Tool-
catalog

Edition 2018

TRUMPF EHT Bending Tools

TruBend Series 8000

TRUMPF

Machine Tools / Power Tools

Laser Technology / Electronics

Contents

	Page
Tooling systems	**1**
EHT bending tools	**3**
Tooling for machines with year of manufacture as of 2016	**6**
Tooling for machines with year of manufacture before 2016	**19**
Accessories	**36**
Useful Tools	**36**
Inquiry form for customized tooling	**37**

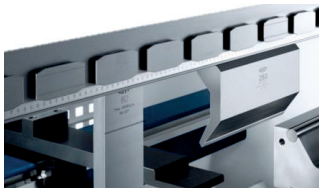
Edition: **07/2018**

Mat.No.: **2401078**

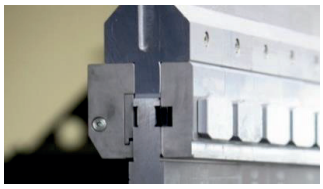
Tooling systems

TruBend Series 8000

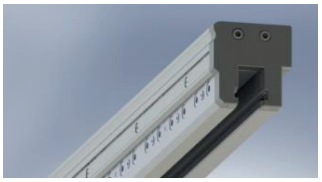
Upper tool clamping system:



EHT pneumatic - 26 mm
Max. load 3,000 kN/m



EHT hydraulic - 26 mm
Max. load 6,000 kN/m

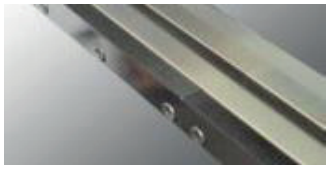


TRUMPF manual - 20 mm
Max. load 3,000 kN/m

TRUMPF hydraulic - 20 mm
3,000 kN/m or 6,000 kN/m

Bottom tool clamping system:

EHT pneumatic - 55 mm
Max. load 6,000 kN/m

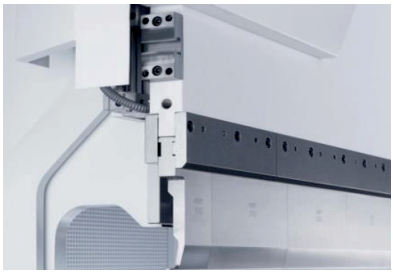


TRUMPF manual - 13 mm
Max. load 3,000 kN/m

TRUMPF hydraulic - 13 mm
3,000 kN/m or 6,000 kN/m

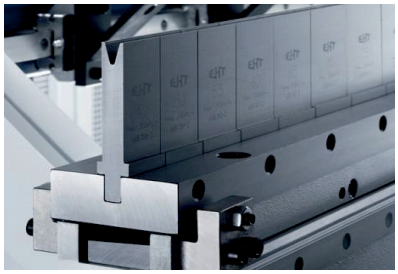
ProfiPress

Upper tool clamping system:



EHT manual - 26 mm
Max. load 3,000 kN/m

Bottom tool clamping system:



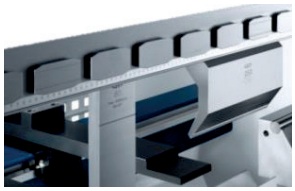
EHT manual - 13 mm
Max. load 3,000 kN/m

Tooling systems

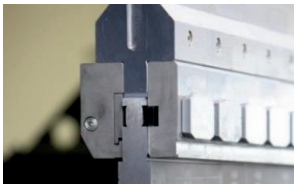
VarioPress

Upper tool clamping system:

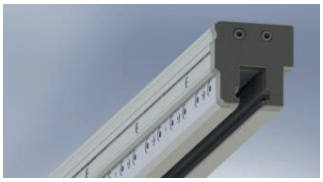
EHT manual - 26 mm
Max. load 3,000 kN/m



EHT pneumatic - 26 mm
Max. load 3,000 kN/m



EHT hydraulic - 26 mm
Max. load 6,000 kN/m



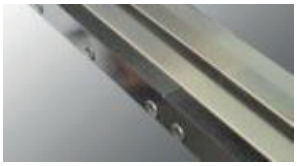
TRUMPF manual - 20 mm
Max. load 3,000 kN/m

TRUMPF hydraulic - 20 mm
3,000 kN/m or 6,000 kN/m

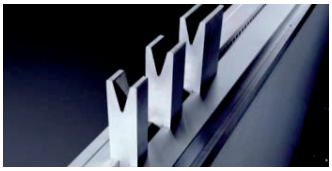
Bottom tool clamping system:

EHT manual - 13/90 mm
Max. load 3,000 kN/m

EHT pneumatic - 55 mm
Max. load 6,000 kN/m



TRUMPF manual - 13 mm
Max. load 3,000 kN/m



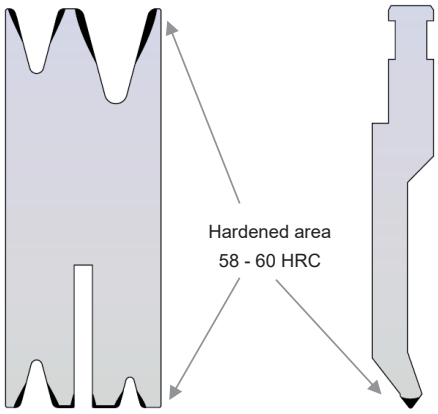
TRUMPF hydraulic - 13 mm
3,000 kN/m or 6,000 kN/m

EHT bending tools

Large surface tool holder for heavy load

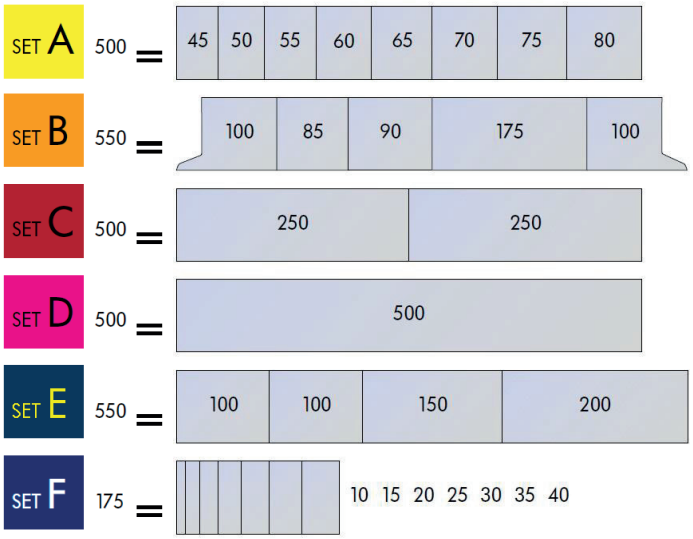
Clear lettering with segment width, order number, max. load.

Induction-hardened 58 - 60 HRC with min.hardening depth 1mm.



Material EHT Multi Tool: 42CrMo 4V

Standard sets of segmentation:



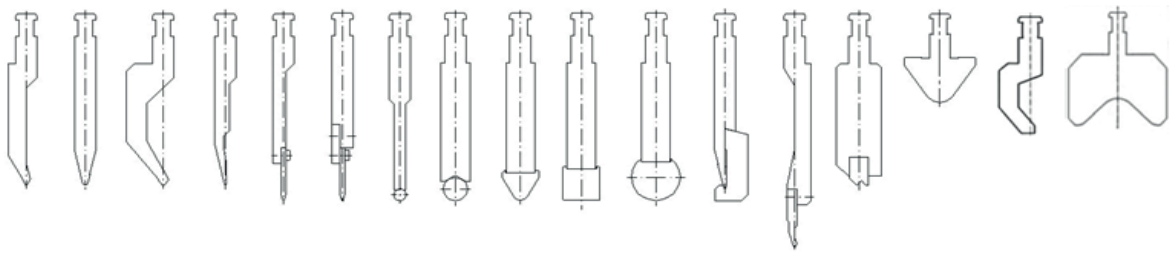
The index parts 100mm in Set B are designed as end pieces only for top dies.
Loose pieces on request!

