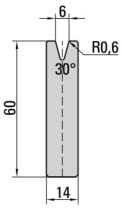
30° Centrical 1-V dies

22.306 — 24h — 350 kN/m

835 mm	5,3 kg	298,– €
415 mm	2,6 kg	174,– €
800 mm sectionalized	5,1 kg	428,– €

SCAN TO SHOP



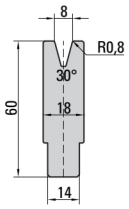


22.308 — 24h — 350 kN/m

835 mm	6,3 kg	298,– €
415 mm	3,1 kg	174,– €
800 mm sectionalized	6,0 kg	428,– €

SCAN TO SHOP



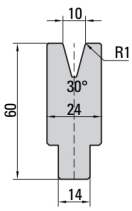


22.310 — 24h — 500 kN/m

835 mm	7,8 kg	310,– €
415 mm	3,9 kg	180,– €
800 mm sectionalized	7,5 kg	448,– €

SCAN TO SHOP



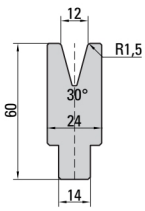


22.312 — 24h — 400 kN/m

835 mm	7,6 kg	310,– €
415 mm	3,8 kg	180,– €
800 mm sectionalized	7,2 kg	448,– €

SCAN TO SHOP



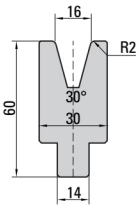


22.316 — 24h — 450 kN/m

835 mm	8,8 kg	334,– €
415 mm	4,4 kg	194,– €
800 mm sectionalized	8,4 kg	474,– €

SCAN TO SHOP



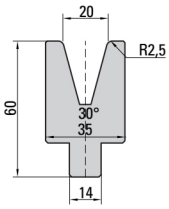


22.320 — 24h — 500 kN/m

835 mm	9,4 kg	352,– €
415 mm	4,7 kg	202,– €
800 mm sectionalized	9,0 kg	494,– €

SCAN TO SHOP



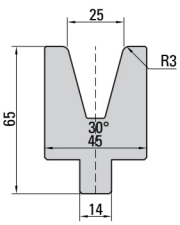


22.325 — 24h — 500 kN/m

835 mm	12,7 kg	372,– €
415 mm	6,3 kg	212,– €
800 mm sectionalized	12,1 kg	518,– €

SCAN TO SHOP





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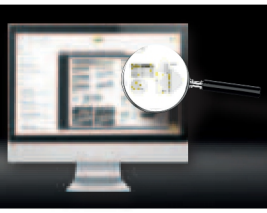


85° T-dies H = 80 mm

20.506

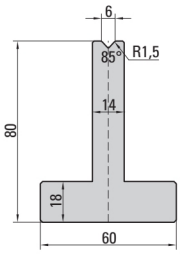
24h
1000 kN/m

835 mm	12,7 kg	278,– €
415 mm	6,3 kg	164,– €
800 mm sectionalized	12,1 kg	408,– €

88° T-die 20.806 on request

SCAN TO SHOP





20.508

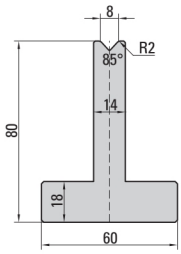
24h
1000 kN/m

835 mm	12,6 kg	278,– €
415 mm	6,3 kg	164,– €
800 mm sectionalized	12,1 kg	408,– €

88° T-die 20.808 on request

SCAN TO SHOP





20.510

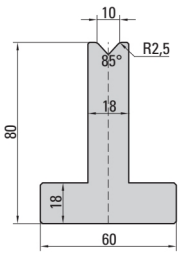
24h
1000 kN/m

835 mm	14,2 kg	278,– €
415 mm	7,1 kg	164,– €
800 mm sectionalized	13,6 kg	408,– €

88° T-die 20.810 on request

SCAN TO SHOP





20.512

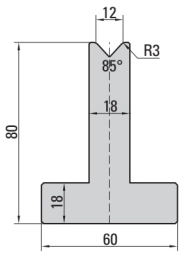
24h
1000 kN/m

835 mm	14,1 kg	278,– €
415 mm	7,0 kg	164,– €
800 mm sectionalized	13,5 kg	408,– €

88° T-die 20.371 on request

SCAN TO SHOP





20.516

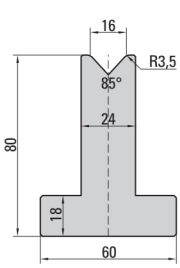
24h
1000 kN/m

835 mm	16,3 kg	278,– €
415 mm	8,1 kg	164,– €
800 mm sectionalized	15,7 kg	408,– €

88° T-die 20.327 on request

SCAN TO SHOP





20.520

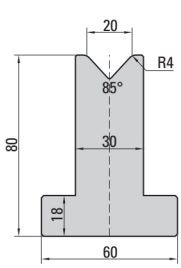
24h
1000 kN/m

835 mm	18,5 kg	278,– €
415 mm	9,2 kg	164,– €
800 mm sectionalized	17,7 kg	408,– €

88° T-die 20.310 on request

SCAN TO SHOP





20.525

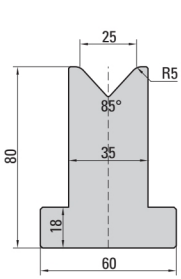
24h
1000 kN/m

835 mm	20,1 kg	278,– €
415 mm	10,0 kg	164,– €
800 mm sectionalized	19,3 kg	408,– €

88° T-die 20.309 on request

SCAN TO SHOP





UKB-PRESS BRAKE TOOL CABINETS
CHAPTER 16



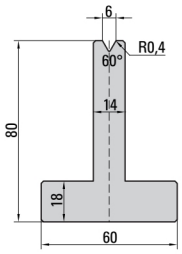
60° T-dies H = 80 mm

20.297 — 24h — 600 kN/m

835 mm	12,6 kg	302,– €
415 mm	6,3 kg	176,– €
800 mm sectionalized	12,1 kg	430,– €

SCAN TO SHOP



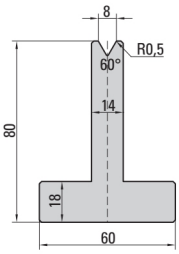


20.298 — 24h — 600 kN/m

835 mm	12,4 kg	302,– €
415 mm	6,2 kg	176,– €
800 mm sectionalized	12,0 kg	430,– €

SCAN TO SHOP



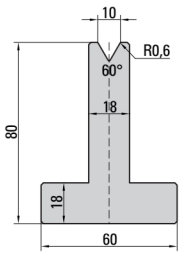


20.299 — 24h — 600 kN/m

835 mm	14,1 kg	302,– €
415 mm	7,0 kg	176,– €
800 mm sectionalized	13,5 kg	430,– €

SCAN TO SHOP



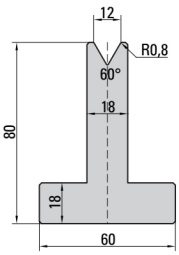


20.300 — 24h — 600 kN/m

835 mm	14,0 kg	302,– €
415 mm	6,9 kg	176,– €
800 mm sectionalized	13,4 kg	430,– €

SCAN TO SHOP



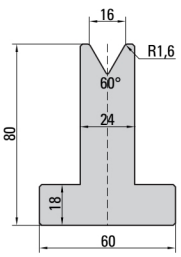


20.301 — 24h — 600 kN/m

835 mm	16,1 kg	302,– €
415 mm	8,0 kg	176,– €
800 mm sectionalized	15,4 kg	430,– €

SCAN TO SHOP



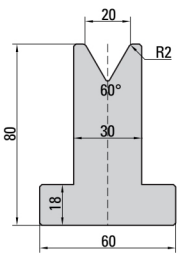


20.308 — 24h — 600 kN/m

835 mm	18,1 kg	302,– €
415 mm	9,0 kg	176,– €
800 mm sectionalized	17,4 kg	430,– €

SCAN TO SHOP



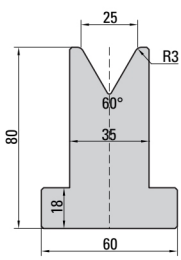


20.311 — 24h — 600 kN/m

835 mm	19,5 kg	302,– €
415 mm	9,7 kg	176,– €
800 mm sectionalized	18,7 kg	430,– €

SCAN TO SHOP





UKB-PROTECTIVE FILM
CHAPTER 13



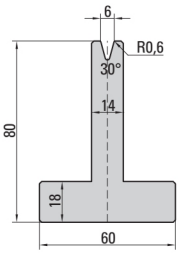
30° T-dies H = 80 mm

20.317 — 24h — 350 kN/m

835 mm	12,5 kg	336,– €
415 mm	6,2 kg	194,– €
800 mm sectionalized	12,0 kg	468,– €

SCAN TO SHOP



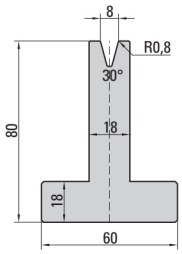


20.318 — 24h — 350 kN/m

835 mm	14,0 kg	336,– €
415 mm	7,0 kg	194,– €
800 mm sectionalized	13,4 kg	468,– €

SCAN TO SHOP



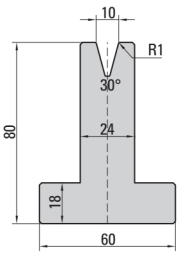


20.319 — 24h — 500 kN/m

835 mm	16,2 kg	336,– €
415 mm	8,1 kg	194,– €
800 mm sectionalized	15,5 kg	468,– €

SCAN TO SHOP



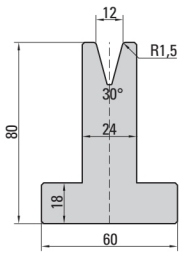


20.320 — 24h — 400 kN/m

835 mm	15,9 kg	336,– €
415 mm	7,9 kg	194,– €
800 mm sectionalized	15,3 kg	468,– €

SCAN TO SHOP



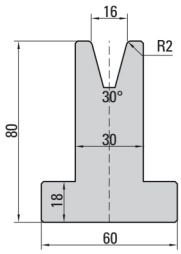


20.321 — 24h — 450 kN/m

835 mm	17,8 kg	336,– €
415 mm	8,9 kg	194,– €
800 mm sectionalized	17,1 kg	468,– €

SCAN TO SHOP



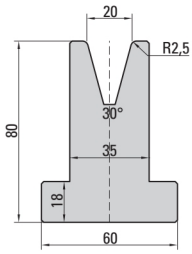


20.322 — 24h — 500 kN/m

835 mm	19,3 kg	336,– €
415 mm	9,6 kg	194,– €
800 mm sectionalized	18,5 kg	468,– €

SCAN TO SHOP



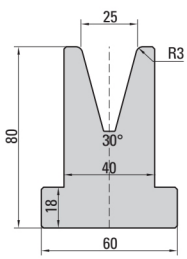


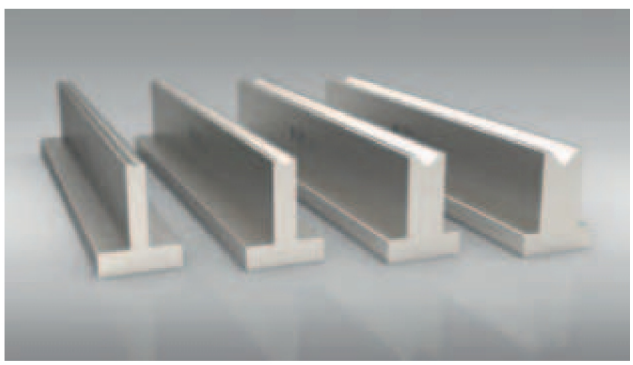
20.323 — 24h — 500 kN/m

835 mm	19,6 kg	336,– €
415 mm	9,8 kg	194,– €
800 mm sectionalized	18,8 kg	468,– €

SCAN TO SHOP







85° T-dies H = 120 mm

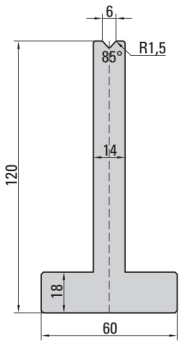
21.506 — 24h — 1000 kN/m

835 mm	16,3 kg	452,– €
415 mm	8,1 kg	256,– €
800 mm sectionalized	15,7 kg	600,– €

88° T-die 21.806 on request

SCAN TO SHOP





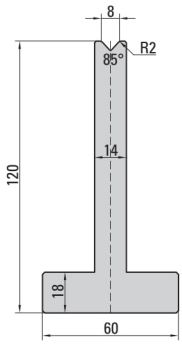
21.508 — 24h — 1000 kN/m

835 mm	16,3 kg	452,– €
415 mm	8,1 kg	256,– €
800 mm sectionalized	15,7 kg	600,– €

88° T-die 21.808 on request

SCAN TO SHOP





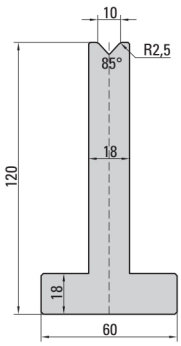
21.510 — 24h — 1000 kN/m

835 mm	18,9 kg	452,– €
415 mm	9,4 kg	256,– €
800 mm sectionalized	18,1 kg	600,– €

88° T-die 21.810 on request

SCAN TO SHOP





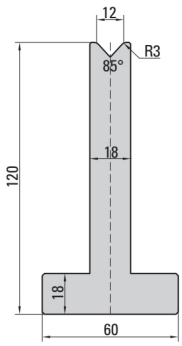
21.512 — 24h — 1000 kN/m

835 mm	18,8 kg	452,– €
415 mm	9,4 kg	256,– €
800 mm sectionalized	18,0 kg	600,– €

88° T-die 20.382 on request

SCAN TO SHOP





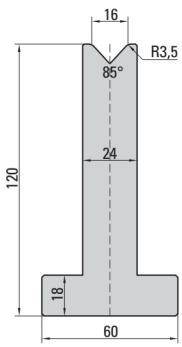
21.516 — 24h — 1000 kN/m

835 mm	22,6 kg	452,– €
415 mm	11,3 kg	256,– €
800 mm sectionalized	21,7 kg	600,– €

88° T-die 20.383 on request

SCAN TO SHOP





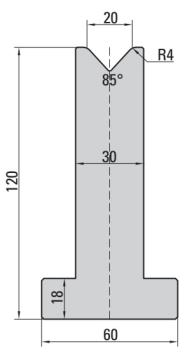
21.520 — 24h — 1000 kN/m

835 mm	26,4 kg	452,– €
415 mm	13,1 kg	256,– €
800 mm sectionalized	25,3 kg	600,– €

88° T-die 20.384 on request

SCAN TO SHOP





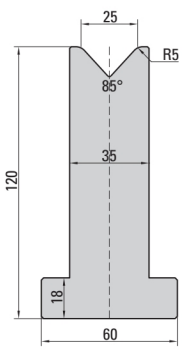
21.525 — 24h — 1000 kN/m

835 mm	29,3 kg	452,– €
415 mm	14,6 kg	256,– €
800 mm sectionalized	28,1 kg	600,– €

88° T-die 20.385 on request

SCAN TO SHOP







60° T-dies H = 120 mm

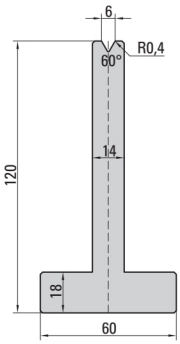
20.386

24h
600 kN/m

835 mm	16,3 kg	470,– €
415 mm	8,1 kg	264,– €
800 mm sectionalized	15,6 kg	620,– €

SCAN TO SHOP





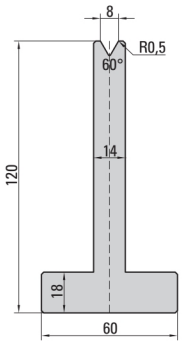
20.387

24h
600 kN/m

835 mm	16,2 kg	470,– €
415 mm	8,1 kg	264,– €
800 mm sectionalized	15,5 kg	620,– €

SCAN TO SHOP





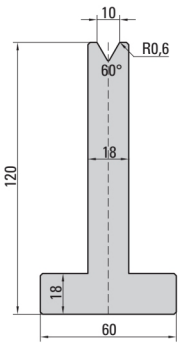
20.388

24h
600 kN/m

835 mm	18,8 kg	470,– €
415 mm	9,3 kg	264,– €
800 mm sectionalized	18,0 kg	620,– €

SCAN TO SHOP





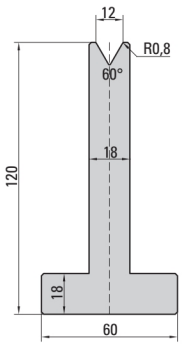
20.389

24h
600 kN/m

835 mm	18,7 kg	470,– €
415 mm	9,3 kg	264,– €
800 mm sectionalized	17,9 kg	620,– €

SCAN TO SHOP



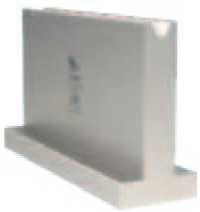


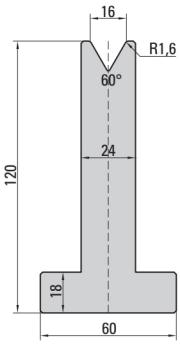
20.390

24h
600 kN/m

835 mm	22,4 kg	470,– €
415 mm	11,1 kg	264,– €
800 mm sectionalized	21,4 kg	620,– €

SCAN TO SHOP





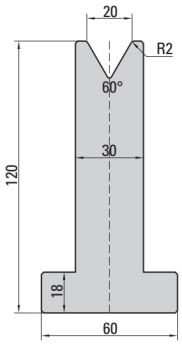
20.391

24h
600 kN/m

835 mm	26,0 kg	470,– €
415 mm	12,9 kg	264,– €
800 mm sectionalized	24,9 kg	620,– €

SCAN TO SHOP





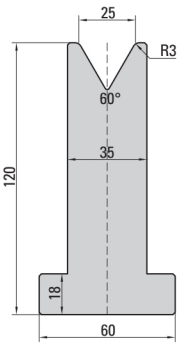
20.392

24h
600 kN/m

835 mm	28,7 kg	470,– €
415 mm	14,3 kg	264,– €
800 mm sectionalized	27,5 kg	620,– €

SCAN TO SHOP





UKB-UNIBEND AND
UKB-WINGBEND PLUS
CHAPTER 10



30° T-dies H = 120 mm

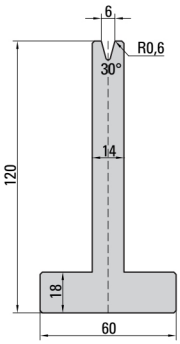
20.351

24h
350 kN/m

835 mm	16,2 kg	504,– €
415 mm	8,1 kg	282,– €
800 mm sectionalized	15,5 kg	652,– €

SCAN TO SHOP





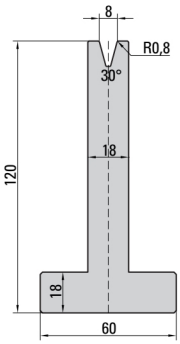
20.352

24h
350 kN/m

835 mm	18,7 kg	504,– €
415 mm	9,3 kg	282,– €
800 mm sectionalized	18,0 kg	652,– €

SCAN TO SHOP





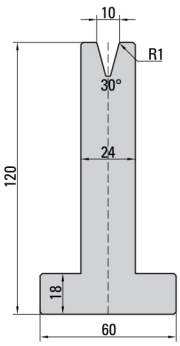
20.353

24h
500 kN/m

835 mm	22,8 kg	504,– €
415 mm	11,3 kg	282,– €
800 mm sectionalized	21,9 kg	652,– €

SCAN TO SHOP





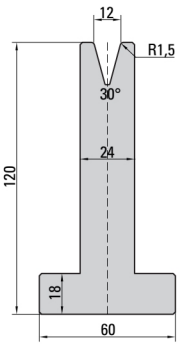
20.354

24h
400 kN/m

835 mm	22,2 kg	504,– €
415 mm	11,1 kg	282,– €
800 mm sectionalized	21,3 kg	652,– €

SCAN TO SHOP





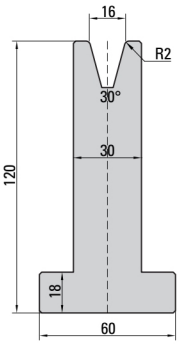
20.401

24h
450 kN/m

835 mm	25,7 kg	504,– €
415 mm	12,8 kg	282,– €
800 mm sectionalized	24,6 kg	652,– €

SCAN TO SHOP





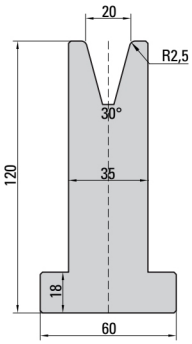
20.402

24h
500 kN/m

835 mm	28,1 kg	504,– €
415 mm	14,0 kg	282,– €
800 mm sectionalized	27,0 kg	652,– €

SCAN TO SHOP





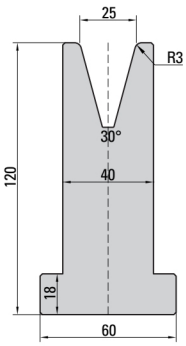
20.403

24h
500 kN/m

835 mm	30,1 kg	504,– €
415 mm	15,0 kg	282,– €
800 mm sectionalized	28,9 kg	652,– €

SCAN TO SHOP





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toolsystems24.de
schanksysteme24.de

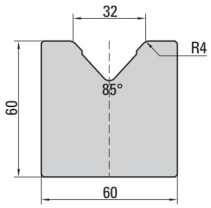
85° 1-V dies

20.210

24h
1000 kN/m

835 mm	21,5 kg	226,– €
415 mm	10,7 kg	132,– €
800 mm sectionalized	20,6 kg	390,– €



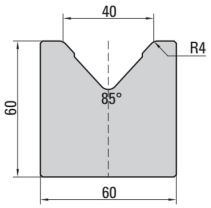


20.211

24h
1000 kN/m

835 mm	20,4 kg	226,– €
415 mm	10,2 kg	132,– €
800 mm sectionalized	19,6 kg	390,– €



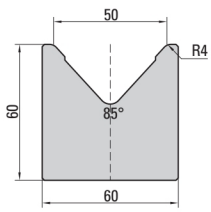


20.212

24h
1000 kN/m

835 mm	18,7 kg	226,– €
415 mm	9,3 kg	132,– €
800 mm sectionalized	18,0 kg	390,– €





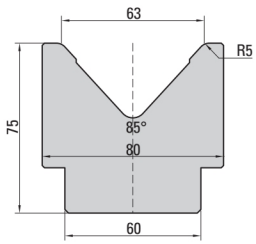
20.213

24h
1000 kN/m

835 mm	29,1 kg	360,– €
415 mm	14,5 kg	210,– €
800 mm sectionalized	27,9 kg	610,– €

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





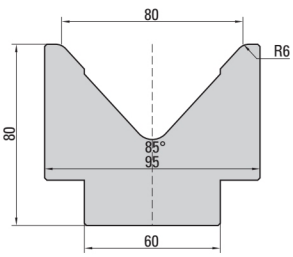
20.214

24h
1000 kN/m

835 mm	33,0 kg	444,– €
415 mm	16,4 kg	262,– €
800 mm sectionalized	31,6 kg	748,– €

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





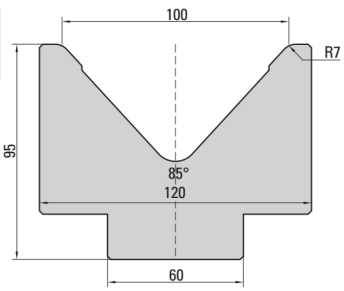
20.215

24h
1000 kN/m

835 mm	48,4 kg	518,– €
415 mm	24,1 kg	306,– €
800 mm sectionalized	46,4 kg	864,– €

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

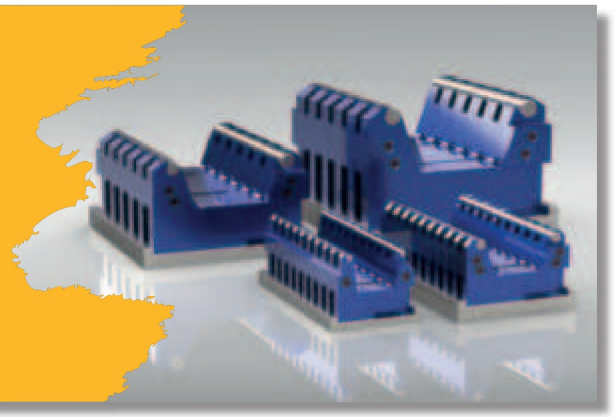




UKB-ADJUSTABLE DIES

- Variable adjustable V-openings
- V-openings quick and easy adjustable via change of the strips
- Usable for materials with high resistance
- Rotating and hardened rollers

CHAPTER 11

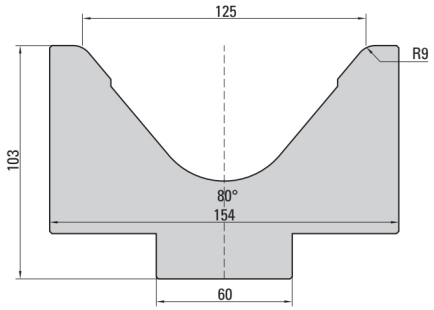


80° 1-V dies

21.125	24h 1500 kN/m	
415 mm	30,4 kg	398,– €
200 mm	14,6 kg	224,– €

SCAN TO SHOP

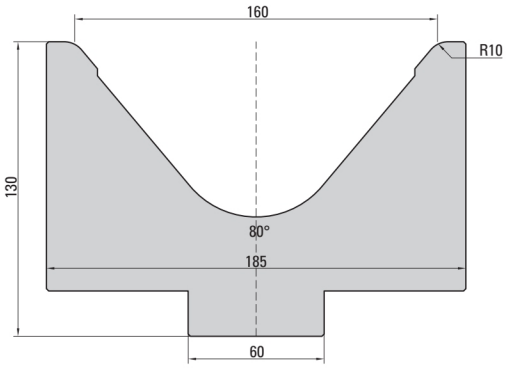




21.160	24h 1500 kN/m	
415 mm	45,4 kg	534,– €
200 mm	21,9 kg	300,– €

SCAN TO SHOP



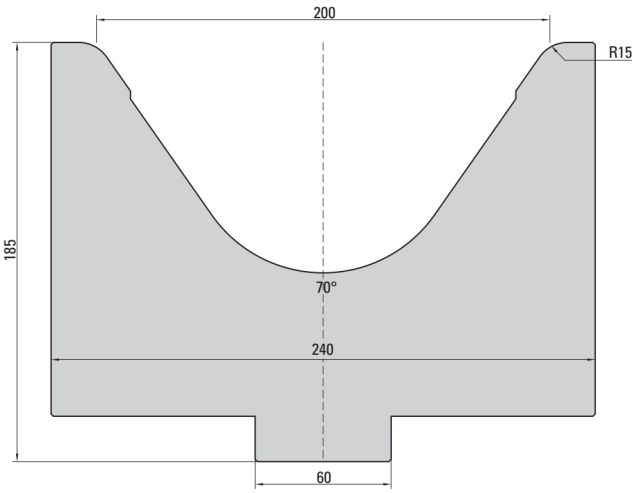


70° 1-V die

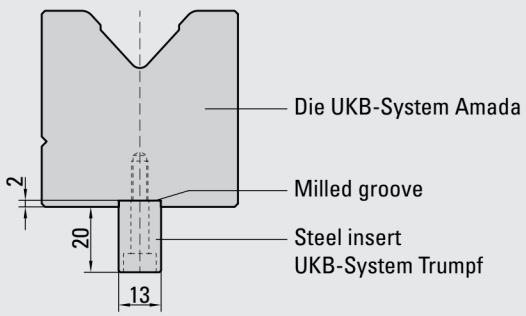
21.200	24h 2000 kN/m	
415 mm	89,9 kg	1.104,– €
200 mm	43,3 kg	614,– €

SCAN TO SHOP





MODIFICATION OF DIES UKB-SYSTEM AMADA





VIDEO

UKB-Modification of press brake tools

60° 1-V dies

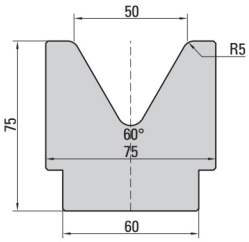
20.650 — 24h — 1000 kN/m

835 mm	27,9 kg	538,– €
415 mm	13,9 kg	306,– €
800 mm sectionalized	26,7 kg	784,– €

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

SCAN TO SHOP



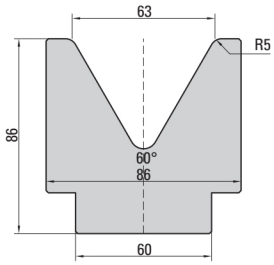


20.370 — 24h — 1000 kN/m

835 mm	34,0 kg	642,– €
415 mm	16,9 kg	362,– €
800 mm sectionalized	32,5 kg	932,– €

SCAN TO SHOP





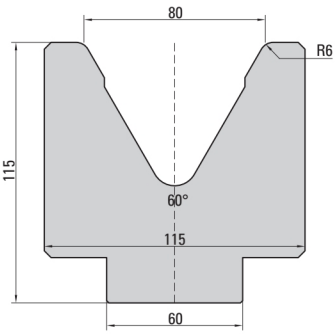
20.680 — 24h — 1000 kN/m

835 mm	60,1 kg	914,– €
415 mm	29,9 kg	532,– €
800 mm sectionalized	57,6 kg	1.356,– €

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

SCAN TO SHOP



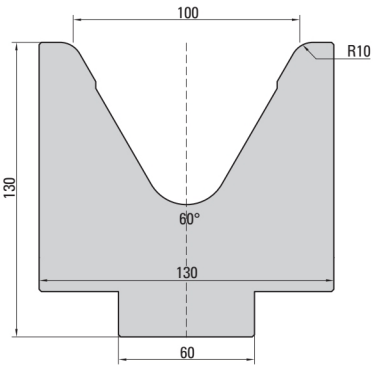


20.610 — 24h — 1000 kN/m

415 mm	36,3 kg	572,– €
800 mm sectionalized	69,9 kg	1.594,– €

SCAN TO SHOP





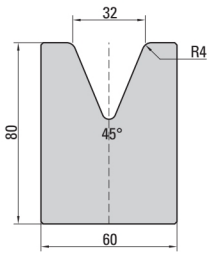
45° 1-V dies

20.484 — 24h — 1000 kN/m

835 mm	27,4 kg	302,– €
415 mm	13,6 kg	182,– €
800 mm sectionalized	26,3 kg	480,– €

SCAN TO SHOP



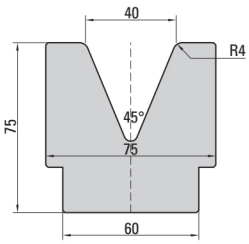


20.440 — 24h — 1000 kN/m

835 mm	28,6 kg	426,– €
415 mm	14,2 kg	250,– €
800 mm sectionalized	27,4 kg	674,– €

SCAN TO SHOP





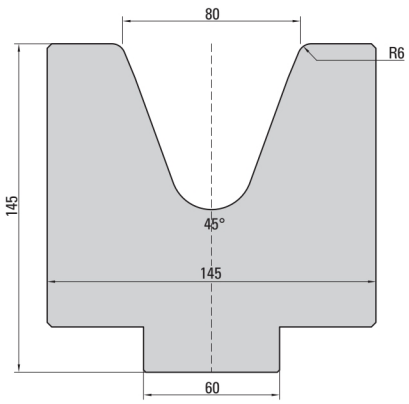
20.380 — 24h — 1000 kN/m

415 mm	50,7 kg	650,– €
200 mm	24,4kg	400,– €

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

SCAN TO SHOP





30° 1-V dies

20.494

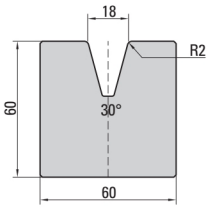
24h
1000 kN/m

835 mm	22,0 kg	254,– €
415 mm	11,0 kg	148,– €
800 mm sectionalized	21,1 kg	402,– €

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

SCAN TO SHOP





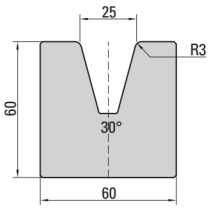
20.325

24h
1000 kN/m

835 mm	20,1 kg	298,– €
415 mm	10,0 kg	168,– €
800 mm sectionalized	19,3 kg	452,– €

SCAN TO SHOP





Die blocks

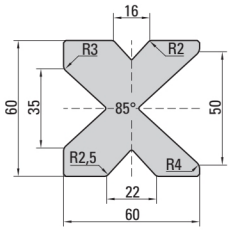
21.207

24h
800 kN/m

835 mm	15,6 kg	290,– €
415 mm	7,8 kg	174,– €
800 mm sectionalized	14,9 kg	462,– €

SCAN TO SHOP





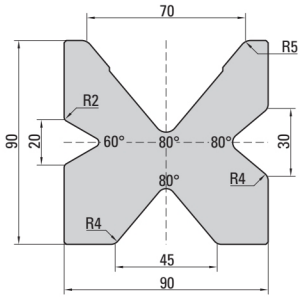
28.820

24h
800 kN/m

835 mm	36,2 kg	666,– €
415 mm	18,0 kg	388,– €
800 mm sectionalized	34,7 kg	1.150,– €

SCAN TO SHOP





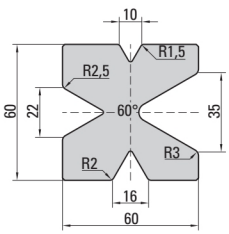
20.350

24h
600 kN/m

835 mm	17,8 kg	402,– €
415 mm	8,8 kg	230,– €
800 mm sectionalized	17,1 kg	578,– €

SCAN TO SHOP





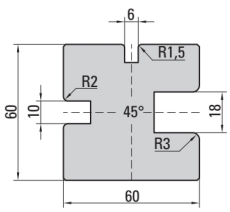
21.209

24h
1000 kN/m

835 mm	20,0 kg	274,– €
415 mm	10,0 kg	166,– €
800 mm sectionalized	19,2 kg	458,– €

SCAN TO SHOP





20.820

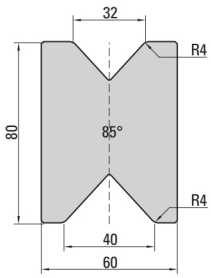
24h
1000 kN/m

835 mm	26,7 kg	368,– €
415 mm	13,3 kg	214,– €
800 mm sectionalized	25,6 kg	646,– €

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

SCAN TO SHOP





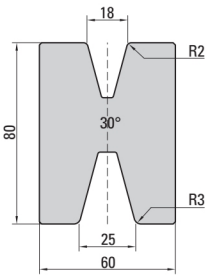
20.830

24h
1000 kN/m

835 mm	26,2 kg	438,– €
415 mm	13,0 kg	250,– €
800 mm sectionalized	25,1 kg	716,– €

SCAN TO SHOP



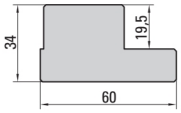


Die holders

20.200

24h
1000 kN/m

835 mm	9,5 kg	172,– €
415 mm	4,7 kg	98,– €



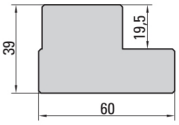
SCAN TO SHOP



20.316

24h
1000 kN/m

835 mm	11,4 kg	178,– €
415 mm	5,7 kg	104,– €



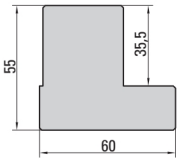
SCAN TO SHOP



20.201

24h
1000 kN/m

835 mm	14,2 kg	196,– €
415 mm	7,1 kg	112,– €



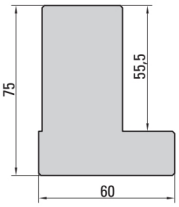
SCAN TO SHOP



20.306

24h
1000 kN/m

835 mm	19,0 kg	240,– €
415 mm	9,4 kg	138,– €



SCAN TO SHOP

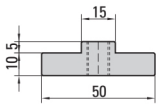


Die holders for centrical 2-V dies

20.287

24h
1000 kN/m

835 mm	3,8 kg	156,– €
415 mm	1,9 kg	92,– €



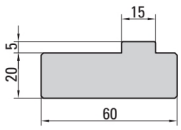
SCAN TO SHOP



20.400

24h
1000 kN/m

835 mm	8,3 kg	216,– €
415 mm	4,1 kg	124,– €



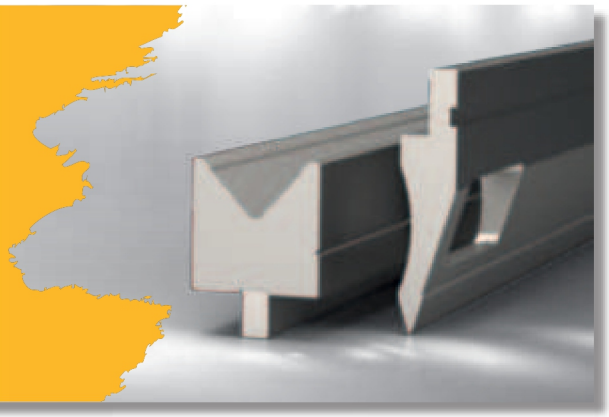
SCAN TO SHOP



UKB-MODIFICATION

- Modification of clampings, punch/top tools and dies
- Special cuttings, cut-outs, coatings and many more
- Flexible and individual
- According agreement within 1 working day

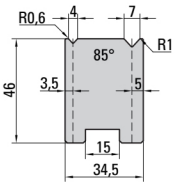
CHAPTER 18



85° Centrical 2-V dies

20.344 — 24h — 800 kN/m

835 mm	9,7 kg	236,– €
415 mm	4,8 kg	136,– €
800 mm sectionalized	9,3 kg	384,– €



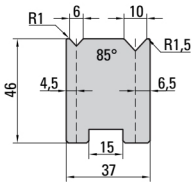
88° Centrical 2-V die 21.275 on request

SCAN TO SHOP



20.345 — 24h — 800 kN/m

835 mm	10,3 kg	236,– €
415 mm	5,1 kg	136,– €
800 mm sectionalized	9,9 kg	384,– €



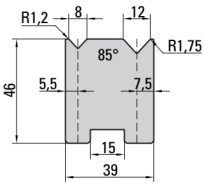
88° Centrical 2-V die 21.276 on request

SCAN TO SHOP



20.346 — 24h — 800 kN/m

835 mm	10,8 kg	236,– €
415 mm	5,4 kg	136,– €
800 mm sectionalized	10,3 kg	384,– €



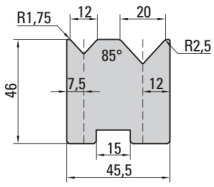
88° Centrical 2-V die 20.339 on request

SCAN TO SHOP



20.347 — 24h — 800 kN/m

835 mm	12,1 kg	240,– €
415 mm	6,0 kg	140,– €
800 mm sectionalized	11,6 kg	388,– €



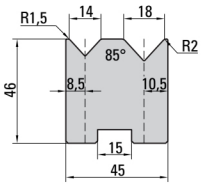
88° Centrical 2-V die 20.279 on request

SCAN TO SHOP



20.349 — 24h — 800 kN/m

835 mm	12,0 kg	240,– €
415 mm	6,0 kg	140,– €
800 mm sectionalized	11,5 kg	388,– €



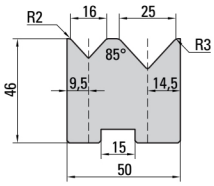
88° Centrical 2-V die 20.278 on request

SCAN TO SHOP



20.348 — 24h — 800 kN/m

835 mm	12,9 kg	244,– €
415 mm	6,4 kg	142,– €
800 mm sectionalized	12,4 kg	392,– €



88° Centrical 2-V die 20.280 on request

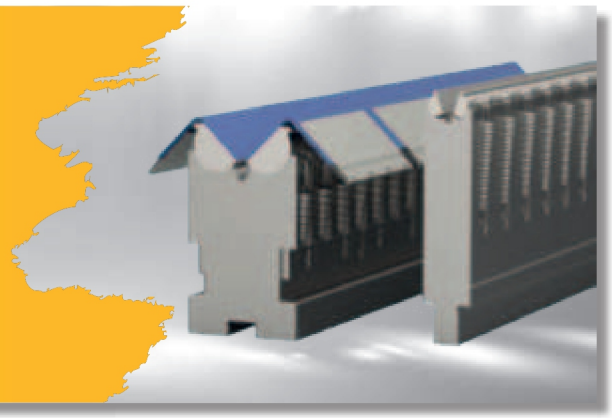
SCAN TO SHOP



UKB-WINGBEND PLUS

- Avoids bending marks on sheets via Slider
- Short flanges with near-mark-free results
- Holes close to the bending line without deformation
- Ideal for perforated sheets, tear plates and checker plates

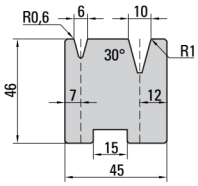
CHAPTER 10



30° Centrical 2-V dies

20.438 — 24h — 400 kN/m

835 mm	12,2 kg	320,– €
415 mm	6,0 kg	188,– €
800 mm sectionalized	11,7 kg	476,– €

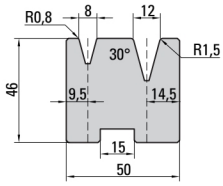


SCAN TO SHOP



20.478 — 24h — 400 kN/m

835 mm	13,2 kg	320,– €
415 mm	6,6 kg	188,– €
800 mm sectionalized	12,7 kg	476,– €



SCAN TO SHOP

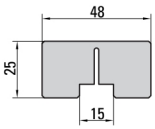


Clamping piece for centrical 2-V dies

20.336 — 24h

Per piece	0,12 kg	26,– €

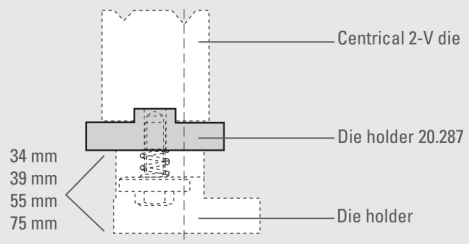
Clamping piece to fix small centrical 2-V dies on the die holder 20.287 and 20.400

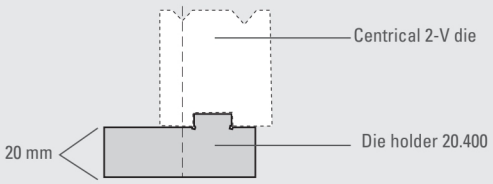


SCAN TO SHOP

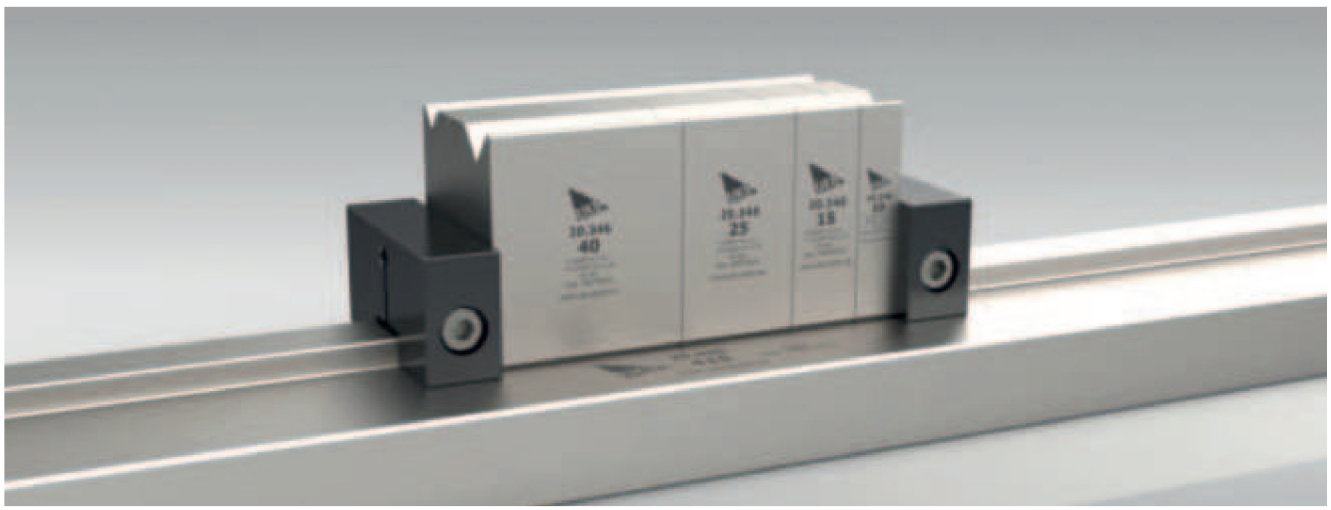


EXAMPLE OF USE





To use on press brakes with lower daylight



Spring-loaded flattening dies

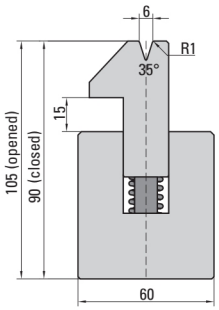
20.264 — 24h — 600 kN/m

835 mm	29,9 kg	632,– €
415 mm	14,9 kg	380,– €

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

SCAN TO SHOP





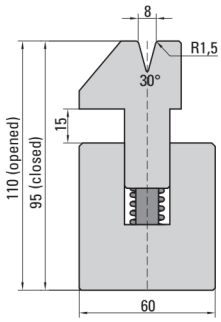
20.303 — 24h — 800 kN/m

835 mm	32,5 kg	692,– €
415 mm	16,2 kg	416,– €

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

SCAN TO SHOP





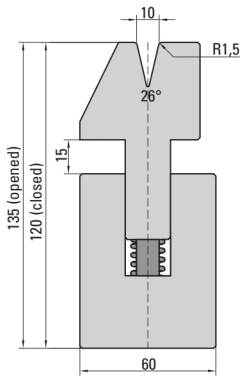
20.231 — 24h — 1000 kN/m

835 mm	42,4 kg	774,– €
415 mm	21,1 kg	478,– €

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

SCAN TO SHOP





20.305 — 24h — 1000 kN/m

835 mm	45,1 kg	914,– €
415 mm	22,4 kg	560,– €

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

SCAN TO SHOP



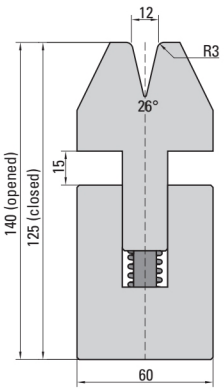
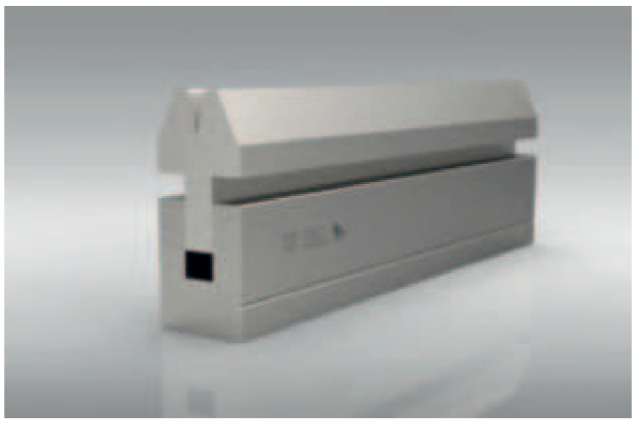


Table of force for flattening

Material: R_m = 400 N/mm², mild steel

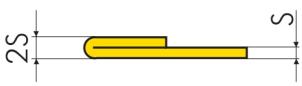
S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	9	3,0	23	1,2
0,8	12	3,0	32	1,6
1,0	15	3,5	40	2,0
1,25	17	3,5	50	2,5
1,5	22	4,6	63	3,0
2,0	30	5,5	80	4,0
2,5	55	6,5	90	5,0
3,0	70	8,0	100	6,0

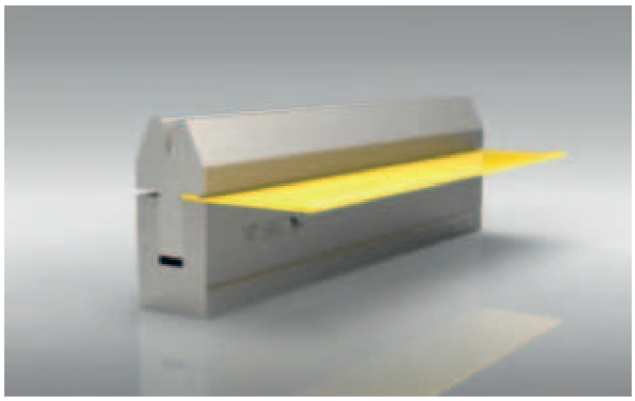


Material: R_m = 700 N/mm², stainless steel

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

Product 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

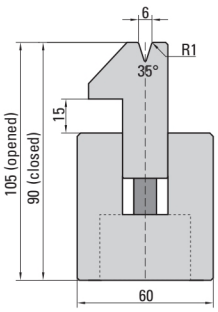
21.264 — 600 kN/m

835 mm	30,0 kg	1.098,– €
415 mm	14,9 kg	846,– €

Max. 1,0 mm material thickness
R_m = 400 N/mm²
Delivery time on request

SCAN TO SHOP





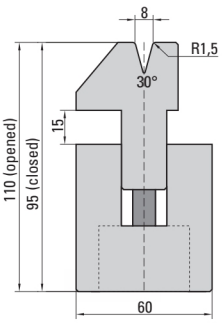
21.303 — 800 kN/m

835 mm	32,5 kg	1.158,– €
415 mm	16,2 kg	882,– €

Max. 1,5 mm material thickness
R_m = 400 N/mm²
Delivery time on request

SCAN TO SHOP





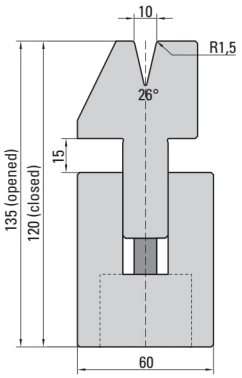
21.231 — 1000 kN/m

835 mm	42,4 kg	1.240,– €
415 mm	21,1 kg	944,– €

Max. 2,0 mm material thickness
R_m = 400 N/mm²
Delivery time on request

SCAN TO SHOP





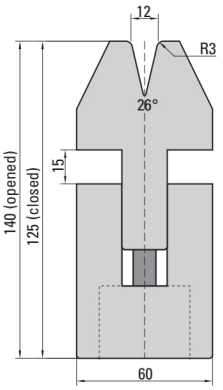
21.305 — 1000 kN/m

835 mm	45,1 kg	1.380,– €
415 mm	22,4 kg	1.026,– €

Max. 3,0 mm material thickness
R_m = 400 N/mm²
Delivery time on request

SCAN TO SHOP





50.720

Per piece	3,5 kg	268,– €

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

SCAN TO SHOP



UKB GROUP
ukb-gmbh.de
toolsystems24.de
schanksysteme24.de

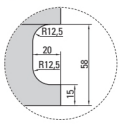
Flattening punches/top tools and flattening dies

11.550

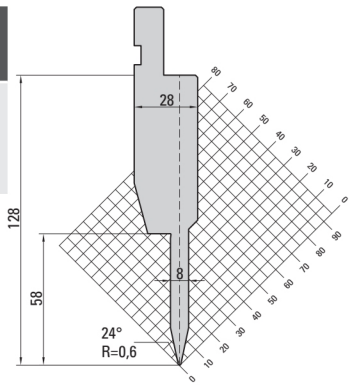
24h
800 kN/m

835 mm	17,3 kg	646,– €
415 mm	8,6 kg	374,– €
800 mm sectionalized	16,1 kg	974,– €

SCAN TO SHOP







20.550

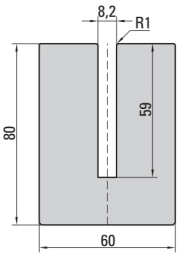
24h
500 kN/m

835 mm	28,3 kg	470,– €
415 mm	14,1 kg	268,– €
800 mm sectionalized	27,3 kg	746,– €

Max. 1,2 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP



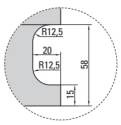


11.554

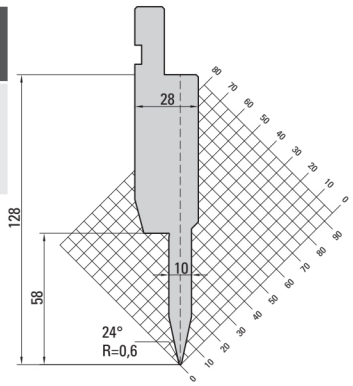
24h
800 kN/m

835 mm	18,1 kg	646,– €
415 mm	9,0 kg	374,– €
800 mm sectionalized	16,8 kg	974,– €

SCAN TO SHOP







20.554

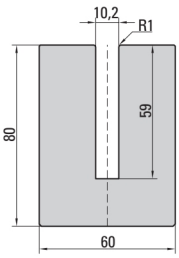
24h
500 kN/m

835 mm	27,5 kg	470,– €
415 mm	13,7 kg	268,– €
800 mm sectionalized	26,4 kg	746,– €

Max. 1,8 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP



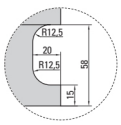


11.560

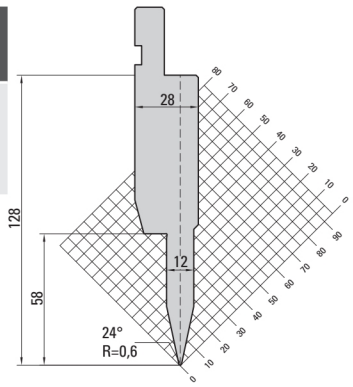
24h
800 kN/m

835 mm	18,6 kg	646,– €
415 mm	9,2 kg	374,– €
800 mm sectionalized	17,3 kg	974,– €

SCAN TO SHOP







20.560

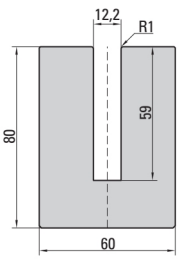
24h
500 kN/m

835 mm	26,7 kg	470,– €
415 mm	13,3 kg	268,– €
800 mm sectionalized	25,8 kg	746,– €

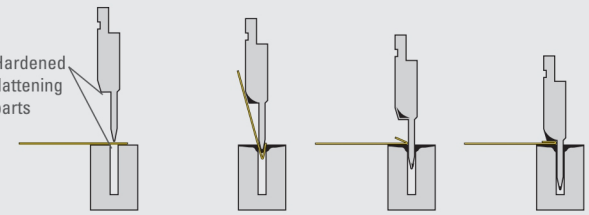
Max. 2,5 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP





EXAMPLE OF USE



Surface ground to reduce marking

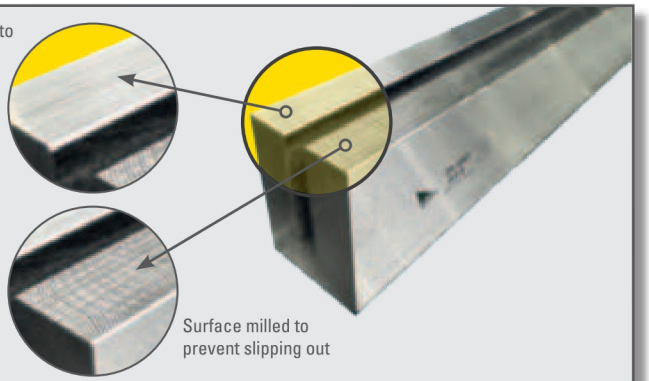


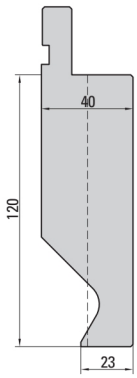
Table of force for flattening see page 62

Flattening punch/top tool and flattening die

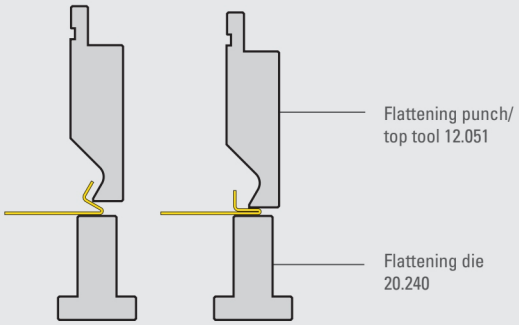
12.051	24h 450 kN/m	
835 mm	28,7 kg	420,– €
415 mm	14,3 kg	238,– €
800 mm sectionalized	26,6 kg	582,– €

SCAN TO SHOP





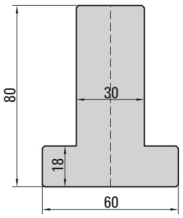
EXAMPLE OF USE



20.240	24h 1000 kN/m	
835 mm	19,2 kg	268,– €
415 mm	9,6 kg	152,– €
800 mm sectionalized	18,4 kg	392,– €

SCAN TO SHOP



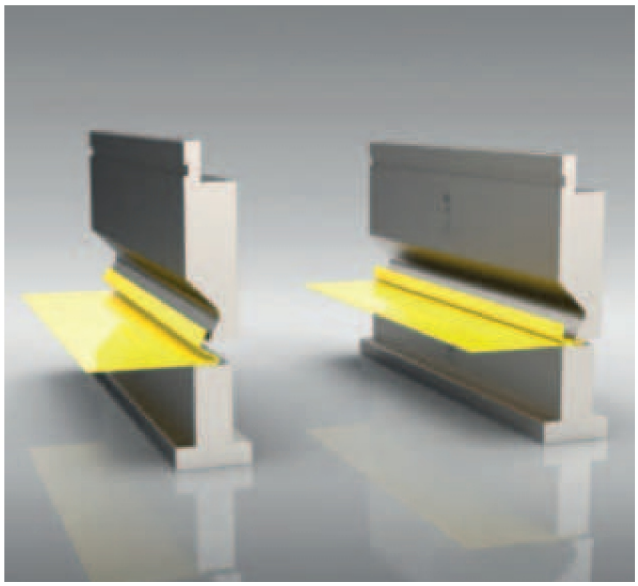


UKB-INFO

Another flattening tool 10.325 see page 187!

VIDEO

UKB-Flattening tools

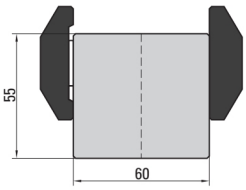


Die riser

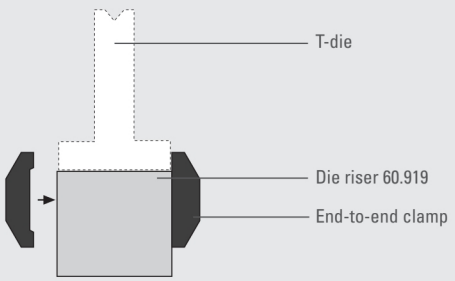
60.919	24h 1000 kN/m	
835 mm	29,3 kg	272,– €
415 mm	14,5 kg	172,– €

SCAN TO SHOP





EXAMPLE OF USE



PRESS BRAKE TOOLS
UKB-SYSTEM TRUMPF

Explanation 68-70

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Simple Clamp 71
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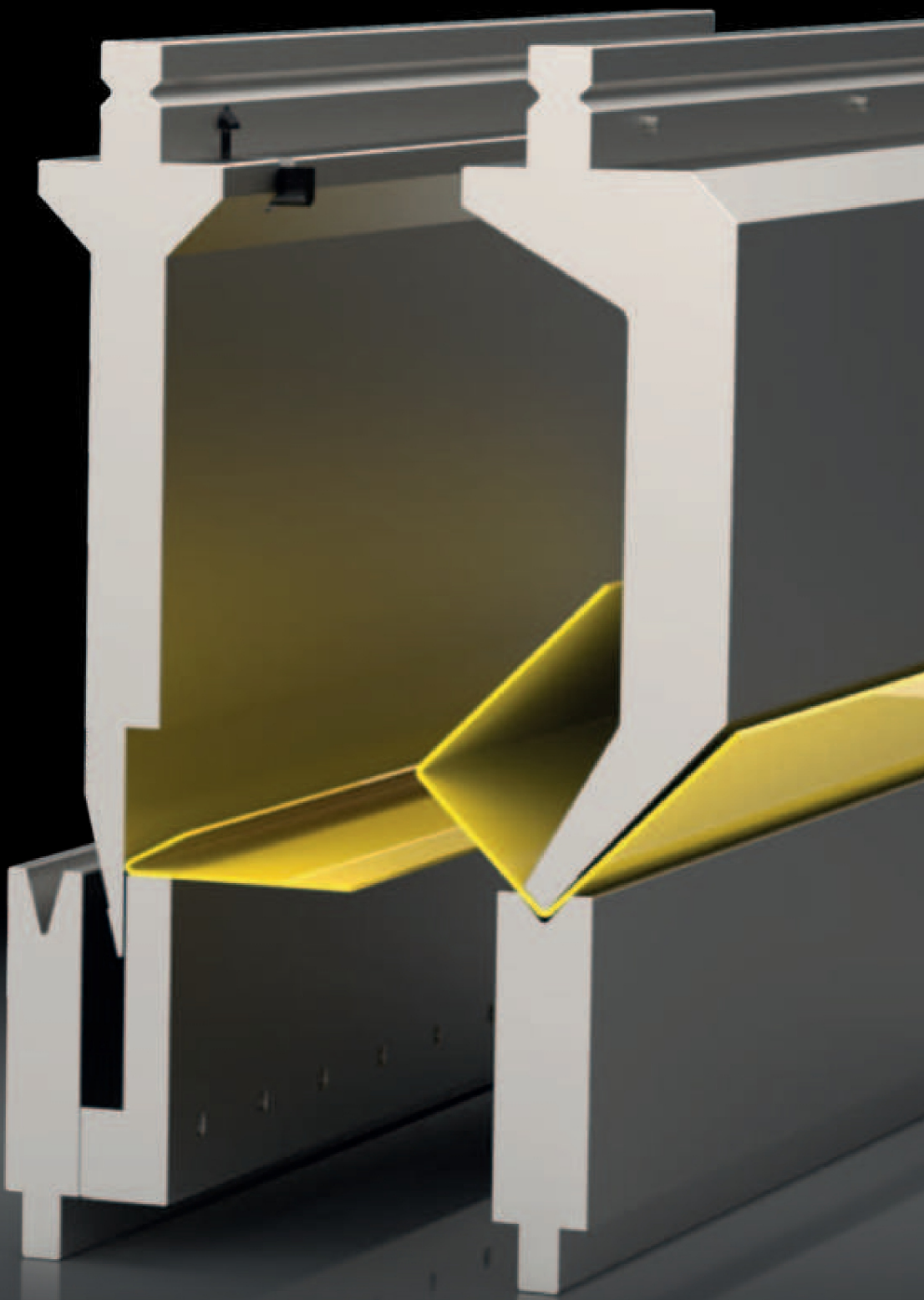

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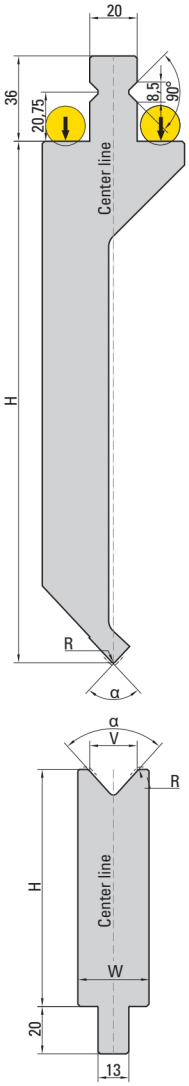
SYSTEM TRUMPF

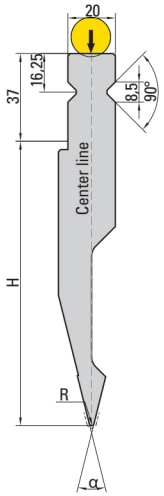
Quality and precision

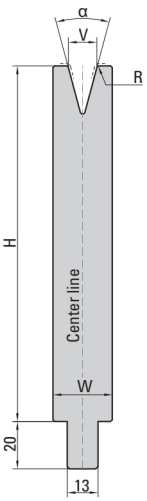
- **Optimum materials**
  - 42 CrMo4, tempered to 1100 - 1200 N/mm²
  - C45, tempered to 800 - 850 N/mm²
  - C45, 650 - 800 N/mm
- Bending radius/intake radii
  hardened up to 52 - 55 HRC
- **Precision ground**
- **Guaranteed exchangeability and parallelism**
- **Punch/top tool clampings in two different 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

Force on shoulder



Force on head





VIDEO

UKB-Press brake tool systems

UKB-ADVANTAGES

VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:	According agreement
Direct courier:	According agreement

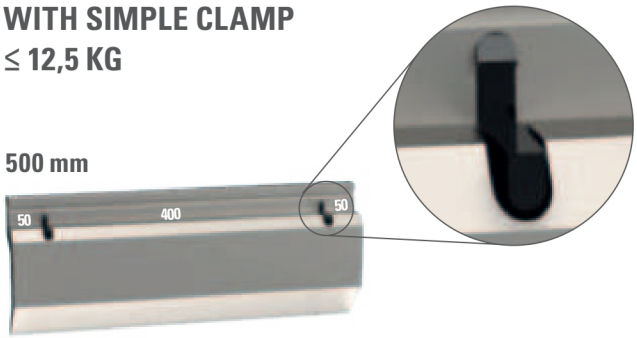
- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Tool lengths

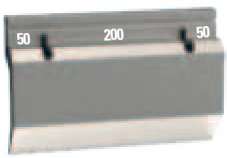
PUNCHES/TOP TOOLS

WITH SIMPLE CLAMP
≤ 12,5 KG

500 mm



300 mm



200 mm



100 mm



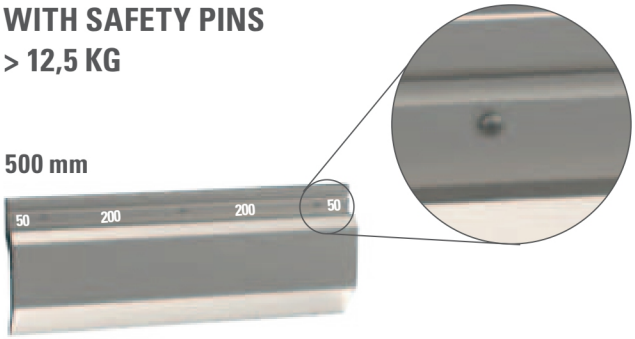
550 mm sectionalized



▸ 10 Segments, with horn extension left and right

WITH SAFETY PINS
> 12,5 KG

500 mm



300 mm



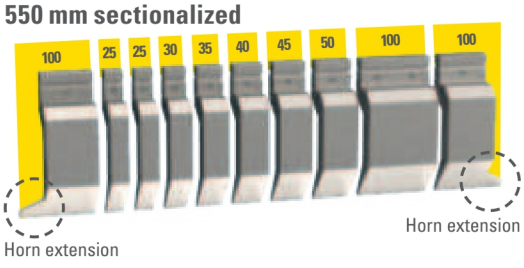
200 mm



100 mm

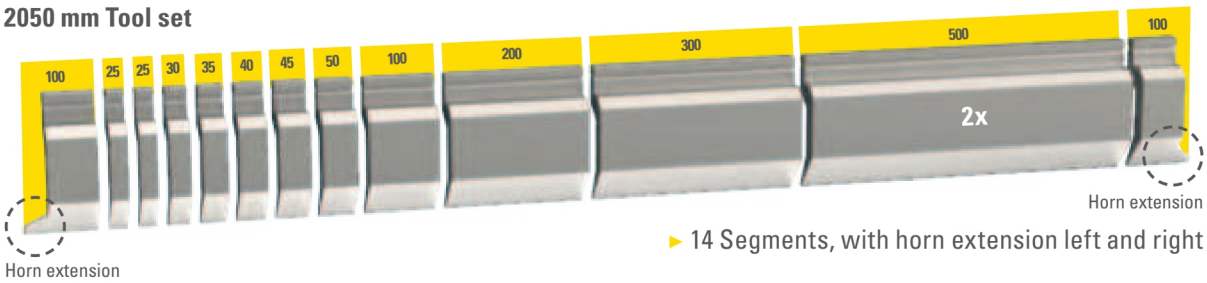


550 mm sectionalized



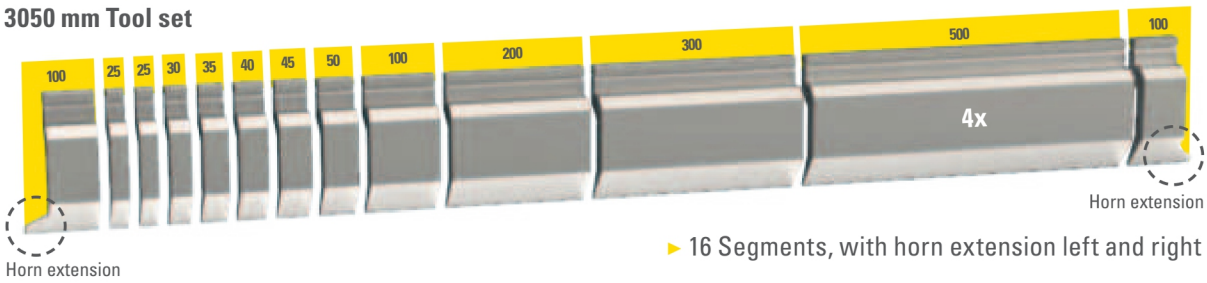
▸ 10 Segments, with horn extension left and right

2050 mm Tool set



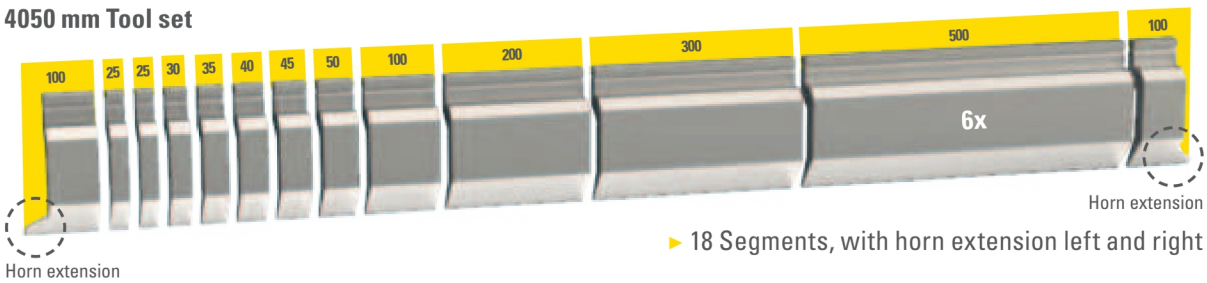
▸ 14 Segments, with horn extension left and right

3050 mm Tool set



▸ 16 Segments, with horn extension left and right

4050 mm Tool set



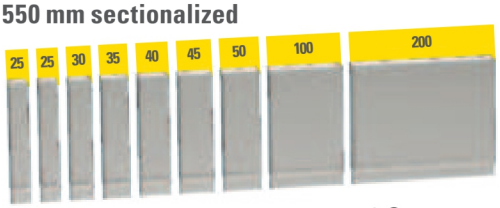
▸ 18 Segments, with horn extension left and right

DIES

500 mm | 300 mm | 200 mm | 100 mm



550 mm sectionalized



▸ 9 Segments

2050 mm Tool set



▸ 14 Segments

3050 mm Tool set



▸ 16 Segments

4050 mm Tool set



▸ 18 Segments

UKB-SYSTEM WILA

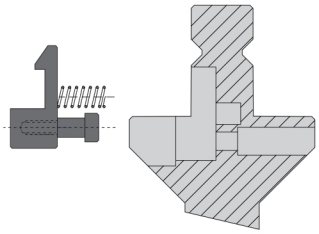
- ▸ Tools can be used in clampings of UKB-System Trumpf
- ▸ Punches/top tools available in H=163 mm and H=200 mm
- ▸ Dies available in H=55 mm and H=100 mm

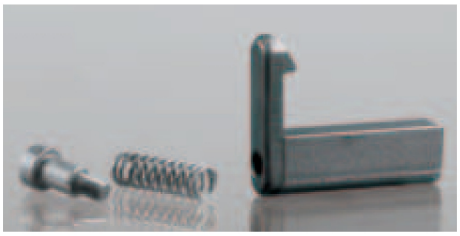
CHAPTER 03



Simple Clamp

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





Set consists of screw, spring and Simple Clamp

70.714 24h

Set 0,012 kg 16,– €

SCAN TO SHOP

Suitable for punch/top tool
15.310

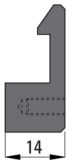


70.715 24h

Set 0,014 kg 16,– €

SCAN TO SHOP

Suitable for punches/top tools
15.320 / 15.620

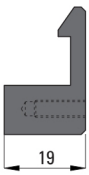


70.716 24h

Set 0,016 kg 18,– €

SCAN TO SHOP

Suitable for punches/top tools
15.330 / 15.335 / 15.902 / 15.904 / 15.905

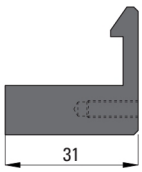


70.717 24h

Set 0,023 kg 18,– €

SCAN TO SHOP

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

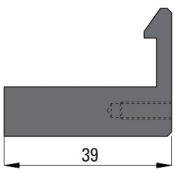


70.718 24h

Set 0,027 kg 20,– €

SCAN TO SHOP

Suitable for punches/top tools
15.370 / 15.480

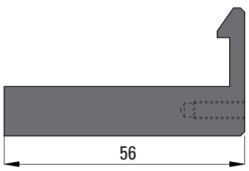


70.719 24h

Set 0,038 kg 20,– €

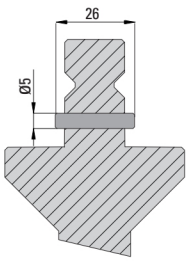
SCAN TO SHOP

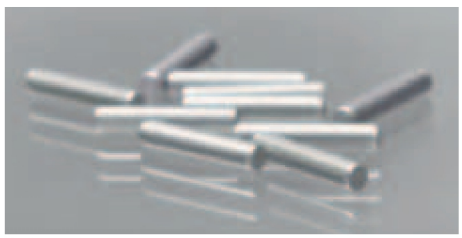
Suitable for punches/top tools
15.380 / 15.700 / 15.800



Safety pins

- **Horizontal** tool change for segments **more than 12,5 kg**
- Safety pins available hardened and non-hardened

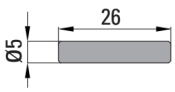




Safety pins

70.130 24h

10 Pieces 0,16 kg 4,– €

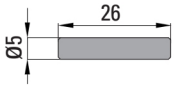


Hardened

SCAN TO SHOP

70.140 24h

10 Pieces 0,16 kg 2,– €



Non-hardened

SCAN TO SHOP

Flexible modification

PUNCHES/TOP TOOLS

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

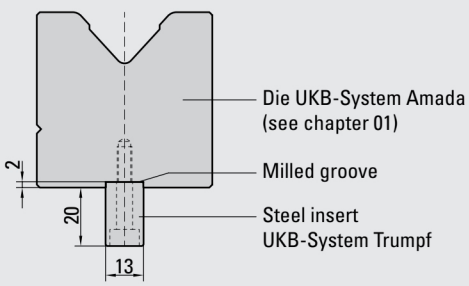


DIES

- Special cuttings
- Laser marking



MODIFICATION OF DIES UKB-SYSTEM AMADA





VIDEO

UKB-Modification of Press Brake Tools

Punches/top tools H = 120 mm

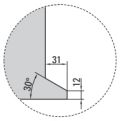
15.330

24h
800 kN/m

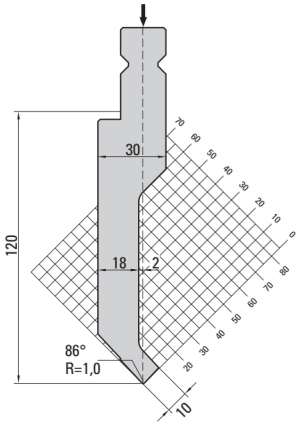
Simple Clamp

500 mm	12,1 kg	360,– €
300 mm	7,2 kg	284,– €
200 mm	4,8 kg	232,– €
100 mm	2,4 kg	132,– €
100 mm Horn left/right	2,0 kg	176,– €
550 mm sectionalized	11,9 kg	810,– €
2050 mm Tool set	48,1 kg	2.006,– €
3050 mm Tool set	72,3 kg	2.684,– €
4050 mm Tool set	96,5 kg	3.346,– €

SCAN TO SHOP







Other radii - prices on request

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

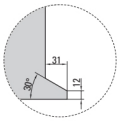
15.335

24h
300 kN/m

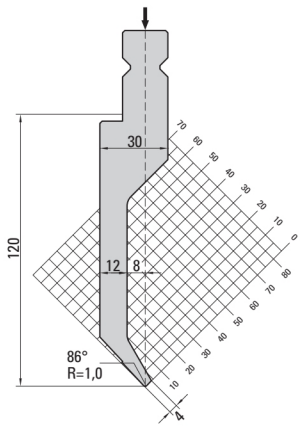
Simple Clamp

500 mm	10,0 kg	490,– €
300 mm	6,0 kg	368,– €
200 mm	4,0 kg	286,– €
100 mm	2,0 kg	164,– €
100 mm Horn left/right	1,7 kg	208,– €
550 mm sectionalized	9,8 kg	932,– €
2050 mm Tool set	39,8 kg	2.514,– €
3050 mm Tool set	59,8 kg	3.440,– €
4050 mm Tool set	79,8 kg	4.344,– €

SCAN TO SHOP







Other radii - prices on request

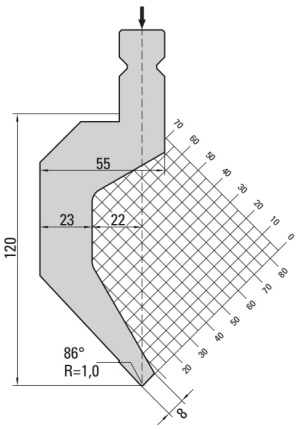
R (mm)	0,5	2,0	2,5	3,0
H (mm)	119,8	119,2	119,0	118,8

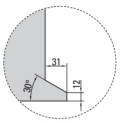
Punches/top tools H = 120 mm

15.370		24h 800 kN/m
Safety pins		
500 mm	14,6 kg	528,– €
Simple Clamp		
300 mm	8,7 kg	430,– €
200 mm	5,8 kg	328,– €
100 mm	2,9 kg	178,– €
100 mm Horn left/right	2,4 kg	222,– €
550 mm sectionalized	14,4 kg	1.014,– €
2050 mm Tool set	58,1 kg	2.772,– €
3050 mm Tool set	87,3 kg	3.768,– €
4050 mm Tool set	116,5 kg	4.742,– €

SCAN TO SHOP







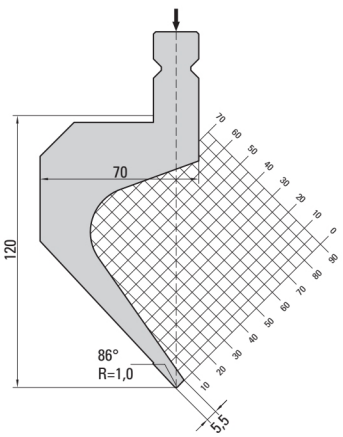
Other radii - prices on request

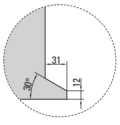
R (mm)	0,5	2,0	2,5	3,0	4,0	5,0	6,0
H (mm)	119,8	119,2	119,0	118,7	118,3	117,8	117,3

15.380		24h 250 kN/m
Safety pins		
500 mm	15,4 kg	758,– €
Simple Clamp		
300 mm	9,3 kg	556,– €
200 mm	6,2 kg	394,– €
100 mm	3,1 kg	222,– €
100 mm Horn left/right	2,6 kg	266,– €
550 mm sectionalized	15,2 kg	1.374,– €
2050 mm Tool set	61,5 kg	3.764,– €
3050 mm Tool set	92,3 kg	5.196,– €
4050 mm Tool set	123,1 kg	6.598,– €

SCAN TO SHOP







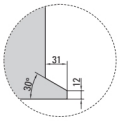
Other radii - prices on request

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

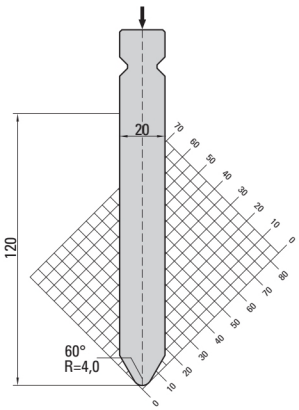
Punches/top tools H = 120 mm

15.310		24h 1300 kN/m
Simple Clamp		
500 mm	11,8 kg	304,– €
300 mm	7,2 kg	246,– €
200 mm	4,8 kg	204,– €
100 mm	2,4 kg	120,– €
100 mm Horn left/right	2,0 kg	164,– €
550 mm sectionalized	11,6 kg	710,– €
2050 mm Tool set	47,2 kg	1.732,– €
3050 mm Tool set	70,8 kg	2.304,– €
4050 mm Tool set	94,4 kg	2.864,– €

SCAN TO SHOP





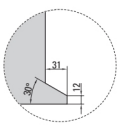


Other radii - prices on request

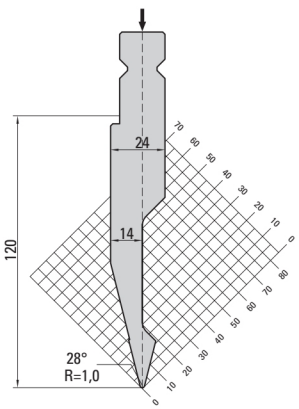
R (mm)	2,0	2,5	3,0	5,0	6,0
H (mm)	119,8	119,8	119,8	118,8	117,6

15.320		24h 800 kN/m
Simple Clamp		
500 mm	9,8 kg	356,– €
300 mm	6,0 kg	284,– €
200 mm	4,0 kg	232,– €
100 mm	2,0 kg	132,– €
100 mm Horn left/right	1,7 kg	176,– €
550 mm sectionalized	9,6 kg	860,– €
2050 mm Tool set	39,2 kg	2.046,– €
3050 mm Tool set	58,8 kg	2.716,– €
4050 mm Tool set	78,4 kg	3.372,– €

SCAN TO SHOP







Other radii - prices on request

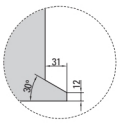
R (mm)	0,5	2,0	2,5	3,0	4,0
H (mm)	119,8	116,0	114,4	112,8	109,8

Punches/top tools H = 140 mm

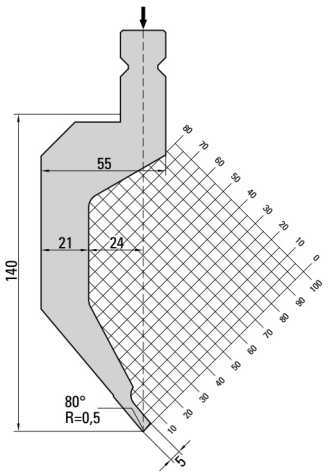
15.480 — 24h — 400 kN/m

Safety pins		
500 mm	15,4 kg	746,– €
Simple Clamp		
300 mm	9,3 kg	514,– €
200 mm	6,2 kg	374,– €
100 mm	3,1 kg	206,– €
100 mm Horn left/right	2,5 kg	250,– €
550 mm sectionalized	15,2 kg	1.250,– €
2050 mm Tool set	61,5 kg	3.558,– €
3050 mm Tool set	92,3 kg	4.968,– €
4050 mm Tool set	123,1 kg	6.350,– €

SCAN TO SHOP







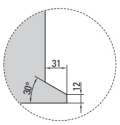
Other radii - prices on request

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

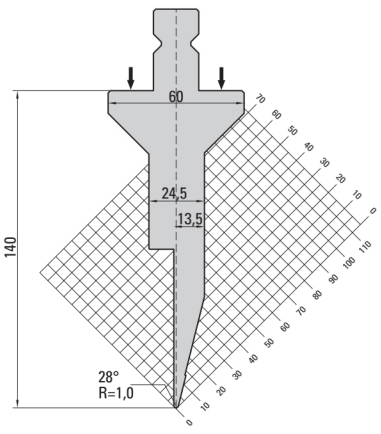
15.450 — 24h — 400 kN/m

Safety pins		
500 mm	14,5 kg	664,– €
Simple Clamp		
300 mm	8,7 kg	528,– €
200 mm	5,8 kg	388,– €
100 mm	2,9 kg	208,– €
100 mm Horn left/right	2,4 kg	252,– €
550 mm sectionalized	14,3 kg	1.390,– €
2050 mm Tool set	57,8 kg	3.562,– €
3050 mm Tool set	86,8 kg	4.814,– €
4050 mm Tool set	115,8 kg	6.038,– €

SCAN TO SHOP







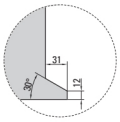
Other radius - price on request

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

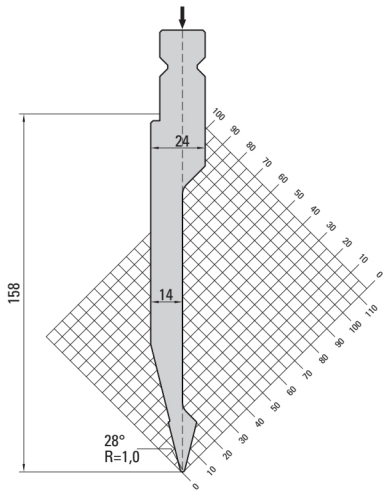
Punch/top tool H = 158 mm

15.620		24h 800 kN/m
Simple Clamp		
500 mm	11,5 kg	410,– €
300 mm	6,9 kg	328,– €
200 mm	4,6 kg	270,– €
100 mm	2,3 kg	152,– €
100 mm Horn left/right	1,9 kg	196,– €
550 mm sectionalized	11,2 kg	988,– €
2050 mm Tool set	45,7 kg	2.358,– €
3050 mm Tool set	68,7 kg	3.130,– €
4050 mm Tool set	91,7 kg	3.884,– €

SCAN TO SHOP







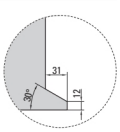
Other radii - prices on request

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

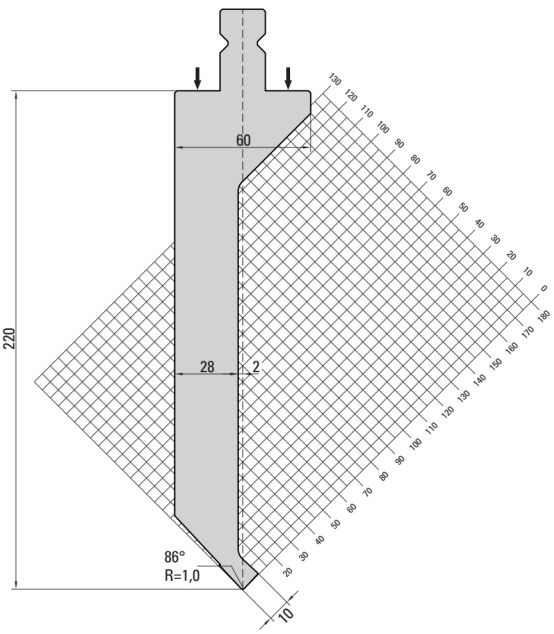
Punch/top tool H = 220 mm

15.710		24h 800 kN/m
Safety pins		
500 mm	28,5 kg	652,– €
300 mm	17,1 kg	482,– €
Simple Clamp		
200 mm	11,4 kg	422,– €
100 mm	5,7 kg	230,– €
100 mm Horn left/right	4,4 kg	274,– €
550 mm sectionalized	27,9 kg	1.452,– €
2050 mm Tool set	113,4 kg	3.586,– €
3050 mm Tool set	170,4 kg	4.816,– €
4050 mm Tool set	227,4 kg	6.018,– €

