

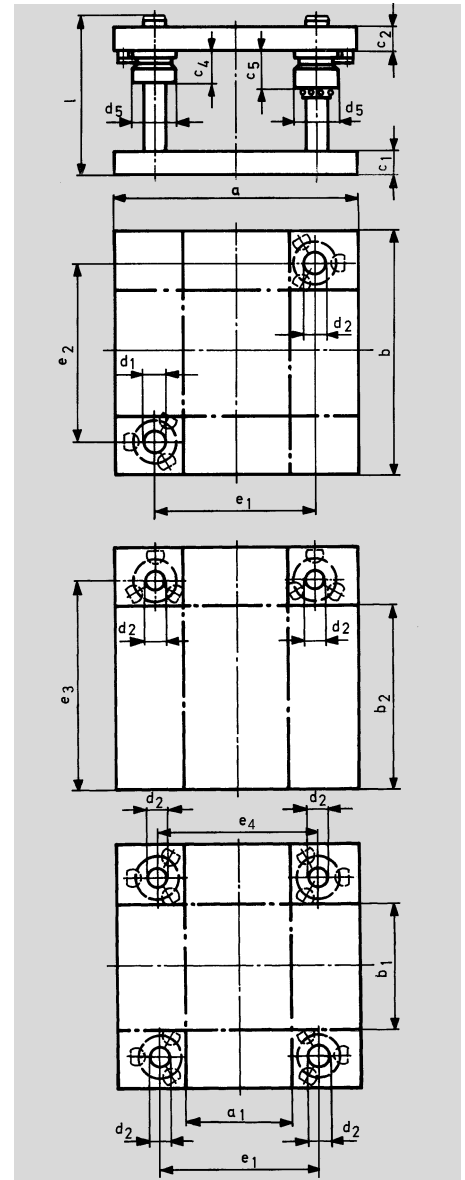
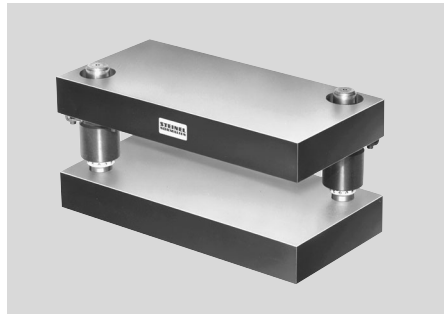
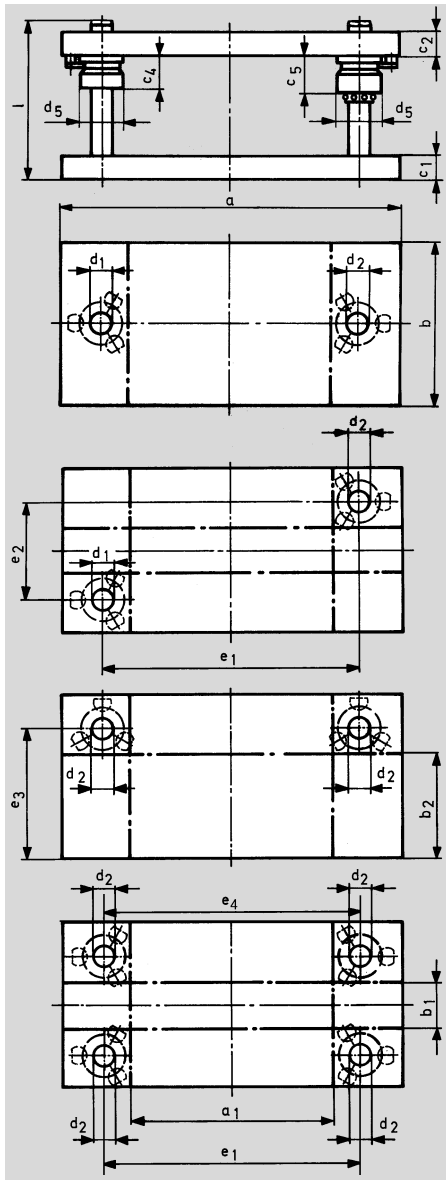
Die sets made of steel and aluminium

- In standardized sizes from stock or in any forms and dimensions to your drawings.
- Die sets stress-relieved, surfaces polished plane parallel. Ruptures, recesses, boreholes to your instructions.
- Sliding guides with guide bushes of hardened steel with bronze-plated treat as well as
- Ball guides, roller guides
- Precision die sets for progressive and compound dies
- Steel plates for die sets
- Centering and damping units



Die sets ST 35..

without stripper plate



Rectangular working area
2 or 4 pillars

Material: 1.0570 (St 52.3) aluminium on request

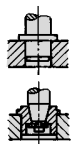
The plates are cleanly flame cut and normalized. Upon request edges finished. Please state on order.

Position of bushings:
Normally the positions of bushings will be as shown. If different positions are required indicate this on the order.

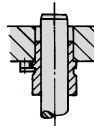
DIN 9868

Different Guide pillars length on request

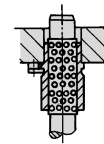
Lifting devices see under accessories



Removable pillars upon request
ST 7120 or
ST 7181/82

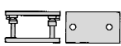


Sliding guide
hardened
steel bushing
bronze plated
Guide bushing
with shoulder ST 7419
medium version



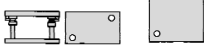
Ball guide
Guide bushing
with shoulder ST 7412
long version
Cage travel
= 1/2 length of stroke

Add size and combination of plates to order number



Order no. **ST 3539.**

Order no. **ST 3532.**



Order no. **ST 3549.**

Order no. **ST 3542.**



Order no. **ST 3559.**

Order no. **ST 3552.**



Order no. **ST 3569.**

Order no. **ST 3562.**



Die sets ST 35..



without stripper plate

Order example:

Die set with 2 rear mounted pillars,
bronze-plated steel **ST 3559**, sliding guide

Size a x b = 250 x 250

c₁ = 40, c₂ = 32

Add **250 x 250.3**

Order number **ST 3559. 250 x 250.3**

Add
size and combination
of plates
to order number

□ x □

a	x	b	a ₁	b ₁	b ₂	c ₁ ^{+0.5} _{+0.2}	c ₂ ^{+0.5} _{+0.2}	c ₄	c ₅	d ₅	e ₁	e ₂	e ₃	e ₄	ST 7100. d ₁ /d ₂ x l	▲
160	x	80	60	-	-	32	32	20	36	40	100	-	50	-	19/20 x 160	160 x 080
160	x	100	60	-	50	32	32	20	36	40	100	-	70	-	19/20 x 160	160 x 100
160	x	125	60	-	75	32	32	20	36	40	100	-	95	-	19/20 x 160	160 x 125
160	x	160	60	60	110	32	32	20	36	40	100	100	130	103	19/20 x 160	160 x 160
200	x	100	70	-	-	40	40	37	57	48	120	-	-	-	24/25 x 180	200 x 100.1 200 x 100.2 200 x 100.3 200 x 100.4
200	x	125	70	-	60	40	40	37	57	48	120	-	85	-	24/25 x 180	200 x 125.1 200 x 125.2 200 x 125.3 200 x 125.4
200	x	160	70	-	95	40	40	37	57	48	120	-	120	-	24/25 x 180	200 x 160.1 200 x 160.2 200 x 160.3 200 x 160.4
200	x	200	70	70	135	40	40	37	57	48	120	120	160	123	24/25 x 180	200 x 200.1 200 x 200.2 200 x 200.3 200 x 200.4
250	x	125	120	-	60	40	40	37	57	48	170	-	85	-	24/25 x 180	250 x 125.1 250 x 125.2 250 x 125.3 250 x 125.4
250	x	160	120	-	95	40	40	37	57	48	170	-	120	-	24/25 x 180	250 x 160.1 250 x 160.2 250 x 160.3 250 x 160.4
250	x	200	120	70	135	40	40	37	57	48	170	120	160	173	24/25 x 180	250 x 200.1 250 x 200.2 250 x 200.3 250 x 200.4
250	x	250	120	120	185	40	40	37	57	48	170	170	210	173	24/25 x 180	250 x 250.1 250 x 250.2 250 x 250.3 250 x 250.4
315	x	160	165	-	85	50	50	45	63	56	225	-	115	-	30/32 x 200	315 x 160.1 315 x 160.2 315 x 160.3 315 x 160.4
315	x	200	165	50	125	50	50	45	63	56	225	110	155	228	30/32 x 200	315 x 200.1 315 x 200.2 315 x 200.3 315 x 200.4
315	x	250	165	100	175	50	50	45	63	56	225	160	205	228	30/32 x 200	315 x 250.1 315 x 250.2 315 x 250.3 315 x 250.4
315	x	315	165	165	240	50	50	45	63	56	225	225	270	228	30/32 x 200	315 x 315.1 315 x 315.2 315 x 315.3 315 x 315.4
400	x	200	250	50	125	50	50	45	63	56	310	110	155	313	30/32 x 200	400 x 200.1 400 x 200.2 400 x 200.3 400 x 200.4
400	x	250	250	100	175	50	50	45	63	56	310	160	205	313	30/32 x 200	400 x 250.1 400 x 250.2 400 x 250.3 400 x 250.4

Die sets ST 35..

without stripper plate



Order example:

Die set with 2 rear mounted pillars,
bronze-plated steel **ST 3559**, sliding guide

