



**EXACTA
FABTOOL**
LIMITED



CONVENTIONAL PRESS BRAKE TOOLING

CONVENTIONAL

SPECIALS

EUROPEAN
PRECISION

AMERICAN
PRECISION

URETHANE DIES/
SHEAR BLADES

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EUROPEAN PRECISION PRESS BRAKE TOOLING	See inside back cover	
AMERICAN PRECISION PRESS BRAKE TOOLING	See inside back cover	

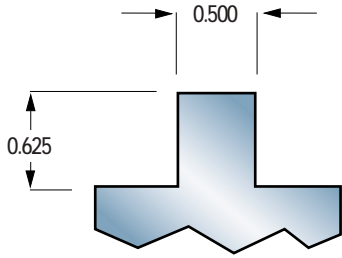
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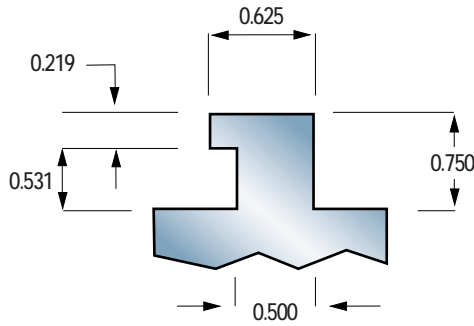
EXACTA Produits de Precision Ltee

5965 CHEMIN, ST. FRANCOIS
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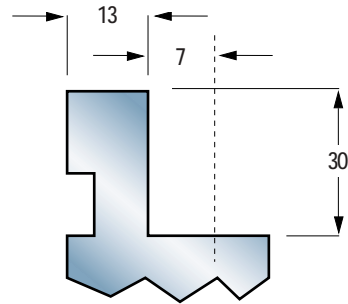
STANDARD TONGUES AVAILABLE



