

## Die sets made of steel and aluminium

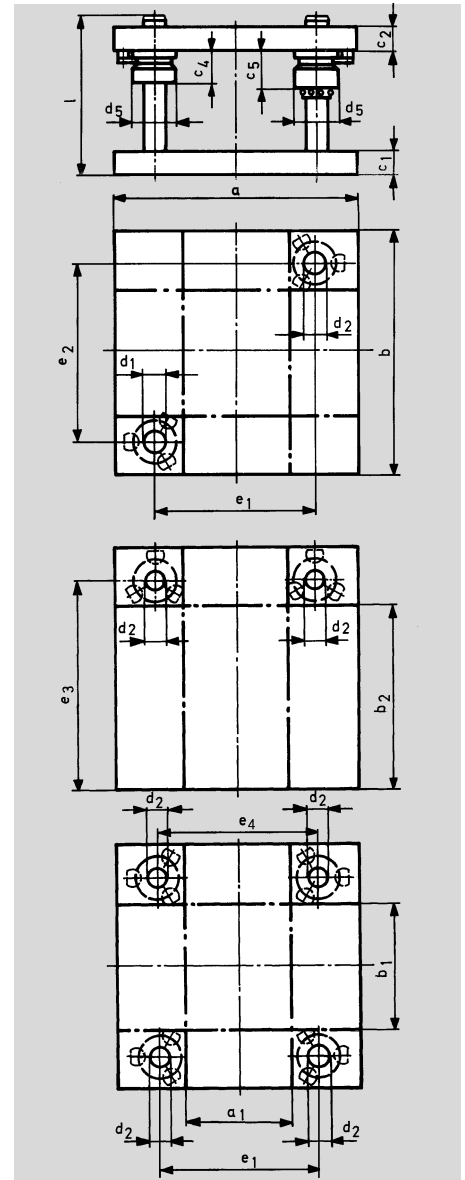
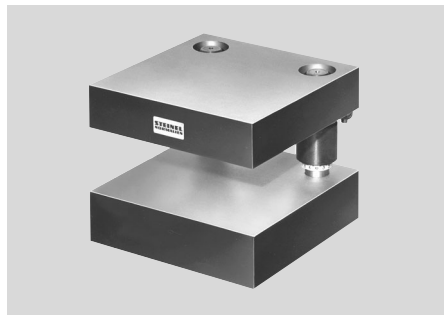
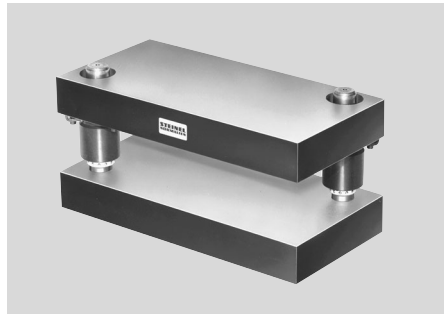
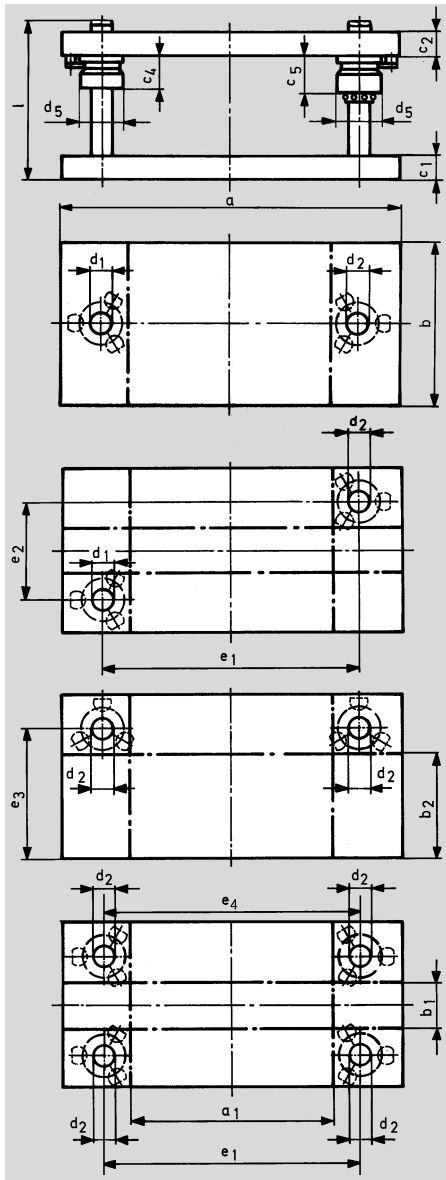
- In standardized sizes from stock or in any forms and dimensions to your drawings.
- Die sets stress-relieved, surfaces polished plane parallel. Ruptures, recesses, boreholes to your instructions.
- Sliding guides with guide bushes of hardened steel with bronze-plated treat as well as
- Ball guides,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





# Die sets ST 35..

without stripper plate



**Rectangular working area  
2 or 4 pillars**

**Material:** 1.0570 (St 52.3) aluminium on request

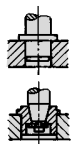
The plates are cleanly flame cut and normalized. Upon request edges finished. Please state on order.

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

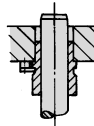
**DIN 9868**

**Different Guide pillars length on request**

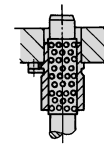
Lifting devices see under accessories



**Removable pillars upon request**  
ST 7120 or  
ST 7181/82

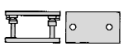


**Sliding guide**  
hardened  
steel bushing  
bronze plated  
Guide bushing with shoulder ST 7419  
medium version



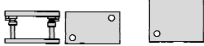
**Ball guide**  
Guide bushing with shoulder ST 7412  
long version  
Cage travel = 1/2 length of stroke