Size a x b = 250 x 250

c₁ = 40, c₂ = 32

Add **250 x 250.3**

Order number **ST 3559. 250 x 250.3**

Add
size and combination
of plates
to order number

□ x □

a	x b	a ₁	b ₁	b ₂	c ₁ ^{+0,5} _{-0,2}	c ₂ ^{+0,5} _{-0,2}	c ₄	c ₅	d ₅	e ₁	e ₂	e ₃	e ₄	ST 7100. d ₁ /d ₂ x l	▲
400 x 315		250	165	240	50	50	45	63	56	310	225	270	313	30/32 x 200	400 x 315.1
					40	50									400 x 315.2
					50	40									400 x 315.3
					40	40									400 x 315.4
400 x 400		250	250	325	50	50	45	63	56	310	310	355	313	30/32 x 200	400 x 400.1
					40	50									400 x 400.2
					50	40									400 x 400.3
					40	40									400 x 400.4
500 x 250		330	80	165	50	50	45	70	66	400	150	200	403	38/40 x 200	500 x 250.1
					40	50									500 x 250.2
					50	40									500 x 250.3
					40	40									500 x 250.4
500 x 315		330	145	230	50	50	45	70	66	400	215	265	403	38/40 x 200	500 x 315.1
					40	50									500 x 315.2
					50	40									500 x 315.3
					40	40									500 x 315.4
500 x 400		330	230	315	50	50	45	70	66	400	300	350	403	38/40 x 200	500 x 400.1
					40	50									500 x 400.2
					50	40									500 x 400.3
					40	40									500 x 400.4
500 x 500		330	330	415	50	50	45	70	66	400	400	450	403	38/40 x 200	500 x 500.1
					40	50									500 x 500.2
					50	40									500 x 500.3
					40	40									500 x 500.4
630 x 315		430	115	215	63	63	50	80	80	510	195	255	513	48/50 x 250	630 x 315.1
					50	63									630 x 315.2
					63	50									630 x 315.3
					50	50									630 x 315.4
630 x 400		430	200	300	63	63	50	80	80	510	280	340	513	48/50 x 250	630 x 400.1
					50	63									630 x 400.2
					63	50									630 x 400.3
					50	50									630 x 400.4
630 x 500		430	300	400	63	63	50	80	80	510	380	440	513	48/50 x 250	630 x 500.1
					50	63									630 x 500.2
					63	50									630 x 500.3
					50	50									630 x 500.4
630 x 630		430	430	530	63	63	50	80	80	510	510	570	513	48/50 x 250	630 x 630.1
					50	63									630 x 630.2
					63	50									630 x 630.3
					50	50									630 x 630.4
710 x 400		510	200	300	63	63	50	80	80	590	280	340	593	48/50 x 250	710 x 400.1
					50	63									710 x 400.2
					63	50									710 x 400.3
					50	50									710 x 400.4
710 x 500		510	300	400	63	63	50	80	80	590	380	440	593	48/50 x 250	710 x 500.1
					50	63									710 x 500.2
					63	50									710 x 500.3
					50	50									710 x 500.4
710 x 630		510	430	530	63	63	50	80	80	590	510	570	593	48/50 x 250	710 x 630.1
					50	63									710 x 630.2
					63	50									710 x 630.3
					50	50									710 x 630.4
800 x 400		600	200	300	63	63	50	80	80	680	280	340	683	48/50 x 250	800 x 400.1
					50	63									800 x 400.2
					63	50									800 x 400.3
					50	50									800 x 400.4
800 x 500		600	300	400	63	63	50	80	80	680	380	440	683	48/50 x 250	800 x 500.1
					50	63									800 x 500.2
					63	50									800 x 500.3
					50	50									800 x 500.4
800 x 630		600	430	530	63	63	50	80	80	680	510	570	683	48/50 x 250	800 x 630.1
					50	63									800 x 630.2
					63	50									800 x 630.3
					50	50									800 x 630.4

Acceptance specifications

for die sets made of steel and aluminium



similar to DIN 9811 part 1

Sizes without tolerances
for machined surfaces: DIN 7168 – middle

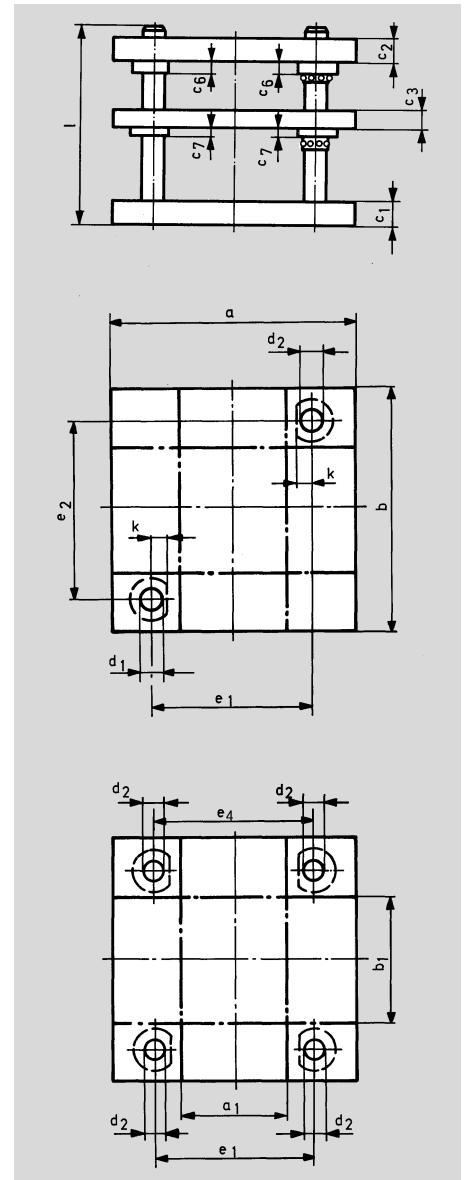
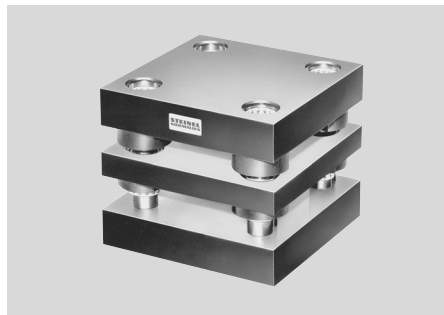
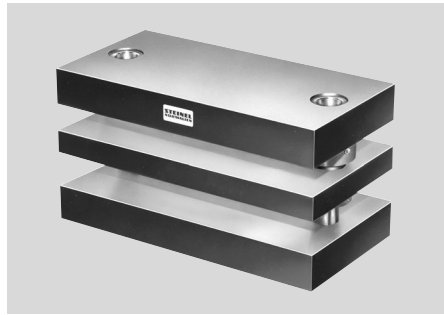
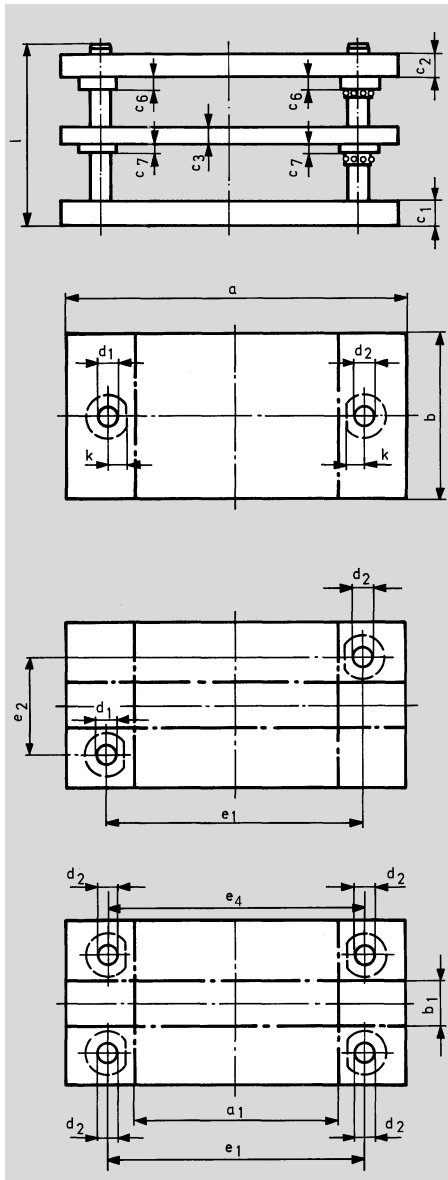
Tolerances of flatness, parallelism and squareness

	Test specimen	Testing position	Max. overall length of working surface l		Tolerances T_p, T_E, T_R
			over	to	
Flatness of surface			—	—	0,005 per 100 mm length of working surface *)
Parallelism of working surfaces			0	100	0,005
			100	200	0,008
			200	300	0,011
			300	400	0,014
			400	500	0,017
			500	600	0,020
Parallelism of contact surfaces			0	100	0,008
			100	200	0,012
			200	300	0,018
			300	400	0,024
			400	500	0,030
			500	600	0,036
Squareness of guide pillars			—	—	0,005 per 100 mm length of pillars *)

*) When testing larger or smaller lengths, multiply tolerance value accordingly with the relevant factor.

Die sets ST 35..

with stripper plate



Rectangular working area
2 or 4 pillars

Material: 1.0570 (St 52.3), Aluminium on request

The plates are cleanly flame cut and normalized. Upon request edges finished. Please state expressly on your order.

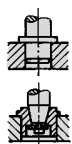
Position of bushings

Normally the positions of bushings will be as shown. If different positions are required please indicate on your order.

