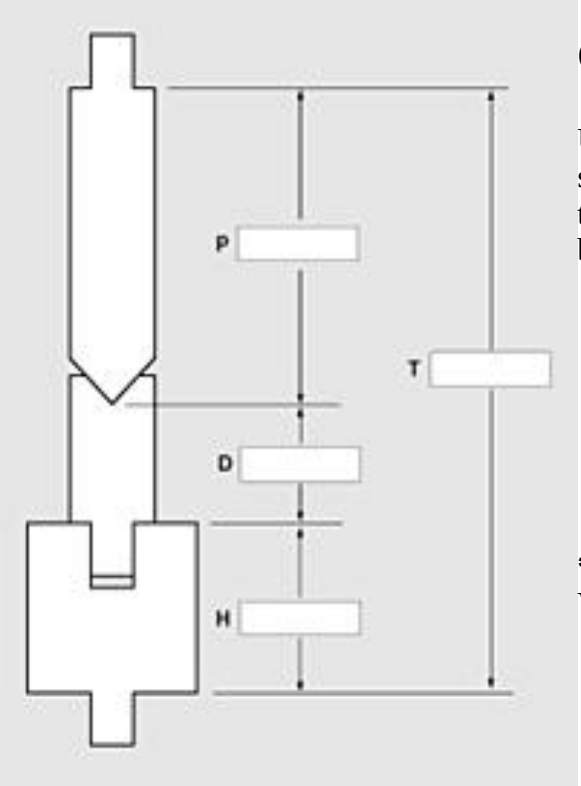
Tool Set Build-Up Guide – Press Brake Tooling

Tool Set Closed Height

The following guidelines are designed to assist you in the determination of tooling dimensions.

For Accurpress press brake models, for others review your machine manual

Model Number	Stroke	Open Height	Closed Height (T)
725	6"	12"	6"
760 - 7175	8"	14"	6"
7250 - 7320	8"	16"	8"
7400 - 7500	10"	20"	10"
7600 - 7750	12"	22"	10"
71000	14"	24"	10"



Closed Height Formulas

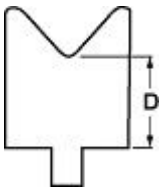
Use the tool set diagram below to determine suitable appropriate tooling sizes. The "T" value in the table above is the closed height of your press brake.

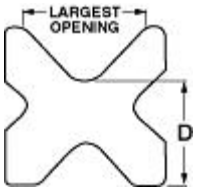
(H) Die Holder Height H = T - (P + D)
(P) Punch Height P = T - (D + H)
(D) Die Height* D = T - (P + H)

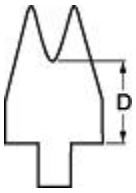
***Note:** D value on 4-way dies refers to the largest V-opening.

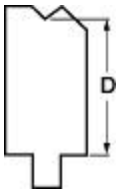
7 Millrace Court ✤ PO BOX 2207 ✤ Williamsville, NY 14231 ✤ PHONE: 716-352-3911 ✤ FAX: 716-204-8538 ✤
E-MAIL: sales@jrmachinery.com ✤ WEBSITE: www.jrmachinery.com

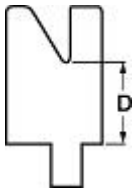
Die Height (D) for Tool Build-up Calculations











Order#	(D)	Order#	(D)	Order#	(D)	Order#	(D)	Order#	(D)
L1	1.60²	4W1	1.50²	L30-1	1.45²	OS1	2.65²	HM1	1.30²
L2	1.50²	4W2	1.75²	L30-2	1.25²	OS2	2.60²		
L3	1.45²	4W3	2.00²	L30-3	1.05²	OS3	2.55²		
L4	1.40²	4W4	2.25²	L30-4	1.35²	OS4	2.50²		
L5	1.35²	4W5	2.50²	L30-5	1.15²	OS5	2.40²		
L6	1.30²	4W6	2.75²	L30-6	1.50²	OS6	2.30²		
L7	1.25²	4W7	3.25²	L30-7	1.45²	OS7	2.20²		
L8	1.15²	4W8	3.25²	L30-8	1.50²	OS8	2.10²		
L9	1.60²	4W9	4.25²	L30-9	1.35²	OS9	2.00²		
L10	1.50²	4W10	4.75²						
L11	1.25²	4W11	6.00²						
L12	1.00²	4W12	7.00²						
L13	1.25²								
L14	2.25²								
L15	2.80²								

Accurpress tooling catalog: http://www.accurpress.com/tooling_cat.html

JR Machinery Associates: www.jrmachinery.com