STANDARD TONGUE



HOOKED TONGUE



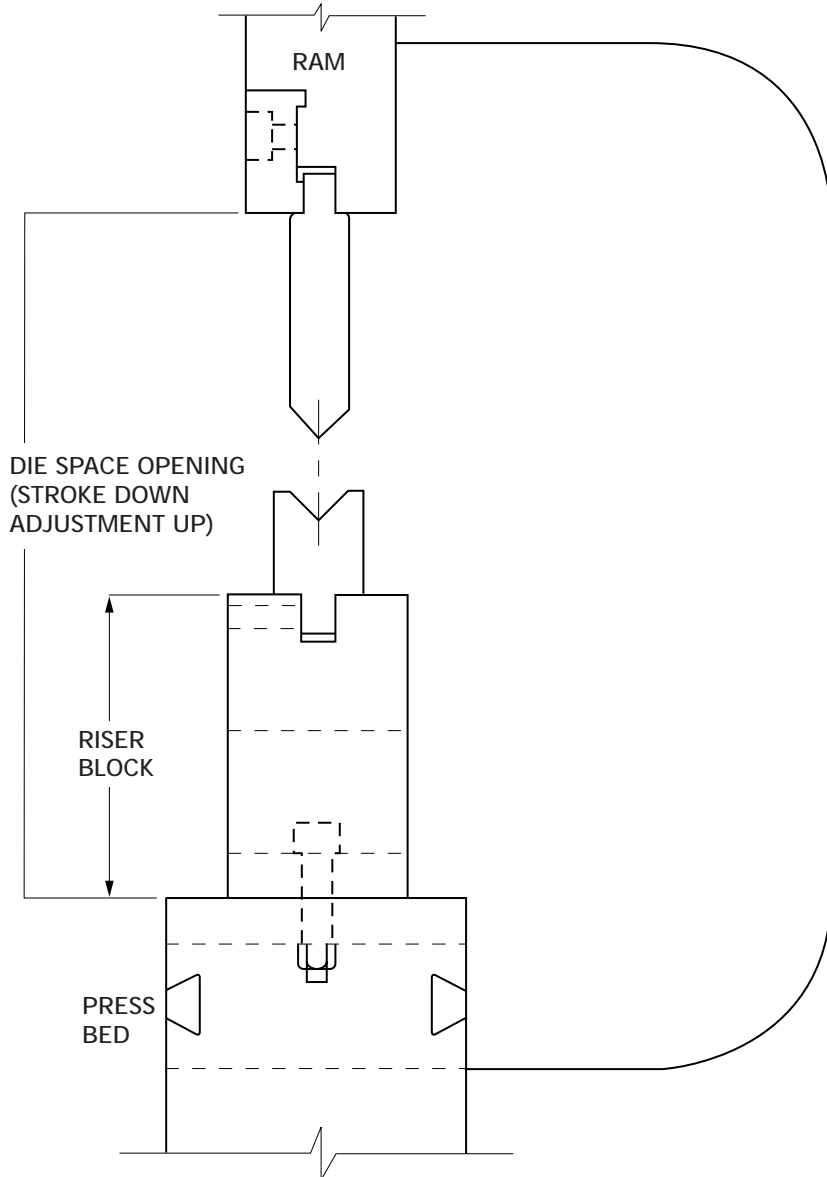
EUROPEAN STYLE

TYPICAL PRESS SETUP

PRACTICE SAFETY

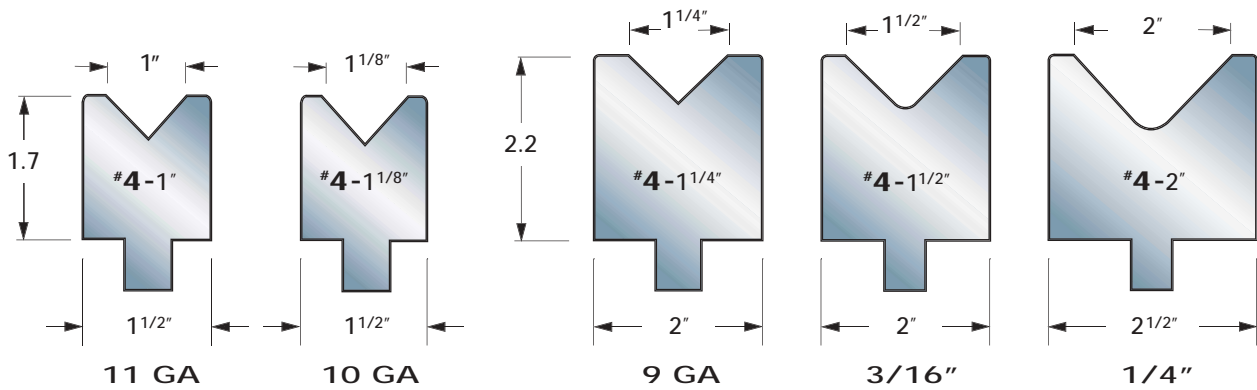
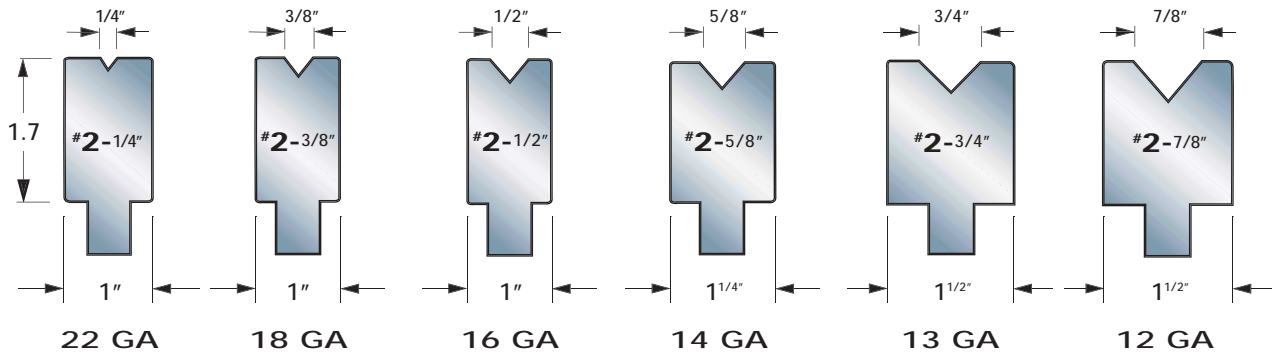
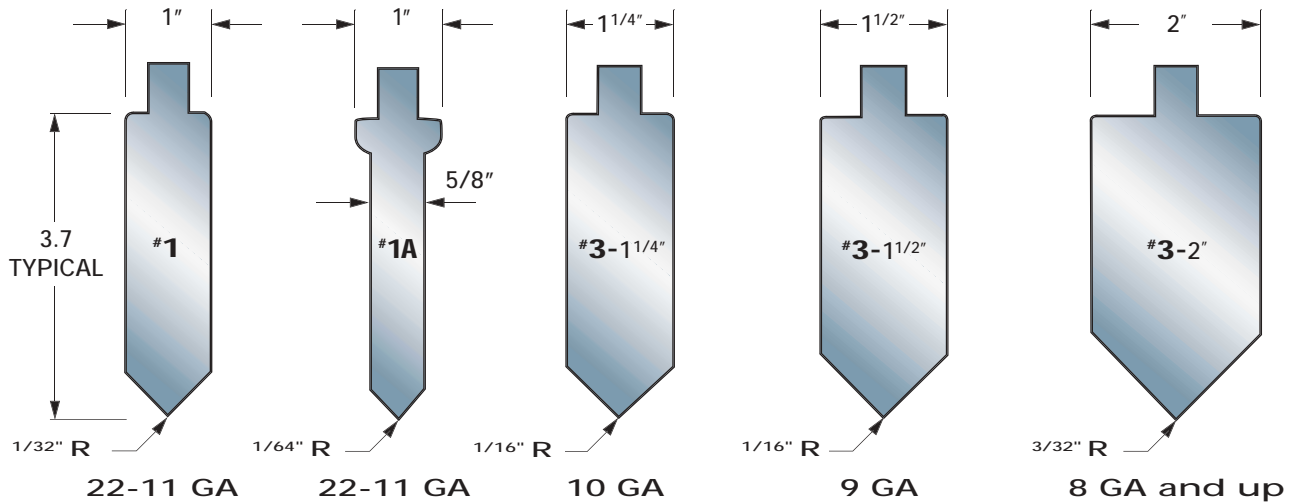
We do all we can to supply Dies that will produce material to your specification. Since we have no control over how the dies are actually put to use, it must be understood that it is the user who has the responsibility of making certain that a proper application with due regard to safety in operation is followed. Safety and industrial standards must be considered to ensure that point of operation protection is effective.

Our Dies are not intended to be used in equipment without means provided for preventing personal injury at any time.

