DMW Maschinen- und Werkzeugbau GmbH

DIETZ systeme

Precision tooling

Trumpf System

Precision tooling systems | CONTENTS

DIETZ systeme

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DMW Maschinen- und Werkzeugbau GmbH

DIETZ systeme

GENERAL INFORMATION

The Company - History	**1.1**
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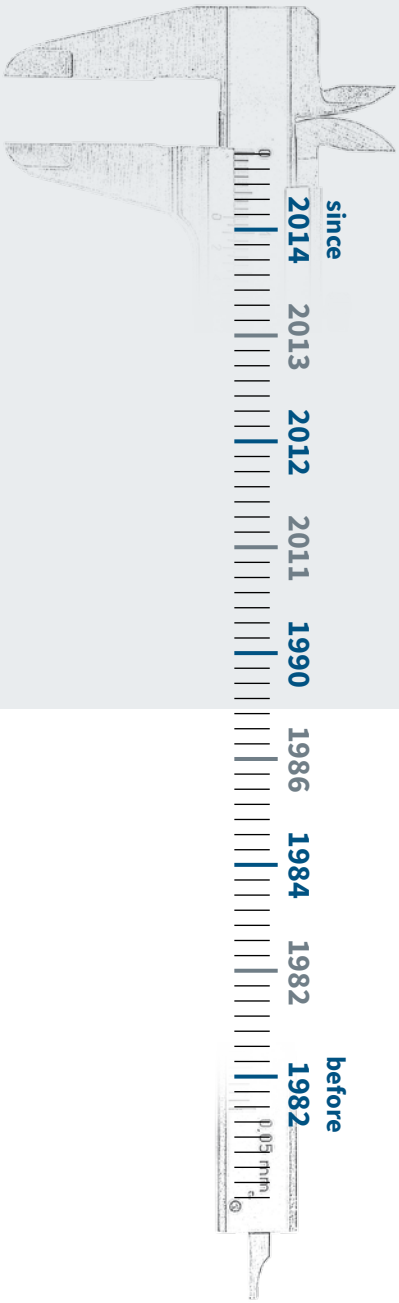
Order form for Trumpf punching tools	**1.3**

DMW Maschinen- und Werkzeugbau GmbH

DIETZ systeme

HISTORY 1982 - 2016



International expansion and cooperation network development

Corporate name changes to DMW GmbH - The brand Dietz remains

Company moves to its new building in Geiersthal

Company passes the 100 employee mark

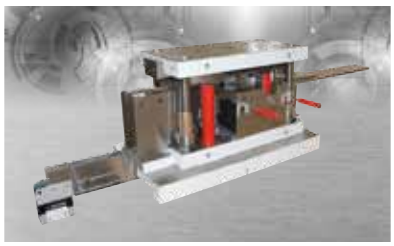
Company enters the automotive industry

Punch and forming tools as well as jig manufacturing

First tool production for the Trumpf system

The Dietz company is established in Viechtach

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



DMW Maschinen- und Werkzeugbau GmbH

DIETZ systeme

Price list 16/01, valid as of 01/01/2016

- Orders of 5 or more units of the same shape and dimension will receive a bulk discount of 5%.
- Prices are ex works, plus VAT, payable as follows: net due 30 days.
  Beyond this our sales terms and delivery conditions apply (refer to: www.dmw-gmbh.com).
- 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.**

Inquiry and order form for standard punch tooling

Template

DMW Maschinen - und Werkzeugbau GmbH · Frankenrieder Str. 3 · D-94244 Geiersthal

Company/address

Contact information in case of questions Phone

Customer ID

DMW contact information

☐ Inquiry ☐ Order

Inquiry or order number

☐ RD ☐ OB ☐ SF _____

☐ RE ☐ SQ

Please indicate your offer number

Requested date of delivery

Machine model

Email address for order confirmation

Article no.	Article Description	Size	Shape	Dimension	Shear	Clear-ance	Quantity	Price/ unit	Total price	Notes

Subtotal:	
Customer discount:	
Total order value:	

Questions? Contact us at any time | +49 9923 80107 - 0 or sales@dmw-gmbh.com

Thank you for your interest!

Date Signature

Article no.	Article Description	Size	Shape	Dimension	Shear	Clear-ance	Quantity	Price/ unit	Total price	Notes
								Subtotal:		
								Customer discount:		
								Total order value:		

Questions? Contact us at any time – +49 9923 80107 - 0 or sales@dmw-gmbh.com

Thank you for your interest!

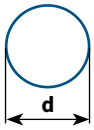
Date Signature

STANDARD TOOLS

Round	**2.1**
Square	**2.2**
Rectangle	**2.3**
Oblong	**2.4**
Heavy Duty	**2.5**
PU strippers	**2.6**

STANDARD ROUND TOOLS

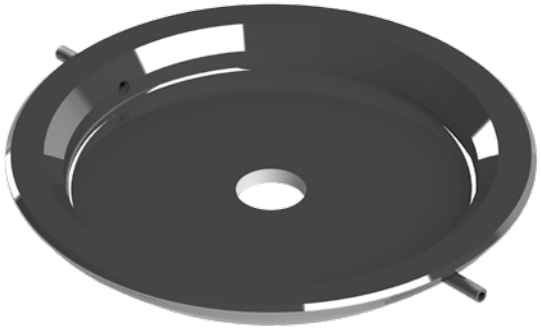
Punches | Strippers | Dies



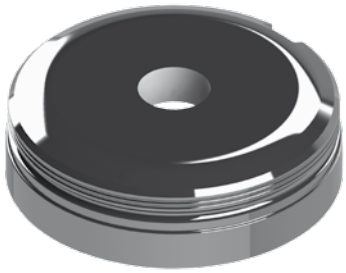
DIETZ systeme

Punches			
Size	**Range d**	**Art. no.**	**Price in EUR**
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**	**Price in EUR**
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 Strippers for Boschert machines, see page 2.6				



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



OPTIONS

Surcharge for shear

Size	Range d	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

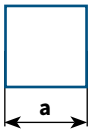
Surcharge for coatings

Size	Range d	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

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

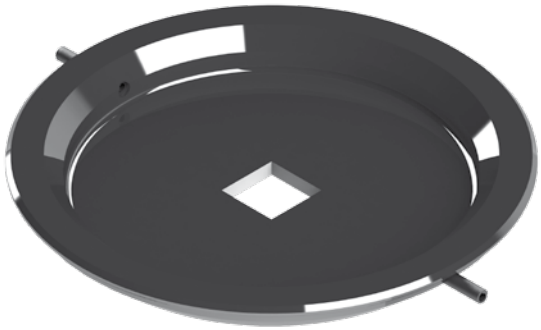
STANDARD SQUARE TOOLS

Punches | Strippers | Dies



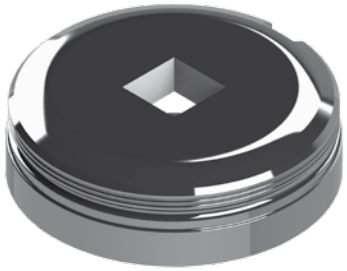
DIETZ systeme

Punches			
Size	**Range a**	**Art. no.**	**Price in EUR**
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**	**Price in EUR**
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.**	**Price in EUR**
1	- 22.0	221 10 QU	
2	- 52.0	225 10 QU	
3	- 73.0	226 10 QU	

OPTIONS

Surcharge for shear

Size	Range d	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

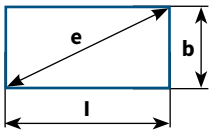
Surcharge for coatings

Size	Range d	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

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

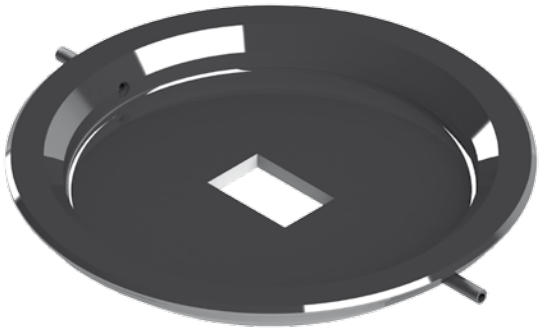
Punches | Strippers | Dies



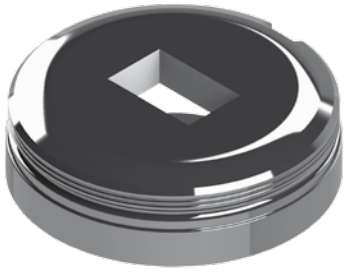
DIETZ systeme

Punches			
Size	**Range e**	**Art. no.**	**Price in EUR**
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**	**Price in EUR**
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 Strippers for Boschert machines, see page 2.6				



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



OPTIONS

Surcharge for shear

Size	Range e	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

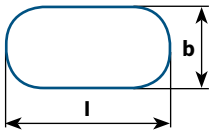
Surcharge for coatings

Size	Range e	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

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

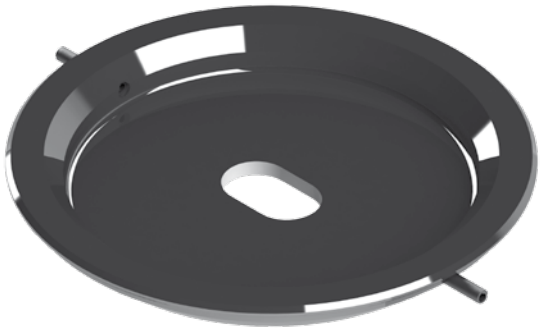
STANDARD OBLONG TOOLS

Punches | Strippers | Dies



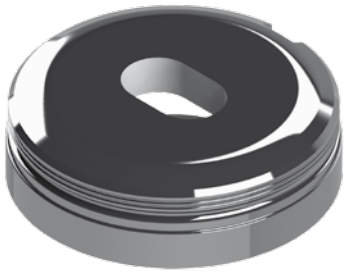
DIETZ systeme

Punches			
Size	**Range l**	**Art. no.**	**Price in EUR**
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**	**Price in EUR**
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.**	**Price in EUR**
1	- 32.0	221 10 LL	
2	- 77.0	225 10 LL	
3	- 107.0	226 10 LL	

