

## Die sets

**MDL**<sup>®</sup>



**AMDL**<sup>®</sup>  
Atelier Mécanique De La Lauch



## STANDARD DIE SETS CONTENTS

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In order to provide a better response to your urgent ordering requirements, we can offer you three new die set solutions:

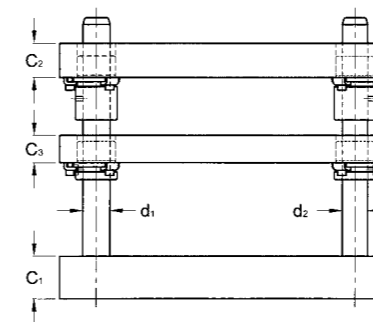
- Standard die sets: 48-hours delivery ex works (See pages 3 to 5).
- Rectangular die sets: 72-hours delivery ex works (See pages 6 to 21).
- Made-to-measure die sets: according to your plans and specifications
- Special die sets: according to individual design requirements

By matching bushes and pillars, we can offer you three adjustment categories:

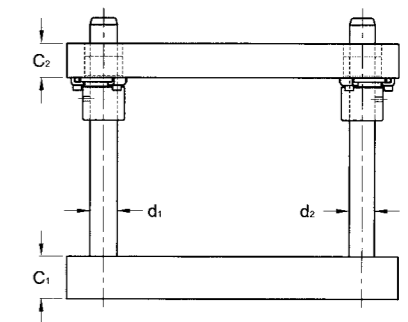
**Category I :** For tooling processing of very thin sheet metal.  
For very fine clearance between punch and die sections.  
Where clearance per side is less than 0.02 mm.

**Category II :** For tooling processing of sheet metal more than 0.4 mm thick  
For clearance between punch and die sections from 0.02 to 0.06 mm per side.  
For most applications.

**Category III :** For clearance between punch and die sections of 0.08 mm per side.  
For automotive, forming dies.



Standard die set with stripper plate Type D61.xxx.xxx

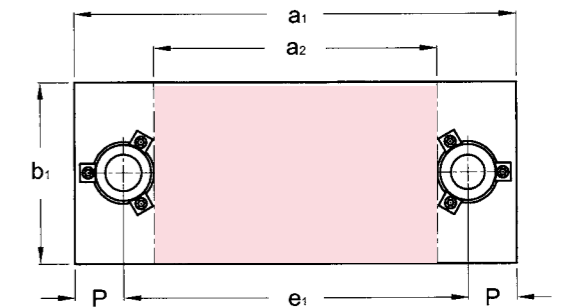


Standard die set Type D71.xxx.xxx

The plates are torch-cut and stress relieved.  
The guide elements can be chosen from our catalogue:

- Straight pillars P10.xxx.xxx
- Demountable pillars P2x.xxx.xxx
- Steel bushes B1x.xxx.xxx
- Bronze-plated bushes B2x.xxx.xxx

**Delivery: 48 hours ex works**

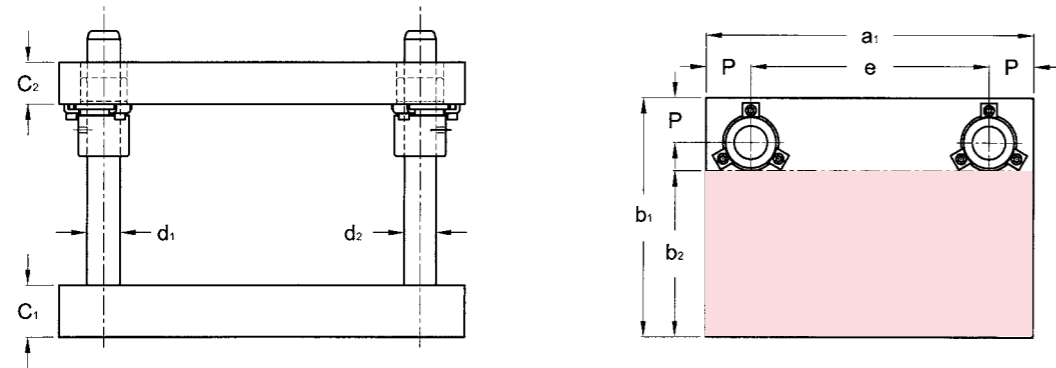


### Examples

Die set with stripper plate : D61.012.010  
Identical die set without stripper plate : D71.012.010

Ext. dimensions			C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e <sub>1</sub>	P	Reference x = 6 : with C3 x = 7 : without C3
a <sub>2</sub>	b <sub>1</sub>	a <sub>1</sub>								
Work space										
100	80	225	32	25	25	25/160	24/160	147	39	Dx1.010.008
125		250						172		Dx1.012.008
160		285						207		Dx1.016.008
200		325						247		Dx1.020.008
100	100	225	32	25	25	25/160	24/160	147	39	Dx1.010.010
125		250						172		Dx1.012.010
160		285						207		Dx1.016.010
250		390						304		Dx1.025.010
125	125	265	40	32	28	32/180	30/180	179	43	Dx1.012.012
160		300						214		Dx1.016.012
200		340						254		Dx1.020.012
315		455						369		Dx1.031.012
160	160	300	50	40	32	32/200	30/200	214	52	Dx1.016.016
200		340						254		Dx1.020.016
250		390						304		Dx1.025.016
315		455						369		Dx1.031.016
200	200	367	50	40	32	40/220	38/220	263	52	Dx1.020.020
315		482						378		Dx1.031.020
315		482						378		Dx1.031.025

L : Pin Length recommendations



The plates are torch-cut and stress relieved.  
The guide elements can be chosen from our catalogue:

- Straight pillars P10.xxx.xxx
- Demountable pillars P2x.xxx.xxx
- Steel bushes B1x.xxx.xxx
- Bronze-plated bushes B2x.xxx.xxx

**Delivery: 48 hours ex works**

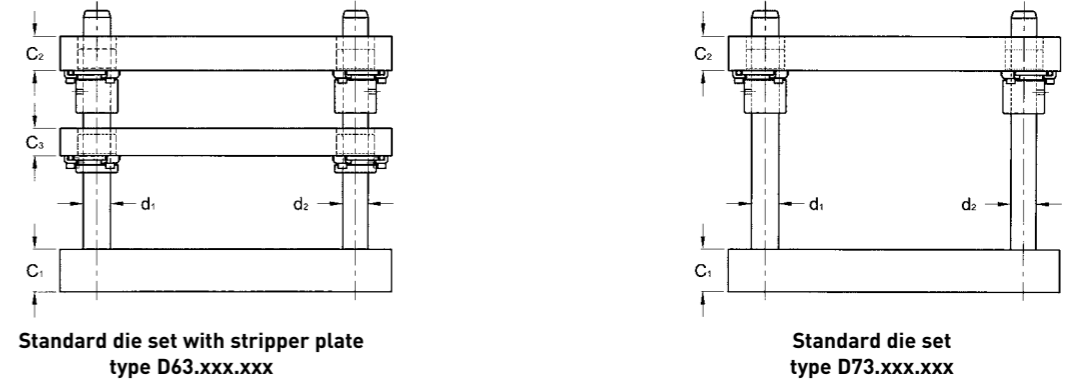
**Example**

Die set with rear pillars :

D72.031.010

Ext. dimensions			C <sub>1</sub> ±1	C <sub>2</sub> ±1	d <sub>1</sub> /L	e	P	Reference
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>						
Work space			40	32	25/180	122	39	D72.020.010
125								
160	63	108	104	D72.016.006				
200			144	D72.020.006				
160			32	25	25/180	82	39	D72.016.008
200	80	143				122		D72.020.008
250						172		D72.025.008
200			40	32	32/200	122	43	D72.020.010
250	100	163				172		D72.025.010
315						237		D72.031.010
200			50	40	32/200	114	52	D72.020.012
250	125	195				164		D72.025.012
315						229		D72.031.012
250			50	40	40/200	164	52	D72.025.016
315	160	230				229		D72.031.016
315	200	284	56	50	40/200	211	52	D72.031.020

L : Pin Length recommendations



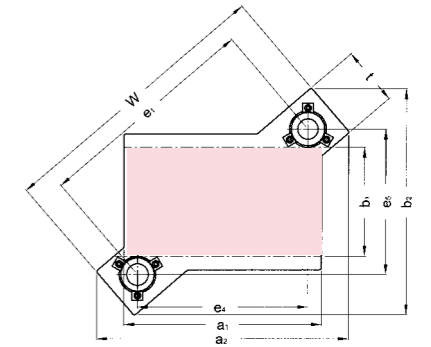
Standard die set with stripper plate  
type D63.xxx.xxx

Standard die set  
type D73.xxx.xxx

The plates are torch-cut and stress relieved.  
The guide elements can be chosen from our catalogue :

- Straight pillars P10.xxx.xxx
- Demountable pillars P2x.xxx.xxx
- Steel bushes B1x.xxx.xxx
- Bronze-plated bushes B2x.xxx.xxx

**Delivery: 48 hours ex works**



**Examples**

Die set with stripper plate :

D63.024.012

Identical die set without stripper plate :

