



böhlerstrip®

**Rule Die Steel
– the unmatched.**



It is in shape for a fast and changing world.

What makes our rule die steel so unique?

Leading the Industry

bohlerstrip is the premium rule die steel manufacturer and the specialist which does not accept any compromise in quality. Our metallurgical know-how combined with highest standards in cold rolling, profiling and edge machining guarantee best cutting results for all kind of applications.

In our industry we offer the widest range of products. These are available world-wide through our own subsidiaries and a professional distribution network in over 60 countries.

We are partner of the industry and develop optimized solutions with enhanced properties for our customers.

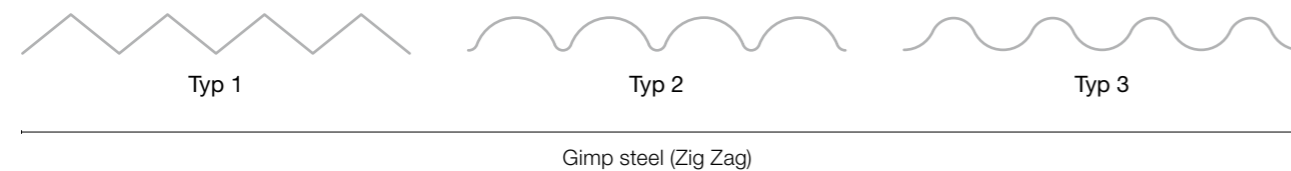
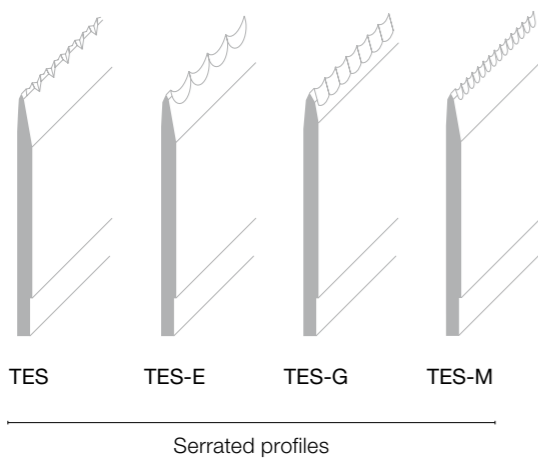
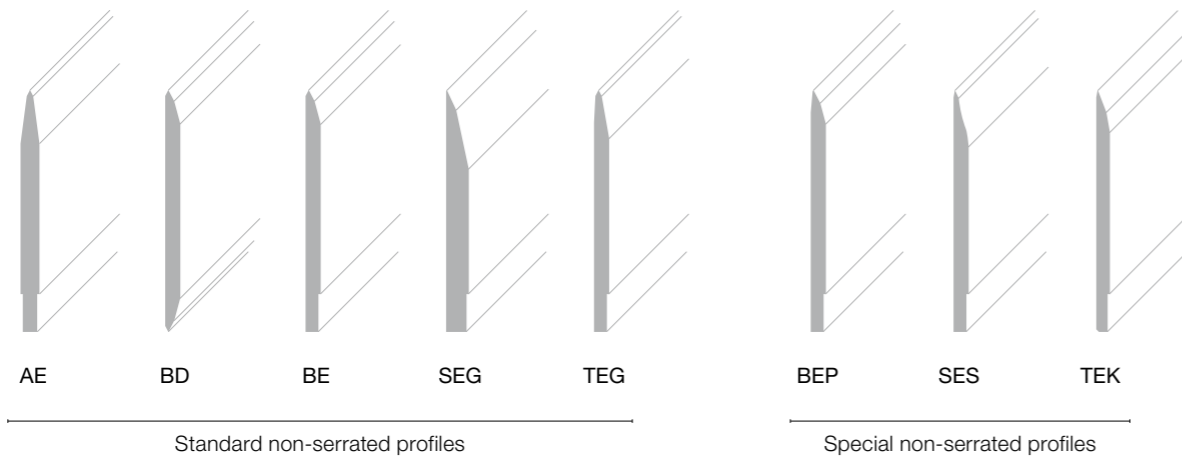
Product Features:

- Best bendability
- High rule die lifetime
- Best dimensional tolerances
- Uniform and stable top quality

bohlerstrip Rule Die Steel

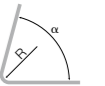
Meeting the requirements of each cutting job in the perfect way, bohlerstrip offers the widest range of profiles in the rule die steel industry:

Standard non-serrated profiles, Special non-serrated profiles, Serrated profiles and Gimp steel.



