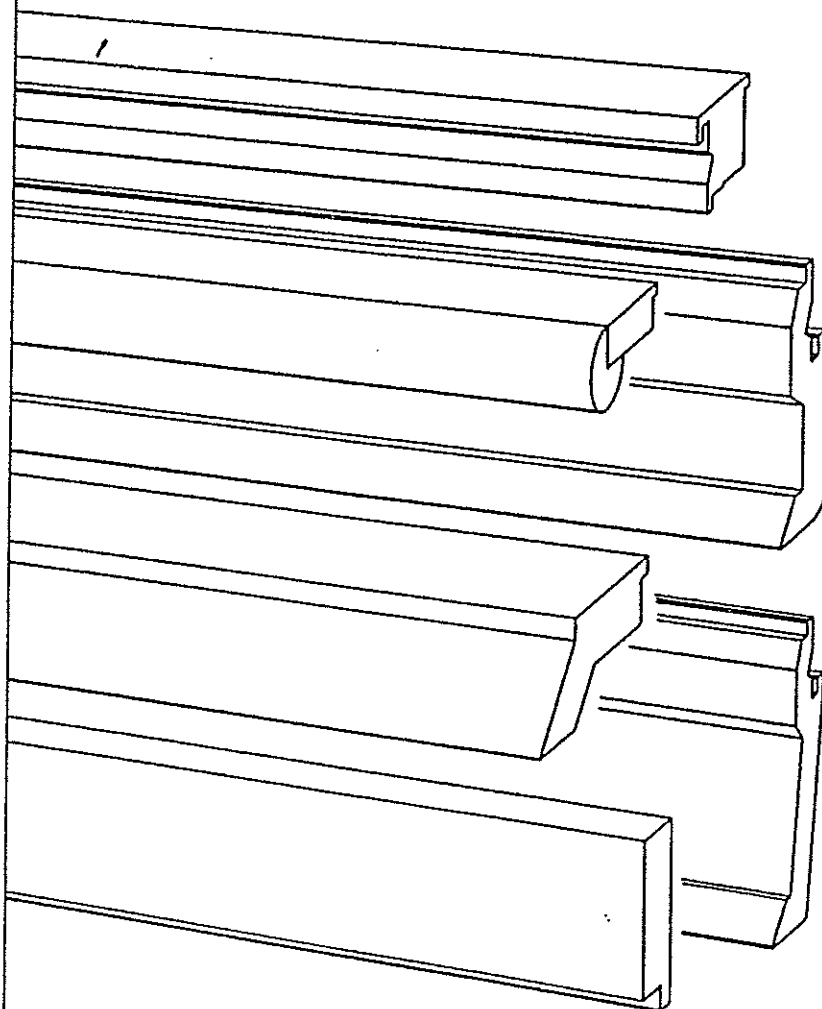




Standard- and special blades

US - execution



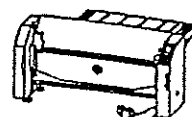
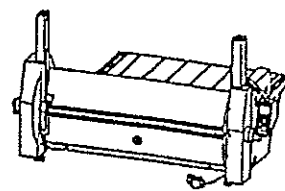
for Folding machine

RAS 64.12	RAS 67.12	RAS 74.20
RAS 64.16	RAS 67.16	RAS 74.25
RAS 64.20	RAS 67.20	RAS 74.30
RAS 64.25	RAS 67.25	RAS 74.40
RAS 64.30	RAS 67.30	
	RAS 67.40	