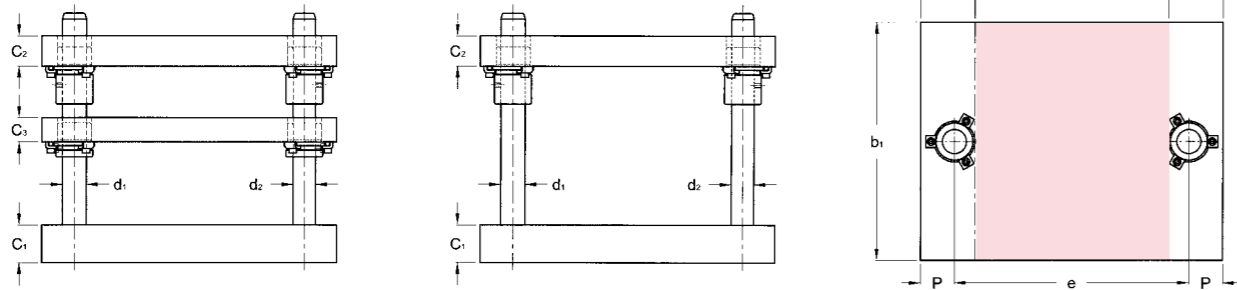
D73.024.012

a <sub>1</sub>	b <sub>1</sub>	Ext. dimensions		C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e <sub>1</sub>	e <sub>5</sub>	e <sub>4</sub>	t	w	Reference x = 6 : with C3 x = 7 : without C3
		a <sub>2</sub>	b <sub>2</sub>											
Work space		235	260	32	25	25	25/180	24/180	193	147	125	78	271	Dx3.016.010
165														
200	100	271							249	200			327	Dx3.024.010
240		310							290	250			368	Dx3.029.010
290		357		40	32	28			240	160			326	Dx3.020.012
200		282							269	200			355	Dx3.024.012
240	125	322	300						308	250			394	Dx3.029.012
290		371							363	315	86		449	Dx3.035.012
355		433					32/200	30/200	293	200			379	Dx3.024.016
240		322							329	214	250		415	Dx3.029.016
290	160	372	335	50	40	32			381	315			467	Dx3.035.016
355		435							363	250			467	Dx3.029.020
290		398							411	263	315	104	515	Dx3.035.020
355	200	462	410				40/220	38/220	444	313	315		548	Dx3.035.025
355	250	462	460											

L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH CENTRE PILLARS

**D81  
D91**



Standard assembly of bushes on underside of stripper plate.

Ext. dimensions			C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e	P	reference x = 8 : with C3 x = 9 : without C3	
a <sub>1</sub>	b <sub>1</sub>	a <sub>2</sub>									
250	Work space										
	160	127	32	32	32	25/200	24/200	174	38	Dx1.125.016	
			32	40						Dx1.225.016	
			40	32						Dx1.325.016	
			40	40						Dx1.425.016	
	200	127	32	32						Dx1.125.020	
			32	40						Dx1.225.020	
			40	32						Dx1.325.020	
			40	40						Dx1.425.020	
	250	127	32	32						Dx1.125.025	
			32	40						Dx1.225.025	
			40	32						Dx1.325.025	
40			40	Dx1.425.025							
315	200	171	32	32	32	32/200	30/200	225	45	Dx1.131.020	
			32	40						Dx1.231.020	
			40	32						Dx1.331.020	
			40	40						Dx1.431.020	
	250		171	32						32	Dx1.131.025
				32						40	Dx1.231.025
				40						32	Dx1.331.025
				40						40	Dx1.431.025
	315		171	40						40	Dx1.131.031
				40						50	Dx1.231.031
				50						40	Dx1.331.031
				50						50	Dx1.431.031
400	200	256	40	40	32	32/220	30/220	310	45	Dx1.140.020	
			40	50						Dx1.240.020	
			50	40						Dx1.340.020	
			50	50						Dx1.440.020	
	250		256	40						40	Dx1.140.025
				40						50	Dx1.240.025
				50						40	Dx1.340.025
				50						50	Dx1.440.025
	315		256	40						40	Dx1.140.031
				40						50	Dx1.240.031
				50						40	Dx1.340.031
				50						50	Dx1.440.031
400	256	40	40	Dx1.140.040							
		40	50	Dx1.240.040							
		50	40	Dx1.340.040							
		50	50	Dx1.440.040							

L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH CENTRE PILLARS

**D81  
D91**

The plates are torch-cut and stress relieved.  
The steel or bronze-plated steel guide elements can be chosen from our "Guide Elements" catalogue.

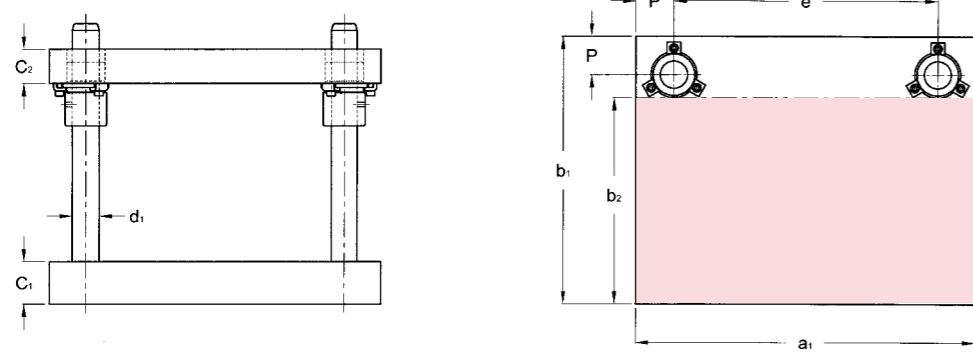
Delivery: 72 hours ex works

### Examples

Die set with stripper plate : D81.463.040  
Identical die set without stripper plate : D91.463.040

a <sub>1</sub>	b <sub>1</sub>	a <sub>2</sub>	C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e	P	Reference x = 8 : with C3 x = 9 : without C3	
											Work space
500	250	337	40	40	32	40/220	38/220	400	50	Dx1.150.025	
			40	50						Dx1.250.025	
			50	40						Dx1.350.025	
			50	50						Dx1.450.025	
	315		337	40						40	Dx1.150.031
				40						50	Dx1.250.031
				50						40	Dx1.350.031
				50						50	Dx1.450.031
	400		337	40						40	Dx1.150.040
				40						50	Dx1.250.040
				50						40	Dx1.350.040
				50						50	Dx1.450.040
500	337	40	40	Dx1.150.050							
		40	50	Dx1.250.050							
		50	40	Dx1.350.050							
		50	50	Dx1.450.050							
630	315	435	50	50	40	50/220	48/220	510	60	Dx1.163.031	
			50	58						Dx1.263.031	
			58	50						Dx1.363.031	
			58	58						Dx1.463.031	
	400		435	50						50	Dx1.163.040
				50						58	Dx1.263.040
				58						50	Dx1.363.040
				58						58	Dx1.463.040
	500		435	50						50	Dx1.163.050
				50						58	Dx1.263.050
				58						50	Dx1.363.050
				58						58	Dx1.463.050
630	435	50	50	Dx1.163.063							
		50	58	Dx1.263.063							
		58	50	Dx1.363.063							
		58	58	Dx1.463.063							
710	400	515	58	58	40	50/250	48/250	590	60	Dx1.171.040	
			58	63						Dx1.271.040	
			63	58						Dx1.371.040	
			63	63						Dx1.471.040	
	500		515	58						58	Dx1.171.050
				58						63	Dx1.271.050
				63						58	Dx1.371.050
				63						63	Dx1.471.050
	630		515	58						58	Dx1.171.063
				58						63	Dx1.271.063
				63						58	Dx1.371.063
				63						63	Dx1.471.063

L : Pin Length recommendations



Ext. dimensions			C <sub>1</sub> ±1	C <sub>2</sub> ±1	d <sub>1</sub> /L	e	P	Reference
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>						
Work space								
250	98	160	32	32	25/200	174	38	D92.125.016
			32	40				D92.225.016
			40	32				D92.325.016
			40	40				D92.425.016
	138	200	32	32				D92.125.020
			32	40				D92.225.020
			40	32				D92.325.020
			40	40				D92.425.020
	188	250	32	32				D92.125.025
			32	40				D92.225.025
			40	32				D92.325.025
			40	40				D92.425.025
315	128	200	32	32	32/200	225	45	D92.131.020
			32	40				D92.231.020
			40	32				D92.331.020
			40	40				D92.431.020
	178	250	32	32				D92.131.025
			32	40				D92.231.025
			40	32				D92.331.025
			40	40				D92.431.025
	243	315	40	40				D92.131.031
			40	50				D92.231.031
			50	40				D92.331.031
			50	50				D92.431.031
400	128	200	40	40	32/220	310	45	D92.140.020
			40	50				D92.240.020
			50	40				D92.340.020
			50	50				D92.440.020
	178	250	40	40				D92.140.025
			40	50				D92.240.025
			50	40				D92.340.025
			50	50				D92.440.025
	243	315	40	40				D92.140.031
			40	50				D92.240.031
			50	40				D92.340.031
			50	50				D92.440.031
318	400	40	40	D92.140.040				
		40	50	D92.240.040				
		50	40	D92.340.040				
		50	50	D92.440.040				

L : Pin Length recommendations

The plates are torch-cut and stress relieved.  
The steel or bronze-plated steel guide elements can be chosen from our "Guide Elements" catalogue.

