

ACHTUNG!
HIER DAS
DECKBLATT
„SÄULENGESTELLE AUS
STAHL UND ALUMINIUM“
DRUCKEN

Die sets made of steel and aluminium

according to drawing

STEINEL®
NORMALIEN

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.

Machining services

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

usw. führen wir nach Ihren Angaben oder Skizzen aus.

Plate machining

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

2000 x 800 mm

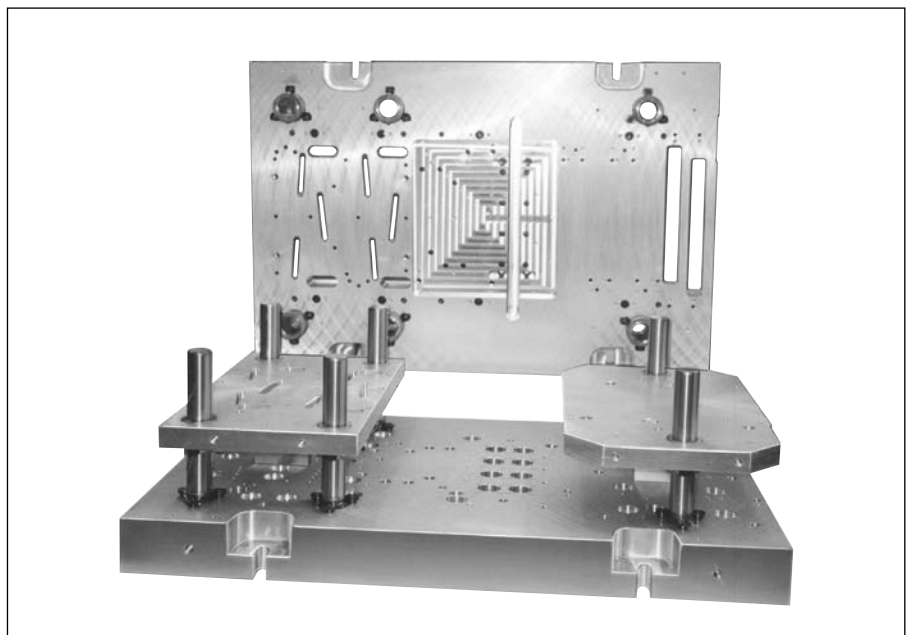
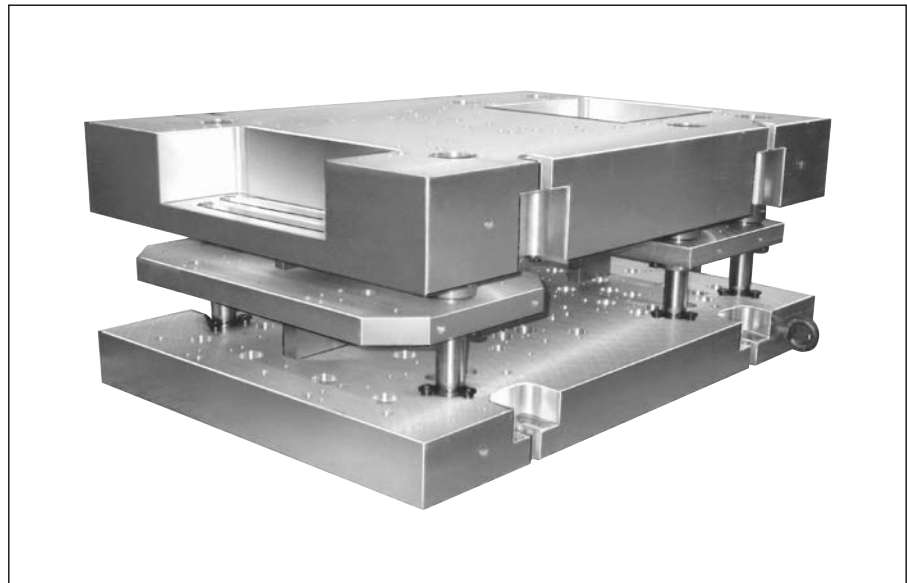
Larger plates finally milled up to:

2500 x 1250 mm

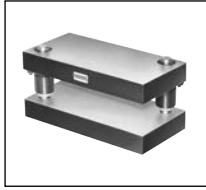
Plate thicknesses up to:

20 – 250 mm

Further dimensions available on request.



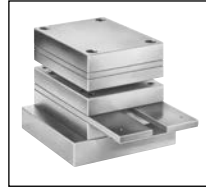
Die sets made of steel and aluminium



ST 35.. page 1.04



ST 35.. page 1.08



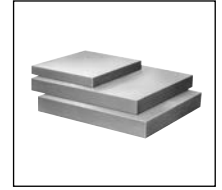
ST 3730 page 1.11



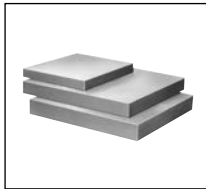
ST 3712 page 1.13



ST 3719 page 1.13



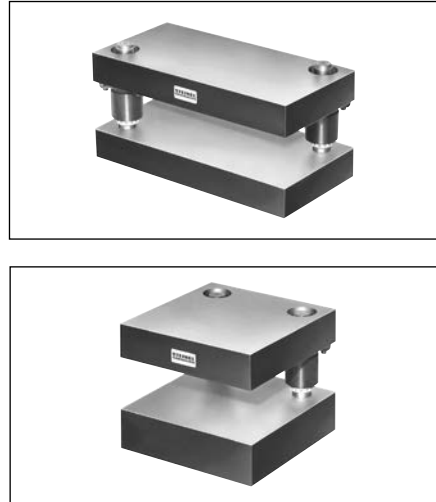
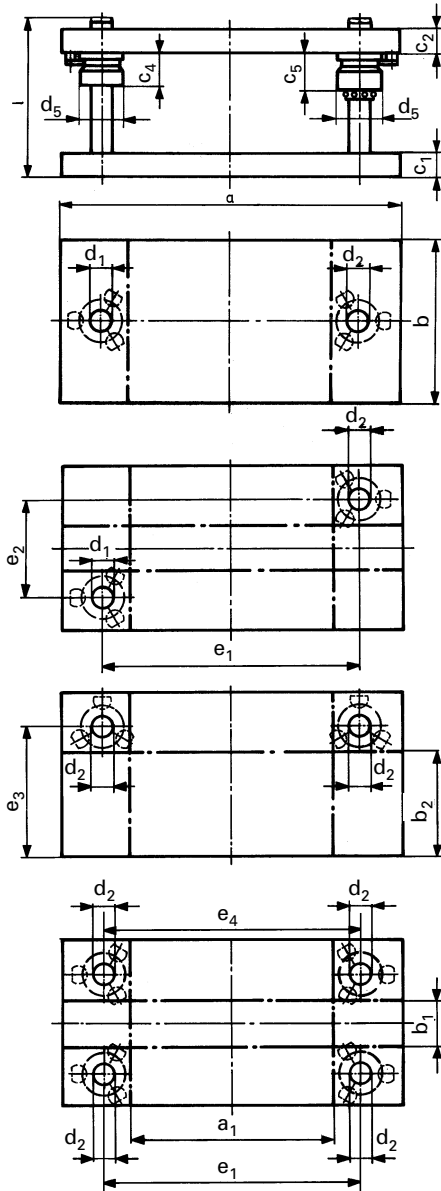
ST 3500 page 1.19