DIN 9868

Different Guide pillars length on request

Lifting devices see under accessories

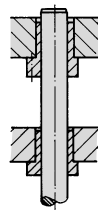


Sliding guide

hardened steel bushing, bronze-plated with flange ST 7429

Upper plate: Guide bushings medium or long version according to combination of plates

Stripper plate: Guide bushings short version



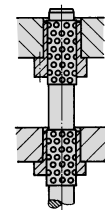
Ball guide

Guide bushings with flange ST 7422

Upper plate: Guide bushings medium or long version according to combination of plates

Stripper plate: Guide bushings short version

Cage travel = 1/2 length of stroke



Removable pillars upon request

ST 7120
ST 7181/82

Add size and combination of plates to order number



Order no. **ST 3579.**

Order no. **ST 3572.**

x



Order no. **ST 3589.**

Order no. **ST 3582.**

x



Order no. **ST 3599.**

Order no. **ST 3592.**

x

Die sets ST 35..



with stripper plate

Order example: Die sets with stripper plate and 4 guide pillars, with ball guide

ST 3592

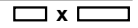
Size a x b = 500 x 500

c₁ = 50, c₂ = 50

Add **500 x 500.1**

Order number **ST 3592. 500 x 500.1**

Add size and combination of plates to order number



a x b	a ₁	b ₁	c ₁ ^{+0.5} _{-0.2}	c ₂ ^{+0.5} _{-0.2}	c ₃ ^{+0.5} _{-0.2}	c ₆	c ₇	k	e ₁	e ₂	e ₄	ST 7100. d ₁ /d ₂ x l	▲
160 x 80	60	-	32	32	25	15	15	18	100	-	-	19/20 x 180	160 x 080
160 x 100	60	-	32	32	25	15	15	18	100	-	-	19/20 x 180	160 x 100
160 x 125	60	-	32	32	25	15	15	18	100	-	-	19/20 x 180	160 x 125
160 x 160	60	60	32	32	25	15	15	18	100	100	103	19/20 x 180	160 x 160
200 x 100	70	-	40	40	25	25	15	23	120	-	-	24/25 x 200	200 x 100.1
			32	40									200 x 100.2
			40	32									200 x 100.3
			32	32									200 x 100.4
200 x 125	70	-	40	40	25	25	15	23	120	-	-	24/25 x 200	200 x 125.1
			32	40									200 x 125.2
			40	32									200 x 125.3
			32	32									200 x 125.4
200 x 160	70	-	40	40	25	25	15	23	120	-	-	24/25 x 200	200 x 160.1
			32	40									200 x 160.2
			40	32									200 x 160.3
			32	32									200 x 160.4
200 x 200	70	70	40	40	25	25	15	23	120	120	123	24/25 x 200	200 x 200.1
			32	40									200 x 200.2
			40	32									200 x 200.3
			32	32									200 x 200.4
250 x 125	120	-	40	40	25	25	15	23	170	-	-	24/25 x 200	250 x 125.1
			32	40									250 x 125.2
			40	32									250 x 125.3
			32	32									250 x 125.4
250 x 160	120	-	40	40	25	25	15	23	170	-	-	24/25 x 200	250 x 160.1
			32	40									250 x 160.2
			40	32									250 x 160.3
			32	32									250 x 160.4
250 x 200	120	70	40	40	25	25	15	23	170	120	173	24/25 x 200	250 x 200.1
			32	40									250 x 200.2
			40	32									250 x 200.3
			32	32									250 x 200.4
250 x 250	120	120	40	40	25	25	15	23	170	170	173	24/25 x 200	250 x 250.1
			32	40									250 x 250.2
			40	32									250 x 250.3
			32	32									250 x 250.4
315 x 160	165	-	50	50	32	25	15	28	225	-	-	30/32 x 224	315 x 160.1
			40	50									315 x 160.2
			50	40									315 x 160.3
			40	40									315 x 160.4
315 x 200	165	50	50	50	32	25	15	28	225	110	228	30/32 x 224	315 x 200.1
			40	50									315 x 200.2
			50	40									315 x 200.3
			40	40									315 x 200.4
315 x 250	165	100	50	50	32	25	15	28	225	160	228	30/32 x 224	315 x 250.1
			40	50									315 x 250.2
			50	40									315 x 250.3
			40	40									315 x 250.4
315 x 315	165	165	50	50	32	25	15	28	225	225	228	30/32 x 224	315 x 315.1
			40	50									315 x 315.2
			50	40									315 x 315.3
			40	40									315 x 315.4
400 x 200	250	50	50	50	32	25	15	28	310	110	313	30/32 x 224	400 x 200.1
			40	50									400 x 200.2
			50	40									400 x 200.3
			40	40									400 x 200.4
400 x 250	250	100	50	50	32	25	15	28	310	160	313	30/32 x 224	400 x 250.1
			40	50									400 x 250.2
			50	40									400 x 250.3
			40	40									400 x 250.4

Die sets ST 35..

with stripper plate



Order example: Die sets with stripper plate and 4 guide pillars, with ball guide

ST 3592

Size a x b = 500 x 500

c₁ = 50, c₂ = 50

Add **500 x 500.1**

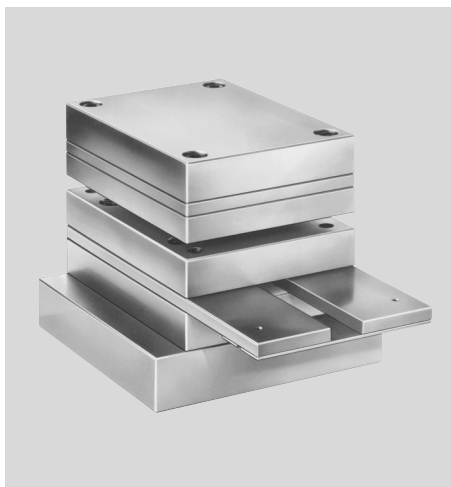
Order number **ST 3592. 500 x 500.1**

Add size and combination of plates to order number

x

a	x b	a ₁	b ₁	c ₁ +0.5 +0.2	c ₂ +0.5 +0.2	c ₃ +0.5 +0.2	c ₆	c ₇	k	e ₁	e ₂	e ₄	ST 7100. d ₁ /d ₂ x l	▲
400 x 315	250	165	50	50	32	25	15	28	310	225	313	30/32 x 224	400 x 315.1	
			40	50									400 x 315.2	
			50	40										400 x 315.3
			40	40										400 x 315.4
400 x 400	250	250	50	50	32	25	15	28	310	310	313	30/32 x 224	400 x 400.1	
			40	50										400 x 400.2
			50	40										400 x 400.3
			40	40										400 x 400.4
500 x 250	330	80	50	50	32	30	25	33	400	150	403	38/40 x 224	500 x 250.1	
			40	50										500 x 250.2
			50	40										500 x 250.3
			40	40										500 x 250.4
500 x 315	330	145	50	50	32	30	25	33	400	215	403	38/40 x 224	500 x 315.1	
			40	50										500 x 315.2
			50	40										500 x 315.3
			40	40										500 x 315.4
500 x 400	330	230	50	50	32	30	25	33	400	300	403	38/40 x 224	500 x 400.1	
			40	50										500 x 400.2
			50	40										500 x 400.3
			40	40										500 x 400.4
500 x 500	330	330	50	50	32	30	25	33	400	400	403	38/40 x 224	500 x 500.1	
			40	50										500 x 500.2
			50	40										500 x 500.3
			40	40										500 x 500.4
630 x 315	430	115	63	63	40	42	25	38	510	195	513	48/50 x 280	630 x 315.1	
			50	63										630 x 315.2
			63	50										630 x 315.3
			50	50										630 x 315.4
630 x 400	430	200	63	63	40	42	25	38	510	280	513	48/50 x 280	630 x 400.1	
			50	63										630 x 400.2
			63	50										630 x 400.3
			50	50										630 x 400.4
630 x 500	430	300	63	63	40	42	25	38	510	380	513	48/50 x 280	630 x 500.1	
			50	63										630 x 500.2
			63	50										630 x 500.3
			50	50										630 x 500.4
630 x 630	430	430	63	63	40	42	25	38	510	510	513	48/50 x 280	630 x 630.1	
			50	63										630 x 630.2
			63	50										630 x 630.3
			50	50										630 x 630.4
710 x 400	510	200	63	63	40	42	25	38	590	280	593	48/50 x 280	710 x 400.1	
			50	63										710 x 400.2
			63	50										710 x 400.3
			50	50										710 x 400.4
710 x 500	510	300	63	63	40	42	25	38	590	380	593	48/50 x 280	710 x 500.1	
			50	63										710 x 500.2
			63	50										710 x 500.3
			50	50										710 x 500.4
710 x 630	510	430	63	63	40	42	25	38	590	510	593	48/50 x 280	710 x 630.1	
			50	63										710 x 630.2
			63	50										710 x 630.3
			50	50										710 x 630.4
800 x 400	600	200	63	63	40	42	25	38	680	280	683	48/50 x 280	800 x 400.1	
			50	63										800 x 400.2
			63	50										800 x 400.3
			50	50										800 x 400.4
800 x 500	600	300	63	63	40	42	25	38	680	380	683	48/50 x 280	800 x 500.1	
			50	63										800 x 500.2
			63	50										800 x 500.3
			50	50										800 x 500.4
800 x 630	600	430	63	63	40	42	25	38	680	510	683	48/50 x 280	800 x 630.1	
			50	63										800 x 630.2
			63	50										800 x 630.3
			50	50										800 x 630.4

Stamping Block ST 3730



There is still a single tool available for the manufacture of metal parts from strip or coiled material. In order to achieve a simplified tool construction and shorten the delivery-time, it is practical to use prefabricated tooling components. This is the reason that STEINEL NORMALIEN offers stamping blocks in several standard sizes to manufacture simple stamped parts.

The stamping blocks are manufactured to the well known STEINEL precision. All plates are ground with square angles on 4 sides, so they can be used as reference edges.

The set edges, depending on their size, are 50 – 100 mm longer than the die block and are provided with a cross plate.

The punch holder is the same width as the stamping block lower plate, which offers an optimal use of the work area.

The plate dimensions are according to DIN and ISO standards, as stated in our catalogue.