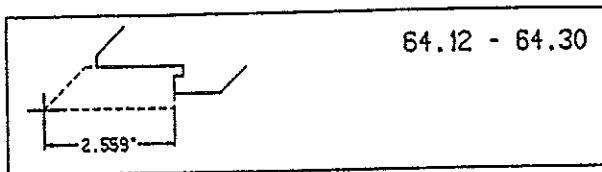
page 1-3

page 4-7

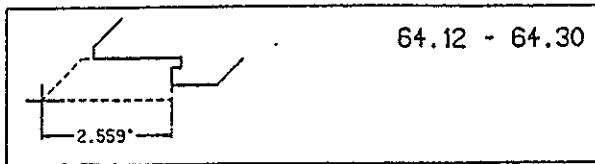
page 8-12



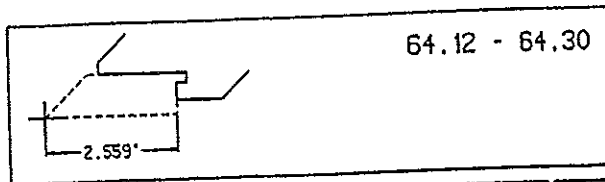
REINHARDT
MASCHINENBAU
G M B H



Sharp blade		64.12	64.16	64.20	64.25	64.30
	20° / $s_{ax} 0.04^{\circ}$	027 052	039 002	024 002	025 002	033 002
	30° / $s_{ax} 0.08^{\circ}$	027 054	039 004	024 004	025 004	033 004
Sharp blade		64.12	64.16	64.20	64.25	64.30
	Standard equipment	112 385	112 387	004 868	005 059	056 679
Sharp blade		64.12	64.16	64.20	64.25	64.30
	45°	027 055	039 005	024 005	025 005	033 005
Screw-on blade		64.12	64.16	64.20	64.25	64.30
		027 060	039 010	024 010	025 010	033 010
Rounding blade		64.12	64.16	64.20	64.25	64.30
	$R=0.08^{\circ}$ $s_{ax} 0.07^{\circ}$	027 152	039 102	024 102	025 102	033 102
Rounding blade		64.12	64.16	64.20	64.25	64.30
	$R=0.10^{\circ}$ $s_{ax} 0.08^{\circ}$	114 594	114 595	004 870	005 060	071 089
Rounding blade		64.12	64.16	64.20	64.25	64.30
	$R=0.12^{\circ}$ $s_{ax} 0.10^{\circ}$	027 153	039 103	024 103	025 103	033 103
	$R=0.195^{\circ}$	027 158	039 108	024 108	025 108	033 108
	$R=0.315^{\circ}$	027 166	039 116	024 116	025 116	033 116
	$R=0.395^{\circ}$	027 171	039 121	024 121	025 121	033 121
	$R=0.49^{\circ}$	027 173	039 123	024 123	025 123	033 123



Radius blade		64.12	64.16	64.20	64.25	64.30
	R=0.04°	027 361	039 301	024 301	025 301	033 301
	R=0.08°	027 362	039 302	024 302	025 302	033 302
	R=0.12°	027 363	039 303	024 303	025 303	033 303
Goal's foot blade		64.12	64.16	64.20	64.25	64.30
	H=1.97° S _{max} 0.10°	027 657	039 560	032 560	026 560	033 560
	H=2.95° S _{max} 0.08°	027 661	039 580	032 580	026 580	033 580
	H=3.94° S _{max} 0.06°	027 665	039 600	032 600	026 600	033 600
	H=5.32° S _{max} 0.04°	027 673	039 640	032 640	026 640	033 640
Goal's foot blade		64.12	64.16	64.20	64.25	64.30
	H=1.97° S _{max} 0.10°	027 660	039 566	032 566	026 566	033 566
	H=2.95° S _{max} 0.08°	027 664	039 586	032 586	026 586	033 586
	H=3.94° S _{max} 0.06°	027 668	039 606	032 606	026 606	033 606
	H=5.32° S _{max} 0.04°	027 676	039 646	032 646	026 646	033 646
Folding blade		64.12	64.16	64.20	64.25	64.30
	A=0.315° S _{max} 0.035°	114 602	114 604	109 539	109 541	131 600
	A=0.395° S _{max} 0.04°	114 603	114 605	112 063	112 064	127 838
Folding blade		64.12	64.16	64.20	64.25	64.30
	A=0.47° S _{max} 0.05°	021 952	022 952	024 902	025 902	033 922
	A=0.63° S _{max} 0.06°	021 954	022 954	024 904	025 904	033 924
Folding blade		64.12	64.16	64.20	64.25	64.30
	Standard equipment	112 389	112 390	004 881	005 068	127 346