SCAN TO SHOP







Other radii - prices on request

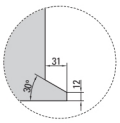
R (mm)	0,5	2,0	2,5	3,0	4,0	5,0	6,0
H (mm)	219,8	219,2	218,7	218,5	218,3	217,8	217,5

Punches/top tools H = 220 mm

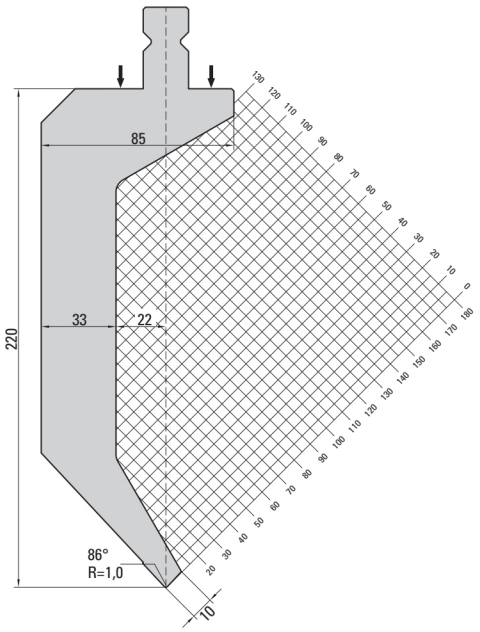
15.700 — 24h — 800 kN/m

Safety pins		
500 mm	33,5 kg	870,– €
300 mm	20,1 kg	656,– €
200 mm	13,4 kg	442,– €
Simple Clamp		
100 mm	6,7 kg	274,– €
100 mm Horn left/right	5,1 kg	318,– €
550 mm sectionalized	32,4 kg	1.764,– €
2050 mm Tool set	132,9 kg	4.510,– €
3050 mm Tool set	199,9 kg	6.152,– €
4050 mm Tool set	266,9 kg	7.758,– €

SCAN TO SHOP







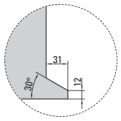
Other radii - prices on request

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

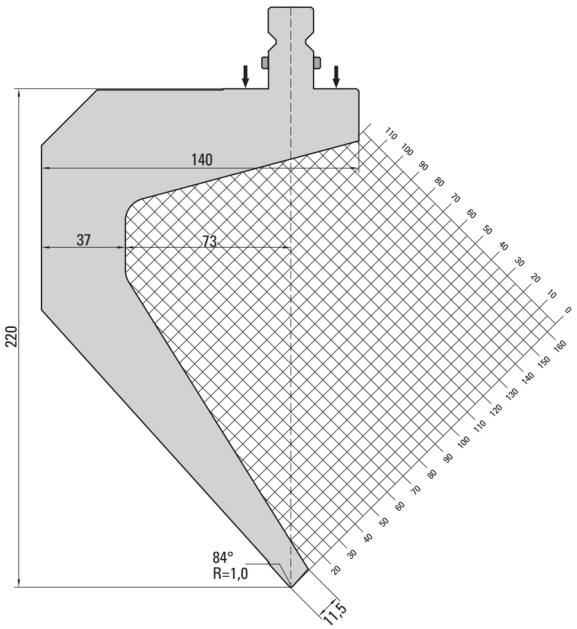
15.790 — 24h — 600 kN/m

Safety pins		
200 mm	17,8 kg	854,– €
100 mm	8,9 kg	482,– €
100 mm Horn left/right	6,8 kg	526,– €
550 mm sectionalized	44,2 kg	3.094,– €

SCAN TO SHOP







Other radii - prices on request

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

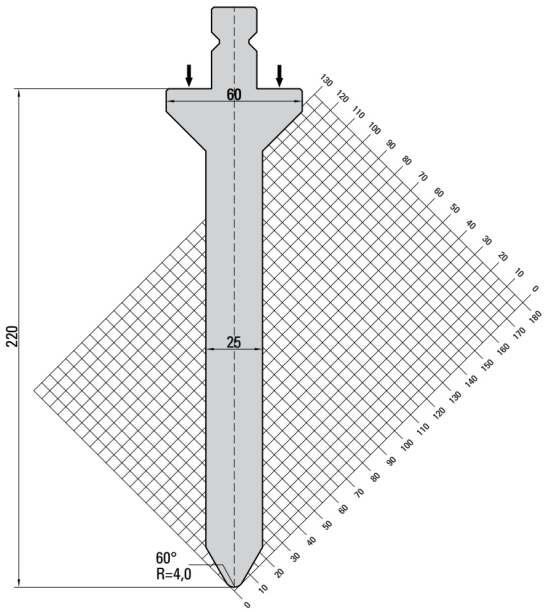
Punches/top tools H = 220 mm

15.730 — 24h — 2500 kN/m

Safety pins		
500 mm	26,0 kg	652,– €
300 mm	15,6 kg	486,– €
Simple Clamp		
200 mm	10,4 kg	422,– €
100 mm	5,2 kg	230,– €
100 mm Horn left/right	4,0 kg	274,– €
550 mm sectionalized	25,7 kg	1.452,– €
2050 mm Tool set	103,7 kg	3.590,– €
3050 mm Tool set	155,7 kg	4.818,– €
4050 mm Tool set	207,7 kg	6.022,– €

SCAN TO SHOP





Other radii - prices on request

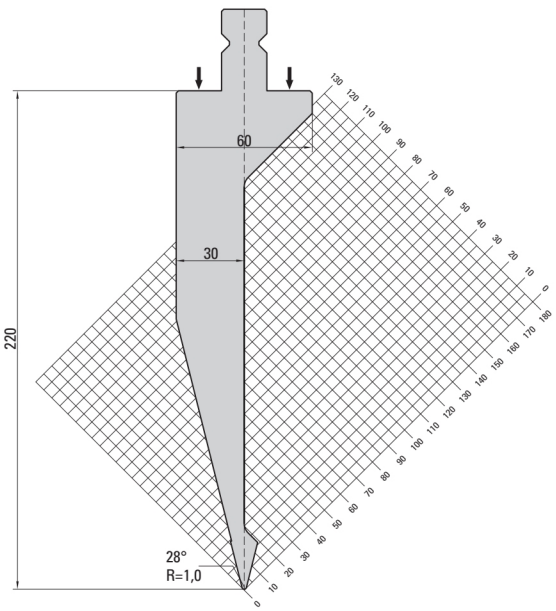
R (mm)	2,0	2,5	3,0	5,0	6,0
H (mm)	219,8	219,8	219,8	218,6	217,6

15.720 — 24h — 800 kN/m

Safety pins		
500 mm	25,0 kg	672,– €
300 mm	15,0 kg	494,– €
Simple Clamp		
200 mm	10,0 kg	430,– €
100 mm	5,0 kg	234,– €
100 mm Horn left/right	3,8 kg	278,– €
550 mm sectionalized	24,4 kg	1.556,– €
2050 mm Tool set	99,4 kg	3.748,– €
3050 mm Tool set	149,4 kg	5.012,– €
4050 mm Tool set	199,4 kg	6.252,– €

SCAN TO SHOP





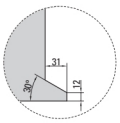
Other radii - prices on request

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

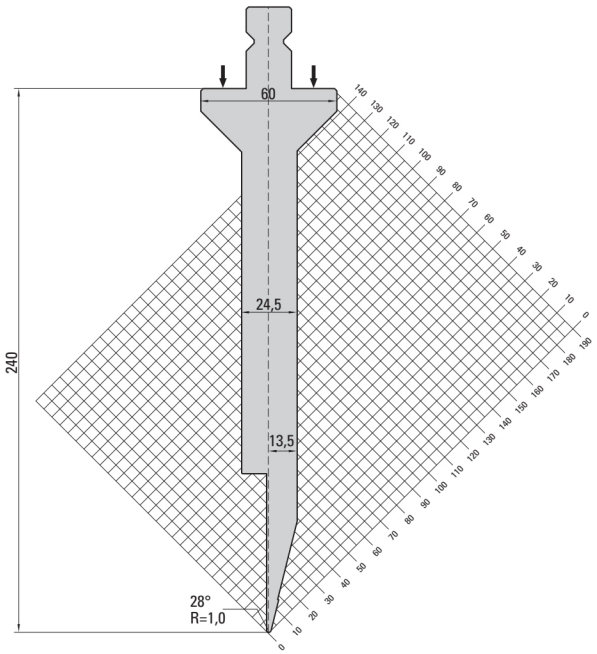
Punch/top tool H = 240 mm

15.750		24h 400 kN/m
Safety pins		
500 mm	24,0 kg	792,– €
300 mm	14,4 kg	588,– €
Simple Clamp		
200 mm	9,6 kg	490,– €
100 mm	4,8 kg	262,– €
100 mm Horn left/right	3,7 kg	306,– €
550 mm sectionalized	23,6 kg	1.706,– €
2050 mm Tool set	95,6 kg	4.280,– €
3050 mm Tool set	143,6 kg	5.774,– €
4050 mm Tool set	191,6 kg	7.234,– €

SCAN TO SHOP







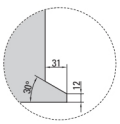
Other radius - price on request

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

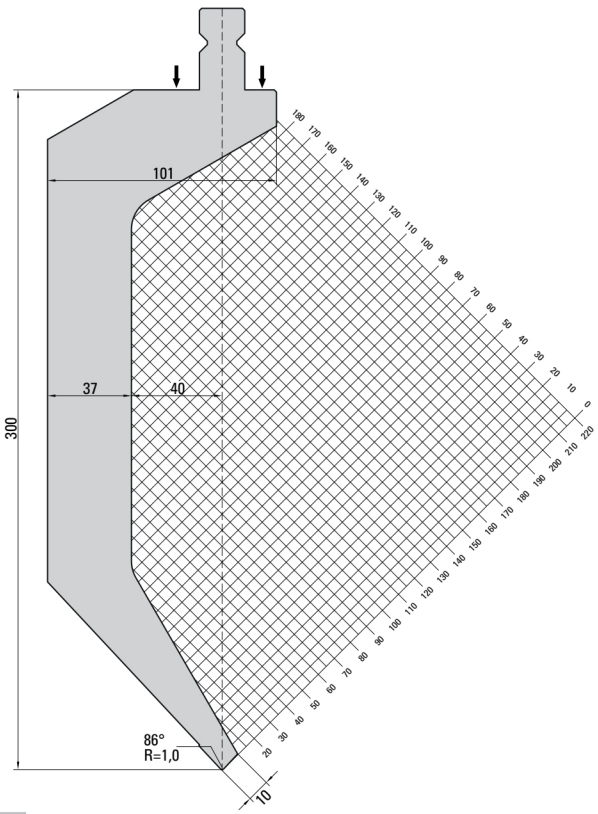
Punch/top tool H = 300 mm

15.800		24h 800 kN/m
Safety pins		
200 mm	19,6 kg	724,– €
Simple Clamp		
100 mm	9,9 kg	452,– €
100 mm Horn left/right	7,3 kg	496,– €
550 mm sectionalized	48,4 kg	3.076,– €

SCAN TO SHOP







Other radii - prices on request

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

Punch/top tool distance piece H = 220 mm

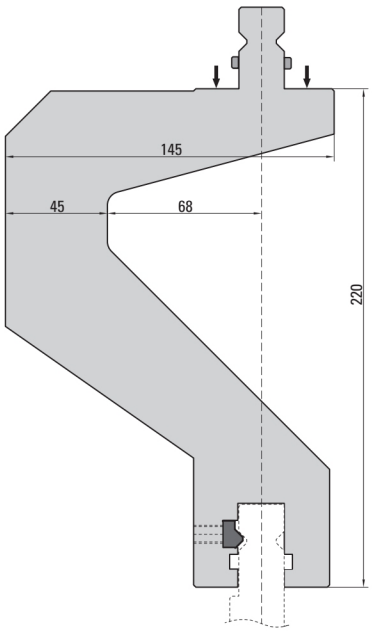
50.503 24h
900 kN/m

Safety pins

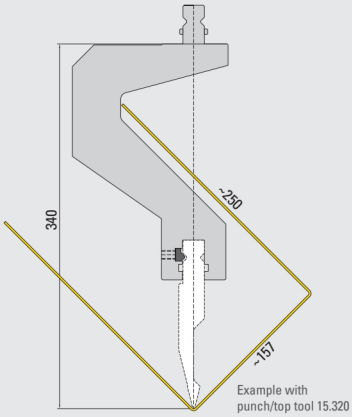
200 mm	24,3 kg	784,– €

SCAN TO SHOP





EXAMPLE OF USE



Punch/top tool distance piece H = 300 mm

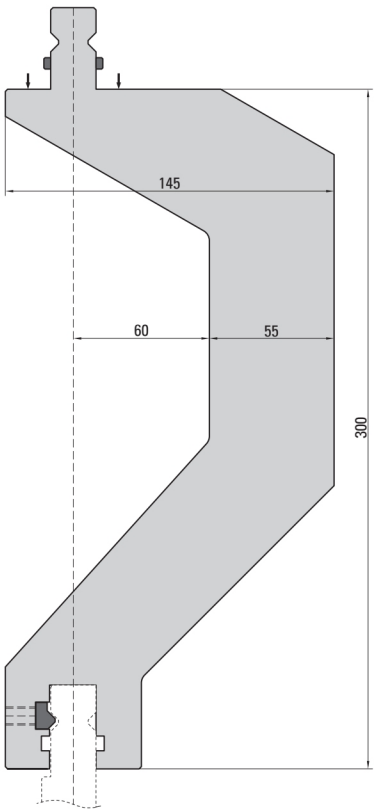
50.504 24h
2000 kN/m

Safety pins

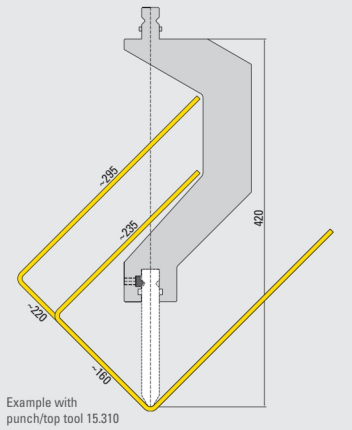
100 mm	16,1 kg	762,– €

SCAN TO SHOP





EXAMPLE OF USE



Punch/top tool distance piece H = 100 mm

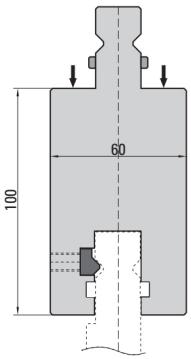
50.410 — 24h — 1000 kN/m

Safety pins		
150 mm	6,9 kg	294,– €
50 mm	2,3 kg	210,– €
250 mm sectionalized	11,5 kg	670,– €

Segmentation: 2x25/30/35/40/45/50

SCAN TO SHOP





Punch/top tool distance piece H = 150 mm

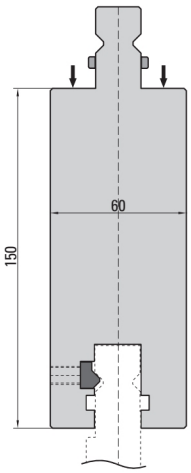
50.440 — 24h — 1000 kN/m

Safety pins		
150 mm	10,5 kg	386,– €
50 mm	3,5 kg	276,– €
250 mm sectionalized	17,5 kg	870,– €

Segmentation: 2x25/30/35/40/45/50

SCAN TO SHOP





Punch/top tool distance piece H = 200 mm

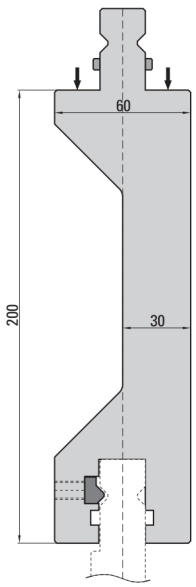
50.460 — 24h — 1000 kN/m

Safety pins		
150 mm	9,9 kg	518,– €
50 mm	3,3 kg	358,– €
250 mm sectionalized	16,5 kg	1.146,– €

Segmentation: 2x25/30/35/40/45/50

SCAN TO SHOP





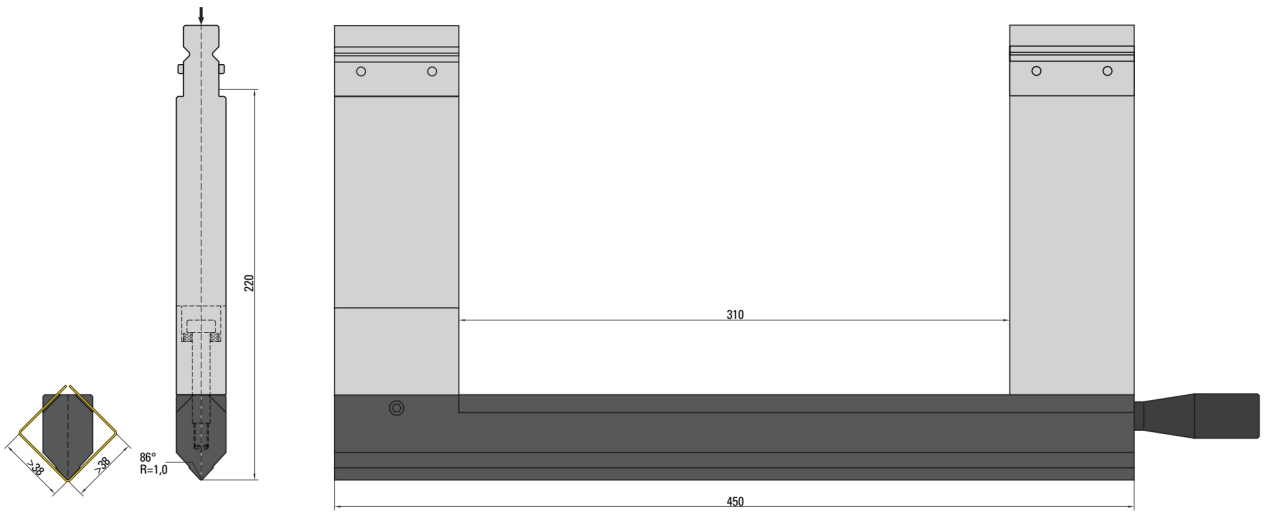
86° Window punch/top tool for closed boxes „Rotax®“

40.690	24h
	150 kN/m
450 mm	10,0 kg	1.154,– €

SCAN TO SHOP

Product advantages

- Bending of **closed profiles**
- Bending of **high U-profiles**
- **Easy removal** by opening the pivot arm
- **Individual production** possible

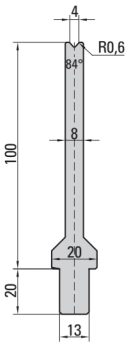




84° Dies H = 100 mm

25.200 — 24h — 250 kN/m

500 mm	4,6 kg	272,– €
300 mm	2,8 kg	194,– €
200 mm	1,9 kg	136,– €
100 mm	0,9 kg	80,– €
550 mm sectionalized	5,1 kg	508,– €
2050 mm Tool set	18,9 kg	1.378,– €
3050 mm Tool set	28,1 kg	1.892,– €
4050 mm Tool set	37,3 kg	2.394,– €

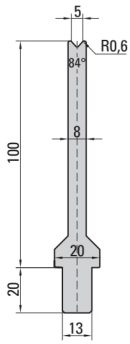


SCAN TO SHOP



25.300 — 24h — 250 kN/m

500 mm	4,6 kg	272,– €
300 mm	2,8 kg	194,– €
200 mm	1,9 kg	136,– €
100 mm	0,9 kg	80,– €
550 mm sectionalized	5,1 kg	508,– €
2050 mm Tool set	18,9 kg	1.378,– €
3050 mm Tool set	28,1 kg	1.892,– €
4050 mm Tool set	37,3 kg	2.394,– €

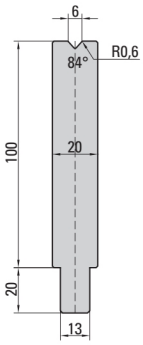


SCAN TO SHOP



25.201 — 24h — 1000 kN/m

500 mm	8,8 kg	180,– €
300 mm	5,3 kg	136,– €
200 mm	3,5 kg	102,– €
100 mm	1,8 kg	70,– €
550 mm sectionalized	9,7 kg	416,– €
2050 mm Tool set	36,2 kg	1.030,– €
3050 mm Tool set	53,8 kg	1.370,– €
4050 mm Tool set	71,4 kg	1.702,– €

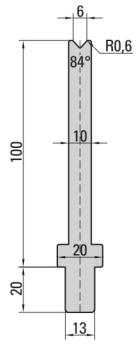


SCAN TO SHOP



25.301 — 24h — 250 kN/m

500 mm	5,3 kg	272,– €
300 mm	3,2 kg	194,– €
200 mm	2,2 kg	136,– €
100 mm	1,1 kg	80,– €
550 mm sectionalized	5,8 kg	508,– €
2050 mm Tool set	21,8 kg	1.378,– €
3050 mm Tool set	32,4 kg	1.892,– €
4050 mm Tool set	43,0 kg	2.394,– €

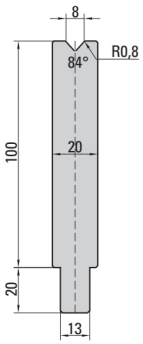


SCAN TO SHOP



25.202 — 24h — 1000 kN/m

500 mm	8,8 kg	180,– €
300 mm	5,3 kg	136,– €
200 mm	3,5 kg	102,– €
100 mm	1,8 kg	70,– €
550 mm sectionalized	9,6 kg	416,– €
2050 mm Tool set	36,1 kg	1.030,– €
3050 mm Tool set	53,7 kg	1.370,– €
4050 mm Tool set	71,3 kg	1.702,– €

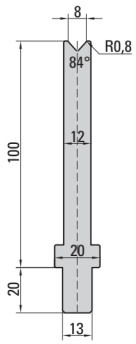


SCAN TO SHOP



25.302 — 24h — 350 kN/m

500 mm	5,9 kg	272,– €
300 mm	3,6 kg	194,– €
200 mm	2,4 kg	136,– €
100 mm	1,2 kg	80,– €
550 mm sectionalized	6,5 kg	508,– €
2050 mm Tool set	24,3 kg	1.378,– €
3050 mm Tool set	36,1 kg	1.892,– €
4050 mm Tool set	47,9 kg	2.394,– €



SCAN TO SHOP



84° Dies H = 100 mm

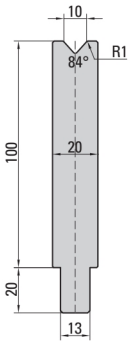
25.203

24h
1000 kN/m

500 mm	8,7 kg	180,– €
300 mm	5,2 kg	136,– €
200 mm	3,5 kg	102,– €
100 mm	1,7 kg	70,– €
550 mm sectionalized	9,6 kg	416,– €
2050 mm Tool set	35,6 kg	1.030,– €
3050 mm Tool set	53,0 kg	1.370,– €
4050 mm Tool set	70,4 kg	1.702,– €

SCAN TO SHOP





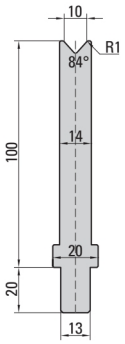
25.303

24h
400 kN/m

500 mm	6,6 kg	272,– €
300 mm	4,0 kg	194,– €
200 mm	2,6 kg	136,– €
100 mm	1,3 kg	80,– €
550 mm sectionalized	7,3 kg	508,– €
2050 mm Tool set	27,1 kg	1.378,– €
3050 mm Tool set	40,3 kg	1.892,– €
4050 mm Tool set	53,5 kg	2.394,– €

SCAN TO SHOP





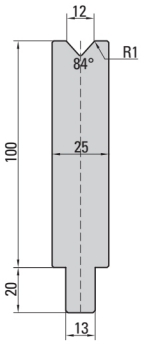
25.204

24h
1000 kN/m

500 mm	10,6 kg	194,– €
300 mm	6,4 kg	144,– €
200 mm	4,3 kg	108,– €
100 mm	2,1 kg	74,– €
550 mm sectionalized	11,7 kg	438,– €
2050 mm Tool set	43,5 kg	1.096,– €
3050 mm Tool set	64,7 kg	1.460,– €
4050 mm Tool set	85,9 kg	1.818,– €

SCAN TO SHOP





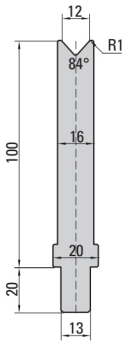
25.304

24h
400 kN/m

500 mm	7,3 kg	272,– €
300 mm	4,4 kg	194,– €
200 mm	2,9 kg	136,– €
100 mm	1,5 kg	80,– €
550 mm sectionalized	8,0 kg	508,– €
2050 mm Tool set	30,0 kg	1.378,– €
3050 mm Tool set	44,6 kg	1.892,– €
4050 mm Tool set	59,2 kg	2.394,– €

SCAN TO SHOP





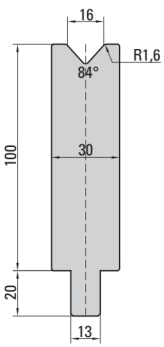
25.205

24h
1000 kN/m

500 mm	12,5 kg	210,– €
300 mm	7,5 kg	154,– €
200 mm	5,0 kg	118,– €
100 mm	2,5 kg	80,– €
550 mm sectionalized	13,7 kg	458,– €
2050 mm Tool set	51,2 kg	1.168,– €
3050 mm Tool set	76,2 kg	1.564,– €
4050 mm Tool set	101,2 kg	1.950,– €

SCAN TO SHOP



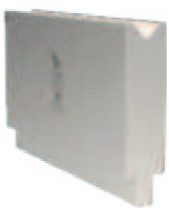


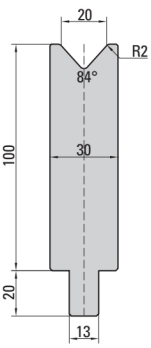
25.206

24h
1000 kN/m

500 mm	12,3 kg	228,– €
300 mm	7,4 kg	170,– €
200 mm	4,9 kg	128,– €
100 mm	2,5 kg	84,– €
550 mm sectionalized	13,5 kg	476,– €
2050 mm Tool set	50,5 kg	1.244,– €
3050 mm Tool set	75,1 kg	1.674,– €
4050 mm Tool set	99,7 kg	2.094,– €

SCAN TO SHOP

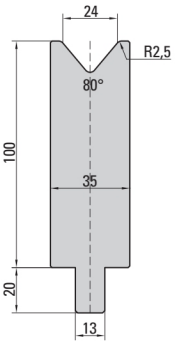




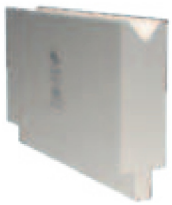
80° Dies H = 100 mm

25.207 — 24h — 1000 kN/m

500 mm	14,0 kg	244,– €
300 mm	8,4 kg	178,– €
200 mm	5,6 kg	132,– €
100 mm	2,8 kg	86,– €
550 mm sectionalized	15,4 kg	498,– €
2050 mm Tool set	57,4 kg	1.310,– €
3050 mm Tool set	85,4 kg	1.770,– €
4050 mm Tool set	113,4 kg	2.220,– €

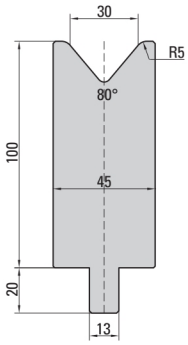


SCAN TO SHOP



25.208 — 24h — 1000 kN/m

500 mm	17,4 kg	294,– €
300 mm	10,4 kg	214,– €
200 mm	7,0 kg	156,– €
100 mm	3,5 kg	100,– €
550 mm sectionalized	19,1 kg	560,– €
2050 mm Tool set	71,3 kg	1.530,– €
3050 mm Tool set	106,1 kg	2.086,– €
4050 mm Tool set	140,9 kg	2.628,– €

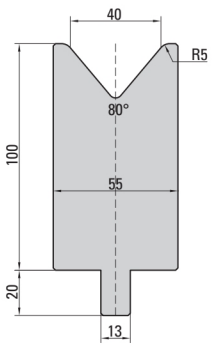


SCAN TO SHOP



25.209 — 24h — 1200 kN/m

500 mm	20,4 kg	316,– €
300 mm	12,2 kg	234,– €
200 mm	8,2 kg	168,– €
100 mm	4,1 kg	108,– €
550 mm sectionalized	22,5 kg	588,– €
2050 mm Tool set	83,7 kg	1.636,– €
3050 mm Tool set	124,5 kg	2.232,– €
4050 mm Tool set	165,3 kg	2.816,– €

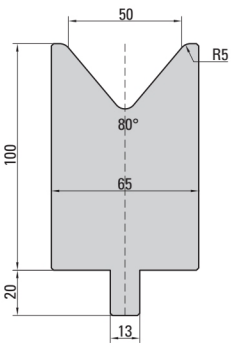


SCAN TO SHOP



25.210 — 24h — 1500 kN/m

500 mm	23,2 kg	396,– €
300 mm	13,9 kg	280,– €
200 mm	9,3 kg	204,– €
100 mm	4,6 kg	130,– €
550 mm sectionalized	25,6 kg	708,– €
2050 mm Tool set	95,1 kg	2.000,– €
3050 mm Tool set	141,5 kg	2.748,– €
4050 mm Tool set	187,9 kg	3.480,– €

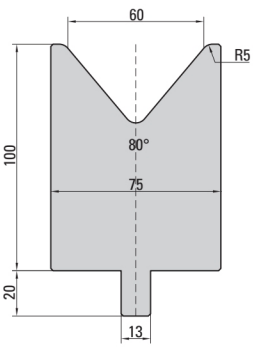


SCAN TO SHOP

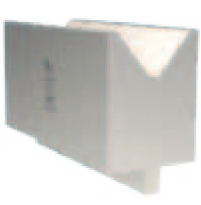


25.111 — 24h — 1500 kN/m

500 mm	25,8 kg	460,– €
300 mm	15,5 kg	328,– €
200 mm	10,3 kg	236,– €
100 mm	5,2 kg	144,– €
550 mm sectionalized	28,4 kg	752,– €
2050 mm Tool set	105,9 kg	2.242,– €
3050 mm Tool set	157,5 kg	3.112,– €
4050 mm Tool set	209,1 kg	3.962,– €

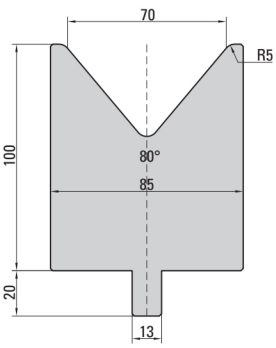


SCAN TO SHOP



25.112 — 24h — 1500 kN/m

500 mm	28,1 kg	506,– €
300 mm	16,9 kg	354,– €
200 mm	11,3 kg	256,– €
100 mm	5,6 kg	156,– €
550 mm sectionalized	31,0 kg	846,– €
2050 mm Tool set	115,3 kg	2.474,– €
3050 mm Tool set	171,5 kg	3.430,– €
4050 mm Tool set	227,7 kg	4.366,– €

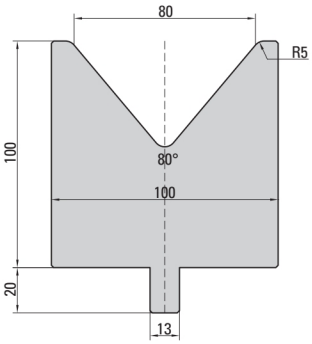


SCAN TO SHOP

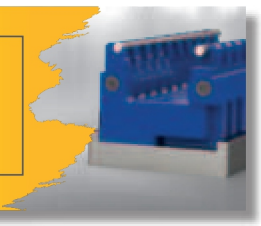


80° Die H = 100 mm

25.113		24h 1500 kN/m
500 mm	32,2 kg	548,– €
300 mm	19,3 kg	380,– €
200 mm	12,9 kg	274,– €
100 mm	6,4 kg	164,– €
550 mm sectionalized	35,4 kg	878,– €
2050 mm Tool set	131,9 kg	2.628,– €
3050 mm Tool set	196,3 kg	3.664,– €
4050 mm Tool set	260,7 kg	4.680,– €



UKB-ADJUSTABLE DIES
CHAPTER 11

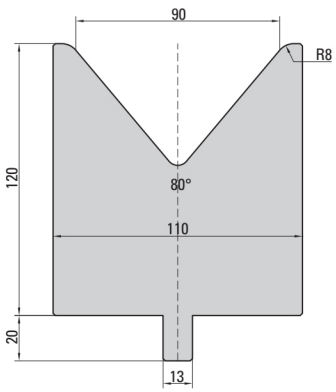


SCAN TO SHOP



80° Dies H = 120 mm

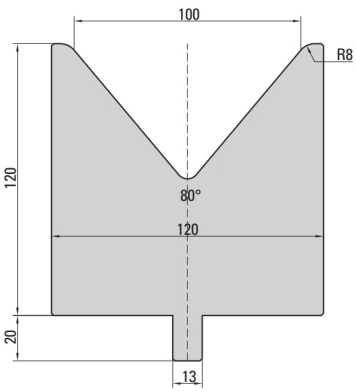
25.114		24h 1500 kN/m
500 mm	42,3 kg	654,– €
300 mm	25,4 kg	450,– €
200 mm	16,9 kg	324,– €
100 mm	8,5 kg	224,– €
550 mm sectionalized	46,5 kg	1.078,– €
2050 mm Tool set	173,5 kg	3.218,– €
3050 mm Tool set	258,1 kg	4.454,– €
4050 mm Tool set	342,7 kg	5.664,– €



SCAN TO SHOP



25.115		24h 1500 kN/m
500 mm	44,7 kg	702,– €
300 mm	26,8 kg	472,– €
200 mm	17,9 kg	348,– €
100 mm	8,9 kg	240,– €
550 mm sectionalized	49,1 kg	1.292,– €
2050 mm Tool set	183,1 kg	3.576,– €
3050 mm Tool set	272,5 kg	4.900,– €
4050 mm Tool set	361,9 kg	6.198,– €

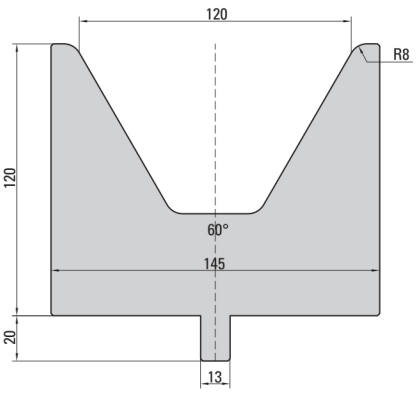


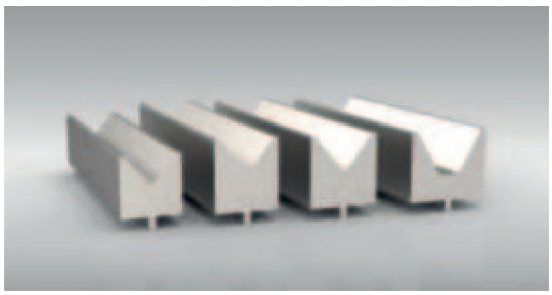
SCAN TO SHOP



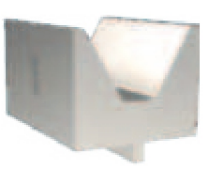
60° Die H = 120 mm

25.116		24h 1600 kN/m
500 mm	45,3 kg	910,– €
300 mm	27,2 kg	632,– €
200 mm	18,1 kg	460,– €
100 mm	9,1 kg	298,– €
550 mm sectionalized	49,9 kg	1.580,– €
2050 mm Tool set	185,9 kg	4.536,– €
3050 mm Tool set	276,5 kg	6.254,– €
4050 mm Tool set	367,1 kg	7.938,– €



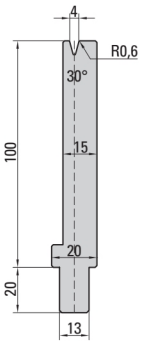


SCAN TO SHOP



30° Dies H = 100 mm

25.400		24h 200 kN/m
500 mm	7,0 kg	310,– €
300 mm	4,2 kg	230,– €
200 mm	2,8 kg	160,– €
100 mm	1,4 kg	90,– €
550 mm sectionalized	7,7 kg	538,– €
2050 mm Tool set	28,7 kg	1.536,– €
3050 mm Tool set	42,7 kg	2.122,– €
4050 mm Tool set	56,7 kg	2.696,– €

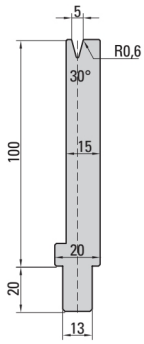


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.500		24h 150 kN/m
500 mm	7,0 kg	310,– €
300 mm	4,2 kg	230,– €
200 mm	2,8 kg	160,– €
100 mm	1,4 kg	90,– €
550 mm sectionalized	7,7 kg	538,– €
2050 mm Tool set	28,7 kg	1.536,– €
3050 mm Tool set	42,7 kg	2.122,– €
4050 mm Tool set	56,7 kg	2.696,– €

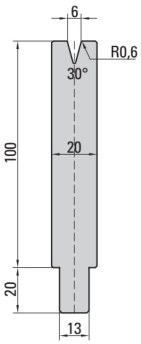


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.401		24h 400 kN/m
500 mm	8,7 kg	248,– €
300 mm	5,2 kg	184,– €
200 mm	3,5 kg	134,– €
100 mm	1,8 kg	86,– €
550 mm sectionalized	9,6 kg	490,– €
2050 mm Tool set	35,8 kg	1.316,– €
3050 mm Tool set	53,2 kg	1.782,– €
4050 mm Tool set	70,6 kg	2.240,– €

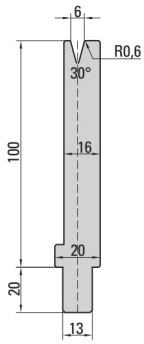


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.501		24h 170 kN/m
500 mm	7,3 kg	310,– €
300 mm	4,4 kg	230,– €
200 mm	2,9 kg	160,– €
100 mm	1,5 kg	90,– €
550 mm sectionalized	8,0 kg	538,– €
2050 mm Tool set	30,0 kg	1.536,– €
3050 mm Tool set	44,6 kg	2.122,– €
4050 mm Tool set	59,2 kg	2.696,– €



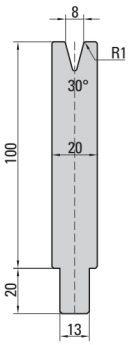
Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



30° Dies H = 100 mm

25.402		24h 400 kN/m
500 mm	8,6 kg	248,– €
300 mm	5,2 kg	184,– €
200 mm	3,4 kg	134,– €
100 mm	1,7 kg	86,– €
550 mm sectionalized	9,4 kg	490,– €
2050 mm Tool set	35,2 kg	1.316,– €
3050 mm Tool set	52,4 kg	1.782,– €
4050 mm Tool set	69,6 kg	2.240,– €

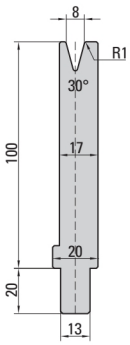


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.502		24h 200 kN/m
500 mm	7,5 kg	310,– €
300 mm	4,5 kg	230,– €
200 mm	3,0 kg	160,– €
100 mm	1,5 kg	90,– €
550 mm sectionalized	8,3 kg	538,– €
2050 mm Tool set	30,8 kg	1.536,– €
3050 mm Tool set	45,8 kg	2.122,– €
4050 mm Tool set	60,8 kg	2.696,– €

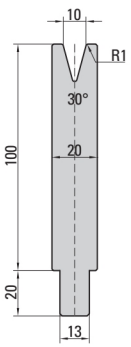


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.403		24h 400 kN/m
500 mm	8,5 kg	248,– €
300 mm	5,1 kg	184,– €
200 mm	3,4 kg	134,– €
100 mm	1,7 kg	86,– €
550 mm sectionalized	9,3 kg	490,– €
2050 mm Tool set	34,8 kg	1.316,– €
3050 mm Tool set	51,8 kg	1.782,– €
4050 mm Tool set	68,8 kg	2.240,– €

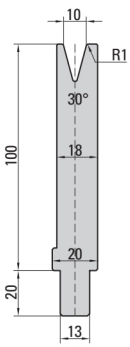


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.503		24h 200 kN/m
500 mm	7,8 kg	310,– €
300 mm	4,7 kg	230,– €
200 mm	3,1 kg	160,– €
100 mm	1,6 kg	90,– €
550 mm sectionalized	8,5 kg	538,– €
2050 mm Tool set	32,0 kg	1.536,– €
3050 mm Tool set	47,6 kg	2.122,– €
4050 mm Tool set	63,2 kg	2.696,– €



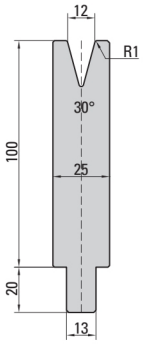
Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



30° Dies H = 100 mm

25.404		24h 400 kN/m
500 mm	10,2 kg	258,– €
300 mm	6,1 kg	188,– €
200 mm	4,1 kg	140,– €
100 mm	2,0 kg	90,– €
550 mm sectionalized	11,3 kg	508,– €
2050 mm Tool set	41,8 kg	1.364,– €
3050 mm Tool set	62,2 kg	1.850,– €
4050 mm Tool set	82,6 kg	2.328,– €

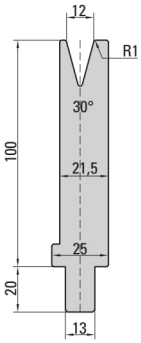


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.504		24h 250 kN/m
500 mm	9,0 kg	320,– €
300 mm	5,4 kg	240,– €
200 mm	3,6 kg	174,– €
100 mm	1,8 kg	98,– €
550 mm sectionalized	9,9 kg	562,– €
2050 mm Tool set	36,9 kg	1.606,– €
3050 mm Tool set	54,9 kg	2.210,– €
4050 mm Tool set	72,9 kg	2.802,– €

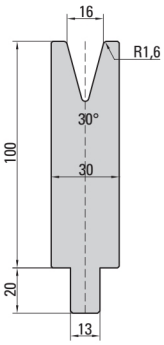


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.405		24h 500 kN/m
500 mm	11,8 kg	276,– €
300 mm	7,1 kg	200,– €
200 mm	4,7 kg	148,– €
100 mm	2,4 kg	96,– €
550 mm sectionalized	12,9 kg	534,– €
2050 mm Tool set	48,4 kg	1.448,– €
3050 mm Tool set	72,0 kg	1.970,– €
4050 mm Tool set	95,6 kg	2.478,– €

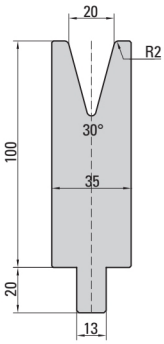


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.406		24h 600 kN/m
500 mm	13,2 kg	296,– €
300 mm	7,9 kg	216,– €
200 mm	5,3 kg	156,– €
100 mm	2,6 kg	100,– €
550 mm sectionalized	14,5 kg	556,– €
2050 mm Tool set	54,0 kg	1.532,– €
3050 mm Tool set	80,4 kg	2.092,– €
4050 mm Tool set	106,8 kg	2.638,– €



SCAN TO SHOP



30° Dies H = 100 mm

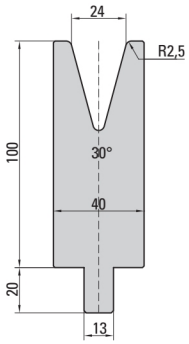
25.407

24h
650 kN/m

500 mm	14,5 kg	320,– €
300 mm	8,7 kg	230,– €
200 mm	5,8 kg	170,– €
100 mm	2,9 kg	106,– €
550 mm sectionalized	15,9 kg	588,– €
2050 mm Tool set	59,4 kg	1.636,– €
3050 mm Tool set	88,4 kg	2.240,– €
4050 mm Tool set	117,4 kg	2.832,– €







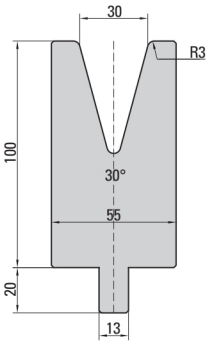
25.408

24h
900 kN/m

500 mm	19,1 kg	416,– €
300 mm	11,5 kg	306,– €
200 mm	7,6 kg	220,– €
100 mm	3,8 kg	132,– €
550 mm sectionalized	21,0 kg	692,– €
2050 mm Tool set	78,3 kg	2.052,– €
3050 mm Tool set	116,5 kg	2.838,– €
4050 mm Tool set	154,7 kg	3.608,– €







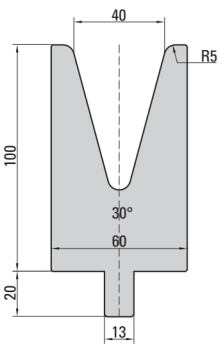
25.409

24h
900 kN/m

500 mm	18,3 kg	522,– €
300 mm	11,0 kg	366,– €
200 mm	7,3 kg	270,– €
100 mm	3,7 kg	174,– €
550 mm sectionalized	20,1 kg	922,– €
2050 mm Tool set	75,1 kg	2.626,– €
3050 mm Tool set	111,7 kg	3.612,– €
4050 mm Tool set	148,3 kg	4.578,– €







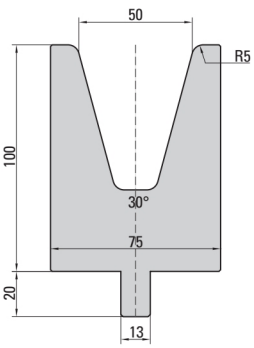
25.410

24h
1000 kN/m

500 mm	21,6 kg	680,– €
300 mm	13,0 kg	440,– €
200 mm	8,6 kg	322,– €
100 mm	4,3 kg	194,– €
550 mm sectionalized	23,8 kg	1.000,– €
2050 mm Tool set	88,6 kg	3.124,– €
3050 mm Tool set	131,8 kg	4.412,– €
4050 mm Tool set	175,0 kg	5.672,– €







30° Dies H = 100 mm R = 3,0 mm

Product advantages

- Dies R = 3,0 **reduce marks** on bent sheets
- **Applicable for foil-coated sheets**

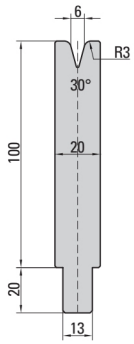


25.421

24h
400 kN/m

500 mm	8,6 kg	248,– €
300 mm	5,2 kg	184,– €
200 mm	3,5 kg	134,– €
100 mm	1,7 kg	86,– €
550 mm sectionalized	9,5 kg	490,– €
2050 mm Tool set	35,3 kg	1.316,– €
3050 mm Tool set	52,5 kg	1.782,– €
4050 mm Tool set	69,7 kg	2.240,– €

Screwable flattening die H = 100 mm and additional drill holes in dies see page 99



SCAN TO SHOP

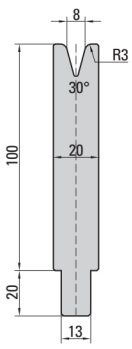


25.422

24h
400 kN/m

500 mm	8,5 kg	248,– €
300 mm	5,1 kg	184,– €
200 mm	3,4 kg	134,– €
100 mm	1,7 kg	86,– €
550 mm sectionalized	9,4 kg	490,– €
2050 mm Tool set	34,9 kg	1.316,– €
3050 mm Tool set	51,9 kg	1.782,– €
4050 mm Tool set	68,9 kg	2.240,– €

Screwable flattening die H = 100 mm and additional drill holes in dies see page 99



SCAN TO SHOP

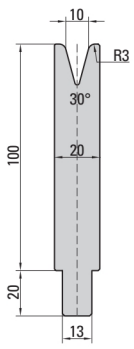


25.423

24h
400 kN/m

500 mm	8,4 kg	248,– €
300 mm	5,0 kg	184,– €
200 mm	3,4 kg	134,– €
100 mm	1,7 kg	86,– €
550 mm sectionalized	9,2 kg	490,– €
2050 mm Tool set	34,4 kg	1.316,– €
3050 mm Tool set	51,2 kg	1.782,– €
4050 mm Tool set	68,0 kg	2.240,– €

Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

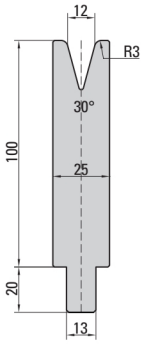


SCAN TO SHOP



30° Dies H = 100 mm R = 3,0 mm

25.424		24h 400 kN/m
500 mm	10,2 kg	258,– €
300 mm	6,1 kg	188,– €
200 mm	4,1 kg	140,– €
100 mm	2,0 kg	90,– €
550 mm sectionalized	11,2 kg	508,– €
2050 mm Tool set	41,7 kg	1.364,– €
3050 mm Tool set	62,1 kg	1.850,– €
4050 mm Tool set	82,5 kg	2.328,– €

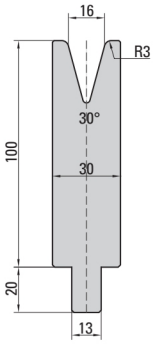


Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



25.425		24h 500 kN/m
500 mm	11,7 kg	276,– €
300 mm	7,0 kg	200,– €
200 mm	4,7 kg	148,– €
100 mm	2,3 kg	96,– €
550 mm sectionalized	12,9 kg	534,– €
2050 mm Tool set	47,9 kg	1.448,– €
3050 mm Tool set	71,3 kg	1.970,– €
4050 mm Tool set	94,7 kg	2.478,– €



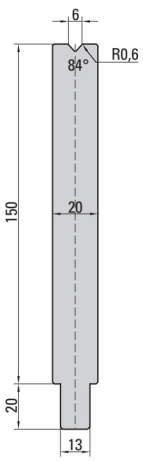
Screwable flattening die H = 100 mm and additional drill holes in dies see page 99

SCAN TO SHOP



84° Dies H = 150 mm

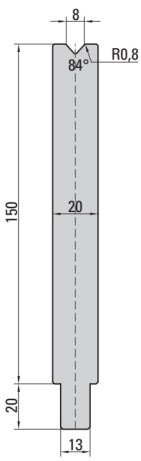
25.621		24h 1000 kN/m
500 mm	12,7 kg	194,– €
300 mm	7,5 kg	144,– €
200 mm	5,1 kg	112,– €
100 mm	2,5 kg	82,– €
550 mm sectionalized	14,0 kg	472,– €
2050 mm Tool set	51,9 kg	1.144,– €
3050 mm Tool set	77,3 kg	1.510,– €
4050 mm Tool set	102,7 kg	1.866,– €



SCAN TO SHOP



25.622		24h 1000 kN/m
500 mm	12,7 kg	194,– €
300 mm	7,6 kg	144,– €
200 mm	5,1 kg	112,– €
100 mm	2,5 kg	82,– €
550 mm sectionalized	14,0 kg	472,– €
2050 mm Tool set	52,0 kg	1.144,– €
3050 mm Tool set	77,4 kg	1.510,– €
4050 mm Tool set	102,8 kg	1.866,– €



SCAN TO SHOP

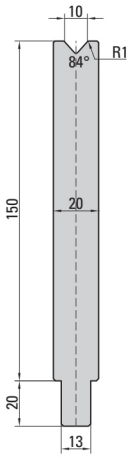


84° Dies H = 150 mm

25.623		24h 1000 kN/m
500 mm	12,6 kg	194,– €
300 mm	7,6 kg	144,– €
200 mm	5,1 kg	112,– €
100 mm	2,5 kg	82,– €
550 mm sectionalized	13,9 kg	472,– €
2050 mm Tool set	51,7 kg	1.144,– €
3050 mm Tool set	76,9 kg	1.510,– €
4050 mm Tool set	102,1 kg	1.866,– €

SCAN TO SHOP

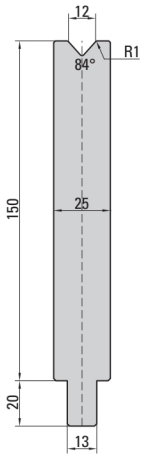




25.624		24h 1000 kN/m
500 mm	15,5 kg	218,– €
300 mm	9,3 kg	160,– €
200 mm	6,2 kg	122,– €
100 mm	3,1 kg	84,– €
550 mm sectionalized	17,1 kg	504,– €
2050 mm Tool set	63,6 kg	1.242,– €
3050 mm Tool set	94,6 kg	1.652,– €
4050 mm Tool set	125,6 kg	2.054,– €

SCAN TO SHOP

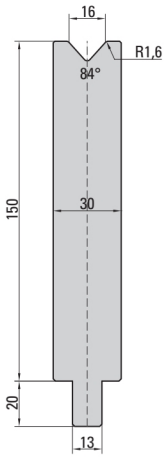




25.625		24h 1000 kN/m
500 mm	18,3 kg	236,– €
300 mm	11,0 kg	170,– €
200 mm	7,3 kg	132,– €
100 mm	3,7 kg	90,– €
550 mm sectionalized	20,2 kg	530,– €
2050 mm Tool set	75,2 kg	1.324,– €
3050 mm Tool set	111,8 kg	1.770,– €
4050 mm Tool set	148,4 kg	2.204,– €

SCAN TO SHOP

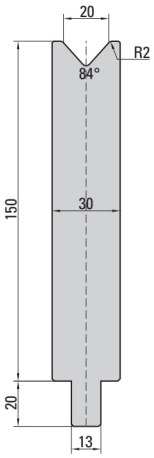




25.626		24h 1000 kN/m
500 mm	18,2 kg	246,– €
300 mm	10,9 kg	180,– €
200 mm	7,3 kg	136,– €
100 mm	3,6 kg	94,– €
550 mm sectionalized	20,0 kg	540,– €
2050 mm Tool set	74,5 kg	1.372,– €
3050 mm Tool set	110,9 kg	1.836,– €
4050 mm Tool set	147,3 kg	2.288,– €

SCAN TO SHOP





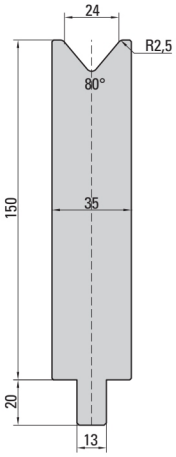
80° Dies H = 150 mm

25.627 — 24h — 1000 kN/m

500 mm	20,8 kg	276,– €
300 mm	12,5 kg	198,– €
200 mm	8,3 kg	148,– €
100 mm	4,2 kg	100,– €
550 mm sectionalized	22,9 kg	582,– €
2050 mm Tool set	85,4 kg	1.502,– €
3050 mm Tool set	127,0 kg	2.022,– €
4050 mm Tool set	168,6 kg	2.530,– €

SCAN TO SHOP



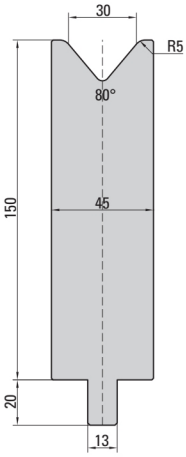


25.628 — 24h — 1000 kN/m

500 mm	26,2 kg	332,– €
300 mm	15,7 kg	238,– €
200 mm	10,5 kg	180,– €
100 mm	5,2 kg	120,– €
550 mm sectionalized	28,8 kg	682,– €
2050 mm Tool set	107,3 kg	1.788,– €
3050 mm Tool set	159,7 kg	2.414,– €
4050 mm Tool set	212,1 kg	3.026,– €

SCAN TO SHOP



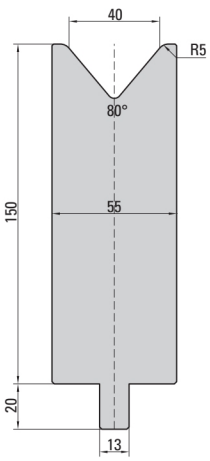


25.629 — 24h — 1000 kN/m

500 mm	31,2 kg	422,– €
300 mm	18,7 kg	300,– €
200 mm	12,5 kg	222,– €
100 mm	6,2 kg	146,– €
550 mm sectionalized	34,3 kg	796,– €
2050 mm Tool set	127,8 kg	2.188,– €
3050 mm Tool set	190,2 kg	2.984,– €
4050 mm Tool set	252,6 kg	3.764,– €

SCAN TO SHOP



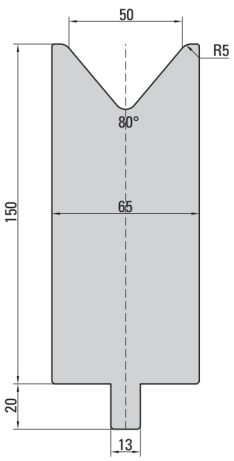


25.630 — 24h — 1500 kN/m

500 mm	36,0 kg	560,– €
300 mm	21,6 kg	400,– €
200 mm	14,4 kg	292,– €
100 mm	7,2 kg	182,– €
550 mm sectionalized	39,6 kg	968,– €
2050 mm Tool set	147,6 kg	2.794,– €
3050 mm Tool set	219,6 kg	3.852,– €
4050 mm Tool set	291,6 kg	4.888,– €

SCAN TO SHOP



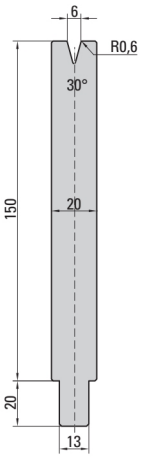


30° Dies H = 150 mm

25.901 — 24h — 400 kN/m

500 mm	12,6 kg	276,– €
300 mm	7,6 kg	198,– €
200 mm	5,0 kg	148,– €
100 mm	2,5 kg	100,– €
550 mm sectionalized	13,9 kg	568,– €
2050 mm Tool set	51,7 kg	1.488,– €
3050 mm Tool set	76,9 kg	2.008,– €
4050 mm Tool set	102,1 kg	2.518,– €

Screwable flattening die H = 150 mm and additional drill holes in dies see page 99



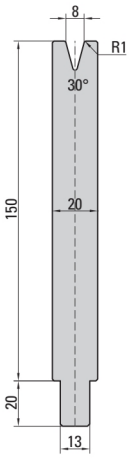
SCAN TO SHOP



25.902 — 24h — 400 kN/m

500 mm	12,5 kg	276,– €
300 mm	7,5 kg	198,– €
200 mm	5,0 kg	148,– €
100 mm	2,5 kg	100,– €
550 mm sectionalized	13,8 kg	568,– €
2050 mm Tool set	51,3 kg	1.488,– €
3050 mm Tool set	76,3 kg	2.008,– €
4050 mm Tool set	101,3 kg	2.518,– €

Screwable flattening die H = 150 mm and additional drill holes in dies see page 99



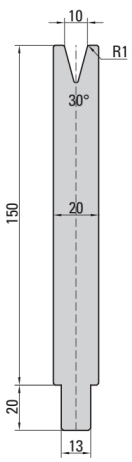
SCAN TO SHOP



25.903 — 24h — 400 kN/m

500 mm	12,4 kg	276,– €
300 mm	7,5 kg	198,– €
200 mm	5,0 kg	148,– €
100 mm	2,5 kg	100,– €
550 mm sectionalized	13,6 kg	568,– €
2050 mm Tool set	50,9 kg	1.488,– €
3050 mm Tool set	75,7 kg	2.008,– €
4050 mm Tool set	100,5 kg	2.518,– €

Screwable flattening die H = 150 mm and additional drill holes in dies see page 99



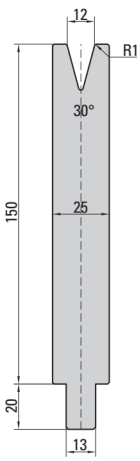
SCAN TO SHOP



25.904 — 24h — 400 kN/m

500 mm	15,2 kg	286,– €
300 mm	9,1 kg	206,– €
200 mm	6,1 kg	154,– €
100 mm	3,0 kg	104,– €
550 mm sectionalized	16,7 kg	592,– €
2050 mm Tool set	62,2 kg	1.546,– €
3050 mm Tool set	92,6 kg	2.086,– €
4050 mm Tool set	123,0 kg	2.614,– €

Screwable flattening die H = 150 mm and additional drill holes in dies see page 99



SCAN TO SHOP



30° Dies H = 150 mm

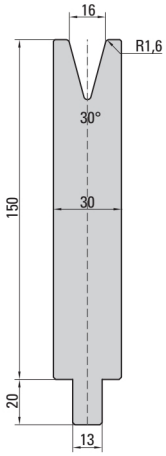
25.905 — 24h — 500 kN/m

500 mm	17,7 kg	308,– €
300 mm	10,6 kg	224,– €
200 mm	7,1 kg	170,– €
100 mm	3,5 kg	110,– €
550 mm sectionalized	19,4 kg	620,– €
2050 mm Tool set	72,4 kg	1.646,– €
3050 mm Tool set	107,8 kg	2.228,– €
4050 mm Tool set	143,2 kg	2.796,– €

Screwable flattening die H = 150 mm and additional drill holes in dies see page 99

SCAN TO SHOP



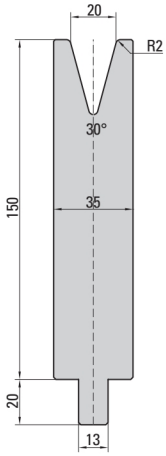


25.906 — 24h — 600 kN/m

500 mm	20,0 kg	328,– €
300 mm	12,0 kg	238,– €
200 mm	8,0 kg	178,– €
100 mm	4,0 kg	116,– €
550 mm sectionalized	22,0 kg	648,– €
2050 mm Tool set	82,0 kg	1.738,– €
3050 mm Tool set	122,0 kg	2.358,– €
4050 mm Tool set	162,0 kg	2.962,– €

SCAN TO SHOP



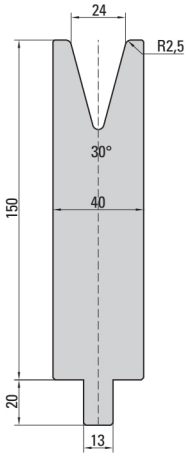


25.907 — 24h — 650 kN/m

500 mm	22,3 kg	346,– €
300 mm	13,4 kg	248,– €
200 mm	8,9 kg	186,– €
100 mm	4,5 kg	120,– €
550 mm sectionalized	24,5 kg	678,– €
2050 mm Tool set	91,5 kg	1.820,– €
3050 mm Tool set	136,1 kg	2.474,– €
4050 mm Tool set	180,7 kg	3.112,– €

SCAN TO SHOP



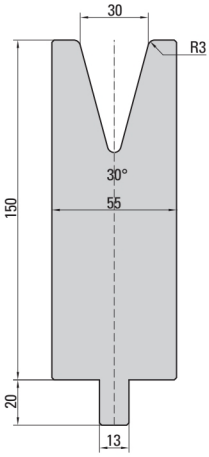


25.908 — 24h — 900 kN/m

500 mm	30,0 kg	514,– €
300 mm	18,0 kg	370,– €
200 mm	12,0 kg	268,– €
100 mm	6,0 kg	170,– €
550 mm sectionalized	33,0 kg	910,– €
2050 mm Tool set	123,0 kg	2.596,– €
3050 mm Tool set	183,0 kg	3.566,– €
4050 mm Tool set	243,0 kg	4.516,– €

SCAN TO SHOP



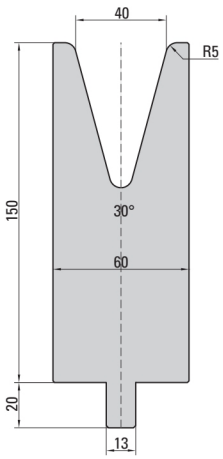


30° Die H = 150 mm

25.909		24h 900 kN/m
500 mm	30,1 kg	624,– €
300 mm	18,0 kg	456,– €
200 mm	12,0 kg	326,– €
100 mm	6,0 kg	196,– €
550 mm sectionalized	33,1 kg	1.024,– €
2050 mm Tool set	123,3 kg	3.058,– €
3050 mm Tool set	183,5 kg	4.236,– €
4050 mm Tool set	243,7 kg	5.392,– €

SCAN TO SHOP



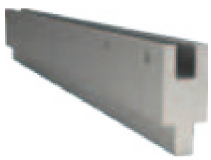


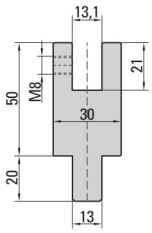


Die riser

60.960		24h 1000 kN/m
500 mm	5,8 kg	348,– €

SCAN TO SHOP

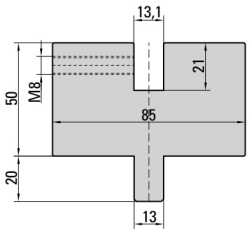




60.965		24h 1000 kN/m
500 mm	16,6 kg	400,– €

SCAN TO SHOP





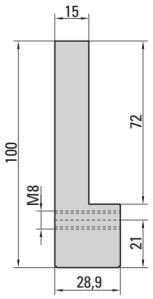


Screwable flattening die H = 100 mm

60.120		24h 1200 kN/m
500 mm	7,4 kg	332,– €
300 mm	4,4 kg	254,– €
200 mm	3,0 kg	190,– €
100 mm	1,5 kg	110,– €
550 mm sectionalized	8,2 kg	552,– €
2050 mm Tool set	30,4 kg	1.656,– €
3050 mm Tool set	45,2 kg	2.284,– €
4050 mm Tool set	60,0 kg	2.898,– €

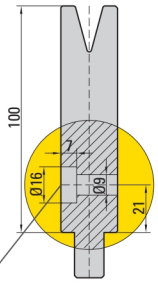
SCAN TO SHOP





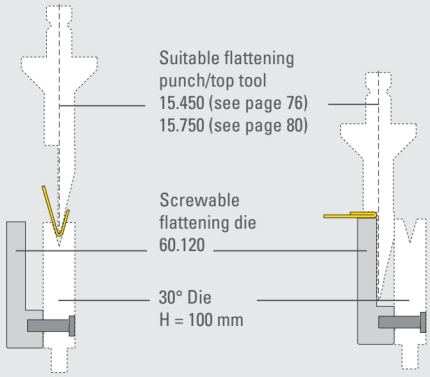
70.800	72h
500 mm	26,– €
300 mm	22,– €
200 mm	18,– €
100 mm	12,– €
550 mm sectionalized	54,– €
2050 mm Tool set	152,– €
3050 mm Tool set	204,– €
4050 mm Tool set	256,– €

SCAN TO SHOP



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

EXAMPLE OF USE



Only usable with i-axis displacement

UKB-INFO

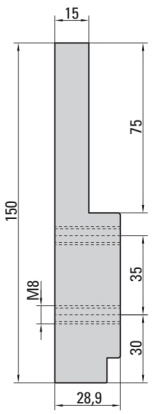
Suitable 30° dies H = 100 mm
see pages 88 – 90 and 92 – 93!

Screwable flattening die H = 150 mm

60.130		24h 1200 kN/m
500 mm	12,7 kg	442,– €
300 mm	7,6 kg	308,– €
200 mm	5,1 kg	232,– €
100 mm	2,6 kg	144,– €
550 mm sectionalized	13,9 kg	718,– €
2050 mm Tool set	52,1 kg	2.154,– €
3050 mm Tool set	77,5 kg	2.990,– €
4050 mm Tool set	102,9 kg	3.808,– €

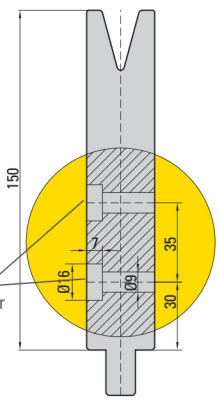
SCAN TO SHOP





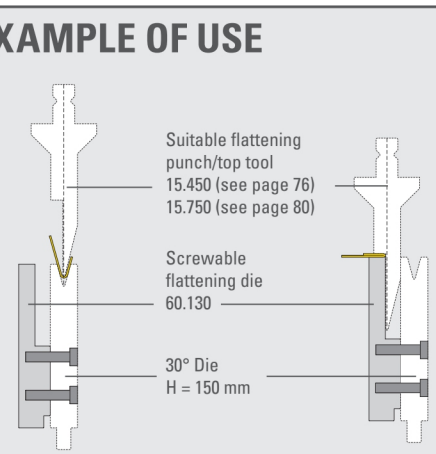
70.810	72h
500 mm	44,– €
300 mm	38,– €
200 mm	28,– €
100 mm	18,– €
550 mm sectionalized	84,– €
2050 mm Tool set	246,– €
3050 mm Tool set	334,– €
4050 mm Tool set	422,– €

SCAN TO SHOP



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

EXAMPLE OF USE



Only usable with i-axis displacement

UKB-INFO

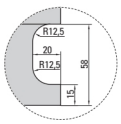
Suitable 30° dies H = 150 mm
see pages 96 – 97!

Flattening punches/top tools and flattening dies

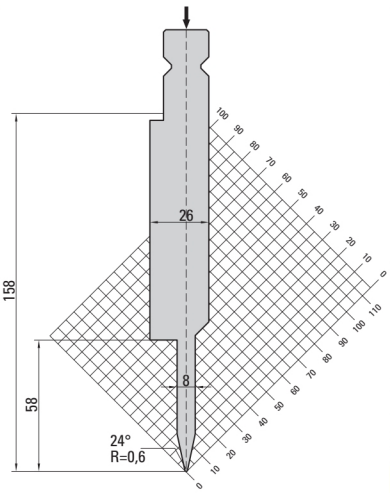
15.902 — 24h — 800 kN/m

Safety pins		
500 mm	14,4 kg	492,– €
Simple Clamp		
300 mm	8,6 kg	438,– €
200 mm	5,6 kg	332,– €
100 mm	2,9 kg	178,– €
550 mm sectionalized	16,0 kg	1.256,– €
2050 mm Tool set	59,0 kg	2.950,– €
3050 mm Tool set	87,8 kg	3.874,– €
4050 mm Tool set	116,6 kg	4.778,– €

SCAN TO SHOP







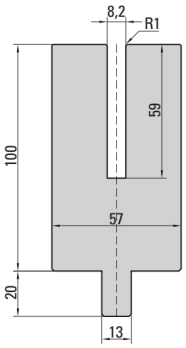
25.992 — 24h — 500 kN/m

500 mm	21,5 kg	494,– €
300 mm	12,9 kg	362,– €
200 mm	8,6 kg	258,– €
100 mm	4,3 kg	154,– €
550 mm sectionalized	23,6 kg	844,– €
2050 mm Tool set	88,1 kg	2.452,– €
3050 mm Tool set	131,1 kg	3.386,– €
4050 mm Tool set	174,1 kg	4.298,– €

Max. 1,2 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP

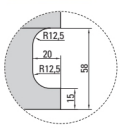




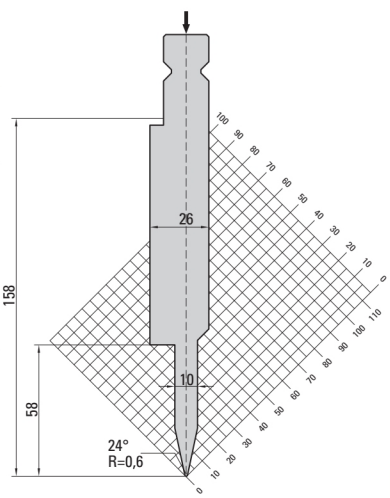
15.904 — 24h — 800 kN/m

Safety pins		
500 mm	14,9 kg	492,– €
Simple Clamp		
300 mm	9,0 kg	438,– €
200 mm	6,0 kg	332,– €
100 mm	3,0 kg	178,– €
550 mm sectionalized	16,2 kg	1.256,– €
2050 mm Tool set	61,0 kg	2.950,– €
3050 mm Tool set	90,8 kg	3.874,– €
4050 mm Tool set	120,6 kg	4.778,– €

SCAN TO SHOP







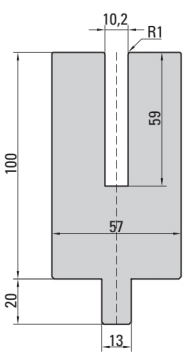
25.994 — 24h — 500 kN/m

500 mm	21,0 kg	494,– €
300 mm	12,6 kg	362,– €
200 mm	8,4 kg	258,– €
100 mm	4,2 kg	154,– €
550 mm sectionalized	23,1 kg	844,– €
2050 mm Tool set	86,1 kg	2.452,– €
3050 mm Tool set	128,1 kg	3.386,– €
4050 mm Tool set	170,1 kg	4.298,– €

Max. 1,8 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP

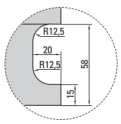




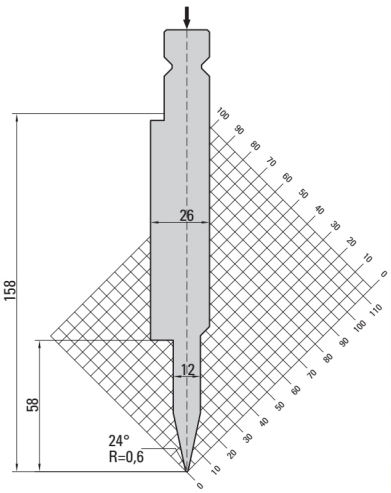
Flattening punch/top tool and flattening die

15.905		24h 800 kN/m
Safety pins		
500 mm	15,0 kg	492,– €
Simple Clamp		
300 mm	9,0 kg	438,– €
200 mm	6,0 kg	332,– €
100 mm	3,0 kg	178,– €
550 mm sectionalized	16,6 kg	1.256,– €
2050 mm Tool set	61,6 kg	2.950,– €
3050 mm Tool set	91,6 kg	3.874,– €
4050 mm Tool set	121,6 kg	4.778,– €

SCAN TO SHOP







25.995		24h 500 kN/m
500 mm	20,5 kg	494,– €
300 mm	12,3 kg	362,– €
200 mm	8,2 kg	258,– €
100 mm	4,1 kg	154,– €
550 mm sectionalized	22,6 kg	844,– €
2050 mm Tool set	84,1 kg	2.452,– €
3050 mm Tool set	125,1 kg	3.386,– €
4050 mm Tool set	166,1 kg	4.298,– €

Max. 2,5 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP



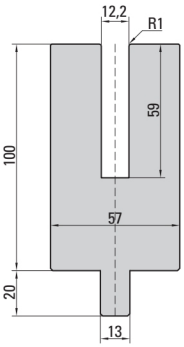


Table of force for flattening

Material: R_m = 400 N/mm², mild steel

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

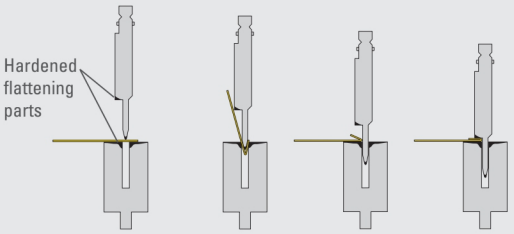
Material: R_m = 700 N/mm², stainless steel

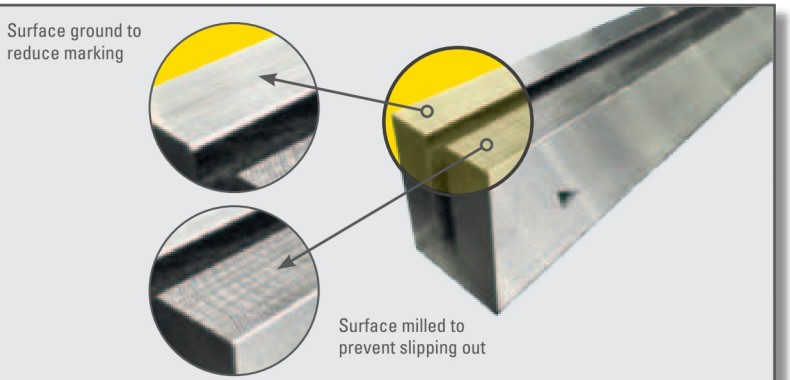
S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	15	3,0	35	1,2
0,8	20	3,0	50	1,6
1,0	25	3,5	60	2,0
1,25	26	3,5	80	2,5
1,5	38	4,6	95	3,0
2,0	50	5,5	130	4,0





EXAMPLE OF USE





PRESS BRAKE TOOLS
UKB-SYSTEM WILA

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Punches/top tools
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Dies
86° Dies H = 55 mm 118
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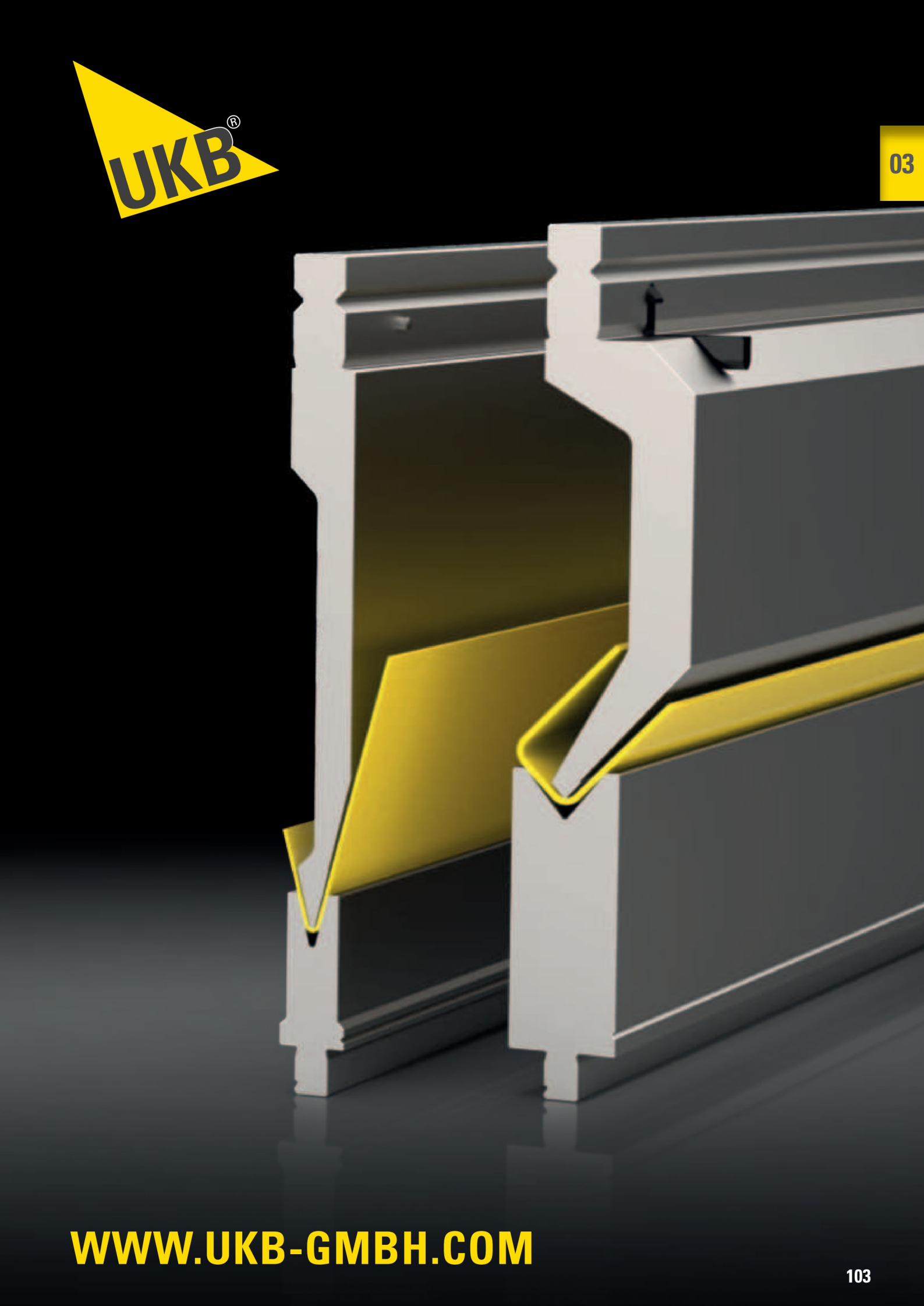
Flattening punch/top tool and flattening die 125





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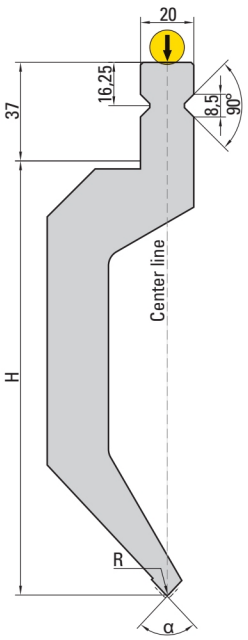
SYSTEM WILA

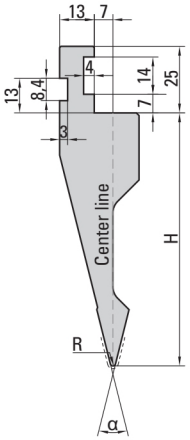
Quality and precision

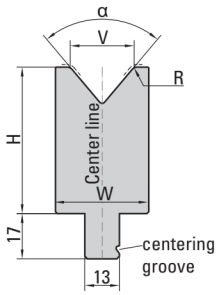
- **Optimum materials**
  - 42 CrMo4, tempered to 1100 - 1200 N/mm²
  - C45, 650 - 800 N/mm
- Bending radius/intake radii
  hardened up to 52 - 55 HRC
- **Precision ground**
- **Guaranteed exchangeability and parallelism**
- **Punch/top tool clampings in two different models**
  - Simple Clamp at segments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

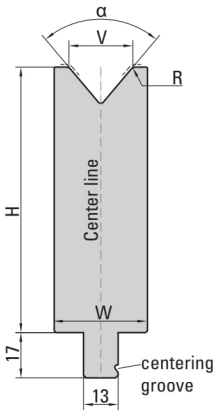
Wila type I



Wila type II







VIDEO

UKB-Press brake tool systems

UKB-ADVANTAGES

VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:	According agreement
Direct courier:	According agreement

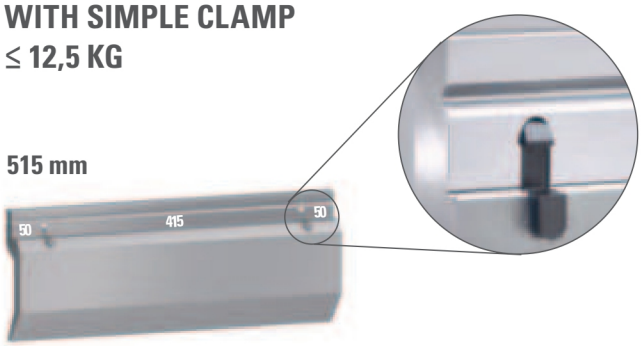
- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Tool lengths

PUNCHES/TOP TOOLS

WITH SIMPLE CLAMP
≤ 12,5 KG

515 mm



300 mm



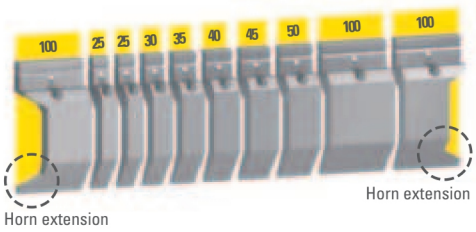
200 mm



100 mm



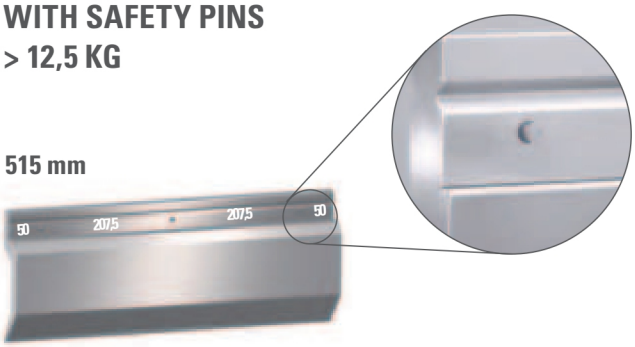
550 mm sectionalized



▸ 10 Segments, with horn extension left and right

WITH SAFETY PINS
> 12,5 KG

515 mm



300 mm



DIES

515 mm



300 mm



200 mm



100 mm

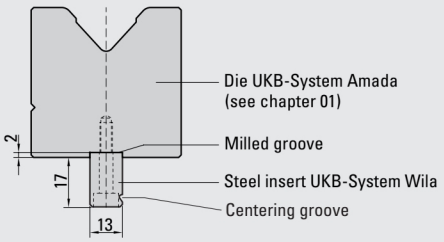


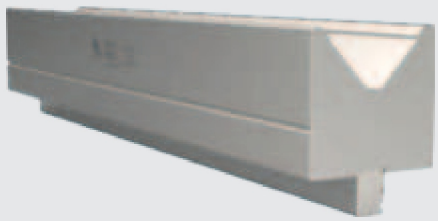
550 mm sectionalized



▸ 9 Segments

MODIFICATION OF DIES UKB-SYSTEM AMADA



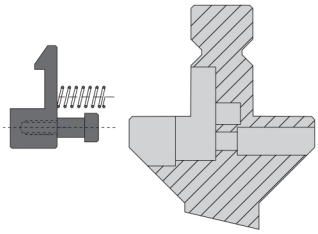


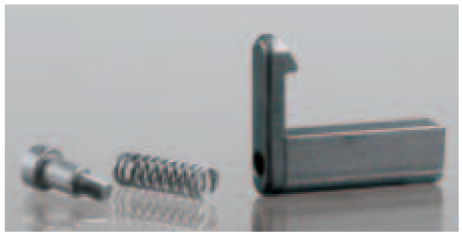
VIDEO

UKB-Modification of
Press Brake Tools

Simple Clamp

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



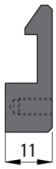


Set consists of screw, spring and Simple Clamp

70.714 24h

Set 0,012 kg 16,– €

SCAN TO SHOP

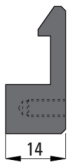


Suitable for punches/top tools
19.024 / 19.034

70.715 24h

Set 0,014 kg 16,– €

SCAN TO SHOP

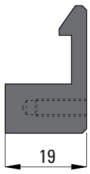


Suitable for punches/top tools
19.021 / 19.031 / 19.221 / 19.224 / 19.231

70.716 24h

Set 0,016 kg 18,– €

SCAN TO SHOP

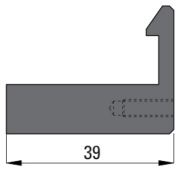


Suitable for punches/top tools
19.022 / 19.032

70.718 24h

Set 0,027 kg 20,– €

SCAN TO SHOP

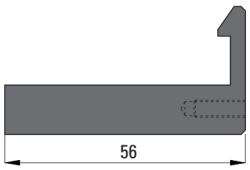


Suitable for punches/top tools
19.023 / 19.033 / 19.225 / 19.233 / 19.235

70.719 24h

Set 0,038 kg 20,– €

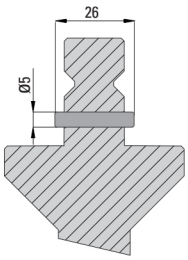
SCAN TO SHOP

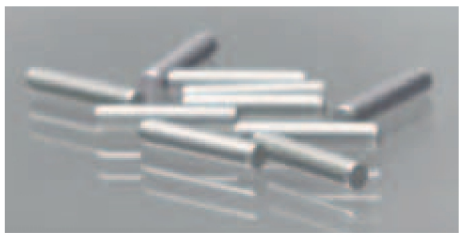


Suitable for punch/top tool
19.226

Safety pins

- **Horizontal** tool change for segments **more than 12,5 kg**
- Safety pins available hardened and non-hardened

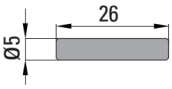




Safety pins

70.130 24h

10 Pieces 0,16 kg 4,– €

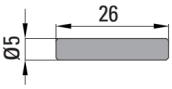


Hardened

SCAN TO SHOP

70.140 24h

10 Pieces 0,16 kg 2,– €



Non-hardened

SCAN TO SHOP

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



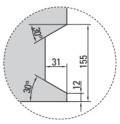
Punches/top tools Wila type I H = 163 mm

