



500x5x150x26/1

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Digima die for an AMADA press brake, TYPE 500x150x26, 5 segments, L=2500mm, 80T pressure

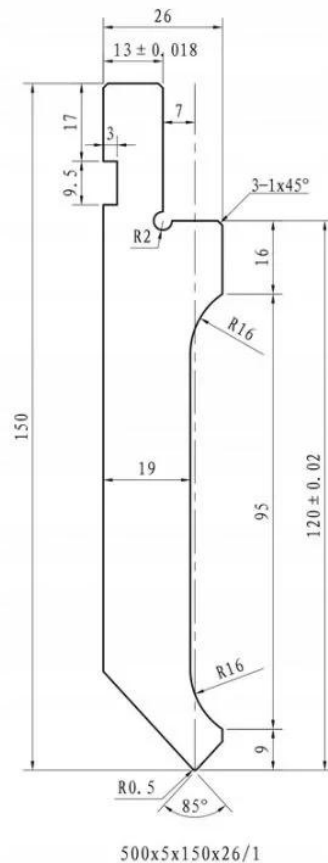
We present a professional top die from Digima, designed for the most demanding bending operations on press brakes operating with the Amada clamping system. This tool is designed for machines with a pressing force of up to 80 tonnes, making it the ideal choice for production facilities prioritising maximum productivity and precision. The die is made from high-grade T8A tool steel, which is characterised by excellent impact resistance and dimensional stability even during intensive, multi-shift operation.

The tool comprises five precision-machined segments, each 500 mm long, providing a total bending line of 2,500 mm. A key factor in extending the punch's service life is the high-frequency induction hardening process applied to the working edge, which achieves a hardness of $HRC\ 45 \pm 2$ degrees. This guarantees exceptional resistance of the cutting edge to blunting and deformation, which directly translates into

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repeatable bending angles and a high-quality finish on workpieces without marks on the material. The precisely ground 85-degree nose enables high-precision bends to be achieved, whilst maintaining full control over the sheet metal forming process

Compatible with the **PBH-80x2500 press and others of these dimensions**



Full technical specifications and design parameters

Below is a complete list of the technical specifications for the punch and die, compiled on the basis of the design drawing:

Geometric and working dimensions:

- **Total height of the tool:** 150 millimetres.
- **Functional height (from the base plane to the bending axis):** 120 plus or minus 0.02 millimetres.
- **Total width of the punch:** 26 millimetres.
- **Body width in the working section:** 19 millimetres.
- **Punch cutting edge angle:** 85 degrees.
- **Radius of the working nose:** R 0.5 millimetres.

Mounting and profile parameters:

- **Standard upper mounting dimension:** 13 plus or minus 0.018 millimetres.
- **Dimensions of the retaining slot:** height 9.5 millimetres with a cut-out depth of 3 millimetres.
- **Socket positioning:** distance of 17 millimetres from the upper edge of the punch and an axial offset of 7 millimetres.
- **Design radii:** an arc at the socket with a radius of R 2 and body profile arcs with a radius of R 16.
- **Edge chamfering:** type 1 chamfer at 45 degrees, applied at three points on the profile.
- **Profile section heights:** an upper straight section 16 millimetres high, a side section 95 millimetres long and a lower flange 9 millimetres high.



Manufacturing standards and tolerances:

- **Heat treatment:** high-frequency hardening of the cutting edge to a hardness of HRC 45 ± 2 degrees.
- **Fitting accuracy:** the error at segment joints when operating as a set (group interchangeability) is less than or equal to 0.05 millimetres.
- **Geometric tolerances:** the tool's parallelism and perpendicularity errors are maintained within limits of 0.05 millimetres or less.
- **End-face finish:** all edges at section joints, except for the cutting edge, are rounded to a radius of R 0.5 millimetres.
- **Set configuration:** total length 2500 mm, comprising 5 segments of 500 millimetres each.

*The photographs are for illustrative purposes only; the main image shows the cross-sectional shape of the tool as depicted in the technical drawing (without indicating the length), whilst the side view provides an example of what such a segment would look like in reality