zertifiziert ISO 9001 for you Cert

MSPN GMBH

Märkische Stanz-Partner

[**säulen**gestelle]
[**die**sets]

Stand / Revision Status 30.10.2020

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[01.07.2020]

[01.07.2020]

Toleranzangaben für Säulengestelle aus Stahl

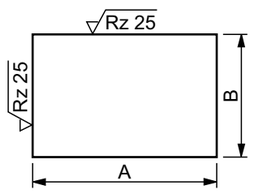
Tolerance - information regarding steel die sets

SÄULENGESTELLE / DIE SETS

[SG]

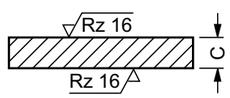
Mat.: C45

Toleranz Außenmaße /
Tolerance of length and width



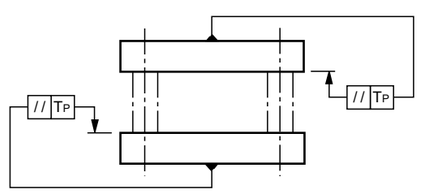
A x B +0,06 –0,06

Toleranz Plattenstärke /
Tolerance of thickness



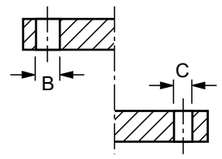
C ± 2

Parallelität der Flächenpaare /
Parallelism of two surfaces



TP = 0,012 / 100 mm

Bohrungstoleranzen /
Hole tolerances



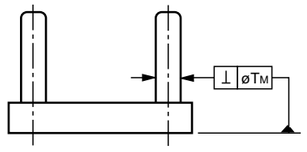
B = Aufnahmebohrung Buchse/ Mounting hole for bushing:

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

C = Aufnahmebohrung Säule/ Mounting hole for leader pin:

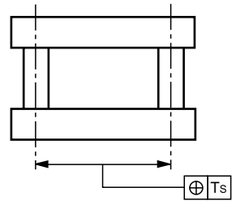
FS 420	= R7
FS 419	= JS6
FS 400/403	= H6

Winkelgenauigkeit der Führungssäulen /
Angular accuracy of leader pins



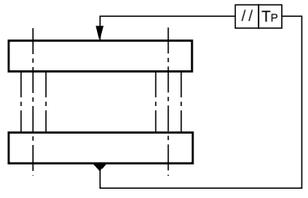
TM = 0,012 / 100 mm

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



TS = ± 0,010

Planparallelität im
zusammengebauten Zustand /
Parallelism after mounting



TP = 0,015 / 100 mm

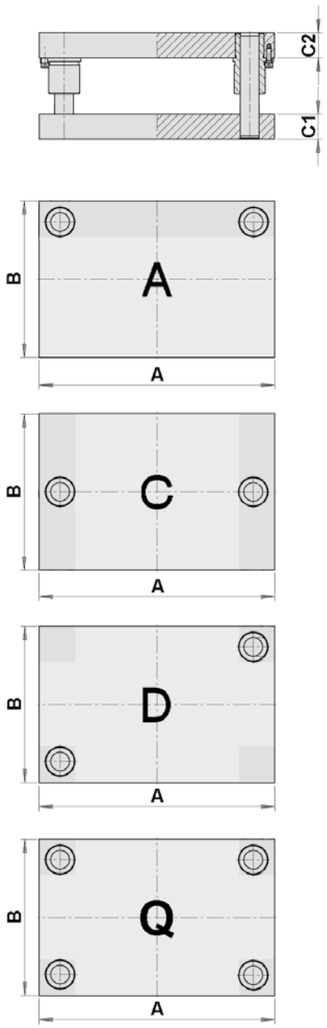
Säulen-Buchsen-Kombination für 2-Plattengestelle

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

Bestellbeispiel / Order-example

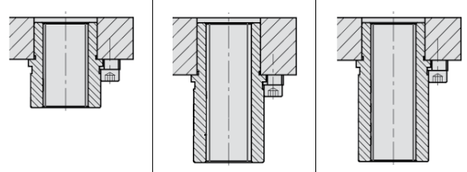
2 C	643	P	41	Z
Gestelltyp Type of die set	Kataloggröße Catalog sizes	Säulentyp Type of leader pin	Buchsentyp Type of bushing	Position der Haltestücke Position of holding clamps

Gestelltyp / Type of die set



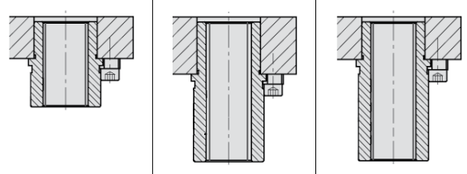
Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



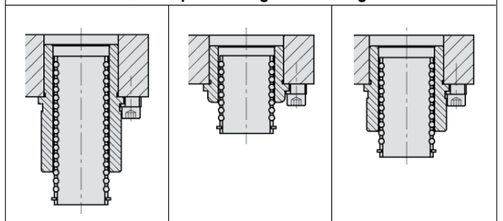
FS 741	FS 751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 641	FS 651	FS 655
41	42	43

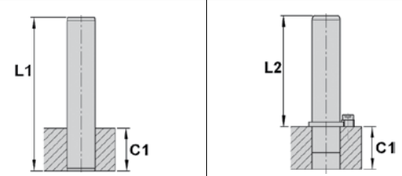
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

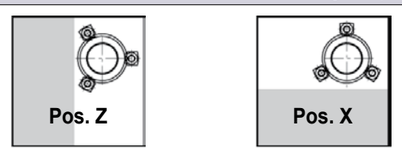
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin with collar



FS 420	FS 419
P	R

Position der Haltestücke / Position of holding clamps



[01.07.2020]

[01.07.2020]

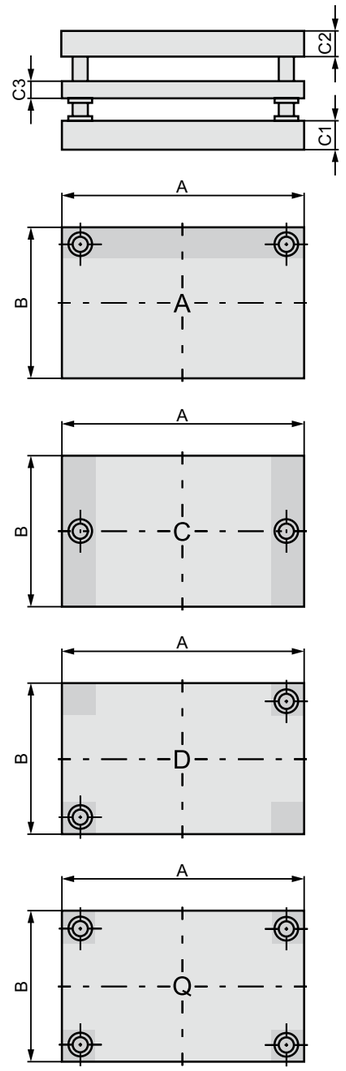
Säulen-Buchsen-Kombination für 3-Plattengestelle

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

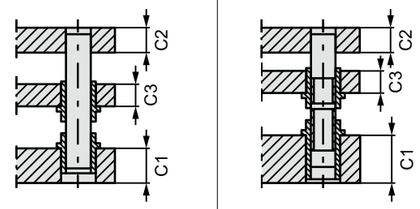
Bestellbeispiel / Order-example

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



Buchsentyp / Type of bushing



Sinterbuchse
Leader pin bushing, sintered

C1 = FS 741 C3 = FS 731	C1 = FS 732 C3 = FS 731
88	87

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated

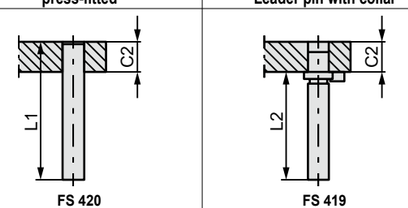
C1 = FS 641 C3 = FS 631	C1 = FS 632 C3 = FS 631
71	72

Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage

C1 = FS 458 + FS 425 C3 = FS 457 + FS 425	C1 = FS 453 + FS 425 C3 = FS 457 + FS 425
91	92

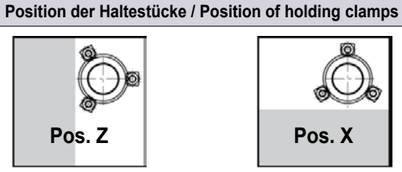
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin with collar



FS 420	FS 419
P	R

Position der Haltestücke / Position of holding clamps



Bestellbeispiel Sondergrößen

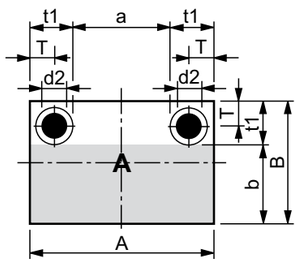
Order-example specials

Position 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 holding clamps
	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

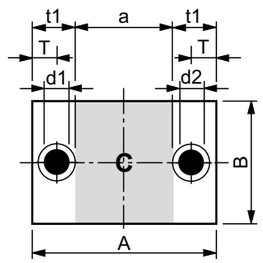
* = Säulentyp in C1 oder C2 bitte angeben. / Please fill in type of leader pin in C1 or C2.
** = Buchsentyp in C1 oder C2 bitte angeben. / Please fill in type of bushing in C1 or C2.

Arbeitsflächen / Working areas

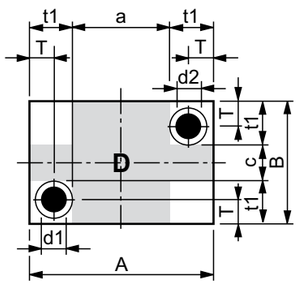
b = B - t1



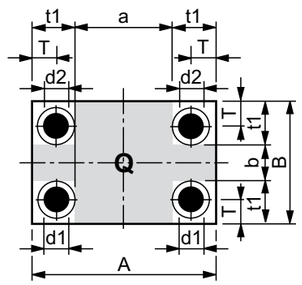
a = A - (2 x t1)



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

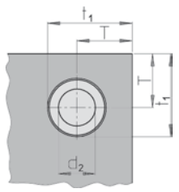


a = A - (2 x t1)
b = B - (2 x t1)



Zylindrische Führungsbuchsen

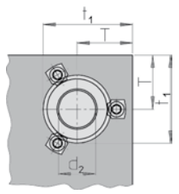
Leader pin bushings, cylindrical



d_1/d_2	T	t_1
18/19	25	40
24/25	29	46
30/32	37	60
40/42	45	74
50/52	52	87
63	–	–
80	–	–

Führungsbuchsen mit Bund

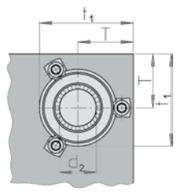
Leader pin bushings, with collar



d_1/d_2	T	t_1
18/19	32	49
24/25	37	59
30/32	44	71
40/42	49	81
50/52	57	97
63	64	117
80	73	135

Führungsbuchsen mit Bund für Kugelführung

Leader pin bushings, with collar for ball-bearings



d_1/d_2	T	t_1
18/19	35	55
24/25	40	65
30/32	48	79
40/42	53	89
50/52	61	105
63	–	–
80	–	–

[01.07.2020]

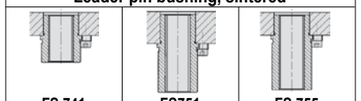
[01.07.2020]

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

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

Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



FS 741	FS751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated

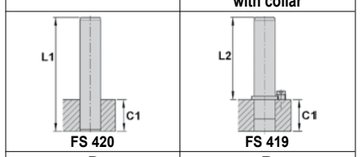
FS 641	FS 651	FS 655
41	42	43

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

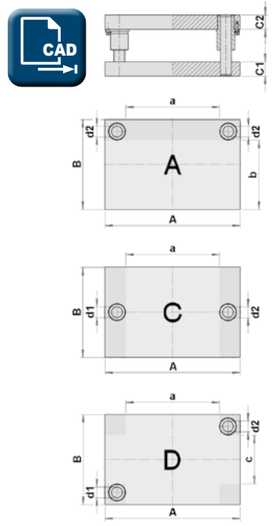
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

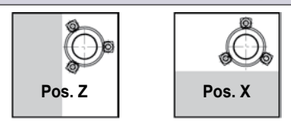


FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



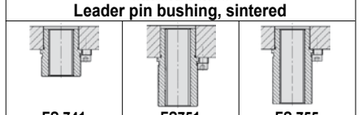
Größe / Size	A x B	Abmessungen / Dimensions: Plattenstärke Plate thickness C1	C2	C3	Ø d1/d2	Säulenlänge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area: a x B	b x A	c x A	46 41 a x B	47 42 b x A	48 43 c x A	51 a x B	52 b x A	53 c x A	Gewicht / Weight [kg]
601	125 X 125	28	23	–	18/19	130	100	–				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

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

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

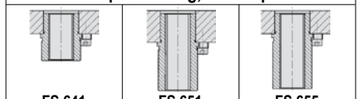
Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



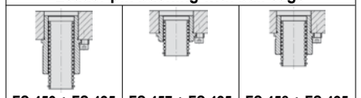
FS 741	FS751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 641	FS 651	FS 655
41	42	43

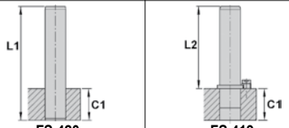
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

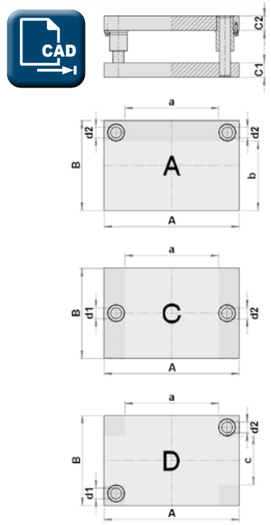
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

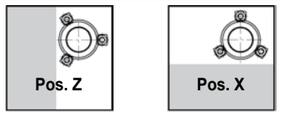


FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	46 41 a X B	b X A	c X A	47 42 a X B	b X A	c X A	48 43 a X B	b X A	c X A	51 a X B	b X A	c X A	52	53	Gewicht / Weight [kg]
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

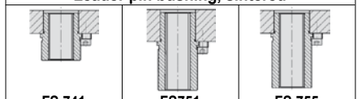
[01.07.2020]

[01.07.2020]