19.023

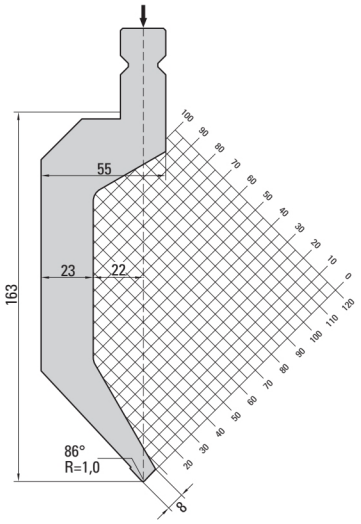
24h
650 kN/m

Safety pins		
515 mm	19,1 kg	624,– €
Simple Clamp		
300 mm	11,2 kg	518,– €
200 mm	7,4 kg	414,– €
100 mm	3,7 kg	212,– €
550 mm sectionalized	19,0 kg	1.176,– €

SCAN TO SHOP







Other radii - prices on request

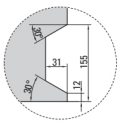
R (mm)	0,5	2,0	2,5	3,0	4,0	5,0	6,0
H (mm)	162,8	162,2	162,0	161,7	161,3	160,8	160,3

19.225

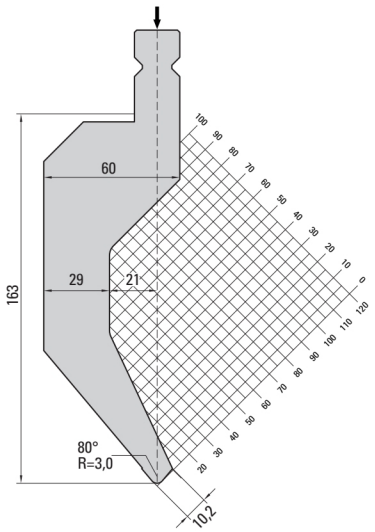
24h
900 kN/m

Safety pins		
515 mm	24,7 kg	624,– €
300 mm	14,4 kg	466,– €
Simple Clamp		
200 mm	9,6 kg	414,– €
100 mm	4,8 kg	212,– €
550 mm sectionalized	24,6 kg	1.176,– €

SCAN TO SHOP







Other radii - prices on request

R (mm)	4,0	5,0	6,0
H (mm)	162,1	161,5	161,0

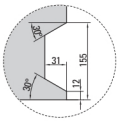
Punches/top tools Wila type I H = 163 mm

19.224 — 24h — 450 kN/m

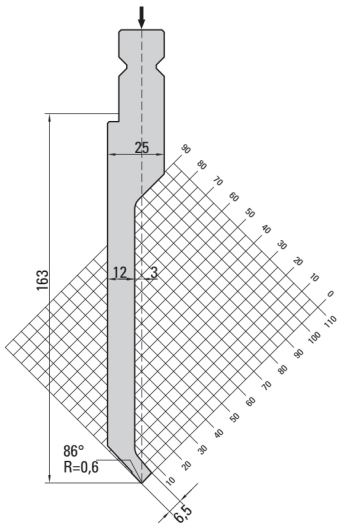
Simple Clamp

515 mm	12,2 kg	438,– €
300 mm	7,1 kg	370,– €
200 mm	4,7 kg	290,– €
100 mm	2,4 kg	168,– €
550 mm sectionalized	12,2 kg	828,– €

SCAN TO SHOP







Other radii - prices on request

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

19.022 — 24h — 800 kN/m

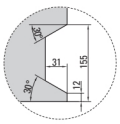
Safety pins

515 mm	16,0 kg	456,– €

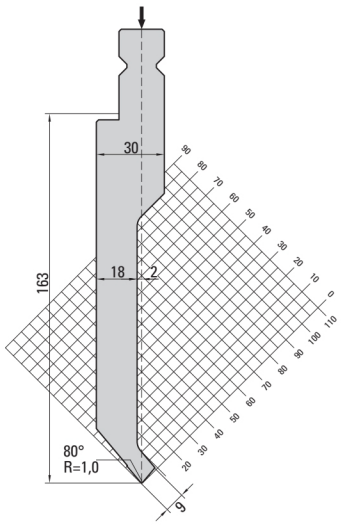
Simple Clamp

300 mm	9,3 kg	376,– €
200 mm	6,2 kg	302,– €
100 mm	3,1 kg	156,– €
550 mm sectionalized	15,9 kg	860,– €

SCAN TO SHOP







Other radii - prices on request

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

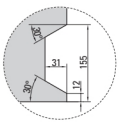
Punches/top tools Wila type I H = 163 mm

19.226

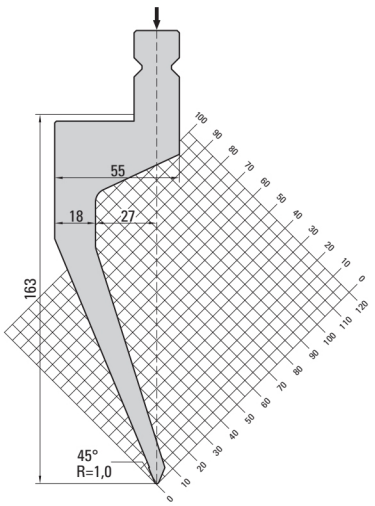
24h
400 kN/m

Safety pins		
515 mm	15,3 kg	722,– €
Simple Clamp		
300 mm	8,9 kg	592,– €
200 mm	5,9 kg	476,– €
100 mm	3,0 kg	246,– €
550 mm sectionalized	15,3 kg	1.362,– €

SCAN TO SHOP







Other radii - prices on request

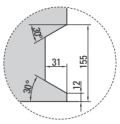
R (mm)	0,5	2,0	2,5
H (mm)	162,8	160,8	159,2

19.024

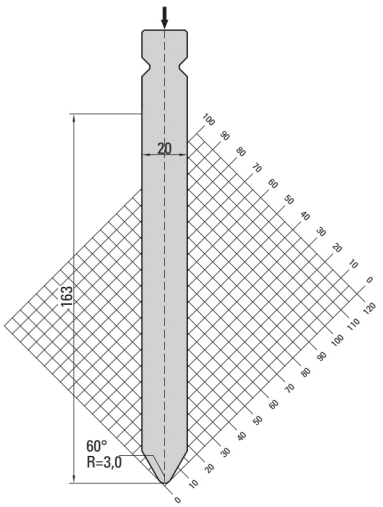
24h
1600 kN/m

Safety pins		
515 mm	16,1 kg	408,– €
Simple Clamp		
300 mm	9,4 kg	324,– €
200 mm	6,3 kg	268,– €
100 mm	3,1 kg	138,– €
550 mm sectionalized	15,9 kg	770,– €

SCAN TO SHOP







Other radii - prices on request

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

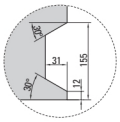
Punches/top tools Wila type I H = 163 mm

19.021 — 24h — 700 kN/m

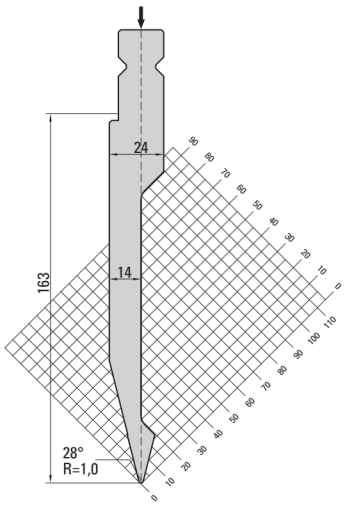
Simple Clamp

515 mm	12,2 kg	442,– €
300 mm	7,1 kg	356,– €
200 mm	4,7 kg	292,– €
100 mm	2,4 kg	152,– €
550 mm sectionalized	12,2 kg	836,– €

SCAN TO SHOP







Other radii - prices on request

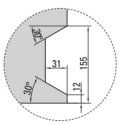
R (mm)	0,5	2,0	2,5
H (mm)	162,8	159,0	157,4

19.221 — 24h — 1000 kN/m

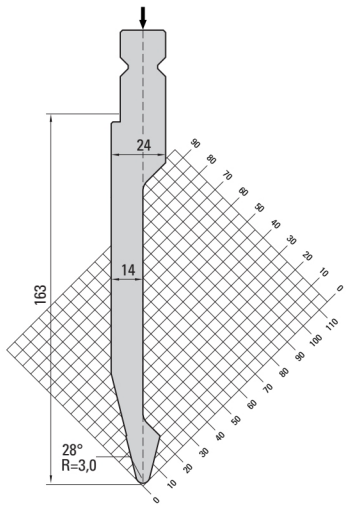
Simple Clamp

515 mm	12,5 kg	442,– €
300 mm	7,3 kg	356,– €
200 mm	4,9 kg	292,– €
100 mm	2,4 kg	152,– €
550 mm sectionalized	12,6 kg	836,– €

SCAN TO SHOP







Other radii - prices on request

R (mm)	4,0	5,0
H (mm)	159,0	155,8

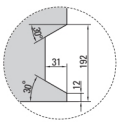
Punches/top tools Wila type I H = 200 mm

19.033

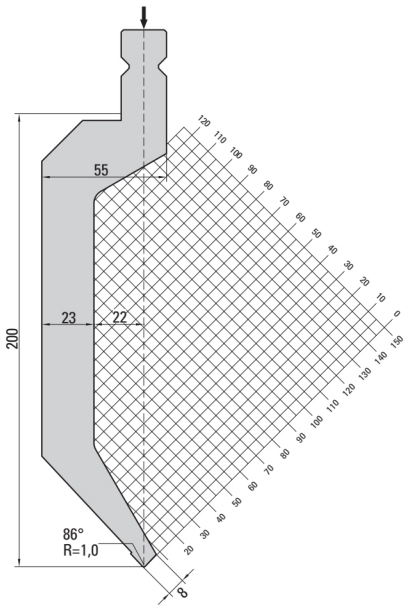
24h
500 kN/m

Safety pins		
515 mm	22,6 kg	676,– €
300 mm	13,2 kg	412,– €
Simple Clamp		
200 mm	8,8 kg	444,– €
100 mm	4,4 kg	230,– €
550 mm sectionalized	22,2 kg	1.272,– €

SCAN TO SHOP







Other radii - prices on request

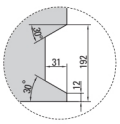
R (mm)	0,5	2,0	2,5	3,0	4,0	5,0	6,0
H (mm)	199,8	199,2	199,0	198,7	198,3	197,8	197,3

19.233

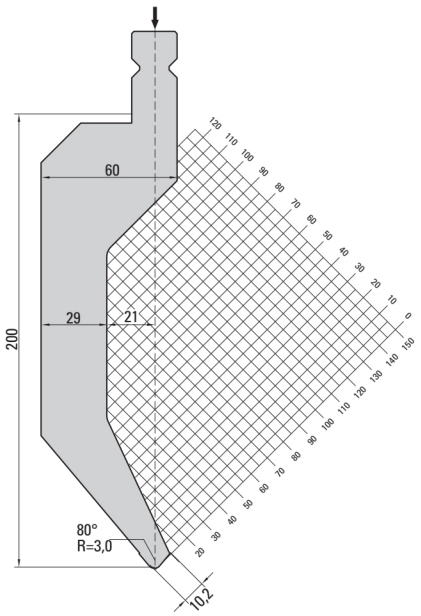
24h
900 kN/m

Safety pins		
515 mm	29,0 kg	676,– €
300 mm	16,9 kg	412,– €
Simple Clamp		
200 mm	11,3 kg	444,– €
100 mm	5,6 kg	230,– €
550 mm sectionalized	29,2 kg	1.272,– €

SCAN TO SHOP







Other radii - prices on request

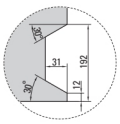
R (mm)	2,0	2,5	4,0	5,0	6,0
H (mm)	199,8	199,8	199,1	198,5	198,0

Punches/top tools Wila type I H = 200 mm

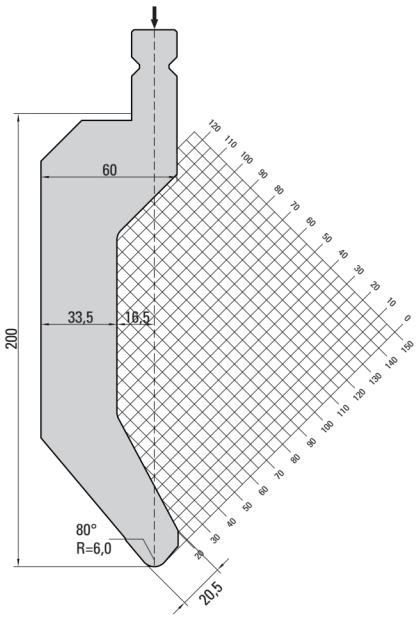
19.235 — 24h — 1300 kN/m

Safety pins		
515 mm	32,0 kg	778,– €
300 mm	18,7 kg	556,– €
Simple Clamp		
200 mm	12,4 kg	432,– €
100 mm	6,2 kg	242,– €
550 mm sectionalized	32,3 kg	1.462,– €

SCAN TO SHOP







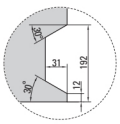
Other radii - prices on request

R (mm)	8,0	10,0
H (mm)	198,6	197,5

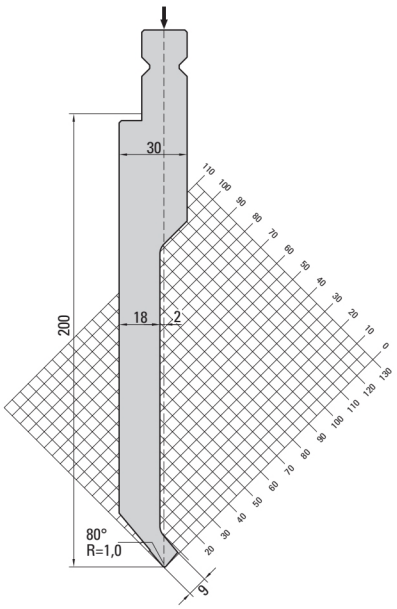
19.032 — 24h — 800 kN/m

Safety pins		
515 mm	19,3 kg	492,– €
Simple Clamp		
300 mm	11,2 kg	406,– €
200 mm	7,5 kg	326,– €
100 mm	3,7 kg	168,– €
550 mm sectionalized	19,0 kg	928,– €

SCAN TO SHOP







Other radii - prices on request

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

Punches/top tools Wila type I H = 200 mm

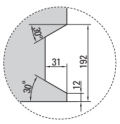
19.034

24h

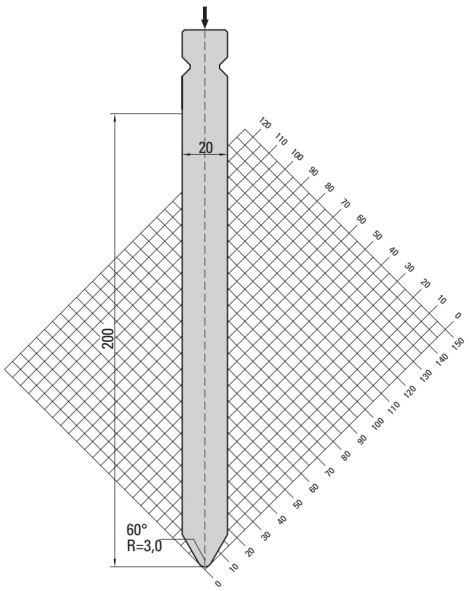
1600 kN/m

Safety pins		
515 mm	19,3 kg	440,– €
Simple Clamp		
300 mm	11,2 kg	364,– €
200 mm	7,5 kg	290,– €
100 mm	3,7 kg	150,– €
550 mm sectionalized	18,9 kg	830,– €

SCAN TO SHOP







Other radii - prices on request

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

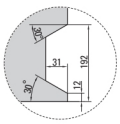
19.031

24h

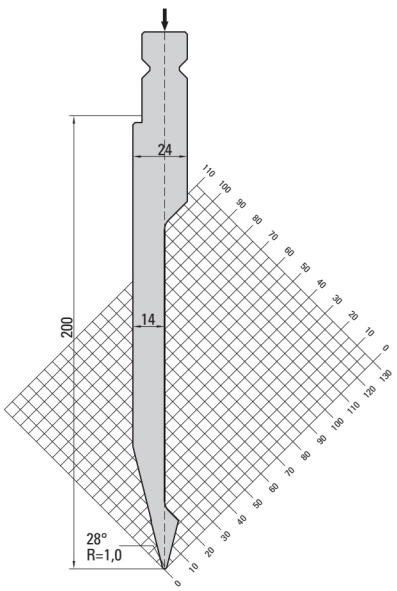
600 kN/m

Safety pins		
515 mm	14,8 kg	478,– €
Simple Clamp		
300 mm	8,6 kg	396,– €
200 mm	5,8 kg	316,– €
100 mm	2,9 kg	162,– €
550 mm sectionalized	14,4 kg	900,– €

SCAN TO SHOP







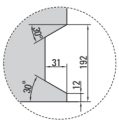
Other radii - prices on request

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

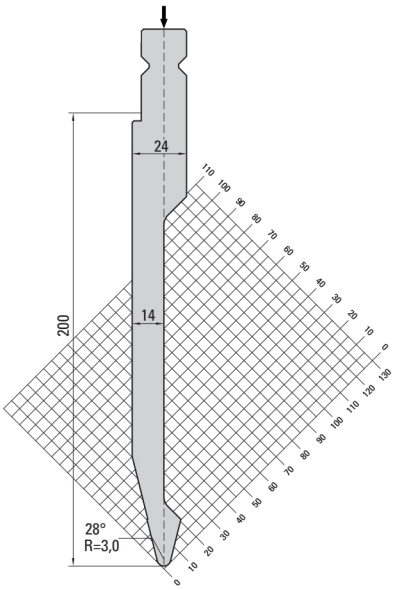
Punch/top tool Wila type I H = 200 mm

19.231		24h 1000 kN/m
Safety pins		
515 mm	15,2 kg	478,– €
Simple Clamp		
300 mm	8,9 kg	396,– €
200 mm	5,9 kg	316,– €
100 mm	3,0 kg	162,– €
550 mm sectionalized	15,4 kg	900,– €

SCAN TO SHOP







Other radii - prices on request

R (mm)	4,0	5,0
H (mm)	196,0	192,8

UKB-WINGBEND PLUS

- ► Avoids bending marks on sheets via Slider
- ► Short flanges with minimal marking
- ► Holes close to the bending line without deformation
- ► Ideal for diagonal or tapered bending, perforated sheets, bulb and chequered plates
- ► No tool contamination while bending galvanized material or aluminium

CHAPTER 10



Punches/top tools Wila type II H = 95 mm

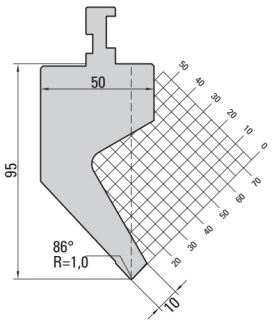
14.040

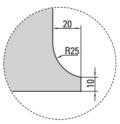
24h
750 kN/m

500 mm	12,0 kg	318,– €
300 mm	7,2 kg	218,– €
200 mm	4,8 kg	146,– €
100 mm	2,4 kg	80,– €
550 mm sectionalized	12,3 kg	568,– €

SCAN TO SHOP







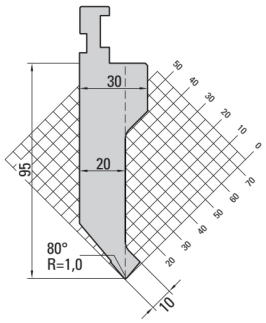
14.020

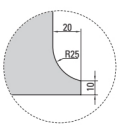
24h
750 kN/m

500 mm	8,8 kg	242,– €
300 mm	5,3 kg	176,– €
200 mm	3,5 kg	120,– €
100 mm	1,8 kg	68,– €
550 mm sectionalized	9,0 kg	464,– €

SCAN TO SHOP







14.010

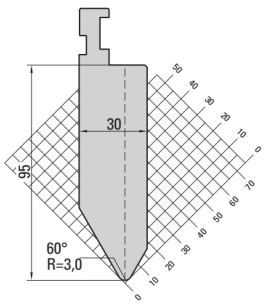
24h
1000 kN/m

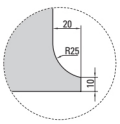
500 mm	10,7 kg	206,– €
300 mm	6,4 kg	146,– €
200 mm	4,3 kg	102,– €
100 mm	2,1 kg	56,– €
550 mm sectionalized	11,0 kg	426,– €

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

SCAN TO SHOP







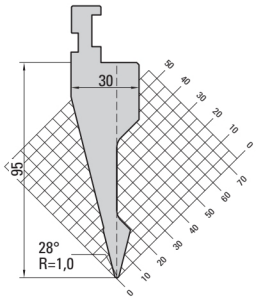
14.030

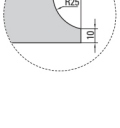
24h
700 kN/m

500 mm	6,9 kg	278,– €
300 mm	4,1 kg	206,– €
200 mm	2,8 kg	142,– €
100 mm	1,4 kg	74,– €
550 mm sectionalized	7,1 kg	502,– €

SCAN TO SHOP



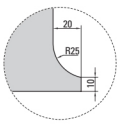




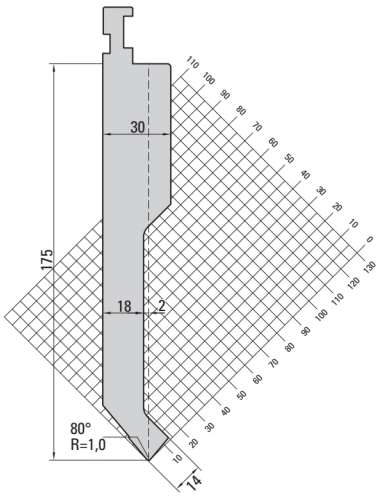
Punches/top tools Wila type II H = 175 mm

14.060		24h 800 kN/m
500 mm	16,1 kg	380,– €
300 mm	9,7 kg	276,– €
200 mm	6,5 kg	190,– €
100 mm	3,2 kg	104,– €
550 mm sectionalized	16,5 kg	790,– €

SCAN TO SHOP

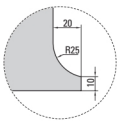




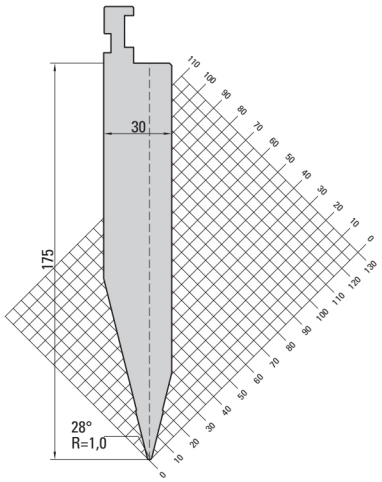


14.050		24h 1000 kN/m
500 mm	17,9 kg	412,– €
300 mm	10,7 kg	298,– €
200 mm	7,1 kg	206,– €
100 mm	3,6 kg	116,– €
550 mm sectionalized	18,2 kg	876,– €

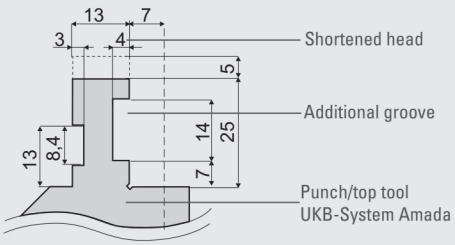
SCAN TO SHOP







MODIFICATION OF CLAMPING UKB-SYSTEM AMADA



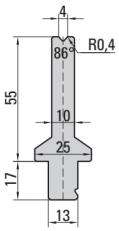
VIDEO

UKB-Modification of Press Brake Tools

86° Dies H = 55 mm

29.524 — 24h — 450 kN/m

515 mm	3,6 kg	252,– €
300 mm	2,1 kg	214,– €
200 mm	1,4 kg	170,– €
100 mm	0,7 kg	88,– €
550 mm sectionalized	3,7 kg	454,– €

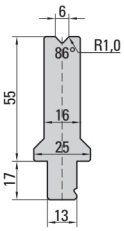


SCAN TO SHOP



29.521 — 24h — 1200 kN/m

515 mm	4,7 kg	252,– €
300 mm	2,7 kg	214,– €
200 mm	1,8 kg	170,– €
100 mm	0,9 kg	88,– €
550 mm sectionalized	5,0 kg	454,– €

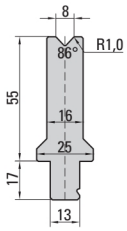


SCAN TO SHOP



29.510 — 24h — 1200 kN/m

515 mm	4,6 kg	252,– €
300 mm	2,7 kg	214,– €
200 mm	1,8 kg	170,– €
100 mm	0,9 kg	88,– €
550 mm sectionalized	4,9 kg	454,– €

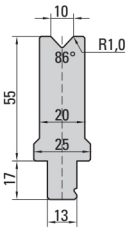


SCAN TO SHOP



29.522 — 24h — 1200 kN/m

515 mm	5,4 kg	252,– €
300 mm	3,1 kg	214,– €
200 mm	2,1 kg	170,– €
100 mm	1,0 kg	88,– €
550 mm sectionalized	5,7 kg	454,– €

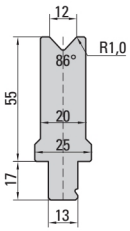


SCAN TO SHOP

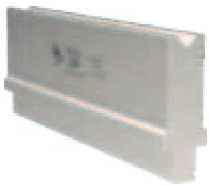


29.511 — 24h — 1200 kN/m

515 mm	5,3 kg	252,– €
300 mm	3,1 kg	214,– €
200 mm	2,1 kg	170,– €
100 mm	1,0 kg	88,– €
550 mm sectionalized	5,7 kg	454,– €

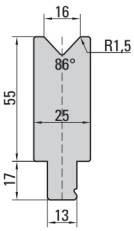


SCAN TO SHOP



29.512 — 24h — 1200 kN/m

515 mm	6,1 kg	252,– €
300 mm	3,6 kg	214,– €
200 mm	2,4 kg	170,– €
100 mm	1,2 kg	88,– €
550 mm sectionalized	6,5 kg	454,– €



SCAN TO SHOP

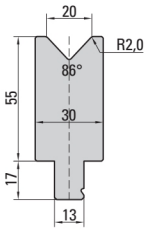


80° Dies H = 55/65 mm

29.523 — 24h — 1200 kN/m

515 mm	7,1 kg	260,– €
300 mm	4,1 kg	236,– €
200 mm	2,8 kg	176,– €
100 mm	1,4 kg	90,– €
550 mm sectionalized	7,6 kg	474,– €

SCAN TO SHOP

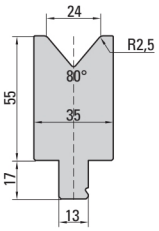




29.513 — 24h — 1250 kN/m

515 mm	7,9 kg	266,– €
300 mm	4,6 kg	230,– €
200 mm	3,1 kg	178,– €
100 mm	1,5 kg	92,– €
550 mm sectionalized	8,5 kg	482,– €

SCAN TO SHOP

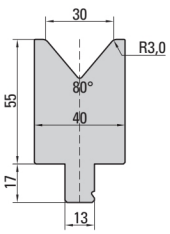




29.514 — 24h — 1250 kN/m

515 mm	8,7 kg	294,– €
300 mm	5,0 kg	252,– €
200 mm	3,4 kg	198,– €
100 mm	1,7 kg	102,– €
550 mm sectionalized	9,2 kg	534,– €

SCAN TO SHOP

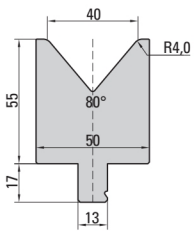




29.515 — 24h — 1250 kN/m

515 mm	10,0 kg	322,– €
300 mm	5,8 kg	274,– €
200 mm	3,9 kg	216,– €
100 mm	1,9 kg	112,– €
550 mm sectionalized	10,7 kg	582,– €

SCAN TO SHOP

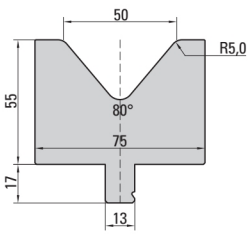




29.535 — 24h — 1500 kN/m

515 mm	14,7 kg	382,– €
300 mm	8,5 kg	330,– €
200 mm	5,7 kg	258,– €
100 mm	2,8 kg	134,– €
550 mm sectionalized	15,5 kg	696,– €

SCAN TO SHOP

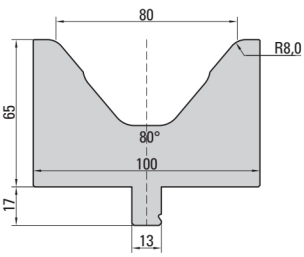




29.517 — 24h — 1500 kN/m

515 mm	19,4 kg	652,– €
300 mm	11,3 kg	424,– €
200 mm	7,5 kg	334,– €
100 mm	3,8 kg	152,– €
550 mm sectionalized	20,7 kg	848,– €

SCAN TO SHOP





30° Dies H = 55 mm

29.561

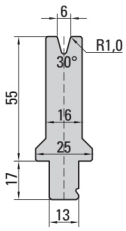
24h
800 kN/m

515 mm	4,6 kg	252,– €
300 mm	2,7 kg	214,– €
200 mm	1,8 kg	170,– €
100 mm	0,9 kg	88,– €
550 mm sectionalized	4,9 kg	454,– €

Max. load for 90° bending

SCAN TO SHOP





29.551

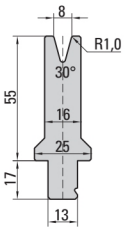
24h
800 kN/m

515 mm	4,5 kg	252,– €
300 mm	2,6 kg	214,– €
200 mm	1,7 kg	170,– €
100 mm	0,9 kg	88,– €
550 mm sectionalized	4,8 kg	454,– €

Max. load for 90° bending

SCAN TO SHOP





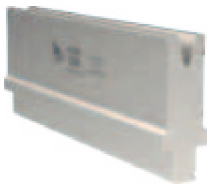
29.562

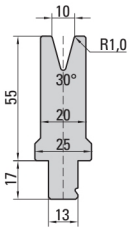
24h
800 kN/m

515 mm	5,1 kg	252,– €
300 mm	3,0 kg	214,– €
200 mm	2,0 kg	170,– €
100 mm	1,0 kg	88,– €
550 mm sectionalized	5,5 kg	454,– €

Max. load for 90° bending

SCAN TO SHOP





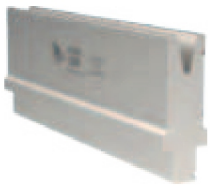
29.552

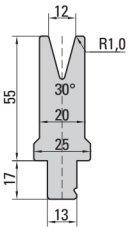
24h
800 kN/m

515 mm	4,9 kg	252,– €
300 mm	2,9 kg	214,– €
200 mm	1,9 kg	170,– €
100 mm	1,0 kg	88,– €
550 mm sectionalized	5,3 kg	454,– €

Max. load for 90° bending

SCAN TO SHOP





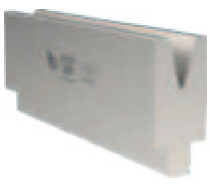
29.553

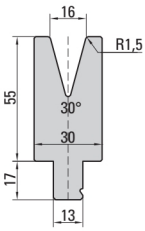
24h
800 kN/m

515 mm	6,6 kg	260,– €
300 mm	3,8 kg	224,– €
200 mm	2,5 kg	176,– €
100 mm	1,3 kg	90,– €
550 mm sectionalized	7,0 kg	474,– €

Max. load for 90° bending

SCAN TO SHOP





29.563

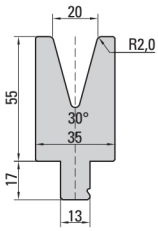
24h
800 kN/m

515 mm	7,2 kg	274,– €
300 mm	4,2 kg	236,– €
200 mm	2,8 kg	184,– €
100 mm	1,4 kg	94,– €
550 mm sectionalized	7,7 kg	496,– €

Max. load for 90° bending

SCAN TO SHOP





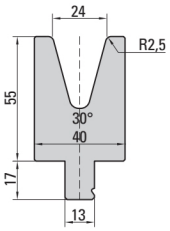
30° Die H = 55 mm

29.554		24h 800 kN/m
515 mm	7,8 kg	292,– €
300 mm	4,5 kg	248,– €
200 mm	3,0 kg	196,– €
100 mm	1,5 kg	100,– €
550 mm sectionalized	8,3 kg	530,– €

Max. load for 90° bending

SCAN TO SHOP





UKB-INFO

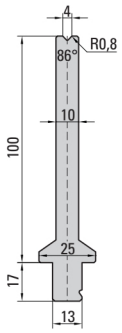
More dies height = 55 mm
see UKB-System Bystronic (chapter 05)

86° Dies H = 100 mm

29.336		24h 450 kN/m
515 mm	5,3 kg	306,– €
300 mm	3,1 kg	250,– €
200 mm	2,1 kg	200,– €
100 mm	1,0 kg	102,– €
550 mm sectionalized	5,7 kg	566,– €

SCAN TO SHOP

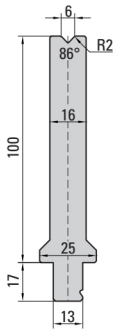




29.321		24h 1200 kN/m
515 mm	7,6 kg	306,– €
300 mm	4,4 kg	250,– €
200 mm	2,9 kg	200,– €
100 mm	1,5 kg	102,– €
550 mm sectionalized	8,1 kg	566,– €

SCAN TO SHOP

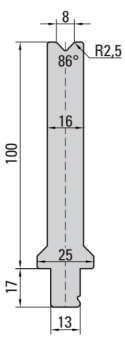




29.290		24h 1200 kN/m
515 mm	7,5 kg	306,– €
300 mm	4,4 kg	250,– €
200 mm	2,9 kg	200,– €
100 mm	1,5 kg	102,– €
550 mm sectionalized	8,0 kg	566,– €

SCAN TO SHOP

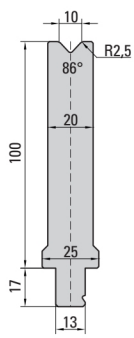




29.322		24h 1200 kN/m
515 mm	9,0 kg	306,– €
300 mm	5,0 kg	250,– €
200 mm	3,5 kg	200,– €
100 mm	1,7 kg	102,– €
550 mm sectionalized	9,6 kg	566,– €

SCAN TO SHOP



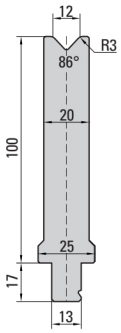


86° Dies H = 100 mm

29.291		24h 1200 kN/m
515 mm	9,0 kg	306,– €
300 mm	5,2 kg	250,– €
200 mm	3,5 kg	200,– €
100 mm	1,7 kg	102,– €
550 mm sectionalized	9,6 kg	566,– €

SCAN TO SHOP

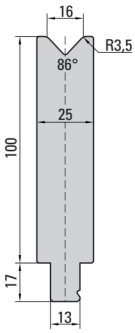




29.292		24h 1200 kN/m
515 mm	10,7 kg	306,– €
300 mm	6,2 kg	250,– €
200 mm	4,1 kg	200,– €
100 mm	2,1 kg	102,– €
550 mm sectionalized	11,4 kg	566,– €

SCAN TO SHOP

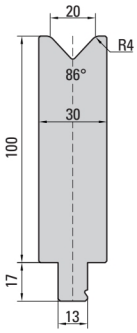




29.323		24h 1200 kN/m
515 mm	12,5 kg	316,– €
300 mm	7,3 kg	260,– €
200 mm	4,9 kg	210,– €
100 mm	2,4 kg	112,– €
550 mm sectionalized	13,4 kg	586,– €

SCAN TO SHOP





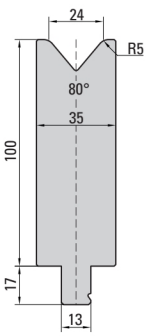


80° Dies H = 100 mm

29.293		24h 1250 kN/m
515 mm	14,3 kg	316,– €
300 mm	8,3 kg	260,– €
200 mm	5,6 kg	210,– €
100 mm	2,8 kg	112,– €
550 mm sectionalized	15,3 kg	586,– €

SCAN TO SHOP

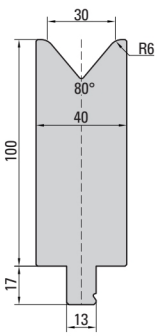




29.324		24h 1250 kN/m
515 mm	15,9 kg	344,– €
300 mm	9,3 kg	288,– €
200 mm	6,2 kg	232,– €
100 mm	3,1 kg	130,– €
550 mm sectionalized	17,0 kg	614,– €

SCAN TO SHOP



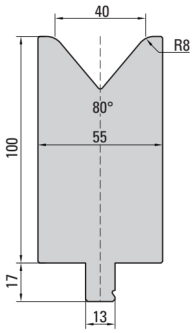


80° Dies H = 100 mm

29.325		24h 1250 kN/m
515 mm	21,1 kg	372,– €
300 mm	12,3 kg	306,– €
200 mm	8,2 kg	250,– €
100 mm	4,1 kg	140,– €
550 mm sectionalized	22,6 kg	668,– €

SCAN TO SHOP

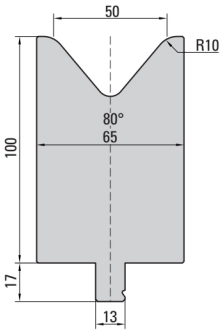




29.326		24h 1500 kN/m
515 mm	24,1 kg	456,– €
300 mm	14,0 kg	372,– €
200 mm	9,4 kg	298,– €
100 mm	4,7 kg	158,– €
550 mm sectionalized	25,8 kg	790,– €

SCAN TO SHOP

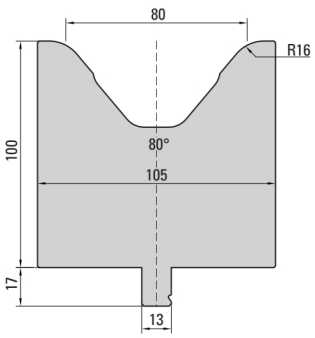




29.297		24h 1500 kN/m
515 mm	35,5 kg	780,– €
300 mm	20,7 kg	586,– €
200 mm	13,8 kg	390,– €
100 mm	6,9 kg	214,– €
550 mm sectionalized	37,9 kg	934,– €

SCAN TO SHOP







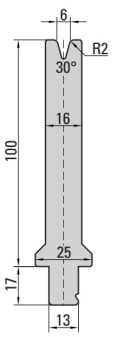
30° Dies H = 100 mm

29.361		24h 800 kN/m
515 mm	7,5 kg	326,– €
300 mm	4,4 kg	264,– €
200 mm	2,9 kg	214,– €
100 mm	1,5 kg	116,– €
550 mm sectionalized	8,0 kg	572,– €

Max. load for 90° bending

SCAN TO SHOP



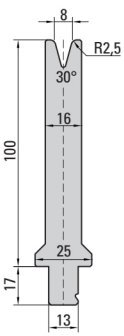


29.351		24h 800 kN/m
515 mm	7,4 kg	326,– €
300 mm	4,3 kg	264,– €
200 mm	2,9 kg	214,– €
100 mm	1,4 kg	116,– €
550 mm sectionalized	7,9 kg	572,– €

Max. load for 90° bending

SCAN TO SHOP





30° Dies H = 100 mm

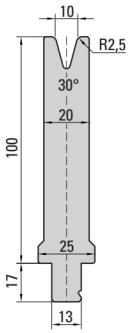
29.362 — 24h — 800 kN/m

515 mm	8,8 kg	326,– €
300 mm	5,1 kg	264,– €
200 mm	3,4 kg	214,– €
100 mm	1,7 kg	116,– €
550 mm sectionalized	9,4 kg	572,– €

Max. load for 90° bending

SCAN TO SHOP





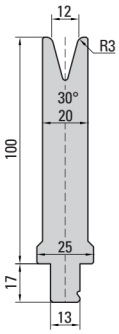
29.352 — 24h — 800 kN/m

515 mm	8,6 kg	326,– €
300 mm	5,0 kg	264,– €
200 mm	3,3 kg	214,– €
100 mm	1,7 kg	116,– €
550 mm sectionalized	9,2 kg	572,– €

Max. load for 90° bending

SCAN TO SHOP





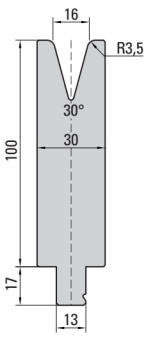
29.353 — 24h — 800 kN/m

515 mm	12,0 kg	334,– €
300 mm	7,0 kg	264,– €
200 mm	4,7 kg	218,– €
100 mm	2,3 kg	120,– €
550 mm sectionalized	12,8 kg	586,– €

Max. load for 90° bending

SCAN TO SHOP





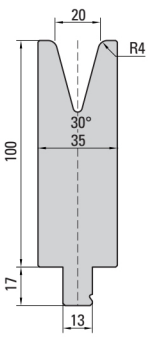
29.363 — 24h — 800 kN/m

515 mm	13,5 kg	340,– €
300 mm	7,9 kg	274,– €
200 mm	5,2 kg	222,– €
100 mm	2,6 kg	130,– €
550 mm sectionalized	14,5 kg	608,– €

Max. load for 90° bending

SCAN TO SHOP





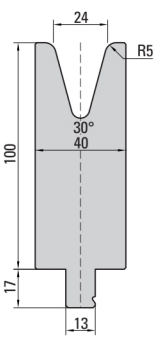
29.354 — 24h — 800 kN/m

515 mm	15,0 kg	354,– €
300 mm	8,7 kg	274,– €
200 mm	5,8 kg	228,– €
100 mm	2,9 kg	130,– €
550 mm sectionalized	16,0 kg	632,– €

Max. load for 90° bending

SCAN TO SHOP





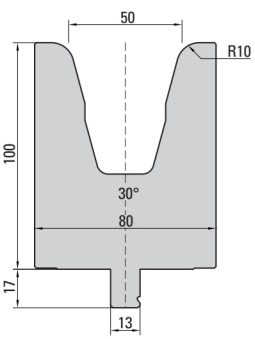
29.330 — 24h — 1500 kN/m

515 mm	24,6 kg	538,– €
300 mm	14,3 kg	408,– €
200 mm	9,5 kg	306,– €
100 mm	4,8 kg	176,– €
550 mm sectionalized	26,2 kg	976,– €

Max. load for 90° bending

SCAN TO SHOP





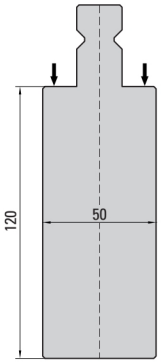
Flattening punch/top tool and flattening die

19.041 — 24h — 1000 kN/m

Safety pins		
515 mm	27,0 kg	570,– €
300 mm	15,7 kg	362,– €
Simple Clamp		
200 mm	10,5 kg	290,– €
100 mm	5,2 kg	154,– €
550 mm sectionalized	28,8 kg	976,– €

SCAN TO SHOP





29.384 — 24h — 1000 kN/m

515 mm	21,2 kg	524,– €
300 mm	12,4 kg	334,– €
200 mm	8,3 kg	226,– €
100 mm	4,2 kg	126,– €
550 mm sectionalized	22,6 kg	850,– €

SCAN TO SHOP



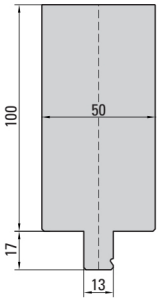


Table of force for flattening

Material: R_m = 400 N/mm², mild steel

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, stainless steel

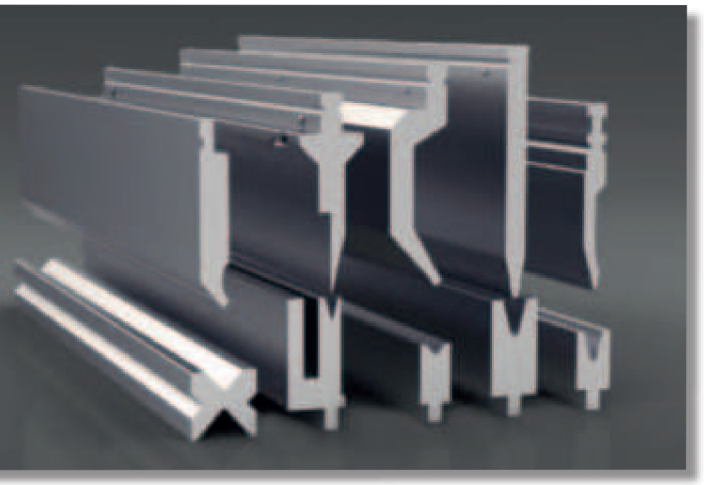
S (mm)	(t/m)	T (mm)	(t/m)	2S (mm)
0,6	15	3,0	35	1,2
0,8	20	3,0	50	1,6
1,0	25	3,5	60	2,0
1,25	26	3,5	80	2,5
1,5	38	4,6	95	3,0
2,0	50	5,5	130	4,0





toolsystems24.de
Press Brake Tools Outlet — made by UKB

- Special offers
- Deal of the week
- Demonstration tools & test tools
- Special and remaining stock
- Used press brake tools



PRESS BRAKE TOOLS
UKB-SYSTEM LVD

Explanation 128-129

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Simple Clamp 130
Safety pins 130
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Dies
78° Dies H = 90 mm 134-135
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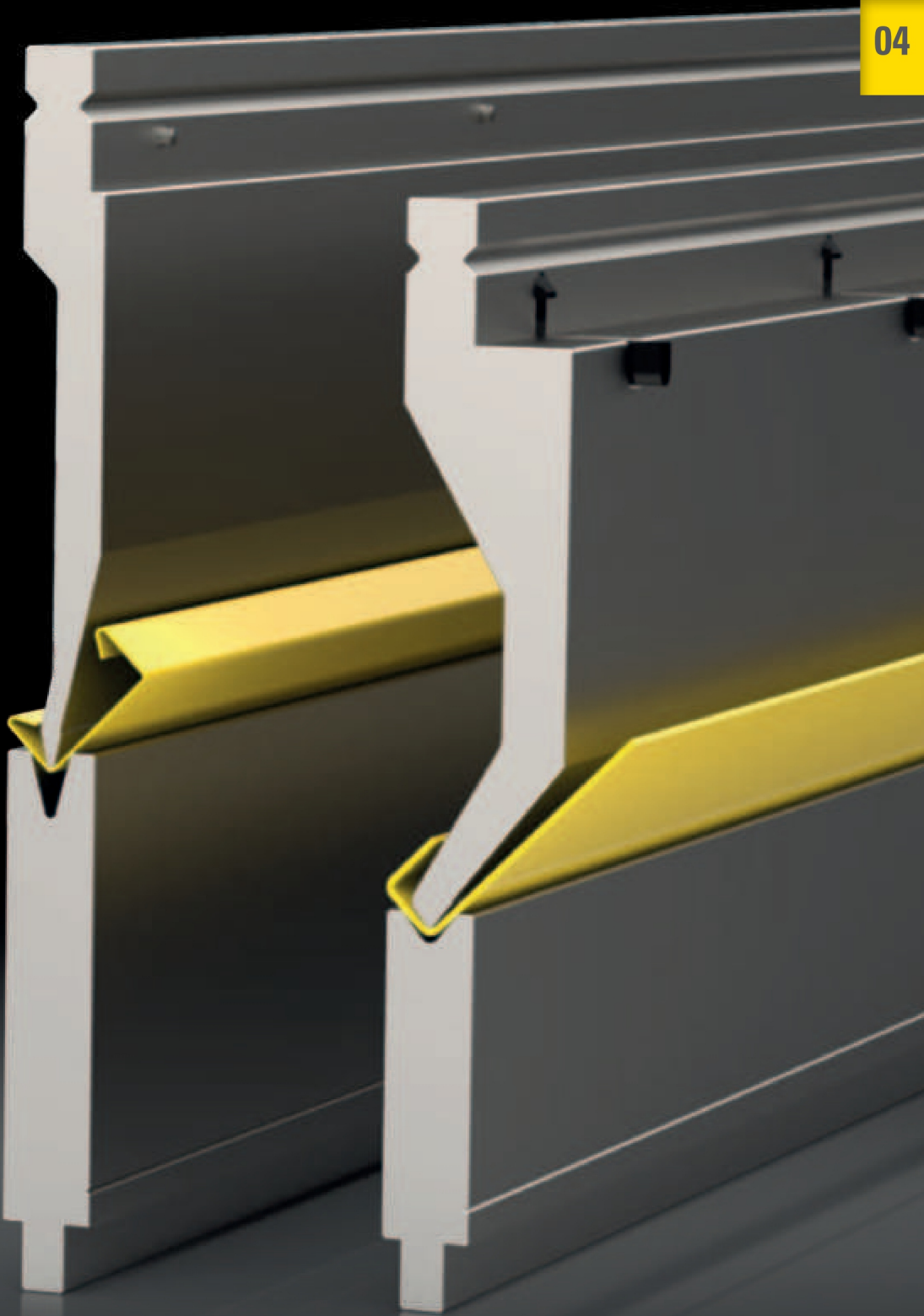
Flattening punches/top tools 142
Flattening dies 143





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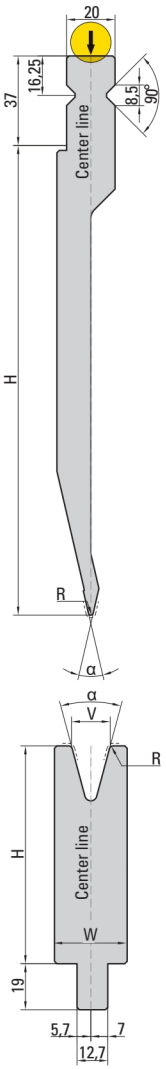
SYSTEM LVD

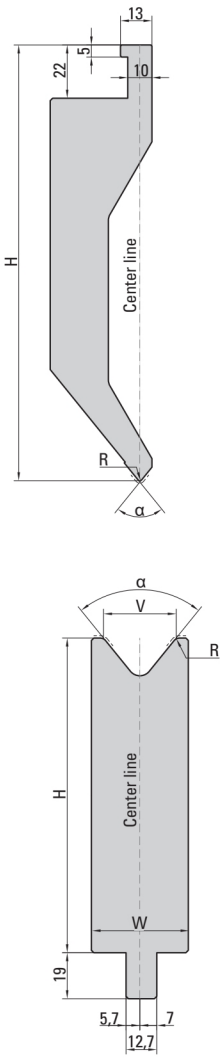
Quality and precision

- **Optimum materials**
  - 42 CrMo4, tempered to 1100 - 1200 N/mm²
  - C45, tempered to 800 - 850 N/mm²
  - C45, 650 - 800 N/mm
- 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



VIDEO

UKB-Press brake tool systems

UKB-ADVANTAGES

VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:	According agreement
Direct courier:	According agreement

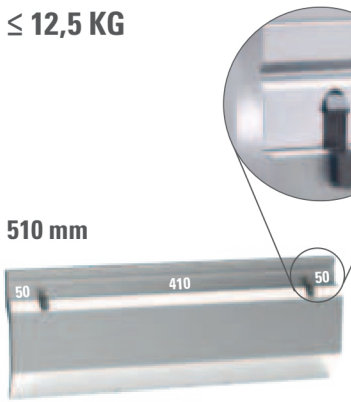
- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Tool lengths

PUNCHES/TOP TOOLS LVD TYPE I

WITH SIMPLE CLAMP
≤ 12,5 KG

510 mm

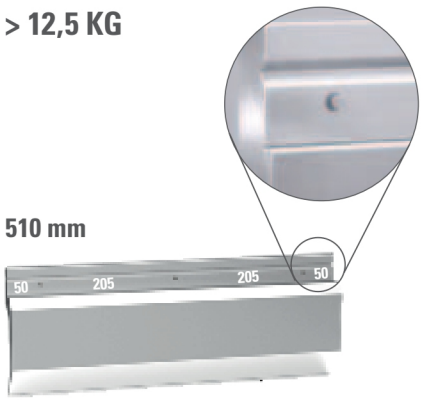


250 mm

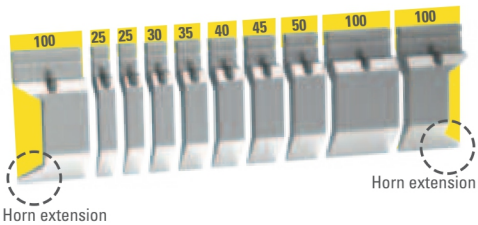


WITH SAFETY PINS
> 12,5 KG

510 mm



550 mm sectionalized



▸ 10 Segments, with horn extension left and right

UKB-INFO

We also supply the lengths 510 mm and 550 mm sectionalized for punches/top tools of the UKB system LVD type II

DIES

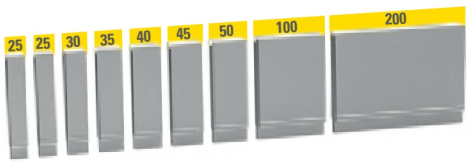
510 mm



250 mm

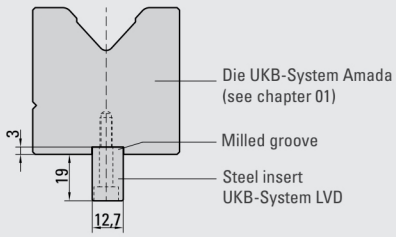


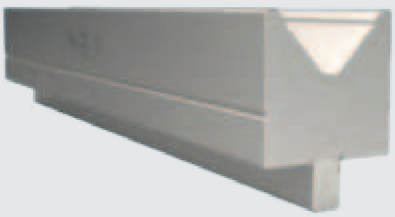
550 mm sectionalized



▸ 9 Segments

MODIFICATION OF DIES UKB-SYSTEM AMADA



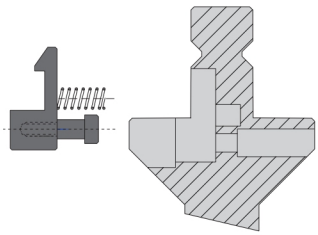


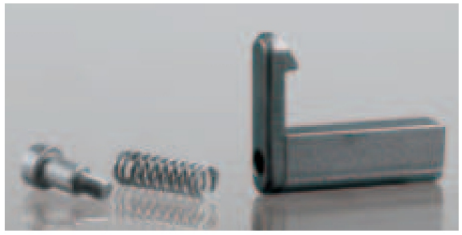
VIDEO

UKB-Modification of Press Brake Tools

Simple Clamp

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





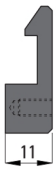
Set consists of screw, spring and Simple Clamp

70.714 24h

Set 0,012 kg 16,– €

SCAN TO SHOP

Suitable for punches/top tools
16.204 / 16.209

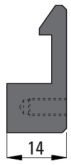


70.715 24h

Set 0,014 kg 16,– €

SCAN TO SHOP

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

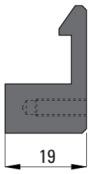


70.716 24h

Set 0,016 kg 18,– €

SCAN TO SHOP

Suitable for punches/top tools
16.808 / 16.810 / 16.812 /
16.908 / 16.910 / 16.912

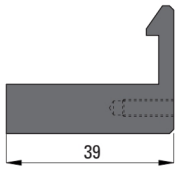


70.718 24h

Set 0,027 kg 20,– €

SCAN TO SHOP

Suitable for punches/top tools
16.200 / 16.205 / 16.210 / 16.211

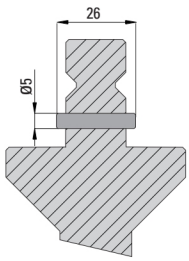


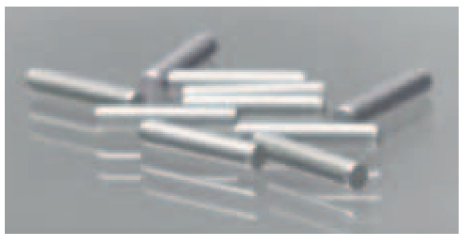
UKB-INFO

Punches/top tools UKB-System Trumpf (chapter 02) and UKB-System Wila type I (chapter 03) can also be used in a clamping UKB-System LVD!

Safety pins

- **Horizontal** tool change for segments **more than 12,5 kg**
- Safety pins available hardened and non-hardened





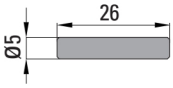
Safety pins

70.130 24h

10 Pieces 0,16 kg 4,– €

Hardened

SCAN TO SHOP

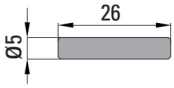


70.140 24h

10 Pieces 0,16 kg 2,– €

Non-hardened

SCAN TO SHOP

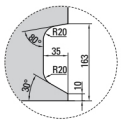


Punches/top tools LVD type I H = 159 mm

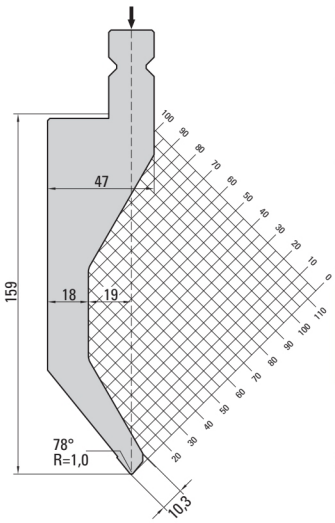
16.200 — 24h — 400 kN/m

Safety pins		
510 mm	18,7 kg	680,– €
Simple Clamp		
250 mm	9,4 kg	472,– €
550 mm sectionalized	18,3 kg	1.284,– €

SCAN TO SHOP



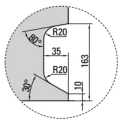




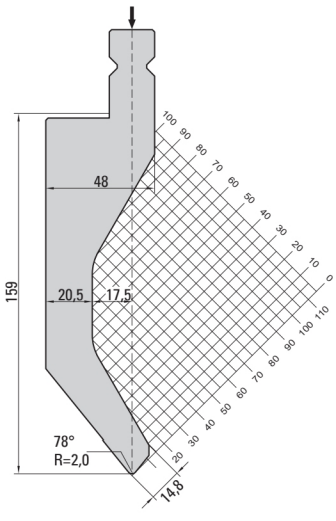
16.210 — 24h — 750 kN/m

Safety pins		
510 mm	20,1 kg	680,– €
Simple Clamp		
250 mm	10,0 kg	472,– €
550 mm sectionalized	19,7 kg	1.284,– €

SCAN TO SHOP



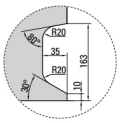




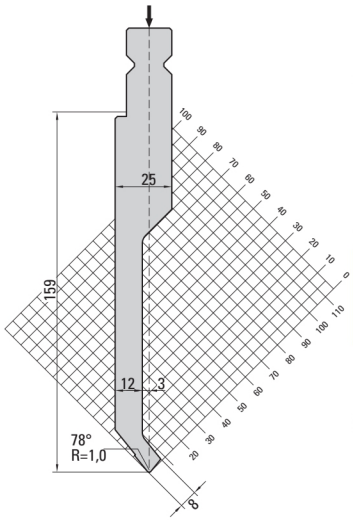
16.201 — 24h — 400 kN/m

Safety pins		
510 mm	13,0 kg	498,– €
Simple Clamp		
250 mm	6,5 kg	344,– €
550 mm sectionalized	12,8 kg	938,– €

SCAN TO SHOP



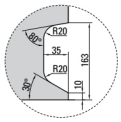




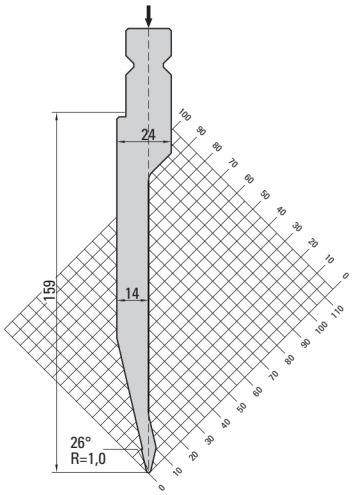
16.202 — 24h — 400 kN/m

Simple Clamp		
510 mm	11,9 kg	482,– €
250 mm	5,9 kg	334,– €
550 mm sectionalized	11,5 kg	910,– €

SCAN TO SHOP



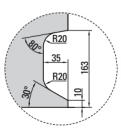




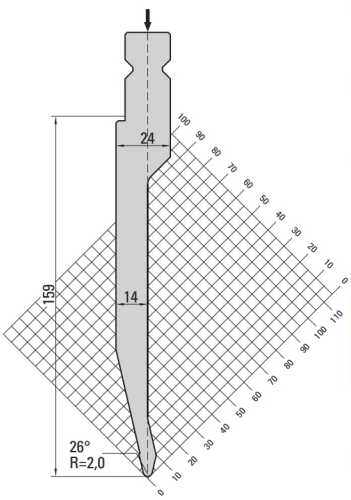
16.203 — 24h — 600 kN/m

Simple Clamp		
510 mm	11,4 kg	482,– €
250 mm	5,7 kg	334,– €
550 mm sectionalized	11,2 kg	910,– €

SCAN TO SHOP



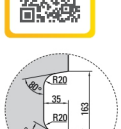




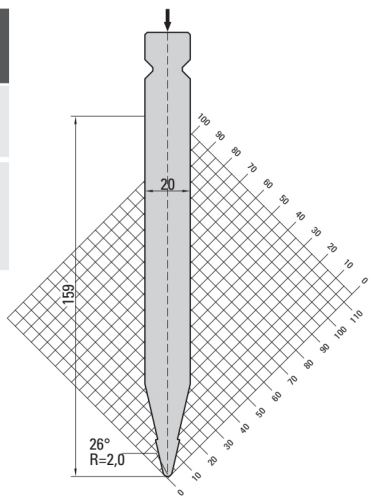
16.204 — 24h — 800 kN/m

Safety pins		
510 mm	14,2 kg	444,– €
Simple Clamp		
250 mm	7,1 kg	308,– €
550 mm sectionalized	13,9 kg	838,– €

SCAN TO SHOP





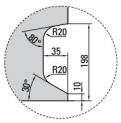


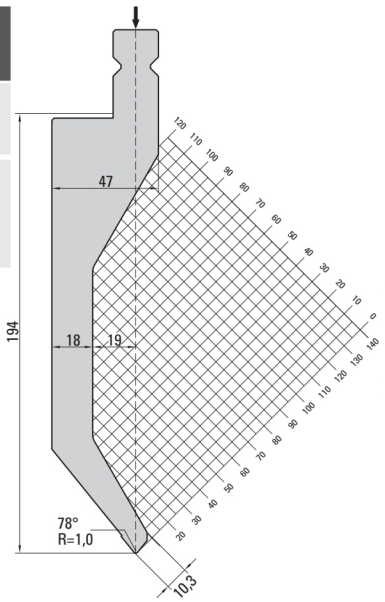
Punches/top tools LVD type I H = 194 mm

16.205 — 24h — 400 kN/m

Safety pins		
510 mm	21,2 kg	736,– €
Simple Clamp		
250 mm	10,6 kg	508,– €
550 mm sectionalized	20,8 kg	1.388,– €

SCAN TO SHOP

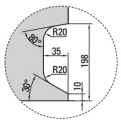


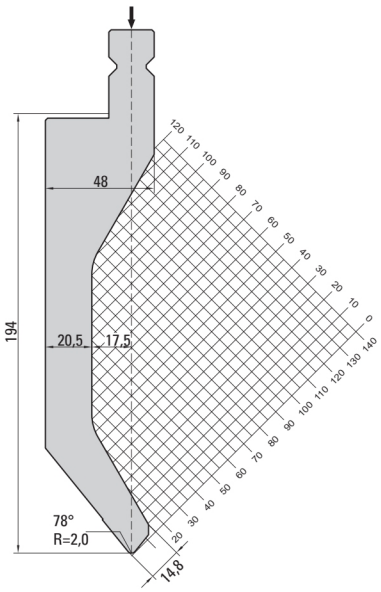


16.211 — 24h — 750 kN/m

Safety pins		
510 mm	23,0 kg	736,– €
Simple Clamp		
250 mm	11,4 kg	508,– €
550 mm sectionalized	22,6 kg	1.388,– €

SCAN TO SHOP



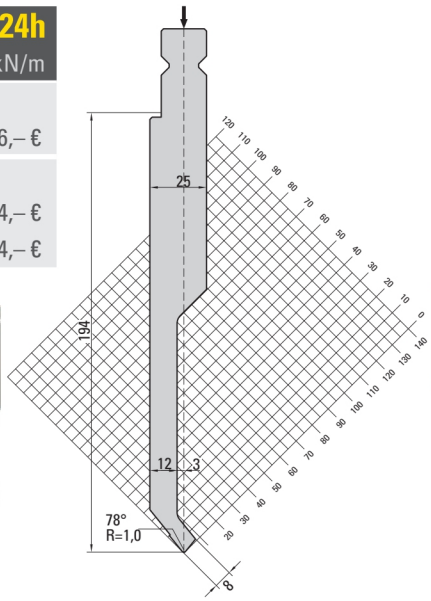


16.206 — 24h — 400 kN/m

Safety pins		
510 mm	14,7 kg	536,– €
Simple Clamp		
250 mm	7,4 kg	374,– €
550 mm sectionalized	14,4 kg	1.014,– €

SCAN TO SHOP





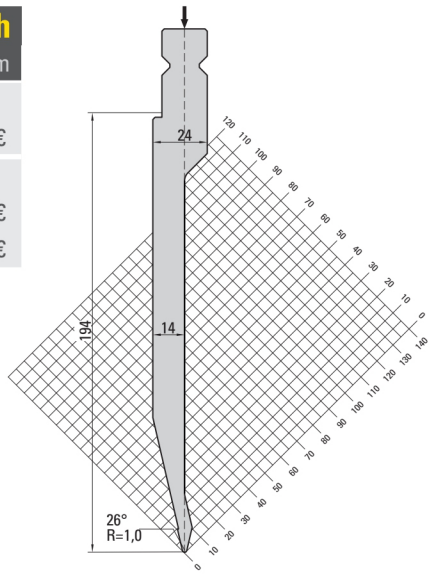
16.207 — 24h — 400 kN/m

Safety pins		
510 mm	13,1 kg	520,– €
Simple Clamp		
250 mm	6,5 kg	362,– €
550 mm sectionalized	12,9 kg	982,– €

SCAN TO SHOP



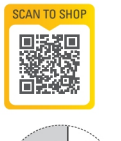


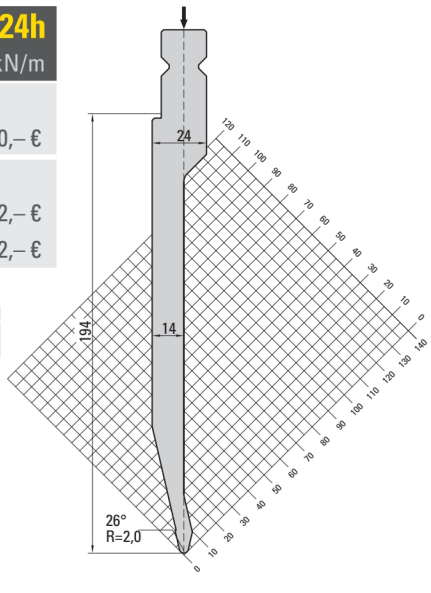


16.208 — 24h — 600 kN/m

Safety pins		
510 mm	13,4 kg	520,– €
Simple Clamp		
250 mm	6,7 kg	362,– €
550 mm sectionalized	13,1 kg	982,– €

SCAN TO SHOP





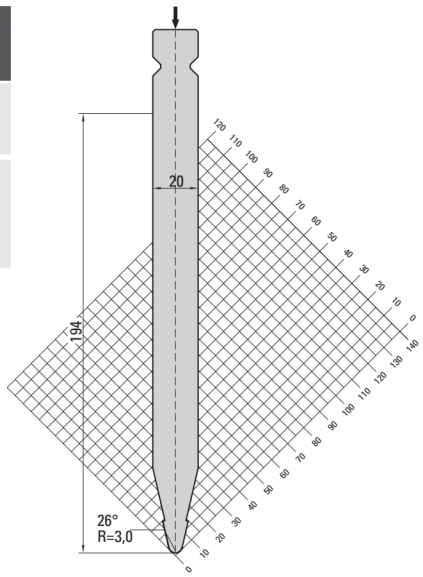
16.209 — 24h — 1200 kN/m

Safety pins		
510 mm	17,3 kg	480,– €
Simple Clamp		
250 mm	8,7 kg	332,– €
550 mm sectionalized	16,9 kg	906,– €

SCAN TO SHOP





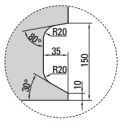


Punches/top tools LVD type II H = 180 mm

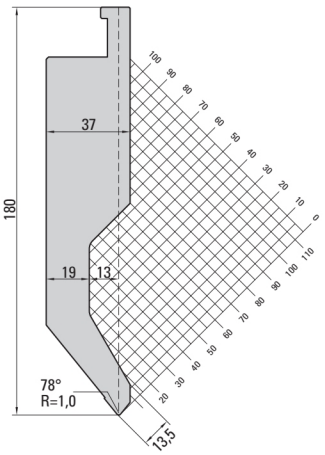
16.500 — 24h — 700 kN/m

510 mm	17,7 kg	426,– €
550 mm sectionalized	19,2 kg	702,– €

SCAN TO SHOP



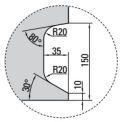




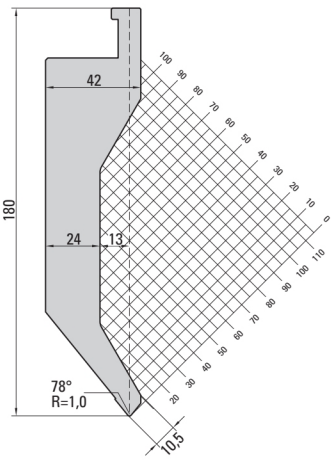
16.510 — 24h — 450 kN/m

510 mm	16,8 kg	454,– €
550 mm sectionalized	18,2 kg	736,– €

SCAN TO SHOP



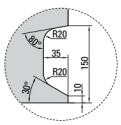




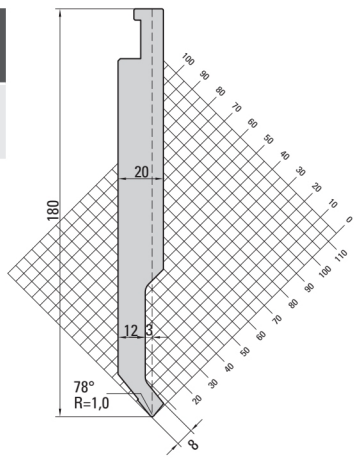
16.520 — 24h — 400 kN/m

510 mm	11,2 kg	332,– €
550 mm sectionalized	12,4 kg	596,– €

SCAN TO SHOP



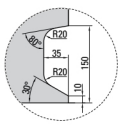




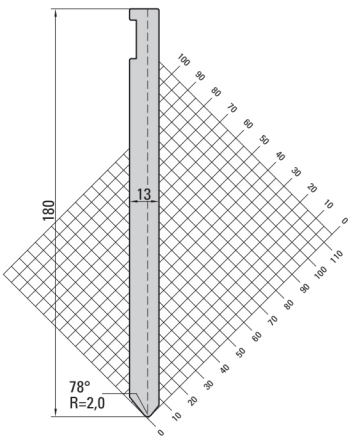
16.540 — 24h — 1000 kN/m

510 mm	9,1 kg	284,– €
550 mm sectionalized	9,8 kg	536,– €

SCAN TO SHOP



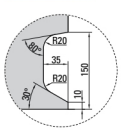




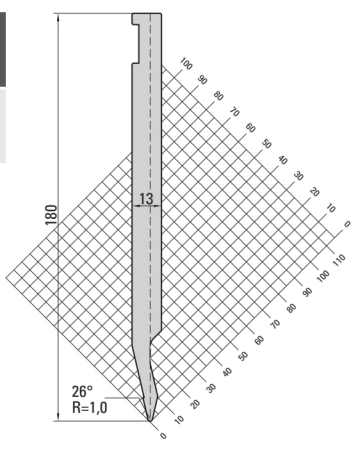
16.530 — 24h — 500 kN/m

510 mm	8,0 kg	308,– €
550 mm sectionalized	8,7 kg	562,– €

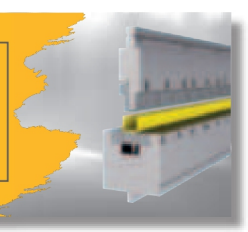
SCAN TO SHOP







UKB-SPECIAL TOOLS
CHAPTER 12



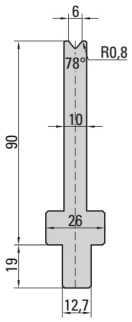
78° Dies H = 90 mm

26.211 — 24h — 280 kN/m

510 mm	5,4 kg	306,– €
250 mm	2,7 kg	180,– €
550 mm sectionalized	5,9 kg	552,– €

SCAN TO SHOP



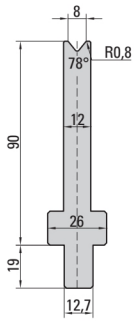


26.212 — 24h — 320 kN/m

510 mm	6,0 kg	306,– €
250 mm	3,0 kg	180,– €
550 mm sectionalized	6,5 kg	552,– €

SCAN TO SHOP



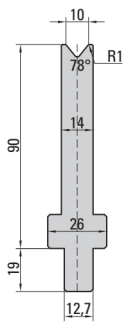


26.213 — 24h — 360 kN/m

510 mm	6,6 kg	306,– €
250 mm	3,3 kg	180,– €
550 mm sectionalized	7,1 kg	552,– €

SCAN TO SHOP



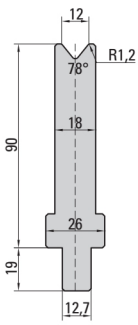


26.214 — 24h — 500 kN/m

510 mm	7,7 kg	306,– €
250 mm	3,8 kg	180,– €
550 mm sectionalized	8,3 kg	552,– €

SCAN TO SHOP



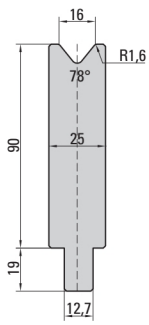


26.215 — 24h — 700 kN/m

510 mm	9,6 kg	312,– €
250 mm	4,8 kg	184,– €
550 mm sectionalized	10,4 kg	556,– €

SCAN TO SHOP



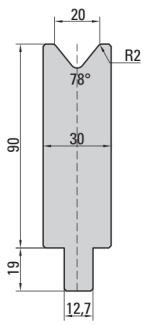


26.216 — 24h — 750 kN/m

510 mm	11,2 kg	316,– €
250 mm	5,6 kg	186,– €
550 mm sectionalized	12,1 kg	562,– €

SCAN TO SHOP



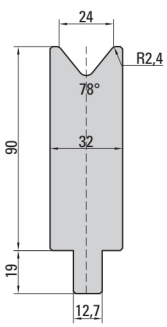


26.217 — 24h — 910 kN/m

510 mm	11,7 kg	328,– €
250 mm	5,9 kg	192,– €
550 mm sectionalized	12,7 kg	572,– €

SCAN TO SHOP



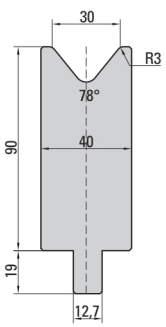


26.218 — 24h — 1150 kN/m

510 mm	14,2 kg	368,– €
250 mm	7,1 kg	216,– €
550 mm sectionalized	15,4 kg	612,– €

SCAN TO SHOP





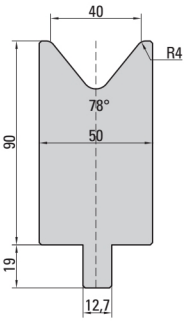
78° Dies H = 90 mm

26.219 — 24h — 1350 kN/m

510 mm	17,0 kg	398,– €
250 mm	8,5 kg	234,– €
550 mm sectionalized	18,4 kg	644,– €

SCAN TO SHOP

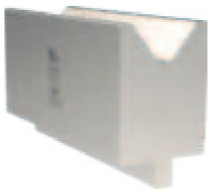


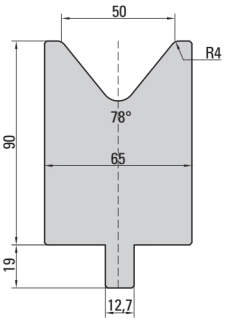


26.220 — 24h — 1800 kN/m

510 mm	21,4 kg	450,– €
250 mm	10,7 kg	266,– €
550 mm sectionalized	23,1 kg	694,– €

SCAN TO SHOP



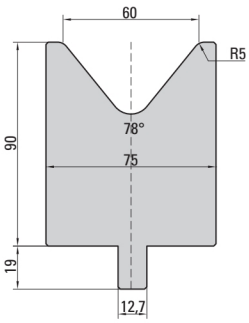


26.221 — 24h — 2000 kN/m

510 mm	23,6 kg	510,– €
250 mm	11,8 kg	300,– €
550 mm sectionalized	25,5 kg	796,– €

SCAN TO SHOP



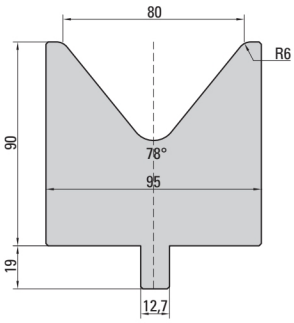


26.222 — 24h — 2300 kN/m

510 mm	27,4 kg	582,– €
250 mm	13,7 kg	342,– €
550 mm sectionalized	29,6 kg	962,– €

SCAN TO SHOP



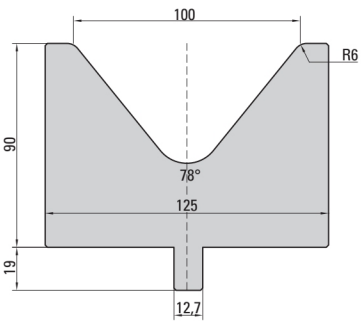


26.223 — 24h — 2500 kN/m

510 mm	34,1 kg	756,– €
250 mm	17,0 kg	444,– €
550 mm sectionalized	36,8 kg	1.350,– €

SCAN TO SHOP





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30° Dies H = 90 mm

26.200

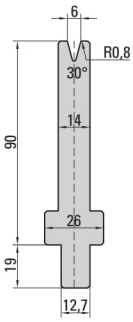
24h
250 kN/m

510 mm	6,6 kg	348,– €
250 mm	3,3 kg	202,– €
550 mm sectionalized	7,1 kg	592,– €

Max. load for 90° bending

SCAN TO SHOP





26.201

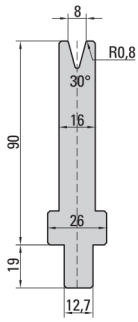
24h
260 kN/m

510 mm	7,1 kg	348,– €
250 mm	3,5 kg	202,– €
550 mm sectionalized	7,6 kg	592,– €

Max. load for 90° bending

SCAN TO SHOP





26.202

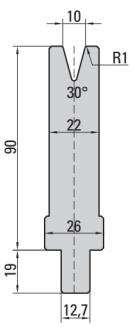
24h
360 kN/m

510 mm	8,7 kg	348,– €
250 mm	4,4 kg	202,– €
550 mm sectionalized	9,4 kg	592,– €

Max. load for 90° bending

SCAN TO SHOP





26.203

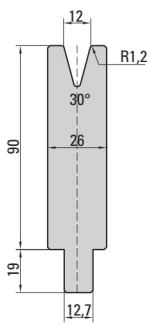
24h
460 kN/m

510 mm	9,8 kg	358,– €
250 mm	4,9 kg	210,– €
550 mm sectionalized	10,6 kg	604,– €

Max. load for 90° bending

SCAN TO SHOP





26.204

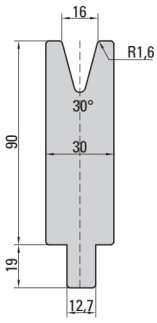
24h
510 kN/m

510 mm	10,8 kg	368,– €
250 mm	5,4 kg	216,– €
550 mm sectionalized	11,7 kg	612,– €

Max. load for 90° bending

SCAN TO SHOP





26.205

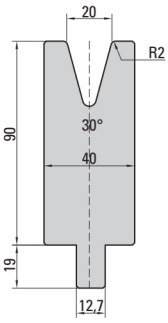
24h
680 kN/m

510 mm	13,9 kg	388,– €
250 mm	6,9 kg	228,– €
550 mm sectionalized	15,0 kg	644,– €

Max. load for 90° bending

SCAN TO SHOP





30° Dies H = 90 mm

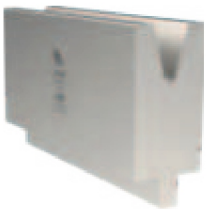
26.206

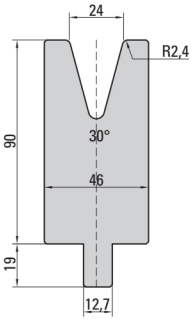
24h
930 kN/m

510 mm	15,6 kg	410,– €
250 mm	7,8 kg	240,– €
550 mm sectionalized	16,8 kg	664,– €

Max. load for 90° bending

SCAN TO SHOP





26.207

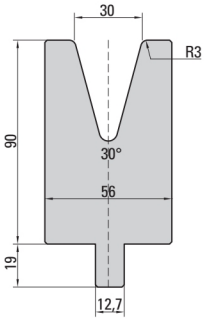
24h
1100 kN/m

510 mm	17,9 kg	592,– €
250 mm	8,9 kg	348,– €
550 mm sectionalized	19,3 kg	910,– €

Max. load for 90° bending

SCAN TO SHOP





26.208

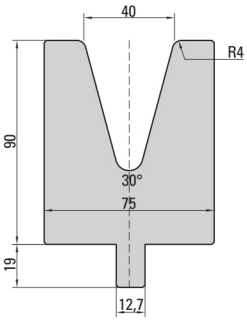
24h
1400 kN/m

510 mm	22,4 kg	654,– €
250 mm	11,2 kg	384,– €
550 mm sectionalized	24,1 kg	970,– €

Max. load for 90° bending

SCAN TO SHOP





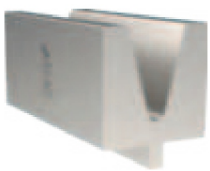
26.209

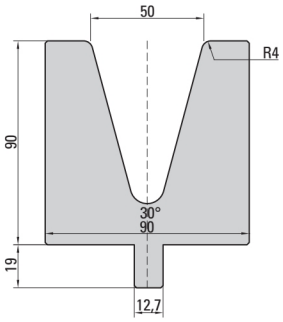
24h
1350 kN/m

510 mm	24,9 kg	726,– €
250 mm	12,5 kg	426,– €
550 mm sectionalized	26,9 kg	1.246,– €

Max. load for 90° bending

SCAN TO SHOP





78° Dies H = 130 mm

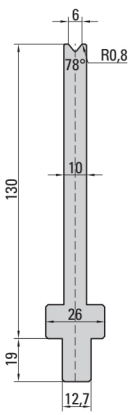
26.262

24h
280 kN/m

510 mm	7,0 kg	378,– €
250 mm	3,5 kg	220,– €
550 mm sectionalized	7,6 kg	644,– €

SCAN TO SHOP





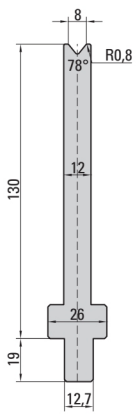
26.263

24h
320 kN/m

510 mm	7,9 kg	378,– €
250 mm	3,9 kg	218,– €
550 mm sectionalized	8,5 kg	644,– €

SCAN TO SHOP



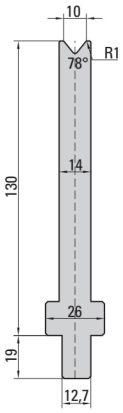


78° Dies H = 130 mm

26.264	24h 360 kN/m	
510 mm	8,8 kg	378,– €
250 mm	4,4 kg	218,– €
550 mm sectionalized	9,5 kg	644,– €

SCAN TO SHOP

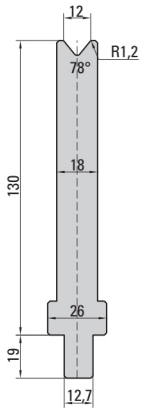




26.265	24h 500 kN/m	
510 mm	10,6 kg	388,– €
250 mm	5,3 kg	228,– €
550 mm sectionalized	11,4 kg	654,– €

SCAN TO SHOP

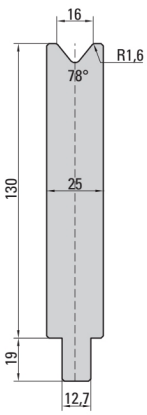




26.266	24h 700 kN/m	
510 mm	13,6 kg	398,– €
250 mm	6,8 kg	236,– €
550 mm sectionalized	14,7 kg	664,– €

SCAN TO SHOP

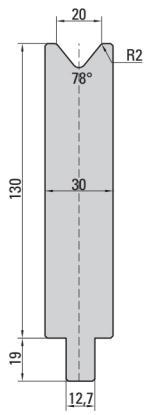




26.267	24h 750 kN/m	
510 mm	16,0 kg	410,– €
250 mm	8,0 kg	244,– €
550 mm sectionalized	17,3 kg	674,– €

SCAN TO SHOP

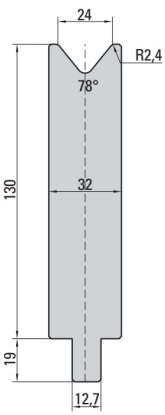




26.268	24h 910 kN/m	
510 mm	16,8 kg	418,– €
250 mm	8,4 kg	254,– €
550 mm sectionalized	18,2 kg	686,– €

SCAN TO SHOP

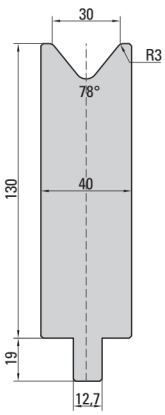




26.269	24h 1150 kN/m	
510 mm	20,7 kg	430,– €
250 mm	10,3 kg	260,– €
550 mm sectionalized	22,3 kg	694,– €

SCAN TO SHOP





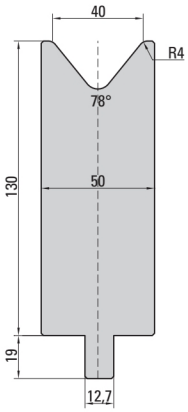
78° Dies H = 130 mm

26.270 — 24h — 1350 kN/m

510 mm	25,0 kg	480,– €
250 mm	12,5 kg	276,– €
550 mm sectionalized	27,0 kg	796,– €

SCAN TO SHOP



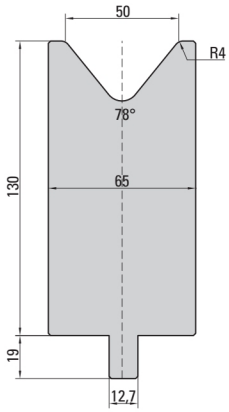


26.271 — 24h — 1800 kN/m

510 mm	31,8 kg	532,– €
250 mm	15,9 kg	302,– €
550 mm sectionalized	34,4 kg	920,– €

SCAN TO SHOP



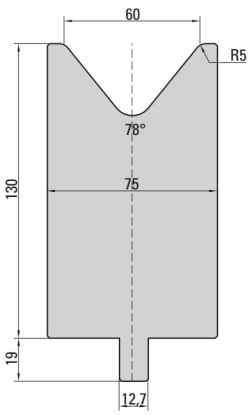


26.272 — 24h — 2000 kN/m

510 mm	35,7 kg	612,– €
250 mm	17,8 kg	356,– €
550 mm sectionalized	38,5 kg	1.094,– €