Add size and combination of plates to order number



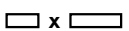
Order no. **ST 3539.**

Order no. **ST 3532.**



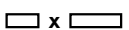
Order no. **ST 3549.**

Order no. **ST 3542.**



Order no. **ST 3559.**

Order no. **ST 3552.**



Order no. **ST 3569.**

Order no. **ST 3562.**



# Die sets ST 35..



without stripper plate

**Order example:**

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

Size a x b = 250 x 250

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

# 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

c<sub>1</sub> = 40, c<sub>2</sub> = 32

Add **250 x 250.3**

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

Add  
size and combination  
of plates  
to order number

□ x □

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

# Acceptance specifications



for die sets made of steel and aluminium

similar to DIN 9811 part 1

Sizes without tolerances

for machined surfaces: DIN 7168 – middle

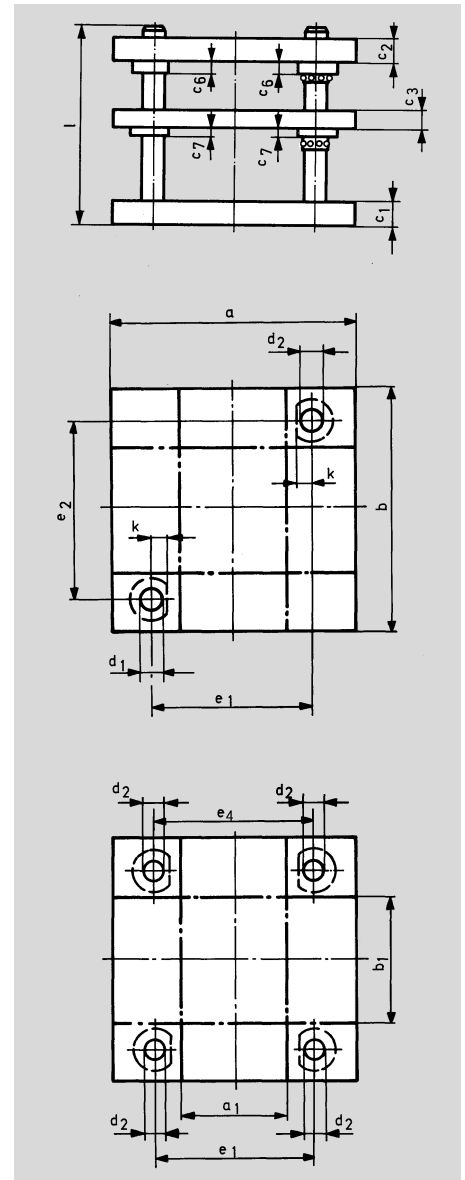
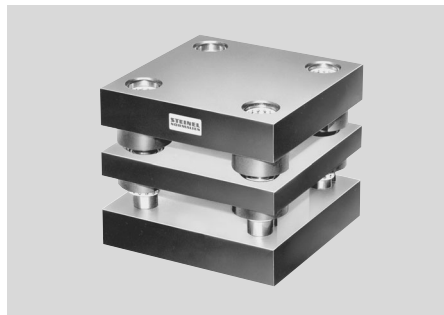
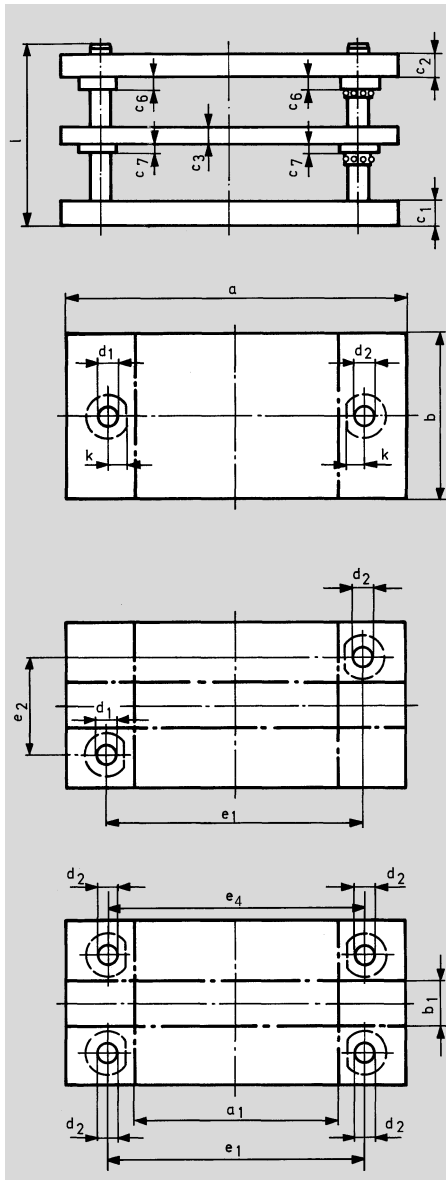
## Tolerances of flatness, parallelism and squareness

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

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

# Die sets ST 35..

with stripper plate



**Rectangular working area**  
2 or 4 pillars

**Material:** 1.0570 (St 52.3), Aluminium on request

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

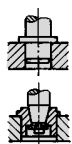
**Position of bushings**

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

**DIN 9868**

**Different Guide pillars length on request**

Lifting devices see under accessories

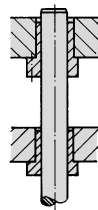


**Sliding guide**

hardened steel bushing, bronze-plated with flange ST 7429

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

Stripper plate: Guide bushings short version



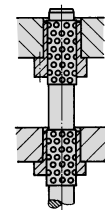
**Ball guide**

Guide bushings with flange ST 7422

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

Stripper plate: Guide bushings short version

Cage travel = 1/2 length of stroke



**Removable pillars upon request**

ST 7120  
ST 7181/82

Add size and combination of plates to order number



Order no. **ST 3579.**

Order no. **ST 3572.**

x



Order no. **ST 3589.**

Order no. **ST 3582.**

x



Order no. **ST 3599.**

Order no. **ST 3592.**

x

# Die sets ST 35..



## with stripper plate

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

**ST 3592**

Size a x b = 500 x 500

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



# 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

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

# Stamping Block ST 3730



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

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

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

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

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

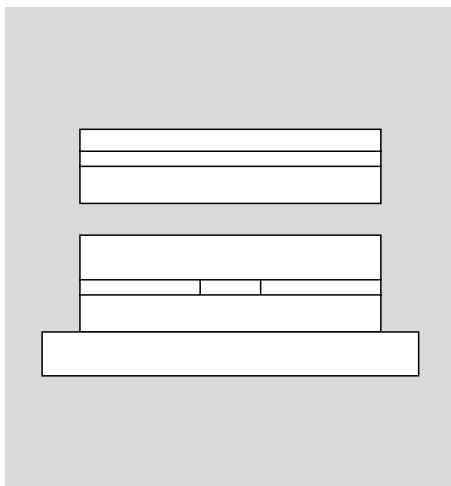
**Tip:** STEINEL-stamping blocks can also be made to your specifications, such as with radius corner set edges, tapped holes for clamping, etc.