**Delivery: 72 hours ex works**

**Example** Rectangular die set with rear pillars: **D92.450.050**

Ext. dimensions			C <sub>1</sub> ±1	C <sub>2</sub> ±1	d <sub>1</sub> /L	e	P	Reference
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>						
Work space								
500	168	250	40	40	40/220	400	50	D92.150.025
			40	50				D92.250.025
			50	40				D92.350.025
			50	50				D92.450.025
	233	315	40	40				D92.150.031
			40	50				D92.250.031
			50	40				D92.350.031
			50	50				D92.450.031
	318	400	40	40				D92.150.040
			40	50				D92.250.040
			50	40				D92.350.040
			50	50				D92.450.040
418	500	40	40	D92.150.050				
		40	50	D92.250.050				
		50	40	D92.350.050				
		50	50	D92.450.050				
630	217	315	50	50	50/220	510	60	D92.163.031
			50	58				D92.263.031
			58	50				D92.363.031
			58	58				D92.463.031
	302	400	50	50				D92.163.040
			50	58				D92.263.040
			58	50				D92.363.040
			58	58				D92.463.040
	402	500	50	50				D92.163.050
			50	58				D92.263.050
			58	50				D92.363.050
			58	58				D92.463.050
532	630	50	50	D92.163.063				
		50	58	D92.263.063				
		58	50	D92.363.063				
		58	58	D92.463.063				
710	302	400	58	58	50/250	590	60	D92.171.040
			58	63				D92.271.040
			63	58				D92.371.040
			63	63				D92.471.040
	402	500	58	58				D92.171.050
			58	63				D92.271.050
			63	58				D92.371.050
			63	63				D92.471.050
	532	630	58	58				D92.171.063
			58	63				D92.271.063
			63	58				D92.371.063
			63	63				D92.471.063

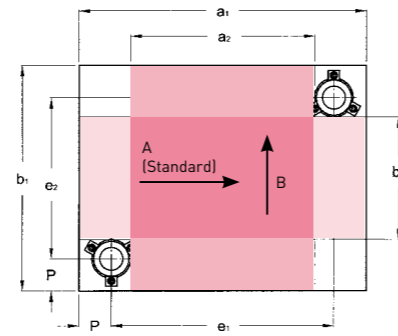
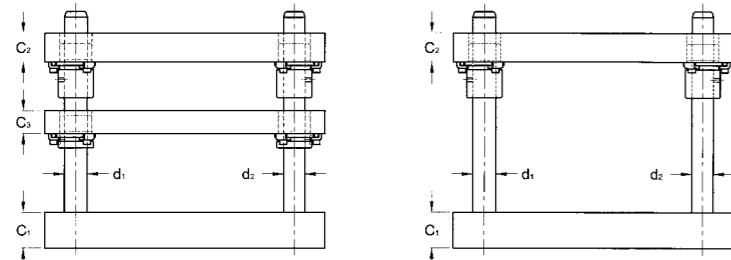
L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH DIAGONAL PILLARS

**D83  
D93**

# RECTANGULAR DIE SETS WITH DIAGONAL PILLARS

**D83  
D93**



Standard assembly of bushes on underside of stripper plate.

Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	Reference x = 8 : with C3 x = 9 : without C3
Work space, direction A		Work space, direction B										
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>									
250	37	160	127	32	32	32	25/200	24/200	174	84	38	Dx3.125.016
				32	40							Dx3.225.016
				40	32							Dx3.325.016
				40	40							Dx3.425.016
	77	200	127	32	32					Dx3.125.020		
				32	40					Dx3.225.020		
				40	32					Dx3.325.020		
				40	40					Dx3.425.020		
	127	250	127	32	32					Dx3.125.025		
				32	40					Dx3.225.025		
				40	32					Dx3.325.025		
				40	40					Dx3.425.025		
315	56	200	171	32	32	32	32/200	30/200	225	110	45	Dx3.131.020
				32	40							Dx3.231.020
				40	32							Dx3.331.020
				40	40							Dx3.431.020
	106	250		171	32					32		Dx3.131.025
					32					40		Dx3.231.025
					40					32		Dx3.331.025
					40					40		Dx3.431.025
	171	315		171	40					40		Dx3.131.031
					40					50		Dx3.231.031
					50					40		Dx3.331.031
					50					50		Dx3.431.031
400	56	200	256	40	40	32	32/220	30/220	310	110	45	Dx3.140.020
				40	50							Dx3.240.020
				50	40							Dx3.340.020
				50	50							Dx3.440.020
	106	250		256	40					40		Dx3.140.025
					40					50		Dx3.240.025
					50					40		Dx3.340.025
					50					50		Dx3.440.025
	171	315		256	40					40		Dx3.140.031
					40					50		Dx3.240.031
					50					40		Dx3.340.031
					50					50		Dx3.440.031
256	400	256	40	40	Dx3.140.040							
			40	50	Dx3.240.040							
			50	40	Dx3.340.040							
			50	50	Dx3.440.040							

L : Pin Length recommendations

The plates are torch-cut and stress relieved.  
The steel or bronze-plated steel guide elements can be chosen from our "Guide Elements" catalogue.

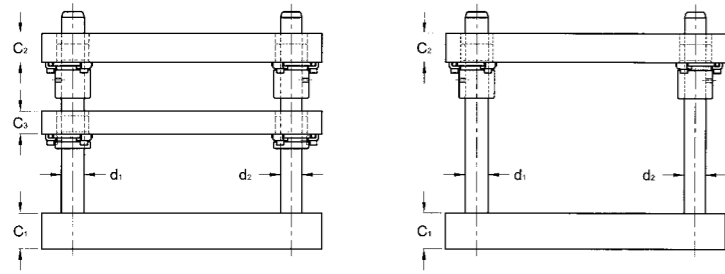
Delivery : 72 hours ex works

### Examples

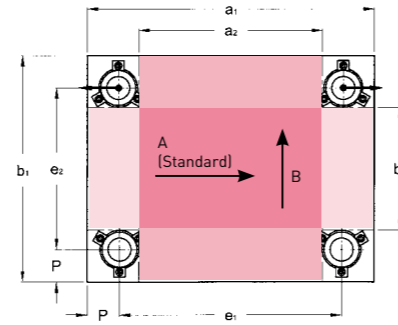
Die set with stripper plate : D83.450.031  
Identical die set without stripper plate : D93.450.031

Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	Références x = 8 : with C3 x = 9 : without C3
Work space, direction A		Work space, direction B										
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>									
500	87	250	337	40	40	32	40/220	38/220	400	150	50	Dx3.150.025
				40	50							Dx3.250.025
				50	40							Dx3.350.025
				50	50							Dx3.450.025
	152	315		337	40					40		Dx3.150.031
					40					50		Dx3.250.031
					50					40		Dx3.350.031
					50					50		Dx3.450.031
	237	400		337	40					40		Dx3.150.040
					40					50		Dx3.250.040
					50					40		Dx3.350.040
					50					50		Dx3.450.040
337	500	337	40	40	Dx3.150.050							
			40	50	Dx3.250.050							
			50	40	Dx3.350.050							
			50	50	Dx3.450.050							
630	120	315	435	50	50	40	50/220	48/220	510	195	60	Dx3.163.031
				50	58							Dx3.263.031
				58	50							Dx3.363.031
				58	58							Dx3.463.031
	205	400		435	50					50		Dx3.163.040
					50					58		Dx3.263.040
					58					50		Dx3.363.040
					58					58		Dx3.463.040
	305	500		435	50					50		Dx3.163.050
					50					58		Dx3.263.050
					58					50		Dx3.363.050
					58					58		Dx3.463.050
435	630	435	50	50	Dx3.163.063							
			50	58	Dx3.263.063							
			58	50	Dx3.363.063							
			58	58	Dx3.463.063							
710	205	400	515	58	58	40	50/250	48/250	590	280	60	Dx3.171.040
				58	63							Dx3.271.040
				63	58							Dx3.371.040
				63	63							Dx3.471.040
	305	500		515	58					58		Dx3.171.050
					58					63		Dx3.271.050
					63					58		Dx3.371.050
					63					63		Dx3.471.050
	435	630		515	58					58		Dx3.171.063
					58					63		Dx3.271.063
					63					58		Dx3.371.063
					63					63		Dx3.471.063

L : Pin Length recommendations



Standard assembly of bushes on underside of stripper plate.



Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	References x = 8 : with C3 x = 9 : without C3
Work space, direction A		Work space, direction B									
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>								
250	37	160	127	32	32	32	25/200	174	84	38	Dx4.125.016
				32	40						Dx4.225.016
				40	32						Dx4.325.016
				40	40						Dx4.425.016
	77	200	127	32	32				Dx4.125.020		
				32	40				Dx4.225.020		
				40	32				Dx4.325.020		
				40	40				Dx4.425.020		
	127	250	127	32	32				Dx4.125.025		
				32	40				Dx4.225.025		
				40	32				Dx4.325.025		
				40	40				Dx4.425.025		
315	77	200	192	32	32	32	25/200	239	124	38	Dx4.131.020
				32	40						Dx4.231.020
				40	32						Dx4.331.020
				40	40						Dx4.431.020
	127	250	192	32	32				Dx4.131.025		
				32	40				Dx4.231.025		
				40	32				Dx4.331.025		
				40	40				Dx4.431.025		
	192	315	192	40	40				Dx4.131.031		
				40	50				Dx4.231.031		
				50	40				Dx4.331.031		
				50	50				Dx4.431.031		
400	77	200	277	40	40	32	25/200	324	124	38	Dx4.140.020
				40	50						Dx4.240.020
				50	40						Dx4.340.020
				50	50						Dx4.440.020
	127	250	277	40	40				Dx4.140.025		
				40	50				Dx4.240.025		
				50	40				Dx4.340.025		
				50	50				Dx4.440.025		
	171	315	256	40	40				Dx4.140.031		
				40	50				Dx4.240.031		
				50	40				Dx4.340.031		
				50	50				Dx4.440.031		
256	400	256	40	40	Dx4.140.040						
			40	50	Dx4.240.040						
			50	40	Dx4.340.040						
			50	50	Dx4.440.040						

L : Pin Length recommendations

The plates are torch-cut and stress relieved.  
The steel or bronze-plated steel guide elements can be chosen from our "Guide Elements" catalogue.  
The two rear pillars are offset by two mm towards the outside for foolproofing.

