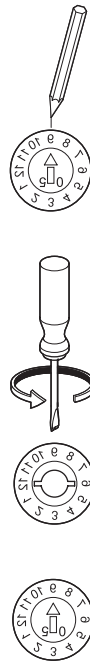


Assembly instruction:

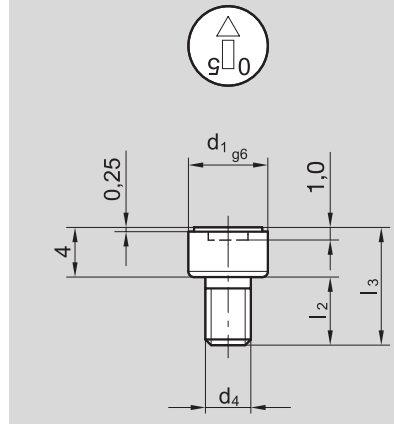
Assemble the embossing stamp and mark the direction of the arrow.

Screw out the inner embossing stamp SZ 6401 and turn the inserts SZ 6402 into the marked position.

Screw the inner embossing stamp SZ 6401 and check the correct position.



Inner embossing stamp SZ 6401



materials: 1.2379
 hardness: 60 HRC

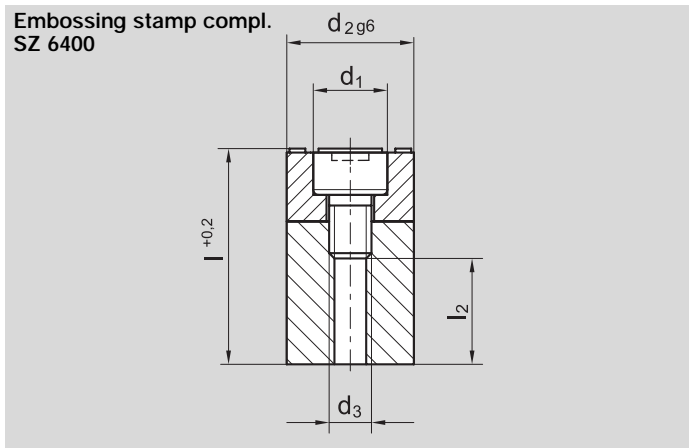
Add size to order number

Order no. **SZ 6401.**

d ₁	l ₂	l ₃	d ₄	▲
3,4	4,5	8,5	M 2,5	06
5,9	5,5	9,5	M 4	10

Please indicate year date in order.

Special gravure on request.



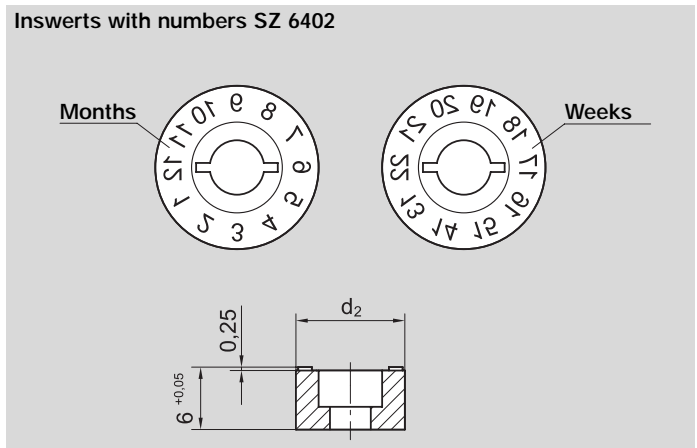
materials: 1.2379
 hardness: 60 HRC

Add size to order number

Bestell-Nr. **SZ 6400.** x

d ₂	l	l ₁	l ₂	l ₄	d ₃	Period Weeks	Period Weeks	▲
6	15	9	6	5,0	M 3	-	1 - 12	06 x 12
6	15	9	6	5,0	M 3	1 - 52	-	06 x 52
10	18	12	8	6,5	M 4	-	1 - 12	10 x 12
10	18	12	8	6,5	M 4	1 - 52	-	10 x 52

