



Märkische Stanz-Partner



[säulengestelle]

[diesets]

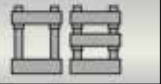
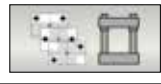
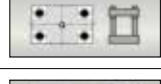
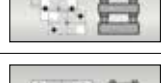
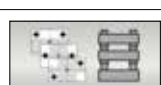
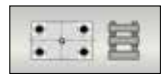
Stand / Revision Status 01.07.2020

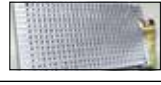
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SÄULENGESTELLE / DIE SETS



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	3 Platten, 2 Säulen, Typ A-C-D	3 plates, 2 leader pins, types A-C-D	SG 3 .	SG. 9 - 12
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Toleranzangaben für Säulengestelle aus Stahl

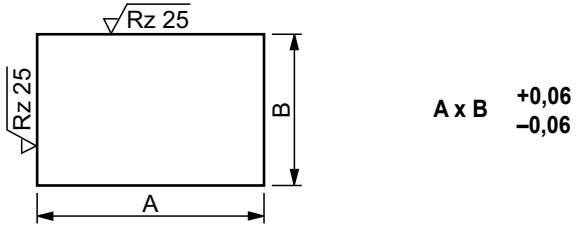
Tolerance - information regarding steel die sets

SÄULENGESTELLE / DIE SETS

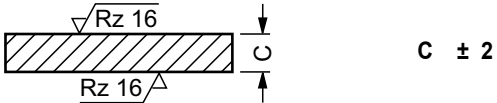


Mat.: C45

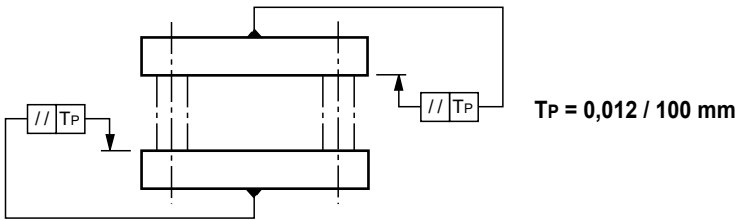
Toleranz Außenmaße /
Tolerance of length and width



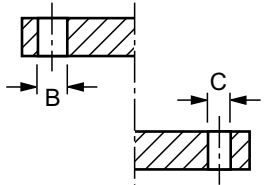
Toleranz Plattenstärke /
Tolerance of thickness



Parallelität der Flächenpaare /
Parallelism of two surfaces



Bohrungstoleranzen /
Hole tolerances



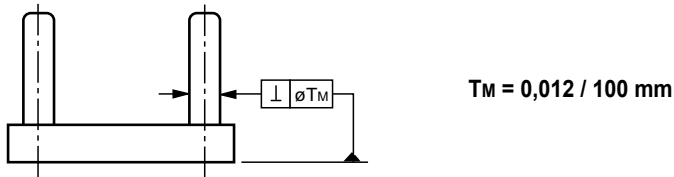
B = Aufnahmebohrung Buchse/ Mounting hole for bushing:

FS 468 = K7
FS 4 .. = H6
FS 6 .. = H6
FS 7 .. = H6

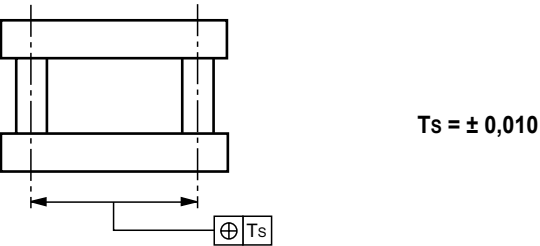
C = Aufnahmebohrung Säule/ Mounting hole for leader pin:

FS 420 = R7
FS 419 = JS6
FS 400/403 = H6

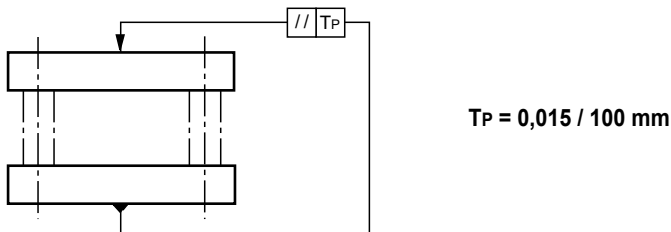
Winkelgenauigkeit der Führungssäulen /
Angular accuracy of leader pins



Toleranz Systemabstände /
Tolerance of dimensions between leader-
pin (and bushing) - holes



Planparallelität im
zusammengebauten Zustand /
Parallelism after mounting

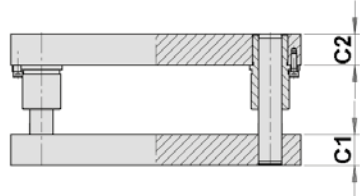
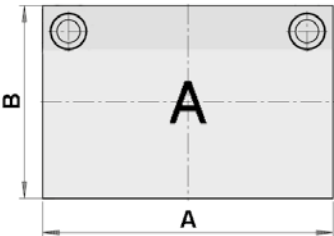
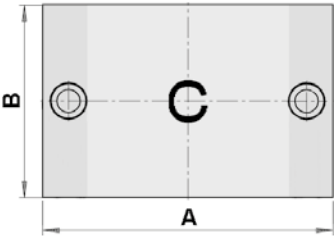
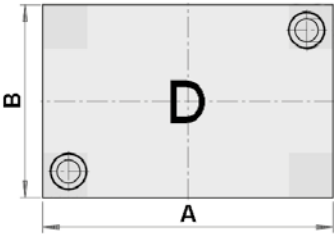
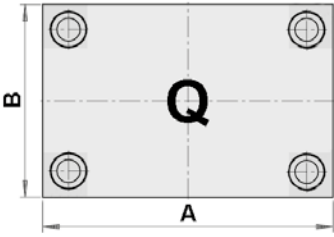
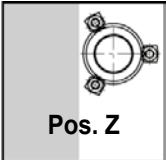
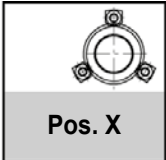


Säulen-Buchsen-Kombination für 2-Plattengestelle

Combination of leader-pin and -bushing in 2-plate-die-sets

SÄULENGESTELLE / DIE SETS

Bestellbeispiel / Order-example

2 C	643	P	41	Z
Gestelltyp Type of die set	Kataloggröße Catalog sizes	Säulentyp Type of leader pin	Buchsentyp Type of bushing	Position der Haltestücke Position of holding clamps
Gestelltyp / Type of die set				
    				
Position der Haltestücke / Position of holding clamps				
 				

[SG.2]

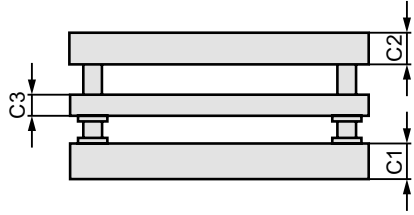
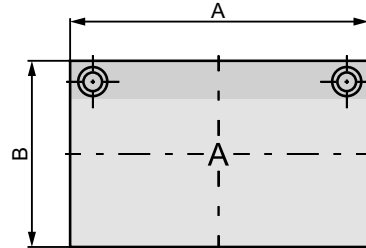
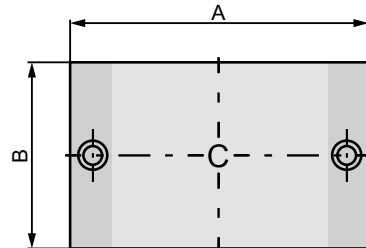
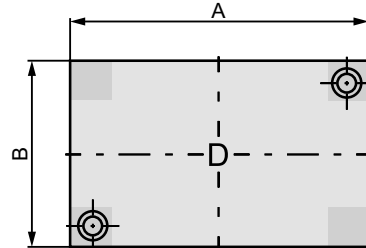
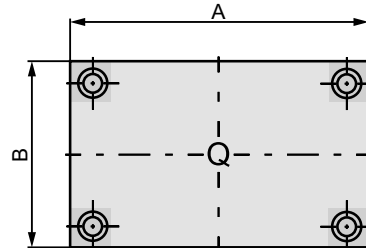
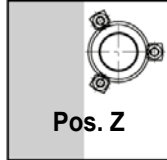
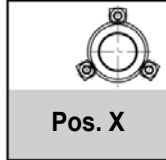


Säulen-Buchsen-Kombination für 3-Plattengestelle

Combination of leader-pin and -bushing in 3-plate-die-sets

SÄULENGESTELLE / DIE SETS

Bestellbeispiel / Order-example

3 C	643	P	71	Z
Gestelltyp Type of die set	Kataloggröße Catalog sizes	Säulentyp Type of leader pin	Buchsentyp Type of bushing	Position der Haltestücke Position of holding clamps
Gestelltyp / Type of die set				
    				
Position der Haltestücke / Position of holding clamps				
 				

[SG.3]



Bestellbeispiel Sondergrößen

Order-example specials

SÄULENGESTELLE / DIE SETS

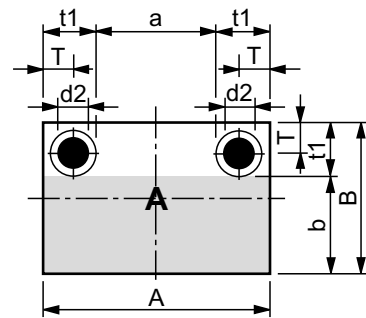
Position	Platten- maße Plate length and width	Platten- stärke Plate thickness			Säulentyp in C1 oder C2* Type of leader pin in C1 or C2*		Buchsentyp in C1 oder C2** Type of bushing in C1 or C2**		Buchsentyp in C3 Type of bushing in C3		Haltestück- position Position of hol- ding clamps
Position	A x B	C1	C2	C3	FS ...	d1 x l	FS ...	d x l	FS ...	d x l	
Q	610 x 494	78	48	38	420	40/42 x 250	632	40/42 x 67	631	40/42 x 51	X

* = Säulentyp in C1 oder C2 bitte angeben. / Please fill in type of leader pin in C1 or C2.

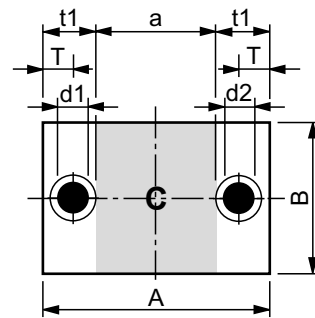
** = Buchsentyp in C1 oder C2 bitte angeben. / Please fill in type of bushing in C1 or C2.

Arbeitsflächen / Working areas

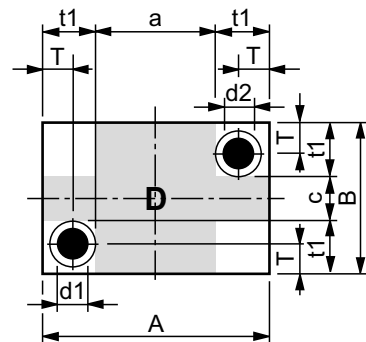
b = B - t₁



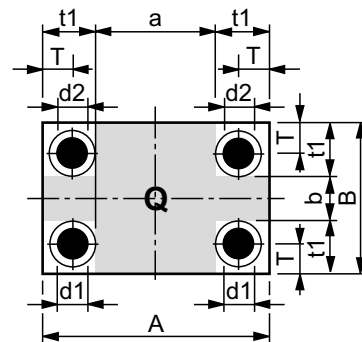
a = A - (2 x t₁)



a = A - (2 x t₁)
c = B - (2 x t₁)

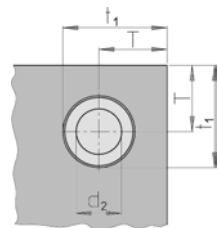


a = A - (2 x t₁)
b = B - (2 x t₁)



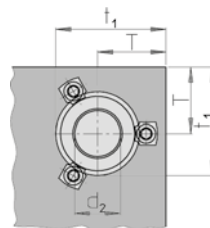
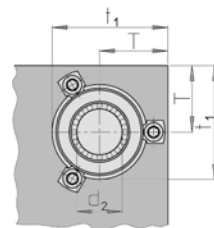
Zylindrische Führungsbuchsen

Leader pin bushings, cylindrical



Führungsbuchsen mit Bund

Leader pin bushings, with collar

Führungsbuchsen mit Bund
für Kugelführung
Leader pin bushings, with collar
for ball-bearings

d ₁ /d ₂	T	t ₁	d ₁ /d ₂	T	t ₁	d ₁ /d ₂	T	t ₁
18/19	25	40	18/19	32	49	18/19	35	55
24/25	29	46	24/25	37	59	24/25	40	65
30/32	37	60	30/32	44	71	30/32	48	79
40/42	45	74	40/42	49	81	40/42	53	89
50/52	52	87	50/52	57	97	50/52	61	105
63	—	—	63	64	117	63	—	—
80	—	—	80	73	135	80	—	—

Säulengestelle aus Stahl, 2 Platten, 2 Säulen, Typ A-C-D

Steel die sets, 2 plates, 2 posts, types A-C-D

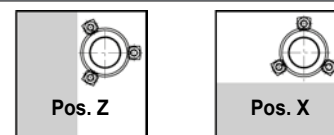
SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing		
Sinterbuchse Leader pin bushing, sintered		
FS 741 46	FS 751 47	FS 755 48
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated		
FS 641 41	FS 651 42	FS 655 43
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage		
FS 453 + FS 425 51	FS 457 + FS 425 52	FS 458 + FS 425 53

Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar
L1 FS 420 P	L2 FS 419 R

Gestelltyp / Type of die set	

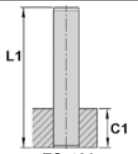
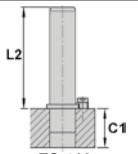
Position der Haltestücke / Position of holding clamps

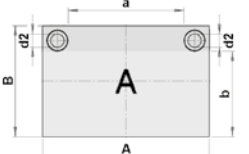
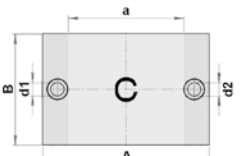
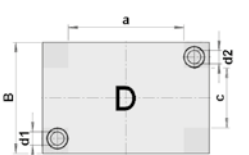