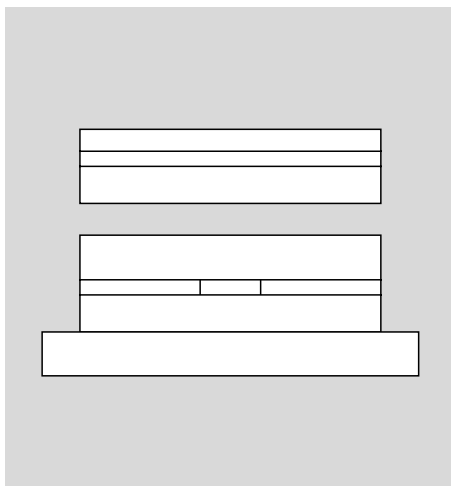
Tip: STEINEL-stamping blocks can also be made to your specifications, such as with radius corner set edges, tapped holes for clamping, etc.

Order example: Stamping block complete **ST 3730**

Stamping block size a x b = 196 x 96

Add **196 x 096**

Order number **ST 3730.196 x 096**



Ground parallel:

Plate length until 250 mm ± 0,015 mm
Plate length until 400 mm ± 0,025 mm

Tolerances:

Plate size – 0,2 mm
Plate thickness – 0,2 mm

Screws in die block:

until 246 mm length = 4 screws
from 311 mm length = 6 screws

Screws in punch holder:

until 246 mm length, 1-piece punch back-up plate = 4 screws
from 311 mm length, 1-piece punch back-up plate = 8 screws
from 396 mm length, 2-piece punch back-up plate = 8 screws

a	b						
	076	096	121	156	196	246	311
096	x	x					
156	x	x	x	x			
196		x	x	x	x		
246		x	x	x	x	x	
311				x	x	x	x
396							x

Material

Punch holder

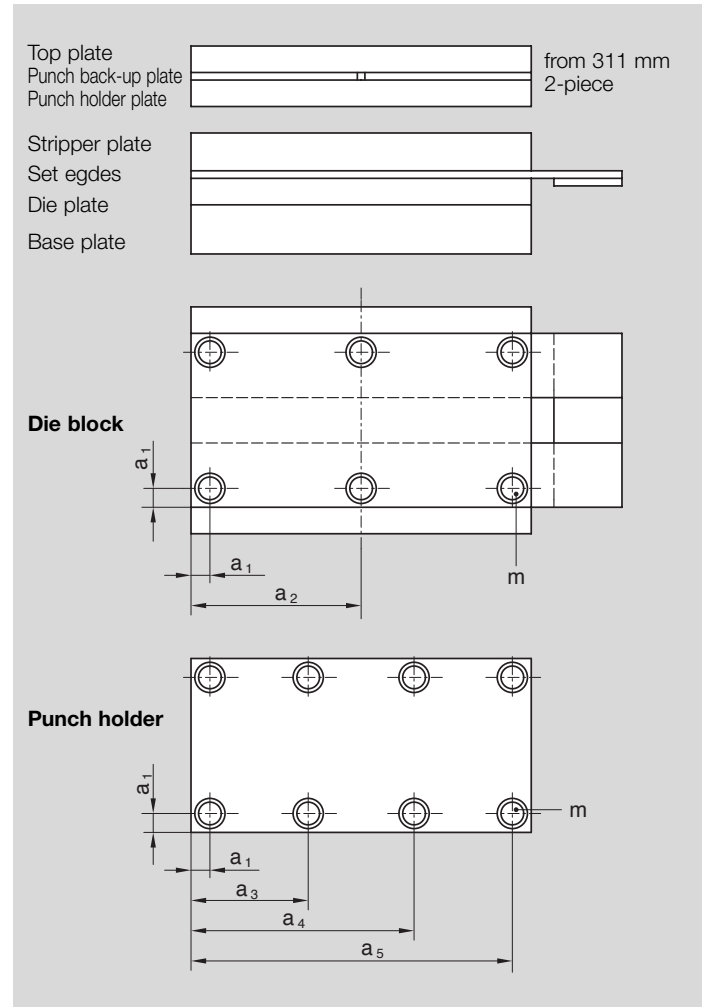
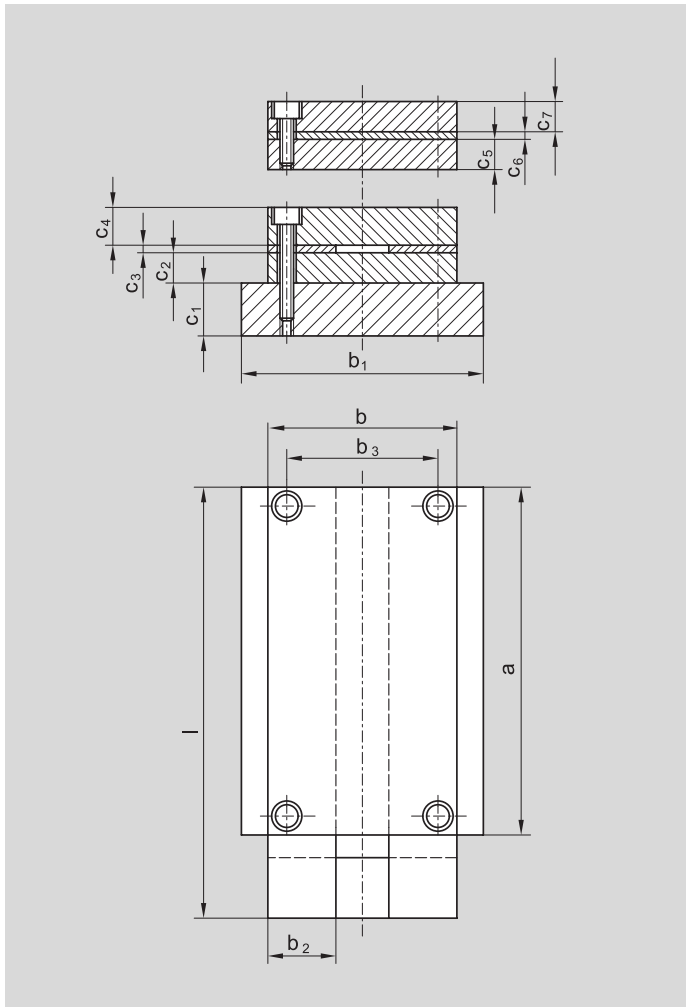
Material number

Top plate	1.1730
Punch back-up plate	1.2379
Punch holder plate	1.1730

Die block

Stripper plate	1.1730
Set edges	1.1730
Die plate	1.2379
Base plate	1.1730

Stamping Block ST 3730



Add size to order number

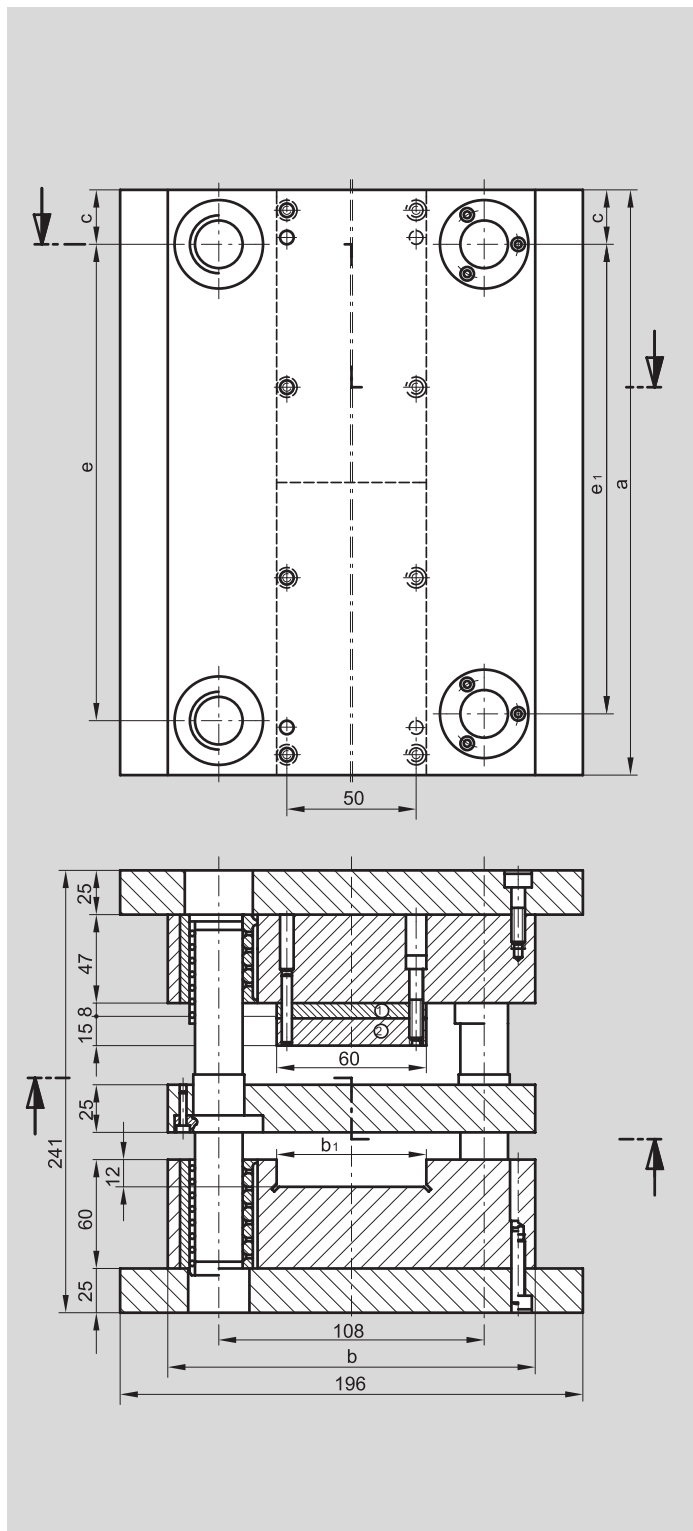
Order number **ST 3730.** x

a x b	b ₁	b ₂	b ₃	l	C ₁	C ₂	C ₃	C ₄	C ₅	C ₆	C ₇	a ₁	a ₂	a ₃	a ₄	a ₅	m	▲
96 x 76	121	30	41	150	25	23	6	23	18	6	18	12				84	M8	096 x 076
156 x 76				240												144		156 x 076
96 x 96	156	40	61	150	25	23	6	23	18	6	18	12				84	M8	096 x 096
156 x 96				240												144		156 x 096
196 x 96				300												184		196 x 096
246 x 96				350												234		246 x 096
156 x 121	156	50	86	240	32	27	8	28	18	8	28	12				144	M8	156 x 121
196 x 121				300												184		196 x 121
246 x 121				350												234		246 x 121
156 x 156	196	70	111	240	32	27	8	28	18	8	28	16				140	M10	156 x 156
196 x 156				300												180		196 x 156
246 x 156				350												230		246 x 156
311 x 156				415												295		311 x 156
196 x 196	246	70	151	300	40	33	10	28	28	10	28	16				180	M10	196 x 196
246 x 196				350												230		246 x 196
311 x 196				415												295		311 x 196
246 x 246	311	80	201	350	40	38	10	38	28	10	28	16				230	M10	246 x 246
311 x 246				415												295		311 x 246
311 x 311	396	100	251	415	40	38	10	38	28	10	28	22	155,5	111	200	289	M12	311 x 311
396 x 311				500									198	139	257	374		396 x 311

Die sets **ST 3712, ST 3719**



for progressive and compound tools



Progressive and compound tools size: 1

Materials: plates ① and ② 1.2842 (90 Mn Cr V 8). All other plates 1.0570 (St 52-3).