ST 3502 page 1.20

Die sets ST 35..

without stripper plate



Rectangular working area
2 or 4 pillars

Material: 1.0570 (St 52.3) aluminium on request

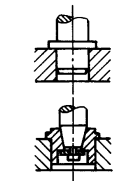
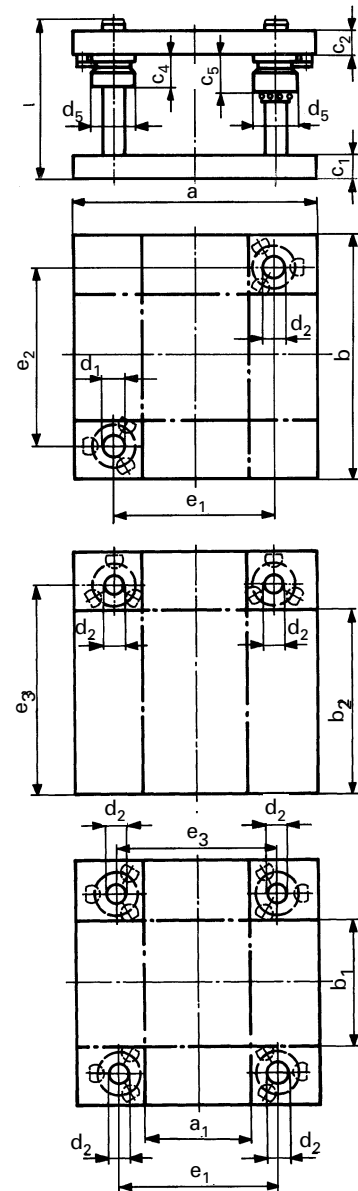
The plates are cleanly flame cut and normalized.
Upon request edges finished. Please state on order.

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

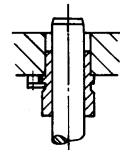
DIN 9868

Different Guide pillars length on request

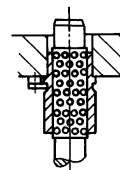
Lifting devices see under accessories



Removable pillars
upon request
ST 7120 or
ST 7181/82

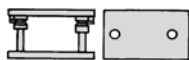


Sliding guide
hardened
steel bushing
bronze plated
Guide bushing
with shoulder ST 7419
(medium version)



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

Add
size and combination
of plates



Order no. **ST 3539.**

Order no. **ST 3532.**

x



Order no. **ST 3549.**

Order no. **ST 3542.**

x



Order no. **ST 3559.**

Order no. **ST 3552.**

x



Order no. **ST 3569.**

Order no. **ST 3562.**

x

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

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
				32	40									200 x 100.2
				40	32									200 x 100.3
				32	32									200 x 100.4
200 x 125	70	-	60	40	40	37	57	48	120	-	85	-	24/25 x 180	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	-	95	40	40	37	57	48	120	-	120	-	24/25 x 180	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	135	40	40	37	57	48	120	120	160	123	24/25 x 180	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	-	60	40	40	37	57	48	170	-	85	-	24/25 x 180	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	-	95	40	40	37	57	48	170	-	120	-	24/25 x 180	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	135	40	40	37	57	48	170	120	160	173	24/25 x 180	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	185	40	40	37	57	48	170	170	210	173	24/25 x 180	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	-	85	50	50	45	63	56	225	-	115	-	30/32 x 200	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	125	50	50	45	63	56	225	110	155	228	30/32 x 200	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	175	50	50	45	63	56	225	160	205	228	30/32 x 200	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	240	50	50	45	63	56	225	225	270	228	30/32 x 200	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	125	50	50	45	63	56	310	110	155	313	30/32 x 200	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	175	50	50	45	63	56	310	160	205	313	30/32 x 200	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..

without stripper plate

STEINEL®
NORMALIEN

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

a x b	a ₁	b ₁	b ₂	c ₁ ^{+0,5} _{1+0,2}	c ₂ ^{+0,5} _{2+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								48/50 x 224	630 x 315.2
				63	50								48/50 x 250	630 x 315.3
				50	50								48/50 x 224	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								48/50 x 224	630 x 400.2
				63	50								48/50 x 250	630 x 400.3
				50	50								48/50 x 224	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								48/50 x 224	630 x 500.2
				63	50								48/50 x 250	630 x 500.3
				50	50								48/50 x 224	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								48/50 x 224	630 x 630.2
				63	50								48/50 x 250	630 x 630.3
				50	50								48/50 x 224	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								48/50 x 224	710 x 400.2
				63	50								48/50 x 250	710 x 400.3
				50	50								48/50 x 224	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								48/50 x 224	710 x 500.2
				63	50								48/50 x 250	710 x 500.3
				50	50								48/50 x 224	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								48/50 x 224	710 x 630.2
				63	50								48/50 x 250	710 x 630.3
				50	50								48/50 x 224	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								48/50 x 224	800 x 400.2
				63	50								48/50 x 250	800 x 400.3
				50	50								48/50 x 224	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								48/50 x 224	800 x 500.2
				63	50								48/50 x 250	800 x 500.3
				50	50								48/50 x 224	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								48/50 x 224	800 x 630.2
				63	50								48/50 x 250	800 x 630.3
				50	50								48/50 x 224	800 x 630.4

Acceptance specifications

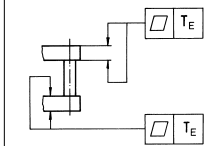
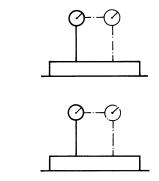
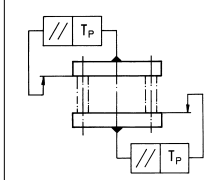
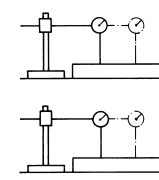
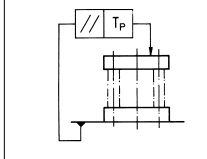
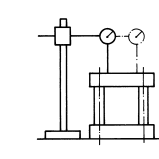
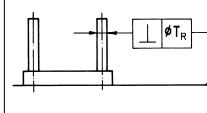
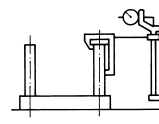
for die sets made of steel and aluminium