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

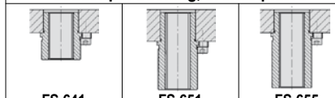
Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



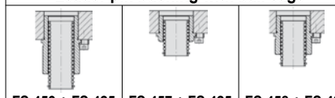
FS 741	FS751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 641	FS 651	FS 655
41	42	43

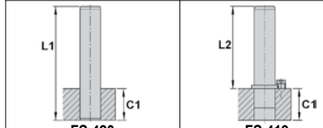
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

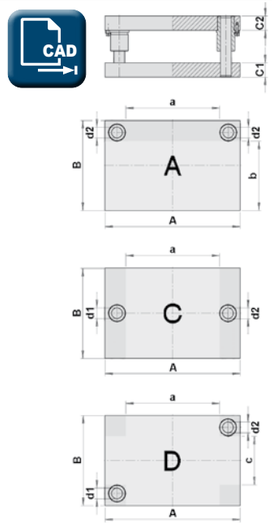
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

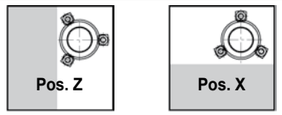


FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



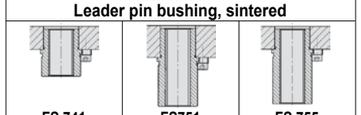
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	46 41 a X B	b X A	c X A	47 42 a X B	b X A	c X A	48 43 a X B	b X A	c X A	51 a X B	b X A	c X A	52	53	Gewicht / Weight [kg]
661	400 X 300	48	38	–	40/42	190	140	–				238 X 300	219 X 400	138 X 400	222 X 300	211 X 400	122 X 400						84,0
662		48	48	–		200	150	–															93,5
663		58	48	–		210	150	140															103,0
664	400 X 350	48	38	–	40/42	190	140	–				238 X 350	269 X 400	188 X 400	222 X 350	261 X 400	172 X 400						97,5
665		48	48	–		200	150	–															109,0
666		58	48	–		210	150	140															120,0
667	400 X 400	48	38	–	40/42	190	140	–				238 X 400	319 X 400	238 X 400	222 X 400	311 X 400	222 X 400						111,0
668		48	48	–		200	150	–															124,0
669		58	48	–		210	150	140															137,0
670	500 X 250	38	33	–	30/32	160	120	–				358 X 250	179 X 500	108 X 500	342 X 250	171 X 500	92 X 500						73,0
671		38	38	–		170	130	–															78,0
672		48	38	–		180	130	120															87,5
673	500 X 300	48	38	–	40/42	190	140	–				338 X 300	219 X 500	138 X 500	322 X 300	211 X 500	122 X 500						105,0
674		48	48	–		200	150	–															116,0
675		58	48	–		210	150	140															128,0
676	500 X 350	48	38	–	40/42	190	140	–				338 X 350	269 X 500	188 X 500	322 X 350	261 X 500	172 X 500						122,0
677		48	48	–		200	150	–															135,0
678		58	48	–		210	150	140															149,0
679	500 X 400	48	38	–	40/42	190	140	–				338 X 400	319 X 500	238 X 500	322 X 400	311 X 500	222 X 500						138,0
680		48	48	–		200	150	–															154,0
681		58	48	–		210	150	140															170,0
682	500 X 500	58	48	–	50/52	220	160	–				306 X 500	403 X 500	306 X 500	290 X 500	395 X 500	290 X 500						213,0
683		58	58	–		230	170	–															233,0
684		68	58	–		240	170	160															252,0
685	600 X 300	58	48	–	50/52	220	160	–				406 X 300	203 X 600	106 X 600	390 X 300	195 X 600	90 X 600						155,0
686		58	58	–		230	170	–															169,0
687		68	58	–		240	170	160															183,0
688	600 X 350	58	48	–	50/52	220	160	–				406 X 350	253 X 600	156 X 600	390 X 350	245 X 600	140 X 600						180,0
689		58	58	–		230	170	–															196,0
690		68	58	–		240	170	160															213,0

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

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

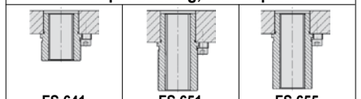
Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



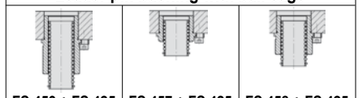
FS 741	FS751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 641	FS 651	FS 655
41	42	43

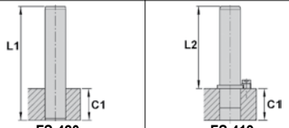
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

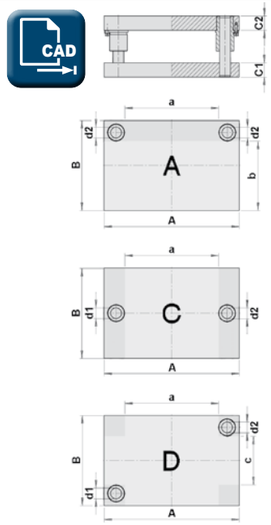
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

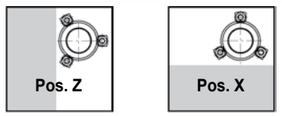


FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	46 41 a X B	47 42 b X A	48 43 c X A	51 a X B	52 b X A	53 c X A	Gewicht / Weight [kg]
691	600 X 400	58	48	–	50/52	220	160	–				406 X 400	303 X 600	206 X 600	390 X 400	295 X 600	190 X 600	205,0
692		58	58	–		230	170	–										224,0
693		68	58	–		240	170	160										242,0
694	600 X 500	58	48	–	50/52	220	160	–				406 X 500	403 X 600	306 X 600	390 X 500	395 X 600	290 X 600	254,0
695		58	58	–		230	170	–										278,0
696		68	58	–		240	170	160										302,0
697	600 X 600	58	48	–	50/52	220	160	–				406 X 600	503 X 600	406 X 600	390 X 600	495 X 600	390 X 600	305,0
698		58	58	–		230	170	–										333,0
699		68	58	–		240	170	160										361,0
700	700 X 350	58	48	–	50/52	220	160	–				506 X 350	253 X 700	156 X 700	490 X 350	245 X 700	140 X 700	209,0
701		58	58	–		230	170	–										228,0
702		68	58	–		240	170	160										247,0
703	700 X 400	58	48	–	50/52	220	160	–				506 X 400	303 X 700	206 X 700	490 X 400	295 X 700	190 X 700	238,0
704		58	58	–		230	170	–										260,0
705		68	58	–		240	170	160										282,0
706	700 X 500	58	48	–	50/52	220	160	–				506 X 500	403 X 700	306 X 700	490 X 500	395 X 700	290 X 700	296,0
707		58	58	–		230	170	–										324,0
708		68	58	–		240	170	160										351,0
709	700 X 600	58	48	–	50/52	220	160	–				506 X 600	503 X 700	406 X 700	490 X 600	495 X 700	390 X 700	354,0
710		58	58	–		230	170	–										388,0
711		68	58	–		240	170	160										420,0
712	800 X 400	58	48	–	50/52	220	160	–				606 X 400	303 X 800	206 X 800	590 X 400	295 X 800	190 X 800	271,0
713		58	58	–		230	170	–										296,0
714		68	58	–		240	170	160										321,0
715	800 X 500	58	48	–	50/52	220	160	–				606 X 500	403 X 800	306 X 800	590 X 500	395 X 800	290 X 800	338,0
716		58	58	–		230	170	–										369,0
717		68	58	–		240	170	160										400,0
718	800 X 600	58	48	–	50/52	220	160	–				606 X 600	503 X 800	406 X 800	590 X 600	495 X 800	390 X 800	404,0
719		58	58	–		230	170	–										442,0
720		68	58	–		240	170	160										480,0

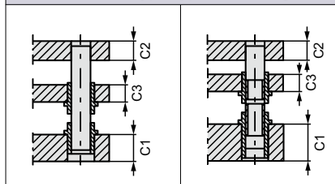
[01.07.2020]

[01.07.2020]

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

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

Buchsentyp / Type of bushing



Sinterbuchse
Leader pin bushing, sintered

C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated

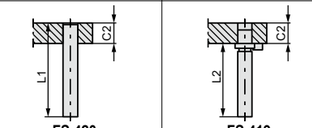
C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72

Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage

C1: FS 458 + FS 425 C3: FS 457 + FS 425	C1: FS 453 + FS 425 C3: FS 457 + FS 425
91	92

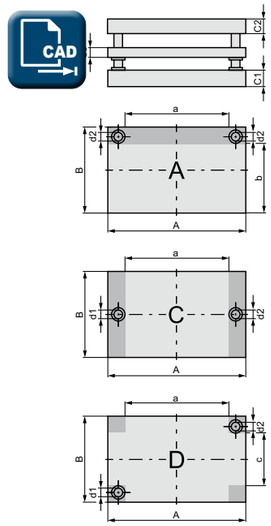
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

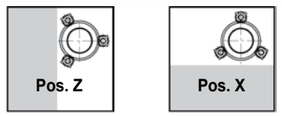


FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps

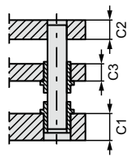


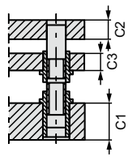
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	88 71 a X B	87 72 b X A	c X A	91 a X B	92 b X A	c X A	Gewicht / Weight [kg]
601	125 X 125	28	23	18	18/19	140	120	–				27 X 125	76 X 125	27 X 125		70 X 125		9,4
602		38	28			160	130	–										11,2
603		38	38			170	130	120										12,4
604	160 X 125	28	23	18	18/19	140	120	–				62 X 125	76 X 160	27 X 160	50 X 125	70 X 160		11,7
605		38	28			160	130	–										14,2
606		38	38			170	130	120										15,8
607	160 X 160	28	23	18	18/19	140	120	–				62 X 160	111 X 160	62 X 160	50 X 160	105 X 160	50 X 160	14,8
608		38	28			160	130	–										17,8
609		38	38			170	130	120										19,8
610	200 X 125	28	23	18	18/19	140	120	–				102 X 125	76 X 200	27 X 200	90 X 125	70 X 200		14,4
611		38	28			160	130	–										17,4
612		38	38			170	130	120										19,4
613	200 X 160	33	28	23	24/25	160	130	–				82 X 160	101 X 200	42 X 200	70 X 160	95 X 200		22,3
614		48	38			190	150	–										28,4
615		48	48			200	150	140										30,9
616	200 X 200	33	28	23	24/25	160	130	–				82 X 200	141 X 200	82 X 200	70 X 200	135 X 200	70 X 200	27,5
617		48	38			190	150	–										35,2
618		48	48			200	150	140										38,4
619	250 X 125	33	28	23	24/25	160	130	–				132 X 125	66 X 250		120 X 125	60 X 250		21,8
620		48	38			190	150	–										27,8
621		48	48			200	150	140										30,2
622	250 X 160	33	28	23	24/25	160	130	–				132 X 160	101 X 250	42 X 250	120 X 160	95 X 250		27,5
623		48	38			190	150	–										35,2
624		48	48			200	150	140										38,4
625	250 X 200	33	28	23	24/25	160	130	–				132 X 200	141 X 250	82 X 250	120 X 200	135 X 250	70 X 250	34,2
626		48	38			190	150	–										43,8
627		48	48			200	150	140										47,7
628	250 X 250	38	33	28	30/32	170	140	–				108 X 250	179 X 250	108 X 250	92 X 250	171 X 250	92 X 250	50,5
629		48	38			190	150	–										57,5
630		48	48			200	150	140										62,5

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

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

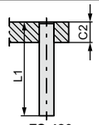
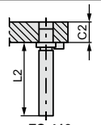
Buchsentyp / Type of bushing



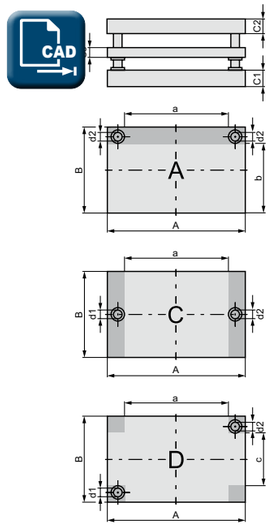


Sinterbuchse Leader pin bushing, sintered	
C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 458 + FS 425 C3: FS 457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

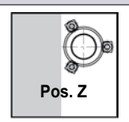
Säulentyp / Type of leader pin

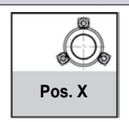
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	88 71 a X B	87 72 b X A	c X A	91 a X B	92 b X A	c X A	Gewicht / Weight [kg]
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										45,9
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

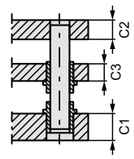
[01.07.2020]

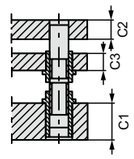
Säulengestelle aus Stahl, 3 Platten, 2 Säulen, Typ A-C-D

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

SÄULENGESTELLE / DIE SETS

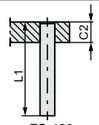
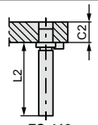
Buchsentyp / Type of bushing



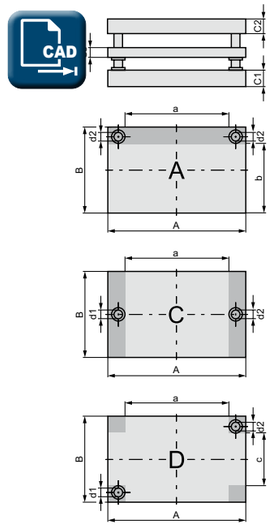


Sinterbuchse Leader pin bushing, sintered	
C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 458 + FS 425 C3: FS 457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

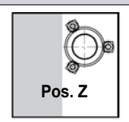
Säulentyp / Type of leader pin

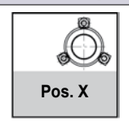
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