The new EHT description for upper tools

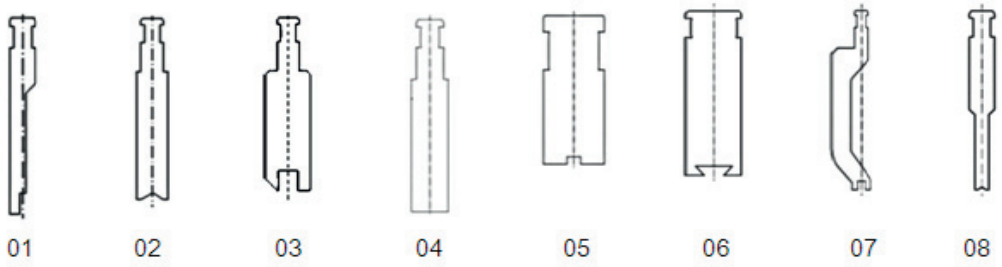
OWZ01K C20 H160 R003 G50 - T026

OWZ = Punches
OWH = Upper tool holder
OWA = Upper tool apapter
OWB = Upper tool insert
01 = Tool form (overview see below)
K / S = Head or shoulder bearing
I00 = Tool without throat
C20 = Tool with throat
H220 = Usable tool height in mm
R003 = Radius
G50 = Degrees
T026 = Receiver size tooling system (E = EHT, T = TRUMPF, A = AMADA etc.)

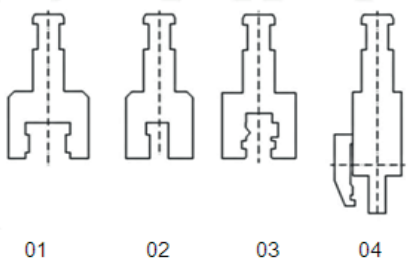
OWZ = Upper tool



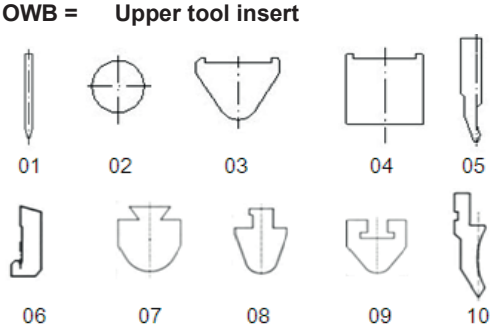
OWH = Upper tool holder



OWA = Upper tool apapter



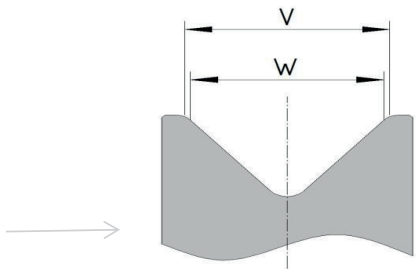
OWB = Upper tool insert



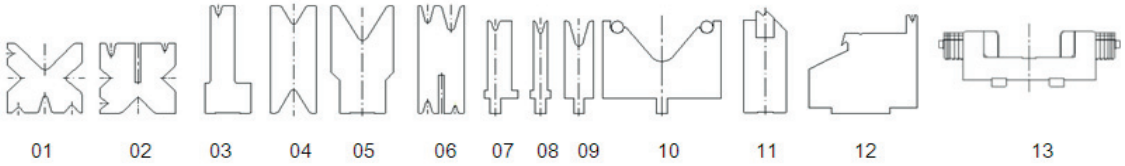
The new EHT description for bottom tools

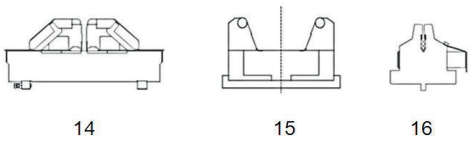
UWZ02S EV H100 V024 G30 - E055

UWZ = Bottom tool
UWH = Bottom tool holder
UWA = Bottom tool adapter
KWZ = Special tool
01 = Tool form (overview see below)
K / S = Head or shoulder bearing
BV = Block die (V), EV = SingleV, MV = MultiV, VV = VarioV
H100 = Usable tool height in mm
V024 = V opening (V = EHT, W = TRUMPF)
G30 = Degrees
E055 = Receiver size tooling system (E = EHT, T = TRUMPF, A = AMADA etc.)

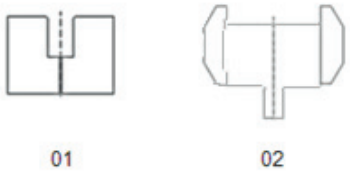


UWZ = Bottom tool





UWA = Bottom tool adapter



Tooling for machines with year of manufacture as of 2016

(new machine / tooling data and deduction values)

Upper tool systems

Standard upper tools: EHT head - 26mm 7
Upper Tool Holder with T adapter EHT - 26mm 11
Upper Tool Holder with T adapter TRUMPF - 20mm 12
Manual adapter: EHT head - 26mm 13
Bending insert for punch holder types OWH 01 14
Bending insert for punch holder types OWH 01 14

Bottom tool systems

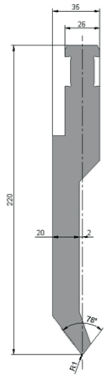
Bottom tool: EHT Standard - foot width 55 mm 15
Standard adapter 18
Special and other tooling 18

Standard upper tools: EHT head - 26mm

Punches

OWZ01K C02 H160 R001 G78 - E026
= Punches >E< OWZ01/K R1/78° H160

Drawing N°: 229611



Max. load:	1 100 kN/m
Linear weight:	38,0 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	2 mm
Head width:	26 mm
Radius	1,0 mm
Angle:	78°

SET:	Ref.
A	678540 = 2197603
B	678541 = 2197604
C	678542 = 2197605
F	678543 = 2197606

Punches

OWZ02K I00 H160 R003 G50 - E026
= Punches >E< OWZ02/K R3/50° H160

Drawing N°: 228393

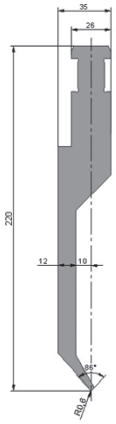
Max. load:	3 000 kN/m
Linear weight:	41,3 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	0 mm
Head width:	26 mm
Radius	3,0 mm
Angle:	50°

SET:	Ref.
A	678033 = 2197128
B	678034 = 2197129
C	678035 = 2197130
F	678036 = 2197131

Punches

OWZ03K C10 H160 R0.6 G86 - E026
= Punches >E< OWZ03/K R0,6/86° H160

Drawing N°: 229623



Max. load:	200 kN/m
Linear weight:	30,5 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	10 mm
Head width:	26 mm
Radius	0,6 mm
Angle:	86°

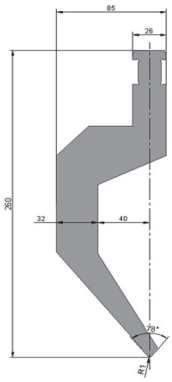
SET:	Ref.
A	678564 = 2197627
B	678565 = 2197628
C	678566 = 2197629
F	678567 = 2197630

Standard upper tools: EHT head - 26mm

Punches

OWZ03K C40 H200 R001 G78 - E026
= Punches >E< OWZ03/K R1/78° H200

Drawing N°: 229625



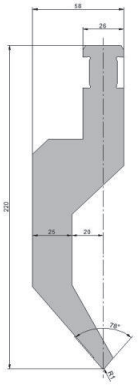
Max. load:	480 kN/m
Linear weight:	65,4 kg/m
Tool height:	260 mm
Usable height:	200 mm
Max. box height:	120 mm
Throat:	40 mm
Head width:	26 mm
Radius	1,0 mm
Angle:	78°

SET:	Ref.
A	678612 = 2197675
B	678613 = 2197676
C	678614 = 2197677
F	678615 = 2197678

Punches

OWZ03K C20 H160 R001 G78 - E026
= Punches >E< OWZ03/K R1/78° H160

Drawing N°: 229624



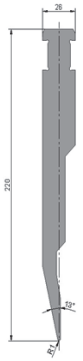
Max. load:	550 kN/m
Linear weight:	47,0 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	20 mm
Head width:	26 mm
Radius	1,0 mm
Angle:	78°

SET:	Ref.
A	678588 = 2197651
B	678589 = 2197652
C	678590 = 2197653
F	678591 = 2197654

Punches

OWZ04K C02 H160 R001 G13 - E026
= Punches >E< OWZ04/K R1/13° H160

Drawing N°: 229626



Max. load:	440 kN/m
Linear weight:	30,0 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	2 mm
Head width:	26 mm
Radius	1,0 mm
Angle:	13°

SET:	Ref.
A	678685 = 2197748
B	678686 = 2197749
C	678687 = 2197750
F	678688 = 2197751

Standard upper tools: EHT head - 26mm

Tool holders:

OWH 01 I000 E026 H192 MT
= Tool holders >E< OWH01/K H112

	Bending:
Max. load:	600 kN/m
Linear weight:	27,2 kg/m
Tool height:	172 mm
Usable height:	112 mm
Max. box height:	105 mm
Head width:	26 mm

