**Dietz** Systeme GmbH

DIETZ systeme

# Precision tooling

## Trumpf System

# Precision tooling systems | CONTENTS

DIETZ systeme

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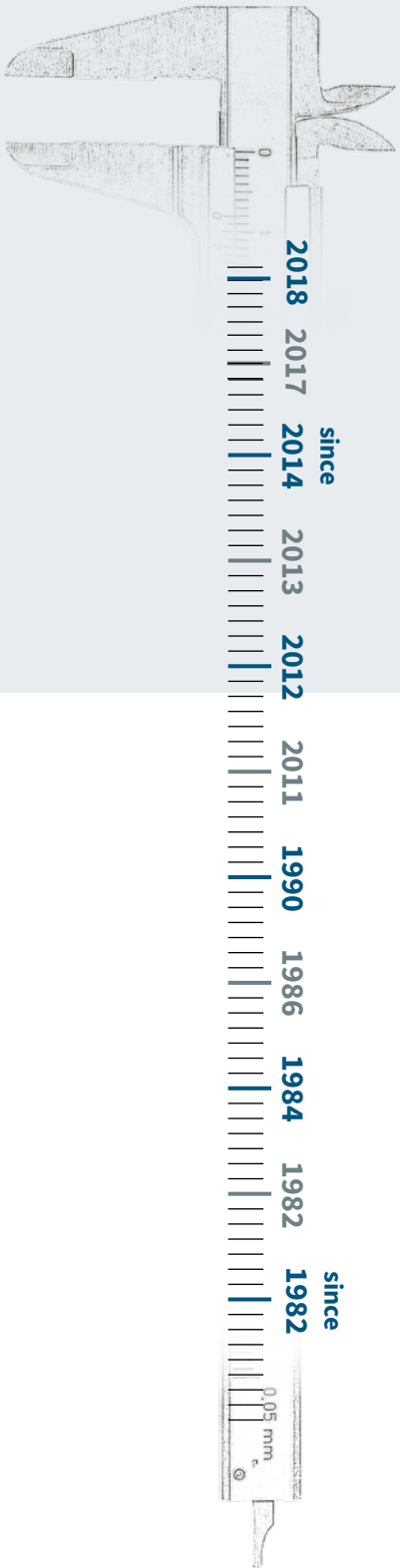
## GENERAL INFORMATION

# HISTORY 1982 - 2018




**2018** Corporate name change to Dietz Systeme GmbH and moving to Viechtach

**2017** Closing of automitive Segment

**since 2014** International expansion and cooperation network development

**2013** Corporate name changes to DMW GmbH - The brand Dietz remains

**2012** Company moves to its new building in Geiersthal

**2011** Company passes the 100 employee mark

**1990** Company enters the automotive industry

**1986** Punch and forming tools as well as jig manufacturing

**1984** First tool production for the Trumpf system

**1982** The Dietz company is established in Viechtach

**since 1982** Ferdinand Dietz invents the AirBlow system
The world's first countersink tool is produced

# **Dietz** Systeme GmbH

## Information

- Prices are ex works, plus VAT (valid since 01.01.2016)
  Beyond this our sales terms and delivery conditions apply (refer to: www.dietz-systeme.de).
- Deliveries abroad Germany are generally EXW Viechtach
- Punches and dies are made of the high quality tool material ***DS***$_{ECO}$.

# Machine groups

| A | B | C | D | E | | F | G | H* | I* | S |
|---|---|---|---|---|---|---|---|---|---|---|
| CN 700 | CN 901 E | CN 1200S | Trumatic | Sunimat 400 | | Trumatic | Trumatic | Trumatic | Trumatic | Trumatic |
| CN 900 | CN 902 | CN 1200A | 20 | Trumatic | Trumatic | 150W | 20aW | 190R | 2000R | 120R |
| CN 701 | CS 75 | CS 15 | 20a | 150K | 202K | 152W | 202W | 200R | 2020R | 160R |
| CN 901 | CS 75.2 | CS 20 | 202M | 151K | 225K | 180W | 300W | 500R | 3000L | |
| | | CS 20a | | 152K | 235K | 180.2W | 300LW | 600L | 3000R | Minimatic |
| | | MP 25 | | 180K | 300K | 180R | 300PW | | 5000R | |
| | | MP 25D | | 180.2K | 300LK | 180.2LW | 300top | | 6000L | |
| | | | | 180KD | 300PK | 180.LW | 400W | | 7000 | |
| | | | | 180LK | 400K | ELX/SWIFT | | | | |
| | | | | 180.2LK | | 185 | | | | |
| | | | | | | 240 | | | | |
| | | | | | | 240R | | | | |
| | | | | | | 250 | | | | |
| | | | | | | 260R | | | | |

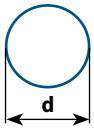
Subject to technical changes and errors!

***The strippers for machine group H/I have a different shape and dimension than the strippers of the other machine groups.**

## STANDARD TOOLS

# STANDARD ROUND TOOLS

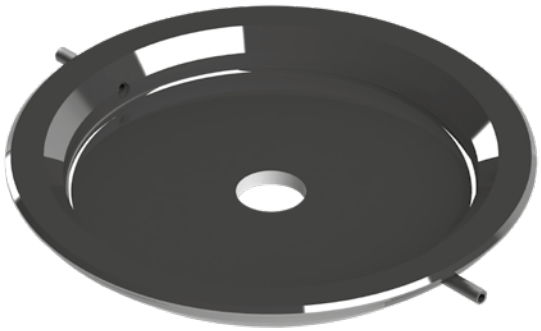
Punches | Strippers | Dies



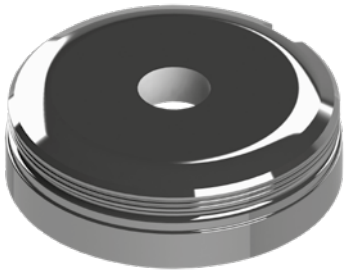

DIETZ systeme

| Punches | | |
|---|---|---|
| **Size** | **Range d** | **Art. no.** |
| 0 | 1.0 - 6.0 | 210 01 |
| 0 | 1.0 - 6.0* | 220 01.1 |
| 0 | 6.1 - 10.5* | 220 01.2 |
| 1 | - 30.5 | 230 01 |
| 2 | - 40.0 | 250 01.1 |
| 2 | - 60.0 | 250 01.2 |
| 2 | - 76.2 | 250 01.3 |
| 3 | - 105.0 | 260 01 |
| * Shaft diameter 10.5 mm | | |

| Strippers | | | |
|---|---|---|---|
| **Size** | **Range d** | **Art. no.** | **Group** |
| 2 | - 78.2 | 280 04 | H/I |
| 2 | - 78.2 | 250 04 | A-G |
| 3 | - 106.0 | 260 04 | C/D / E/G |
| Strippers for scratch-free machining, see page 7.3<br>Strippers for Boschert machines, see page 2.6 | | | |



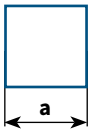
| Dies | | |
|---|---|---|
| **Size** | **Range d** | **Art. no.** |
| 1 | - 32.0 | 210 10 |
| 2 | - 77.0 | 250 10 |
| 3 | - 107.0 | 260 10 |



Heavy duty punches and dies, see page 2.5
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, die shims, tooling cartridges, refer to pages 7.1 and 7.2

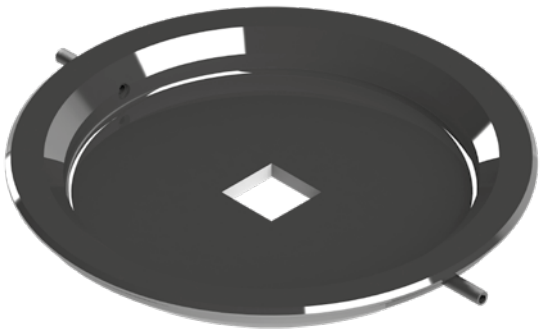
# STANDARD SQUARE TOOLS

Punches | Strippers | Dies



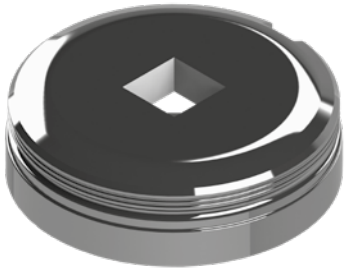

DIETZ systeme

| Punches | | |
|---|---|---|
| **Size** | **Range a** | **Art. no.** |
| 0 | 1.0 - 4.2 | 221 01 QU |
| 0 | 4.3 - 7.4 | 222 01 QU |
| 1 | - 21.0 | 223 01 QU |
| 2 | - 28.0 | 225 01.1 QU |
| 2 | - 35.0 | 225 01.2 QU |
| 2 | - 42.0 | 225 01.3 QU |
| 2 | - 50.8 | 225 01.4 QU |
| 3 | - 72.0 | 226 01 QU |



| Strippers | | | |
|---|---|---|---|
| **Size** | **Range a** | **Art. no.** | **Group** |
| 2 | - 55.0 | 228 04 QU | H/I |
| 2 | - 55.0 | 225 04 QU | A-G |
| 3 | - 74.0 | 226 04 QU | C/D / E/G |

Strippers for scratch-free machining, see page 7.3
Strippers for Boschert machines, see page 2.6

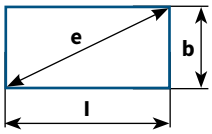


| Dies | | |
|---|---|---|
| **Size** | **Range a** | **Art. no.** |
| 1 | - 22.0 | 221 10 QU |
| 2 | - 52.0 | 225 10 QU |
| 3 | - 73.0 | 226 10 QU |

Heavy Duty Tools punches and dies, see page 2.5
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# STANDARD RECTANGLE TOOLS

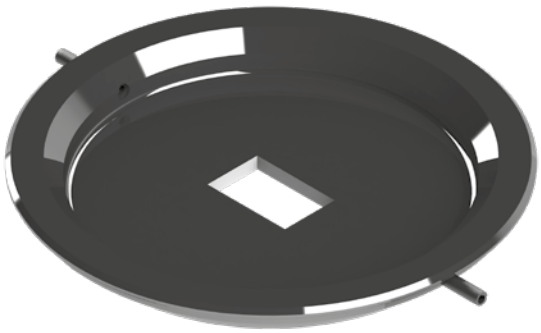
Punches | Strippers | Dies



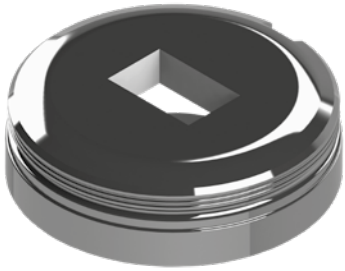

DIETZ systeme

| Punches | | |
|---|---|---|
| **Size** | **Range e** | **Art. no.** |
| 0 | 1.0 - 6.0 | 221 01 RE |
| 0 | 6.1 - 10.5 | 222 01 RE |
| 1 | - 30.5 | 223 01 RE |
| 2 | - 40.0 | 225 01.1 RE |
| 2 | - 50.8 | 225 01.2 RE |
| 2 | - 60.0 | 225 01.3 RE |
| 2 | - 76.2 | 225 01.4 RE |
| 3 | - 105.0 | 226 01 RE |

| Strippers | | | |
|---|---|---|---|
| **Size** | **Range e** | **Art. no.** | **Group** |
| 2 | - 78.2 | 228 04 RE | H/I |
| 2 | - 78.2 | 225 04 RE | A-G |
| 3 | - 106.0 | 226 04 RE | C/D / E/G |
| Strippers for scratch-free machining, see page 7.3<br>Strippers for Boschert machines, see page 2.6 | | | |



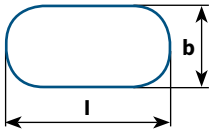
| Dies | | |
|---|---|---|
| **Size** | **Range e** | **Art. no.** |
| 1 | - 32.0 | 221 10 RE |
| 2 | - 77.0 | 225 10 RE |
| 3 | - 107.0 | 226 10 RE |



Heavy Duty Tools punches and dies, see page 2.5
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

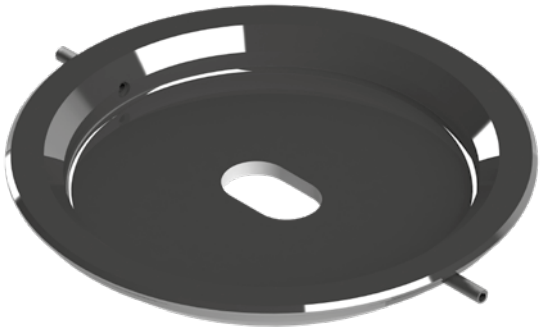
# STANDARD OBLONG TOOLS

Punches | Strippers | Dies



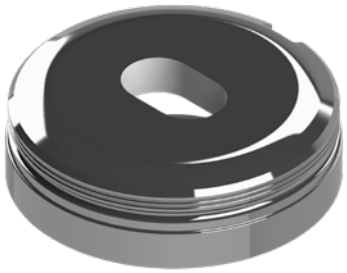

DIETZ systeme

| Punches | | |
|---|---|---|
| **Size** | **Range l** | **Art. no.** |
| 0 | 1.0 - 6.0 | 221 01 LL |
| 0 | 6.1 - 10.5 | 222 01 LL |
| 1 | - 30.5 | 223 01 LL |
| 2 | - 40.0 | 225 01.1 LL |
| 2 | - 50.0 | 225 01.2 LL |
| 2 | - 60.0 | 225 01.3 LL |
| 2 | - 76.2 | 225 01.4 LL |
| 3 | - 105.0 | 226 01 LL |



| Strippers | | | |
|---|---|---|---|
| **Size** | **Range l** | **Art. no.** | **Group** |
| 2 | - 78.2 | 228 04 LL | H/I |
| 2 | - 78.2 | 225 04 LL | A-G |
| 3 | - 106.0 | 226 04 LL | C/D / E/G |

Strippers for scratch-free machining, see page 7.3
Strippers for Boschert machines, see page 2.6

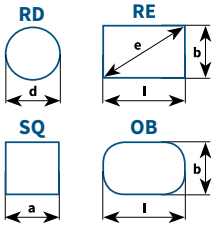


| Dies | | |
|---|---|---|
| **Size** | **Range l** | **Art. no.** |
| 1 | - 32.0 | 221 10 LL |
| 2 | - 77.0 | 225 10 LL |
| 3 | - 107.0 | 226 10 LL |

Heavy duty punches and dies, see page 2.5
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