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

Stamping block size a x b = 196 x 96

Add **196 x 096**

Order number **ST 3730.196 x 096**



**Ground parallel:**

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

**Tolerances:**

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

**Screws in die block:**

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

**Screws in punch holder:**

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

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

**Material**

**Punch holder**

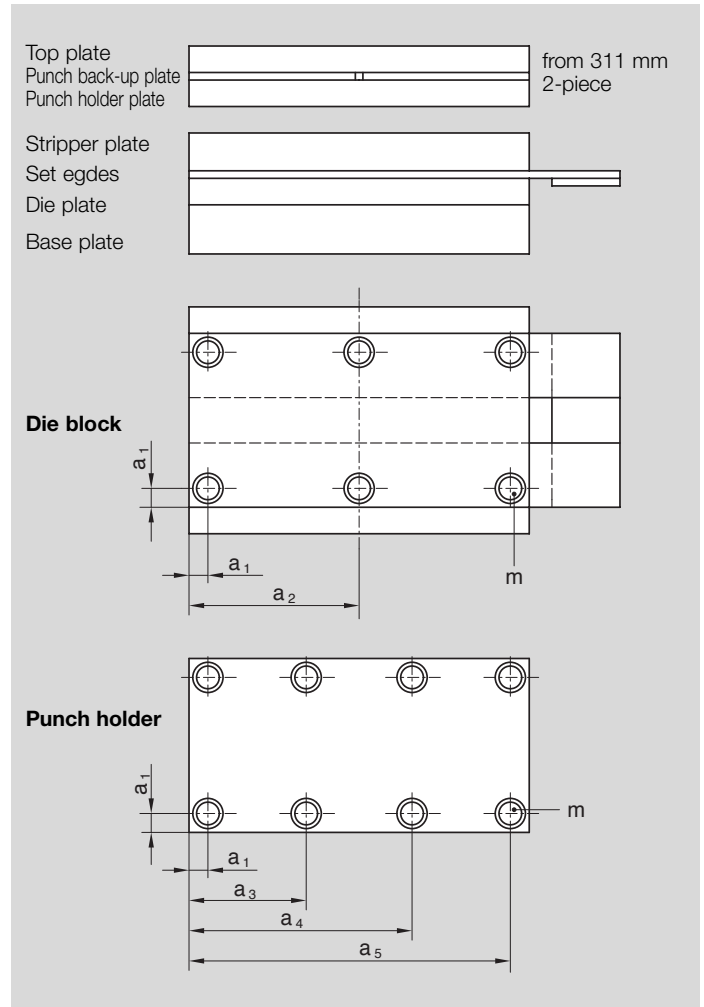
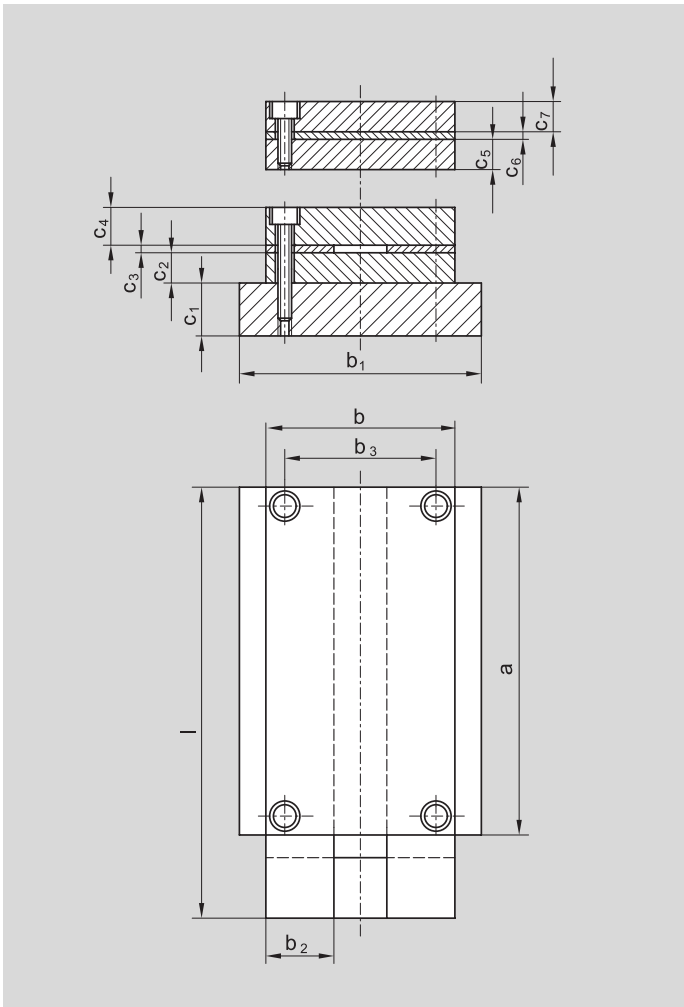
Material number

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

**Die block**

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

# Stamping Block ST 3730



Add size to order number

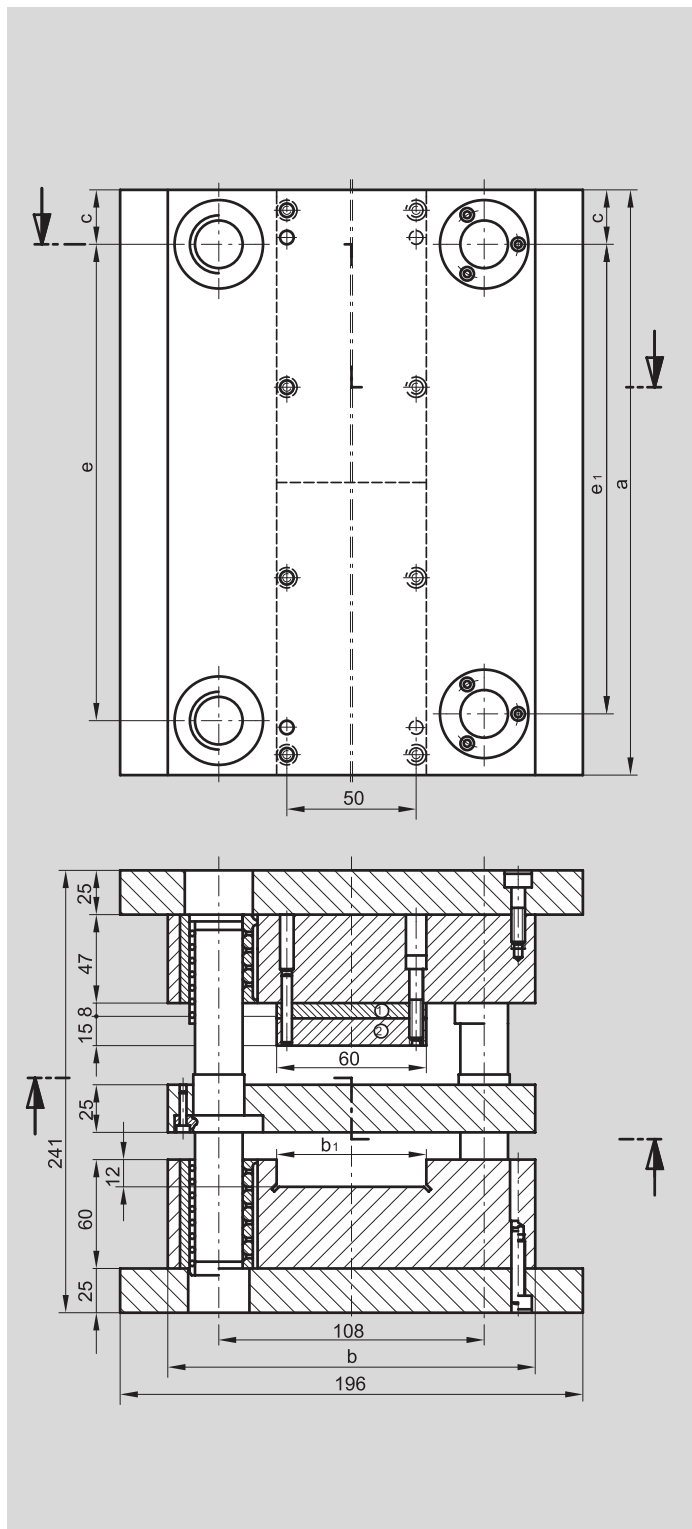
Order number **ST 3730.**  x

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

# Die sets **ST 3712, ST 3719**



for progressive and compound tools



### Progressive and compound tools size: 1

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

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

**For segmentation:** Precision steel plate on request.

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

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

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

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

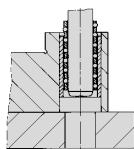
**Sliding guides:** can be connected with central lubrication (M 8 x 1).