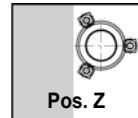
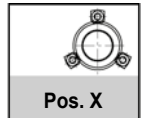
Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]	
Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin						46 41	47 42	48 43	51	52	53		
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A		
601	125 X 125	28	23	—	18/19	130	100	—					27 X 125	76 X 125	27 X 125		70 X 125		7,0
602		28	28	—		140	110	—											7,7
603		38	28	—		150	110	100											8,9
604	160 X 125	28	23	—	18/19	130	100	—					62 X 125	76 X 160	27 X 160	50 X 125	70 X 160		8,8
605		28	28	—		140	110	—										9,6	
606		38	28	—		150	110	100											11,2
607	160 X 160	28	23	—	18/19	130	100	—					62 X 160	111 X 160	62 X 160	50 X 160	105 X 160	50 X 160	11,0
608		28	28	—		140	110	—										12,0	
609		38	28	—		150	110	100											14,0
610	200 X 125	28	23	—	18/19	130	100	—					102 X 125	76 X 200	27 X 200	90 X 125	70 X 200		10,8
611		28	28	—		140	110	—										11,8	
612		38	28	—		150	110	100											13,7
613	200 X 160	33	28	—	24/25	150	110	—					82 X 160	101 X 200	42 X 200	70 X 160	95 X 200	30 X 200	16,4
614		33	33	—		160	120	—										17,6	
615		48	38	—		180	130	120											22,6
616	200 X 200	33	28	—	24/25	150	110	—					82 X 200	141 X 200	82 X 200	70 X 200	135 X 200	70 X 200	20,2
617		33	33	—		160	120	—										21,8	
618		48	38	—		180	130	120											28,0
619	250 X 125	33	28	—	24/25	150	110	—					132 X 125	66 X 250		120 X 125	60 X 250		16,0
620		33	33	—		160	120	—										17,3	
621		48	38	—		180	130	120											22,1
622	250 X 160	33	28	—	24/25	150	110	—					132 X 160	101 X 250	42 X 250	120 X 160	95 X 250	30 X 250	20,2
623		33	33	—		160	120	—										21,8	
624		48	38	—		180	130	120											28,0
625	250 X 200	33	28	—	24/25	150	110	—					132 X 200	141 X 250	82 X 250	120 X 200	135 X 250	70 X 250	25,0
626		33	33	—		160	120	—										27,0	
627		48	38	—		180	130	120											34,8
628	250 X 250	38	33	—	30/32	160	120	—					108 X 250	179 X 250	108 X 250	92 X 250	171 X 250	92 X 250	36,4
629		38	38	—		170	130	—											38,8
630		48	38	—		180	130	120											43,7

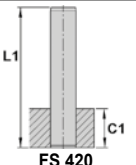
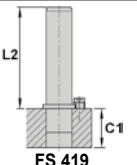
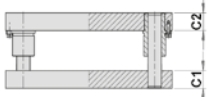
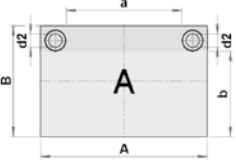
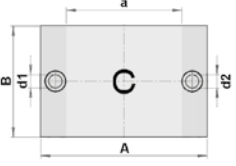
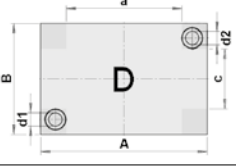
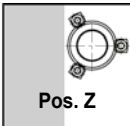
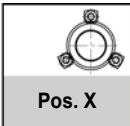
Buchstentyp / Type of bushing		
Sinterbuchse Leader pin bushing, sintered		
		
FS 741	FS 751	FS 755
46	47	48
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated		
		
FS 641	FS 651	FS 655
41	42	43
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage		
		
FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

Abmessungen / Dimensions										Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin						46 41	47 42	48 43	51	52	53		
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A		
631	300 X 160	33	28	–	24/25	150	110	–				182 X 160	101 X 300	42 X 300	170 X 160	95 X 300	30 X 300	24,0	
632		33	33	–		160	120	–										25,9	
633		48	38	–		180	130	120										33,4	
634	300 X 200	33	28	–	24/25	150	110	–				182 X 200	141 X 300	82 X 300	170 X 200	135 X 300	70 X 300	29,8	
635		33	33	–		160	120	–										32,1	
636		48	38	–		180	130	120										41,5	
637	300 X 250	38	33	–	30/32	160	120	–				158 X 250	179 X 300	108 X 300	142 X 250	171 X 300	92 X 300	43,3	
638		38	38	–		170	130	–										46,3	
639		48	38	–		180	130	120										52,5	
640	300 X 300	38	33	–	30/32	160	120	–				158 X 300	229 X 300	158 X 300	142 X 300	221 X 300	142 X 300	52,0	
641		38	38	–		170	130	–										55,5	
642		48	38	–		180	130	120										62,5	
643	350 X 200	33	28	–	24/25	150	110	–				232 X 200	141 X 350	82 X 350	220 X 200	135 X 350	70 X 350	34,6	
644		33	33	–		160	120	–										37,3	
645		48	38	–		180	130	120										48,3	
646	350 X 250	38	33	–	30/32	160	120	–				208 X 250	179 X 350	108 X 350	192 X 250	171 X 350	92 X 350	50,5	
647		38	38	–		170	130	–										54,0	
648		48	38	–		180	130	120										61,0	
649	350 X 300	48	38	–	40/42	190	140	–				188 X 300	219 X 350	138 X 350	172 X 300	211 X 350	122 X 350	74,0	
650		48	48	–		200	150	–										82,5	
651		58	48	–		210	150	140										90,5	
652	350 X 350	48	38	–	40/42	190	140	–				188 X 350	269 X 350	188 X 350	172 X 350	261 X 350	172 X 350	86,0	
653		48	48	–		200	150	–										95,5	
654		58	48	–		210	150	140										105,0	
655	400 X 200	33	28	–	24/25	150	110	–				282 X 200	141 X 400	82 X 400	270 X 200	135 X 400	70 X 400	39,4	
656		33	33	–		160	120	–										42,5	
657		48	38	–		180	130	120										55,0	
658	400 X 250	38	33	–	30/32	160	120	–				258 X 250	179 X 400	108 X 400	242 X 250	171 X 400	92 X 400	57,5	
659		38	38	–		170	130	–										61,5	
660		48	38	–		180	130	120										69,0	

Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechsel- säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

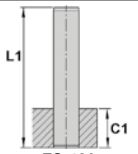
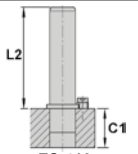
Gestelltyp / Type of die set	
	
	
	
	

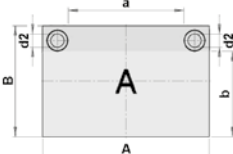
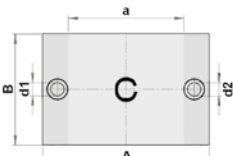
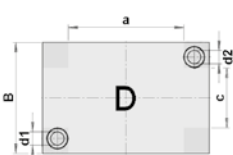
Position der Haltestücke / Position of holding clamps	
	
Pos. Z	Pos. X

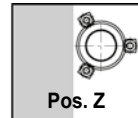
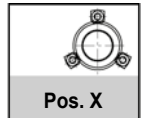
Buchsentyp / Type of bushing		
Sinterbuchse Leader pin bushing, sintered		
		
FS 741 46	FS 751 47	FS 755 48
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated		
		
FS 641 41	FS 651 42	FS 655 43
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage		
		
FS 453 + FS 425 51	FS 457 + FS 425 52	FS 458 + FS 425 53
Säulentyp / Type of leader pin		
eingepresst press-fitted		Schnellwechselsäule mit Bund Leader pin, with collar
		
FS 420 P		FS 419 R
Gestelltyp / Type of die set		
		
		
		
		
Position der Haltestücke / Position of holding clamps		
		
		

Buchstentyp / Type of bushing		
Sinterbuchse Leader pin bushing, sintered		
		
FS 741	FS 751	FS 755
46	47	48
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated		
		
FS 641	FS 651	FS 655
41	42	43
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage		
		
FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

Abmessungen / Dimensions										Arbeitsflächen / Working area									Gewicht / Weight [kg]	
Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin						46	47	48	51			52		53
		C1	C2	C3		L1	L2	L3	a	b	c	a	b	c	a	b	c			
											X B	X A	X A	X B	X A	X A	X B	X A		X A
691	600 X 400	58	48	—	50/52	220	160	—				406	303	206	390	295	190	205,0		
692		58	58	—		230	170	—				X	X	X	X	X	X	224,0		
693		68	58	—		240	170	160				400	600	600	400	600	600	242,0		
694	600 X 500	58	48	—	50/52	220	160	—				406	403	306	390	395	290	254,0		
695		58	58	—		230	170	—				X	X	X	X	X	X	278,0		
696		68	58	—		240	170	160				500	600	600	500	600	600	302,0		
697	600 X 600	58	48	—	50/52	220	160	—				406	503	406	390	495	390	305,0		
698		58	58	—		230	170	—				X	X	X	X	X	X	333,0		
699		68	58	—		240	170	160				600	600	600	600	600	600	361,0		
700	700 X 350	58	48	—	50/52	220	160	—				506	253	156	490	245	140	209,0		
701		58	58	—		230	170	—				X	X	X	X	X	X	228,0		
702		68	58	—		240	170	160				350	700	700	350	700	700	247,0		
703	700 X 400	58	48	—	50/52	220	160	—				506	303	206	490	295	190	238,0		
704		58	58	—		230	170	—				X	X	X	X	X	X	260,0		
705		68	58	—		240	170	160				400	700	700	400	700	700	282,0		
706	700 X 500	58	48	—	50/52	220	160	—				506	403	306	490	395	290	296,0		
707		58	58	—		230	170	—				X	X	X	X	X	X	324,0		
708		68	58	—		240	170	160				500	700	700	500	700	700	351,0		
709	700 X 600	58	48	—	50/52	220	160	—				506	503	406	490	495	390	354,0		
710		58	58	—		230	170	—				X	X	X	X	X	X	388,0		
711		68	58	—		240	170	160				600	700	700	600	700	700	420,0		
712	800 X 400	58	48	—	50/52	220	160	—				606	303	206	590	295	190	271,0		
713		58	58	—		230	170	—				X	X	X	X	X	X	296,0		
714		68	58	—		240	170	160				400	800	800	400	800	800	321,0		
715	800 X 500	58	48	—	50/52	220	160	—				606	403	306	590	395	290	338,0		
716		58	58	—		230	170	—				X	X	X	X	X	X	369,0		
717		68	58	—		240	170	160				500	800	800	500	800	800	400,0		
718	800 X 600	58	48	—	50/52	220	160	—				606	503	406	590	495	390	404,0		
719		58	58	—		230	170	—				X	X	X	X	X	X	442,0		
720		68	58	—		240	170	160				600	800	800	600	800	800	480,0		

Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechsel- säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set	
	
	
	
	

Position der Haltestücke / Position of holding clamps	
	
Pos. Z	Pos. X

Buchsentyp / Type of bushing			
Sinterbuchse Leader pin bushing, sintered			
C1: FS 741	C1: FS 732		
C3: FS 731	C3: FS 731		
88	87		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 641	C1: FS 632		
C3: FS 631	C3: FS 631		
71	72		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 458 + FS 425	C1: FS 453 + FS 425		
C3: FS 457 + FS 425	C3: FS 457 + FS 425		
91	92		

Säulentyp / Type of leader pin			
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar		
FS 420	FS 419		
P	R		

Gestelltyp / Type of die set			

Position der Haltestücke / Position of holding clamps			
Pos. Z	Pos. X		

Säulengestelle aus Stahl, 3 Platten, 2 Säulen, Typ A-C-D



Steel die sets, 3 plates, 2 posts, types A-C-D

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			
Sinterbuchse Leader pin bushing, sintered			
C1: FS 741	C1: FS 732		
C3: FS 731	C3: FS 731		
88	87		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 641	C1: FS 632		
C3: FS 631	C3: FS 631		
71	72		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 458 + FS 425	C1: FS 453 + FS 425		
C3: FS 457 + FS 425	C3: FS 457 + FS 425		
91	92		

Säulentyp / Type of leader pin			
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar		
FS 420	FS 419		
P	R		

Gestelltyp / Type of die set			

Position der Haltestücke / Position of holding clamps			
Pos. Z	Pos. X		

Abmessungen / Dimensions						Arbeitsflächen / Working area												Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness			Ø d1/d2	Säulenlänge Length of leader pin												
		C1	C2	C3		L1	L2	L3	88 71			87 72			91 92			
									a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A	
631	300 X 160	33	28	23	24/25	160	130	—				182 X 160	101 X 300	42 X 300	170 X 160	95 X 300		32,8
632		48	38			190	150	—										42,1
633		48	48			200	150	140										
634	300 X 200	33	28	23	24/25	160	130	—				182 X 200	141 X 300	82 X 300	170 X 200	135 X 300	76 X 300	40,7
635		48	38			190	150	—									52,5	
636		48	48			200	150	140										57,5
637	300 X 250	38	33	28	30/32	170	140	—				158 X 250	179 X 300	108 X 300	142 X 250	171 X 300	92 X 300	60,0
638		48	38			190	150	—									69,0	
639		48	48			200	150	140										74,5
640	300 X 300	38	33	28	30/32	170	140	—				158 X 300	229 X 300	158 X 300	142 X 300	221 X 300	142 X 300	71,5
641		48	38			190	150	—									82,5	
642		48	48			200	150	140										89,5
643	350 X 200	33	28	23	24/25	160	130	—				232 X 200	141 X 350	82 X 350	220 X 200	135 X 350	70 X 350	47,3
644		48	38			190	150	—									60,5	
645		48	48			200	150	140										66,5
646	350 X 250	38	33	28	30/32	170	140	—				208 X 250	179 X 350	108 X 350	192 X 250	171 X 350	92 X 350	69,5
647		48	38			190	150	—									80,0	
648		48	48			200	150	140										87,0
649	350 X 300	48	38	33	40/42	200	160	—				188 X 300	219 X 350	138 X 350	172 X 300	211 X 350	122 X 350	101,0
650		58	48			220	170	—									118,0	
651		58	58			230	170	160										126,0
652	350 X 350	48	38	33	40/42	200	160	—				188 X 350	269 X 350	188 X 350	172 X 350	261 X 350	172 X 350	118,0
653		58	48			220	170	—									137,0	
654		58	58			230	170	160										147,0
655	400 X 200	33	28	23	24/25	160	130	—				282 X 200	141 X 400	82 X 400	270 X 200	135 X 400	70 X 400	54,0
656		48	38			190	150	—										69,5
657		48	48			200	150	130										75,0
658	400 X 250	38	33	28	30/32	170	140	—				258 X 250	179 X 400	108 X 400	242 X 250	171 X 400	92 X 400	79,5
659		48	38			190	150	—										91,0
660		48	48			200	150	140										99,0

[SG.10]

Säulengestelle aus Stahl, 3 Platten, 2 Säulen, Typ A-C-D



Steel die sets, 3 plates, 2 posts, types A-C-D

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			
Sinterbuchse Leader pin bushing, sintered			
C1: FS 741		C1: FS 732	
C3: FS 731		C3: FS 731	
88		87	
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 641		C1: FS 632	
C3: FS 631		C3: FS 631	
71		72	
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 458 + FS 425		C1: FS 453 + FS 425	
C3: FS 457 + FS 425		C3: FS 457 + FS 425	
91		92	

