

General



In punching and bending tools, active elements are the cutting and shaping parts. Here, the highest requirements in dimensional accuracy and surface quality must be met. Active elements are wearing parts and can be replaced several times over the course of a tool's life time.

In addition to standard active elements, STEINEL also offers individual solutions tailored to your specifications. Upon request, you will receive all required active elements from a single source – from a single unit to mass production.



Properties

- Starting materials for the STEINEL active elements are high-quality materials such as:
 - conventional tool steels
 - powder metallurgical steels
 - carbides
- microblasted cutting edges upon request
- PVD coatings upon request, such as:
 - AlCrN (aluminium chrome nitride)
 - TiN (titanium nitride)
 - TiCN (titanium carbonitride)
 - CrN (chrome nitride)
 - Futura TiAlN (titanium aluminium nitride)
 - Futura Nano TiAlN

Cutting punch, cutting bushes



Cutting punch	Standard	Shape	Diameter	Length	Material
with trumpet head	–	D	3.0-20.0	71, 80, 100	HSS
		C	1.0-19.5	71, 80, 100	HSS
with conical head	DIN 9861 / ISO 6752	D	0.8-16.0	71, 80, 100	HSS, HWS, PM
	DIN 9861 / ISO 9181	C	0.5-2.9	71, 80	HSS
with cylindrical head	ISO 8020	A	3.0-25.0	71, 80, 90, 100	HSS, PM
		B	1.0-24.5	71, 80, 90, 100	HSS, PM
		E	6.0-2.0	71, 80, 90, 100	HSS
		F	1.6-24.5	71, 80, 90, 100	HSS
Quick-change cutting punch	DIN ISO 10071	–	6.0-25.0	71, 80	HWS



Cutting bushes	Standard	Shape	Diameter	Length	Material
for pressing-in	ISO 8977	A	1.0-25.0	20, 25	HSS
for pressing-in with shoulder	ISO 8977	B	1.0-25.0	25, 32	HSS
Quick-change cutting bushes	–	–	2.0-25.0	32	HWS

Shape-cutting elements, shape-cutting bushes



Shape-cutting elements*	Standard	Shape	Length	Material
continuously shaped (with/without hot upset head)	–	square, rectangular, oval	80	HSS
with reduced shaft, with twisting surface	ISO 8020	square, rectangular, oval	80	HSS

*available in several versions, and as a special design



Shape-cutting bushes*	Standard	Shape	Length	Material
with shoulder, with twisting surface	DIN ISO 8977	square, rectangular, oval	32	HSS

*available in several versions, and as a special design