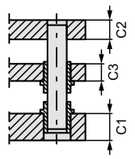
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	88 71 a X B	87 72 b X A	c X A	91 a X B	92 b X A	c X A	Gewicht / Weight [kg]
661	400 X 300	48	38	33	40/42	200	160	–				238 X 300	219 X 400	138 X 400	222 X 300	211 X 400	122 X 400	115,0
662		58	48			220	170	–										134,0
663		58	58			230	170	160										144,0
664	400 X 350	48	38	33	40/42	200	160	–				238 X 350	269 X 400	188 X 400	222 X 350	261 X 400	172 X 400	134,0
665		58	48			220	170	–										156,0
666		58	58			230	170	160										167,0
667	400 X 400	48	38	33	40/42	200	160	–				238 X 400	319 X 400	238 X 400	222 X 400	311 X 400	222 X 400	153,0
668		58	48			220	170	–										178,0
669		58	58			230	170	160										190,0
670	500 X 250	38	33	28	30/32	170	140	–				358 X 250	179 X 500	108 X 500	342 X 250	171 X 500	92 X 500	99,0
671		48	38			190	150	–										114,0
672		48	48			200	150	140										124,0
673	500 X 300	48	38	33	40/42	200	160	–				338 X 300	219 X 500	138 X 500	322 X 300	211 X 500	122 X 500	143,0
674		58	48			220	170	–										167,0
675		58	58			230	170	160										179,0
676	500 X 350	48	38	33	40/42	200	160	–				338 X 350	269 X 500	188 X 500	322 X 350	261 X 500	172 X 500	167,0
677		58	48			220	170	–										194,0
678		58	58			230	170	160										208,0
679	500 X 400	48	38	33	40/42	200	160	–				338 X 400	319 X 500	238 X 500	322 X 400	311 X 500	222 X 500	190,0
680		58	48			220	170	–										222,0
681		58	58			230	170	160										237,0
682	500 X 500	58	48	38	50/52	230	180	–				306 X 500	403 X 500	306 X 500	290 X 500	395 X 500	290 X 500	287,0
683		68	58			250	200	–										327,0
684		68	68			260	200	180										346,0
685	600 X 300	58	48	38	50/52	230	180	–				406 X 300	203 X 600	106 X 600	390 X 300	195 X 600	90 X 600	208,0
686		68	58			250	200	–										237,0
687		68	68			260	200	180										251,0
688	600 X 350	58	48	38	50/52	230	180	–				406 X 350	253 X 600	156 X 600	390 X 350	245 X 600	140 X 600	242,0
689		68	58			250	200	–										275,0
690		68	68			260	200	180										292,0

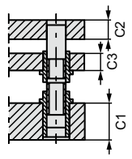
[01.07.2020]

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

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

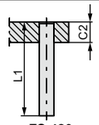
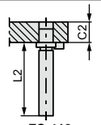
Buchsentyp / Type of bushing



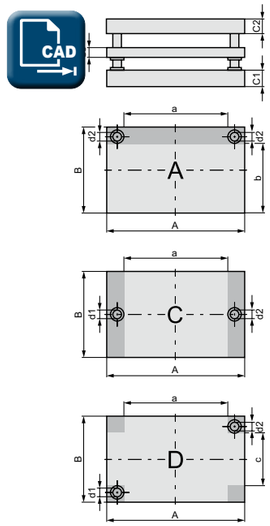


Sinterbuchse Leader pin bushing, sintered	
C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 458 + FS 425 C3: FS 457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

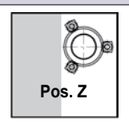
Säulentyp / Type of leader pin

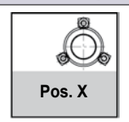
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	88 71 a X B	87 72 b X A	c X A	91 a X B	92 b X A	c X A	Gewicht / Weight [kg]
691	600 X 400	58	48	38	50/52	230	180	–				406 X 400	303 X 600	206 X 600	390 X 400	295 X 600	190 X 600	276,0
692		68	58			250	200	–										314,0
693		68	68			260	200	180										333,0
694	600 X 500	58	48	38	50/52	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			250	200	–										391,0
696		68	68			260	200	180										415,0
697	600 X 600	58	48	38	50/52	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			250	200	–										468,0
699		68	68			260	200	180										497,0
700	700 X 350	58	48	38	50/52	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			250	200	–										320,0
702		68	68			260	200	180										340,0
703	700 X 400	58	48	38	50/52	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			250	200	–										365,0
705		68	68			260	200	180										387,0
706	700 X 500	58	48	38	50/52	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			250	200	–										455,0
708		68	68			260	200	180										483,0
709	700 X 600	58	48	38	50/52	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			250	200	–										545,0
711		68	68			260	200	180										579,0
712	800 X 400	58	48	38	50/52	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			250	200	–										417,0
714		68	68			260	200	180										442,0
715	800 X 500	58	48	38	50/52	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			250	200	–										520,0
717		68	68			260	200	180										551,0
718	800 X 600	58	48	38	50/52	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			250	200	–										623,0
720		68	68			260	200	180										661,0

[01.07.2020]

[01.07.2020]

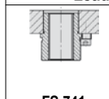
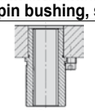
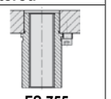
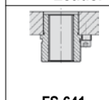
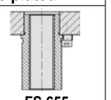
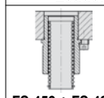
Säulengestelle aus Stahl, 2 Platten, 4 Säulen, Typ Q

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

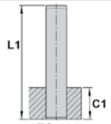
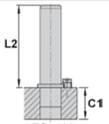
SÄULENGESTELLE / DIE SETS

[SG]

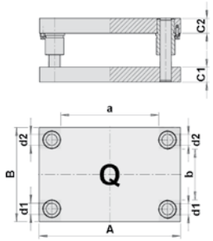
Buchsentyp / Type of bushing

Sinterbuchse Leader pin bushing, sintered		
		
FS 741	FS751	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

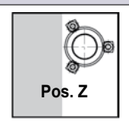
Säulentyp / Type of leader pin

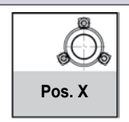
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





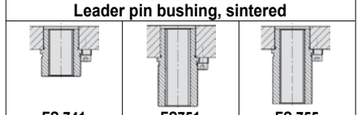
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	46 41 a X B	47 42 b X A	48 43 c X A	51 a X B	52 b X A	53 c X A	Gewicht / Weight [kg]
601	125 X 125	28	23	–	18/19	130	100	–				27 X 125	27 X 125					7,8
602		28	28	–		140	110	–										8,4
603		38	28	–		150	110	100										9,7
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

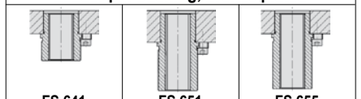
Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



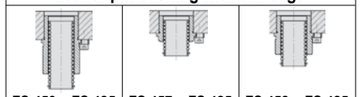
FS 741	FS751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 641	FS 651	FS 655
41	42	43

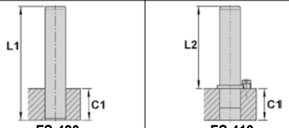
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

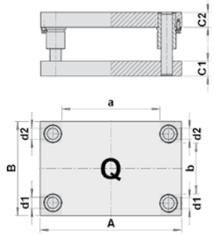
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

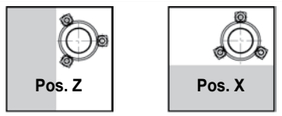


FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	46 41 a X B	b X A	c X A	47 42 a X B	b X A	c X A	48 43 a X B	b X A	c X A	51 a X B	b X A	c X A	52	53	Gewicht / Weight [kg]
631	300 X 160	33	28	–	24/25	150	110	–				182 X 160	42 X 300					170 X 160	30 X 300				25,0
632		33	33	–		160	120	–															26,9
633		48	38	–		180	130	120															34,4
634	300 X 200	33	28	–	24/25	150	110	–				182 X 200	82 X 300					170 X 200	70 X 300				30,8
635		33	33	–		160	120	–															33,1
636		48	38	–		180	130	120															42,5
637	300 X 250	38	33	–	30/32	160	120	–				158 X 250	108 X 300					142 X 250	92 X 300				44,8
638		38	38	–		170	130	–															47,8
639		48	38	–		180	130	120															54,0
640	300 X 300	38	33	–	30/32	160	120	–				158 X 300	158 X 300					142 X 300	142 X 300				53,5
641		38	38	–		170	130	–															57,0
642		48	38	–		180	130	120															64,0
643	350 X 200	33	28	–	24/25	150	110	–				232 X 200	82 X 350					220 X 200	70 X 350				35,6
644		33	33	–		160	120	–															38,3
645		48	38	–		180	130	120															49,3
646	350 X 250	38	33	–	30/32	160	120	–				208 X 250	108 X 350					192 X 250	92 X 350				52,5
647		38	38	–		170	130	–															55,5
648		48	38	–		180	130	120															62,0
649	350 X 300	38	33	–	30/32	160	120	–				208 X 300	158 X 350					192 X 300	142 X 350				61,5
650		38	38	–		170	130	–															66,0
651		48	38	–		180	130	120															74,0
652	350 X 350	38	33	–	30/32	160	120	–				208 X 350	208 X 350					192 X 350	192 X 350				71,5
653		38	38	–		170	130	–															76,5
654		48	38	–		180	130	120															86,0
655	400 X 200	33	28	–	24/25	150	110	–				282 X 200	82 X 400					270 X 200	70 X 400				40,4
656		33	33	–		160	120	–															43,5
657		48	38	–		180	130	120															56,0
658	400 X 250	38	33	–	30/32	160	120	–				258 X 250	108 X 400					242 X 250	92 X 400				59,0
659		38	38	–		170	130	–															63,0
660		48	38	–		180	130	120															70,5

[01.07.2020]

[01.07.2020]

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

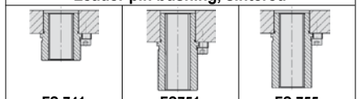
Steel die sets, 2 plates, 4 posts, type Q

SÄULENGESTELLE / DIE SETS

[SG]

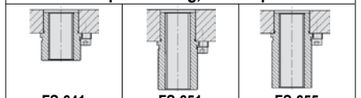
Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



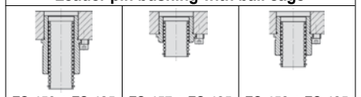
FS 741	FS751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 641	FS 651	FS 655
41	42	43

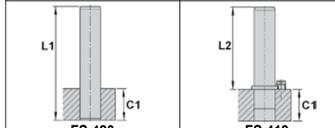
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

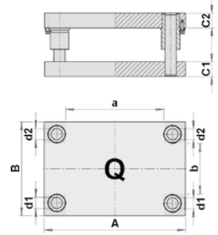
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

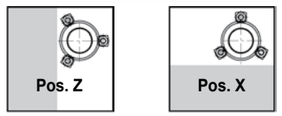


FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



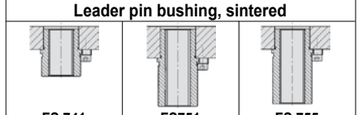
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	46 41 a X B	b X A	c X A	47 42 a X B	b X A	c X A	48 43 a X B	b X A	c X A	51 a X B	b X A	c X A	52	53	Gewicht / Weight [kg]
661	400 X 300	48	38	–	40/42	190	140	–				238 X 300	138 X 400					222 X 300	122 X 400				87,0
662		48	48	–		200	150	–															96,5
663		58	48	–		210	150	140															106,0
664	400 X 350	48	38	–	40/42	190	140	–				238 X 350	188 X 400					222 X 350	172 X 400				101,0
665		48	48	–		200	150	–															112,0
666		58	48	–		210	150	140															123,0
667	400 X 400	48	38	–	40/42	190	140	–				238 X 400	238 X 400					222 X 400	222 X 400				114,0
668		48	48	–		200	150	–															127,0
669		58	48	–		210	150	140															140,0
670	500 X 250	38	33	–	30/32	160	120	–				358 X 250	108 X 500					342 X 250	92 X 500				73,0
671		38	38	–		170	130	–															78,0
672		48	38	–		180	130	120															87,5
673	500 X 300	48	38	–	40/42	190	140	–				338 X 300	138 X 500					322 X 300	122 X 500				108,0
674		48	48	–		200	150	–															119,0
675		58	48	–		210	150	140															131,0
676	500 X 350	48	38	–	40/42	190	140	–				338 X 350	188 X 500					322 X 350	172 X 500				125,0
677		48	48	–		200	150	–															138,0
678		58	48	–		210	150	140															152,0
679	500 X 400	48	38	–	40/42	190	140	–				338 X 400	238 X 500					322 X 400	222 X 500				141,0
680		48	48	–		200	150	–															157,0
681		58	48	–		210	150	140															173,0
682	500 X 500	48	38	–	40/42	190	140	–				338 X 500	338 X 500					322 X 500	322 X 500				175,0
683		48	48	–		200	150	–															195,0
684		58	48	–		210	150	140															214,0
685	600 X 300	48	38	–	40/42	190	140	–				438 X 300	138 X 600					422 X 300	122 X 600				128,0
686		48	48	–		200	150	–															142,0
687		58	48	–		210	150	140															156,0
688	600 X 350	48	38	–	40/42	190	140	–				438 X 350	188 X 600					422 X 350	172 X 600				148,0
689		48	48	–		200	150	–															165,0
690		58	48	–		210	150	140															181,0

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

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

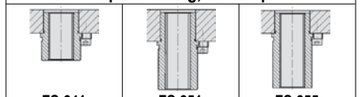
Buchsentyp / Type of bushing

Sinterbuchse
Leader pin bushing, sintered



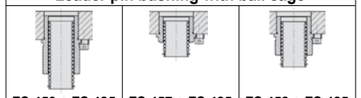
FS 741	FS751	FS 755
46	47	48

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



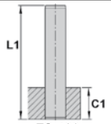
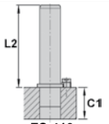
FS 641	FS 651	FS 655
41	42	43

Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage

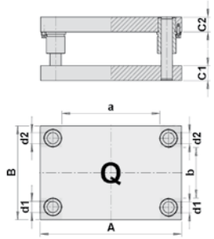


FS 453 + FS 425	FS 457 + FS 425	FS 458 + FS 425
51	52	53

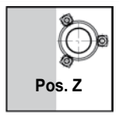
Säulentyp / Type of leader pin

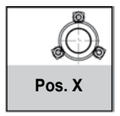
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps


Pos. Z


Pos. X

Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness C1	C2	C3	Ø d1/d2	Säulenlänge Length of leader pin L1	L2	L3	a X B	b X A	c X A	46 41 a X B	47 42 b X A	48 43 c X A	51 a X B	52 b X A	53 c X A	
691	600 X 400	48	38	–	40/42	190	140	–				438 X 400	238 X 600		422 X 400	222 X 600		168,0
692		48	48	–		200	150	–										187,0
693		58	48	–		210	150	140										206,0
694	600 X 500	58	48	–	50/52	220	160	–				406 X 500	306 X 600		390 X 500	290 X 600		259,0
695		58	58	–		230	170	–										283,0
696		68	58	–		240	170	160										306,0
697	600 X 600	58	48	–	50/52	220	160	–				406 X 600	406 X 600		390 X 600	390 X 600		309,0
698		58	58	–		230	170	–										337,0
699		68	58	–		240	170	160										365,0
700	700 X 350	48	38	–	40/42	190	140	–				538 X 350	188 X 700		522 X 350	172 X 700		172,0
701		48	48	–		200	150	–										191,0
702		58	48	–		210	150	140										210,0
703	700 X 400	58	48	–	50/52	220	160	–				506 X 400	206 X 700		490 X 400	190 X 700		242,0
704		58	58	–		230	170	–										264,0
705		68	58	–		240	170	160										286,0
706	700 X 500	58	48	–	50/52	220	160	–				506 X 500	306 X 700		490 X 500	290 X 700		300,0
707		58	58	–		230	170	–										328,0
708		68	58	–		240	170	160										356,0
709	700 X 600	58	48	–	50/52	220	160	–				506 X 600	406 X 700		490 X 600	390 X 700		359,0
710		58	58	–		230	170	–										392,0
711		68	58	–		240	170	160										425,0
712	800 X 400	58	48	–	50/52	220	160	–				606 X 400	206 X 800		590 X 400	190 X 800		276,0
713		58	58	–		230	170	–										301,0
714		68	58	–		240	170	160										326,0
715	800 X 500	58	48	–	50/52	220	160	–				606 X 500	306 X 800		590 X 500	290 X 800		342,0
716		58	58	–		230	170	–										374,0
717		68	58	–		240	170	160										405,0
718	800 X 600	58	48	–	50/52	220	160	–				606 X 600	406 X 800		590 X 600	390 X 800		409,0
719		58	58	–		230	170	–										447,0
720		68	58	–		240	170	160										484,0

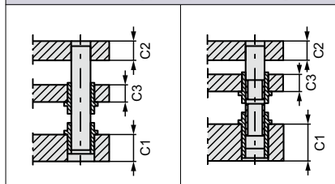
[01.07.2020]

[01.07.2020]

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

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

Buchsentyp / Type of bushing



Sinterbuchse
Leader pin bushing, sintered

C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87

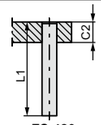
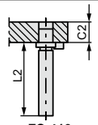
Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated

C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72

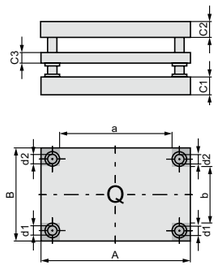
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage

C1: FS 458 + FS 425 C3: FS 457 + FS 425	C1: FS 453 + FS 425 C3: FS 457 + FS 425
91	92

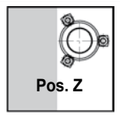
Säulentyp / Type of leader pin

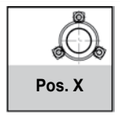
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps


Pos. Z

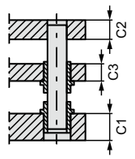

Pos. X

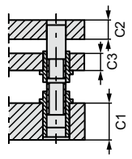
Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness C1	C2	C3	Ø d1/d2	Säulenlänge Length of leader pin L1	L2	L3	a X B	b X A	c X A	88 71 a X B	87 72 b X A	c X A	91 a X B	92 b X A	c X A	
601	125 X 125	28	23	18	18/19	140	120	–				27 X 125	27 X 125					10,0
602		38	28			160	130	–										11,8
603		38	38			170	130	120										13,1
604	160 X 125	28	23	18	18/19	140	120	–				62 X 125	27 X 160					12,4
605		38	28			160	130	–										14,2
606		38	38			170	130	120										16,3
607	160 X 160	28	23	18	18/19	140	120	–				62 X 160	62 X 160		50 X 160	50 X 160		15,4
608		38	28			160	130	–										18,4
609		38	38			170	130	120										20,4
610	200 X 125	28	23	18	18/19	140	120	–				102 X 125	27 X 200		90 X 125			15,1
611		38	28			160	130	–										18,0
612		38	38			170	130	120										20,0
613	200 X 160	28	23	18	18/19	140	120	–				102 X 160	62 X 200		90 X 160	50 X 200		18,9
614		38	28			160	130	–										22,6
615		38	38			170	130	120										25,2
616	200 X 200	28	23	18	18/19	140	120	–				102 X 200	102 X 200		90 X 200	90 X 200		23,2
617		38	28			160	130	–										27,9
618		38	38			170	130	120										31,1
619	250 X 125	28	23	18	18/19	140	120	–				152 X 125	27 X 250		140 X 125			18,5
620		38	28			160	130	–										22,1
621		38	38			170	130	120										24,6
622	250 X 160	28	23	18	18/19	140	120	–				152 X 160	60 X 250		140 X 160	50 X 250		23,2
623		38	28			160	130	–										27,9
624		38	38			170	130	120										31,1
625	250 X 200	33	28	23	24/25	160	130	–				132 X 200	82 X 250		120 X 200	70 X 250		35,0
626		48	38			190	150	–										44,8
627		48	48			200	150	140										48,7
628	250 X 250	33	28	23	24/25	160	130	–				132 X 250	132 X 250		120 X 250	120 X 250		43,2
629		48	38			190	150	–										55,5
630		48	48			200	150	140										60,5

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

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

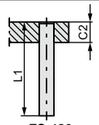
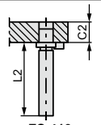
Buchsentyp / Type of bushing



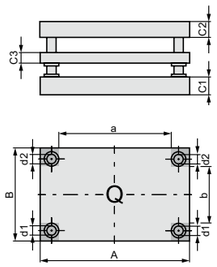


Sinterbuchse Leader pin bushing, sintered	
C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 458 + FS 425 C3: FS 457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

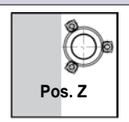
Säulentyp / Type of leader pin

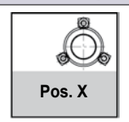
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness			Ø	Säulenlänge Length of leader pin						88 87 71 72			91 92			
		C1	C2	C3	d1/d2	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

[01.07.2020]

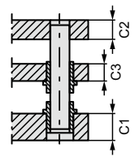
[01.07.2020]

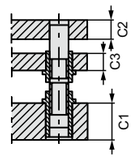
Säulengestelle aus Stahl, 3 Platten, 4 Säulen, Typ Q

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

SÄULENGESTELLE / DIE SETS

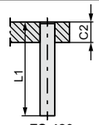
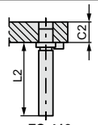
Buchsentyp / Type of bushing



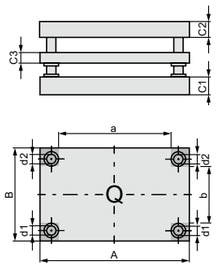


Sinterbuchse Leader pin bushing, sintered	
C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 458 + FS 425 C3: FS 457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

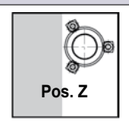
Säulentyp / Type of leader pin

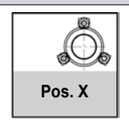
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



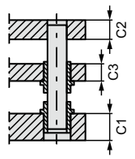


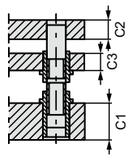
Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness			Ø	Säulenlänge Length of leader pin						88 87 71 72			91 92			
		C1	C2	C3	d1/d2	L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A	
661	400 X 300	48	38	33	40/42	200	160	–				238 X 300	138 X 400		222 X 300	122 X 400		118,0
662		58	48			220	170	–										137,0
663		58	58			230	170	160										147,0
664	400 X 350	48	38	33	40/42	200	160	–				238 X 350	188 X 400		222 X 350	172 X 400		137,0
665		58	48			220	170	–										159,0
666		58	58			230	170	160										170,0
667	400 X 400	48	38	33	40/42	200	160	–				238 X 400	238 X 400		222 X 400	222 X 400		156,0
668		58	48			220	170	–										181,0
669		58	58			230	170	160										194,0
670	500 X 250	38	33	28	30/32	170	140	–				358 X 250	108 X 500		342 X 250	92 X 500		100,0
671		48	38			190	150	–										115,0
672		48	48			200	150	140										125,0
673	500 X 300	48	38	33	40/42	200	160	–				338 X 300	138 X 500		322 X 300	122 X 500		146,0
674		58	48			220	170	–										170,0
675		58	58			230	170	160										182,0
676	500 X 350	48	38	33	40/42	200	160	–				338 X 350	188 X 500		322 X 350	172 X 500		170,0
677		58	48			220	170	–										197,0
678		58	58			230	170	160										211,0
679	500 X 400	48	38	33	40/42	200	160	–				338 X 400	238 X 500		322 X 400	222 X 500		193,0
680		58	48			220	170	–										225,0
681		58	58			230	170	160										240,0
682	500 X 500	48	38	33	40/42	200	160	–				338 X 500	338 X 500		322 X 500	322 X 500		240,0
683		58	48			220	170	–										279,0
684		58	58			230	170	160										299,0
685	600 X 300	48	38	33	40/42	200	160	–				438 X 300	138 X 600		422 X 300	122 X 600		174,0
686		58	48			220	170	–										203,0
687		58	58			230	170	160										217,0
688	600 X 350	48	38	33	40/42	200	160	–				438 X 350	188 X 600		422 X 350	172 X 600		202,0
689		58	48			220	170	–										235,0
690		58	58			230	170	160										252,0

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

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

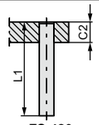
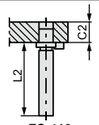
Buchsentyp / Type of bushing



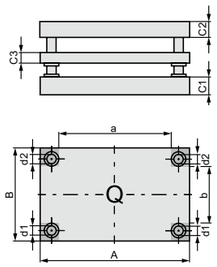


Sinterbuchse Leader pin bushing, sintered	
C1: FS 741 C3: FS 731	C1: FS 732 C3: FS 731
88	87
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 641 C3: FS 631	C1: FS 632 C3: FS 631
71	72
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 458 + FS 425 C3: FS 457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

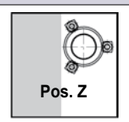
Säulentyp / Type of leader pin

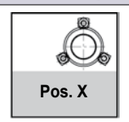
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 420	FS 419
P	R

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Platten-stärke Plate thickness			Ø	Säulen-länge Length of leader pin						88 87 71 72			91 92			
		C1	C2	C3	d1/d2	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	–				438 X 400	238 X 600		422 X 400	222 X 600		230,0
692		58	48			220	170	–										268,0
693		58	58			230	170	160										287,0
694	600 X 500	58	48	38	50/52	230	180	–				406 X 500	306 X 600		390 X 500	290 X 600		348,0
695		68	58			250	200	–										395,0
696		68	68			260	200	180										419,0
697	600 X 600	58	48	38	50/52	230	180	–				406 X 600	406 X 600		390 X 600	390 X 600		416,0
698		68	58			250	200	–										473,0
699		68	68			260	200	180										501,0
700	700 X 350	48	38	33	40/42	200	160	–				538 X 350	188 X 700		522 X 350	172 X 700		235,0
701		58	48			220	170	–										274,0
702		58	58			230	170	160										293,0
703	700 X 400	58	48	38	50/52	230	180	–				506 X 400	206 X 700		490 X 400	190 X 700		326,0
704		68	58			250	200	–										370,0
705		68	68			260	200	180										392,0
706	700 X 500	58	48	38	50/52	230	180	–				506 X 500	306 X 700		490 X 500	290 X 700		405,0
707		68	58			250	200	–										460,0
708		68	68			260	200	180										487,0
709	700 X 600	58	48	38	50/52	230	180	–				506 X 600	406 X 700		490 X 600	390 X 700		484,0
710		68	58			250	200	–										540,0
711		68	68			260	200	180										583,0
712	800 X 400	58	48	38	50/52	230	180	–				606 X 400	206 X 800		590 X 400	190 X 800		371,0
713		68	58			250	200	–										421,0
714		68	68			260	200	180										447,0
715	800 X 500	58	48	38	50/52	230	180	–				606 X 500	306 X 800		590 X 500	290 X 800		461,0
716		68	58			250	200	–										524,0
717		68	68			260	200	180										556,0
718	800 X 600	58	48	38	50/52	230	180	–				606 X 600	406 X 800		590 X 600	390 X 800		552,0
719		68	58			250	200	–										627,0
720		68	68			260	200	180										665,0

[01.07.2020]

[01.07.2020]

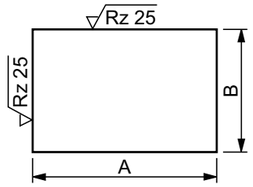
Toleranzangaben für Säulengestelle aus Stahl, M-Line

Tolerance - information regarding steel die sets, M-Line

[SG]

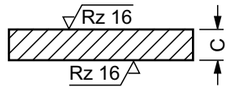
Mat.: C45

Toleranz Außenmaße /
Tolerance of length and width



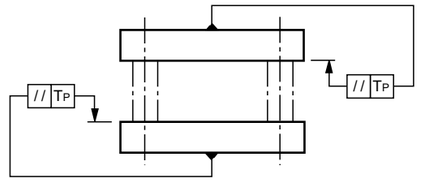
A x B +0,06 –0,06

Toleranz Plattenstärke /
Tolerance of thickness



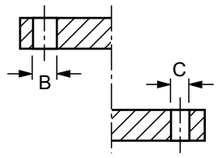
C ± 2

Parallelität der Flächenpaare /
Parallelism of two surfaces



TP = 0,012 / 100 mm

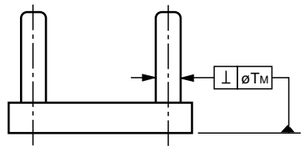
Bohrungstoleranzen /
Hole tolerances



B = Aufnahmebohrung Buchse/ Mounting hole for bushing:
FS 4 . . = H6
FS 6 . . = H6

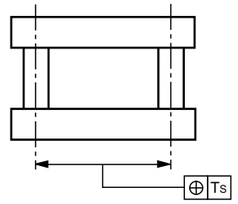
C = Aufnahmebohrung Säule/ Mounting hole for leader pin:
FS 320 = R7
FS 319 = JS6