Säulentyp / Type of leader pin			
eingepresst press-fitted		Schnellwechselsäule mit Bund Leader pin, with collar	
FS 420		FS 419	
P		R	

Gestelltyp / Type of die set			

Position der Haltestücke / Position of holding clamps			

Abmessungen / Dimensions						Arbeitsflächen / Working area												Gewicht / Weight [kg]					
Größe / Size	A X B	Plattenstärke Plate thickness			Ø d1/d2	Säulenlänge Length of leader pin																	
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A						
661		48	38			200	160	-															115,0
662	400 X 300	58	48	33	40/42	220	170	-							238 X 300	219 X 400	138 X 400	222 X 300	211 X 400	122 X 400			134,0
663		58	58			230	170	160															144,0
664		48	38			200	160	-															134,0
665	400 X 350	58	48	33	40/42	220	170	-							238 X 350	269 X 400	188 X 400	222 X 350	261 X 400	172 X 400			156,0
666		58	58			230	170	160															167,0
667		48	38			200	160	-															153,0
668	400 X 400	58	48	33	40/42	220	170	-							238 X 400	319 X 400	238 X 400	222 X 400	311 X 400	222 X 400			178,0
669		58	58			230	170	160															190,0
670		38	33			170	140	-															99,0
671	500 X 250	48	38	28	30/32	190	150	-							358 X 250	179 X 500	108 X 500	342 X 250	171 X 500	92 X 500			114,0
672		48	48			200	150	140															124,0
673		48	38			200	160	-															143,0
674	500 X 300	58	48	33	40/42	220	170	-							338 X 300	219 X 500	138 X 500	322 X 300	211 X 500	122 X 500			167,0
675		58	58			230	170	160															179,0
676		48	38			200	160	-															167,0
677	500 X 350	58	48	33	40/42	220	170	-							338 X 350	269 X 500	188 X 500	322 X 350	261 X 500	172 X 500			194,0
678		58	58			230	170	160															208,0
679		48	38			200	160	-															190,0
680	500 X 400	58	48	33	40/42	220	170	-							338 X 400	319 X 500	238 X 500	322 X 400	311 X 500	222 X 500			222,0
681		58	58			230	170	160															237,0
682		58	48			230	180	-															287,0
683	500 X 500	68	58	38	50/52	250	200	-							306 X 500	403 X 500	306 X 500	290 X 500	395 X 500	290 X 500			327,0
684		68	68			260	200	180															346,0
685		58	48			230	180	-															208,0
686	600 X 300	68	58	38	50/52	250	200	-							406 X 300	203 X 600	106 X 600	390 X 300	195 X 600	90 X 600			237,0
687		68	68			260	200	180															251,0
688		58	48			230	180	-															242,0
689	600 X 350	68	58	38	50/52	250	200	-							406 X 350	253 X 600	156 X 600	390 X 350	245 X 600	140 X 600			275,0
690		68	68			260	200	180															292,0

[SG.11]

Säulengestelle aus Stahl, 3 Platten, 2 Säulen, Typ A-C-D

Steel die sets, 3 plates, 2 posts, types A-C-D



SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			
Sinterbuchse Leader pin bushing, sintered			
C1: FS 741	C1: FS 732		
C3: FS 731	C3: FS 731		
88	87		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 641	C1: FS 632		
C3: FS 631	C3: FS 631		
71	72		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 458 + FS 425	C1: FS 453 + FS 425		
C3: FS 457 + FS 425	C3: FS 457 + FS 425		
91	92		

Säulentyp / Type of leader pin			
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar		
FS 420 P	FS 419 R		

Gestelltyp / Type of die set			

Position der Haltestücke / Position of holding clamps			
Pos. Z	Pos. X		

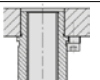
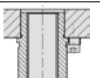
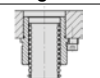
Abmessungen / Dimensions										Arbeitsflächen / Working area										Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness			Ø d1/d2	Säulenlänge Length of leader pin														
		C1	C2	C3		L1	L2	L3	88 71			87 72			91 92					
									a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A			
691		58	48			230	180	-												276,0
692	600 X 400	68	58	38	50/52	250	200	-				406 X 400	303 X 600	206 X 600	390 X 400	295 X 600	190 X 600			314,0
693		68	68			260	200	180												333,0
694	600 X 500	58	48			230	180	-				406 X 500	403 X 600	306 X 600	390 X 500	395 X 600	290 X 600			344,0
695		68	58	38	50/52	250	200	-												391,0
696		68	68			260	200	180												415,0
697	600 X 600	58	48			230	180	-				406 X 600	503 X 600	406 X 600	390 X 600	495 X 600	390 X 600			412,0
698		68	58	38	50/52	250	200	-												468,0
699		68	68			260	200	180												497,0
700	700 X 350	58	48			230	180	-				506 X 350	253 X 700	156 X 700	490 X 350	245 X 700	140 X 700			282,0
701		68	58	38	50/52	250	200	-												320,0
702		68	68			260	200	180												340,0
703	700 X 400	58	48			230	180	-				506 X 400	303 X 700	206 X 700	490 X 400	295 X 700	190 X 700			321,0
704		68	58	38	50/52	250	200	-												365,0
705		68	68			260	200	180												387,0
706	700 X 500	58	48			230	180	-				506 X 500	403 X 700	306 X 700	490 X 500	395 X 700	290 X 700			400,0
707		68	58	38	50/52	250	200	-												455,0
708		68	68			260	200	180												483,0
709	700 X 600	58	48			230	180	-				506 X 600	503 X 700	406 X 700	490 X 600	495 X 700	390 X 700			480,0
710		68	58	38	50/52	250	200	-												545,0
711		68	68			260	200	180												579,0
712	800 X 400	58	48			230	180	-				606 X 400	303 X 800	206 X 800	590 X 400	295 X 800	190 X 800			366,0
713		68	58	38	50/52	250	200	-												417,0
714		68	68			260	200	180												442,0
715	800 X 500	58	48			230	180	-				606 X 500	403 X 800	306 X 800	590 X 500	395 X 800	290 X 800			457,0
716		68	58	38	50/52	250	200	-												520,0
717		68	68			260	200	180												551,0
718	800 X 600	58	48			230	180	-				606 X 600	503 X 800	406 X 800	590 X 600	495 X 800	390 X 800			547,0
719		68	58	38	50/52	250	200	-												623,0
720		68	68			260	200	180												661,0

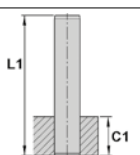
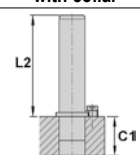
Säulengestelle aus Stahl, 2 Platten, 4 Säulen, Typ Q

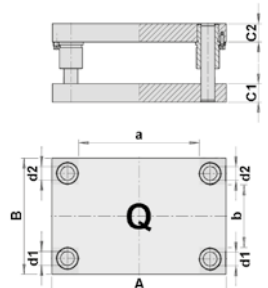
Steel die sets, 2 plates, 4 posts, type Q

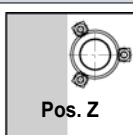
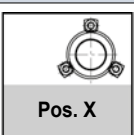


SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing				Abmessungen / Dimensions							Arbeitsflächen / Working area										Gewicht / Weight [kg]	
Sinterbuchse Leader pin bushing, sintered				A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin			46 41			47 42	48 43	51 52			53		
					C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A		
																						
FS 741 46				FS 751 47				FS 755 48														
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated																						
																						
FS 641 41				FS 651 42				FS 655 43														
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage																						
																						
FS 453 + FS 425 51				FS 457 + FS 425 52				FS 458 + FS 425 53														

Säulentyp / Type of leader pin																				
eingepresst press-fitted		Schnellwechsel- säule mit Bund Leader pin, with collar																		
																				
FS 420 P		FS 419 R																		

Gestelltyp / Type of die set																				
																				

Position der Haltestücke / Position of holding clamps																				
																				
Pos. Z		Pos. X																		

601	125 X 125	28	23	–	18/19	130	100	–							27 X 125	27 X 125						7,8
602		28	28	–		140	110	–														8,4
603		38	28	–		150	110	100														
604	160 X 125	28	23	–	18/19	130	100	–							62 X 125	27 X 160		50 X 125				9,5
605		28	28	–		140	110	–													10,4	
606		38	28	–		150	110	100														11,9
607	160 X 160	28	23	–	18/19	130	100	–							62 X 160	62 X 160		50 X 160	50 X 160			11,9
608		28	28	–		140	110	–													12,8	
609		38	28	–		150	110	100														14,8
610	200 X 125	28	23	–	18/19	130	100	–							102 X 125	27 X 200		90 X 125				11,5
611		28	28	–		140	110	–													12,5	
612		38	28	–		150	110	100														14,5
613	200 X 160	28	23	–	18/19	130	100	–							102 X 160	62 X 200		90 X 160	50 X 200			14,3
614		28	28	–		140	110	–													15,6	
615		38	28	–		150	110	100														18,1
616	200 X 200	28	23	–	18/19	130	100	–							102 X 200	102 X 200		90 X 200	90 X 200			17,5
617		28	28	–		140	110	–													19,1	
618		38	28	–		150	110	100														22,3
619	250 X 125	28	23	–	18/19	130	100	–							152 X 125	27 X 250		140 X 125				14,0
620		28	28	–		140	110	–													15,3	
621		38	28	–		150	110	100														17,7
622	250 X 160	28	23	–	18/19	130	100	–							152 X 160	60 X 250		140 X 160	50 X 250			17,5
623		28	28	–		140	110	–													19,1	
624		38	28	–		150	110	100														22,3
625	250 X 200	33	28	–	24/25	150	110	–							132 X 200	82 X 250		120 X 200	70 X 250			26,0
626		33	33	–		160	120	–													27,9	
627		48	38	–		180	130	120														35,8
628	250 X 250	33	28	–	24/25	150	110	–							132 X 250	132 X 250		120 X 250	120 X 250			32,0
629		33	33	–		160	120	–													34,4	
630		48	38	–		170	130	120														44,2

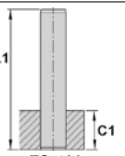
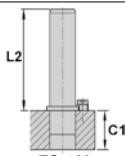
Säulengestelle aus Stahl, 2 Platten, 4 Säulen, Typ Q

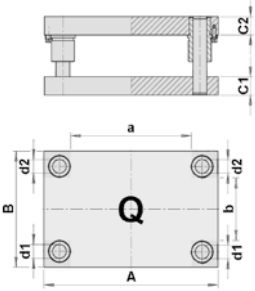


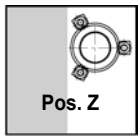
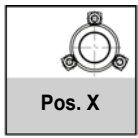
Steel die sets, 2 plates, 4 posts, type Q

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Sinterbuchse Leader pin bushing, sintered			A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin						46 41	47 42	48 43	51	52	53		
				C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A		
			FS 741	FS 751	FS 755																
46	47	48																			
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated																					
			FS 641	FS 651	FS 655																
41	42	43																			
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage																					
			FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425																
51	52	53																			

Säulentyp / Type of leader pin			eingepresst press-fitted		Schnellwechsel- säule mit Bund Leader pin, with collar	
			FS 420	FS 419		
P	R					

Gestelltyp / Type of die set		
		

Position der Haltestücke / Position of holding clamps		
		
Pos. Z	Pos. X	

[SG.14]

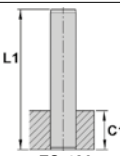
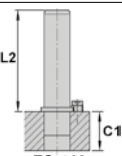
Säulengestelle aus Stahl, 2 Platten, 4 Säulen, Typ Q

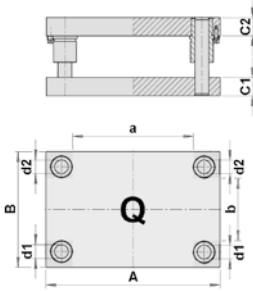


Steel die sets, 2 plates, 4 posts, type Q

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing		
Sinterbuchse Leader pin bushing, sintered		
		
FS 741 46	FS 751 47	FS 755 48
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated		
		
FS 641 41	FS 651 42	FS 655 43
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage		
		
FS 453 + FS 425 51	FS 457 + FS 425 52	FS 458 + FS 425 53

Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechsel- säule mit Bund Leader pin, with collar
	
FS 420 P	FS 419 R

Gestelltyp / Type of die set

Q

Position der Haltestücke / Position of holding clamps	
	
Pos. Z	Pos. X

[SG.15]

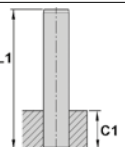
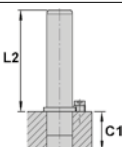
Säulengestelle aus Stahl, 2 Platten, 4 Säulen, Typ Q

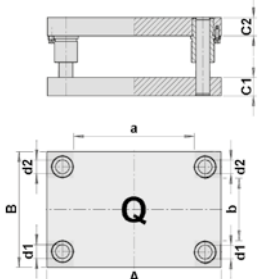


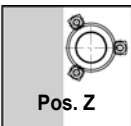
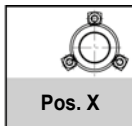
Steel die sets, 2 plates, 4 posts, type Q

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			Abmessungen / Dimensions										Arbeitsflächen / Working area									Gewicht / Weight [kg]		
Sinterbuchse Leader pin bushing, sintered  FS 741 FS 751 FS 755 46 47 48			A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin																
				C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A					
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated																								
 FS 641 FS 651 FS 655 41 42 43																								
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage																								
 FS 453 + FS 425 FS 457 + FS 425 FS 458 + FS 425 51 52 53																								

Säulentyp / Type of leader pin																							
eingepresst press-fitted		Schnellwechsel- säule mit Bund Leader pin, with collar																					
 FS 420 P		 FS 419 R																					

Gestelltyp / Type of die set		
 Q		

Position der Haltestücke / Position of holding clamps					
 Pos. Z			 Pos. X		

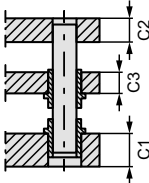
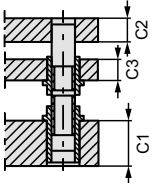
[SG.16]

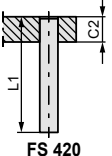
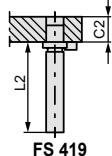
Säulengestelle aus Stahl, 3 Platten, 4 Säulen, Typ Q

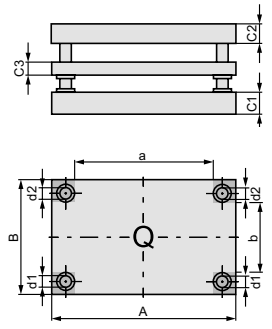


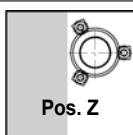
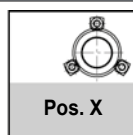
Steel die sets, 3 plates, 4 posts, type Q