Attention 1	For folding radii >0.4". Use wide angle blade for folding beam	Folding blade		64.12	64.16	64.20	64.25	64.30
			for radii >0.4"	114 596	114 597	005 178	005 089	132 933

Divided Goal's Foot Tool System patented DBP 2042509
(Tool set with Holding rail)

heat treated tools with max. 145 ksi

Technical drawing of a corner piece. The drawing shows a cross-section of the piece with the following dimensions: a vertical height of 0.51" at the top left, a horizontal width of 0.20" below it, a vertical height of 2.00" on the left side, a 45° angle at the bottom left corner, a horizontal width of 0.87" at the bottom, a total width of 1.77" at the base, a vertical height of 2.95" on the right side, and a horizontal width of 2.72" at the base of the right side.

1280mm /	50.394" -	64.12
1630mm /	64.173" -	64.16
2040mm /	80.315" -	64.20
2540mm /	100.000" -	64.25
3200mm /	125.984" -	64.30

Technical drawing of a segment and corner pieces. The drawing shows a cross-section of the segment and corner pieces with the following dimensions: a horizontal width of 5" for the corner piece LH, a horizontal width of 1" for the segment, and a horizontal width of 5" for the corner piece RH. The drawing also shows a vertical height of 2.00" for the corner pieces and a horizontal width of 2.72" for the segment.

Corner piece LH

Segment

Corner piece RH

Holding rail	 H=2.95" s=0.08"	64.12	64.16	64.20	64.25	64.30
		114 497	114 068	076 796	078 451	081 258

Goal's foot tool heat treated with Holding rail	 H=2.95" s=0.08"	64.12	64.16	64.20	64.25	64.30
		170 869	170 870	170 871	170 872	167 837

each 1 Corner piece RH and LH (E)
1 Holding blade
and each 1 piece (T):

consisting of:

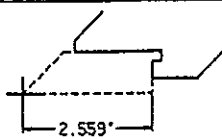
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3.625", 4", 5", 8", 9"
E - 2.5"

T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3",
3.625", 4", 5", 8", 10", 13"
E - 2.5"

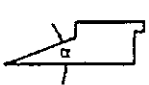
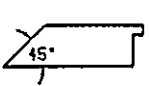
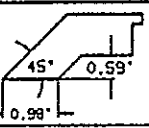
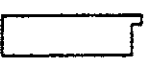
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E - 2.5"

T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3",
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E - 2.5"

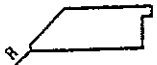
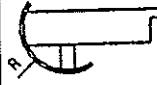
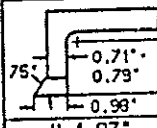
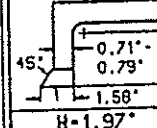
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3.25", 4", 5", 8", 10", 20", 25", 30"
E - 2.5"

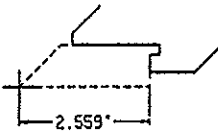
	67.12 - 67.40
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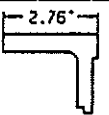
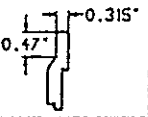
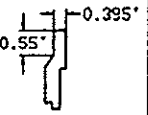
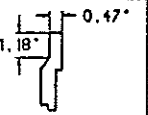
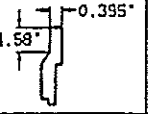