Steel Grades – Hardness

Not only profile design but also hardness matters. In order to achieve best results for a wide range of applications we offer the following steel grades:



HF Orange

High-frequency (HF) edge hardened top-quality steel, optimised for best bendability, best durability and outstanding cutting performance.

Thickness	≤2.0mm	2.5mm	2.8mm	3.0mm	>3.0mm
Hardness					
Body	36–40HRC	35–39HRC	35–39HRC	34–38HRC	30–35HRC
Edge	~510HV (50HRC)				
Bendability	α = 60°	α = 80°	α = 85°	α = 90°	α = 90°
Packaging	orange				

Yellow

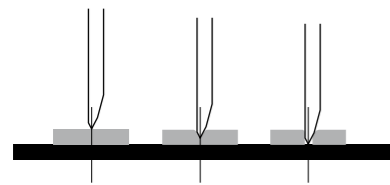
Increased body hardness for higher stability in die cutting – no HF hardened cutting edge.

Thickness	≤2.0mm	2.5mm	2.8mm	3.0mm	>3.0mm
Hardness					
Body	40–44HRC	39–44HRC	-	-	-
Edge	40–44HRC	39–44HRC	-	-	-
Bendability	α = 90°	α = 90°	-	-	-
Packaging	yellow				

HF Yellow

Higher body hardness combined with HF hardened cutting edge for heavy duty applications.

Thickness	≤2.0mm	2.5mm	2.8mm	3.0mm	>3.0mm
Hardness					
Body	40–44HRC	39–44HRC	-	-	-
Edge	~510HV (50HRC)				
Bendability	α = 90°	α = 90°	-	-	-
Packaging	yellow				



Single-layer Cutting

Non-serrated profiles, for leather cutting

AE



Dimensions [mm]	Application
19 x 2.0 / 2.5	Shoes
32 x 2.0 / 2.5	

Symmetric profile for slitting knives

BD



Dimensions [mm]	Application
19 x 2.0 / 2.5	Shoes, gloves
32 x 2.0 / 2.5	

Double-edge profile for single-layer leather cutting

BE



Dimensions [mm]	Application
19 x 2.0 / 2.5	Shoes, gloves, bags
32 x 2.0 / 2.5 / 2.8	
50 x 2.8	

Basic-type profile for single-layer leather cutting

BEP



Dimensions [mm]	Application
19 x 2.0	Shoes
32 x 2.0	

Polished inside bevel for extra clean cutting results

Non-serrated profiles, for cutting hard and rigid materials

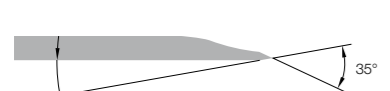
SEG



Dimensions [mm]	Application
19 x 2.0 / 2.5	Outsoles, gaskets
32 x 2.0 / 2.5	

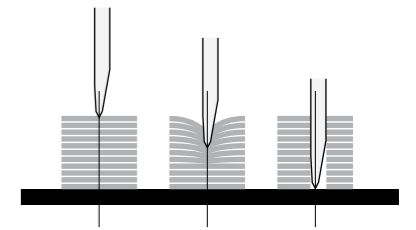
Profile for cutting hard and rigid materials, extra short inside bevel

SES



Dimensions [mm]	Application
32 x 2.0 / 2.5	Rubber, plywood, insole material

Extra sharp cutting edge angle which minimizes material displacement



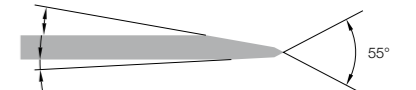
Multi-layer Cutting

Non-serrated profiles, for textile cutting

TEG

Dimensions [mm]	Application
19 x 2.0	Synthetic, TPU
32 x 2.0 / 2.5	
50 x 2.5 / 2.8	

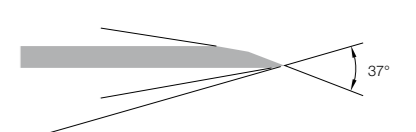
Very popular profile with standard bevel angle and long secondary inside bevel which guarantees best dimensional tolerances of material cut in multi-layers