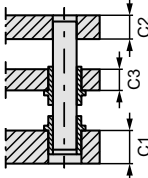
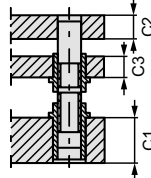
SÄULENGESTELLE / DIE SETS

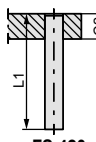
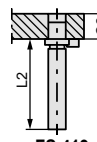
Buchsentyp / Type of bushing			
			
Sinterbuchse Leader pin bushing, sintered			
C1: FS 741	C1: FS 732		
C3: FS 731	C3: FS 731		
88	87		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 641	C1: FS 632		
C3: FS 631	C3: FS 631		
71	72		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 458 + FS 425	C1: FS 453 + FS 425		
C3: FS 457 + FS 425	C3: FS 457 + FS 425		
91	92		

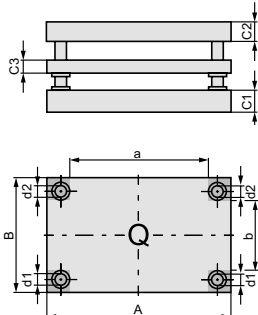
Säulentyp / Type of leader pin			
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar		
			
FS 420	FS 419		
P	R		

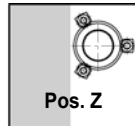
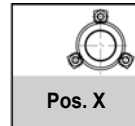
Gestelltyp / Type of die set			
			

Position der Haltestücke / Position of holding clamps	
	
Pos. Z	Pos. X

Buchsentyp / Type of bushing			
			
Sinterbuchse Leader pin bushing, sintered			
C1: FS 741		C1: FS 732	
C3: FS 731		C3: FS 731	
88		87	
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 641		C1: FS 632	
C3: FS 631		C3: FS 631	
71		72	
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 458 + FS 425		C1: FS 453 + FS 425	
C3: FS 457 + FS 425		C3: FS 457 + FS 425	
91		92	

Säulentyp / Type of leader pin			
eingepresst press-fitted		Schnellwechselsäule mit Bund Leader pin, with collar	
			
FS 420		FS 419	
P		R	

Gestelltyp / Type of die set			
			

Position der Haltestücke / Position of holding clamps			
			
Pos. Z		Pos. X	

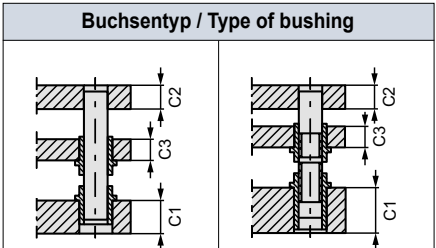
Abmessungen / Dimensions						Arbeitsflächen / Working area									Gewicht / Weight [kg]					
Größe / Size	A X B	Plattenstärke Plate thickness			Ø d1/d2	Säulenlänge Length of leader pin						88 71		87 72		91		92		
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A		a X B	b X A	c X A		
631	300 X 160	33	28	23	24/25	160	130	—				182 X 160	42 X 300			170 X 160	30 X 300		33,7	
632		48	38			190	150	—											43,1	
633		48	48			200	150	140												46,9
634	300 X 200	33	28	23	24/25	160	130	—				182 X 200	82 X 300			170 X 200	70 X 300		41,6	
635		48	38			190	150	—											53,5	
636		48	48			200	150	140												58,5
637	300 X 250	38	33	28	30/32	170	140	—				158 X 250	108 X 300			142 X 250	92 X 300		61,5	
638		48	38			190	150	—											70,5	
639		48	48			200	150	140												76,0
640	300 X 300	38	33	28	30/32	170	140	—				158 X 300	158 X 300			142 X 300	142 X 300		73,0	
641		48	38			190	150	—											83,5	
642		48	48			200	150	140												90,5
643	350 X 200	33	28	23	24/25	160	130	—				232 X 200	82 X 350			220 X 200	70 X 350		48,2	
644		48	38			190	150	—											62,0	
645		48	48			200	150	140												67,5
646	350 X 250	38	33	28	30/32	170	140	—				208 X 250	108 X 350			192 X 250	92 X 350		71,0	
647		48	38			190	150	—											81,5	
648		48	48			200	150	140												88,5
649	350 X 300	38	33	28	30/32	170	140	—				208 X 300	158 X 350			192 X 300	142 X 350		85,0	
650		48	38			190	150	—											97,0	
651		48	48			200	150	140												105,0
652	350 X 350	38	33	28	30/32	170	140	—				208 X 350	208 X 350			192 X 350	192 X 350		98,5	
653		48	38			190	150	—											113,0	
654		48	48			200	150	140												123,0
655	400 X 200	33	28	23	24/25	160	130	—				282 X 200	82 X 400			270 X 200	70 X 400		55,0	
656		48	38			190	150	—											70,5	
657		48	48			200	150	130												77,0
658	400 X 250	38	33	28	30/32	170	140	—				258 X 250	108 X 400			242 X 250	92 X 400		81,0	
659		48	38			190	150	—											92,5	
660		48	48			200	150	140												101,0

[illegible]

Säulengestelle aus Stahl, 3 Platten, 4 Säulen, Typ Q

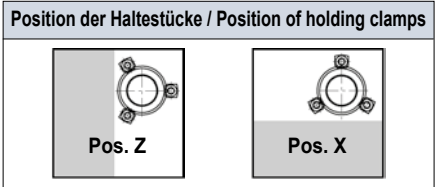
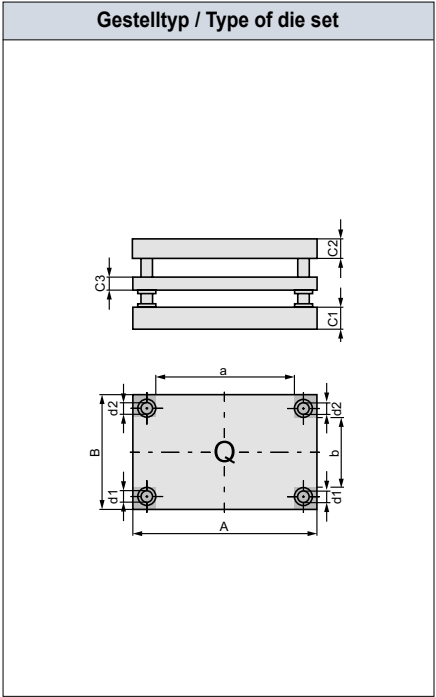
Steel die sets, 3 plates, 4 posts, type Q

SÄULENGESTELLE / DIE SETS



Sinterbuchse Leader pin bushing, sintered	
C1: FS 741	C1: FS 732
C3: FS 731	C3: FS 731
88	87
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 641	C1: FS 632
C3: FS 631	C3: FS 631
71	72
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 458 + FS 425	C1: FS 453 + FS 425
C3: FS 457 + FS 425	C3: FS 457 + FS 425
91	92

Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar
FS 420	FS 419
P	R



Abmessungen / Dimensions									Arbeitsflächen / Working area											Gewicht / Weight [kg]
Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin						88 71	87 72							
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A			
691	600 X 400	48	38	33	40/42	200	160	—												230,0
692		58	48			220	170	—				438 X 400	238 X 600		422 X 400	222 X 600				268,0
693		58	58			230	170	160												287,0
694	600 X 500	58	48	38	50/52	230	180	—												348,0
695		68	58			250	200	—				406 X 500	306 X 600		390 X 500	290 X 600				395,0
696		68	68			260	200	180												419,0
697	600 X 600	58	48	38	50/52	230	180	—												416,0
698		68	58			250	200	—				406 X 600	406 X 600		390 X 600	390 X 600				473,0
699		68	68			260	200	180												501,0
700	700 X 350	48	38	33	40/42	200	160	—												235,0
701		58	48			220	170	—				538 X 350	188 X 700		522 X 350	172 X 700				274,0
702		58	58			230	170	160												293,0
703	700 X 400	58	48	38	50/52	230	180	—												326,0
704		68	58			250	200	—				506 X 400	206 X 700		490 X 400	190 X 700				370,0
705		68	68			260	200	180												392,0
706	700 X 500	58	48	38	50/52	230	180	—												405,0
707		68	58			250	200	—				506 X 500	306 X 700		490 X 500	290 X 700				460,0
708		68	68			260	200	180												487,0
709	700 X 600	58	48	38	50/52	230	180	—												484,0
710		68	58			250	200	—				506 X 600	406 X 700		490 X 600	390 X 700				540,0
711		68	68			260	200	180												583,0
712	800 X 400	58	48	38	50/52	230	180	—												371,0
713		68	58			250	200	—				606 X 400	206 X 800		590 X 400	190 X 800				421,0
714		68	68			260	200	180												447,0
715	800 X 500	58	48	38	50/52	230	180	—												461,0
716		68	58			250	200	—				606 X 500	306 X 800		590 X 500	290 X 800				524,0
717		68	68			260	200	180												556,0
718	800 X 600	58	48	38	50/52	230	180	—												552,0
719		68	58			250	200	—				606 X 600	406 X 800		590 X 600	390 X 800				627,0
720		68	68			260	200	180												665,0

Toleranzangaben für Säulengestelle aus Stahl, M-Line

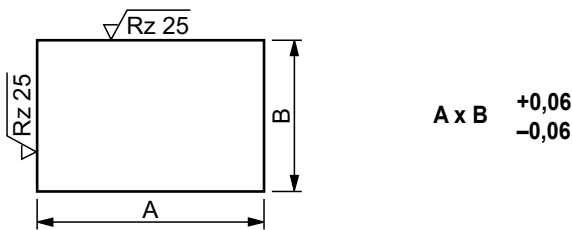
Tolerance - information regarding steel die sets, M-Line

SÄULENGESTELLE / DIE SETS

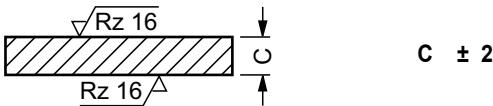


Mat.: C45

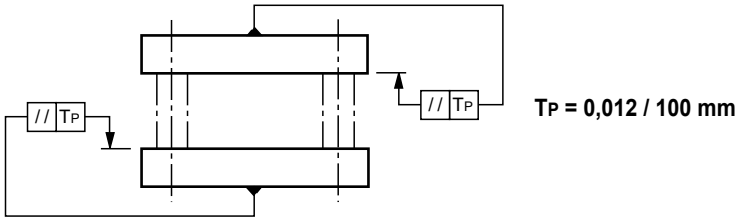
Toleranz Außenmaße /
Tolerance of length and width



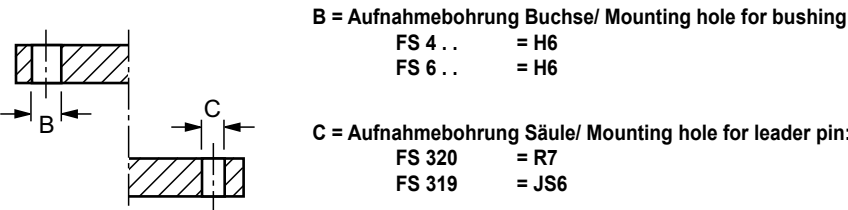
Toleranz Plattenstärke /
Tolerance of thickness



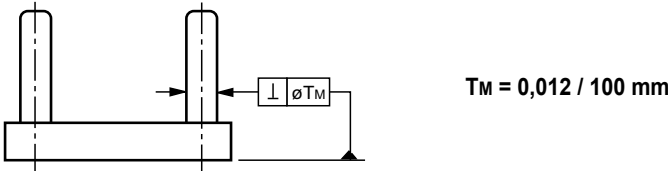
Parallelität der Flächenpaare /
Parallelism of two surfaces



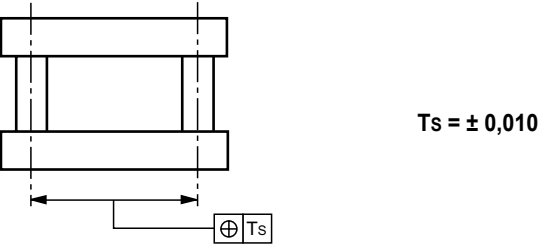
Bohrungstoleranzen /
Hole tolerances



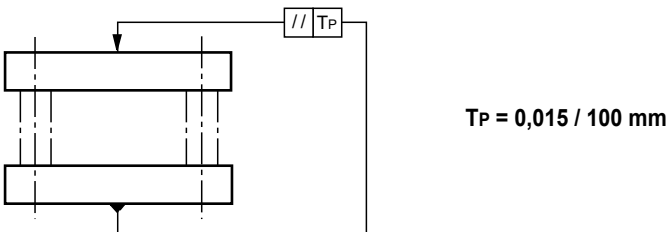
Winkelgenauigkeit der Führungssäulen /
Angular accuracy of leader pins



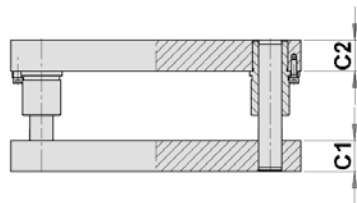
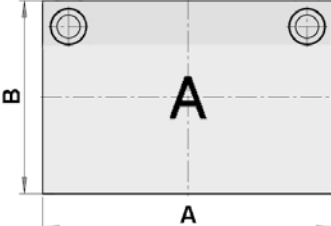
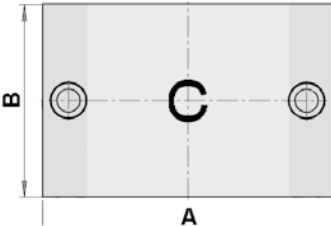
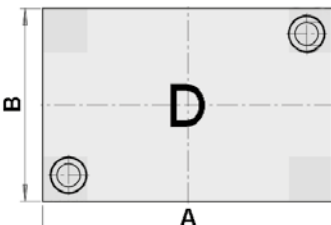
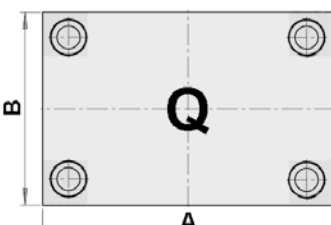
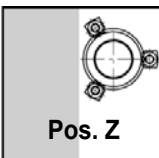
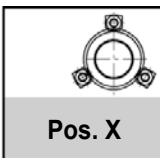
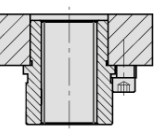
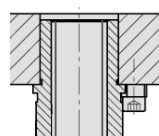
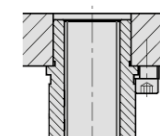
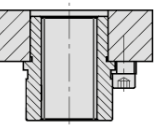
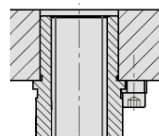
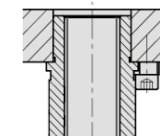
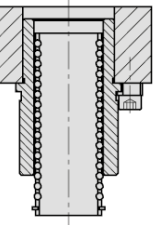
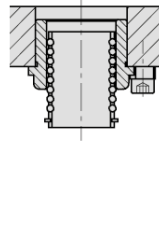
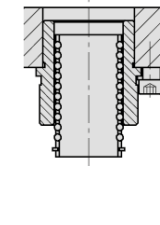
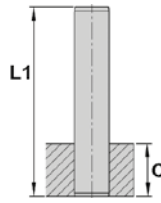
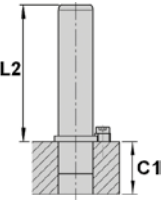
Toleranz Systemabstände /
Tolerance of dimensions between leader-pin (and bushing) - holes