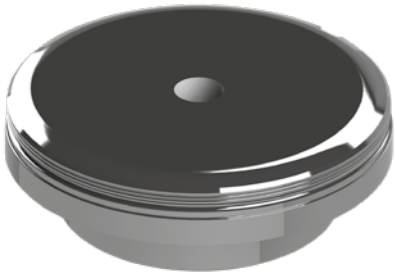
# HEAVY DUTY TOOLS

Punches | Dies




DIETZ systeme

| Punches | |
|---|---|
| **Range** | **Art. no.** |
| d (- 40) | 230 01 VS DR |
| a (-28) | 223 01 VS QU |
| d (-40) | 223 01 VS RE |
| l (-40) | 223 01 VS LL |



| Dies | |
|---|---|
| **Range** | **Art. no.** |
| d (- 62) | 250 10 VS DR |
| a (-43) | 225 10 VS QU |
| d (-62) | 225 10 VS RE |
| l (-62) | 225 10 VS LL |

For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# STANDARD TOOLS

PU strippers

Version 1

| Without shape | | |
|---|---|---|
| **Version** | **Punch version** | **Range** |
| 1 | Flat size 0 | - 6.00 mm |
| 1 | Flat size 0 | - 10.50 mm |
| 1 | Flat | - 12.00 mm |
| 1 | Whisper | - 12.00 mm |
| 2 | Flat | - 30.50 mm |
| 2 | Whisper | - 30.50 mm |
| 3 | Flat | - 48.00 mm |
| 3 | Whisper | - 48.00 mm |
| | Flat/ Whisper | > 48.00 mm |

Version 2

| Round | | |
|---|---|---|
| **Version** | **Punch version** | **Range** |
| 1 | Flat size 0 | - 6.00 mm |
| 1 | Flat size 0 | - 10.50 mm |
| 1 | Flat | - 12.00 mm |
| 1 | Whisper | - 12.00 mm |
| 2 | Flat | - 30.50 mm |
| 2 | Whisper | - 30.50 mm |
| 3 | Flat | - 48.00 mm |
| 3 | Whisper | - 48.00 mm |
| | Flat/ Whisper | > 48.00 mm |

Version 3

| Shape | | |
|---|---|---|
| **Version** | **Punch version** | **Range** |
| 1 | Flat size 0 | - 6.00 mm |
| 1 | Flat size 0 | - 10.50 mm |
| 1 | Flat | - 12.00 mm |
| 1 | Whisper | - 12.00 mm |
| 2 | Flat | - 30.50 mm |
| 2 | Whisper | - 30.50 mm |
| 3 | Flat | - 48.00 mm |
| 3 | Whisper | - 48.00 mm |
| | Flat/ Whisper | > 48.00 mm |

Tool lengths:
Flat = length 74.00 mm
Whisper = length 77.00 mm
Flat size 0 = length 59.50 mm

## SPECIAL SHAPES

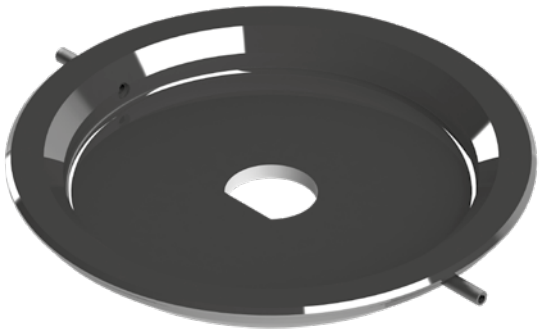
# SPECIAL SHAPES CATEGORY 1

Punches | Strippers | Dies

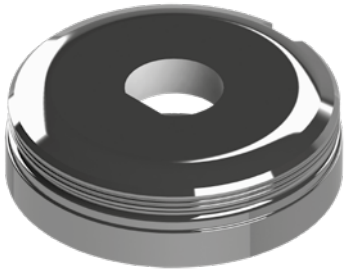


| Punches | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 0 A | 1.00 - 6.00 | 221 01.xx |
| 0 B | 6.01 - 10.5 | 222 01.xx |
| 1 | - 30.5 | 223 01.xx |
| 2 A | - 40.0 | 225 01.1.xx |
| 2 B | - 50.8 | 225 01.2.xx |
| 2 C | - 60.0 | 225 01.3.xx |
| 2 D | - 76.2 | 225 01.4.xx |
| 3 | - 105.0 | 226 01.xx |

| Strippers | | | |
|---|---|---|---|
| **Size** | **Range** | **Art. no.** | **Group** |
| 2 | - 78.2 | 228 04.xx | H/I |
| 2 | - 78.2 | 225 04.xx | A-G |
| 3 | - 106.0 | 226 04.xx | C/D / E/G |
| Strippers for scratch-free machining, see page 7.3<br>PU strippers on request | | | |



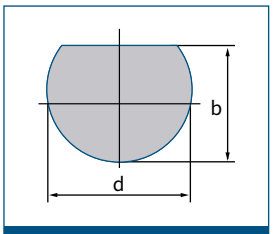
| Dies | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 1 | - 32.0 | 221 10.xx |
| 2 | - 77.0 | 225 10.xx |
| 3 | - 107.0 | 226 10.xx |



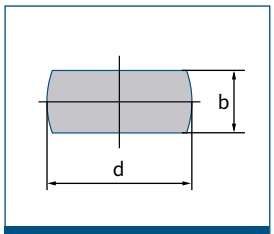
Heavy duty punches and dies available on request
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# SPECIAL SHAPES CATEGORY 1

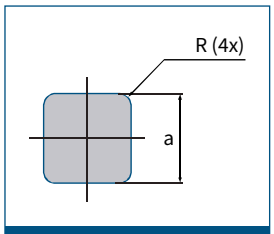
Shapes Category 1



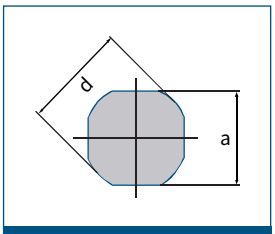

SF 06



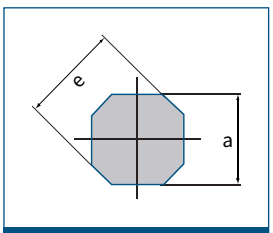

SF 07



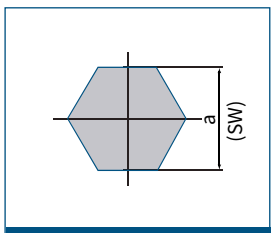

SF 10



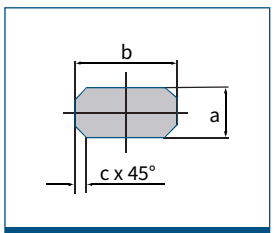

SF 11



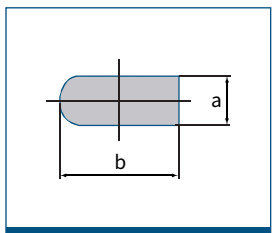

SF 12




SF 13




SF 30




SF 32

**Example:**

**Punch size 1, special shape SF 08**

**Article number: 223 01.08**

The standard slot position for special shapes is 0°

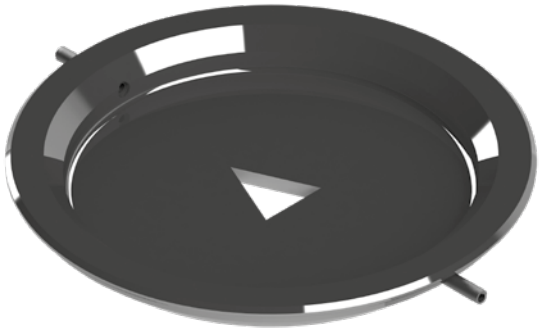
# SPECIAL SHAPES CATEGORY 2

Punches | Strippers | Dies

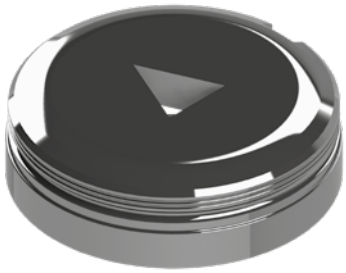


| Punch | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 0 A | 1.00 -6.00 | 221 01.xx |
| 0 B | 6.01 - 10.5 | 222 01.xx |
| 1 | - 30.5 | 223 01.xx |
| 2 A | - 40.0 | 225 01.1.xx |
| 2 B | - 50.8 | 225 01.2.xx |
| 2 C | - 60.0 | 225 01.3.xx |
| 2 D | - 76.2 | 225 01.4.xx |
| 3 | - 105.0 | 226 01.xx |

| Stripper | | | |
|---|---|---|---|
| **Size** | **Range** | **Art. no.** | **Group** |
| 2 | - 78.2 | 228 04.xx | H/I |
| 2 | - 78.2 | 225 04.xx | A-G |
| 3 | - 106.0 | 226 04.xx | C/D / E/G |
| Strippers for scratch-free machining, see page 7.3<br>PU strippers on request | | | |



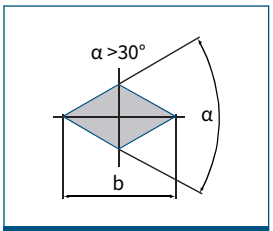
| Dies | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 1 | - 31.0 | 221 10.xx |
| 2 | - 77.0 | 225 10.xx |
| 3 | - 107.0 | 226 10.xx |



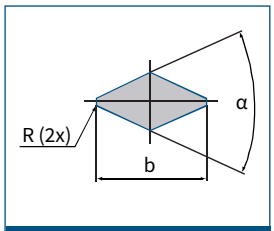
Please, include drawings with your inquiry (DXF or STEP). Heavy duty punches and dies available on request.
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# SPECIAL SHAPES CATEGORY 2

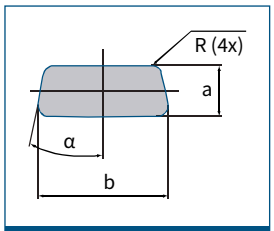
Shapes Category 2



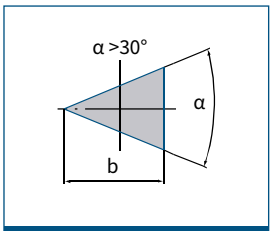

SF 16



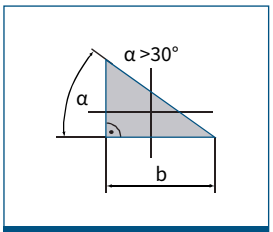

SF 17



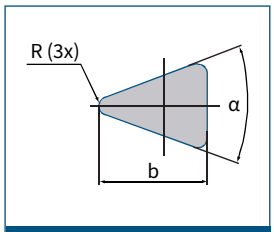

SF 18



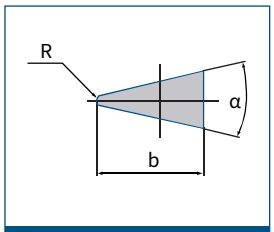

SF 20



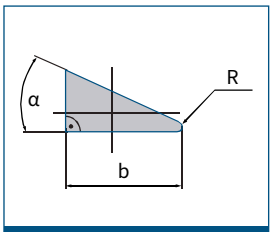

SF 21



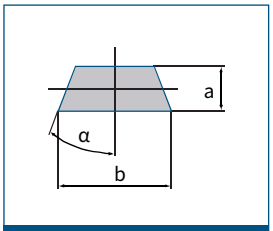

SF 22



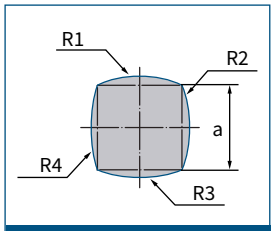

SF 23



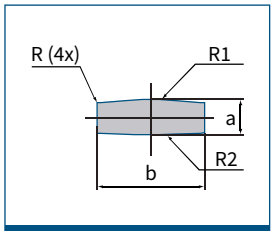

SF 24



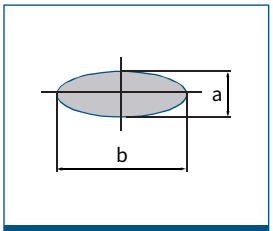

SF 25



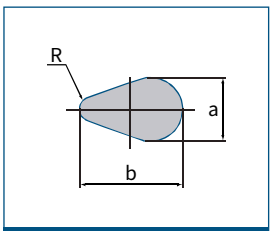

SF 26



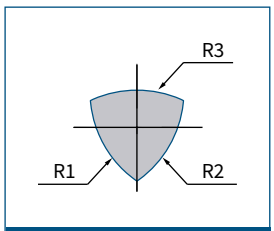

SF 29




SF 36




SF 39




SF 41

**Example:**

**Punch size 1, special shape SF 16:**

**Article number: 223 01.16**

The standard slot position for special shapes is 0°

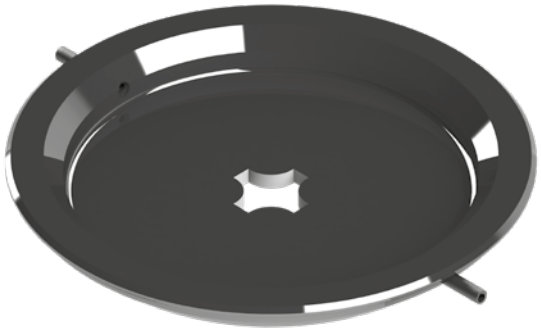
# SPECIAL SHAPES CATEGORY 3

Punches | Strippers | Dies

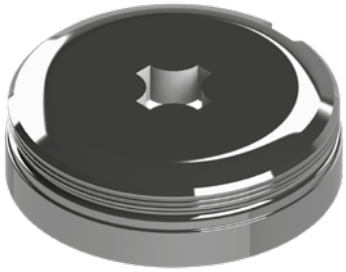


| Punch | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 0 A | 1.00 -6.00 | 221 01.xx |
| 0 B | 6.01 - 10.5 | 222 01.xx |
| 1 | - 30.5 | 223 01.xx |
| 2 A | - 40.0 | 225 01.1.xx |
| 2 B | - 50.8 | 225 01.2.xx |
| 2 C | - 60.0 | 225 01.3.xx |
| 2 D | - 76.2 | 225 01.4.xx |
| 3 | - 105.0 | 226 01.xx |

| Stripper | | | |
|---|---|---|---|
| **Size** | **Range** | **Art. no.** | **Group** |
| 2 | - 78.2 | 228 04.xx | H/I |
| 2 | - 78.2 | 225 04.xx | A-G |
| 3 | - 106.0 | 226 04.xx | C/D / E/G |
| Strippers for scratch-free machining, see page 7.3<br>PU strippers on request | | | |



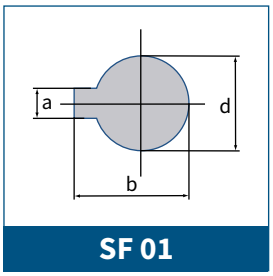
| Dies | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 1 | - 32.0 | 221 10.xx |
| 2 | - 77.0 | 225 10.xx |
| 3 | - 107.0 | 226 10.xx |