SCAN TO SHOP

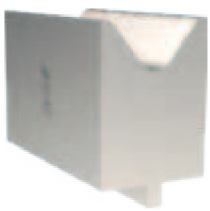


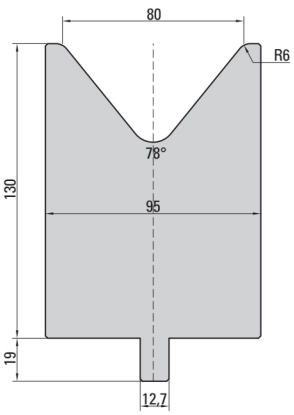


26.273 — 24h — 2300 kN/m

510 mm	42,5 kg	704,– €
250 mm	21,2 kg	402,– €
550 mm sectionalized	45,9 kg	1.254,– €

SCAN TO SHOP



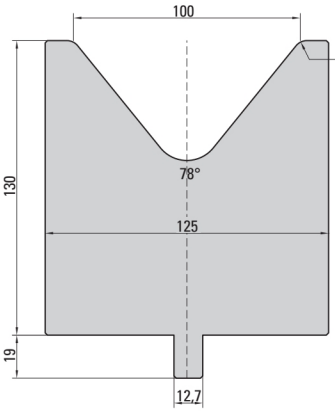


26.274 — 24h — 3400 kN/m

510 mm	53,9 kg	910,– €
250 mm	26,9 kg	524,– €
550 mm sectionalized	58,1 kg	1.488,– €

SCAN TO SHOP

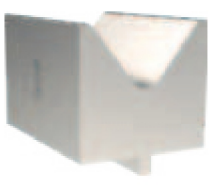


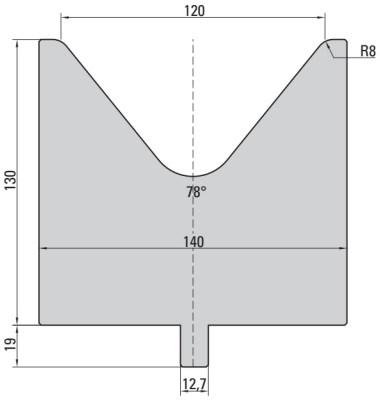


26.275 — 24h — 2700 kN/m

510 mm	56,3 kg	992,– €
250 mm	28,1 kg	572,– €
550 mm sectionalized	60,7 kg	1.594,– €

SCAN TO SHOP





30° Dies H = 130 mm

26.250

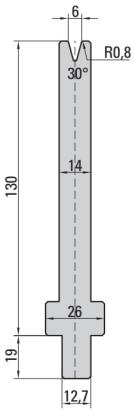
24h
250 kN/m

510 mm	8,8 kg	410,– €
250 mm	4,4 kg	240,– €
550 mm sectionalized	9,5 kg	716,– €

Max. load for 90° bending

SCAN TO SHOP





26.251

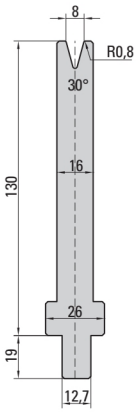
24h
260 kN/m

510 mm	9,6 kg	410,– €
250 mm	4,8 kg	240,– €
550 mm sectionalized	10,4 kg	716,– €

Max. load for 90° bending

SCAN TO SHOP





26.252

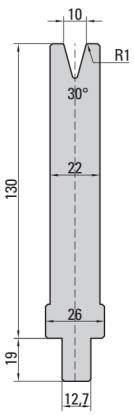
24h
360 kN/m

510 mm	12,3 kg	410,– €
250 mm	6,1 kg	240,– €
550 mm sectionalized	13,2 kg	716,– €

Max. load for 90° bending

SCAN TO SHOP







26.253

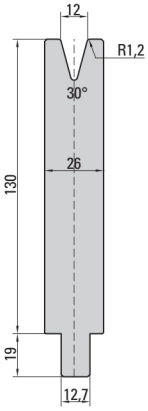
24h
460 kN/m

510 mm	13,9 kg	418,– €
250 mm	6,9 kg	246,– €
550 mm sectionalized	15,0 kg	724,– €

Max. load for 90° bending

SCAN TO SHOP





26.254

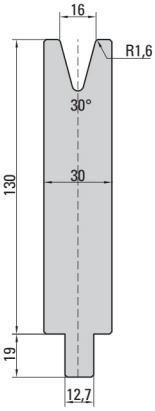
24h
510 kN/m

510 mm	15,6 kg	428,– €
250 mm	7,8 kg	250,– €
550 mm sectionalized	16,9 kg	736,– €

Max. load for 90° bending

SCAN TO SHOP





30° Dies H = 130 mm

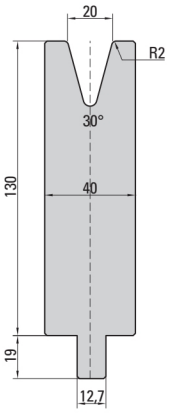
26.255 — 24h — 680 kN/m

510 mm	20,3 kg	440,– €
250 mm	10,1 kg	258,– €
550 mm sectionalized	21,9 kg	746,– €

Max. load for 90° bending

SCAN TO SHOP





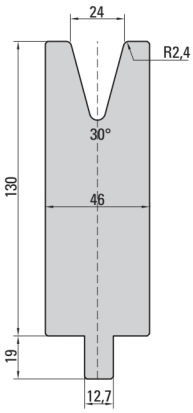
26.256 — 24h — 930 kN/m

510 mm	22,9 kg	480,– €
250 mm	11,4 kg	280,– €
550 mm sectionalized	24,7 kg	898,– €

Max. load for 90° bending

SCAN TO SHOP





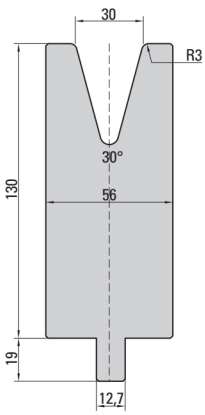
26.257 — 24h — 1100 kN/m

510 mm	26,9 kg	602,– €
250 mm	13,4 kg	354,– €
550 mm sectionalized	29,0 kg	1.074,– €

Max. load for 90° bending

SCAN TO SHOP





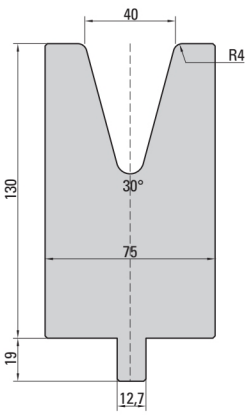
26.258 — 24h — 1400 kN/m

510 mm	34,4 kg	644,– €
250 mm	17,2 kg	368,– €
550 mm sectionalized	37,1 kg	1.144,– €

Max. load for 90° bending

SCAN TO SHOP





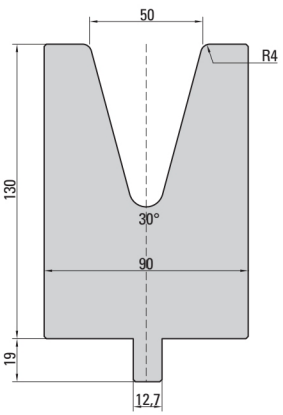
26.259 — 24h — 1700 kN/m

510 mm	39,3 kg	858,– €
250 mm	19,6 kg	500,– €
550 mm sectionalized	42,4 kg	1.460,– €

Max. load for 90° bending

SCAN TO SHOP



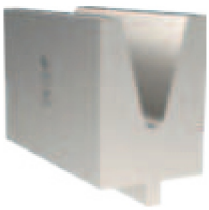


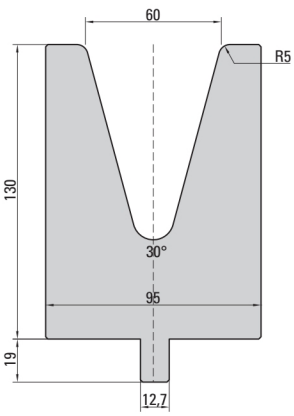
26.260 — 24h — 1550 kN/m

510 mm	37,5 kg	992,– €
250 mm	18,7 kg	554,– €
550 mm sectionalized	40,5 kg	1.624,– €

Max. load for 90° bending

SCAN TO SHOP





Flattening punches/top tools

16.808 — 24h — 400 kN/m

Safety pins

510 mm	15,4 kg	646,– €

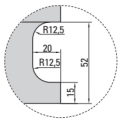
Simple Clamp

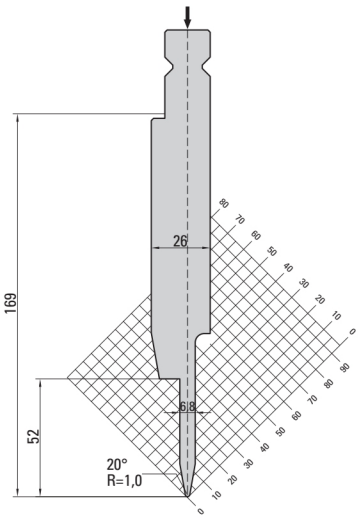
250 mm	7,8 kg	416,– €
550 mm sectionalized	15,5 kg	1.730,– €

1000 kN/m for flattening

SCAN TO SHOP







16.908 — 24h — 400 kN/m

Safety pins

510 mm	20,2 kg	738,– €

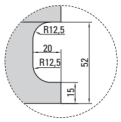
Simple Clamp

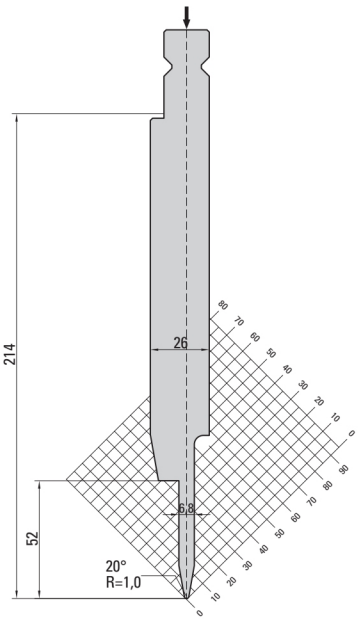
250 mm	10,1 kg	466,– €
550 mm sectionalized	20,0 kg	1.896,– €

1000 kN/m for flattening

SCAN TO SHOP







16.810 — 24h — 400 kN/m

Safety pins

510 mm	16,0 kg	646,– €

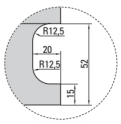
Simple Clamp

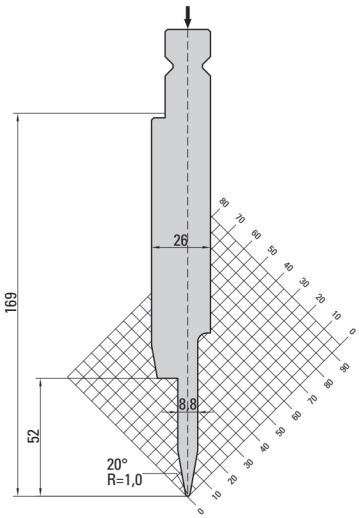
250 mm	8,0 kg	416,– €
550 mm sectionalized	15,9 kg	1.730,– €

1000 kN/m for flattening

SCAN TO SHOP







16.910 — 24h — 400 kN/m

Safety pins

510 mm	20,7 kg	738,– €

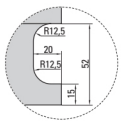
Simple Clamp

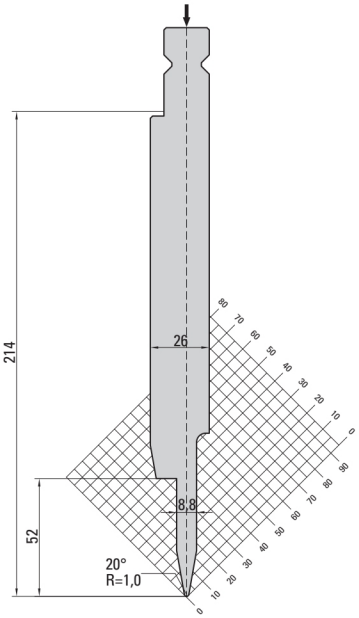
250 mm	10,4 kg	466,– €
550 mm sectionalized	20,4 kg	1.896,– €

1000 kN/m for flattening

SCAN TO SHOP







16.812 — 24h — 400 kN/m

Safety pins

510 mm	17,1 kg	646,– €

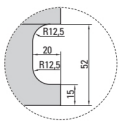
Simple Clamp

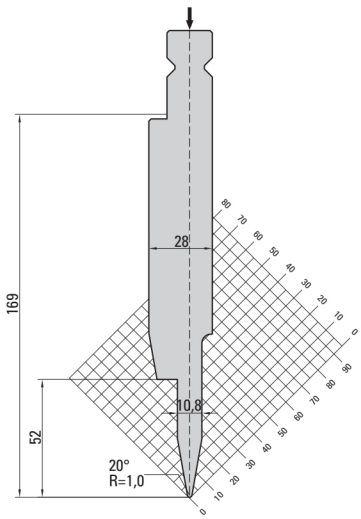
250 mm	8,5 kg	416,– €
550 mm sectionalized	16,9 kg	1.730,– €

1000 kN/m for flattening

SCAN TO SHOP







16.912 — 24h — 400 kN/m

Safety pins

510 mm	22,2 kg	738,– €

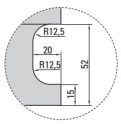
Simple Clamp

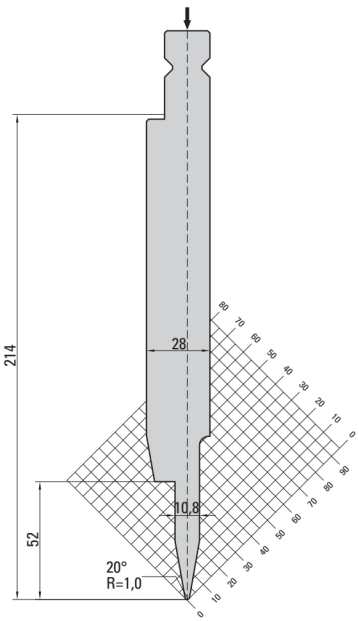
250 mm	11,1 kg	466,– €
550 mm sectionalized	21,9 kg	1.896,– €

1000 kN/m for flattening

SCAN TO SHOP







Flattening dies

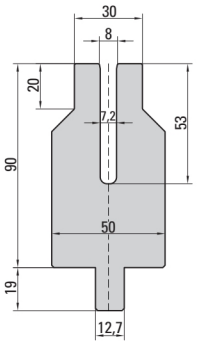
26.808 — 24h — 360 kN/m

510 mm	15,4 kg	510,– €
250 mm	7,7 kg	280,– €
550 mm sectionalized	16,7 kg	798,– €

1000 kN/m for flattening

SCAN TO SHOP





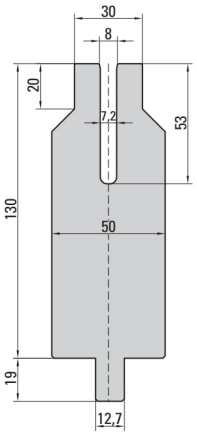
26.908 — 24h — 360 kN/m

510 mm	23,5 kg	588,– €
250 mm	11,7 kg	308,– €
550 mm sectionalized	25,3 kg	948,– €

1000 kN/m for flattening

SCAN TO SHOP





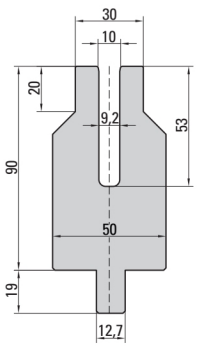
26.810 — 24h — 300 kN/m

510 mm	15,0 kg	510,– €
250 mm	7,5 kg	280,– €
550 mm sectionalized	16,2 kg	798,– €

1000 kN/m for flattening

SCAN TO SHOP





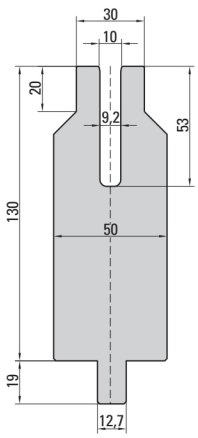
26.910 — 24h — 300 kN/m

510 mm	23,0 kg	588,– €
250 mm	11,5 kg	308,– €
550 mm sectionalized	24,8 kg	948,– €

1000 kN/m for flattening

SCAN TO SHOP





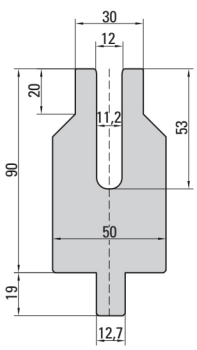
26.812 — 24h — 210 kN/m

510 mm	14,6 kg	510,– €
250 mm	7,3 kg	280,– €
550 mm sectionalized	15,8 kg	798,– €

1000 kN/m for flattening

SCAN TO SHOP





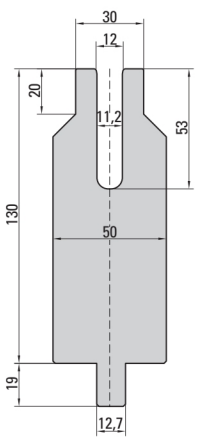
26.912 — 24h — 210 kN/m

510 mm	22,6 kg	588,– €
250 mm	11,3 kg	308,– €
550 mm sectionalized	24,4 kg	948,– €

1000 kN/m for flattening

SCAN TO SHOP





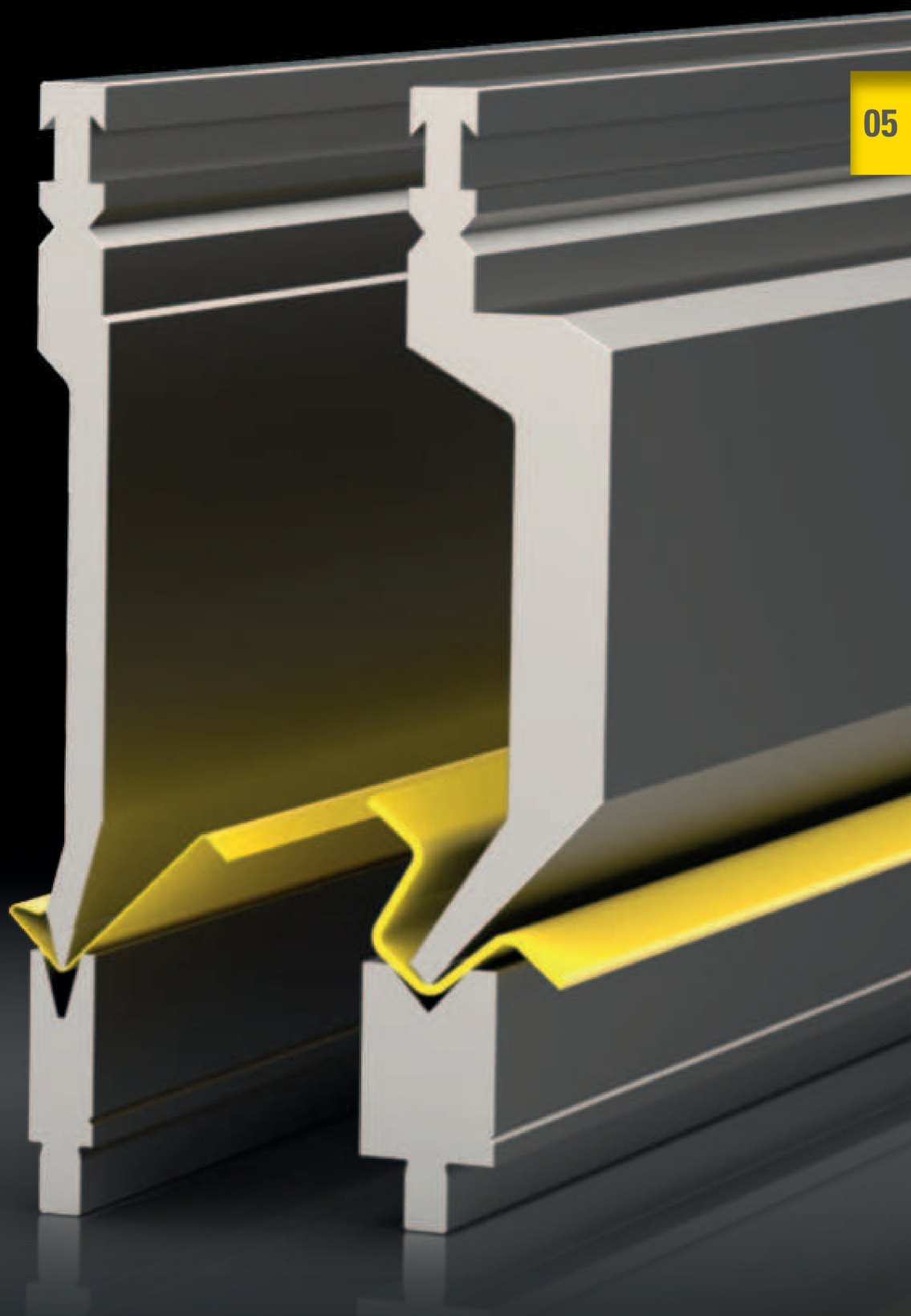
PRESS BRAKE TOOLS
UKB-SYSTEM BYSTRONIC

Explanation 146-147

Punches/top tools
Punches/top tools H = 175 mm 148-149
Punches/top tools H = 250 mm 149-151
Punch/top tool distance piece 151

Dies
85° Dies H = 55 mm 152-153
60° Dies H = 55 mm 154
60° Die H = 65 mm 154
30° Dies H = 55 mm 155-156
30° Die H = 60 mm 156
Flattening punches/top tools and flattening dies 156-157



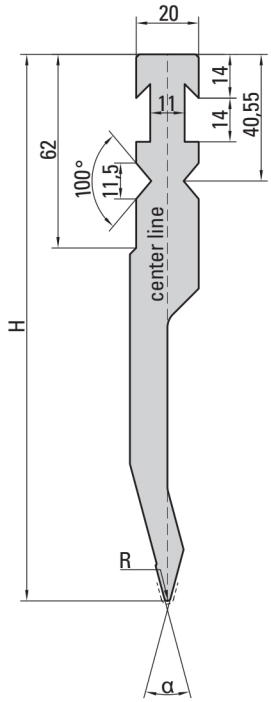


05

WWW.UKB-GMBH.COM

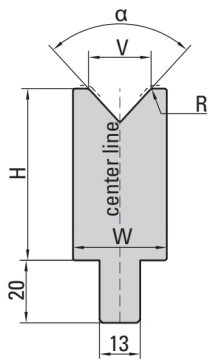
Quality and precision

- **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



VIDEO

UKB-Press brake tool systems



UKB-ADVANTAGES

VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **Delivery time:** Press brake tools UKB-System Bystronic in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

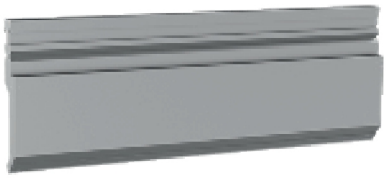
Standard:	1 - 3 working days by parcel service or forwarder
Express:	According agreement
Direktkurier:	According agreement

- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

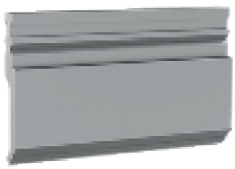
Tool lengths

PUNCHES/TOP TOOLS

515 mm



300 mm



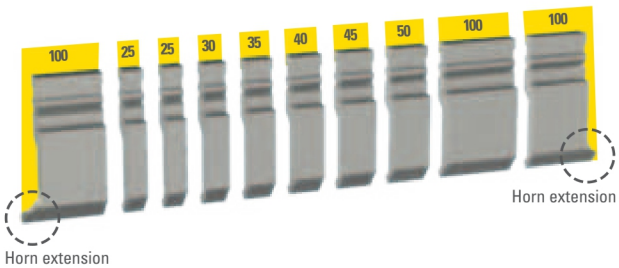
200 mm



100 mm



550 mm sectionalized



▸ 10 Segments, with horn extension left and right

DIES

515 mm



300 mm



200 mm



100 mm

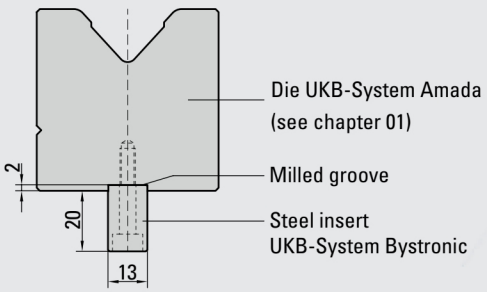


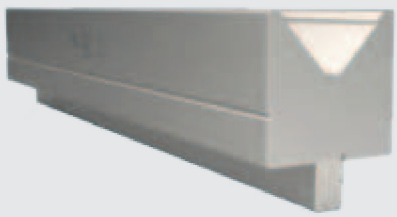
550 mm sectionalized



▸ 9 Segments

MODIFICATION OF DIES UKB-SYSTEM AMADA





VIDEO

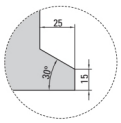
UKB-Modification of Press Brake Tools

Punches/top tools H = 175 mm

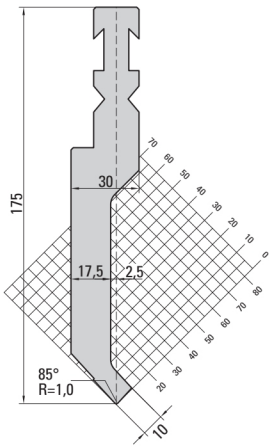
14.150 — 24h — 1300 kN/m

515 mm	12,6 kg	502,– €
300 mm	7,4 kg	320,– €
200 mm	4,9 kg	234,– €
100 mm	2,5 kg	130,– €
550 mm sectionalized	12,4 kg	966,– €

SCAN TO SHOP



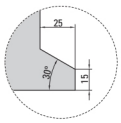




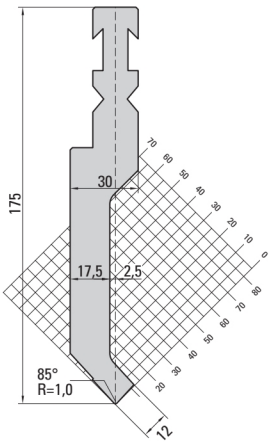
14.151 — 24h — 1300 kN/m

515 mm	12,8 kg	502,– €
300 mm	7,4 kg	320,– €
200 mm	5,0 kg	234,– €
100 mm	2,5 kg	130,– €
550 mm sectionalized	12,6 kg	966,– €

SCAN TO SHOP



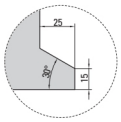




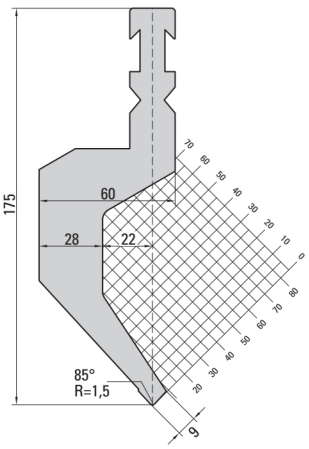
14.152 — 24h — 600 kN/m

515 mm	17,1 kg	766,– €
300 mm	10,0 kg	492,– €
200 mm	6,6 kg	360,– €
100 mm	3,2 kg	198,– €
550 mm sectionalized	16,8 kg	1.280,– €

SCAN TO SHOP



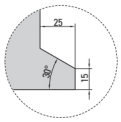




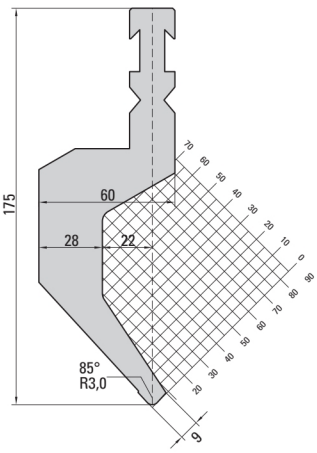
14.166 — 24h — 600 kN/m

515 mm	16,8 kg	766,– €
300 mm	9,8 kg	492,– €
200 mm	6,5 kg	360,– €
100 mm	3,3 kg	198,– €
550 mm sectionalized	16,5 kg	1.280,– €

SCAN TO SHOP



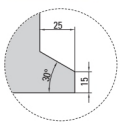




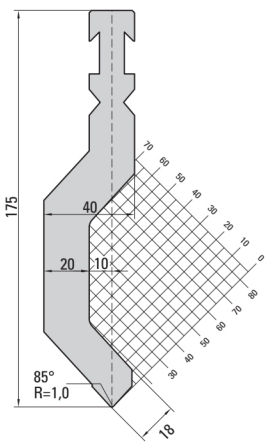
14.156 — 24h — 1000 kN/m

515 mm	13,7 kg	710,– €
300 mm	8,0 kg	456,– €
200 mm	5,3 kg	334,– €
100 mm	2,7 kg	186,– €
550 mm sectionalized	13,5 kg	1.212,– €

SCAN TO SHOP



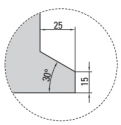




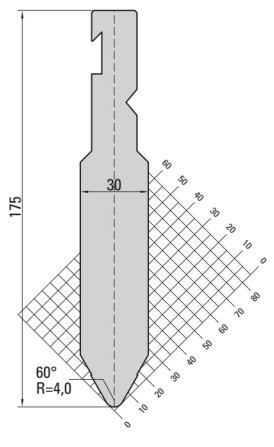
14.157 — 24h — 1600 kN/m

515 mm	17,2 kg	490,– €
300 mm	10,0 kg	314,– €
200 mm	6,7 kg	230,– €
100 mm	3,3 kg	128,– €
550 mm sectionalized	16,8 kg	912,– €

SCAN TO SHOP





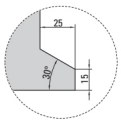


Punches/top tools H = 175 mm

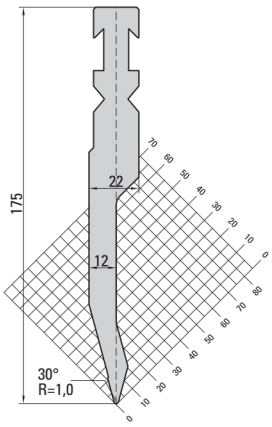
14.153 — 24h — 1000 kN/m

515 mm	9,7 kg	524,– €
300 mm	5,7 kg	334,– €
200 mm	3,8 kg	246,– €
100 mm	1,9 kg	136,– €
550 mm sectionalized	9,6 kg	990,– €

SCAN TO SHOP



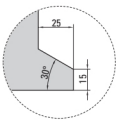




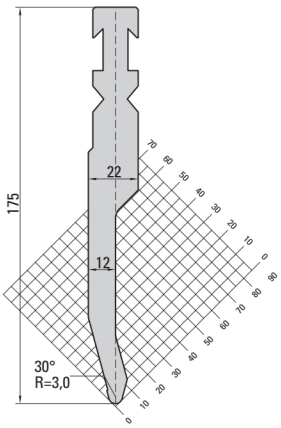
14.167 — 24h — 1000 kN/m

515 mm	10,2 kg	524,– €
300 mm	5,9 kg	334,– €
200 mm	4,0 kg	246,– €
100 mm	2,0 kg	136,– €
550 mm sectionalized	9,9 kg	990,– €

SCAN TO SHOP



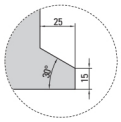




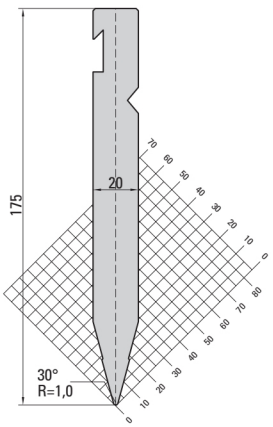
14.154 — 24h — 1500 kN/m

515 mm	12,4 kg	422,– €
300 mm	7,2 kg	270,– €
200 mm	4,8 kg	198,– €
100 mm	2,4 kg	110,– €
550 mm sectionalized	12,2 kg	844,– €

SCAN TO SHOP



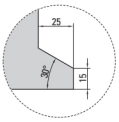




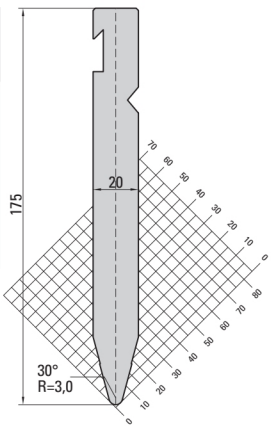
14.155 — 24h — 1600 kN/m

515 mm	12,8 kg	422,– €
300 mm	7,5 kg	270,– €
200 mm	5,0 kg	198,– €
100 mm	2,5 kg	110,– €
550 mm sectionalized	12,6 kg	844,– €

SCAN TO SHOP





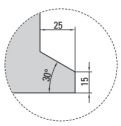


Punches/top tools H = 250 mm

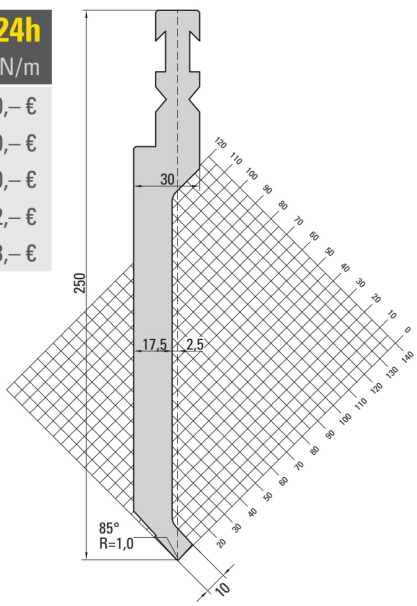
14.158 — 24h — 1000 kN/m

515 mm	18,0 kg	700,– €
300 mm	10,5 kg	450,– €
200 mm	7,0 kg	330,– €
100 mm	3,5 kg	182,– €
550 mm sectionalized	17,7 kg	1.268,– €

SCAN TO SHOP



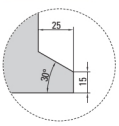




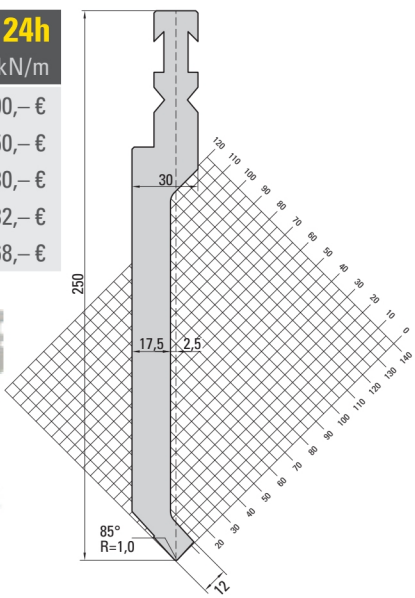
14.159 — 24h — 1400 kN/m

515 mm	18,1 kg	700,– €
300 mm	10,5 kg	450,– €
200 mm	7,0 kg	330,– €
100 mm	3,5 kg	182,– €
550 mm sectionalized	17,8 kg	1.268,– €

SCAN TO SHOP





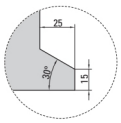


Punches/top tools H = 250 mm

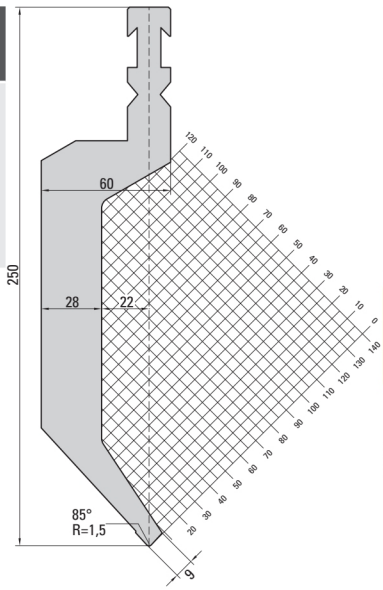
14.160 — 24h — 600 kN/m

515 mm	25,6 kg	1.088,– €
300 mm	14,9 kg	698,– €
200 mm	10,0 kg	512,– €
100 mm	5,0 kg	282,– €
550 mm sectionalized	25,1 kg	1.700,– €

SCAN TO SHOP



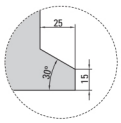




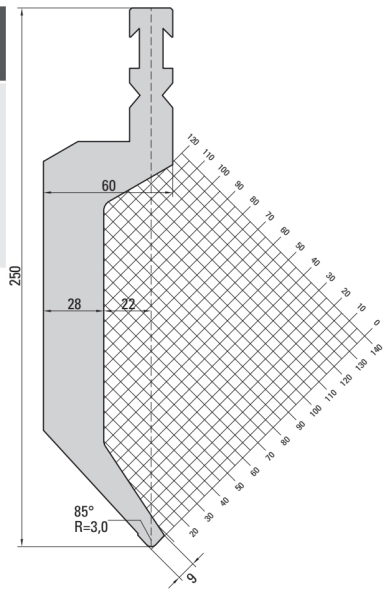
14.168 — 24h — 600 kN/m

515 mm	25,3 kg	1.088,– €
300 mm	14,7 kg	698,– €
200 mm	9,8 kg	512,– €
100 mm	4,9 kg	282,– €
550 mm sectionalized	24,9 kg	1.700,– €

SCAN TO SHOP



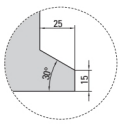




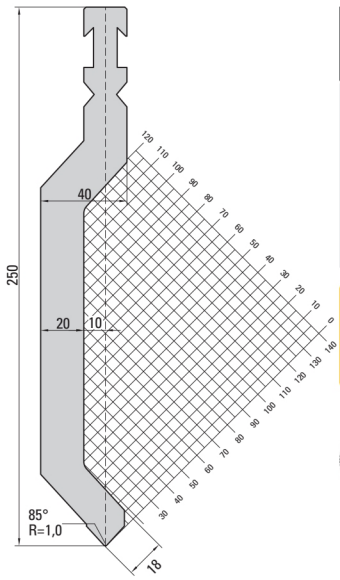
14.164 — 24h — 1000 kN/m

515 mm	19,7 kg	1.034,– €
300 mm	11,5 kg	664,– €
200 mm	7,6 kg	486,– €
100 mm	3,8 kg	268,– €
550 mm sectionalized	19,5 kg	1.588,– €

SCAN TO SHOP



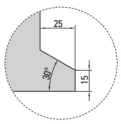




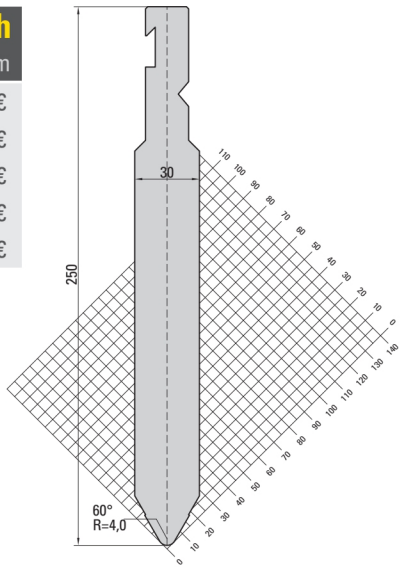
14.165 — 24h — 1600 kN/m

515 mm	26,3 kg	688,– €
300 mm	15,1 kg	442,– €
200 mm	10,2 kg	324,– €
100 mm	5,1 kg	178,– €
550 mm sectionalized	25,8 kg	1.222,– €

SCAN TO SHOP







UKB-FIELD SERVICE

- Individual advice and sale
- Test bending in your house or at the UKB-Test Center
- Tool demonstrations
- Pick up service for tools to rework

CHAPTER 19

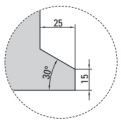


Punches/top tools H = 250 mm

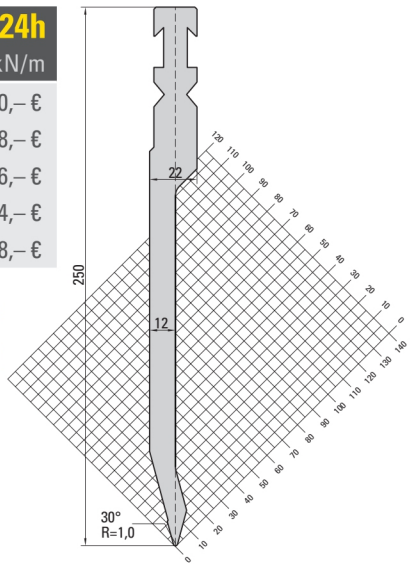
14.161 — 24h — 750 kN/m

515 mm	13,4 kg	590,– €
300 mm	7,8 kg	378,– €
200 mm	5,2 kg	276,– €
100 mm	2,6 kg	154,– €
550 mm sectionalized	13,1 kg	1.068,– €

SCAN TO SHOP



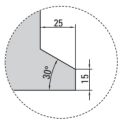




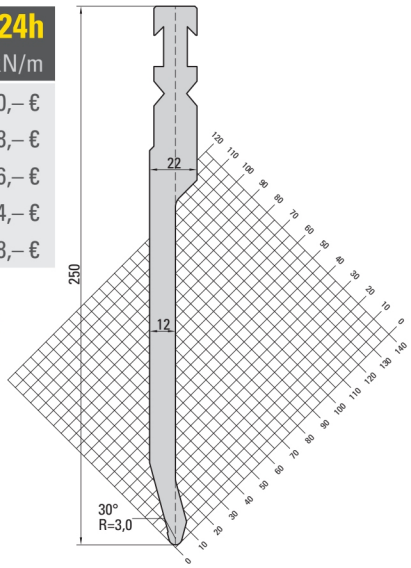
14.169 — 24h — 1000 kN/m

515 mm	13,8 kg	590,– €
300 mm	8,1 kg	378,– €
200 mm	5,4 kg	276,– €
100 mm	2,7 kg	154,– €
550 mm sectionalized	13,6 kg	1.068,– €

SCAN TO SHOP



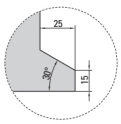




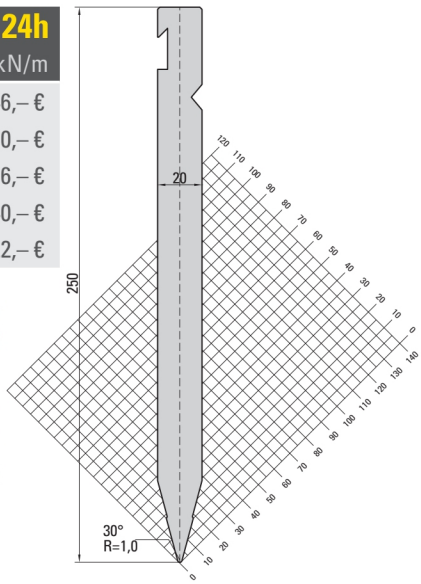
14.162 — 24h — 1400 kN/m

515 mm	18,5 kg	546,– €
300 mm	10,8 kg	350,– €
200 mm	7,2 kg	256,– €
100 mm	3,6 kg	140,– €
550 mm sectionalized	18,1 kg	1.022,– €

SCAN TO SHOP



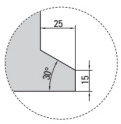




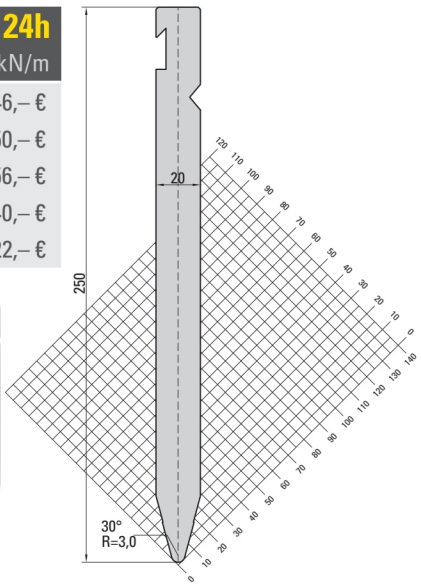
14.163 — 24h — 1400 kN/m

515 mm	18,9 kg	546,– €
300 mm	11,0 kg	350,– €
200 mm	7,4 kg	256,– €
100 mm	3,7 kg	140,– €
550 mm sectionalized	18,5 kg	1.022,– €

SCAN TO SHOP







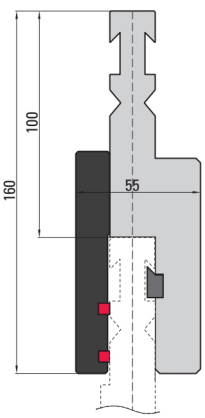
Punch/top tool distance piece

50.400 — 24h — 1000 kN/m

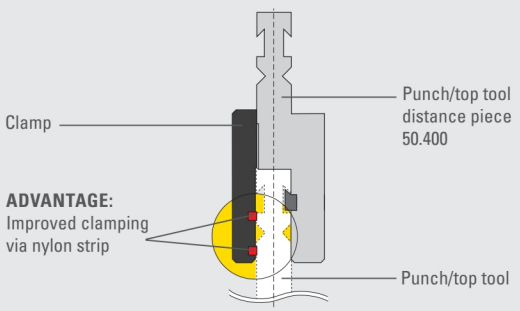
150 mm	6,2 kg	332,– €

SCAN TO SHOP





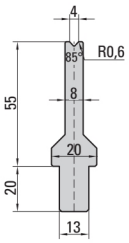
EXAMPLE OF USE



85° Dies H = 55 mm

24.100 — 24h — 300 kN/m

515 mm	3,5 kg	230,– €
300 mm	2,1 kg	158,– €
200 mm	1,4 kg	108,– €
100 mm	0,7 kg	62,– €
550 mm sectionalized	3,8 kg	436,– €

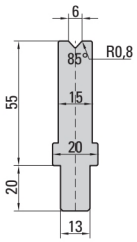


SCAN TO SHOP



24.101 — 24h — 700 kN/m

515 mm	4,5 kg	218,– €
300 mm	2,7 kg	150,– €
200 mm	1,8 kg	104,– €
100 mm	0,9 kg	54,– €
550 mm sectionalized	5,0 kg	424,– €

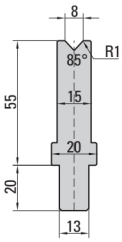


SCAN TO SHOP



24.102 — 24h — 700 kN/m

515 mm	4,5 kg	218,– €
300 mm	2,7 kg	150,– €
200 mm	1,8 kg	104,– €
100 mm	0,9 kg	54,– €
550 mm sectionalized	5,0 kg	424,– €

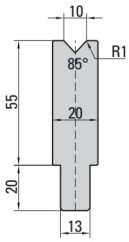


SCAN TO SHOP



24.104 — 24h — 1000 kN/m

515 mm	5,5 kg	158,– €
300 mm	3,3 kg	118,– €
200 mm	2,2 kg	82,– €
100 mm	1,1 kg	46,– €
550 mm sectionalized	6,1 kg	338,– €

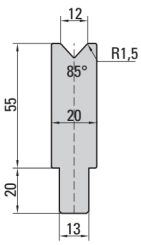


SCAN TO SHOP



24.106 — 24h — 1000 kN/m

515 mm	5,5 kg	158,– €
300 mm	3,3 kg	118,– €
200 mm	2,2 kg	82,– €
100 mm	1,1 kg	46,– €
550 mm sectionalized	6,1 kg	338,– €

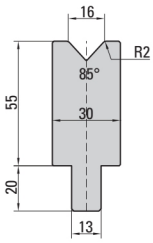


SCAN TO SHOP



24.108 — 24h — 1000 kN/m

515 mm	7,5 kg	174,– €
300 mm	4,5 kg	126,– €
200 mm	3,0 kg	88,– €
100 mm	1,5 kg	50,– €
550 mm sectionalized	8,3 kg	362,– €



SCAN TO SHOP

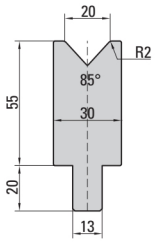


85° Dies H = 55 mm

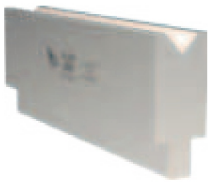
24.109

24h
1000 kN/m

515 mm	7,7 kg	182,– €
300 mm	4,5 kg	130,– €
200 mm	3,0 kg	92,– €
100 mm	1,5 kg	50,– €
550 mm sectionalized	8,3 kg	368,– €



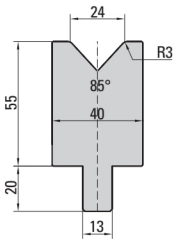
SCAN TO SHOP



24.110

24h
1000 kN/m

515 mm	9,5 kg	206,– €
300 mm	5,7 kg	146,– €
200 mm	3,8 kg	110,– €
100 mm	1,9 kg	74,– €
550 mm sectionalized	10,5 kg	424,– €



SCAN TO SHOP

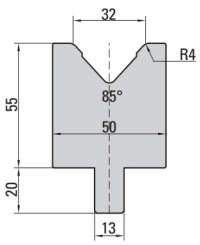


24.011

24h
1000 kN/m

515 mm	10,8 kg	240,– €
300 mm	6,3 kg	174,– €
200 mm	4,2 kg	118,– €
100 mm	2,1 kg	66,– €
550 mm sectionalized	11,5 kg	472,– €

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



SCAN TO SHOP

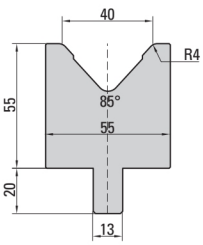


24.012

24h
1000 kN/m

515 mm	11,1 kg	258,– €
300 mm	6,6 kg	186,– €
200 mm	4,4 kg	126,– €
100 mm	2,2 kg	72,– €
550 mm sectionalized	12,1 kg	500,– €

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



SCAN TO SHOP



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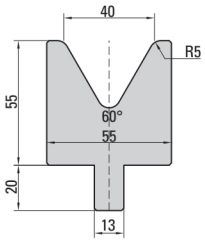
TOOL DXF´S
ONLINE CATALOGUE
VIDEO CHANNEL
ONLINE SHOP
LIVE-CHAT

60° Dies H = 55 mm

24.040		24h 800 kN/m
515 mm	10,5 kg	360,– €
300 mm	6,1 kg	232,– €
200 mm	4,1 kg	168,– €
100 mm	2,0 kg	96,– €
550 mm sectionalized	11,2 kg	516,– €

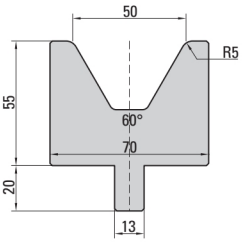


SCAN TO SHOP



24.050		24h 1000 kN/m
515 mm	12,6 kg	400,– €
300 mm	7,3 kg	264,– €
200 mm	4,9 kg	188,– €
100 mm	2,4 kg	116,– €
550 mm sectionalized	13,4 kg	590,– €

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

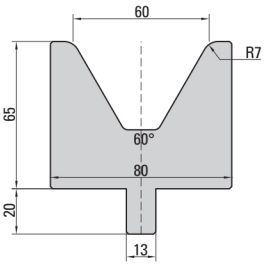


SCAN TO SHOP



60° Die H = 65 mm

24.060		24h 1000 kN/m
515 mm	16,1 kg	442,– €
300 mm	9,4 kg	316,– €
200 mm	6,3 kg	220,– €
100 mm	3,1 kg	136,– €
550 mm sectionalized	17,2 kg	746,– €



SCAN TO SHOP



UKB-INFO

Dies with larger V-openings see pages 86 - 87!

UKB-REPAIR- AND REGRINDING SERVICE

- For press brake tools, machine tables, slide rails, shear blades and other workpieces
- Grind, harden, blast, polish and re-mark
- We repair chipping or deformations as needed
- According agreement within 1 working day

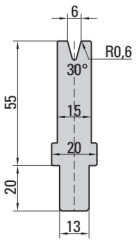
CHAPTER 19



30° Dies H = 55 mm

24.013 — 24h — 350 kN/m

515 mm	4,1 kg	226,– €
300 mm	2,4 kg	168,– €
200 mm	1,6 kg	114,– €
100 mm	0,8 kg	60,– €
550 mm sectionalized	4,4 kg	388,– €

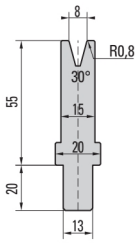


SCAN TO SHOP



24.014 — 24h — 350 kN/m

515 mm	4,0 kg	226,– €
300 mm	2,4 kg	168,– €
200 mm	1,6 kg	114,– €
100 mm	0,8 kg	60,– €
550 mm sectionalized	4,4 kg	388,– €

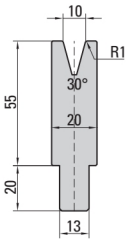


SCAN TO SHOP



24.015 — 24h — 500 kN/m

515 mm	5,0 kg	220,– €
300 mm	3,0 kg	160,– €
200 mm	2,0 kg	108,– €
100 mm	1,0 kg	58,– €
550 mm sectionalized	5,5 kg	382,– €

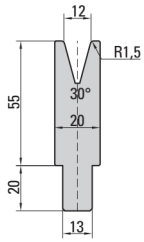


SCAN TO SHOP



24.016 — 24h — 400 kN/m

515 mm	5,0 kg	220,– €
300 mm	3,0 kg	160,– €
200 mm	2,0 kg	108,– €
100 mm	1,0 kg	58,– €
550 mm sectionalized	5,5 kg	382,– €

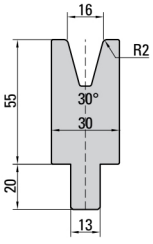


SCAN TO SHOP



24.017 — 24h — 450 kN/m

515 mm	7,0 kg	242,– €
300 mm	4,2 kg	180,– €
200 mm	2,8 kg	126,– €
100 mm	1,4 kg	74,– €
550 mm sectionalized	7,7 kg	410,– €

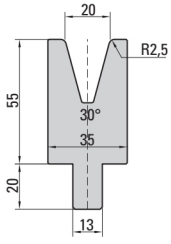


SCAN TO SHOP



24.019 — 24h — 500 kN/m

515 mm	7,0 kg	240,– €
300 mm	4,2 kg	174,– €
200 mm	2,8 kg	118,– €
100 mm	1,4 kg	66,– €
550 mm sectionalized	7,7 kg	430,– €



SCAN TO SHOP

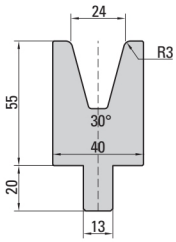


30° Die H = 55 mm

24.018		24h 500 kN/m
515 mm	7,8 kg	274,– €
300 mm	4,8 kg	212,– €
200 mm	3,2 kg	148,– €
100 mm	1,6 kg	90,– €
550 mm sectionalized	8,8 kg	464,– €

SCAN TO SHOP





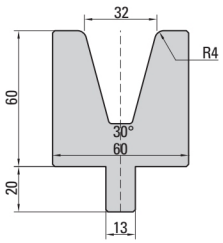


30° Die H = 60 mm

24.035		24h 500 kN/m
515 mm	11,8 kg	354,– €
300 mm	6,9 kg	258,– €
200 mm	4,6 kg	174,– €
100 mm	2,3 kg	92,– €
550 mm sectionalized	12,7 kg	634,– €

SCAN TO SHOP



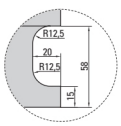




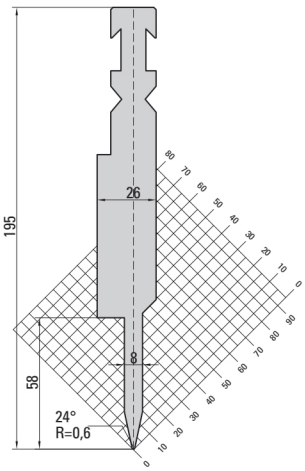
Flattening punches/top tools and flattening dies

14.908		24h 800 kN/m
500 mm	13,1 kg	584,– €
300 mm	7,9 kg	420,– €
200 mm	5,3 kg	282,– €
100 mm	2,6 kg	142,– €
550 mm sectionalized	14,3 kg	1.134,– €

SCAN TO SHOP





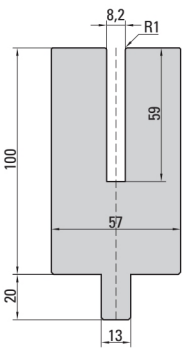


25.992		24h 500 kN/m
500 mm	21,5 kg	494,– €
300 mm	12,9 kg	362,– €
200 mm	8,6 kg	258,– €
100 mm	4,3 kg	154,– €
550 mm sectionalized	23,6 kg	844,– €

Max. 1,2 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP



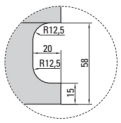


Flattening punches/top tools and flattening dies

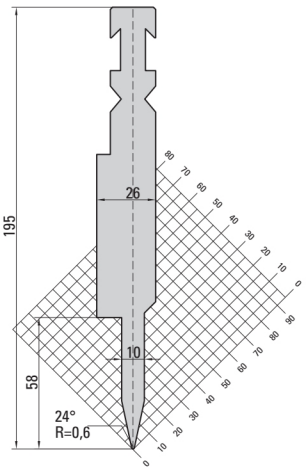
14.910 — 24h — 800 kN/m

500 mm	13,5 kg	584,– €
300 mm	8,1 kg	420,– €
200 mm	5,4 kg	282,– €
100 mm	2,7 kg	142,– €
550 mm sectionalized	14,8 kg	1.134,– €

SCAN TO SHOP







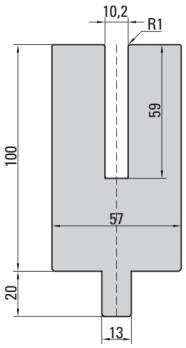
25.994 — 24h — 500 kN/m

500 mm	21,0 kg	494,– €
300 mm	12,6 kg	362,– €
200 mm	8,4 kg	258,– €
100 mm	4,2 kg	154,– €
550 mm sectionalized	23,1 kg	844,– €

Max. 1,8 mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP

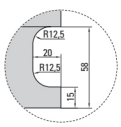




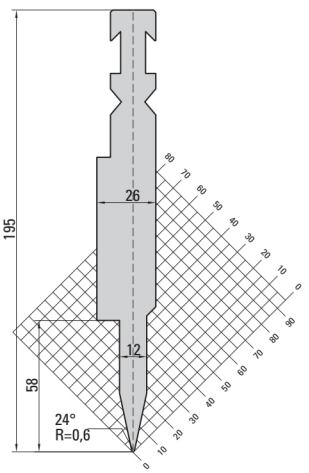
14.912 — 24h — 800 kN/m

500 mm	13,8 kg	584,– €
300 mm	8,3 kg	420,– €
200 mm	5,5 kg	282,– €
100 mm	2,8 kg	142,– €
550 mm sectionalized	15,1 kg	1.134,– €

SCAN TO SHOP







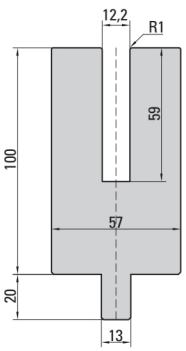
25.995 — 24h — 500 kN/m

500 mm	20,5 kg	494,– €
300 mm	12,3 kg	362,– €
200 mm	8,2 kg	258,– €
100 mm	4,1 kg	154,– €
550 mm sectionalized	22,6 kg	844,– €

Max. 2,5mm material thickness
R_m = 400 N/mm²
800 kN/m for flattening

SCAN TO SHOP





EXAMPLE OF USE

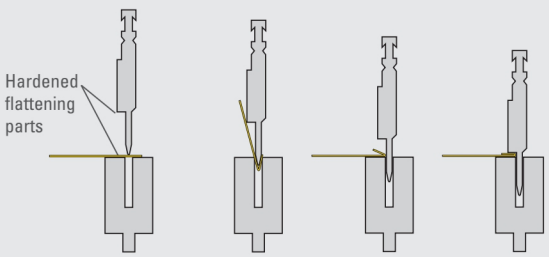
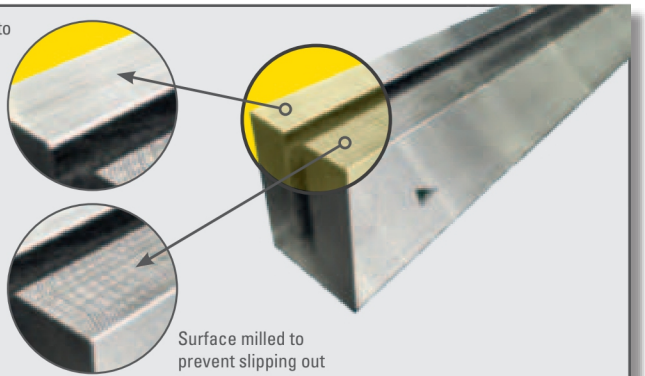


Table of force for flattening see page 101



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

UKB-System EHT

Explanation 160-161
86° Punch/top tool H = 220 mm 162
78° Punches/top tools H = 220 mm 162
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UKB-System Weinbrenner

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Punches/top tools 170
Holder for blades with changeable blade 170
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Other Systems

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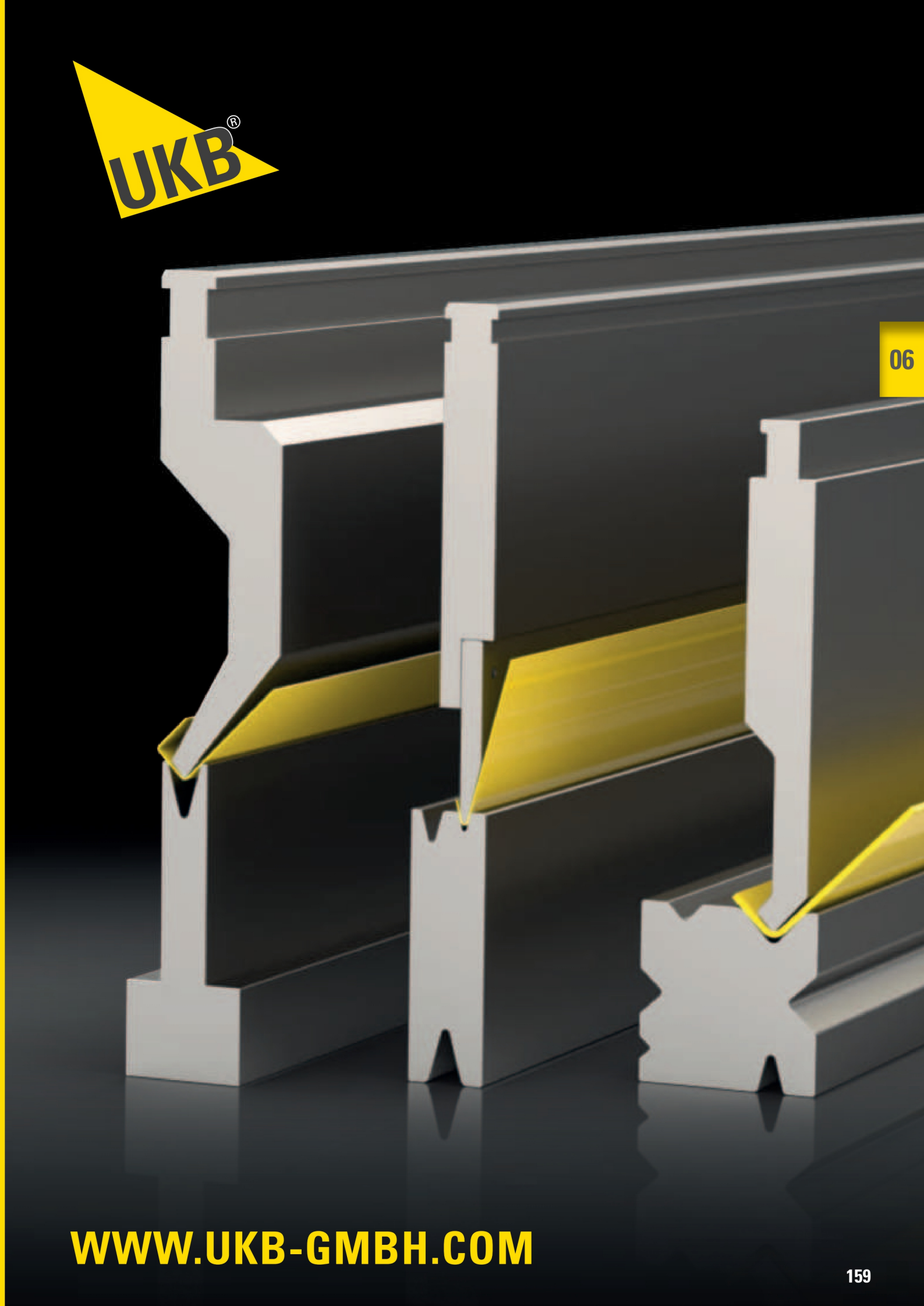
Examples punch/top tool clampings 172
Examples die clampings 172
Examples punches/top tools 173
Examples dies 173




UKB®
06
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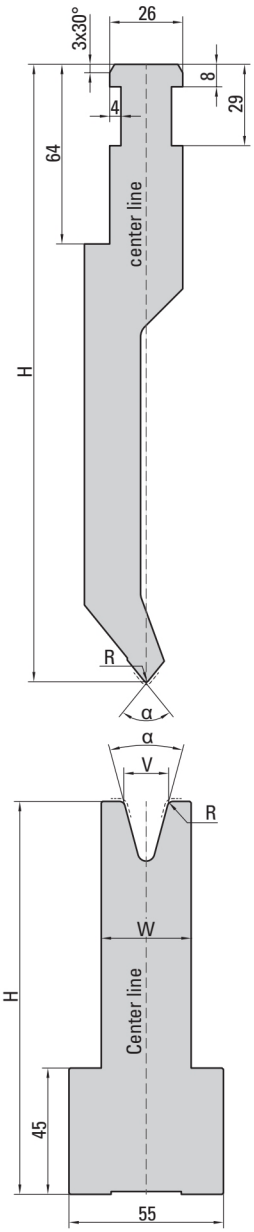
SYSTEM EHT

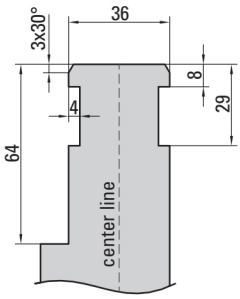
Quality and precision

- **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

26 mm clamping



36 mm clamping



UKB-INFO

All punches/top tools and dies are produced according to your individual specifications!

Contact us!

VIDEO

UKB-Press brake tool systems

UKB-ADVANTAGES

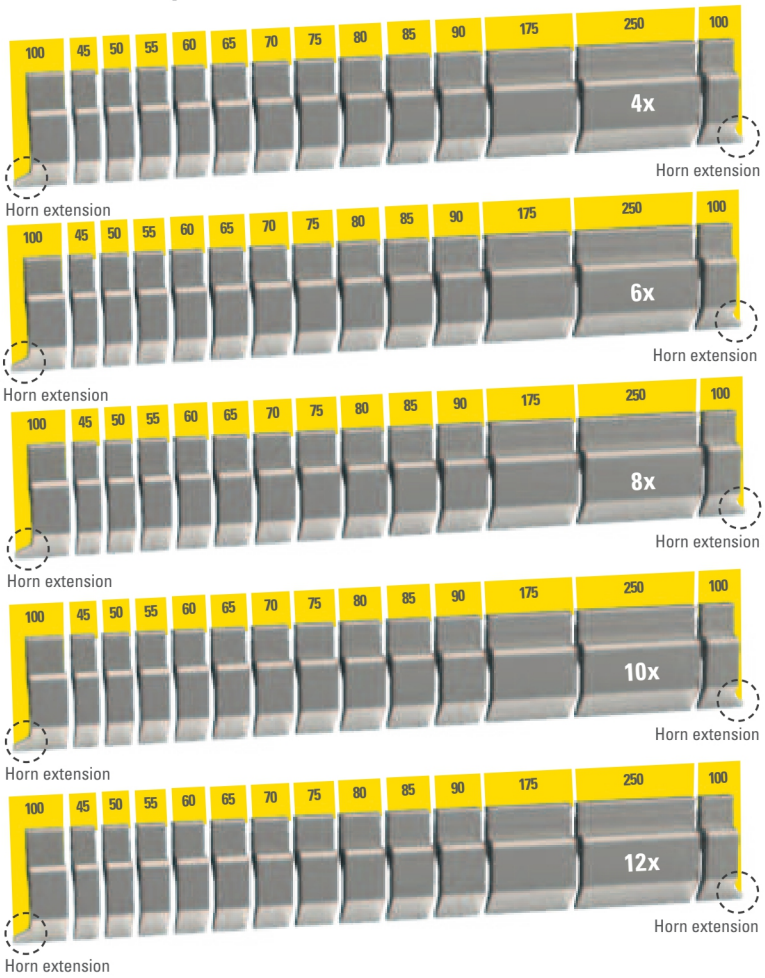
VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:** 14 days 2% cash-discount, 30 days net

Tool length

PUNCHES/TOP TOOLS



2050 mm
- 17 Segments, with horn extension left and right

2550 mm
- 19 Segments, with horn extension left and right

3050 mm
- 21 Segments, with horn extension left and right

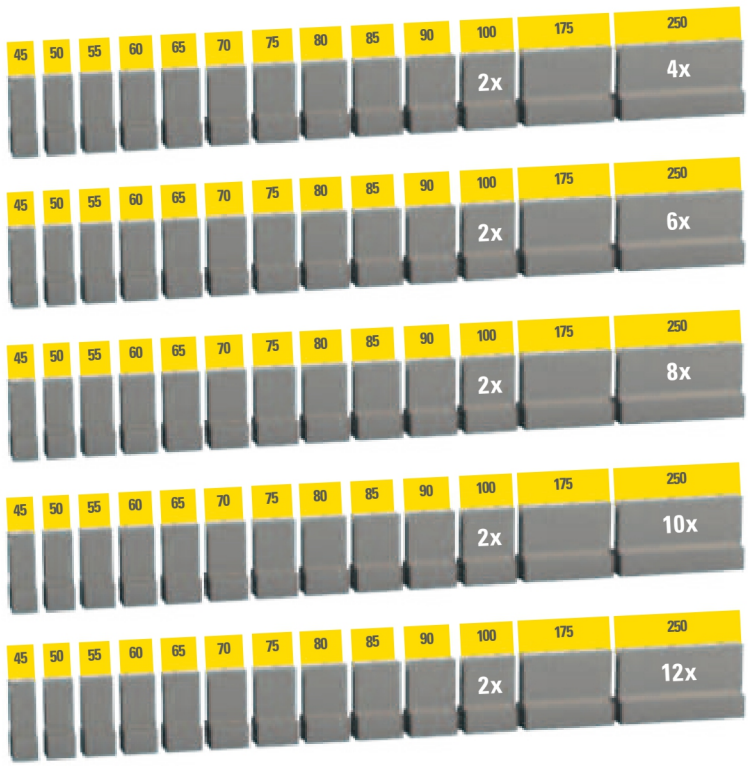
3550 mm
- 23 Segments, with horn extension left and right

4050 mm
- 25 Segments, with horn extension left and right

UKB-INFO

Configure your required lengths individually to match your specifications!

DIES



2050 mm
- 17 Segments

2550 mm
- 19 Segments

3050 mm
- 21 Segments

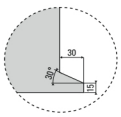
3550 mm
- 23 Segments

4050 mm
- 25 Segments

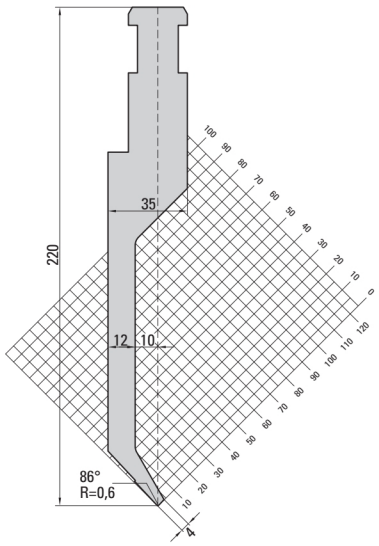
86° Punch/top tool H = 220 mm

17.100	200 kN/m
2050 mm Tool set	3.330,– €
2550 mm Tool set	4.010,– €
3050 mm Tool set	4.700,– €
3550 mm Tool set	5.390,– €
4050 mm Tool set	6.080,– €

SCAN TO SHOP



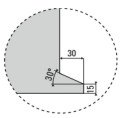




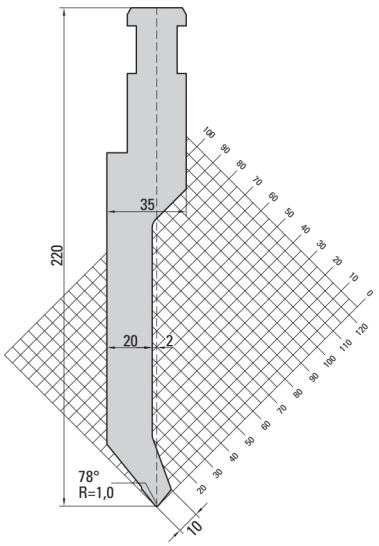
78° Punches/top tools H = 220 mm

17.110	1100 kN/m
2050 mm Tool set	3.140,– €
2550 mm Tool set	3.780,– €
3050 mm Tool set	4.430,– €
3550 mm Tool set	5.070,– €
4050 mm Tool set	5.710,– €

SCAN TO SHOP

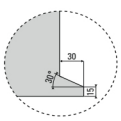




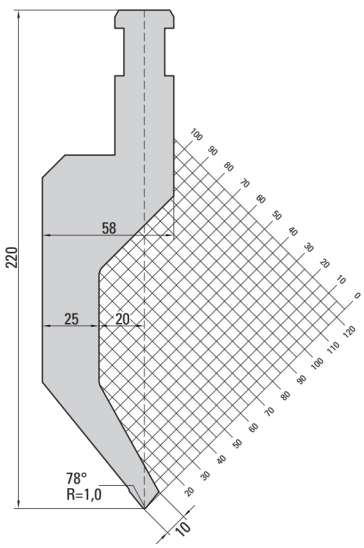


17.120	550 kN/m
2050 mm Tool set	4.120,– €
2550 mm Tool set	5.000,– €
3050 mm Tool set	5.880,– €
3550 mm Tool set	6.760,– €
4050 mm Tool set	7.530,– €

SCAN TO SHOP



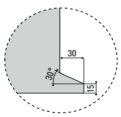




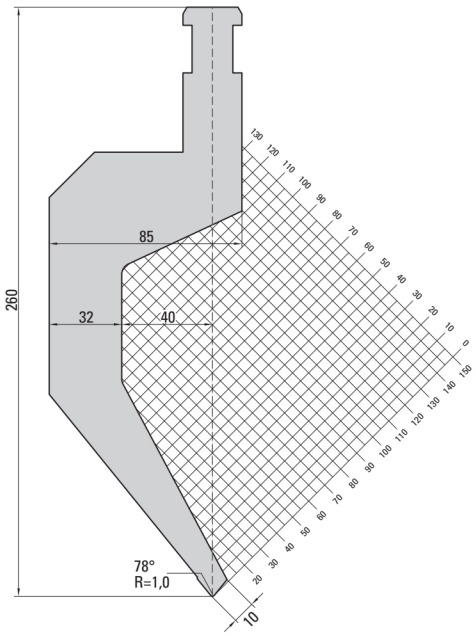
78° Punch/top tool H = 260 mm

17.130	480 kN/m
2050 mm Tool set	5.470,– €
2550 mm Tool set	6.650,– €
3050 mm Tool set	7.830,– €
3550 mm Tool set	9.010,– €
4050 mm Tool set	10.910,– €

SCAN TO SHOP



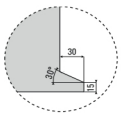




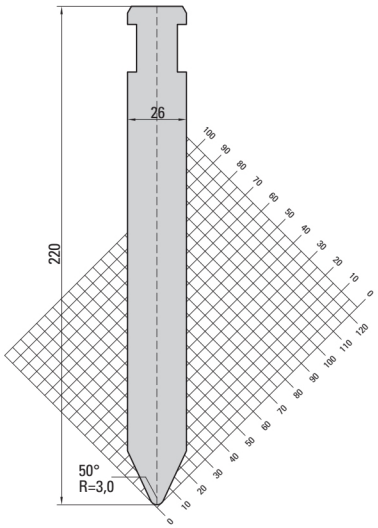
50° Punch/top tool H = 220 mm

17.180	3000 kN/m
2050 mm Tool set	2.600,– €
2550 mm Tool set	3.120,– €
3050 mm Tool set	3.640,– €
3550 mm Tool set	4.160,– €
4050 mm Tool set	4.680,– €

SCAN TO SHOP



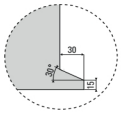




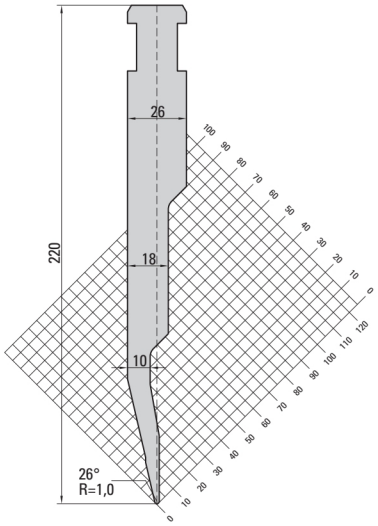
26° Punch/top tool H = 220 mm

17.140	440 kN/m
2050 mm Tool set	3.130,– €
2550 mm Tool set	3.780,– €
3050 mm Tool set	4.430,– €
3550 mm Tool set	5.080,– €
4050 mm Tool set	5.730,– €

SCAN TO SHOP







Dies H = 140 mm

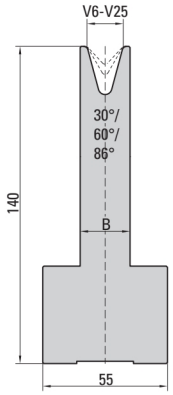
27.010

2050 mm Tool set	2.990,– €
2550 mm Tool set	3.640,– €
3050 mm Tool set	4.280,– €
3550 mm Tool set	4.930,– €
4050 mm Tool set	5.580,– €

Available in V6 to V25
with 30°/60°/86°

SCAN TO SHOP



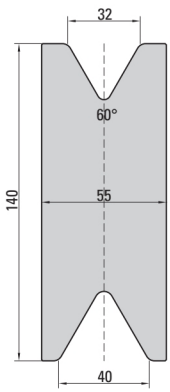


27.040 800 kN/m

2050 mm Tool set	2.990,– €
2550 mm Tool set	3.640,– €
3050 mm Tool set	4.280,– €
3550 mm Tool set	4.930,– €
4050 mm Tool set	5.580,– €

SCAN TO SHOP



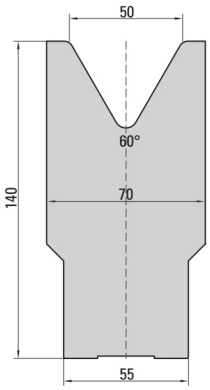


27.050 1100 kN/m

2050 mm Tool set	2.930,– €
2550 mm Tool set	3.560,– €
3050 mm Tool set	4.200,– €
3550 mm Tool set	4.830,– €
4050 mm Tool set	5.460,– €

SCAN TO SHOP





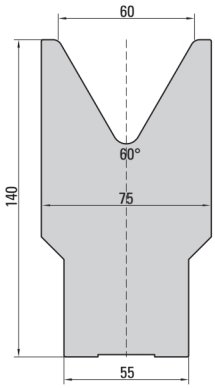
Dies H = 140 mm

27.060 — 1300 kN/m

2050 mm Tool set	3.160,– €
2550 mm Tool set	3.840,– €
3050 mm Tool set	4.530,– €
3550 mm Tool set	5.220,– €
4050 mm Tool set	5.910,– €

SCAN TO SHOP



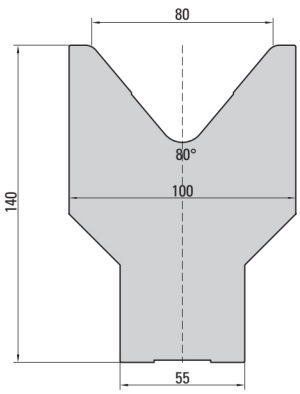


27.030 — 2000 kN/m

2050 mm Tool set	3.830,– €
2550 mm Tool set	4.670,– €
3050 mm Tool set	5.510,– €
3550 mm Tool set	6.250,– €
4050 mm Tool set	7.070,– €

SCAN TO SHOP



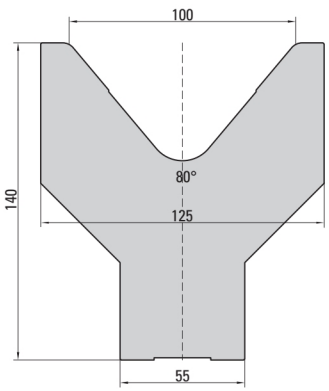


27.035 — 2000 kN/m

2050 mm Tool set	4.840,– €
2550 mm Tool set	5.910,– €
3050 mm Tool set	6.870,– €
3550 mm Tool set	7.920,– €
4050 mm Tool set	8.970,– €

SCAN TO SHOP



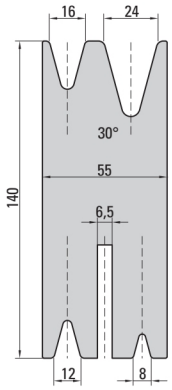


Die H = 140 mm

27.070	400 kN/m
2050 mm Tool set	3.340,– €
2550 mm Tool set	4.080,– €
3050 mm Tool set	4.810,– €
3550 mm Tool set	5.550,– €
4050 mm Tool set	6.280,– €

SCAN TO SHOP

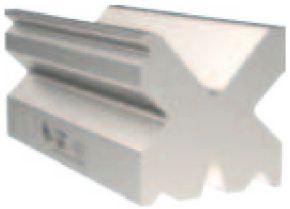


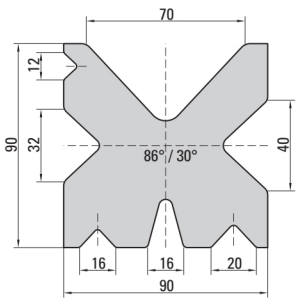


Dies H = 90 mm

27.080	
2050 mm Tool set	4.610,– €
2550 mm Tool set	5.670,– €
3050 mm Tool set	6.720,– €
3550 mm Tool set	7.780,– €
4050 mm Tool set	8.840,– €

SCAN TO SHOP

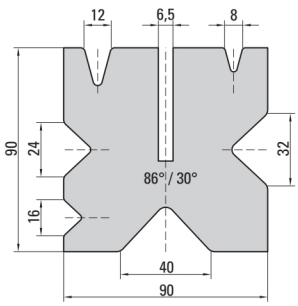




27.090	
2050 mm Tool set	4.510,– €
2550 mm Tool set	5.540,– €
3050 mm Tool set	6.580,– €
3550 mm Tool set	7.620,– €
4050 mm Tool set	8.650,– €

SCAN TO SHOP





Holders for blades with changeable blades

Product advantages

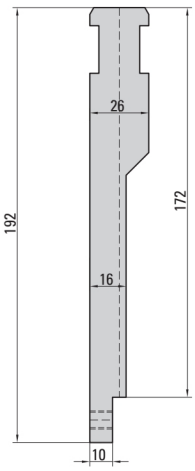
- **Cost saving:** One holder for different blades
- **Flexible application:** Thanks to changeable blades
- **Efficient blade change:** Quick and easy
- **Hardened flattening part:** Increased service life

Holders for blades

17.150	600 kN/m
2050 mm Tool set	2.380,– €
2550 mm Tool set	2.880,– €
3050 mm Tool set	3.380,– €
3550 mm Tool set	3.880,– €
4050 mm Tool set	4.380,– €

SCAN TO SHOP

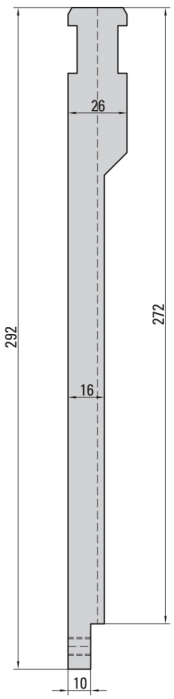




17.151	600 kN/m
2050 mm Tool set	3.150,– €
2550 mm Tool set	3.810,– €
3050 mm Tool set	4.460,– €
3550 mm Tool set	5.120,– €
4050 mm Tool set	5.770,– €

SCAN TO SHOP

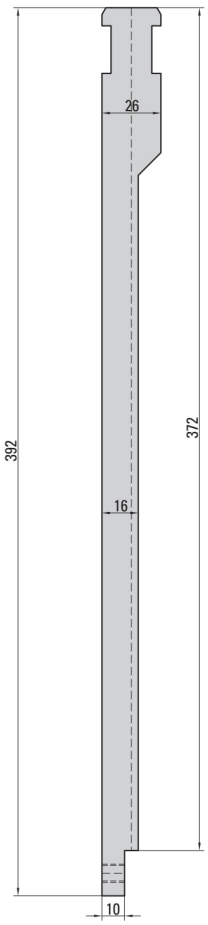




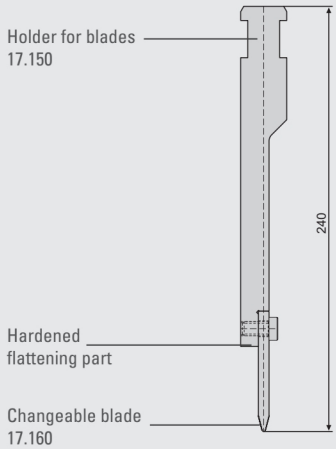
17.152	600 kN/m
2050 mm Tool set	3.920,– €
2550 mm Tool set	4.730,– €
3050 mm Tool set	5.540,– €
3550 mm Tool set	6.350,– €
4050 mm Tool set	7.050,– €

SCAN TO SHOP



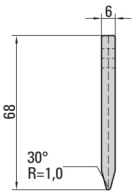


EXAMPLE OF USE

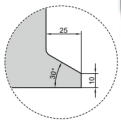


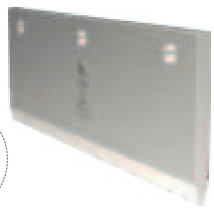
Blades

17.160	600 kN/m
2050 mm Tool set	1.410,– €
2550 mm Tool set	1.670,– €
3050 mm Tool set	1.940,– €
3550 mm Tool set	2.200,– €
4050 mm Tool set	2.480,– €

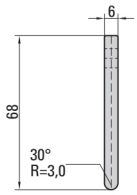


SCAN TO SHOP

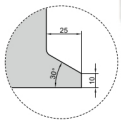


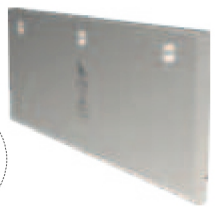


17.170	600 kN/m
2050 mm Tool set	1.410,– €
2550 mm Tool set	1.670,– €
3050 mm Tool set	1.940,– €
3550 mm Tool set	2.200,– €
4050 mm Tool set	2.480,– €

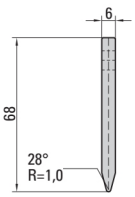


SCAN TO SHOP

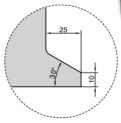


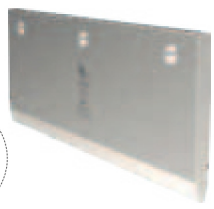


17.161	600 kN/m
2050 mm Tool set	1.410,– €
2550 mm Tool set	1.670,– €
3050 mm Tool set	1.940,– €
3550 mm Tool set	2.200,– €
4050 mm Tool set	2.480,– €

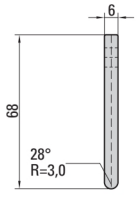


SCAN TO SHOP

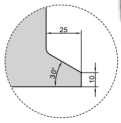


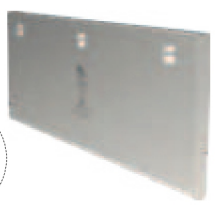


17.171	600 kN/m
2050 mm Tool set	1.410,– €
2550 mm Tool set	1.670,– €
3050 mm Tool set	1.940,– €
3550 mm Tool set	2.200,– €
4050 mm Tool set	2.480,– €



SCAN TO SHOP





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

- **Cost saving:** One holder for different blades
- **Flexible application:** Thanks to changeable blades
- **Efficient blade change:** Quick and easy
- **Hardened flattening part:** Increased service life

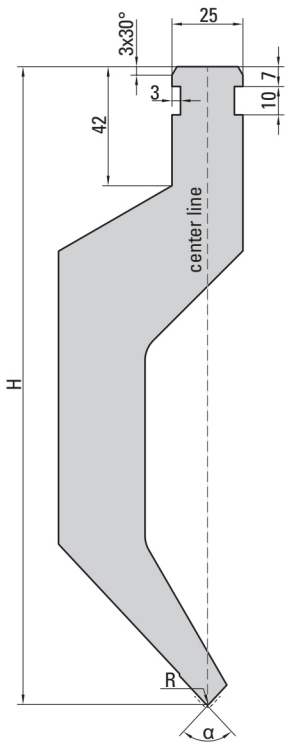
CHAPTER 07



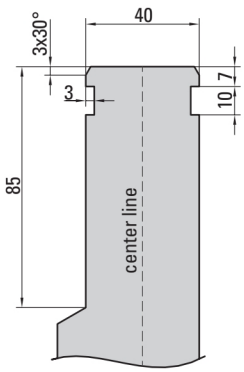
Quality and precision

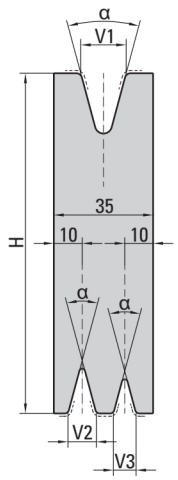
- **Optimum materials**
  - 42 CrMo4, tempered to 1100 - 1200 N/mm²
  - C45, tempered to 800 - 850 N/mm²
  - C45, 650 - 800 N/mm²
  - 1.2312, tempered to 950 - 1100 N/mm²
- Bending radius/intake radii
  hardened up to 52 - 55 HRC
- **Precision ground**
- **Guaranteed exchangeability and parallelism**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

25 mm clamping



40 mm clamping





UKB-INFO

All punches/top tools and dies are produced according to your individual specifications!