Similar to DIN 9811 part 1

Sizes without tolerances

for machined surfaces: DIN 7168 – middle

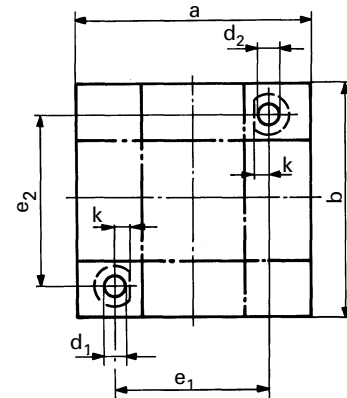
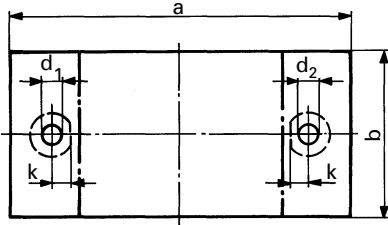
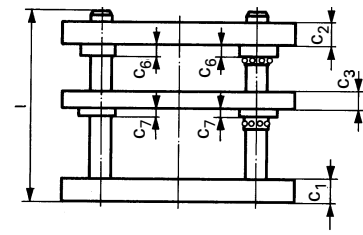
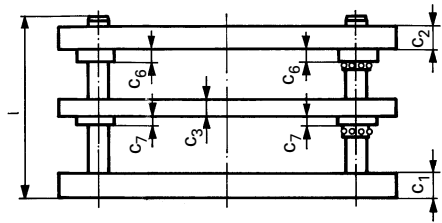
Tolerances of flatness, parallelism and squareness

	Test specimen	Testing position	Max. overall length of working		Testing data 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.

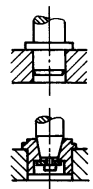
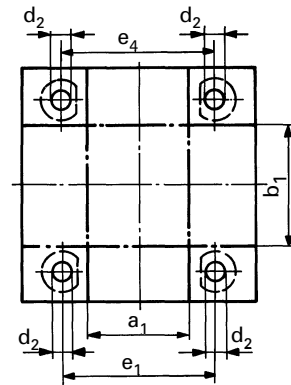
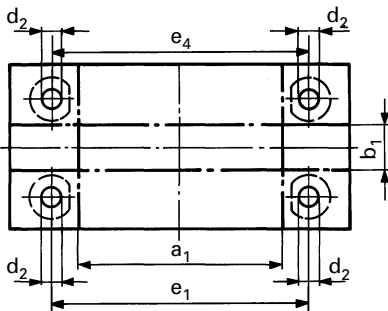
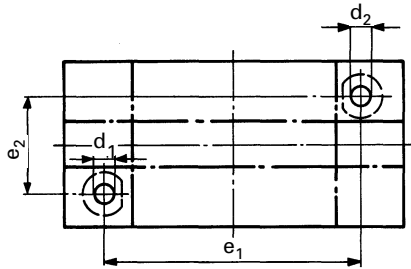
Position of bushings

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

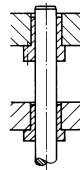
Lifting devices see under accessories



Removable pillars upon request
ST 7120
ST 7181/82

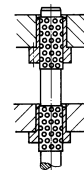
Sliding guide

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

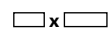


Add
size and combination
of plates
to order number



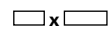
Order no. **ST 3579.**

Order no. **ST 3572.**



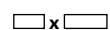
Order no. **ST 3589.**

Order no. **ST 3582.**



Order no. **ST 3599.**

Order no. **ST 3592.**



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**

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

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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



here 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.

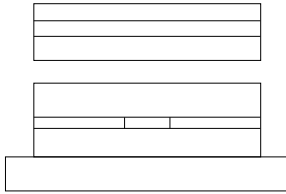
This is the reason that STEINEL NORMALIEN offers stamping blocks in several standard sizes to manufacture simple stamped parts.

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.



Ground parallel:

Plate length until 250 mm \pm 0,015 mm

Plate length until 400 mm \pm 0,025 mm

Tolerances:

Plate size - 0,2 mm

Plate thickness - 0,2 mm

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**

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

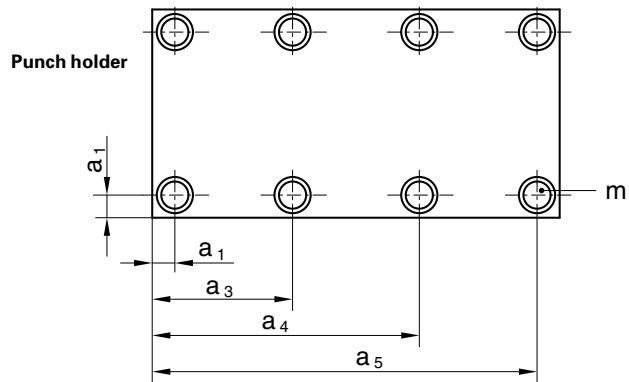
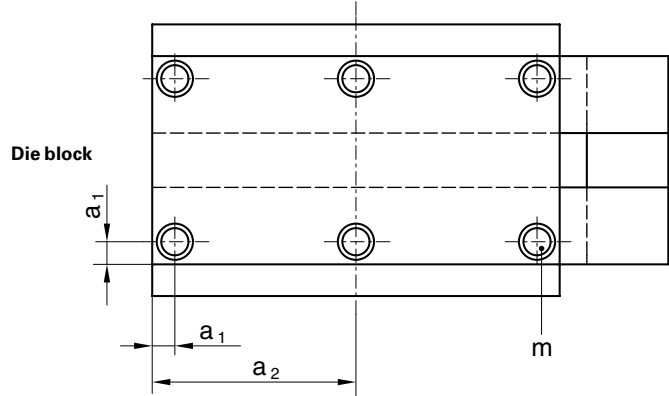
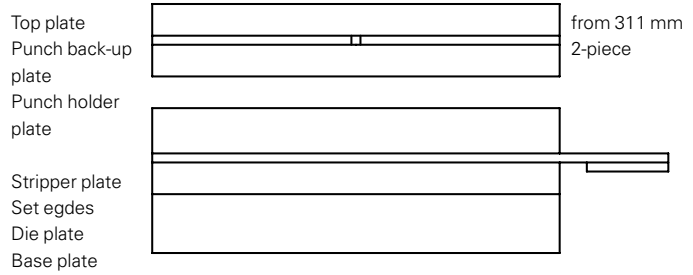
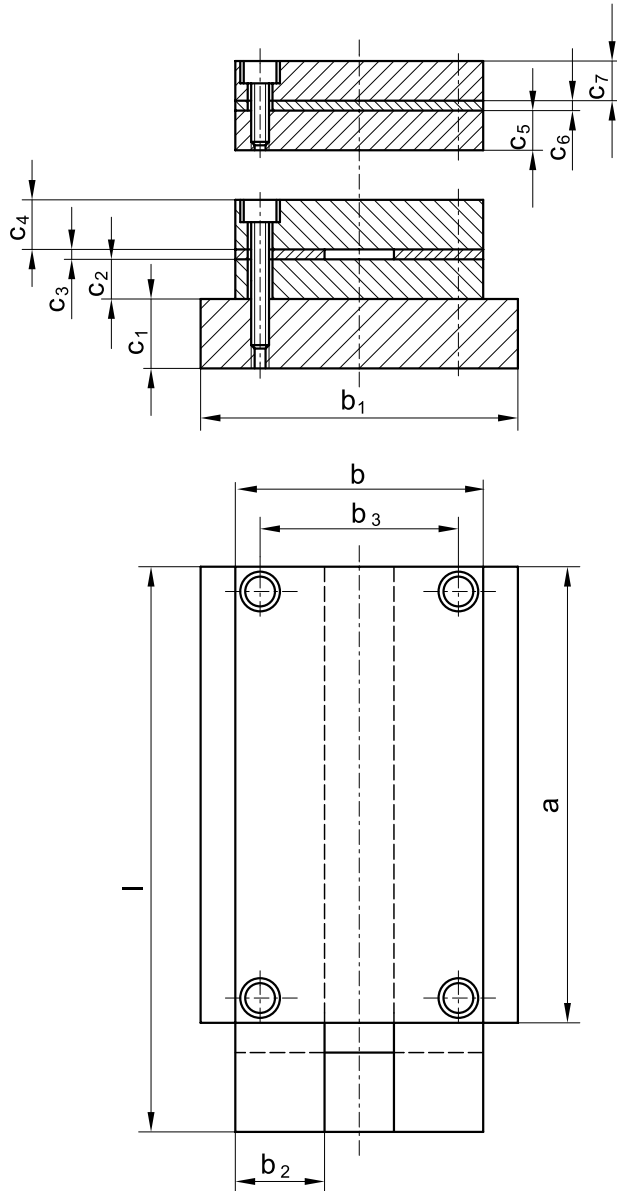
Punch holder	Material number
Top plate	1.1730
Punch back-up plate	1.2379
Punch holder plate	1.1730