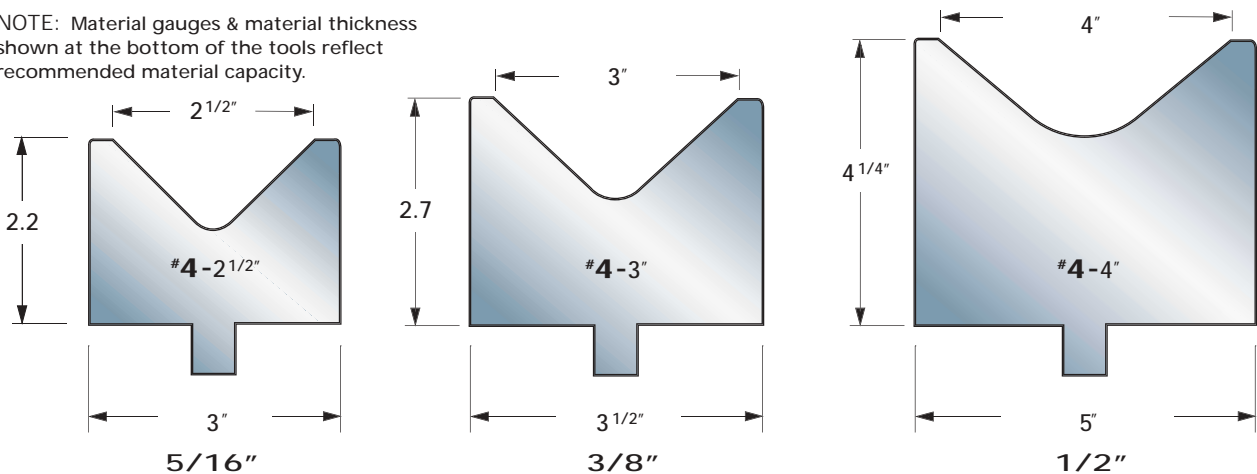


FORMING PUNCHES AND DIES

Up to 1 1/4": Upper Punches 88°/Lower Dies 89°
 over 1 1/4": Upper Punches 85°/Lower Dies 85°
 Other angles and radii are available upon request.

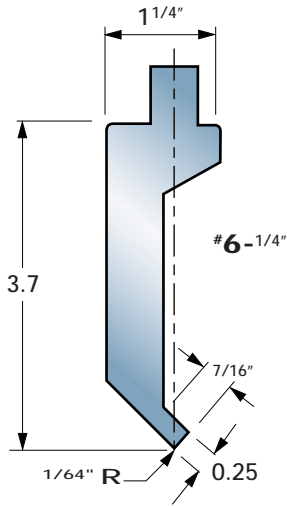


NOTE: Material gauges & material thickness shown at the bottom of the tools reflect recommended material capacity.

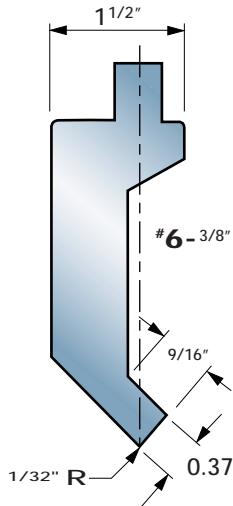


GOOSENECK PUNCHES 88°

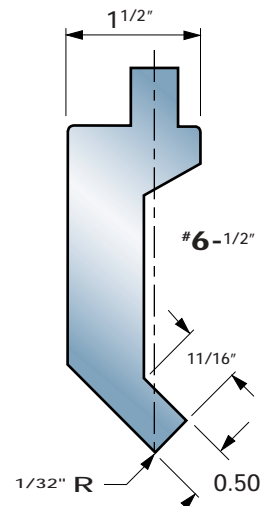
Other angles and radii are available upon request.



22 GA



18 GA



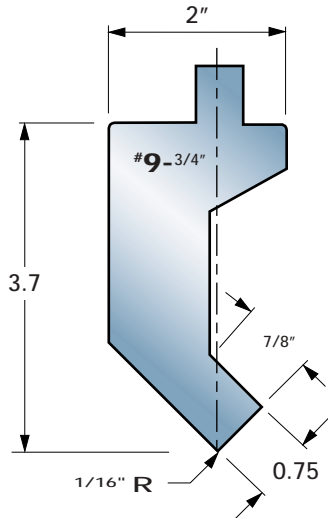
14 GA

PLEASE NOTE:

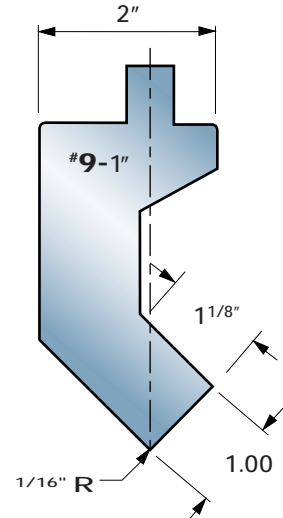
The size of the opening in the lower Die determines the inside radius of the bend. The recommended opening is eight times the material thickness and this will provide an inside radius equal to approximately 15% of the Die opening. This is generally just short of the fracture point of most materials. By increasing the size of the Die opening, the pressure required to make the bend is considerably reduced while the inside radius is proportionately increased.

NOTE: Outside widths shown are Bar Sizes prior to cleanup.

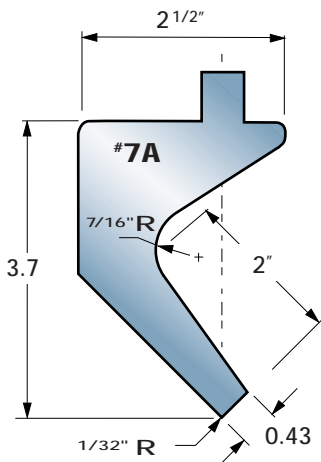
Material gauges & material thickness shown at the bottom of the tools reflect recommended material capacity.