Period Months = 1 insert with numbers
 Period Weeks = 5 inserts with numbers



materials: 1.2379
 hardness: 60 HRC

Add size to order number

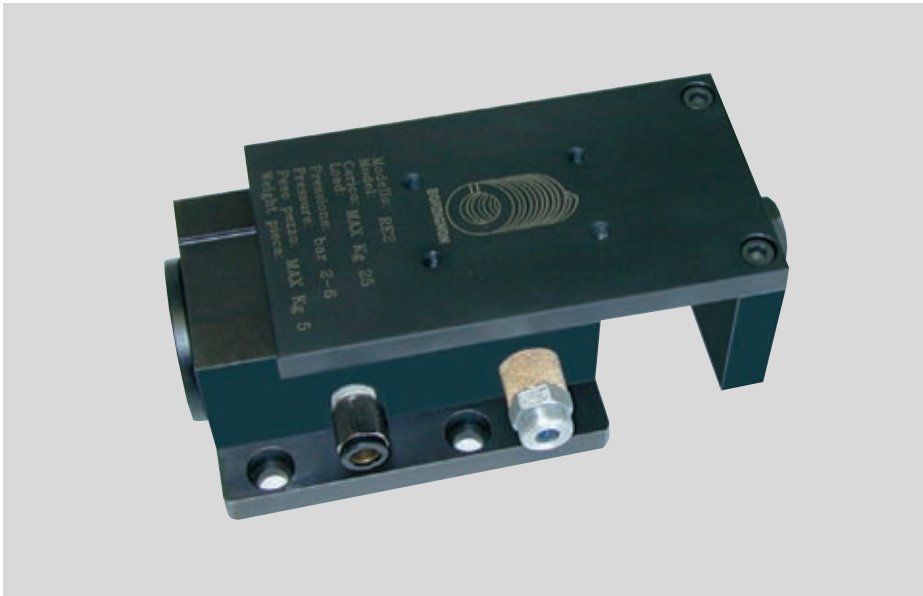
Bestell-Nr. **SZ 6402.** x

d ₂	Period Weeks	Period Weeks	▲
6	-	1 - 12	06 x 12
6	1 - 52	-	06 x 52
10	-	1 - 12	10 x 12
10	1 - 52	-	10 x 52

Period Months = 1 insert with numbers
 Period Weeks = 5 inserts with numbers

Scrap Transporter SZ 8800

Pneumatic



Application:

The pneumatic scrap transporter is used to transport parts and dispose of scraps. The stamped parts and scraps are transported by vibration out of the tool. The transfer tray is adjusted and screwed on to serve as the parts transporter.

Transfer trays can be made according to your drawings. Price and delivery upon request.

Special Features:

- Low air consumption
- Maintenance-free
- Noiseless
- Low production costs

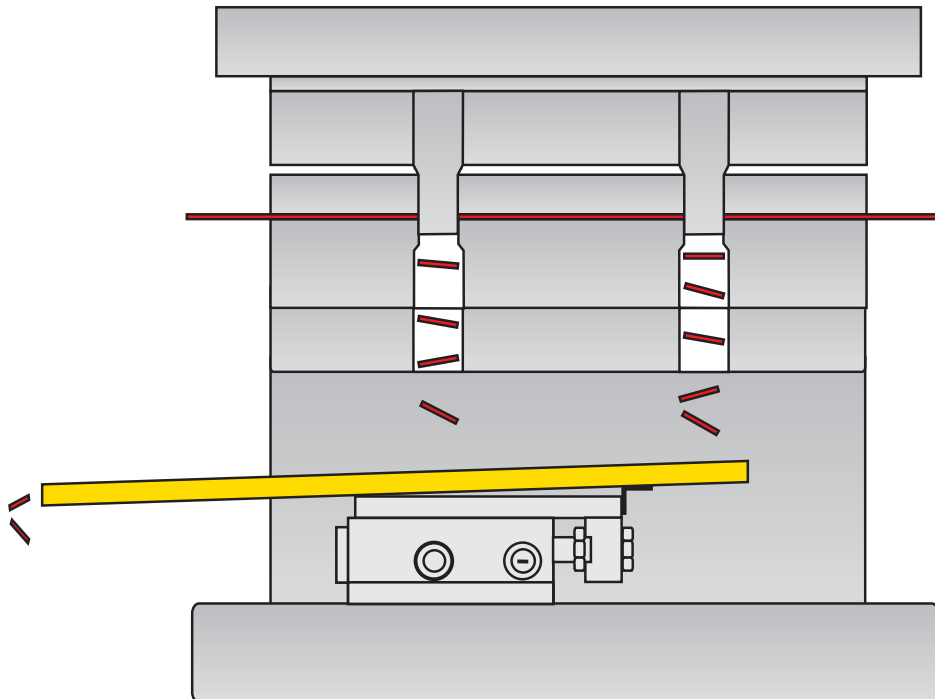
Order example: Scrap transporter **SZ 8800**