Die block

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

Stamping Block ST 3730

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Add
size to
order number

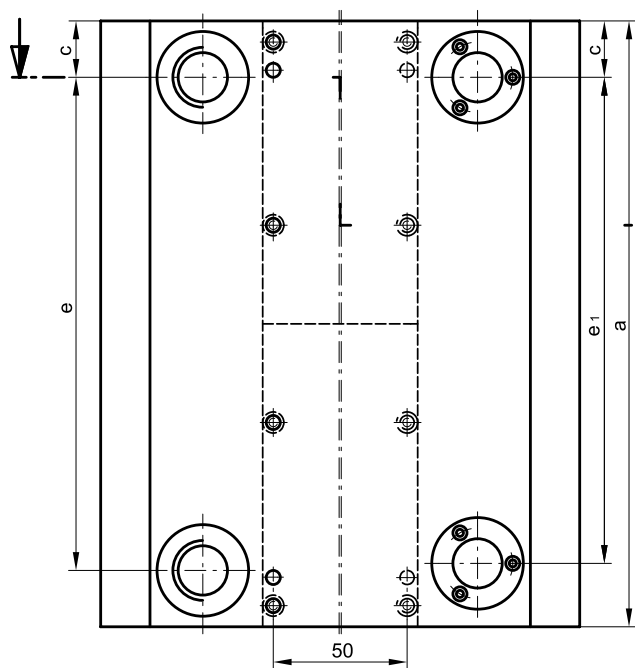
Order no. **ST 3730.**



a x b	b₁	b₂	b₃	l	c₁	c₂	c₃	c₄	c₅	c₆	c₇	a₁	a₂	a₃	a₄	a₅	m	
96 x 76	121	30	41	150	25	23	6	23	18	6	18	12				84	M 8	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	M 8	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	M 8	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	M 10	156 x 156
196 x 156				300												180		196 x 156
246 x 156				350												230		246 x 156
311 x 156				415									155,5	109	202	295		311 x 156
196 x 196	246	70	151	300	40	33	10	28	28	10	28	16				180	M 10	196 x 196
246 x 196				350												230		246 x 196
311 x 196				415									155,5	109	202	295		311 x 196
246 x 246	311	80	201	350	40	38	10	38	28	10	28	16				230	M 10	246 x 246
311 x 246				415									155,5	109	202	295		311 x 246
311 x 311	396	100	251	415	40	38	10	38	28	10	28	22	155,5	111	200	289	M 12	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 **a** and **b** 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").

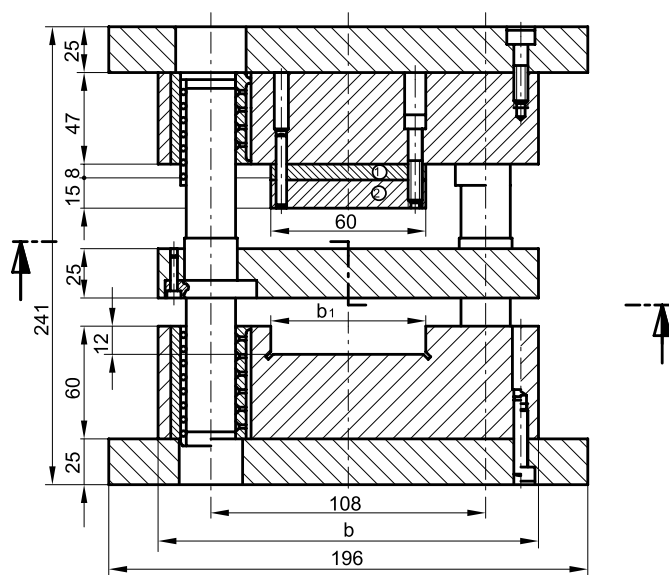
For segmentation: Precision steel plate on request.

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.



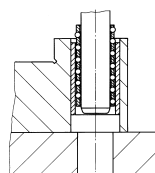
Sliding guides: can be connected with central lubrication (M 8 x 1).