Contact us!

VIDEO

UKB-Press brake tool systems

UKB-ADVANTAGES

VIDEO

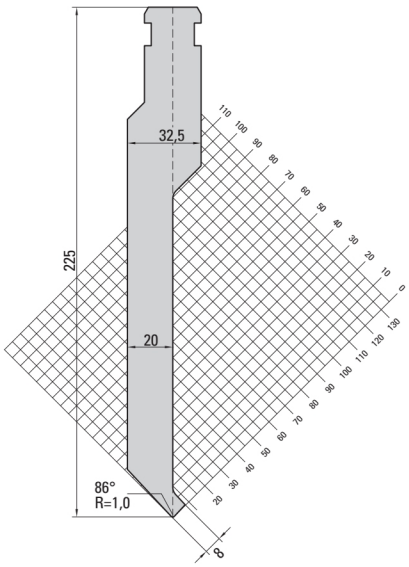
UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:** 14 days 2% cash-discount, 30 days net

Punches/top tools

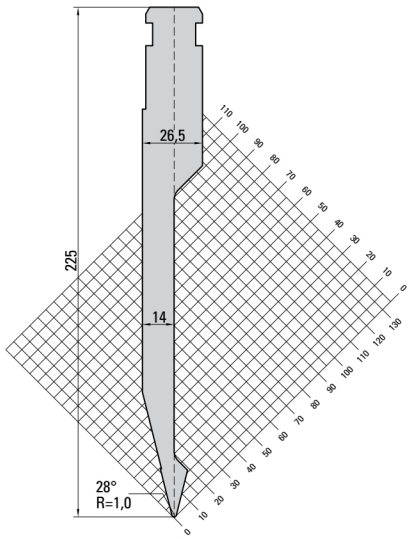
17.500

On request



17.520

On request



17.530

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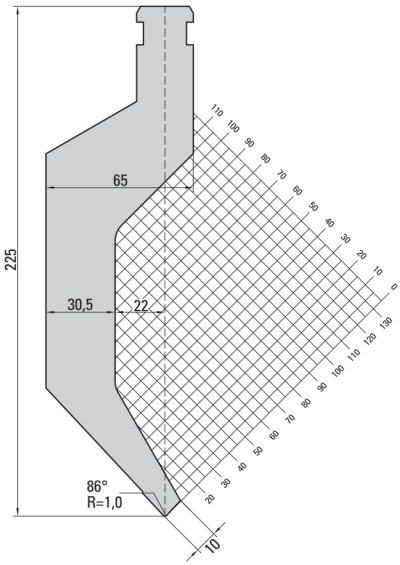

17.540

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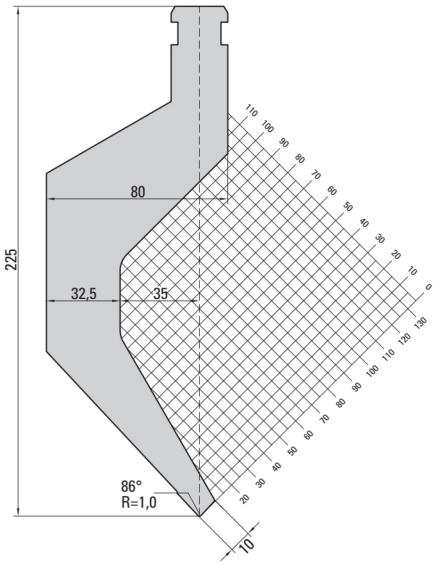
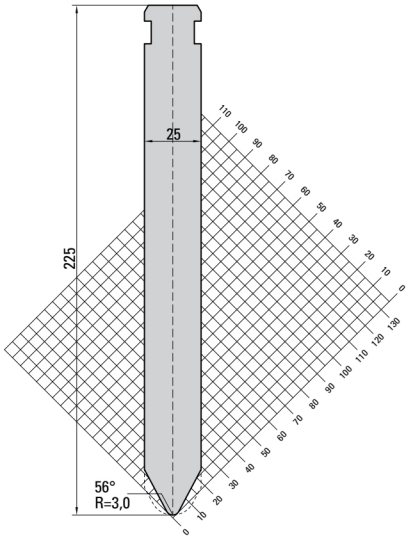


Holder for blades with changeable blade

17.560

On request



17.650

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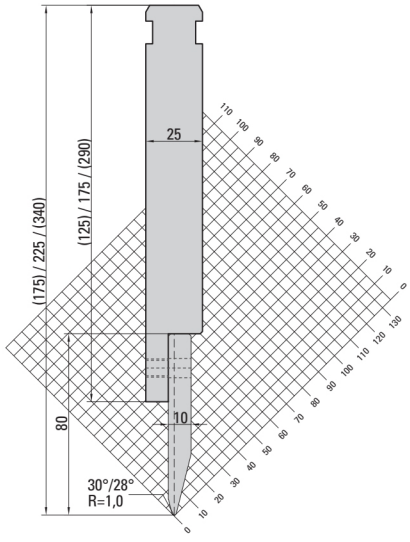
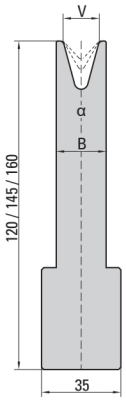


Dies

27.200

On request



27.210

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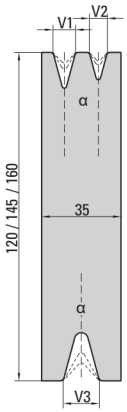

27.220

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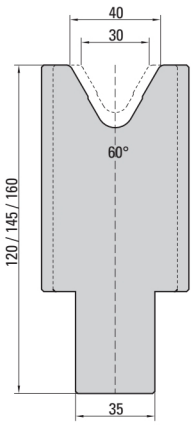

27.230

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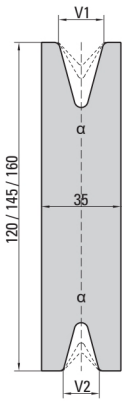
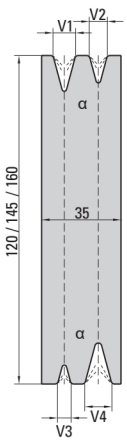


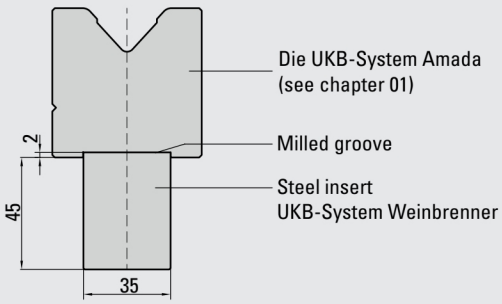
27.240

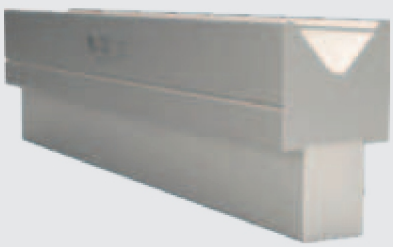
On request





MODIFICATION OF DIES UKB-SYSTEM AMADA





VIDEO

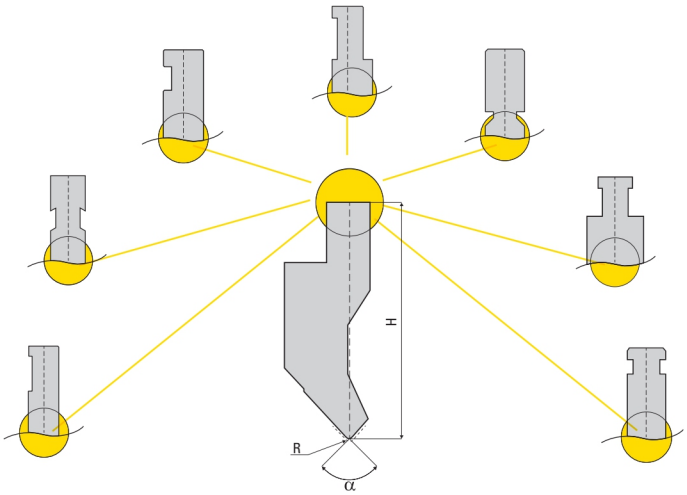
UKB-Modification of Press Brake Tools

OTHER SYSTEMS

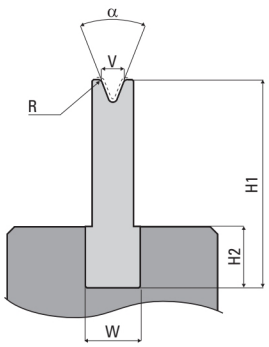
Quality and precision

- **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

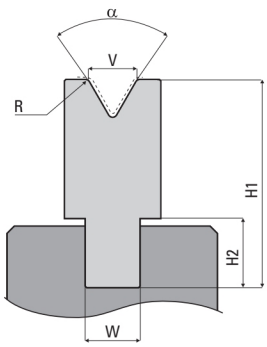
Examples punch/top tool clampings



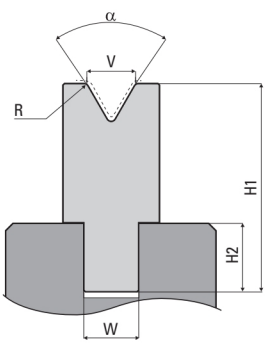
Examples die clampings



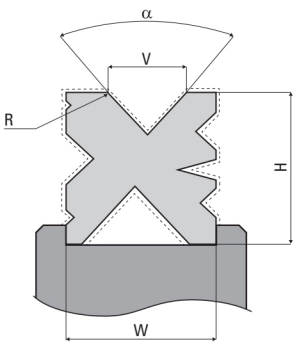
Force on the base



Force on the base



Force on the shoulder



Clamping multi V-die

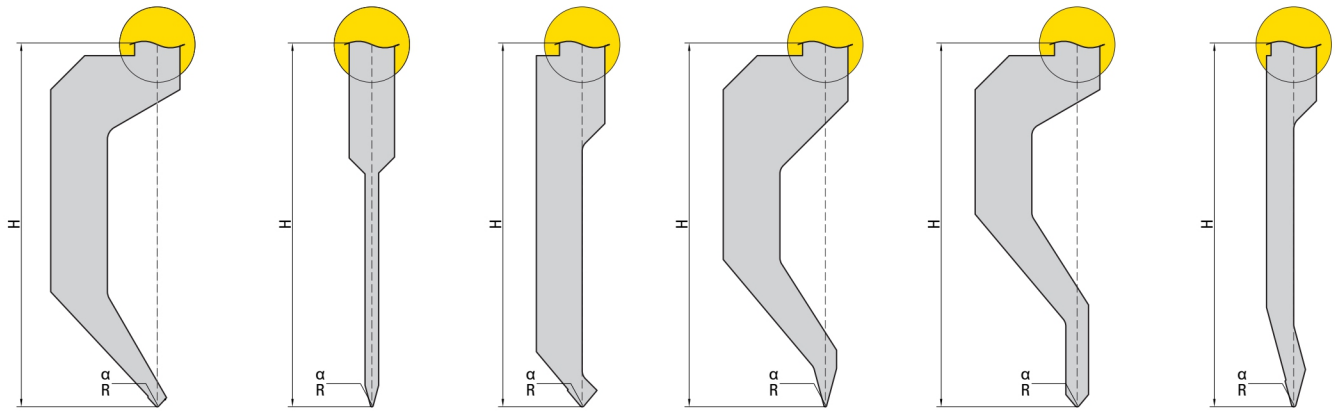
UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:** 14 days 2% cash-discount, 30 days net

VIDEO

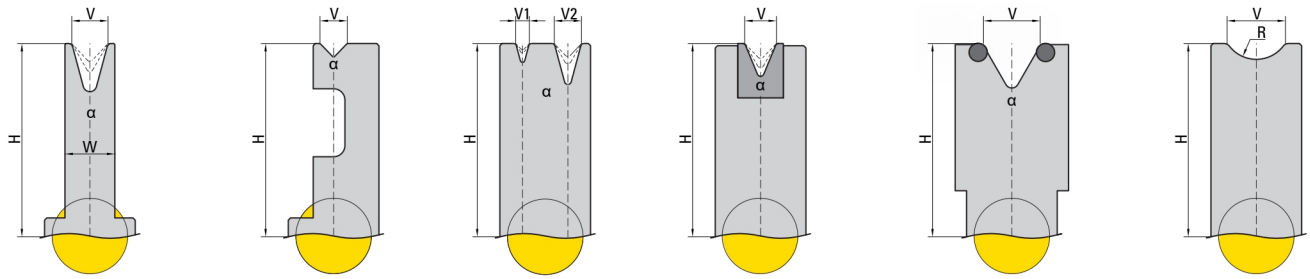
UKB-Image

Examples punches/top tools

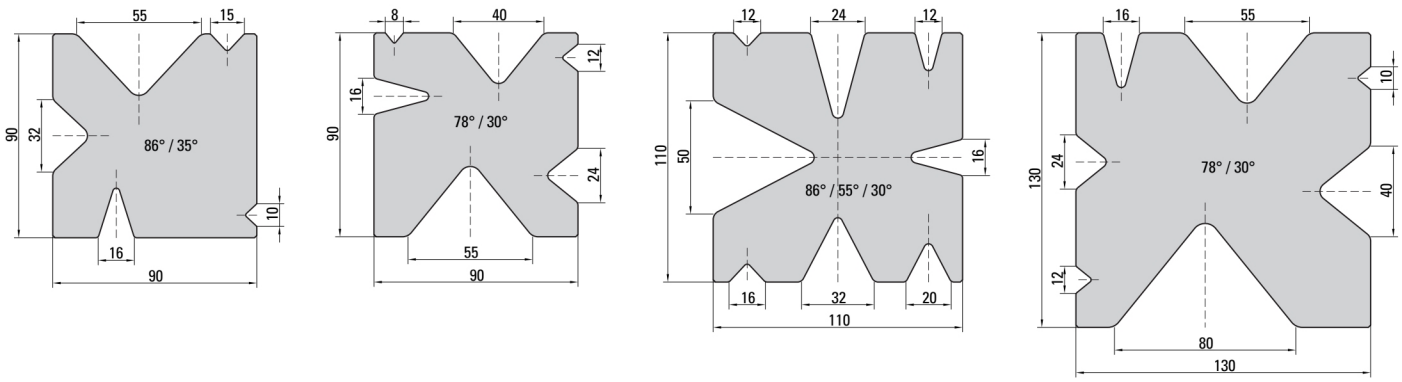


Example 1 | Example 2 | Example 3 | Example 4 | Example 5 | Example 6

Examples dies



Example 1 | Example 2 | Example 3 | Example 4 | Example 5 | Example 6



Example 7 | Example 8 | Example 9 | Example 10

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

Explanation 176-177
Holders for blades 178-179
Blades R 0,5 - 6,0 179





07

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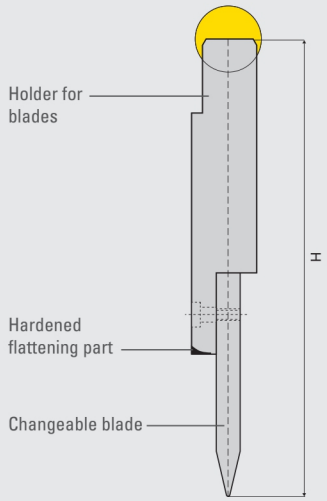
HOLDERS FOR BLADES AND BLADES R 0,5 – 6,0

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:** Thanks to changeable blades
- **Efficient blade change:** Quick and easy
- **Hardened flattening part:** Increased service life

VIDEO

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

UKB-ADVANTAGES

VIDEO

UKB-Image

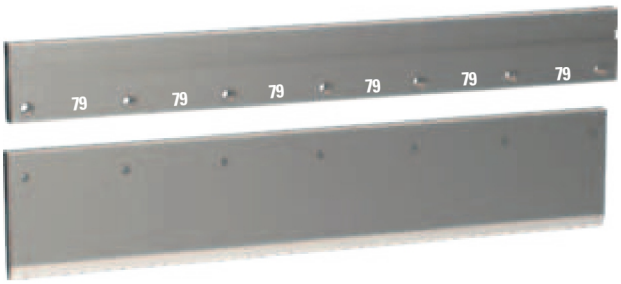
- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **Delivery time:** UKB-Holders for blades and blades R 0,5 – 6,0 in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

Standard:	1 - 3 working days by parcel service or forwarder
Express:	According agreement
Direct courier:	According agreement

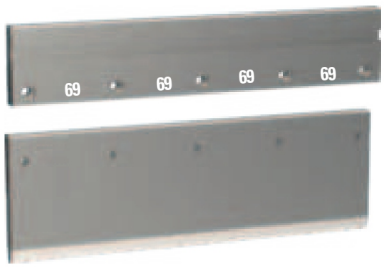
- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Tool lengths

500 mm



300 mm



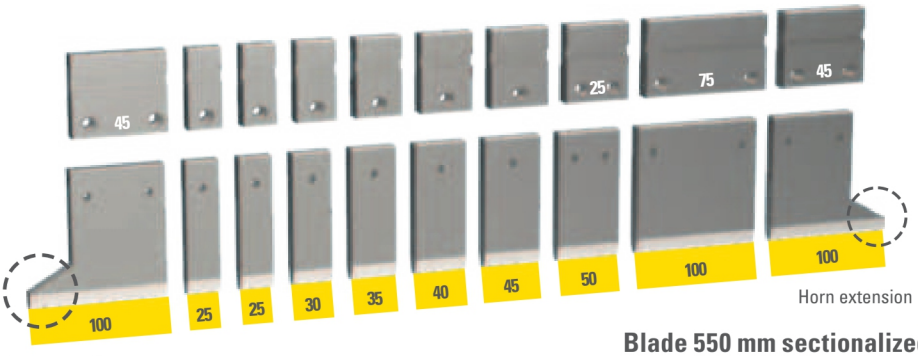
200 mm



100 mm



Holder for blades 488 mm sectionalized



Blade 550 mm sectionalized

- 10 Segments, with horn extension left and right

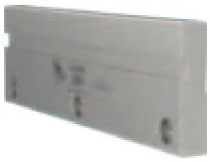


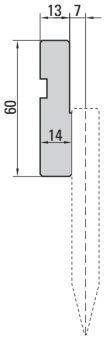
Holders for blades

UKB-SYSTEM AMADA

10.400		24h 1000 kN/m
500 mm	3,0 kg	122,– €
300 mm	1,8 kg	88,– €
200 mm	1,2 kg	66,– €
100 mm	0,6 kg	42,– €
488 mm sectionalized	3,2 kg	230,– €

SCAN TO SHOP







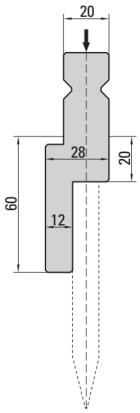
Holder for blades 15.755 with Simple Clamp

UKB-SYSTEMS TRUMPF/WILA/LVD

15.755		24h 1000 kN/m
Simple Clamp		
500 mm	6,7 kg	370,– €
300 mm	4,0 kg	294,– €
200 mm	2,7 kg	202,– €
100 mm	1,4 kg	104,– €
550 mm sectionalized	7,0 kg	800,– €
2050 mm Tool set	27,1 kg	1.996,– €
3050 mm Tool set	40,5 kg	2.692,– €
4050 mm Tool set	53,9 kg	3.376,– €

SCAN TO SHOP

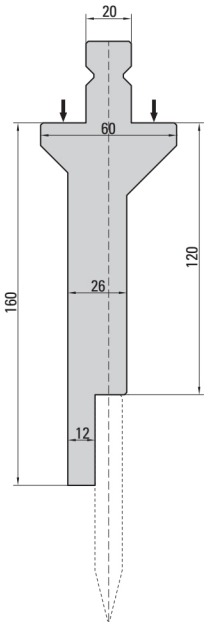




15.760		24h 1000 kN/m
Safety Pins		
500 mm	19,5 kg	702,– €
300 mm	11,7 kg	512,– €
Simple Clamp		
200 mm	7,8 kg	410,– €
100 mm	3,9 kg	234,– €
550 mm sectionalized	19,6 kg	1.364,– €
2050 mm Tool set	78,1 kg	3.616,– €
3050 mm Tool set	117,1 kg	4.942,– €
4050 mm Tool set	156,1 kg	6.238,– €

SCAN TO SHOP



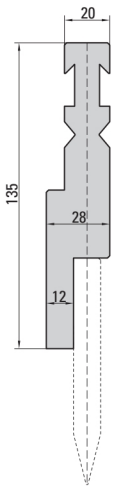


UKB-SYSTEM BYSTRONIC

14.282		24h 1000 kN/m
500 mm	7,0 kg	438,– €
300 mm	4,2 kg	350,– €
200 mm	2,8 kg	240,– €
100 mm	1,4 kg	130,– €
488 mm sectionalized	7,7 kg	782,– €

SCAN TO SHOP



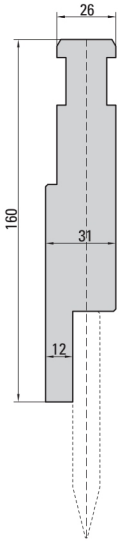


UKB-SYSTEM EHT

17.070		24h 1000 kN/m
500 mm	15,0 kg	450,– €
300 mm	9,0 kg	298,– €
200 mm	6,0 kg	206,– €
100 mm	3,0 kg	134,– €
488 mm sectionalized	16,5 kg	818,– €

SCAN TO SHOP





Holders for blades

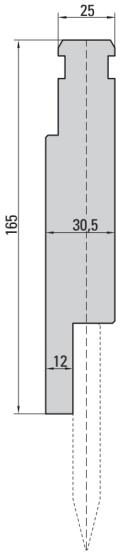
UKB-SYSTEM WEINBRENNER

17.570		1000 kN/m
500 mm	15,5 kg	454,– €
300 mm	9,3 kg	364,– €
200 mm	6,2 kg	250,– €
100 mm	3,1 kg	134,– €
488 mm sectionalized	17,0 kg	834,– €

Delivery time on request

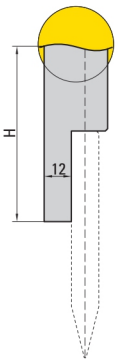
SCAN TO SHOP





OTHER SYSTEMS

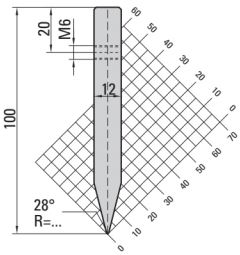
Holder for blades with individual clamping, suitable for your press brake
On request



07

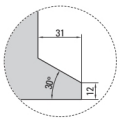
Blades R 0,5 – 6,0

28°									24h 1000 kN/m
R (mm)	Model	500 mm	300 mm	200 mm	100 mm	550 mm sectionalized	2050 mm Tool set	3050 mm Tool set	4050 mm Tool set
		Price	Price	Price	Price	Price	Price	Price	Price
0,5	15.761	150,– €	120,– €	86,– €	50,– €	268,– €	758,– €	1.042,– €	1.320,– €
1,0	15.763	138,– €	110,– €	78,– €	46,– €	244,– €	694,– €	954,– €	1.210,– €
1,5	15.762	150,– €	120,– €	86,– €	50,– €	268,– €	758,– €	1.042,– €	1.320,– €
2,0	15.765	138,– €	110,– €	78,– €	46,– €	244,– €	694,– €	954,– €	1.210,– €
2,5	15.764	150,– €	120,– €	86,– €	50,– €	268,– €	758,– €	1.042,– €	1.320,– €
3,0	15.766	138,– €	110,– €	78,– €	46,– €	244,– €	694,– €	954,– €	1.210,– €
4,0	15.767	138,– €	110,– €	78,– €	46,– €	244,– €	694,– €	954,– €	1.210,– €
5,0	15.768	138,– €	110,– €	78,– €	46,– €	244,– €	694,– €	954,– €	1.210,– €
6,0	15.769	138,– €	110,– €	78,– €	46,– €	244,– €	694,– €	954,– €	1.210,– €
Weight		4,5 kg	2,7 kg	1,8 kg	0,9 kg	5,0 kg	18,5 kg	27,5 kg	36,5 kg





SCAN TO SHOP





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

Holders for radius-tools and radius-tools type I

Explanation 182-183
Holders for radius-tools type I 183-185
Radius-tools type I R 7,0 – 50,0 186
Mounting set for radius-tools type I 187
Flattening tool type I 187
Adjustment aid for setting radius-tools R 7,0 – 12,0. 187

Holders for radius-tools and radius-tools type II

Explanation 188-189
Holders for radius-tools type II. 190
Radius-tools type II R 10,0 – 40,0 191
Radius-tools type II R 45,0 – 50,0 191

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08
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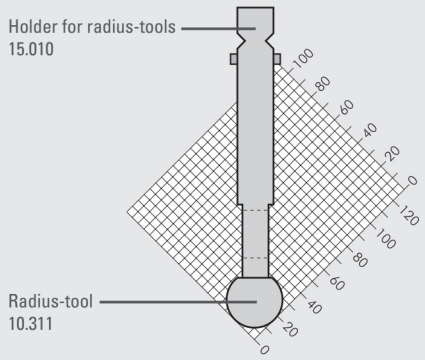
Radius-tools type I

Quality and precision

- **Optimum materials**
  - 42 CrMo4, tempered to 1100 - 1200 N/mm²
  - C45, 650 - 800 N/mm²
- Radius-tools in **two different models:**
  - **Non-hardened**
  - **Hardened up to 60 HRC**
- **Precision ground**
- **Guaranteed exchangeability and parallelism**
- **Tool marking** with all technical information

EXAMPLE OF USE



Product advantages

- **Cost-saving:** One holder for different radius-tools
- **Flexible application:** Thanks to changeable radius-tools
- **Efficient radius-tool change:** Quick and easy
- **No adjustment necessary:** For radius-tools R 12,5 – 50,0
- **High stability**

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

VIDEO
UKB-Image

UKB-ADVANTAGES

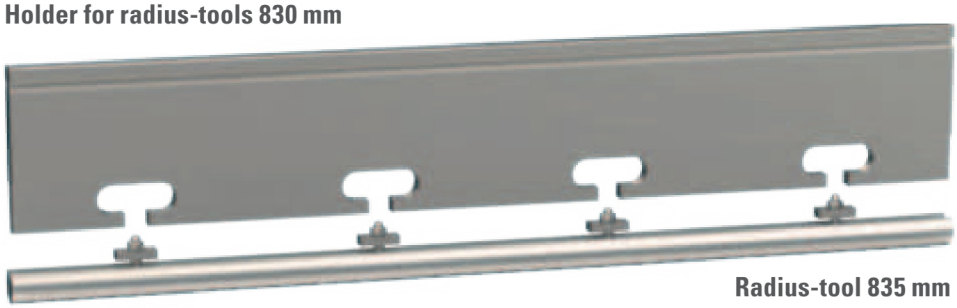
- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **Delivery time:** UKB-Holder for radius-tools and radius-tools in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

Standard:	1 - 3 working days by parcel service or forwarder
Express:	According agreement
Direct courier:	According agreement

- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

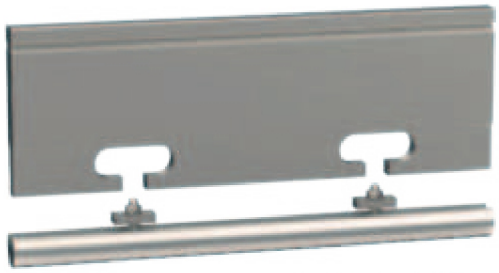
Tool lengths

Holder for radius-tools 830 mm



Radius-tool 835 mm

Holder for radius-tools 412 mm



Radius-tool 415 mm

UKB-INFO

UKB-Holder for radius-tools and radius-tools R 3,0 – 6,5 see page 35!

Holders for radius-tools type I

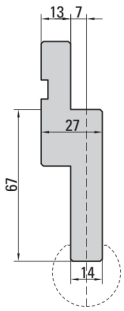
UKB-SYSTEM AMADA

10.115 — 24h — 800 kN/m

830 mm	10,0 kg	200,– €
412 mm	5,0 kg	114,– €

SCAN TO SHOP

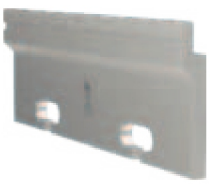


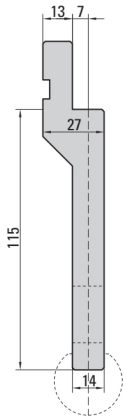


10.116 — 24h — 800 kN/m

830 mm	13,5 kg	312,– €
412 mm	6,7 kg	174,– €

SCAN TO SHOP



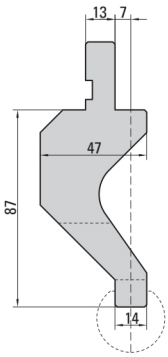


10.190 — 24h — 500 kN/m

830 mm	16,0 kg	490,– €
412 mm	8,0 kg	274,– €

SCAN TO SHOP



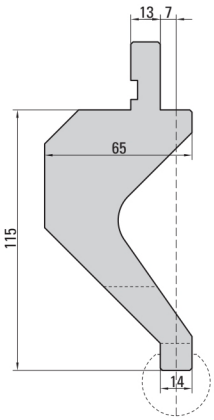


10.191 — 24h — 500 kN/m

830 mm	26,0 kg	652,– €
412 mm	13,0 kg	368,– €

SCAN TO SHOP





Holders for radius-tools type I

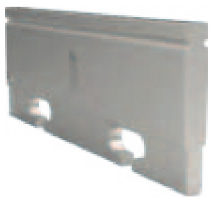
UKB-SYSTEMS TRUMPF/WILA/LVD

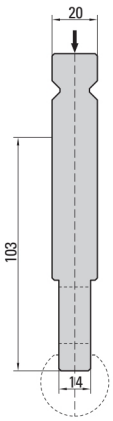
15.010 — 24h — 800 kN/m

Safety Pins		
830 mm	16,0 kg	332,– €
412 mm	8,0 kg	196,– €
Simple Clamp		
412 mm	8,0 kg	266,– €

You should not exceed the weight of 12,5 kg incl. the radius-tool for tools with Simple Clamp

SCAN TO SHOP



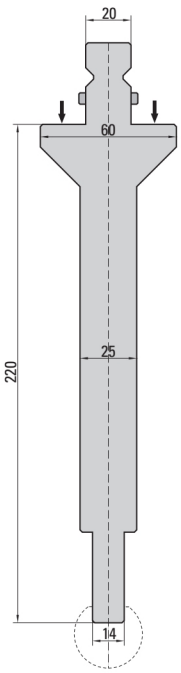


15.018 — 24h — 800 kN/m

Safety Pins		
830 mm	41,0 kg	836,– €
412 mm	20,5 kg	446,– €

SCAN TO SHOP

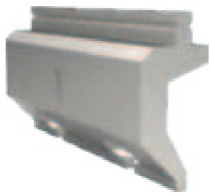


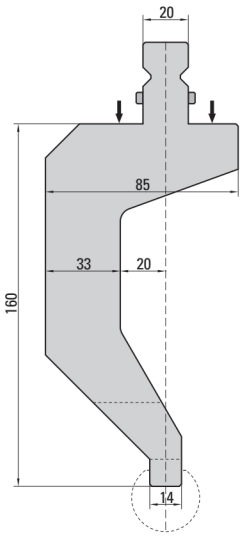


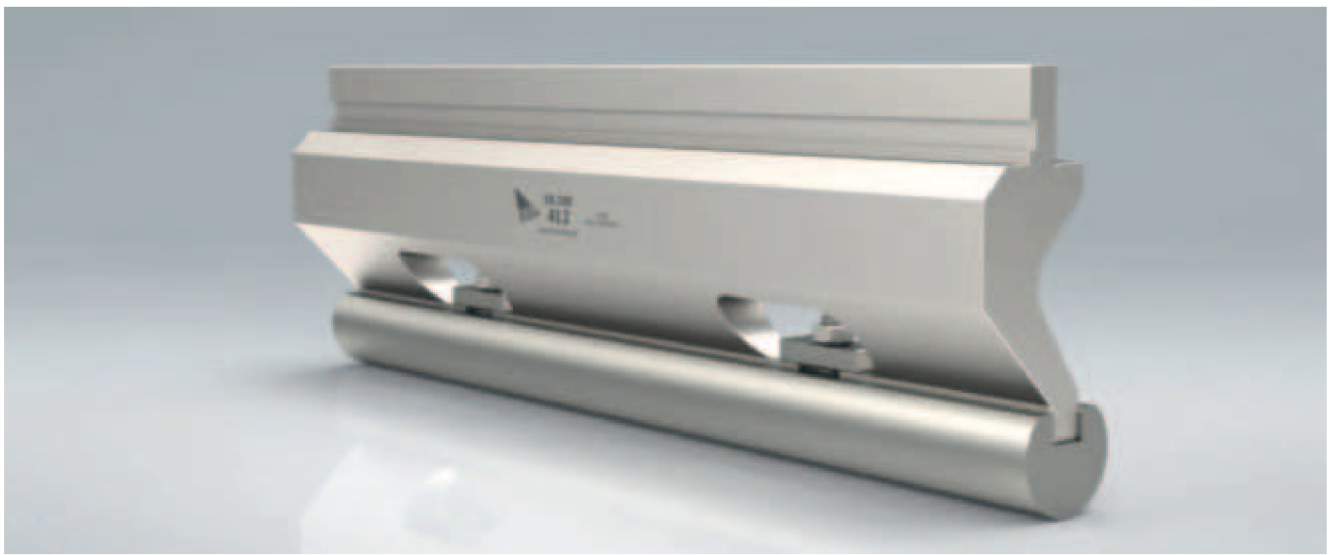
15.014 — 24h — 800 kN/m

Safety Pins		
830 mm	47,0 kg	1.002,– €
412 mm	23,5 kg	558,– €

SCAN TO SHOP





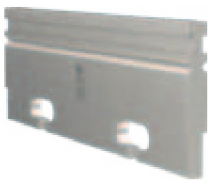


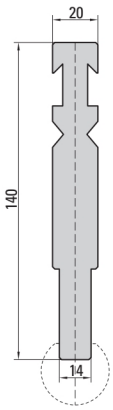
Holders for radius-tools type I

UKB-SYSTEM BYSTRONIC

14.252		24h 800 kN/m
830 mm	14,5 kg	354,– €
412 mm	7,2 kg	206,– €

SCAN TO SHOP



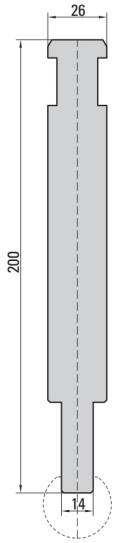


UKB-SYSTEM EHT

17.010		24h 800 kN/m
830 mm	28,8 kg	472,– €
412 mm	14,3 kg	272,– €

SCAN TO SHOP





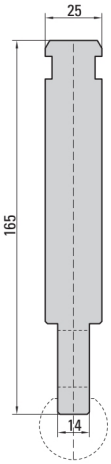
UKB-SYSTEM WEINBRENNER

17.510		800 kN/m
830 mm	22,8 kg	414,– €
412 mm	11,3 kg	236,– €

Delivery time on request

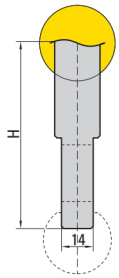
SCAN TO SHOP

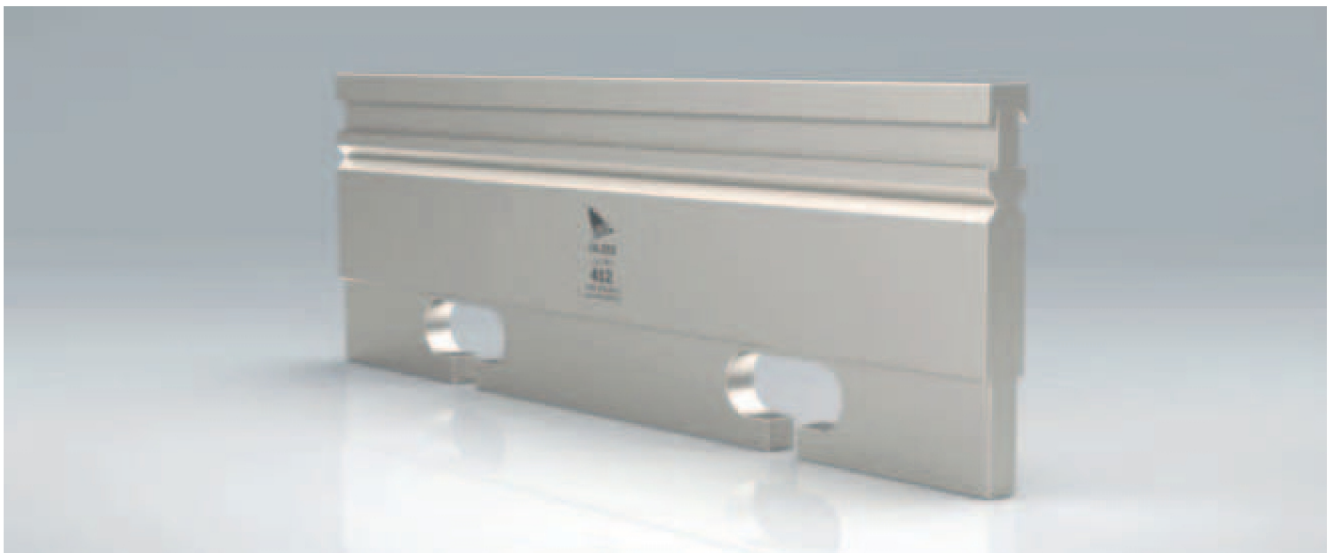




OTHER SYSTEMS

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





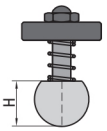
Radius-tools type I R 7,0 – 50,0

R 7,0 – 12,0

24h
800 kN/m

SCAN TO SHOP

R (mm)	H (mm)	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
7,0	11,5	10.300	0,9 kg	76,– €	0,4 kg	46,– €	11.300	0,9 kg	178,– €	0,4 kg	108,– €
7,5	11,5	10.301	1,0 kg	76,– €	0,5 kg	46,– €	11.301	1,0 kg	186,– €	0,5 kg	108,– €
8,0	13,0	10.302	1,2 kg	76,– €	0,6 kg	46,– €	11.302	1,2 kg	210,– €	0,6 kg	110,– €
9,0	16,0	10.303	1,6 kg	84,– €	0,8 kg	50,– €	11.303	1,6 kg	200,– €	0,8 kg	118,– €
10,0	16,0	10.304	1,8 kg	66,– €	0,9 kg	42,– €	11.304	1,8 kg	212,– €	0,9 kg	124,– €
11,0	16,0	10.305	2,0 kg	98,– €	1,0 kg	58,– €	11.305	2,0 kg	224,– €	1,0 kg	130,– €
11,5	19,0	10.306	2,4 kg	98,– €	1,2 kg	58,– €	11.306	2,4 kg	230,– €	1,2 kg	134,– €
12,0	20,0	10.307	2,6 kg	98,– €	1,3 kg	58,– €	11.307	2,6 kg	234,– €	1,3 kg	134,– €
		C45	Radius-tools non-hardened				42CrMo4	Radius-tools hardened up to 60 HRC			



R 7,0 – 12,0

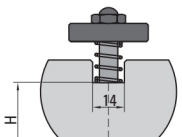


R 12,5 – 50,0

24h
800 kN/m

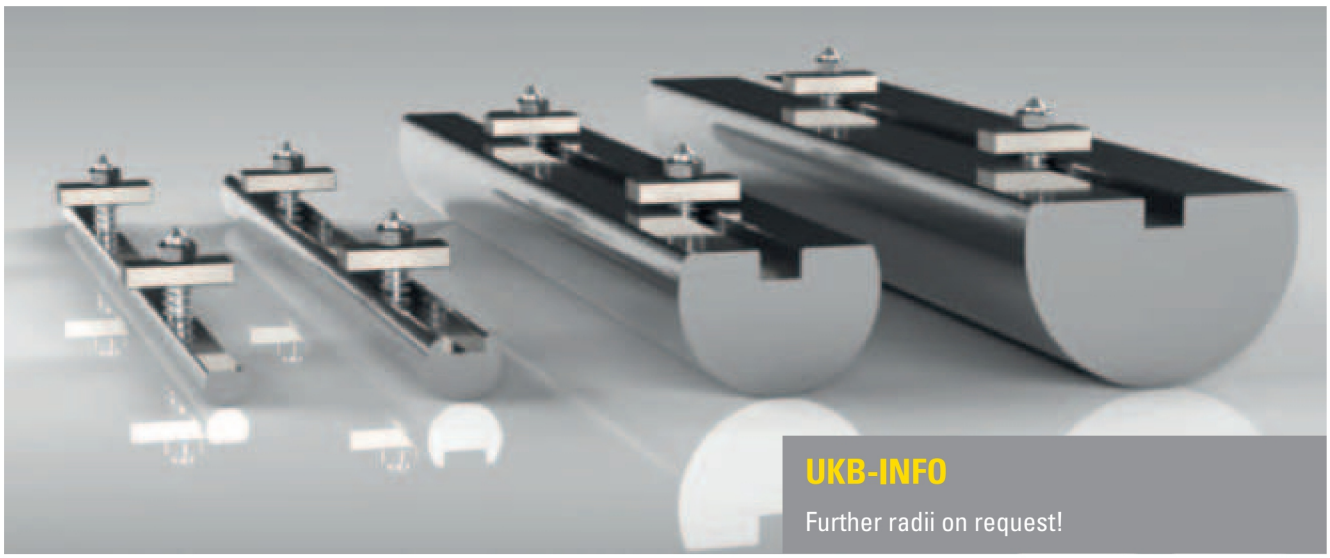
SCAN TO SHOP

R (mm)	H (mm)	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
12,5	16,0	10.308	2,4 kg	108,– €	1,2 kg	64,– €	11.308	2,4 kg	240,– €	1,2 kg	142,– €
13,0	17,0	10.309	3,2 kg	108,– €	1,6 kg	64,– €	11.309	3,2 kg	248,– €	1,6 kg	146,– €
14,0	19,0	10.310	3,3 kg	108,– €	1,6 kg	64,– €	11.310	3,3 kg	256,– €	1,6 kg	150,– €
15,0	20,0	10.311	4,3 kg	90,– €	2,1 kg	56,– €	11.311	4,3 kg	268,– €	2,1 kg	156,– €
16,0	21,0	10.312	4,3 kg	128,– €	2,1 kg	76,– €	11.312	4,3 kg	280,– €	2,1 kg	160,– €
17,0	21,5	10.313	4,7 kg	128,– €	2,3 kg	76,– €	11.313	4,7 kg	290,– €	2,3 kg	168,– €
17,5	22,0	10.314	5,1 kg	108,– €	2,6 kg	72,– €	11.314	5,1 kg	296,– €	2,6 kg	176,– €
19,0	25,0	10.315	6,0 kg	140,– €	3,0 kg	84,– €	11.315	6,0 kg	312,– €	3,0 kg	186,– €
20,0	24,0	10.316	6,6 kg	132,– €	3,3 kg	84,– €	11.316	6,6 kg	324,– €	3,3 kg	190,– €
22,5	25,0	10.317	7,5 kg	160,– €	3,7 kg	96,– €	11.317	7,5 kg	358,– €	3,7 kg	208,– €
25,0	29,0	10.318	9,9 kg	132,– €	4,9 kg	90,– €	11.318	9,9 kg	390,– €	4,9 kg	224,– €
27,5	34,0	10.319	12,5 kg	184,– €	6,2 kg	108,– €	11.319	12,5 kg	422,– €	6,2 kg	248,– €
30,0	34,0	10.320	13,7 kg	182,– €	6,8 kg	114,– €	11.320	13,7 kg	490,– €	6,8 kg	280,– €
35,0	45,0	10.321	20,4 kg	274,– €	10,1 kg	164,– €	11.321	20,4 kg	524,– €	10,1 kg	296,– €
40,0	45,0	10.322	23,3 kg	318,– €	11,6 kg	190,– €	11.322	23,3 kg	692,– €	11,6 kg	380,– €
45,0	50,0	10.323	28,6 kg	368,– €	14,2 kg	226,– €	11.323	28,6 kg	758,– €	14,2 kg	422,– €
50,0	54,0	10.324	33,9 kg	394,– €	16,9 kg	248,– €	11.324	33,9 kg	802,– €	16,9 kg	458,– €
		C45	Radius-tools non-hardened				42CrMo4	Radius-tools hardened up to 60 HRC			



R 12,5 – 50,0





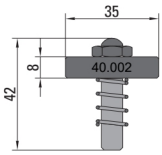
UKB-INFO

Further radii on request!

Mounting set for radius-tools type I

40.002		24h
Set	0,1 kg	8,– €

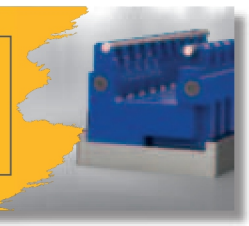
Mounting set for radius-tools
R 7,0 – 50,0



SCAN TO SHOP

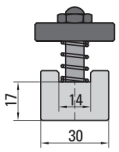


UKB-ADJUSTABLE DIES
CHAPTER 11



Flattening tool type I

10.325		24h 800 kN/m
835 mm	3,9 kg	116,– €
415 mm	1,9 kg	68,– €



SCAN TO SHOP



UKB-INFO

Suitable flattening die 20.240 see page 65 and 29.384 see page 125!

Adjustment aid for setting radius-tools R 7,0 – 12,0

R 7,0 – 12,0			24h
R (mm)	Model	Weight	Price per pair
7,0	10.330	0,04 kg	22,– €
7,5	10.331	0,04 kg	22,– €
8,0	10.332	0,04 kg	22,– €
9,0	10.333	0,04 kg	22,– €
10,0	10.334	0,04 kg	22,– €
11,0	10.335	0,04 kg	22,– €
11,5	10.336	0,04 kg	22,– €
12,0	10.337	0,04 kg	22,– €

SCAN TO SHOP





R = 7,0 – 12,0



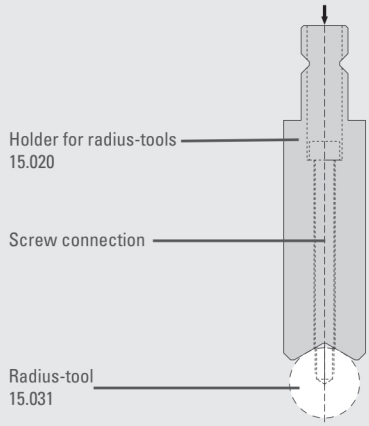
HOLDERS FOR RADIUS-TOOLS AND RADIUS-TOOLS R 7,0 – 50,0

Radius-tools type II

Quality and precision

- **Optimum materials**
  - C45, 650 - 800 N/mm²
- Radius-tools **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 radius-tools
- **Flexible application:** Thanks to changeable radius-tools
- **Efficient radius-tool change:** Quick and easy
- **No adjustment necessary**
- **High stability**
- **Sectionalized radius-tools**

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

UKB-ADVANTAGES

VIDEO
UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **Delivery time:** UKB-Holder 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:	According agreement
Direct courier:	According agreement

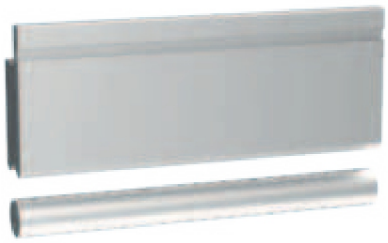
- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Tool lengths

500 mm



300 mm



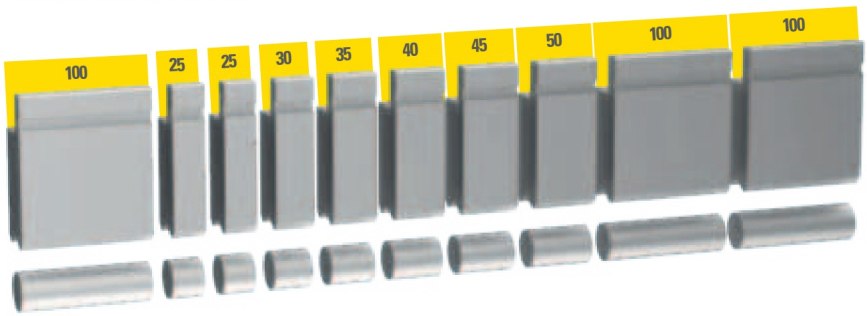
200 mm



100 mm



550 mm sectionalized



- 10 Segments



Holder for radius-tools type II

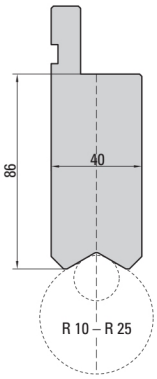
UKB-SYSTEM AMADA

10.192		24h 1300 kN/m
500 mm	14,4 kg	334,– €
300 mm	8,7 kg	234,– €
200 mm	5,8 kg	158,– €
100 mm	2,9 kg	82,– €
550 mm sectionalized	15,0 kg	758,– €

For radius-tools R 10,0 – 25,0

SCAN TO SHOP



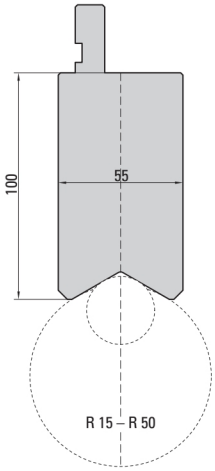


10.193		24h 1500 kN/m
500 mm	21,9 kg	362,– €
300 mm	13,1 kg	266,– €
200 mm	8,8 kg	172,– €
100 mm	4,4 kg	94,– €
550 mm sectionalized	22,3 kg	886,– €

For radius-tools R 15,0 – 50,0

SCAN TO SHOP





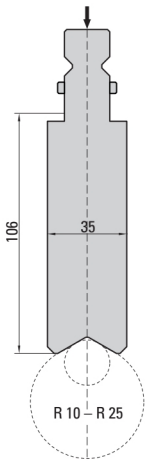
UKB-SYSTEMS TRUMPF/WILA/LVD

15.020		24h 1300 kN/m
Safety Pins		
500 mm	16,7 kg	368,– €
300 mm	10,0 kg	292,– €
200 mm	6,7 kg	176,– €
550 mm sectionalized	16,8 kg	968,– €
Simple Clamp		
100 mm	3,3 kg	136,– €
2050 mm Tool set	66,9 kg	2.128,– €
3050 mm Tool set	100,3 kg	2.820,– €
4050 mm Tool set	133,7 kg	3.498,– €

For radius-tools R 10,0 – 25,0

SCAN TO SHOP



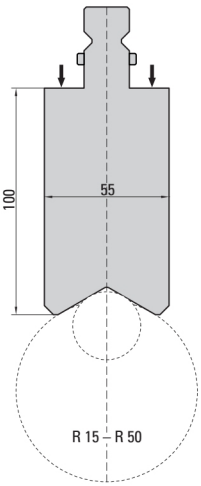


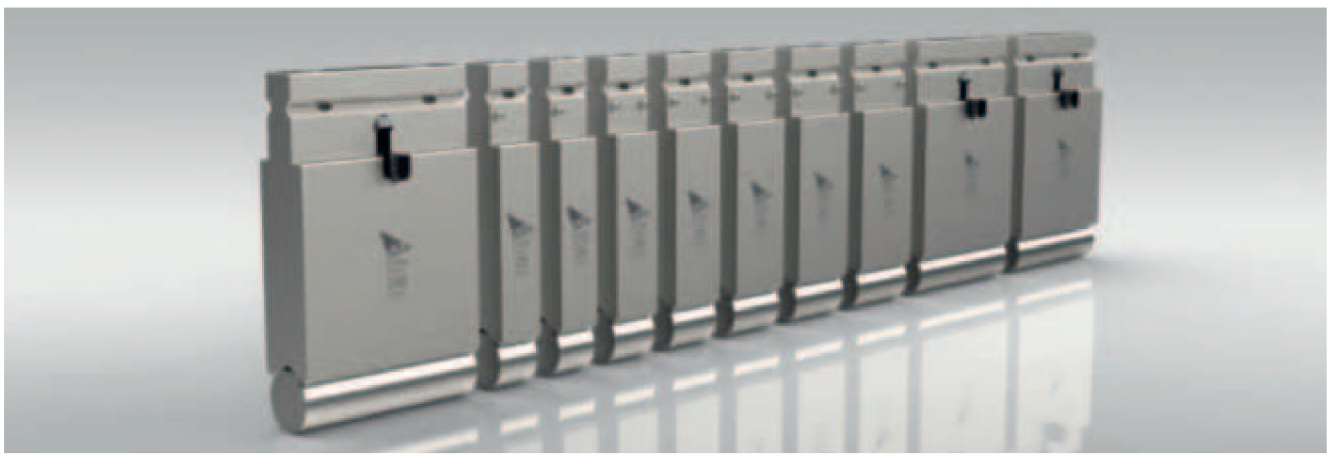
15.025		24h 1500 kN/m
Safety Pins		
500 mm	18,1 kg	504,– €
300 mm	10,9 kg	368,– €
200 mm	7,2 kg	272,– €
550 mm sectionalized	18,8 kg	1.104,– €
Simple Clamp		
100 mm	3,6 kg	168,– €
2050 mm Tool set	73,1 kg	2.696,– €
3050 mm Tool set	109,3 kg	3.648,– €
4050 mm Tool set	145,5 kg	4.578,– €

For radius-tools R 15,0 – 50,0

SCAN TO SHOP







Radius-tools type II R 10,0 – 40,0

R 10,0 – 12,5

24h
1300 kN/m

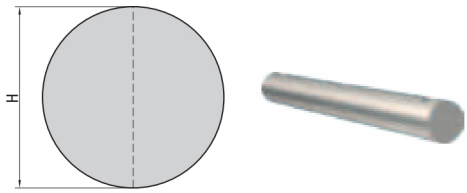
SCAN TO SHOP

Model	15.030		15.031	
R (mm)	10,0		12,5	
H (mm)	20		25	
Length	Weight	Price	Weight	Price
500 mm	1,2 kg	176,– €	1,9 kg	180,– €
300 mm	0,7 kg	120,– €	1,2 kg	124,– €
200 mm	0,5 kg	84,– €	0,8 kg	88,– €
100 mm	0,2 kg	38,– €	0,4 kg	40,– €
550 mm sectionalized	1,4 kg	306,– €	2,1 kg	310,– €
2050 mm Tool set	5,0 kg	844,– €	7,9 kg	864,– €
3050 mm Tool set	7,4 kg	1.178,– €	11,7 kg	1.204,– €
4050 mm Tool set	9,8 kg	1.504,– €	15,5 kg	1.538,– €

Radius-tools hardened up to 52-55 HRC



Radius-tools 15.038,15.039 and 15.040



R 10,0 – 40,0

R 15,0 – 40,0

24h
1500 kN/m

SCAN TO SHOP

Model	15.032		15.033		15.034		15.035		15.036		15.037		15.038	
R (mm)	15,0		17,5		20,0		25,0		30,0		35,0		40,0	
H (mm)	30		35		40		50		60		70		80	
Length	Weight	Price	Weight	Price	Weight	Price	Weight	Price	Weight	Price	Weight	Price	Weight	Price
500 mm	2,8 kg	184,– €	3,8 kg	222,– €	5,0 kg	226,– €	7,7 kg	230,– €	11,1 kg	274,– €	15,1 kg	278,– €	19,7 kg	282,– €
300 mm	1,7 kg	128,– €	2,3 kg	158,– €	3,0 kg	162,– €	4,6 kg	166,– €	6,7 kg	196,– €	9,1 kg	200,– €	11,8kg	204,– €
200 mm	1,2 kg	92,– €	1,6 kg	110,– €	2,0 kg	114,– €	3,1 kg	118,– €	4,4 kg	136,– €	6,0 kg	140,– €	7,9 kg	144,– €
100 mm	0,6 kg	42,– €	0,8 kg	64,– €	1,0 kg	66,– €	1,5 kg	68,– €	2,2 kg	74,– €	3,0 kg	78,– €	3,9 kg	82,– €
550 mm sectionalized	3,0 kg	314,– €	4,2 kg	380,– €	5,4 kg	386,– €	8,5 kg	392,– €	12,2 kg	474,– €	16,6 kg	480,– €	21,7 kg	486,– €
2050 mm Tool set	11,5 kg	884,– €	15,7 kg	1.070,– €	20,4 kg	1.092,– €	31,6 kg	1.114,– €	45,5 kg	1.326,– €	61,9 kg	1.348,– €	80,8 kg	1.370,– €
3050 mm Tool set	17,1 kg	1.232,– €	23,3 kg	1.490,– €	30,4 kg	1.520,– €	47,0 kg	1.548,– €	67,7 kg	1.844,– €	92,1 kg	1.874,– €	120,2 kg	1.904,– €
4050 mm Tool set	22,7 kg	1.572,– €	30,9 kg	1.900,– €	40,4 kg	1.938,– €	62,4 kg	1.974,– €	89,9 kg	2.352,– €	122,3 kg	2.388,– €	159,6 kg	2.424,– €

Radius-tools hardened up to 52-55 HRC

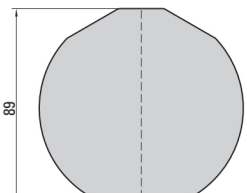
Radius-tools type II R 45,0 – 50,0

15.039

24h
1500 kN/m

SCAN TO SHOP

500 mm	24,7 kg	456,– €
300 mm	14,8 kg	326,– €
200 mm	9,9 kg	232,– €
100 mm	4,9 kg	130,– €
550 mm sectionalized	27,1 kg	772,– €
2050 mm Tool set	101,2 kg	2.198,– €
3050 mm Tool set	150,6 kg	3.060,– €
4050 mm Tool set	200,0 kg	3.904,– €



R 45,0



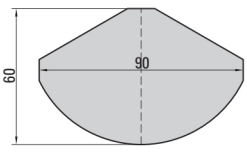
Suitable for radius-tool holders
10.193 / 15.025

15.040

24h
1500 kN/m

SCAN TO SHOP

500 mm	14,9 kg	586,– €
300 mm	9,0 kg	418,– €
200 mm	6,0 kg	298,– €
100 mm	3,0 kg	172,– €
550 mm sectionalized	16,4 kg	994,– €
2050 mm Tool set	61,2 kg	2.824,– €
3050 mm Tool set	91,0 kg	3.932,– €
4050 mm Tool set	120,8 kg	5.016,– €



R 50,0



Suitable for radius-tool holders
10.193 / 15.025

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

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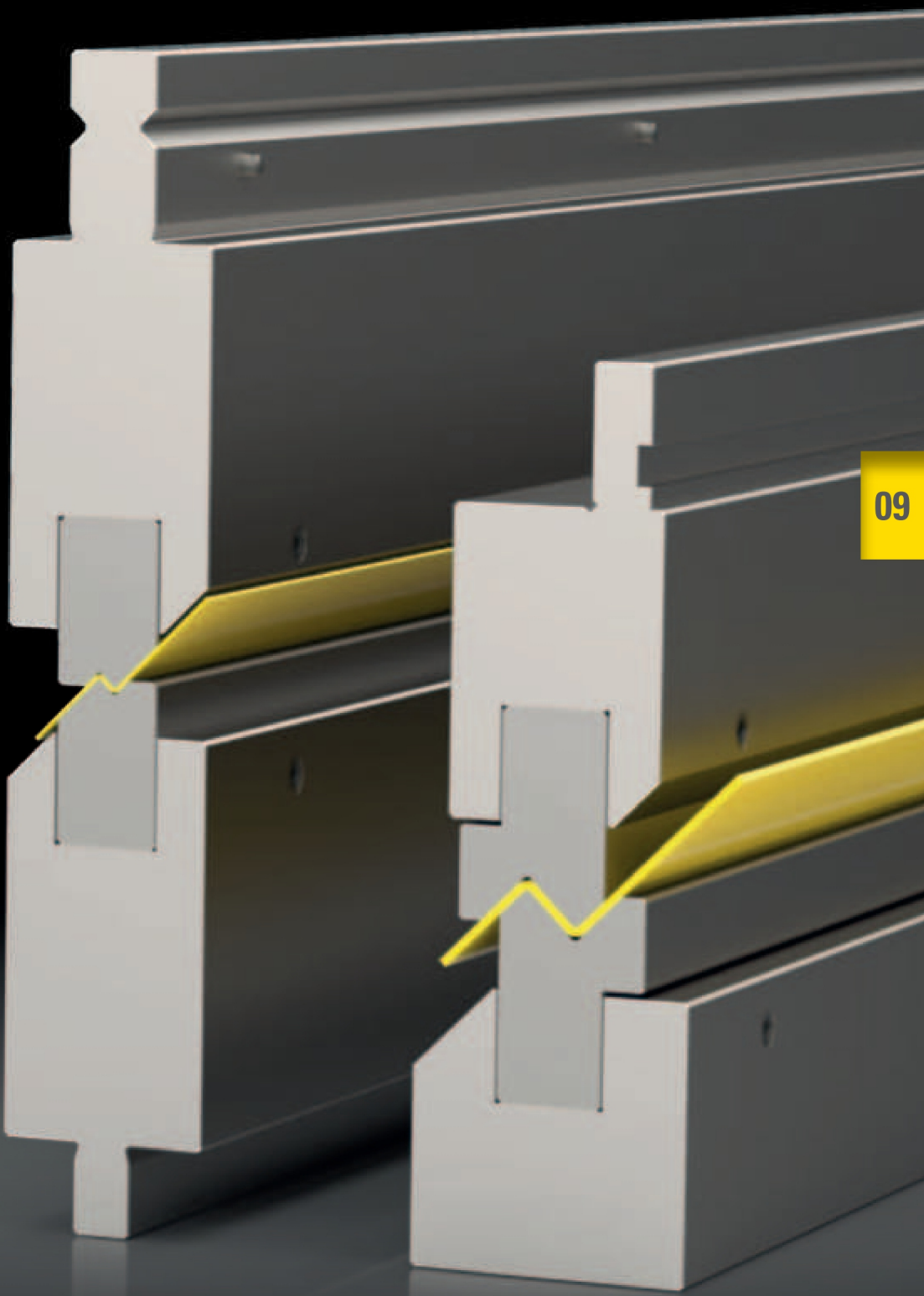
Z-Tool holders 195-196
Flattening insert 196
Z-Tool inserts Z 1,0 – 15,0 197





09

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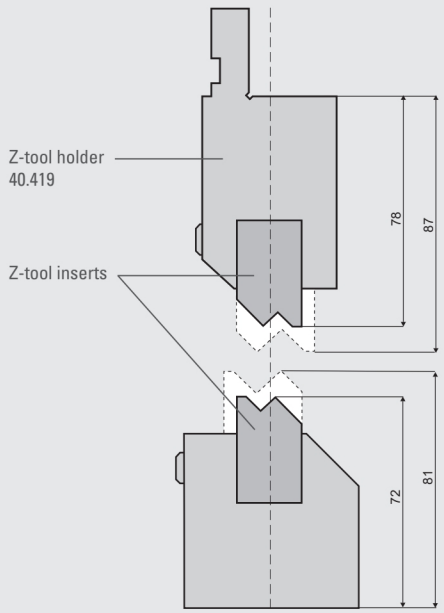
Quality and precision

- **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

EXAMPLE OF USE



Z-tool inserts are fixed by M10 grub screws in the Z-tool holders

Product advantages

- **Cost-saving:** One holder for different Z-tool inserts
- **Flexible application:** Thanks to changeable Z-tool inserts
- **Efficient bending:** Z-bends in one stroke
- **Complete set:** Z-tool holder and Z-tool inserts are each delivered as a set
- **No adjustment necessary**
- **Z-bends with long flanges possible**
- **Sectionalized Z-tools:** On request

VIDEO
UKB-Z-tool holders and Z-tool inserts Z 1,0 – 15,0

VIDEO
UKB-Image

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **Delivery time:** UKB-Z-tool holders and Z-tool inserts 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:	According agreement
Direct courier:	According agreement

- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Z-Tool holders

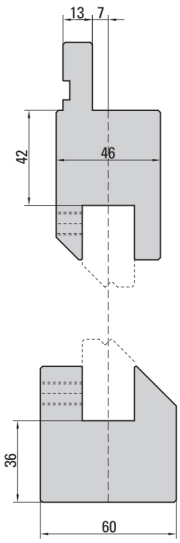
UKB-SYSTEM AMADA

40.419 — 24h — 1000 kN/m

835 mm	37,3 kg	824,– €
415 mm	18,7 kg	462,– €

SCAN TO SHOP





UKB-SYSTEMS TRUMPF/WILA

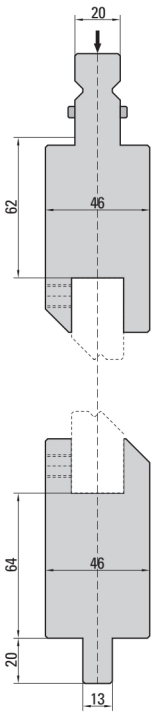
15.050 — 24h — 1000 kN/m

Safety Pins

835 mm	50,6 kg	1.168,– €
415 mm	25,2 kg	636,– €

SCAN TO SHOP





UKB-SYSTEM LVD

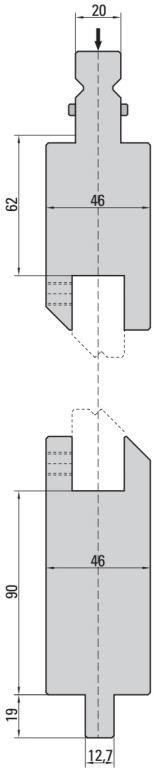
16.060 — 24h — 1000 kN/m

Safety Pins

835 mm	58,4 kg	1.392,– €
415 mm	29,0 kg	726,– €

SCAN TO SHOP





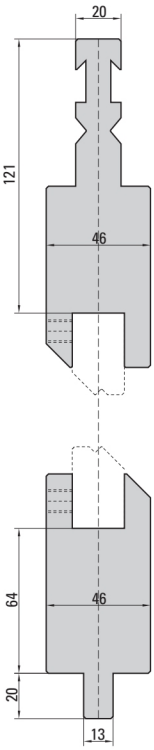
UKB-SYSTEM BYSTRONIC

14.080 — 24h — 1000 kN/m

835 mm	51,5 kg	1.482,– €
415 mm	25,6 kg	800,– €

SCAN TO SHOP





Z-Tool holders

UKB-SYSTEM EHT

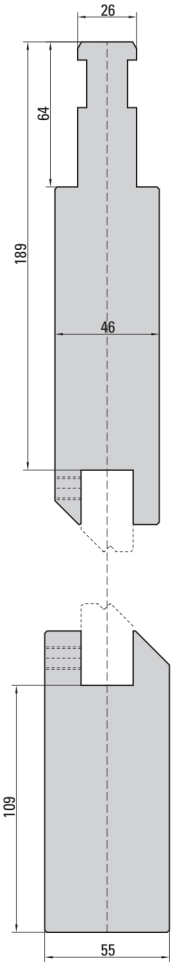
17.050 1000 kN/m

415 mm	46,8 kg	712,– €

Delivery time on request

SCAN TO SHOP





UKB-SYSTEM WEINBRENNER

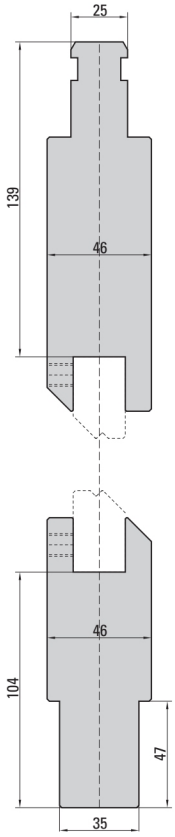
17.550 1000 kN/m

415 mm	34,8 kg	694,– €

Delivery time on request

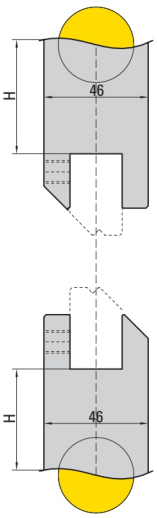
SCAN TO SHOP





OTHER SYSTEMS

Z-tool holder with
individual clamping,
suitable for your press brake
On request



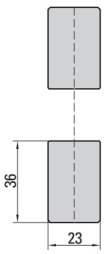
Flattening insert

40.500 **24h** 1000 kN/m

835 mm	10,8 kg	280,– €
415 mm	5,4 kg	156,– €

SCAN TO SHOP





Z-Tool inserts Z 1,0 – 15,0

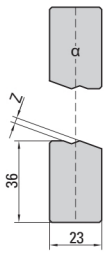
Z 1,0 – 2,5

24h
1000 kN/m

SCAN TO SHOP

Z (mm)	Model	α	835 mm Price	415 mm Price
1,0	40.510	160°	416,– €	230,– €
1,5	40.515	160°	416,– €	230,– €
2,0	40.520	150°	416,– €	230,– €
2,5	40.525	140°	416,– €	230,– €
Weight			10,7 kg	5,3 kg





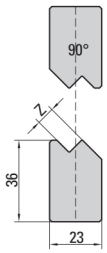
Z 1,0 – 8,0

24h
1000 kN/m

SCAN TO SHOP

Z (mm)	Model	α	835 mm Price	415 mm Price
1,0	40.511	90°	416,– €	230,– €
1,5	40.516	90°	416,– €	230,– €
2,0	40.521	90°	416,– €	230,– €
2,5	40.526	90°	416,– €	230,– €
3,0	40.530	90°	416,– €	230,– €
3,5	40.535	90°	416,– €	230,– €
4,0	40.540	90°	416,– €	230,– €
4,5	40.545	90°	416,– €	230,– €
5,0	40.550	90°	416,– €	230,– €
5,5	40.555	90°	416,– €	230,– €
6,0	40.560	90°	416,– €	230,– €
6,5	40.565	90°	416,– €	230,– €
7,0	40.570	90°	416,– €	230,– €
7,5	40.575	90°	416,– €	230,– €
8,0	40.580	90°	416,– €	230,– €
Weight			10,0 kg	5,0 kg





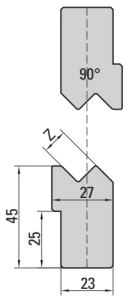
Z 8,5 – 12,0

24h
1000 kN/m

SCAN TO SHOP

Z (mm)	Model	α	835 mm Price	415 mm Price
8,5	40.585	90°	466,– €	256,– €
9,0	40.590	90°	466,– €	256,– €
10,0	40.610	90°	466,– €	256,– €
11,0	40.611	90°	466,– €	256,– €
12,0	40.612	90°	466,– €	256,– €
Weight			13,7 kg	6,8 kg





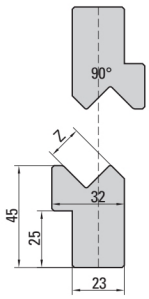
Z 13,0 – 15,0

24h
1000 kN/m

SCAN TO SHOP

Z (mm)	Model	α	835 mm Price	415 mm Price
13,0	40.613	90°	466,– €	256,– €
14,0	40.614	90°	466,– €	256,– €
15,0	40.615	90°	466,– €	256,– €
Weight			14,5 kg	7,3 kg





UKB-UNIBEND AND UKB-WINGBEND PLUS

UKB-UniBend
Explanation 200-201
UniBend dies 201-202
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Technical data 204

UKB-UniBend VARIO
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UKB-WingBend PLUS
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Slider 210
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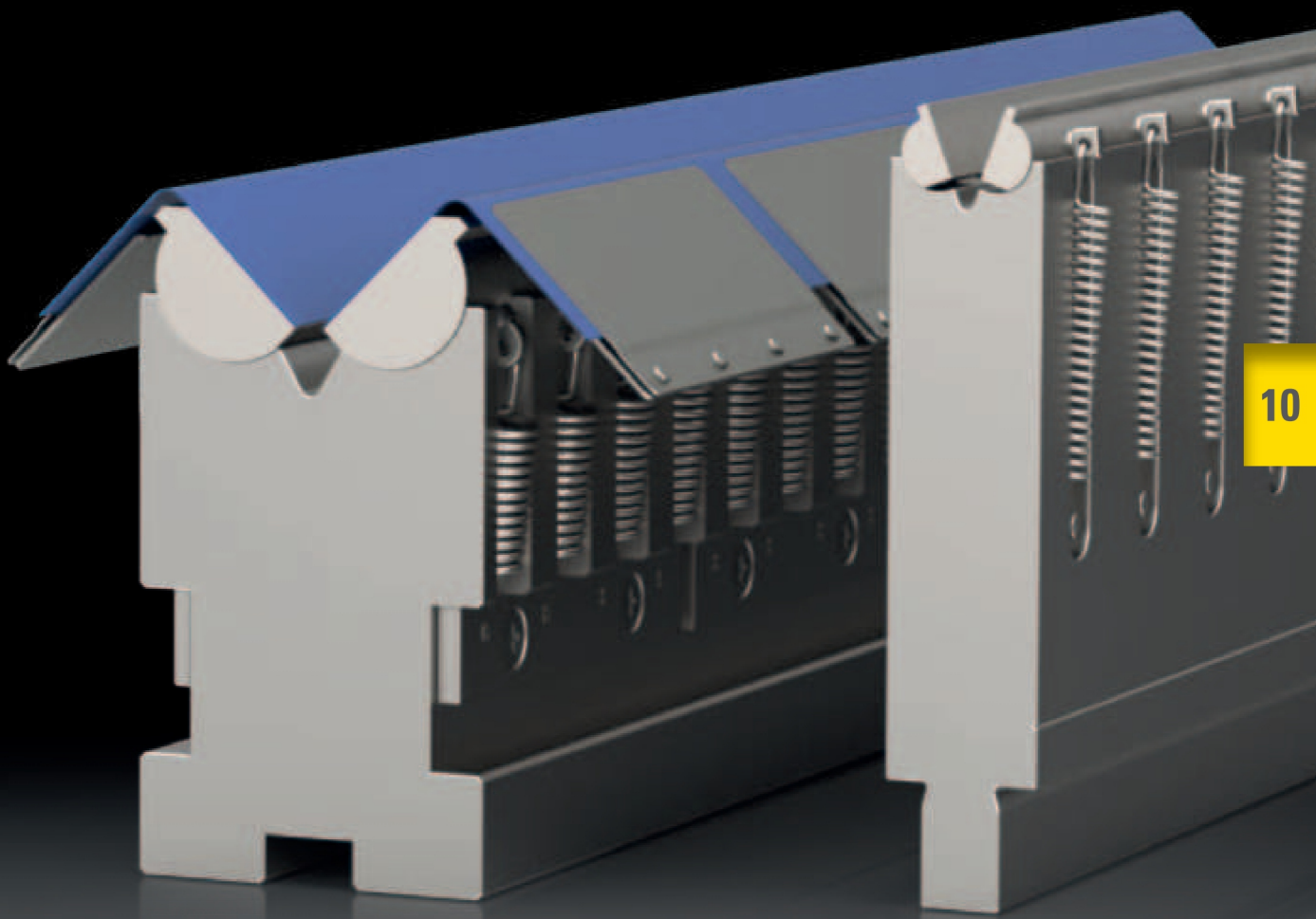

10

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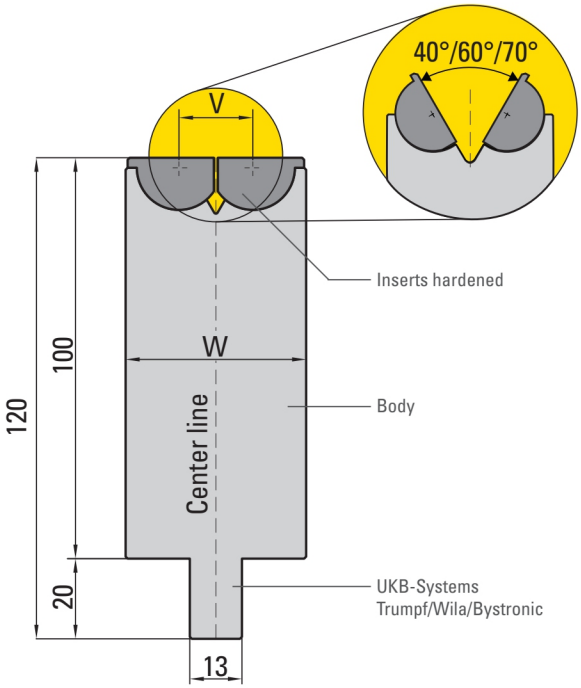
UNIBEND

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 **perforated 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**

VIDEO

UKB-UniBend and UKB-WingBend PLUS

VIDEO

UKB-Image

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **Delivery time:** UKB-UniBend dies in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

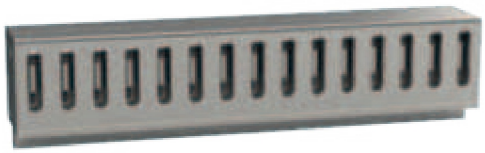
Standard:	1 - 3 working days by parcel service or forwarder
Express:	According agreement
Direct courier:	According agreement

- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

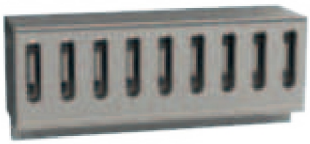
Tool lengths

DIES

500 mm



300 mm



200 mm

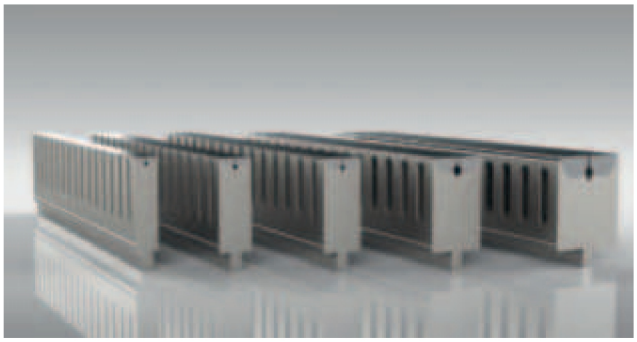


100 mm



50 mm





Dies UniBend 29.000, 29.100, 29.150, 29.200 and 29.300

EXAMPLE OF USE



Holder for blades 15.755 with 28° blade (see page 178)

Holes close to the bending line without deformation

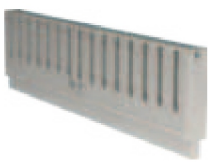
UniBend die 29.000

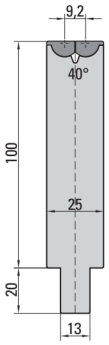
UniBend dies

29.000		24h 1000 kN/m
500 mm	10,0 kg	1.768,– €
300 mm	6,0 kg	1.288,– €
200 mm	4,0 kg	964,– €
100 mm	2,0 kg	644,– €
50 mm	1,0 kg	430,– €

Recommended material thicknesses:
R_m = 450 N/mm² max. 2,0 mm
R_m = 700 N/mm² max. 1,5 mm

SCAN TO SHOP

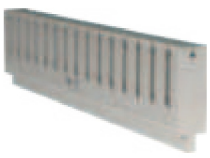


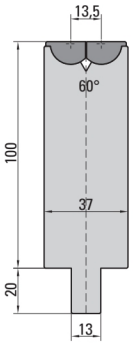


29.100		24h 1300 kN/m
500 mm	14,0 kg	1.930,– €
300 mm	8,4 kg	1.448,– €
200 mm	5,6 kg	1.072,– €
100 mm	2,8 kg	696,– €
50 mm	1,4 kg	484,– €

Recommended material thicknesses:
R_m = 450 N/mm² max. 3,0 mm
R_m = 700 N/mm² max. 2,0 mm

SCAN TO SHOP

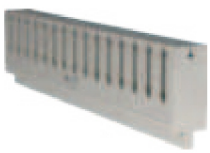


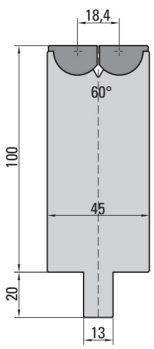


29.150		24h 1500 kN/m
500 mm	15,0 kg	2.170,– €
300 mm	9,0 kg	1.660,– €
200 mm	6,0 kg	1.232,– €
100 mm	3,0 kg	776,– €
50 mm	1,5 kg	510,– €

Recommended material thicknesses:
R_m = 450 N/mm² max. 4,0 mm
R_m = 700 N/mm² max. 3,0 mm

SCAN TO SHOP

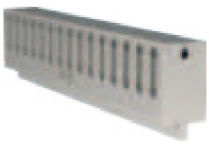


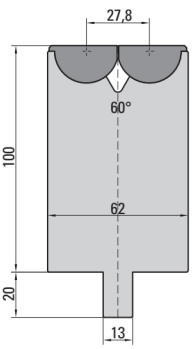


29.200		24h 1700 kN/m
500 mm	22,5 kg	2.412,– €
300 mm	13,5 kg	1.876,– €
200 mm	9,0 kg	1.394,– €
100 mm	4,5 kg	858,– €
50 mm	2,3 kg	536,– €

Recommended material thicknesses:
R_m = 450 N/mm² max. 5,0 mm
R_m = 700 N/mm² max. 4,0 mm

SCAN TO SHOP





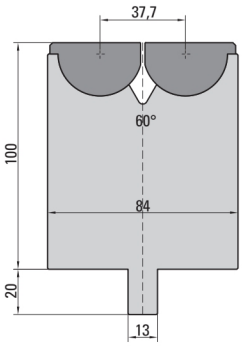
UniBend dies

29.300		24h 2000 kN/m
500 mm	29,0 kg	2.786,– €
300 mm	17,4 kg	2.090,– €
200 mm	11,6 kg	1.502,– €
100 mm	5,8 kg	964,– €
50 mm	2,9 kg	662,– €

Recommended material thicknesses:
R_m = 450 N/mm² max. 6,0 mm
R_m = 700 N/mm² max. 5,0 mm

SCAN TO SHOP



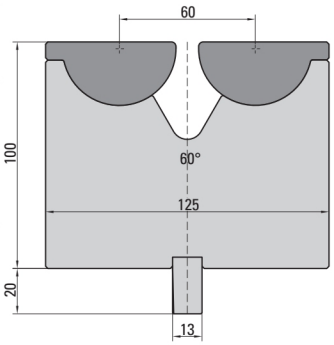


29.600		24h 2000 kN/m
500 mm	45,3 kg	3.200,– €
300 mm	27,2 kg	2.428,– €
200 mm	18,2 kg	1.834,– €
100 mm	9,1 kg	1.104,– €

Recommended material thicknesses:
R_m = 450 N/mm² max. 8,0 mm
R_m = 700 N/mm² max. 6,0 mm

SCAN TO SHOP



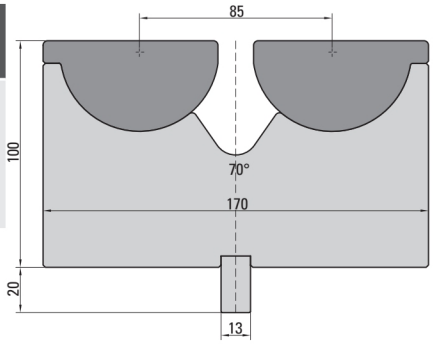


29.850		24h 2500 kN/m
500 mm	61,5 kg	3.660,– €
300 mm	36,8 kg	2.762,– €
200 mm	24,6 kg	2.042,– €
100 mm	12,3 kg	1.270,– €

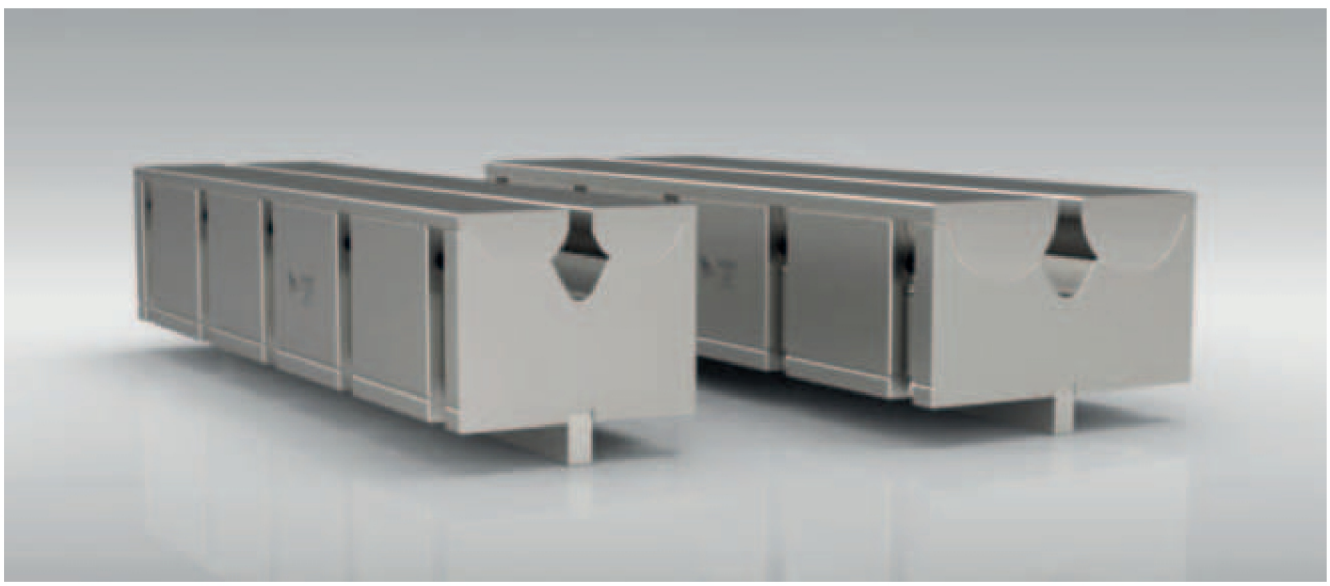
Recommended material thicknesses:
R_m = 450 N/mm² max. 12,0 mm
R_m = 700 N/mm² max. 10,0 mm

