



Press Brake Goose Neck Die #43



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Summary

I recently picked up the SWAG Offroad 20 ton heavy duty finger brake. and one of the things about 3d printing that I...

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I recently picked up the SWAG Offroad 20 ton heavy duty finger brake. and one of the things about 3d printing that I find most interesting is the ability to create durable items reasonably quick. The iterative design process, and the ability to make custom tools and parts

So, After seeing what others have done with 3d printing press tooling, I knew I had to try my hand at it.

Print Settings

Printer Brand:

Creality

Printer:

Ender 3

Rafts:

No

Supports:

No

Resolution:

.4mm

Infill:

90%

Filament: HATCHBOX PLA Black

Notes:

Extruder temp 210

Bed Temp 60

Speed 175

Post-Printing









Print failed after 4 bends in 1/8" mild steel. I suspect this is partly due to a filament change at the end of the print, an increase in print speed But most importantly, the angle being off, causing extreme stress on the die at the 45 Deg stopping point

Faster you fail, the faster you succeed

This will need some redesign, to fit the angle iron bottom Die that comes on the SWAG Offroad finger brake. along with some more experimenting with print settings.

Failure, happen at the top skin layers, and That was about the time I had to change filament

How I Designed This

Designed in Inventor 2020, based off what appears to be an industry standard #43 gooseneck die for 10g sheet metal

Category: Machine Tools

Model files



43_gooseneck_die__2inch.ipt



43_gooseneck_die__2.obj

Other files



43_gooseneck_die__2inch.pdf

[Find source .stl files on Thingiverse.com](#)

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