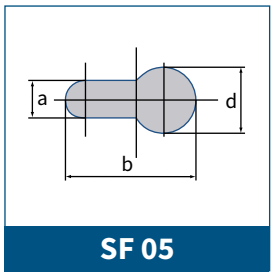
Please, include drawings with your inquiry (DXF or STEP). Heavy duty punches and dies available on request.
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.4
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# SPECIAL SHAPES CATEGORY 3

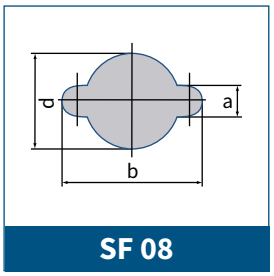
Shapes Category 3



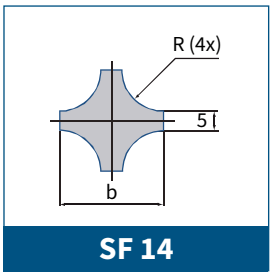

SF 01



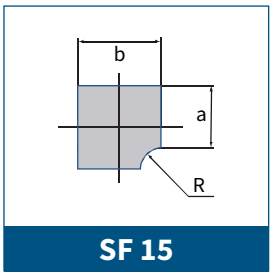

SF 05



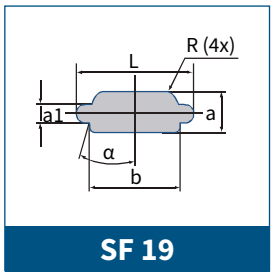

SF 08



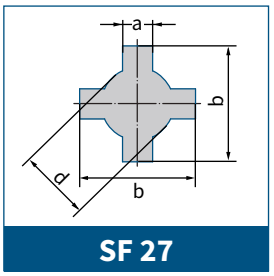

SF 14



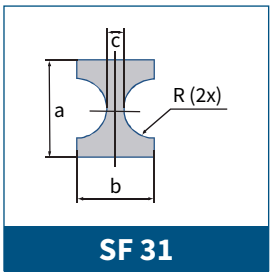

SF 15



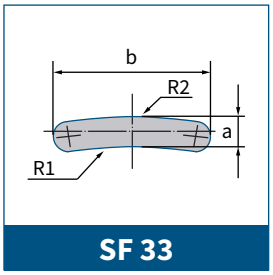

SF 19



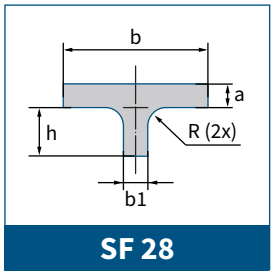

SF 27



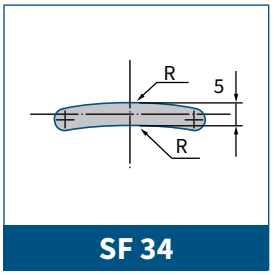

SF 31



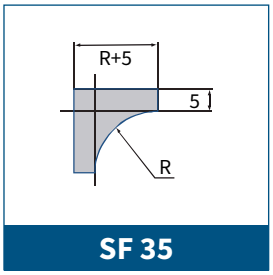

SF 33



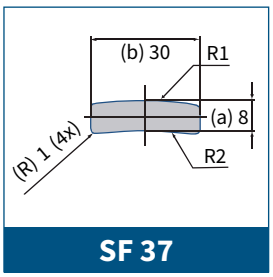

SF 28



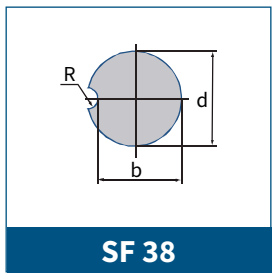

SF 34



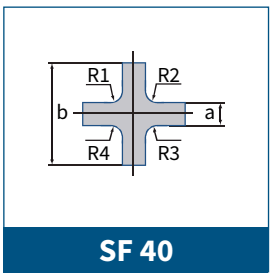

SF 35




SF 37




SF 38




SF 40

**Example:**

**Punch size 1, special shape SF 14:**

**Article number: 223 01.14**

The standard slot position for special shapes is 0°

# SPECIAL SHAPES CATEGORY 4

Punches | Strippers | Dies



| Punch | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 0 | - 10.5 | 221 01.xx |
| 1 | 10.6 - 30.5 | 223 01.xx |
| 2 | 30.6 - 76.2 | 225 01.xx |
| 3 | - 105.0 | 226 01.xx |

| Stripper | | | |
|---|---|---|---|
| **Size** | **Range** | **Art. no.** | **Group** |
| 2 | - 78.2 | 228 04.xx | H/I |
| 2 | - 78.2 | 225 04.xx | A-G |
| 3 | - 106.0 | 226 04.xx | C/D / E/G |
| Strippers for scratch-free machining, see page 7.3. PU strippers on request | | | |

| Dies | | |
|---|---|---|
| **Size** | **Range** | **Art. no.** |
| 1 | - 32.0 | 221 10.xx |
| 2 | - 77.0 | 225 10.xx |
| 3 | - 107.0 | 226 10.xx |

Please, include drawings with your inquiry (DXF or STEP). Heavy duty punches and dies available on request.
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

## SLITTING TOOLS

# SLITTING TOOL

With interchangeable inserts 5 x 30

| Complete tool | |
|---|---|
| **Art. no.** | **Description** |
| 223 40-1 | Rectangle |
| 223 40-2 | Oblong |
| 223 40-3 | Trapezoid |
| 223 40-4 | Double trapezoid |

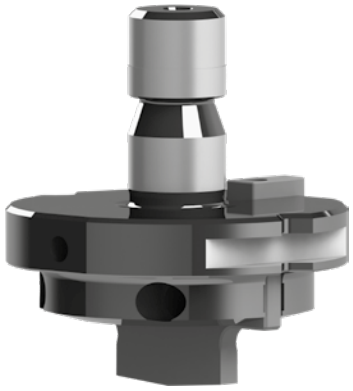
| Adapter for punch insert | |
|---|---|
| **Art. no.** | **Description** |
| 223 63-O | Punch holder |

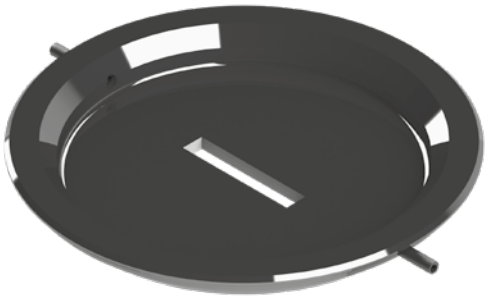
| Punch insert | |
|---|---|
| **Art. no.** | **Description** |
| 223 60-RE | Rectangle |
| 223 60-LL | Oblong |
| 223 60-MT | Trapezoid |
| 223 60-MS | Double trapezoid |

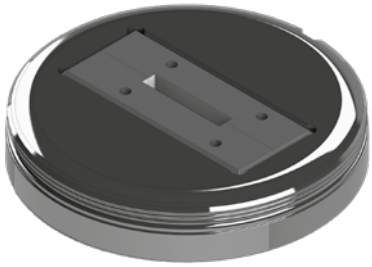
| Stripper | |
|---|---|
| **Art. no.** | **Description** |
| 228 04 RE / LL | Rectangle/ oblong |
| 228 04 MT / MS | Trapezoid / double trapezoid |

| Die insert | |
|---|---|
| **Art. no.** | **Shape** |
| 223 70-RE | Rectangle |
| 223 70-LL | Oblong |
| 223 70-MT | Trapezoid |
| 223 70-MS | Double trapezoid |

| Adapter for die insert | |
|---|---|
| **Art. no.** | **Insert** |
| 223 20-O | Die Adapter |



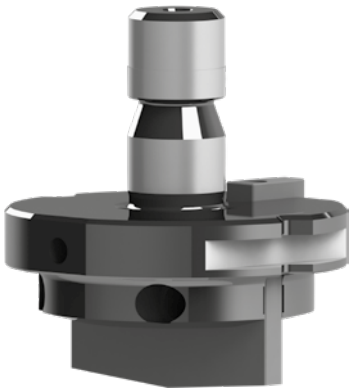


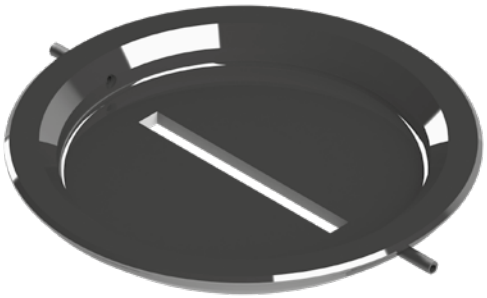


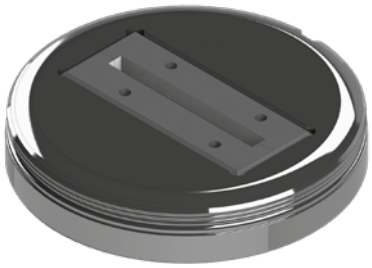
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# SLITTING TOOL

With interchangeable inserts 5 x 56







| Complete tool | |
|---|---|
| **Art. no.** | **Description** |
| 223 41-1 | Rectangle |
| 223 41-2 | Oblong |
| 223 41-3 | Trapezoid |
| 223 41-4 | Double trapezoid |

| Adapter for punch insert | |
|---|---|
| **Art. no.** | **Description** |
| 223 63-O | Punch holder |

| Punch insert | |
|---|---|
| **Art. no.** | **Description** |
| 223 61-RE | Rectangle |
| 223 61-LL | Oblong |
| 223 61-MT | Trapezoid |
| 223 61-MS | Double trapezoid |

| Stripper | |
|---|---|
| **Art. no.** | **Description** |
| 228 04 RE / LL | Rectangle/ oblong |
| 228 04 MT / MS | Trapezoid / double trapezoid |

| Die insert | |
|---|---|
| **Art. no.** | **Shape** |
| 223 71-RE | Rectangle |
| 223 71-LL | Oblong |
| 223 71-MT | Trapezoid |
| 223 71-MS | Double trapezoid |

| Adapter for die insert | |
|---|---|
| **Art. no.** | **Insert** |
| 223 21-O | Die Adapter |

For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# SLITTING TOOL

With interchangeable inserts 5 x 76.2

| Complete tool | |
|---|---|
| **Art. no.** | |
| 223 42-1 | Rectangle |
| 223 42-2 | Oblong |
| 223 42-3 | Trapezoid |
| 223 42-4 | Double trapezoid |

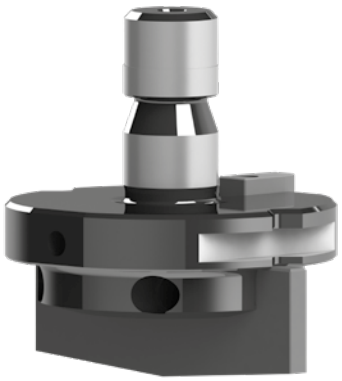
| Adapter for punch insert | |
|---|---|
| **Art. no.** | |
| 223 63-O | Punch holder |

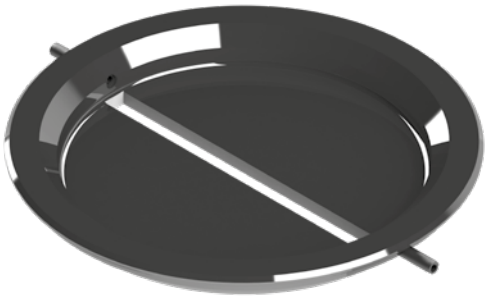
| Punch insert | |
|---|---|
| **Art. no.** | |
| 223 62-RE | Rectangle |
| 223 62-LL | Oblong |
| 223 62-MT | Trapezoid |
| 223 62-MS | Double trapezoid |

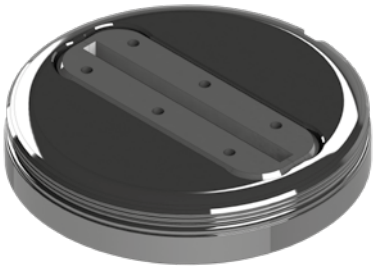
| Stripper | |
|---|---|
| **Art. no.** | |
| 228 04 RE / LL | Rectangle/ oblong |
| 228 04 MT / MS | Trapezoid / double trapezoid |

| Die insert | |
|---|---|
| **Art. no.** | **Shape** |
| 223 72-RE | Rectangle |
| 223 72-LL | Oblong |
| 223 72-MT | Trapezoid |
| 223 72-MS | Double trapezoid |

| Adapter for die insert | |
|---|---|
| **Art. no.** | **Insert** |
| 223 22-O | Die Adapter |







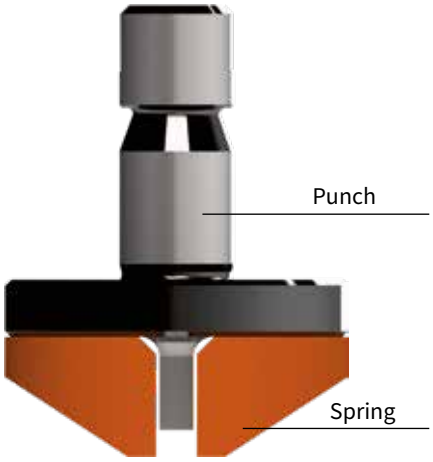
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

# SLITTING TOOLS

Close to form

| Slitting tool, 5 x 30, Rectangle | |
|---|---|
| **Art. no.** | **Description** |
| 223 01<br>HL OK W | Slitting punch without spring element |
| 223 80 | Spring element, incl. bolts |
| 221 10 | Die |

| Slitting tool, 5 x 56, Rectangle | |
|---|---|
| **Art. no.** | **Description** |
| 225 01<br>HL OK W | Slitting punch without spring element |
| 224 80 | Spring element, incl. bolts |
| 225 10 | Die |

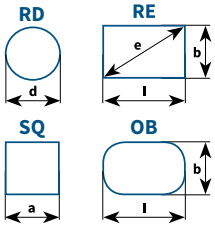



| Slitting tool, 5 x 76.2, Rectangle | |
|---|---|
| **Art. no.** | **Description** |
| 225 01-1<br>HL OK W | Slitting punch without spring element |
| 225 80 | Spring element, incl. bolts |
| 225 10 | Die |

| Spare parts for spring elements 5 x 30 \| 5 x 56 \| 5 x 76,2 | |
|---|---|
| **Art. no.** | **Description** |
| 240 02-S | Bolt for spring element |