Drawing N°: 229510

Folding:
800 kN/m

SET:	Ref.
A	678441 = 2197528
B	678442 = 2197529
C	678443 = 2197530
F	678444 = 2197531

Tool holders:

OWH 01 I000 E026 H292 MT
= Tool holders >E< OWH01/K H212

	Bending:
Max. load:	600 kN/m
Linear weight:	39,2 kg/m
Tool height:	272 mm
Usable height:	212 mm
Max. box height:	175 mm
Head width:	26 mm

Drawing N°: 229644

Folding:
800 kN/m

SET:	Ref.
A	678661 = 2197724
B	678662 = 2197725
C	678663 = 2197726
F	678664 = 2197727

Tool holders:

OWH 01 I000 E026 H392 MT
= Tool holders >E< OWH01/K H312

	Bending:
Max. load:	600 kN/m
Linear weight:	52,7 kg/m
Tool height:	372 mm
Usable height:	312 mm
Max. box height:	245 mm
Head width:	26 mm

Drawing N°: 229646

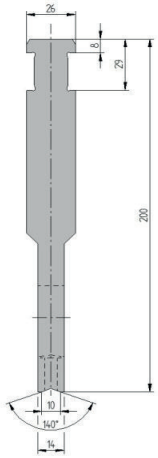
Folding:
800 kN/m

SET:	Ref.
A	678718 = 2197781
B	678719 = 2197782
C	679440 = 2198495

Standard combination upper tools

Tool holders: **OWH08K I00 H140 - E026** Drawing N°: 215249

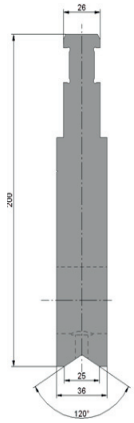
= Tool holders >E< OWH08/K H140



		SET:	Ref.
Max. load:	600 kN/m	C	670779 = 2189909
Linear weight:	31,2 kg/m		
		E	215249 = 2137646
Tool height:	200 mm		
Usable height:	140 mm		
Head width:	26 mm		
Insert width:	14,0 mm		
Insert diameter:	R7,5 - R14,0		

Tool holders: **OWH02K I00 H140 - E026** Drawing N°: 223022

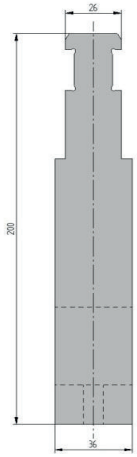
= Tool holders >E< OWH02/K H140



		SET:	Ref.
Max. load:	1 200 kN/m	C	674777 = 2193892
Linear weight:	49,5 kg/m		
		E	223022 = 2145320
Tool height:	200 mm		
Usable height:	140 mm		
Head width:	26 mm		
Insert width:	36,0 mm		
Insert diameter:	R10,0 - R25,0		

Tool holders: **OWH04K I00 H140 - E026** Drawing N°: 224181

= Tool holders >E< OWH04/K H140

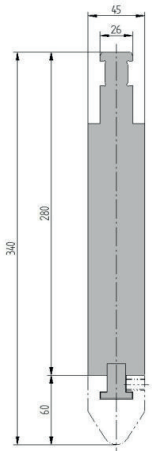


		SET:	Ref.
Max. load:	3 000 kN/m	C	681889 = 2200889
Linear weight:	49,6 kg/m		
		E	676402 = 2195508
Tool height:	200 mm		
Usable height:	140 mm		
Head width:	26 mm		
Insert width:	36,0 mm		

Upper Tool Holder with T adapter EHT - 26mm

Tool holders: **OWH05K I00 H220 - E026** Drawing N°: 237058

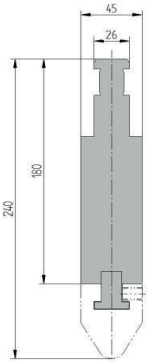
= Tool holders >E< OWH05/K H220



		SET:	Ref.
Max. load:	3 000 kN/m	C	682421 = 2201408
Linear weight:	92,0 kg/m	E	682420 = 2201407
Tool height:	280,0 mm		
Usable height:	220 mm		
Head width:	26 mm		
Insert width:	45,0 mm		

Tool holders: **OWH05K I00 H120 - E026** Drawing N°: 237059

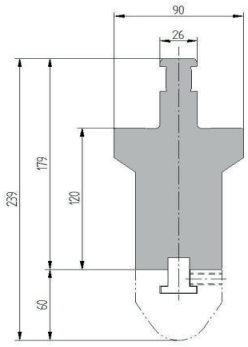
= Tool holders >E< OWH05/K H120



		SET:	Ref.
Max. load:	3 000 kN/m	C	682426 = 2201413
Linear weight:	56,0 kg/m	E	682425 = 2201412
Tool height:	180 mm		
Usable height:	120 mm		
Head width:	26 mm		
Insert width:	45,0 mm		

Tool holders: **OWH05S I00 H120 - E026** Drawing N°: 237060

= Tool holders >E< OWH05/K H120

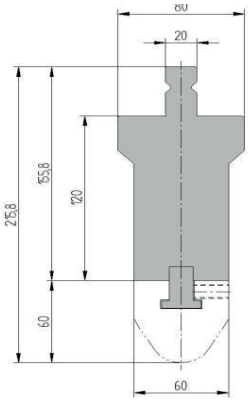


		SET:	Ref.
Max. load:	6 000 kN/m	C	682431 = 2201418
Linear weight:	78,0 kg/m	E	682430 = 2201417
Tool height:	179 mm		
Usable height:	120 mm		
Head width:	26 mm		
Insert width:	60,0 mm		

Upper Tool Holder with T adapter TRUMPF - 20mm

Tool holders: **OWH05S I00 H120 - T020** Drawing N°: 237062

= Tool holders >E< OWH05/S H120



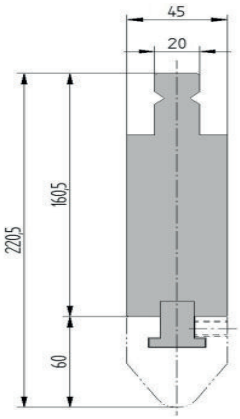
Max. load:	6 000 kN/m
Linear weight:	70,0 kg/m
Tool height:	155,8 mm
Usable height:	120 mm
Head width:	20 mm
Insert width:	60,0 mm

Delivery time: 4 weeks

SET:	Ref.
C	682441 = 2201423
E	682440 = 2201422

Tool holders: **OWH05K I00 H120 - T020** Drawing N°: 237061

= Tool holders >E< OWH05/K H123,5



Max. load:	2 000 kN/m
Linear weight:	51,0 kg/m
Tool height:	160,5 mm
Usable height:	123,5 mm
Head width:	20 mm
Insert width:	60,0 mm

Delivery time: 4 weeks

SET:	Ref.
C	682436 = 2084558
E	682435 = 2084557

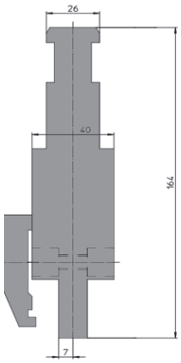
Manual adapter: EHT head - 26mm

Adapter EHT - Amada:

OWA04K E026 A014 H104
= Adapter >E< OWA04 H104

Drawing N°: 214525

Ref.
214525= 2136930



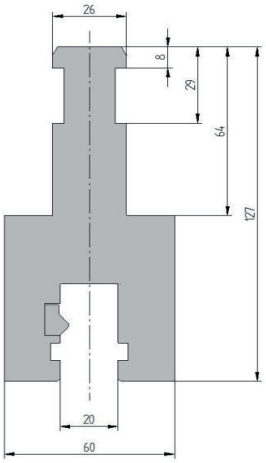
For punch:	Amada (13mm)
Length:	150 mm
Tool heigth:	164 mm
Usable height:	104 mm
Max. load:	1 000 kN/m
Linear weight:	5,5 kg/m
Head width:	26 mm

Adapter EHT - TRUMPF:

OWA03K E026 T020 H067
= Adapter >E< OWA03 H67

Drawing N°: 158880

Ref.
158880 = 2117968

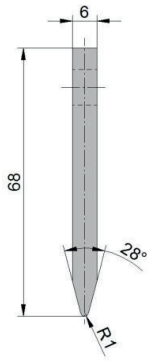


For punch:	TRUMPF (20mm)
Length:	150 mm
Tool heigth:	127 mm
Usable height:	67 mm
Max. load:	1 000 kN/m
Linear weight:	5,5 kg/m
Head width:	26 mm

