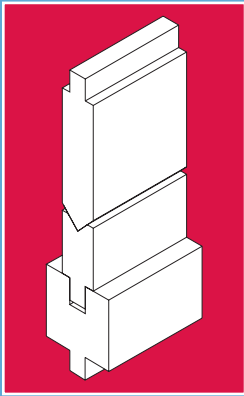


Premium Tooling



1 Tool Set Closed Height

Accurpress Tooling Systems offers special, fully customized tooling to fulfill your fabrication requirements. The following guidelines are designed to assist you in the determination of tooling dimensions.

MODEL NUMBER	STROKE	OPEN HEIGHT	CLOSED HEIGHT (T)
725	6"	12"	6"
760 - 7175	8"	14"	6"
7250	8"	16"	8"
7320	10"	18"	8"
7400 - 7500	10"	20"	10"
7600 - 7750	12"	22"	10"
71000	14"	24"	10"

2 Closed Height Formulas

Use the tool set diagram below to determine suitable appropriate tooling sizes. The "T" value in the table above is the closed height of your press brake.

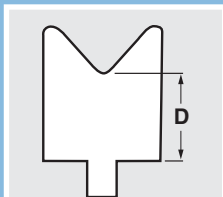
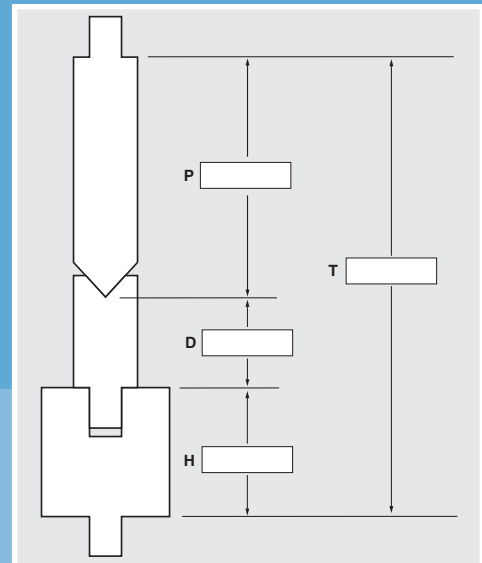
(H) Die Holder Height $H = T - (P + D)$

(P) Punch Height $P = T - (D + H)$

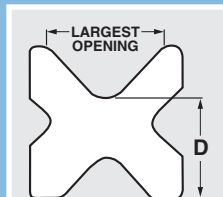
(D) Die Height* $D = T - (P + H)$

*Note: D value on 4-way dies refers to the largest V-opening.

3 Closed Height Diagram

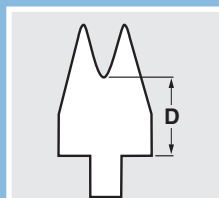


Order #	(D)
L1	1.60"
L2	1.50"
L3	1.45"
L4	1.40"
L5	1.35"
L6	1.30"
L7	1.25"
L8	1.15"
L9	1.60"
L10	1.50"
L11	1.25"
L12	1.00"
L13	1.25"
L14	2.25"
L15	2.80"

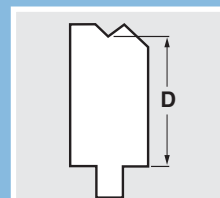


Order #	(D)
4W1	1.50"
4W2	1.75"
4W3	2.00"
4W4	2.25"
4W5	2.50"
4W6	2.75"
4W7	3.25"
4W8	3.25"
4W9	4.25"
4W10	4.75"
4W11	6.00"
4W12	7.00"

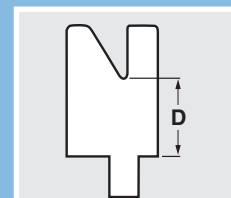
Die Height (D) for Tool Build-up Calculations



Order #	(D)
L30-1	1.45"
L30-2	1.25"
L30-3	1.05"
L30-4	1.35"
L30-5	1.15"
L30-6	1.50"
L30-7	1.45"
L30-8	1.50"
L30-9	1.35"



Order #	(D)
OS1	2.65"
OS2	2.60"
OS3	2.55"
OS4	2.50"
OS5	2.40"
OS6	2.30"
OS7	2.20"
OS8	2.10"
OS9	2.00"



Order #	(D)
HMI	1.30"