

Steel and aluminium die sets

- Available from stock in standard sizes or in any shape and size according to your drawings
- Tension-free annealed die sets, plane-parallel ground surfaces. Breakthroughs, milled cavities, recesses, drilling templates according to your specifications
- Sliding guide (steel with bronze coating, solid bronze with solid lubricant)
- Ball guides, roller guides
- Precision die sets for progressive
- Steel plates for die sets



Steel and aluminium die sets

according to drawing

STEINEL steel and aluminium die sets can be produced in any size and shape at short notice within the maximum production range according to your specifications or drawings.

Plate machining:

Cleanly flame cut or machined on all sides, tension-free annealed, plane-parallel ground to the maximum of

2000 x 800 mm

Larger plates precision-milled to the maximum of

2500 x 1250 mm

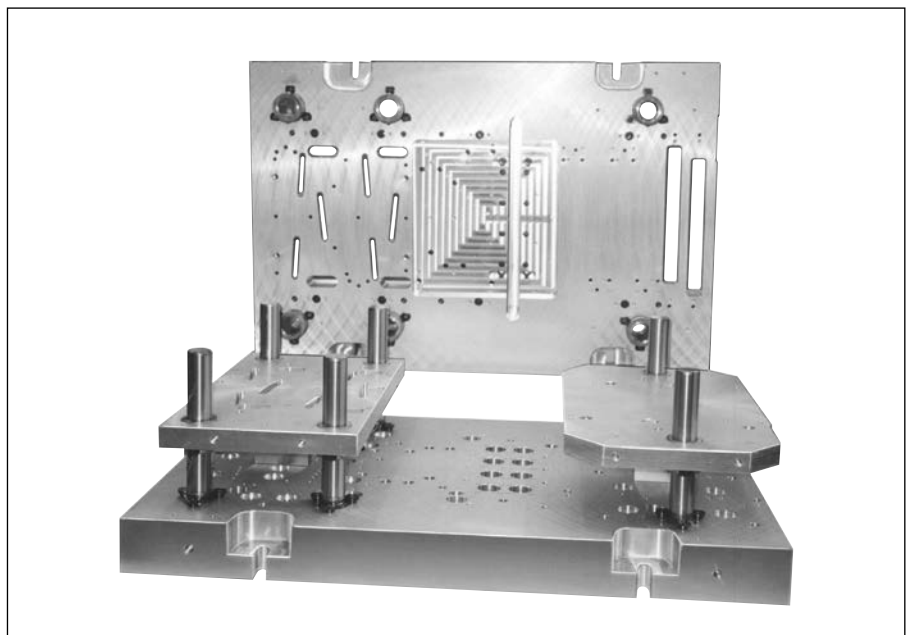
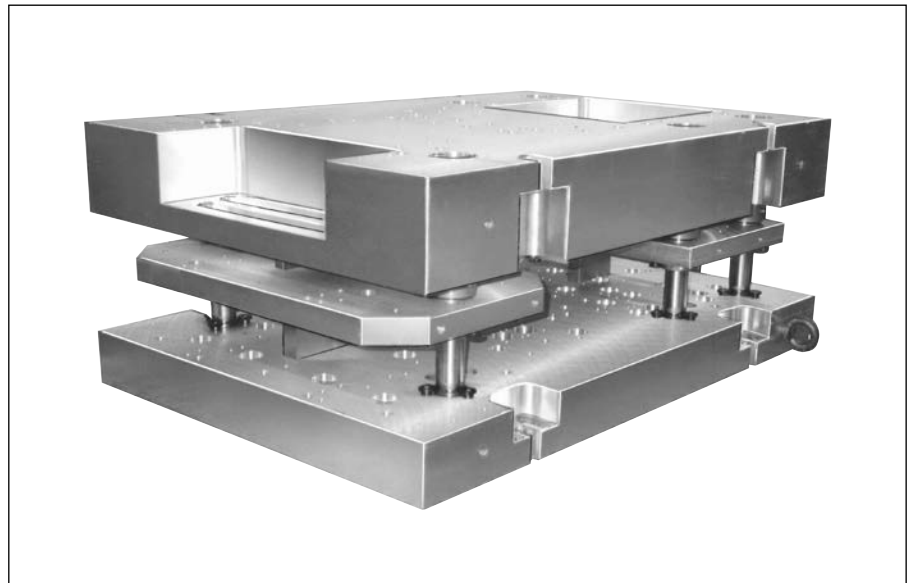
Plate thickness of

20–250 mm

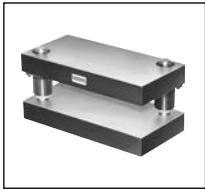
Further sizes upon request.

Machining service:

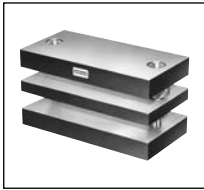
Breakthroughs, milled cavities, recesses, drilling templates, jig grinding, electrical discharge machining.



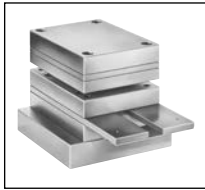
Steel and aluminium die sets



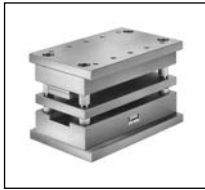
ST 35.. Page 1.04



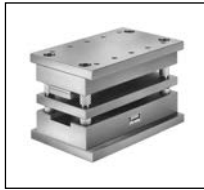
ST 35.. Page 1.08



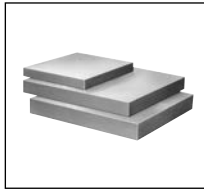
ST 3730 Page 1.11



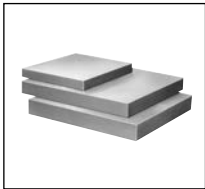
ST 3712 Page 1.13



ST 3719 Page 1.13



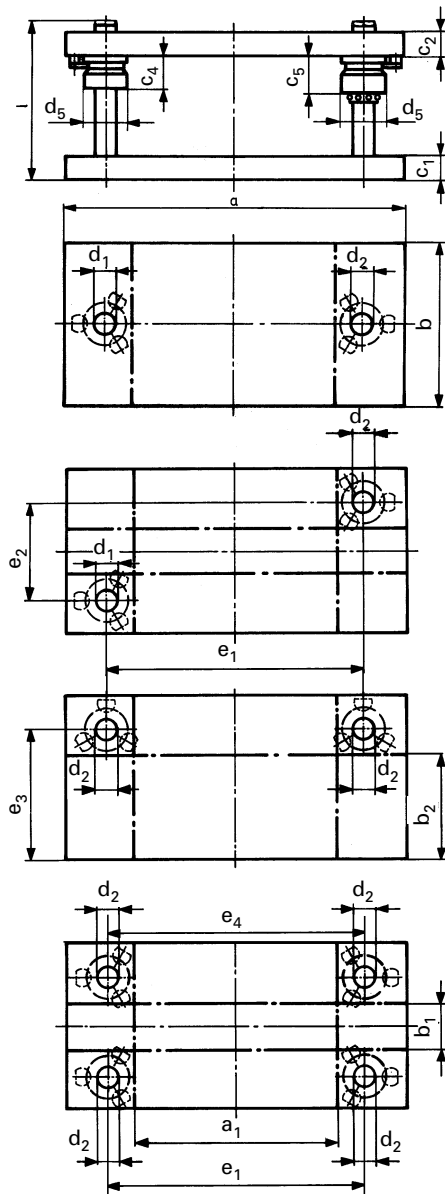
ST 3500 Page 1.19



ST 3502 Page 1.20

Die sets ST 35..