For a load size of 25 kp = Typ 2

Add **02**

Order number: **SZ 8800.02**

Example of use



Low air consumption

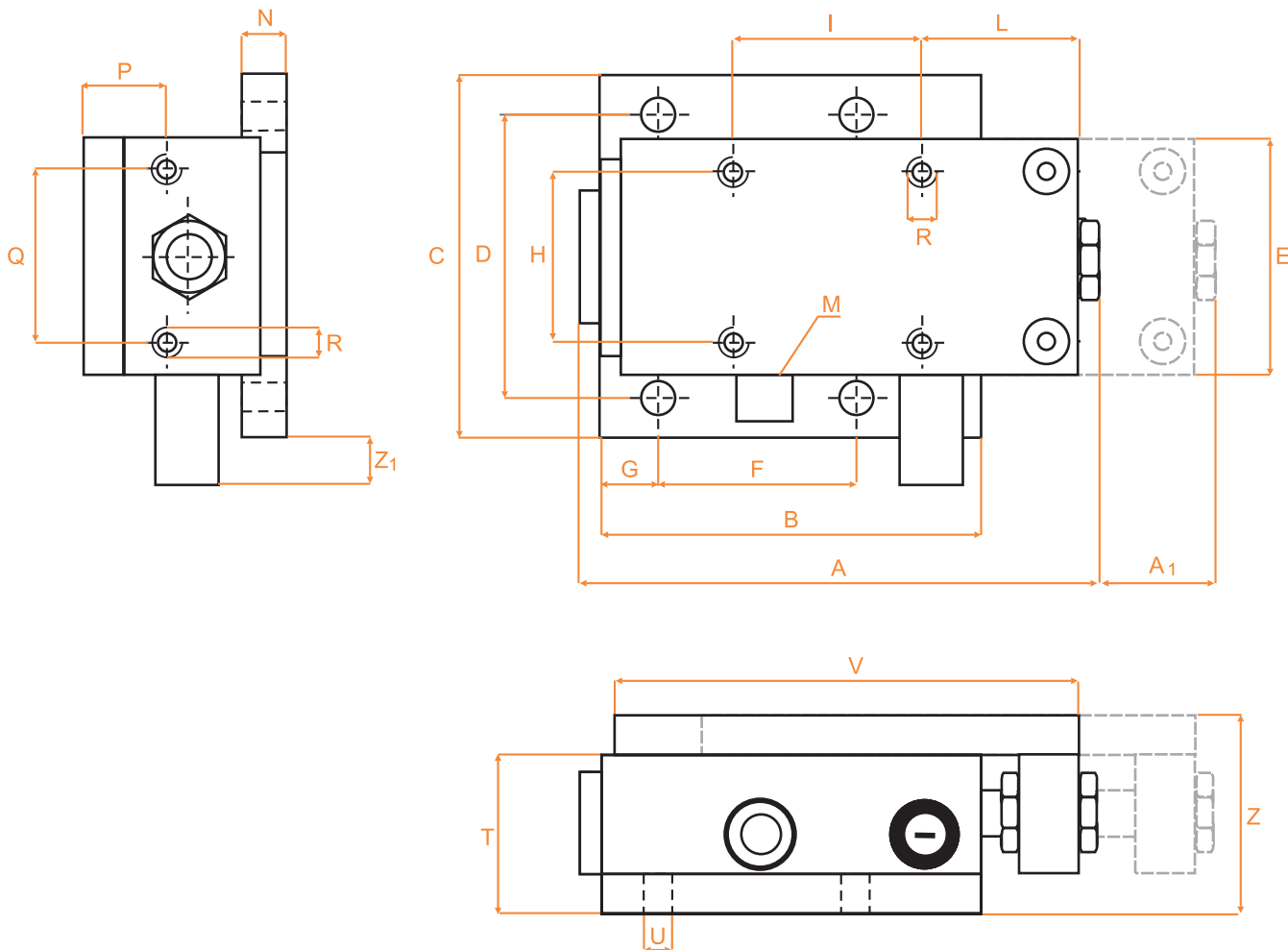
High load capacity

Model	Type	Working pressure (bar)	Max. piston stroke (m/min.)	Min. mounting inclination	Max. load (kg)
SZ 8800.01	Air	2/6	25	5°	10
SZ 8800.02			25		25
SZ 8800.03			25		50
SZ 8800.04			25		80