Bending insert for punch holder types OWH 01

Bending insert: **OWB01K I00 H048 R001 G28 - E006**
= Insert >E< OWB01 R1/28

Drawing N°: 229511



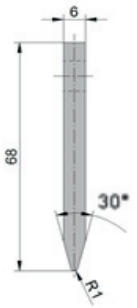
Max. load:	600 kN/m
Linear weight:	2,8 kg/m
Tool height:	68 mm
Usable height:	48 mm
Width:	6 mm
Radius	1,0 mm
Angle:	28°

SET:	Ref.
A	678415 = 2197502
B	678416 = 2197503
C	678417 = 2197504
F	678420 = 2197507

Bending insert for punch holder types OWH 01

Bending insert: **OWB01K I00 H048 R001 G30 - E006**
= Insert >E< OWB01 R1/30

Drawing N°: 207401



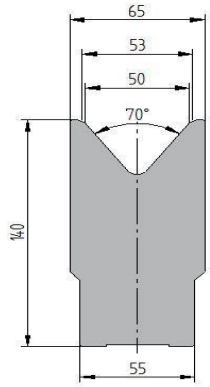
Max. load:	600 kN/m
Linear weight:	3,2 kg/m
Tool height:	68 mm
Usable height:	48 mm
Width:	6 mm
Radius	1,0 mm
Angle:	30°

SET:	Ref.
A	System divisions on demand
B	
C	
F	

Bottom tool: EHT Standard - foot width 55 mm

Bottom tool: UWZ05K EV H100 V053 G70 - E055
= Die >E< UWZ05 EV W50/70° R5

Drawing N°: 237035

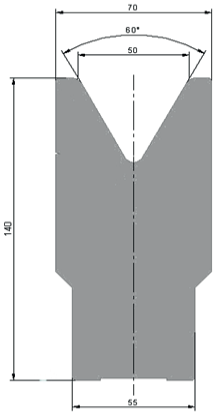


W Opening	50 mm
V Opening	53 mm
Angle:	70°
max. load:	1 500 kN/m
Weight:	60,0 kg/m
Width:	65 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	682363 = 2201350
B	682364 = 2201351
C	682365 = 2201352

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 50mm x 060°
= Die >E< UWZ05 EV W47,7/60° R4

Drawing N°: 213080

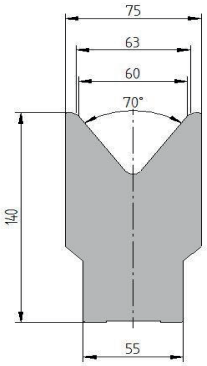


W Opening	47,7 mm
V Opening	50 mm
Angle:	60°
max. load:	1 100 kN/m
Weight:	62,5 kg/m
Width:	70 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	609285 = 2182186
B	609286 = 2182187
C	609287 = 2182188

Bottom tool: UWZ05K EV H100 V063 G70 - E055
= Die >E< UWZ05 EV W60/70° R5

Drawing N°: 237036



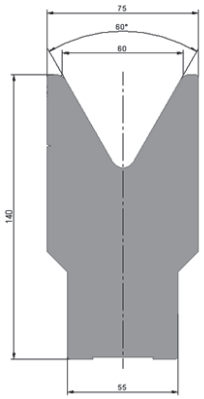
W Opening	60 mm
V Opening	63 mm
Angle:	70°
max. load:	1 500 kN/m
Weight:	64,0 kg/m
Width:	75 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	682384 = 2201371
B	682385 = 2201372
C	682386 = 2201373

Bottom tool: EHT Standard - foot width 55 mm

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 60mm x 060°
= Die >E< UWZ05 EV W57,7/60° R4

Drawing N°: 222322

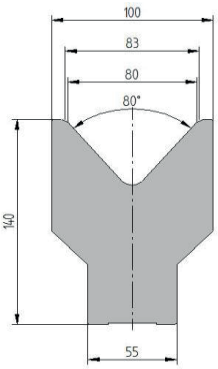


W Opening	57.7 mm
V Opening	60 mm
Angle:	60°
max. load:	1 300 kN/m
Weight:	62,5 kg/m
Width:	75 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	674363 = 2193479
B	674364 = 2193480
C	674365 =2193481

Bottom tool: UWZ05K EV H100 V083 G80 - E055
= Die >E< UWZ05 EV W80/80° R5

Drawing N°: 237037

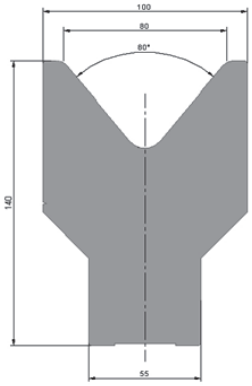


W Opening	80 mm
V Opening	83 mm
Angle:	80°
max. load:	2 000 kN/m
Weight:	75,5 kg/m
Width:	100 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	682399 = 2201386
B	682400 = 2201387
C	682401 = 2201388

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 80mm x 080°
= Die >E< UWZ05 EV W76,4/80° R6

Drawing N°: 222346



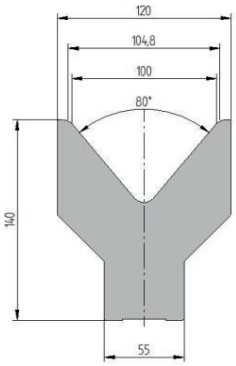
W Opening	76,4 mm
V Opening	80 mm
Angle:	80°
max. load:	2 000 kN/m
Weight:	75,4 kg/m
Width:	100 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	674425 = 2193541
B	674426 = 2193542
C	674427 = 2193543

Bottom tool: EHT Standard - foot width 55 mm

Bottom tool: UWZ05K EV H100 V104 G080 - E055
= Die >E< UWZ05 EV W100/80° R8

Drawing N°: 237038

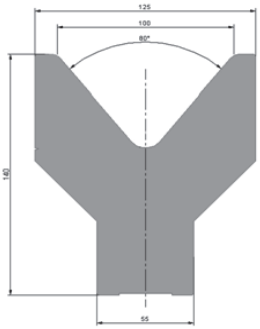


W Opening	100,0 mm
V Opening	104,8 mm
Angle:	80°
max. load:	2 000 kN/m
Weight:	77,0 kg/m
Width:	120 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	682414 = 2201401
B	682415 = 2201402
C	682416 = 2201403

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 100mm x 080°
= Die >E< UWZ05 EV W96,4/80° R6

Drawing N°: 222386

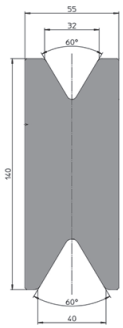


W Opening	96,4 mm
V Opening	100,0 mm
Angle:	80°
max. load:	
Weight:	2 000 kN/m 80,4 kg/m
Width:	125 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm

SET:	Ref.
A	674456 = 2193572
B	674457 = 2193573
C	674458 = 2193574

Bottom tool: Doppel-V-Die UWZ04K MV H100 V032 V040
= Die >E< UWZ04 MV

Drawing N°: 209641



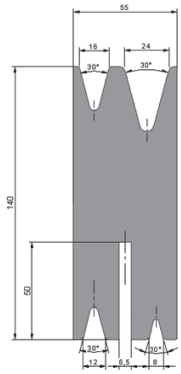
W Opening	30,27 mm	37,69 mm
V Opening	32 mm	40 mm
Angle:	60°	60°
max. load:	800 kN/m	900 kN/m
Weight:	52,0 kg/m	
Width:	55 mm	
Tool heigth:	140 mm	
Usable height:	100 mm	

SET:	Ref.
A	606677 = 2179580
B	606676 = 2179579
C	675640 = 2194752
D	606675 =2179578
F	671744 = 2190867

Bottom tool: EHT Standard - foot width 55 mm

Bottom tool: Multi-V-Die UWZ06K MV H100 V008 V024
= Die >E< UWZ06 MV

Drawing N°: 209642



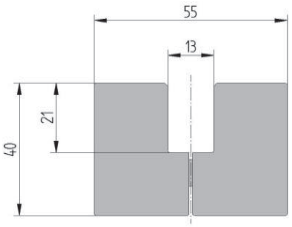
W Opening	7,4 mm	11,21 mm	15,21 mm	22,81 mm	
V Opening	8 mm	12 mm	16 mm	24 mm	Folding:
Angle:	30°	30°	30°	30°	
max. load:	400 kN/m	500 kN/m	400 kN/m	500 kN/m	900 kN/m
Weight:	50,7 kg/m				
Width:	55 mm				
Tool heigth:	140 mm				
Usable height:	100 mm				

SET:	Ref.
A	606694 = 2179597
B	606693 = 2179596
C	675378 = 2194492
D	606692 = 2179595
F	671083 = 2190208

Standard adapter

Adapter: UWA01K - E055 T013
= Adapter >E< UWA01 H40

Drawing N°: 215582

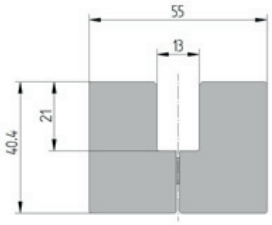


Opening:	13 mm
Foot width:	55 mm
Tool heigth:	40 mm
Length:	500 mm
Note:	Insert strips for thinner dies can be used

SET:	Ref.
D	215582 = 2137966

Adapter: UWA01K - E055 T013
= Adapter >E< UWA01 H40,4

Drawing N°: 239858



Opening:	13 mm
Foot width:	55 mm
Tool heigth:	40,4 mm
Length:	500 mm

SET:	Ref.
D	239858 = 2337069

Special and other tooling

Unusual projects need unusual tools: our experts check your inquiry with regard to feasibility and work with you to develop complex special tools according to your specifications.
You can rely on our expertise.

