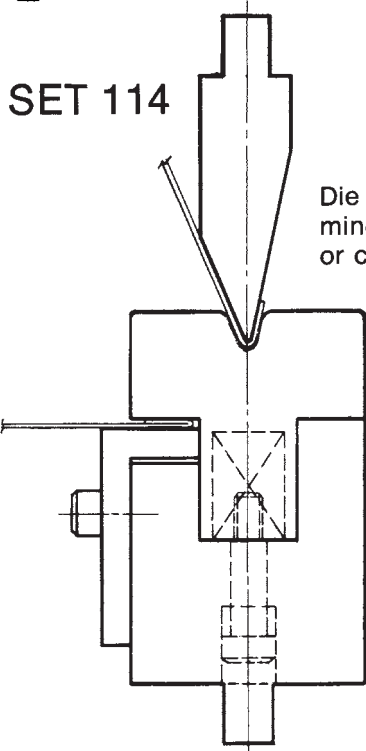


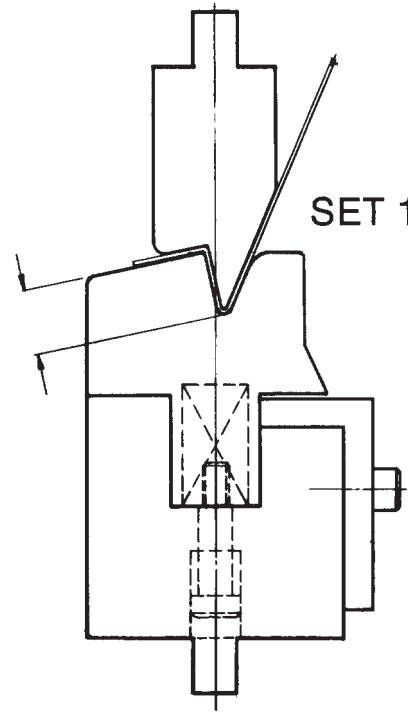


HEMMING AND CAM ACTION FORM DIES



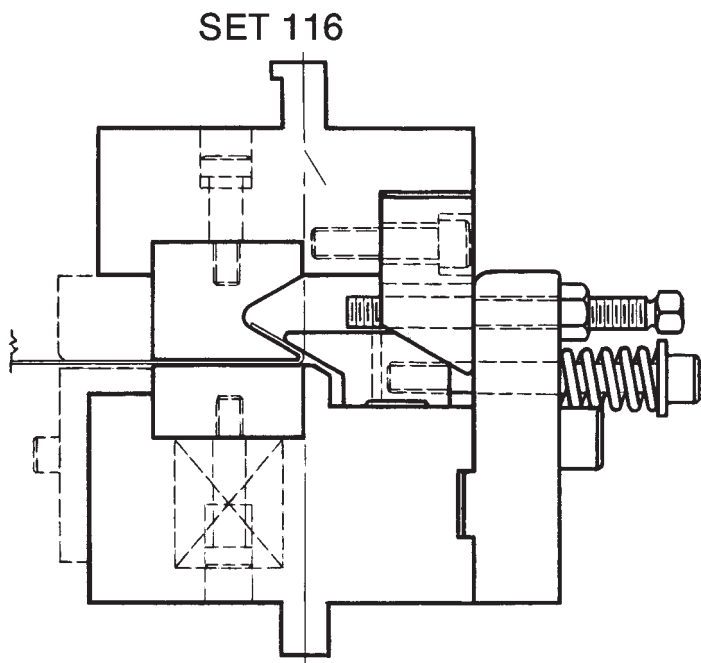
SET 114

Die set #114 is a three high hemming die. It will produce an open or closed hem.



SET 115

Die set #115 is used to form a standing seam in two operations.



SET 116

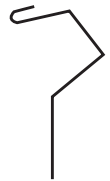
Die set #116 is used for high production in hemming wide sheets. Max. hem length is 3/4". This die set is recommended for 20 ga. and lighter. Capacity can be increased to 18 ga. by extending the anvil and adding adjustable angle to the lower section.



REVOLUTIONARY HEMMING SYSTEM

"THE HEM PRO"

In the past, hemming die sets have been spring loaded. The first operation makes an acute 30 degree bend, the second operation closes the hem in a gap in front of the tool set. Bending angles other than 30 degrees is impossible with conventional die sets because the lower die "floats" on springs. Air bending on this unstable surface gives inconsistent results.



The new "HEM PRO" system utilizes air cylinders to open the gap in front of the tools when a hem is needed. The air cylinders can be closed with a foot switch at any time to allow the die to rest on a flat surface. This enables the tooling to be used for air bending like standard acute angle tooling. With the use of a programmable ram depth press brake, Riteway's system can be used to hem and form any angle between 30 to 179 degrees in a single part handling.