For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

## MULTITOOL

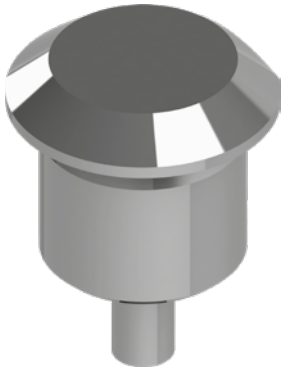



DIETZ systeme

# 5-Station Multitool

Range up to 16 mm

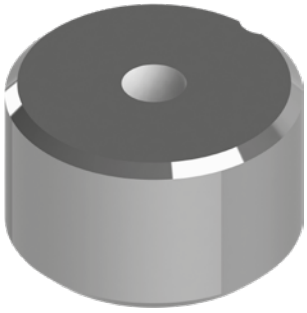
| Punches |
|---|
| Art. no. |
| 263 11 RD |
| 263 12 SQ |
| 263 12 RE |
| 263 12 OB |



**PM steel**

| Standard stripper |
|---|
| Art. no. |
| 263 04/1 |
| **Close-fit stripper** |
| 263 04/2 |

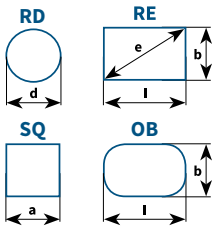
| Dies |
|---|
| Art. no. |
| 263 10 RD |
| 263 20 SQ |
| 263 20 RE |
| 263 20 OB |



**PM steel**



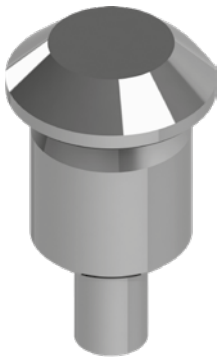
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2




DIETZ systeme

# 10-Station Multitool

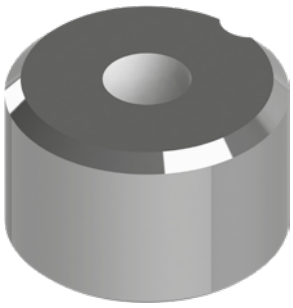
Range up to 10.5 mm



**PM steel**

| Punches |
|---|
| Art. no. |
| 264 11 DR |
| 264 12 QU |
| 264 12 RE |
| 264 12 LL |

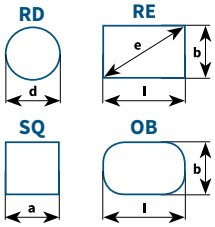
| Standard stripper |
|---|
| Art. no. |
| 264 04/1 |
| **Close-fit stripper** |
| 264 04/2 |



**PM steel**

| Dies |
|---|
| Art. no. |
| 264 10 DR |
| 264 20 QU |
| 264 20 RE |
| 264 20 LL |

For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

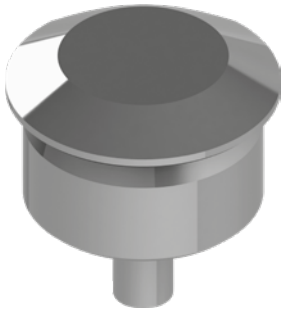



DIETZ systeme

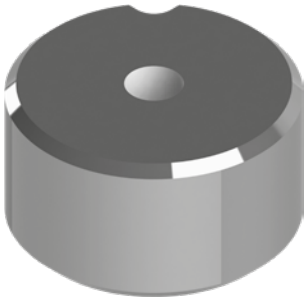
# 4-Station Multitool

Range up to 16 mm

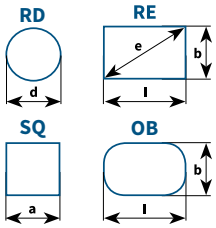
| Punches |
|---|
| Art. no. |
| 261 11 DR |
| 261 12 QU |
| 261 12 RE |
| 261 12 LL |



| Dies |
|---|
| Art. no. |
| 261 10 DR |
| 261 20 QU |
| 261 20 RE |
| 261 20 LL |



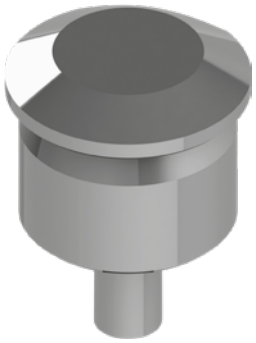
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2



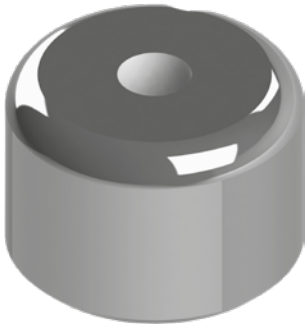

DIETZ systeme

# 6-Station Multitool

Range up to 10.5 mm



| Punches |
|---|
| Art. no. |
| 262 11 DR |
| 262 12 QU |
| 262 12 RE |
| 262 12 LL |



| Dies |
|---|
| Art. no. |
| 262 10 DR |
| 262 20 QU |
| 262 20 RE |
| 262 20 LL |

For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

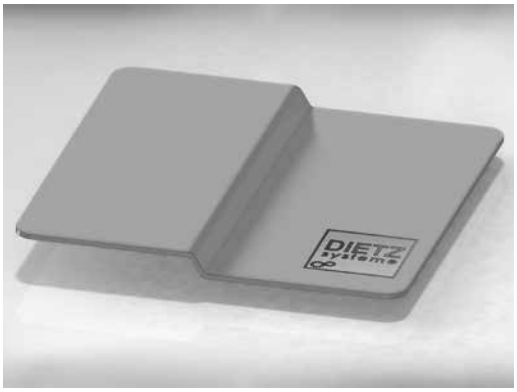
## SPECIAL TOOL ORDER FORMS

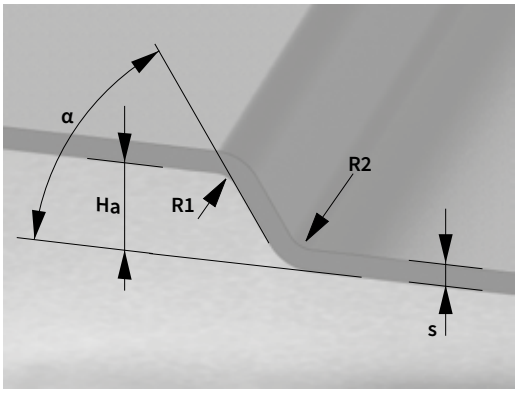
# SPECIAL TOOL ORDER FORM

Continuous offset tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 011 | |
| | | | downwards | 012 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Offset height Ha | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | 5.0 | 50 | |
| | | | Special dimension (see below) | XX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **012** | Type, bottom = **02** | Material, Carbon steel = **ST** |
Sheet thickness s, 1.0 = **10** | Offset height Ha, 2.5 = **25**
**This creates following part number: T 012 02 ST 10 25**

## Tool information

**Tool design rigid incl. alignment ring**

**Standard angle α** **45°**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Offset height Ha | mm | Angle α | ° |
| Radius R1 | mm | Radius R2 | mm |

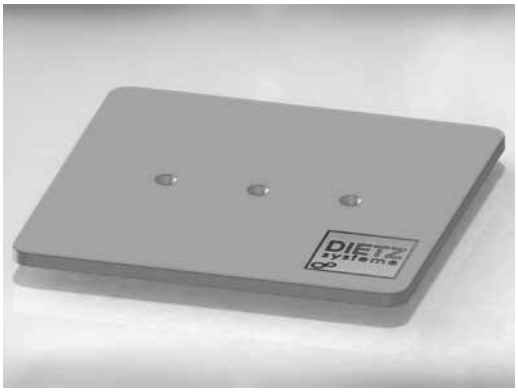
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

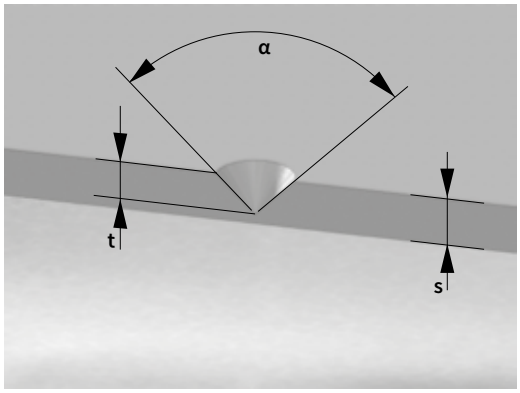
# SPECIAL TOOL ORDER FORM

Centre point

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 021 | |
| | | | downwards | 022 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Centre punch needle | 01 | |
| | | | Die | 02 | |
| | | | Replacement centres | 08 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet range | 0.8 - 6 mm (only for machine group I) | 08 | |
| | | | 0.8 - 3 mm | 30 | |
| | | | 3 - 6 mm | 60 | |
| | | | 6 - 8 mm | 80 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Angle α | 60° | 060 | |
| | | | 90° | 090 | |
| | | | 120° | 120 | |
| | | | Special dimension (see below) | XXX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **021** | Type, complete tool = **00** | Material, Carbon steel = **ST** | Sheet range, 0.8 - 3 mm = **30** | Angle α, 90° = **090**
**This creates following part number: T 021 00 ST 30 090**

## Tool information

**Tool design rigid incl. alignment ring**

**The centre punch depth is 0.3 - 0.8 mm, depending on sheet thickness**

**There are 4 standard versions:**
0.8 - 6 mm (only for machine group I)
0.8 - 3 mm
3 - 6 mm
6 - 8 mm

## Special dimensions

| Material | | Sheet range | mm |
|---|---|---|---|
| Centre punch depth t | mm | Angle α | ° |

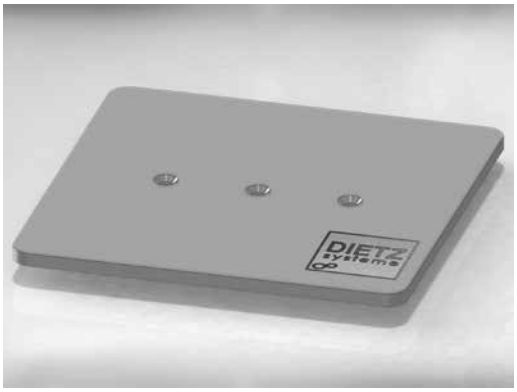
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

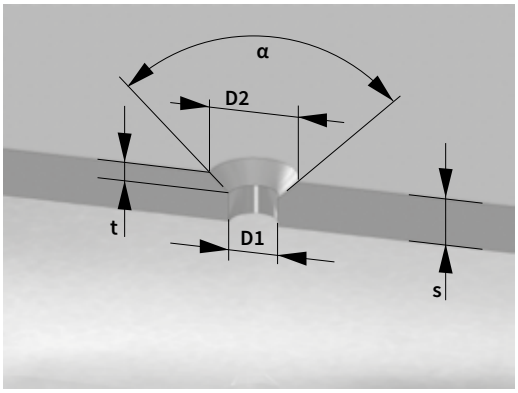
# SPECIAL TOOL ORDER FORM

Spring-loaded countersink tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 031 | |
| | | | downwards | 032 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for top | 03 | |
| | | | Insert for bottom | 09 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | 5.0 | 50 | |
| | | | 6.0 | 60 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Thread size | M2.5 | 025 | |
| | | | M3 | 030 | |
| | | | M4 | 040 | |
| | | | M5 | 050 | |
| | | | M6 | 060 | |
| | | | M8 | 080 | |
| | | | Special dimension (see below) | XXX | |
| | 7. | Countersink Version | AF | F | |
| | | | AM | M | |
| | 8. | Pilot | without pilot | 0 | |
| | | | with pilot | 1 | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **031** | Type, complete tool = **00** |
Material, Carbon steel = **ST** | Sheet thickness s, 1.0 = **10** |
Thread size, M3 = **030** | Countersink, AF = **F** |
Pilot, without Pilot = **0**

**This creates following part number:**

**T 031 00 ST 10 030 F 0**

## Tool information

**Tool design incl. integr. alignment ring and spring-loaded metal stripper**

**Countersink depth depends on material, sheet thickness and machine model**

**Imperial thread sizes on request**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Diameter D1 | mm | Diameter D2 | mm |
| Countersink depth t | mm | Angle α | ° |

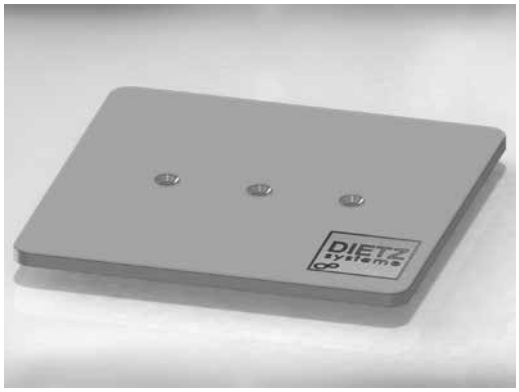
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

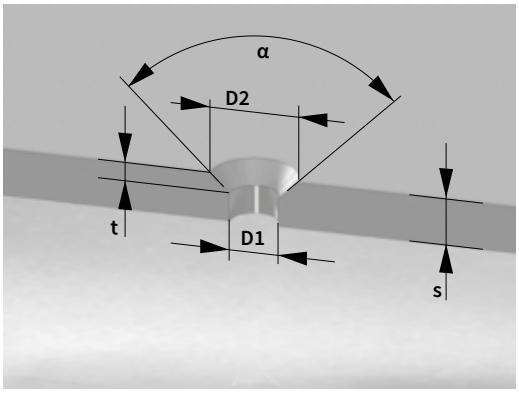
# SPECIAL TOOL ORDER FORM

Rigid countersink tool with PU stripper

DIETZ systeme

| | | | | | |
|---|---|---|---|---|---|
| Mark with “X” | | | | | |
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | downwards | 042 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | 5.0 | 50 | |
| | | | 6.0 | 60 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Thread size | M2.5 | 025 | |
| | | | M3 | 030 | |
| | | | M4 | 040 | |
| | | | M5 | 050 | |
| | | | M6 | 060 | |
| | | | M8 | 080 | |
| | | | Special dimension (see below) | XXX | |
| | 7. | Countersink version | AF | F | |
| | | | AM | M | |
| | 8. | Pilot | without pilot | 0 | |
| | | | with ilot | 1 | |






**Example:** Trumpf Tool System = **T**
Forming direction, downwards = **042** | Type, complete tool = **00** |
Material, Carbon steel = **ST** | Sheet thickness s, 1.0 = **10** |
Thread size, M3 = **030** | Countersink, AF = **F** |
Pilot, without Pilot = **0**
**This creates following part number:**
**T 042 00 ST 10 030 F 0**

## Tool information

**Tool design incl. alignment ring**

**Countersink depth depends on material, sheet thickness and machine model**

**Imperial thread sizes on request**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Diameter D1 | mm | Diameter D2 | mm |
| Countersink depth t | mm | Angle α | ° |

