

STEEL RULE GUIDE TECHNICAL INFORMATION

(Base Information Gathered In 1999 Please Contact The Manufacturer For Their Most Up To Date Information.)

BOHLER Telephone USA and Canada 800 638 2520

Rule Type or Name	Supreme	Supreme 60	K-Back	K-Back 60	Universal	Universal 60
Bevel Angle	47°	47°	45°	45°	53°	53°
Edge Type	Ground	Ground	Shaved	Shaved	Shaved or Ground	Shaved or Ground
Body Rockwell	34	45	34	45	34	45
Cutting Edge Rockwell	59	59	59	59	59	59
Body Coating	Rust Inhibitor on all.					
Edge Coating	molybdenum	molybdenum	Moly Avail.	Moly Avail.	None	None
Decarb. Thickness	N/A	N/A	N/A	N/A	N/A	N/A
Cut Edge Hardening Method	Induction	Induction	Induction	Induction	Induction	Induction
Minimum Bend Radius	.016"	.02"	.012"	.016"	.012"	.016"
Maximum Angle at the Minimum Bend Radius	85°	85°	85°	85°	85°	85°
Standard Heights	.315" - 3.397"	.315" - 3.397"	.315" - 3.397"	.315" - 3.397"	.315" - 3.397"	.315" - 3.397"
Height Tolerance	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"
Pricing	\$\$\$	\$\$\$	\$\$	\$\$	\$\$	\$\$
Special Notes	Engineered with fine grain structure and tight tolerances for durability and ease of use in automatic and manual bending.					

BOHLER (Continued)

Rule Type or Name	Universal 75	Top	H75
Bevel Angle	53°	53°	53°
Edge Type	Shaved or Ground	Shaved	Shaved
Body Rockwell	51	45	51
Cutting Edge Rockwell	59	45	51
Body Coating	Rust Inhibitor on all.		
Edge Coating	None	None	None
Decarb. Thickness	N/A	N/A	N/A
Cut Edge Hardening Method	Induction	None	None
Minimum Bend Radius	.066"	.016"	.066"
Maximum Angle at the Minimum Bend Radius	90°	85°	90°
Standard Heights	.315" - 3.397"	.315" - 3.397"	.315" - 3.397"
Height Tolerance	±.0008"	±.0008"	±.0008"
Pricing	\$\$	\$	\$

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Essmann & Schaefer Telephone 0202 / 46 10 50 Germany

Rule Type or Name	H2	H3	H4	H2 TopDur Flex	H2 TopDur Flex Special 60W
Bevel Angle	54° and 42°	54° and 42°	54° and 42°	54° and 42°	54° and 42°
Edge Type	Ground or Shaved	Ground or Shaved	Ground or Shaved	Ground or Shaved	Ground or Shaved
Body Rockwell	36	43	50	36	36
Cutting Edge Rockwell	36	43	50	53	53
Body Coating	None	None	None	None	None
Edge Coating	None	None	None	None	None
Decarb. Thickness	.004"	.004"	.004"	.004"	.004"
Cut Edge Hardening Method	None	None	None	High Frequency	High Frequency
Minimum Bend Radius	.019"	.031"	.043"	.019"	.019"
Maximum Angle at the Minimum Bend Radius	50	60	90	50	50
Standard Heights	.937", .918"	.937", .918"	.937", .918"	.937", .918"	.937", .918"
Height Tolerance	±.0004"	±.0004"	±.0004"	±.0004"	±.0003"
Pricing	N/A	N/A	N/A	N/A	N/A
Special Notes	H2 TopDur Flex Special 60W is micro ground and carries US Patent # 4.829.854 All rules are available in both strips and coils.				

J.F. Helmold & Bro., Inc. Telephone (847) 437 7085 USA

Rule Type or Name	Lazer Blade	Helmex	Helmex	S-70	S-70	70	70
Bevel Angle	40°, 50°, 60°	40°, 50°, 60°	60°	40°, 50°, 60°	60°	40°, 50°, 60°	60°
Edge Type	Shaved	Shaved	Ground	Shaved	Ground	Shaved	Ground
Body Rockwell	33-35	40-42	40-42	43-46	43-46	47-50	47-50
Cutting Edge Rockwell	59-61	40-42	40-42	43-46	43-46	47-50	47-50
Body Coating	Proprietary Rust Preventative Coating						
Edge Coating	None	None	None	None	None	None	None
Decarb. Thickness	.001"	.0005"	.0005"	.0005"	.0005"	.0005"	.0005"
Cut Edge Hardening Method	Laser	None	None	None	None	None	None
Minimum Bend Radius	.005"	.015"	.015"	.040"	.040"	.062"	.062"
Maximum Angle at the Minimum Bend Radius	160°	160°	160°	180°	180°	180°	180°
Standard Heights	.918", .923", .937"	.918", .923", .937"	.918", .923", .937"	.918", .923", .937"	.918", .923", .937"	.918", .923", .937"	.918", .923", .937"
Height Tolerance	±.001" **	±.001"	±.001"	±.001"	±.001"	±.001"	±.001"
Pricing	\$\$	\$	\$	\$	\$	\$	\$
Special Notes	** Laser Blade has a matched height tolerance of ±.00025" within a single box of rule.						