Scrap Transporter SZ 8800



Technical Data



Add size to Order number

Scrap Transporter

Order number **SZ 8800.**

A	A ₁	B	C	D	E	F	G	H	I	L	M	N	P	Q	R	T	U	V	Z	Z ₁	▲
131	30	95	90	70	60	49	14	25	40	40	1/8"	10	20	40	M6	36	9	120	48	15	01
158	29	118	100	82	70	60	15	30	50	50	1/4"	12	25	50	M6	53	9	145	65	15	02
158	33	118	122	104	90	60	15	40	60	60	1/4"	14	25	75	M6	76	9	145	88	18	03
169	34	130	150	130	110	65	20	50	70	70	3/8"	18	30	80	M6	94	11	157	107	22	04

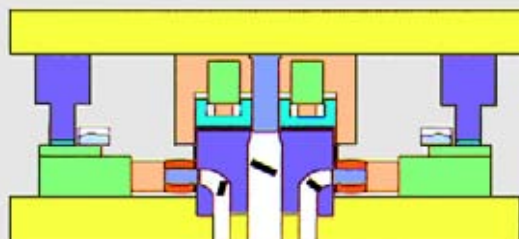
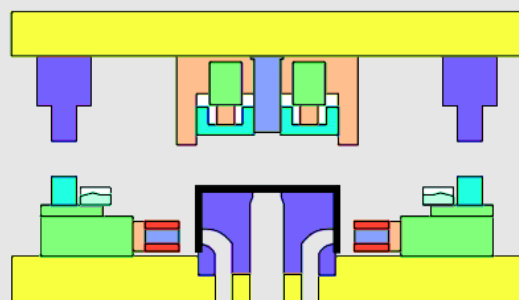
Transfer trays are available in several versions according to your specifications upon request.

JOLLYCAM[®]

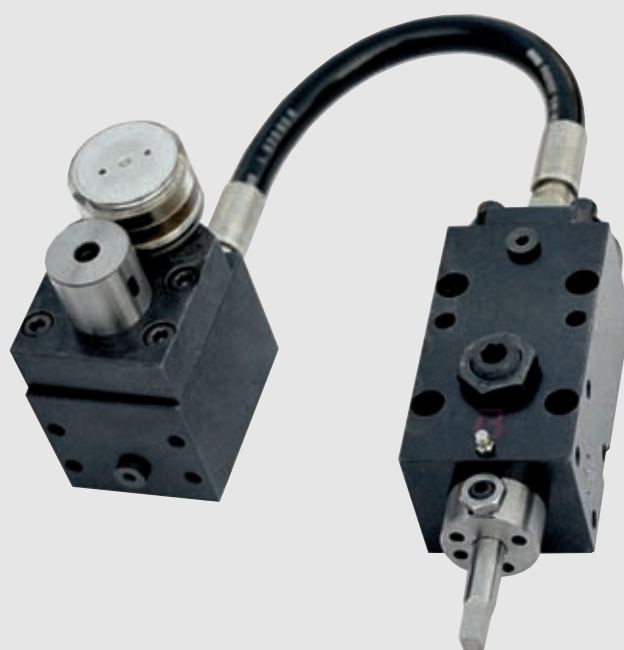
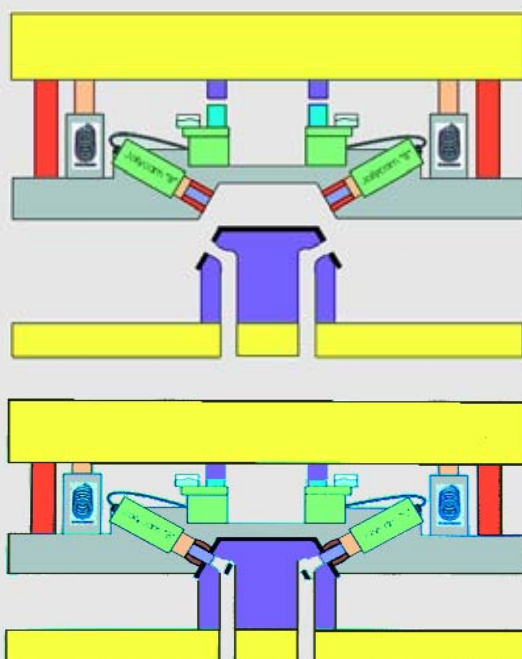
Combination Hydraulic Slide

