

Tool Set Build-Up Guide – Press Brake Tooling

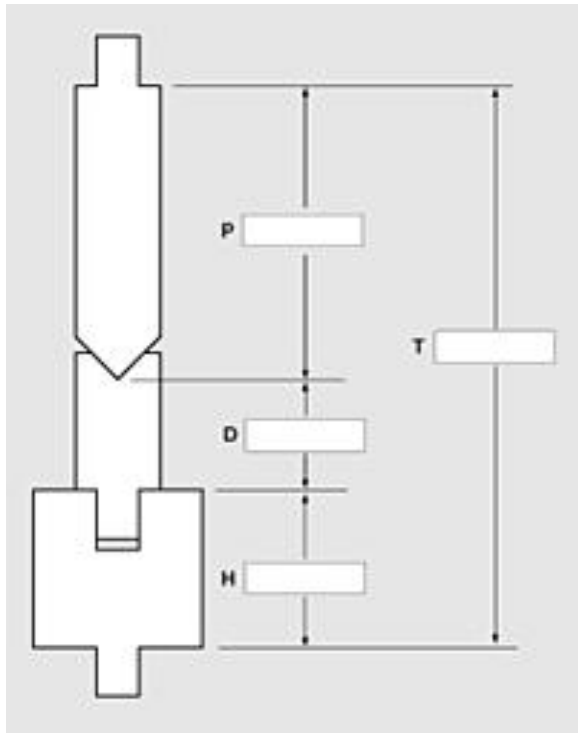


Tool Set Closed Height

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.

$$(H) \text{ Die Holder Height } H = T - (P + D)$$

$$(P) \text{ Punch Height } P = T - (D + H)$$

$$(D) \text{ Die Height* } D = T - (P + H)$$

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

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