without guide plate



**Rectangular working surface,
2 or 4 guide pillars**

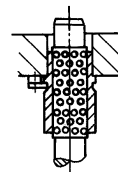
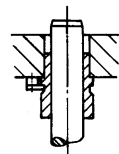
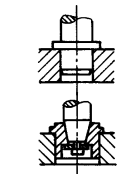
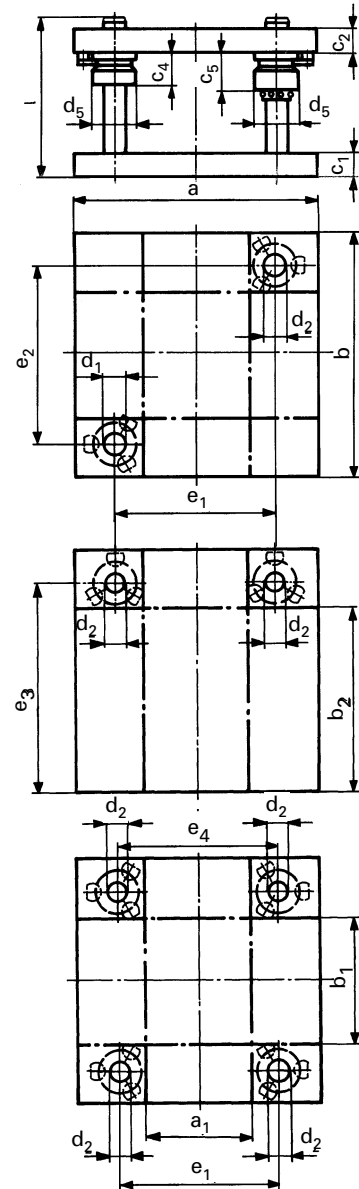
Material:
All plates are tension-free annealed the edges are milled.

Travel direction and bush set-up:
In the standard version, the bush set-up is delivered as drawn. Please emphasise in order if a different set-up is required.

DIN 9868

Different pillar lengths upon request

For carrying elements, see under accessories



**Upon request
replacement
guide pillars:**
ST 7120 or
ST 7181/82

Sliding guide:
Hardened steel bush,
bronze coating,
guide bush
with shoulder ST 7419
(medium length version)

Ball guide:
Guide bush
with shoulder ST 7412
(long version),
cage travel = 1/2 stroke
length

Addition of size and
plate combination to
order number



Order number **ST 3539**

Order number **ST 3532**

x



Order number **ST 3549**

Order number **ST 3542**

x



Order number **ST 3559**

Order number **ST 3552**

x



Order number **ST 3569**

Order number **ST 3562**

x

Die sets ST 35..

without guide plate

Order example: Die set with 2 rear standing guide pillars with sliding guide

Steel bronze coating **ST 3559**

Die set size a x b = 250 x 250

c₁ = 40, c₂ = 32

Addition **250 x 250.3**

Order number ST 3559 250 x 250.3

Addition of size and plate combination to order number

a x b	a ₁	b ₁	b ₂	c ₁ +0.2 +0.5	c ₂ +0.2 +0.5	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 guide plate

STEINEL®

Order example: Die set with 2 rear standing guide pillars with sliding guide

Steel bronze coating **ST 3559**

Die set size a x b = 250 x 250

c₁ = 40, c₂ = 32

Addition **250 x 250.3**

Order number **ST 3559 250 x 250.3**

Addition of size and plate combination to order number

a x b	a ₁	b ₁	b ₂	c ₁ ^{+0.5} c ₁ ^{+0.2}	c ₂ ^{+0.5} c 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 conditions for steel and aluminium die sets

Similar DIN 9811 part 1

Dimensions without tolerance specification
for machined surfaces: DIN 7168 – medium

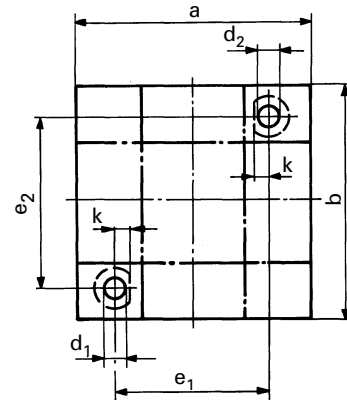
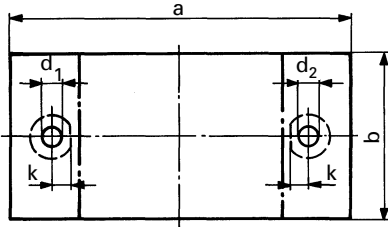
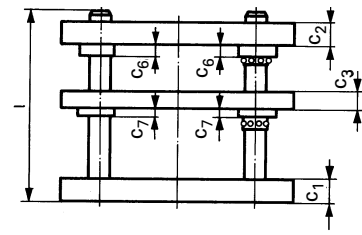
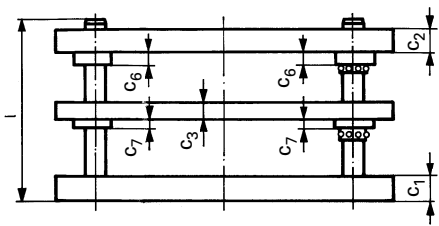
Evenness, parallelism and squareness tolerances

	Test piece	Test area	Largest length of working surface		Test values T_p, T_E, T_R
			over	up to	
Evenness of the surfaces			-	-	0.005 to 100 mm length of the
Parallelism of the surface pairs			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 the 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 tolerance of the guide pillars			-	-	Working surface *) 0.005 to 100 mm length of the guide pillars *)

*) If larger or smaller lengths are checked, the tolerance value is to be multiplied by a corresponding factor.

Die sets ST 35..

with guide plate



**Rectangular working surface,
2 or 4 guide pillars**

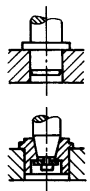
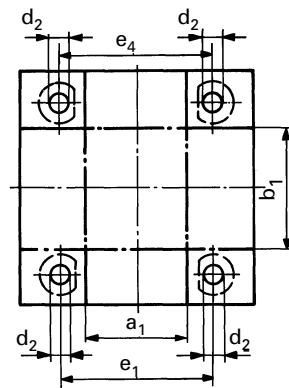
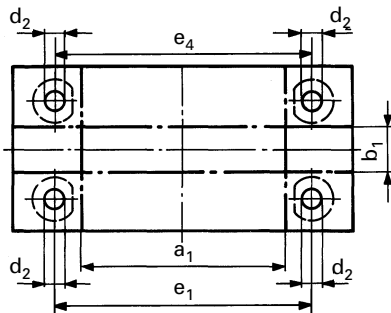
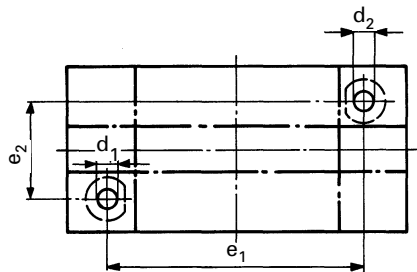
Material:
1.0570 (St 52-3), Al upon request

Travel direction and bush set-up:
In the standard version, the bush set-up is delivered as drawn. Please emphasise different set-up.