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J.F. Helmold & Bro., Inc. (cont.)

Rule Type or Name	Duredge	Bendex	Bendex
Bevel Angle	50°	40°, 50°, 60°	60°
Edge Type	Shaved	Shaved	Ground
Body Rockwell	33-35	43-46	43-46
Cutting Edge Rockwell	56	43-46	43-46
Body Coating	Proprietary Rust Preventative Coating		
Edge Coating	None	None	None
Decarb. Thickness	.001"	.0005"	.0005"
Cut Edge Hardening Method	Induction	None	None
Minimum Bend Radius	.015"	.020"	.020"
Maximum Angle at the Minimum Bend Radius	160°	90°	90°
Standard Heights	.937"	.918", .923", .937"	.918", .923", .937"
Height Tolerance	±.001"	±.001"	±.001"
Pricing	\$\$	\$	\$
Special Notes			

Martin Miller North America, Inc. Telephone (770)434-3366 USA

Rule Type or Name	MM44	MM47	Flex34HF	Flex40HF	Flex34HP	Flex40HP	Flex47HP
Bevel Angle	54° or 42°	54° or 42°	54° or 42°	54° or 42°	54° or 42°	54° or 42°	54° or 42°
Edge Type	Shaved	Shaved	Shaved	Shaved	Shaved	Shaved	Shaved
Body Rockwell	44	47	34	40	34	40	47
Cutting Edge Rockwell	44	47	53	53	61	61	61
Body Coating	None	None	None	None	None	None	None
Edge Coating	Moly or Titan	Moly or Titan	Moly or Titan	Moly or Titan	Moly or Titan	Moly or Titan	Moly or Titan
Decarb. Thickness	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Cut Edge Hardening Method	None	None	High Frequency	High Frequency	Plasma	Plasma	Plasma
Minimum Bend Radius	.008"	.008"	N/A	.008"	.008"	.008"	N/A
Maximum Angle at the Minimum Bend Radius	110°	110°	N/A	130°	130°	130°	N/A
Standard Heights	.393" to 4.330"	.393" to 4.330"	.393" to 4.330"	.393" to 4.330"	.393" to 4.330"	.393" to 4.330"	.393" to 4.330"
Height Tolerance	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"
Pricing	\$\$	\$\$	\$\$	\$\$	\$\$	\$\$	\$\$
Special Notes	Fine grain steel for automatic bending. Special straightness for automatic cutting. Moly and Titan coatings are shortened names for Molybdenum and Titanium coatings.						

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Notting Telephone (44) 181-801-6667 UK

Rule Type or Name	Superflex	NX3 Easy Bend	GX3 Easy Bend	NX3	GX3	Super 63
Bevel Angle	54°,52° 48°,42°	54°,52° 48°,42°	54°,52° 48°,42°	54°,52° 48°,42°	54°,52° 48°,42°	54°
Edge Type	Shaved	Shaved	Ground	Shaved	Ground	Shaved
Body Rockwell	34-38	38-42	38-42	44-47	44-47	48-52
Cutting Edge Rockwell	55-58	54-56	54-56	44-47	44-47	48-52
Body Coating	Lightly Oiled					
Edge Coating	None	None	None	None	None	None
Decarb. Thickness	.005"	.007"	.007"	.007"	.007"	None
Cut Edge Hardening Method	Induction	Induction	Induction	None	None	None
Minimum Bend Radius	.012"	.016"	.019"	.016"	.019"	.120"
Maximum Angle at the Minimum Bend Radius	165°	165°	165°	165°	165°	120°
Standard Heights	.918",.937"	.918",.937"	.918",.937"	.918",.937"	.918",.937"	.918",.937"
Height Tolerance	±.0005"	±.0005"	±.001"	±.0005"	±.001"	±.0005"
Pricing	\$\$	\$\$	\$\$	\$\$	\$\$	\$\$
Special Notes	Superflex, NX3 Easy Bend, and GX3 Easy Bend Rules have been developed to work well with rule processors.					