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

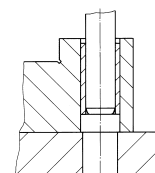
Mount size a x b = 246 x 156

Add **246 x 156**

Order number **ST 3719.246 x 156**



Ball guide:
retainer length
= 1/2 length of stroke



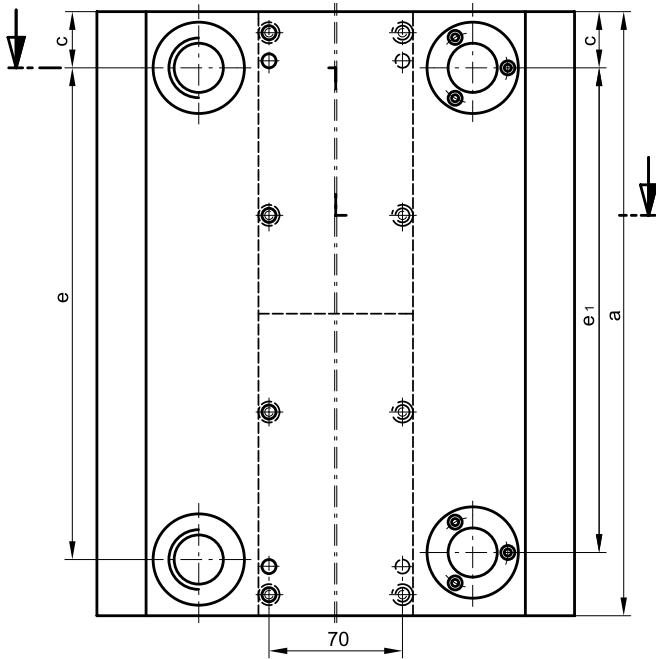
Sliding guide:
hardened
steel bushing
bronze plated

Add
size to
order number

Outside Dimensions a x b	Slot width b₁	c	e	e₁	Order no. ST 3712.	Order no. ST 3719.	<input type="checkbox"/> x <input type="checkbox"/>
196 x 156	60	24	148	145	Pillars ST 7117. d₁ x l	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 **a** and **b** 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").

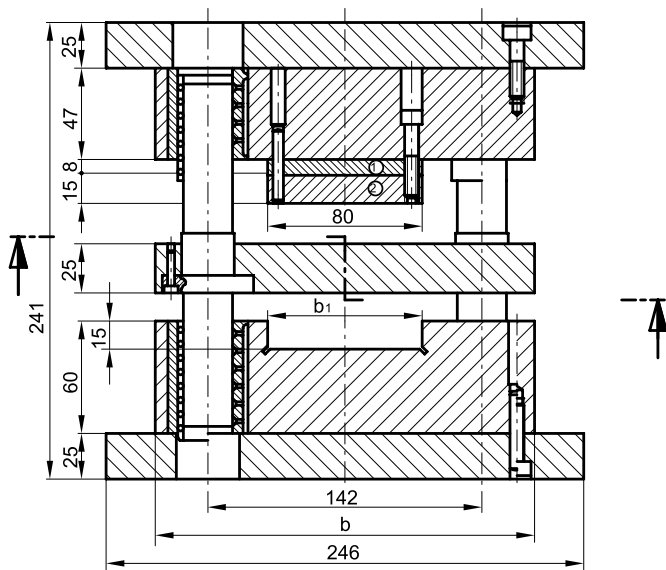
For segmentation: Precision steel plate on request.

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.



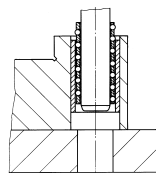
Sliding guides: can be connected with central lubrication (M 8 x 1).

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

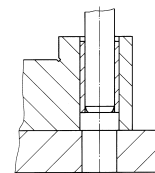
Mount size a x b = 311 x 196

Add **311 x 196**

Order number **ST 3719.311 x 196**



Ball guide:
retainer length
= 1/2 length of stroke



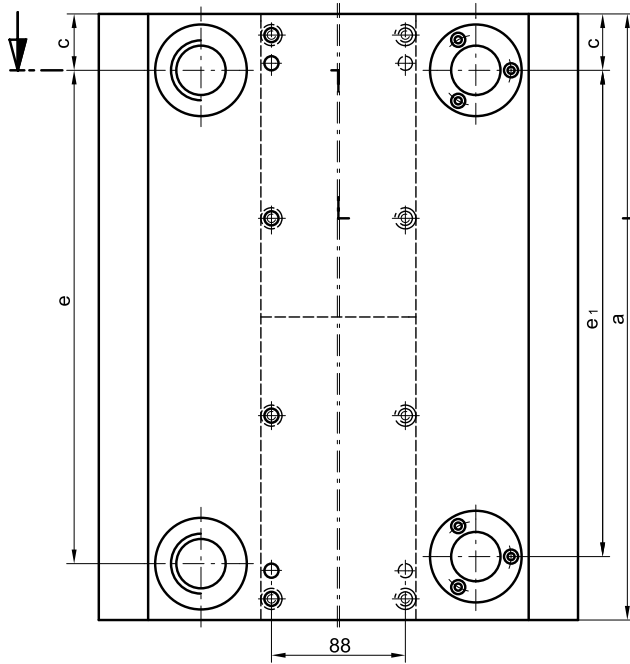
Sliding guide:
hardened
steel bushing
bronze plated

Add
size to
order number

Outside Dimensions a x b	Slot width b₁	c	e	e₁	Pillars ST 7117 d₁ x l	Order no. ST 3712	Order no. ST 3719	<input type="checkbox"/> x <input type="checkbox"/>
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 a and b 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").

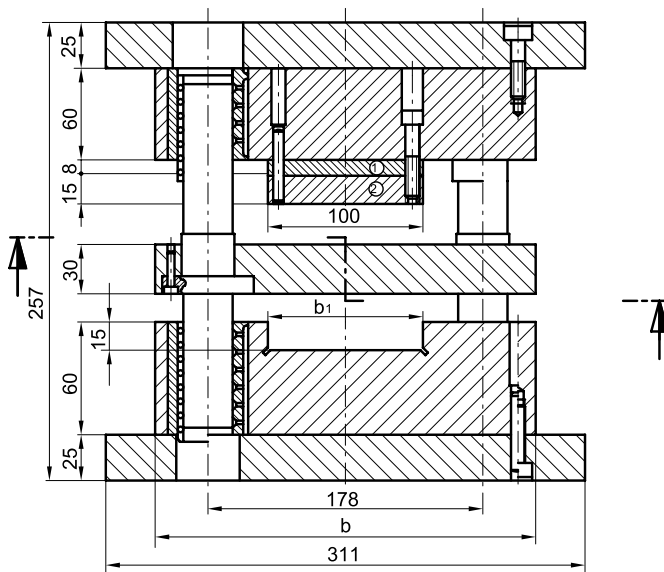
For segmentation: Precision steel plate on request.

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.



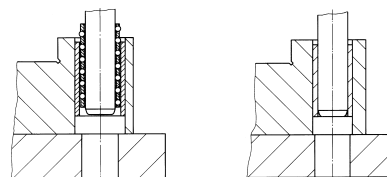
Sliding guides: can be connected with central lubrication (M 8 x 1).