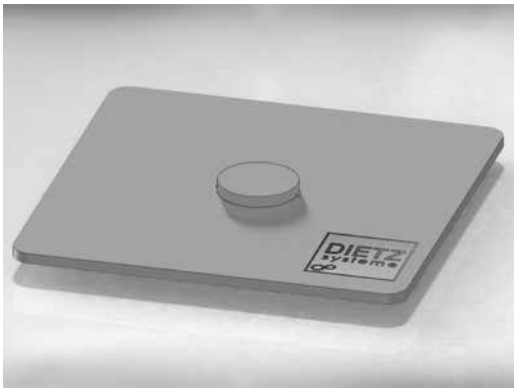
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

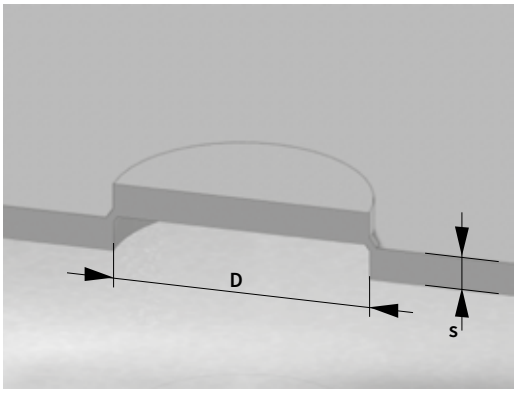
# SPECIAL TOOL ORDER FORM

Knock-out tool - round

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 051 | |
| | | | downwards | 052 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Replacement for top | 03 | |
| | | | Replacement for bottom | 04 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Diameter D | 15.0 | 150 | |
| | | | 20.0 | 200 | |
| | | | 25.0 | 250 | |
| | | | 30.0 | 300 | |
| | | | 35.0 | 350 | |
| | | | 40.0 | 400 | |
| | | | 45.0 | 450 | |
| | | | Special dimension (see below) | XXX | |
| | 7. | Number of connections | 2 | 2 | |
| | | | 3 | 3 | |
| | | | 4 | 4 | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **051** | Type, complete tool = **00** | Material, Carbon steel = **ST** |
Sheet thickness s, 1.0 = **10** | Diameter D, 15.0 = **150** | Number of connections = **2**
**This creates following part number: T 051 00 ST 10 150 2**

## Tool information

**Tool design incl. integr. alignment ring**

**Other diameters on request**

## Special dimensions

| Material | | Sheet thickness s | mm |
|---|---|---|---|
| Diameter D | mm | | |

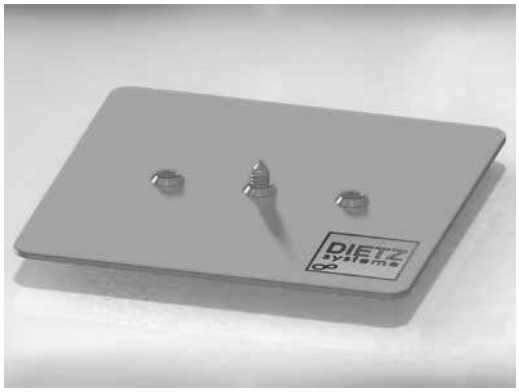
Please include drawings with your inquiry (DXF or STEP). Special contours (shape) on request
Please use the corresponding table to indicate special dimensions.

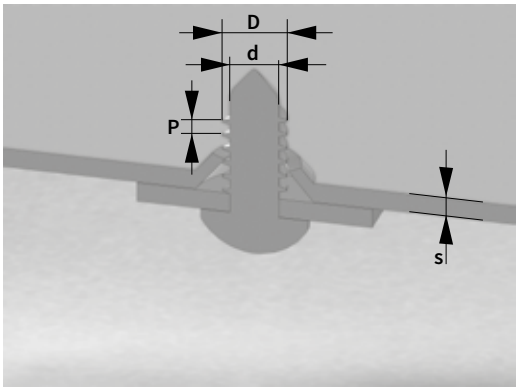
# SPECIAL TOOL ORDER FORM

Thread form tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 061 | |
| | | | downwards | 062 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for top | 09 | |
| | | | Insert for bottom | 03 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Thread size D | 3.3 | 033 | |
| | | | 3.5 | 035 | |
| | | | 3.9 | 039 | |
| | | | 4.2 | 042 | |
| | | | 4.8 | 048 | |
| | | | 5.5 | 055 | |
| | | | 6.3 | 063 | |
| | | | Special dimension (see below) | XXX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **061** | Type, complete tool = **00** | Material, Carbon steel = **ST** |
Sheet thickness s, 0.5 = **05** | Thread size D, 4.8 = **048**
**This creates following part number: T 061 00 ST 05 048**

## Tool information

**Tool design incl. alignment ring**

**A prepunch tool is required**
**(e.g. special shape 5, see page 3.6)**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Pitch P | mm | Thread size D | mm |
| Core diameter D | mm | | |

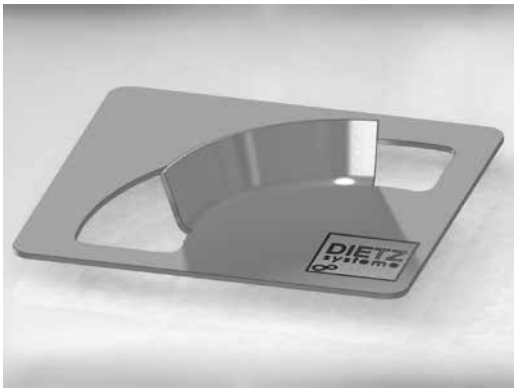
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

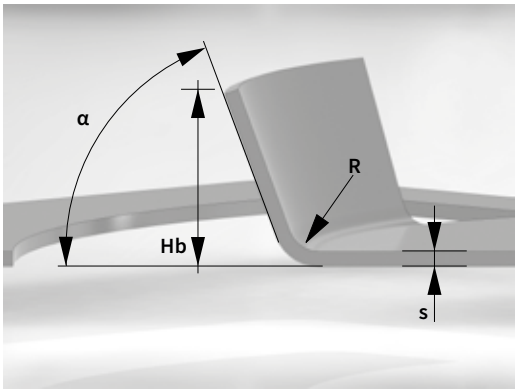
# SPECIAL TOOL ORDER FORM

Continuous bending tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 071 | |
| | | | downwards | 072 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Height Hb | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | 5.0 | 50 | |
| | | | 6.0 | 60 | |
| | | | 7.0 | 70 | |
| | | | Special dimension (see below) | XX | |
| | 7. | Angle α | 30° | 30 | |
| | | | 45° | 45 | |
| | | | 60° | 60 | |
| | | | 80° | 80 | |
| | | | Special dimension (see below) | XX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **071** | Type, complete tool = **00** |
Material, Carbon steel = **ST** |
Sheet thickness s, 1.0 = **10** | Height Hb, 2.5 = **25** | Angle α, 45° =45
**This creates following part number:**
**T 071 00 ST 10 25 45**

## Tool information

**Tool design incl. alignment ring**

**Flange height** **max. 7.00 mm**

**max. angle α** **80°**

## Special dimensions

| Material | | Sheet thickness s | mm |
|---|---|---|---|
| Height Hb | mm | Angle α | ° |
| Radius R | mm | | |

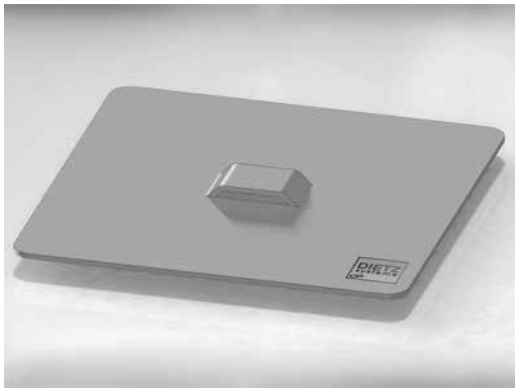
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

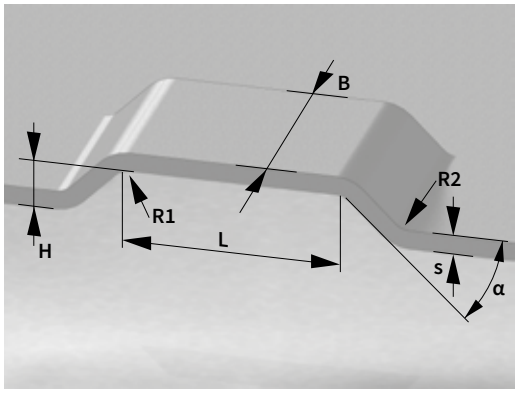
# SPECIAL TOOL ORDER FORM

Bridge tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 081 | |
| | | | downwards | 082 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for top | 09 | |
| | | | Insert for bottom | 03 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Please indicate dimensions L, B, H, in your correspondence | | | | | |






**Example:** Trumpf Tool System = **T**

Forming direction, upwards = **081** | Type, complete tool = **00** | Material, Carbon steel = **ST** | Sheet thickness s, 1.0 = **10**

**This creates following part number: T 081 00 ST 10**

## Tool information

**Tool design is available with separate or with integrated alignment ring (incl. internal ejector)**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Length L | mm | With W | mm |
| Height H | mm | Angle α | ° |
| Radius R1 | mm | Radius R2 | mm |

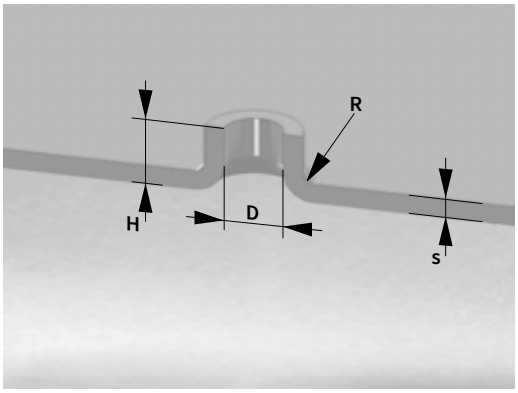
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

# SPECIAL TOOL ORDER FORM

Extrusion tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 091 | |
| | | | downwards | 092 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for bottom | 03 | |
| | | | Individual extrusion punch | 07 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 7. | Thread size | M2.5 | 025 | |
| | | | M3 | 030 | |
| | | | M4 | 040 | |
| | | | M5 | 050 | |
| | | | M6 | 060 | |
| | 8. | Thread shaping | Thread forming | gf | |
| | | | Thread Slitting | gs | |




**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **091** | Type, complete tool = **00** | Material, Carbon steel = **ST** | Sheet thickness s, 1.0 = **10** | Thread size G, M5 = **050 |**
Thread shaping, thread Slitting = **gs**
**This creates following part number:**
**T 091 00 ST 10 050 gs**

## Tool information

**Tool design incl. integrated alignment ring**

**Feasibility depends on material, sheet thickness & thread size**

**Forming direction upwards**
Thread size for thread forming — M2.5 - M10
Forming height H — 2 x sheet thickness s, max. 5.0 mm

**Forming direction downwards**
Thread size for thread forming — M2.5 - M6
Forming height H — 2 x sheet thickness s

**Imperial thread sizes on request**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Height H | mm | Diameter D | mm |
| Radius R | mm | | |

Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

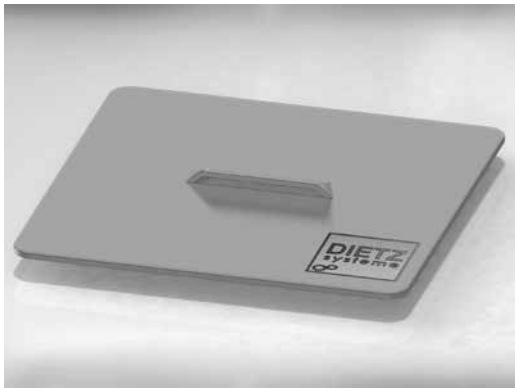
# SPECIAL TOOL ORDER FORM

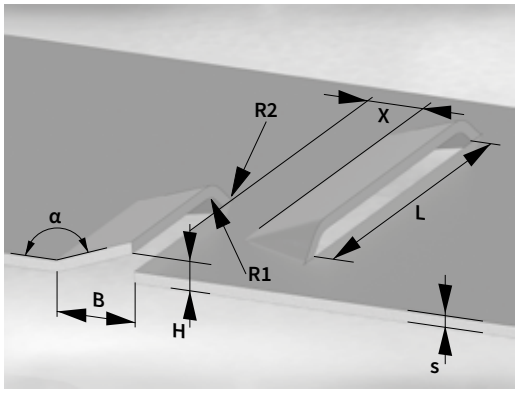
Louver tool

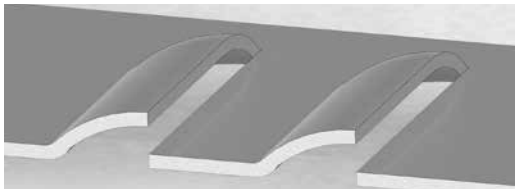
DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 101 | |
| | | | downwards | 102 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Louver insert for top | 03 | |
| | | | Louver insert for bottom | 04 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Louver shape | Shape A | A | |
| | | | Shape B | B | |
| | 7. | Dimensions | W=8/ H=3 | 083 | |
| | | | W=10/ H=4 | 104 | |
| | | | W=12/ H=5 | 125 | |
| | | | W=15/ H=6 | 156 | |
| | | | Special dimension (see below) | XX | |
| | 8. | Length L | 40.0 | 4 | |
| | | | 50.0 | 5 | |
| | | | 60.0 | 6 | |
| | | | Special dimension (see below) | X | |

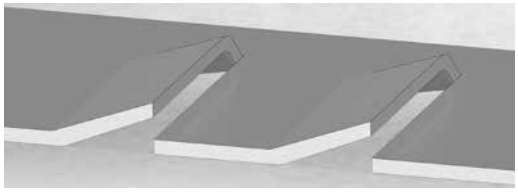
**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **101** | Type, complete tool = **00** | Material, Carbon steel = **ST** | Sheet thickness s, 1.0 = **10** | Louver shape, shape A = **A** | Dimensions, W=8/ H=3 = **083** | Length L, 40.0 = 4 | **This creates following part number: T 101 00 ST 10 A 083 4**





**Louver type A - round louver**



**Louver type B - Rectangle louver**

## Tool information

**Tool design incl. alignment ring**

**Feasibility depends on material, sheet thickness and louver size**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Length L | mm | With W | mm |
| Height H | mm | Angle α | ° |
| Distance X | mm | Radius R1 | mm |
| Radius R2 | mm | | |

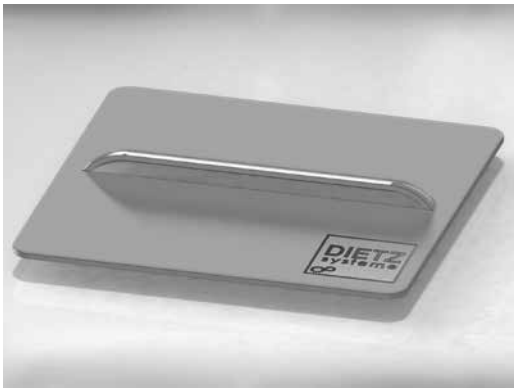
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