Delivery: 72 hours ex works

### Examples

Die set with stripper plate : D84.450.031  
Identical die set without stripper plate : D94.450.031

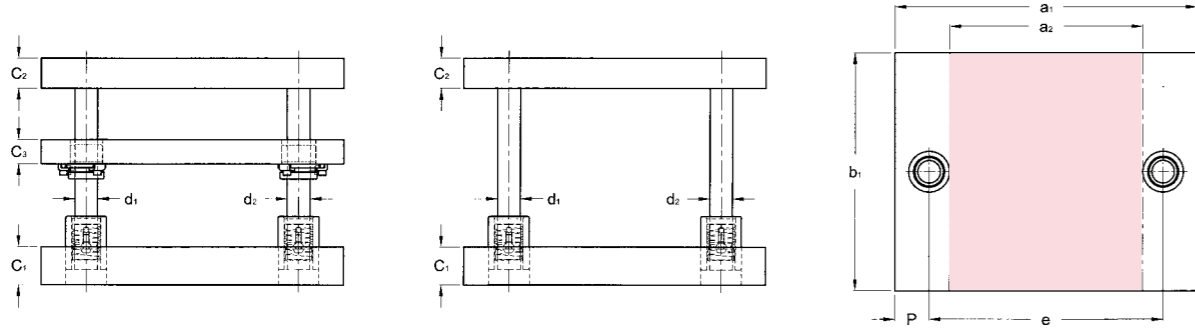
Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	References x = 8 : with C3 x = 9 : without C3
Work space, direction A		Work space, direction B									
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>								
500	106	250	356	40	40	32	32/220	410	160	45	Dx4.150.025
				40	50						Dx4.250.025
				50	40						Dx4.350.025
				50	50						Dx4.450.025
	171	315		356	40				40		Dx4.150.031
					40				50		Dx4.250.031
					50				40		Dx4.350.031
					50				50		Dx4.450.031
	256	400		356	40				40		Dx4.150.040
					40				50		Dx4.250.040
					50				40		Dx4.350.040
					50				50		Dx4.450.040
356	500	356	40	40	Dx4.150.050						
			40	50	Dx4.250.050						
			50	40	Dx4.350.050						
			50	50	Dx4.450.050						
630	152	315	467	50	50	40	40/220	530	215	50	Dx4.163.031
				50	58						Dx4.263.031
				58	50						Dx4.363.031
				58	58						Dx4.463.031
	237	400		467	50				50		Dx4.163.040
					50				58		Dx4.263.040
					58				50		Dx4.363.040
					58				58		Dx4.463.040
	337	500		467	50				50		Dx4.163.050
					50				58		Dx4.263.050
					58				50		Dx4.363.050
					58				58		Dx4.463.050
467	630	467	50	50	Dx4.163.063						
			50	58	Dx4.263.063						
			58	50	Dx4.363.063						
			58	58	Dx4.463.063						
710	205	400	515	58	58	40	50/250	590	280	60	Dx4.171.040
				58	63						Dx4.271.040
				63	58						Dx4.371.040
				63	63						Dx4.471.040
	305	500		515	58				58		Dx4.171.050
					58				63		Dx4.271.050
					63				58		Dx4.371.050
					63				63		Dx4.471.050
	435	630		515	58				58		Dx4.171.063
					58				63		Dx4.271.063
					63				58		Dx4.371.063
					63				63		Dx4.471.063

L : Pin Length recommendations



# RECTANGULAR DIE SETS WITH CENTRAL PILLARS AND BALL BEARING GUIDE BUSHES

**D86  
D96**



Standard assembly of bushes on stripper plate :  
 - on underside for demountable guide bushes (B1x.xxx.xxx and B2x.xxx.xxx)  
 - on top side for ball bearing guide bushes (B4x.xxx.xxx)

Ext. dimensions a <sub>1</sub>	Work space		C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e	P	Reference x = 8 : with C3 x = 9 : without C3	
	b <sub>1</sub>	a <sub>2</sub>									
250	160	120	32	32	32	25/200	24/200	165	42,5	Dx6.125.016	
			32	40						Dx6.225.016	
			40	32						Dx6.325.016	
			40	40						Dx6.425.016	
			32	32						Dx6.125.020	
			32	40						Dx6.225.020	
	200	120	120	40	32	32	25/200	24/200	165	42,5	Dx6.325.020
				40	40						Dx6.425.020
				32	32						Dx6.125.025
				32	40						Dx6.225.025
				40	32						Dx6.325.025
				40	40						Dx6.425.025
315	200	170	32	32	32	32/200	30/200	224	45,5	Dx6.131.020	
			32	40						Dx6.231.020	
			40	32						Dx6.331.020	
			40	40						Dx6.431.020	
			32	32						Dx6.131.025	
			32	40						Dx6.231.025	
	250	170	170	40	32	32	32/200	30/200	224	45,5	Dx6.331.025
				40	40						Dx6.431.025
				40	40						Dx6.131.031
				40	50						Dx6.231.031
				50	40						Dx6.331.031
				50	50						Dx6.431.031
400	200	255	40	40	32	32/200	30/200	309	45,5	Dx6.140.020	
			40	50						Dx6.240.020	
			50	40						Dx6.340.020	
			50	50						Dx6.440.020	
			40	40						Dx6.140.025	
			40	50						Dx6.240.025	
	250	255	255	50	40	32	32/200	30/200	309	45,5	Dx6.340.025
				50	50						Dx6.440.025
				40	40						Dx6.140.031
				40	50						Dx6.240.031
				50	40						Dx6.340.031
				50	50						Dx6.440.031
315	255	255	40	40	32	32/200	30/200	309	45,5	Dx6.140.040	
			40	50						Dx6.240.040	
			50	40						Dx6.340.040	
			50	50						Dx6.440.040	
			40	40						Dx6.140.040	
			40	50						Dx6.240.040	
400	255	255	50	40	32	32/200	30/200	309	45,5	Dx6.340.040	
			50	50						Dx6.440.040	

L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH CENTRAL PILLARS AND BALL BEARING GUIDE BUSHES

**D86  
D96**

The plates are torch-cut and stress relieved.  
 The guide elements with ball bearings (bush B30.xxx.xxx) can be chosen from our "Guide Elements" catalogue.

**Please note:** The work space is reduced if B40 or B42 bushes are used (see pages 9 and 10 - position of clamps - dimensions Q1 and Q2).

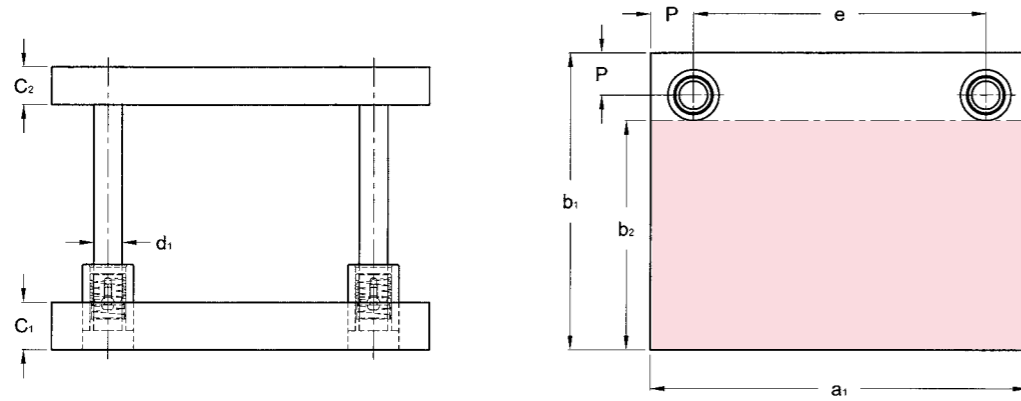
**Delivery: 72 hours ex works**

### Examples

Die set with stripper plate: D86.463.040  
 Identical die set without stripper plate: D96.463.040

Ext. dimensions a <sub>1</sub>	Work space		C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e	P	Reference x = 8 : with C3 x = 9 : without C3	
	b <sub>1</sub>	a <sub>2</sub>									
500	250	330	40	40	32	40/220	38/220	395	52,5	Dx6.150.025	
			40	50						Dx6.250.025	
			50	40						Dx6.350.025	
			50	50						Dx6.450.025	
			40	40						Dx6.150.031	
			40	50						Dx6.250.031	
	315	330	330	50	40	32	40/220	38/220	395	52,5	Dx6.350.031
				50	50						Dx6.450.031
				40	40						Dx6.150.040
				40	50						Dx6.250.040
				50	40						Dx6.350.040
				50	50						Dx6.450.040
630	315	429	40	40	40	50/220	48/220	510	60	Dx6.150.050	
			40	50						Dx6.250.050	
			50	40						Dx6.350.050	
			50	50						Dx6.450.050	
			50	50						Dx6.163.031	
			50	58						Dx6.263.031	
	400	429	429	58	50	40	50/220	48/220	510	60	Dx6.363.031
				58	58						Dx6.463.031
				50	50						Dx6.163.040
				50	58						Dx6.263.040
				58	50						Dx6.363.040
				58	58						Dx6.463.040
500	429	429	50	50	40	50/220	48/220	510	60	Dx6.163.050	
			50	58						Dx6.263.050	
			58	50						Dx6.363.050	
			58	58						Dx6.463.050	
			50	50						Dx6.163.063	
			50	58						Dx6.263.063	
710	400	509	58	58	40	50/250	48/250	590	60	Dx6.363.063	
			58	58						Dx6.463.063	
			58	63						Dx6.171.040	
			63	58						Dx6.271.040	
			63	63						Dx6.371.040	
			63	63						Dx6.471.040	
	500	509	509	58	58	40	50/250	48/250	590	60	Dx6.171.050
				58	63						Dx6.271.050
				63	58						Dx6.371.050
				63	63						Dx6.471.050
				58	58						Dx6.171.063
				58	63						Dx6.271.063
630	509	509	63	58	40	50/250	48/250	590	60	Dx6.371.063	
			63	63						Dx6.471.063	