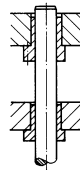
DIN 9868

Different pillar lengths upon request

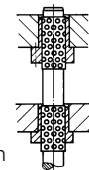
For carrying elements, see under accessories



Sliding guide:
Hardened steel bush, bronze coating, guide bush with flange ST 7429
Upper part: Guide bush medium length or length version according to plate combination
Guide plate: Guide bush short version



Ball guide:
Guide bush with flange ST 7422
Upper part: Guide bush medium length or length version according to plate combination
Guide plate: Guide bush short version, cage travel = 1/2 stroke length



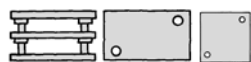
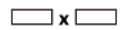
Addition of size and plate combination to order number

Upon request replacement guide pillars:
ST 7120 ST 7181/82



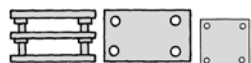
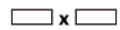
Order number **ST 3579**

Order number **ST 3572**



Order number **ST 3589**

Order number **ST 3582**



Order number **ST 3599**

Order number **ST 3592**



Die sets ST 35..

with guide plate

Order example: Die set with guide plate and 4 guide pillars with ball guide **ST 3592**

Die set size a x b = 500 x 500

c₁ = 50, c₂ = 50

Addition **500 x 500.1**

Order number **ST 3592 500 x 500.1**

Addition of size and plate combination to order number

a x b	a ₁	b ₁	c ₁ ^{+0.5} c ₁ ^{+0.2}	c ₂ ^{+0.5} c ₂ ^{+0.2}	c ₃ ^{+0.5} c ₃ ^{+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 guide plate

STEINEL®

Order example: Die set with guide plate and 4 guide pillars with ball guide **ST 3592**

Die set size a x b = 500 x 500

c₁ = 50, c₂ = 50

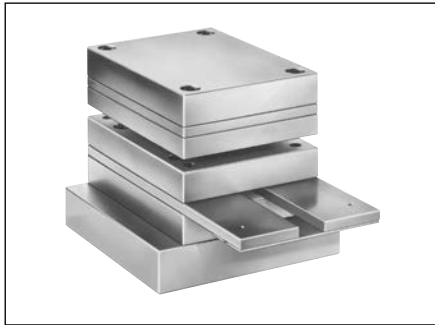
Addition **500 x 500.1**

Order number **ST 3592 500 x 500.1**

Addition of size and plate combination to order number

a x b	a ₁	b ₁	c ₁ ^{+0.5} _{1+0.2}	c ₂ ^{+0.5} _{2+0.2}	c ₃ ^{+0.5} _{3+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



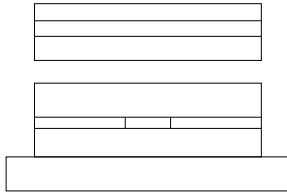
There is still a single tool available for the manufacture of sheet metal parts. In order to make the design work easier and the delivery time shorter, it is useful to obtain pre-fabricated die units. Therefore, STEINEL Normalien provides stamping blocks for the manufacture of simple punched parts in various standard sizes.

The stamping blocks are produced with the familiar "STEINEL precision". All plates are ground at right angles on 4 sides and can therefore be used as reference edges.

Depending on the size of the stamping blocks, the guide bars are 50–100 mm longer and provided with a cross plate made of sheet metal.

The punch head is the same width as the lower part of the stamping block and therefore provides an optimal utilisation of the working surface.

The plate dimensions correspond with the DIN/ISO sizes, as stated in our catalogue.



Note:

We also deliver STEINEL stamping blocks in every special design according to your specifications (with transversal guide bars, threads for clamping sockets etc., amongst other things).

Order example: Complete stamping block **ST 3730**

Stamping block size a x b = 196 x 96

Addition **196 x 096**

Order number **ST 3730.196 x 096**

Plane-parallelism:

Plate length up to 250 mm ± 0.015 mm

Plate length up to 400 mm ± 0.025 mm

Tolerances:

Plate size -0.2 mm

Plate thickness -0.2 mm

Screws in stamping block:

up to 246 mm length = 4 screws

from 311 mm length = 6 screws

Screws in punch head:

up to 246 mm length,

1 part pressure plate = 4 screws
from 311 mm length,

1 part pressure plate = 8 screws
from 396 mm length,

2 part pressure 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

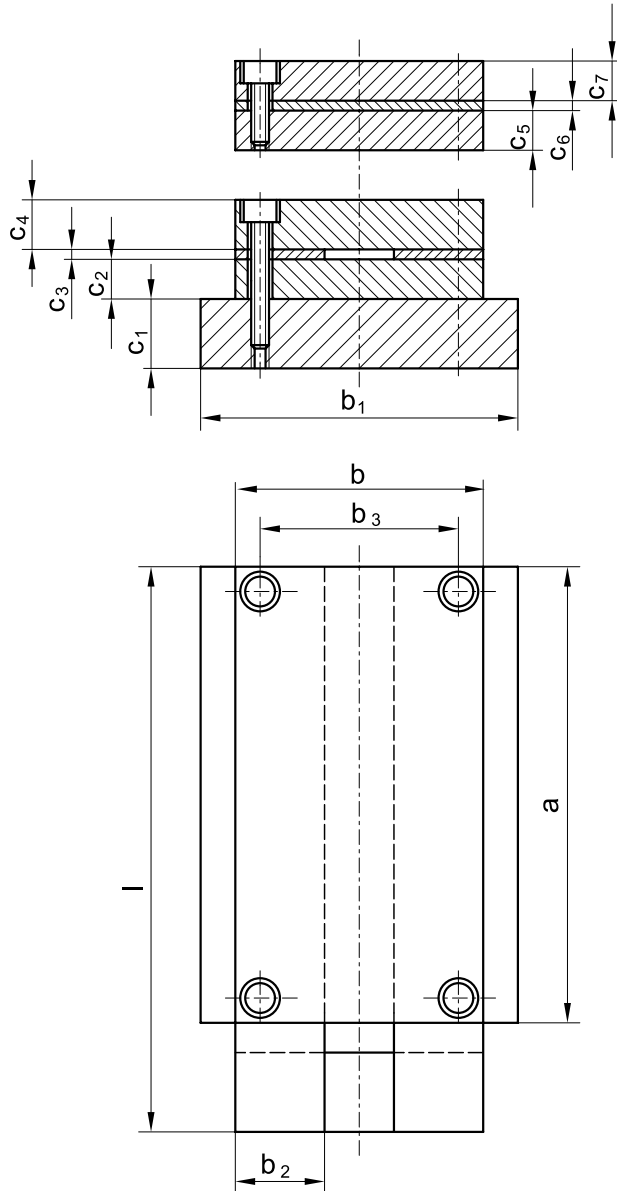
Material

Punch head	Material number
Cover plate	1.1730
Pressure plate	1.2379
Die plate	1.1730