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

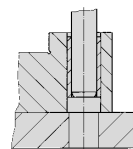
Mount size a x b = 246 x 156

Add **246 x 156**

Order number **ST 3719.246 x 156**



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



**Sliding guide**  
hardened  
bronze plated  
steel bushing

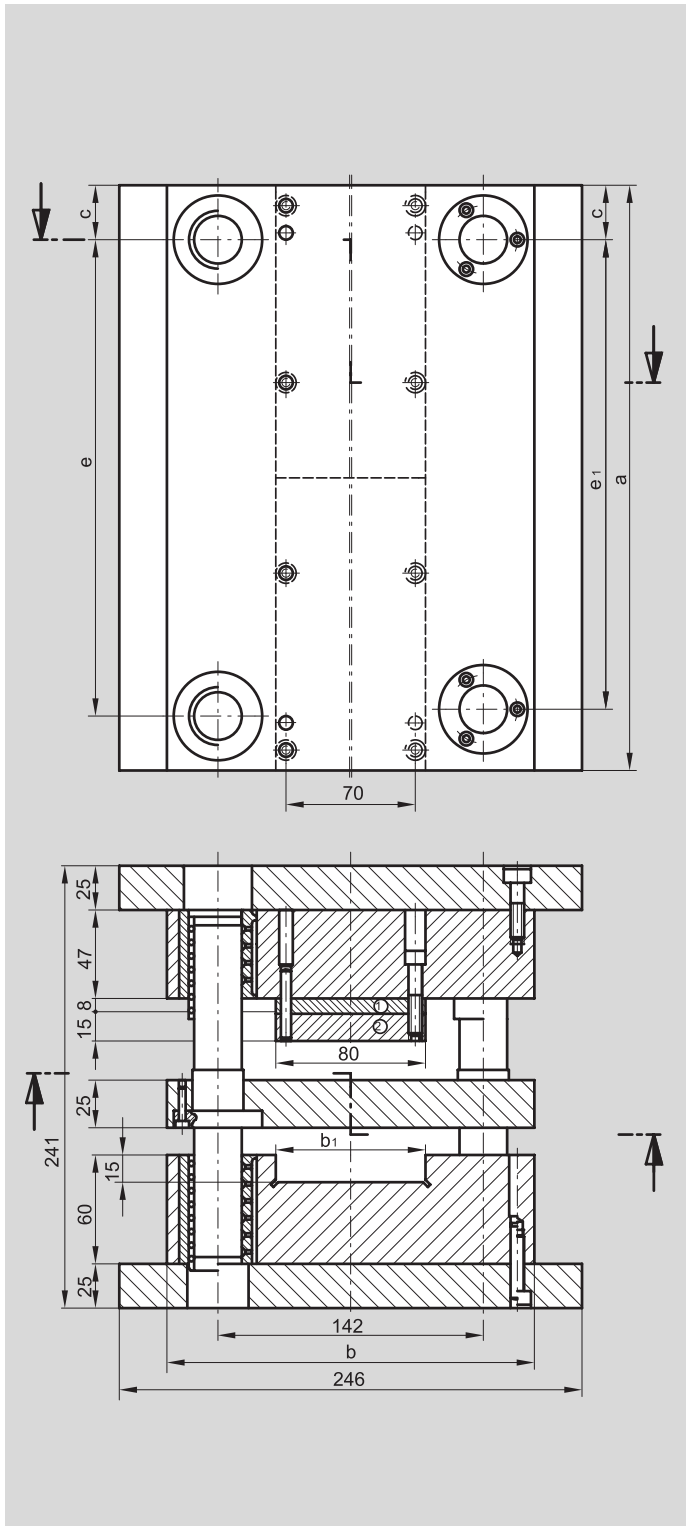
Add  
size to  
order number

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

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

# Die sets ST 3712, ST 3719

for progressive and compound tools



### Progressive and compound tools size: 2

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

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

**For segmentation:** Precision steel plate on request.

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

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

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

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

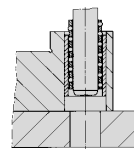
**Sliding guides:** can be connected with central lubrication (M 8 x 1).