(registered patent)

Type A



Type B



JOLLYCAM[®]

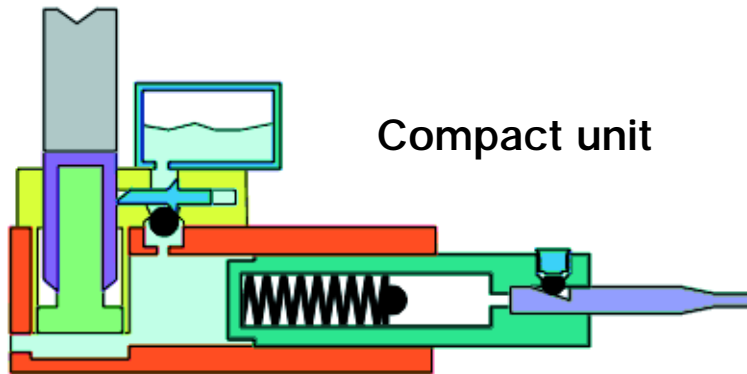
Functional structure

STEINEL[®]
NORMALIEN

Type A sz 8600

Combination Hydraulic Slide

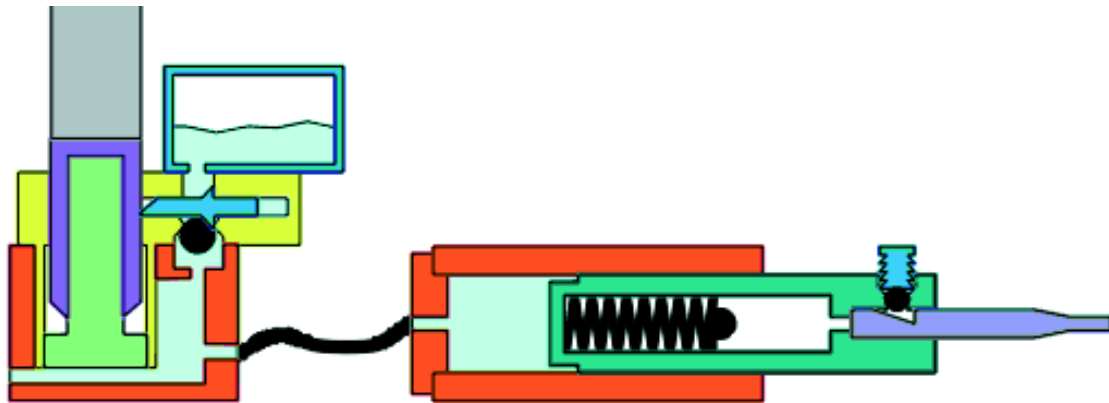
This compact unit is used where lateral perforation, punching and similar operations are necessary. The slide operates in the final phase of the downward movement and the initial phase of the upward movement of the tool. Slide retraction is realised by a built-in helical compression spring. Slide movement is horizontal.



Type B sz 8610

Pressure Cylinder with External Slide

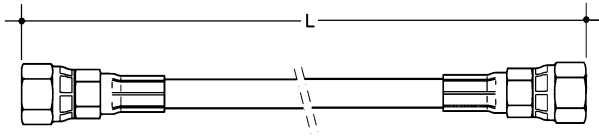
The pressure cylinder is utilised to actuate the freely-positionable slide. The slides are connected to the pressure cylinder by a pressure hose line and can thus be fitted in any position or angle on the tool.



Caution: Type B is supplied in an assembled state (pump + hose + slide), completely screwed together and aerated.