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 guide:
retainer length
= 1/2 length of stroke

Sliding guide:
hardened
steel bushing
bronze plated

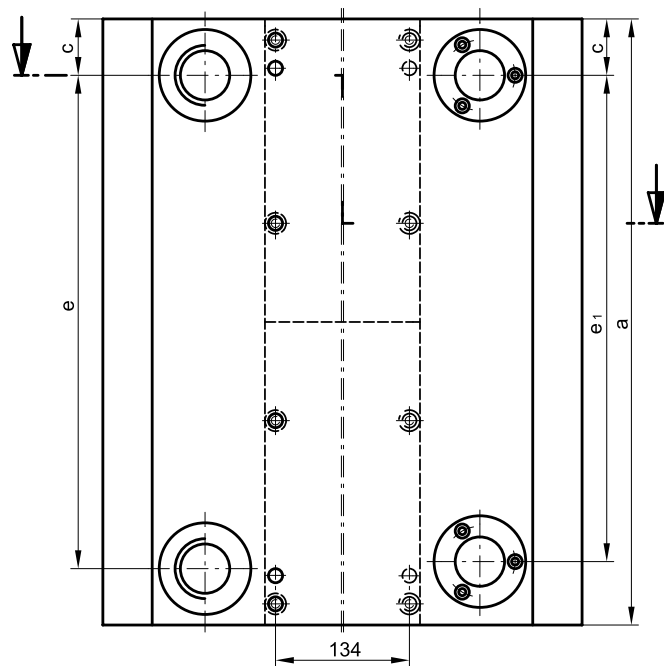
Add
size to
order number

Outside Dimensions a x b	Slot width b₁	c	e	e₁	Order no. ST 3712. Pillars ST 7117. d₁ x l	Order no. ST 3719.	<input type="checkbox"/> x <input type="checkbox"/>
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	

Die sets ST 3712, ST 3719

for progressive and compound tools

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Progressive and compound tools size: 4

Materials: plates **a** and **b** 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").

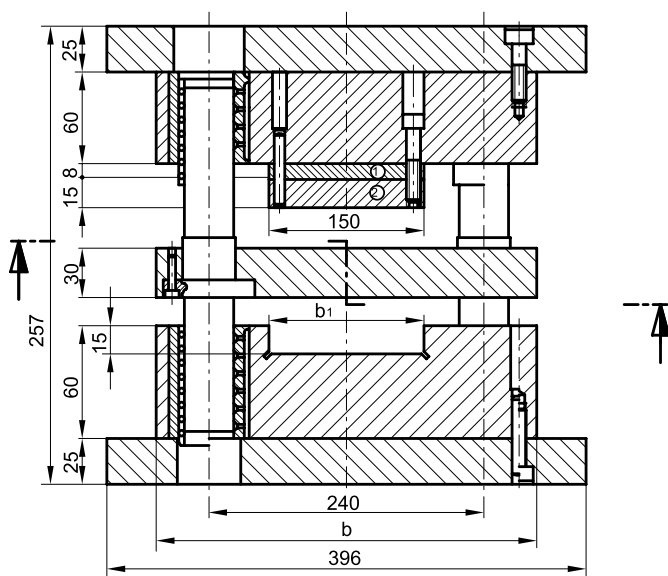
For segmentation: Precision steel plate on request.

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.



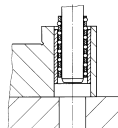
Sliding guides: can be connected with central lubrication (M 8 x 1).

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

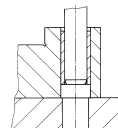
Mount size $a \times b = 496 \times 311$

Add **496 x 311**

Order number **ST 3719.496 x 311**



Ball bearing:
retainer length
= 1/2 length of stroke



Sliding guide:
hardened
steel bushing
bronze plated

Add
size to
order number

Outside Dimensions $a \times b$	Slot width b_1	c	e	e_1	Pillars ST 7117 . $d_1 \times l$	Order no. ST 3712 .	Order no. ST 3719 .	<input type="checkbox"/> x <input type="checkbox"/>
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

Order sheet for

Progressive and compound tools (Die Sets)

Materials: plates **a** and **b** 1.2842 (90 Mn Cr V 8).
All other plates 1.0570 (ST 52-3).

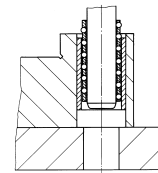
Soft pressure plate, upon request can also be delivered hardened.
(Please indicate on your order: "With hardened pressure plate").

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

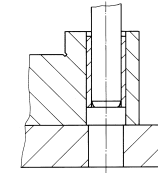
When choosing guide elements/units, please note the catalogue dimensions.

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.



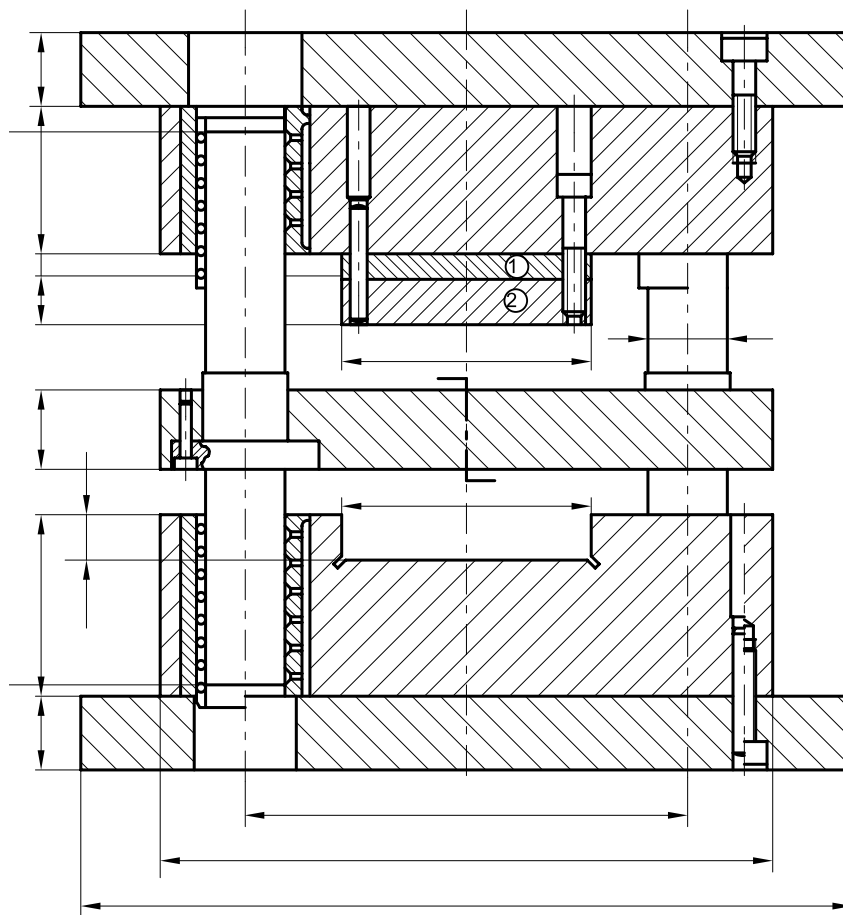
Ball guide:
Cage travel
= 1/2 length of stroke