OPTIONS

Surcharge for shear

Size	Range 1	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

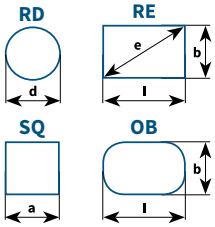
Surcharge for coatings

Size	Range 1	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

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

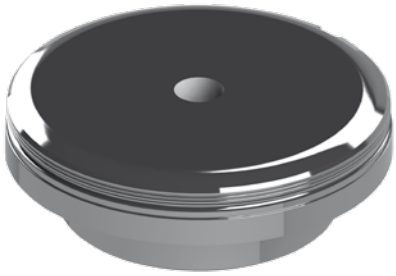
HEAVY DUTY TOOLS

Punches | Dies



DIETZ systeme

Punches		
Range	**Art. no.**	**Price in EUR**
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.**	**Price in EUR**
d (- 62)	225 10 VS DR	
a (-43)	225 10 VS QU	
d (-62)	250 10 VS RE	
l (-62)	225 10 VS LL	

OPTIONS

Surcharge for shear

Size	Range d	Price in EUR
2	- 60	

Surcharge for coatings

Size	Range d	Price in EUR
2	- 60	

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**	**Art. no.**	**Price/EUR**
1	Flat size 0	- 6.00 mm	20 10	
1	Flat size 0	- 10.50 mm	20 11	
1	Flat	- 12.00 mm	20 12	
1	Whisper	- 12.00 mm	20 13	
2	Flat	- 30.50 mm	30 10	
2	Whisper	- 30.50 mm	30 11	
3	Flat	- 48.00 mm	40 10	
3	Whisper	- 48.00 mm	40 11	
	Flat/ Whisper	> 48.00 mm		

Version 2

Round				
Version	**Punch version**	**Range**	**Art. no.**	**Price/EUR**
1	Flat size 0	- 6.00 mm	20 14	
1	Flat size 0	- 10.50 mm	20 15	
1	Flat	- 12.00 mm	20 16	
1	Whisper	- 12.00 mm	20 17	
2	flat	- 30.50 mm	30 12	
2	Whisper	- 30.50 mm	30 13	
3	Flat	- 48.00 mm	40 12	
3	Whisper	- 48.00 mm	40 13	
	Flat/ Whisper	> 48.00 mm		

Version 3

Shape				
Version	**Punch version**	**Range**	**Art. no.**	**Price/EUR**
1	Flat size 0	- 6.00 mm	20 18	
1	Flat size 0	- 10.50 mm	20 19	
1	Flat	- 12.00 mm	20 20	
1	Whisper	- 12.00 mm	20 21	
2	Flat	- 30.50 mm	30 14	
2	Whisper	- 30.50 mm	30 15	
3	Flat	- 48.00 mm	40 14	
3	Whisper	- 48.00 mm	40 15	
	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

Category 1 - standard grinding shape	**3.1 - 3.2**
Category 2 - special grinding shape	**3.3 - 3.4**
Category 3 - standard EDM shape	**3.5 - 3.6**
Category 4 - special EDM shape	**3.7**

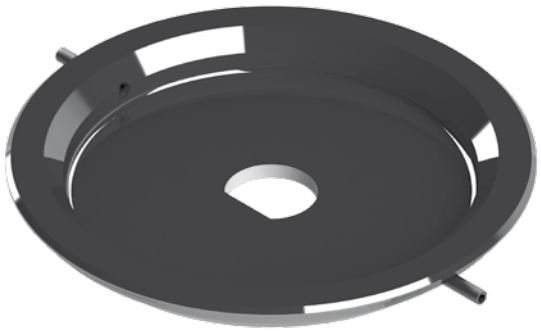
SPECIAL SHAPES CATEGORY 1

Punches | Strippers | Dies

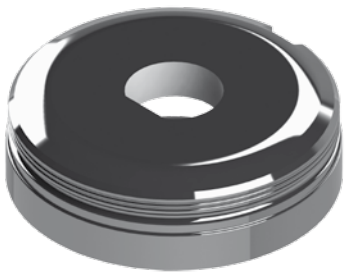
DIETZ systeme

Punches			
Size	**Range**	**Art. no.**	**Price in EUR**
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**	**Price in EUR**
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.**	**Price in EUR**
1	- 32.0	221 10.xx	
2	- 77.0	225 10.xx	
3	- 107.0	226 10.xx	



OPTIONS

Surcharge for shear

Size	Range d	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

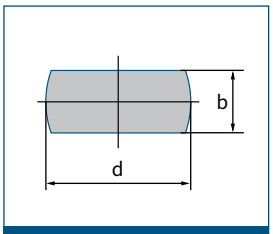
Surcharge for coatings

Size	Range d	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

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



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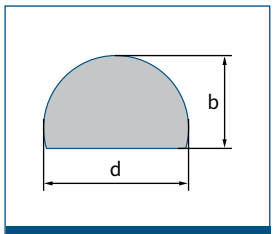
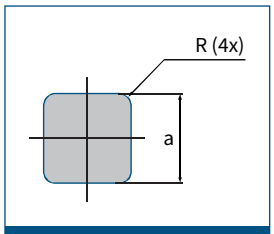
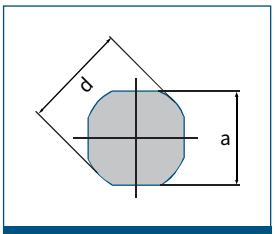


SF 09



SF 10



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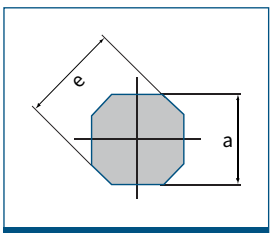
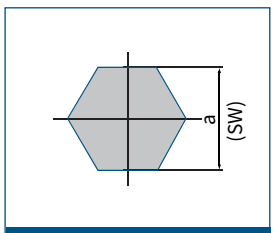
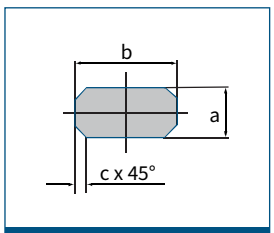


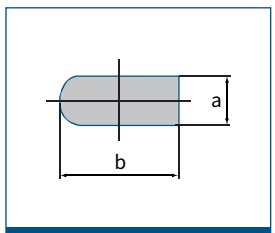
SF 12



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°

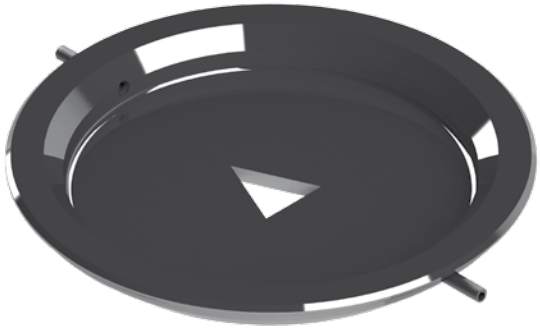
SPECIAL SHAPES CATEGORY 2

Punches | Strippers | Dies

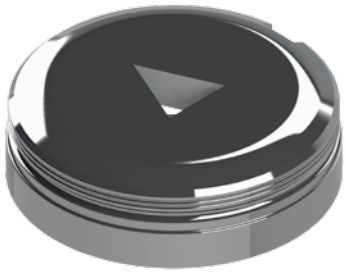
DIETZ systeme

Punch			
Size	**Range**	**Art. no.**	**Price in EUR**
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**	**Price in EUR**
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.**	**Price in EUR**
1	- 31.0	221 10.xx	
2	- 77.0	225 10.xx	
3	- 107.0	226 10.xx	



OPTIONS

Surcharge for shear

Size	Range d	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

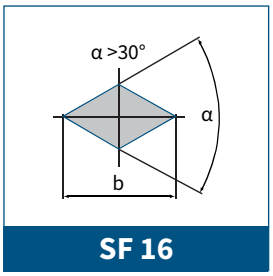
Surcharge for coatings

Size	Range d	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

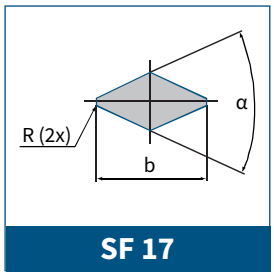
Please, include drawings with your inquiry (DXF or STEP). Heavy duty punches and dies available on request.
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

SPECIAL SHAPES CATEGORY 2

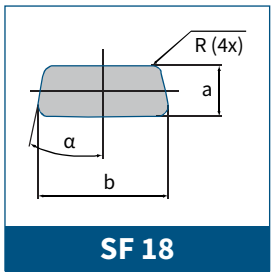
Shapes Category 2



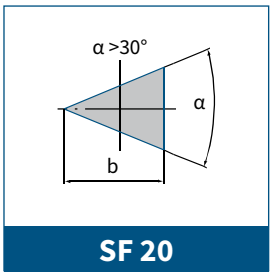
SF 16



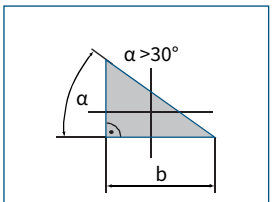
SF 17



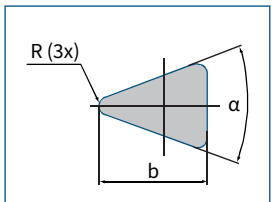
SF 18



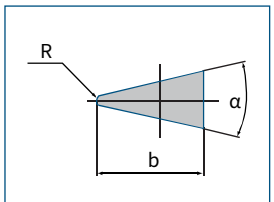
SF 20



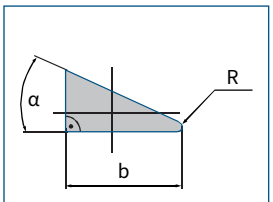
SF 21



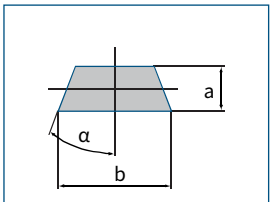
SF 22



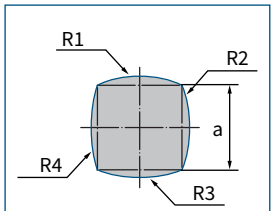
SF 23



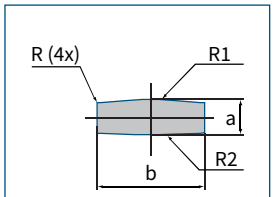
SF 24



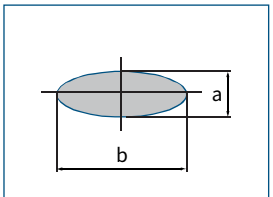
SF 25



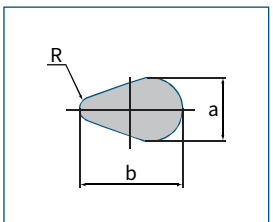
SF 26



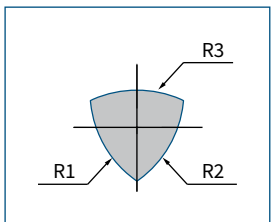
SF 29



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

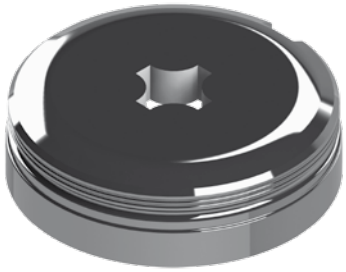
Punches | Strippers | Dies

DIETZ systeme

Punch			
Size	**Range**	**Art. no.**	**Price in EUR**
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**	**Price in EUR**
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.**	**Price in EUR**
1	- 32.0	221 10.xx	
2	- 77.0	225 10.xx	
3	- 107.0	226 10.xx	