Tooling for machines with year of manufacture before 2016

Page

(previous machine / tool data and deduction values)

Upper tool systems

Standard upper tools: EHT head - 26mm **20**
Standard combination upper tools **24**
Z-Bending: EHT System **25**
Manual adapter: EHT head - 26mm **26**

Bottom tool systems

EHT Standard: 90 x 90 mm (block die in undivided version) **27**
EHT VarioTool: 60 x 60 mm (block die) **27**
EHT VarioTool: 90 x 90 mm **28**

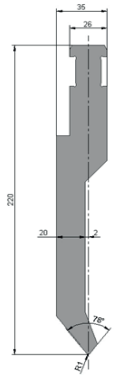
Bottom tool: EHT Standard - foot width 55 mm **29**
Bottom tool: EHT Standard - foot width 13 mm **31**
Standard adapter **35**

Special and other tooling **35**

Standard upper tools: EHT head - 26mm

Punches: OWZ 01 C002 E026 H220 MT R01,0 - 078°
= Punches >E< OWZ01/K R1/78° H160

Drawing N°: 229611



Max. load:	1 100 kN/m
Linear weight:	38,0 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	2 mm
Head width:	26 mm
Radius:	1,0 mm
Angle:	78°

SET:	Ref.
A	678540 = 2197603
B	678541 = 2197604
C	678542 = 2197605
F	678543 = 2197606

Punches: OWZ 02 I000 E026 H220 MT R03,0 - 0 50°
= Punches >E< OWZ02/K R3/50° H160

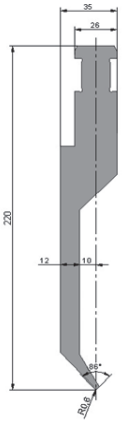
Drawing N°: 228393

Max. load:	3 000 kN/m
Linear weight:	41,3 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	0 mm
Head width:	26 mm
Radius:	3,0 mm
Angle:	50°

SET:	Ref.
A	678033 = 2197128
B	678034 = 2197129
C	678035 = 2197130
F	678036 = 2197131

Punches: OWZ 03 C010 E026 H220 MT R00,6 - 086°
= Punches >E< OWZ03/K R0,6/86° H160

Drawing N°: 229623



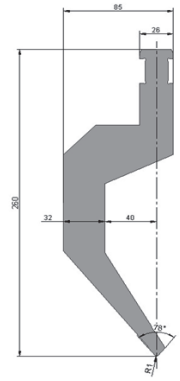
Max. load:	200 kN/m
Linear weight:	30,5 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	10 mm
Radius:	0,6 mm
Angle:	86°

SET:	Ref.
A	678564 = 2197627
B	678565 = 2197628
C	678566 = 2197629
F	678567 = 2197630

Standard upper tools: EHT head - 26mm

Punches: OWZ 03 C040 E026 H260 MT R01,0 - 078°
= Punches >E< OWZ03/K R1/78° H200

Drawing N°: 229625

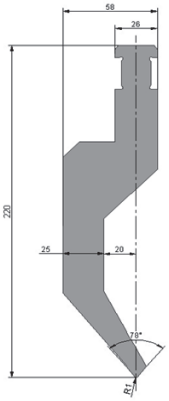


Max. load:	480 kN/m
Linear weight:	65,4 kg/m
Tool height:	260 mm
Usable height:	200 mm
Max. box height:	120 mm
Throat:	40 mm
Head width:	26 mm
Radius:	1,0 mm
Angle:	78°

SET:	Ref.
A	678612 = 2197675
B	678613 = 2197676
C	678614 = 2197677
F	678615 = 2197678

Punches: OWZ 03 C020 E026 H220 MT R01.0 - 078°
= Punches >E< OWZ03/K R1/78° H160

Drawing N°: 229624



Max. load:	550 kN/m
Linear weight:	47,0 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	20 mm
Head width:	26 mm
Radius:	1,0 mm
Angle:	78°

SET:	Ref.
A	678588 = 2197651
B	678589 = 2197652
C	678590 = 2197653
F	678591 = 2197654

Punches: OWZ 04 C002 E026 H220 MT R01,0 - 013°
= Punches >E< OWZ04/K R1/13° H160

Drawing N°: 229626

Max. load:	440 kN/m
Linear weight:	30,0 kg/m
Tool height:	220 mm
Usable height:	160 mm
Max. box height:	90 mm
Throat:	2 mm
Radius:	1,0 mm
Angle:	13°

SET:	Ref.
A	678685 = 2197748
B	678686 = 2197749
C	678687 = 2197750
F	678688 = 2197751

Standard upper tools: EHT head - 26mm

Tool holders: **OWH 01 I000 E026 H192 MT**
= Tool holder >E< OWH01/K H112

Drawing N°: 229510

	Bending:
Max. load:	600 kN/m
Linear weight:	27,2 kg/m
Tool height:	172 mm
Usable height:	112 mm
Max. box height:	105 mm
Throat:	0 mm
Head width:	26 mm

Folding:
800 kN/m

SET:	Ref.
A	678441 = 2197528
B	678442 = 2197529
C	678443 = 2197530
F	678444 = 2197531

Tool holders: **OWH 01 I000 E026 H292 MT**
= Tool holder >E< OWH01/K H212

Drawing N°: 229644

	Bending:
Max. load:	600 kN/m
Linear weight:	39,2 kg/m
Tool height:	272 mm
Usable height:	212 mm
Max. box height:	175 mm
Throat:	0 mm
Head width:	26 mm

Folding:
800 kN/m

SET:	Ref.
A	678661 = 2197724
B	678662 = 2197725
C	678663 = 2197726
F	678664 = 2197727

Tool holders: **OWH 01 I000 E026 H392 MT**
= Tool holder >E< OWH01/K H312

Drawing N°: 229646

	Bending:
Max. load:	600 kN/m
Linear weight:	52,7 kg/m
Tool height:	372 mm
Usable height:	312 mm
Max. box height:	245 mm
Throat:	0 mm
Head width:	26 mm

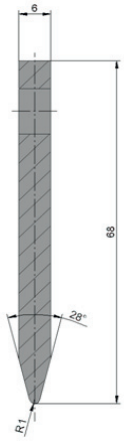
Folding:
800 kN/m

SET:	Ref.
A	678718 = 2197781
B	678719 = 2197782
C	679440 = 2198495

Bending insert for punch holder types OWZ 05

Bending insert: **OWB 01 l000 E006 H068 MT R01,0 - 028°**
= Insert >E< OWB01 R1/28

Drawing N°: 229511



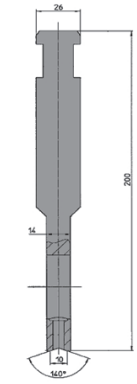
Tool heigth:	68 mm
Usable height:	48 mm
Width:	6 mm
Radius:	1,0 mm
Angle:	28°

SET:	Ref.
A	678415 = 2197502
B	678416 = 2197503
C	678417 = 2197504
F	678420 = 2197507

Comments: This insert is also available with a 30° angle. Other radii available on request.

