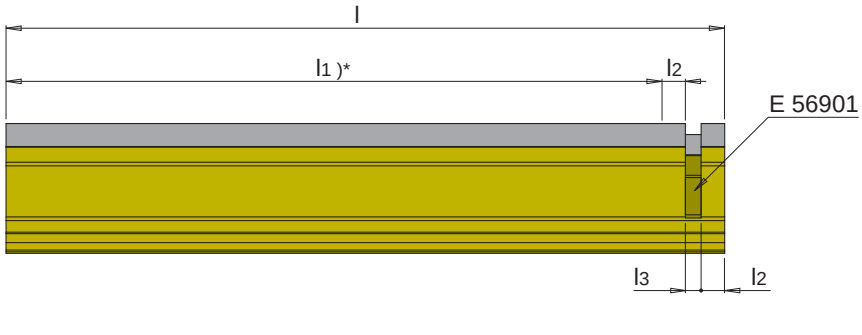
E 5690

Rollbieger

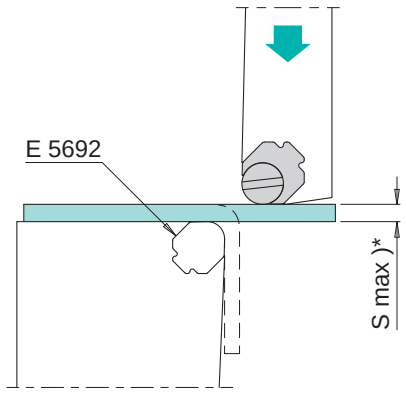
Bending unit

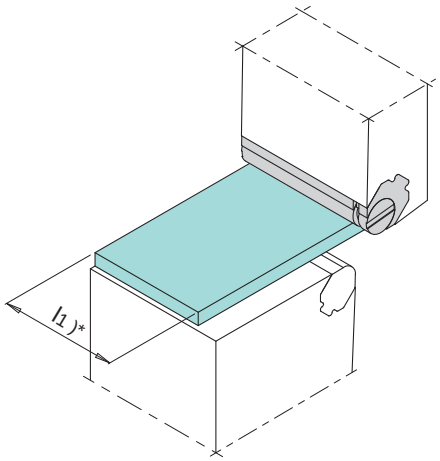
TRIBMATE®
EASY ROLLA™

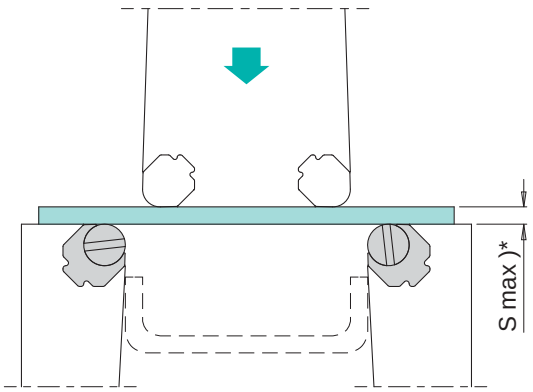


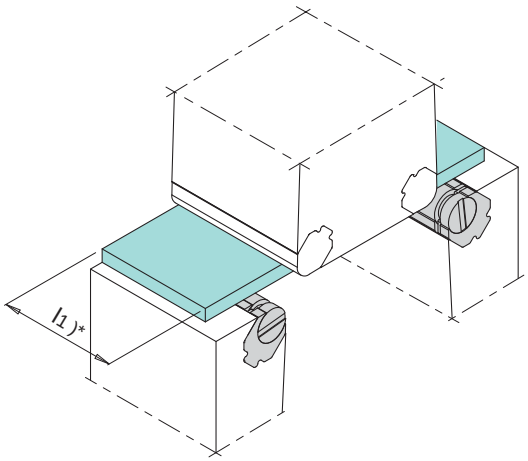
Mat.: 1.3505 ≈ 60 HRC / CuSn11P t max. = 250°C

b	h	l	l2	l3	S max)*	d	l1	Nr. /No.
4.2	4.95	27.4	0.9	0.6	1	**3**	**25**	E 5690/ 3 x 25
5.6	6.6	28.2	1.2	0.8	1.5	**4**	**25**	E 5690/ 4 x 25
7	8.25	29	1.5	1	2	**5**	**25**	E 5690/ 5 x 25
		54				**5**	**50**	E 5690/ 5 x 50
8.4	9.9	29.8	1.8	1.2	2.5	**6**	**25**	E 5690/ 6 x 25
		54.8				**6**	**50**	E 5690/ 6 x 50
11.2	13.2	31.4	2.4	1.6	3.5	**8**	**25**	E 5690/ 8 x 25
		56.4				**8**	**50**	E 5690/ 8 x 50
14	16.5	33	3	2	5	**10**	**25**	E 5690/10 x 25
		58				**10**	**50**	E 5690/10 x 50
		108				**10**	**100**	E 5690/10 x 100