OPTIONS

Surcharge for shear

Size	Range d	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

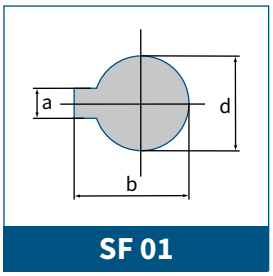
Surcharge for coatings

Size	Range d	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

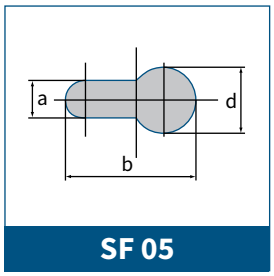
Please, include drawings with your inquiry (DXF or STEP). Heavy duty punches and dies available on request.
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.4
Accessories: For alignment rings, adapter rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

SPECIAL SHAPES CATEGORY 3

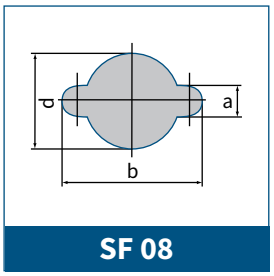
Shapes Category 3



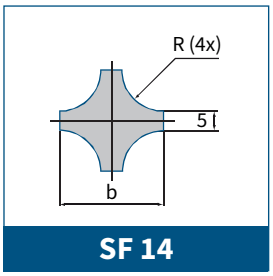
SF 01



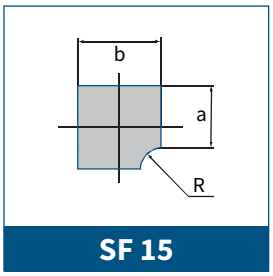
SF 05



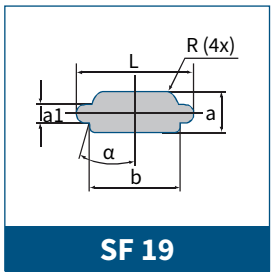
SF 08



SF 14



SF 15



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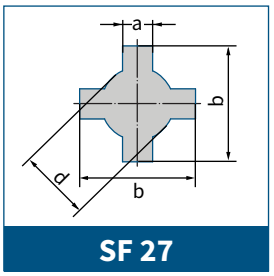
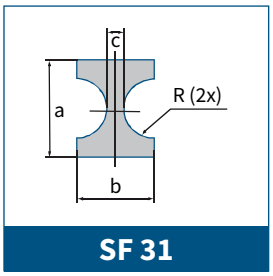
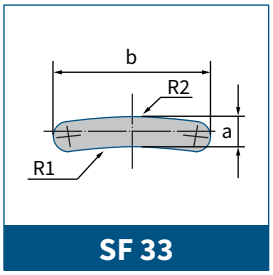


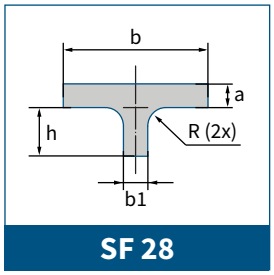
SF 27



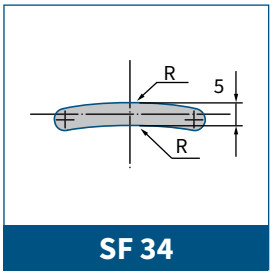
SF 31



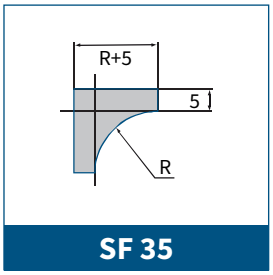
SF 33



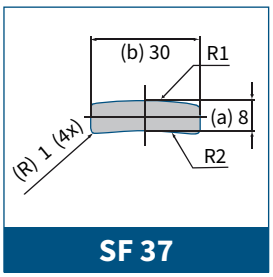
SF 28



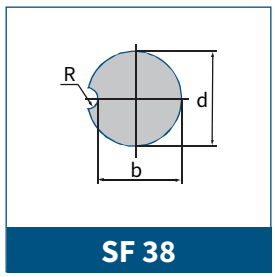
SF 34



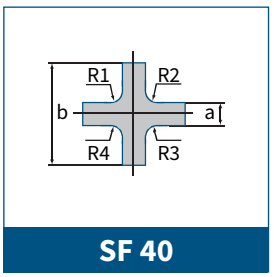
SF 35



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

DIETZ systeme

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

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

Dies			
Size	**Range**	**Art. no.**	**Price in EUR**
1	- 32.0	221 10.xx	upon request
2	- 77.0	225 10.xx	upon request
3	- 107.0	226 10.xx	upon request

OPTIONS

Surcharge for shear

Size	Range d	Price in EUR
1	- 30.5	
2	- 76.2	
3	-105.0	

Surcharge for coatings

Size	Range d	Price in EUR
0	- 10.5	
1	- 30.0	
2	- 76.2	
3	-105.0	

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

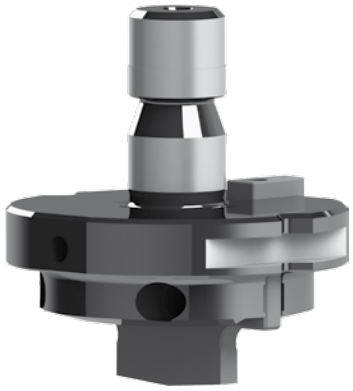
With interchangeable inserts 5 x 30	**4.1**
With interchangeable inserts 5 x 56	**4.2**
With interchangeable inserts 5 x 76.2	**4.3**
Close to form	**4.4**

SLITTING TOOL

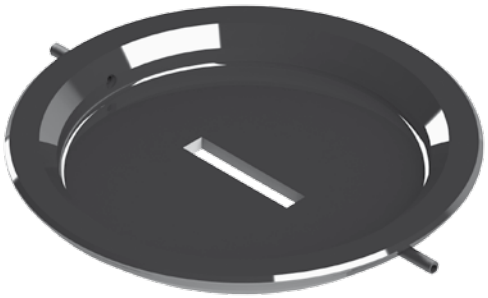
With interchangeable inserts 5 x 30

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

Adapter for punch insert		
Art. no.	**Description**	**Price in EUR**
223 43-O	Punch holder	

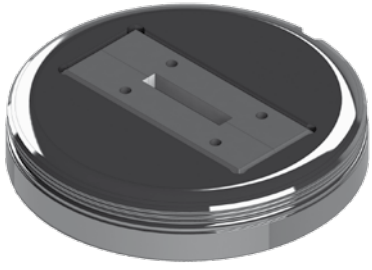


Punch insert		HSS
Art. no.	**Description**	**Price in EUR**
223 60-RE	Rectangle	
223 60-LL	Oblong	
223 60-MT	Trapezoid	
223 60-MS	Double trapezoid	



Stripper		
Art. no.	**Description**	**Price in EUR**
228 04 RE / LL	Rectangle/ oblong	
228 04 MT / MS	Trapezoid / double trapezoid	

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



Adapter for die insert		
Art. no.	**Insert**	**Price in EUR**
223 21-O	Die Adapter	

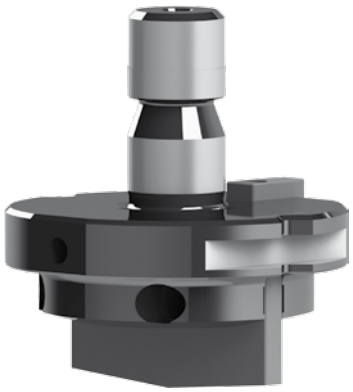
OPTIONS

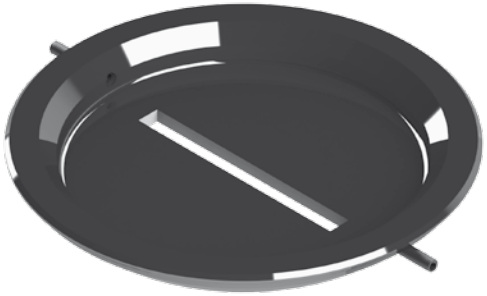
Surcharge for coating on punch insert
Price in EUR

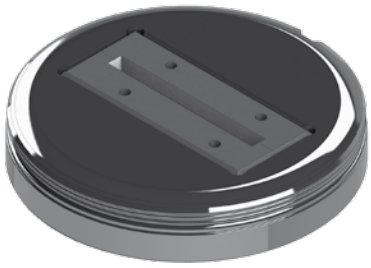
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2

SLITTING TOOL

With interchangeable inserts 5 x 56







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

Adapter for punch insert		
Art. no.	**Description**	**Price in EUR**
223 43-O	Punch holder	

Punch insert		HSS
Art. no.	**Description**	**Price in EUR**
223 61-RE	Rectangle	
223 61-LL	Oblong	
223 61-MT	Trapezoid	
223 61-MS	Double trapezoid	

Stripper		
Art. no.	**Description**	**Price in EUR**
228 04 RE / LL	Rectangle/ oblong	
228 04 MT / MS	Trapezoid / double trapezoid	