Winkelgenauigkeit der Führungssäulen /
Angular accuracy of leader pins



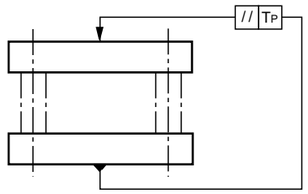
TM = 0,012 / 100 mm

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



TS = ± 0,010

Planparallelität im zusammengebauten Zustand /
Parallelism after mounting



TP = 0,015 / 100 mm

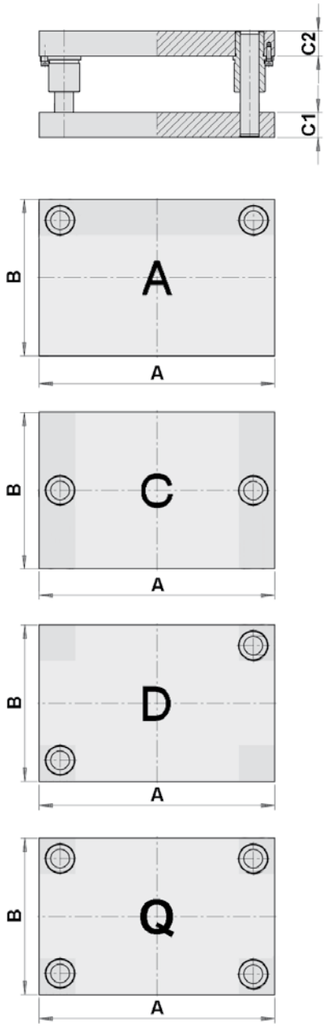
Säulen-Buchsen-Kombination für 2-Plattengestelle, M-Line

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

Bestellbeispiel / Order-example

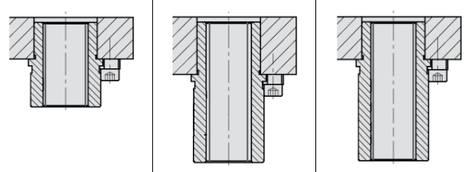
2 C	343	IEP	141	Z
Gestelltyp Type of die set	Kataloggröße Catalog sizes	Säulentyp Type of leader pin	Buchsentyp Type of bushing	Position der Haltestücke Position of holding clamps

Gestelltyp / Type of die set



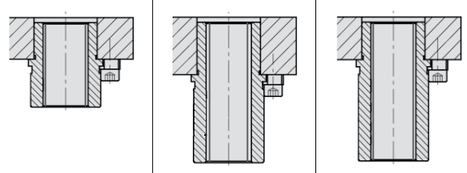
Buchsentyp / Type of bushing

Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated



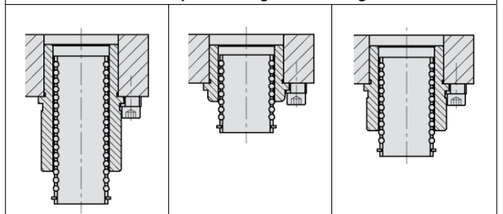
FS 330 RM	FS 340 RM	FS 350 RM
141	142	143

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



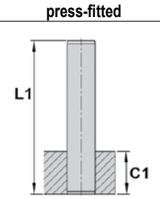
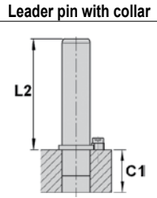
FS 331	FS 351	FS 355
131	132	133

Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage

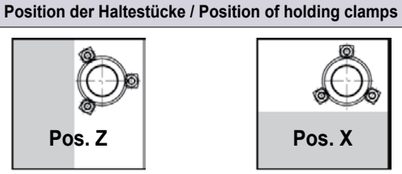


FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153

Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin with collar
	
FS 320	FS 319
IEP	IER

Position der Haltestücke / Position of holding clamps



[01.07.2020]

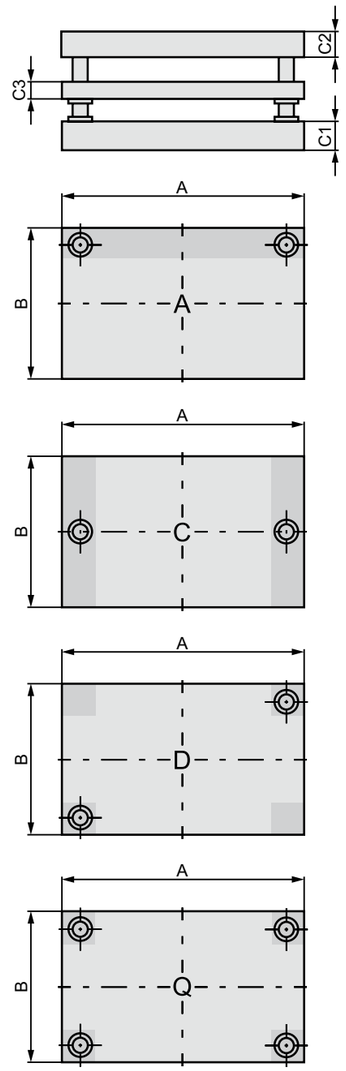
Säulen-Buchsen-Kombination für 3-Plattengestelle, M-Line

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

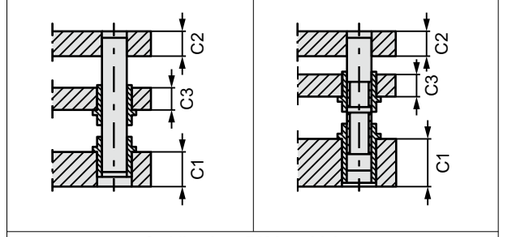
Bestellbeispiel / Order-example

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



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

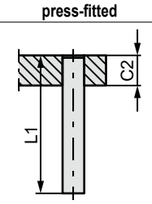
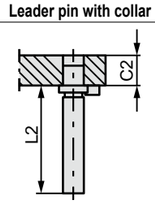
Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated

C1 = FS 351 C3 = FS 331	C1 = FS 355 C3 = FS 331
172	173

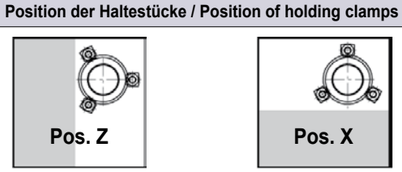
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage

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 420	FS 419
IEP	IER

Position der Haltestücke / Position of holding clamps



Bestellbeispiel Sondergrößen, M-Line

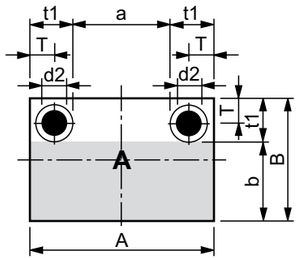
Order-example specials, M-Line

Position 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 holding clamps
	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

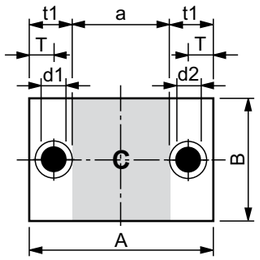
* = Säulentyp in C1 oder C2 bitte angeben. / Please fill in type of leader pin in C1 or C2.
** = Buchsentyp in C1 oder C2 bitte angeben. / Please fill in type of bushing in C1 or C2.

Arbeitsflächen / Working areas

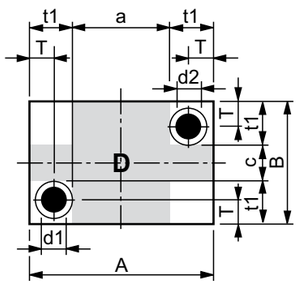
b = B - t1



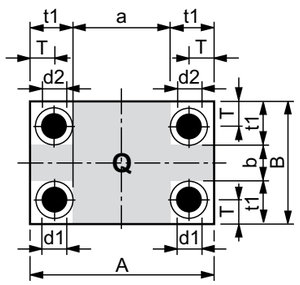
a = A - (2 x t1)



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

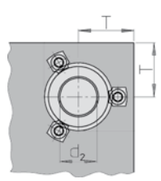


a = A - (2 x t1)
b = B - (2 x t1)



Führungsbuchsen mit Bund

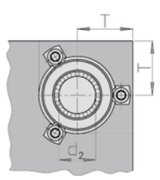
Leader pin bushings, with collar



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

[01.07.2020]

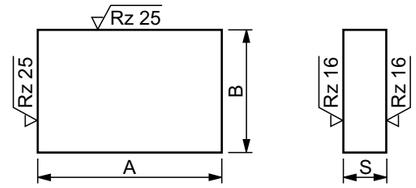
[01.07.2020]

Größen Systemplatten, M-Line

Sizes systemplates, M-Line

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

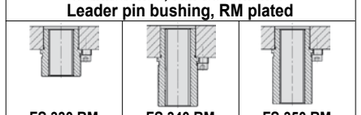
A x B	S							
	18	23	28	33	38	48	58	68
125 x 125	●	●	●		●			
160 x 125	●	●	●		●			
160 x 160	●	●	●		●			
200 x 125	●	●	●		●			
200 x 160	●	●	●	●	●	●		
200 x 200	●	●	●	●	●	●		
250 x 125	●	●	●	●	●	●		
250 x 160	●	●	●	●	●	●		
250 x 200		●	●	●	●	●		
250 x 250		●	●	●	●	●		
300 x 160		●	●	●	●	●		
300 x 200		●	●	●	●	●		
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					●	●	●	●

Säulengest. a. Stahl, 2 Platten, 2 Säulen, Typ A-C-D, M-Line

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

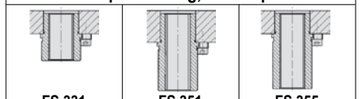
Buchsentyp / Type of bushing

Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated



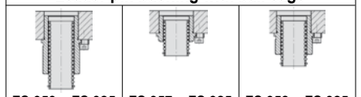
FS 330 RM	FS 340 RM	FS 350 RM
141	142	143

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 331	FS 351	FS 355
131	132	133

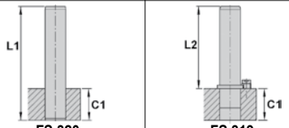
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153

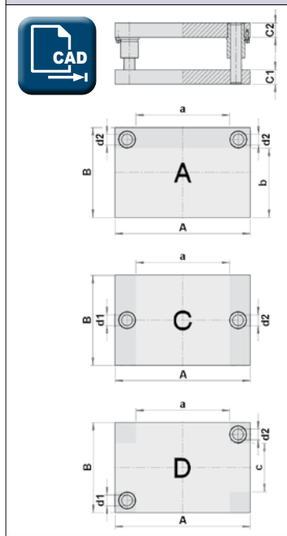
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

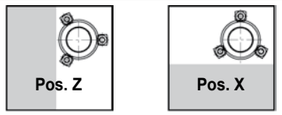


FS 320	FS 319
IEP	IER

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
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

[01.07.2020]

[01.07.2020]

Säulengest. a. Stahl, 2 Platten, 2 Säulen, Typ A-C-D, M-Line
Steel die sets, 2 plates, 2 posts, types A-C-D, M-Line
SÄULENGESTELLE / DIE SETS

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 | 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

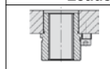
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
331	300 X 160	33	28	–	24/25	140	112	–				172 X 160	96 X 300	32 X 300	172 X 160	96 X 300	32 X 300	24,0
332		33	33	–		160	126	–										25,9
333		48	38	–		180	140	–										33,4
334	300 X 200	33	28	–	24/25	140	112	–				172 X 200	136 X 300	72 X 300	172 X 200	136 X 300	72 X 300	29,8
335		33	33	–		160	125	–										32,1
336		48	38	–		180	140	–										41,5
337	300 X 250	38	33	–	30/32	160	125	–				156 X 250	178 X 300	106 X 300	156 X 250	178 X 300	106 X 300	43,3
338		38	38	–		180	140	–										46,3
339		48	38	–		180	140	–										52,5
340	300 X 300	38	33	–	30/32	160	125	–				156 X 300	228 X 300	156 X 300	156 X 300	228 X 300	156 X 300	52,0
341		38	38	–		180	140	–										55,5
342		48	38	–		180	140	–										62,5
343	350 X 200	33	28	–	24/25	140	112	–				222 X 200	136 X 350	72 X 350	222 X 200	136 X 350	72 X 350	34,6
344		33	33	–		160	125	–										37,3
345		48	38	–		180	140	–										48,3
346	350 X 250	38	33	–	30/32	160	125	–				206 X 250	178 X 350	106 X 350	206 X 250	178 X 350	106 X 350	50,5
347		38	38	–		180	140	–										54,0
348		48	38	–		180	140	–										61,0
349	350 X 300	48	38	–	38/40	180	140	–				182 X 300	216 X 350	132 X 350	182 X 300	216 X 350	132 X 350	74,0
350		48	48	–		200	160	–										82,5
351		58	48	–		224	160	–										90,5
352	350 X 350	48	38	–	38/40	180	140	–				182 X 350	266 X 350	182 X 350	182 X 350	266 X 350	182 X 350	86,0
353		48	48	–		200	160	–										95,5
354		58	48	–		224	160	–										105,0
355	400 X 200	33	28	–	24/25	140	112	–				272 X 200	136 X 400	72 X 400	272 X 200	136 X 400	72 X 400	39,4
356		33	33	–		160	125	–										42,5
357		48	38	–		180	140	–										55,0
358	400 X 250	38	33	–	30/32	160	125	–				256 X 250	178 X 400	106 X 400	256 X 250	178 X 400	106 X 400	57,5
359		38	38	–		180	140	–										61,5
360		48	38	–		180	140	–										69,0

Säulengest. a. Stahl, 2 Platten, 2 Säulen, Typ A-C-D, M-Line

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

Buchsentyp / Type of bushing

Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated

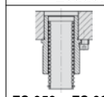


FS 330 RM	FS 340 RM	FS 350 RM
141	142	143

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated

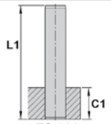
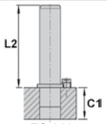
FS 331	FS 351	FS 355
131	132	133

Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage

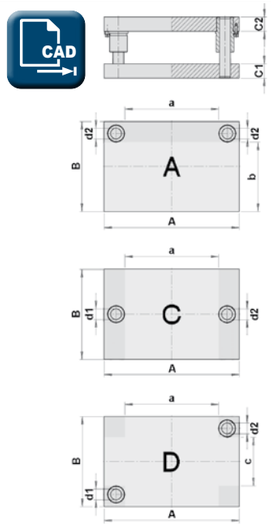


FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153

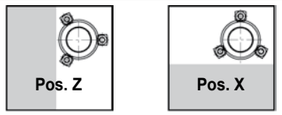
Säulentyp / Type of leader pin

eingepresst press-fitted	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



Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
361	400 X 300	48	38	–	38/40	180	140	–				232 X 300	216 X 400	132 X 400	232 X 300	216 X 400	132 X 400	84,0
362		48	48	–		200	160	–										93,5
363		58	48	–		224	160	–										103,0
364	400 X 350	48	38	–	38/40	180	140	–				232 X 350	266 X 400	182 X 400	232 X 350	266 X 400	182 X 400	97,5
365		48	48	–		200	160	–										109,0
366		58	48	–		224	160	–										120,0
367	400 X 400	48	38	–	38/40	180	140	–				232 X 400	316 X 400	232 X 400	232 X 400	316 X 400	232 X 400	111,0
368		48	48	–		200	160	–										124,0
369		58	48	–		224	160	–										137,0
370	500 X 250	38	33	–	30/32	160	125	–				356 X 250	178 X 500	106 X 500	356 X 250	178 X 500	106 X 500	73,0
371		38	38	–		180	140	–										78,0
372		48	38	–		180	140	–										87,5
373	500 X 300	48	38	–	38/40	180	140	–				332 X 300	216 X 500	132 X 500	332 X 300	216 X 500	132 X 500	105,0
374		48	48	–		200	160	–										116,0
375		58	48	–		224	160	–										128,0
376	500 X 350	48	38	–	38/40	180	140	–				332 X 350	266 X 500	182 X 500	332 X 350	266 X 500	182 X 500	122,0
377		48	48	–		200	160	–										135,0
378		58	48	–		224	160	–										149,0
379	500 X 400	48	38	–	38/40	180	140	–				332 X 400	316 X 500	232 X 500	332 X 400	316 X 500	232 X 500	138,0
380		48	48	–		200	160	–										154,0
381		58	48	–		224	160	–										170,0
382	500 X 500	58	48	–	48/50	224	160	–				306 X 500	403 X 500	306 X 500	306 X 500	403 X 500	306 X 500	213,0
383		58	58	–		250	180	–										233,0
384		68	58	–		250	180	–										252,0
385	600 X 300	58	48	–	48/50	224	160	–				406 X 300	203 X 600	106 X 600	406 X 300	203 X 600	106 X 600	155,0
386		58	58	–		250	180	–										169,0
387		68	58	–		250	180	–										183,0
388	600 X 350	58	48	–	48/50	224	160	–				406 X 350	253 X 600	156 X 600	406 X 350	253 X 600	156 X 600	180,0
389		58	58	–		250	180	–										196,0
390		68	58	–		250	180	–										213,0

[01.07.2020]

[01.07.2020]

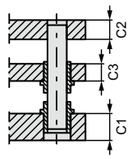
Säulengest. a. Stahl, 2 Platten, 2 Säulen, Typ A-C-D, M-Line
Steel die sets, 2 plates, 2 posts, types A-C-D, M-Line
SÄULENGESTELLE / DIE SETS
Buchsentyp / Type of bushing
Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated
FS 330 RM 141
FS 340 RM 142
FS 350 RM 143
Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated
FS 331 131
FS 351 132
FS 355 133
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage
FS 353 + FS 325 151
FS 357 + FS 325 152
FS 358 + FS 325 153
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

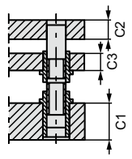
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
391	600 X 400	58	48	–	48/50	224	180	–				406 X 400	303 X 600	206 X 600	406 X 400	303 X 600	206 X 600	205,0
392		58	58	–		250	180	–										224,0
393		68	58	–		250	180	–										242,0
394	600 X 500	58	48	–	48/50	224	160	–				406 X 500	403 X 600	306 X 600	406 X 500	403 X 600	306 X 600	254,0
395		58	58	–		250	180	–										278,0
396		68	58	–		250	180	–										302,0
397	600 X 600	58	48	–	48/50	224	160	–				406 X 600	503 X 600	406 X 600	406 X 600	503 X 600	406 X 600	305,0
398		58	58	–		234	180	–										333,0
399		68	58	–		250	180	–										361,0
400	700 X 350	58	48	–	48/50	224	160	–				506 X 350	253 X 700	156 X 700	506 X 350	253 X 700	156 X 700	209,0
401		58	58	–		250	180	–										228,0
402		68	58	–		250	180	–										247,0
403	700 X 400	58	48	–	48/50	224	160	–				506 X 400	303 X 700	206 X 700	506 X 400	303 X 700	206 X 700	238,0
404		58	58	–		250	180	–										260,0
405		68	58	–		250	180	–										282,0
406	700 X 500	58	48	–	48/50	224	160	–				506 X 500	403 X 700	306 X 700	506 X 500	403 X 700	306 X 700	296,0
407		58	58	–		250	180	–										324,0
408		68	58	–		250	180	–										351,0
409	700 X 600	58	48	–	48/50	224	160	–				506 X 600	503 X 700	406 X 700	506 X 600	503 X 700	406 X 700	354,0
410		58	58	–		250	180	–										388,0
411		68	58	–		250	180	–										420,0
412	800 X 400	58	48	–	48/50	224	160	–				606 X 400	303 X 800	206 X 800	606 X 400	303 X 800	206 X 800	271,0
413		58	58	–		250	180	–										296,0
414		68	58	–		250	180	–										321,0
415	800 X 500	58	48	–	48/50	224	160	–				606 X 500	403 X 800	306 X 800	606 X 500	403 X 800	306 X 800	338,0
416		58	58	–		250	180	–										369,0
417		68	58	–		250	180	–										400,0
418	800 X 600	58	48	–	48/50	224	160	–				606 X 600	503 X 800	406 X 800	606 X 600	503 X 800	406 X 800	404,0
419		58	58	–		250	180	–										442,0
420		68	58	–		250	180	–										480,0

Säulengest. a. Stahl, 3 Platten, 2 Säulen, Typ A-C-D, M-Line

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

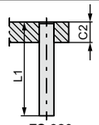
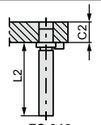
Buchsentyp / Type of bushing



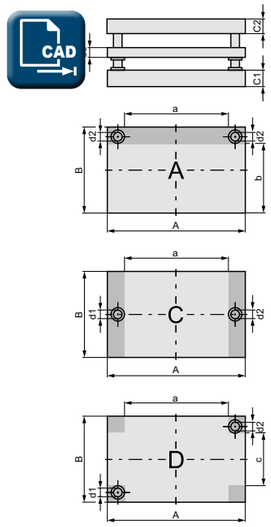


Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated	
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM
182	183
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331
172	173
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage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

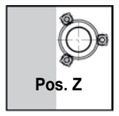
Säulentyp / Type of leader pin

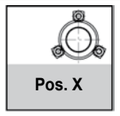
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 320	FS 319
IEP	IER

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps


Pos. Z


Pos. X

Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	182 172 a X B	b X A	c X A	183 173 a X B	b X A	c X A	192 a X B	b X A	c X A	193 a X B	b X A	c X A	Gewicht / Weight [kg]
301	125 X 125	28	23	23	19/20	140	125	–				15 X 125	70 X 125	15 X 125	15 X 125	70 X 125	15 X 125							9,4
302		38	28			160	140	–																11,2
303		38	38			180	140	–																12,4
304	160 X 125	28	23	23	19/20	140	125	–				50 X 125	70 X 160	15 X 160	50 X 125	70 X 160	15 X 160							11,7
305		38	28			160	140	–																14,2
306		38	38			180	140	–																15,8
307	160 X 160	28	23	23	19/20	140	125	–				50 X 160	105 X 160	50 X 160	50 X 160	105 X 160	50 X 160							14,8
308		38	28			160	140	–																17,8
309		38	38			180	140	–																19,8
310	200 X 125	28	23	23	19/20	140	125	–				90 X 125	70 X 200	15 X 200	90 X 125	70 X 200	15 X 200							14,4
311		38	28			160	140	–																17,4
312		38	38			180	140	–																19,4
313	200 X 160	33	28	23	24/25	160	125	–				72 X 160	96 X 200	32 X 200	72 X 160	96 X 200	32 X 200							22,3
314		48	38			180	160	–																28,4
315		48	48			200	160	–																30,9
316	200 X 200	33	28	23	24/25	160	125	–				72 X 200	136 X 200	72 X 200	72 X 200	136 X 200	72 X 200							27,5
317		48	38			180	160	–																35,2
318		48	48			200	160	–																38,4
319	250 X 125	33	28	23	24/25	160	125	–				122 X 125	61 X 250		122 X 125	61 X 250								21,8
320		48	38			180	160	–																27,8
321		48	48			200	160	–																30,2
322	250 X 160	33	28	23	24/25	160	125	–				122 X 160	96 X 250	32 X 250	122 X 160	96 X 250	32 X 250							27,5
323		48	38			180	160	–																35,2
324		48	48			200	160	–																38,4
325	250 X 200	33	28	23	24/25	160	125	–				122 X 200	136 X 250	72 X 250	122 X 200	136 X 250	72 X 250							34,2
326		48	38			180	160	–																43,8
327		48	48			200	160	–																47,7
328	250 X 250	38	33	33	30/32	180	125	–				106 X 250	178 X 250	106 X 250	106 X 250	178 X 250	106 X 250							50,5
329		48	38			200	160	–																57,5
330		48	48			200	160	–																62,5

[01.07.2020]

[01.07.2020]

Säulengest. a. Stahl, 3 Platten, 2 Säulen, Typ A-C-D, M-Line

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

SÄULENGESTELLE / DIE SETS

[SG]

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 — FS 320 — IEP
Schnellwechsel-säule mit Bund / Leader pin, with collar — FS 319 — IER

Gestelltyp / Type of die set

Position der Haltestücke / Position of holding clamps

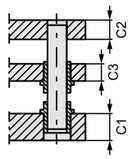
Pos. Z
Pos. X

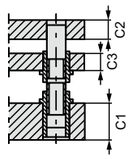
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	182 172 a X B	b X A	c X A	183 173 a X B	b X A	c X A	192 a X B	b X A	c X A	193 a X B	b X A	c X A	Gewicht / Weight [kg]
331	300 X 160	33	28	23	24/25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

Säulengest. a. Stahl, 3 Platten, 2 Säulen, Typ A-C-D, M-Line

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

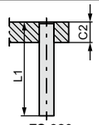
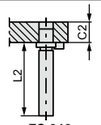
Buchsentyp / Type of bushing



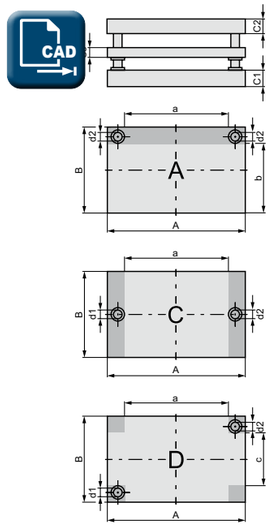


Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated	
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM
182	183
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331
172	173
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage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

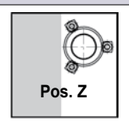
Säulentyp / Type of leader pin

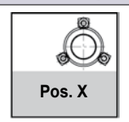
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 320	FS 319
IEP	IER

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	182 172 a X B	b X A	c X A	183 173 a X B	b X A	c X A	192 a X B	b X A	c X A	193 a X B	b X A	c X A	Gewicht / Weight [kg]
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	–																292,0

[01.07.2020]

[01.07.2020]

Säulengest. a. Stahl, 3 Platten, 2 Säulen, Typ A-C-D, M-Line

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

SÄULENGESTELLE / DIE SETS

[SG]

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

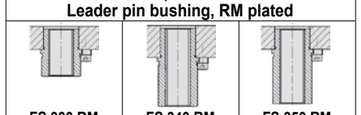
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	182 172 a X B	b X A	c X A	183 173 a X B	b X A	c X A	192 a X B	b X A	c X A	193 a X B	b X A	c X A	Gewicht / Weight [kg]
391	600 X 400	58	48	48	48/50	224	180	–				406 X 400	303 X 600	206 X 600	406 X 400	303 X 600	206 X 600							276,0
392		68	58			250	200	–																314,0
393		68	68			280	200	–																333,0
394	600 X 500	58	48	48	48/50	224	180	–				406 X 500	403 X 600	306 X 600	406 X 500	403 X 600	306 X 600							344,0
395		68	58			250	200	–																391,0
396		68	68			280	200	–																415,0
397	600 X 600	58	48	48	48/50	224	180	–				406 X 600	503 X 600	406 X 600	406 X 600	503 X 600	406 X 600							412,0
398		68	58			250	200	–																468,0
399		68	68			280	200	–																497,0
400	700 X 350	58	48	48	48/50	224	180	–				506 X 350	253 X 700	156 X 700	506 X 350	253 X 700	156 X 700							282,0
401		68	58			250	200	–																320,0
402		68	68			280	200	–																340,0
403	700 X 400	58	48	48	48/50	224	180	–				506 X 400	303 X 700	206 X 700	506 X 400	303 X 700	206 X 700							321,0
404		68	58			250	200	–																365,0
405		68	68			280	200	–																387,0
406	700 X 500	58	48	48	48/50	224	180	–				506 X 500	403 X 700	306 X 700	506 X 500	403 X 700	306 X 700							400,0
407		68	58			250	200	–																455,0
408		68	68			280	200	–																483,0
409	700 X 600	58	48	48	48/50	224	180	–				506 X 600	503 X 700	406 X 700	506 X 600	503 X 700	406 X 700							480,0
410		68	58			250	200	–																545,0
411		68	68			280	200	–																579,0
412	800 X 400	58	48	48	48/50	224	180	–				606 X 400	303 X 800	206 X 800	606 X 400	303 X 800	206 X 800							366,0
413		68	58			250	200	–																417,0
414		68	68			280	200	–																442,0
415	800 X 500	58	48	48	48/50	224	180	–				606 X 500	403 X 800	306 X 800	606 X 500	403 X 800	306 X 800							457,0
416		68	58			250	200	–																520,0
417		68	68			280	200	–																551,0
418	800 X 600	58	48	48	48/50	224	180	–				606 X 600	503 X 800	406 X 800	606 X 600	503 X 800	406 X 800							547,0
419		68	58			250	200	–																623,0
420		68	68			280	200	–																661,0