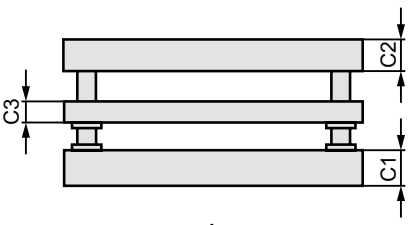
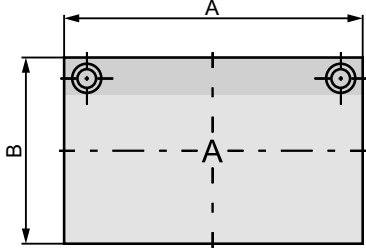
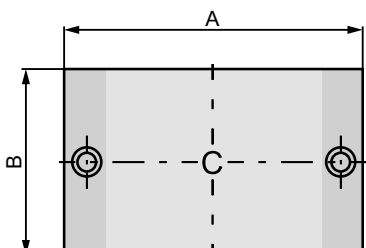
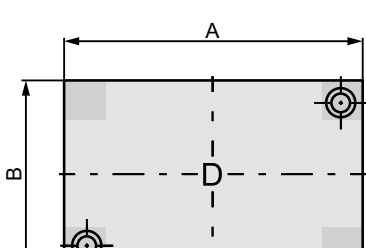
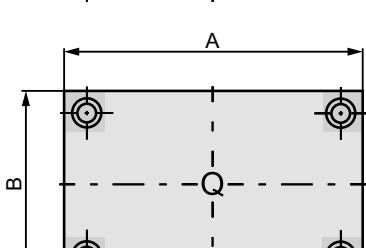
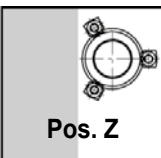
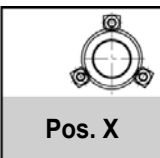
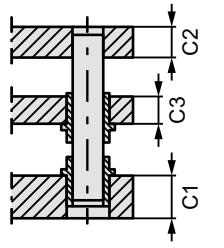
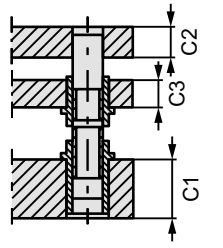
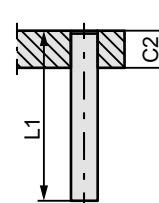
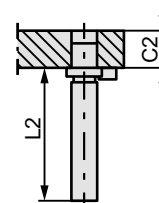
Planparallelität im
zusammgebauten Zustand /
Parallelism after mounting



Bestellbeispiel / Order-example

2 C	343	IEP	141	Z
Gestelltyp Type of die set	Kataloggröße Catalog sizes	Säulentyp Type of leader pin	Buchsentyp Type of bushing	Position der Haltestücke Position of holding clamps
Gestelltyp / Type of die set				
				
				
				
				
				
Position der Haltestücke / Position of holding clamps				
				
				
Buchsentyp / Type of bushing				
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated				
				
				
				
FS 330 RM FS 340 RM FS 350 RM				
141 142 143				
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated				
				
				
				
FS 331 FS 351 FS 355				
131 132 133				
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage				
				
				
				
FS 353 + FS 325 FS 357 + FS 325 FS 358 + FS 325				
151 152 153				
Säulentyp / Type of leader pin				
eingepresst press-fitted				
				
FS 320				
IEP				
Schnellwechselsäule mit Bund Leader pin with collar				
				
FS 319				
IER				

Bestellbeispiel / Order-example

3 C	343	IEP	182	Z
Gestelltyp Type of die set	Kataloggröße Catalog sizes	Säulentyp Type of leader pin	Buchsentyp Type of bushing	Position der Haltestücke Position of holding clamps
Gestelltyp / Type of die set				
				
				
				
				
				
Position der Haltestücke / Position of holding clamps				
				
				
Buchsentyp / Type of bushing				
				
				
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated				
C1 = FS 340 RM C1 = FS 350 RM				
C3 = FS 330 RM C3 = FS 330 RM				
182 183				
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated				
C1 = FS 351 C1 = FS 355				
C3 = FS 331 C3 = FS 331				
172 173				
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage				
C1 = FS 358 + FS 325 C1 = FS 353 + FS 325				
C3 = FS 357 + FS 325 C3 = FS 357 + FS 325				
192 193				
Säulentyp / Type of leader pin				
eingepresst press-fitted				
				
FS 420				
IEP				
Schnellwechselsäule mit Bund Leader pin with collar				
				
FS 419				
IER				

Bestellbeispiel Sondergrößen, M-Line

Order-example specials, M-Line



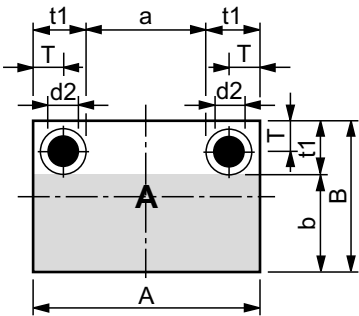
SÄULENGESTELLE / DIE SETS

Position	Platten- maße Plate length and width	Platten- stärke Plate thickness			Säulentyp in C1 oder C2* Type of leader pin in C1 or C2*		Buchsentyp in C1 oder C2** Type of bushing in C1 or C2**		Buchsentyp in C3 Type of bushing in C3		Haltestück- position Position of hol- ding clamps
Position	A x B	C1	C2	C3	FS ...	d1 x l	FS ...	d x l	FS ...	d x l	
Q	610 x 494	78	48	38	320	40/42 x 250	351	40/42 x 67	331	40/42 x 51	X

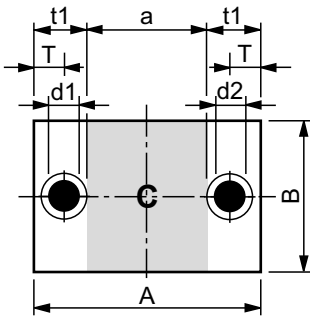
* = Säulentyp in C1 oder C2 bitte angeben. / Please fill in type of leader pin in C1 or C2.
** = Buchsentyp in C1 oder C2 bitte angeben. / Please fill in type of bushing in C1 or C2.

Arbeitsflächen / Working areas

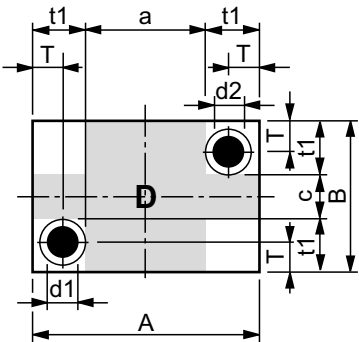
b = B - t1



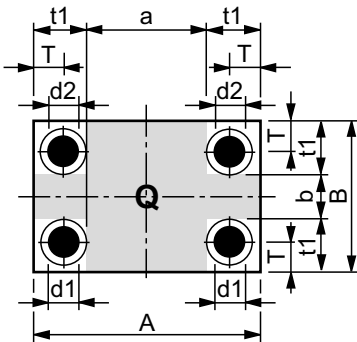
a = A - (2 x t1)



a = A - (2 x t1)
c = B - (2 x t1)

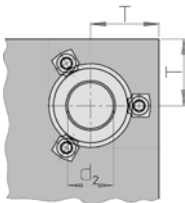


a = A - (2 x t1)
b = B - (2 x t1)



Führungsbuchsen mit Bund

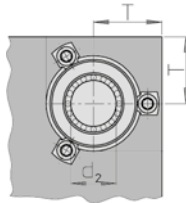
Leader pin bushings, with collar



d ₁ /d ₂	T
19/20	35
24/25	40
30/32	43,5
38/40	51
48/50	57
60/63	68
80	76

Führungsbuchsen mit Bund

für Kugelführung
Leader pin bushings, with collar
for ball-bearings



d ₁ /d ₂	T
19/20	35
24/25	40
30/32	43,5
38/40	51
48/50	57
60/63	68
80	76

Größen Systemplatten, M-Line

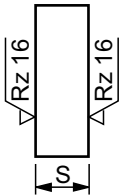
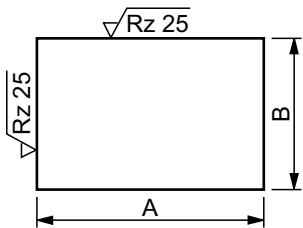
Sizes systemplates, M-Line



SÄULENGESTELLE / DIE SETS

Mat.: C45

Toleranz Außenmaße /
Tolerance of length and width



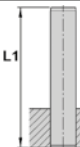
A x B +0,06
-0,06
S ± 2

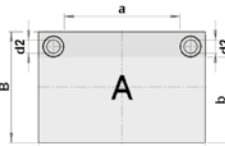
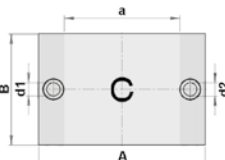
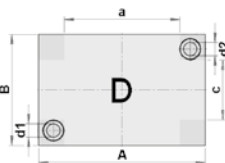
Parallelität S / Parallelism S: 0,012 / 100 mm

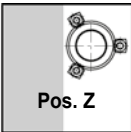
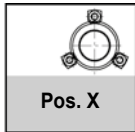
A x B	S							
	18	23	28	33	38	48	58	68
125 x 125	•	•	•		•			
160 x 125	•	•	•		•			
160 x 160	•	•	•		•			
200 x 125	•	•	•		•			
200 x 160	•	•	•	•	•	•		
200 x 200	•	•	•	•	•	•		
250 x 125	•	•	•	•	•	•		
250 x 160	•	•	•	•	•	•		
250 x 200		•	•	•	•	•		
250 x 250		•	•	•	•	•		
300 x 160		•	•	•	•	•		
300 x 200		•	•	•	•	•		
300 x 250			•	•	•	•		
300 x 300			•	•	•	•		
350 x 200		•	•	•	•	•		
350 x 250			•	•	•	•		
350 x 300			•	•	•	•	•	
350 x 350			•	•	•	•	•	
400 x 200		•	•	•	•	•		
400 x 250			•	•	•	•		
400 x 300				•	•	•	•	
400 x 350				•	•	•	•	
400 x 400				•	•	•	•	
500 x 250			•	•	•	•		
500 x 300				•	•	•	•	
500 x 350				•	•	•	•	
500 x 400				•	•	•	•	
500 x 500				•	•	•	•	•
600 x 300				•	•	•	•	•
600 x 350				•	•	•	•	•
600 x 400				•	•	•	•	•
600 x 500					•	•	•	•
600 x 600					•	•	•	•
700 x 350				•	•	•	•	•
700 x 400					•	•	•	•
700 x 500					•	•	•	•
700 x 600					•	•	•	•
800 x 400					•	•	•	•
800 x 500					•	•	•	•
800 x 600					•	•	•	•

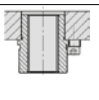
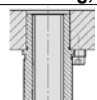
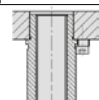
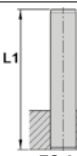
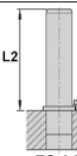
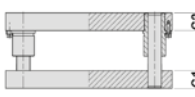
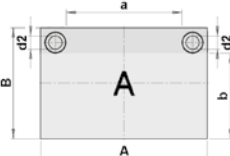
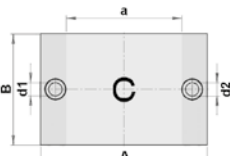
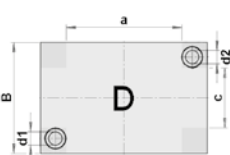
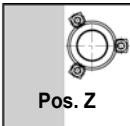
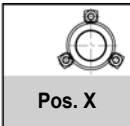
Buchsentyp / Type of bushing		
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated		
		
FS 330 RM	FS 340 RM	FS 350 RM
141	142	143
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated		
		
FS 331	FS 351	FS 355
131	132	133
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage		
		
FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153

Abmessungen / Dimensions										Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin						141 131	142 132	143 133	151 152 153				
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A		
301	125 X 125	28	23	—	19/20	125	100	—					15 X 120	70 X 125	15 X 125		70 X 125		7,0
302		28	28	—		140	112	—										7,7	
303		38	28	—		160	112	—										8,9	
304	160 X 125	28	23	—	19/20	125	100	—					50 X 125	70 X 160	15 X 160	50 X 125	70 X 160		8,8
305		28	28	—		140	112	—									9,6		
306		38	28	—		160	112	—									11,2		
307	160 X 160	28	23	—	19/20	125	100	—					50 X 160	105 X 160	50 X 160	50 X 160	105 X 160	50 X 160	11,0
308		28	28	—		140	112	—									12,0		
309		38	28	—		160	112	—									14,0		
310	200 X 125	28	23	—	19/20	125	100	—					90 X 125	70 X 200	15 X 200	90 X 125	70 X 200		10,8
311		28	28	—		140	112	—									11,8		
312		38	28	—		160	112	—									13,7		
313	200 X 160	33	28	—	24/25	140	112	—					72 X 160	96 X 200	32 X 200	70 X 160	95 X 200	32 X 200	16,4
314		33	33	—		160	125	—									17,6		
315		48	38	—		180	140	—									22,6		
316	200 X 200	33	28	—	24/25	140	112	—					72 X 200	136 X 200	72 X 200	72 X 200	136 X 200	72 X 200	20,2
317		33	33	—		160	125	—									21,8		
318		48	38	—		180	140	—									28,0		
319	250 X 125	33	28	—	24/25	140	112	—					122 X 125	61 X 250		122 X 125	61 X 250		16,0
320		33	33	—		160	125	—									17,3		
321		48	38	—		180	140	—									22,1		
322	250 X 160	33	28	—	24/25	140	112	—					122 X 160	96 X 250	32 X 250	122 X 160	96 X 250	32 X 250	20,2
323		33	33	—		160	125	—									21,8		
324		48	38	—		180	140	—									28,0		
325	250 X 200	33	28	—	24/25	140	112	—					122 X 200	136 X 250	72 X 250	122 X 200	136 X 250	72 X 250	25,0
326		33	33	—		160	125	—									27,0		
327		48	38	—		180	140	—									34,8		
328	250 X 250	38	33	—	30/32	160	125	—					106 X 250	178 X 250	106 X 250	106 X 250	178 X 250	106 X 250	36,4
329		38	38	—		180	140	—									38,8		
330		48	38	—		180	140	—									43,7		