Die insert		
Art. no.	**Shape**	**Price in EUR**
223 70-RE	Rectangle	
223 71-LL	Oblong	
223 71-MT	Trapezoid	
223 71-MS	Double trapezoid	

Adapter for die insert		
Art. no.	**Insert**	**Price in EUR**
223 21-O	Die Adapter	

OPTIONS

Surcharge for coating on punch insert
Price in EUR

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.		**Price in EUR**
223 42-1	Rectangle	
223 42-2	Oblong	
223 42-3	Trapezoid	
223 42-4	Double trapezoid	

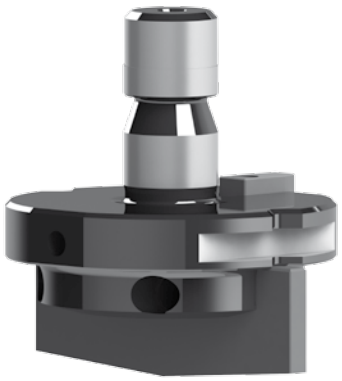
Adapter for punch insert		
Art. no.		**Price in EUR**
223 43-O	Punch holder	

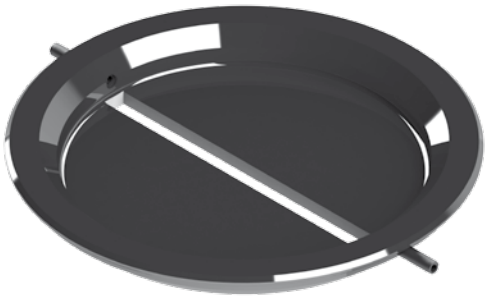
Punch insert		HSS
Art. no.		**Price in EUR**
223 62-RE	Rectangle	
223 62-LL	Oblong	
223 62-MT	Trapezoid	
223 62-MS	Double trapezoid	

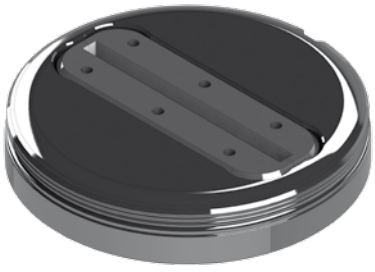
Stripper		
Art. no.		**Price in EUR**
228 04 RE / LL	Rectangle/ oblong	
228 04 MT / MS	Trapezoid / double trapezoid	

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

Adapter for die insert		
Art. no.	**Insert**	**Price in EUR**
223 22-O	Die Adapter	







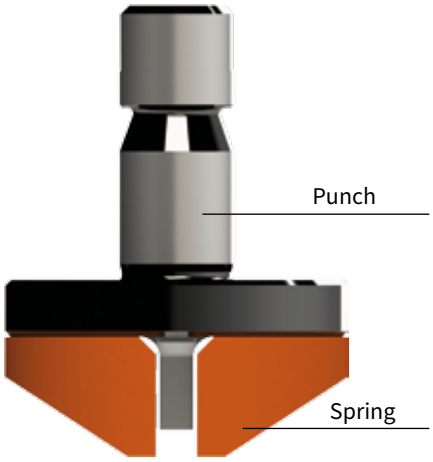
OPTIONS

Surcharge for coating on punch insert
Price in EUR

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**	**Price in EUR**
223 01 HL OK W	Slitting punch without spring element	
223 80	Spring element, incl. bolts	
223 10	Die	

Slitting tool, 5 x 56, Rectangle		
Art. no.	**Description**	**Price in EUR**
225 01 HL OK W	Slitting punch without spring element	
224 80	Spring element, incl. bolts	
225 10	Die	

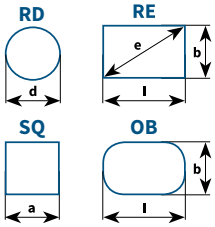
Slitting tool, 5 x 76.2, Rectangle		
Art. no.	**Description**	**Price in EUR**
225 01-1 HL OK W	Slitting punch without spring element	
225 80	Spring element, incl. bolts	
225 10	Die	

Spare parts for spring elements 5 x 30 | 5 x 56 | 5 x 76,2		
Art. no.	**Description**	**Price in EUR**
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

5-station (range up to 16 mm)	**5.1**
10-station (range up to 10.5 mm)	**5.2**
4-station (range up to 16 mm)	**5.3**
6-station (range up to 10.5 mm)	**5.4**

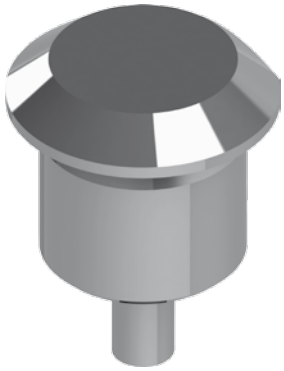


DIETZ systeme

5-Station Multitool

Range up to 16 mm

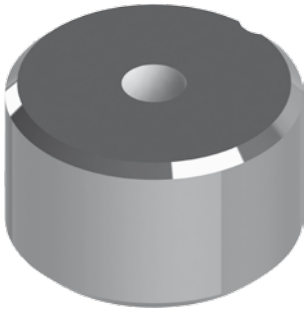
Punches	PM
Art. no.	Price in EUR
263 11 RD	
263 12 SQ	
263 12 RE	
263 12 OB	



PM steel

Standard stripper	
Art. no.	Price in EUR
263 01/1	
Close-fit stripper	
263 04/2	

Dies	PM
Art. no.	Price in EUR
263 10 RD	
263 20 SQ	
263 20 RE	
263 20 OB	

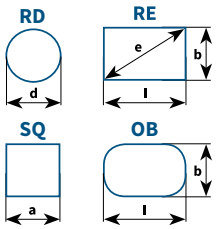


PM steel

OPTIONS

Surcharge for coatings
Price in EUR

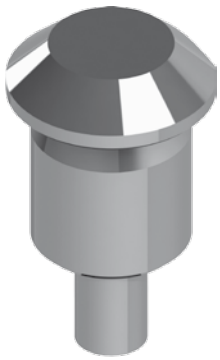
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2



DIETZ systeme

10-Station Multitool

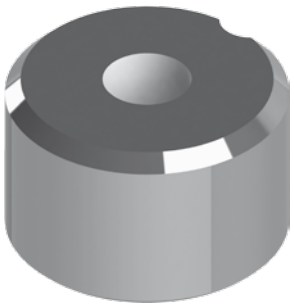
Range up to 10.5 mm



PM steel

Punches	PM
Art. no.	Price in EUR
264 11 DR	
264 12 QU	
264 12 RE	
264 12 LL	

Standard stripper	
Art. no.	Price in EUR
264 04/1	
Close-fit stripper	
264 04/2	



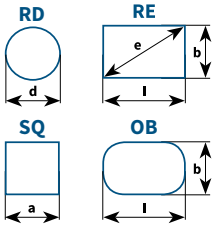
PM steel

Dies	PM
Art. no.	Price in EUR
264 10 DR	
264 20 QU	
264 20 RE	
264 20 LL	

OPTIONS

Surcharge for coatings
Price in EUR

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

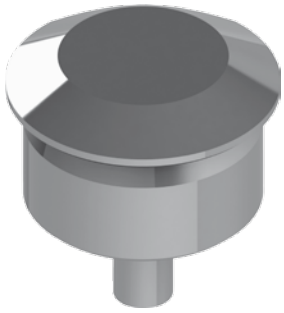


DIETZ systeme

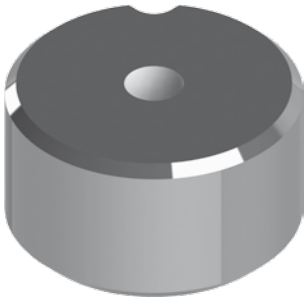
4-Station Multitool

Range up to 16 mm

Punches	
Art. no.	**Price in EUR**
261 11 DR	
261 12 QU	
261 12 RE	
261 12 LL	



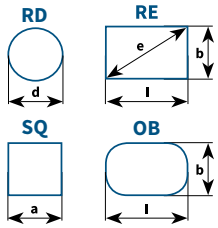
Dies	
Art. no.	**Price in EUR**
261 10 DR	
261 20 QU	
261 20 RE	
261 20 LL	



OPTIONS

Surcharge for coatings
Price in EUR

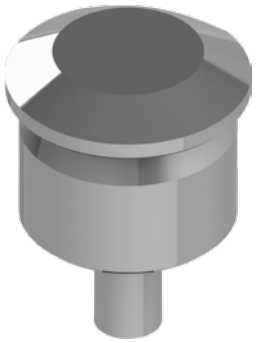
For a description of the shear bevels and coatings, refer to pages 7.4 and 7.5
Accessories: For alignment rings, washers, tooling cartridges, refer to pages 7.1 and 7.2



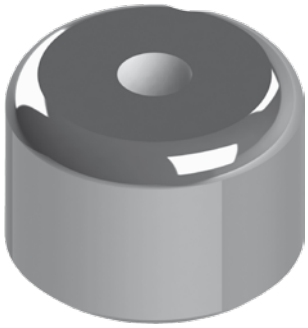
DIETZ systeme

6-Station Multitool

Range up to 10.5 mm



Punches	
Art. no.	**Price in EUR**
262 11 DR	
262 12 QU	
262 12 RE	
262 12 LL	



Dies	
Art. no.	**Price in EUR**
262 10 DR	
262 20 QU	
262 20 RE	
262 20 LL	

OPTIONS

Surcharge for coatings
Price in EUR

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

Continuous offset tool	**6.1**
Centre point	**6.2**
Spring-loaded countersink tool	**6.3**
Rigid countersink tool with PU stripper	**6.4**
Knock-out tool - round	**6.5**
Thread form tool	**6.6**
Continuous bending tool	**6.7**
Bridge tool	**6.8**
Extrusion tool	**6.9**
Louver tool	**6.10**
Continuous louver tool	**6.11**
Lance & Form tool	**6.12**
Cluster tool	**6.13**
Spring-loaded emboss tool	**6.14**
Rigid emboss tool	**6.15**
Marking tool - symbol	**6.16**
Logo tool (embossed)	**6.17**
Hinge tool	**6.18**
Multi hinge tool	**6.19**
Dimple tool	**6.20**
Bending tool	**6.21**
Countersink forming tool	**6.22**
Continuous beading tool	**6.23**
Half shear tool	**6.24**

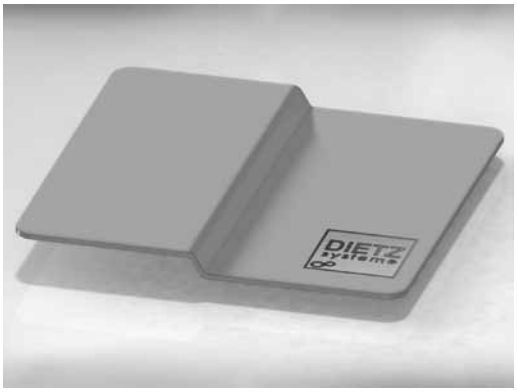
Template

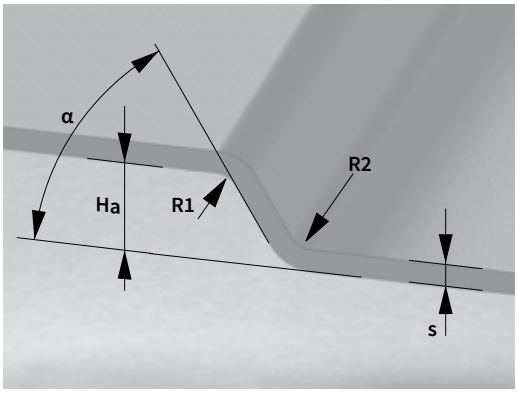
SPECIAL TOOL ORDER FORM

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.