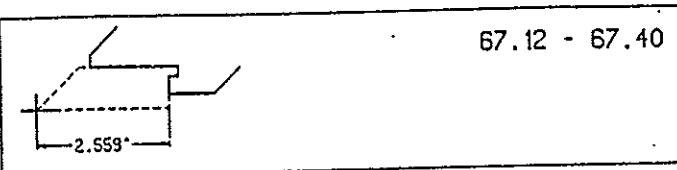
Sharp blade		67.12	67.16	67.20	67.25	67.30	67.40
	20° / s_{max} 0.04°	027 052	039 002	024 002	025 002	033 002	019 002
	30° / s_{max} 0.08°	027 054	039 004	024 004	025 004	033 004	019 004
Sharp blade		67.12	67.16	67.20	67.25	67.30	67.40
	Standard equipment	112 385	112 387	004 868	005 059	056 679	019 000
Sharp blade		67.12	67.16	67.20	67.25	67.30	67.40
	45°	027 055	039 005	024 005	025 005	033 005	019 005
Screw-on blade		67.12	67.16	67.20	67.25	67.30	67.40
		027 060	039 010	024 010	025 010	033 010	019 010
Rounding blade		67.12	67.16	67.20	67.25	67.30	67.40
	$R=0.08^\circ$ $s_{\text{max}} 0.07^\circ$	027 152	039 102	024 102	025 102	033 102	019 102
Rounding blade		67.12	67.16	67.20	67.25	67.30	67.40
	$R=0.10^\circ$ $s_{\text{max}} 0.08^\circ$	114 594	114 595	004 870	005 060	071 089	019 140
Rounding blade		67.12	67.16	67.20	67.25	67.30	67.40
	$R=0.12^\circ$ $s_{\text{max}} 0.10^\circ$	027 153	039 103	024 103	025 103	033 103	019 103
	$R=0.195^\circ$	027 158	039 108	024 108	025 108	033 108	019 108
	$R=0.315^\circ$	027 165	039 116	024 116	025 116	033 116	019 116
	$R=0.395^\circ$	027 171	039 121	024 121	025 121	033 121	019 121
	$R=0.49^\circ$	027 173	039 123	024 123	025 123	033 123	019 123



Radius blade		67.12	67.16	67.20	67.25	67.30	67.40
	R=0.04°	027 361	039 301	024 301	025 301	033 301	019 301
	R=0.08°	027 362	039 302	024 302	025 302	033 302	019 302
	R=0.12°	027 363	039 303	024 303	025 303	033 303	019 303
Radius blade composed		67.12	67.16	67.20	67.25	67.30	67.40
	R=0.785°	027 371	039 314	024 314	025 314	033 314	019 314
Radius blade composed		67.12	67.16	67.20	67.25	67.30	67.40
	R=1.635°	027 375	039 326	024 326	025 326	033 326	019 326
	R=3.13°	027 380	039 346	024 346	025 346	033 346	019 346
Goal's foot blade		67.12	67.16	67.20	67.25	67.30	67.40
	H=1.97° S _{80x} 0.10°	027 657	039 560	032 560	026 560	033 560	019 560
	H=2.95° S _{80x} 0.08°	027 661	039 580	032 580	026 580	033 580	019 580
	H=3.94° S _{80x} 0.06°	027 665	039 600	032 600	026 600	033 600	019 600
	H=5.32° S _{80x} 0.04°	027 673	039 640	032 640	026 640	033 640	019 640
Goal's foot blade		67.12	67.16	67.20	67.25	67.30	67.40
	H=1.97° S _{80x} 0.10°	027 660	039 566	032 566	026 566	033 566	019 566
	H=2.95° S _{80x} 0.08°	027 664	039 586	032 586	026 586	033 586	019 586
	H=3.94° S _{80x} 0.06°	027 668	039 606	032 606	026 606	033 606	019 606
	H=5.32° S _{80x} 0.04°	027 676	039 646	032 646	026 646	033 646	019 646
Folding blade		67.12	67.16	67.20	67.25	67.30	67.40
	A=0.59° S _{80x} 0.06°	027 952	039 902	032 902	026 902	033 952	019 902
	A=0.785° S _{80x} 0.08°	027 951	039 901	032 901	026 901	033 951	019 901