L : Pin Length recommendations



Ext. dimensions			C <sub>1</sub> ±1	C <sub>2</sub> ±1	d <sub>1</sub> /L	e	P	Reference
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>						
Work space								
250	93	160	32	32	32/200	170	40	D97.125.016
			32	40				D97.225.016
			40	32				D97.325.016
			40	40				D97.425.016
	133	200	32	32				D97.125.020
			32	40				D97.225.020
			40	32				D97.325.020
			40	40				D97.425.020
	183	250	32	32				D97.125.025
			32	40				D97.225.025
			40	32				D97.325.025
			40	40				D97.425.025
315	128	200	32	32	32/200	225	45	D97.131.020
			32	40				D97.231.020
			40	32				D97.331.020
			40	40				D97.431.020
	178	250	32	32				D97.131.025
			32	40				D97.231.025
			40	32				D97.331.025
			40	40				D97.431.025
	243	315	40	40				D97.131.031
			40	50				D97.231.031
			50	40				D97.331.031
			50	50				D97.431.031
400	128	200	40	40	32/220	310	45	D97.140.020
			40	50				D97.240.020
			50	40				D97.340.020
			50	50				D97.440.020
	178	250	40	40				D97.140.025
			40	50				D97.240.025
			50	40				D97.340.025
			50	50				D97.440.025
	230	315	40	40				D97.140.031
			40	50				D97.240.031
			50	40				D97.340.031
			50	50				D97.440.031
315	400	40	40	D97.140.040				
		40	50	D97.240.040				
		50	40	D97.340.040				
		50	50	D97.440.040				

L : Pin Length recommendations

The plates are torch-cut and stress relieved.  
The guide elements with ball bearings (bush B30.xxx.xxx) can be chosen from our "Guide Elements" catalogue.

**Please note:** The work space is reduced if B40 bushes are used  
(see pages 9 - position of clamps - dimensions Q1 and Q2).

**Delivery: 72 hours ex works**

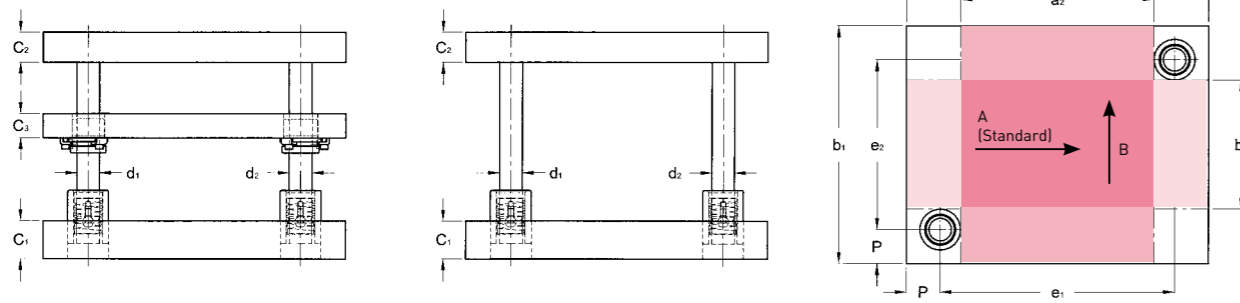
**Example** Rectangular stock die set with rear ball bearing guides: **D97.350.040**

Ext. dimensions			C <sub>1</sub> ±1	C <sub>2</sub> ±1	d <sub>1</sub> /L	e	P	Reference
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>						
Work space								
500	157	250	40	40	40/220	395	52,5	D97.150.025
			40	50				D97.250.025
			50	40				D97.350.025
			50	50				D97.450.025
	222	315	40	40				D97.150.031
			40	50				D97.250.031
			50	40				D97.350.031
			50	50				D97.450.031
	307	400	40	40				D97.150.040
			40	50				D97.250.040
			50	40				D97.350.040
			50	50				D97.450.040
407	500	40	40	D97.150.050				
		40	50	D97.250.050				
		50	40	D97.350.050				
		50	50	D97.450.050				
630	206	315	50	50	50/220	510	60	D97.163.031
			50	58				D97.263.031
			58	50				D97.363.031
			58	58				D97.463.031
	291	400	50	50				D97.163.040
			50	58				D97.263.040
			58	50				D97.363.040
			58	58				D97.463.040
	391	500	50	50				D97.163.050
			50	58				D97.263.050
			58	50				D97.363.050
			58	58				D97.463.050
521	630	50	50	D97.163.063				
		50	58	D97.263.063				
		58	50	D97.363.063				
		58	58	D97.463.063				
710	291	400	58	58	50/250	590	60	D97.171.040
			58	63				D97.271.040
			63	58				D97.371.040
			63	63				D97.471.040
	391	500	58	58				D97.171.050
			58	63				D97.271.050
			63	58				D97.371.050
			63	63				D97.471.050
	521	630	58	58				D97.171.063
			58	63				D97.271.063
			63	58				D97.371.063
			63	63				D97.471.063

L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH DIAGONAL PILLARS AND BALL BEARING GUIDES

**D88  
D98**



Standard assembly of bushes on stripper plate :  
 - on underside for demountable guide bushes (B1x.xxx.xxx and B2x.xxx.xxx)  
 - on top side for ball bearing guide bushes (B4x.xxx.xxx)

Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	Reference x = 8 : with C3 x = 9 : without C3										
Work space, direction A		Work space, direction B																				
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>																			
250	30	160	120	32	32	32	25/200	24/200	165	75	42,5	Dx8.125.016 Dx8.225.016 Dx8.325.016 Dx8.425.016										
				40	40								50	145	52,5							
				32	32											210						
				40	40																	
	32	32	295																			
	40	40		395																		
	32	32			52,5																	
	40	40																				
	70	200	200							120			32	32		32	25/200	24/200	165	115	42,5	Dx8.125.020 Dx8.225.020 Dx8.325.020 Dx8.425.020
				40									40	210								
				32	32								295									
				40	40																	
32	32	395																				
40	40		52,5																			
32	32			52,5																		
40	40																					
120	250	250			120	32	32	32	25/200	24/200	165	165	42,5	Dx8.125.025 Dx8.225.025 Dx8.325.025 Dx8.425.025								
			40			40	210															
			32	32		295																
			40	40																		
32	32	395																				
40	40		52,5																			
32	32			52,5																		
40	40																					
315	56	200			171	32	32					32			32/200	30/200	225	110	45	Dx8.131.020 Dx8.231.020 Dx8.331.020 Dx8.431.020		
			40			40	195															
			32	32		280																
			40	40																		
	32	32	380																			
	40	40		510																		
	32	32			510																	
	40	40																				
	106	250	250			171	32	32	32	32/200	30/200		225	160				45			Dx8.131.025 Dx8.231.025 Dx8.331.025 Dx8.431.025	
				40			40	280														
				32	32		380															
				40	40																	
32	32	510																				
40	40		510																			
32	32			510																		
40	40																					
171	315	315			171	40	40	32				32/200		30/200	225	225	45		Dx8.131.031 Dx8.231.031 Dx8.331.031 Dx8.431.031			
			50			50	380															
			40	40		510																
			50	50																		
40	40	510																				
50	50		510																			
40	40			510																		
50	50																					
400	56	200			260	40	40		32	32/200	30/200		310			110		45		Dx8.140.020 Dx8.240.020 Dx8.340.020 Dx8.440.020		
			50			50	280															
			40	40		380																
			50	50																		
	40	40	510																			
	50	50		510																		
	40	40			510																	
	50	50																				
	106	250	250			260	40	40				32		32/200	30/200	310	160		45		Dx8.140.025 Dx8.240.025 Dx8.340.025 Dx8.440.025	
				50			50	280														
				40	40		380															
				50	50																	
40	40	510																				
50	50		510																			
40	40			510																		
50	50																					
171	315	315			260	40	40	32	32/200	30/200	310		225				45	Dx8.140.031 Dx8.240.031 Dx8.340.031 Dx8.440.031				
			50			50	380															
			40	40		510																
			50	50																		
40	40	510																				
50	50		510																			
40	40			510																		
50	50																					
256	400	400			260	40	40					32	32/200	30/200	310	310			45	Dx8.140.040 Dx8.240.040 Dx8.340.040 Dx8.440.040		
			50			50	280															
			40	40		380																
			50	50																		
40	40	510																				
50	50		510																			
40	40			510																		
50	50																					

L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH DIAGONAL PILLARS AND BALL BEARING GUIDES

**D88  
D98**

The plates are torch-cut and stress relieved.  
 The guide elements with ball bearings (bush B30.xxx.xxx) can be chosen from our "Guide Elements" catalogue.

**Please note:** The work space is reduced if B40 bushes are used  
 (see page 9 and 10 - position of clamps - dimensions Q1 and Q2).