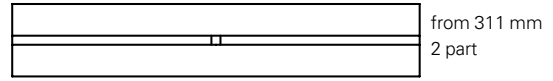
Stamping block

Guide plate	1.1730
Guide bars	1.1730
Die plate	1.2379
Lower plate	1.1730

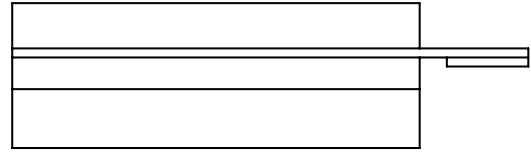
Stamping block ST 3730



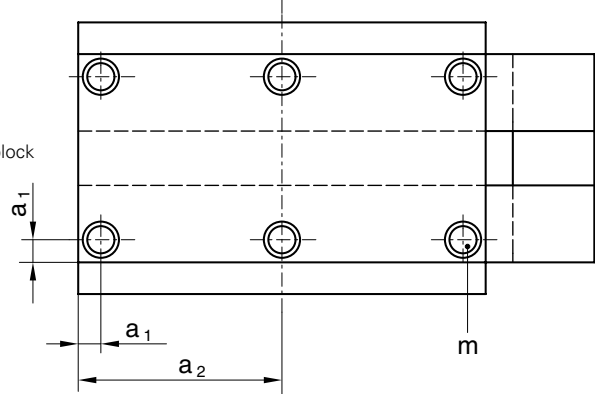
Cover plate
Pressure plate
Die plate



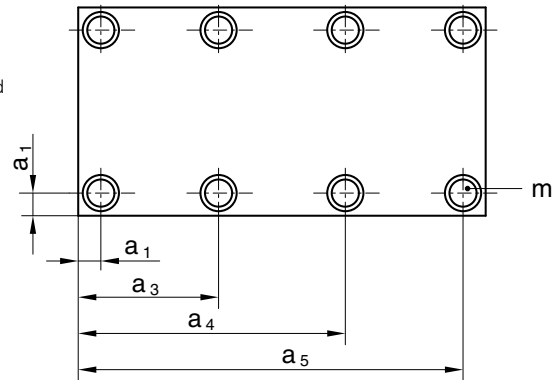
Guide plate
Guide bar
Die plate
Lower plate



Stamping block



Punch head



Add size of
order number

Order number **ST 3730.**

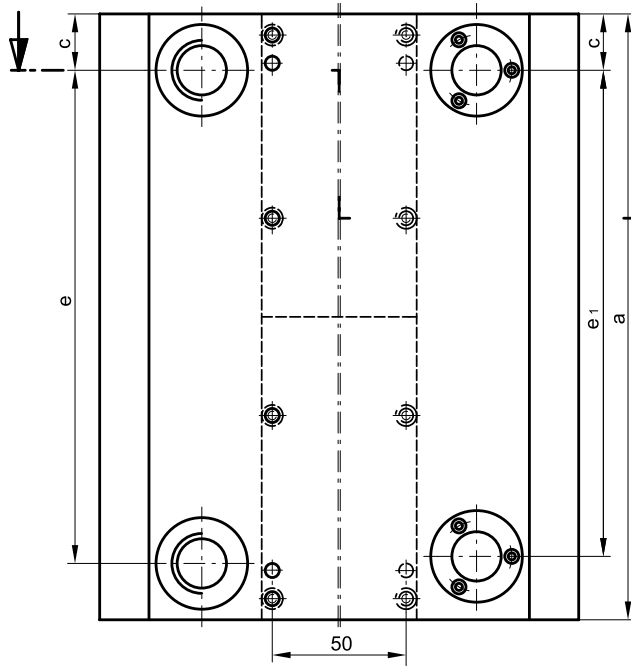
x

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	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 tools

STEINEL®



Size: 1

Material:

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

Pressure plate soft, also deliverable in hardened form upon request. (Please specify in the order: "With hardened pressure plate".)

For the segmentation:

Precision flat steel upon request

Note:

We also deliver STEINEL die sets in every special design according to your specifications. The plate dimensions correspond with the DIN/ISO sizes, as stated in our catalogue.

The die sets are manufactured according to the modular design principle and in all respects guarantee efficient use for the benefit of the customer.

Our in-stock system spring units can be used as spring systems. You have a choice of 4 different types of load (SZ 8565).

Via the middle fastening of the pillars in the guide plate and the resulting halved length of the stress application point compared to conventional pillar attachments in the upper or bottom part of the tool, these pillars can bear eight times more weight than standard pillars.

Sliding guide:

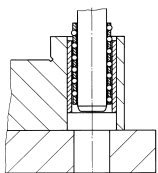
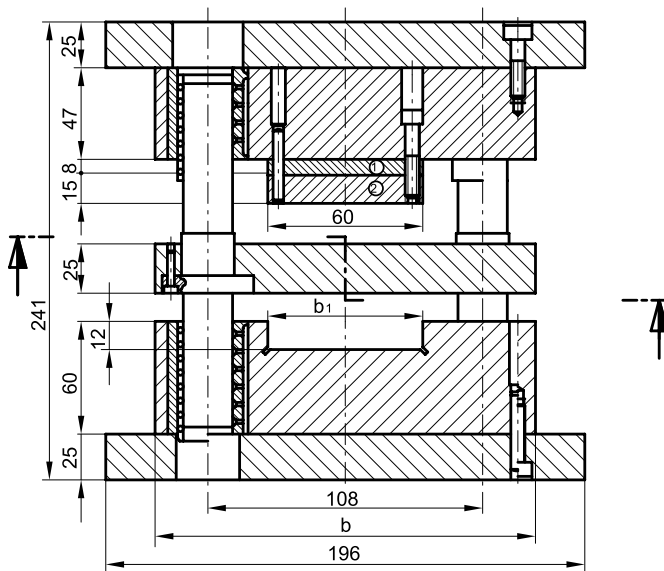
Connectable to the central lubrication (M 8 x 1).

Order example: Die set for progressive and composite tools with sliding guide steel bronze coating **ST 3719**.