Soft pressure plate: upon request can also be delivered hardened. (Please indicate on your order. "With hardened pressure plate").

For segmentation: Precision steel plate on request.

Tip: Steinel also delivers special design column mounts to fit your requirements. The plate sizes correspond to DIN/ISO standards, as they are listed in our catalog.

The column mounts are constructed according to the mechanical assembly technique and are guaranteed to offer an economical application to our clients.

You can use our bearing mounting spring units as your spring system. You have the choice among four different load bearing types (SZ 8565).

These columns can be weighted more than standard columns by a factor of eight since the central mounting of the columns in the guide plate reduces the length of the stress application point by half in the upper and lower part of the tool.

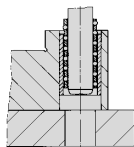
Sliding guides: can be connected with central lubrication (M 8 x 1).

Order example: Column mount for progressive and compound tools with bronze plated steel sliding guide **ST 3719**.

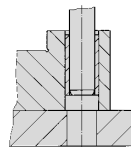
Mount size a x b = 246 x 156

Add **246 x 156**

Order number **ST 3719.246 x 156**



Ball guide
retainer length
= 1/2 length of stroke



Sliding guide
hardened
bronze plated
steel bushing

Add
size to
order number

Order number **ST 3712**

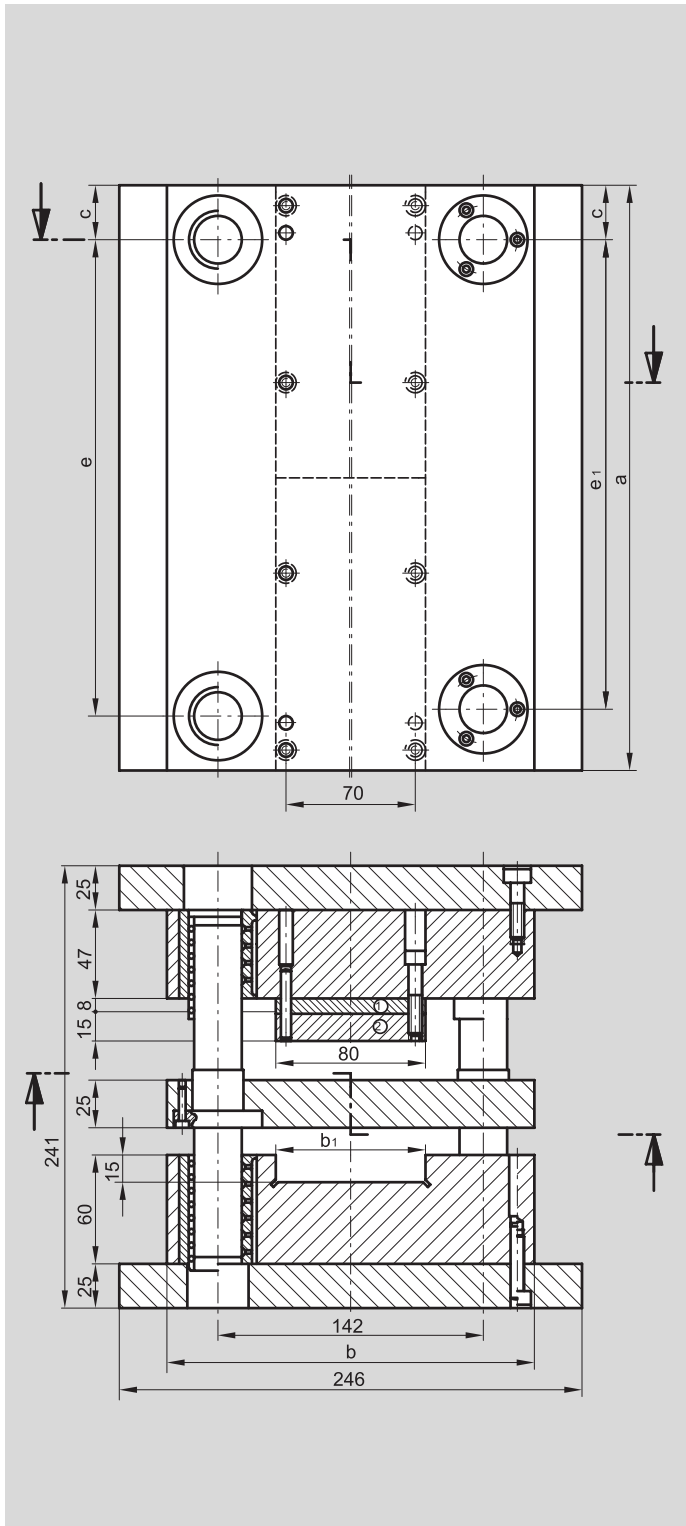
Order number **ST 3719**

x

Outside Dimensions a x b	Slot width b ₁	c	e	e ₁	Pillars ST 7117. d ₁ x l	▲ order number
196 x 156	60	24	148	145	19 x 180	196 x 156
246 x 156	60	24	198	195	19 x 180	246 x 156
311 x 156	60	24	263	260	19 x 180	311 x 156

Die sets ST 3712, ST 3719

for progressive and compound tools



Progressive and compound tools size: 2

Materials: plates ① and ② 1.2842 (90 Mn Cr V 8). All other plates 1.0570 (St 52-3).

Soft pressure plate: upon request can also be delivered hardened. (Please indicate on your order. "With hardened pressure plate").

For segmentation: Precision steel plate on request.

Tip: Steinel also delivers special design column mounts to fit your requirements. The plate sizes correspond to DIN/ISO standards, as they are listed in our catalog.

The column mounts are constructed according to the mechanical assembly technique and are guaranteed to offer an economical application to our clients.

You can use our bearing mounting spring units as your spring system. You have the choice among four different load bearing types (SZ 8565).

These columns can be weighted more than standard columns by a factor of eight since the central mounting of the columns in the guide plate reduces the length of the stress application point by half in the upper and lower part of the tool.

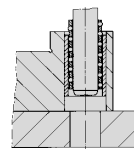
Sliding guides: can be connected with central lubrication (M 8 x 1).

Order example: Column mount for progressive and compound tools with bronze plated steel sliding guide **ST 3719**.