Sliding guide:
hardened
steel bushing
bronze plated



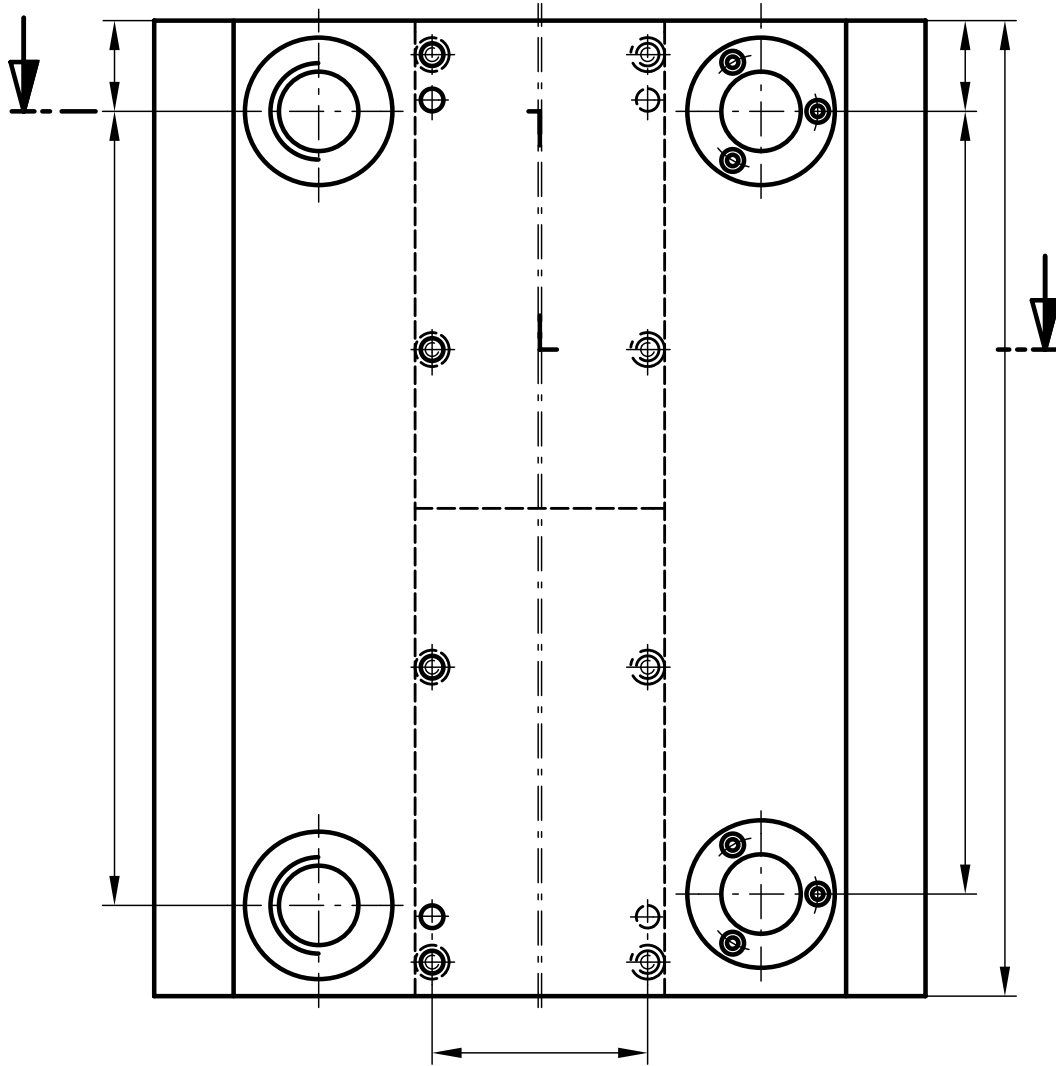
Progressive and compound tools can be supplied in special designs according to your specifications.



Order sheet for

Progressive and compound tools (Die Sets)

STEINEL®
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Room/Space for messages/information and notes

Company: _____

Street address: _____

City, State, Zip Code: _____

Contact Person: _____

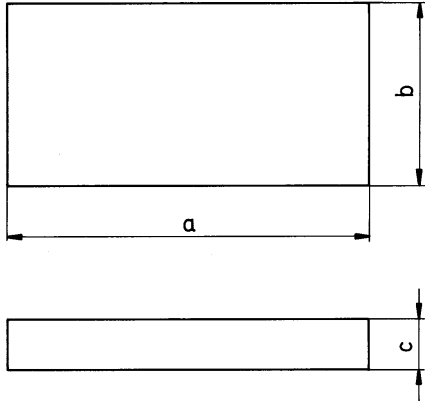
Telephone Number: _____

Fax-Number: _____

Date: _____

Steel plates ST 3500

for die sets



DIN 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. Upon request: Edge processing or reference edge using milling or grinding. Please note specific preference.

Larger steel plates can be manufactured shortdated 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**

Add size to order number

Order no. ST 3500.	<input type="text"/> x <input type="text"/> x <input type="text"/>
a x b	c
160 x 080	25
160 x 080	32
160 x 100	25
160 x 100	32
160 x 125	25
160 x 125	32
160 x 160	25
160 x 160	32
200 x 100	25
200 x 100	32
200 x 100	40
200 x 125	25
200 x 125	32
200 x 125	40
200 x 160	25
200 x 160	32
200 x 160	40
200 x 200	25
200 x 200	32
200 x 200	40
250 x 125	25
250 x 125	32
250 x 125	40
250 x 160	25
250 x 160	32
250 x 160	40
250 x 200	25
250 x 200	32
250 x 200	40
250 x 250	25
250 x 250	32
250 x 250	40