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

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

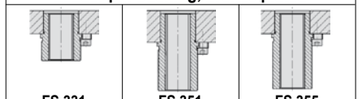
Buchsentyp / Type of bushing

Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated



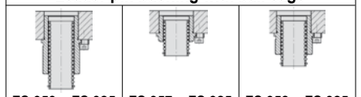
FS 330 RM	FS 340 RM	FS 350 RM
141	142	143

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 331	FS 351	FS 355
131	132	133

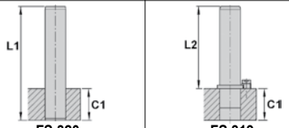
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153

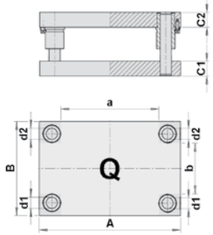
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

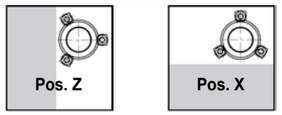


FS 320	FS 319
IEP	IER

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



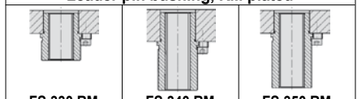
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
301	125 X 125	28	23	–	19/20	125	100	–				15 X 125	15 X 125					7,8
302		28	28	–		140	112	–										8,4
303		38	28	–		160	112	–										9,7
304	160 X 125	28	23	–	19/20	125	100	–				50 X 125	15 X 160		50 X 125			9,5
305		28	28	–		140	112	–										10,4
306		38	28	–		150	112	–										11,9
307	160 X 160	28	23	–	19/20	125	100	–				50 X 160	50 X 160		50 X 160	50 X 160		11,9
308		28	28	–		140	112	–										12,8
309		38	28	–		160	112	–										14,8
310	200 X 125	28	23	–	19/20	125	100	–				90 X 125	15 X 200		90 X 125			11,5
311		28	28	–		140	112	–										12,5
312		38	28	–		160	112	–										14,5
313	200 X 160	28	23	–	19/20	125	100	–				90 X 160	50 X 200		90 X 160	50 X 200		14,3
314		28	28	–		140	112	–										15,6
315		38	28	–		160	112	–										18,1
316	200 X 200	28	23	–	19/20	125	100	–				90 X 200	90 X 200		90 X 200	90 X 200		17,5
317		28	28	–		140	112	–										19,1
318		38	28	–		160	112	–										22,3
319	250 X 125	28	23	–	19/20	125	100	–				140 X 125	15 X 250		140 X 125			14,0
320		28	28	–		140	112	–										15,3
321		38	28	–		160	112	–										17,7
322	250 X 160	28	23	–	19/20	125	100	–				140 X 160	50 X 250		140 X 160	50 X 250		17,5
323		28	28	–		140	112	–										19,1
324		38	28	–		160	112	–										22,3
325	250 X 200	33	28	–	24/25	160	112	–				122 X 200	72 X 250		122 X 200	70 X 250		26,0
326		33	33	–		160	125	–										27,9
327		48	38	–		180	140	–										35,8
328	250 X 250	33	28	–	24/25	160	112	–				122 X 250	122 X 250		122 X 250	120 X 250		32,0
329		33	33	–		160	125	–										34,4
330		48	38	–		180	140	–										44,2

[01.07.2020]

[01.07.2020]

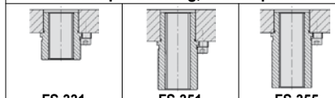
Säulengest. a. Stahl, 2 Platten, 4 Säulen, Typ Q, M-Line
Steel die sets, 2 plates, 4 posts, type Q, M-Line
SÄULENGESTELLE / DIE SETS

Buchsentyp / Type of bushing
Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated



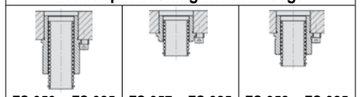
FS 330 RM	FS 340 RM	FS 350 RM
141	142	143

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



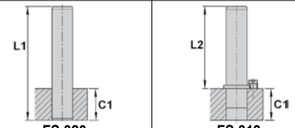
FS 331	FS 351	FS 355
131	132	133

Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



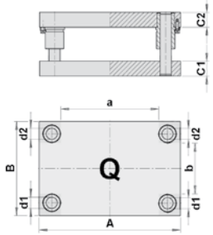
FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153

Säulentyp / Type of leader pin
eingepresst
press-fitted
Schnellwechsel-säule mit Bund
Leader pin, with collar

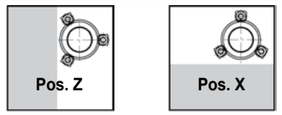


FS 320	FS 319
IEP	IER

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



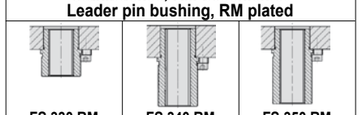
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	Arbeitsflächen / Working area a X B	b X A	c X A	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
331	300 X 160	33	28	–	24/25	160	112	–				172 X 160	32 X 300		172 X 160	32 X 300		25,0
332		33	33	–		160	125	–										26,9
333		48	38	–		180	140	–										34,4
334	300 X 200	33	28	–	24/25	160	112	–				172 X 200	72 X 300		172 X 200	72 X 300		30,8
335		33	33	–		160	125	–										33,1
336		48	38	–		180	140	–										42,5
337	300 X 250	38	33	–	30/32	160	125	–				156 X 250	106 X 300		156 X 250	106 X 300		44,8
338		38	38	–		180	140	–										47,8
339		48	38	–		180	140	–										54,0
340	300 X 300	38	33	–	30/32	160	125	–				156 X 300	156 X 300		156 X 300	156 X 300		53,5
341		38	38	–		180	140	–										57,0
342		48	38	–		180	130	–										64,0
343	350 X 200	33	28	–	24/25	160	112	–				222 X 200	72 X 350		222 X 200	72 X 350		35,6
344		33	33	–		160	125	–										38,3
345		48	38	–		180	140	–										49,3
346	350 X 250	38	33	–	30/32	160	125	–				206 X 250	106 X 350		206 X 250	106 X 350		52,5
347		38	38	–		180	140	–										55,5
348		48	38	–		180	140	–										62,0
349	350 X 300	38	33	–	30/32	160	125	–				206 X 300	206 X 350		206 X 300	206 X 350		61,5
350		38	38	–		180	140	–										66,0
351		48	38	–		180	140	–										74,0
352	350 X 350	38	33	–	30/32	160	125	–				206 X 350	206 X 350		206 X 350	206 X 350		71,5
353		38	38	–		180	140	–										76,5
354		48	38	–		180	140	–										86,0
355	400 X 200	33	28	–	24/25	160	112	–				272 X 200	72 X 400		272 X 200	72 X 400		40,4
356		33	33	–		160	125	–										43,5
357		48	38	–		180	140	–										56,0
358	400 X 250	38	33	–	30/32	160	125	–				256 X 250	106 X 400		256 X 250	106 X 400		59,0
359		38	38	–		180	140	–										63,0
360		48	38	–		180	140	–										70,5

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

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

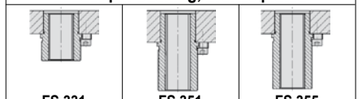
Buchsentyp / Type of bushing

Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated



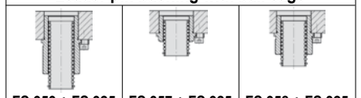
FS 330 RM	FS 340 RM	FS 350 RM
141	142	143

Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated



FS 331	FS 351	FS 355
131	132	133

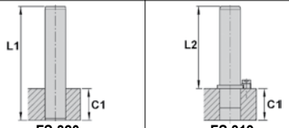
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage



FS 353 + FS 325	FS 357 + FS 325	FS 358 + FS 325
151	152	153

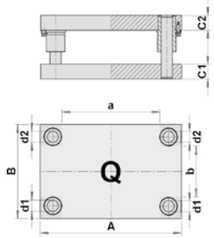
Säulentyp / Type of leader pin

eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

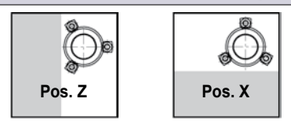


FS 320	FS 319
IEP	IER

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps



Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
361	400 X 300	48	38	–	38/40	180	140	–			232 X 300	232 X 300	132 X 400		87,0
362		48	48	–		200	160	–							96,5
363		58	48	–		224	160	–							106,0
364	400 X 350	48	38	–	38/40	180	140	–			232 X 350	232 X 350	182 X 400		101,0
365		48	48	–		200	160	–							112,0
366		58	48	–		224	160	–							123,0
367	400 X 400	48	38	–	38/40	180	140	–			232 X 400	232 X 400	232 X 400		114,0
368		48	48	–		200	160	–							127,0
369		58	48	–		224	160	–							140,0
370	500 X 250	38	33	–	30/32	160	125	–			356 X 250	356 X 250	106 X 500		73,0
371		38	38	–		180	140	–							78,0
372		48	38	–		180	140	–							87,5
373	500 X 300	48	38	–	38/40	180	140	–			332 X 300	332 X 300	132 X 500		108,0
374		48	48	–		200	160	–							119,0
375		58	48	–		224	160	–							131,0
376	500 X 350	48	38	–	38/40	180	140	–			332 X 350	332 X 350	182 X 500		125,0
377		48	48	–		200	160	–							138,0
378		58	48	–		224	160	–							152,0
379	500 X 400	48	38	–	38/40	180	140	–			332 X 400	332 X 400	232 X 500		141,0
380		48	48	–		200	160	–							157,0
381		58	48	–		224	160	–							173,0
382	500 X 500	48	38	–	38/40	180	140	–			332 X 500	332 X 500	332 X 500		175,0
383		48	48	–		200	160	–							195,0
384		58	48	–		224	160	–							214,0
385	600 X 300	48	38	–	38/40	180	140	–			432 X 300	432 X 300	132 X 600		128,0
386		48	48	–		200	160	–							142,0
387		58	48	–		224	160	–							156,0
388	600 X 350	48	38	–	38/40	180	140	–			432 X 350	432 X 350	182 X 600		148,0
389		48	48	–		200	160	–							165,0
390		58	48	–		224	160	–							181,0

[01.07.2020]

[01.07.2020]

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

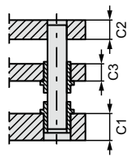
Buchsentyp / Type of bushing
Stahlbuchse, RM-beschichtet
Leader pin bushing, RM plated
FS 330 RM | FS 340 RM | FS 350 RM
141 | 142 | 143
Stahlbuchse mit Bronzeplattierung
Leader pin bushing, bronze plated
FS 331 | FS 351 | FS 355
131 | 132 | 133
Stahlbuchse mit Ms-Käfig
Leader pin bushing with ball cage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

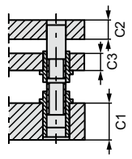
Größe / Size	A X B	Platten-stärke Plate thickness C1	C2	C3	Ø d1/d2	Säulen-länge Length of leader pin L1	L2	L3	141 131 a X B	142 132 b X A	143 133 c X A	151 a X B	152 b X A	153 c X A	Gewicht / Weight [kg]
391	600 X 400	48	38	–	38/40	180	140	–			432 X 400	432 X 400	232 X 600		168,0
392		48	48	–		200	160	–							187,0
393		58	48	–		224	160	–							206,0
394	600 X 500	58	48	–	48/50	224	160	–			406 X 500	406 X 500	306 X 600		259,0
395		58	58	–		250	180	–							283,0
396		68	58	–		250	180	–							306,0
397	600 X 600	58	48	–	48/50	224	160	–			406 X 600	406 X 600	406 X 600		309,0
398		58	58	–		250	180	–							337,0
399		68	58	–		250	180	–							365,0
400	700 X 350	48	38	–	38/40	180	140	–			532 X 350	532 X 350	182 X 700		172,0
401		48	48	–		200	160	–							191,0
402		58	48	–		224	160	–							210,0
403	700 X 400	58	48	–	48/50	224	160	–			506 X 400	506 X 400	206 X 700		242,0
404		58	58	–		250	180	–							264,0
405		68	58	–		250	180	–							286,0
406	700 X 500	58	48	–	48/50	224	160	–			506 X 500	506 X 500	306 X 700		300,0
407		58	58	–		250	180	–							328,0
408		68	58	–		250	180	–							356,0
409	700 X 600	58	48	–	48/50	224	160	–			506 X 600	506 X 600	406 X 700		359,0
410		58	58	–		250	180	–							392,0
411		68	58	–		250	180	–							425,0
412	800 X 400	58	48	–	48/50	224	160	–			606 X 400	606 X 400	206 X 800		276,0
413		58	58	–		250	180	–							301,0
414		68	58	–		250	180	–							326,0
415	800 X 500	58	48	–	48/50	224	160	–			606 X 500	606 X 500	306 X 800		342,0
416		58	58	–		250	180	–							374,0
417		68	58	–		250	180	–							405,0
418	800 X 600	58	48	–	48/50	224	160	–			606 X 600	606 X 600	406 X 800		409,0
419		58	58	–		250	180	–							447,0
420		68	58	–		250	180	–							484,0

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

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

Buchsentyp / Type of bushing

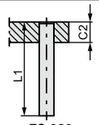


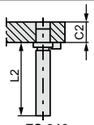


Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated	
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM
182	183
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331
172	173
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
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

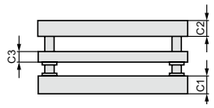
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar