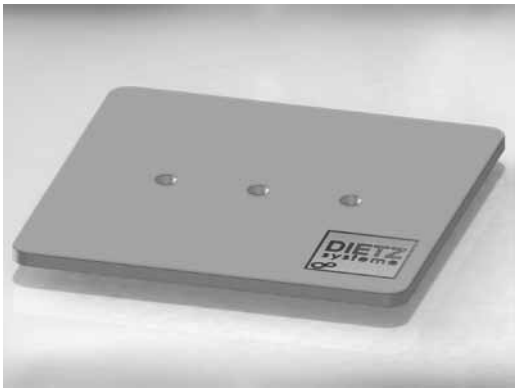
Template

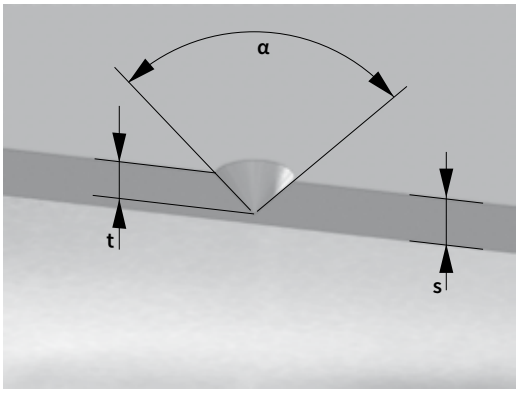
SPECIAL TOOL ORDER FORM

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.

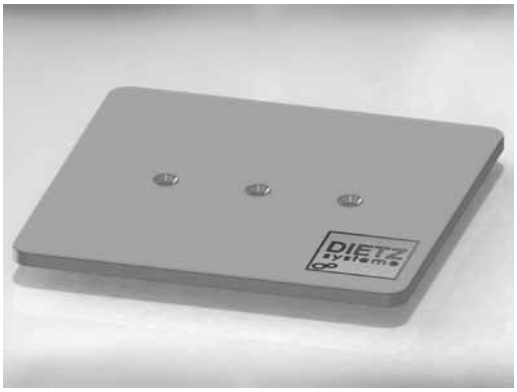
Template

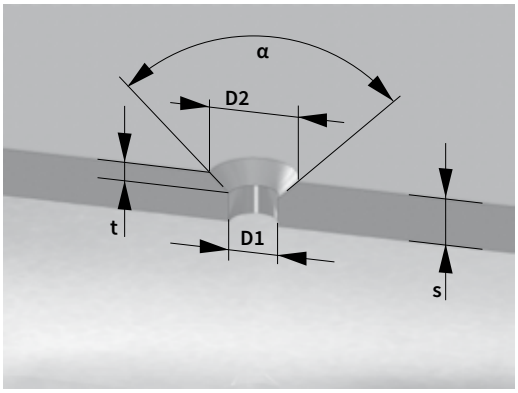
SPECIAL TOOL ORDER FORM

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.

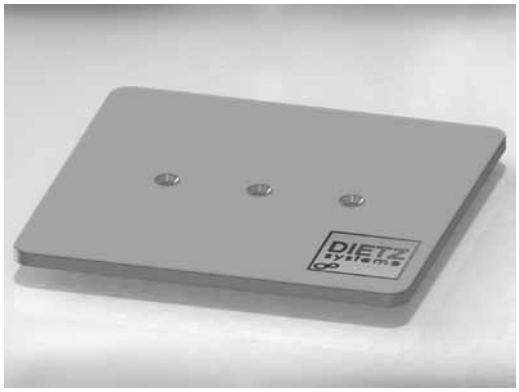
Template

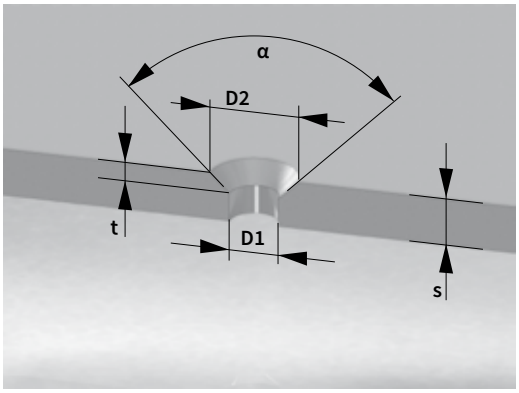
SPECIAL TOOL ORDER FORM

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.

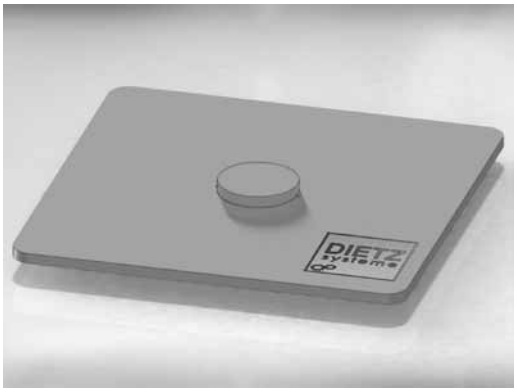
Template

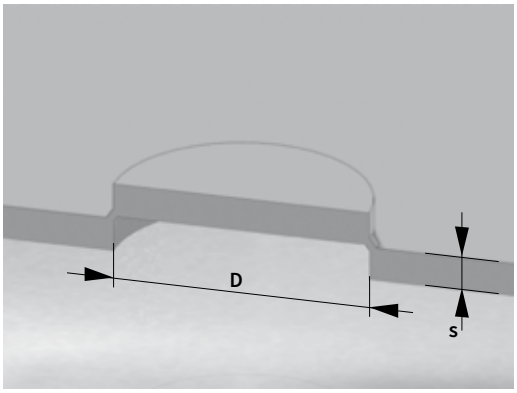
SPECIAL TOOL ORDER FORM

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.

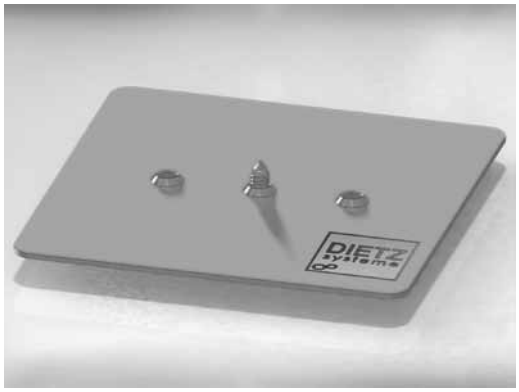
Template

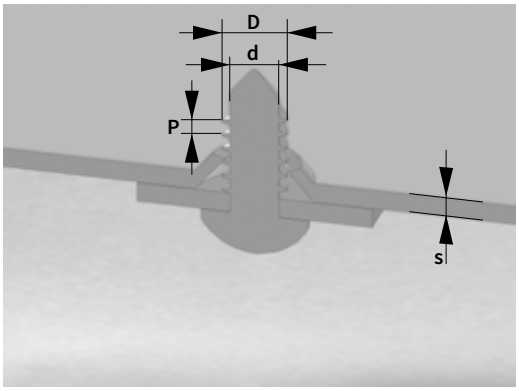
SPECIAL TOOL ORDER FORM

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.

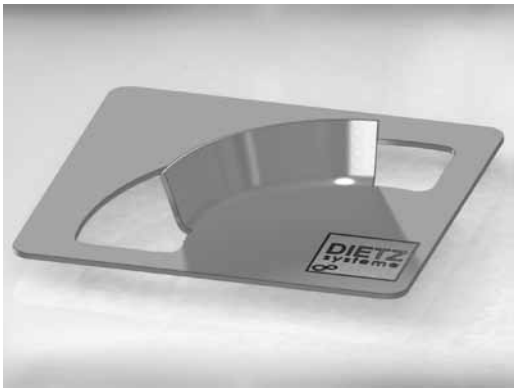
Template

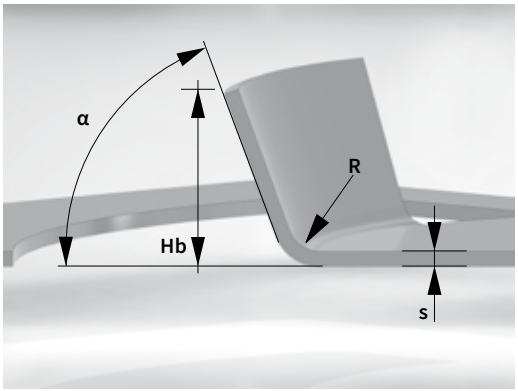
SPECIAL TOOL ORDER FORM

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.