**Delivery: 72 hours ex works**

### Examples

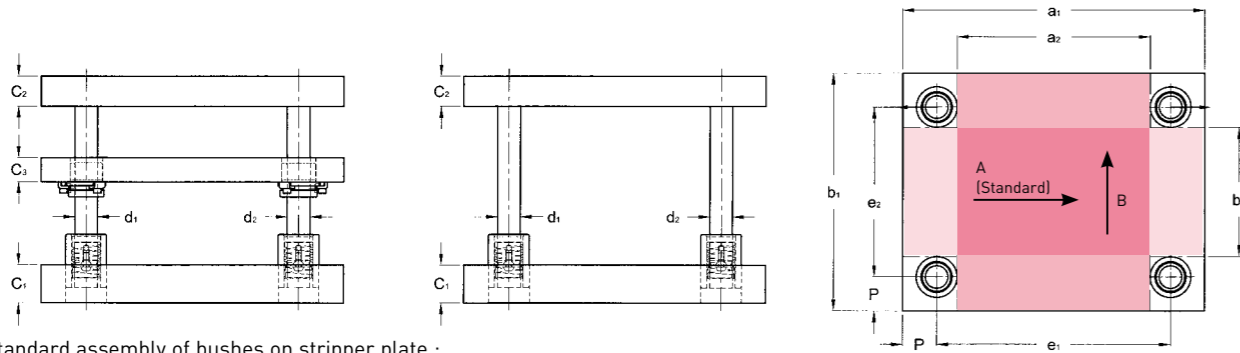
Die set with stripper plate: D88.125.016  
 Identical die set without stripper plate: D98.125.016

Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	d <sub>2</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	Reference x = 8 : with C3 x = 9 : without C3														
Work space, direction A		Work space, direction B																								
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>																							
500	80	250	330	40	40	32	40/220	38/220	395	145	52,5	Dx8.150.025 Dx8.250.025 Dx8.350.025 Dx8.450.025														
				40	40								210													
				50	50									295												
				50	50																					
	40	40	395																							
	40	40		52,5																						
	40	40																								
	50	50																								
	630	114	315		429					50			50	40	50/220	48/220	510	195	60	Dx8.163.031 Dx8.263.031 Dx8.363.031 Dx8.463.031						
				50						58			280													
				58						50											380					
				58						58																
50		50	510																							
50		58		510																						
58		50																								
58		58																								
299		500	500		429	50	50	40	50/220	48/220	510	380	60					Dx8.163.040 Dx8.263.040 Dx8.363.040 Dx8.463.040								
				50		58	510																			
				58		50																				
				58		58																				
429	630	630	429	50	50	40						50/220		48/220	510	510	60		Dx8.163.050 Dx8.263.050 Dx8.363.050 Dx8.463.050							
				50	58		510																			
				58	50																					
				58	58																					
710	199	400	509	58	58											40				50/250	48/250	590	280	60	Dx8.171.040 Dx8.271.040 Dx8.371.040 Dx8.471.040	
				58	63		380																			
				63	58																					510
				63	63																					
	58	58	510																							
	58	63		510																						
	63	58																								
	63	63																								
	429	630	630		509	58	58	40	50/250	48/250	590	380	60	Dx8.171.050 Dx8.271.050 Dx8.371.050 Dx8.471.050												
				58		63	510																			
				63		58																				
				63		63																				
429	630	630	509	58	58	40						50/250			48/250	590	510	60	Dx8.171.063 Dx8.271.063 Dx8.371.063 Dx8.471.063							
				58	63		510																			
				63	58																					
				63	63																					

L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH FOUR PILLARS AND BALL BEARING GUIDES

**D89  
D99**



Standard assembly of bushes on stripper plate :  
- on underside for demountable guide bushes (B1x.xxx.xxx and B2x.xxx.xxx)  
- on top side for ball bearing guide bushes (B4x.xxx.xxx)

Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	Reference x = 8 : with C3 x = 9 : without C3
Work space, direction A		Work space, direction B									
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>								
250	30	160	120	32	32	32	25/200	165	75	42,5	Dx9.125.016
				32	40						Dx9.225.016
				40	32						Dx9.325.016
				40	40						Dx9.425.016
	70	200	120	32	32				Dx9.125.020		
				32	40				Dx9.225.020		
				40	32				Dx9.325.020		
				40	40				Dx9.425.020		
	120	250	120	32	32				Dx9.125.025		
				32	40				Dx9.225.025		
				40	32				Dx9.325.025		
				40	40				Dx9.425.025		
315	70	200	185	32	32	32	25/200	230	115	42,5	Dx9.131.020
				32	40						Dx9.231.020
				40	32						Dx9.331.020
				40	40						Dx9.431.020
	120	250	185	32	32				Dx9.131.025		
				32	40				Dx9.231.025		
				40	32				Dx9.331.025		
				40	40				Dx9.431.025		
	185	315	185	40	40				Dx9.131.031		
				40	50				Dx9.231.031		
				50	40				Dx9.331.031		
				50	50				Dx9.431.031		
400	70	200	270	40	40	32	25/200	315	115	42,5	Dx9.140.020
				40	50						Dx9.240.020
				50	40						Dx9.340.020
				50	50						Dx9.440.020
	120	250	270	40	40				Dx9.140.025		
				40	50				Dx9.240.025		
				50	40				Dx9.340.025		
				50	50				Dx9.440.025		
	165	315	250	40	40				Dx9.140.031		
				40	50				Dx9.240.031		
				50	40				Dx9.340.031		
				50	50				Dx9.440.031		
250	400	250	40	40	Dx9.140.040						
			40	50	Dx9.240.040						
			50	40	Dx9.340.040						
			50	50	Dx9.440.040						

L : Pin Length recommendations

# RECTANGULAR DIE SETS WITH FOUR PILLARS AND BALL BEARING GUIDES

**D89  
D99**

The plates are torch-cut and stress relieved.  
The guide elements with ball bearings (bush B30.xxx.xxx) can be chosen from our "Guide Elements" catalogue.

**Please note:** The work space is reduced if B40 bushes are used  
(see pages 9 and 10 - position of clamps - dimensions Q1 and Q2).

**Delivery: 72 hours ex works**

### Examples

Die set with stripper plate: D89.125.016  
Identical die set without stripper plate: D99.125.016

Ext. dimensions				C <sub>1</sub> ±1	C <sub>2</sub> ±1	C <sub>3</sub> ±1	d <sub>1</sub> /L	e <sub>1</sub>	e <sub>2</sub>	P	Reference x = 8 : with C3 x = 9 : without C3
Work space, direction A		Work space, direction B									
a <sub>1</sub>	b <sub>2</sub>	b <sub>1</sub>	a <sub>2</sub>								
500	100	250	350	40	40	32	32/220	404	154	48	Dx9.150.025
				40	50						Dx9.250.025
				50	40						Dx9.350.025
				50	50						Dx9.450.025
	165	315	350	40	40				Dx9.150.031		
				40	50				Dx9.250.031		
				50	40				Dx9.350.031		
				50	50				Dx9.450.031		
	250	400	350	40	40				Dx9.150.040		
				40	50				Dx9.250.040		
				50	40				Dx9.350.040		
				50	50				Dx9.450.040		
350	500	350	40	40	Dx9.150.050						
			40	50	Dx9.250.050						
			50	40	Dx9.350.050						
			50	50	Dx9.450.050						
630	140	315	455	50	50	40	40/220 520	520	205	55	Dx9.163.031
				50	58						Dx9.263.031
				58	50						Dx9.363.031
				58	58						Dx9.463.031
	225	400		455	50				50		Dx9.163.040
					50				58		Dx9.263.040
					58				50		Dx9.363.040
					58				58		Dx9.463.040
	325	500		455	50				50		Dx9.163.050
					50				58		Dx9.263.050
					58				50		Dx9.363.050
					58				58		Dx9.463.050
455	630	455	50	50	Dx9.163.063						
			50	58	Dx9.263.063						
			58	50	Dx9.363.063						
			58	58	Dx9.463.063						
710	190	400	500	58	58	40	50/250	581	271	64,5	Dx9.171.040
				58	63						Dx9.271.040
				63	58						Dx9.371.040
				63	63						Dx9.471.040
	290	500		500	58				58		Dx9.171.050
					58				63		Dx9.271.050
					63				58		Dx9.371.050
					63				63		Dx9.471.050
	420	630		500	58				58		Dx9.171.063
					58				63		Dx9.271.063
					63				58		Dx9.371.063
					63				63		Dx9.471.063

L : Pin Length recommendations



# DIE SETS - MACHINED PLATES ACCORDING TO DRAWING CONTENTS

■ Machine capacities .....	24
■ Special die sets .....	25
■ MDL geometric standards .....	26
■ Dimensioning instructions for special rectangular die sets .....	27
■ Machined plates .....	28
■ The KIT - Die Sets .....	29

We perform machining on CNC machines.