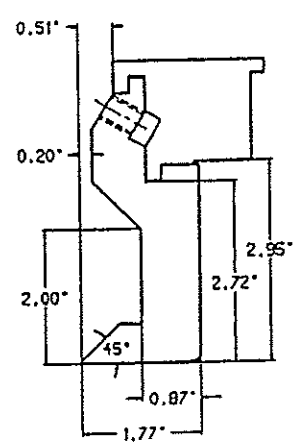
	67.12 - 67.40					
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Folding blade		67.12	67.16	67.20	67.25	67.30	67.40
	Standard equipment	114 600	114 601	055 283	055 284	116 408	019 900
Attention !	For folding radii $>0.4^{\circ}$, Use wide angle blade for folding beam						
Folding blade		67.12	67.16	67.20	67.25	67.30	67.40
	for radii $>0.4^{\circ}$	027 957	039 907	032 907	026 907	033 957	019 907
Folding blade		67.12	67.16	67.20	67.25	67.30	67.40
	$S_{\max} 0.035^{\circ}$	027 953	039 903	032 903	026 903	033 953	019 903
Folding blade		67.12	67.16	67.20	67.25	67.30	67.40
	$S_{\max} 0.04^{\circ}$	027 954	039 904	032 904	026 904	033 954	019 904
Folding blade	0.79° raised 	67.12	67.16	67.20	67.25	67.30	67.40
	$S_{\max} 0.05^{\circ}$	027 962	039 912	032 912	026 912	033 962	019 912
Folding blade	1.18° raised 	67.12	67.16	67.20	67.25	67.30	67.40
	$S_{\max} 0.04^{\circ}$	143 466	143 467	130 028	120 886	120 518	143 468

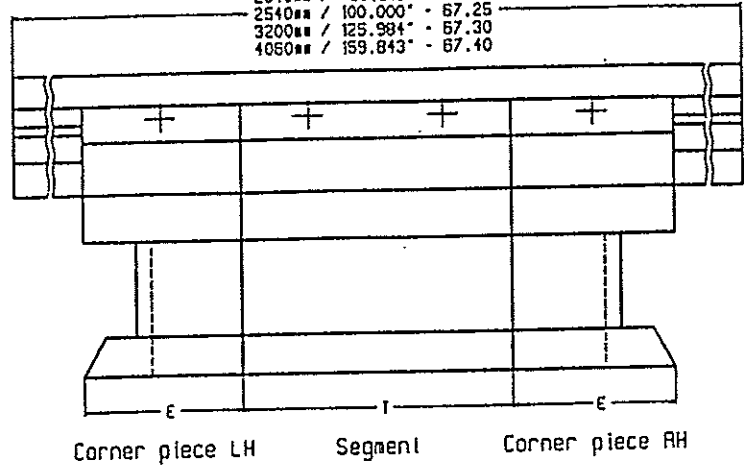


Divided Goat's Foot Tool System patented DBP 2042509
(Tool set with Holding rail)

heat treated tools with max. 145 ksi

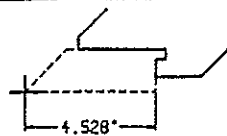


1280mm	/	50.394"	-	67.12
1630mm	/	64.173"	-	67.16
2040mm	/	80.315"	-	67.20
2540mm	/	100.000"	-	67.25
3200mm	/	125.984"	-	67.30
4060mm	/	159.843"	-	67.40



Holding rail						
	67.12	67.16	67.20	67.25	67.30	67.40
	114 497	114 068	076 795	078 451	081 258	143 301

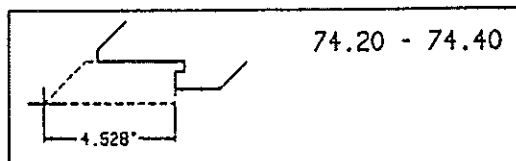
Goat's foot tool heat treated with Holding rail						
	67.12	67.16	67.20	67.25	67.30	67.40
H=2.95" S _{avg} =0.08"	170 869	170 870	170 871	170 872	167 837	170 873
consisting of:						
each 1 Corner piece RH and LH (E)						
1 Holding blade						
and each 1 piece (T):						
T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3", 3.625", 4", 5", 8", 9"						
E - 2.5"						
T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3", 3.625", 4", 5", 8", 10", 13"						
E - 2.5"						
T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3", 3.625", 4", 5", 8", 10", 29"						
E - 2.5"						
T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3", 3.25", 4", 5", 8", 10", 20", 29"						
E - 2.5"						
T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3", 3.25", 4", 5", 8", 10", 20", 25", 30"						
E - 2.5"						
T - 1.5", 1.75", 2", 2.25", 2.5", 2.75", 3", 3.125", 4", 5", 8", 10", 20", 25", 30", 34"						
E - 2.5"						