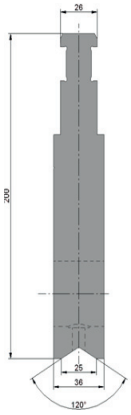
Standard combination upper tools

Tool holders: **OWH 08 I000 E026 H200 MT 10mm x 140°** Drawing N°: 215249
= Tool holder >E< OWH08/K H140



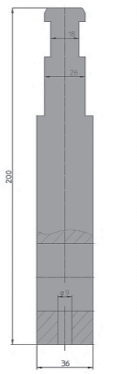
		SET:	Ref.
Max. load:	600 kN/m	C	670779 = 2189909
Linear weight:	31,2 kg/m	E	215249 = 2137646
Tool height:	200 mm		
Usable height:	140 mm		
Throat:	0 mm		
Head width:	26 mm		
Insert width:	14,0 mm		
Insert diameter:	R07,5 - R14		

Tool holders: **OWH 02 I000 E026 H200 MT 25mm x 120°**
= Tool holder >E< OWH02/K H140 Drawing N°: 223022



		SET:	Ref.
Max. load:	1 200 kN/m	C	674777 = 2193892
Linear weight:	48,5 kg/m	E	223022 = 2145320
Tool height:	200 mm		
Usable height:	140 mm		
Throat:	0 mm		
Head width:	26 mm		
Insert width:	36,0 mm		
Insert diameter:	R10 - R25		

Tool holders: **OWH 04 I000 E026 H200 VT** Drawing N°: 224181
= Tool holder >E< OWH04/K H140



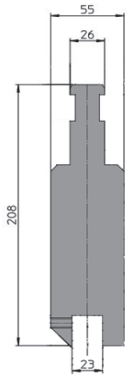
		SET:	Ref.
Max. load:	3 000 kN/m	C	681889 = 2200889
Linear weight:	49,6 kg/m	E	676402 = 2195508
Tool height:	200 mm		
Usable height:	140 mm		
Throat:	0 mm		
Head width:	26 mm		
Insert width:	36,0 mm		

Z-Bending: EHT System

Tool holders:

OWH 03 l000 E026 H208 MT 23mm x 24mm
= Tool holder >E< OWH03/K H148

Drawing N°: 215256



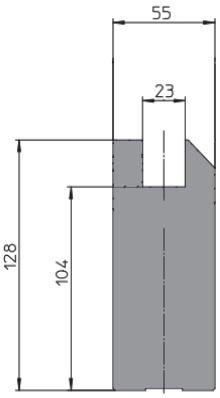
Max. load:	1 000 kN/m
Linear weight:	34,2 kg/m
Tool height:	208 mm
Usable height:	148 mm
Throat:	0 mm
Head width:	26 mm
Insert width:	23 x 24 mm

SET:	Ref.
D	215256 =2137653

Bottom tool holder:

UWH 01 E055 H128 MT 23mm x 24mm
= Tool holder >E< UWH01/

Drawing N°: 215257

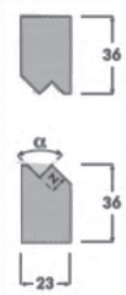


Max. load:	1 000 kN/m
Linear weight:	25,0 kg/m
Tool heigth:	128 mm
Width:	55 mm
Foot width:	55 mm
Insert width:	23 x 24 mm

SET:	Ref.
D	215257 = 2137654

Z-Bending inserts:

KWZ 01 Z030 W090 VT



Max. load:	1 000 kN/m
	OWZ:
Linear weight:	6,0 kg/m
	UWZ:
Linear weight:	6,0 kg/m
Z-Width:	3,0 mm
Angle:	90°
Tool heigth:	36 mm
Apprehension:	23 mm

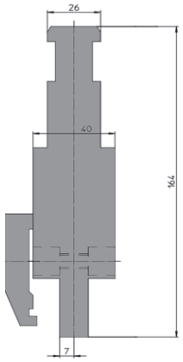
SET: D

on demand

Z	α
1,0 mm	160°
1,5 mm	160°
2,0 mm	150°
2,5 mm	140°
3,0 mm	90°
3,5 mm	90°
4,0 mm	90°
4,5 mm	90°
5,0 mm	90°
5,5 mm	90°
6,0 mm	90°
6,5 mm	90°
7,0 mm	90°
7,5 mm	90°
8,0 mm	90°

Manual adapter: EHT head - 26mm

Adapter EHT - Amada:



OWA 04 E026 A014 H164 MT
= Adapter >E< OWA04 H104

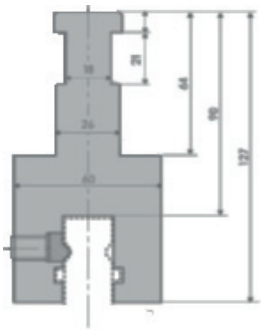
For punch:	Amada (13mm)
Length:	150 mm
Tool heigth:	164 mm
Usable height:	104 mm
Max. load:	1 000 kN/m
Linear weight:	5,5 kg/m
Throat:	0 mm
Head width:	26 mm

Drawing N°: 214525

Ref.

214525= 2136930

Adapter EHT - Wila:



OWA 03 I000 E026 W020 H127 VT
= Adapter >E< OWA03 H67

For punch:	Wila (20mm)
Length:	150 mm
Tool heigth:	127 mm
Usable height:	67 mm
Max. load:	1 000 kN/m
Linear weight:	5,5 kg/m
Throat:	0 mm
Head width:	26 mm

Drawing N°: 158880

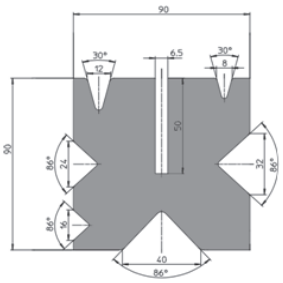
Ref.

158880 = 2117968

EHT Standard: 90 x 90 mm (block die in undivided version)

Block die: UWZ 02 BV 3-4-07 E090 H090 MT Drawing N°: 209805

= Die >E< UWZ02 BV



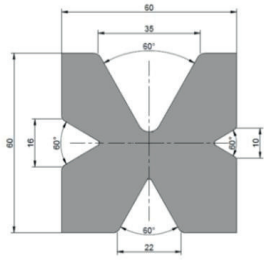
W-Opening:	7,4	11,21	15,11	22,81	30,22	37,63	
Opening:	8	12	16	24	32	40	Folding:
Angle:	30°	30°	86°	86°	86°	86°	
max. load:	400 kN/m	500 kN/m	600 kN/m	700 kN/m	800 kN/m	900 kN/m	900 kN/m
Weight:	51,3 kg/m						
Width:	90 mm						
Tool heigth:	90 mm						

SET:	Ref.
A	606955 = 2179858
B	606956 = 2179859
D	606957 = 2179860

EHT VarioTool: 60 x 60 mm (block die)

Block die: UWZ 01 BV 1-4-04 A060 H060 VT Drawing N°: 228830

= Die >E< UWZ01 BV



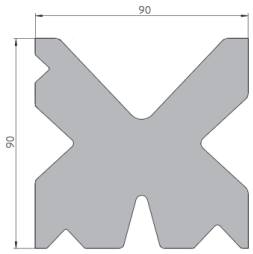
W-Opening:	9,13	14,85	20,56	33,27
Opening:	10	16	22	35
Angle:	60°	60°	60°	60°
max. load:	600 kN/m			
Weight:	21,0 kg/m			
Width:	60 mm			
Tool heigth:	60 mm			

SET:	Ref.
D	228830 = 2150998

Remark : Prices, other opening and angle on request!

EHT VarioTool: 90 x 90 mm

Block die: UWZ 01 BV 3-4-07 E090 H090 VT Drawing N°: 205343
= Die >E< UWZ01 BV

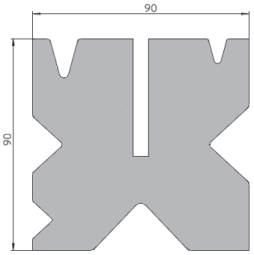


W-Opening:	11,11	15,21	15,11	18,81	30,22	37,63	67,63
Opening:	12	16	16	20	32	40	70
Angle:	86°	30°	86°	86°	86°	86°	86°
max. load:	400 kN/m	600 kN/m	600 kN/m	600 kN/m	700 kN/m	800 kN/m	900 kN/m
Weight:	45,6 kg/m						
Width:	90 mm						
Tool heigth:	90 mm						

Remark : Prices, other opening and angle on request!