**CNC TORCH CUTTING** Max. L x W x thickness: 6,000 x 2,300 x 250 mm  
Tolerance to  $\pm 2$  mm

**STRESS RELIEVING** L x W x H max.: 4,500 x 2,300 x 1,600 mm  
Max. load: 20 T

## MACHINING

**Grinding:** Blancard and tangential-type. Max.load: 2T  
Max. diagonal: 2,200 mm

**Milling on machining centre**  
Max. stroke (X) : X x Y x Z: 3,650 x 1,750 x 710 mm Max. load: 9 T  
Max. stroke (Y and Z) : X x Y x Z: 3,000 x 2,500 x 1,000 mm Max. load: 6 T  
Large capacity : X x Y x Z: 4,010 x 2,500 x 670 mm Max. load: 15 T

**Deep drilling**  
Max. stroke : X x Y x Z: 2,000 x 1,000 x 1,500 mm Max. load: 15 T

**Boring, Drilling, Edge milling, etc.**

**MECHANICAL WELDING** can be carried out upon demand

**HANDLING**  
Bridge cranes of up to 20 T

## STEEL PLATE SPECIFICATIONS

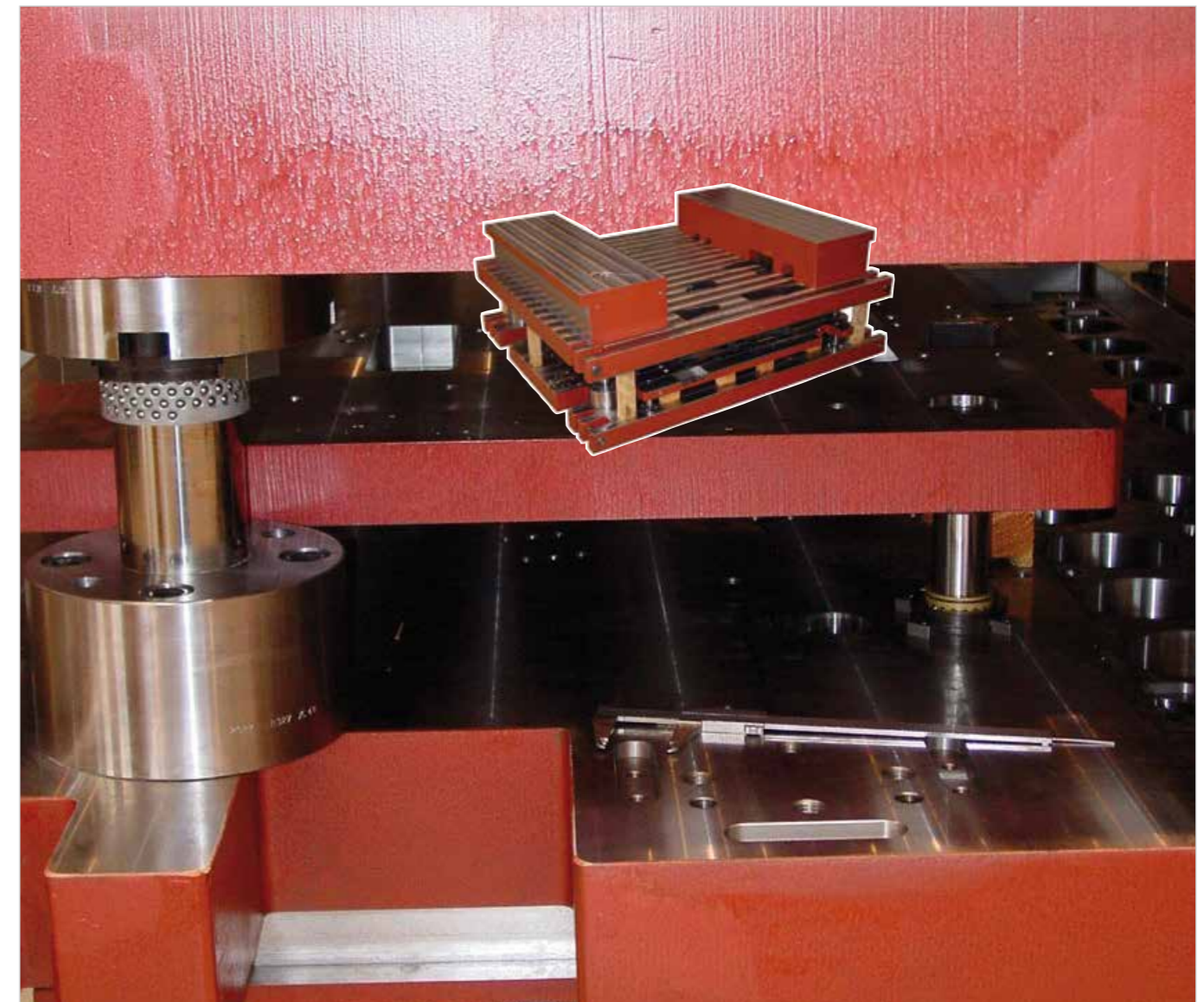
**In stock:** C25 - C45  
**Upon demand:** Pre-treated steel, high-strength aluminium, etc.  
Stress relieving upon request.

## TYPES OF PLATES

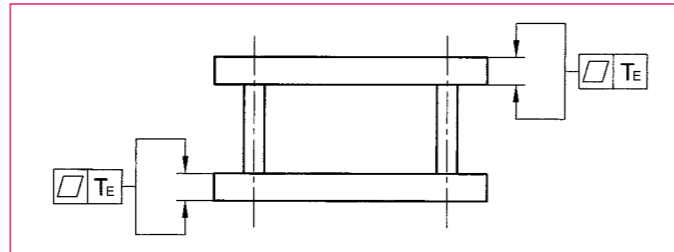
The peripheral shapes are torch-cut and deburred. The edges may be milled for reference surfaces.  
**If tolerances are not specified for the thickness, the plates will be spotfaced to the minimum extent**, i.e. the blank sheet of the specified thickness is ground until our standards of flatness and parallel alignment are obtained  
Spot facing = 0 to 3 mm/metre max.

## DIE SETS WITH TORCH-CUTTING AND MACHINING ACCORDING TO DRAWING

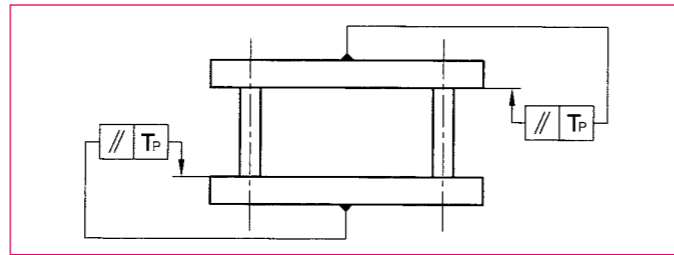
We manufacture die sets according to your drawing and design specifications. Heavy machining removing a lot of metal, carried out after the die set has been assembled, may cause deformations. We recommend that you let us perform these machining operations.



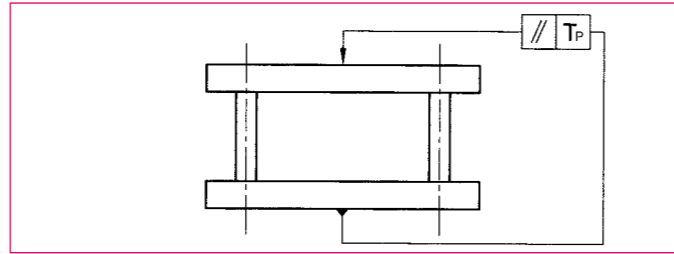
FLATNESS OF PLATE FACES	
Thickness	TE
E > 30mm	0,004 / 100 mm
20 < E < 30 mm	0,008 / 100 mm



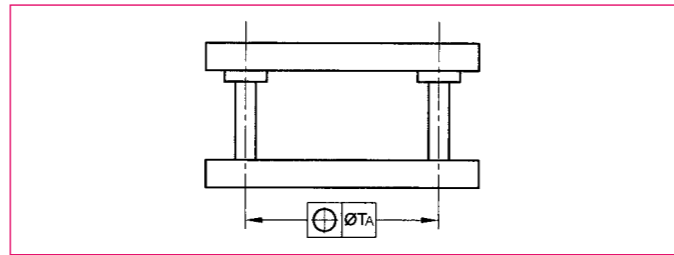
PARALLEL ALIGNMENT OF PLATE FACES		
from mm	to mm	TP
0	100	0,006
100	200	0,012
200	300	0,018



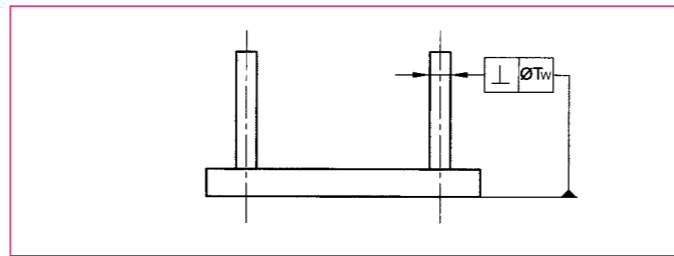
PARALLEL ALIGNMENT OF EXTERNAL FACES OF DIE SET		
from mm	to mm	TP
0	100	0,008
100	200	0,012
200	300	0,018
300	400	0,024
400	500	0,030
500	600	0,036