74.20 - 74.40

Sharp blade		74.20	74.25	74.30	74.40
	$20^\circ / s_{\text{max}} 0.08^\circ$	028 002	029 002	030 052	038 002
	$30^\circ / s_{\text{max}} 0.12^\circ$	028 004	029 004	030 054	038 004
Sharp blade		74.20	74.25	74.30	74.40
	Standard equipment	007 269	007 554	131 390	083 761
Sharp blade	heat treated blades with max. 145 ksi				
		74.20	74.25	74.30	74.40
	45°	007 433	007 453	132 934	086 441
Screw-on blade		74.20	74.25	74.30	74.40
		028 010	029 010	030 060	038 010
Rounding blade		74.20	74.25	74.30	74.40
	$R=0.12^\circ$ $s_{\text{max}} 0.10^\circ$	028 101	029 101	030 151	038 101
Rounding blade		74.20	74.25	74.30	74.40
	$R=0.20^\circ$ $s_{\text{max}} 0.10^\circ$	028 102	029 102	030 152	038 102
Rounding blade composed		74.20	74.25	74.30	74.40
	$R=0.395^\circ$	028 106	029 106	030 156	038 106
Rounding blade		74.20	74.25	74.30	74.40
	$R=0.785^\circ$	028 112	029 112	030 162	038 112
Rounding blade composed		74.20	74.25	74.30	74.40
	$R=1.18^\circ$	028 308	029 308	030 358	038 308

Goal's foot blade	heat treated foot with max. 145 ksi				
		74.20	74.25	74.30	74.40
	$H=1.97^\circ$ $s_{\text{max}} 0.10^\circ$	028 504	029 504	030 604	038 504
	$H=3.94^\circ$ $s_{\text{max}} 0.08^\circ$	028 528	029 528	030 628	038 528
Goal's foot blade	heat treated foot with max. 145 ksi				
		74.20	74.25	74.30	74.40
	$H=1.97^\circ$ $s_{\text{max}} 0.10^\circ$	028 513	029 513	030 613	038 513
	$H=3.94^\circ$ $s_{\text{max}} 0.08^\circ$	028 534	029 534	030 634	038 534
Folding blade		74.20	74.25	74.30	74.40
	$A=0.59^\circ$ $s_{\text{max}} 0.06^\circ$	028 951	029 951	030 951	038 951
	$A=0.785^\circ$ $s_{\text{max}} 0.08^\circ$	028 952	029 952	030 952	038 952
	$A=0.985^\circ$	028 957	029 957	030 957	038 957
Folding blade		74.20	74.25	74.30	74.40
	Standard equipment	132 937	132 938	131 400	132 939
Attention ! For folding radial > 0.4°. Use wide angle blade for folding beam					
Folding blade		74.20	74.25	74.30	74.40
	for radial > 0.4°	028 960	029 960	030 960	038 960
Folding blade		74.20	74.25	74.30	74.40
	$s_{\text{max}} 0.035^\circ$	028 953	029 953	030 953	038 953

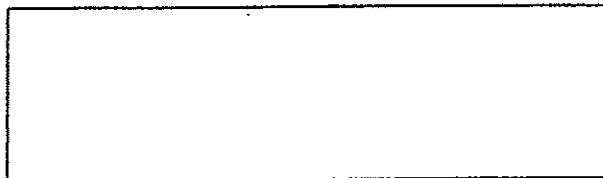


4 / 1995

Folding blade		74.20	74.25	74.30	74.40
	$s_{max} 0.04"$	028 954	029 954	030 954	038 954

Folding blade		74.20	74.25	74.30	74.40
	$s_{max} 0.05"$	028 955	029 955	030 955	038 955