Please do not remove the hose, as air will otherwise penetrate the oil circuit and the functionality of the unit can no longer be ensured.

Dismantling necessary for repairs is not easy and should only be carried out by skilled personnel. Repairs can be carried out at our facility.



Hoses for Type B

Hose	DA
1/4"	13,2
3/8"	17,2

Please give the hose length for Type B as well when ordering.

Table of forces

SZ 8600	Stroke mm	Force ① tonne	Retraction force ② daN	
			Helical spring	
			Initial force	Final force
060 x 015 060 x 025	15 25	1,5	40	80
070 x 015 070 x 025	15 25	3	75	150
080 x 015 080 x 025	15 25	5	125	250
100 x 025 100 x 050	25 50	7	150	350
110 x 025 110 x 050	25 50	10	200	500
SZ 8610				
060 x 015 060 x 025	15 25	1,5	40	80
070 x 015 070 x 025	15 25	3	75	150
080 x 015 080 x 025	15 25	5	125	250
100 x 025 100 x 050	25 50	7	150	350
110 x 025 110 x 050	25 50	10	200	500

Remark:

- ① The forces specified apply at a pressure of approx. 250 bar.
- ② The retraction springs cannot be used for stripping.
Always use an urethane or rubber stripper for this purpose.

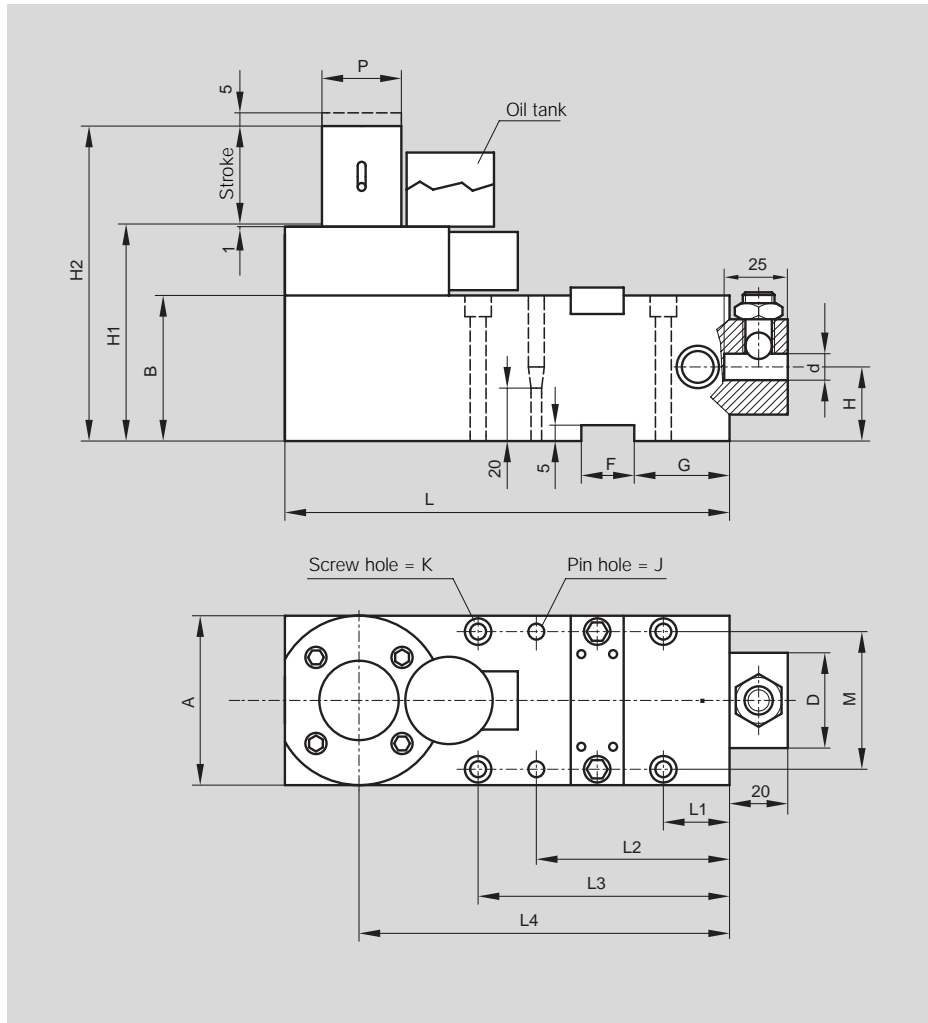
**The compact unit and slide can be supplied with a gas retraction spring for greater retraction forces.
(Price and delivery date available on request)**

Maximum working temperature: 70 °C
Maximum stroke speed: 10 m/min.