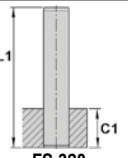
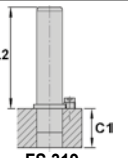
Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechsel- säule mit Bund Leader pin, with collar
	
FS 320 IEP	FS 319 IER

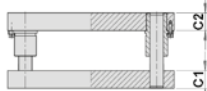
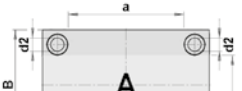
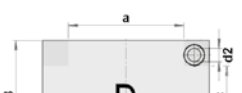
Gestelltyp / Type of die set	
	
	
	
	

Position der Haltestücke / Position of holding clamps	
	
Pos. Z	Pos. X

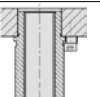
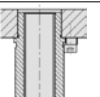
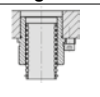
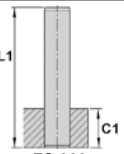
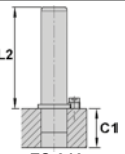
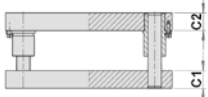
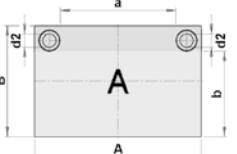
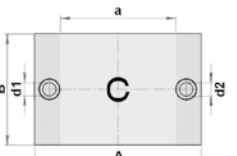
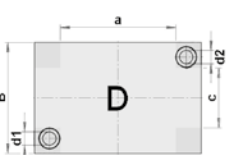
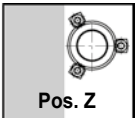
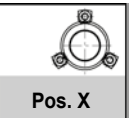
Buchsentyp / Type of bushing		
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated		
		
FS 330 RM	FS 340 RM	FS 350 RM
141	142	143
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated		
		
FS 331	FS 351	FS 355
131	132	133
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage		
		
FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153
Säulentyp / Type of leader pin		
eingepreßt press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar	
		
FS 320	FS 319	
IEP	IER	
Gestelltyp / Type of die set		
		
		
		
		
Position der Haltestücke / Position of holding clamps		
		
		
Pos. Z		
Pos. X		

Buchsentyp / Type of bushing			Abmessungen / Dimensions						Arbeitsflächen / Working area									Gewicht / Weight [kg]								
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin			141 131			142 132			143 133			151 152			153			
				C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B		b X A	c X A						
FS 330 RM	FS 340 RM	FS 350 RM																								
141	142	143																								
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated																										
																										
FS 331	FS 351	FS 355																								
131	132	133																								
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage																										
																										
FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325																								
151	152	153																								

Säulentyp / Type of leader pin																					
eingepresst press-fitted		Schnellwechsel- säule mit Bund Leader pin, with collar																			
																					
FS 320	FS 319																				
IEP	IER																				

Gestelltyp / Type of die set																					
																					
																					
																					
																					

Position der Haltestücke / Position of holding clamps																					
																					
																					

Buchsentyp / Type of bushing			Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin			141 131			142 132	143 133	151 152 153				
					C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A	
FS 330 RM	FS 340 RM	FS 350 RM																			
141	142	143																			
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated																					
																					
FS 331	FS 351	FS 355																			
131	132	133																			
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage																					
																					
FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325																			
151	152	153																			
Säulentyp / Type of leader pin																					
eingepresst press-fitted		Schnellwechselsäule mit Bund Leader pin, with collar																			
																					
FS 320		FS 319																			
IEP		IER																			
Gestelltyp / Type of die set																					
																					
																					
																					
																					
Position der Haltestücke / Position of holding clamps																					
																					
Pos. Z			Pos. X																		



Buchsentyp / Type of bushing			
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			
C1: FS 340 RM	C1: FS 350 RM		
C3: FS 330 RM	C3: FS 330 RM		
182	183		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 351	C1: FS 355		
C3: FS 331	C3: FS 331		
172	173		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 358 + FS 325	C1: FS 353 + FS 325		
C3: FS 357 + FS 325	C3: FS 357 + FS 325		
192	193		

Säulentyp / Type of leader pin			
eingepresst	Schnellwechselsäule mit Bund		
press-fitted	Leader pin, with collar		
FS 320	FS 319		
IEP	IER		

Gestelltyp / Type of die set			

Position der Haltestücke / Position of holding clamps			
Pos. Z			
Pos. X			

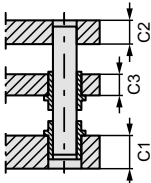
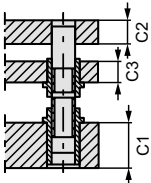


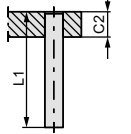
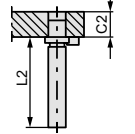
Buchsentyp / Type of bushing			Abmessungen / Dimensions						Arbeitsflächen / Working area									Gewicht / Weight [kg]				
		A X B		Platten- stärke Plate thickness		Ø d1/d2	Säulen- länge Length of leader pin						182 172		183 173		192 193					
				C1	C2		C3	L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B		b X A	c X A		
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			331	300	33	28			160	125	–					172	96	32	172	96	32	32,8
C1: FS 340 RM C3: FS 330 RM 182			332	X 160	48	38	23	24/25	180	160	–				X 160	X 300	X 300	X 160	X 300	X 300	42,1	
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			333		48	48			200	160	–										45,9	
C1: FS 351 C3: FS 331 172			334	300	33	28			160	125	–				172	136	72	172	136	72	40,7	
C1: FS 355 C3: FS 331 173			335	X 200	48	38	23	24/25	180	160	–				X 200	X 300	X 300	X 200	X 300	X 300	52,5	
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			336		48	48			200	160	–										57,5	
C1: FS 358 + FS 325 C3: FS 357 + FS 325 192			337		38	33			180	140	–										60,0	
C1: FS 353 + FS 325 C3: FS 357 + FS 325 193			338	300	48	38	33	30/32	200	160	–				156	178	106	156	178	106	69,0	
			339	X 250	48	48			200	160	–				X 250	X 300	X 300	X 250	X 300	X 300	74,5	
			340		38	33			180	140	–										71,5	
			341	300	48	38	33	30/32	200	160	–				156	228	156	156	228	156	82,5	
			342	X 300	48	48			200	160	–				X 300	X 300	X 300	X 300	X 300	X 300	89,5	
			343		33	28			160	125	–										47,3	
			344	350	48	38	23	24/25	180	160	–				222	136	72	222	136	72	60,5	
			345	X 200	48	48			200	160	–				X 200	X 350	X 350	X 200	X 350	X 350	66,5	
			346		38	33			180	140	–										69,5	
			347	350	48	38	33	30/32	200	160	–				206	178	106	206	178	106	80,0	
			348	X 250	48	48			200	160	–				X 250	X 350	X 350	X 250	X 350	X 350	87,0	
			349		48	38			200	160	–										101,0	
			350	350	58	48	38	38/40	224	180	–				182	216	132	182	216	132	118,0	
			351	X 300	58	58			250	180	–				X 300	X 350	X 350	X 300	X 350	X 350	126,0	
			352		48	38			200	160	–										118,0	
			353	350	58	48	38	38/40	224	180	–				182	266	182	182	266	182	137,0	
			354	X 350	58	58			250	180	–				X 350	X 350	X 350	X 350	X 350	X 350	147,0	
			355		33	28			160	125	–										54,0	
			356	400	48	38	23	24/25	180	160	–				272	136	72	272	136	72	69,5	
			357	X 200	48	48			200	160	–				X 200	X 400	X 400	X 200	X 400	X 400	75,0	
			358		38	33			180	125	–										79,5	
			359	400	48	38	33	30/32	200	160	–				256	178	106	256	178	106	91,0	
			360	X 250	48	48			200	160	–				X 250	X 400	X 400	X 250	X 400	X 400	99,0	

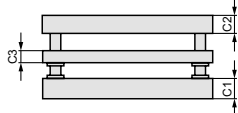
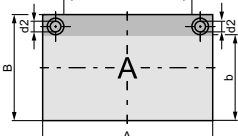
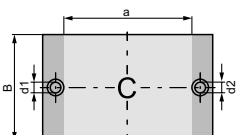
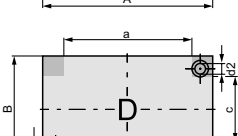
Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar
FS 320 IEP	FS 319 IER

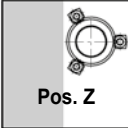
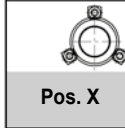
Gestelltyp / Type of die set	

Position der Haltestücke / Position of holding clamps	
Pos. Z	Pos. X

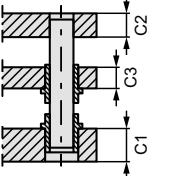
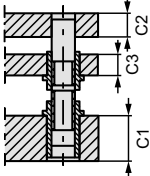
Buchsentyp / Type of bushing			
			
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM		
182	183		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331		
172	173		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 358 + FS 325 C3: FS 357 + FS 325	C1: FS 353 + FS 325 C3: FS 357 + FS 325		
192	193		

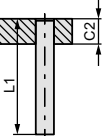
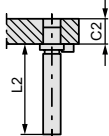
Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechsel- säule mit Bund Leader pin, with collar
	
FS 320 IEP	FS 319 IER

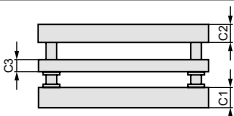
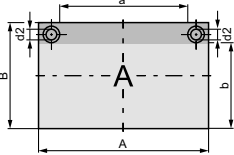
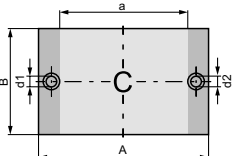
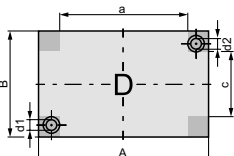
Gestelltyp / Type of die set	
	
	
	
	

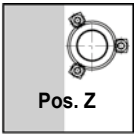
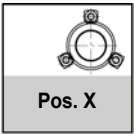
Position der Haltestücke / Position of holding clamps	
	
Pos. Z	Pos. X

Abmessungen / Dimensions						Arbeitsflächen / Working area										Gewicht / Weight [kg]				
Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin						182 172		183 173			192		193	
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B		b X A	c X A		
361	400 X 300	48	38	38	38/40	200	160	—					232 X 300	216 X 400	132 X 400	232 X 300	216 X 400	132 X 400	115,0	
362		58	48			224	180	—										134,0		
363		58	58			250	180	—											144,0	
364	400 X 350	48	38	38	38/40	200	160	—					232 X 350	266 X 400	182 X 400	232 X 350	266 X 400	182 X 400	134,0	
365		58	48			224	180	—										156,0		
366		58	58			250	180	—											167,0	
367	400 X 400	48	38	38	38/40	200	160	—					232 X 400	316 X 400	232 X 400	232 X 400	316 X 400	232 X 400	153,0	
368		58	48			224	180	—											178,0	
369		58	58			250	180	—												190,0
370	500 X 250	38	33	33	30/32	180	140	—					356 X 250	178 X 500	106 X 500	356 X 250	178 X 500	106 X 500	99,0	
371		48	38			200	160	—											114,0	
372		48	48			200	160	—												124,0
373	500 X 300	48	38	38	38/40	200	160	—					332 X 300	216 X 500	132 X 500	332 X 300	216 X 500	132 X 500	143,0	
374		58	48			224	180	—											167,0	
375		58	58			250	180	—												179,0
376	500 X 350	48	38	38	38/40	200	160	—					332 X 350	266 X 500	182 X 500	332 X 350	266 X 500	182 X 500	167,0	
377		58	48			224	180	—											194,0	
378		58	58			250	180	—												208,0
379	500 X 400	48	38	38	38/40	200	160	—					332 X 400	316 X 500	232 X 500	332 X 400	316 X 500	232 X 500	190,0	
380		58	48			224	180	—											222,0	
381		58	58			250	180	—												237,0
382	500 X 500	58	48	48	48/50	224	180	—					306 X 500	403 X 500	306 X 500	306 X 500	403 X 500	306 X 500	287,0	
383		68	58			250	200	—											327,0	
384		68	68			280	200	—												346,0
385	600 X 300	58	48	48	48/50	224	180	—					406 X 300	203 X 600	106 X 600	406 X 300	203 X 600	106 X 600	208,0	
386		68	58			250	200	—											237,0	
387		68	68			280	200	—												251,0
388	600 X 350	58	48	48	48/50	224	180	—					406 X 350	253 X 600	156 X 600	406 X 350	253 X 600	156 X 600	242,0	
389		68	58			250	200	—												275,0
390		68	68			280	200	—												

Buchsentyp / Type of bushing				
				
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated				
C1: FS 340 RM C3: FS 330 RM 182		C1: FS 350 RM C3: FS 330 RM 183		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated				
C1: FS 351 C3: FS 331 172		C1: FS 355 C3: FS 331 173		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage				
C1: FS 358 + FS 325 C3: FS 357 + FS 325 192		C1: FS 353 + FS 325 C3: FS 357 + FS 325 193		

Säulentyp / Type of leader pin				
eingepresst press-fitted		Schnellwechselsäule mit Bund Leader pin, with collar		
				
FS 320 IEP		FS 319 IER		

Gestelltyp / Type of die set				
				
				
				
				

Position der Haltestücke / Position of holding clamps				
				
				

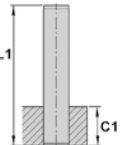
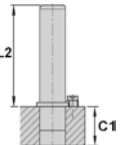
Säulengest. a. Stahl, 2 Platten, 4 Säulen, Typ Q, M-Line

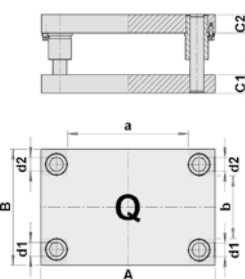


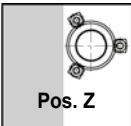
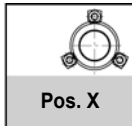
Steel die sets, 2 plates, 4 posts, type Q, M-Line

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin												
					C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A	
FS 330 RM	FS 340 RM	FS 350 RM																			
141	142	143																			
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated																					
																					
FS 331	FS 351	FS 355																			
131	132	133																			
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage																					
																					
FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325																			
151	152	153																			

Säulentyp / Type of leader pin																						
eingepresst press-fitted		Schnellwechsel- säule mit Bund Leader pin, with collar																				
																						
FS 320	FS 319																					
IEP	IER																					

Gestelltyp / Type of die set																						
																						

Position der Haltestücke / Position of holding clamps																						
																						
Pos. Z	Pos. X																					

[SG.34]