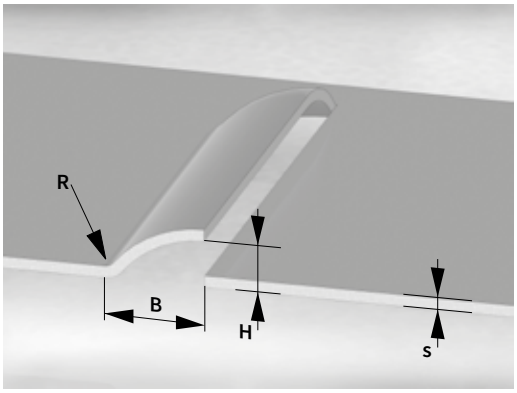
# SPECIAL TOOL ORDER FORM

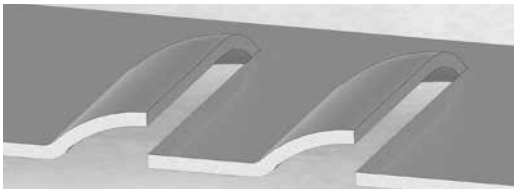
Continuous louver tool

DIETZ systeme

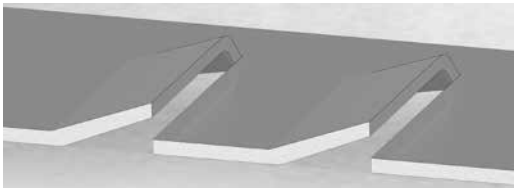
| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 111 | |
| | | | downwards | 112 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Louver bar for bottom | 06 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Louver shape | Shape A | A | |
| | | | Shape B | B | |
| | 7. | Dimensions | W=8/ H=3 | 083 | |
| | | | W=10/ H=4 | 104 | |
| | | | W=12/ H=5 | 125 | |
| | | | W=15/ H=6 | 156 | |
| | | | Special dimension (see below) | XX | |





**Louver type A - round louver**



**Louver type B - Rectangle louver**

**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **111** | type, complete tool = **00** | material, Carbon steel = **ST** |
Sheet thickness s, 1.0 = **10** | Louver shape, shape A = **A** | Dimensions, W=8/ H=3 = **083** |
**This creates following part number: T 111 00 ST 10 A 083**

## Tool information

**Tool design rigid incl. alignment ring**

**Feasibility depends on material, sheet thickness and louver size**

## Special dimensions

| Material | | Sheet thickness s | mm |
|---|---|---|---|
| Height H | mm | With W | mm |
| Radius R | mm | | |

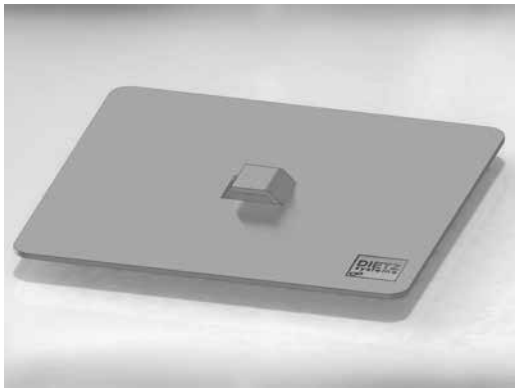
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

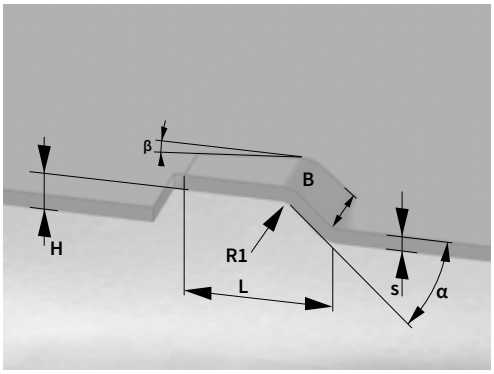
# SPECIAL TOOL ORDER FORM

Lance & Form tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 121 | |
| | | | downwards | 122 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for top | 09 | |
| | | | Insert for bottom | 03 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Please indicate dimensions L, B, H, in your correspondence | | | | | |






**Example:** Trumpf Tool System = **T**
Forming direction, downwards = **122** | Type, complete tool = **00** | Material, Carbon steel = **ST** |
Sheet thickness s, 1.5 = **15**
**This creates following part number: T 122 00 ST 15**

## Tool information

**Tool design incl. alignment ring**

**Parallel design on request (without angle ß)**

## Special dimensions

| | | | | |
|---|---|---|---|---|
| Material | | | Sheet thickness s | mm |
| Length L | | mm | With W | mm |
| Height H | | mm | Angle α | ° |
| Angle ß | | mm | Radius R1 | mm |
| Radius R2 | | mm | | |

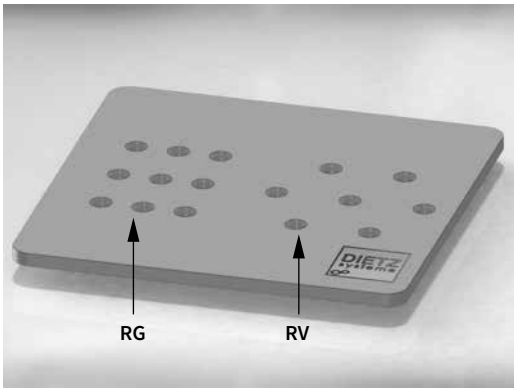
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

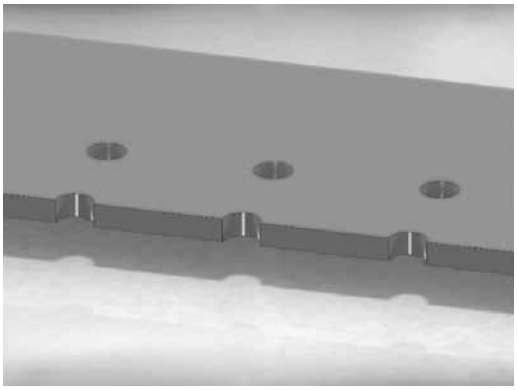
# SPECIAL TOOL ORDER FORM

Cluster tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Type | Complete tool | 241 00 | |
| | | | Punch | 241 01 | |
| | | | Die | 241 02 | |
| | 3. | Superordination | interchangeable inserts | WE | |
| | | | as a single piece | ST | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Shape | Round | RU | |
| | | | Square | QU | |
| | | | Rectangle | RE | |
| | | | Oblong | LL | |
| | | | Special dimension | XX | |
| | 6. | Holes per stroke | Quantity: | | |
| | 7. | Sheet thickness s | 0,5 | 05 | |
| | | | 0,8 | 08 | |
| | | | 1,0 | 10 | |
| | | | 1,5 | 15 | |
| | | | 2,0 | 20 | |
| | | | 2,5 | 25 | |
| | | | 3,0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Please include the hole pattern in your correspondence (drawing, sketch) | | | | | |



**Example:** Trumpf Tool System = **T**

AType, punch = **241 01** | Superordination, interchangeable inserts = **WE** |

Material, aluminium = **AL** | Rectangle = **RE** | Holes per stroke = **12**

Sheet thickness s, 1.0 = **10**

**This creates following part number: T 241 01 WE AL RE 12 10**

## Tool information

**Tool design incl. alignment ring**

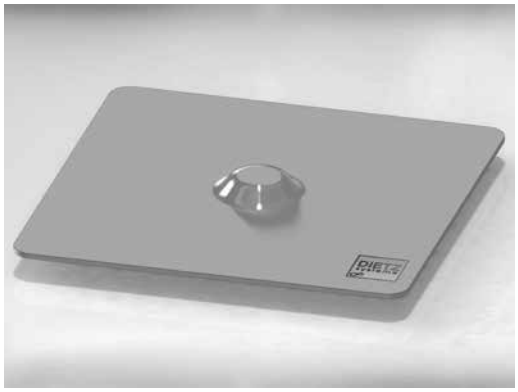
For all other cluster tools, please, provide drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

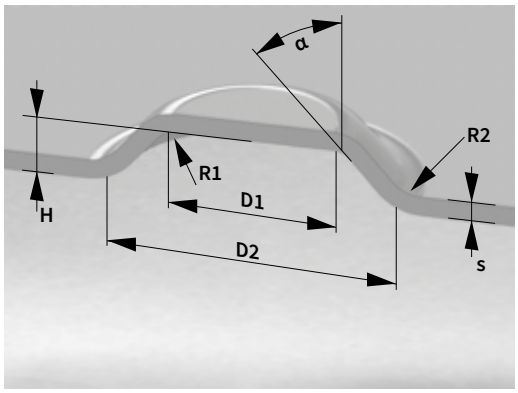
# SPECIAL TOOL ORDER FORM

Spring-loaded emboss tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 131 | |
| | | | downwards | 132 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for top | 09 | |
| | | | Insert for bottom | 03 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Height H | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | 5.0 | 50 | |
| | | | Special dimension (see below) | XX | |
| | 7. | Angle α | 30° | 30 | |
| | | | 45° | 45 | |
| | | | 60° | 60 | |
| | | | Special dimension (see below) | XX | |
| Please indicate dimensons D1 or D2 in your correspondence | | | | | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **131** | Type, complete tool = **00** |
Material, aluminium = **AL** | Sheet thickness s, 1.0 = **10** |
Height H, 2.5 = **25** | Angle α, 45° =**45**
**This creates following part number:**
**T 131 00 AL 10 25 45**

## Tool information

**Tool design incl. alignment ring**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Diameter D1 | mm | Diameter D2 | mm |
| Height H | mm | Angle α | ° |
| Radius R1 | mm | Radius R2 | mm |

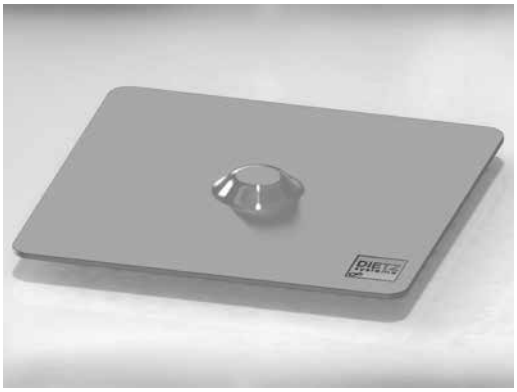
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

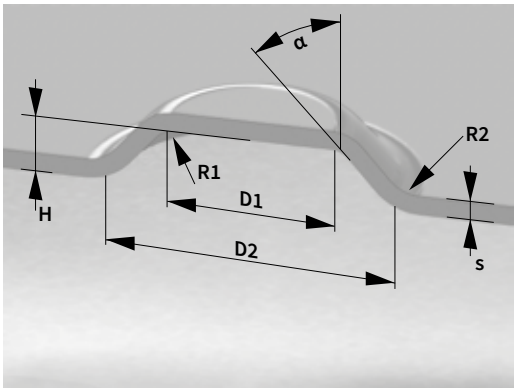
# SPECIAL TOOL ORDER FORM

Rigid emboss tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 141 | |
| | | | downwards | 142 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Height H | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | 5.0 | 50 | |
| | | | Special dimension (see below) | XX | |
| | 8. | Angle α | 30° | 30 | |
| | | | 45° | 45 | |
| | | | 60° | 60 | |
| | | | Special dimension (see below) | XX | |
| Please indicate dimensons D1 or D2 in your correspondence | | | | | |






**Example:** Trumpf Tool System = T
Forming direction, upwards = **141** | Type, complete tool = **00** |
Material, aluminium = **AL** | Sheet thickness s, 1.0 = **10** |
Height H, 2.5 = **25** | Angle α, 45° =**45**
**This creates following part number:**
**T 141 00 AL 10 25 45**

## Tool information

**Tool design rigid incl. alignment ring**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Diameter D1 | mm | Diameter D2 | mm |
| Height H | mm | Angle α | ° |
| Radius R1 | mm | Radius R2 | mm |

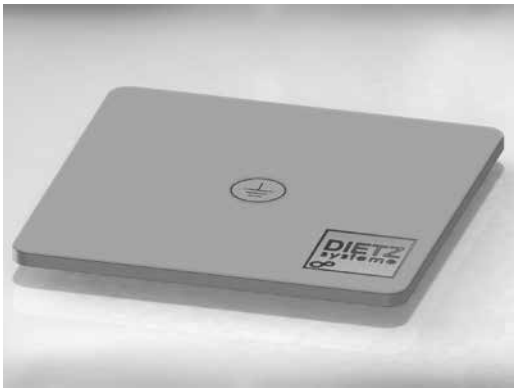
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

# SPECIAL TOOL ORDER FORM

Marking tool - symbol

DIETZ systeme

| Mark with “X” | | | | |
|---|---|---|---|---|
| Article number | | | | |
| Basic information | 1. | Trumpf Tool System | T | X |
| | 2. Forming direction | upwards | 151 | |
| | | downwards | 152 | |
| | 3. Type | Complete tool | 00 | |
| | | Top | 01 | |
| | | Bottom | 02 | |
| | | Punch, upper | 09 | |
| | | Insert for bottom | 03 | |
| | 4. Material | Carbon steel (CS) | ST | |
| | | Aluminium | AL | |
| | | Stainless steel (SS) | VA | |
| | 5. Shapes |  Earth ground symbol | 01 | |
| | |  Protective earth ground symbol | 02 | |
| | |  Noisless earth ground symbol | 03 | |
| | |  Chassis ground symbol | 04 | |
| | | Special dimension (see below) | XX | |
| Additional information | 6. Size | 4.0 | 40 | |
| | | 5.0 | 50 | |
| | | 6.0 | 60 | |
| | | 8.0 | 80 | |
| | | 10.0 | 10 | |
| | | 12.0 | 12 | |
| | | Special dimension (see below) | XX | |



**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **151** | Type, complete tool = **00** |
Material, aluminium = **AL** | Shapes = **01** | Size, 4.0 = **40**
**This creates following part number:**
**T 151 00 AL 01 40**

## Tool information

**Tool design upwards = spring-loaded, incl. alignment ring**
**downwards = rigid, incl. alignment ring**

## Special dimensions

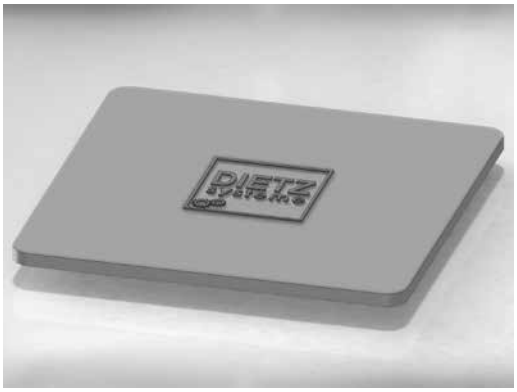
| Material | | Sheet thickness s | mm |
|---|---|---|---|
| Size (L x W) | mm | | |