Add size to order number

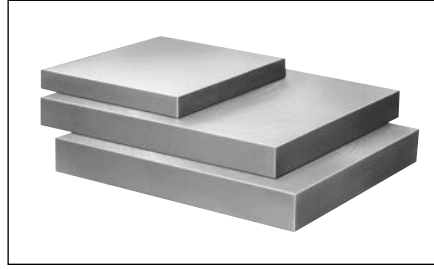
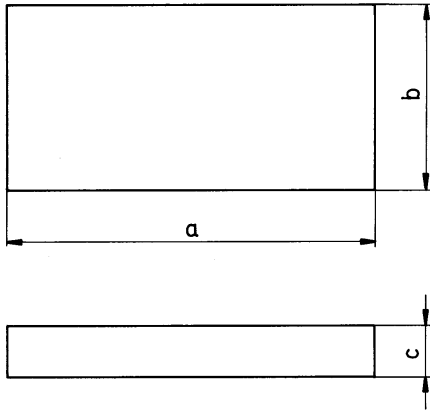
Order no. ST 3500.	<input type="text"/> x <input type="text"/> x <input type="text"/>
a x b	c
315 x 160	32
315 x 160	40
315 x 160	50
315 x 200	32
315 x 200	40
315 x 200	50
315 x 250	32
315 x 250	40
315 x 250	50
315 x 315	32
315 x 315	40
315 x 315	50
400 x 200	32
400 x 200	40
400 x 200	50
400 x 250	32
400 x 250	40
400 x 250	50
400 x 315	32
400 x 315	40
400 x 315	50
400 x 400	32
400 x 400	40
400 x 400	50
500 x 250	32
500 x 250	40
500 x 250	50
500 x 315	32
500 x 315	40
500 x 315	50
500 x 400	32
500 x 400	40
500 x 400	50

Add size to order number

Order no. ST 3500.	<input type="text"/> x <input type="text"/> x <input type="text"/>
a x b	c
500 x 500	32
500 x 500	40
500 x 500	50
630 x 315	40
630 x 315	50
630 x 315	63
630 x 400	40
630 x 400	50
630 x 400	63
630 x 500	40
630 x 500	50
630 x 500	63
630 x 630	40
630 x 630	50
630 x 630	63
710 x 400	40
710 x 400	50
710 x 400	63
710 x 500	40
710 x 500	50
710 x 500	63
710 x 630	40
710 x 630	50
710 x 630	63
800 x 400	40
800 x 400	50
800 x 400	63
800 x 500	40
800 x 500	50
800 x 500	63
800 x 630	40
800 x 630	50
800 x 630	63

Steel plates 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 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 no **ST 3502.** x x
Add size to order number

$\begin{matrix} +0,4 \\ 0 \end{matrix}$ a	$\begin{matrix} +0,4 \\ 0 \end{matrix}$ x b	$\begin{matrix} +0,5 \\ +0,2 \end{matrix}$ c	
156 x 076	25	156 x 076 x 25	
	32	156 x 076 x 32	
156 x 096	25	156 x 096 x 25	
	32	156 x 096 x 32	
156 x 121	25	156 x 121 x 25	
	32	156 x 121 x 32	
156 x 156	25	156 x 156 x 25	
	32	156 x 156 x 32	
196 x 096	25	196 x 096 x 25	
	32	196 x 096 x 32	
	40	196 x 096 x 40	
196 x 121	25	196 x 121 x 25	
	32	196 x 121 x 32	
	40	196 x 121 x 40	
196 x 156	25	196 x 156 x 25	
	32	196 x 156 x 32	
	40	196 x 156 x 40	
196 x 196	25	196 x 196 x 25	
	32	196 x 196 x 32	
	40	196 x 196 x 40	
246 x 121	25	246 x 121 x 25	
	32	246 x 121 x 32	
	40	246 x 121 x 40	
246 x 156	25	246 x 156 x 25	
	32	246 x 156 x 32	
	40	246 x 156 x 40	
246 x 196	25	246 x 196 x 25	
	32	246 x 196 x 32	
	40	246 x 196 x 40	
246 x 246	25	246 x 246 x 25	
	32	246 x 246 x 32	
	40	246 x 246 x 40	

Order no. **ST 3502.** x x
Add size to order number

$\begin{matrix} +0,4 \\ 0 \end{matrix}$ a	$\begin{matrix} +0,4 \\ 0 \end{matrix}$ x b	$\begin{matrix} +0,5 \\ +0,2 \end{matrix}$ c	
311 x 156	32	311 x 156 x 32	
	40	311 x 156 x 40	
	50	311 x 156 x 50	
311 x 196	32	311 x 196 x 32	
	40	311 x 196 x 40	
	50	311 x 196 x 50	
311 x 246	32	311 x 246 x 32	
	40	311 x 246 x 40	
	50	311 x 246 x 50	
311 x 311	32	311 x 311 x 32	
	40	311 x 311 x 40	
	50	311 x 311 x 50	
396 x 196	32	396 x 196 x 32	
	40	396 x 196 x 40	
	50	396 x 196 x 50	
396 x 246	32	396 x 246 x 32	
	40	396 x 246 x 40	
	50	396 x 246 x 50	
396 x 311	32	396 x 311 x 32	
	40	396 x 311 x 40	
	50	396 x 311 x 50	
396 x 396	32	396 x 396 x 32	
	40	396 x 396 x 40	
	50	396 x 396 x 50	
496 x 246	32	496 x 246 x 32	
	40	496 x 246 x 40	
	50	496 x 246 x 50	
496 x 311	32	496 x 311 x 32	
	40	496 x 311 x 40	
	50	496 x 311 x 50	
496 x 396	32	496 x 396 x 32	
	40	496 x 396 x 40	
	50	496 x 396 x 50	
496 x 496	32	496 x 496 x 32	
	40	496 x 496 x 40	
	50	496 x 496 x 50	

Order no. **ST 3502.** x x
Add size to order number

$\begin{matrix} +0,4 \\ 0 \end{matrix}$ a	$\begin{matrix} +0,4 \\ 0 \end{matrix}$ x b	$\begin{matrix} +0,5 \\ +0,2 \end{matrix}$ c	
626 x 311	40	626 x 311 x 40	
	50	626 x 311 x 50	
	63	626 x 311 x 63	
626 x 396	40	626 x 396 x 40	
	50	626 x 396 x 50	
	63	626 x 396 x 63	
626 x 496	40	626 x 496 x 40	
	50	626 x 496 x 50	
	63	626 x 496 x 63	
626 x 626	40	626 x 626 x 40	
	50	626 x 626 x 50	
	63	626 x 626 x 63	
706 x 396	40	706 x 396 x 40	
	50	706 x 396 x 50	
	63	706 x 396 x 63	
706 x 496	40	706 x 496 x 40	
	50	706 x 496 x 50	
	63	706 x 496 x 63	
706 x 626	40	706 x 626 x 40	
	50	706 x 626 x 50	
	63	706 x 626 x 63	
796 x 396	40	796 x 396 x 40	
	50	796 x 396 x 50	
	63	796 x 396 x 63	
796 x 496	40	796 x 496 x 40	
	50	796 x 496 x 50	
	63	796 x 496 x 63	
796 x 626	40	796 x 626 x 40	
	50	796 x 626 x 50	
	63	796 x 626 x 63	