Folding blade		74.20	74.25	74.30	74.40
	$s_{max} 0.04"$	170 856	170 857	134 654	170 858



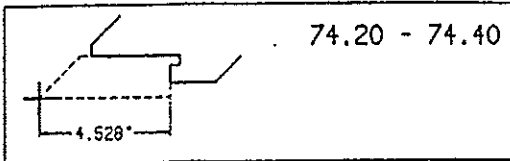
Divided folding tool heat treated					
	$A=0.59" / s_{max}=0.06"$ $A=0.75" / s_{max}=0.08"$ $A=1.14" / s_{max}=0.14"$				
	Section				

Divided folding tool Basic segment	1.38" raised for Standard, divided blade on lower beam				
		A-0.59"	A-0.75"	A-1.14"	
	T=195mm	165 278	166 079	166 089	

Divided folding tool Basic segment	1.77" raised for 0.39" raised and divided blade on lower beam				
		A-0.59"	A-0.75"	A-1.14"	
	T=195mm	167 779	167 789	167 799	

Divided folding tool Adapter set	1.38" raised for Standard, divided blade on lower beam				
		A-0.59"	A-0.75"	A-1.14"	
	ΣT=555mm	165 269	166 070	166 080	
	consisting of:	each 1 piece (T): T = 30, 35, 40, 45, 50, 55, 60, 2 x 120mm			

Divided folding tool Adapter set	1.77" raised for 0.39" raised and divided blade on lower beam				
		A-0.59"	A-0.75"	A-1.14"	
	ΣT=555mm	167 770	167 780	167 790	
	consisting of:	each 1 piece (T): T = 30, 35, 40, 45, 50, 55, 60, 2 x 120mm			



Divided Goat's Foot Tool System patented DBP 2042509
(Tool set with Holding rail)

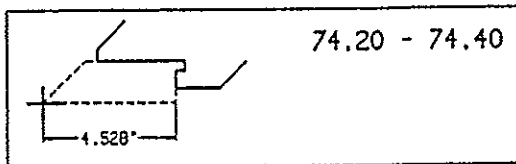
heat treated tools with max. 145 ksi

2040mm / 80.315" - 74.20
2540mm / 100.000" - 74.25
3200mm / 125.984" - 74.30
4060mm / 159.843" - 74.40

H=3.15" / h=2.83" / 8+0.98" / $\alpha=15^\circ$ / $s_{max}=0.14"$
H=4.25" / h=3.94" / 8+1.02" / $\alpha=12^\circ$ / $s_{max}=0.12"$
H=5.04" / h=4.72" / 8+1.06" / $\alpha=10^\circ$ / $s_{max}=0.10"$
H=6.22" / h=5.91" / 8+1.06" / $\alpha=8^\circ$ / $s_{max}=0.08"$

Holding rail				
	74.20	74.25	74.30	74.40
	124 952	123 312	131 054	142 136

Goat's foot tool heat treated with Holding rail				
	74.20	74.25	74.30	74.40
H=3.15" / h=2.83"	171 480	171 481	157 860	171 482
H=4.25" / h=3.94"	171 483	171 484	171 485	171 486
H=5.04" / h=4.72"	171 487	171 488	171 489	171 490
H=6.22" / h=5.91"	171 491	171 492	171 493	171 494
consisting of:				
each 1 Corner piece RH and LH (E)	T = 1.5" 1.75" 2" 2.25" 2.5" 2.75" 3"			
1 Holding blade	3.625" 4" 5" 8" 10" 26"			
and each 1 piece (T),	E = 4"			
	T = 1.5" 1.75" 2" 2.25" 2.5" 2.75" 3"			
	3.25" 4" 5" 8" 10" 20" 26"			
	E = 4"			
	T = 1.5" 1.75" 2" 2.25" 2.5" 2.75" 3"			
	3.25" 4" 5" 8" 10" 20" 25" 27"			
	E = 4"			
	T = 1.5" 1.75" 2" 2.25" 2.5" 2.75" 3"			
	3.125" 4" 5" 8" 10" 20" 25" 30" 31"			
	E = 4"			