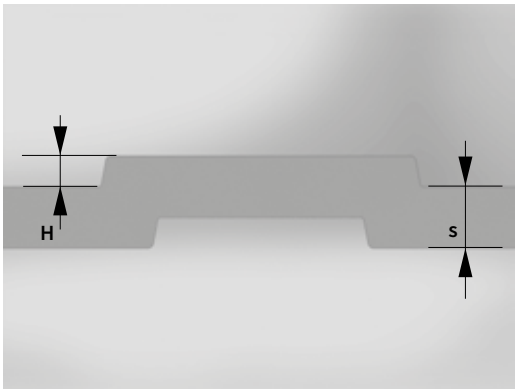
For all other symbols, please, provide drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

# SPECIAL TOOL ORDER FORM

Logo tool (embossed)

| | | | | | |
|---|---|---|---|---|---|
| Mark with “X” | | | | | |
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 161 | |
| | | | downwards | 162 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Punch, upper | 09 | |
| | | | Insert for bottom | 03 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| Additional information | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | Special dimension (see below) | XX | |
| | 6. | Height H | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | Special dimension (see below) | XX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **161** | Type, complete tool = **00** | Material, aluminium = **AL** | Sheet thickness s, 1.0 = **10** | Height, 5.0 = **05** |
**This creates following part number:**
**T 161 00 AL 10 05**

## Tool information

**Tool design** — **upwards: spring-loaded, with alignment ring**
**downwards: rigid, with alignment ring**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Size (L x W) | mm | | |

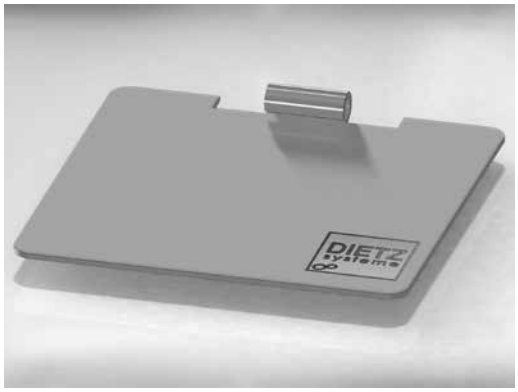
For all other logos, please, provide drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

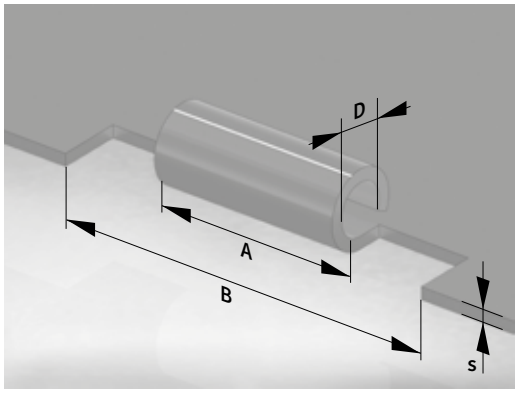
# SPECIAL TOOL ORDER FORM

Hinge tool

DIETZ systeme

| | | | | | |
|---|---|---|---|---|---|
| Mark with “X” | | | | | |
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 171 | |
| | 3. | Type | Tool set | 12 | |
| | | | Pre-bending tool | 13 | |
| | | | Roller tool | 14 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Diameter D | 2.0 | 020 | |
| | | | 2.5 | 025 | |
| | | | 3.0 | 030 | |
| | | | 3.2 | 035 | |
| | | | 4.0 | 040 | |
| | | | 5.0 | 050 | |
| | | | 6.0 | 060 | |
| | | | Special dimension (see below) | XXX | |
| | 7. | Hinge length A | 20.0 | 020 | |
| | | | 30.0 | 030 | |
| | | | 40.0 | 040 | |
| | | | Special dimension (see below) | XXX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **171** | Type, tool set = **12** |
Material, aluminium = **AL** | Sheet thickness s, 1.0 = **10** |
Diameter D, 5.0 = **050** | Width W, 20.0 = **020**
**This creates following part number: T 171 12 AL 10 050 020**

## Tool information

**Hinge size depends on sheet thickness s and diameter D**

| S | D |
|---|---|
| 0.8 - 1.0 mm | 4.0/ 5.0/ 6.0 mm |
| 1.5 mm | 5.0/ 6.0 mm |

**Other dimensions on request**

**The hinge is manufactured using 2 tools:**

1. **Pre-bending tool (incl. alignment ring)**
2. **Roller tool (incl. alignment ring**

## Special dimensions

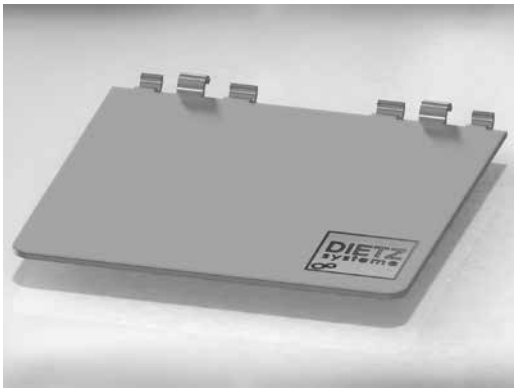
| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Diameter D | mm | With W | mm |
| Hinge length A | mm | | |

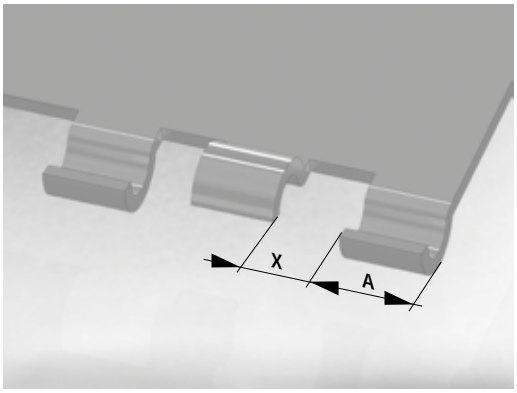
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

# SPECIAL TOOL ORDER FORM

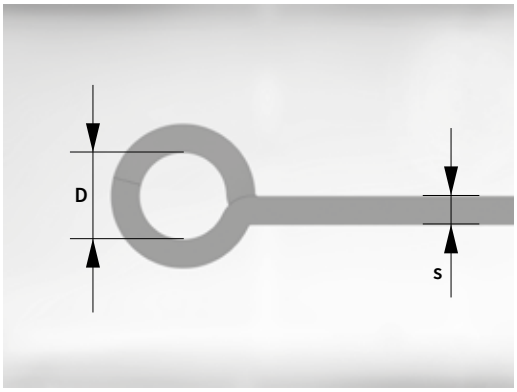
Multi hinge tool

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 181 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Diameter D | 4.0 | 040 | |
| | | | 5.0 | 050 | |
| | | | 6.0 | 060 | |
| | | | Special dimension (see below) | XXA | |
| Please indicate dimensons A, X in your correspondence | | | | | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **181** | Type, top = **01** | Material, steel = **ST** |
Sheet thickness s, 1.0 = **10** | Diameter D, 5.0 = **050**
**This creates following part number: T 181 01 ST 10 050**




## Tool information

**Tool design incl. alignment ring**
**The hinge is manufactured in one stroke**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Diameter D | mm | Width A | mm |
| Distance X | mm | | |

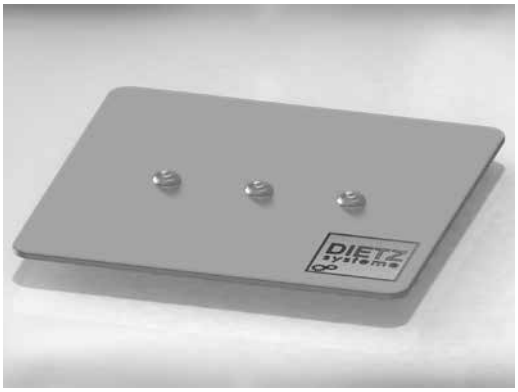
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

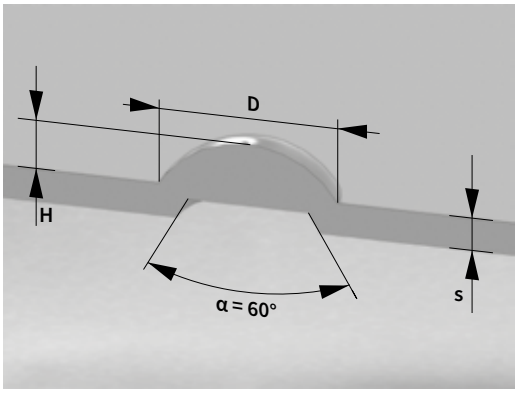
# SPECIAL TOOL ORDER FORM

Dimple tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 201 | |
| | | | downwards | 202 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for top | 09 | |
| | | | Insert for bottom | 03 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Diameter D | 2.5 | 025 | |
| | | | 3.0 | 030 | |
| | | | 3.2 | 032 | |
| | | | 4.0 | 040 | |
| | | | 5.0 | 050 | |
| | | | 6.0 | 060 | |
| | | | 6.3 | 063 | |
| | | | Special dimension (see below) | XXX | |
| | 7. | Height H | 0.63 | 063 | |
| | | | 0.80 | 080 | |
| | | | 1.00 | 100 | |
| | | | 1.25 | 125 | |
| | | | 1.60 | 160 | |
| | | | Special dimension (see below) | XXX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **201** | Type, complete tool = **00** |
Material, aluminium = **AL** | Sheet thickness s, 1.0 = **10** |
Diameter D, 5.00 = **050** | Height, 0.63 = **063**
**This creates following part number:**
**T 201 00 AL 10 050 063**

## Tool information

**Tool design incl. alignment ring**

## Special dimensions

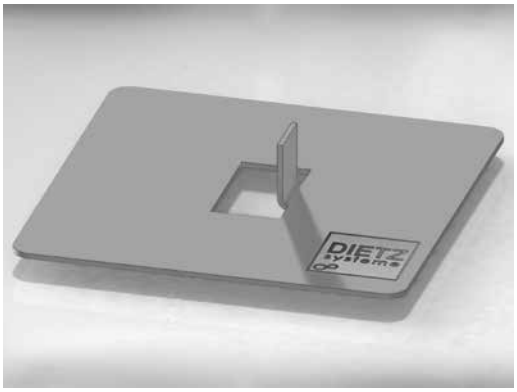
| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Height H | mm | Diameter D | mm |
| Angle α | ° | | |

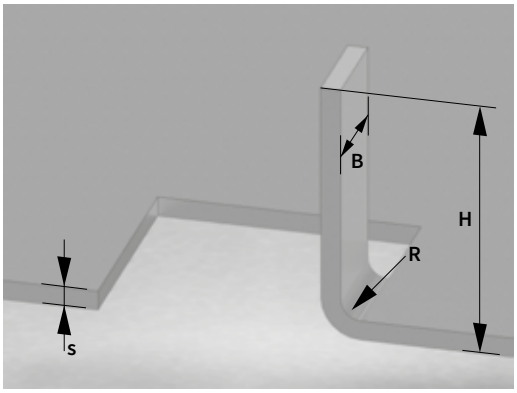
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

# SPECIAL TOOL ORDER FORM

Bending tool

| | | | | | |
|---|---|---|---|---|---|
| Mark with “X” | | | | | |
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 231 | |
| | | | downwards | 232 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Height H | 10 -25 | 100 | |
| | | | Special dimension (see below) | XX | |
| | 7. | Width B | 10.0 | 10 | |
| | | | 15.0 | 15 | |
| | | | 20.0 | 20 | |
| | | | 25.0 | 25 | |
| | | | 30.0 | 30 | |
| | | | 40.0 | 40 | |
| | | | 50.0 | 50 | |
| | | | 55.0 | 55 | |
| | | | Special dimension (see below) | XX | |






**Example:** Trumpf Tool System = **T**

Forming direction, upwards = **231** | Type, complete tool = **00** | Material, aluminium = **AL** |

Sheet thickness s, 1.0 = **10** | Height H, 10 - 25 = **100** | Width B 15.0 = **15**

**This creates following part number: T 231 00 AL 10 100 15**

## Tool information

**Tool design incl. integrated alignment ring**

**Angle: 90° ± 1°**

## Special dimensions

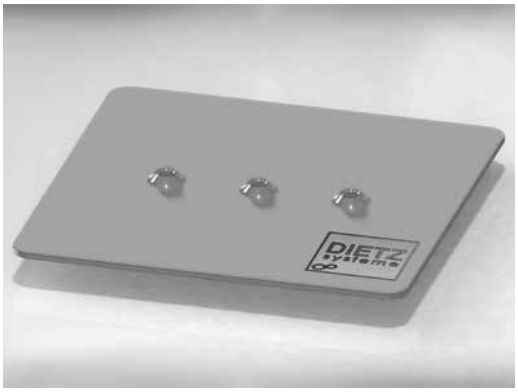
| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Height H | mm | Radius R | ° |
| With W | mm | | |

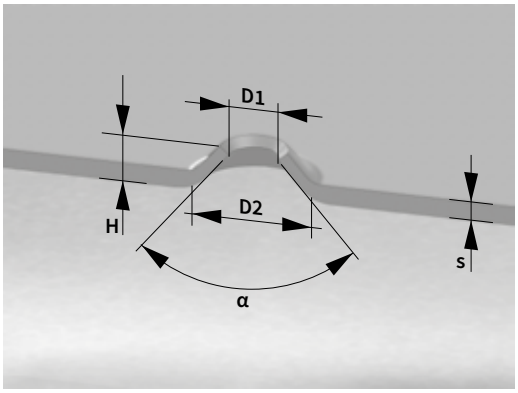
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

# SPECIAL TOOL ORDER FORM

Countersink forming tool

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 191 | |
| | | | downwards | 192 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for bottom | 03 | |
| | | | Punch | 10 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.5 | 05 | |
| | | | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Thread size | M2.5 | 025 | |
| | | | M3 | 030 | |
| | | | M4 | 040 | |
| | | | M5 | 050 | |
| | | | M6 | 060 | |
| | | | M8 | 080 | |
| | | | M10 | 100 | |
| | | | Special dimension (see below) | XXX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **191** | Type, complete tool = **00** |
Material, aluminium = **AL** | Sheet thickness s, 1.0 = **10** |
Thread size, M3 = **030**
**This creates following part number:**
**T 191 00 AL 10 030**