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

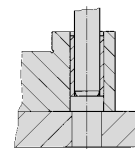
Mount size a x b = 311 x 196

Add **311 x 196**

Order number **ST 3719.311 x 196**



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



**Sliding guide**  
hardened  
bronze plated  
steel bushing

Add  
size to  
order number

Order number **ST 3712**

Order number **ST 3719**

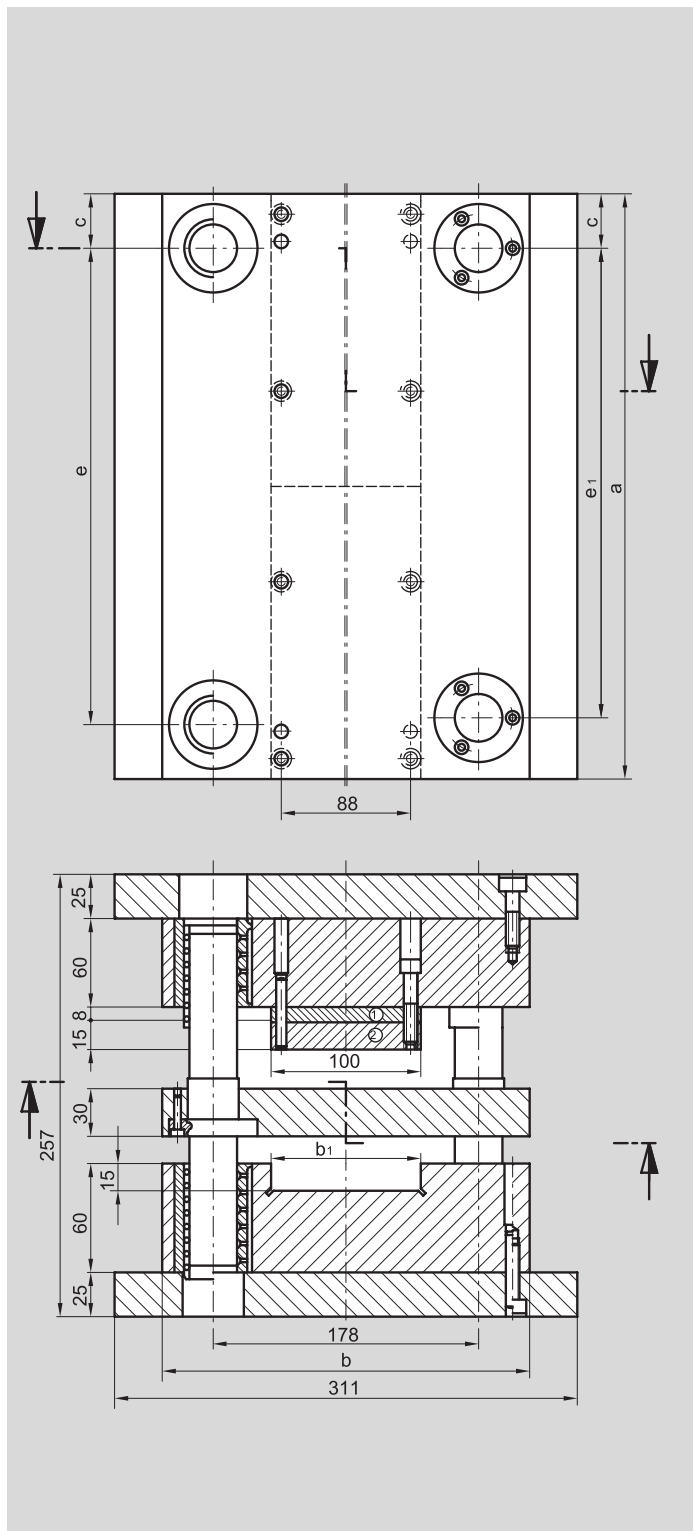
x

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

# Die sets **ST 3712, ST 3719**



for progressive and compound tools



### Progressive and compound tools size: 3

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

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

**For segmentation:** Precision steel plate on request.

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

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

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

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

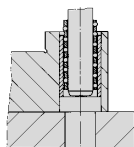
**Sliding guides:** can be connected with central lubrication (M 8 x 1).

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

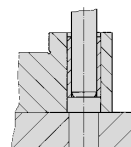
Mount size a x b = 311 x 246

Add **311 x 246**

Order number **ST 3719.311 x 246**



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



**Sliding guide**  
hardened  
bronze plated  
steel bushing

Add  
size to  
order number

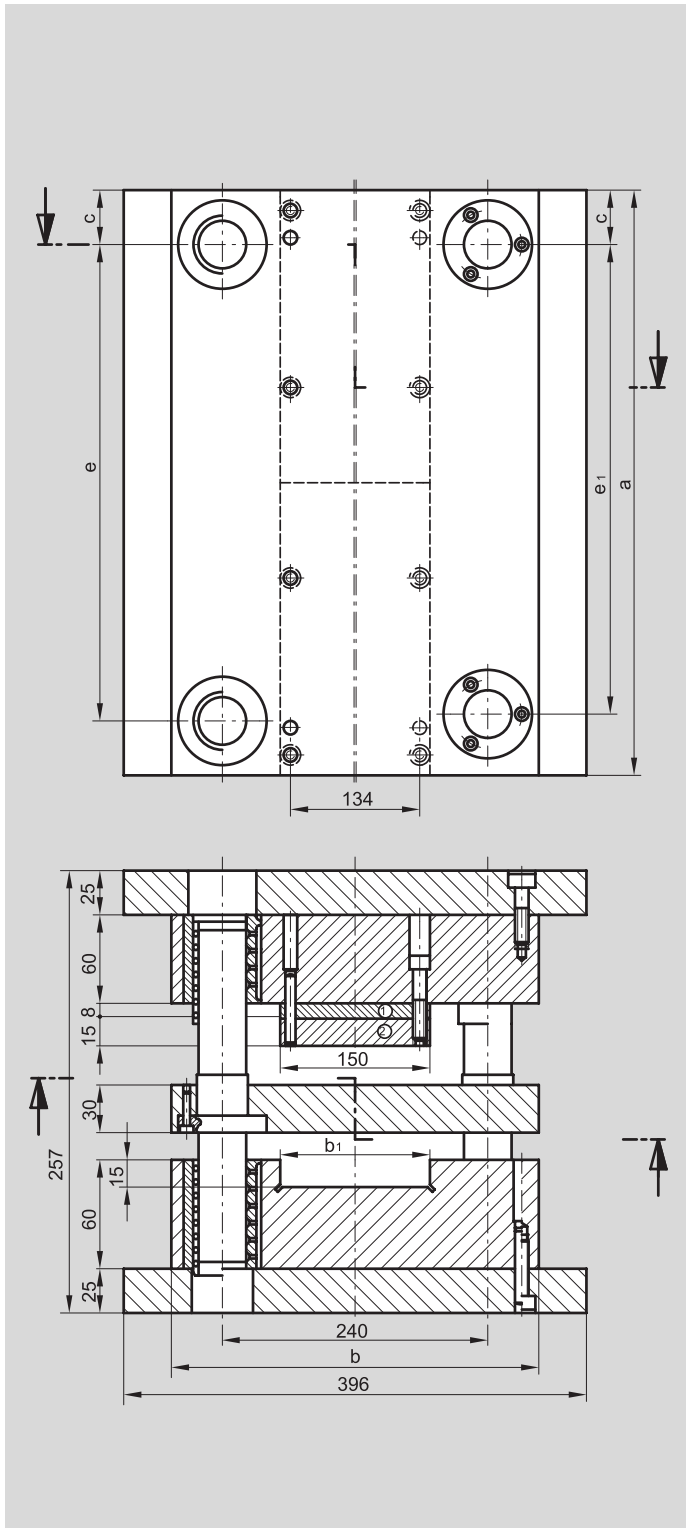
Order number **ST 3712**    Order number **ST 3719**     x

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

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

# Die sets **ST 3712 ST 3719**

for progressive and compound tools



**Progressive and compound tools size: 4**

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

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

**For segmentation:** Precision steel plate on request.

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

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

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

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

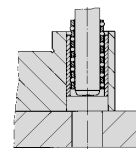
**Sliding guides:** can be connected with central lubrication (M 8 x 1).

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

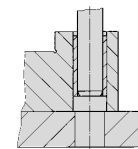
Mount size a x b = 496 x 311

Add **496 x 311**

Order number **ST 3719.496 x 311**



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



**Sliding guide**  
hardened  
bronze plated  
steel bushing

Add size to order number

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

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

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

# Order sheet for



## Progressive and compound tools (Die Sets)

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

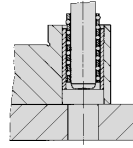
Soft pressure plate, upon request can also be delivered hardened.  
(Please indicate on your order: "With hardened pressure plate").

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

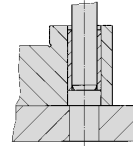
When choosing guide elements/units, please note the catalogue dimensions given in section 3.