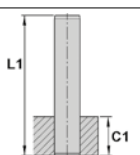
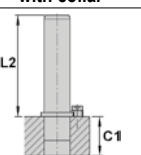
Säulengest. a. Stahl, 2 Platten, 4 Säulen, Typ Q, M-Line

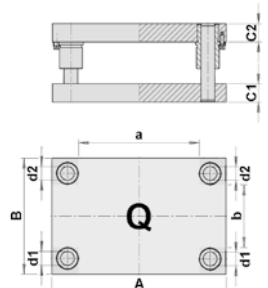
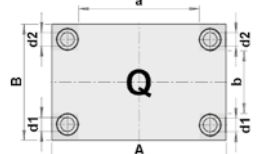
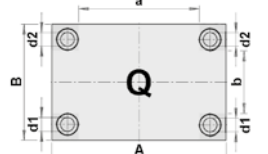
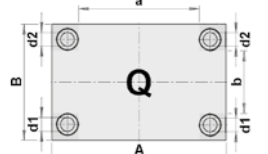
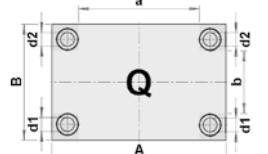
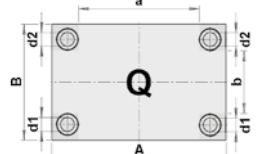
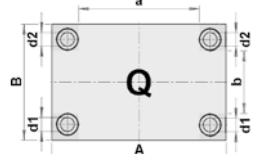
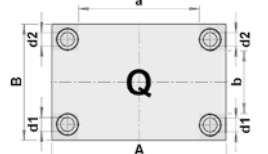
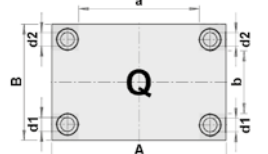
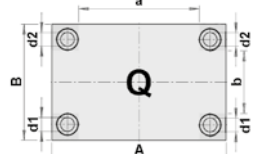
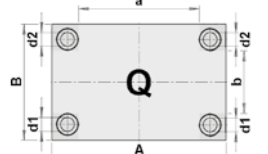
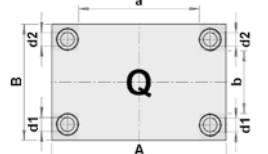
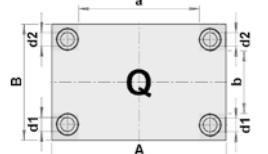
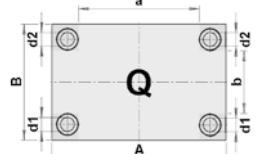
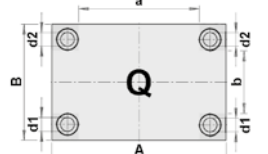
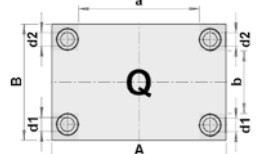
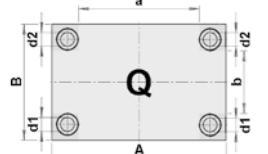
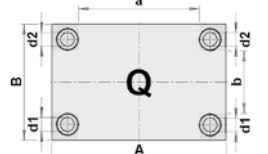
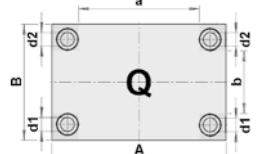
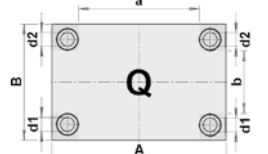
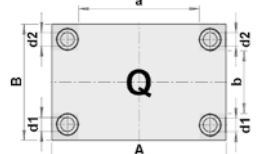
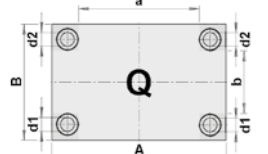
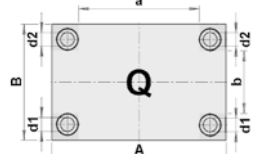
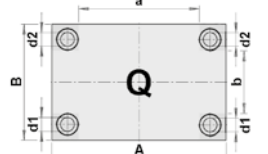
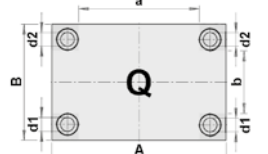
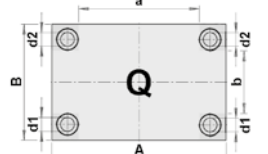
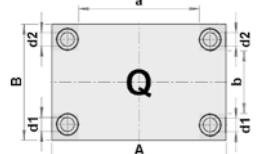
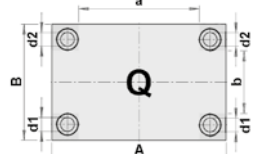
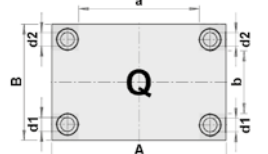
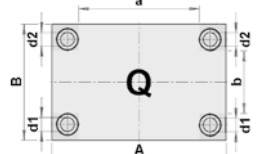
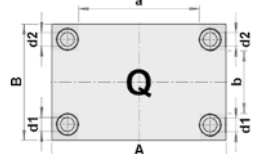
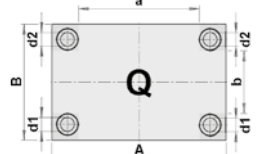
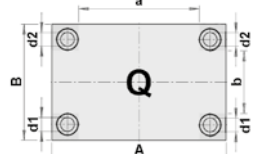
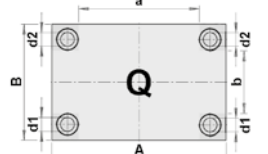
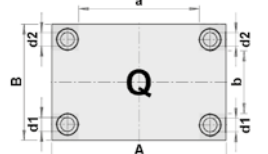
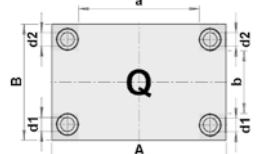
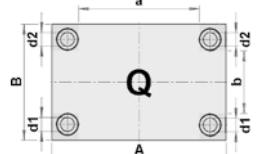
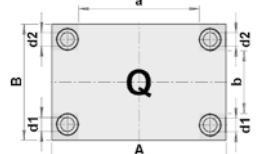
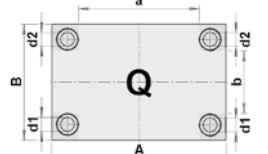
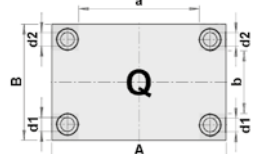
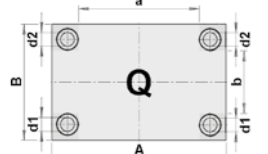
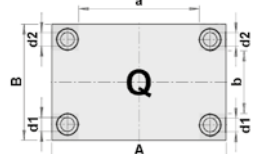
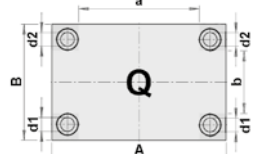
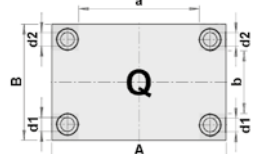
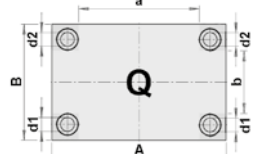
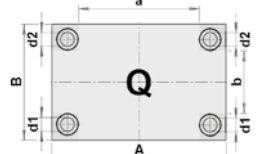
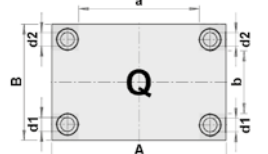
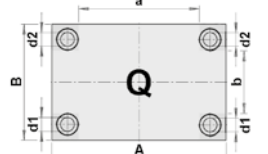
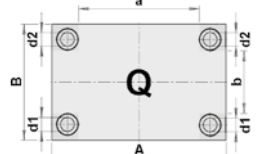
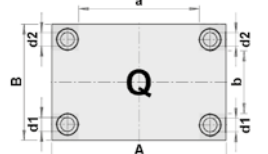
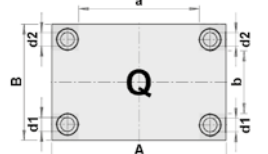
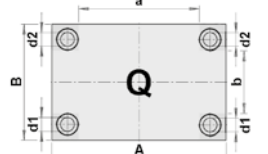
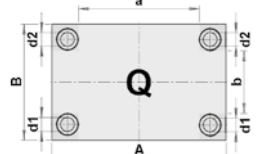
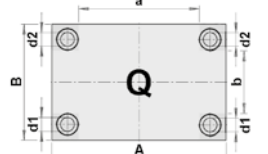
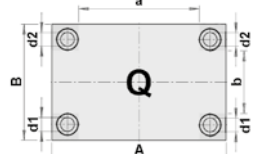
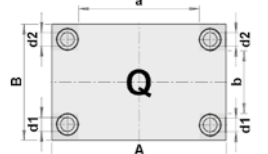
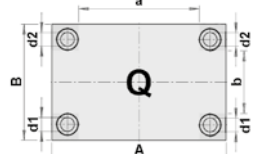
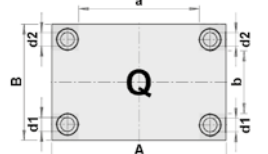
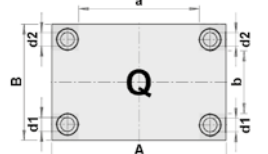
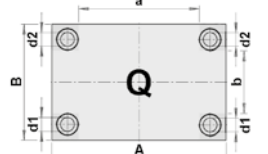
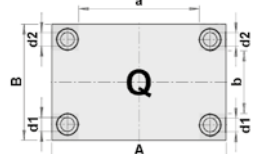
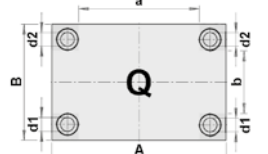
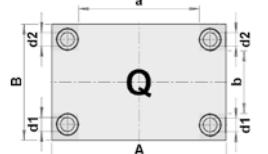
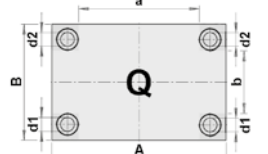
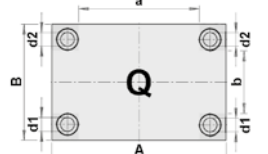
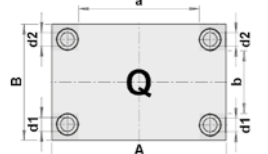
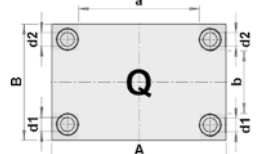
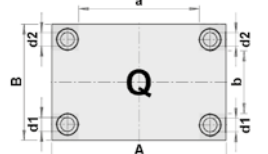
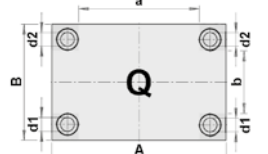
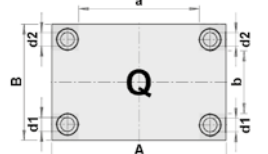
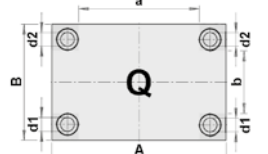
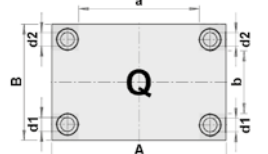
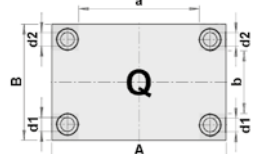
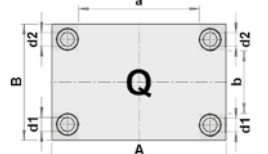
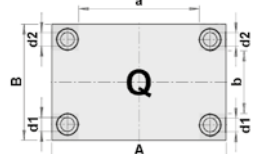
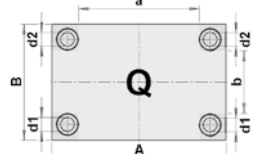
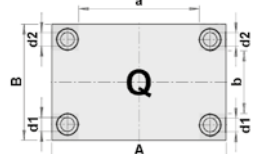
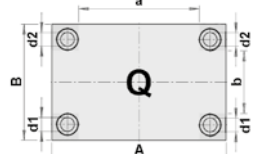
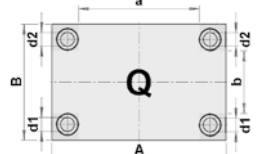
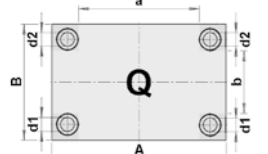
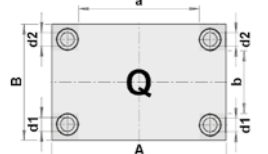
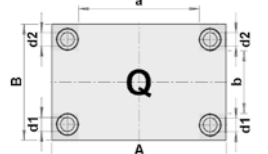
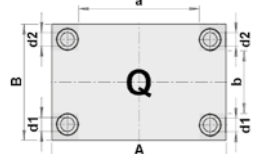
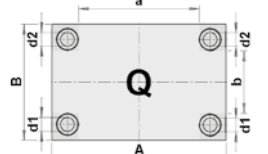
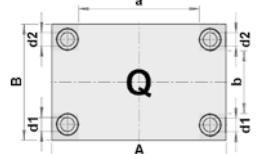
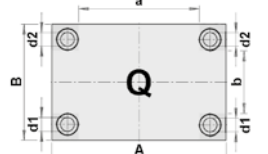
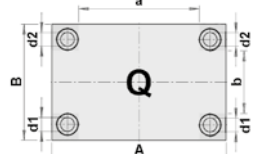
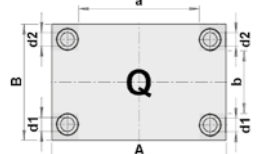
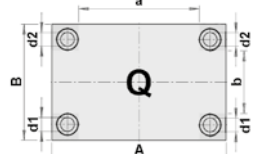
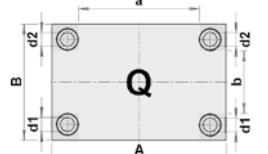
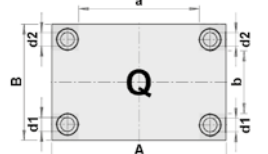
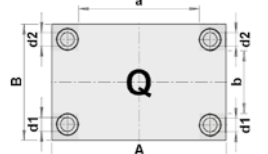


Steel die sets, 2 plates, 4 posts, type Q, M-Line

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]			
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			Größe / Size	A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin			141 131			142 132			143 133				151 152 153		
					C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A				
			FS 330 RM	FS 340 RM	FS 350 RM	141	142	143																
			141	142	143																			
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated																								
			FS 331	FS 351	FS 355	131	132	133																
			131	132	133																			
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage																								
			FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325	151	152	153																
			151	152	153																			