SCAN TO SHOP





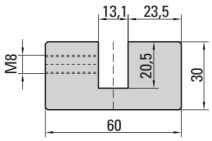




Die adaptors

60.910 — 24h — 1000 kN/m

1000 mm	12,0 kg	236,– €
500 mm	6,0 kg	136,– €



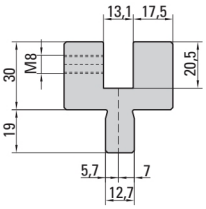
UKB-System Amada ➔
UKB-Systems Trumpf/Wila/Bystronic

SCAN TO SHOP



60.935 — 24h — 1000 kN/m

1000 mm	11,0 kg	422,– €
500 mm	5,5 kg	232,– €



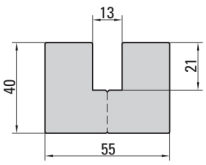
UKB-System LVD ➔
UKB-Systems Trumpf/Wila/Bystronic

SCAN TO SHOP



60.940 — 24h — 1000 kN/m

500 mm	7,5 kg	278,– €



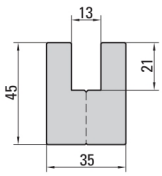
UKB-System EHT ➔
UKB-Systems Trumpf/Wila/Bystronic

SCAN TO SHOP



60.950 — 24h — 1000 kN/m

500 mm	5,1 kg	258,– €

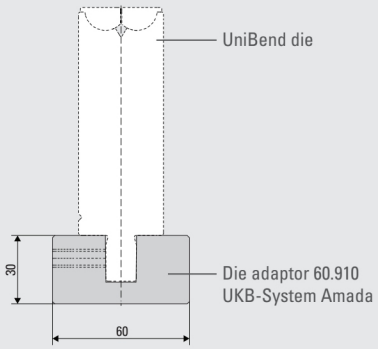


UKB-System Weinbrenner ➔
UKB-Systems Trumpf/Wila/Bystronic

SCAN TO SHOP



EXAMPLE OF USE



Lubricating grease

40.629 — 24h

100 ml	28,– €

SCAN TO SHOP



For lubrication of UniBend dies



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	F in kN/m						1350
Material thickness 12,0 mm							1630

DOWNLOAD

Manual UKB-UniBend

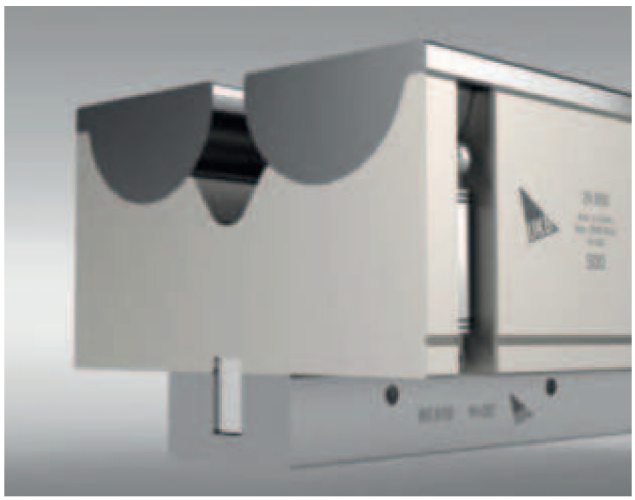
Reference value for minimum flange: mild steel

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	Flange in 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 29.150 and die adaptor 60.910



Die UniBend 29.850 and die adaptor 60.910

UniBend VARIO die

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

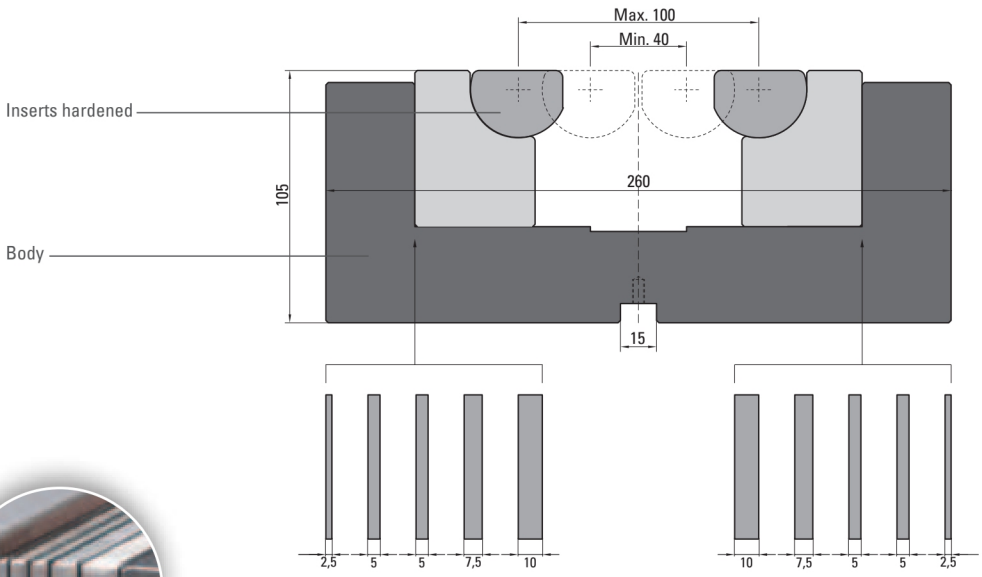
VIDEO
UKB-UniBend and UKB-WingBend PLUS

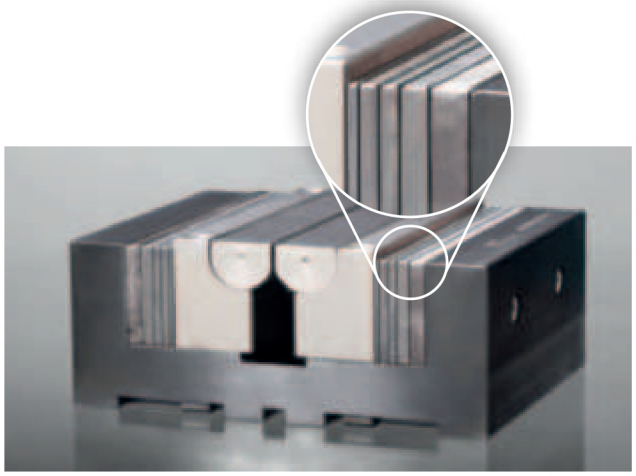
62.094	24h 1500 kN/m	
200 mm	40,0 kg	2.992,– €

UniBend VARIO die 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

SCAN TO SHOP







Strips inserted, V = 40 mm



Without strips, V = 100 mm







Bending results with die UniBend VARIO

Die holders

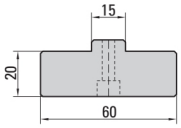
UKB-SYSTEM AMADA

60.102 24h

200 mm | 2,1 kg | 90,– €

Screwed on holder

SCAN TO SHOP





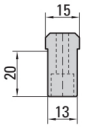
UKB-SYSTEMS TRUMPF/WILA/BYSTRONIC

60.103 24h

200 mm | 0,6 kg | 58,– €

Screwed on holder

SCAN TO SHOP





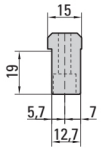
UKB-SYSTEM LVD

60.105 24h

200 mm | 0,5 kg | 58,– €

Screwed on holder

SCAN TO SHOP





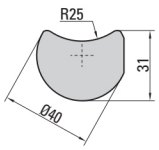
Changeable inserts

62.181 24h

200 mm | 1,5 kg | 286,– €

Insert type concave for 62.094
Price per piece

SCAN TO SHOP



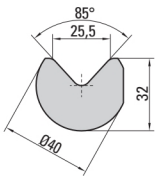


62.182 24h

200 mm | 1,4 kg | 286,– €

Insert type V for 62.094
Price per piece

SCAN TO SHOP



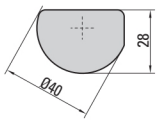


62.183 24h

200 mm | 1,5 kg | 232,– €

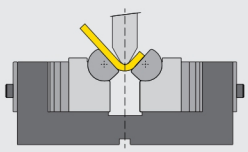
Insert type flat for 62.094
Price per piece

SCAN TO SHOP





EXAMPLE OF USE



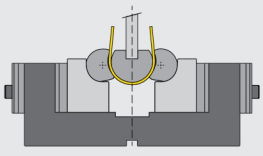
V-bending



inserts type flat



Result



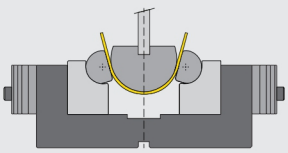
Radius bending/overbending



inserts type concave



Result



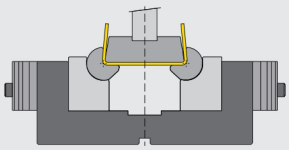
Radius-bending



inserts type flat



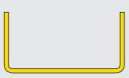
Result



U-bending



inserts type V

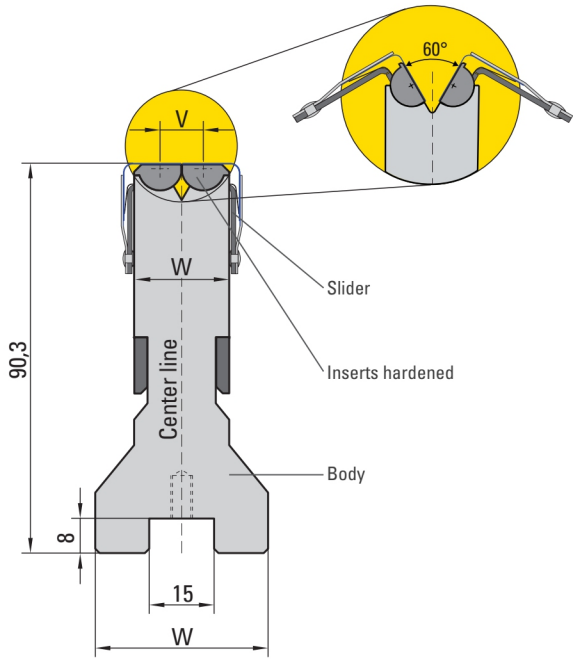


Result

WINGBEND PLUS

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

- **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 **perforated 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**

VIDEO

UKB-UniBend and UKB-WingBend PLUS

10

UKB-ADVANTAGES

VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **Delivery time:** UKB-WingBend PLUS dies in **24 h**
- **Shipping:** Orders placed before 4:00pm on the same working day
- **Delivery service:**

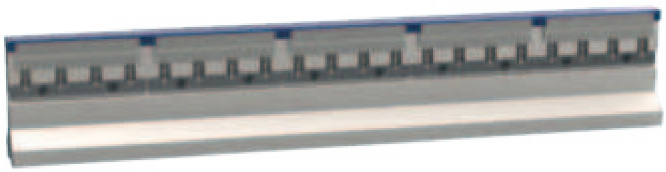
Standard:	1 - 3 working days by parcel service or forwarder
Express:	According agreement
Direct courier:	According agreement

- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

Tool lengths

DIES

500 mm



200 mm



100 mm



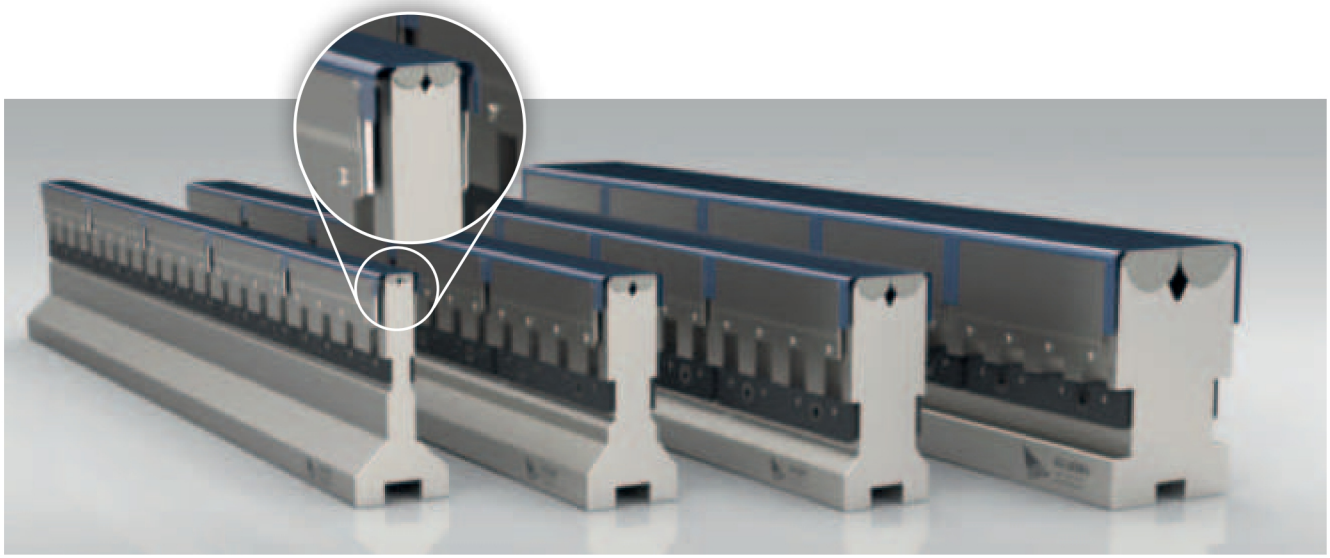
50 mm



90 mm sectionalized



▸ 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

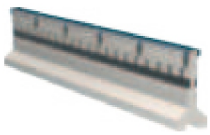
WingBend PLUS dies

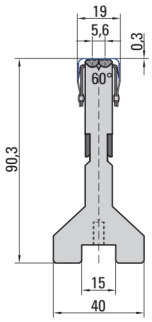
62.120 — 24h — 500 kN/m

500 mm	5,5 kg	1.958,– €
200 mm	2,2 kg	982,– €
100 mm	1,1 kg	706,– €
50 mm	0,6 kg	386,– €
90 mm sectionalized	1,0 kg	1.542,– €

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

SCAN TO SHOP



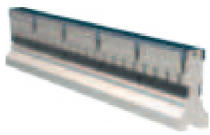


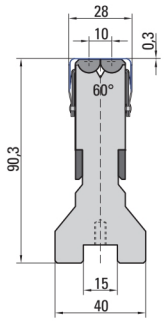
62.230 — 24h — 700 kN/m

500 mm	8,0 kg	2.138,– €
200 mm	3,2 kg	1.010,– €
100 mm	1,6 kg	722,– €
50 mm	0,8 kg	408,– €
90 mm sectionalized	1,5 kg	1.622,– €

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

SCAN TO SHOP



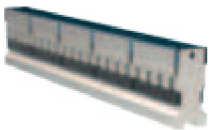


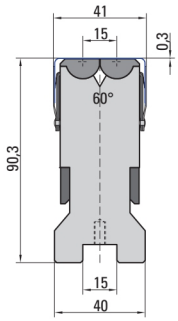
62.350 — 24h — 1000 kN/m

500 mm	8,3 kg	2.314,– €
200 mm	4,1 kg	1.302,– €
100 mm	2,1 kg	940,– €
50 mm	1,1 kg	508,– €

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

SCAN TO SHOP



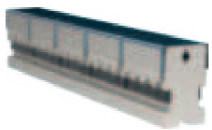


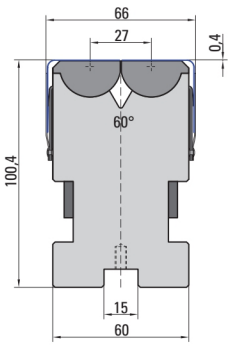
62.650s — 24h — 1500 kN/m

500 mm	18,0 kg	3.310,– €
200 mm	7,2 kg	1.374,– €
100 mm	3,6 kg	968,– €
50 mm	1,8 kg	534,– €

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

SCAN TO SHOP





Die holders

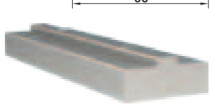
UKB-SYSTEM AMADA

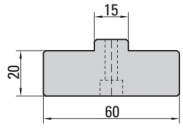
60.102 — 24h

500 mm	5,2 kg	204,– €
200 mm	2,1 kg	90,– €
100 mm	1,0 kg	78,– €
50 mm	0,5 kg	74,– €
90 mm sectionalized	0,9 kg	180,– €

Screwed on holder

SCAN TO SHOP





UKB-SYSTEMS TRUMPF/WILA/BYSTRONIC

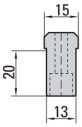
60.103 — 24h

500 mm	1,5 kg	132,– €
200 mm	0,6 kg	58,– €
100 mm	0,3 kg	50,– €
50 mm	0,2 kg	48,– €
90 mm sectionalized	0,3 kg	150,– €

Screwed on holder

SCAN TO SHOP





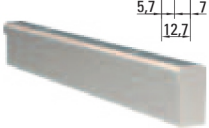
UKB-SYSTEM LVD

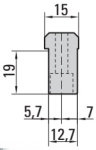
60.105 — 24h

500 mm	1,5 kg	132,– €
200 mm	0,5 kg	58,– €
100 mm	0,3 kg	50,– €
50 mm	0,2 kg	48,– €
90 mm sectionalized	0,3 kg	150,– €

Screwed on holder

SCAN TO SHOP





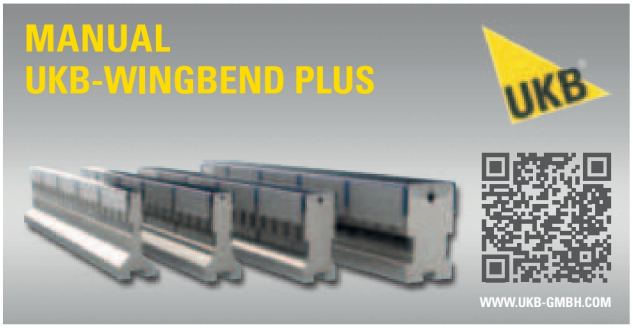
Lubricating grease

40.629	24h
100 ml	28,– €

SCAN TO SHOP

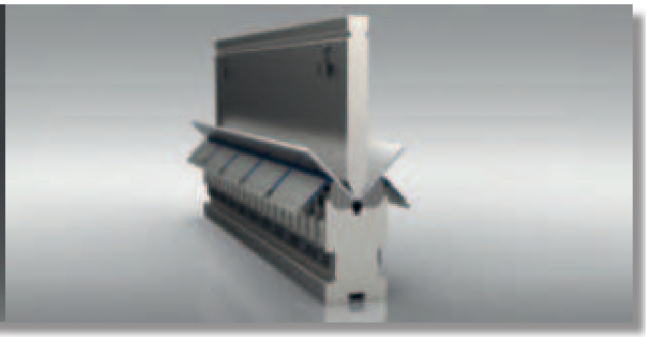


For lubrication of WingBend PLUS dies



UKB-TEST BENDING

- First test bending – then order!
- With your sample sheets in your house or in the UKB-Test Center
- Free of charge!



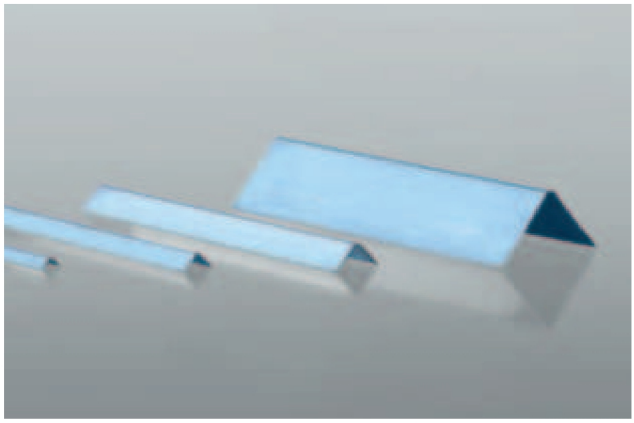
Slider

Slider 24h

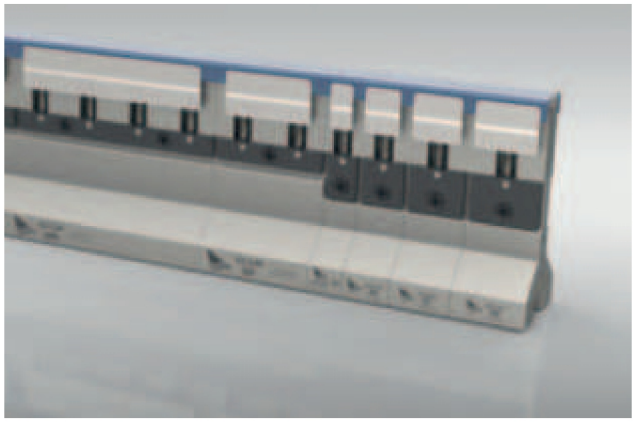
for Model	available in one piece up to length	MORE INFORMATION WWW.UKB-GMBH.DE
62.120	2000 mm	
62.230	3000 mm	
62.350	3000 mm	
62.650s	3000 mm	

Product advantages

- Avoids bending marks on sheets
- Slider up to a length of 3000 mm available
- Available from stock



Slider for models 62.120, 62.230, 62.350 and 62.650s



Model 62.120 with continously Slider

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	F in kN/m								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	Flange in 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

DOWNLOAD

Manual UKB-WingBend PLUS

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The comparison: Bending results with WingBend PLUS and standard-V-die

UKB-ADJUSTABLE DIES

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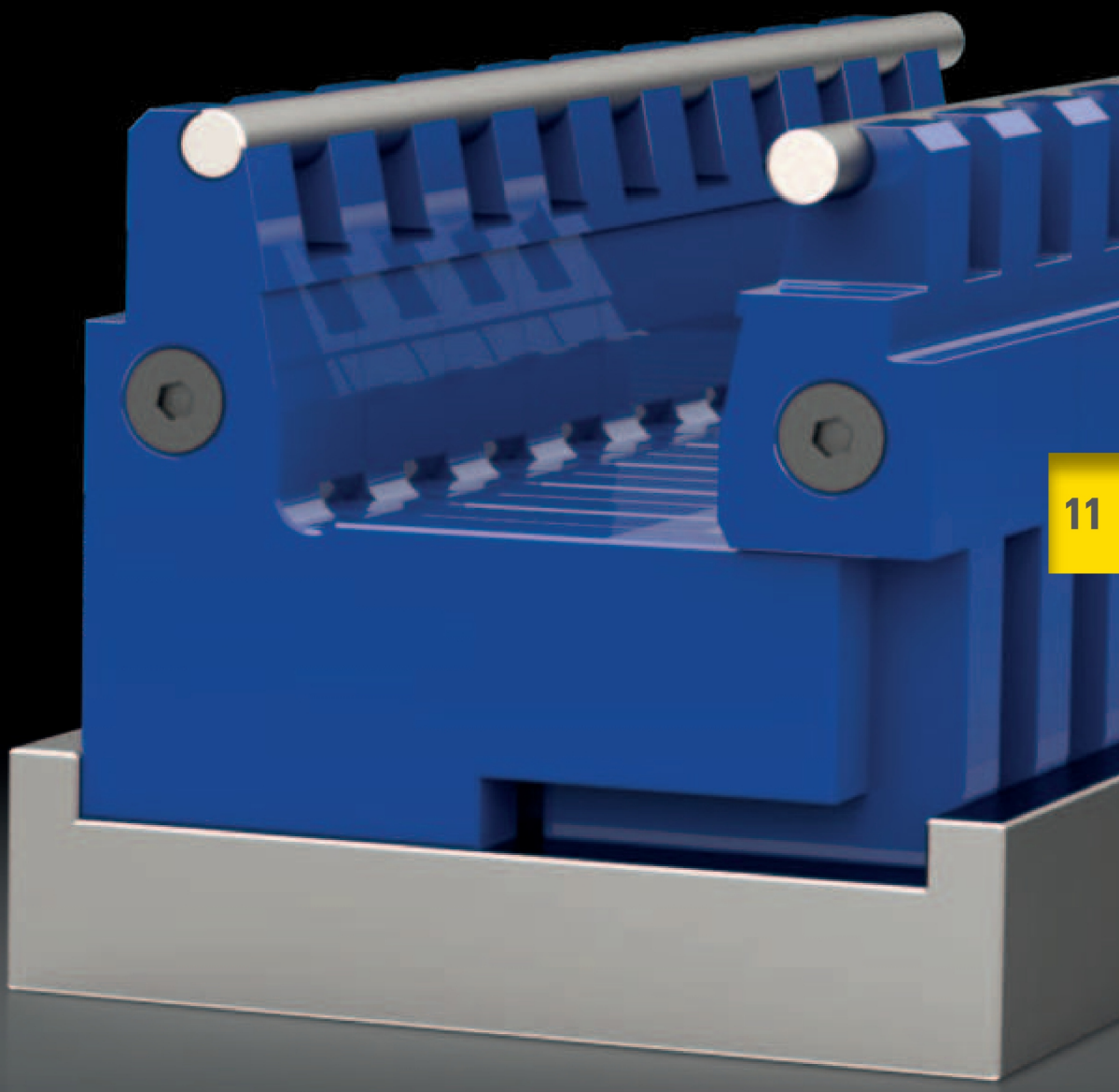

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WWW.UKB-GMBH.COM

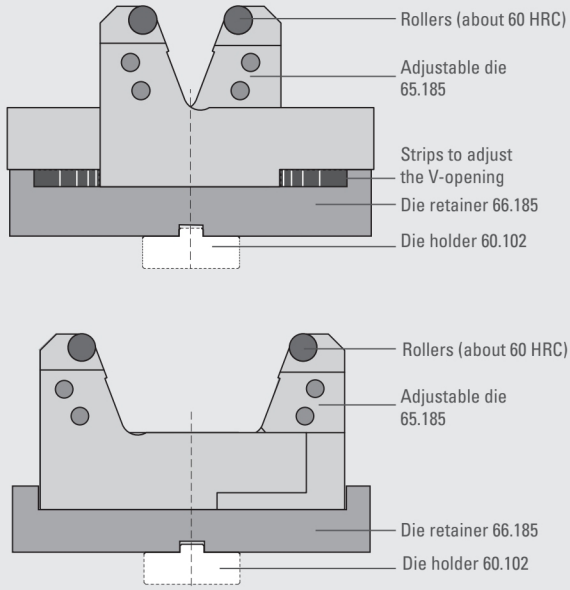
ADJUSTABLE DIES

Quality and precision

- **Optimum materials**
- **Hardened rollers**
- **Precision ground**
- **Guaranteed exchangeability and parallelism**

EXAMPLE OF USE

Minimum and maximum V-opening



Product advantages

- **Variable adjustable V-openings**
  - 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

VIDEO

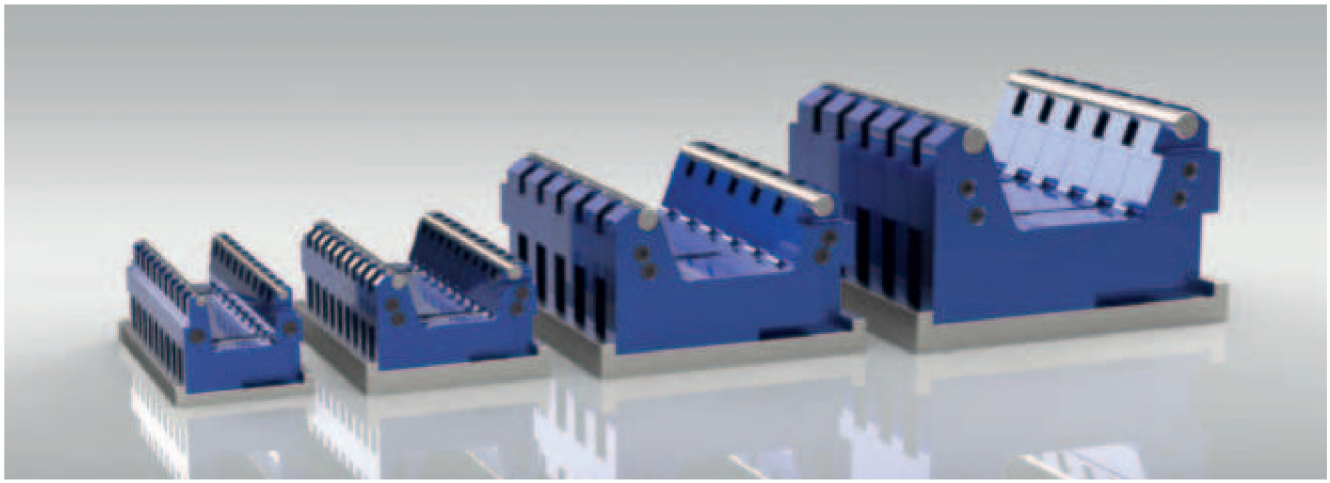
UKB-Image

UKB-ADVANTAGES

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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:	According agreement
Direct courier:	According agreement

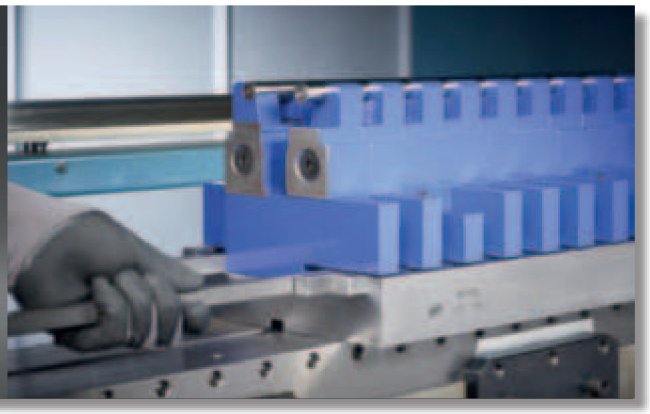
- **Package:** Ecologically sensitive and safe – with self recycled packing material
- **Payment options:** 14 days 2% cash-discount, 30 days net

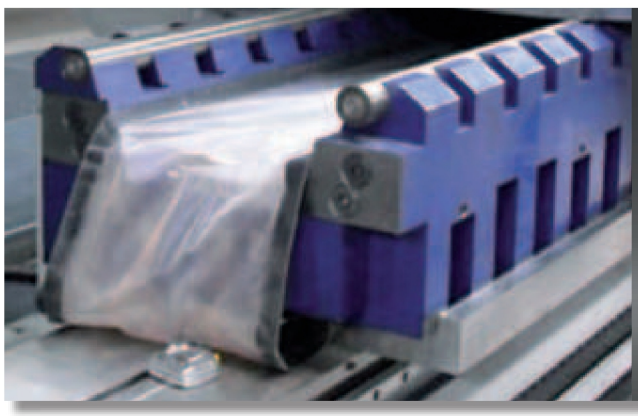


Adjustable dies 65.125, 65.185, 65.300 and 65.400

STRIPS TO ADJUST THE V-OPENING WIDTH

- For variable adjustable V-openings
- Availabe up to a length of L = 3000 mm!





DUST PROTECTION FILM

- The use of the dust protection film is recommended
- Protects the inside of the die
- No blockade of the die through tinder, dust, etc.
- Adjustment via hook-and-loop tape

UKB-TEST BENDING

- First test bending - then order!
- With your sample sheets in your house or in the UKB-Test Center
- Free of charge!



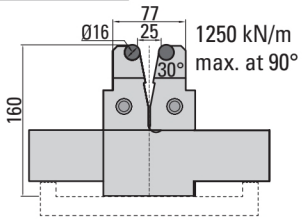
ADJUSTABLE DIES

Adjustable dies V25 – V125

65.125		24h 1250 kN/m
250 mm	34,0 kg	822,– €
500 mm	64,0 kg	1.510,– €
1000 mm	125,0 kg	2.838,– €

- 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

SCAN TO SHOP



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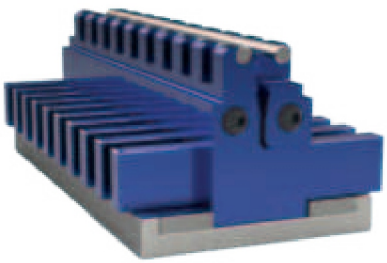
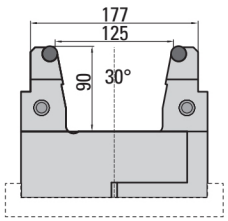




Opened

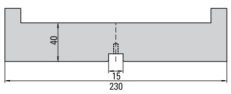


Die retainer

66.125		24h
500 mm	38,0 kg	400,– €

SCAN TO SHOP

For model 65.125

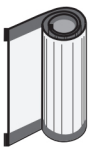


Dust protection film

67.125		24h
5 m	1,0 kg	94,– €

SCAN TO SHOP

For model 65.125



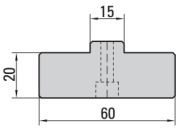
Die holders

UKB-SYSTEM AMADA

60.102		24h
500 mm	5,2 kg	204,– €

Screwed on holder

SCAN TO SHOP



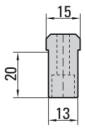


UKB-SYSTEMS TRUMPF/WILA/BYSTRONIC

60.103		24h
500 mm	1,5 kg	132,– €

Screwed on holder

SCAN TO SHOP



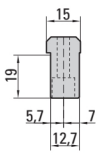


UKB-SYSTEM LVD

60.105		24h
500 mm	1,5 kg	132,– €

Screwed on holder

SCAN TO SHOP



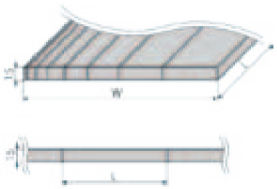


Strips to adjust the V-opening width

66.000 H = 15		24h
2050 mm	84,0 kg	664,– €
1550 mm	63,0 kg	522,– €
1050 mm	42,0 kg	360,– €
500 mm	21,0 kg	182,– €

SCAN TO SHOP

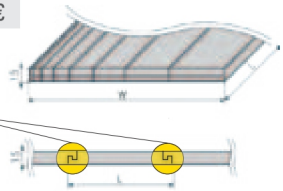
For model 65.125
Strips in a set:
Width = 2 x each 2/5/10/15/20/30/40/50 mm



66.001 H = 15		24h
1010 mm	42,5 kg	560,– €
510 mm	21,5 kg	382,– €

SCAN TO SHOP

For model 65.125
Strips in a set:
Width = 2 x each 2/5/10/15/20/30/40/50 mm
Advantage: Incl. connection groove

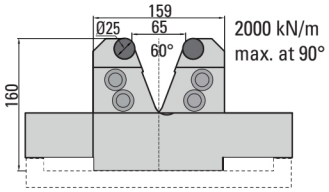


Adjustable dies V65 – V185

65.185	24h 2000 kN/m	
250 mm	44,0 kg	1.008,– €
500 mm	86,0 kg	1.888,– €
1000 mm	170,0 kg	3.522,– €

- α = max. 60°
- Radius of the rollers R = 12,5 mm
- Recommended material thicknesses: about 6 - 20 mm at a tensile strength R_m = 450 N/mm²

SCAN TO SHOP



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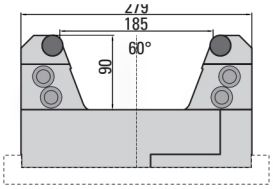


Opened



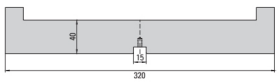


Die retainers

66.185	24h	
500 mm	53,0 kg	552,– €

SCAN TO SHOP

For model 65.185

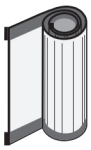


Dust protection film

67.185	24h	
5 m	1,0 kg	102,– €

SCAN TO SHOP

For model 65.185



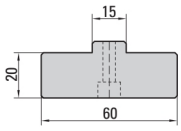
Die holders

UKB-SYSTEM AMADA

60.102	24h	
500 mm	5,2 kg	204,– €

Screwed on holder

SCAN TO SHOP



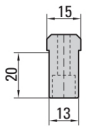


UKB-SYSTEMS TRUMPF/WILA/BYSTRONIC

60.103	24h	
500 mm	1,5 kg	132,– €

Screwed on holder

SCAN TO SHOP



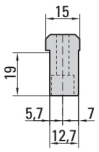


UKB-SYSTEM LVD

60.105	24h	
500 mm	1,5 kg	132,– €

Screwed on holder

SCAN TO SHOP



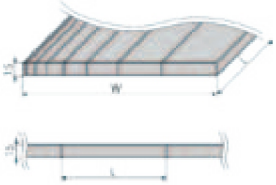


Strips to adjust the V-opening width

66.000 H = 15	24h	
2050 mm	84,0 kg	664,– €
1550 mm	63,0 kg	522,– €
1050 mm	42,0 kg	360,– €
500 mm	21,0 kg	182,– €

SCAN TO SHOP

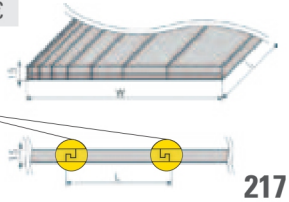
For model 65.185
Strips in a set:
Width = 2 x each 2/5/10/15/20/30/40/50 mm



66.001 H = 15	24h	
1010 mm	42,5 kg	560,– €
510 mm	21,5 kg	382,– €

SCAN TO SHOP

For model 65.185
Strips in a set:
Width = 2 x each 2/5/10/15/20/30/40/50 mm
Advantage: Incl. connection groove



ADJUSTABLE DIES

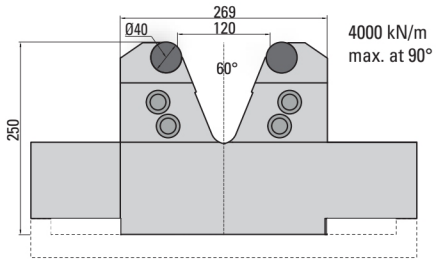
Adjustable dies V120 – V300

65.300 4000 kN/m

600 mm	360,0 kg	on request

- α = max. 60°
- Radius of the rollers R = 20 mm
- Recommended material thicknesses: about 8 - 30 mm at a tensile strength R_m = 450 N/mm²

SCAN TO SHOP



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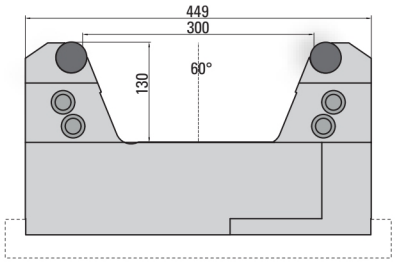

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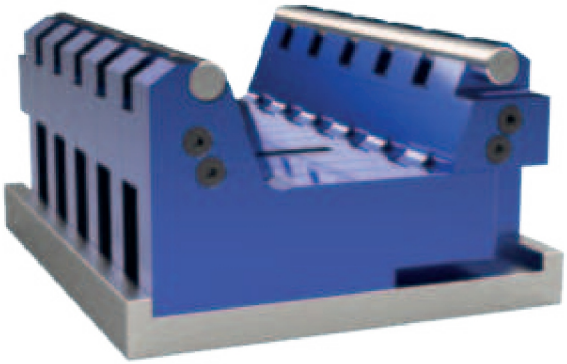
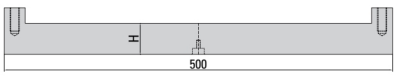


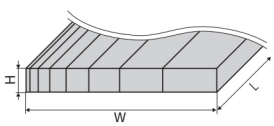
Die retainer

Die retainer suitable for your press brake
On request



Strips to adjust the V-opening width

Strips to adjust the V-opening width we produce individually according to your specifications
On request



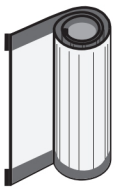
Dust protection film

67.300

5 m	1,0 kg	On request

SCAN TO SHOP

For model 65.300



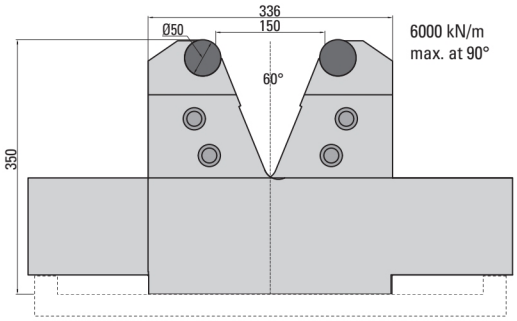
Adjustable dies V150 – V400

65.400 6000 kN/m

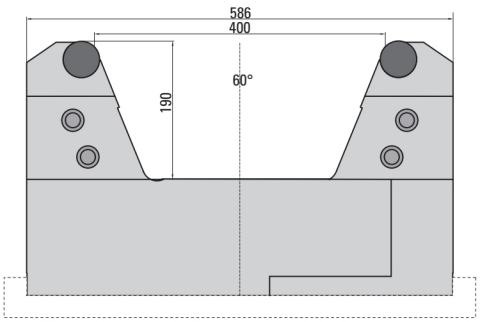
600 mm	560,0 kg	on request

- 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

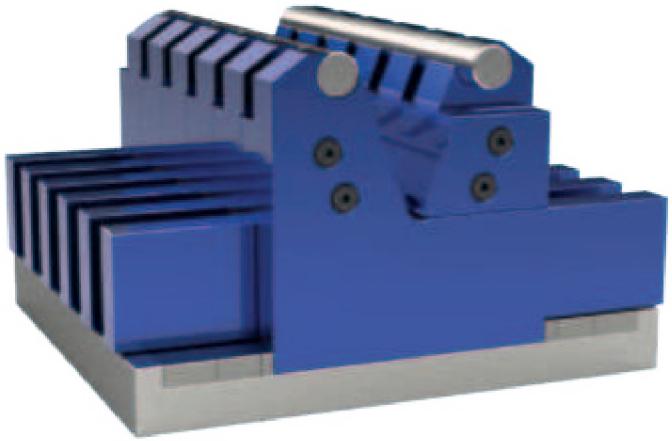
SCAN TO SHOP

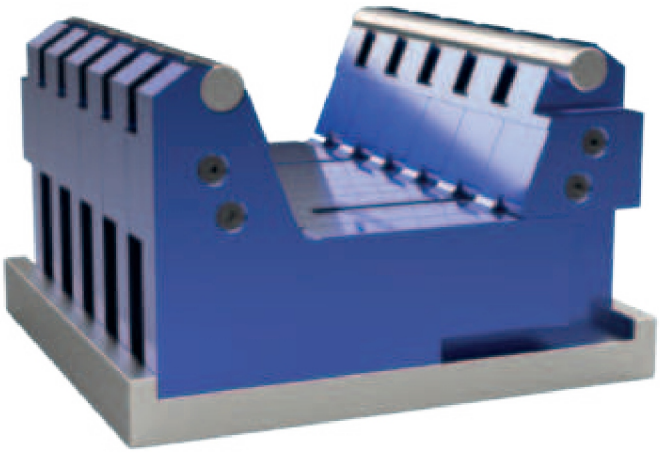


Closed



Opened

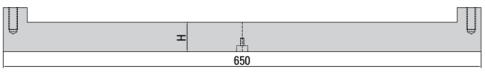




11

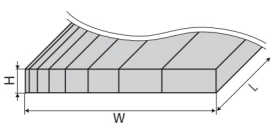
Die retainer

Die retainer suitable for your press brake
On request



Strips to adjust the V-opening width

Strips to adjust the V-opening width we produce individually according to your specifications
On request



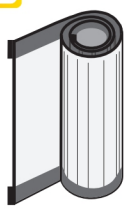
Dust protection film

67.400

5 m	1,0 kg	On request

SCAN TO SHOP

For model 65.400



UKB-SPECIAL TOOLS

Explanation 222-223
UKB-Full service for special tools 224-229
U-bending tools 230-231
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Hinge tools 234-235
Beading tools 236
Beading tools for long bead rib 237
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Radius embossing tools 239
Trapezoidal bending tools 240
Flattening tools 241
Louvre tools 242
More special tools 243-249





12

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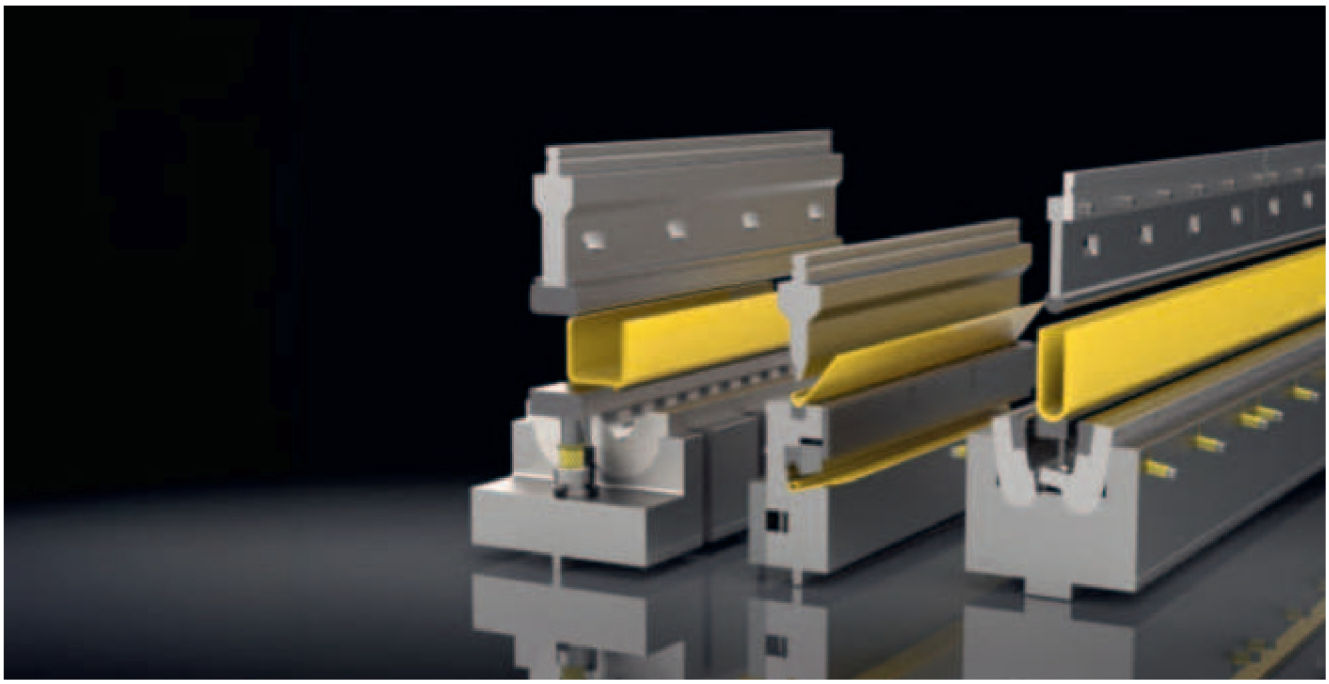
Quality and precision

- 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



UKB-ADVANTAGES

VIDEO

UKB-Image

- **Office hours:** From Monday to Friday from 7:30am to 5:00pm
- **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 options:** 14 days 2% cash-discount, 30 days net

Quality and precision

Due to permanent investments in the latest production technology we develop individual tool solutions for the most demanding applications. At UKB, the customer is at the centre of all projects – individually and competently supported.

From consultation and development, through construction and production until delivery – everything is done in-house.

EXSPECT THE BEST!

Some examples from our special tools portfolio

- U-bending tools
- Z-bending tools
- Hinge tools
- Beading tools
- Louvre tools
- Beading tools for long beadings
- Embossing-tools
- Trapezoidal bending tools
- Flattening tools
- Bending tools for closed profiles
- Special tools comprising of one, two or even more stations

VIDEO
UKB-Special tools I

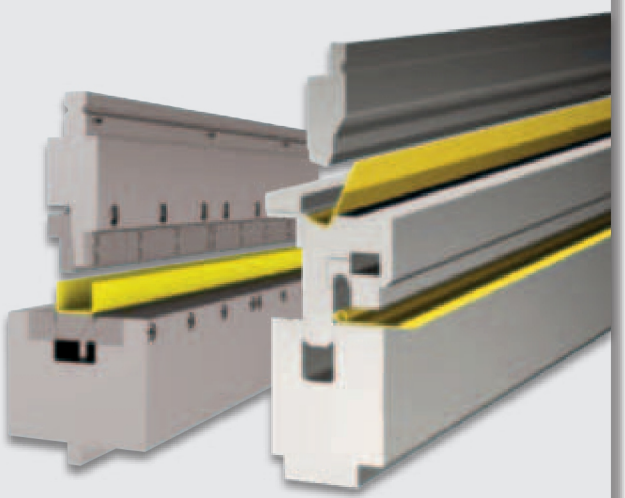
VIDEO
UKB-Special tools II

THE PERFECT SPECIAL TOOL FOR YOUR APPLICATION

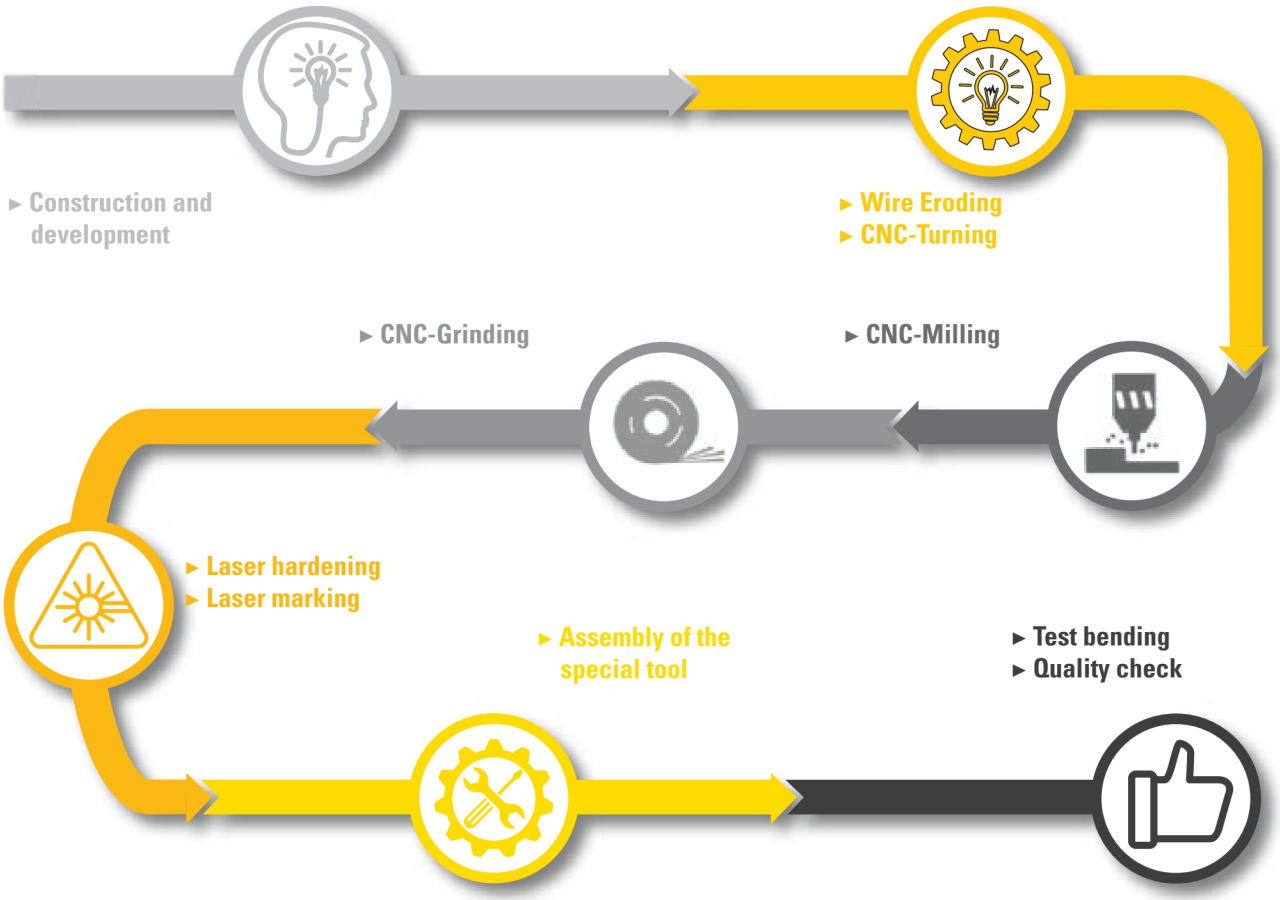
Challenge us!

PRODUCING MORE THAN STANDARD!

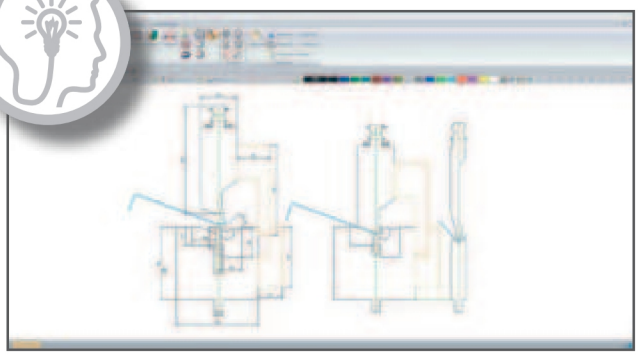
MORE EXAMPLES SEE
WWW.UKB-GMBH.COM



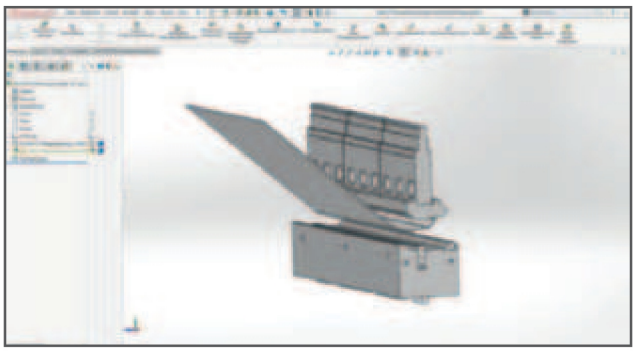
UKB-Full service for special tools



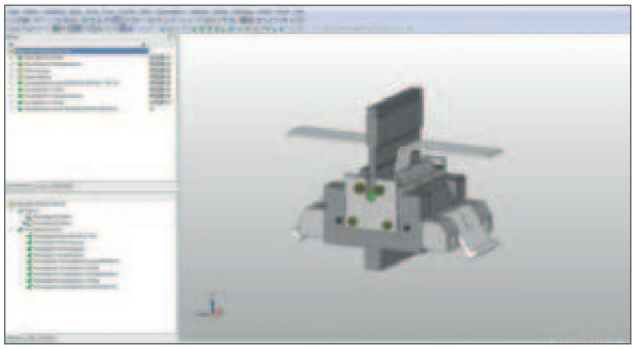
CONSTRUCTION AND DEVELOPMENT



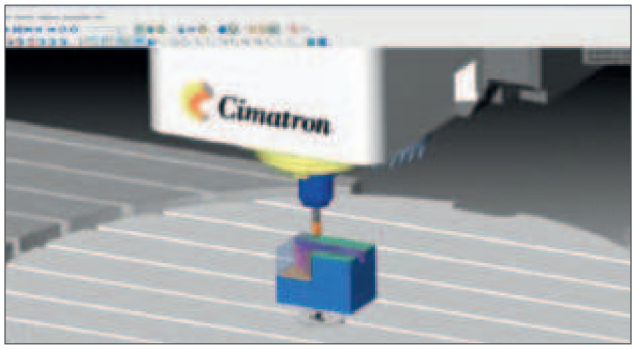
Software MEGACAD 2D/3D



Software SolidWorks 3D



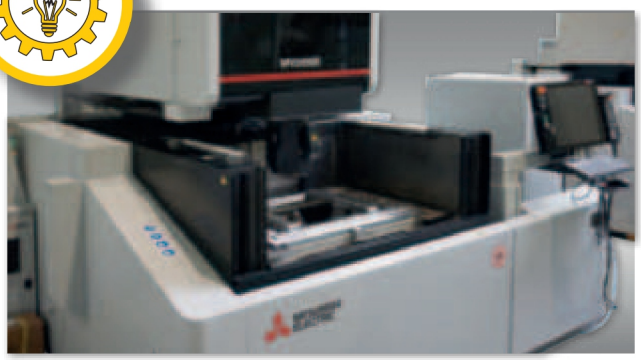
Software CIMATRON 3D

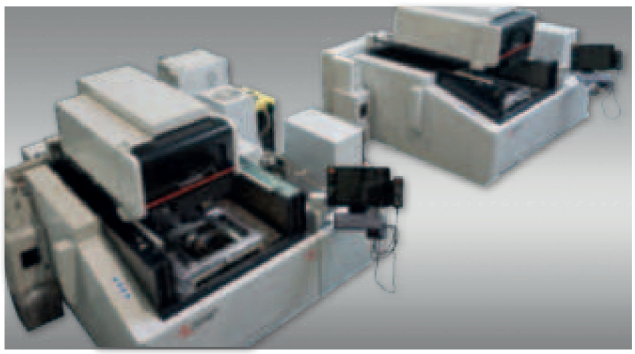


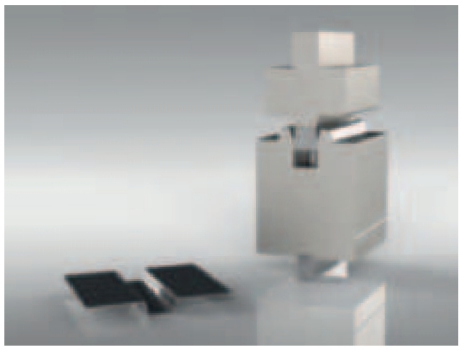
Software CIMATRON 3D NC-programming

After receiving the order, the proposed 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 this contour will be transferred to the production tool.

CNC-TURNING









TECHNICAL INFORMATION:

- 1 CNC- turning machine
- Traverse path:
  X = 307,5 mm
  Y = 60 mm
  Z = 1.140 mm

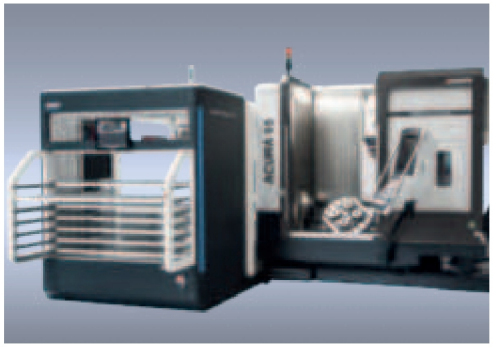
Due to a 6-sided complete machining with counter spindle and Y-axis, the CNC-turning can be precisely performed according to the specific requirements.

CNC-MILLING











TECHNICAL INFORMATION:

- 20 CNC-milling machines
- Traverse path:
  - X = 6.000 mm
  - Y = 1.250 mm
  - Z = 1.600 mm
- Simultaneous 5-axes 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.
Using the latest machines we produce the best results!

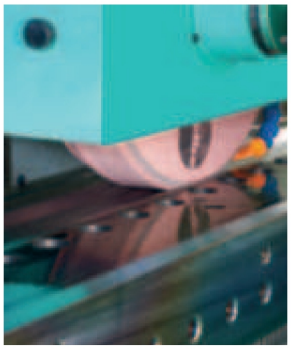
CNC-GRINDING











TECHNICAL INFORMATION:

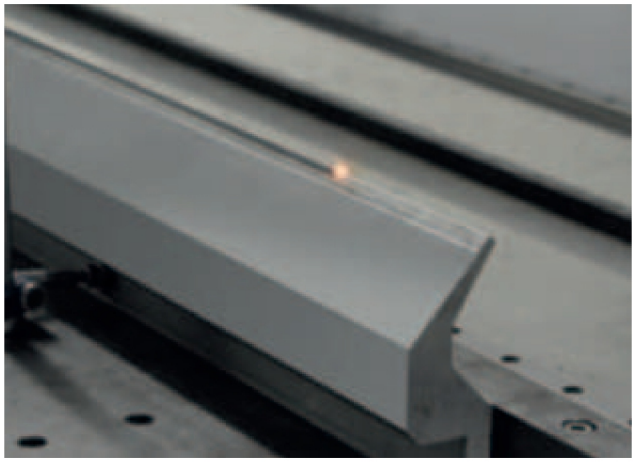
- 8 CNC-profile grinding machines
- 3 CNC-flat grinding machines
- Traverse path:
  X = 6.000 mm
  Y = 800 mm
  Z = 800 mm

The bending contour and the active surfaces of the special tool will be precision ground.
The grinding wheels are profiled according to your demands.
For precise tasks we are perfectly equipped!

SPECIAL TOOLS

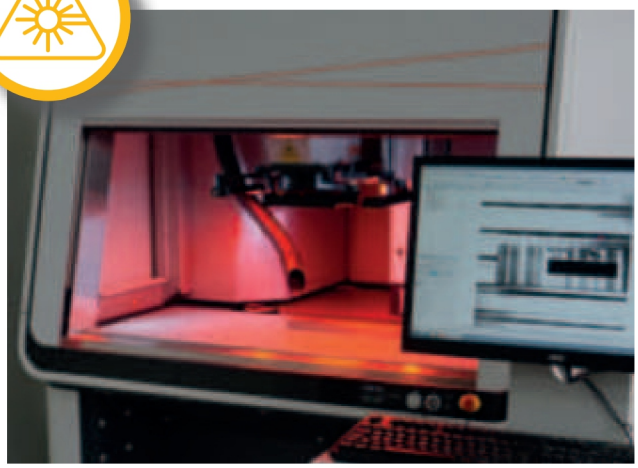
LASER HARDENING





In accordance to the purpose, our special tools will be laser hardened, through hardened or nitrated.

LASER MARKING





The flexibile laser marking system allows customer-specific marking such as internal tool-numbers to be added.

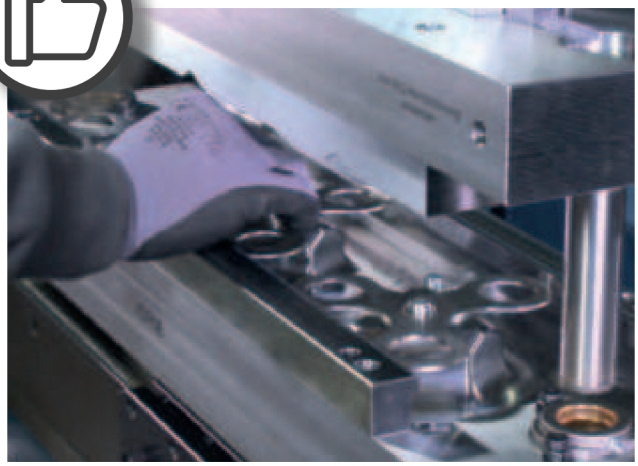
ASSEMBLY OF THE SPECIAL TOOL

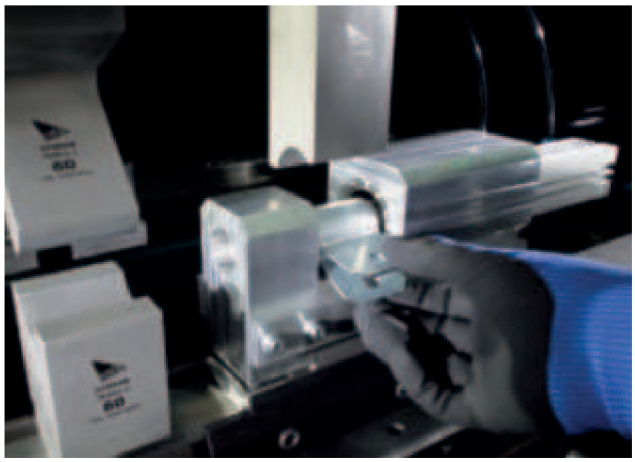




The single components will be assembled and aligned to each other.

TEST BENDING





Finally the functional test will be done with your sample sheets. Test bending will be performed on our press brakes (up to L = 4050 mm, up to 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.

UKB-FIELD SERVICE

- Individual advice and sale
- Test bending in your house or at the UKB-Test Center
- Tool demonstrations
- Pick up service for tools to rework

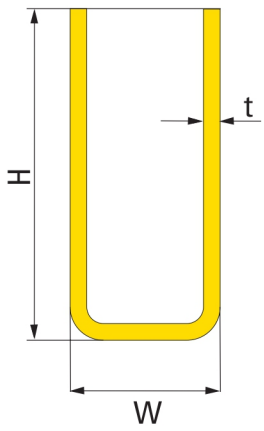
CHAPTER 19

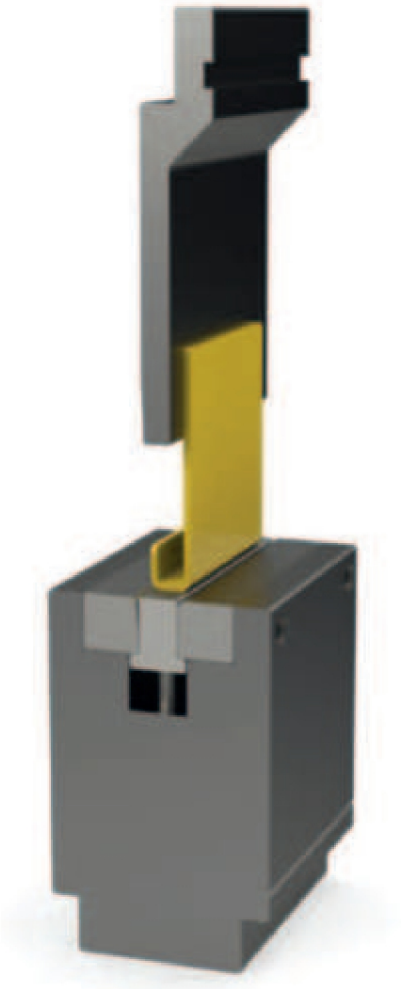


U-bending tools

ADVANTAGES

- Production in one step
- Easy removal of the profiles
- Small inside measurements with high flanges of the profiles possible
- Process stability
- Reduction of marks through spring loaded ejector
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets

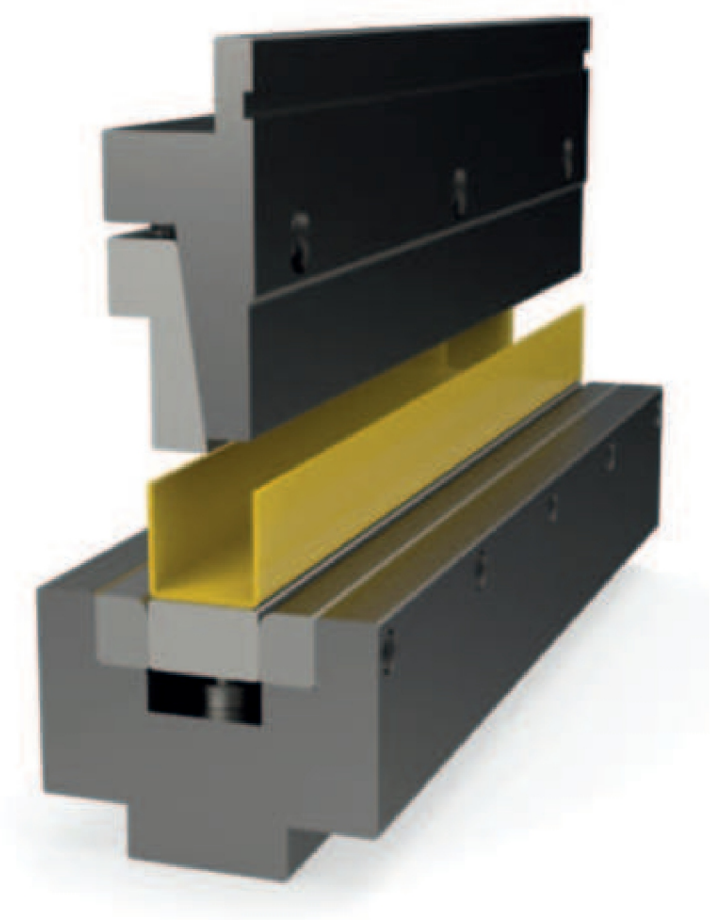




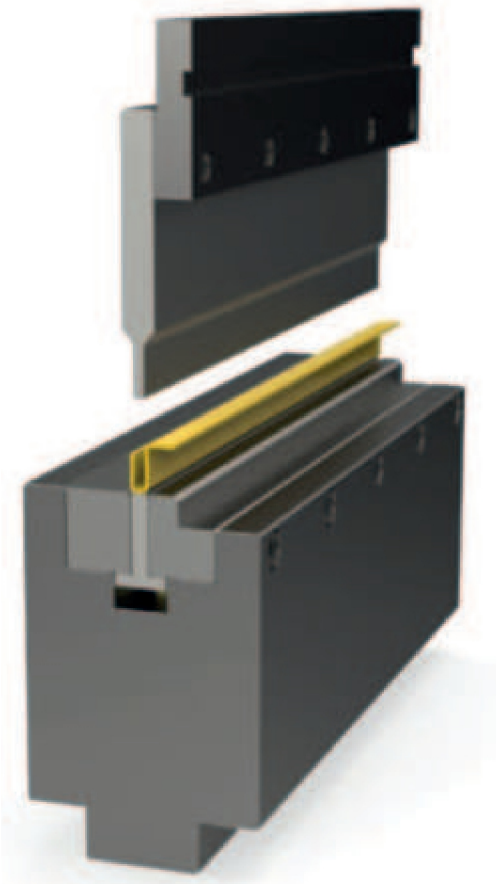
U-bending tool for profiles
with small inner dimensions

EXAMPLES FOR U-BENDING TOOLS

► Other shapes and layouts are manufactured individually according to your specifications



U-bending tool
with spring-loaded upper part
for process-reliable removal

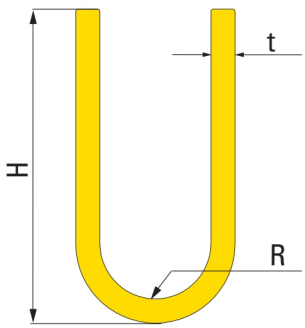


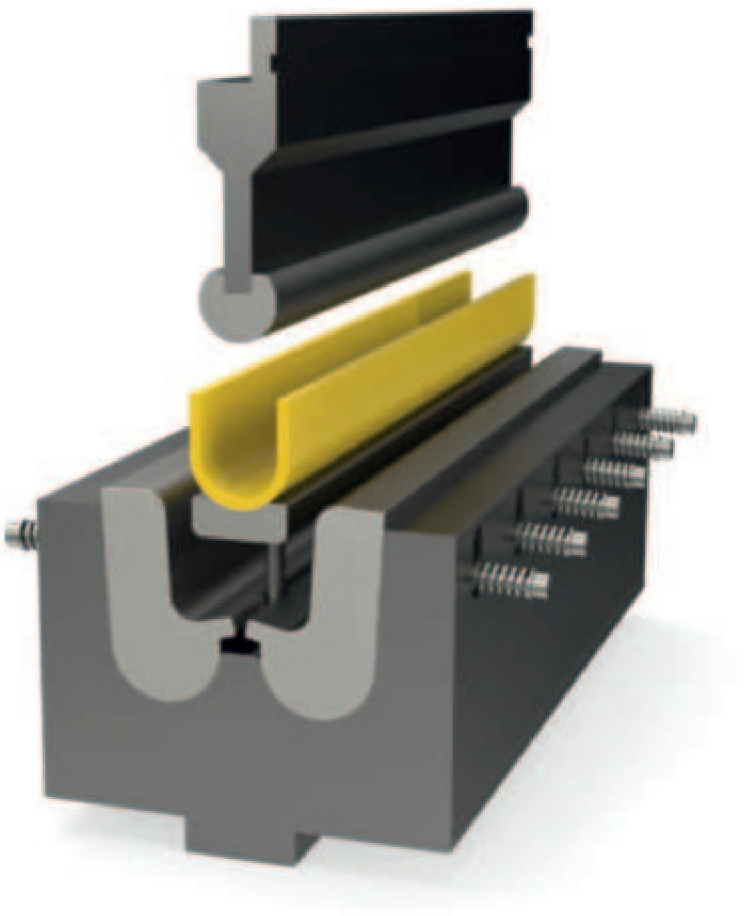
U-bending tool for small profiles
with close 90° flanges

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 compensate the springback of the profiles
- Reduction of bending marks through use of spring-loaded ejector or counter support
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets

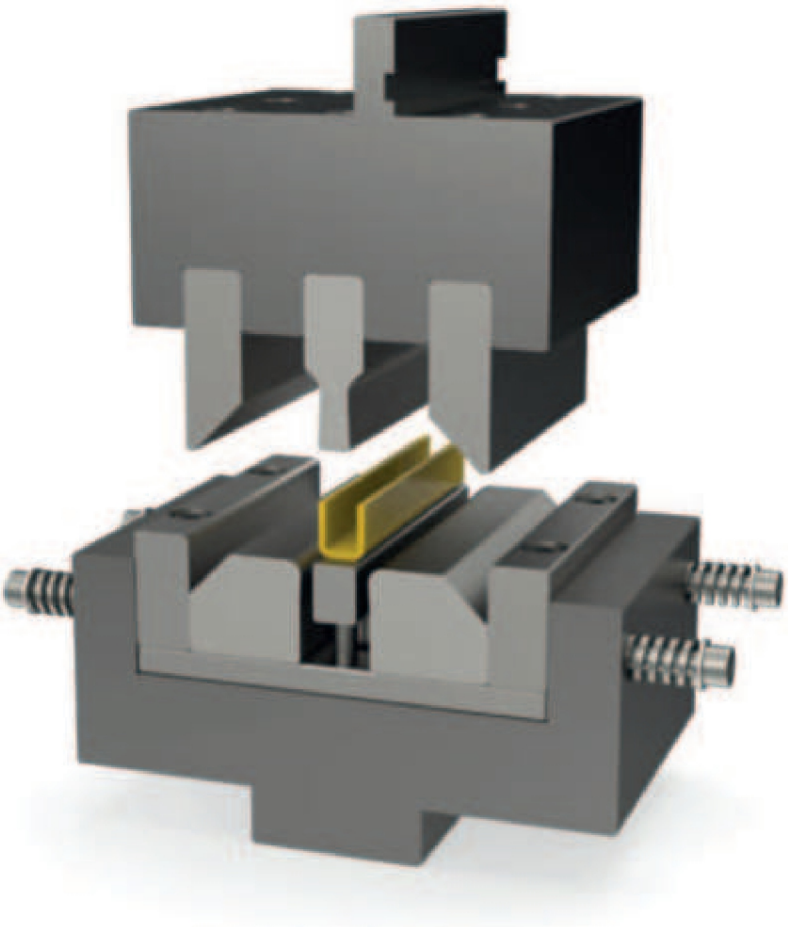




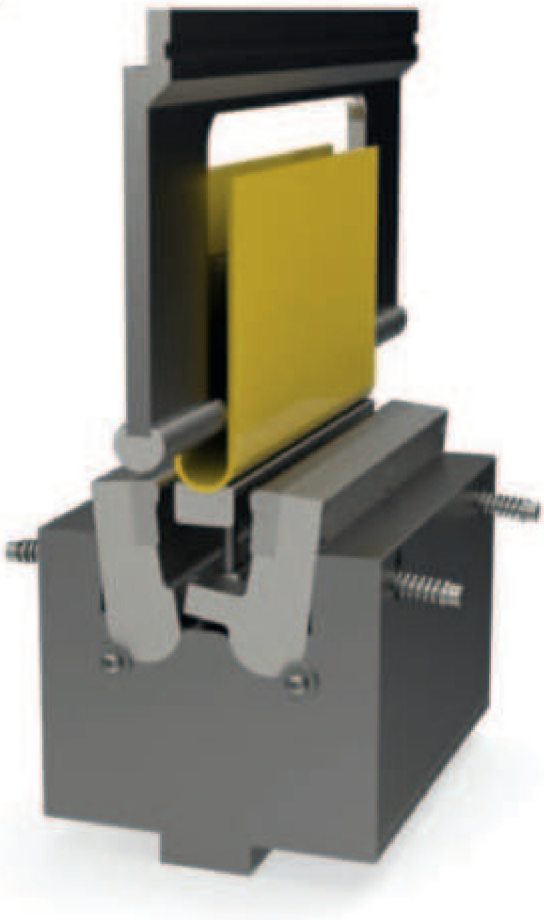
U-bending tool
with overbending strips

EXAMPLES FOR U-BENDING TOOLS WITH MOVABLE BENDING STRIPS

► Other shapes and layouts are manufactured individually according to your specifications



U-bending tool with wedge slide technology
to compensate for the springback of the material



U-bending tool
for profiles with long bending flanges

Hinge tools

ADVANTAGES

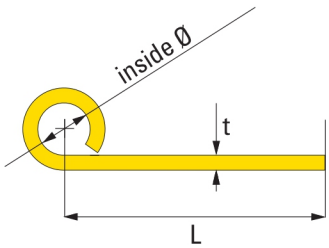
- Production in two or three strokes
- Reduction of marks through spring loaded hold-down-device
- Active components are hardened
- High repeatability through integrated backgauge
- Functional test and adjustment through test bends – with your sample sheets

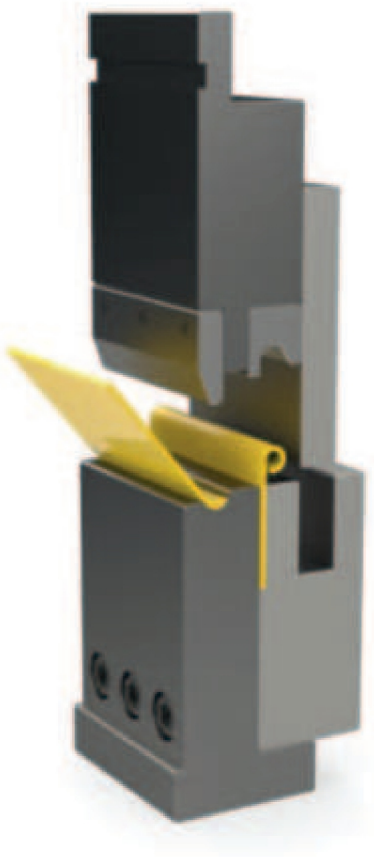
SUITABLE FOR

- Material thickness up to 4,0 mm
- Minimum inside Ø:
  2,5 x material thickness for steel and aluminium
  3,0 x material thickness for stainless steel

VIDEO

Hinge tool





Hinge tool for production
in one station with two strokes

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

TWO STATION HINGE TOOL

Station 1:
Pre-bending of the profile in two strokes

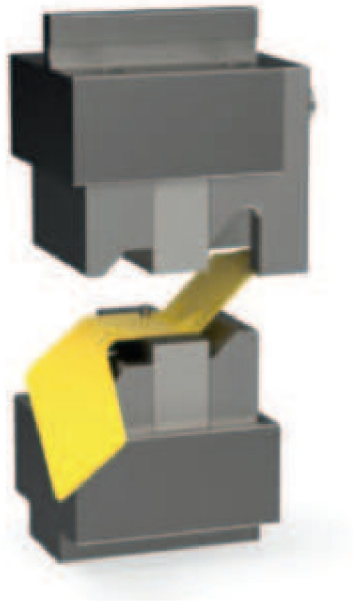
Station 2:
Roll in the profile in one stroke



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 execution of the beadings according to customer specification
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets



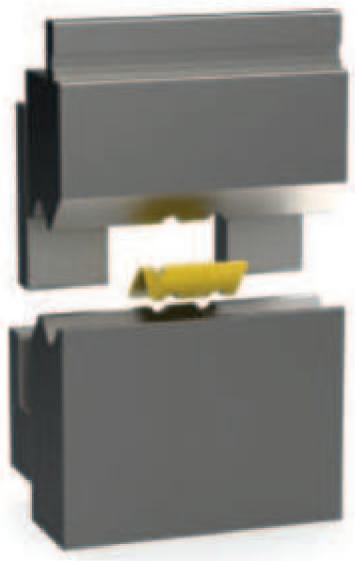
Special tool for Z-profile, guided and spring loaded, for four stiffening beads in one stroke

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, rear 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

Beading tools for long bead rib

ADVANTAGES

- Production in one step
- One tool suitable for different sheet thickness and materials
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets



Tool for small round bead

SUITABLE FOR

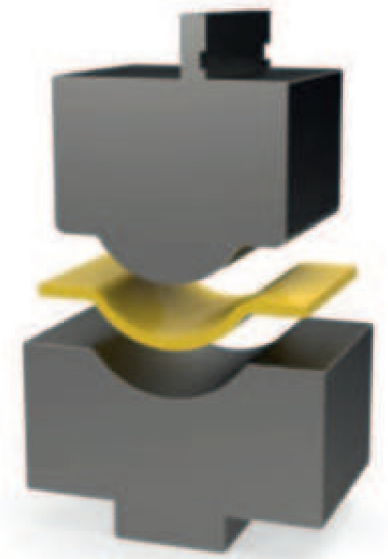
- Various material thicknesses, depending on the profile geometry and press force of your press brake

EXAMPLES FOR BEADING TOOLS FOR LONG BEAD RIB

- Other shapes and layouts are manufactured individually according to your specifications



Tool for long V-bead with spring loaded ejector



Tool for big round bead

Z-bending tools

ADVANTAGES

- Production in one step
- One tool suitable for different sheet thickness and materials
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets



Z-bending tool
for big Z-step

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 rear guide for
thick materials

Radius embossing tools

ADVANTAGES

- Production in one step
- One tool suitable for different sheet thickness and materials
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets



Radius embossing tool for radii with straight flanges

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 big radii and prebend flanges



Double radius embossing tool

Trapezoidal bending tools

ADVANTAGES

- Production in one step
- One tool suitable for different sheet thickness and materials
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets



Trapezoidal bending tool with spring loaded ejector

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 for big profile

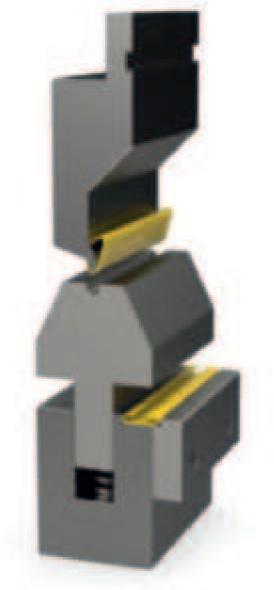
VIDEO

Trapezoidal bending tools

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



Flattening tool
for small C-profile

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 big C-profile
and centered flattening



Flattening tool for double-sided flattening
shape with adjacent 90° bend

Louvre tools

ADVANTAGES

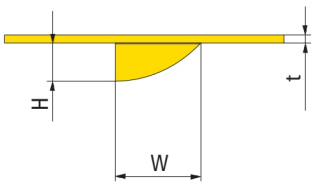
- Production in one step
- One tool suitable for different sheet thickness and materials
- Only minimum deformation of the sheet through spring loaded hold-down device
- Active components are hardened
- Functional test and adjustment through test bends – with your sample sheets



Louvre tool in simple design, without hold-down device

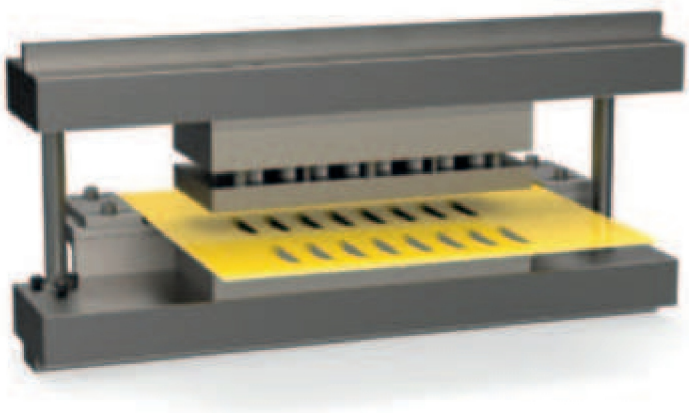
SUITABLE FOR

- 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

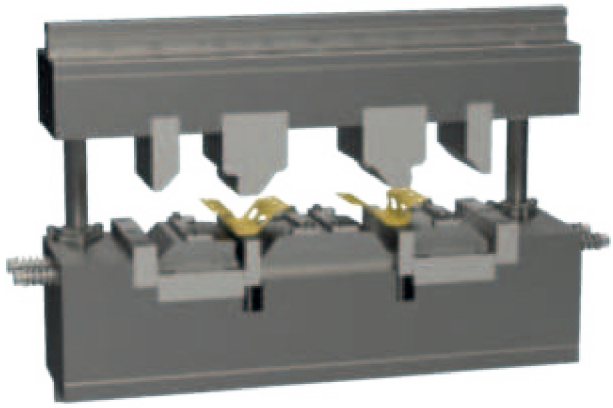


Louvre tool with spring loaded hold-down device for minimum deformation of the sheet

VIDEO

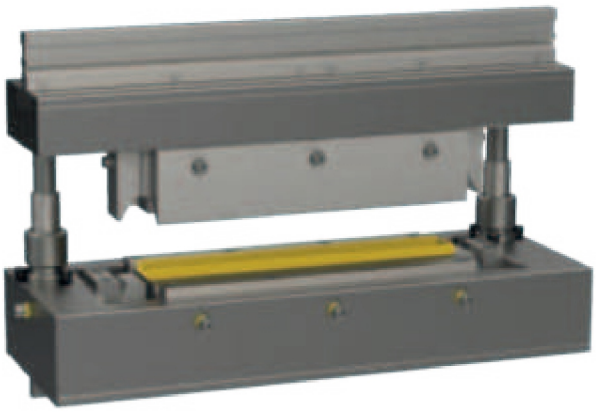
Louvre tool

More special tools



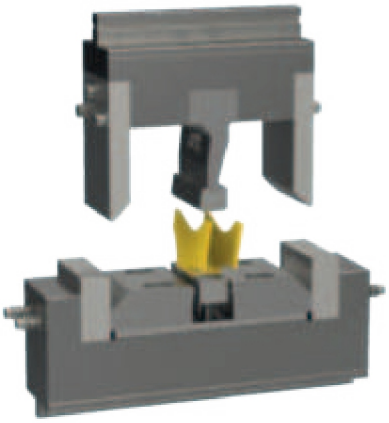
Multiple embossing tool

VIDEO
Multiple embossing tool



Special tool with wedge slide technology for all sided bending

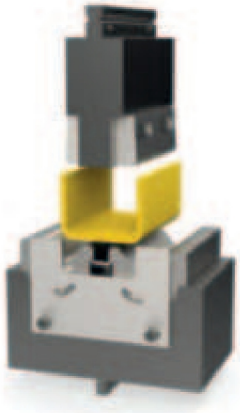
VIDEO
Special tool for all sided bending



U-bending tool with wedge slide technology for asymmetrical U-form

VIDEO
U-Bending tool

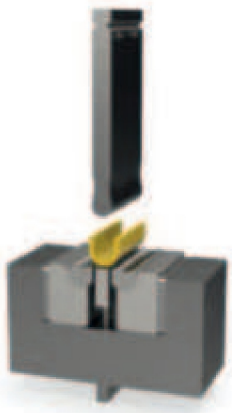
More special tools



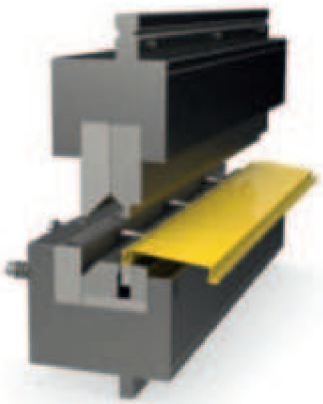
U-bending tool with rotary bending strips