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

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



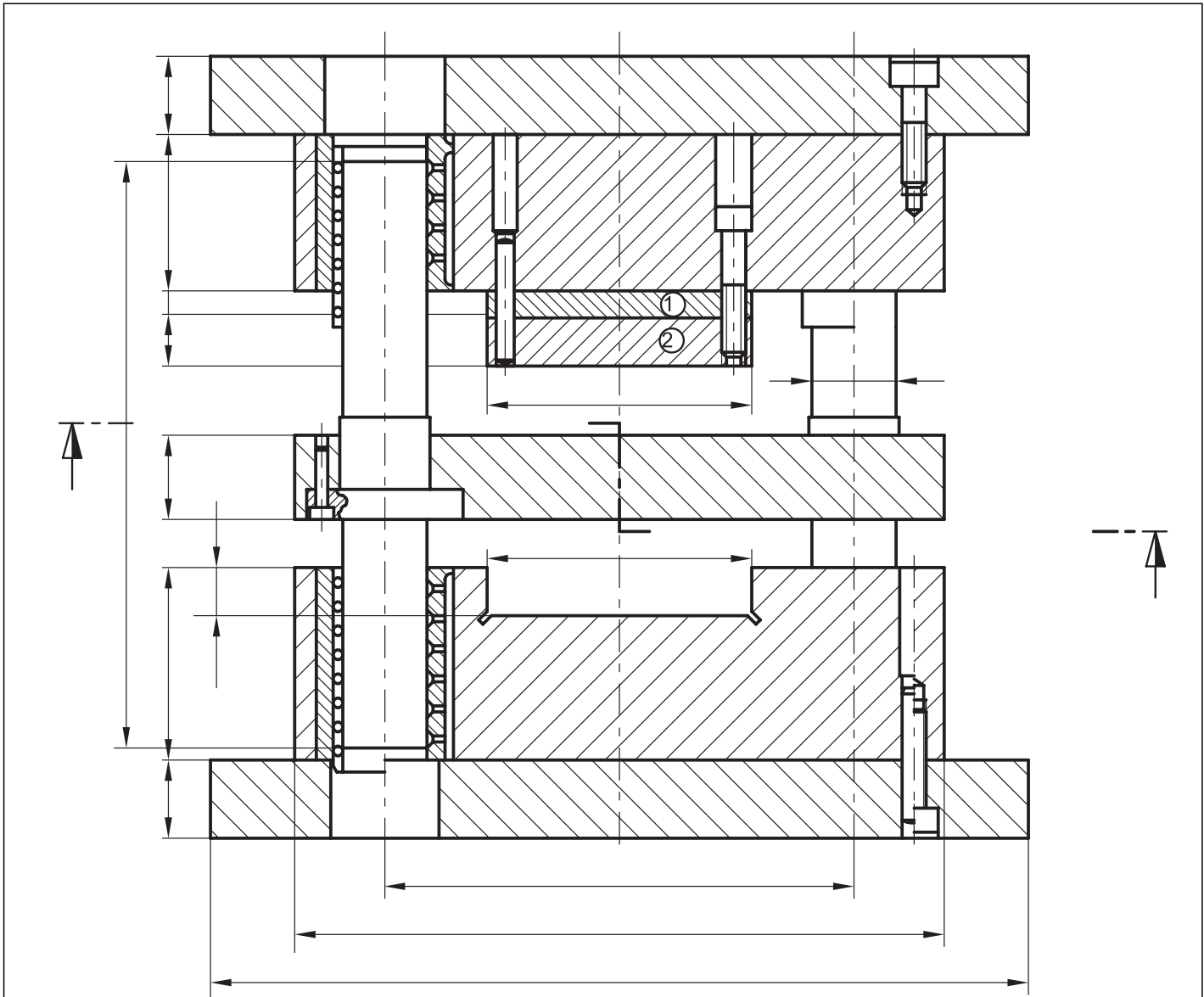
**Ball guide**  
Cage travel  
= 1/2 length of stroke



**Sliding guide**  
hardened  
steel bushing  
bronze-plated



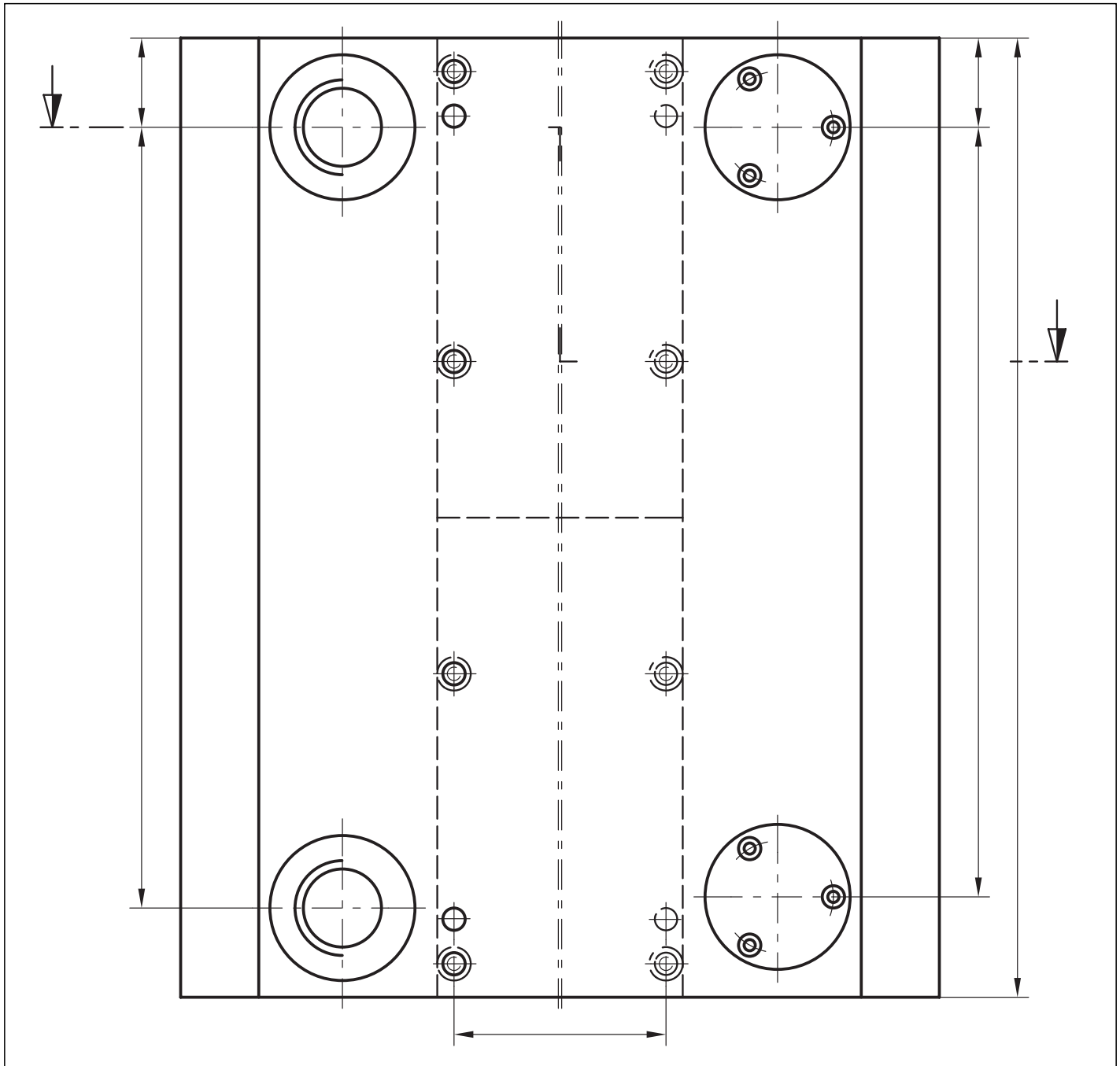
**Progressive and compound tools can be supplied in special designs according to your specifications.**