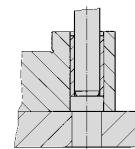
Mount size a x b = 311 x 196

Add **311 x 196**

Order number **ST 3719.311 x 196**



Ball guide
retainer length
= 1/2 length of stroke



Sliding guide
hardened
bronze plated
steel bushing

Add
size to
order number

Order number **ST 3712**

Order number **ST 3719**

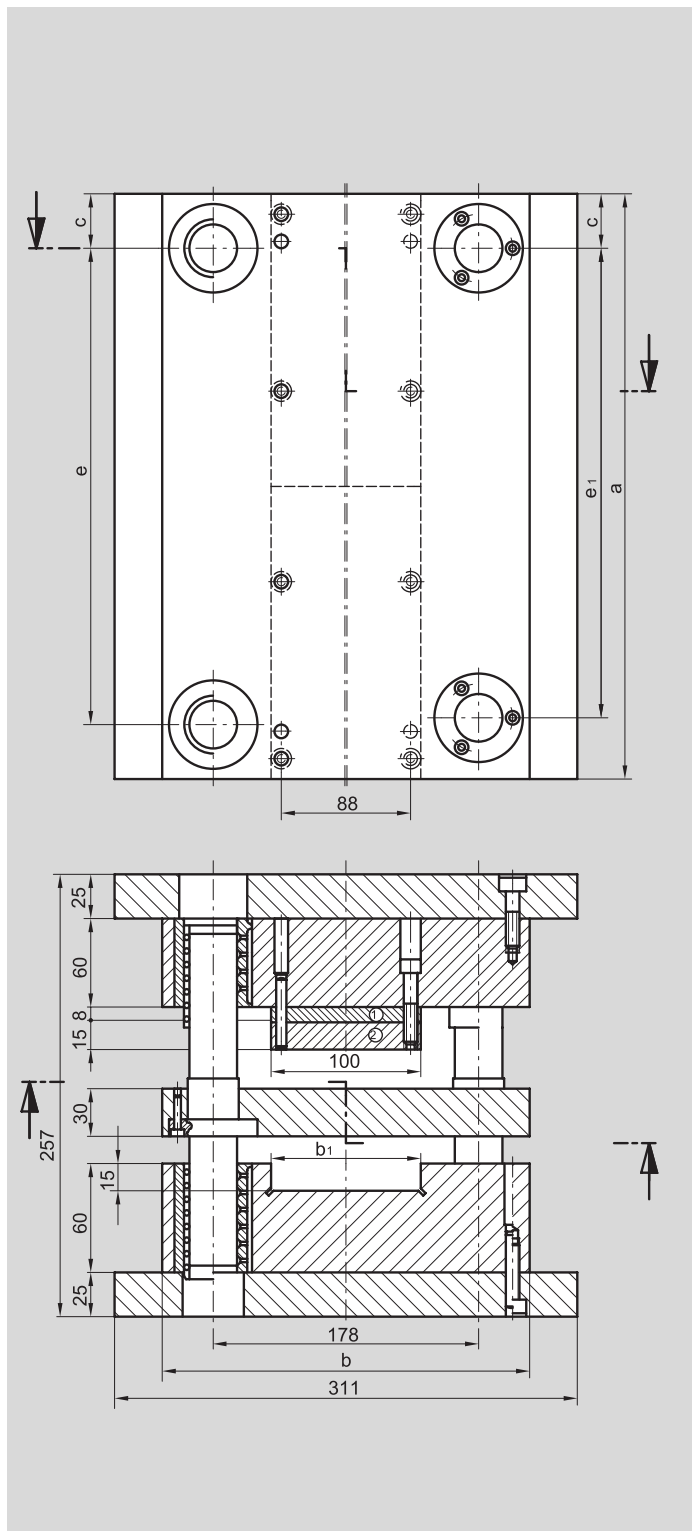
x

Outside Dimensions a x b	Slot width b ₁	c	e	e ₁	Pillars ST 7117. d ₁ x l	▲
246 x 196	80	27	192	189	25 x 180	246 x 196
311 x 196	80	27	257	254	25 x 180	311 x 196
396 x 196	80	27	342	339	25 x 180	396 x 196

Die sets **ST 3712, ST 3719**



for progressive and compound tools



Progressive and compound tools size: 3

Materials: plates ① and ② 1.2842 (90 Mn Cr V 8). All other plates 1.0570 (St 52-3).

Soft pressure plate: upon request can also be delivered hardened. (Please indicate on your order. "With hardened pressure plate").

For segmentation: Precision steel plate on request.

Tip: Steinel also delivers special design column mounts to fit your requirements. The plate sizes correspond to DIN/ISO standards, as they are listed in our catalog.

The column mounts are constructed according to the mechanical assembly technique and are guaranteed to offer an economical application to our clients.

You can use our bearing mounting spring units as your spring system. You have the choice among four different load bearing types (SZ 8565).

These columns can be weighted more than standard columns by a factor of eight since the central mounting of the columns in the guide plate reduces the length of the stress application point by half in the upper and lower part of the tool.

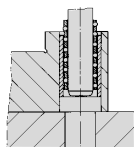
Sliding guides: can be connected with central lubrication (M 8 x 1).

Order example: Column mount for progressive and compound tools with bronze plated steel sliding guide **ST 3719**.

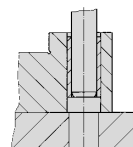
Mount size a x b = 311 x 246

Add **311 x 246**

Order number **ST 3719.311 x 246**



Ball bearing
retainer length
= 1/2 length of stroke



Sliding guide
hardened
bronze plated
steel bushing

Add
size to
order number

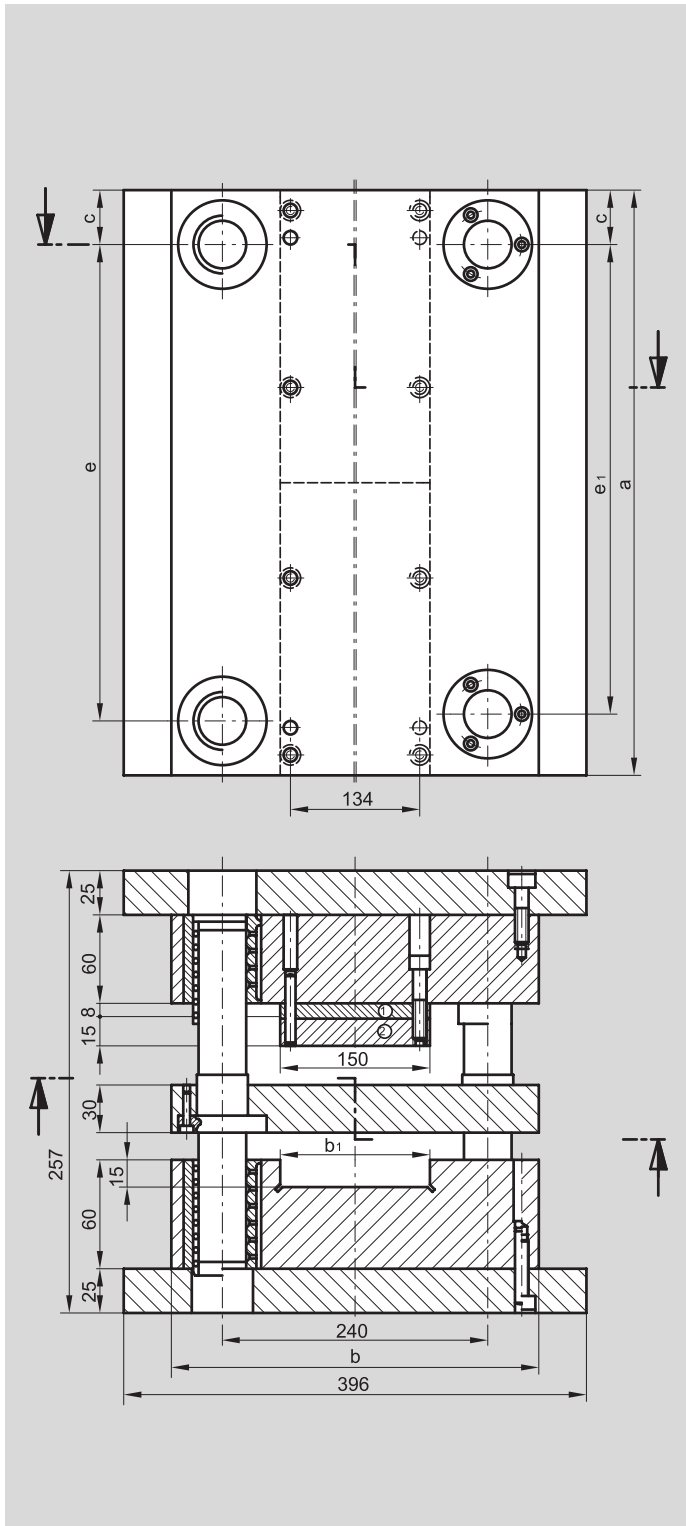
Order number **ST 3712** Order number **ST 3719** x

Outside Dimensions a x b	Slot width b ₁	c	e	e ₁	Pillars ST 7117. d ₁ x l	▲
311 x 246	100	34	243	240	32 x 210	311 x 246
396 x 246	100	34	328	325	32 x 210	396 x 246
496 x 246	100	34	428	425	32 x 210	496 x 246

From length a = 396 mm = 2-piece pressure plate

Die sets **ST 3712 ST 3719**

for progressive and compound tools



Progressive and compound tools size: 4

Materials: plates ① and ② 1.2842 (90 Mn Cr V 8). All other plates 1.0570 (St 52-3).

Soft pressure plate: upon request can also be delivered hardened. (Please indicate on your order. "With hardened pressure plate").

For segmentation: Precision steel plate on request.

Tip: Steinel also delivers special design column mounts to fit your requirements. The plate sizes correspond to DIN/ISO standards, as they are listed in our catalog.

The column mounts are constructed according to the mechanical assembly technique and are guaranteed to offer an economical application to our clients.

You can use our bearing mounting spring units as your spring system. You have the choice among four different load bearing types (SZ 8565).

These columns can be weighted more than standard columns by a factor of eight since the central mounting of the columns in the guide plate reduces the length of the stress application point by half in the upper and lower part of the tool.

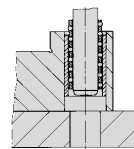
Sliding guides: can be connected with central lubrication (M 8 x 1).

Order example: Column mount for progressive and compound tools with bronze plated steel sliding guide **ST 3719**.

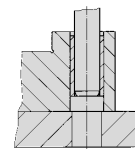
Mount size a x b = 496 x 311

Add **496 x 311**

Order number **ST 3719.496 x 311**



Ball bearing
retainer length
= 1/2 length of stroke



Sliding guide
hardened
bronze plated
steel bushing

Add
size to
order number

Order number **ST 3712**

Order number **ST 3719**

x

Outside Dimensions a x b	Slot width b ₁	c	e	e ₁	Pillars ST 7117. d ₁ x l	▲
396 x 311	150	35	326	323	32 x 210	396 x 311
496 x 311	150	35	426	423	32 x 210	496 x 311
626 x 311	150	35	556	553	32 x 210	626 x 311

From length a = 396 mm = 2-piece pressure plate

Order sheet for



Progressive and compound tools (Die Sets)

Material: Plates ① and ② 1.2842 (90 Mn Cr V 8).
All other plates 1.0570 (ST 52-3).

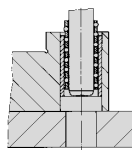
Soft pressure plate, upon request can also be delivered hardened.
(Please indicate on your order: "With hardened pressure plate").

Fill in the required dimensions in the drawing below and mark off which type of guidance.

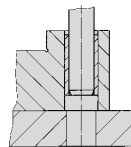
When choosing guide elements/units, please note the catalogue dimensions given in section 3.

As a spring system, our system spring units available from stock can be used. There is a choice of 4 different load types (SZ 8565)

These columns/pillars can be weighted more than standard pillars by a factor of eight, since the central mounting of the pillars in the guide plate reduces the length of the stress application point by half in the upper and lower part of the tool.