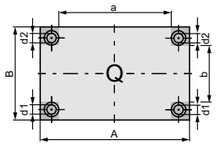




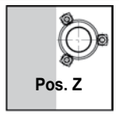
FS 320	FS 319
IEP	IER

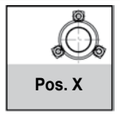
Gestelltyp / Type of die set





Position der Haltestücke / Position of holding clamps





Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness			Ø	Säulenlänge Length of leader pin						182 172	183 173		192	193		
		C1	C2	C3	d1/d2	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	23	19/20	140	125	–				15 X 125	15 X 125		15 X 125	15 X 125		10,0
302		38	28			160	140	–										11,8
303		38	38			180	140	–										13,1
304	160 X 125	28	23	23	19/20	140	125	–				50 X 125	15 X 160		50 X 125	15 X 160		12,4
305		38	28			160	140	–										14,2
306		38	38			180	140	–										16,3
307	160 X 160	28	23	23	19/20	140	125	–				50 X 160	50 X 160		50 X 160	50 X 160		15,4
308		38	28			160	140	–										18,4
309		38	38			180	140	–										20,4
310	200 X 125	28	23	23	19/20	140	125	–				90 X 125	15 X 200		90 X 125	15 X 200		15,1
311		38	28			160	140	–										18,0
312		38	38			180	140	–										20,0
313	200 X 160	28	23	23	19/20	140	125	–				90 X 160	50 X 200		90 X 160	50 X 200		18,9
314		38	28			160	140	–										22,6
315		38	38			180	140	–										25,2
316	200 X 200	28	23	23	19/20	140	125	–				90 X 200	90 X 200		90 X 200	90 X 200		23,2
317		38	28			160	140	–										27,9
318		38	38			180	140	–										31,1
319	250 X 125	28	23	23	19/20	140	125	–				140 X 125	15 X 250		140 X 125	15 X 250		18,5
320		38	28			160	140	–										22,1
321		38	38			180	140	–										24,6
322	250 X 160	28	23	23	19/20	140	125	–				140 X 160	50 X 250		140 X 160	50 X 250		23,2
323		38	28			160	140	–										27,9
324		38	38			180	140	–										31,1
325	250 X 200	33	28	23	24/25	160	125	–				122 X 200	72 X 250		122 X 200	72 X 250		35,0
326		48	38			180	160	–										44,8
327		48	48			200	160	–										48,7
328	250 X 250	33	28	23	24/25	160	125	–				122 X 250	122 X 250		122 X 250	122 X 250		43,2
329		48	38			180	160	–										55,5
330		48	48			200	160	–										60,5

[01.07.2020]

[01.07.2020]

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 – 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 – IEP (FS 320)

Schnellwechselsäule mit Bund / Leader pin, with collar – IER (FS 319)

Gestelltyp / Type of die set

Position der Haltestücke / Position of holding clamps

Pos. Z

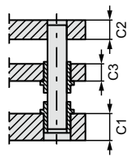
Pos. X

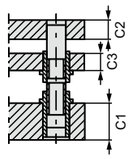
Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness			Ø	Säulenlänge Length of leader pin						182 172	183 173		192	193		
		C1	C2	C3	d1/d2	L1	L2	L3	a X B	b X A	c X A	a X B	b X A	c X A	a X B	b X A	c X A	
331	300 X 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

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

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

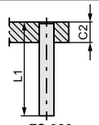
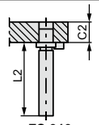
Buchsentyp / Type of bushing



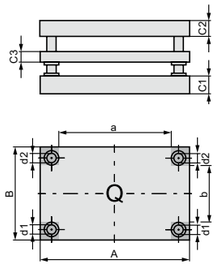


Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated	
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM
182	183
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331
172	173
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage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

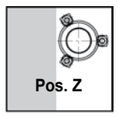
Säulentyp / Type of leader pin

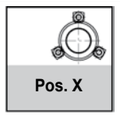
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 320	FS 319
IEP	IER

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	Säulenlänge Length of leader pin						182 172	183 173		192	193		
		C1	C2	C3	d1/d2	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	132 X 400		232 X 300	132 X 400		118,0
362		58	48			224	180	–										137,0
363		58	58			250	180	–										147,0
364	400 X 350	48	38	38	38/40	200	160	–				232 X 350	182 X 400		232 X 350	182 X 400		137,0
365		58	48			224	180	–										159,0
366		58	58			250	180	–										170,0
367	400 X 400	48	38	38	38/40	200	160	–				232 X 400	232 X 400		232 X 400	232 X 400		156,0
368		58	48			224	180	–										181,0
369		58	58			250	180	–										194,0
370	500 X 250	38	33	33	30/32	180	140	–				356 X 250	106 X 500		356 X 250	106 X 500		100,0
371		48	38			200	160	–										115,0
372		48	48			200	160	–										125,0
373	500 X 300	48	38	38	38/40	200	160	–				332 X 300	132 X 500		332 X 300	132 X 500		146,0
374		58	48			224	180	–										170,0
375		58	58			250	180	–										182,0
376	500 X 350	48	38	38	38/40	200	160	–				332 X 350	182 X 500		332 X 350	182 X 500		170,0
377		58	48			224	180	–										197,0
378		58	58			250	180	–										211,0
379	500 X 400	48	38	38	38/40	200	160	–				332 X 400	232 X 500		332 X 400	232 X 500		193,0
380		58	48			224	180	–										225,0
381		58	58			250	180	–										240,0
382	500 X 500	48	38	38	38/40	200	160	–				332 X 500	332 X 500		332 X 500	332 X 500		240,0
383		58	48			224	180	–										279,0
384		58	58			250	180	–										299,0
385	600 X 300	48	38	38	38/40	200	160	–				432 X 300	132 X 600		432 X 300	132 X 600		174,0
386		58	48			224	180	–										203,0
387		58	58			250	180	–										217,0
388	600 X 350	48	38	38	38/40	200	160	–				432 X 350	182 X 600		432 X 350	182 X 600		202,0
389		58	48			224	180	–										235,0
390		58	58			250	180	–										252,0

[01.07.2020]

[01.07.2020]

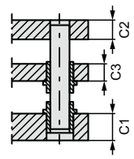
Säulengest. a. Stahl, 3 Platten, 4 Säulen, Typ Q, M-Line

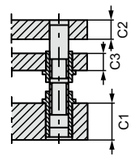
Steel die sets, 3 plates, 4 posts, type Q, M-Line

SÄULENGESTELLE / DIE SETS

[SG]

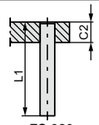
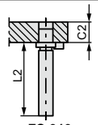
Buchsentyp / Type of bushing



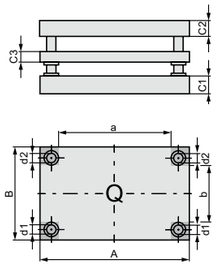


Stahlbuchse, RM-beschichtet Leader pin bushing, RM plated	
C1: FS 340 RM C3: FS 330 RM	C1: FS 350 RM C3: FS 330 RM
182	183
Stahlbuchse mit Bronzeplattierung Leader pin bushing, bronze plated	
C1: FS 351 C3: FS 331	C1: FS 355 C3: FS 331
172	173
Stahlbuchse mit Ms-Käfig Leader pin bushing with ball cage	
C1: FS 358 + FS 325 C3: FS 357 + FS 325	C1: FS 353 + FS 325 C3: FS 357 + FS 3CAD25
192	193

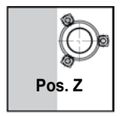
Säulentyp / Type of leader pin

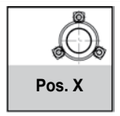
eingepresst press-fitted	Schnellwechsel-säule mit Bund Leader pin, with collar
	
FS 320	FS 319
IEP	IER

Gestelltyp / Type of die set



Position der Haltestücke / Position of holding clamps





Abmessungen / Dimensions									Arbeitsflächen / Working area									Gewicht / Weight [kg]
Größe / Size	A X B	Plattenstärke Plate thickness			Ø	Säulenlänge Length of leader pin						182 172	183 173		192	193		
		C1	C2	C3	d1/d2	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	
391	600 X 400	48	38	38	38/40	200	160	–				432 X 400	232 X 600		432 X 400	232 X 600		230,0
392		58	48			224	180	–										268,0
393		58	58			250	180	–										287,0
394	600 X 500	58	48	48	48/50	224	180	–				406 X 500	306 X 600		406 X 500	306 X 600		348,0
395		68	58			250	200	–										395,0
396		68	68			280	200	–										419,0
397	600 X 600	58	48	48	48/50	224	180	–				406 X 600	406 X 600		406 X 600	406 X 600		416,0
398		68	58			250	200	–										473,0
399		68	68			280	200	–										501,0
400	700 X 350	48	38	48	38/40	200	160	–				532 X 350	182 X 700		532 X 350	182 X 700		235,0
401		58	48			224	180	–										274,0
402		58	58			250	180	–										293,0
403	700 X 400	58	48	48	48/50	224	180	–				506 X 400	206 X 700		506 X 400	206 X 700		326,0
404		68	58			250	200	–										370,0
405		68	68			280	200	–										392,0
406	700 X 500	58	48	48	48/50	224	180	–				506 X 500	306 X 700		506 X 500	306 X 700		405,0
407		68	58			250	200	–										460,0
408		68	68			280	200	–										487,0
409	700 X 600	58	48	48	48/50	224	180	–				506 X 600	406 X 700		506 X 600	406 X 700		484,0
410		68	58			250	200	–										540,0
411		68	68			280	200	–										583,0
412	800 X 400	58	48	48	48/50	224	180	–				606 X 400	206 X 800		606 X 400	206 X 800		371,0
413		68	58			250	200	–										421,0
414		68	68			280	200	–										447,0
415	800 X 500	58	48	48	48/50	224	180	–				606 X 500	306 X 800		606 X 500	306 X 800		461,0
416		68	58			250	200	–										524,0
417		68	68			280	200	–										556,0
418	800 X 600	58	48	48	48/50	224	180	–				606 X 600	406 X 800		606 X 600	406 X 800		552,0
419		68	58			250	200	–										627,0
420		68	68			280	200	–										665,0

Notizen

Notes

[01.07.2020]

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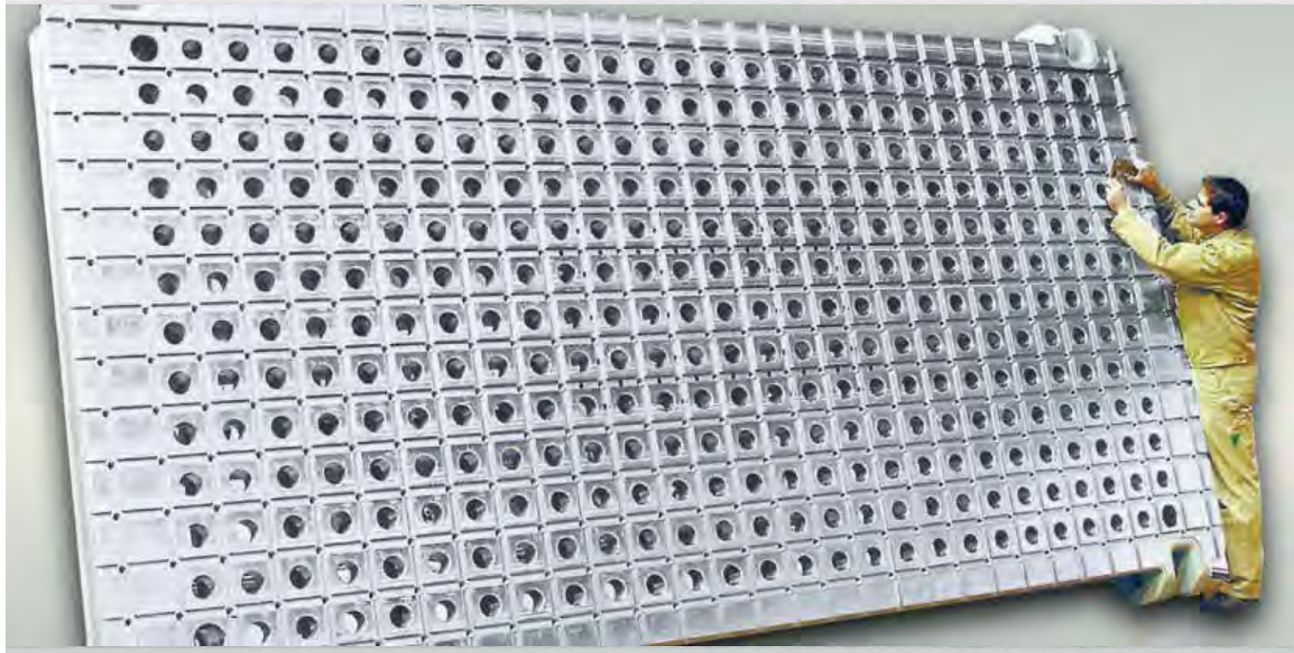
MSP GMBH

Märkische Stanz-Partner



[stanznormalien]

Großstahlplatten und Stahl-Schweiß-
Konstruktionen mit Sonderbearbeitungen

[standarddiecomponents]

XXL - Steel plates and welded units
with additional work / secondary operation

CNC - Brennschneiden CNC - flame cutting	Materiallager ST 52-3, Blechdicken 10 – 600 mm Stock ST 52-3, sheet thickness 10 – 600 mm	
Glühen Annealing	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	
Stahlkies strahlen Steel shot blasting	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	
Richten Flattening	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	
Farbgebung - Grundierung Coloring - priming	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	
CNC - Diskusschleifen CNC - rotary grinding	Verfahrweg Travelling distance	4.000 x 1.250 x 300 mm
CNC - Feinschleifen CNC - finish grinding	Verfahrweg Travelling distance	3.000 x 1.600 x 600 mm

[01.07.2020]

[01.07.2020]

Großstahlplatten und Stahl-Schweiß-Konstruktionen
XXL - Steel plates and welded units
SÄULENGESTELLE / DIE SETS
[SG]

CNC - Lehrenbohren CNC - jig boring	Verfahrweg Travelling distance	3.000 x 1.600 x 600 mm
CNC - Portalfräsen CNC - portal milling	Verfahrweg Travelling distance	7.000 x 3.000 x 1.400 mm
CNC - Fräsen und Bohren CNC - milling and -drilling	Verfahrweg Travelling distance	4.900 x 2.400 x 800 mm
CNC - Portalmessen CNC - portal measuring	Verfahrweg Travelling distance	3.000 x 1.600 x 800 mm
CNC - Tieflochbohren CNC - gun drilling	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 manufacuring process are drawings supplied by the customer, printed or as DXF-, DWG-, IGES-, VDA- or Catia - CAD - data files.

zertifiziert ISO 9001 for you Cert

MSPN GMBH

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

[nitrocylGasdruckfedern]
umfangreiches Programm für unterschiedliche Anwendungen

[nitrocylGasSprings]
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

Märkische Stanz-Partner Normalien GmbH
Jüngerstrasse 17 • D-58515 Lüdenscheid
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e-mail: mail@maerkische-stanz-partner.de • www.maerkische-stanz-partner.de

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