# Order sheet for

## Progressive and compound tools (Die Sets)



Room/Space for messages/information and notes

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Company:

Street address:

City, State, Zip Code:

Contact Person:

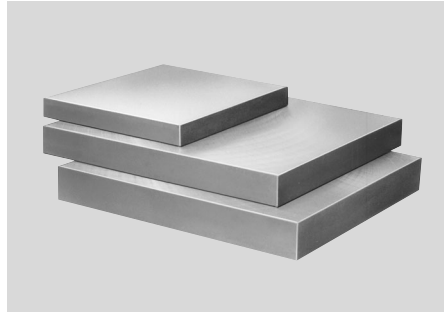
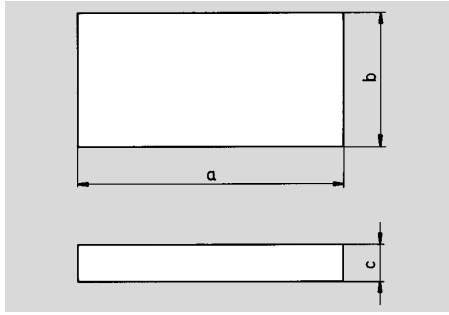
Telephone Number.:

Fax Number.:

Date:

# Steel plates ST 3500

for die sets



**DIN 9873, ISO 6753**

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

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

**Order example:** steel plate **ST 3500**

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

Add **200 x 100 x 32**

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

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

a x b	c <sup>+0,5</sup> / <sub>-0,2</sub>	▲
160 x 080	25 32	<b>160 x 080 x 25</b> <b>160 x 080 x 32</b>
160 x 100	25 32	<b>160 x 100 x 25</b> <b>160 x 100 x 32</b>
160 x 125	25 32	<b>160 x 125 x 25</b> <b>160 x 125 x 32</b>
160 x 160	25 32	<b>160 x 160 x 25</b> <b>160 x 160 x 32</b>
200 x 100	25 32 40	<b>200 x 100 x 25</b> <b>200 x 100 x 32</b> <b>200 x 100 x 40</b>
200 x 125	25 32 40	<b>200 x 125 x 25</b> <b>200 x 125 x 32</b> <b>200 x 125 x 40</b>
200 x 160	25 32 40	<b>200 x 160 x 25</b> <b>200 x 160 x 32</b> <b>200 x 160 x 40</b>
200 x 200	25 32 40	<b>200 x 200 x 25</b> <b>200 x 200 x 32</b> <b>200 x 200 x 40</b>
250 x 125	25 32 40	<b>250 x 125 x 25</b> <b>250 x 125 x 32</b> <b>250 x 125 x 40</b>
250 x 160	25 32 40	<b>250 x 160 x 25</b> <b>250 x 160 x 32</b> <b>250 x 160 x 40</b>
250 x 200	25 32 40	<b>250 x 200 x 25</b> <b>250 x 200 x 32</b> <b>250 x 200 x 40</b>
250 x 250	25 32 40	<b>250 x 250 x 25</b> <b>250 x 250 x 32</b> <b>250 x 250 x 40</b>

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

a x b	c <sup>+0,5</sup> / <sub>-0,2</sub>	▲
315 x 160	32 40 50	<b>315 x 160 x 32</b> <b>315 x 160 x 40</b> <b>315 x 160 x 50</b>
315 x 200	32 40 50	<b>315 x 200 x 32</b> <b>315 x 200 x 40</b> <b>315 x 200 x 50</b>
315 x 250	32 40 50	<b>315 x 250 x 32</b> <b>315 x 250 x 40</b> <b>315 x 250 x 50</b>
315 x 315	32 40 50	<b>315 x 315 x 32</b> <b>315 x 315 x 40</b> <b>315 x 315 x 50</b>
400 x 200	32 40 50	<b>400 x 200 x 32</b> <b>400 x 200 x 40</b> <b>400 x 200 x 50</b>
400 x 250	32 40 50	<b>400 x 250 x 32</b> <b>400 x 250 x 40</b> <b>400 x 250 x 50</b>
400 x 315	32 40 50	<b>400 x 315 x 32</b> <b>400 x 315 x 40</b> <b>400 x 315 x 50</b>
400 x 400	32 40 50	<b>400 x 400 x 32</b> <b>400 x 400 x 40</b> <b>400 x 400 x 50</b>
500 x 250	32 40 50	<b>500 x 250 x 32</b> <b>500 x 250 x 40</b> <b>500 x 250 x 50</b>
500 x 315	32 40 50	<b>500 x 315 x 32</b> <b>500 x 315 x 40</b> <b>500 x 315 x 50</b>
500 x 400	32 40 50	<b>500 x 400 x 32</b> <b>500 x 400 x 40</b> <b>500 x 400 x 50</b>

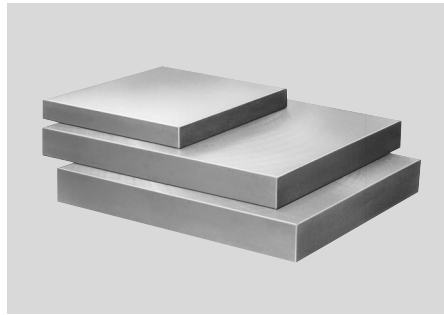
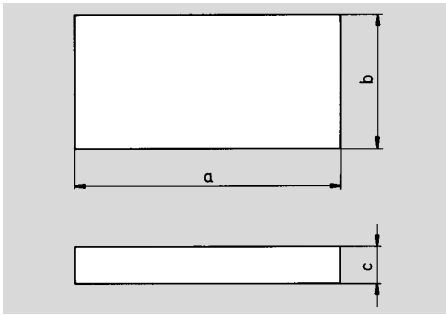
Order number **ST 3500.**  x  x  Add size to order number