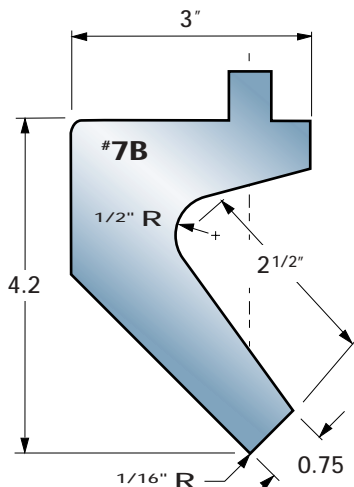
10 GA



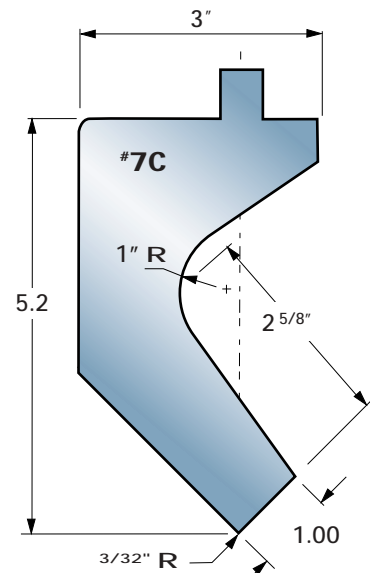
9 GA



16 GA

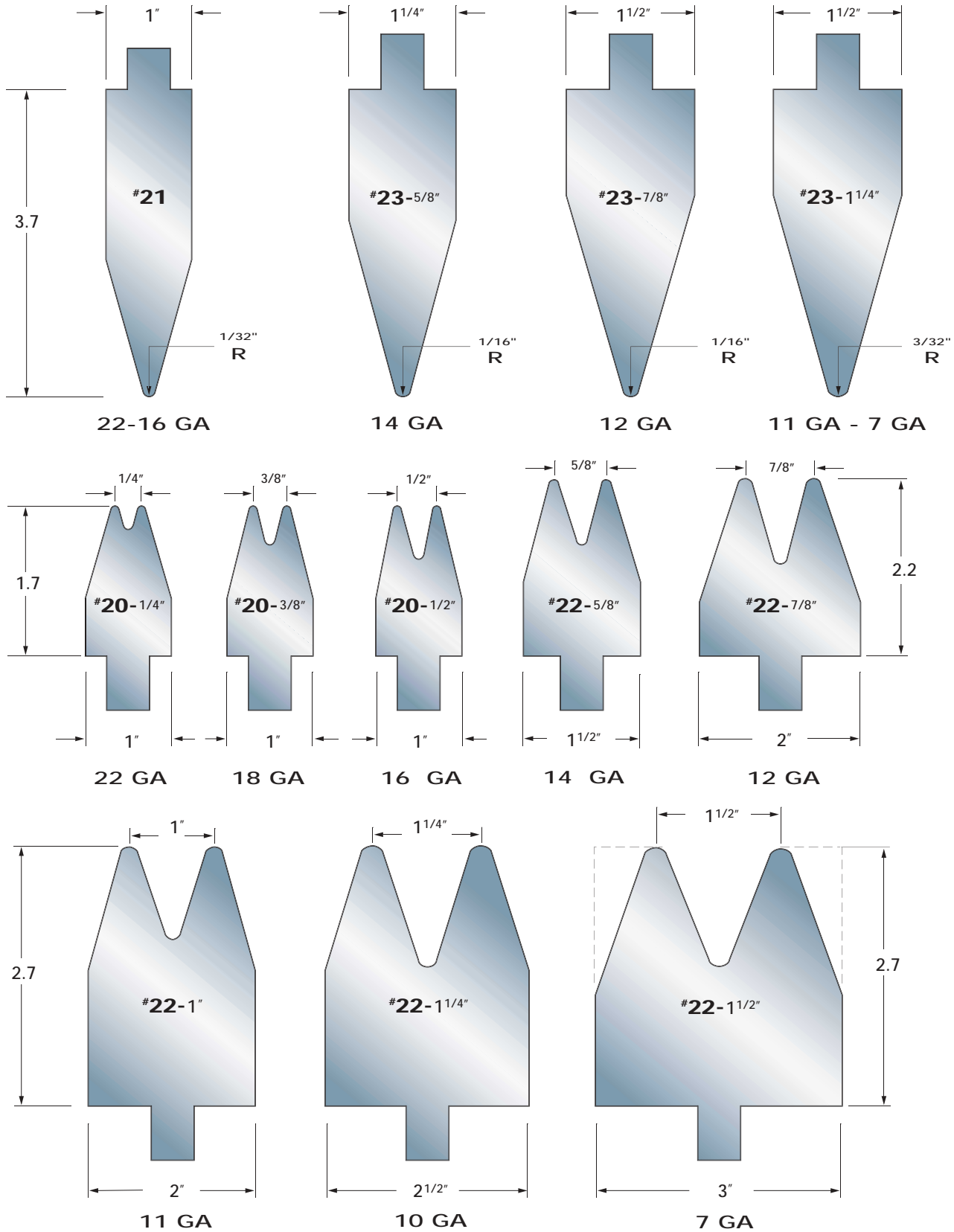


12 GA



10 GA

30° FORMING PUNCHES AND DIES



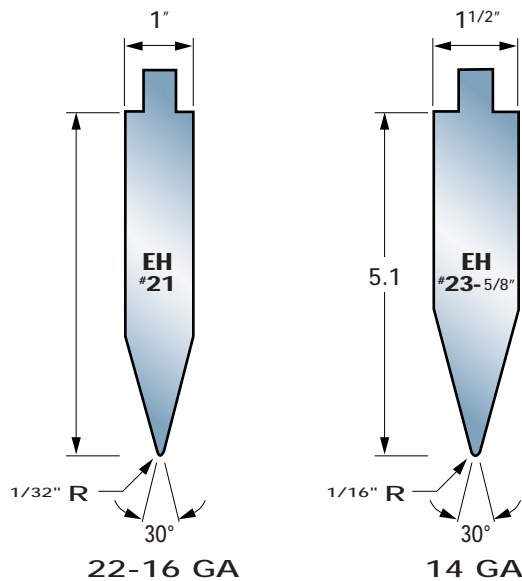
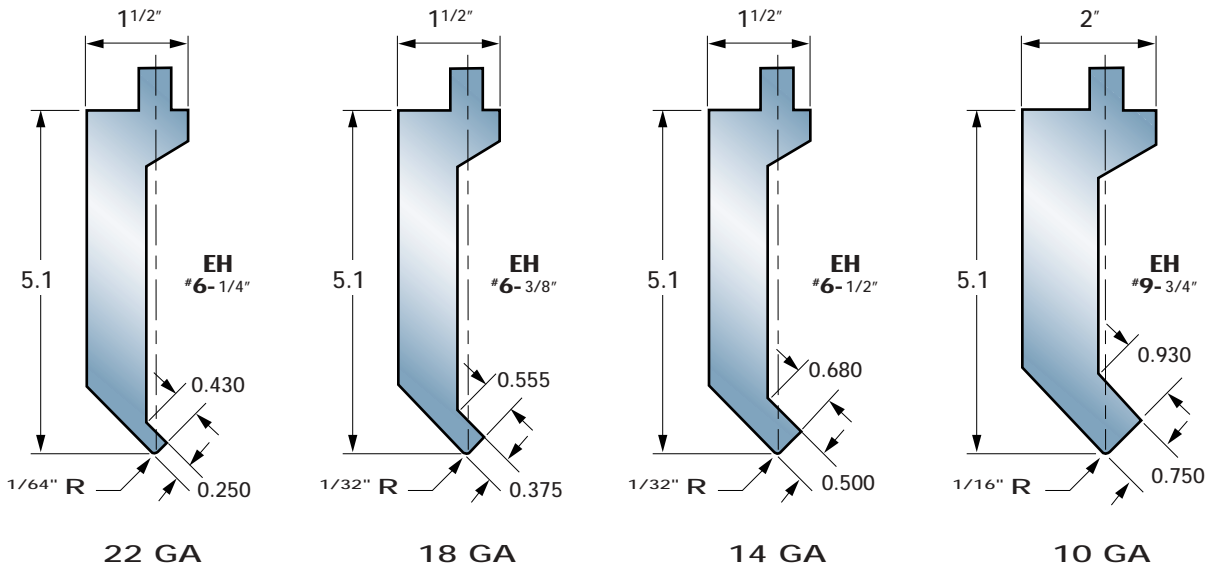
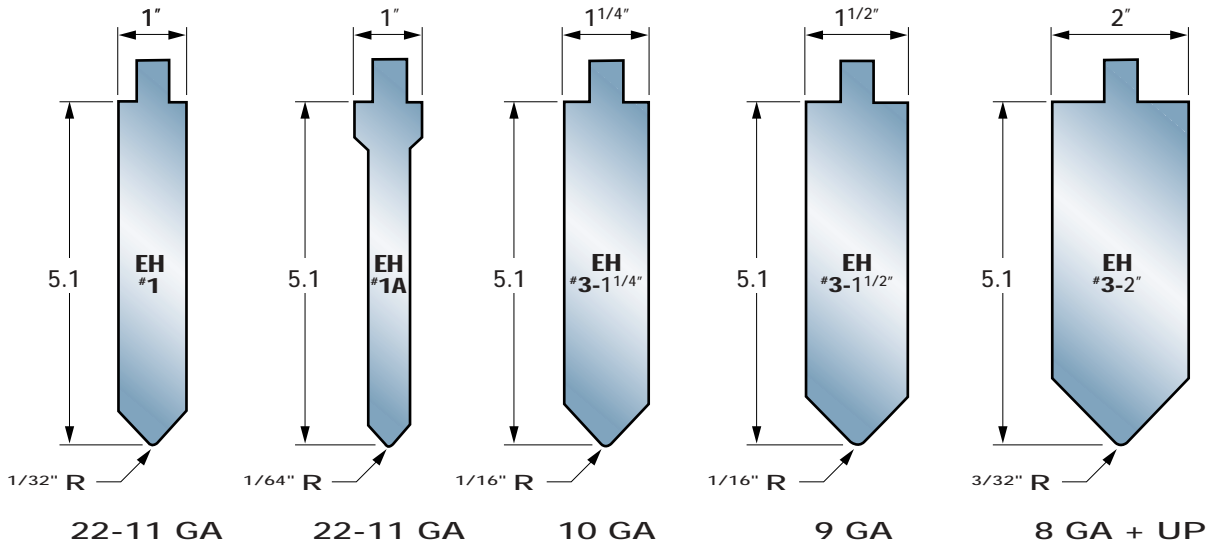
For acute angle forming, from 30° to shallow bends and first operation in hemming. The depth that the Punch enters the Die - regulated by the ram or bed adjustment, determines the degree of angle formed.

30° bottom dies can be ordered either sloping sides or flat top. Sloping sides are standard.

NOTE: Outside widths shown are Bar Sizes prior to cleanup.
Material gauges & material thickness shown at the bottom of the tools reflect recommended material capacity.