JOLLYCAM® SZ 8600



Type A Compact Unit



Combination Hydraulic Slide

Function:

The slide operates in the final phase of the downward movement and the initial phase of the upward movement of the tool.

Tool stroke = Slide stroke

Slide retraction: helical compression spring

Application:

Bending, embossing, beading, trimming, perforation, etc.

Price and delivery date available on request.

Order example: Type 1A SZ 8600

combination hydraulic slide with a width of A = 80 mm

and stroke of 25 mm

Add: **080 x 025**

Order number **SZ 8600.080 x 025**

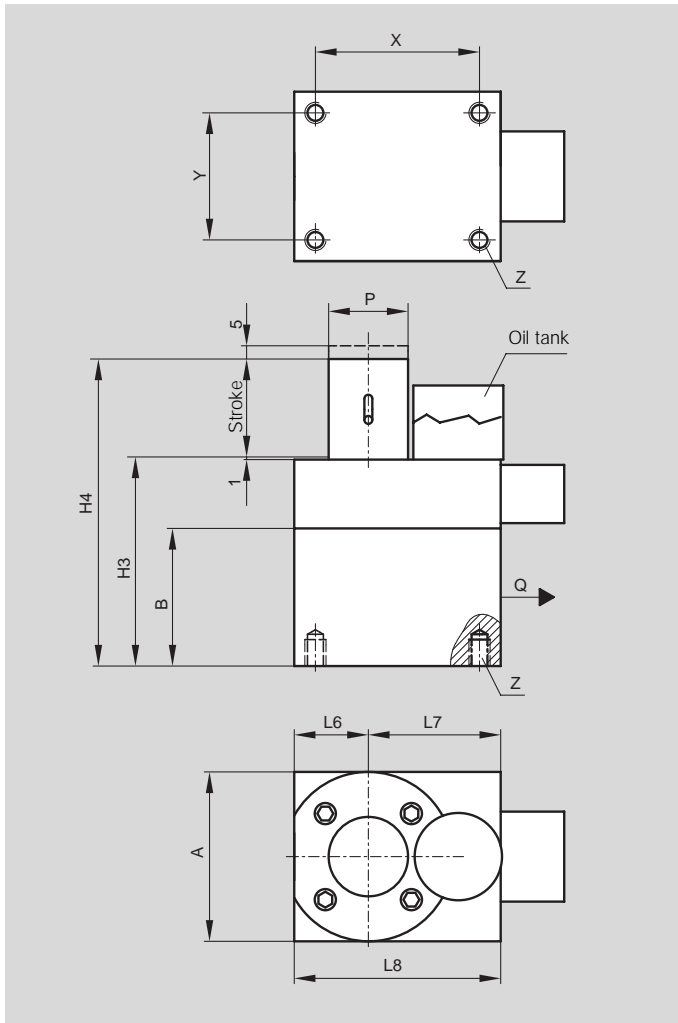
Add size to order number

Order no. **SZ 8600** x

A	Stroke	B	d	D	F	G	H=0.02	H1	H2	J	K	L	L1	L2	L3	L4	M	P	▲
60	15	50	10	32	18	33	25	75	90	5,8	M 6	145	25	55	70	118	47	28	060 x 015
	100								70					90	138	060 x 025			
70	15	60	13	40	18	36	30	85	100	7,8	M 8	155	30	60	75	124	55	36	070 x 015
	110								75					95	144	070 x 025			
80	15	70	16	50	18	36	35	95	110	7,8	M 8	170	30	60	80	133	65	44	080 x 015
	120								80					100	153	080 x 025			
100	25	85	20	60	18	50	40	110	135	9,8	M 10	210	35	85	105	167	80	50	100 x 025
	160								135					155	217	100 x 050			
110	25	95	25	70	18	50	45	120	145	11,8	M 12	220	35	85	105	172	90	60	110 x 025
	170								135					155	222	110 x 050			