a x b	c <sup>+0,5</sup> / <sub>-0,2</sub>	▲
500 x 500	32 40 50	<b>500 x 500 x 32</b> <b>500 x 500 x 40</b> <b>500 x 500 x 50</b>
630 x 315	40 50 63	<b>630 x 315 x 40</b> <b>630 x 315 x 50</b> <b>630 x 315 x 63</b>
630 x 400	40 50 63	<b>630 x 400 x 40</b> <b>630 x 400 x 50</b> <b>630 x 400 x 63</b>
630 x 500	40 50 63	<b>630 x 500 x 40</b> <b>630 x 500 x 50</b> <b>630 x 500 x 63</b>
630 x 630	40 50 63	<b>630 x 630 x 40</b> <b>630 x 630 x 50</b> <b>630 x 630 x 63</b>
710 x 400	40 50 63	<b>710 x 400 x 40</b> <b>710 x 400 x 50</b> <b>710 x 400 x 63</b>
710 x 500	40 50 63	<b>710 x 500 x 40</b> <b>710 x 500 x 50</b> <b>710 x 500 x 63</b>
710 x 630	40 50 63	<b>710 x 630 x 40</b> <b>710 x 630 x 50</b> <b>710 x 630 x 63</b>
800 x 400	40 50 63	<b>800 x 400 x 40</b> <b>800 x 400 x 50</b> <b>800 x 400 x 63</b>
800 x 500	40 50 63	<b>800 x 500 x 40</b> <b>800 x 500 x 50</b> <b>800 x 500 x 63</b>
800 x 630	40 50 63	<b>800 x 630 x 40</b> <b>800 x 630 x 50</b> <b>800 x 630 x 63</b>

# Steel plate ST 3502



## Machined type



### DIN 9873

**Material:** 1.0570 (ST 52-3)

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

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

**Order example:** Steel plate **ST 3502**

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

Add **246 x 156 x 32**

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

Order number <b>ST 3502.</b>	<input type="checkbox"/> x <input type="checkbox"/> x <input type="checkbox"/>	Add size to order number
$a^{+0.4} \times b^{+0.4}$	$c^{+0.5}_{+0.2}$	▲
156 x 076	25 32	<b>156 x 076 x 25</b> <b>156 x 076 x 32</b>
156 x 096	25 32	<b>156 x 096 x 25</b> <b>156 x 096 x 32</b>
156 x 121	25 32	<b>156 x 121 x 25</b> <b>156 x 121 x 32</b>
156 x 156	25 32	<b>156 x 156 x 25</b> <b>156 x 156 x 32</b>
196 x 096	25 32 40	<b>196 x 096 x 25</b> <b>196 x 096 x 32</b> <b>196 x 096 x 40</b>
196 x 121	25 32 40	<b>196 x 121 x 25</b> <b>196 x 121 x 32</b> <b>196 x 121 x 40</b>
196 x 156	25 32 40	<b>196 x 156 x 25</b> <b>196 x 156 x 32</b> <b>196 x 156 x 40</b>
196 x 196	25 32 40	<b>196 x 196 x 25</b> <b>196 x 196 x 32</b> <b>196 x 196 x 40</b>
246 x 121	25 32 40	<b>246 x 121 x 25</b> <b>246 x 121 x 32</b> <b>246 x 121 x 40</b>
246 x 156	25 32 40	<b>246 x 156 x 25</b> <b>246 x 156 x 32</b> <b>246 x 156 x 40</b>
246 x 196	25 32 40	<b>246 x 196 x 25</b> <b>246 x 196 x 32</b> <b>246 x 196 x 40</b>
246 x 246	25 32 40	<b>246 x 246 x 25</b> <b>246 x 246 x 32</b> <b>246 x 246 x 40</b>

Order number <b>ST 3502.</b>	<input type="checkbox"/> x <input type="checkbox"/> x <input type="checkbox"/>	Add size to order number
$a^{+0.4} \times b^{+0.4}$	$c^{+0.5}_{+0.2}$	▲
311 x 156	32 40 50	<b>311 x 156 x 32</b> <b>311 x 156 x 40</b> <b>311 x 156 x 50</b>
311 x 196	32 40 50	<b>311 x 196 x 32</b> <b>311 x 196 x 40</b> <b>311 x 196 x 50</b>
311 x 246	32 40 50	<b>311 x 246 x 32</b> <b>311 x 246 x 40</b> <b>311 x 246 x 50</b>
311 x 311	32 40 50	<b>311 x 311 x 32</b> <b>311 x 311 x 40</b> <b>311 x 311 x 50</b>
396 x 196	32 40 50	<b>396 x 196 x 32</b> <b>396 x 196 x 40</b> <b>396 x 196 x 50</b>
396 x 246	32 40 50	<b>396 x 246 x 32</b> <b>396 x 246 x 40</b> <b>396 x 246 x 50</b>
396 x 311	32 40 50	<b>396 x 311 x 32</b> <b>396 x 311 x 40</b> <b>396 x 311 x 50</b>
396 x 396	32 40 50	<b>396 x 396 x 32</b> <b>396 x 396 x 40</b> <b>396 x 396 x 50</b>
496 x 246	32 40 50	<b>496 x 246 x 32</b> <b>496 x 246 x 40</b> <b>496 x 246 x 50</b>
496 x 311	32 40 50	<b>496 x 311 x 32</b> <b>496 x 311 x 40</b> <b>496 x 311 x 50</b>
496 x 396	32 40 50	<b>496 x 396 x 32</b> <b>496 x 396 x 40</b> <b>496 x 396 x 50</b>
496 x 496	32 40 50	<b>496 x 496 x 32</b> <b>496 x 496 x 40</b> <b>496 x 496 x 50</b>

Order number <b>ST 3502.</b>	<input type="checkbox"/> x <input type="checkbox"/> x <input type="checkbox"/>	Add size to order number
$a^{+0.4} \times b^{+0.4}$	$c^{+0.5}_{+0.2}$	▲
626 x 311	40 50 63	<b>626 x 311 x 40</b> <b>626 x 311 x 50</b> <b>626 x 311 x 63</b>
626 x 396	40 50 63	<b>626 x 396 x 40</b> <b>626 x 396 x 50</b> <b>626 x 396 x 63</b>
626 x 496	40 50 63	<b>626 x 496 x 40</b> <b>626 x 496 x 50</b> <b>626 x 496 x 63</b>
626 x 626	40 50 63	<b>626 x 626 x 40</b> <b>626 x 626 x 50</b> <b>626 x 626 x 63</b>
706 x 396	40 50 63	<b>706 x 396 x 40</b> <b>706 x 396 x 50</b> <b>706 x 396 x 63</b>
706 x 496	40 50 63	<b>706 x 496 x 40</b> <b>706 x 496 x 50</b> <b>706 x 496 x 63</b>
706 x 626	40 50 63	<b>706 x 626 x 40</b> <b>706 x 626 x 50</b> <b>706 x 626 x 63</b>
796 x 396	40 50 63	<b>796 x 396 x 40</b> <b>796 x 396 x 50</b> <b>796 x 396 x 63</b>
796 x 496	40 50 63	<b>796 x 496 x 40</b> <b>796 x 496 x 50</b> <b>796 x 496 x 63</b>
796 x 626	40 50 63	<b>796 x 626 x 40</b> <b>796 x 626 x 50</b> <b>796 x 626 x 63</b>

# Die sets made of steel

## and aluminium according to drawing

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

### Plate machining

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

**2000 x 800 mm**

Larger plates finally milled up to:

**2500 x 1250 mm**

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

Further dimensions available on request.

### Machining services

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