TEK

Dimensions [mm]	Application
32 x 1.8	Synthetic, TPU

Sharp cutting edge angle, optimized to cut thin and rigid material

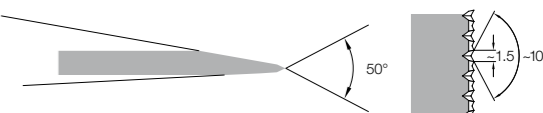


Serrated profiles, for cutting engineered and high performance materials

TES

Dimensions [mm]	Application
19 x 2.0	Elastic materials
32 x 2.0	

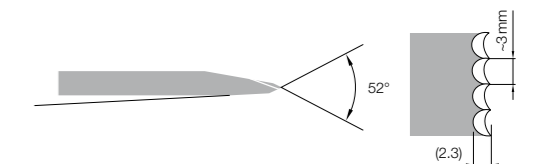
Basic serrated profile



TES-E

Dimensions [mm]	Application
19 x 2.0	Elastic materials, mesh, engineered mesh
32 x 2.0 / 2.5	

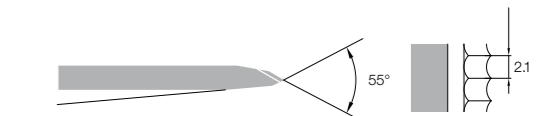
Economic version of serrated RDS



TES-G

Dimensions [mm]	Application
19 x 2.0 / 2.5	Mesh, engineered mesh, Goretex
32 x 2.0 / 2.5	

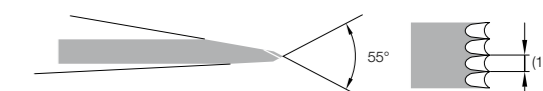
Fine serrated cutting edge RDS



TES-M

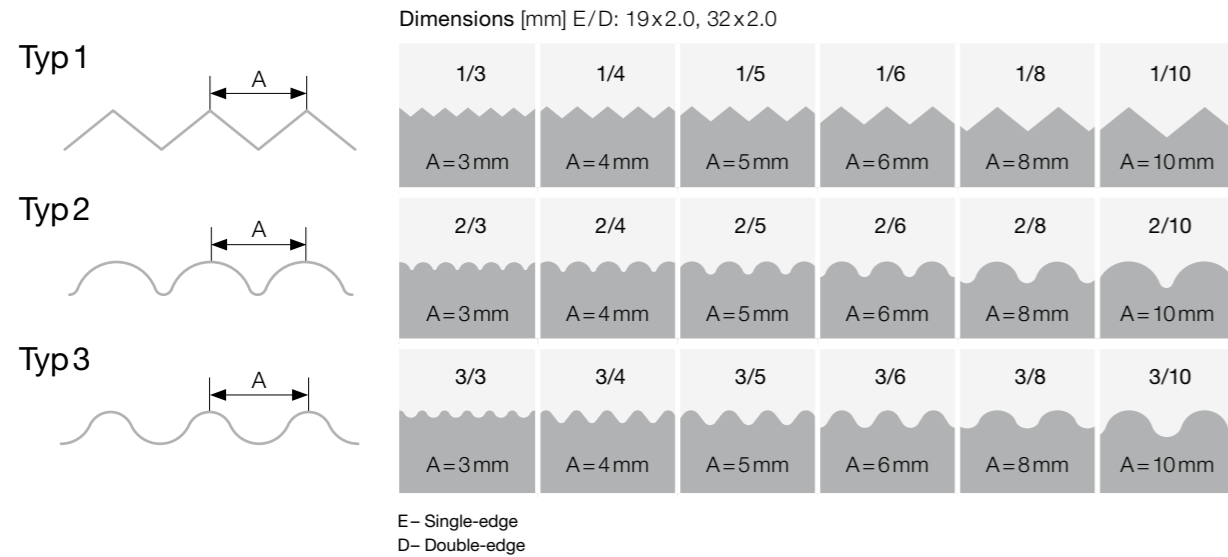
Dimensions [mm]	Application
32 x 2.0	Thin fibre materials, mesh, engineered mesh
50 x 2.8	

Super fine serrated cutting edge RDS



Gimp Steel (Zig Zag)

For decoration purposes in the fashion shoe industry.