Säulentyp / Type of leader pin																						
eingepresst press-fitted		Schnellwechsel- säule mit Bund Leader pin, with collar																				
		FS 320	FS 319																			
IEP		IER																				

Gestelltyp / Type of die set																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					
																					

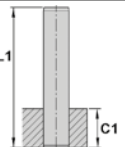
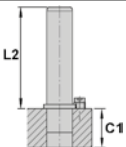
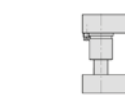
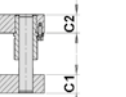
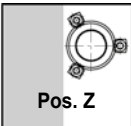
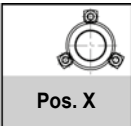
[SG.35]

Säulengest. a. Stahl, 2 Platten, 4 Säulen, Typ Q, M-Line



Steel die sets, 2 plates, 4 posts, type Q, M-Line

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			Abmessungen / Dimensions						Arbeitsflächen / Working area									Gewicht / Weight [kg]					
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin			141 131			142 132			143 133			151 152 153			
				C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B		b X A	c X A			
FS 330 RM	FS 340 RM	FS 350 RM																					
141	142	143																					
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin			141 131			142 132			143 133			151 152 153			
				C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A				
FS 331	FS 351	FS 355																					
131	132	133																					
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			A X B	Platten- stärke Plate thickness			Ø d1/d2	Säulen- länge Length of leader pin			141 131			142 132			143 133			151 152 153			
				C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A				
FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325																					
151	152	153																					
Säulentyp / Type of leader pin																					Gewicht / Weight [kg]		
eingepresst press-fitted		Schnellwechsel- säule mit Bund Leader pin, with collar		L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1					
FS 320	FS 319																						
IEP	IER																						
Gestelltyp / Type of die set																					Gewicht / Weight [kg]		
		L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1				
FS 320	FS 319																						
IEP	IER																						
Position der Haltestücke / Position of holding clamps																					Gewicht / Weight [kg]		
		L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1	L1	L2	C1				
Pos. Z	Pos. X																						

Säulengest. a. Stahl, 3 Platten, 4 Säulen, Typ Q, M-Line



Steel die sets, 3 plates, 4 posts, type Q, M-Line

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM		
182	183		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331		
172	173		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 358 + FS 325 C3: FS 357 + FS 325	C1: FS 353 + FS 325 C3: FS 357 + FS 325		
192	193		

Säulentyp / Type of leader pin			
eingepresst press-fitted	Schnellwechsel- säule mit Bund Leader pin, with collar		
FS 320 IEP	FS 319 IER		

Gestelltyp / Type of die set			

Position der Haltestücke / Position of holding clamps			
Pos. Z	Pos. X		

[SG.38]

Säulengest. a. Stahl, 3 Platten, 4 Säulen, Typ Q, M-Line



Steel die sets, 3 plates, 4 posts, type Q, M-Line

SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing			
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM		
182	183		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331		
172	173		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 358 + FS 325 C3: FS 357 + FS 325	C1: FS 353 + FS 325 C3: FS 357 + FS 325		
192	193		

Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechselsäule mit Bund Leader pin, with collar
FS 320 IEP	FS 319 IER

Gestelltyp / Type of die set	

Abmessungen / Dimensions										Arbeitsflächen / Working area										Gewicht / Weight [kg]	
Größe / Size	A X B	Plattenstärke Plate thickness			Ø d1/d2	Säulenlänge Length of leader pin						182 172			183 173			192 193			
		C1	C2	C3		L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A				
331	300 X 160	33	28	23	24/25	160	125	—					172 X 160	32 X 300		172 X 160	32 X 300		33,7		
332		48	38			180	140	—										43,1			
333		48	48			200	140	—											46,9		
334	300 X 200	33	28	23	24/25	160	125	—					172 X 200	72 X 300		172 X 200	72 X 300		41,6		
335		48	38			180	140	—										53,5			
336		48	48			200	140	—											58,5		
337	300 X 250	38	33	33	30/32	180	140	—					156 X 250	106 X 300		152 X 250	106 X 300		61,5		
338		48	38			200	160	—										70,5			
339		48	48			200	160	—											76,0		
340	300 X 300	38	33	33	30/32	180	140	—					156 X 300	156 X 300		156 X 300	156 X 300		73,0		
341		48	38			200	160	—										83,5			
342		48	48			200	160	—											90,5		
343	350 X 200	33	28	23	24/25	160	125	—					222 X 200	72 X 350		222 X 200	72 X 350		48,2		
344		48	38			180	160	—										62,0			
345		48	48			200	160	—											67,5		
346	350 X 250	38	33	33	30/32	180	140	—					206 X 250	106 X 350		206 X 250	106 X 350		71,0		
347		48	38			200	160	—										81,5			
348		48	48			200	160	—											88,5		
349	350 X 300	38	33	33	30/32	180	140	—					206 X 300	156 X 350		206 X 300	156 X 350		85,0		
350		48	38			200	160	—										97,0			
351		48	48			200	160	—											105,0		
352	350 X 350	38	33	33	30/32	180	140	—					206 X 350	206 X 350		206 X 350	206 X 350		98,5		
353		48	38			200	160	—										113,0			
354		48	48			200	160	—											123,0		
355	400 X 200	33	28	23	24/25	160	125	—					272 X 200	72 X 400		272 X 200	72 X 400		55,0		
356		48	38			180	140	—										70,5			
357		48	48			200	140	—											77,0		
358	400 X 250	38	33	33	30/32	180	140	—					256 X 250	106 X 400		256 X 250	106 X 400		81,0		
359		48	38			200	160	—											92,5		
360		48	48			200	160	—												101,0	

Position der Haltestücke / Position of holding clamps	
Pos. Z	Pos. X

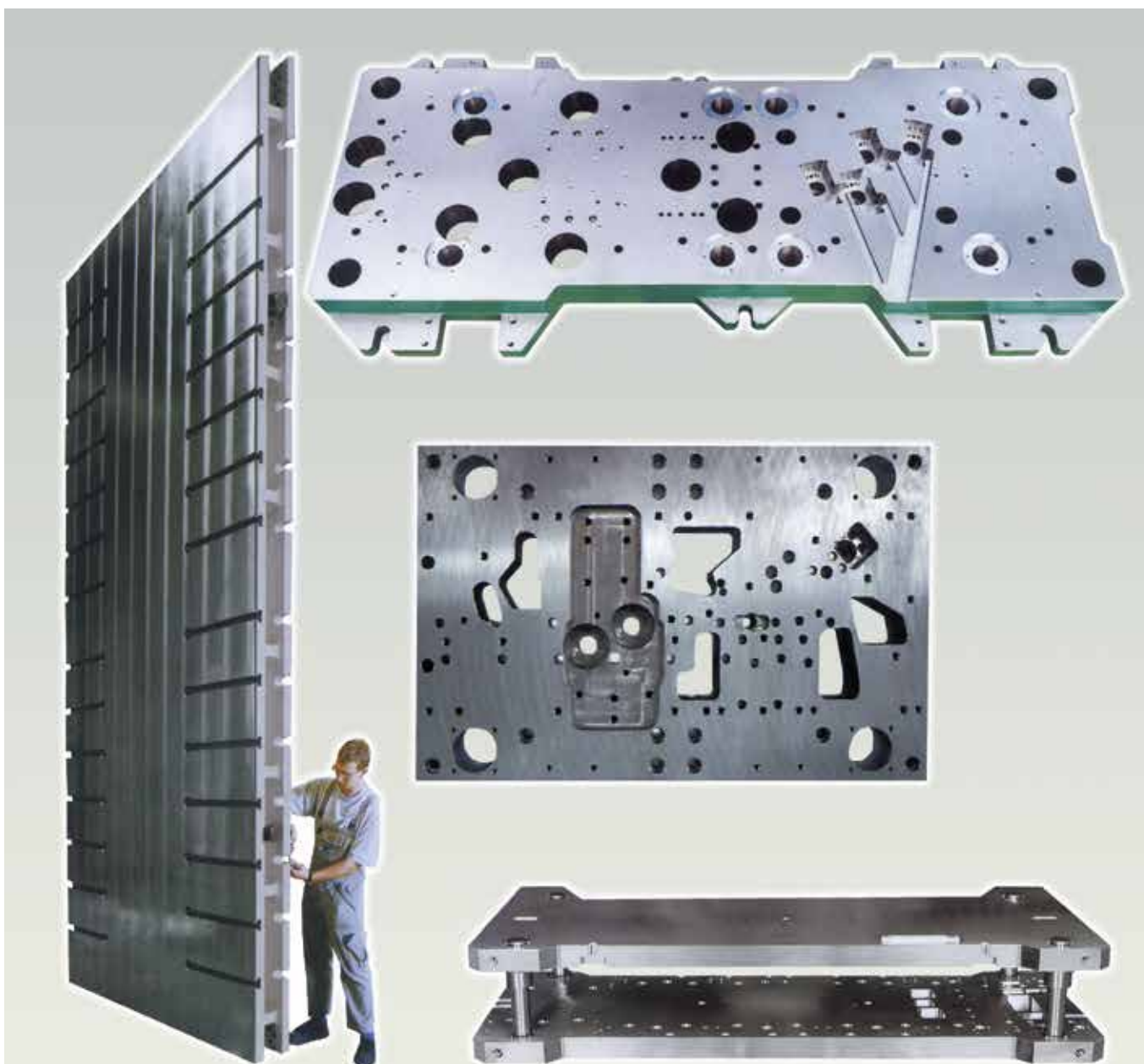
[SG.39]

Buchsentyp / Type of bushing			
Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated			
C1: FS 340 RM	C1: FS 350 RM		
C3: FS 330 RM	C3: FS 330 RM		
182	183		
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated			
C1: FS 351	C1: FS 355		
C3: FS 331	C3: FS 331		
172	173		
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage			
C1: FS 358 + FS 325	C1: FS 353 + FS 325		
C3: FS 357 + FS 325	C3: FS 357 + FS 325		
192	193		

Säulentyp / Type of leader pin	
eingepresst press-fitted	Schnellwechsel- säule mit Bund Leader pin, with collar
FS 320 IEP	FS 319 IER

Gestelltyp / Type of die set	

Position der Haltestücke / Position of holding clamps	
Pos. Z	Pos. X



CNC - Brennschneiden
CNC - flame cutting

Glühen
Annealing

Stahlkies strahlen
Steel shot blasting

Richten
Flattening

Farbgebung - Grundierung
Coloring - priming

CNC - Diskusschleifen
CNC - rotary grinding

CNC - Feinschleifen
CNC - finish grinding

Materiallager ST 52-3, Blechdicken 10 – 600 mm
Stock ST 52-3, sheet thickness 10 – 600 mm

Abmessungen 6.000 x 3.000 x 2.000 mm, bis 25 t Stückgewicht
Dimensions 6.000 x 3.000 x 2.000 mm, up to 25 t unit weight

Abmessungen 6.000 x 3.000 x 2.000 mm, bis 25 t Stückgewicht
Dimensions 6.000 x 3.000 x 2.000 mm, up to 25 t unit weight

Abmessungen 6.000 x 3.000 x 2.000 mm, bis 25 t Stückgewicht
Dimensions 6.000 x 3.000 x 2.000 mm, up to 25 t unit weight

Abmessungen 6.000 x 3.000 x 2.000 mm, bis 25 t Stückgewicht
Dimensions 6.000 x 3.000 x 2.000 mm, up to 25 t unit weight

Verfahrweg
Travelling distance 4.000 x 1.250 x 300 mm

Verfahrweg
Travelling distance 3.000 x 1.600 x 600 mm



CNC - Lehrenbohren
CNC - jig boring

CNC - Portalfräsen
CNC - portal milling

CNC - Fräsen und Bohren
CNC - milling and -drilling

CNC - Portalmessen
CNC - portal measuring

CNC - Tieflochbohren
CNC - gun drilling

Verfahrweg
Travelling distance 3.000 x 1.600 x 600 mm

Verfahrweg
Travelling distance 7.000 x 3.000 x 1.400 mm

Verfahrweg
Travelling distance 4.900 x 2.400 x 800 mm

Verfahrweg
Travelling distance 3.000 x 1.600 x 800 mm

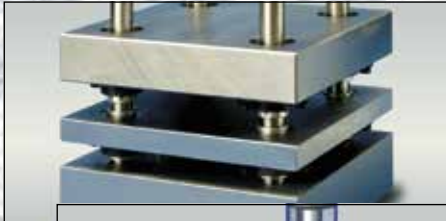
Durchmesser 30 – 120 mm / Diameter 30 – 120 mm
bis 1.500 mm als Sacklochbohrung / Blind holes up to 1.500 mm deep
bis 3.000 mm als Durchgangsbohrung / Through holes up to 3.000 mm long

Die Herstellung/Bearbeitung der Produkte erfolgt nach Kundenzeichnung oder nach CAD-Datei im DXF-, DWG-, IGES-, VDA- oder Catia-Format. / Basis for the manufacturing process are drawings supplied by the customer, printed or as DXF-, DWG-, IGES-, VDA- or Catia - CAD - data files.



Märkische Stanz-Partner

[lieferprogramm] [productrange]

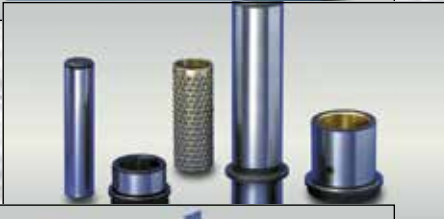


[säulengestelle]

in Standard- und Sonder-
Abmessungen ab 125 x 125 mm
bis 3.000 x 6.000 mm

[diesets]

in standard and custom sizes
between 125 x 125 mm up to
3.000 x 6.000 mm



[führungssysteme]

in den verschiedensten
Ausführungen

[guidingsystems]

available in various designs



[schneidelemente]

mit unterschiedlichsten
Schneidgeometrien

[cuttingelements]

with countless cutting-tip
geometries



[technischeHilfsmittel]

umfangreiche Auswahl von
Schrauben bis zu kleinen
Schiebern

[generaldiecomponents]

huge selection ranging from
screws to small cam units



[federelemente]

umfassendes Programm an ISO-,
Elastomer- und ähnlichen Federn

[springs]

extensive program of ISO-,
elastomer- and similar springs



[nitrocy]Gasdruckfedern]

umfangreiches Programm für
unterschiedliche Anwendungen

[nitrocy]GasSprings]

large program for all commonly
used applications



[hysonStickstoffSysteme]

große Auswahl aus dem Programm
eines der Weltmarktführer

[hysonNitrogenSystems]

huge program from one of the
world market leaders

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e-mail: mail@maerkische-stanz-partner.de • www.maerkische-stanz-partner.de

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