## Tool information

**Tool design** **upwards: spring-loaded, incl. alignment ring**
**downwards: rigid, incl. alignment ring**

**Imperial thread sizes on request**

## Special dimensions

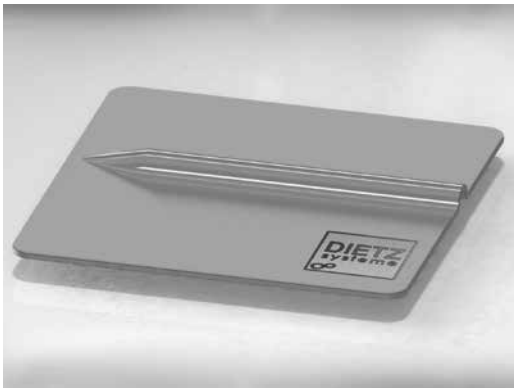
| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Height H | | Angle α | ° |
| Diameter D1 | mm | Diameter D2 | mm |

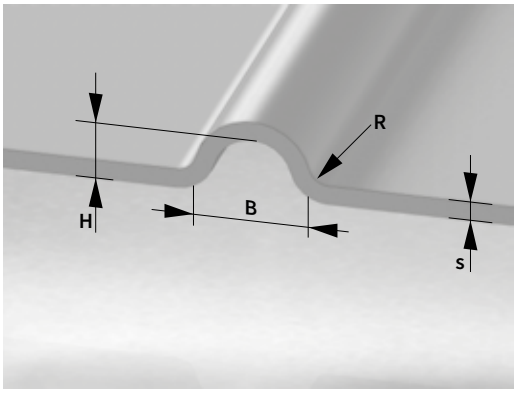
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

# SPECIAL TOOL ORDER FORM

Continuous beading tool

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 211 | |
| | | | downwards | 212 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 0.8 | 08 | |
| | | | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Size | 2.0 x 4.0 | 0204 | |
| | | | 3.0 x 6.0 | 0306 | |
| | | | 4.0 x 8.0 | 0408 | |
| | | | 5.0 x 10.0 | 0510 | |
| | | | Special dimension (see below) | XXXX | |




**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **211** | Type, complete tool = **00** | Material, aluminium = **AL** | Sheet thickness s, 1.0 = **10** | Size, 4.0 x 8.0 = **0408**
**This creates following part number: T 211 00 AL 10 0408**

## Tool information

**Tool design incl. alignment ring**

**If the beginning and the end of the bead requires a shaped form, an additional tool is required.**

## Special dimensions

| | | | |
|---|---|---|---|
| Material | | Sheet thickness s | mm |
| Height H | mm | With W | mm |
| Radius R | mm | | |

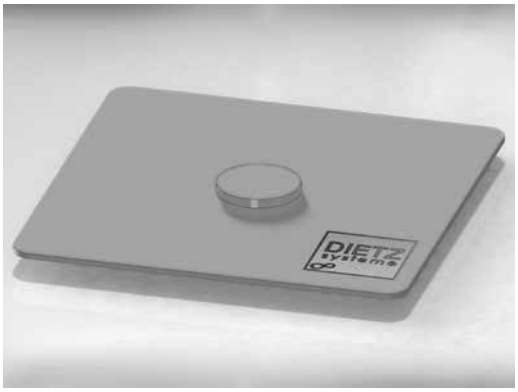
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

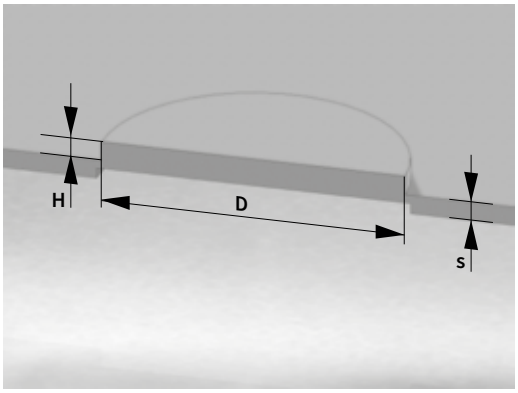
# SPECIAL TOOL ORDER FORM

Half shear tool

DIETZ systeme

| Mark with “X” | | | | | |
|---|---|---|---|---|---|
| Article number | | | | | |
| Basic information | 1. | Trumpf Tool System | | T | X |
| | 2. | Forming direction | upwards | 221 | |
| | | | downwards | 222 | |
| | 3. | Type | Complete tool | 00 | |
| | | | Top | 01 | |
| | | | Bottom | 02 | |
| | | | Insert for top | 09 | |
| | | | Insert for bottom | 03 | |
| | 4. | Material | Carbon steel (CS) | ST | |
| | | | Aluminium | AL | |
| | | | Stainless steel (SS) | VA | |
| | 5. | Sheet thickness s | 1.0 | 10 | |
| | | | 1.5 | 15 | |
| | | | 2.0 | 20 | |
| | | | 2.5 | 25 | |
| | | | 3.0 | 30 | |
| | | | 4.0 | 40 | |
| | | | 5.0 | 50 | |
| | | | Special dimension (see below) | XX | |
| Additional information | 6. | Outside diameter D | 2.0 | 020 | |
| | | | 2.5 | 025 | |
| | | | 3.0 | 030 | |
| | | | 3.2 | 032 | |
| | | | 4.0 | 040 | |
| | | | 5.0 | 050 | |
| | | | 6.0 | 060 | |
| | | | Special dimension (see below) | XXX | |






**Example:** Trumpf Tool System = **T**
Forming direction, upwards = **221** | Type, complete tool = **00** |
Material, Carbon steel = **ST** | Sheet thickness s, 1.0 = **10** |
Outside diameter, 2.5 = **025**
**This creates following part number:**
**T 221 00 AL 10 025**

## Tool information

**Tool design incl. alignment ring**
**Height H can be adjusted on the tool.**

## Special dimensions

| Material | | Sheet thickness s | mm |
|---|---|---|---|
| Height H | mm | Outside diameter D | mm |

Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

## ACCESSORIES AND INFORMATION

# ACCESSORIES AND INFORMATION

Alignment rings | Adapter rings | Punch chucks | Tooling cartridges

DIETZ systeme

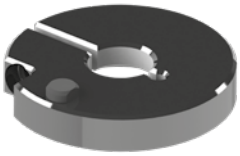
**Adjustment ring for cartridges with automatic tool changer (with recess)**

| Size | Art. no. |
|---|---|
| 1 | 200 01 |

**Adjustment ring for cartridges with automatic tool changer**

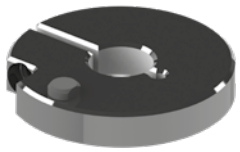
| Size | Art. no. |
|---|---|
| 2 / 3 | 200 02 |

**Adjustment ring for manual tool change (with recess)**



| Size | Art. no. |
|---|---|
| 1 | 200 03 |

**Adjustment ring for manual tool change**



| Size | Art. no. |
|---|---|
| 2 / 3 | 200 04 |

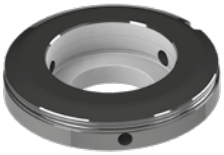
**Alignment ring - heavy duty**

| Size | Art. no. |
|---|---|
| 1 | 200 11 |

**Punch chuck for punching needles**

| Range | Art. no. |
|---|---|
| 0.5 - 6.0 | 221 02 |
| 6.1 - 10.5 | 222 02 |

**Die adapter**



| Size | Art. no. |
|---|---|
| 1 / 2 | 200 06 |

**Die adapter, incl. brush insert**

| Size | Art. no. |
|---|---|
| 1 / 2 | 200 06 B |

**Tooling cartridges and die plates**

Price on request and Die plates

# ACCESSORIES AND INFORMATION

Shims | DMW Cut Plus oil

| Size 1 |
|---|
|  |
| **Size 2** |
|  |

| Die shims size 1 | | |
|---|---|---|
| **Size** | **Thickness** | **Art. no.** |
| 1 | 0.1 | 210 30 1 |
| | 0.3 | 210 30 3 |
| | 0.5 | 210 30 5 |
| **Die shims size 2** | | |
| 2 | 0.1 | 250 30 1 |
| | 0.3 | 250 30 3 |
| | 0.5 | 250 30 5 |

| 5 x 30 \| 5 x 56 |
|---|
|  |
| **5 x 76.2** |
|  |

| Slitting tool shims | | |
|---|---|---|
| **Size** | **Thickness** | **Art. no.** |
| 5 x 30 | 0.1 | 223 21 1 |
| | 0.3 | 223 21 3 |
| | 0.5 | 223 21 5 |
| 5 x 56 | 0.1 | 223 22 1 |
| | 0.3 | 223 22 3 |
| | 0.5 | 223 22 5 |
| 5 x 76.2 | 0.1 | 223 23 1 |
| | 0.3 | 223 23 3 |
| | 0.5 | 223 23 5 |

| Punch lubricant: DMW Cut Plus oil |
|---|
| **Quantity/ltr** |
| 1 |
| 3 |
| 5 |
| 10 |
| 25 |

| Multitool shim | | |
|---|---|---|
| **Size** | **Thickness** | **Art. no.** |
| 5-station | 2 x 0,1 / 0,3 / 0,5 | 263 30 |
| 10-station | 2 x 0,1 / 0,3 / 0,5 | 264 30 |
| 4-station | 2 x 0,1 / 0,3 / 0,5 | 261 30 |
| 6-station | 2 x 0,1 / 0,3 / 0,5 | 262 30 |
| Price are based on a set | | |

| Schleifscheibe \| 200 93 |
|---|
| **Für Trumpf QuickSharp** |
|  |
| |

| Combo |
|---|
| **Cartridge and die carrier are also separately available** |
|  |
| |

# ACCESSORIES AND INFORMATION

PA stripper for scratch-free machining

| | Round | Shape |
|---|---|---|
| | Art. no. | Art. no. |
| Complete | 280 04 F PA | 228 04 F PA |
| Ring | 280 04 F-1 PA | 280 04 F-1 PA |
| PA insert | 280 04 F-2 PA | 228 04 F-2 PA |

## Tool information

| Material | max. sheet thickness |
|---|---|
| Carbon steel | 3mm |
| Stainless steel | 2mm |
| Aluminium | 4mm |

**Benefits of the PA-stripper are:**
- Increased Surface Quality
- Replaces Adhesive Pads
- Can be used on any machine with Trumpf tool system

# ACCESSORIES AND INFORMATION

Shear types

| | | Advantages | Disadvantages |
|---|---|---|---|
|  | **WT** | • Easy regrinding<br>• Shear force reduced by up to 70%<br>• Reduced noise<br>• Less deformation of components | • Radial forces<br>• Suitable for trimming, under certain conditions |
|  | **DOWT** | • Easy regrinding<br>• No radial forces<br>• Shear force reduced by up to 35% | • Not suitable for trimming |
|  | **WTC** | • Reduced corner load<br>• Less deformation of components | • Radial forces |
|  | **2PT** | • No radial forces<br>• Optimum punching cut<br>• Suitable for trimming | • Only viable for large, thin contours<br>• Difficult to regrind |
|  | **4PT** | • No radial forces<br>• Optimum punching cut<br>• Suitable for trimming | • Only viable for large contours<br>• Difficult to regrind |

The most important benefits are:
- Punch Load Reduction
- Noise Reduction

# ACCESSORIES AND INFORMATION

Coatings

| Hardness in HV | Friction coefficient | Colour | Characteristics | |
|---|---|---|---|---|
| 3700 ± 500 | 0.25 | Reddish grey | Reduced adhesive and abrasive wear | **DT+** |

**Application**
• Mixed processing • High alloyed chromium/ nickel • Thick steel sheets
• Stainless steel • Cold working • Slitting high-strength sheet metal
• Cold forging operations with high surface loads

| | | | | |
|---|---|---|---|---|
| 3000 | 0.1 | black | • Reduced adhesion<br>• Combination of high degree of hardness and extremely low friction coefficient | **HT** |

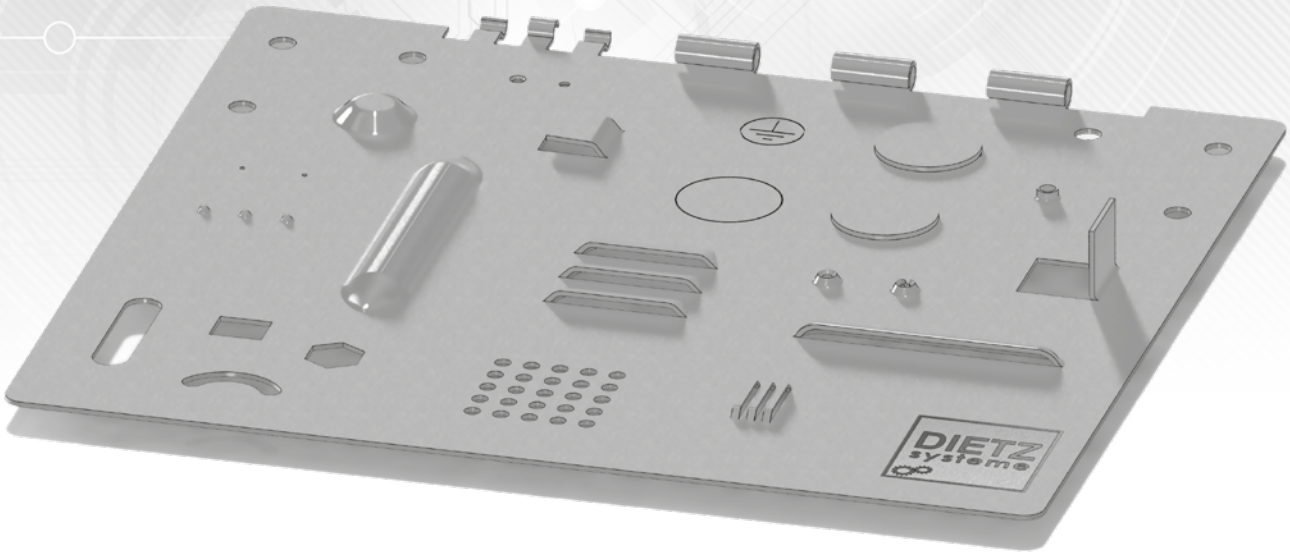
**Application**
• Aluminium
• Punching/ Slitting
• Precision Slitting
• Cold forming

| | | | | |
|---|---|---|---|---|
| 3500 ± 500 | 0.2 | Antique pink | • Low friction<br>• High oxidation resistance | **VT** |

**Application**
• Mixed processing
• High and low alloyed steels
• Galvanized sheet metal

The most important benefits are:
- Increased lifetime (reduced regrinding intervals)
- Reduced material build-up
- Increased tool replacement circle

**Dietz** Systeme GmbH




**Dietz Systeme GmbH**
Reichsdorfer Str. 2
D - 94234 Viechtach

Tel.: +49 9942 9489-0
Fax: +49 9942 9489-101

sales@dietz-systeme.de