EXTRA HIGH PUNCHES - 88° / 30°

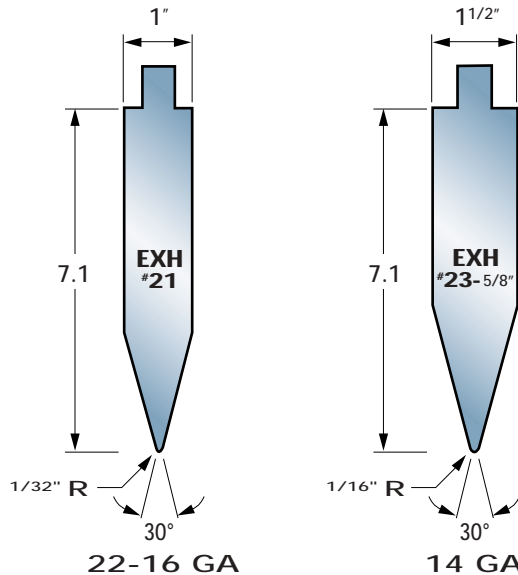
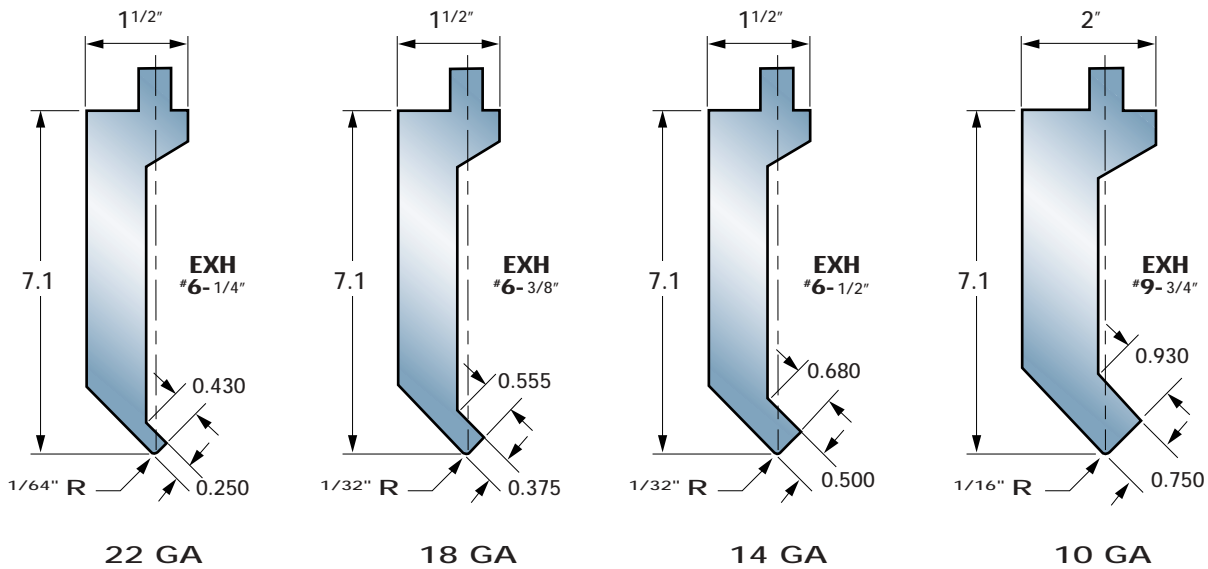
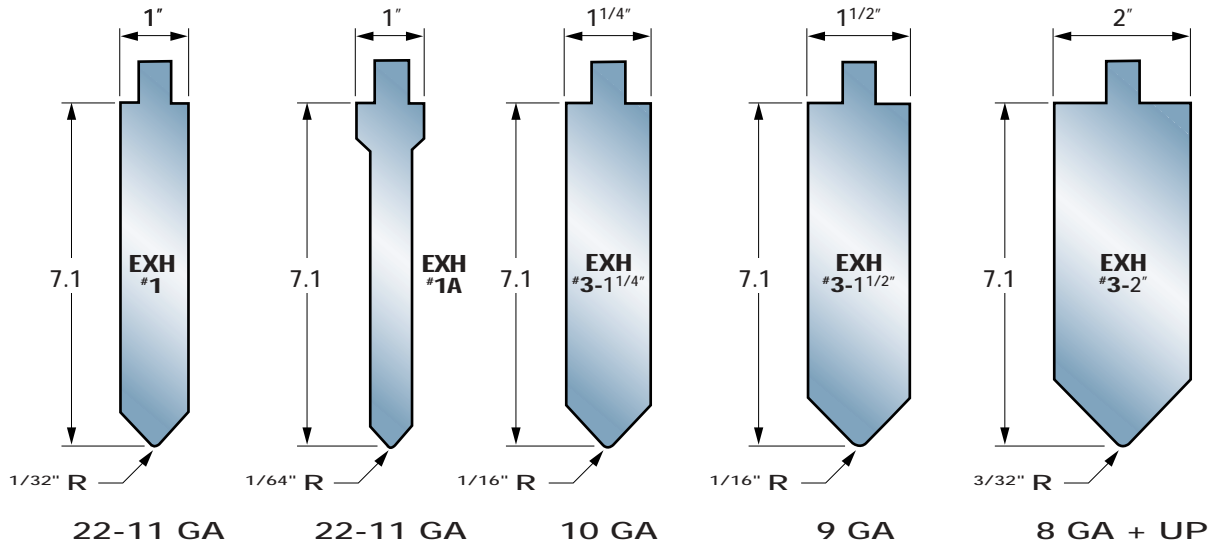
Shoulder to tip dimension = approx. 5.125"



NOTE: Outside widths shown are Bar Sizes prior to cleanup.
Material gauges & material thickness shown at the bottom of the tools reflect recommended material capacity.

EXTRA HIGH PUNCHES - 88° / 30°

Shoulder to tip dimension = approx. 7.125"

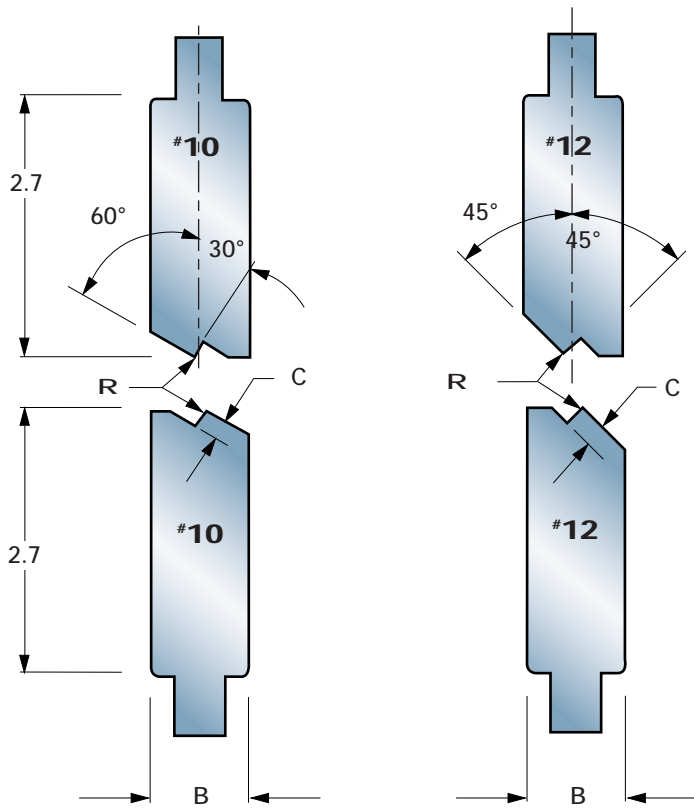


NOTE: Outside widths shown are Bar Sizes prior to cleanup.

