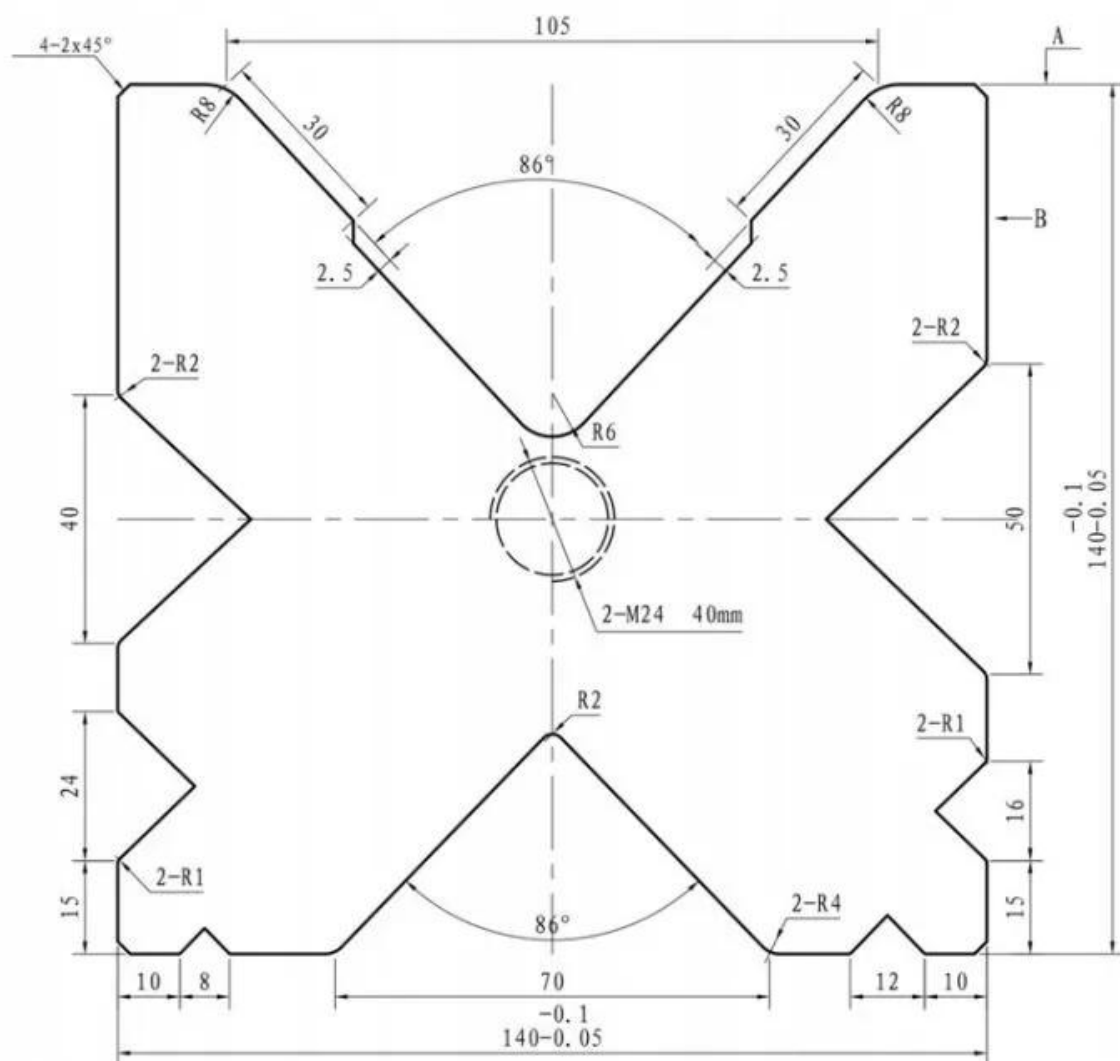
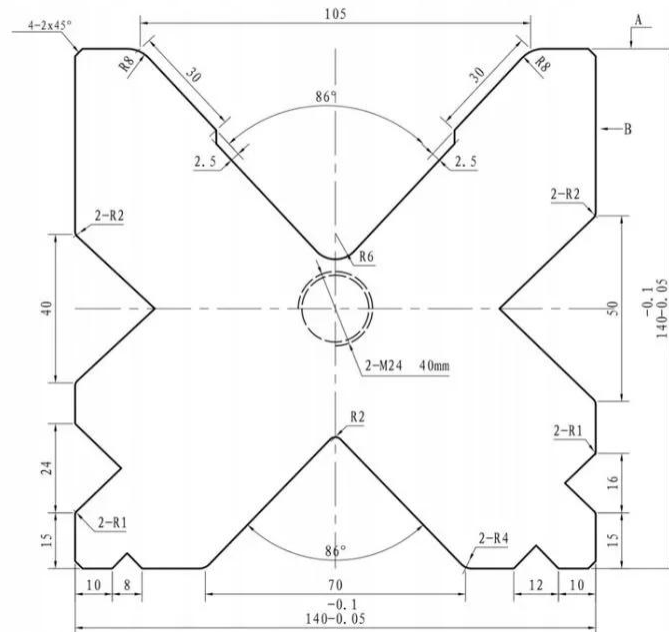