Length:	Ref.	Length:	Ref.
1050	2390390	**4050**	604659 = 2177562
1550	2390411	**4550**	2390412
2050	604718 = 2177621	**5050**	2390413
2550	604658 = 2177561	**5550**	2390414
3050	608071 = 2180974	**6050**	2390415
3550	205343 = 2127774		

Block die: UWZ 02 BV 3-4-07 E090 H090 VT Drawing N°: 209262
= Die >E< UWZ01 BV



W-Opening:	7,4	11,21	15,11	22,81	30,81	38,22	
Opening:	8	12	16	24	32	40	Folding:
Angle:	30°	30°	86°	86°	86°	86°	
max. load:	400 kN/m	500 kN/m	600 kN/m	700 kN/m	800 kN/m	900 kN/m	900 kN/m
Weight:	51,3 kg/m						
Width:	90 mm						
Tool heigth:	90 mm						

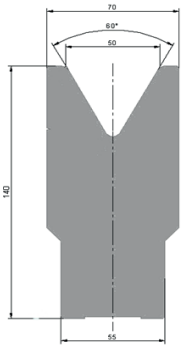
Remark 1: for VarioPress with the option "bottom tool shift".
Remark 2: folding with the upper tool type OWZ 05 ***Remark***
3: Prices, other opening and angle on request!

Length:	Ref.	Length:	Ref.
1050	2392596	**4050**	209262 = 2131692
1550	2392597	**4550**	2392598
2050	609212 = 2182113	**5050**	2392599
2550	679832 = 2198880	**5550**	2392600
3050	672135 = 2191259	**6050**	2392621
3550	607570 = 2180473		

Bottom tool: EHT Standard - foot width 55 mm

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 50mm x 060°
= Die >E< UWZ05 EV W47,7/60° R4

Drawing N°: 213080

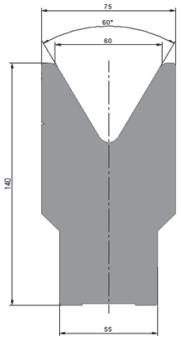


W-Opening:	47,7 mm
Opening:	50 mm
Angle:	60°
max. load:	1 100 kN/m
Weight:	62,5 kg/m
Width:	70 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm
Foot depth:	43 mm

SET:	Ref.
A	609285 = 2182186
B	609286 = 2182187
C	609287 = 2182188

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 60mm x 060°
= Die >E< UWZ05 EV W57,7/60° R4

Drawing N°: 222322

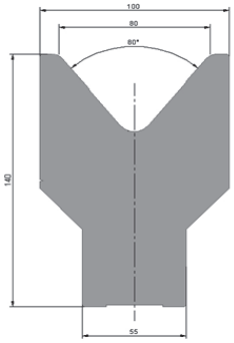


W-Opening:	57,7 mm
Opening:	60 mm
Angle:	60°
max. load:	1 300 kN/m
Weight:	62,5 kg/m
Width:	75 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm
Foot depth:	43 mm

SET:	Ref.
A	674363 = 2193479
B	674364 = 2193480
C	674365 =2193481

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 80mm x 080°
= Die >E< UWZ05 EV W76,4/80° R6

Drawing N°: 222346



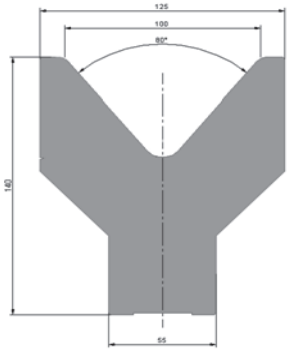
W-Opening:	76,4 mm
Opening:	80 mm
Angle:	80°
max. load:	2 000 kN/m
Weight:	75,4 kg/m
Width:	100 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm
Foot depth:	43 mm

SET:	Ref.
A	674425 = 2193541
B	674426 = 2193542
C	674427 = 2193543

Bottom tool: EHT Standard - foot width 55 mm

Bottom tool: UWZ 05 EV 1-1-01 E055 H140 MT 100mm x 080°
= Die >E< UWZ05 EV W96,4/80° R6

Drawing N°: 222386

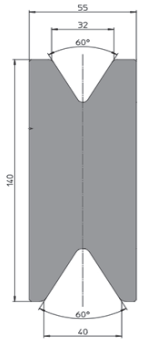


W-Opening:	96,4 mm
Opening:	100 mm
Angle:	80°
max. load:	2 000 kN/m
Weight:	80,4 kg/m
Width:	125 mm
Tool heigth:	140 mm
Usable height:	100 mm
Foot width:	55 mm
Foot depth:	43 mm

SET:	Ref.
A	674456 = 2193572
B	674457 = 2193573
C	674458 = 2193574

Bottom tool: UWZ 04 MV 1-2-02 E055 H140 MT V32/40-60°
= Die >E< UWZ04 MV

Drawing N°: 209641

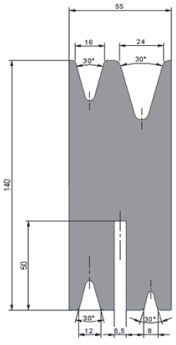


W-Opening:	30,27 mm	37,69 mm
Opening:	32 mm	40 mm
Angle:	60°	60°
max. load:	800 kN/m	900 kN/m
Weight:	52,0 kg/m	
Usable height:	100 mm	
Width:	55 mm	
Tool heigth:	140 mm	

SET:	Ref.
A	606677 = 2179580
B	606676 = 2179579
C	675640 = 2194752
D	606675 =2179578
F	671744 = 2190867

Bottom tool: UWZ 06 MV 5-2-05 E055 H140 MT
= Die >E< UWZ04 MV

Drawing N°: 209642



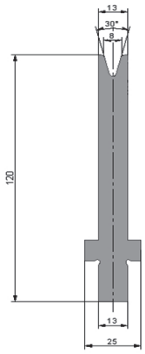
W-Opening:	7,4	11,21	15,21	22,81		
Opening:	8	12	16	24	Folding:	
Angle:	30°	30°	30°	30°		
max. load:	400 kN/m	500 kN/m	400 kN/m	500 t/m	900 t/m	
Weight:	50,7 kg/m					
Width:	55 mm					
Tool heigth:	140 mm					
Usable height:	100 mm					

SET:	Ref.
A	606694 = 2179597
B	606693 = 2179596
C	675378 = 2194492
D	606692 = 2179595
F	671083 = 2190208

Bottom tool: EHT Standard - foot width 13 mm

Bottom tool: UWZ 08 EV 1-1-01 E013 H120 MT 8mm x 030°
= Die >E< UWZ08 EV W7,4/30° R1,5

Drawing N°: 211956



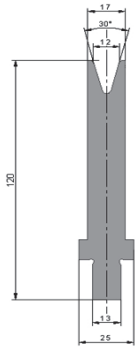
W-Opening:	7,4 mm
Opening:	8 mm
Angle:	30°
max. load:	300 kN/m
Weight:	12,8 kg/m
Width:	13 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

Delivery time: 4 weeks

SET:	Ref.
A	608138 = 2181041
B	608139 = 2181042
D	608140 = 2181043
F	673780 = 2192900

Bottom tool: UWZ 08 EV 1-1-01 E013 H120 MT 12mm x 030°
= Die >E< UWZ08 EV W11,21/30° R2

Drawing N°: 211957



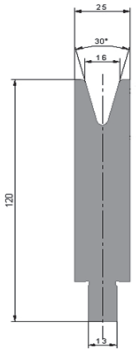
W-Opening:	11,21 mm
Opening:	12 mm
Angle:	30°
max. load:	350 kN/m
Weight:	15,0 kg/m
Width:	17 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

Delivery time: 4 weeks

SET:	Ref.
A	608155 = 2181058
B	608156 =2181059
D	608157 = 2181060
F	676271 =2195378

Bottom tool: UWZ 09 EV 1-1-01 E013 H120 MT 16mm x 030°
= Die >E< UWZ09 EV W15,21/30° R2

Drawing N°: 211958



W-Opening:	15,21 mm
Opening:	16 mm
Angle:	30°
max. load:	400 kN/m
Weight:	19,8 kg/m
Width:	25 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

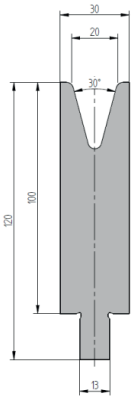
Delivery time: 4 weeks

SET:	Ref.
A	608173 = 2181076
B	608174 = 2181077
D	608175 = 2181078
F	672624 = 2191749

Bottom tool: EHT Standard - foot width 13 mm

Bottom tool: UWZ 09 EV 1-1-01 E013 H120 MT 20mm x 030°
= Die >E< UWZ09 EV W18,81/30° R3

Drawing N°: 234021



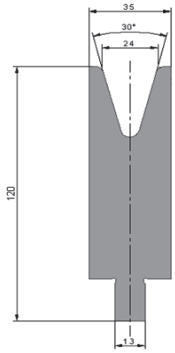
W-Opening:	18,81 mm
Opening:	20 mm
Angle:	30°
max. load:	450 kN/m
Weight:	22,8 kg/m
Width:	30 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