Material gauges & material thickness shown at the bottom of the tools reflect recommended material capacity.

OFFSET DIES

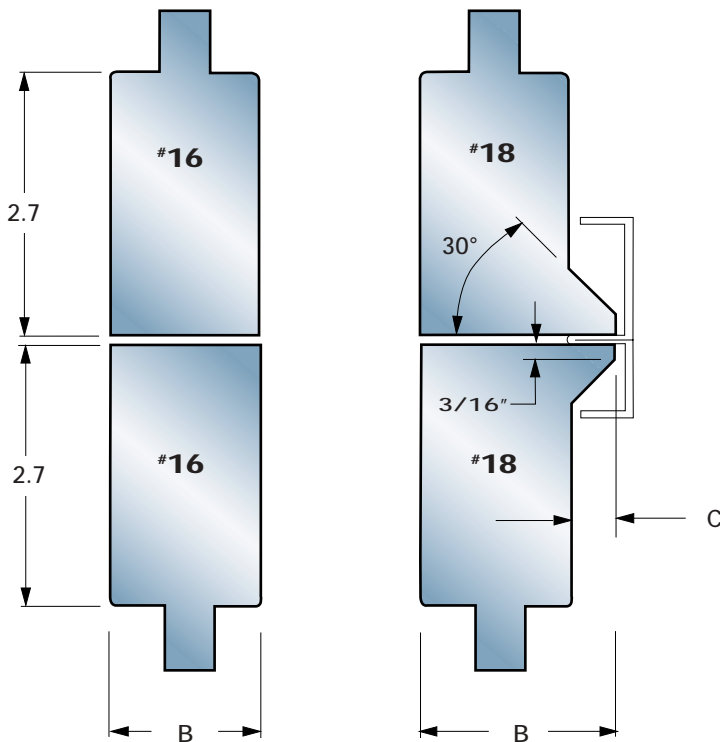
For producing two 90° bends simultaneously.



SET #	B	C	R
#10 3/16"	1"	3/16"	1/64"
#12 1/4"	1"	1/4"	1/64"
#12 5/16"	1"	5/16"	1/64"
#12 3/8"	1 1/4"	3/8"	1/32"
#12 1/2"	1 1/4"	1/2"	1/32"
#12 5/8"	1 1/2"	5/8"	1/32"
#12 3/4"	2"	3/4"	1/32"
#12 7/8"	2"	7/8"	1/32"
#12 1"	2"	1"	1/32"

A set consists of Top & Bottom.