Digima prism die for the AMADA press brake, 140x140x4000 mm, 250T, M24





KARTA PRODUKTOWA



Digima multi-groove prism die for an AMADA press brake, TYPE 140x140x4000 mm, 250T, M24

We are pleased to present a professional Digima bottom die with a four-sided design, engineered for heavy-duty use on press brakes utilising the Amada clamping system. This tool has been optimised for use with machines with a pressing force of up to 250 tonnes, enabling the precise bending of thick sheet metal whilst maintaining full process stability. Manufactured from high-grade T8A tool steel, it guarantees extreme resistance to compression and a long service life for the cutting edges, even during intensive industrial use.

The die features a universal multi-groove design with a cross-section of 140 by 140 millimetres, offering the operator access to a wide range of bending channels without the need to dismantle or replace the tool. The use of such a solid profile ensures excellent die rigidity, which directly translates into high angular repeatability and the elimination of tool deformation under high pressure. Each working channel has undergone precision grinding, which protects the surface of the material being bent and ensures a clean bend line along the entire length of 4,000 millimetres.

Suitable for the **PBH-250-4000 press and others of these dimensions**



Technical parameters and design specifications

Below is a detailed summary of the technical specifications for the multi-row die, compiled directly from the design documentation:

Overall dimensions and tolerances of the body:

- **Total length of the tool:** 4,000 millimetres, divided into three sections.
- **Cross-sectional profile:** a square with a side length of 140 millimetres.
- **Tolerance on the external dimension:** 140 millimetres with a deviation ranging from minus 0.1 millimetres to minus 0.05 millimetres.
- **Geometric precision:** the error in parallelism and straightness of the die along its entire length does not exceed 0.05 millimetres.

Geometry of the bending channels and V-grooves:

- **Main upper channel:** a very wide opening measuring 105 millimetres, with internal sections 30 millimetres wide and fillet radii of R8.
- **Main lower channel:** an opening 70 millimetres wide.
- **Set of left-hand side channels:** grooves 40 millimetres, 24 millimetres and 15 millimetres wide.
- **Set of right-hand side channels:** grooves 50 millimetres, 16 millimetres and 15 millimetres wide.
- **Bend angles:** all standard V-channels have a bend angle of 86 degrees.
- **Working edge radii:** edges finished with specialist radii such as R8, R6, R4, R2 and R1 to protect the material from damage and ensure smooth bending.



Installation details and finish specifications

- **Stabilisation system:** the die has two mounting holes for M24 bolts, 40 millimetres deep.
- **Final machining of the body:** sharp edges at both ends of the die have been safely rounded off with a wide 5 by 45-degree chamfer.
- **Finish of external edges:** a 45-degree type 1 longitudinal external chamfer on the body, machined at four points along the profile.
- **Additional technical parameters:** relief channels measuring 2 by 2 millimetres have been machined in the bottoms of the working channels. All channel radii not marked on the drawing are R 0.5 millimetres.

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