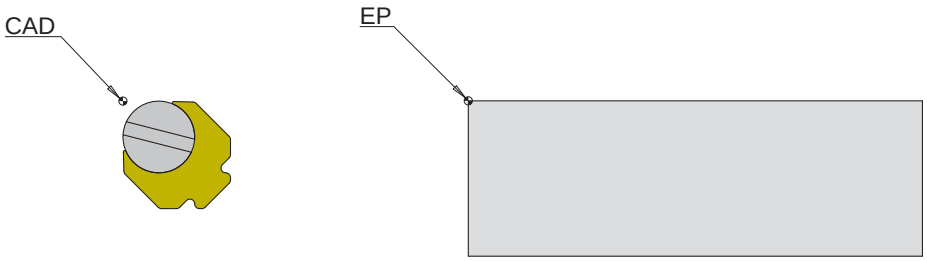




l1)* nutzbare Länge
usable length

S max)* bei R_m = 1000 N/mm²
at TS = 1000 N/mm²

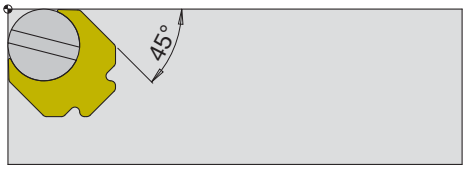
CAD-Nullpunkt
CAD datum point



CAD: CAD-Nullpunkt
CAD datum point

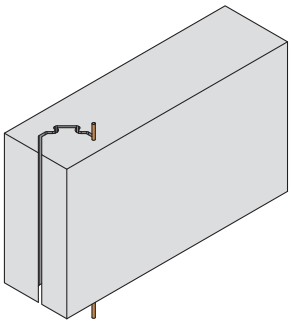
EP: Eckpunkt
corner point

Rollbieger im Stempel positionieren
Position bending unit in punch



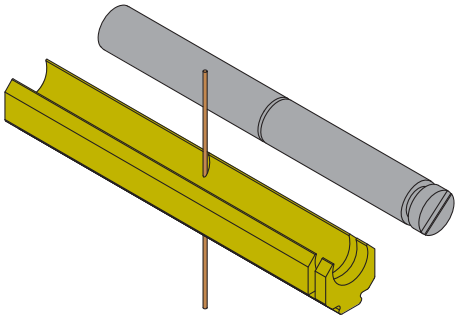
CAD-Nullpunkt des Rollbiegers auf dem Eckpunkt platzieren
Place the CAD zero point of the bending unit on the corner point

Kontur drahterodieren
Wire EDM contour



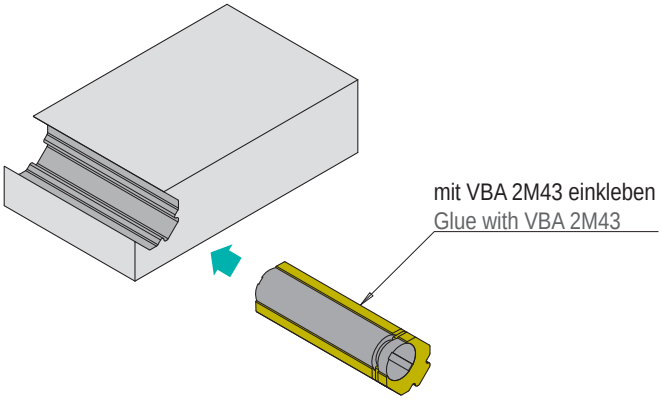
Kontur in den Stempel erodieren (G7-Toleranz)
EDM contour in the punch (G7 tolerance)

Rollbieger ablängen
Shorten bending unit



Rollbieger auf benötigte Länge mittels Drahterodieren ablängen (Rolle und Halter seperat)
Shorten the bending unit to the required length by means of wire EDM (Roller and holder separately)

Rollbieger einkleben
Glue bending unit



Darauf achten dass die Halteklammer vollständig vom Stempel umgeben ist.
Ansonsten kann diese verloren gehen.
Make sure that the retaining clip is completely surrounded by the punch.
Otherwise this can get lost.