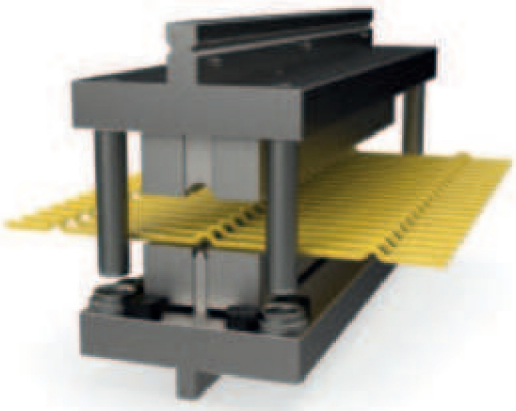
Rear guided U-bending tool



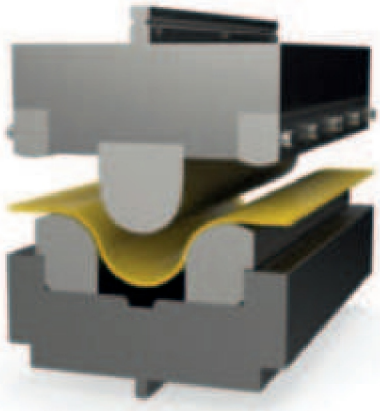
U-bending tool with movable bending strips and ejector



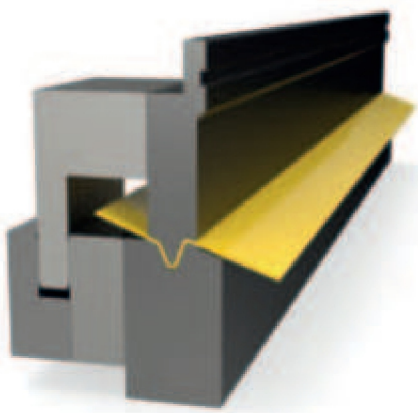
U-bending tool with wedge slide technology for profiles adjacent to 90° bend



Multiple embossing tool for the production of round V-beads in bar material



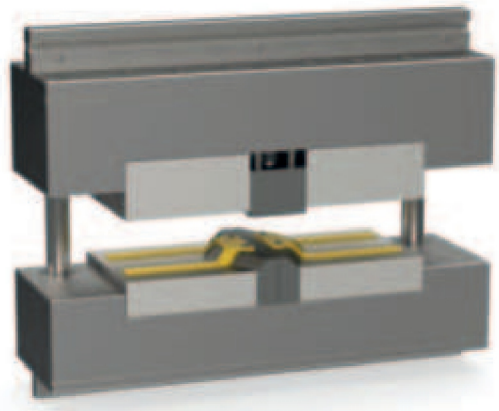
Circular beading tool with adjustable bending strips



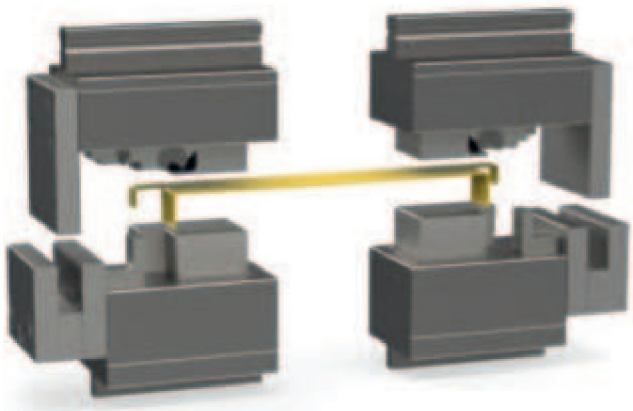
Rear guided embossing tool for asymmetric V-shapes



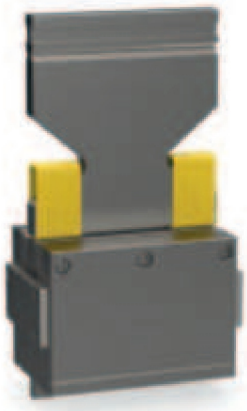
Tool for 20° profiles with spring-loaded ejector



Pillar-guided Z-embossing tool with spring-loaded hold-down device – two parts



Bending tool with spring-loaded hold-down device and rotary bending strips for bending four 90° bends in one stroke

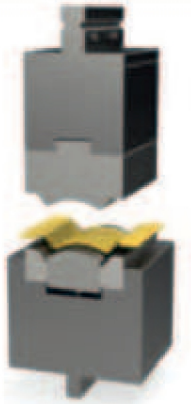


U-bending tool for the production of two closed profiles in one stroke



Pillar guided tool for bending two different sized radii in one stroke

More special tools



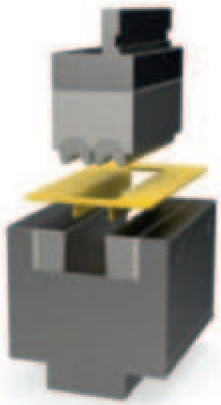
Embossing tool for the production of wave-shaped profiles



Rear guided Z-embossing tool



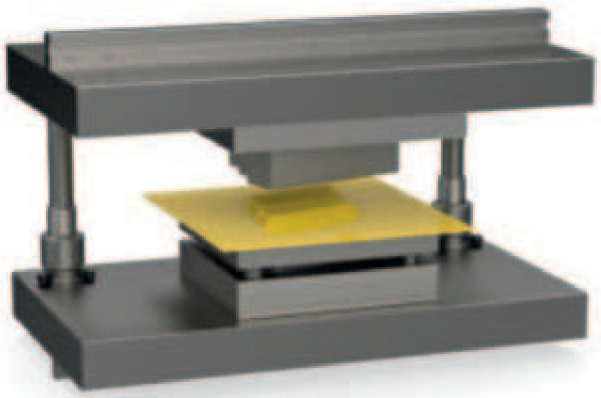
Special tool for the production of 90° bends in horizontal position



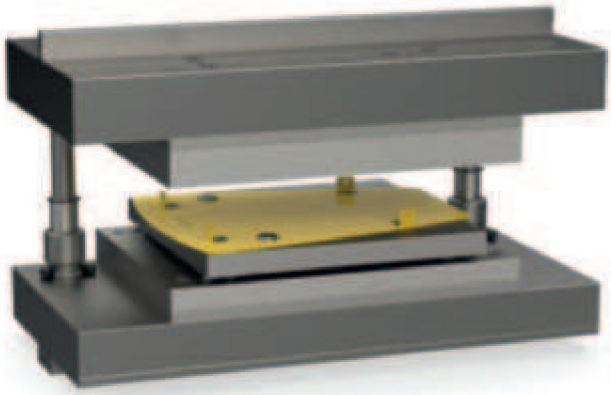
Special tool with movable bending strips for the production of two inside 90° bends in one stroke



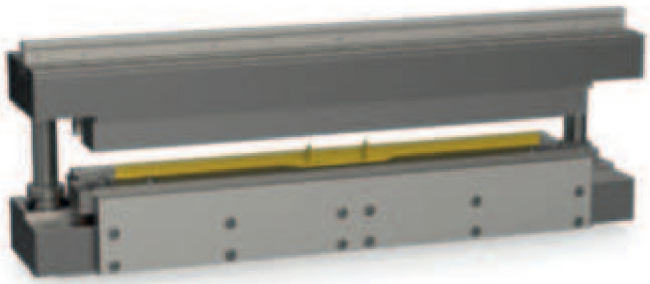
Pillar guided embossing tool for the production of two profiles in one stroke



Pillar guided louvre tool



Pillar guided special tool for the production of four inside 90° bends in one stroke

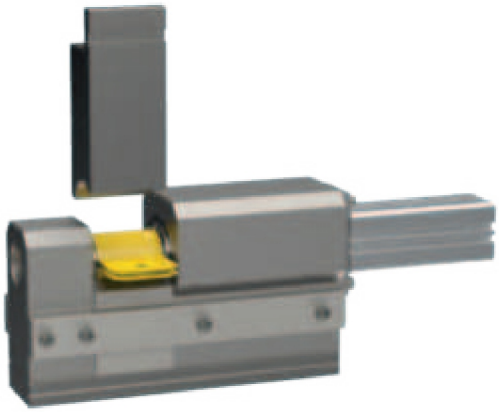


Pillar guided special tool for the production of three bends up and down in one stroke

TWO-STATION TOOL FOR THE PRODUCTION ON PIPE-CLAMP PROFILES



Station 1: Pre-bending of the profile in two steps



Station 2: Closing the pipe-clamp profile. Tool with pneumatically controlled bending pin for automated removal

VIDEO

Special tool pipe-clamp

More special tools

TWO STATION TOOL FOR THE PRODUCTION OF A BRACKET

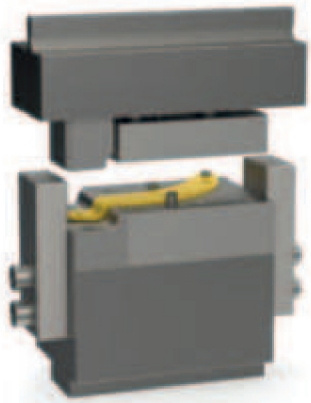


Station 1: Rear guided U-bending tool with spring-loaded ejector

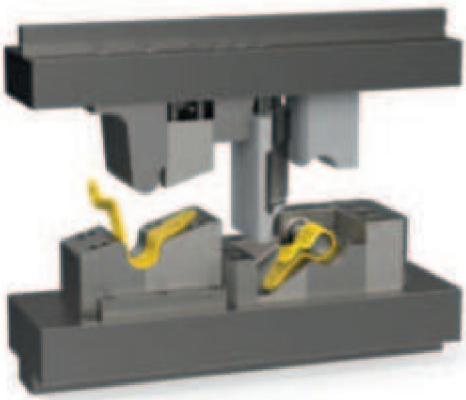


Station 2: V-shape embossing tool with rear guidance adjusted to the previous U-bend

TWO STATION TOOL FOR THE PRODUCTION OF A PIPE-CLAMP

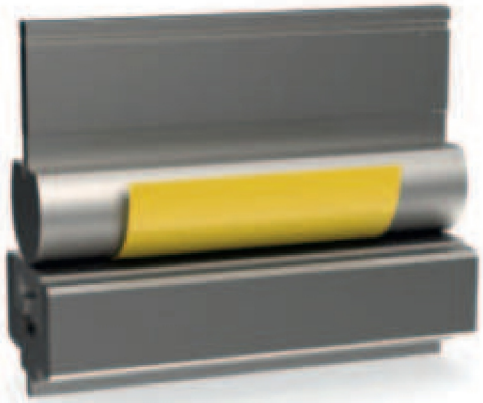


Station 1: Z-embossing tool for pipe-clamp shape with spring-loaded hold-down device and lateral support

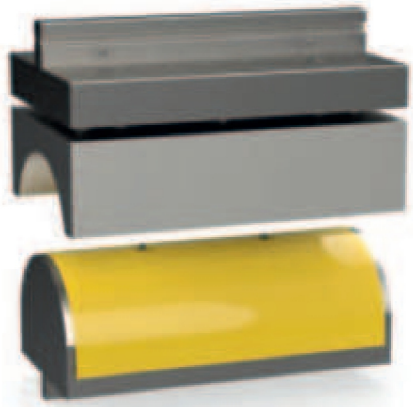


Station 2: Tool for the embossing of a radius (left) and roll into a pipe-clamp shape (right), with spring-loaded hold down devices an integrated support

TWO STATION TOOL FOR THE PRODUCTION OF A HOUSING COVER

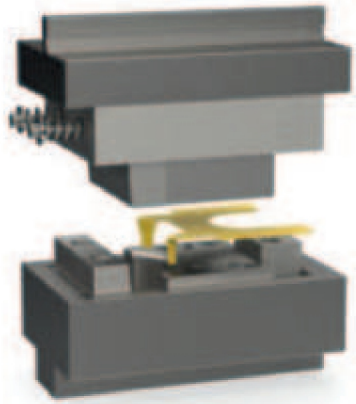


Station 1: Radius-tool with PU-insert for bending a 180° radius without bending marks



Station 2: Calibration tool with integrated embossing stamps, for simultaneous stamping of two small emboss forms in the radius

TWO STATION TOOL FOR THE PRODUCTION OF A RETAINING PLATE



Station 1: Embossing tool for two 90° flanges with 3D-Shape

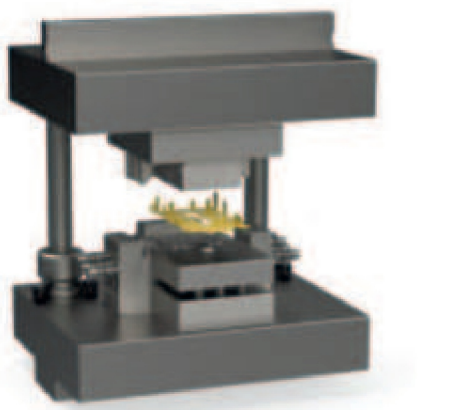


Station 2: Bending tool for folding two short tags on the already bent flanges, with the help of movable wedge sliders

TWO STATION TOOL FOR THE PRODUCTION OF COMPLEX CONTOURS



Station 1: Pre-bending of different bends in two stations



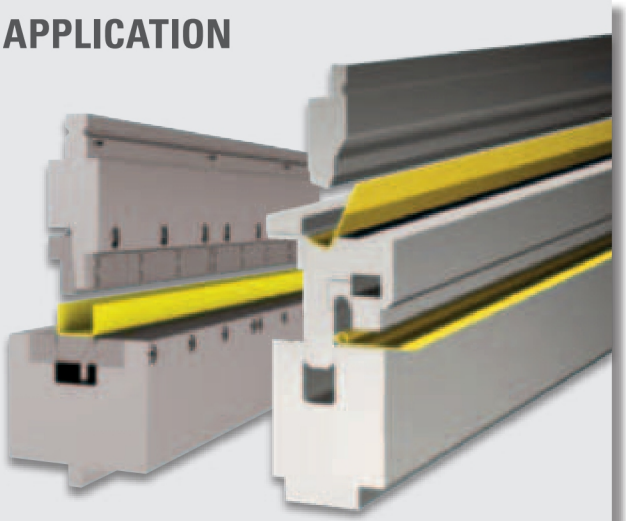
Station 2: Finish bending of several complex contours in one stroke

THE PERFECT SPECIAL TOOL FOR YOUR APPLICATION

Challenge us!

PRODUCING MORE THAN STANDARD!

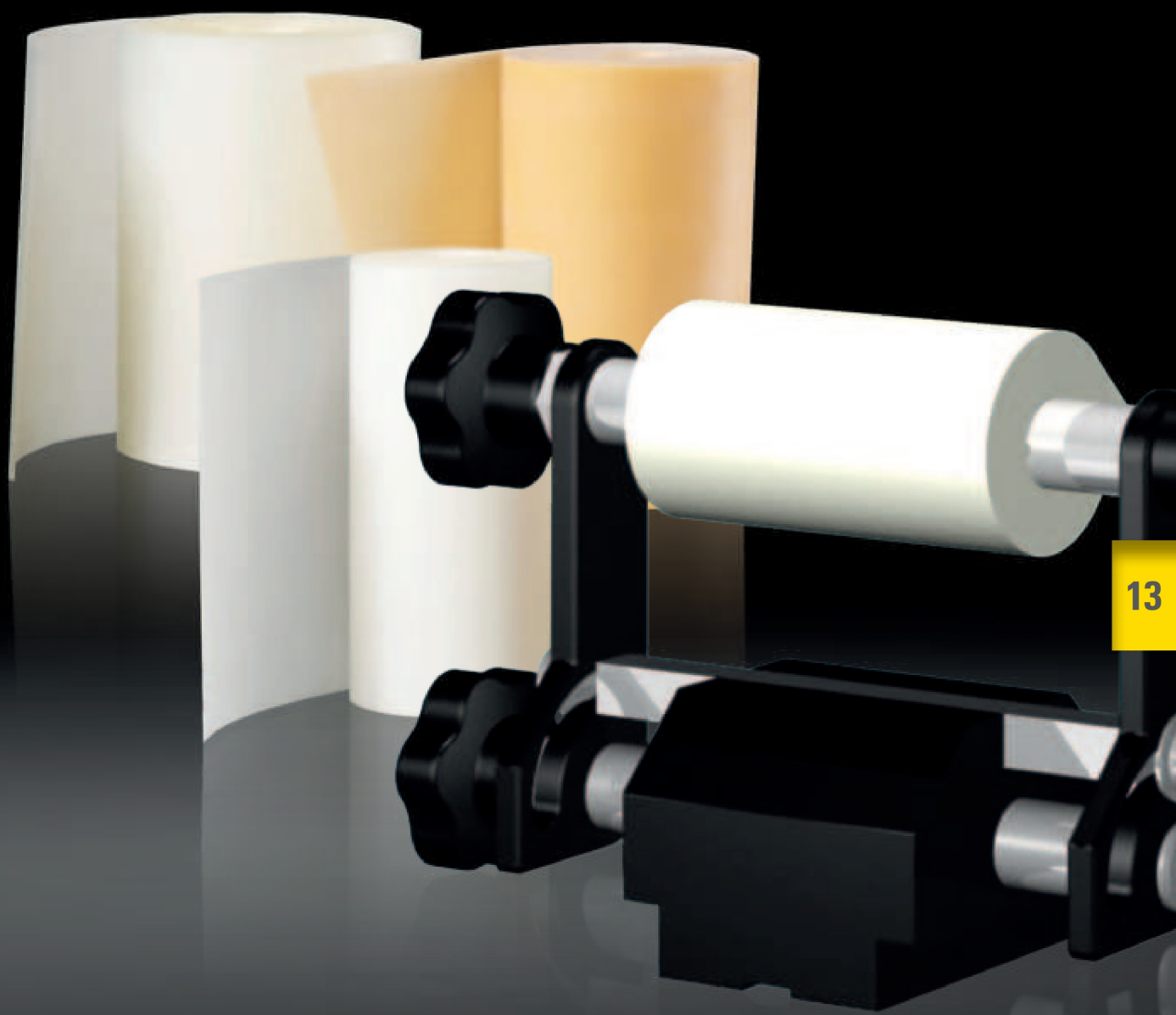
MORE EXAMPLES SEE
WWW.UKB-GMBH.COM



UKB-PROTECTIVE FILM

VU sample set 252
Protective film Shore 95 A 253
Protective film Shore 60 A 254
Holder for protective film 254-255
Steel insert for other systems 255





13

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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
- **Increased product quality**
- **Easy handling**
- **Applicable on all dies**
- **Less wearout of the protective film** by correct use

VIDEO

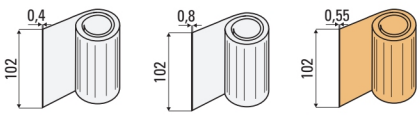
UKB-Protective film

VU sample set

24h

5 m	Shore 95 A	VU 0,4 x 102		
5 m	Shore 95 A	VU 0,8 x 102	1,3 kg	146,– €
5 m	Shore 60 A	VU 0,55 x 102		

SCAN TO SHOP



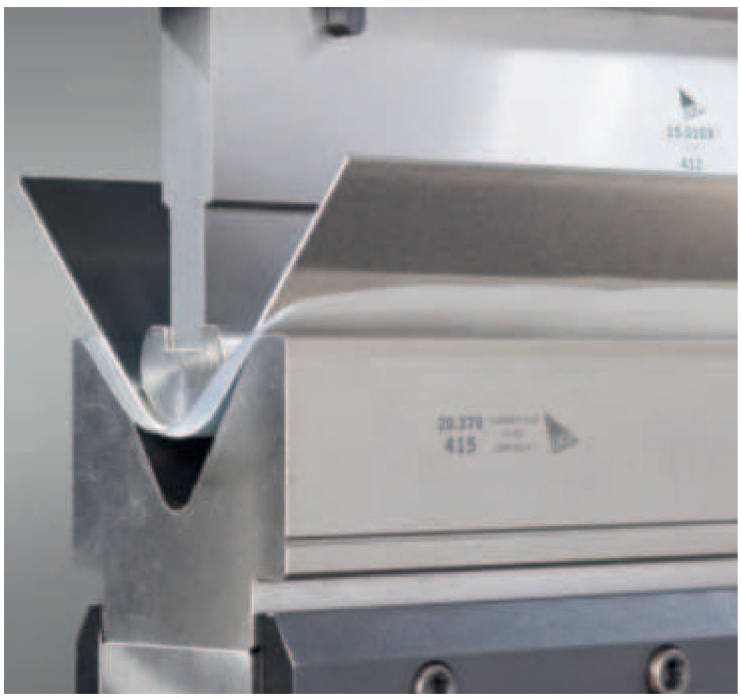




Bending result without protective film



Bending result with protective film

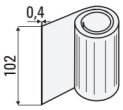


Protective film Shore 95 A

VU 0,4 x 102

24h

Roll	Weight	Price
30 m	1,6 kg	202,– €
15 m	0,8 kg	126,– €
5 m	0,3 kg	50,– €
6 Rolls of 30 m	10,0 kg	968,– €

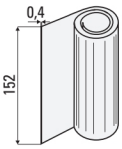


SCAN TO SHOP

VU 0,4 x 152

24h

Roll	Weight	Price
30 m	2,4 kg	302,– €
15 m	1,2 kg	190,– €
5 m	0,4 kg	76,– €
4 Rolls of 30 m	10,0 kg	968,– €

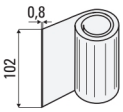


SCAN TO SHOP

VU 0,8 x 102

24h

Roll	Weight	Price
30 m	3,2 kg	302,– €
15 m	1,6 kg	190,– €
5 m	0,6 kg	76,– €
6 Rolls of 30 m	19,6 kg	1.452,– €

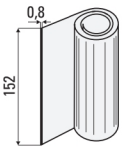


SCAN TO SHOP

VU 0,8 x 152

24h

Roll	Weight	Price
30 m	4,6 kg	454,– €
15 m	2,3 kg	284,– €
5 m	0,8 kg	114,– €
4 Rolls of 30 m	19,0 kg	1.452,– €

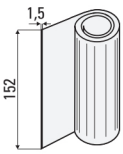


SCAN TO SHOP

VU 1,5 x 152

24h

Roll	Weight	Price
15 m	4,4 kg	332,– €
5 m	1,5 kg	132,– €
4 Rolls of 15 m	18,0 kg	1.058,– €

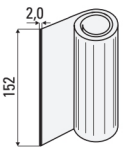


SCAN TO SHOP

VU 2,0 x 152

24h

Roll	Weight	Price
15 m	6,6 kg	378,– €
5 m	2,2 kg	152,– €
4 Rolls of 15 m	27,0 kg	1.210,– €



SCAN TO SHOP

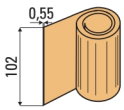


PROTECTIVE FILM

Protective film Shore 60 A

VU 0,55 x 102 — 24h

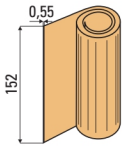
Roll	Weight	Price
30 m	2,0 kg	316,– €
15 m	1,0 kg	198,– €
5 m	0,4 kg	80,– €
6 Rolls of 30 m	12,4 kg	1.520,– €



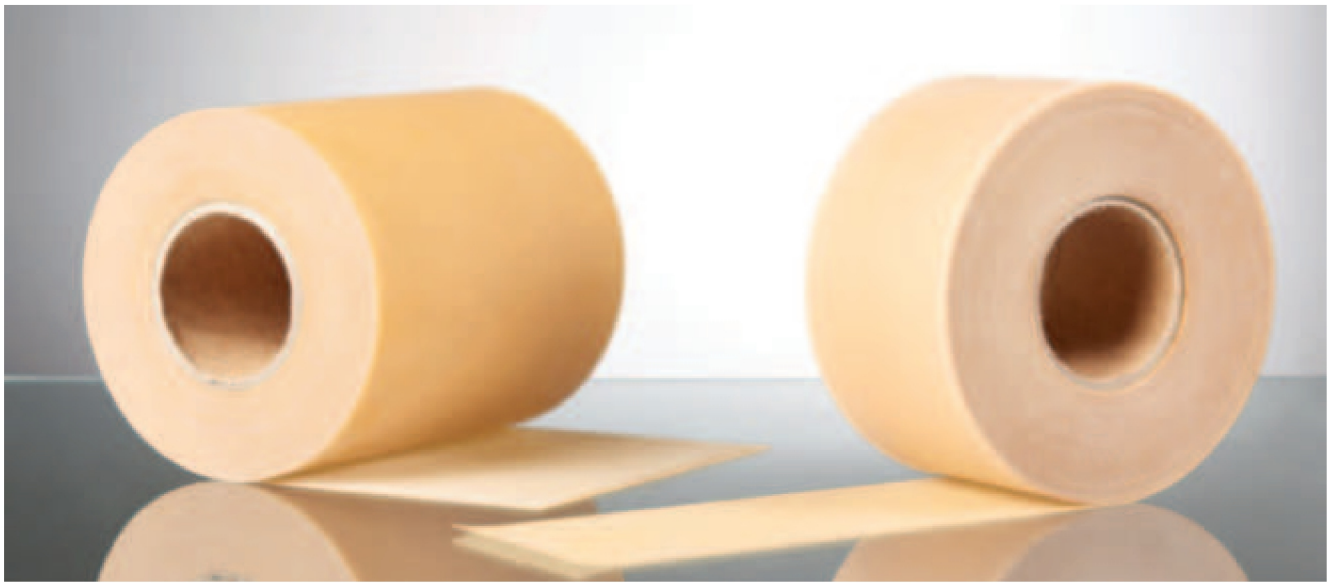
SCAN TO SHOP

VU 0,55 x 152 — 24h

Roll	Weight	Price
30 m	2,9 kg	476,– €
15 m	1,5 kg	298,– €
5 m	0,5 kg	118,– €
4 Rolls of 30 m	12,0 kg	1.520,– €



SCAN TO SHOP



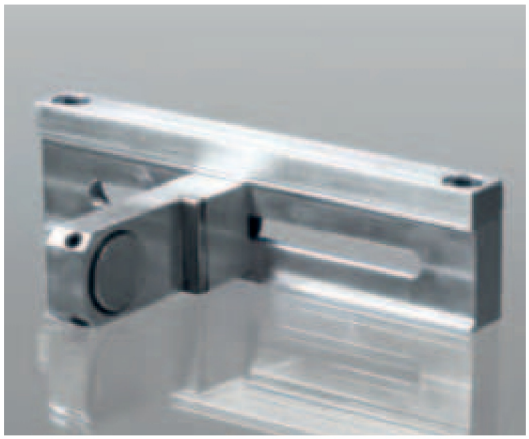
Holder for protective film

40.850 — 24h

Per pair	3,0 kg	212,– €

SCAN TO SHOP

For protective film up to 152 mm width





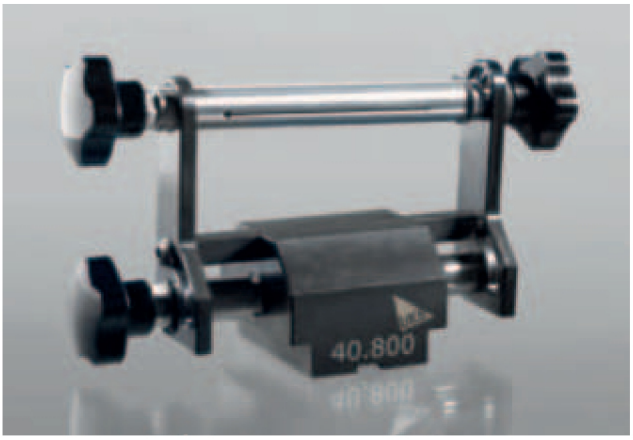
Mounted via magnets directly to the die

Holder for protective film

40.800		24h
Per pair	8,0 kg	568,– €

For protective film up to 102 mm width

SCAN TO SHOP





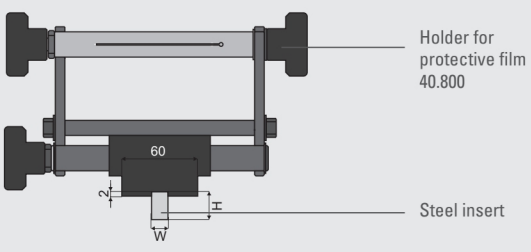
Steel insert for other systems

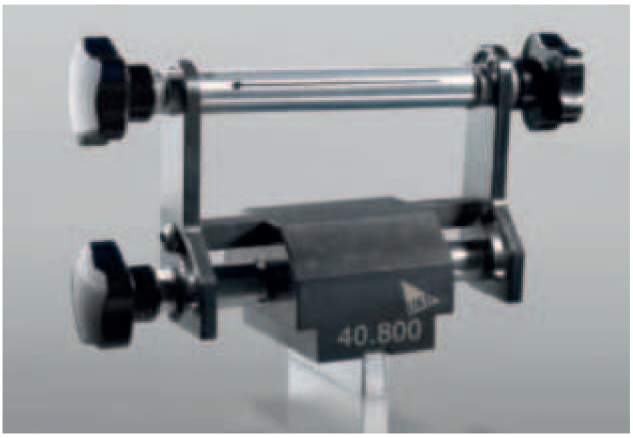
System	Steel insert (W x H)	Price
Trumpf/Wila/Bystronic	13,0 x 22,0 mm	50,– €
EHT	55,0 x 47,0 mm	145,– €
LVD	12,7 x 21,0 mm	50,– €
Weinbrenner	35,0 x 47,0 mm	120,– €
Other Systems	W x H mm	On request

SCAN TO SHOP

Delivery time 1 - 3 working days

EXAMPLE OF USE



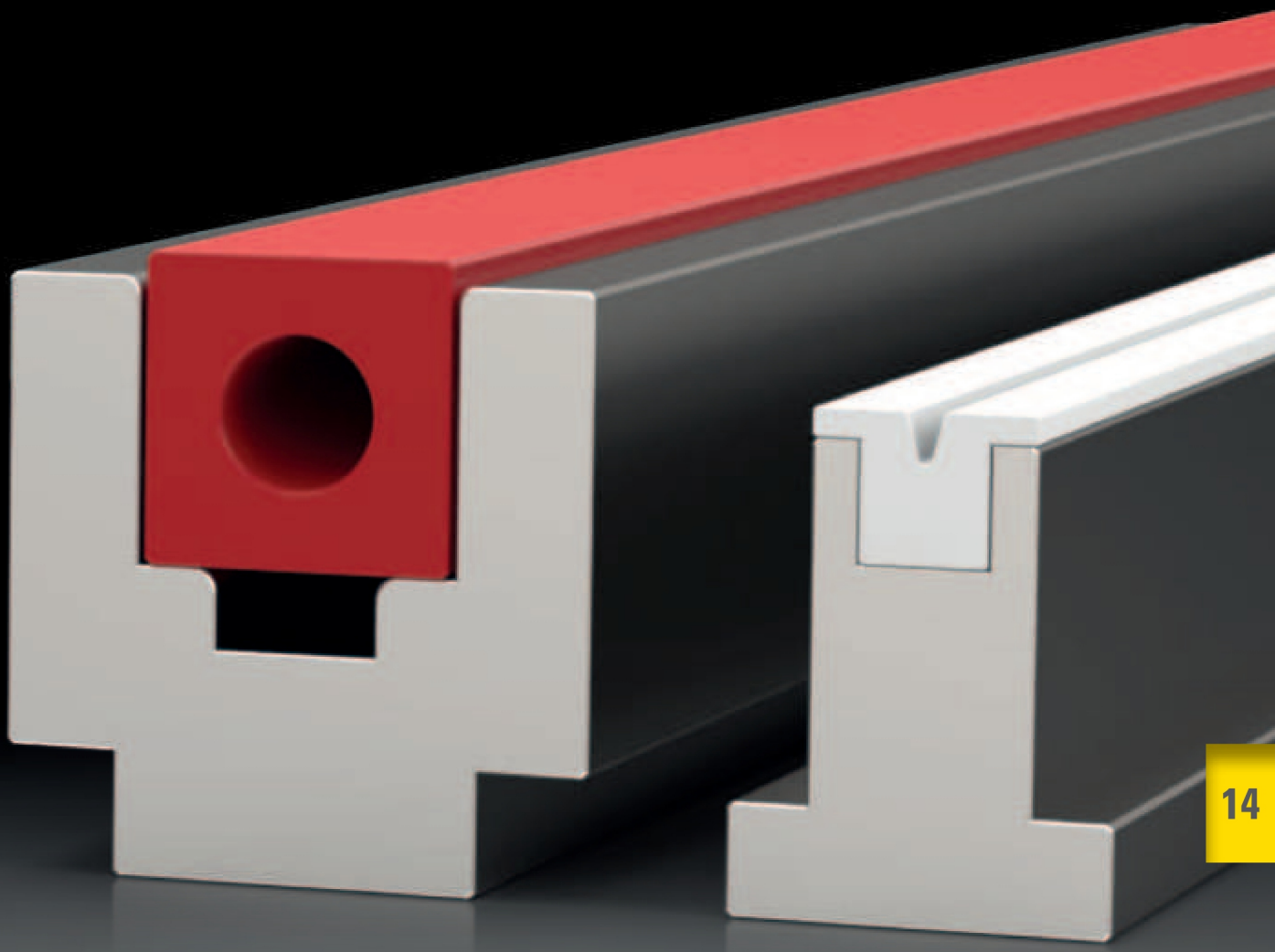


Holder for protective film with steel insert for UKB-Systems Trumpf/Wila/Bystronic

UKB-MARK FREE AND UKB-MARK REDUCED BENDING

Composite dies 258
Holders for composite dies 259
PU-Holders and -inserts 260-261





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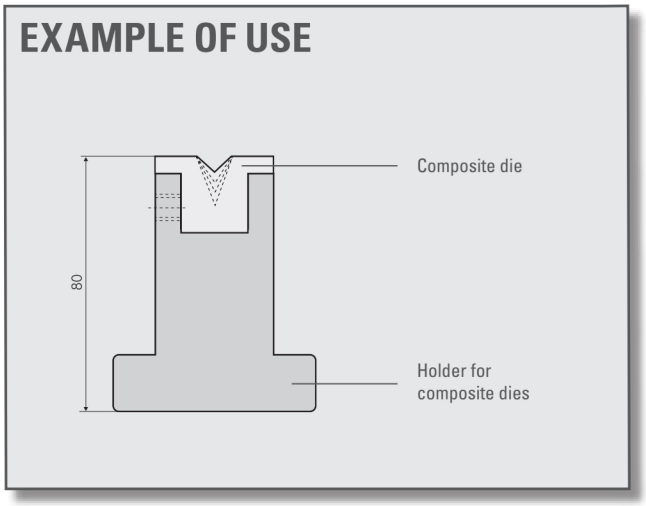
Composite dies

Product advantages

- **Reduces bending marks** on sheets
- **Ideal** for bending **aluminium, stainless steel and painted surfaces**
- **No reworking** of workpieces necessary
- **No contamination** of the bended parts
- **Increased product quality**
- **Efficient die change:** Quick and easy

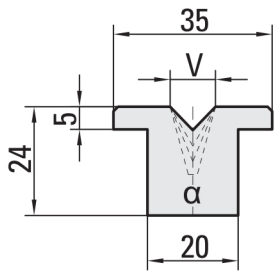
EXAMPLE OF USE



32.... — **24h** — 200 kN/m

Model	α	V (mm)	835 mm Price	415 mm Price
32.806	88°	6,0	150,– €	86,– €
32.808	88°	8,0	150,– €	86,– €
32.810	88°	10,0	150,– €	86,– €
32.812	88°	12,0	150,– €	86,– €
32.816	88°	16,0	150,– €	86,– €
32.606	60°	6,0	150,– €	86,– €
32.608	60°	8,0	150,– €	86,– €
32.610	60°	10,0	150,– €	86,– €
32.612	60°	12,0	150,– €	86,– €
32.616	60°	16,0	150,– €	86,– €
32.306	30°	6,0	150,– €	86,– €
32.308	30°	8,0	150,– €	86,– €
32.310	30°	10,0	150,– €	86,– €
Weight			0,40 kg	0,20 kg

SCAN TO SHOP





VIDEO

UKB-Mark free and mark reduced bending



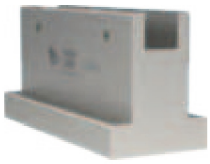


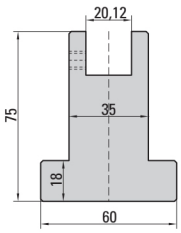
Holders for composite dies

UKB-SYSTEM AMADA

22.002		24h 200 kN/m
835 mm	17,6 kg	350,– €
415 mm	8,7 kg	198,– €
800 mm sectionalized	16,8 kg	464,– €

SCAN TO SHOP



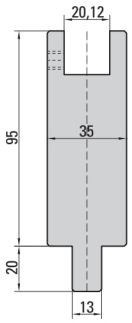


UKB-SYSTEM TRUMPF

22.005		24h 200 kN/m
835 mm	20,9 kg	436,– €
415 mm	10,4 kg	244,– €
800 mm sectionalized	20,0 kg	582,– €

SCAN TO SHOP

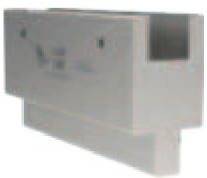


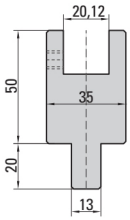


UKB-SYSTEMS WILA/BYSTRONIC

22.004		24h 200 kN/m
835 mm	10,6 kg	334,– €
415 mm	5,3 kg	190,– €
800 mm sectionalized	10,1 kg	428,– €

SCAN TO SHOP



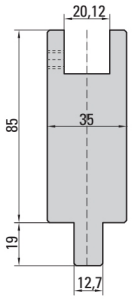


UKB-SYSTEM LVD

26.005		24h 200 kN/m
835 mm	18,5 kg	446,– €
415 mm	9,2 kg	256,– €
800 mm sectionalized	17,7 kg	602,– €

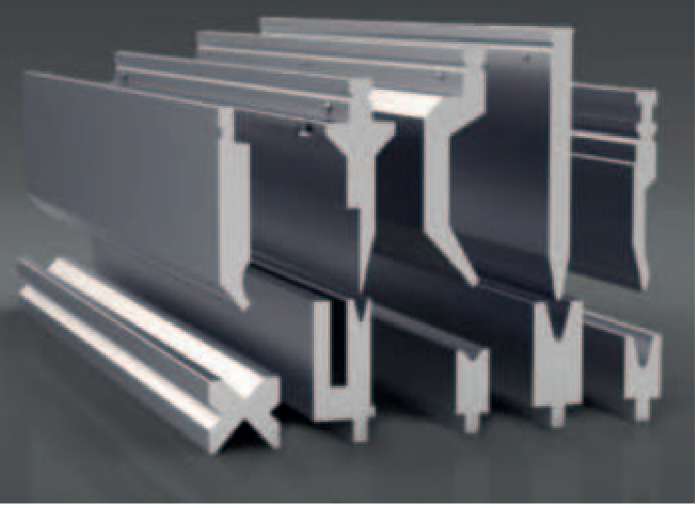
SCAN TO SHOP





toolsystems24.de
Press Brake Tools Outlet — made by UKB

- Special offers
- Deal of the week
- Demonstration tools & test tools
- Special and remaining stock
- Used press brake tools



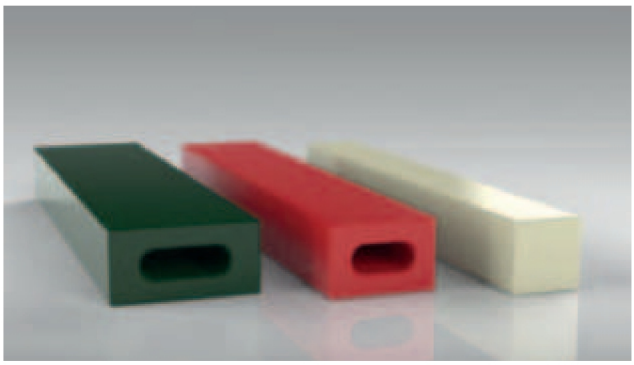
PU-Holders and -inserts

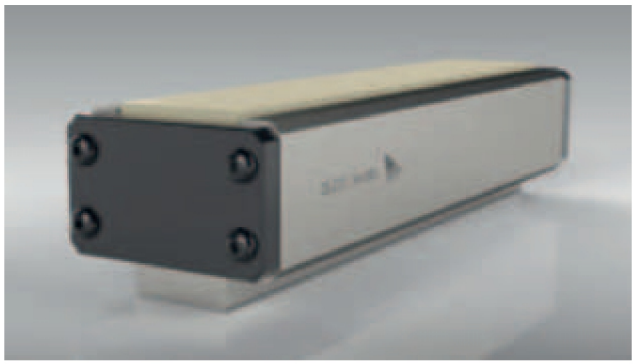
Product advantages

- **Avoids bending marks** on 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
- **Increased product quality**

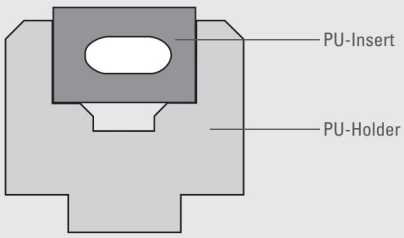
VIDEO

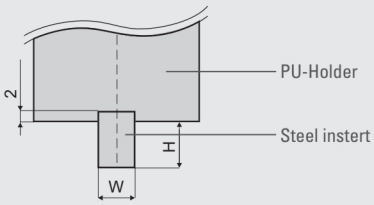
UKB-Mark free and mark reduced bending





MODIFICATION PU-HOLDER





VIDEO

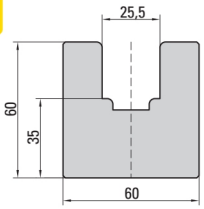
UKB-Modification of press brake tools

UKB-SYSTEM AMADA

20.271 — 24h

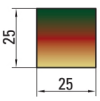
835 mm	18,8 kg	288,– €
415 mm	9,4 kg	168,– €

SCAN TO SHOP



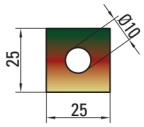
PU-Insert — 24h

Shore	Model	835 mm		415 mm	
		Weight	Price	Weight	Price
80 A	34.180	0,7 kg	46,– €	0,3 kg	30,– €
90 A	34.190	0,7 kg	46,– €	0,3 kg	30,– €
95 A	34.195	0,7 kg	46,– €	0,3 kg	30,– €



PU-Insert with core hole — 24h

Shore	Model	835 mm		415 mm	
		Weight	Price	Weight	Price
80 A	35.180	0,6 kg	58,– €	0,3 kg	36,– €
90 A	35.190	0,6 kg	58,– €	0,3 kg	36,– €
95 A	35.195	0,6 kg	58,– €	0,3 kg	36,– €



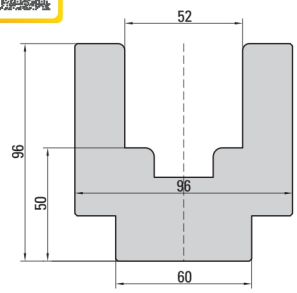
PU-Holders and -inserts

UKB-SYSTEM AMADA

20.272 — 24h

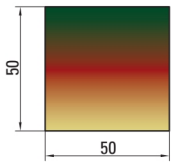
835 mm	37,7 kg	522,– €
415 mm	18,7 kg	288,– €

SCAN TO SHOP



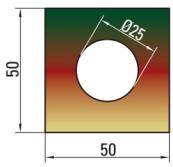
PU-Insert — 24h

Shore	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
80 A	34.280	2,9 kg	132,– €	1,5 kg	74,– €
90 A	34.290	2,9 kg	132,– €	1,5 kg	74,– €
95 A	34.295	2,9 kg	132,– €	1,5 kg	74,– €



PU-Insert with core hole — 24h

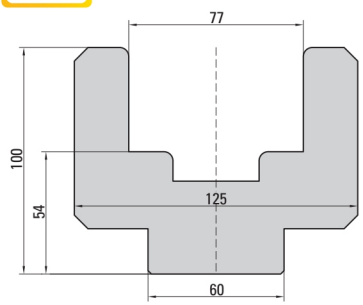
Shore	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
80 A	35.280	2,2 kg	164,– €	1,1 kg	90,– €
90 A	35.290	2,2 kg	164,– €	1,1 kg	90,– €
95 A	35.295	2,2 kg	164,– €	1,1 kg	90,– €



20.273 — 24h

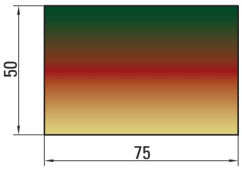
835 mm	46,4 kg	700,– €
415 mm	23,1 kg	402,– €

SCAN TO SHOP



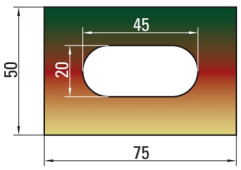
PU-Insert — 24h

Shore	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
80 A	34.380	3,5 kg	202,– €	1,7 kg	112,– €
90 A	34.390	3,5 kg	202,– €	1,7 kg	112,– €
95 A	34.395	3,5 kg	202,– €	1,7 kg	112,– €



PU-Insert with core hole — 24h

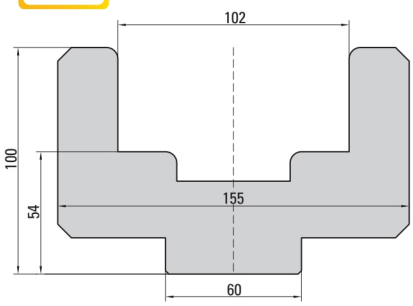
Shore	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
80 A	35.380	2,8 kg	304,– €	1,4 kg	166,– €
90 A	35.390	2,8 kg	304,– €	1,4 kg	166,– €
95 A	35.395	2,8 kg	304,– €	1,4 kg	166,– €



20.274 — 24h

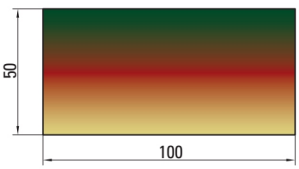
835 mm	56,0 kg	818,– €
415 mm	27,8 kg	474,– €

SCAN TO SHOP



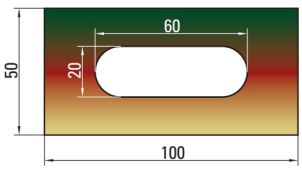
PU-Insert — 24h

Shore	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
80 A	34.480	5,0 kg	220,– €	2,5 kg	126,– €
90 A	34.490	5,0 kg	220,– €	2,5 kg	126,– €
95 A	34.495	5,0 kg	220,– €	2,5 kg	126,– €



PU-Insert with core hole — 24h

Shore	Model	835 mm Weight	835 mm Price	415 mm Weight	415 mm Price
80 A	35.480	4,0 kg	332,– €	2,0 kg	176,– €
90 A	35.490	4,0 kg	332,– €	2,0 kg	176,– €
95 A	35.495	4,0 kg	332,– €	2,0 kg	176,– €

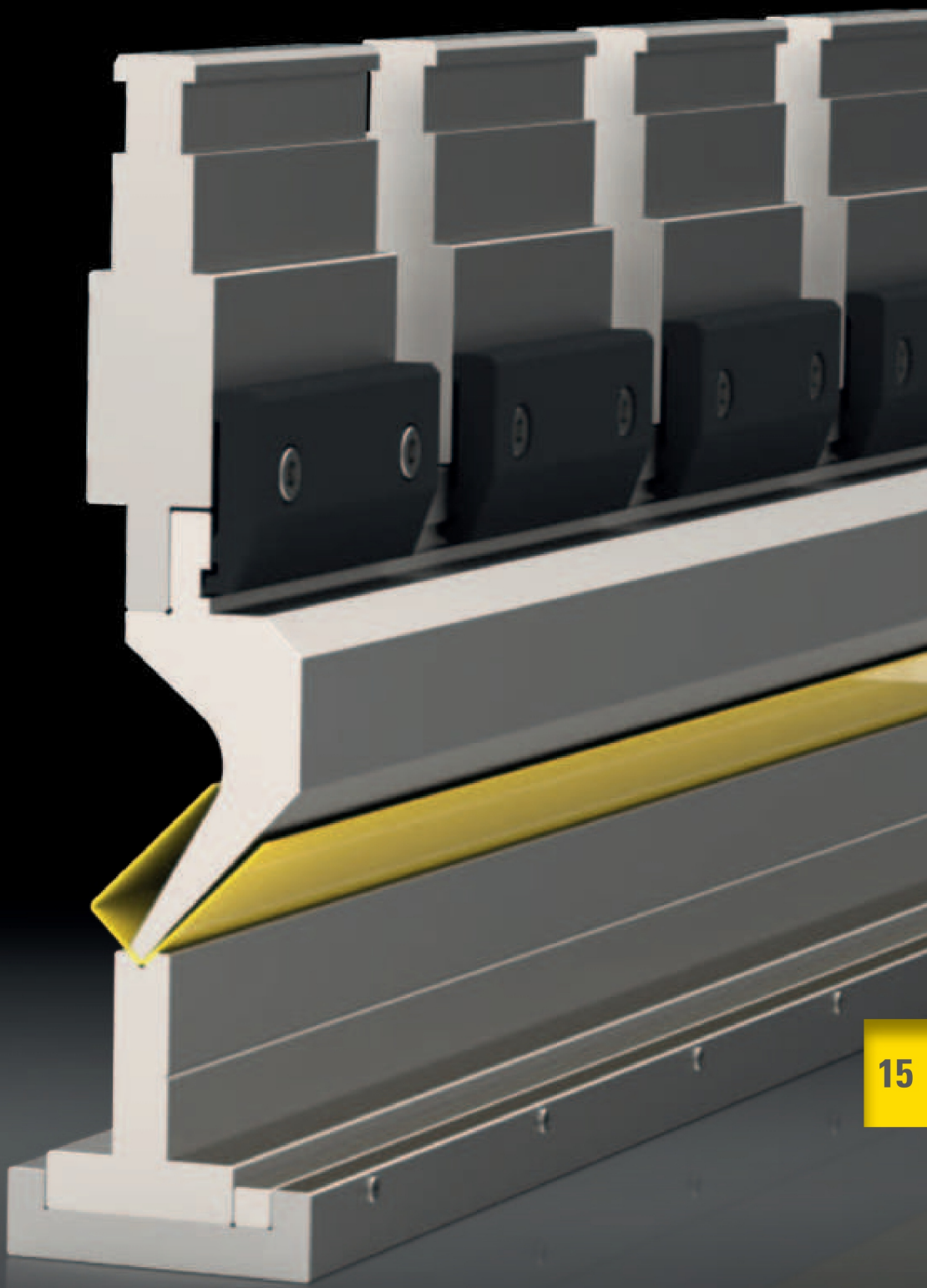


UKB-ADAPTORS

Punch/top tool adaptors
Punch/top tool adaptors ➔ UKB-System Amada 264-266
Clamps L = 150 mm 267
Punch/top tool adaptors ➔ UKB-Systems Trumpf/Wila/LVD 268
Screw on adaptor 269

Die adaptors
Die shoe adaptors UKB-System Amada 270
Die shoe adaptors UKB-Systems Trumpf/Wila/Bystronic 271
Die adaptors 272-273
Individual die adaptors 273





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Punch/top tool adaptors

Product advantages

- **Cost-saving, easy and fast change of your press brake** via 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 50mm)

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

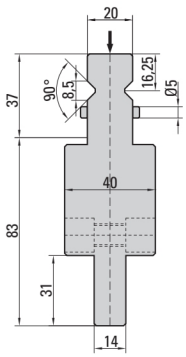
Punch/top tool adaptors ➔ UKB-System Amada

50.970 24h
1000 kN/m
150 mm | 3,7 kg | 118,– €

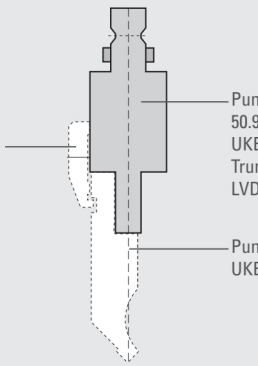
UKB-Systems Trumpf/Wila type I/LVD type I
➔ UKB-System Amada

SCAN TO SHOP





EXAMPLE OF USE

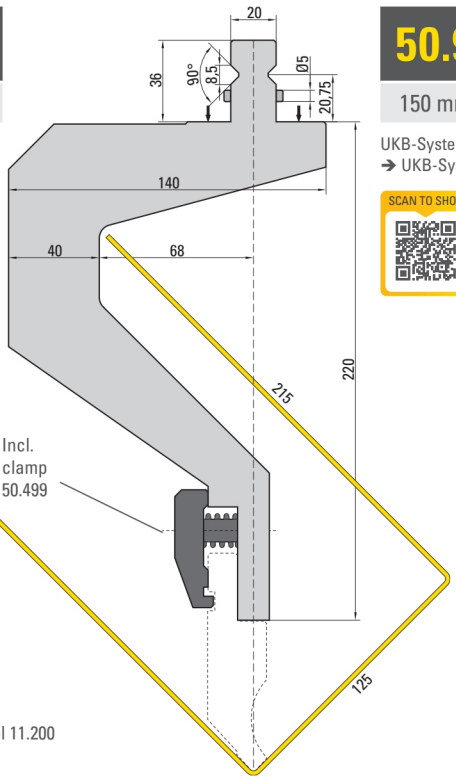


50.502 24h
900 kN/m
200 mm | 19,2 kg | 724,– €

UKB-Systems Trumpf/Wila type I/LVD type I
➔ UKB-System Amada

SCAN TO SHOP





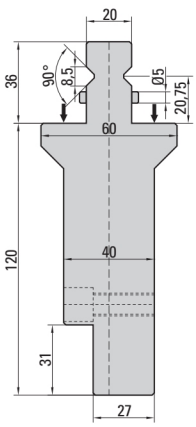
Example with
punch/top tool 11.200

50.940 24h
1000 kN/m
150 mm | 6,3 kg | 168,– €

UKB-Systems Trumpf/Wila type I/LVD type I
➔ UKB-System Amada

SCAN TO SHOP





Punch/top tool adaptors ➔ UKB-System Amada

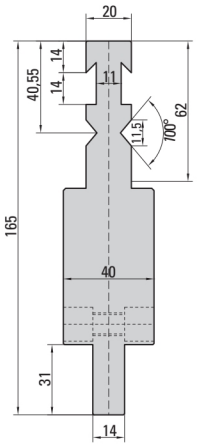
50.983 — 24h — 1000 kN/m

150 mm | 5,0 kg | 176,– €

UKB-System Bystronic „RF-A“ ➔
UKB-System Amada

SCAN TO SHOP





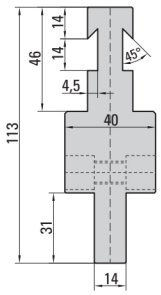
50.980 — 24h — 1000 kN/m

150 mm | 3,1 kg | 120,– €

UKB-System Bystronic „R“ ➔
UKB-System Amada

SCAN TO SHOP





UKB-INFO

Needed clamps see page 267!

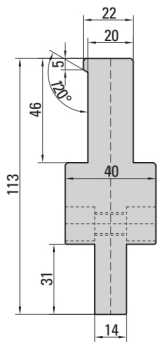
50.981 — 24h — 1000 kN/m

150 mm | 3,3 kg | 118,– €

UKB-System Bystronic „S“ ➔
UKB-System Amada

SCAN TO SHOP





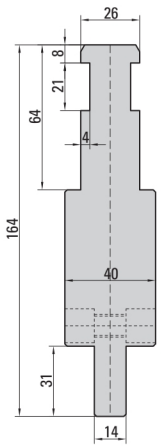
50.991 — 24h — 1000 kN/m

150 mm | 5,5 kg | 146,– €

UKB-System EHT ➔
UKB-System Amada

SCAN TO SHOP





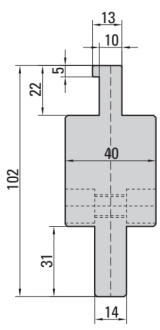
50.990 — 24h — 1000 kN/m

150 mm | 3,1 kg | 116,– €

UKB-System LVD type II ➔
UKB-System Amada

SCAN TO SHOP





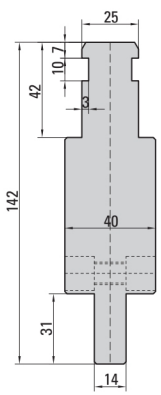
50.993 — 24h — 1000 kN/m

150 mm | 4,9 kg | 120,– €

UKB-System Weinbrenner ➔
UKB-System Amada

SCAN TO SHOP





Punch/top tool adaptors ➔ UKB-System Amada

50.994

24h

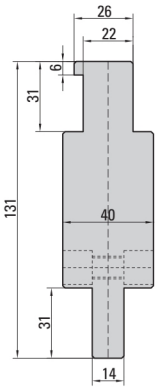
1000 kN/m

150 mm	4,6 kg	116,– €

Darley ➔ UKB-System Amada

SCAN TO SHOP





50.998

24h

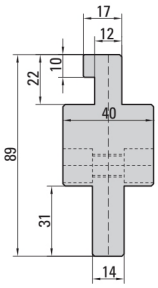
1000 kN/m

150 mm	2,6 kg	110,– €

Haco ➔ UKB-System Amada

SCAN TO SHOP





810.000

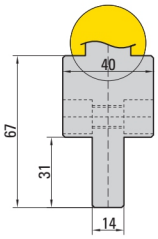
1000 kN/m

150 mm	On request

Individual punch/top tool adaptors
Delivery time on request

Please exactly measure the adaptor clamping!

SCAN TO SHOP



820.000

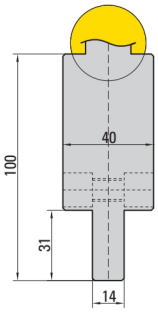
1000 kN/m

150 mm	On request

Individual punch/top tool adaptors
Delivery time on request

Please exactly measure the adaptor clamping!

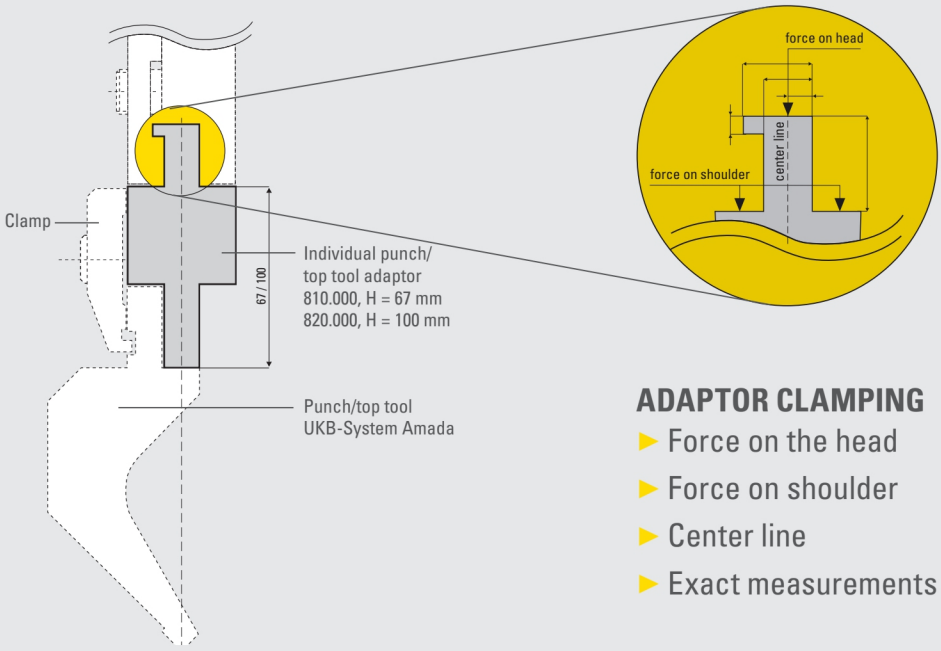
SCAN TO SHOP



UKB-INFO

Needed clamps see page 267!

EXAMPLE OF USE



ADAPTOR CLAMPING

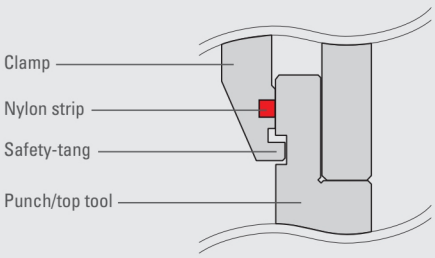
- Force on the head
- Force on shoulder
- Center line
- Exact measurements

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

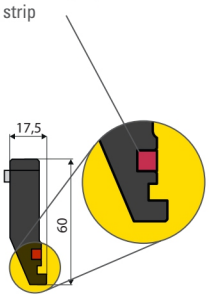
150 mm | 0,9 kg | 56,– €

Mechanical fast clamp
Adjusted by eccentric lever

SCAN TO SHOP



ADVANTAGE:
Improved clamping via nylon strip



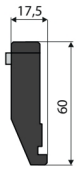
50.900 — 24h

150 mm | 0,9 kg | 48,– €

Mechanical fast clamp
Adjusted by eccentric lever

SCAN TO SHOP





50.905 — 24h

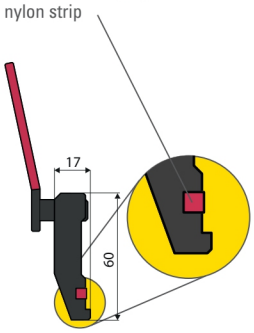
150 mm | 0,9 kg | 52,– €

Mechanical fast clamp
Adjusted by handle

SCAN TO SHOP



ADVANTAGE:
Improved clamping via nylon strip



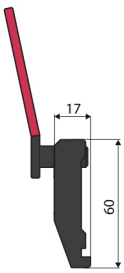
50.551 — 24h

150 mm | 0,9 kg | 44,– €

Mechanical fast clamp
Adjusted by handle

SCAN TO SHOP





50.910 — 24h

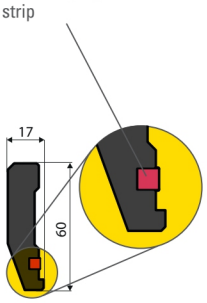
150 mm | 0,9 kg | 42,– €

Clamp
Clamping by screws

SCAN TO SHOP



ADVANTAGE:
Improved clamping via nylon strip



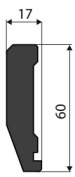
50.571 — 24h

150 mm | 0,9 kg | 34,– €

Clamp
Clamping by screws

SCAN TO SHOP



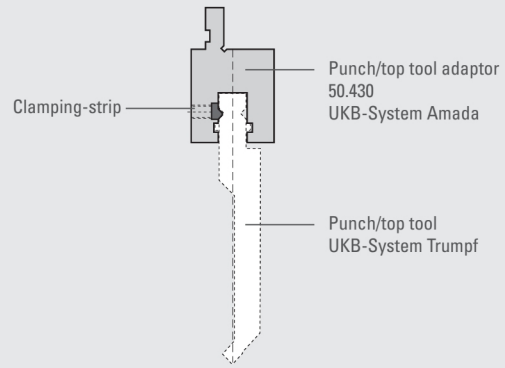


Punch/top tool adaptors ➔ UKB-Systems Trumpf/Wila/LVD

Quantity of the needed punch/top tool adaptors
(Mounting distance 50 mm)

Length of the press brake (mm)	Quantity (pieces)
800	4
1.250	6
2.100	10
2.600	13
3.100	15
4.100	20

EXAMPLE OF USE



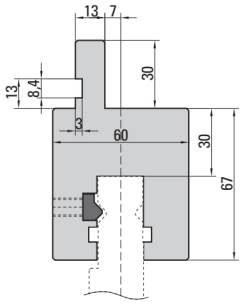
50.430 — 24h — 1000 kN/m

150 mm | 4,0 kg | 288,– €

UKB-System Amada ➔
UKB-Systems Trumpf/Wila type I/LVD type I

SCAN TO SHOP





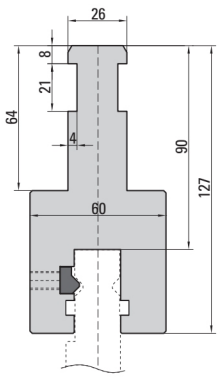
50.450 — 24h — 1000 kN/m

150 mm | 5,0 kg | 378,– €

UKB-System EHT ➔
UKB-Systems Trumpf/Wila type I/LVD type I

SCAN TO SHOP



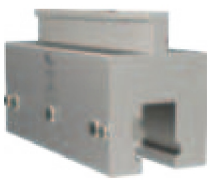


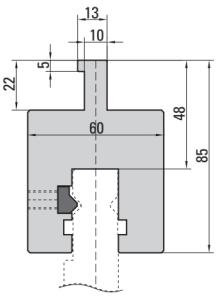
50.470 — 1000 kN/m

150 mm | 3,8 kg | On request

UKB-System LVD type II ➔
UKB-Systems Trumpf/Wila type I/LVD type I

SCAN TO SHOP





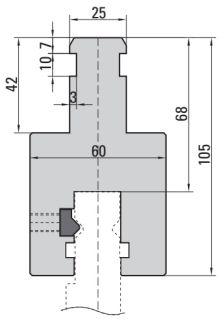
50.490 — 1000 kN/m

150 mm | 4,5 kg | On request

UKB-System Weinbrenner ➔
UKB-Systems Trumpf/Wila type I/LVD type I

SCAN TO SHOP



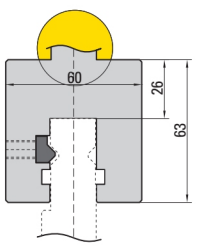


850.000 — 1000 kN/m

150 mm | On request

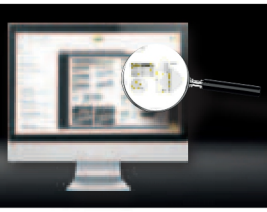
Individual punch/top tool adaptors ➔
UKB-Systems Trumpf/Wila type I/LVD type I
Please exactly measure the adaptor clamping!

SCAN TO SHOP



UKB-ONLINE CATALOGUES

View or download the catalog online



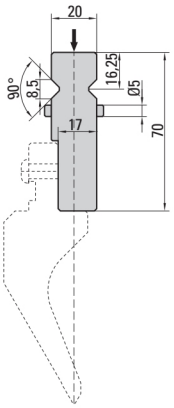
Screw on adaptor

50.965		24h 1000 kN/m
835 mm	8,3 kg	256,– €
415 mm	4,2 kg	168,– €
800 mm sectionalized	7,7 kg	336,– €

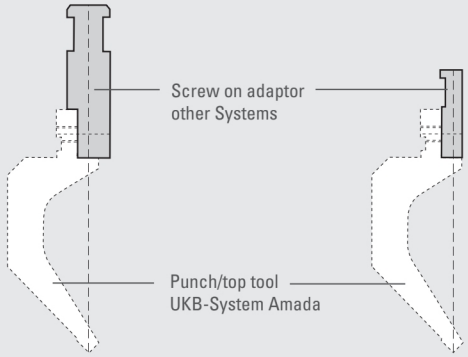
UKB-System Amada →
UKB-Systems Trumpf/Wila type I/LVD type I

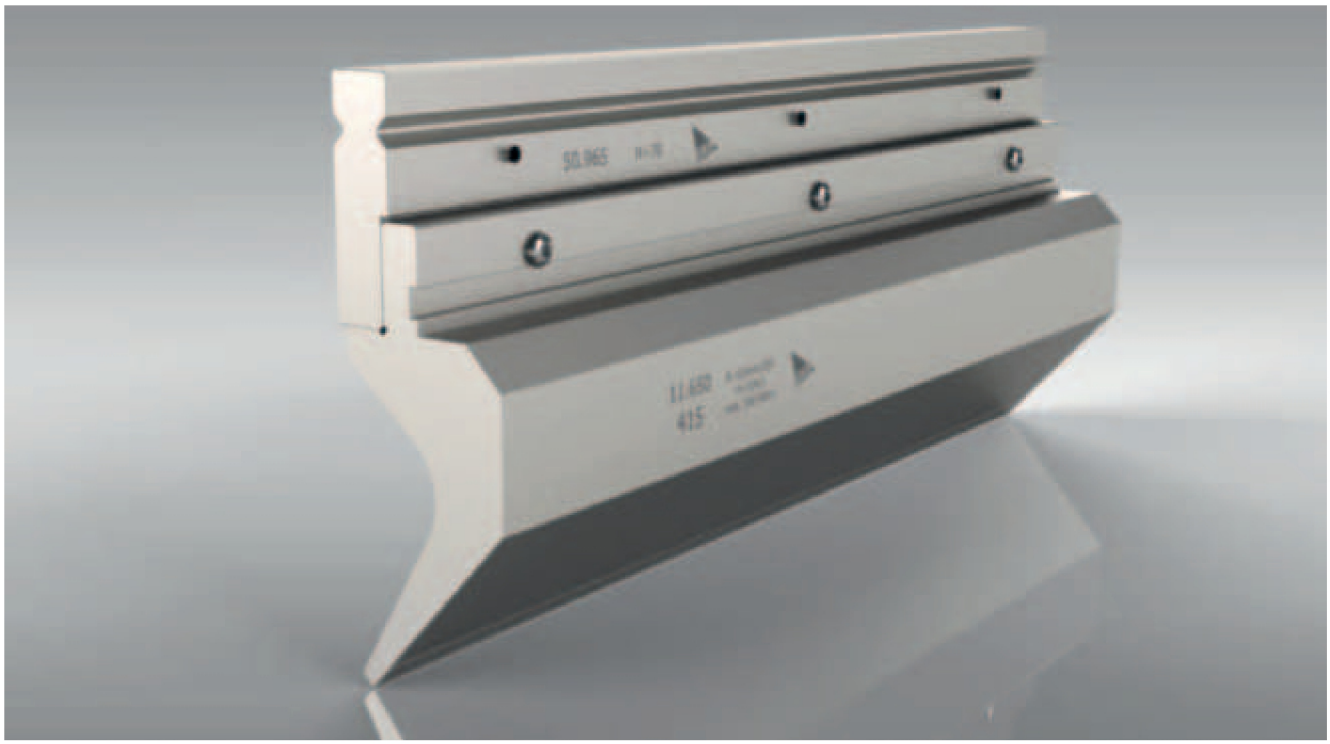
SCAN TO SHOP





EXAMPLE OF USE





UKB-FIELD SERVICE

- Individual advice and sale
- Test bending in your house or at the UKB-Test Center
- Tool demonstrations
- Pick up service for tools to rework

CHAPTER 19



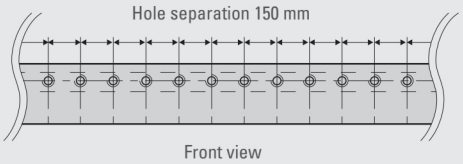
Die shoe adaptors UKB-System Amada

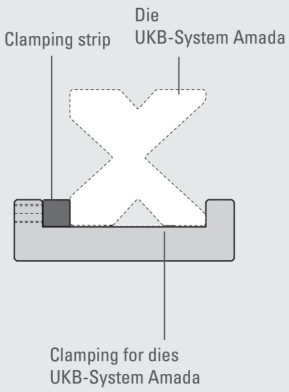
Product advantages

- 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 01)

EXAMPLE OF USE

M8 grub screw for a constant clamping of sectionalized dies UKB-System Amada with clamping strip



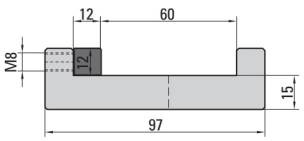


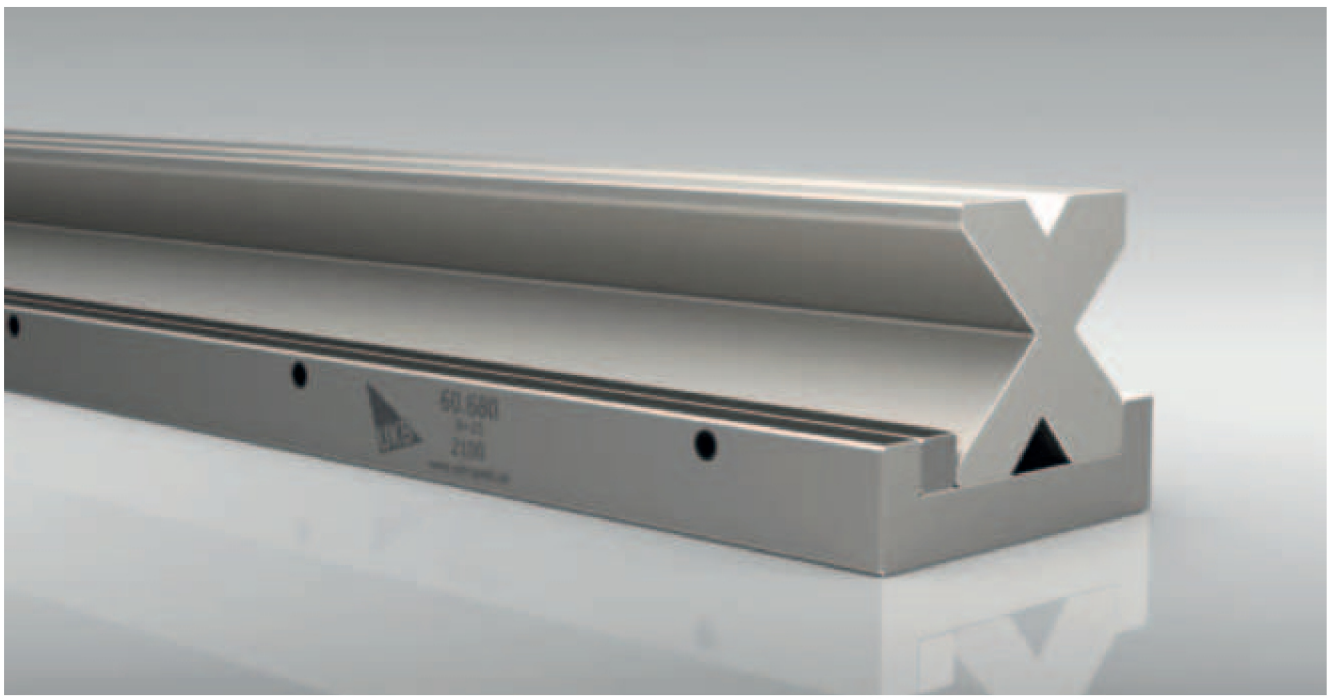
60.680 – 60.683

24h

Model	Length	Weight	Price
60.680	2100 mm	31,2 kg	668,– €
60.681	2600 mm	38,6 kg	824,– €
60.682	3100 mm	46,0 kg	974,– €
60.683	4100 mm	60,9 kg	1.264,– €

SCAN TO SHOP





Die shoe adaptors UKB-Systems Trumpf/Wila/Bystronic

Product advantages

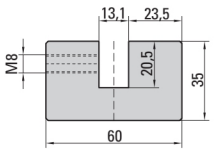
- Die shoe adaptor for 13 x 20 mm clamping width can be used on all press brakes with a flat table, to use dies **UKB-Systems Trumpf/Wila/Bystronic**
- Use the variety of the dies
  UKB-System Trumpf (see chapter 02)
  UKB-System Wila (see chapter 03)
  UKB-System Bystronic (see chapter 05)

60.901 – 60.904

24h

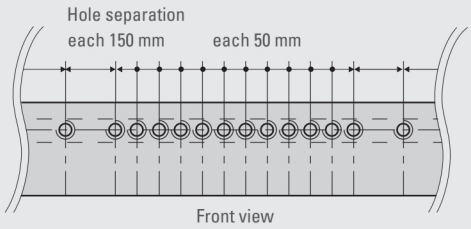
Model	Length	Weight	Price
60.901	2100 mm	30,0 kg	668,– €
60.902	2600 mm	37,2 kg	824,– €
60.903	3100 mm	44,3 kg	974,– €
60.904	4100 mm	58,6 kg	1.264,– €

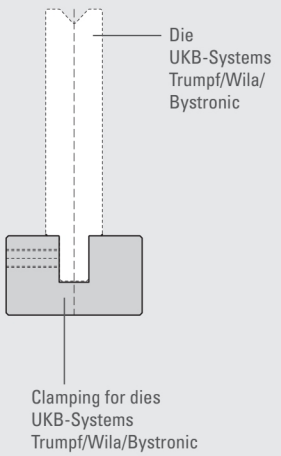
SCAN TO SHOP

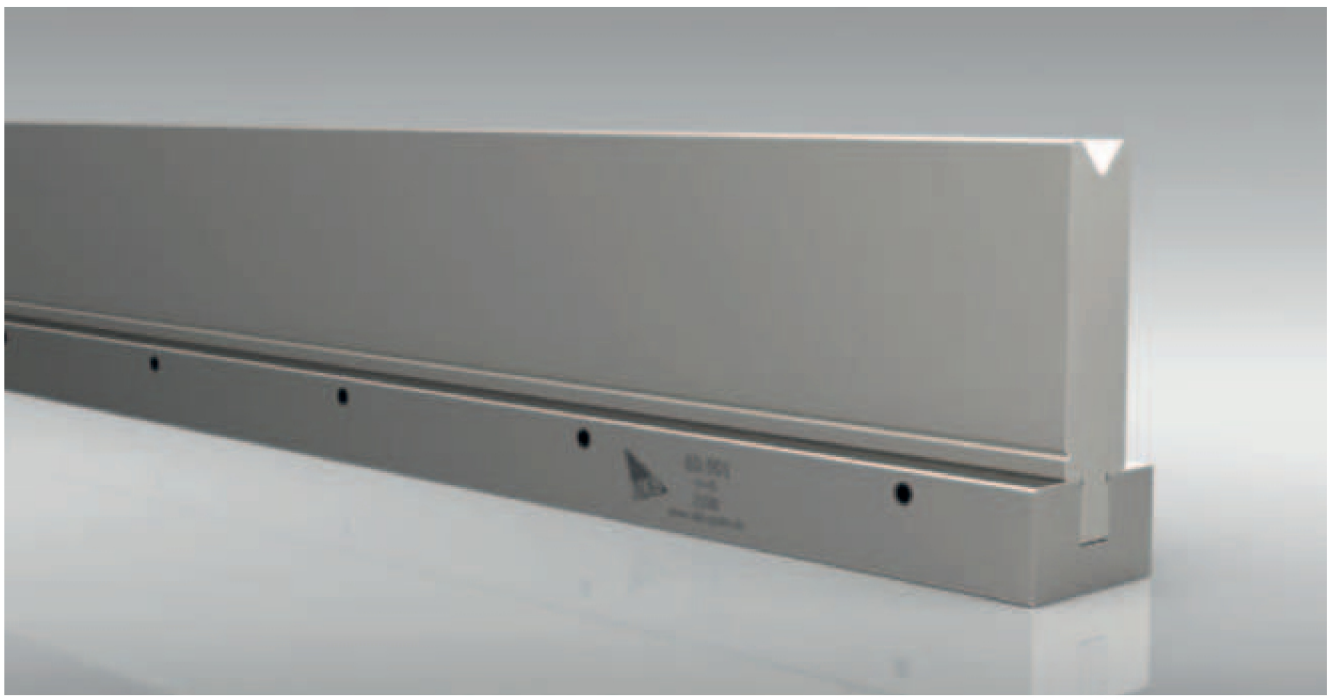


EXAMPLE OF USE

M8 grub screw for a constant clamping of sectionalized dies UKB-Systems Trumpf/Wila/Bystronic







Die adaptors

60.910

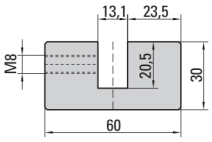
24h
1000 kN/m

1000 mm	12,0 kg	236,– €
500 mm	6,0 kg	136,– €

UKB-System Amada ➔
UKB-SystemsTrumpf/Wila/Bystronic

SCAN TO SHOP





60.920

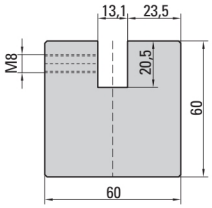
24h
1000 kN/m

1000 mm	26,1 kg	276,– €
500 mm	13,1 kg	160,– €

UKB-System Amada ➔
UKB-Systems Trumpf/Wila/Bystronic

SCAN TO SHOP





60.925

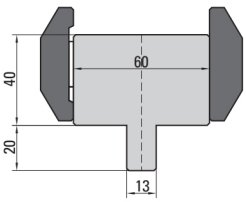
24h
1000 kN/m

835 mm	25,0 kg	336,– €
415 mm	12,5 kg	202,– €

UKB-Systems Trumpf/Wila/Bystronic ➔
UKB-System Amada

SCAN TO SHOP





60.940

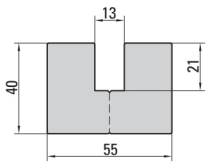
24h
1000 kN/m

500 mm	7,5 kg	278,– €

UKB-System EHT ➔
UKB-Systems Trumpf/Wila/Bystronic

SCAN TO SHOP





60.930

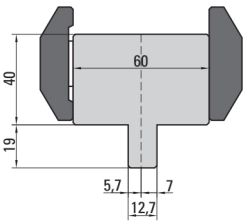
24h
1000 kN/m

835 mm	25,4 kg	336,– €
415 mm	12,6 kg	202,– €

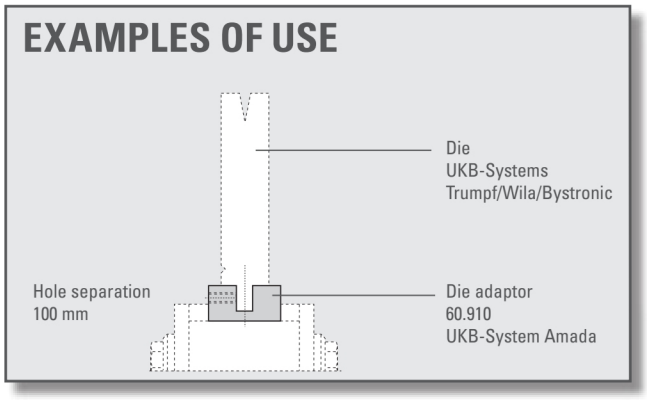
UKB-System LVD ➔
UKB-System Amada

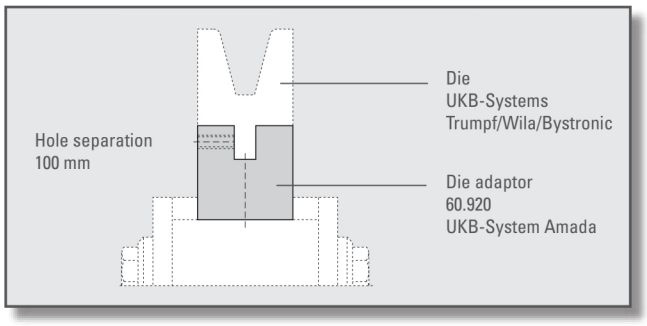
SCAN TO SHOP

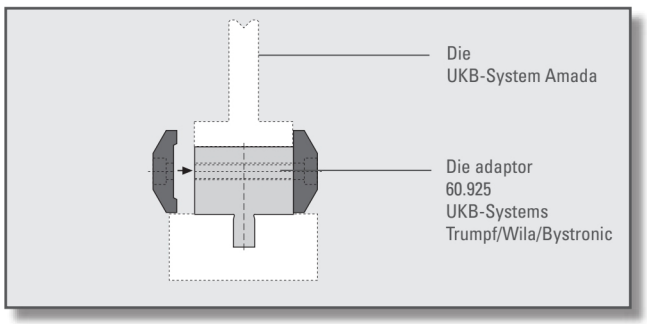


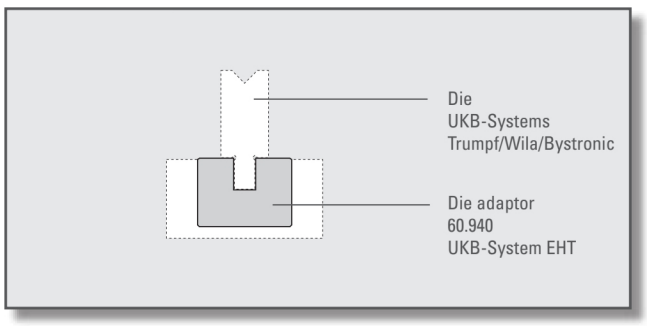


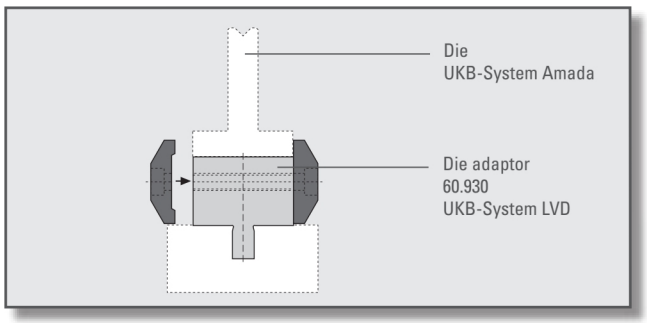
EXAMPLES OF USE











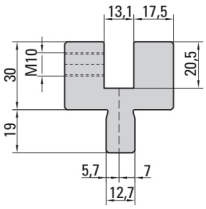
Die adaptors

60.935		24h 1000 kN/m
1000 mm	11,0 kg	422,– €
500 mm	5,5 kg	232,– €

UKB-System LVD ➔
UKB-Systems Trumpf/Wila/Bystronic

SCAN TO SHOP



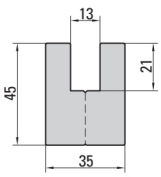


60.950		24h 1000 kN/m
500 mm	5,1 kg	258,– €

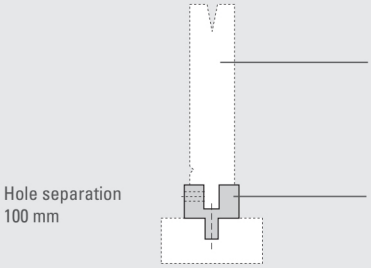
UKB-System Weinbrenner ➔
UKB-Systems Trumpf/Wila/Bystronic

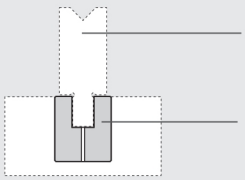
SCAN TO SHOP





EXAMPLES OF USE

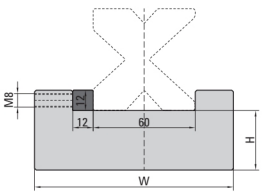




Individual die adaptors

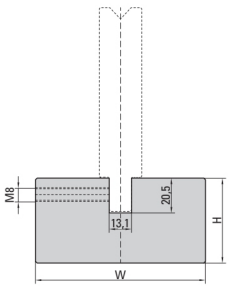
Individual die adaptor
➔ UKB-System Amada

Die adaptor according to your specifications suitable for your press brake
On request



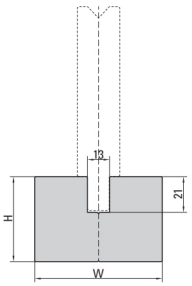
Individual die adaptor
➔ UKB-Systems Trumpf/Wila/ Bystronic

Die adaptor according to your specifications suitable for your press brake
On request



Individual die adaptor
➔ UKB-Systems Trumpf/Wila/ Bystronic

Die adaptor according to your specifications suitable for your press brake
On request





UKB-PRESS BRAKE TOOL CABINETS

Explanation 276
Flexible color design 277

Tool trolley
Tool trolley UKB-System Amada 278
Tool trolley UKB-Systems Trumpf/Wila/LVD 279

Press brake tool cabinets
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Shelves UKB-System Amada 281
Press brake tool cabinets UKB-Systems Trumpf/Wila/LVD/Bystronic 282-283
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Shelves UKB-Systems EHT/Weinbrenner/Other systems 285





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Press brake tool cabinets

Product advantages

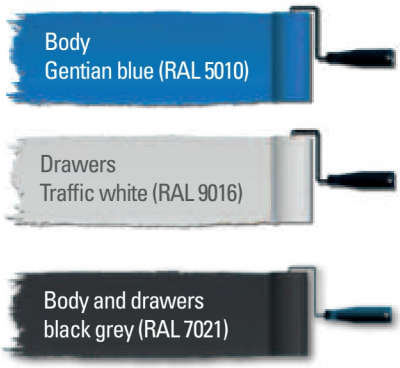
- Tools are **secured** against damage and soiling
- **Time-saving** through quick access and easy handling
- **Robust and strong construction**
- **Functional and practical**

VIDEO

UKB-Press brake tool cabinets



- Powder-coated in standard colours:





- Can be moved with a forklift or pallet truck



- Height adjustable, galvanized shelves for punches/top tools and dies
- 900 kg load capacity per drawer
- Access from both sides