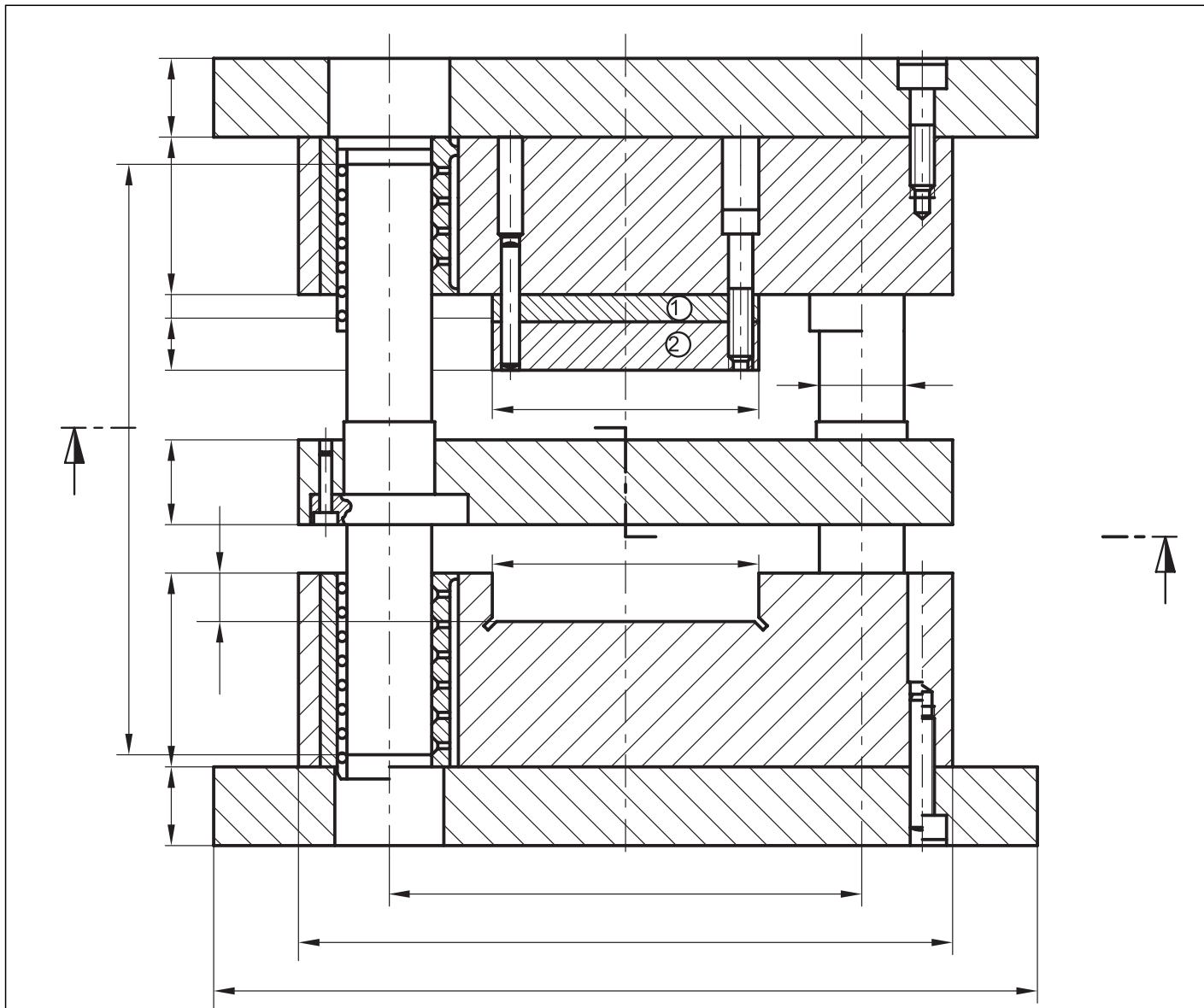
Ball guide
Cage travel
= 1/2 length of stroke



Sliding guide
hardened
steel bushing
bronze-plated

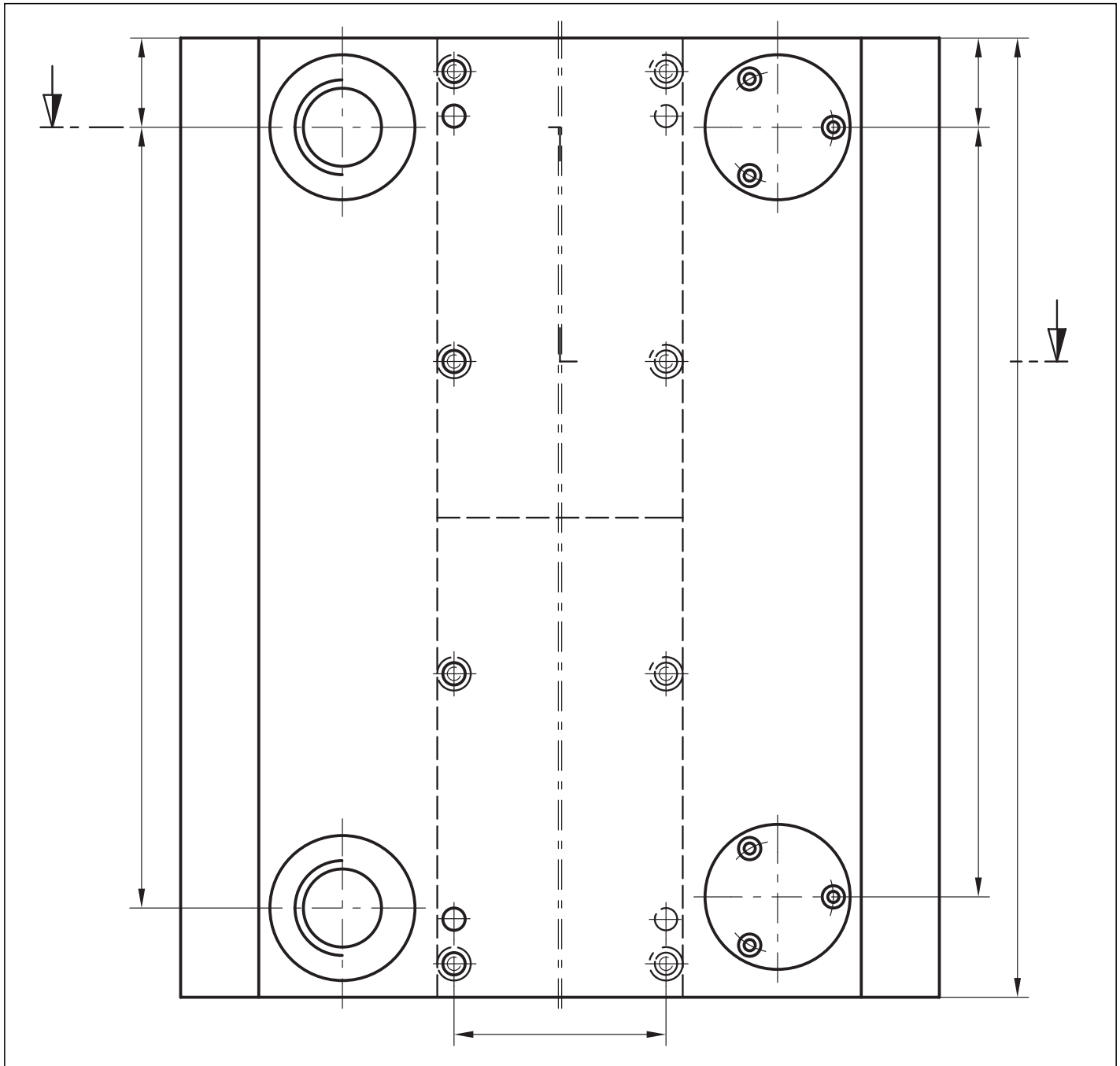


Progressive and compound tools can be supplied in special designs according to your specifications.



Order sheet for

Progressive and compound tools (Die Sets)



Room/Space for messages/information and notes

Company:

Street address:

City, State, Zip Code:

Contact Person:

Telephone Number.:

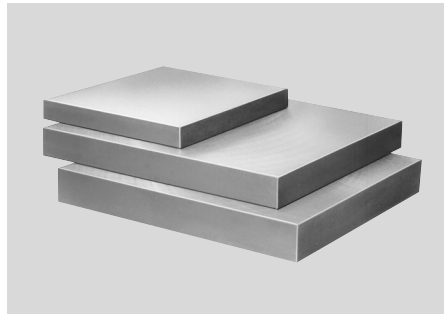
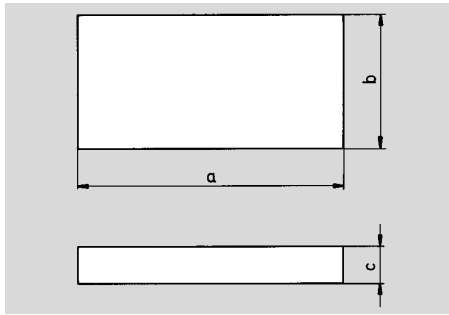
Fax Number.:

Date:

Steel plates ST 3500



for die sets



DIN 9873, ISO 6753

Material: 1.0570 (St. 52.3), other materials for example super heat treated or aluminium 3.4365.71 (Al Zn Mg Cu 1.5) are available upon request. All cleanly flame-cut sizes and normalized, both sides plane-parallel machined to max. 2000 x 800 mm ground. Please state on order.

Larger steel plates can be manufactured short-dated according to your instructions within the max. size of 2000 x 1000 mm and thickness of 20 to 150 mm in each size and form.