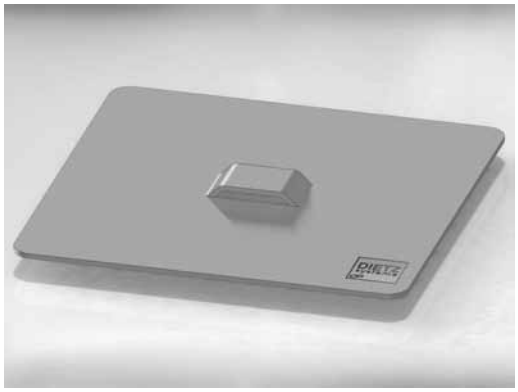
Template

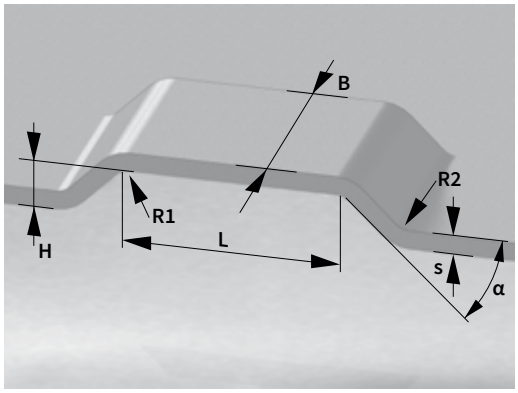
SPECIAL TOOL ORDER FORM

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

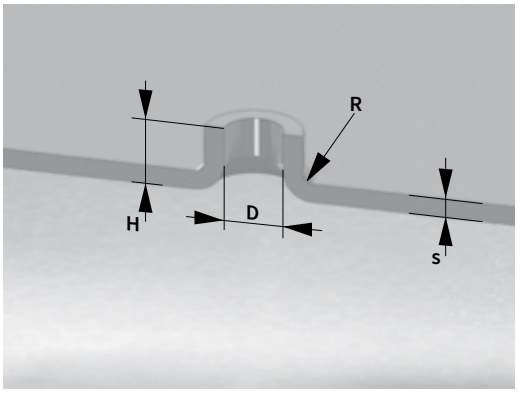
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

Template

SPECIAL TOOL ORDER FORM

Extrusion tool

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.

Template

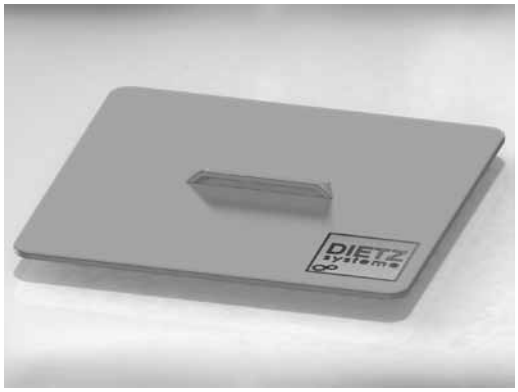
SPECIAL TOOL ORDER FORM

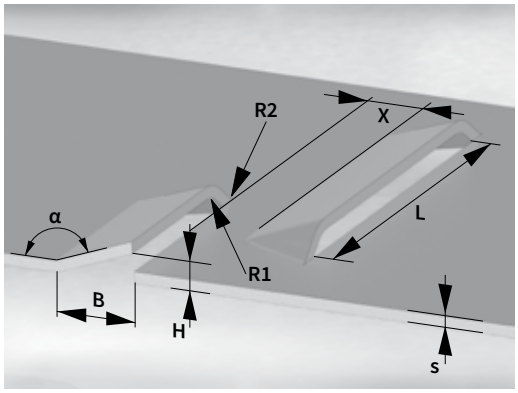
Louver tool

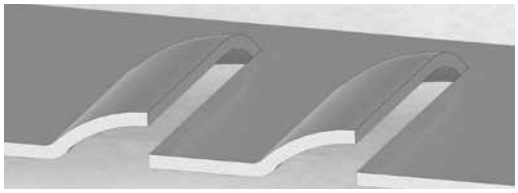
DIETZ systeme

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	

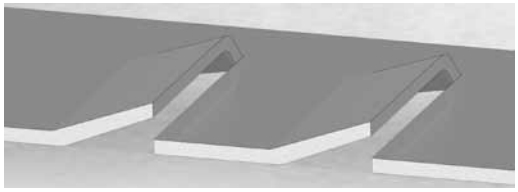
Example: Trumpf Tool System = **T**
Forming direction, upwards = **101** | Type, complete tool = **00** | Material, Carbon steel = **ST** | Sheet thickness s, 1.0 = **10** | Louver shape, shape A = **A** | Dimensions, W=8/ H=3 = **083** | Length L, 40.0 = **4** | **This creates following part number: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

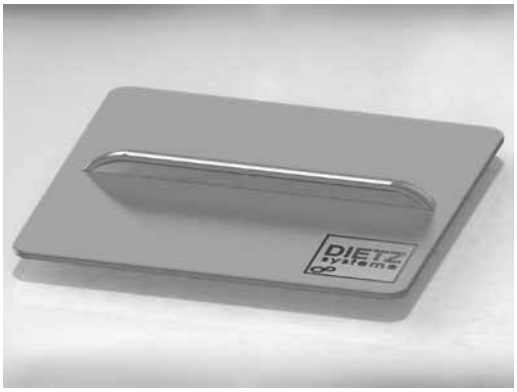
Please include drawings with your inquiry (DXF or STEP).
Please use the corresponding table to indicate special dimensions.

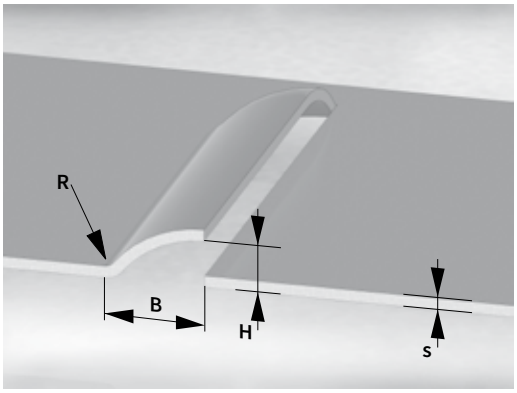
Template

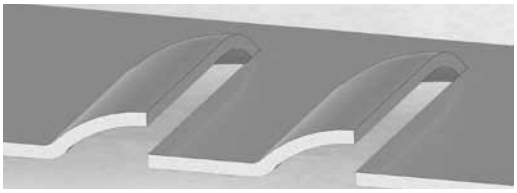
SPECIAL TOOL ORDER FORM

Continuous louver tool

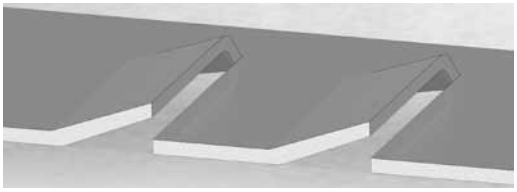
Mark with “X”					
Article number					
Basic information	1.	Trumpf Tool System		T	X
	2.	Forming direction	upwards	111	
			downwards	112	
	3.	Type	Complete tool	00	
			Top	01	
			Bottom	02	
			Louver bar for bottom	06	
	4.	Material	Carbon steel (CS)	ST	
			Aluminium	AL	
			Stainless steel (SS)	VA	
	5.	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.

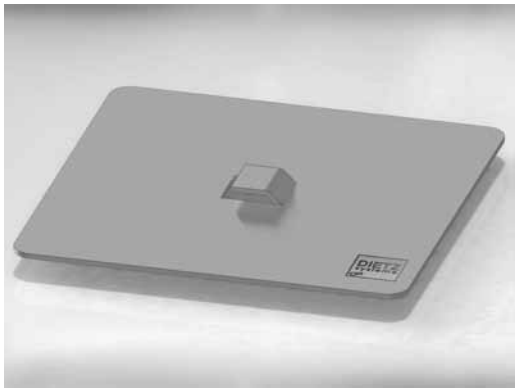
Template

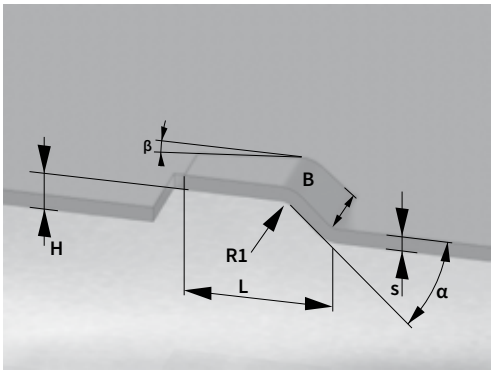
SPECIAL TOOL ORDER FORM

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.

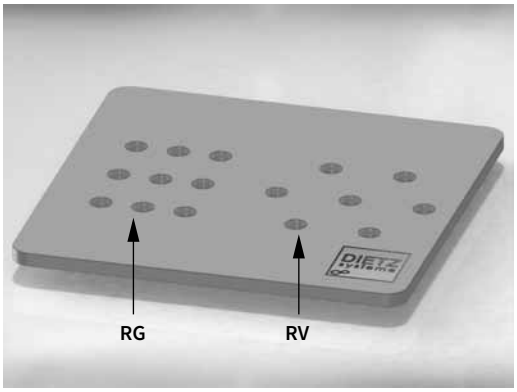
Template

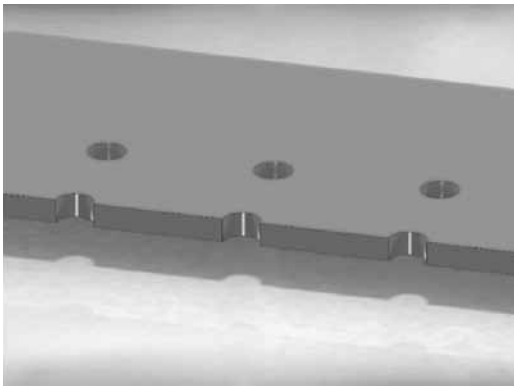
SPECIAL TOOL ORDER FORM

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.