Forms of Delivery



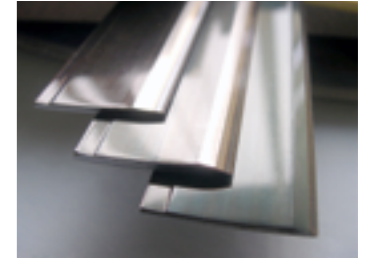
Packaging:

All coils are secured with a steel strap for safety-reasons (outside-diameter 560 mm or 700 mm). Additionally the coils are double-wrapped in in anti-corrosion paper and packed in single carton boxes.

For transport each coil is packed in sliding boxes made of corrugated cardboard. Additional packing in wodden cases ensure safe overseas shipment.

Coil lengths	at steel heights of [mm]	
Thickness [mm]	19-36	37-52
1.8	~ 75m	~ 70m
2.0	~ 75m	~ 65m
2.5	~ 60m	~ 50m
2.8	~ 55m	~ 45m
3.0	~ 50m	~ 40m
3.5	~ 45m	~ 35m
4.0	~ 40m	~ 30m

Matrix



bohlerstrip Rule Die Steel

Profiles	Edge	Single-layer cutting						Multi-layer cutting					Gimp Steel				
		AE	BD	BE	BEP	SEG	SES	TEG	TEK	TES	TES-E	TES-G	TES-M	TYP1	TYP2	TYP3	
Edge	Single	•		•	•	•	•	•	•	•	•	•	•	•	•	•	•
	Double		•												•	•	•
Applications		Single-layer cutting						Multi-layer cutting					Gimp Steel				
Leather shoes		•	•	•	•										•	•	•
Leather gloves			•	•													
Leather bags				•													
Outsoles						•											
Gaskets						•											
Rubber, plywood, insole material							•										
Synthetic, TPU								•	•								
Elastic materials										•	•						
Mesh, engineered mesh												•	•				
Goretex												•					
Thin fibre materials													•				
Dimension [mm]	Heights	Thickness	Single-layer cutting						Multi-layer cutting					Gimp Steel			
	19	2.0	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
		2.5	•	•	•		•					•					
	32	1.8							•								
		2.0	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
		2.5	•	•	•		•	•	•	•		•	•				
		2.8			•												
	50	2.5							•								
		2.8							•				•				
Profiles			AE	BD	BE	BEP	SEG	SES	TEG	TEK	TES	TES-E	TES-G	TES-M	TYP1	TYP2	TYP3

Quality Assurance

There are many ways to define quality but only one standard that really matters: Your satisfaction!

Our Target – Quality Competence

With almost 150 years of experience in converting of steel into components for high-grade final products we honor the concept of a good partnership. For us the first step towards an optimum solution is to understand our customers' demands.

Quality is an essential part of our corporate culture, and this is reflected in all areas of our business activities. Close relationship with customers, reliability and quick decision-making are essential elements of our organisation. Many of our innovations and solutions are permanently enhanced for customers benefit.

voestalpine Precision Strip has the most up-to-date laboratory and testing knowledge. We are of course certified according to EN ISO 9001 and EN ISO 14001 (environmental approval).



The Company

Experience in steel manufacturing – from iron ore to serrated rule die steel – the entire production chain is within our group.

Continuous innovation and investment to be one step ahead – we are world market leader in high quality rule die steel.

Short lead times and fast reaction to customer requirements – our additional small unit facilities in China and USA ensure best service.

Product developments and new solutions for market demands – our in-house R&D center with profound knowledge in steel processing and application guarantees our success.

Customer care and direct contact with the factory – our global distribution network and experienced outside sales staff take care of your specific issue.

Strip Steel Technology since 1872.

bohlerstrip Facts

Words are nice. Facts are better.

The Precision Strip group

Production locations in Austria and Sweden.

Production in Europe's most modern cold rolling mill in Kematen an der Ybbs, Austria, since 2011.

Stockholding distribution offices in Austria, Sweden, China, United States, Spain and Mexico.

Worldwide more than 1,100 employees.

Since 2007 member of the voestalpine AG, Austria.

Renaming in April 2015

from Bohler-Uddeholm Precision Strip GmbH to voestalpine Precision Strip GmbH

Core business

- Bimetal strip for the metal saw industry
- Special precision strip for different applications
e.g. for knives, springs, special saws, electronic parts, razor blades, scalpels and flapper valves
- Steel rules for the packaging industry
- Rule die steel for the leather and textile industry
- Wood band saw and circular saw steel
- Stone saw steel for marble cutting
- Coating and creping blades for the pulp and paper industry

voestalpine
ONE STEP AHEAD.



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