Die set size a x b = 246 x 156

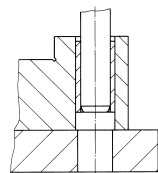
Addition **246 x 156**

Order number **ST 3719.246 x 156**



Ball guide:

Cage travel
= 1/2 stroke length



Sliding guide:

Hardened addition,
steel bushing,
bronze coating

Add size of
order number

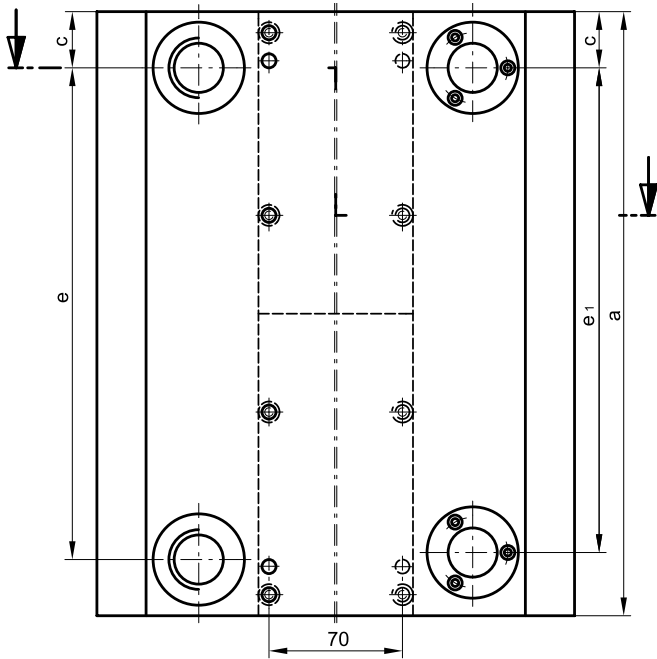
Order number **ST 3712**. Order number **ST 3719**.

External dimensions a x b	Grinding b1	c	e	e1	Pillars ST 7117. d1 x l	<input type="checkbox"/> x <input type="checkbox"/>
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 tools

STEINEL®



Size: 2

Material:

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

Pressure plate soft, also deliverable in hardened form upon request.
(Please specify in the order: "With hardened pressure plate".)

For the segmentation:

Precision flat steel upon request

Note:

We also deliver STEINEL die sets in every special design according to your specifications. The plate dimensions correspond with the DIN/ISO sizes, as stated in our catalogue.

The die sets are manufactured according to the modular design principle and in all respects guarantee efficient use for the benefit of the customer.

Our in-stock system spring units can be used as spring systems. You have a choice of 4 different types of load (SZ 8565).

Via the middle fastening of the pillars in the guide plate and the resulting halved length of the stress application point compared to conventional pillar attachments in the upper or bottom part of the tool, these pillars can bear eight times more weight than standard pillars.

Sliding guide:

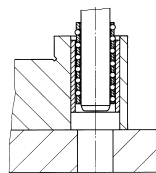
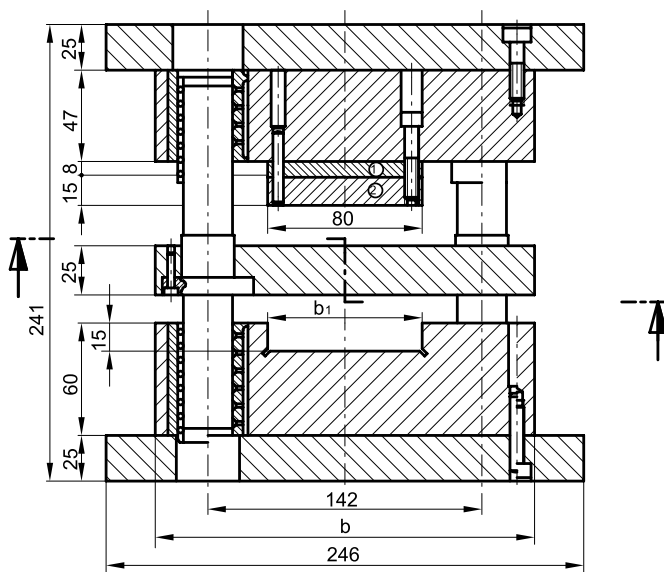
Connectable to the central lubrication (M 8 x 1).

Order example: Die set for progressive and composite tools with sliding guide steel bronze coating **ST 3719**.

Die set size a x b = 311 x 196

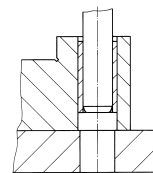
Addition **311 x 196**

Order number **ST 3719.311 x 196**



Ball guide:

Cage travel
= 1/2 stroke length



Sliding guide:

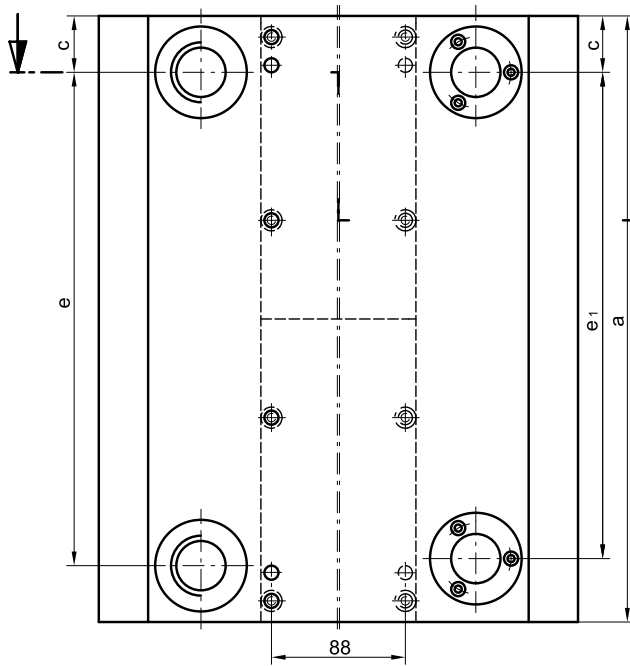
Hardened addition,
steel bushing,
bronze coating

Add size to
order number

External dimensions a x b	Grinding b1	c	e	e1	Order number ST 3712.	Order number ST 3719.	<input type="checkbox"/> x <input type="checkbox"/>
					Pillars ST 7117. d1 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 tools



Size: 3

Material:

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

Pressure plate soft, also deliverable in hardened form upon request.
(Please specify in the order: "With hardened pressure plate".)

For the segmentation:

Precision flat steel upon request

Note:

We also deliver STEINEL die sets in every special design according to your specifications. The plate dimensions correspond with the DIN/ISO sizes, as stated in our catalogue.

The die sets are manufactured according to the modular design principle and in all respects guarantee efficient use for the benefit of the customer.

Our in-stock system spring units can be used as spring systems. You have a choice of 4 different types of load (SZ 8565).

Via the middle fastening of the pillars in the guide plate and the resulting halved length of the stress application point compared to conventional pillar attachments in the upper or bottom part of the tool, these pillars can bear eight times more weight than standard pillars.

Sliding guide:

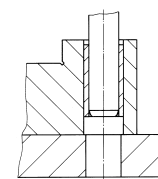
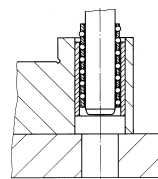
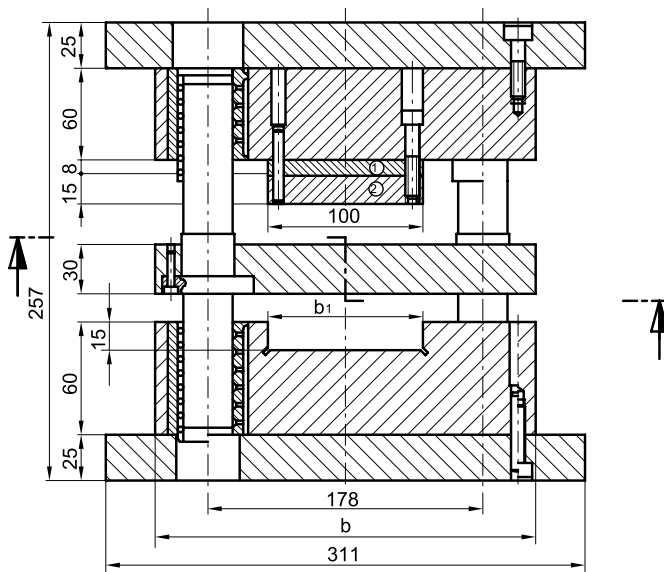
Connectable to the central lubrication (M 8 x 1).