Order example: steel plate **ST 3500**

Size a x b x c = 200 x 100 x 32

Add **200 x 100 x 32**

Order number **ST 3500.200 x 100 x 32**

Order number **ST 3500.** x x Add size to order number

a x b	c ^{+0,5} / _{-0,2}	▲
160 x 080	25 32	160 x 080 x 25 160 x 080 x 32
160 x 100	25 32	160 x 100 x 25 160 x 100 x 32
160 x 125	25 32	160 x 125 x 25 160 x 125 x 32
160 x 160	25 32	160 x 160 x 25 160 x 160 x 32
200 x 100	25 32 40	200 x 100 x 25 200 x 100 x 32 200 x 100 x 40
200 x 125	25 32 40	200 x 125 x 25 200 x 125 x 32 200 x 125 x 40
200 x 160	25 32 40	200 x 160 x 25 200 x 160 x 32 200 x 160 x 40
200 x 200	25 32 40	200 x 200 x 25 200 x 200 x 32 200 x 200 x 40
250 x 125	25 32 40	250 x 125 x 25 250 x 125 x 32 250 x 125 x 40
250 x 160	25 32 40	250 x 160 x 25 250 x 160 x 32 250 x 160 x 40
250 x 200	25 32 40	250 x 200 x 25 250 x 200 x 32 250 x 200 x 40
250 x 250	25 32 40	250 x 250 x 25 250 x 250 x 32 250 x 250 x 40

Order number **ST 3500.** x x Add size to order number

a x b	c ^{+0,5} / _{-0,2}	▲
315 x 160	32 40 50	315 x 160 x 32 315 x 160 x 40 315 x 160 x 50
315 x 200	32 40 50	315 x 200 x 32 315 x 200 x 40 315 x 200 x 50
315 x 250	32 40 50	315 x 250 x 32 315 x 250 x 40 315 x 250 x 50
315 x 315	32 40 50	315 x 315 x 32 315 x 315 x 40 315 x 315 x 50
400 x 200	32 40 50	400 x 200 x 32 400 x 200 x 40 400 x 200 x 50
400 x 250	32 40 50	400 x 250 x 32 400 x 250 x 40 400 x 250 x 50
400 x 315	32 40 50	400 x 315 x 32 400 x 315 x 40 400 x 315 x 50
400 x 400	32 40 50	400 x 400 x 32 400 x 400 x 40 400 x 400 x 50
500 x 250	32 40 50	500 x 250 x 32 500 x 250 x 40 500 x 250 x 50
500 x 315	32 40 50	500 x 315 x 32 500 x 315 x 40 500 x 315 x 50
500 x 400	32 40 50	500 x 400 x 32 500 x 400 x 40 500 x 400 x 50

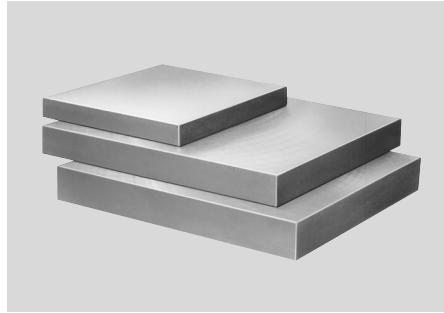
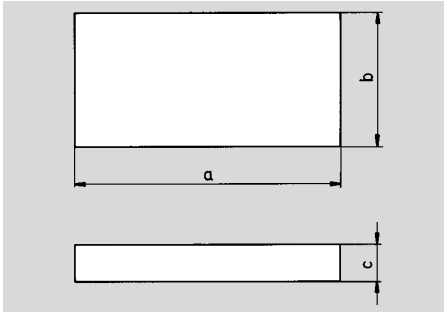
Order number **ST 3500.** x x Add size to order number

a x b	c ^{+0,5} / _{-0,2}	▲
500 x 500	32 40 50	500 x 500 x 32 500 x 500 x 40 500 x 500 x 50
630 x 315	40 50 63	630 x 315 x 40 630 x 315 x 50 630 x 315 x 63
630 x 400	40 50 63	630 x 400 x 40 630 x 400 x 50 630 x 400 x 63
630 x 500	40 50 63	630 x 500 x 40 630 x 500 x 50 630 x 500 x 63
630 x 630	40 50 63	630 x 630 x 40 630 x 630 x 50 630 x 630 x 63
710 x 400	40 50 63	710 x 400 x 40 710 x 400 x 50 710 x 400 x 63
710 x 500	40 50 63	710 x 500 x 40 710 x 500 x 50 710 x 500 x 63
710 x 630	40 50 63	710 x 630 x 40 710 x 630 x 50 710 x 630 x 63
800 x 400	40 50 63	800 x 400 x 40 800 x 400 x 50 800 x 400 x 63
800 x 500	40 50 63	800 x 500 x 40 800 x 500 x 50 800 x 500 x 63
800 x 630	40 50 63	800 x 630 x 40 800 x 630 x 50 800 x 630 x 63

Steel plate ST 3502



Machined type



DIN 9873

Material: 1.0570 (ST 52-3)

The plane parallel plates are uniformly finished, spot-facing is at right angles. Other dimensions or materials are available upon demand.

Tip: These plates are particularly well suited for the inner area of punching tools as well as for die sets.

Order example: Steel plate **ST 3502**

Size a x b x c = 246 x 156 x 32

Add **246 x 156 x 32**

Order number **ST 3502.246 x 156 x 32**

Order number ST 3502.	<input type="checkbox"/> x <input type="checkbox"/> x <input type="checkbox"/>	Add size to order number	
$a^{+0.4} \times b^{+0.4}$	$c^{+0.5}$	▲	
156 x 076	25 32	156 x 076 x 25 156 x 076 x 32	
156 x 096	25 32	156 x 096 x 25 156 x 096 x 32	
156 x 121	25 32	156 x 121 x 25 156 x 121 x 32	
156 x 156	25 32	156 x 156 x 25 156 x 156 x 32	
196 x 096	25 32 40	196 x 096 x 25 196 x 096 x 32 196 x 096 x 40	
196 x 121	25 32 40	196 x 121 x 25 196 x 121 x 32 196 x 121 x 40	
196 x 156	25 32 40	196 x 156 x 25 196 x 156 x 32 196 x 156 x 40	
196 x 196	25 32 40	196 x 196 x 25 196 x 196 x 32 196 x 196 x 40	
246 x 121	25 32 40	246 x 121 x 25 246 x 121 x 32 246 x 121 x 40	
246 x 156	25 32 40	246 x 156 x 25 246 x 156 x 32 246 x 156 x 40	
246 x 196	25 32 40	246 x 196 x 25 246 x 196 x 32 246 x 196 x 40	
246 x 246	25 32 40	246 x 246 x 25 246 x 246 x 32 246 x 246 x 40	

Order number ST 3502.	<input type="checkbox"/> x <input type="checkbox"/> x <input type="checkbox"/>	Add size to order number	
$a^{+0.4} \times b^{+0.4}$	$c^{+0.5}$	▲	
311 x 156	32 40 50	311 x 156 x 32 311 x 156 x 40 311 x 156 x 50	
311 x 196	32 40 50	311 x 196 x 32 311 x 196 x 40 311 x 196 x 50	
311 x 246	32 40 50	311 x 246 x 32 311 x 246 x 40 311 x 246 x 50	
311 x 311	32 40 50	311 x 311 x 32 311 x 311 x 40 311 x 311 x 50	
396 x 196	32 40 50	396 x 196 x 32 396 x 196 x 40 396 x 196 x 50	
396 x 246	32 40 50	396 x 246 x 32 396 x 246 x 40 396 x 246 x 50	
396 x 311	32 40 50	396 x 311 x 32 396 x 311 x 40 396 x 311 x 50	
396 x 396	32 40 50	396 x 396 x 32 396 x 396 x 40 396 x 396 x 50	
496 x 246	32 40 50	496 x 246 x 32 496 x 246 x 40 496 x 246 x 50	
496 x 311	32 40 50	496 x 311 x 32 496 x 311 x 40 496 x 311 x 50	
496 x 396	32 40 50	496 x 396 x 32 496 x 396 x 40 496 x 396 x 50	
496 x 496	32 40 50	496 x 496 x 32 496 x 496 x 40 496 x 496 x 50	

Order number ST 3502.	<input type="checkbox"/> x <input type="checkbox"/> x <input type="checkbox"/>	Add size to order number	
$a^{+0.4} \times b^{+0.4}$	$c^{+0.5}$	▲	
626 x 311	40 50 63	626 x 311 x 40 626 x 311 x 50 626 x 311 x 63	
626 x 396	40 50 63	626 x 396 x 40 626 x 396 x 50 626 x 396 x 63	
626 x 496	40 50 63	626 x 496 x 40 626 x 496 x 50 626 x 496 x 63	
626 x 626	40 50 63	626 x 626 x 40 626 x 626 x 50 626 x 626 x 63	
706 x 396	40 50 63	706 x 396 x 40 706 x 396 x 50 706 x 396 x 63	
706 x 496	40 50 63	706 x 496 x 40 706 x 496 x 50 706 x 496 x 63	
706 x 626	40 50 63	706 x 626 x 40 706 x 626 x 50 706 x 626 x 63	
796 x 396	40 50 63	796 x 396 x 40 796 x 396 x 50 796 x 396 x 63	
796 x 496	40 50 63	796 x 496 x 40 796 x 496 x 50 796 x 496 x 63	
796 x 626	40 50 63	796 x 626 x 40 796 x 626 x 50 796 x 626 x 63	

Die sets made of steel

and aluminium according to drawing

Steinel steel or aluminium columnar frames can be rapidly manufactured according to your specifications or drawings in any desired dimensions or forms within the maximal production limits.

Plate machining

Burned or machine clean on all sides, heated tension-free, polish plano-parallel up to a maximum of:

2000 x 800 mm

Larger plates finally milled up to:

2500 x 1250 mm

Plate thicknesses up to: **20 – 250 mm.**

Further dimensions available on request.

Machining services

Breakthroughs, countersinks, hollowing, drilling patterns, coordinate grinding, eroding etc. can be done according to your specifications or sketches.