FLATTENING DIES

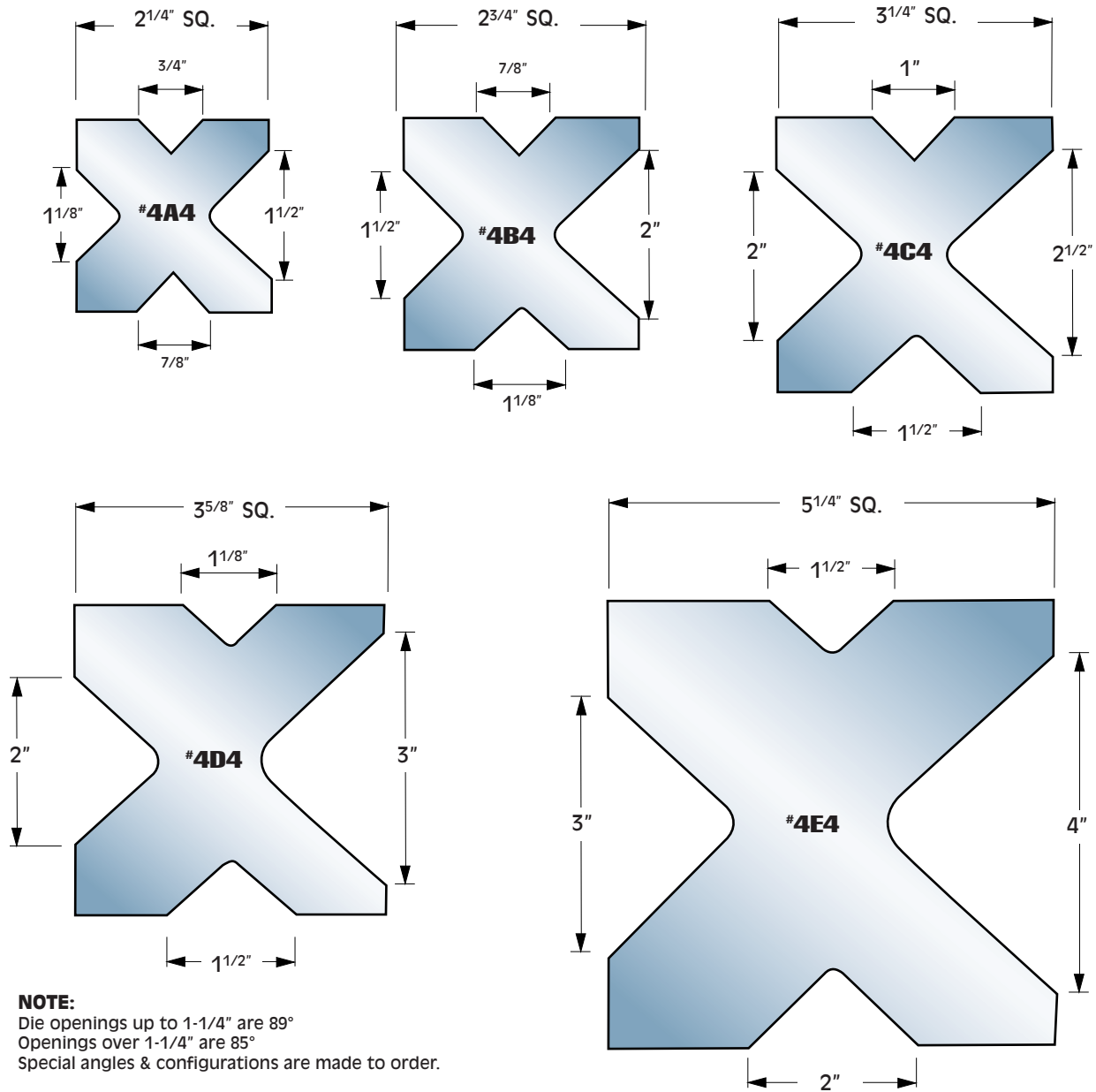


SET #	B	C
#16 1 1/2"	1 1/2"	
#16 2"	2"	
#16 2 1/2"	2 1/2"	
#18 2"	1 7/8"	1/2"
#18 2 1/2"	2 3/8"	3/4"

A set consists of Top & Bottom.

NOTE: Outside widths shown are Bar Sizes prior to cleanup.

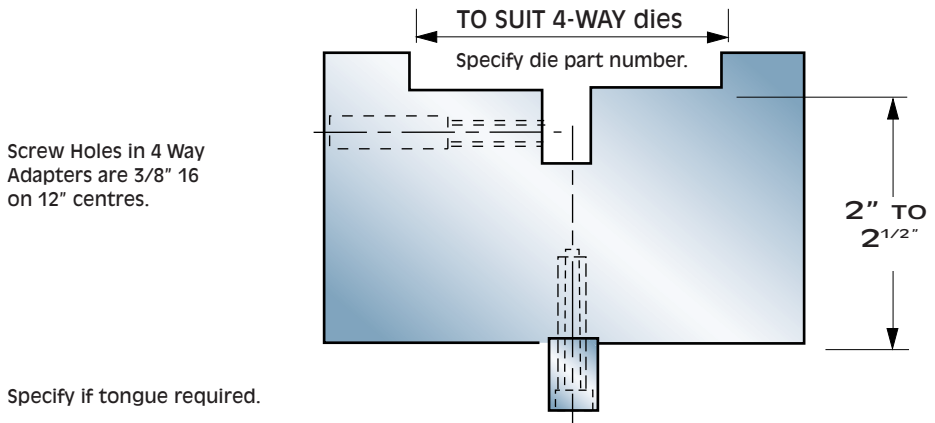
4-WAY DIES



NOTE:
 Die openings up to 1-1/4" are 89°
 Openings over 1-1/4" are 85°
 Special angles & configurations are made to order.

For quick die changes where multiple bends are required.
 All are supplied with tapped holes on each end for lifting.

4-WAY DIE ADAPTERS



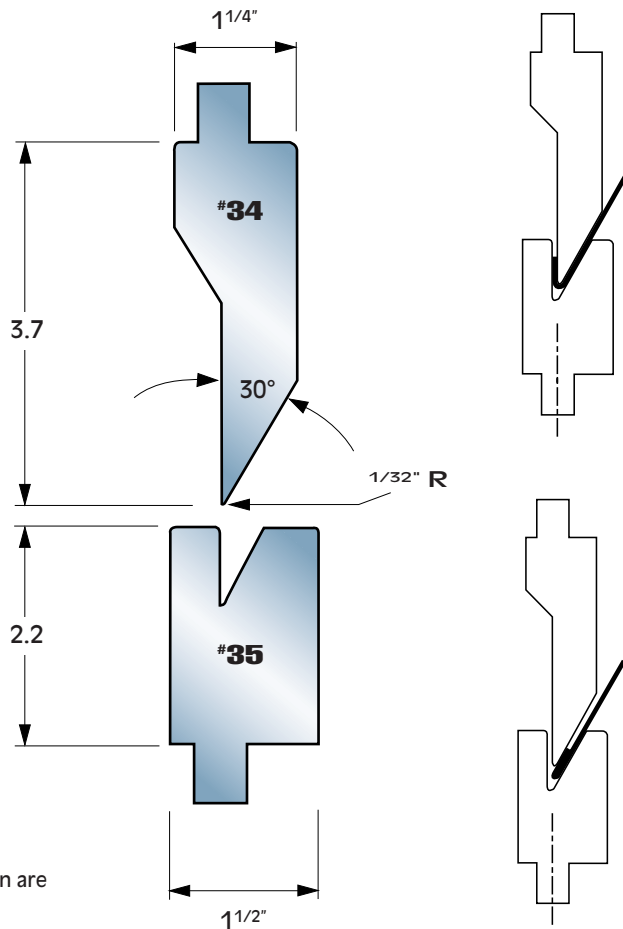
HEMMING DIES

For bending and crimping the edge of a sheet
18 GA. or lighter.

For hemming material
heavier than 18 gauge
refer to Page 12 # 3TD.

Two strokes produce
a Flattened Hem.

NOTE: Outside widths shown are
Bar Sizes prior to cleanup.



RADIUS PUNCHES

Normally used with standard Lower Dies.
Radius (R) to be specified.