Order example: Die set for progressive and composite tools with sliding guide steel bronze coating **ST 3719**.

Die set size a x b = 311 x 246

Addition **311 x 246**

Order number **ST 3719.311 x 246**



Ball guide:

Cage travel
= 1/2 stroke length

Sliding guide:

Hardened addition,
steel bushing,
bronze coating

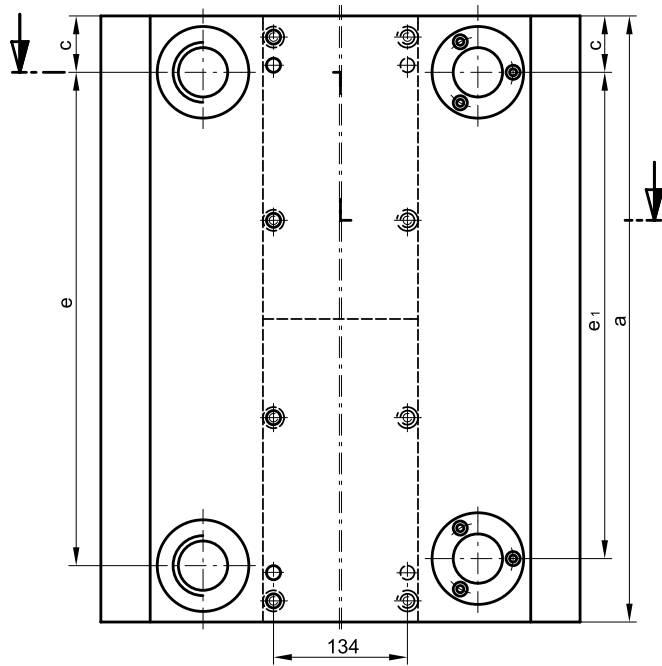
Add size to
order number

External dimensions a x b	Grinding b1	c	e	e1	Pillars ST 7117. d1 x l	Order number ST 3712.	Order number 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 tools

STEINEL®



Size: 4

Material:

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

Pressure plate soft, also deliverable in hardened form upon request.
(Please specify in the order: "With hardened pressure plate".)

For the segmentation:

Precision flat steel upon request

Note:

We also deliver STEINEL die sets in every special design according to your specifications. The plate dimensions correspond with the DIN/ISO sizes, as stated in our catalogue.

The die sets are manufactured according to the modular design principle and in all respects guarantee efficient use for the benefit of the customer.

Our in-stock system spring units can be used as spring systems. You have a choice of 4 different types of load (SZ 8565).

Via the middle fastening of the pillars in the guide plate and the resulting halved length of the stress application point compared to conventional pillar attachments in the upper or bottom part of the tool, these pillars can bear eight times more weight than standard pillars.

Sliding guide:

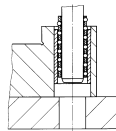
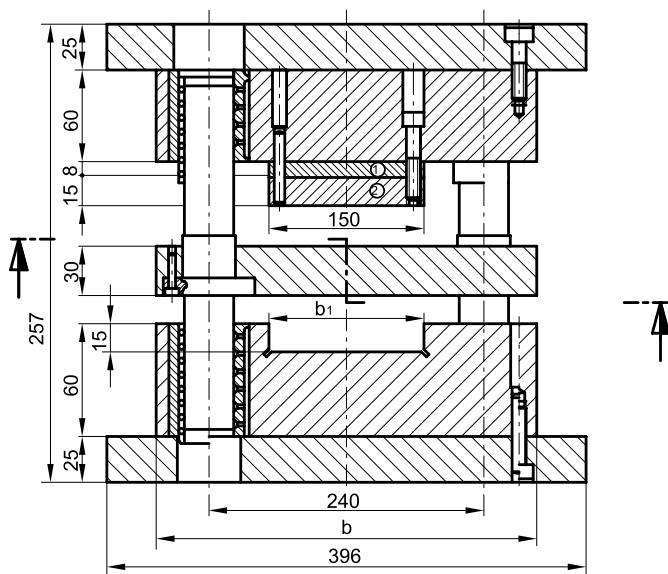
Connectable to the central lubrication (M 8 x 1).

Order example: Die set for progressive and composite tools with sliding guide steel bronze coating **ST 3719**.

Die set size a x b = 496 x 311

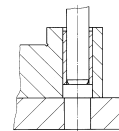
Addition **496 x 311**

Order number **ST 3719.496 x 311**



Ball guide:

Cage travel
= 1/2 stroke length



Sliding guide:

Hardened addition,
steel bushing,
bronze coating

Add size of
order number

External dimensions a x b	Grinding b1	c	e	e1	Order number ST 3712.	Order number ST 3719.	Pillars ST 7117. d1 x l	396 x 311 496 x 311 626 x 311
396 x 311	150	35	326	323			32 x 210	
496 x 311	150	35	426	423			32 x 210	
626 x 311	150	35	556	553			32 x 210	

Order sheet for progressive tool

Material:

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

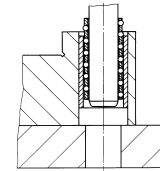
Pressure plate soft, also deliverable in hardened form upon request.
(Please specify in the order: "With hardened pressure plate".)

Enter the dimensions according to your specifications in the drawing, and mark the desired type of guidance.

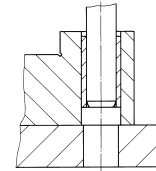
When selecting the guide unit, please note the catalogue dimensions.

Our in-stock system spring units can be used as spring systems. You have a choice of 4 different types of load (SZ 8565).

Via the middle fastening of the pillars in the guide plate and the resulting halved length of the stress application point compared to conventional pillar attachments in the upper or bottom part of the tool, these pillars can bear eight times more weight than standard pillars.