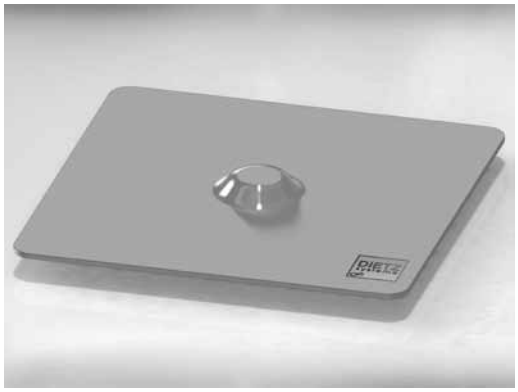
Template

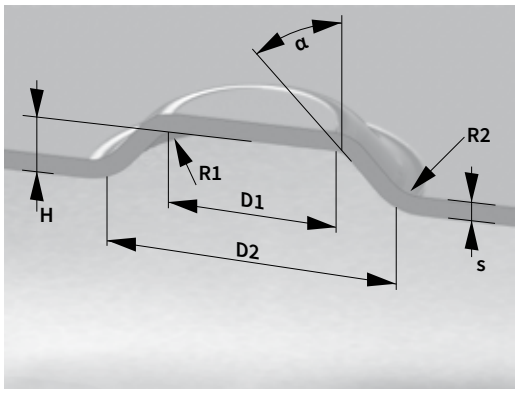
SPECIAL TOOL ORDER FORM

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.

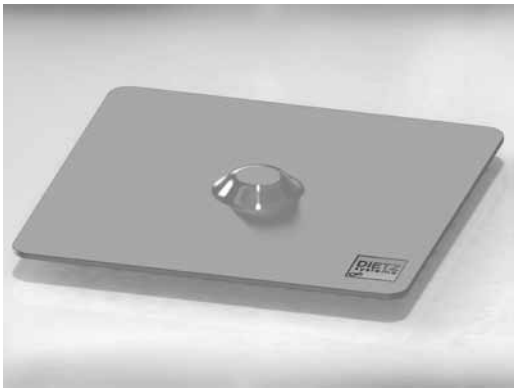
Template

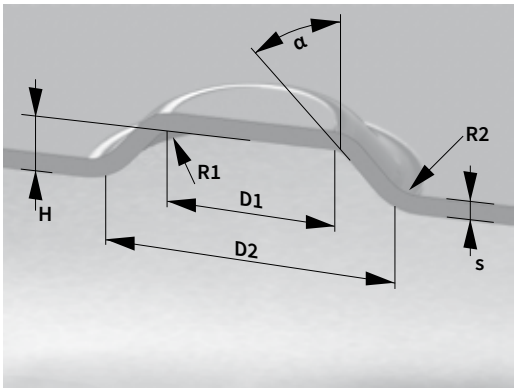
SPECIAL TOOL ORDER FORM

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.

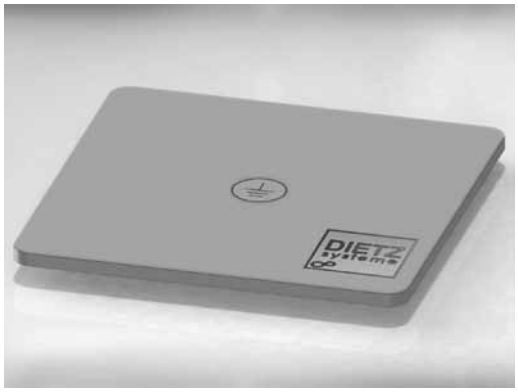
Template

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.

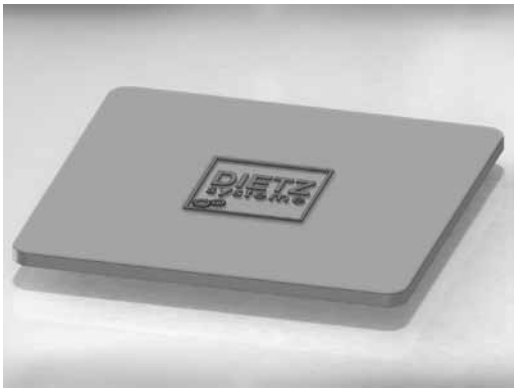
Template

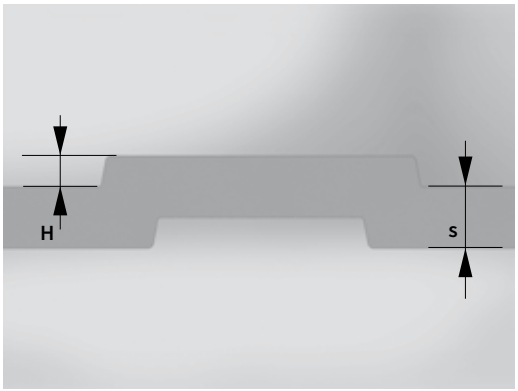
SPECIAL TOOL ORDER FORM

Logo tool (embossed)

DIETZ systeme

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.

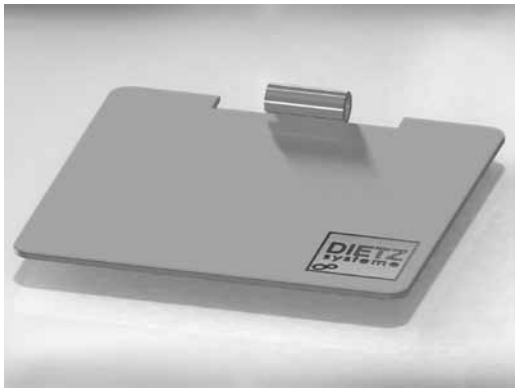
Template

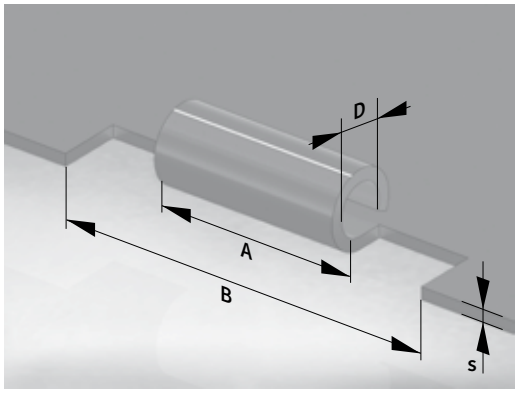
SPECIAL TOOL ORDER FORM

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.

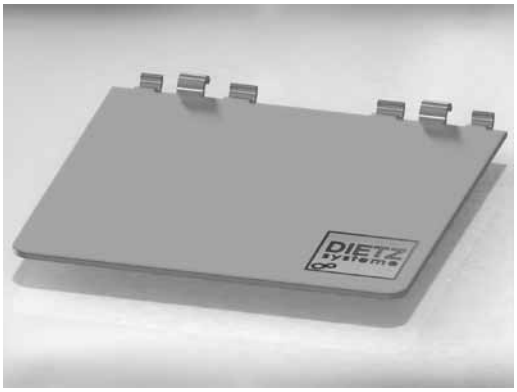
Template

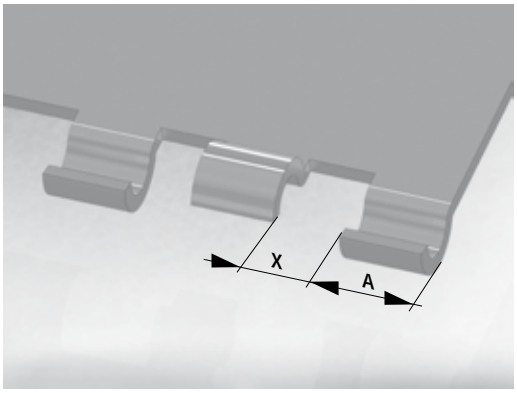
SPECIAL TOOL ORDER FORM

Multi hinge tool

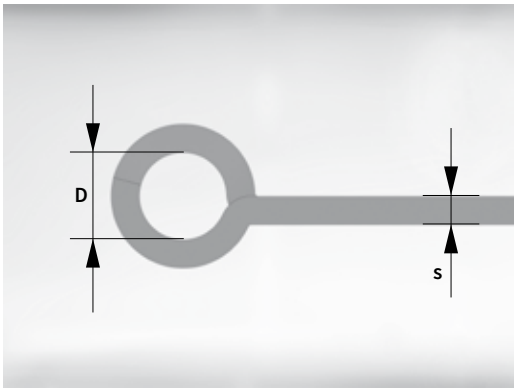
DIETZ systeme

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.

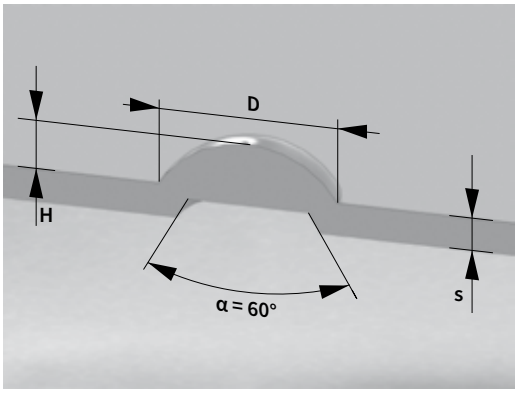
Template

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.

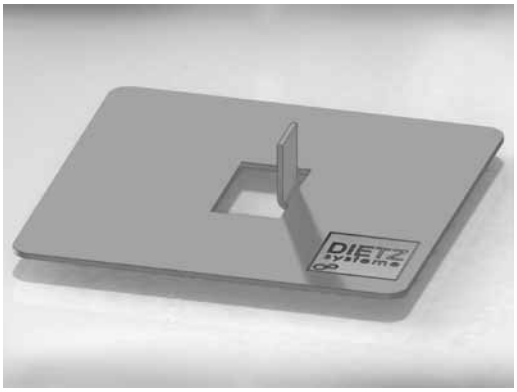
Template

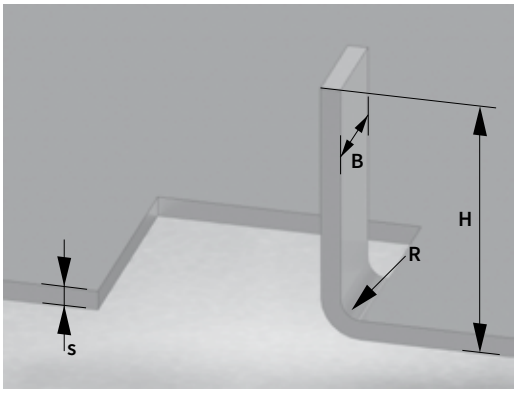
SPECIAL TOOL ORDER FORM

Bending tool

DIETZ systeme

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.