LOCATION	
TA: ±12 µm/m + additional 5 µm/m	



PERPENDICULARITY	
TW	
0,015 / 100mm	



ADJUSTMENT OF BORES	
Guide pillar	Guide bush
d = R6	D = H6

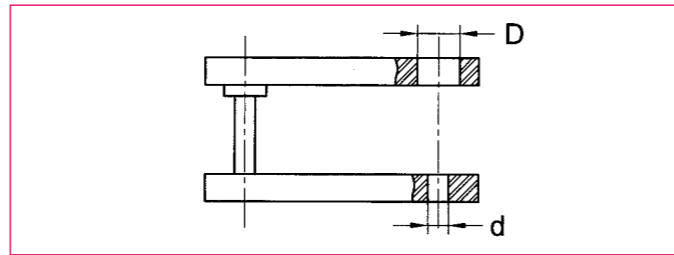
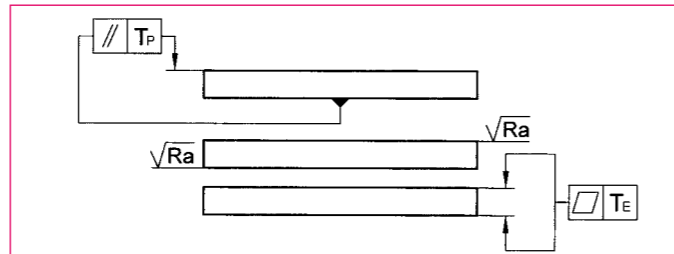
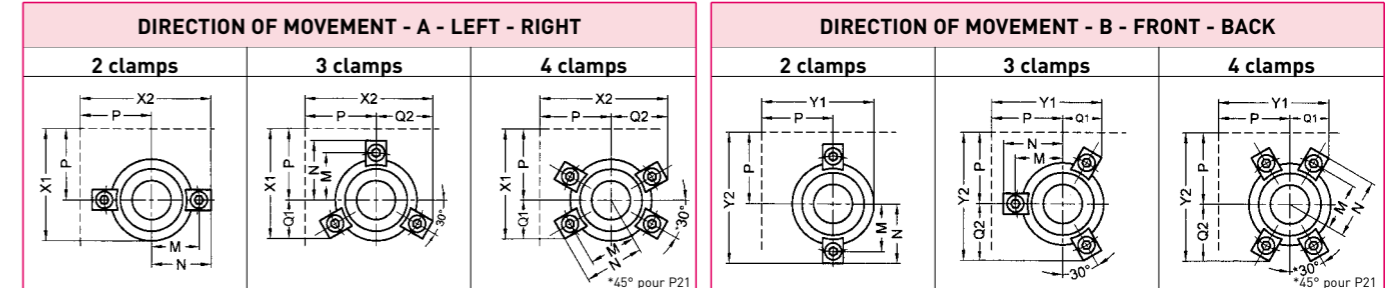


PLATE WITH MIN. SPOTFACING		
TE	TP	RA
0,04/1000 mm	0,06/1000 mm	3,2



RECOMMENDED PILLAR DIAMETER ACCORDING TO LENGTH A1 OF PLATE						
Length a1	150 - 300	350 - 500	550 - 700	750 - 1000	1100 - 1900	2000 - 2500
Recommended d1	25	32	40	50	63	80



STANDARD POSITION OF GUIDES AND FIXINGS							
GUIDE PILLAR				P10 - P21 - P22			
Diameter	19 - 20	24 - 25	30 - 32	38 - 40	48 - 50	63	80
no. of P21 clamps	3 x M5	3 x M6	3 x M6	4 x M8	4 x M8	4 x M8	4 x M8
GUIDE BUSH				B10 - B20			
P	30	40	45	50	60	65	75
X1 / Y1	46,3	64,2	71	81,5	97,5	111,5	132,5
X2 / Y2	55,5	74	82	94,1	112,3	122	141,6
no. of clamps	2 x M5	3 x M6	3 x M6	4 x M8	4 x M8	4 x M8	4 x M8
GUIDE BUSH				B12 - B22			
P	30	40	45	50	60	65	75
X1 / Y1	46,3	65,3	72	83,8	97,5	102,5	132,5
X2 / Y2	55,5	76,6	84,6	99	114,2	127,5	146,6
no. of clamps	2 x M5	3 x M6	3 x M6	4 x M8	4 x M8	4 x M8	4 x M8
BALL BEARING GUIDE BUSH				B30 - B40			
P	-	45	50	55	65	70	80
X1 / Y1	-	71	81,5	92,5	111,5	124	142,5
X2 / Y2	-	82	94,1	104,3	122	134	151,8
no. of B40 clamps	-	3 x M6	3 x M8	4 x M8	4 x M8	4 x M8	4 x M8
BALL BEARING GUIDE BUSH intermediate plate				B42			
P	-	45	50	55	65	-	-
X1 / Y1	-	72	79,3	92,5	111,5	-	-
X2 / Y2	-	84,6	93,5	103,7	121,5	-	-
no. of clamps	-	3 x M6	3 x M6	4 x M6	4 x M6	-	-

RECOMMENDED PLATE THICKNESS ACCORDING TO TYPE OF GUIDE ELEMENT USED									
Diameter	P10	P21	P22	B10-B20	B12-B22	B30	B40	B42	Plates
19 - 20	25	25	38	-	-	-	-	-	C1
	20	20	30	20	20	-	-	-	C2
	-	-	-	20	20	-	-	-	C3
24 - 25	32	32	46	-	-	32	32	-	C1
	25	25	38	25	25	32	32	-	C2
	-	-	-	25	25	-	-	22	C3
30 - 32	40	40	56	-	-	40	40	-	C1
	32	32	48	28	32	40	40	-	C2
	-	-	-	25	28	-	-	22	C3
38 - 40	50	50	66	-	-	50	50	-	C1
	40	40	58	32	40	50	50	-	C2
	-	-	-	32	50	-	-	32	C3
48 - 50	58	58	76	-	-	58	58	-	C1
	50	50	68	38	50	58	58	-	C2
	-	-	-	32	50	-	-	38	C3
63	63	63	86	-	-	63	63	-	C1
	58	58	78	50	63	63	63	-	C2
	-	-	-	40	63	-	-	-	C3
80	68	68	98	-	-	-	-	-	C1
	60	60	92	50	80	-	-	-	C2
	-	-	-	40	80	-	-	-	C3

### STEEL PLATE SPECIFICATIONS

**In stock:** C25 - C45  
**Upon demand:** Pre-treated steel, high-strength aluminium, etc.  
 Stress relieving upon request.

### TYPES OF PLATES:

The peripheral shapes are torch-cut and deburred. The edges can be milled for reference surfaces.  
**If tolerances are not specified for the thickness, the plates will be spotfaced to the minimum extent**, i.e. the blank sheet of the specified thickness is ground until our standards of flatness and parallel alignment are obtained  
 Spot facing = Max. of 0 to 3 mm/metre

### PLATES WITH TORCH CUTTING AND SPECIAL MACHINING

We can torch-cut, grind and machine **plates according to your drawings**. All of our plates are annealed. If these machining operations require the removal of large amounts of material, it is in your interest to let us perform the roughing (see finish). We control the risks of deformations due to internal stresses.

### PLATES WITH TORCH CUTTING AND SPECIAL MACHINING - Other thicknesses available upon request.

C25 : 12 - 15 - 20 - 25 - 30 - 35 - 40 - 42 - 45 - 50 - 52 - 55 - 60 - 65 - 70 - 75 - 80 - 85 - 90 - 95 - 100 - 105 - 110 - 120 - 150  
 C45 : 15 - 20 - 25 - 30 - 35 - 40 - 45 - 50 - 55 - 60 - 65 - 70 - 80 - 85 - 90 - 95 - 100 - 105 - 110 - 120 - 130 - 140 - 160

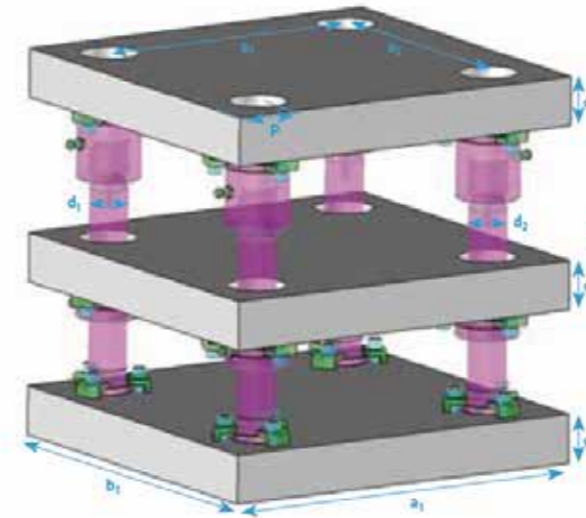
### FOR YOUR PLATE ORDERS

- Please specify: :
- Steel grade of the plate
  - Number of plates
  - External dimensions
  - Spotfaced or toleranced faces
  - Torch-cut or milled edges
  - **Special machining operations with detailed drawing**



## NEW - THE KIT

### PLATE (S)



### GUIDING ELEMENTS



Example of possible arrangement of the KIT, configuration and options

The KIT is of machined plates according to customer specifications and delivered with MDL Standard guiding components.

- Plates are in C25 Steel, flamse cut and stress relieved.
- Plates are segment surface grinded.
- Guiding elements are from our catalogs (from MDL standard, DIN, or AFNOR) , and are delivered not-assembled with the plates.
- Machining tolerances (mm / lm) :

	0,06		0,04	Ra	<3,2		+/-0,2		+/-2
--	------	--	------	----	------	--	--------	--	------

• Delivery time : 72 hours EXW

- **Options :**
  - Bore machining for Pillar/Bushes
  - Reference surface machining
  - Lifting holes
  - Flame cut areas according to drawings

**Example** Die Sets (incl C3) Le KIT with 4 guiding elements (to be detailed with the related order document).  
 DI16K – Die Sets – The KIT.

Dim. Externes	C123 + 1	D <sub>1</sub>	D <sub>2</sub>	e <sub>1</sub>	e <sub>2</sub>	P	REFERENCES
diagonal max = 2200 mm	150 mm max						
a <sub>1</sub> et b <sub>1</sub> to be detailed with the order	to be detailed with the order	according to your guiding element spec.		Options to be detailed with the order			<b>DI16K</b> Options to be detailed with the order





**AMDL**  
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