JOLLYCAM® SZ 8610

Type B Pressure Cylinder with External Slide



Pressure Cylinder with External Slide

Function:

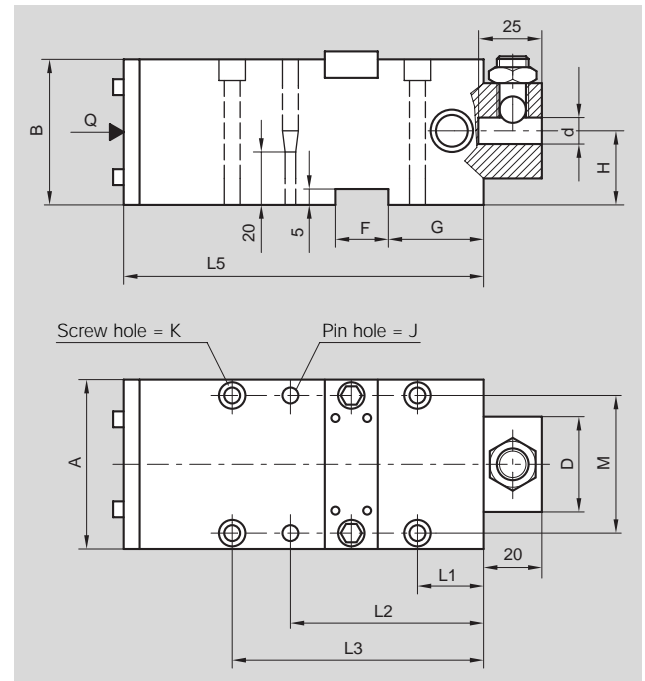
The pressure cylinder is utilised to actuate the freely-positionable slide. The slides are connected to the pressure cylinder by a pressure hose line and can thus be fitted in any position or angle on the tool.

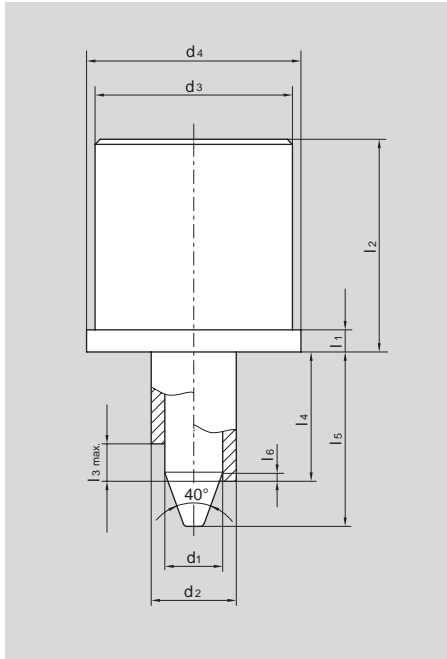
Order example: Pressure cylinder with Type B SZ 8610 slide, with a width of A = 80 mm and stroke of 25 mm

Extension: **080 x 025**

Order number: **SZ 8610.080 x 025**

Please state the required hose lengths as well!





Pilot Pin Unit

Features:

This pilot pin unit is a combination of a pilot pin with a spring-loaded stripper in a compact design.

Application:

This unit will be primarily used in large tools for the manufacture of sheet metal stamped parts. The sheet metal part is stripped by means of an integrated compression spring.

Order example: Pilot pin unit **SZ 4540**

$d_1 = 12 \text{ mm}$

Add **12**

Order number: **SZ 4540.12**

Add size to Order number

Pilot pin unit Bestell-Nr. **SZ 4540.**

$d_1 -0,05$	$d_2 k_6$	$d_3 h_9$	$d_4 h_9$	$l_1 -0,1$	$l_2 -0,2$	$l_3 \text{ max.}$	l_4	l_5	l_6	Initial F in N	▲
6	12	29	33	5	45	8	27	31,5	1,5	50	06
8	14	31	35	5	45	8	27	32,5	1,5	80	08
10	16	33	37	5	45	8	27	33,5	1,5	100	10
12	18	36	40	5	45	8	27	35,5	1,5	120	12
16	22	41	45	5	45	8	27	40,5	1,5	160	16

Mounting example