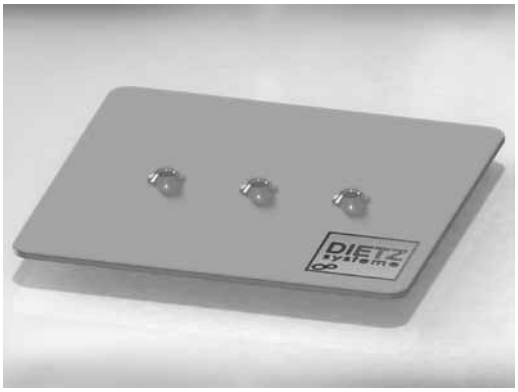
Template

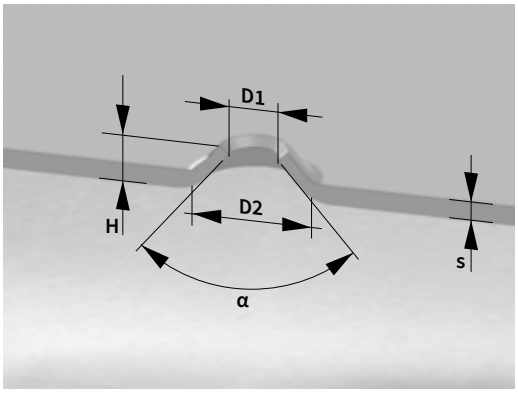
SPECIAL TOOL ORDER FORM

Countersink forming tool

DIETZ systeme

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.

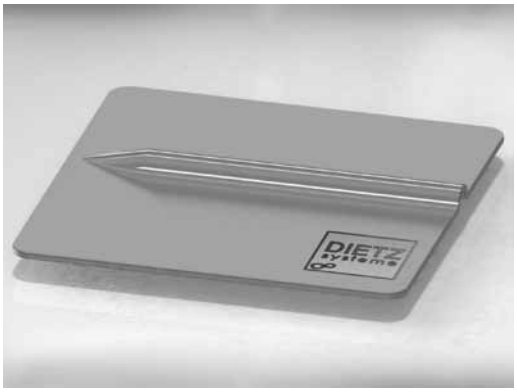
Template

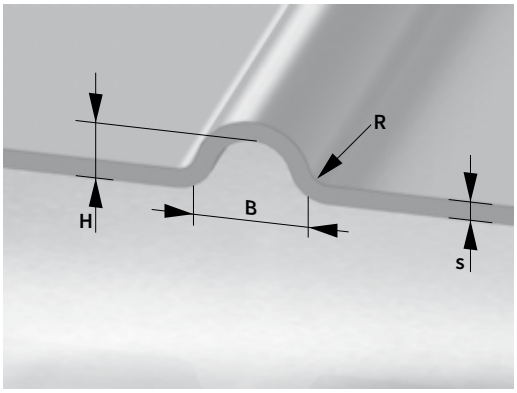
SPECIAL TOOL ORDER FORM

Continuous beading tool

DIETZ systeme

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.

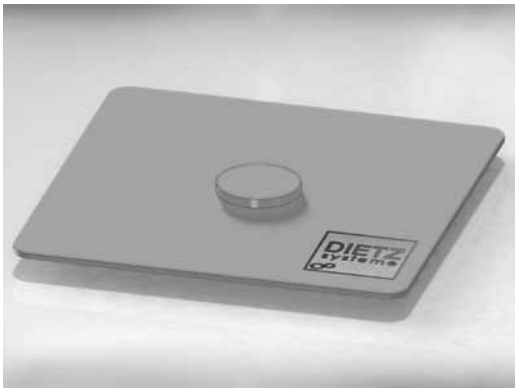
Template

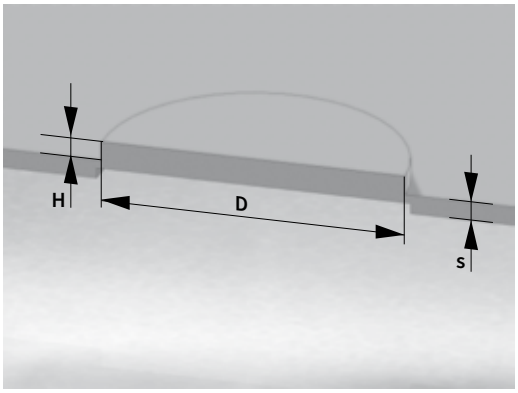
SPECIAL TOOL ORDER FORM

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

Alignmet rings | Adapter rings | Punch chucks | Tooling cartridges	**7.1**
Shims | DMW Cut Plus oil	**7.2**
PA stripper for scratch-free machining	**7.3**
Punch shear types	**7.4**
Punch coatings	**7.5**

ACCESSORIES AND INFORMATION

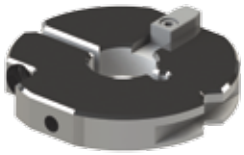
Alignment rings | Adapter rings | Punch chucks | Tooling cartridges

DIETZ systeme

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

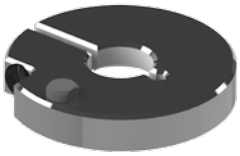
Size	Art. no.	Price in EUR
1	200 01	

Adjustment ring for cartridges with automatic tool changer



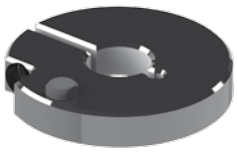
Size	Art. no.	Price in EUR
2 / 3	200 02	

Adjustment ring for manual tool change (with recess)



Size	Art. no.	Price in EUR
1	200 03	

Adjustment ring for manual tool change



Size	Art. no.	Price in EUR
2 / 3	200 04	

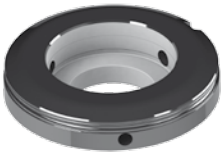
Alignment ring - heavy duty

Size	Art. no.	Price in EUR
1	200 11	

Punch chuck for punching needles

Range	Art. no.	Price in EUR
0.5 - 6.0	221 02	
6.1 - 10.5	222 02	

Die adapter



Size	Art. no.	Price in EUR
1 / 2	200 06	

Die adapter, incl. brush insert

Size	Art. no.	Price in EUR
1 / 2	200 06 B	

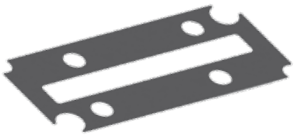
Tooling cartridges and die plates
Price on request and Die plates

Size 1

Size 2

Die shims size 1			
Size	**Thickness**	**Art. no.**	**Price in EUR**
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.**	**Price in EUR**
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	**Price in EUR/L**
1	
3	
5	
10	
25	

Multitool shim set			
Size	**Thickness**	**Art. no.**	**Price in EUR**
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	
1 set = 2 x 0.1 | 0.3 | 0.5			

ACCESSORIES AND INFORMATION

PA stripper for scratch-free machining

	Round		Shape	
	Art. no.	Price in EUR	Art. no.	Price in EUR
Complete	280 04 F PA	116.00	228 04 F PA	
Ring	280 04 F-1 PA	48.00	280 04 F-1 PA	
PA insert	280 04 F-2 PA	65.00	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 • Shear force reduced by up to 70% • Reduced noise • Less deformation of components	• Radial forces • Suitable for trimming, under certain conditions
	DOWT	• Easy regrinding • No radial forces • Shear force reduced by up to 35%	• Not suitable for trimming
	WTC	• Reduced corner load • Less deformation of components	• Radial forces
	2PT	• No radial forces • Optimum punching cut • Suitable for trimming	• Only viable for large, thin contours • Difficult to regrind
	4PT	• No radial forces • Optimum punching cut • Suitable for trimming	• Only viable for large contours • Difficult to regrind

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

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

Hardness in HV	Friction coefficient	Colour	Characteristics	
3000	0.1	black	• Reduced adhesion • Combination of high degree of hardness and extremely low friction coefficient	**HT**

Application
- Aluminium
- Punching/ Slitting
- Precision Slitting
- Cold forming

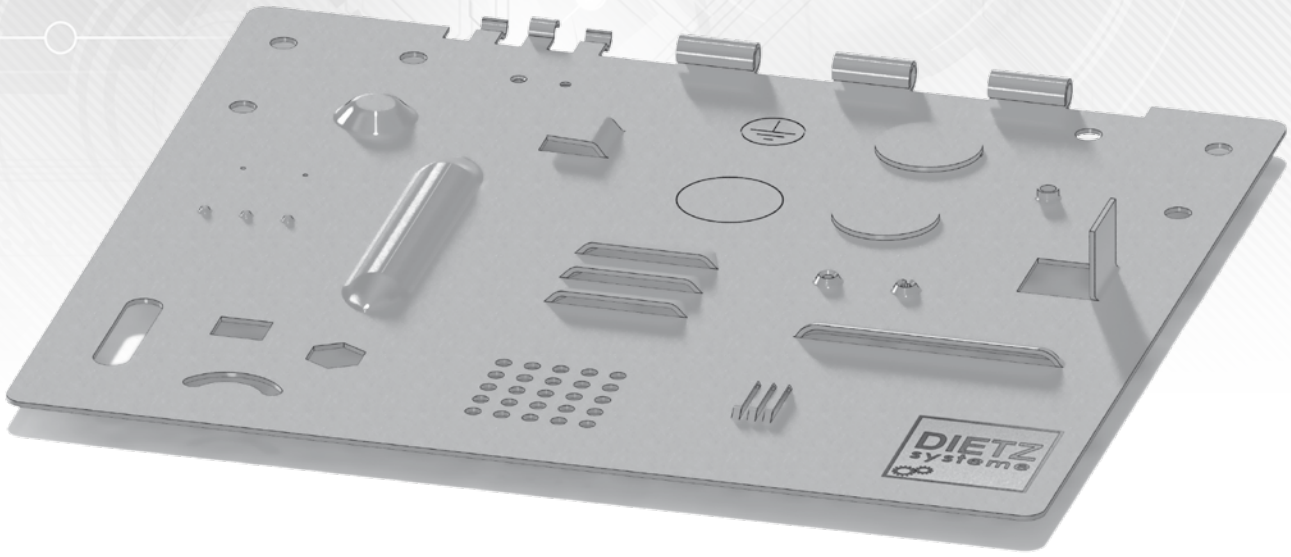
Hardness in HV	Friction coefficient	Colour	Characteristics	
3500 ± 500	0.2	Antique pink	• Low friction • High oxidation resistance	**VT**

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

DMW Maschinen- und Werkzeugbau GmbH

DIETZ systeme



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