Holding blade		74.20	74.25	74.30	74.40
		158 020	158 025	156 010	158 030

Sharp tools: Basic segment Adapter piece					
		Section			

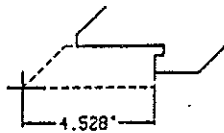
Sharp Tool Basic segment		T-400			
		$s_{\text{max}} 0.20''$	156 713		
Sharp Tool Adapter piece		T-60	T-40		
		$s_{\text{max}} 0.20''$	156 714	156 715	

Divided tool's Foot Tool for Automatic Clamping System	heat treat blades with max. 145 ksi				
	 $H=100\text{mm} (3.94'') / s_{\text{max}} 0.16''$ $H=150\text{mm} (5.91'') / s_{\text{max}} 0.12''$ $H=200\text{mm} (7.87'') / s_{\text{max}} 0.08''$ $H=250\text{mm} (9.84'') / s_{\text{max}} 0.08''$				
	 2040mm / 80.315" - 74.20 2540mm / 100.000" - 74.25 3200mm / 125.984" - 74.30 4050mm / 159.843" - 74.40				
	Corner piece LH Segment Corner piece RH				

Basic segment		100 V	150 V	200 V	250 V
		T = 195mm	156 680	156 691	156 702
Corner piece left hand		100 V	150 V	200 V	250 V
		E = 120mm	156 689	156 700	156 711

Adapter set		100 V	150 V	200 V	250 V
	$\Sigma T=315\text{mm}$	156 681	156 692	156 703	166 600
	consisting of:	each 1 piece (T): T = 30, 35, 40, 45, 50, 55, 60mm			

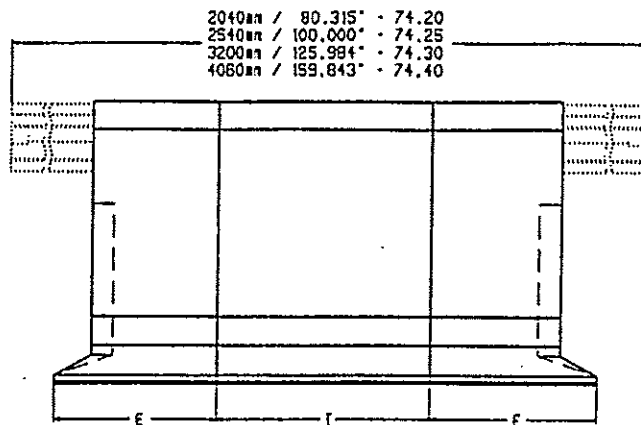
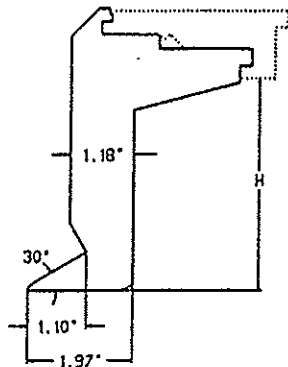
Corner piece right hand		100 V	150 V	200 V	250 V
	E = 120mm	156 690	156 701	156 712	166 610



74.20 - 74.40

Divided Goat's Foot Tool for Automatic Clamping System

heat treated tools with max. 145 ksi



Corner piece LH Segment Corner piece RH

H=100mm (3.94") / S _{max} = 0.16"
H=150mm (5.91") / S _{max} = 0.12"
H=200mm (7.87") / S _{max} = 0.08"

Basic segment		100 H	150 H	200 H	
	T=195mm	156 727	156 738	156 716	
Adapter set		100 H	150 H	200 H	
	ΣT=315mm	156 728	156 739	156 717	
	consisting of:	each 1 piece (1): T = 30, 35, 40, 45, 50, 55, 60mm			
Corner piece left hand		100 H	150 H	200 H	
	E=77mm	156 736	156 747	156 725	
Corner piece right hand		100 H	150 H	200 H	
	E=77mm	156 737	156 748	156 726	