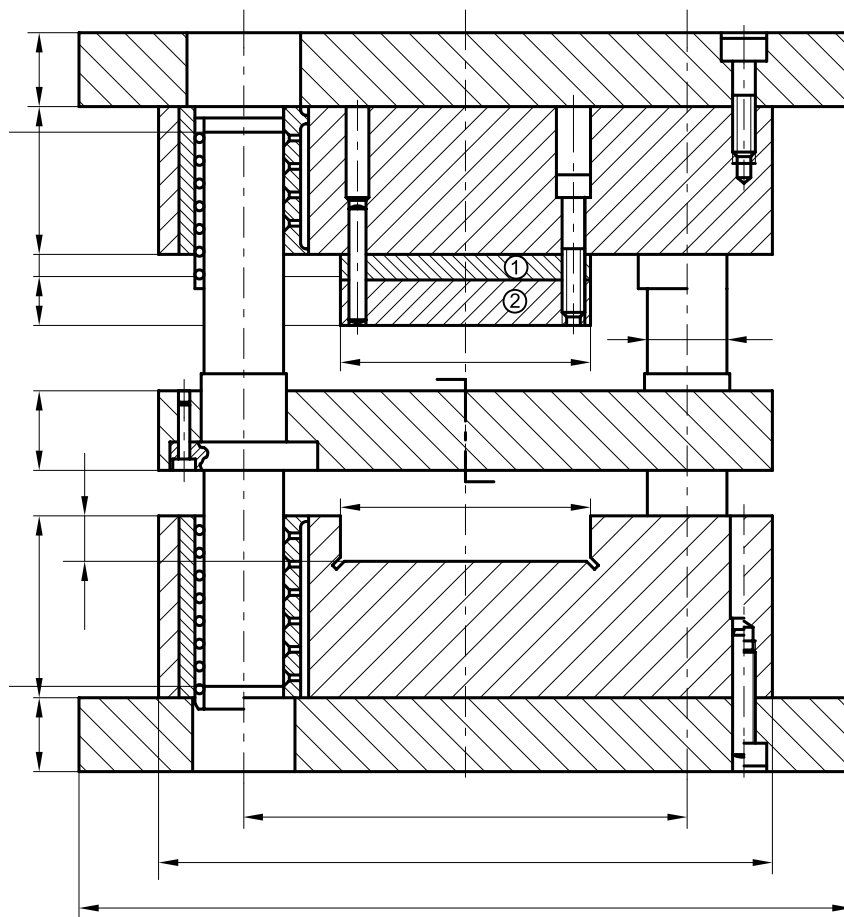
Ball guide:
Cage travel
= 1/2 stroke length



Sliding guide:
Hardened
steel bushing,
bronze coating

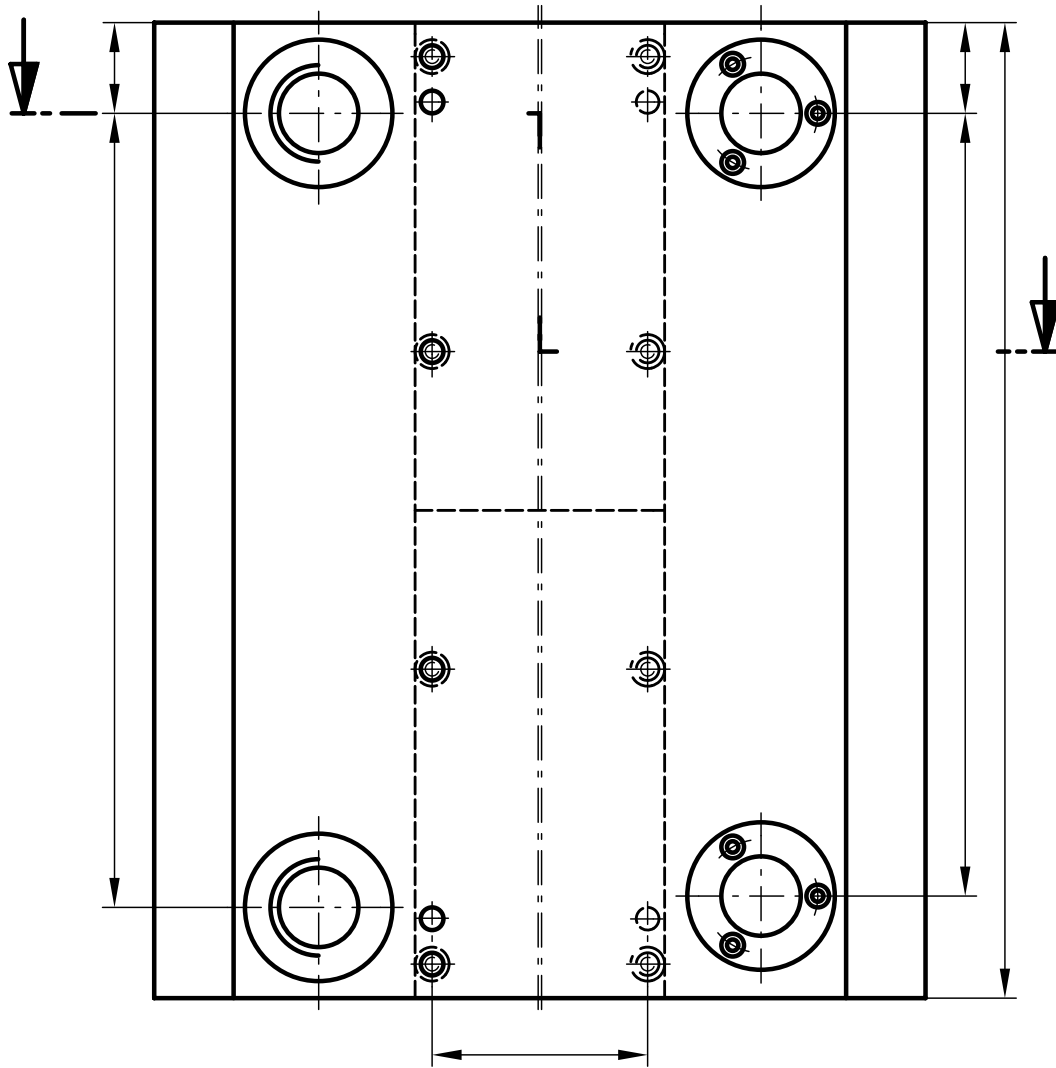


We deliver progressive and composite tools in every special design according to your specifications.



Order sheet

for progressive tool



Space for messages and notes

Company: _____

Street: _____

Postal code, city: _____

Contact person: _____

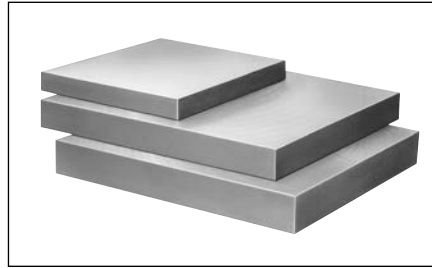
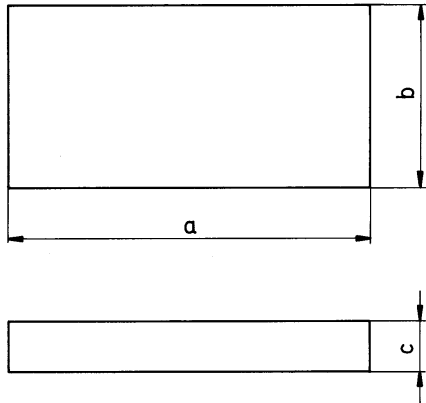
Phone: _____

Fax: _____

Date: _____

Steel plates ST 3500

for die sets



DIN ISO 6753

Material:

1.0570 (ST 52-3), other materials, e.g. super heat treated or aluminium 3.4365.77 (AlZnMgCu1.5) deliverable upon request. Tension-free annealed, both sides plane-parallel machined, ground up to 2000 x 800 mm maximum, and precision-milled. Upon request: Edge finishing or reference edges by milling or grinding. Please emphasise.