Delivery time: 4 weeks

SET:	Ref.
A	680726 = 2199755
B	680727 = 2199756
D	680728 = 2199757
F	681838 = 2200839

Bottom tool: UWZ 09 EV 1-1-01 E013 H120 MT 24mm x 030°
= Die >E< UWZ09 EV W22,81/30° R3

Drawing N°: 211959



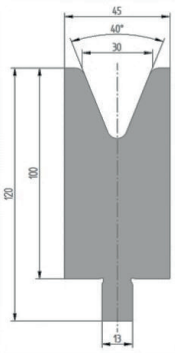
W-Opening:	22,81 mm
Opening:	24 mm
Angle:	30°
max. load:	500 kN/m
Weight:	25,6 kg/m
Width:	35 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

Delivery time: 4 weeks

SET:	Ref.
A	608190 = 2181092
B	608191 = 2181093
D	608192 = 2181094
F	675001 = 2194117

Bottom tool: UWZ 09 EV 1-1-01 E013 H120 MT 30mm x 040°
= Die >E< UWZ09 EV W28,08/40° R4

Drawing N°: 234022



W-Opening:	28,08 mm
Opening:	30 mm
Angle:	40°
max. load:	1 000 kN/m
Weight:	32,6 kg/m
Width:	45 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

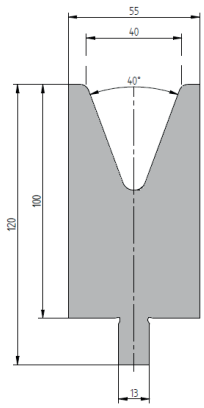
Delivery time: 4 weeks

SET:	Ref.
A	680741 = 2199770
B	680742 = 2199771
D	680743 =2199772

Bottom tool: EHT Standard - foot width 13 mm

Bottom tool: UWZ 09 EV 1-1-01 E013 H120 MT 40mm x 040°
= Die >E< UWZ09 EV W38,08/40° R4

Drawing N°: 234023



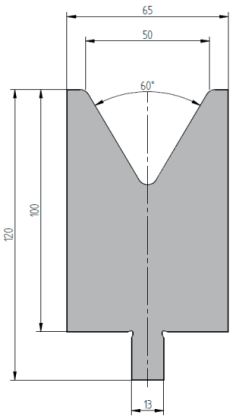
W-Opening:	38,08 mm
Opening:	40 mm
Angle:	40°
max. load:	1 000 kN/m
Weight:	36,8 kg/m
Width:	55 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

Delivery time: 4 weeks

SET:	Ref.
A	680756 = 2199785
B	680757 = 2199786
D	680758 = 2199787

Bottom tool: UWZ 09 EV 1-1-01 E013 H120 MT 50mm x 060°
= Die >E< UWZ09 EV W47,69/60° R4

Drawing N°: 234024



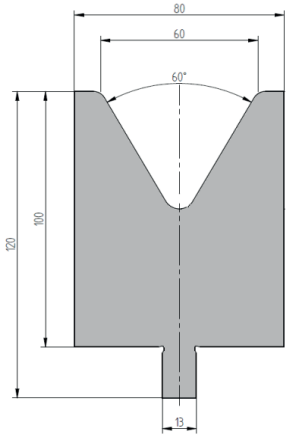
W-Opening:	47,69 mm
Opening:	50 mm
Angle:	60°
max. load:	1 200 kN/m
Weight:	44,8 kg/m
Width:	65 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

Delivery time: 4 weeks

SET:	Ref.
A	680772 = 2199801
B	680773 = 2199802
C	680774 = 2199803

Bottom tool: UWZ 09 EV 1-1-01 E013 H120 MT 60mm x 060°
= Die >E< UWZ09 EV W57,11/60° R5

Drawing N°: 234025



W-Opening:	57,11 mm
Opening:	60 mm
Angle:	60°
max. load:	1 500 kN/m
Weight:	52,8 kg/m
Width:	80 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

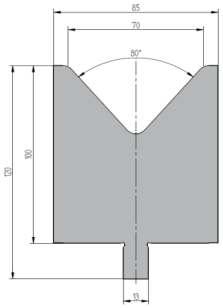
Delivery time: 4 weeks

SET:	Ref.
A	680787 = 2199816
B	680788 = 2199817
C	680789 = 2199818

Bottom tool: EHT Standard - foot width 13 mm

Bottom tool: UWZ 09 EV 1-1-01 W013 H120 MT 70mm x 080°
= Die >E< UWZ09 EV W66,4/80° R6

Drawing N°: 234026



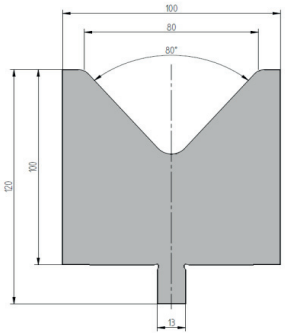
W-Opening:	66,4 mm
Opening:	70 mm
Angle:	80°
max. load:	1 800 kN/m
Weight:	57,4 kg/m
Width:	85 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

SET:	Ref.
A	680803 = 2199832
B	680804 = 2199833
C	680805 = 2199834

Delivery time: 4 weeks

Bottom tool: UWZ 09 EV 1-1-01 W013 H120 MT 80mm x 080°
= Die >E< UWZ09 EV W76,4/80° R6

Drawing N°: 234027



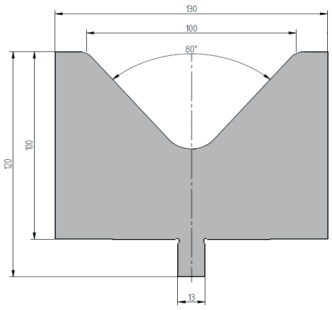
W-Opening:	76,4 mm
Opening:	80 mm
Angle:	80°
max. load:	2 000 kN/m
Weight:	65,6 kg/m
Width:	100 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

SET:	Ref.
A	680835 = 2199857
B	680836 = 2199858
C	680837 = 2199859

Delivery time: 4 weeks

Bottom tool: UWZ 09 EV 1-1-01 W013 H120 MT 100mm x 080°
= Die >E< UWZ09 EV W95,2/80° R8

Drawing N°: 234028



W-Opening:	95,2 mm
Opening:	100 mm
Angle:	80°
max. load:	2 500 kN/m
Weight:	81,0 kg/m
Width:	130 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

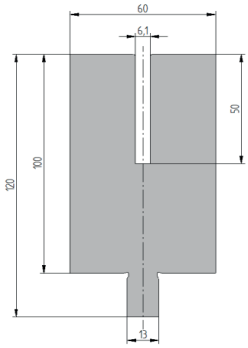
SET:	Ref.
A	680850 = 2199872
B	680851 = 2199873
C	680852 = 2199874

Delivery time: 4 weeks

Folding

Bottom tool: UWZ 25 1-1-01 W013 H120 MT
= Die >E< UWZ25 EV-F W6,1 R1

Drawing N°: 234060



W-Opening:	6,1 mm
Opening:	13,0 mm
max. load:	900 kN/m
Weight:	46,8 kg/m
Width:	60 mm
Tool heigth:	120 mm
Usable height:	100 mm
Foot width:	13 mm
Foot depth:	20 mm

Delivery time: 4 weeks

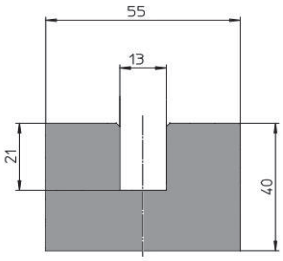
SET:	Ref.
A	680865 = 2199887
B	680866 = 2199888
C	680867 = 2199889

Remark: folding with the upper tool type OWZ 05

Standard adapter

Adapter: UWA 01 E055 T013 H040 MT
= Adapter >E< UWA01 H40

Drawing N°: 215582



Opening:	13 mm
Foot width:	55 mm
Tool heigth:	40 mm
Length:	500 mm

SET:	Ref.
D	215582 = 2137966

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Contact person: _____
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ZIP code / place: _____
Telephone: _____
Fax: _____
E-mail: _____

Details of your machine:

Machine type: _____

Serial-No.: _____

Mounting height: _____

Your sketch:

Details of material:

Material: _____

Sheet thickness: _____

Length: _____

Tolerances: _____

Comments: _____

Details of the new tool:

Desired tool lenght: _____

Division: _____

Comments: _____

Please attach a sketch of your bending part.

TRUMPF

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