Flexible colour design

FLEXIBLE COLOUR DESIGN FOR EACH PRESS BRAKE

► Available in all RAL-colours





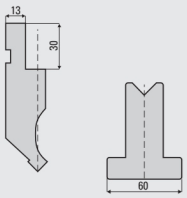
Tool trolley UKB-System Amada

40.630

RAL Colour	Model	Delivery time	Price
7021	40.630 S	24h	1.490,– €
RAL	40.630 RAL	On request	1.540,– €

RAL Colour on demand

SCAN TO SHOP

Tools	
Equipment	▸ 26 Pieces of shelves for punches/top tools and dies L ≤ 835 mm ▸ adjustable shelves
Capacity	Up to 22 m punches/top tools and dies
Dimensions	1090 mm x 1570 mm x 1140 mm (W x H x D)
Weight	72 kg





PUNCHES/TOP TOOLS

- due to asymmetrical shelves ideal for gooseneck punches/top tools
- suitable for sectionalized tools



DIES

- Universal shelves for dies and punches/top tools
- suitable for all die heights

Tool trolley UKB-Systems Trumpf/Wila/LVD

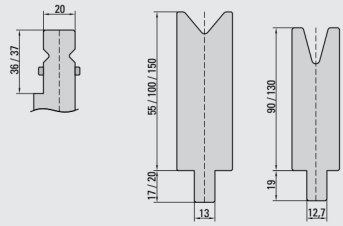
40.633

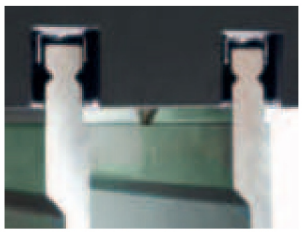
RAL Colour	Model	Delivery time	Price
7021	40.633 S	24h	1.794,– €
RAL	40.633 RAL	On request	1.844,– €

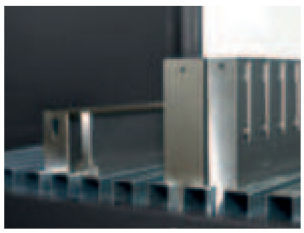
RAL Colour on demand

SCAN TO SHOP



Tools	
Equipment	▸ 8 Pieces of shelves for punches/top tools with safety pins L ≤ 500 mm ▸ 2 Pieces of shelves for punches/top tools In total about 1600 mm ▸ 48 Pieces of shelves for dies L ≤ 500 mm ▸ Possibility to store accessories
Capacity	Up to 5,6 m punches/top tools and up to 24 m dies
Dimensions	1060 mm x 1710 mm x 610 mm (W x H x D)
Weight	120 kg





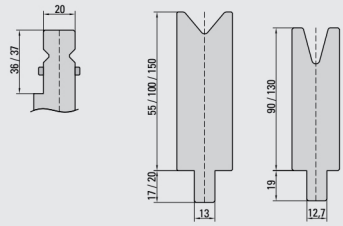
40.634

RAL Colour	Model	Delivery time	Price
7021	40.633 S	24h	812,– €
RAL	40.633 RAL	On request	862,– €

RAL Colour on demand

SCAN TO SHOP



Tools	
Equipment	▸ 8 Mounting rails for punches/top tools L ≤ 500 mm ▸ 24 Mounting rails for dies L ≤ 500 mm ▸ 1 drawer for accessories (Measuring devices, consumables, etc .) ▸ Possibility to store accessories
Capacity	Up to 6,4 m punches/top tools and up to 12 m dies
Dimensions	1000 mm x 980 mm x 600 mm (W x H x D)
Weight	80 kg





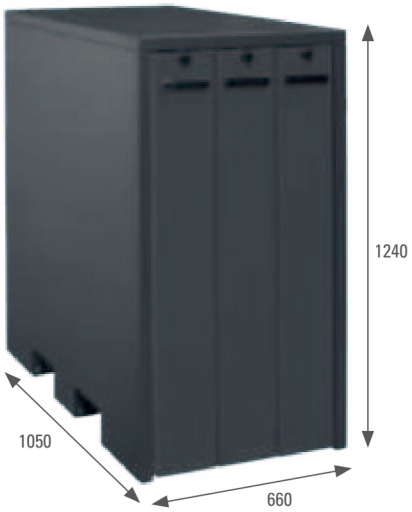
Press brake tool cabinets UKB-System Amada

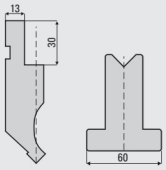
40.641

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
7021	7021	40.641 S	24h	1.926,– €
5010	9016	40.641 B	24h	1.926,– €
RAL	RAL	40.641 RAL	On request	1.976,– €

RAL Colour on demand

SCAN TO SHOP



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



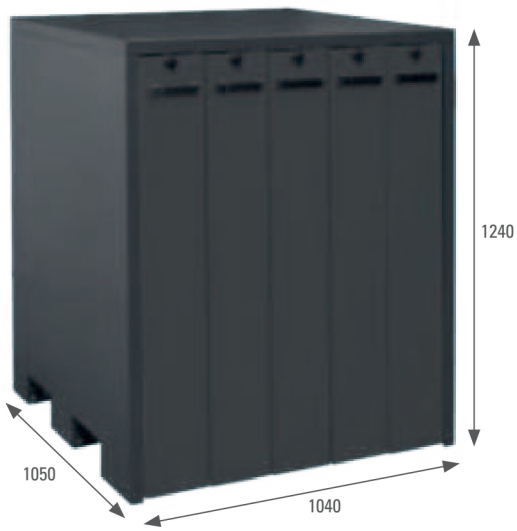


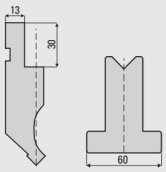
40.651

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
7021	7021	40.651 S	24h	2.550,– €
5010	9016	40.651 B	24h	2.550,– €
RAL	RAL	40.651 RAL	On request	2.600,– €

RAL Colour on demand

SCAN TO SHOP



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 punches/top tools and dies
Dimensions	1040 mm x 1240 mm x 1050 mm (W x H x D)
Weight	270 kg



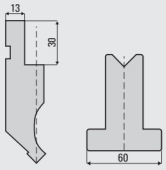


Press brake tool cabinets UKB-System Amada

40.650

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
7021	7021	**40.650 S**	**24h**	2.092,– €
5010	9016	**40.650 B**	**24h**	2.092,– €
RAL	RAL	**40.650 RAL**	On request	2.142,– €

RAL Colour on demand

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 punches/top tools and dies
Dimensions	900 mm x 1550 mm x 900 mm (W x H x D)
Weight	220 kg

SCAN TO SHOP





Shelves UKB-System Amada

92.681 — 24h

SCAN TO SHOP

1,8 kg — 16,– €

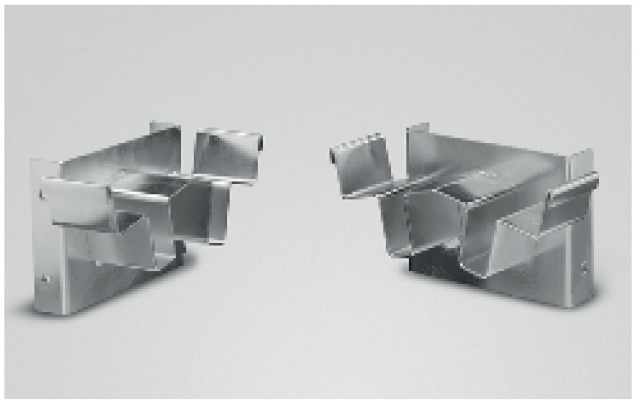
For Punches/top tools and dies
with L = 835 mm
Capacity : 1,67 m

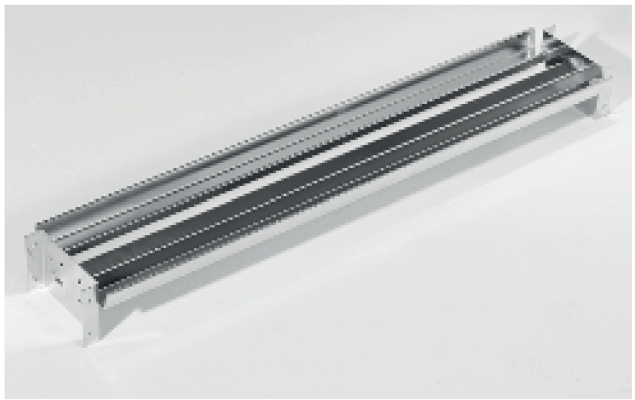
92.682 — 24h

SCAN TO SHOP

4,1 kg — 56,– €

For punches/top tools and dies
with L ≤ 835 mm
Capacity : 1,67 m





Press brake tool cabinets UKB-Systems Trumpf/Wila/LVD/Bystronic

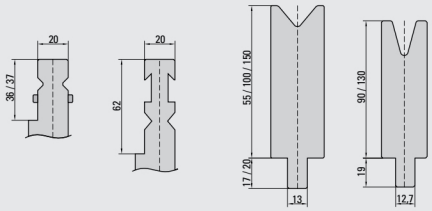
40.643

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
5010	9016	**40.643 B**	**24h**	2.148,– €
7021	7021	**40.643 S**	**24h**	2.148,– €
RAL	RAL	**40.643 RAL**	On request	2.198,– €

RAL Colour on demand

SCAN TO SHOP



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





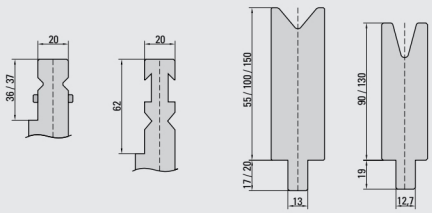
40.653

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
5010	9016	**40.653 B**	**24h**	2.758,– €
7021	7021	**40.653 S**	**24h**	2.758,– €
RAL	RAL	**40.653 RAL**	On request	2.808,– €

RAL Colour on demand

SCAN TO SHOP



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

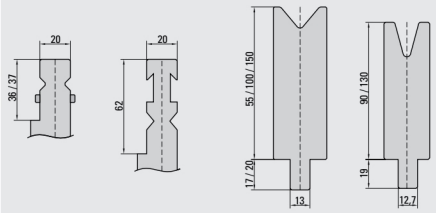
40.654

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
5010	9016	**40.654 B**	**24h**	3.430,– €
7021	7021	**40.654 S**	**24h**	3.430,– €
RAL	RAL	**40.654 RAL**	On request	3.480,– €

RAL Colour on demand

SCAN TO SHOP



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 seperating 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

SCAN TO SHOP

5,2 kg	60,– €

For punches/top tools with L ≤ 1100 mm
Capacity : 2,2 m

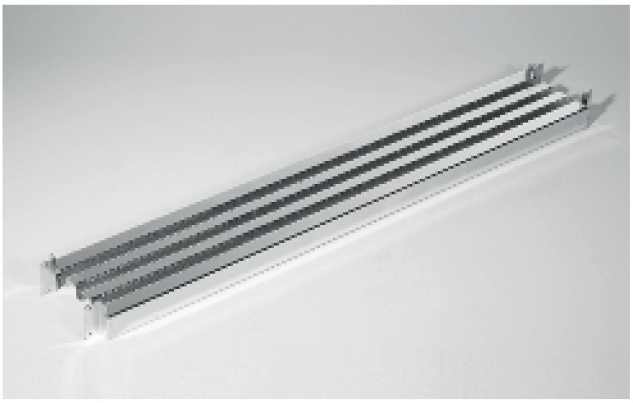
92.686 — 24h

SCAN TO SHOP

5,2 kg	66,– €

For dies with L ≤ 1100 mm
incl. 6 seperating plates
Capacity : 3,3 m





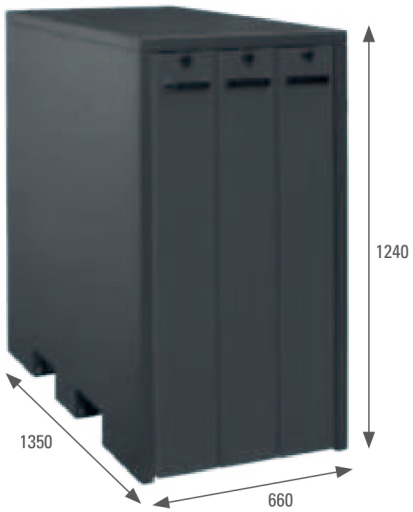
Press brake tool cabinets UKB-Systems EHT/Weinbrenner/Other Systems

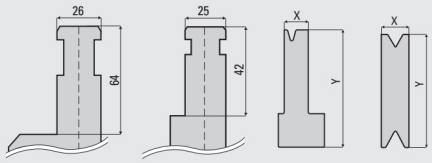
40.642

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
7021	7021	**40.642 S**	**24h**	2.114,– €
5010	9016	**40.642 B**	**24h**	2.114,– €
RAL	RAL	**40.642 RAL**	On request	2.164,– €

RAL Colour on demand

SCAN TO SHOP



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 punches/top tools and dies
Dimensions	660 mm x 1240 mm x 1350 mm (W x H x D)
Weight	245 kg



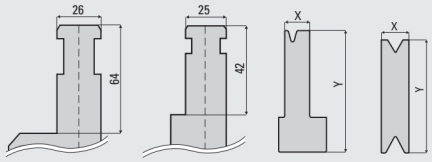
40.652

RAL Colour Body	RAL Colour Drawers	Model	Delivery time	Price
7021	7021	**40.652 S**	**24h**	2.718,– €
5010	9016	**40.652 B**	**24h**	2.718,– €
RAL	RAL	**40.652 RAL**	On request	2.768,– €

RAL Colour on demand

SCAN TO SHOP



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 punches/top tools and dies
Dimensions	1040 mm x 1240 mm x 1350 mm (W x H x D)
Weight	360 kg



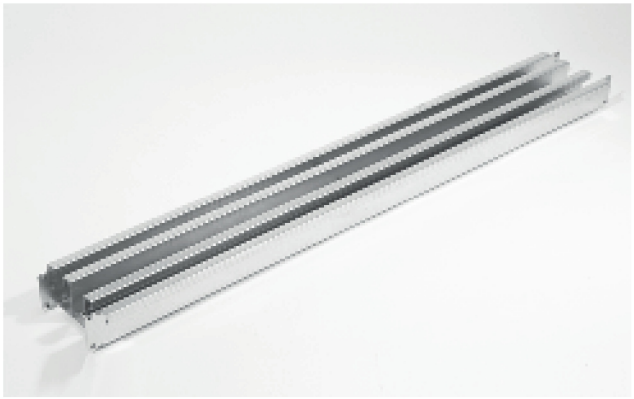
Shelves UKB-Systems EHT/Weinbrenner/Other systems

92.684 24h

6,5 kg 60,– €

SCAN TO SHOP

For punches/top tools and dies
with L ≤ 1100 mm,
clamping flange individual adjustable
Capacity: 3,3 m



UKB-INTERMEDIATES „SPEEDGRIP“

- Quick **vertical** tool change for punches/top tools UKB-System Amada - without modification
- Automatic clamping and centering
- Cost-effective, simple and quick retrofit of your press brake

CHAPTER 01

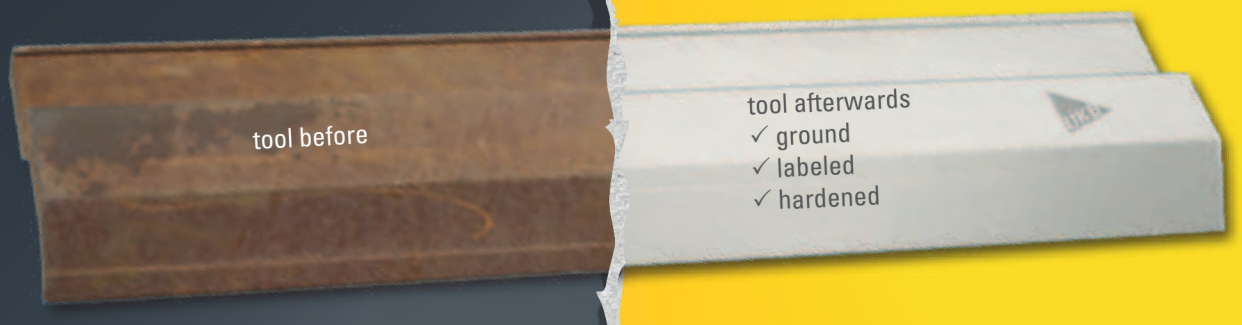


UKB-REPAIR AND REGRINDINGSERVICE

Old tools – precision-restored!

✓ precisely ✓ professionally
✓ inexpensive ✓ fast

1 working day
(according agreement)



UKB-ACCESSORIES

Squaring arms. 288-289
Digital angle gauges 289
Insertion tools. 290-291
Punch tool adaptor 292
Vibro Hammer. 293





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Squaring arms

VIDEO
UKB-Accessories

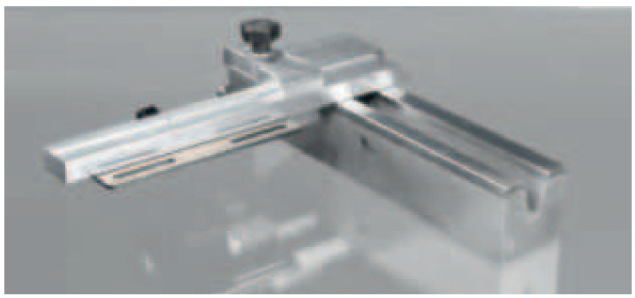
PRODUCT ADVANTAGES

- **Flexible and exact adjustable**
- **Angle infinitely variable** (depending on the model)
- **Stopper system** for long, small and not square sheet metal parts

SQUARING ARMS 90°

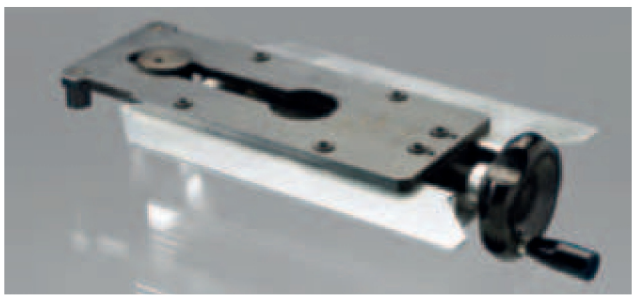
40.720 24h
1,5 kg 184,– €

- 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
1,5 kg 206,– €

- 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



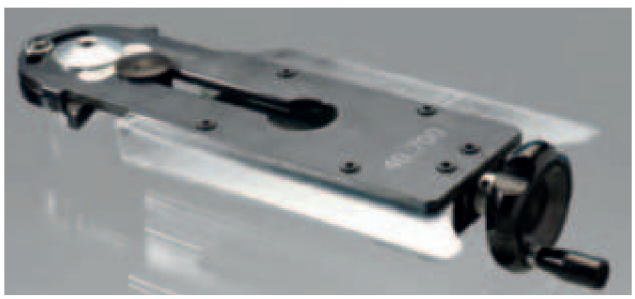
40.660 24h
3,0 kg 266,– €

- 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
3,5 kg 336,– €

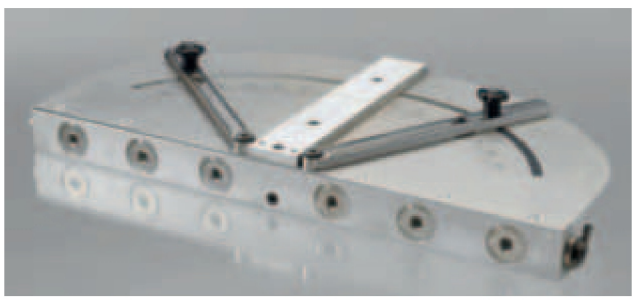
- Stepless angle adjustment by 30° each
- Usable as a stop left and right
- Fixation on the die by adjustable clamping
- Flexible applicable on all dies up to 60 mm width
- Light construction
- Dimensions (H x W x D) about 70 x 170 x 460 mm



MAGNETIC, ADJUSTABLE SQUARING ARM 30° – 90°

40.750 24h
5,5 kg 550,– €

- 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 devices
- 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

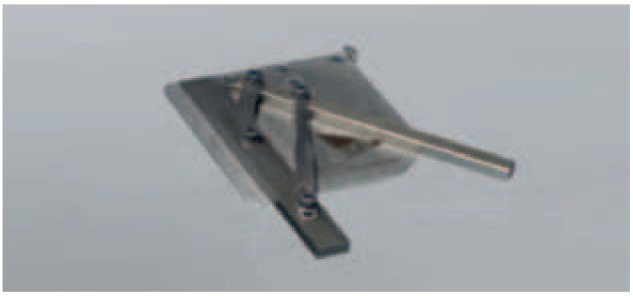
SQUARING ARMS 0° – 90°

40.740 24h

1,5 kg 252,– €

SCAN TO SHOP

- 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

1,5 kg 252,– €

SCAN TO SHOP

- 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

3,0 kg Set 478,– €

SCAN TO SHOP

- Stepless angle adjustment 90°
- Usable as a stop left or 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) each about 50 x 130 x 190 mm



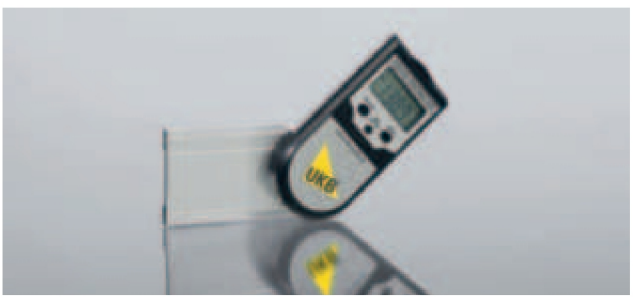
Digital angle gauges

40.015 24h

0,2 kg 62,– €

SCAN TO SHOP

- 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

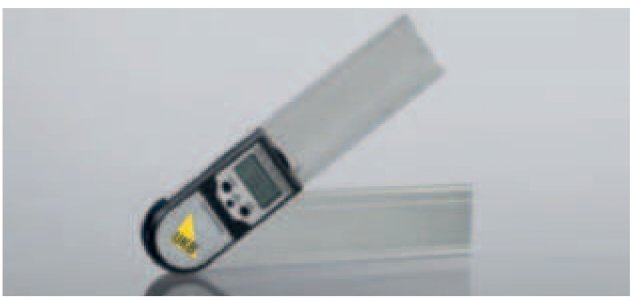


40.016 24h

0,4 kg 68,– €

SCAN TO SHOP

- 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



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

UKB-SYSTEM AMADA

40.950		24h
1 Set	5,5 kg	878,– €

Set consists of:
Punch/top tool holder
Die holder
4 Bolts
Tool case

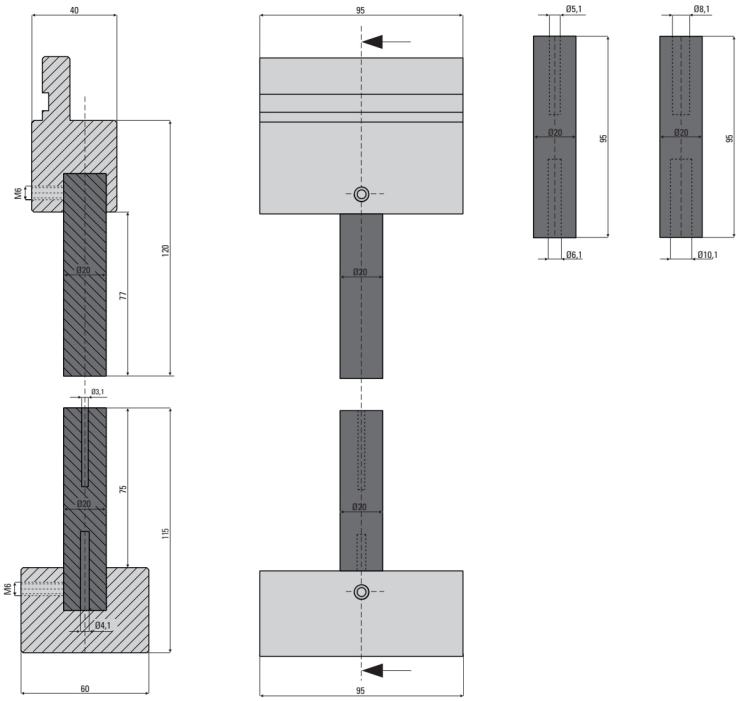
SCAN TO SHOP



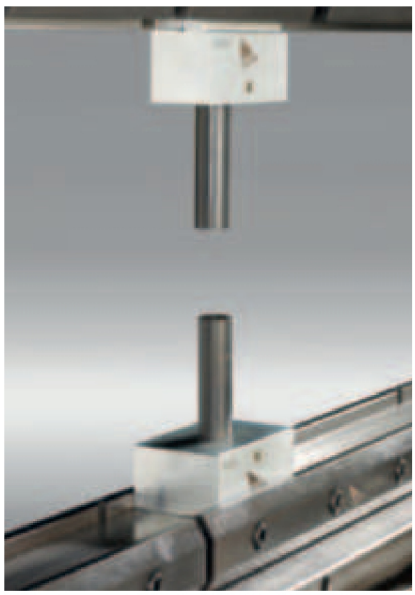
UKB-INFO

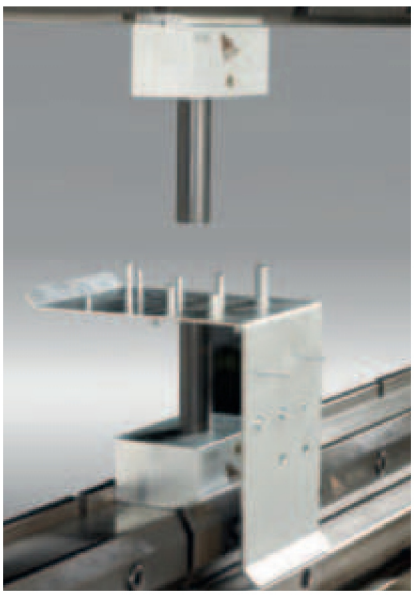
Via adaptor systems applicable on all other press brakes!





Insertion tools





UKB-SYSTEMS TRUMPF/WILA

40.960 24h

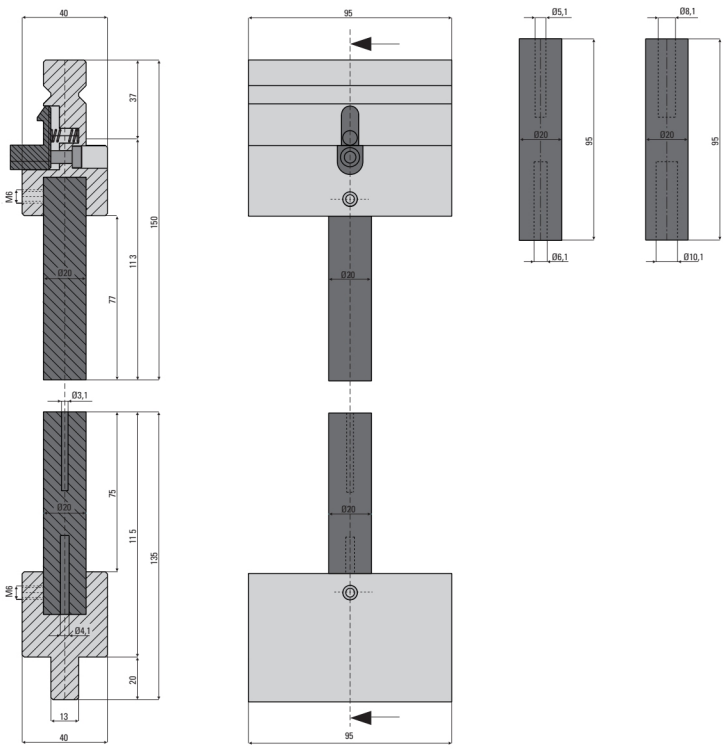
1 Set	5,2 kg	878,– €

Set consists of:
Punch/top tool holder incl. Simple Clamp
Die holder
4 Bolts
Tool case

SCAN TO SHOP







Punch tool adaptor

Product advantages

- Use your **punching tools** on the **press brake**
- **Expanded production capabilities** thanks to the installation height and higher tonnage of the press brake
- **Increased machine flexibility** shortens lead times
- **Punching contours can be added subsequently**
- **Increased production depth** on the press brake, including through station bending combinations
- All **Trumpf-type punching tools** can be used

Punch tool adaptor

24h

1000 kN/m

SCAN TO SHOP

Model	Suitable for	Weight	Price per Set
40.970	UKB-Systems Trumpf/Wila	12,0 kg	980,– €
40.971	UKB-System Amada	11,3 kg	980,– €
40.972	UKB-System Bystronic	12,0 kg	980,– €



40.970 UKB-Systems Trumpf/Wila



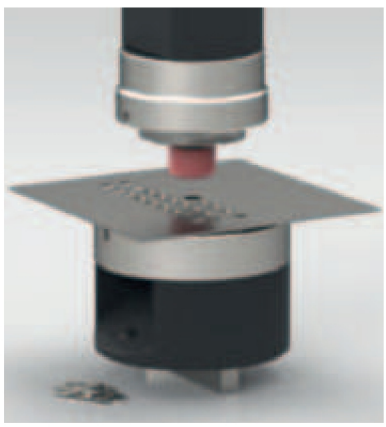
40.971 UKB-System Amada



40.972 UKB-System Bystronic



Ideal for smaller contours, e.g. as a louver tool



Opening for easy removal of punching waste and use of punching tools with PU hold-down

Vibro Hammer

Product advantages

- **Blanks** of laser or water jet cut sheets **can be easily removed**
- The **exchangeable tool inserts** prevent damage
- Enormous **reduction of time and effort**
- **Easy connection** to your conventional compressor / air pressure connection
- The vibration can be controlled by **regulating the air pressure**
- Tool inserts **available as spare parts**

40.100			24h
Vibro Hammer	Set	1,3 kg	400,– €

incl. all 4 tool inserts (40.101 - 40.104)

SCAN TO SHOP



VIDEO
UKB-Vibro Hammer

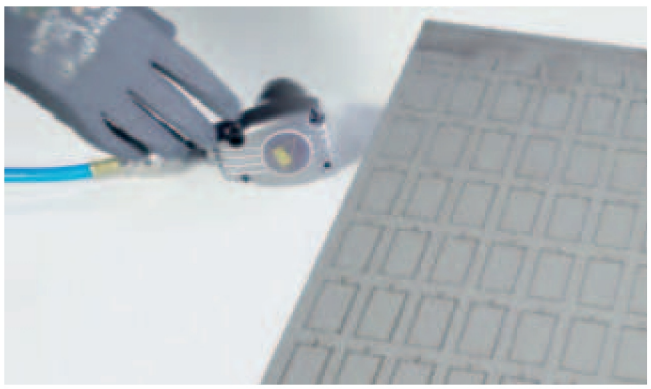
Tool inserts

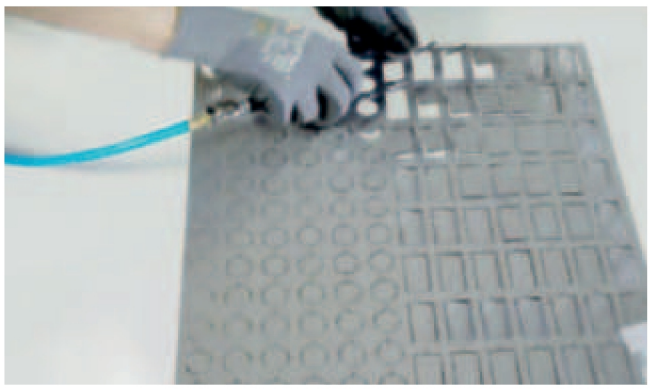
24h

SCAN TO SHOP

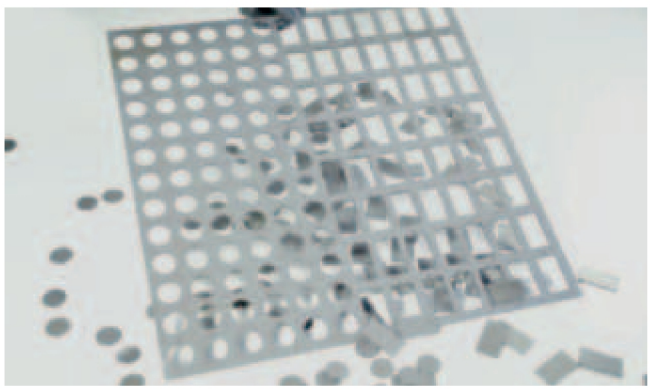
Model	Tool insert material	Colour	Weight	Price
40.101	Soft-Plastic	blue	0,1 kg	32,– €
40.102	Medium-Plastic	black	0,1 kg	32,– €
40.103	Hard-Plastic	yellow	0,1 kg	32,– €
40.104	Aluminium	silver	0,1 kg	32,– €











UKB-MODIFICATION OF PRESS BRAKE TOOLS

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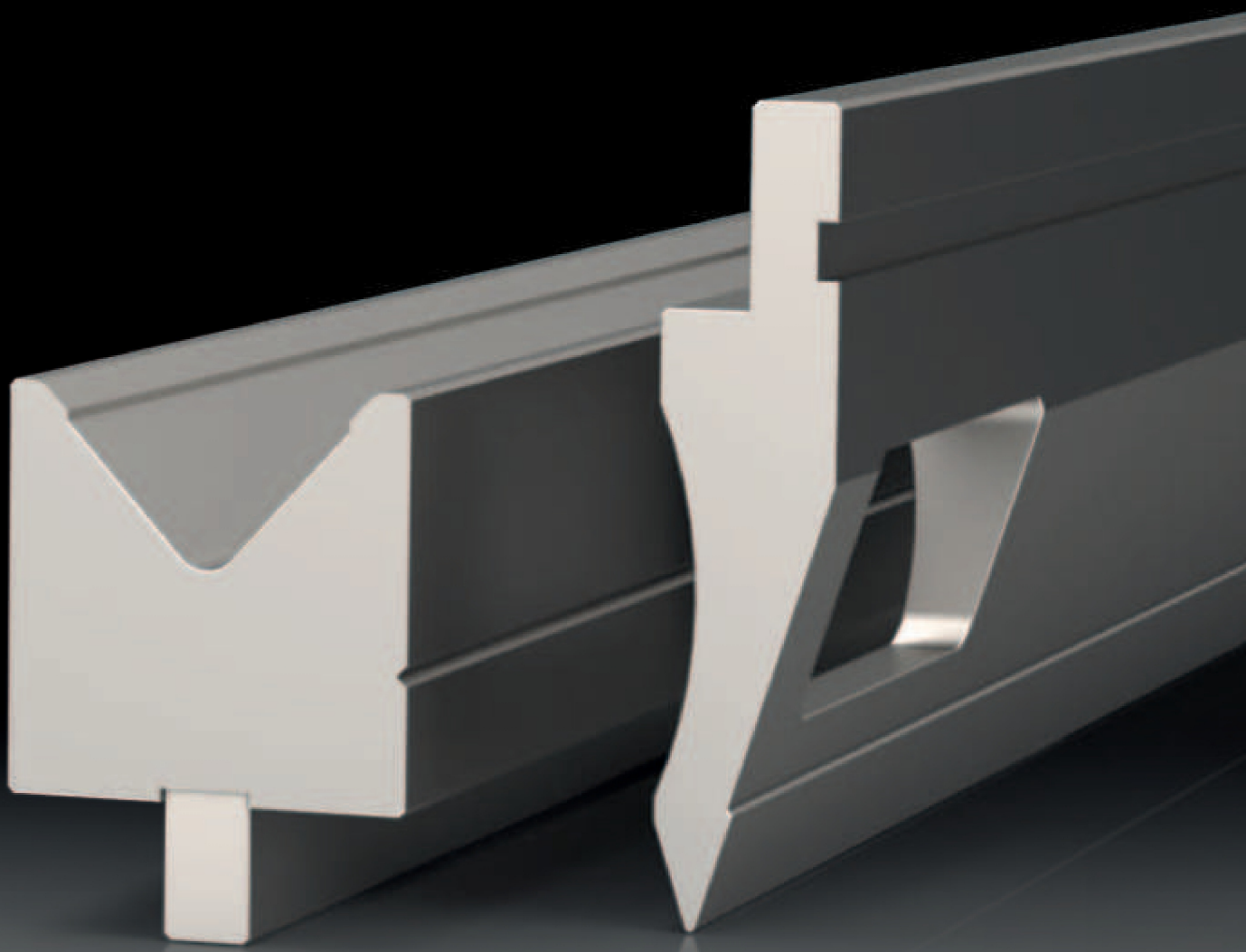

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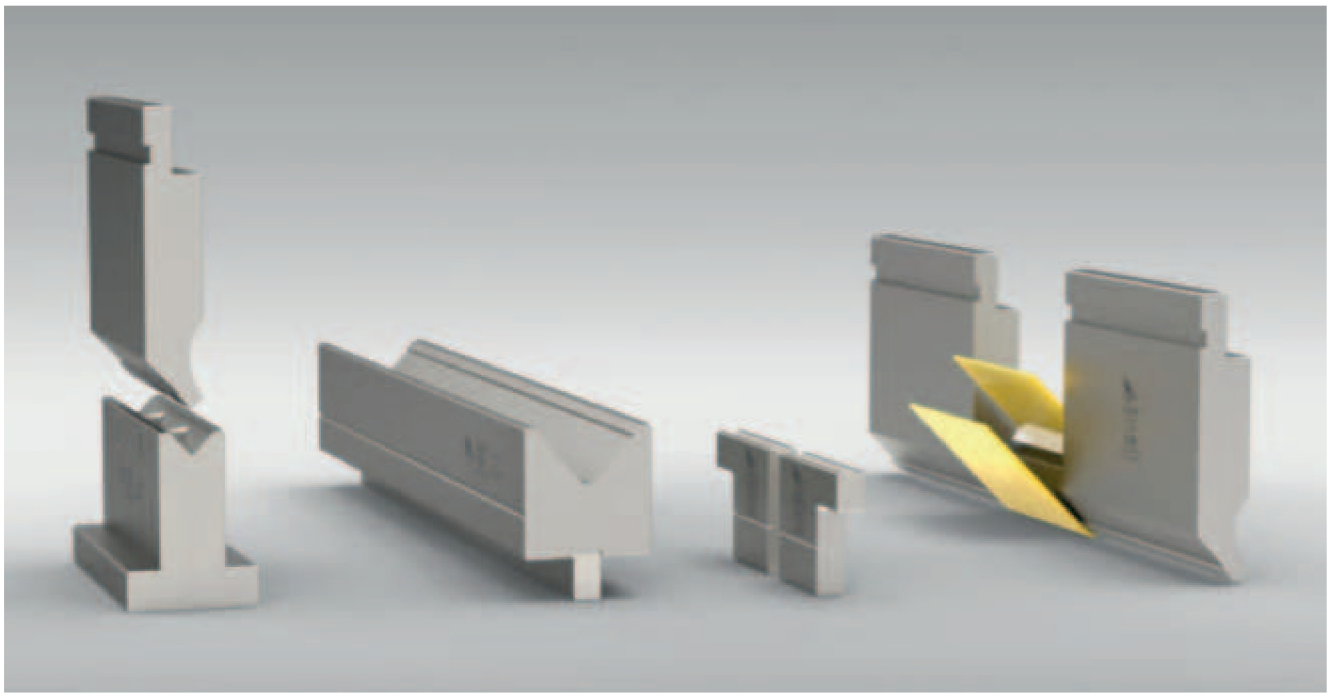
MODIFICATION OF PRESS BRAKE TOOLS

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
- Change of V-openings
- Laser marking
- Surface coating and refinement
- Insertion of drill holes

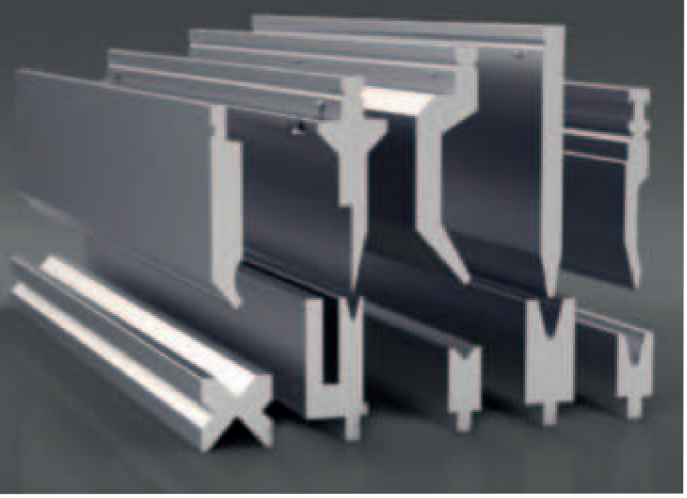
VIDEO

UKB-Modification of press brake tools



toolsystems24.de
Press Brake Tools Outlet — made by UKB

- Special offers
- Deal of the week
- Demonstration tools & test tools
- Special and remaining stock
- Used 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 CUSTOMISED MODIFICATION

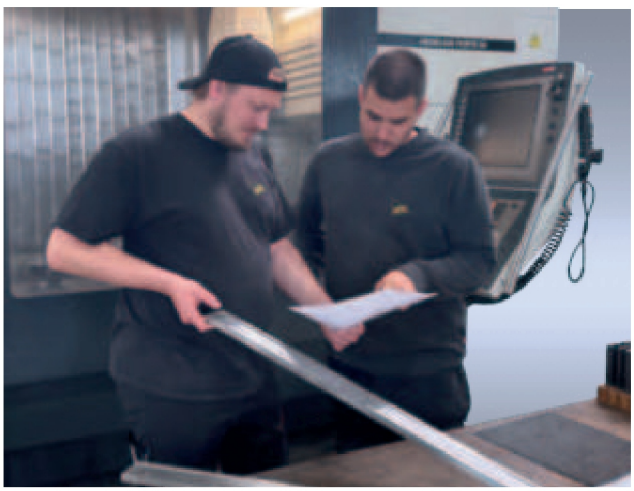
=

FASTEST REALISATION OF YOUR DEMANDS!

According agreement within 1 working day!



High stock availability



Fast realisation of your demands



Modification department

Modification of clampings UKB-System Amada

ADVANTAGES

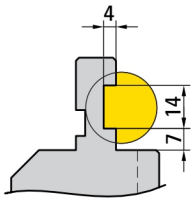
- Punches/top tools UKB-System Amada (chapter 01) via modifications applicable on other press brakes
- According agreement within **1 working day**

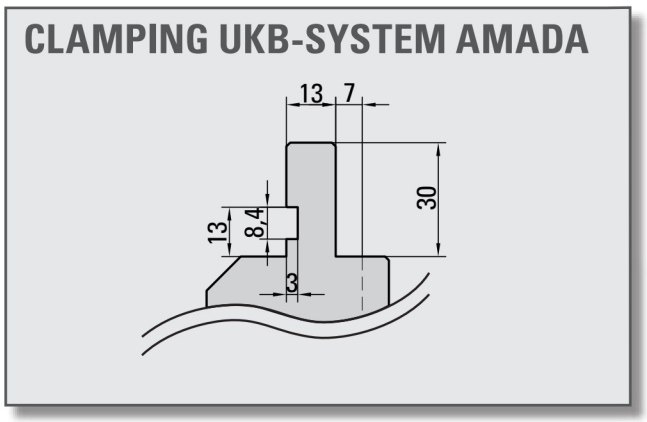
EXAMPLES FOR MODIFICATIONS

70.501 — 72h

835 mm	35,– €
415 mm	25,– €
800 mm sectionalized	55,– €

Additional groove for:
- UKB-System Wila type II

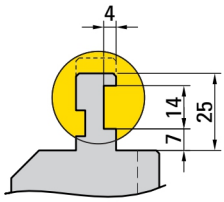




70.503 — 72h

835 mm	65,– €
415 mm	50,– €
800 mm sectionalized	95,– €

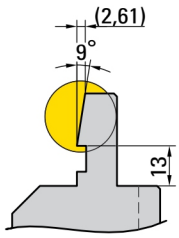
Additional groove and shortened head for:
- UKB-System Wila type II



70.504 — 72h

835 mm	55,– €
415 mm	40,– €
800 mm sectionalized	75,– €

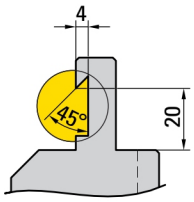
Clamping for:
- „Amada one touch"



70.600 — 72h

835 mm	65,– €
415 mm	50,– €
800 mm sectionalized	105,– €

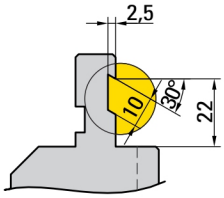
Modified groove for:
- Hydraulic clamping Gasparini



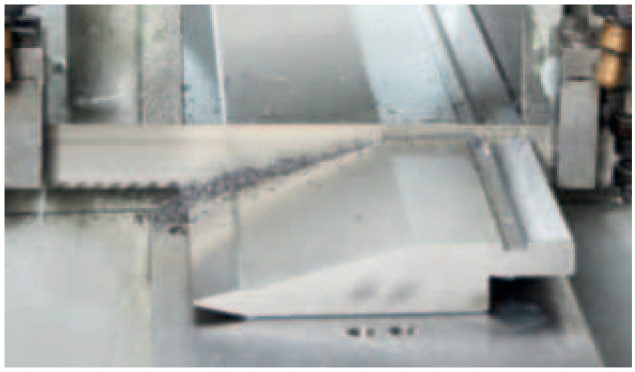
70.1050 — 72h

835 mm	65,– €
415 mm	50,– €
800 mm sectionalized	105,– €

Additional groove for:
- Pneumatic clamping „CLARK®"



Special cuttings



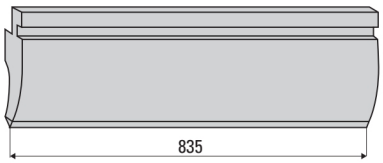
ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- According agreement within **1 working day**

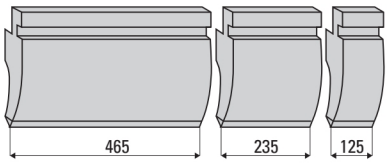
EXAMPLES FOR MODIFICATIONS

70.000	72h
Per piece	from 25,– €

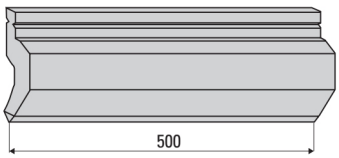
Before



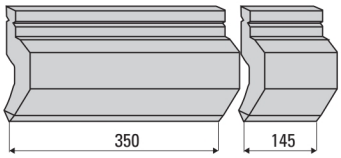
After



Before



After





MODIFICATION

Individual horn extensions

ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- According agreement within **1 working day**

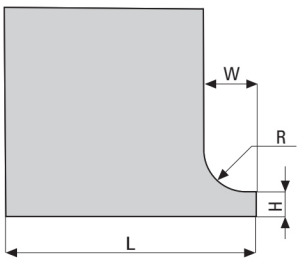
UKB-INFO

The maximum load could be reduced by modification!

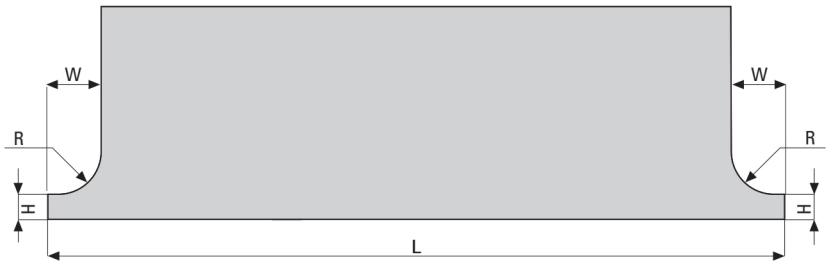
70.200	**72h**
Per piece	from 40,– €

EXAMPLES FOR MODIFICATIONS

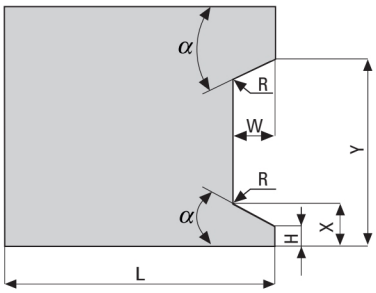
One-sided



Left and right



One-sided



Left and right





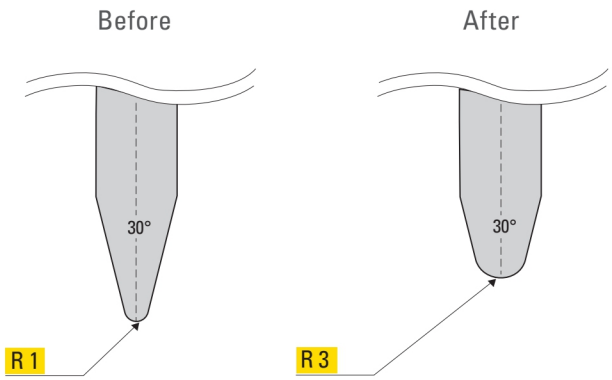
Change of radii

ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- Rehardening if necessary
- According agreement within **1 working day**

70.100 72h

EXAMPLE FOR MODIFICATION



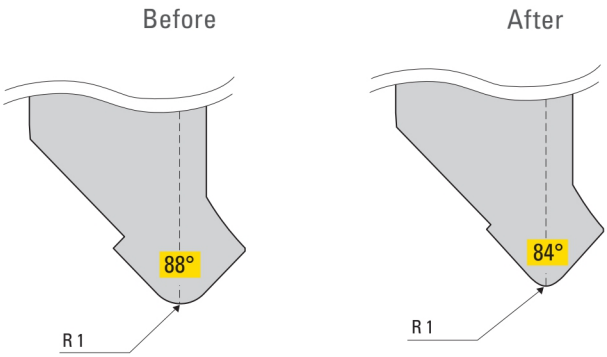
Change of angles

ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- Rehardening if necessary
- According agreement within **1 working day**

70.100 72h

EXAMPLE FOR MODIFICATION



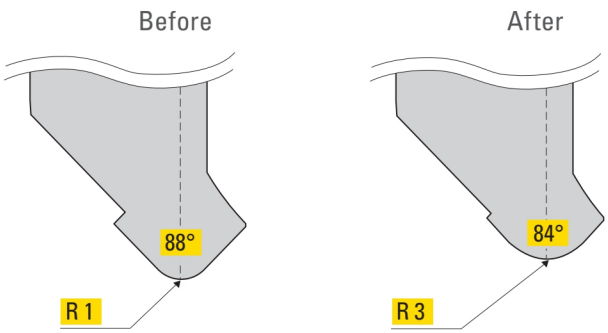
Change of radii and angles

ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- Rehardening if necessary
- According agreement within **1 working day**

70.100 72h

EXAMPLE FOR MODIFICATION



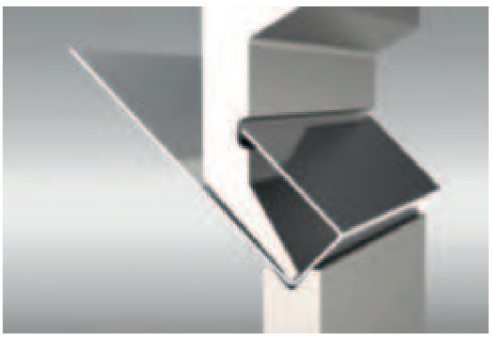
MODIFICATION

Cut-outs at punches/top tools

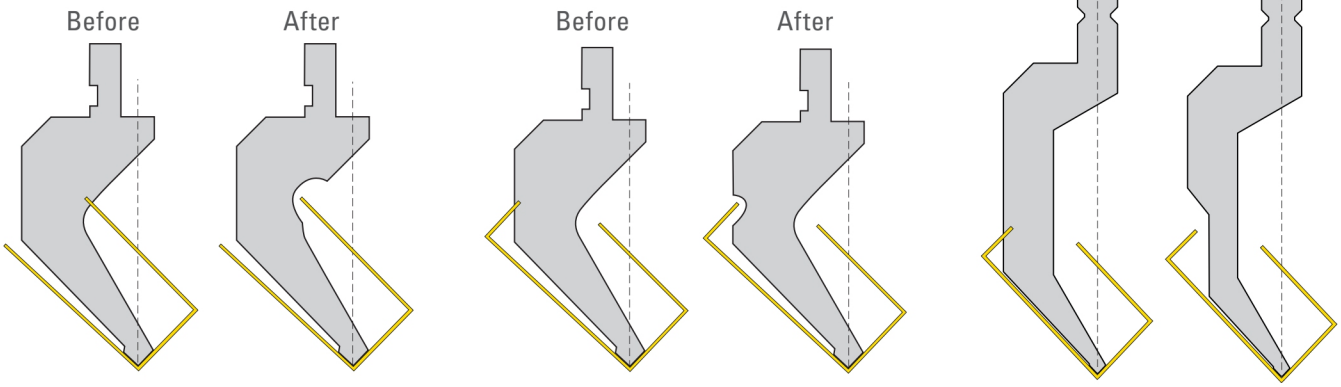
ADVANTAGES

- Cost-saving, fast modification of all punches/top tools
- According agreement within **1 working day**

Reworking of tools **72h**



EXAMPLES FOR MODIFICATIONS



Beading in the bending

UKB-INFO

The maximum load could be reduced by modification!

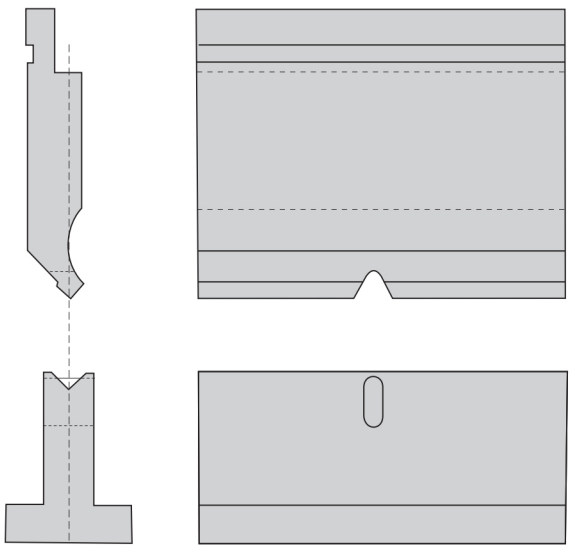
ADVANTAGES

- Cost-saving, fast modification of all punches/top tools and dies

EXAMPLE FOR MODIFICATION

70.102 **72h**

Insertion of a bolt in the die and appropriate milling in the punch/top tool for beading in the bending





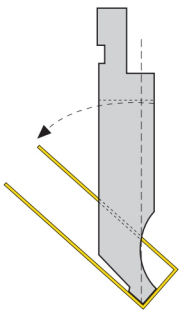
Windows for U-profiles

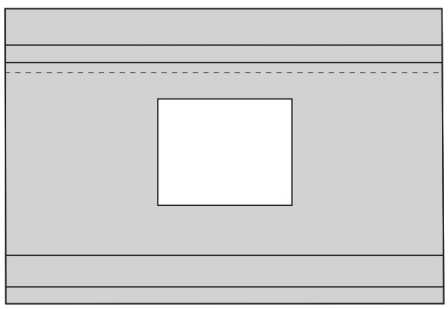
ADVANTAGES

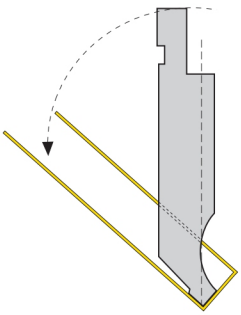
- Cost-saving, fast modification of all punches/top tools
- According agreement within **1 working day**

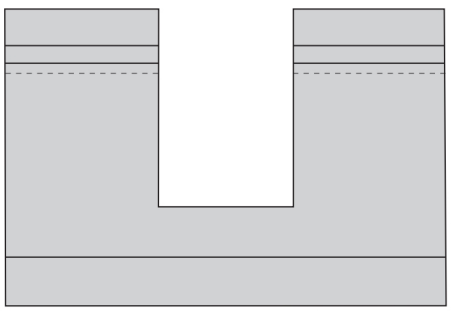
Reworking of tools 72h

EXAMPLES FOR MODIFICATIONS

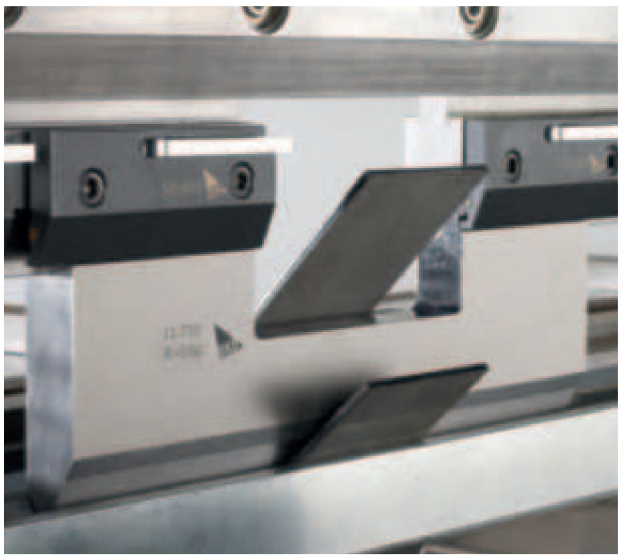










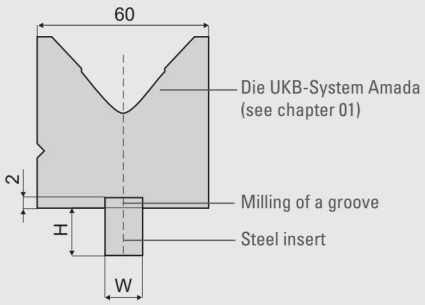


Insertion of a steel insert

ADVANTAGES

- Cost-saving and fast modification of dies UKB-System Amada (chapter01) for the use on other press brakes
- According agreement within **1 working day**

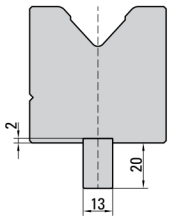
EXAMPLE OF USE



EXAMPLES FOR MODIFICATIONS

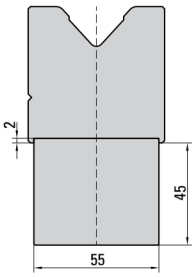
70.990	72h
835 mm	70,– €
415 mm	50,– €
800 mm sectionalized	190,– €

Steel insert 13 x 22 mm
- UKB-Systems Trumpf/Wila/ Bystronic



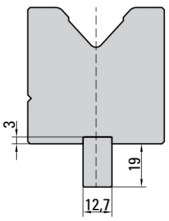
70.995	72h
835 mm	235,– €
415 mm	145,– €
800 mm sectionalized	460,– €

Steel insert 55 x 47 mm
- UKB-System EHT



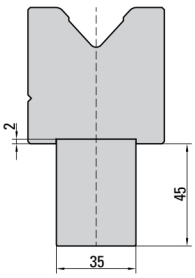
70.991	72h
835 mm	70,– €
415 mm	50,– €
800 mm sectionalized	190,– €

Steel insert 12,7 x 21 mm
- UKB-System LVD



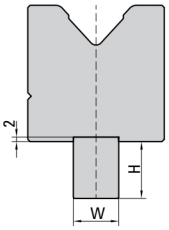
70.992	72h
835 mm	195,– €
415 mm	120,– €
800 mm sectionalized	420,– €

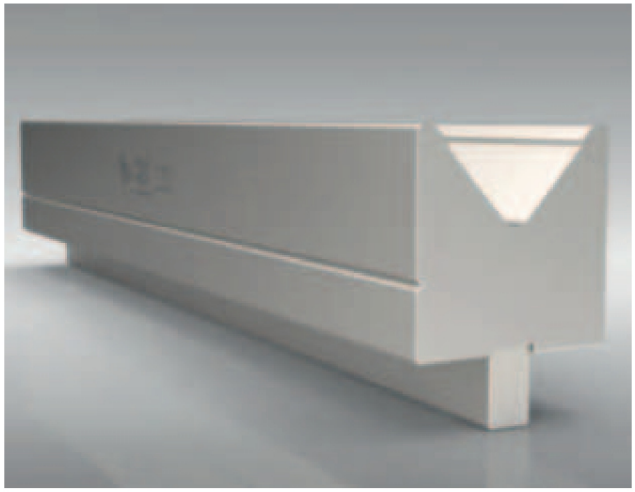
Steel insert 35 x 47 mm
- UKB-System Weinbrenner



70.993	72h
835 mm	On request
415 mm	On request
800 mm sectionalized	On request

Steel insert for other systems



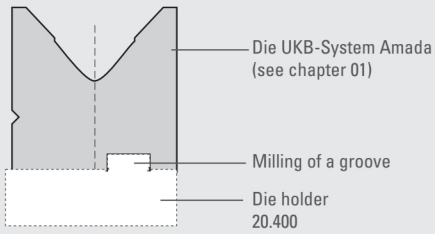


Milling of a groove

ADVANTAGES

- Cost-saving and fast modification of dies
- According agreement within **1 working day**

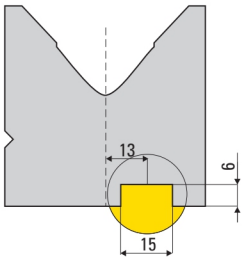
MODIFICATION EXAMPLE



EXAMPLES FOR MODIFICATIONS

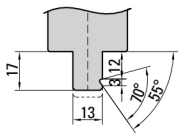
70.994	72h
835 mm	60,– €
415 mm	40,– €
800 mm sectionalized	85,– €

Groove for die holders
- UKB-System Amada 20.287 and 20.400 for centrical 2-V dies (see page 59)



70.900	72h
500/515 mm	45,– €
300 mm	35,– €
200 mm	30,– €
100 mm	25,– €
550 mm sectionalized	85,– €

Centering groove and shortened tang for dies
- UKB-Systems Trumpf/Wila/ Bystronic



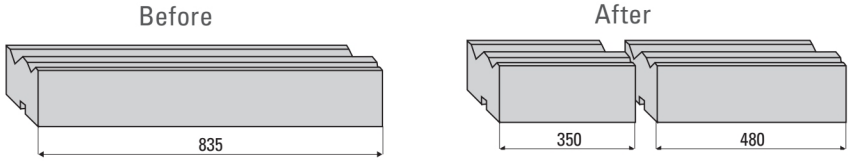
Special cuttings

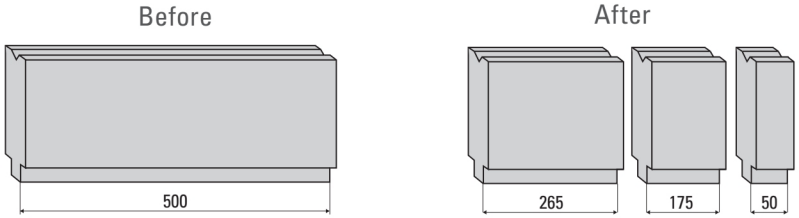
ADVANTAGES

- Cost-saving and fast modification of dies
- According agreement within **1 working day**

EXAMPLES FOR MODIFICATIONS

70.000	72h
Per piece	From 25,– €





MODIFICATION

Cut-outs at dies

ADVANTAGES

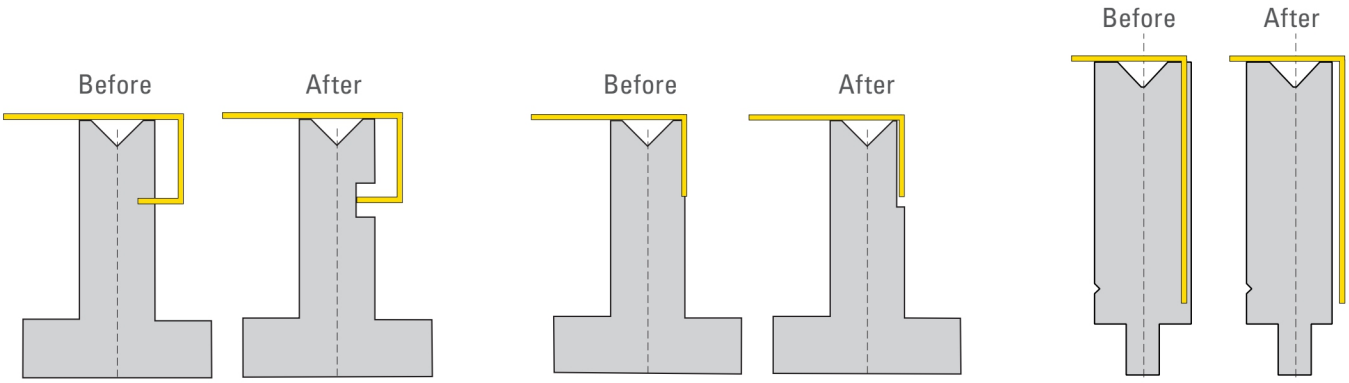
- Cost-saving and fast modification of dies
- According agreement within **1 working day**

UKB-INFO

The maximum load could be reduced by modification!

Reworking of tools 72h

EXAMPLES FOR MODIFICATIONS



Individual horn extensions



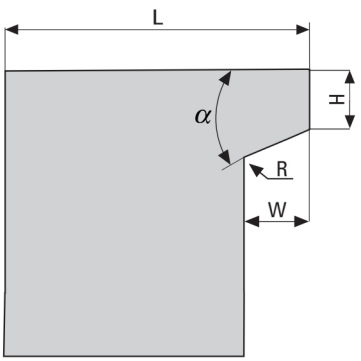
ADVANTAGES

- Cost-saving and fast modification of dies
- According agreement within **1 working day**

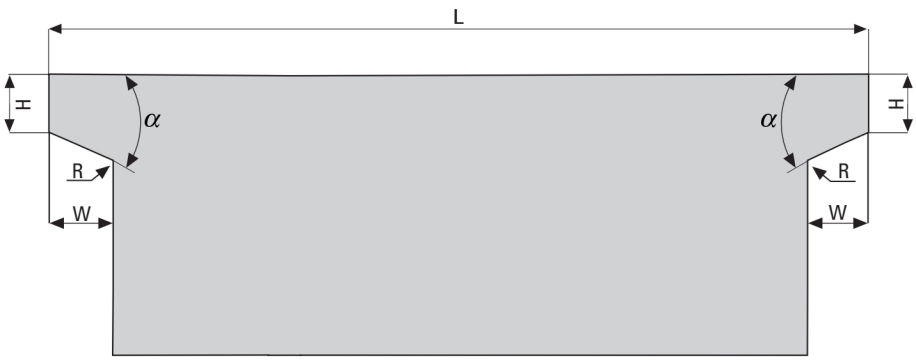
70.200 72h

EXAMPLES FOR MODIFICATIONS

One-sided



Left and Right



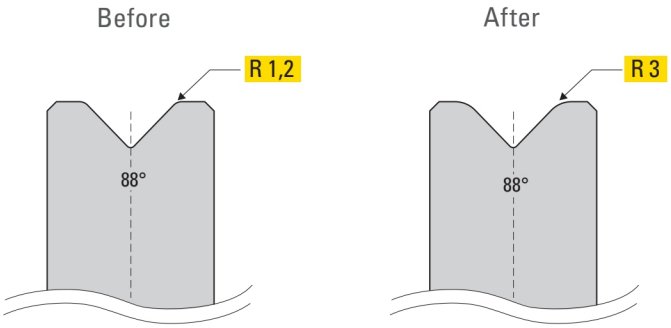
Change of the intake radii

ADVANTAGES

- Cost-saving, fast modification of dies
- Rehardening if necessary
- According agreement within **1 working day**

70.100 72h

EXAMPLE FOR MODIFICATION



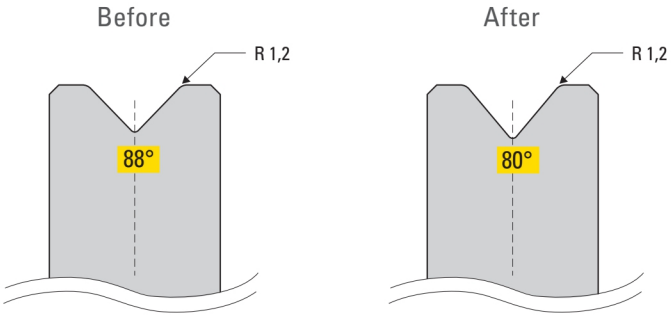
Change of angles

ADVANTAGES

- Cost-saving, fast modification of dies
- Rehardening if necessary
- According agreement within **1 working day**

70.100 72h

EXAMPLE FOR MODIFICATION



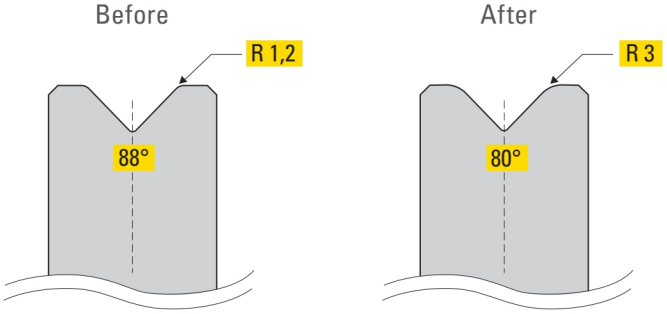
Change of intake radii and angles

ADVANTAGES

- Cost-saving, fast modification of dies
- Rehardening if necessary
- According agreement within **1 working day**

70.100 72h

EXAMPLE FOR MODIFICATION



MODIFICATION

Change of V-openings

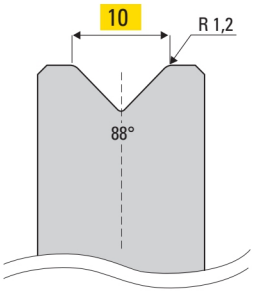
ADVANTAGES

- Cost-saving, fast modification of dies
- Rehardening if necessary
- According agreement within **1 working day**

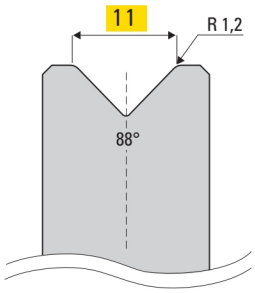
70.100 72h

EXAMPLE FOR MODIFICATION

Before



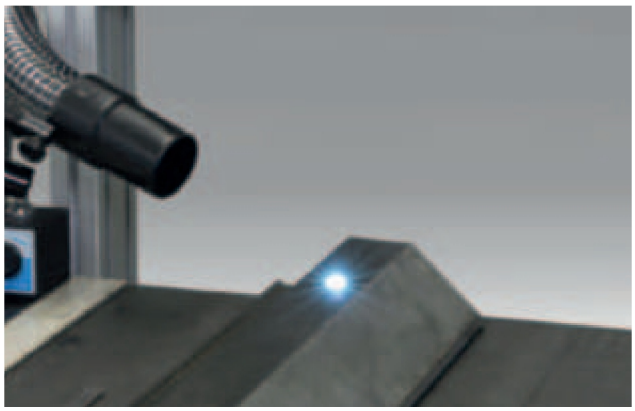
After



Laser marking

ADVANTAGES

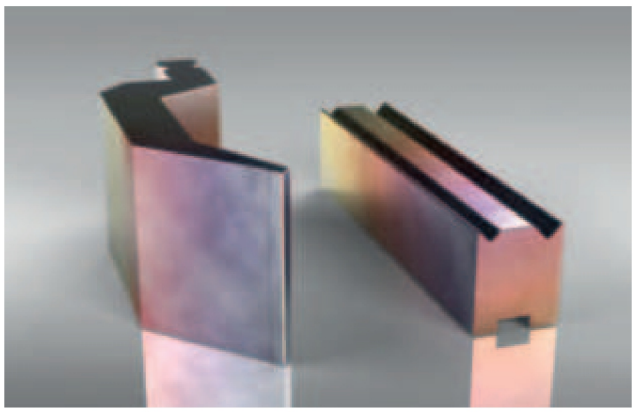
- All important data at a glance
- Permanent, high contrast marking
- Individual marking possible



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
- Corrosion-resistant
- Minimised adhesion of material abrasion of the bended part



Insertion of drill holes in dies UKB-System Trumpf

ADVANTAGES

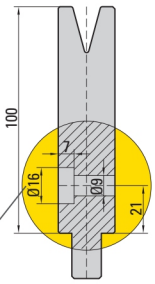
- Cost-saving and fast modification of the 30° dies UKB-System Trumpf (chapter 02) for the use with screwable flattening dies 60.120 and 60.130
- According agreement within **1 working day**

UKB-INFO

Suitable 30° dies H = 100 mm
see pages 88 – 90 and 92 – 93!
Suitable 30° dies H = 150 mm
see pages 96 – 97!

70.800	72h
500 mm	26,– €
300 mm	22,– €
200 mm	18,– €
100 mm	12,– €
550 mm sectionalized	54,– €
2050 mm Tool set	152,– €
3050 mm Tool set	204,– €
4050 mm Tool set	256,– €

SCAN TO SHOP

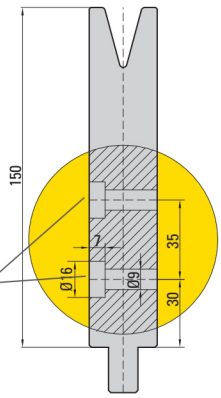


Drill hole in the die for the use of screwable flattening die 60.120



70.810	72h
500 mm	44,– €
300 mm	38,– €
200 mm	28,– €
100 mm	18,– €
550 mm sectionalized	84,– €
2050 mm Tool set	246,– €
3050 mm Tool set	334,– €
4050 mm Tool set	422,– €

SCAN TO SHOP



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

UKB-Regrinding service 312-313
UKB-Repair service 313
UKB-Holiday flat 314
UKB-Field service 315



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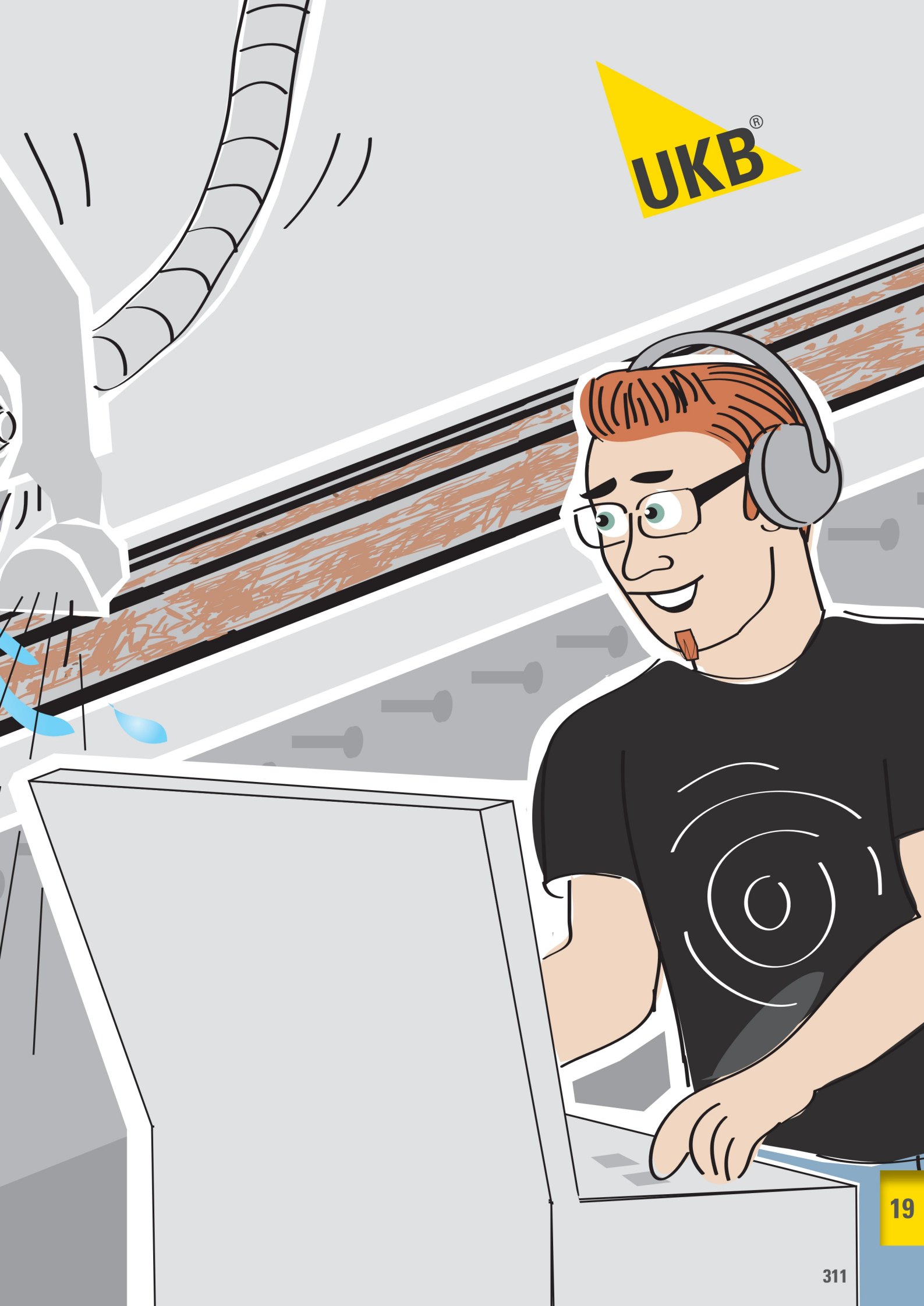

UKB®

UKB-Regrinding service

Old tools – precision-restored!

We professionally, precisely, quickly, and cost-effectively regrind your press brake tools.
Our eight state-of-the-art CNC profile grinding machines ensure exact accuracy in shape, parallelism, and repeatability.
Additional laser hardening increases the lifetime and wear resistance of your press brake tools.

Take advantage of our fast regrinding service for machine tables, side rails, shear blades (see chapter 20), and other workpieces.

Product advantages

- Fast processing of tools from all manufacturers
- According agreement within **1 working day**
- CNC-profile grinding machines traverse path:
  X = 6.000 mm
  Y = 800 mm
  Z = 800 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









UKB-Regrinding service



CNC-profile grinding machine Stöckel FD6080



Laser hardening machine Stiefelmayer Vario



Tool Before



Tool After

UKB-Repair service

Do your press brake tools show chipping or deformation, making regrinding no longer possible?
Is cutting out the damaged section or sectionalizing the tool not an option?
Is a new production too expensive?

Our solution: We weld material onto the damaged area before regrinding!
To achieve the best possible result, please let us know the raw material of your press brake tool.



Weld on of a damaged tool (MAG welding)



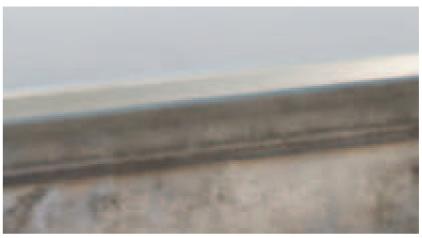
WIG welding



Chipping



Welded on



Regrinded

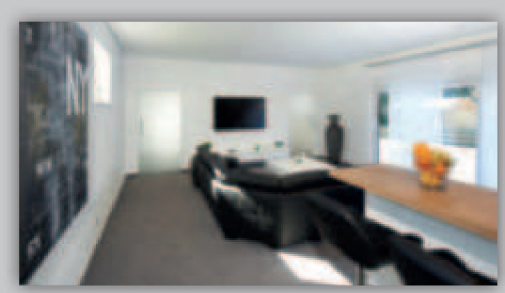
UKB-HOLIDAY FLAT

WE REPAIR YOUR PRESS BRAKE TOOLS – WHILE YOU RELAX!

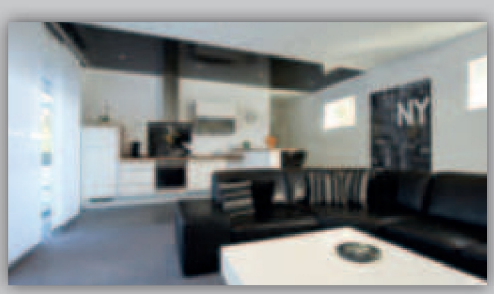
Is the delivery by a forwarding agent too inconvenient for you?
You could only spare your tools for a short time?
Just bring them over in person and use our special service:

Relax with a free stay in our holiday flat – while we realize our service for you!

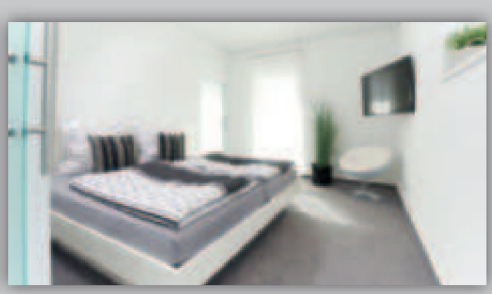
For more information about the UKB-Holiday flat, visit: www.ukb-gmbh.com



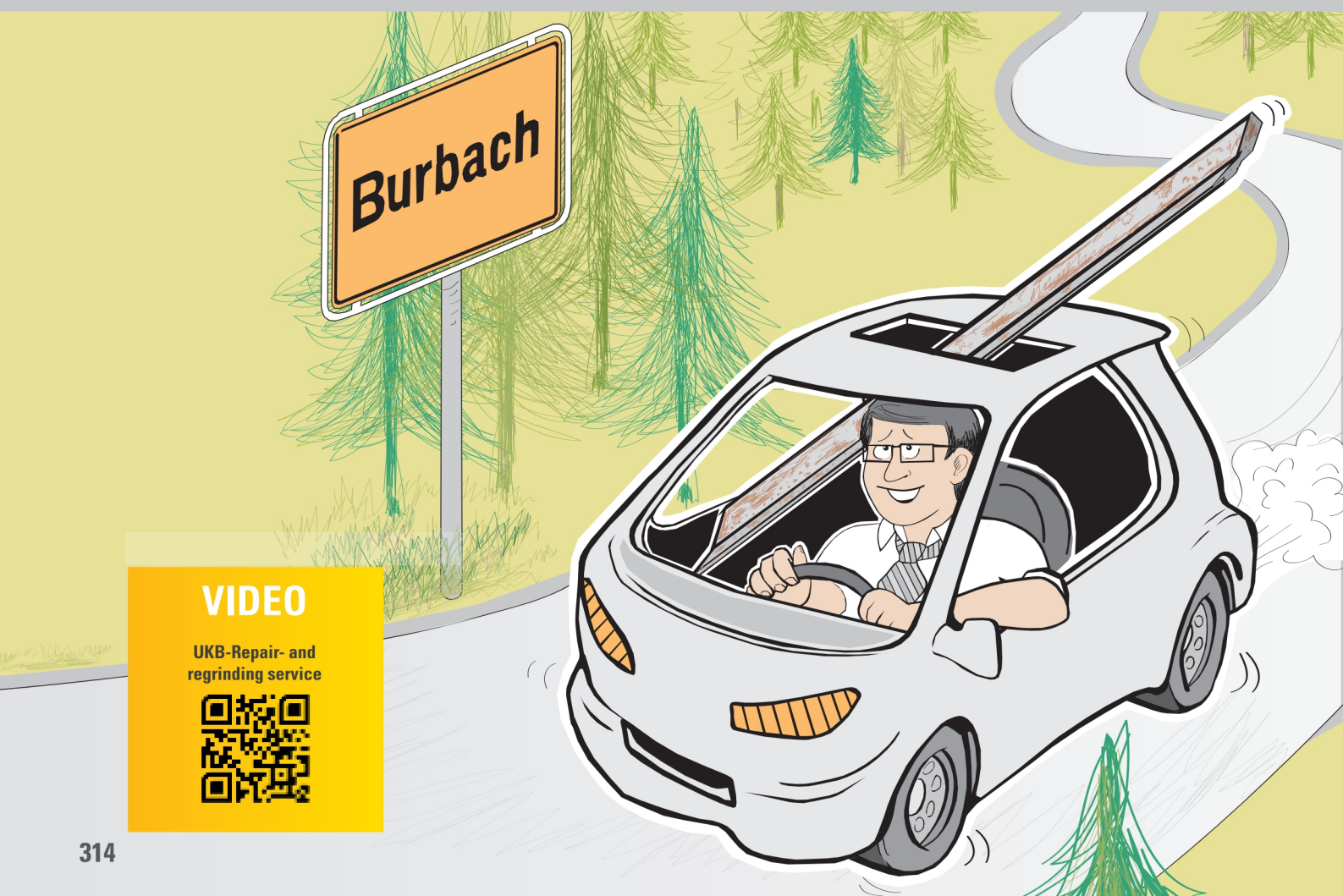
Arrive relaxed – and enjoy your stay!



Generous living room with kitchen for self-catering



Nice and comfortable double bedroom



VIDEO

UKB-Repair- and regrinding service

UKB-FIELD SERVICE

COMMITTED AND CUSTOMER ORIENTED!

Are you interested in our products and would like individual on-site advice?
Our field service staff will be happy to visit you – of course free of charge and without obligation.

OUR TASKS:

- Individual advice and sale
- Technical solutions for special bending tasks
- Test bending in your house or at the UKB-Test Center
- Tool demonstrations
- Pick up service for tools to rework



UKB-INFO

Schedule an appointment:
Your personal contact partner can be found at:
www.ukb-gmbh.com or contact us directly in our live chat!



UKB-SHEAR BLADES

Production of shear blades 318
Regrinding of shear blades 319
Flat grinding 319





WWW.UKB-GMBH.COM

SHEAR BLADES

Production of shear blades

Product advantages

For your shear we produce shear blades according to your specifications. The raw material of the blades is selected especially for the use and the material that have to be cut.

- Up to 4.100 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

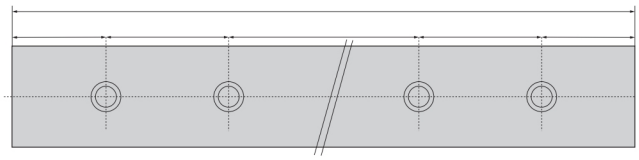
Machine type/ manufacturer	

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

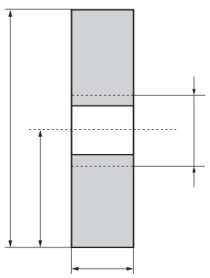
Upper-blade	Piece
Lower-blade	Piece

UKB-INFO

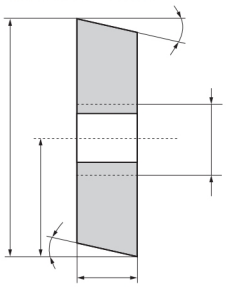
Copy this datasheet or download at
www.ukb-gmbh.com
Simply fill in and send back!

EXAMPLES:

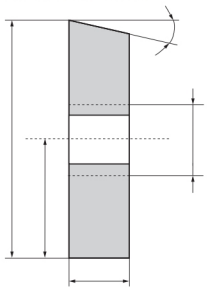
4 - Cutting edges with threaded hole



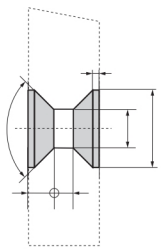
2 - Cutting edges with threaded hole



1 - Cutting edge with threaded hole



Double sided countersink



Regrinding of shear blades

- According agreement within **1 working day**
- Up to 5.000 mm in one-piece
- 4-, 2- or 1 cutting edge

Contact us!

UKB-INFO

You will find your personal contact partner at www.ukb-gmbh.com!

Regrinding of shear blades

Length (mm)	Price per blade
Up to 2.200	120,– €
Up to 2.700	140,– €
Up to 3.200	160,– €
Up to 3.700	180,– €
Up to 4.200	200,– €

Quoted prices are valid for shear blades without breakouts







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)



1996

New company building at
Burbach´s industrial area



2003

Construction of a new
storage facility



2008

Expansion of the
production hall



2022

Move to the new building at the new location



2025

UKB-Teamplayer

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UKB - UWE KRUMM GMBH . Struthwiese 1 . 57299 Burbach . Germany
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