Larger steel plates can be produced in any size and shape at short notice within the maximum production range at 2000 x 1000 mm and a thickness of 20 up to 150 mm according to your specifications.

Order example: Steel plate ST 3500

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

Addition **200 x 100 x 32**

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

Add size of
order number

Order number ST 3500. <input type="text"/> x <input type="text"/> x <input type="text"/>		
a x b	c ^{+0.5} _{-0.2}	
160 x 080	25	160 x 080 x 25
	32	160 x 080 x 32
160 x 100	25	160 x 100 x 25
	32	160 x 100 x 32
160 x 125	25	160 x 125 x 25
	32	160 x 125 x 32
160 x 160	25	160 x 160 x 25
	32	160 x 160 x 32
200 x 100	25	200 x 100 x 25
	32	200 x 100 x 32
	40	200 x 100 x 40
200 x 125	25	200 x 125 x 25
	32	200 x 125 x 32
	40	200 x 125 x 40
200 x 160	25	200 x 160 x 25
	32	200 x 160 x 32
	40	200 x 160 x 40
200 x 200	25	200 x 200 x 25
	32	200 x 200 x 32
	40	200 x 200 x 40
250 x 125	25	250 x 125 x 25
	32	250 x 125 x 32
	40	250 x 125 x 40
250 x 160	25	250 x 160 x 25
	32	250 x 160 x 32
	40	250 x 160 x 40
250 x 200	25	250 x 200 x 25
	32	250 x 200 x 32
	40	250 x 200 x 40
250 x 250	25	250 x 250 x 25
	32	250 x 250 x 32
	40	250 x 250 x 40

Add size of
order number

Order number ST 3500. <input type="text"/> x <input type="text"/> x <input type="text"/>		
a x b	c ^{+0.5} _{-0.2}	
315 x 160	32	315 x 160 x 32
	40	315 x 160 x 40
	50	315 x 160 x 50
315 x 200	32	315 x 200 x 32
	40	315 x 200 x 40
	50	315 x 200 x 50
315 x 250	32	315 x 250 x 32
	40	315 x 250 x 40
	50	315 x 250 x 50
315 x 315	32	315 x 315 x 32
	40	315 x 315 x 40
	50	315 x 315 x 50
400 x 200	32	400 x 200 x 32
	40	400 x 200 x 40
	50	400 x 200 x 50
400 x 250	32	400 x 250 x 32
	40	400 x 250 x 40
	50	400 x 250 x 50
400 x 315	32	400 x 315 x 32
	40	400 x 315 x 40
	50	400 x 315 x 50
400 x 400	32	400 x 400 x 32
	40	400 x 400 x 40
	50	400 x 400 x 50
500 x 250	32	500 x 250 x 32
	40	500 x 250 x 40
	50	500 x 250 x 50
500 x 315	32	500 x 315 x 32
	40	500 x 315 x 40
	50	500 x 315 x 50
500 x 400	32	500 x 400 x 32
	40	500 x 400 x 40
	50	500 x 400 x 50

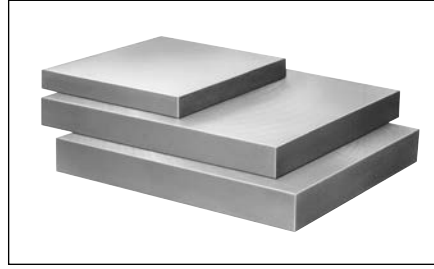
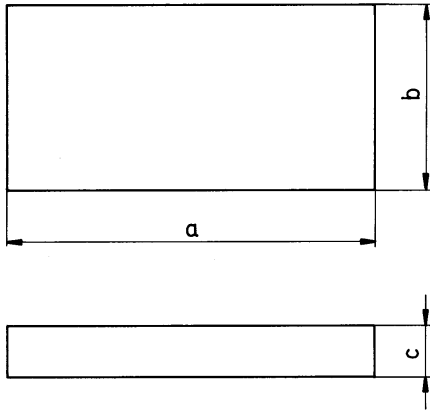
Add size of
order number

Order number ST 3500. <input type="text"/> x <input type="text"/> x <input type="text"/>		
a x b	c ^{+0.5} _{-0.2}	
500 x 500	32	500 x 500 x 32
	40	500 x 500 x 40
	50	500 x 500 x 50
630 x 315	40	630 x 315 x 40
	50	630 x 315 x 50
	63	630 x 315 x 63
630 x 400	40	630 x 400 x 40
	50	630 x 400 x 50
	63	630 x 400 x 63
630 x 500	40	630 x 500 x 40
	50	630 x 500 x 50
	63	630 x 500 x 63
630 x 630	40	630 x 630 x 40
	50	630 x 630 x 50
	63	630 x 630 x 63
710 x 400	40	710 x 400 x 40
	50	710 x 400 x 50
	63	710 x 400 x 63
710 x 500	40	710 x 500 x 40
	50	710 x 500 x 50
	63	710 x 500 x 63
710 x 630	40	710 x 630 x 40
	50	710 x 630 x 50
	63	710 x 630 x 63
800 x 400	40	800 x 400 x 40
	50	800 x 400 x 50
	63	800 x 400 x 63
800 x 500	40	800 x 500 x 40
	50	800 x 500 x 50
	63	800 x 500 x 63
800 x 630	40	800 x 630 x 40
	50	800 x 630 x 50
	63	800 x 630 x 63

Steel plates ST 3502

machined version

STEINEL®



DIN 9873

Material:

1.0570 (ST 52-3)

The plates are machined, plane-parallel ground, the front surfaces are rectangular milled. Other sizes and materials are deliverable upon request.

Note:

These plates are especially suitable for the punching tool interiors and die sets.

Order example: Steel plate **ST 3502**

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

Addition **246 x 156 x 32**

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

Add size of
order number

Order number ST 3502.	<input type="text"/> x <input type="text"/> x <input type="text"/>
$a \begin{smallmatrix} +0.4 \\ 0 \end{smallmatrix} \times b \begin{smallmatrix} +0.4 \\ 0 \end{smallmatrix}$	$c \begin{smallmatrix} +0.5 \\ +0.2 \end{smallmatrix}$
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

Add size of
order number

Order number ST 3502.	<input type="text"/> x <input type="text"/> x <input type="text"/>
$a \begin{smallmatrix} +0.4 \\ 0 \end{smallmatrix} \times b \begin{smallmatrix} +0.4 \\ 0 \end{smallmatrix}$	$c \begin{smallmatrix} +0.5 \\ +0.2 \end{smallmatrix}$
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

Add size of
order number

Order number ST 3502.	<input type="text"/> x <input type="text"/> x <input type="text"/>
$a \begin{smallmatrix} +0.4 \\ 0 \end{smallmatrix} \times b \begin{smallmatrix} +0.4 \\ 0 \end{smallmatrix}$	$c \begin{smallmatrix} +0.5 \\ +0.2 \end{smallmatrix}$
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