

Stamping Dies (Metal forming):

Spend Volume per Year (Europe):

- approximately €50 Mio.

Number of dies per Year:

- 250 - 300 Dies

Types of Dies:

- Transfer Dies (48%)
- Progressive Dies (28%)
- Manuel Dies (4%)
- Hotforming Dies (20%)

Die sizes:

- From 1.000 mm up to 6.000 mm length

to be used on Mechanical Presses:

- Presses from 250to up to 2500to
- Automatic Presses with Decoiling line, with Transfer System and without

Materials (from coils):

- For Cold forming: Mainly carbon steels, up to 1200 MPa yield strength
- For Hot forming: Uncoated or AlSi coated, 1500 – 2000 MPa yield strenth (after hardening process)
- Aluminium (max. 10% of dies)

Material Thickness to be processed with the stamping dies:

- From 0,30 mm up to 12,00 mm (main range 0,5mm to 2,5mm)