Sandvik Telephone (616)926-7241 USA

Rule Type or Name	Dieflex	Dieflex-A	Dieflex Ultra	Dieflex Hard	XD-700	Vertex
Bevel Angle	52°, 42°	52°, 42°	52°, 42°	52°, 42°	52°, 42°	52°, 42°
Edge Type	Ground or Shaved	Ground or Shaved	Shaved	Ground or Shaved	Shaved	Ground or Shaved
Body Rockwell	35	39	35	41	41	44
Cutting Edge Rockwell	56	56	56	56	60	44
Body Coating	Oil/Dry Protection on all rules					
Edge Coating	None	None	Low Friction	None	None	None
Decarb. Thickness	.0035"	.0035"	.0035"	.0035"	.0035"	.0039"
Cut Edge Hardening Method	High Frequency	High Frequency	High Frequency	High Frequency	High Frequency	None
Minimum Bend Radius	.0138"	.0138"	.0138"	.0138"	.0138"	.0138"
Maximum Angle at the Minimum Bend Radius	60°	30°	60°	70°	110°	60°
Standard Heights	.937"	.937"	.937"	.937"	.937"	.937"
Height Tolerance	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"
Pricing	\$\$	\$\$	\$\$\$	\$\$	\$\$	\$
Special Notes						

Seaboard Telephone (860)582-6614 USA

Rule Type or Name	Medium	Medium Hard	Hard	Extra Hard	Soft
Bevel Angle	60°	60°	60°	60°	60°
Edge Type	Ground	Ground	Ground	Ground	Ground
Body Rockwell	36-39	41-44	46-49	51-54	Annealed / Soft
Cutting Edge Rockwell	36-39	41-44	46-49	51-54	Annealed / Soft
Body Coating	Rust Inhibitor on all				
Edge Coating	None	None	None	None	None
Decarb. Thickness	N/A	N/A	N/A	N/A	N/A
Cut Edge Hardening Method	None	None	None	None	None
Minimum Bend Radius	N/A	N/A	N/A	N/A	N/A
Maximum Angle at the Minimum Bend Radius	N/A	N/A	N/A	N/A	N/A
Standard Heights	.937", 1.00", 1.125", 1.25", 1.50", 2.00"				
Height Tolerance	±.001"	±.001"	±.001"	±.001"	±.001"
Pricing	\$	\$	\$	\$	\$
Special Notes	Not all heights are available in all hardnesses.				

Simonds Industries, Inc. Telephone (978) 343 3731 USA

Rule Type or Name	Razor X-3	HardEdge	Shaved Edge	Mirror Edge	702A	Auto Bend
Bevel Angle	42° and 52°	48°	52°	48°	60°	52°
Edge Type	Ground	Shaved	Shaved	Ground	Ground	Ground or Shaved
Body Rockwell	45	40	45	45	45	36-39
Cutting Edge Rockwell	90	58-60	45	45	45	55-57
Body Coating	Specialty protective coating					
Edge Coating	Specialty	None	None	None	None	None
Decarb. Thickness	.002"	.002"	.002"	.002"	.002"	.002"
Cut Edge Hardening Method	Specialty Coating	High Frequency	None	None	None	High Frequency
Minimum Bend Radius	.015"	.015"	.015"	.015"	.015"	.015"
Maximum Angle at the Minimum Bend Radius	130°	130°	130°	130°	130°	130°
Standard Heights	.937"	.918", .923", .937"	.918", .923", .937"	.918", .923", .937"	.918", .923", .937"	.937"
Height Tolerance	+.001"-.000"	±.0007"	±.0007"	+.001"-.000"	+.001"-.000"	±.0007"
Pricing	\$\$\$\$	\$\$	\$	\$\$	\$	\$\$\$
Special Notes	Specialty steel allows for tight bends with high Rockwell measurements.					

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Stahl Steel Acier Telephone ++43 (0) 52 38/801-0 Austria

Rule Type or Name	HD-200 Ecoline	HD-100 (HF) Ecoline	HD-200 Eco.Extra	HD-100 EcoFlex	HD-100 Ecoflex 60
Bevel Angle	53°	53°	53°	53°	53°
Edge Type	Shaved	Ground or Shaved	Shaved	Ground or Shaved	Ground or Shaved
Body Rockwell	37-41	28-34	43-47	32-35	43-47
Cutting Edge Rockwell	37-41	52-60	43-47	58-65	58-65
Body Coating	Coatings are used but are proprietary				
Edge Coating	Coatings are used but are proprietary				
Decarb. Thickness	N/A	N/A	N/A	N/A	N/A
Cut Edge Hardening Method	Through-hardened	High Frequency	Through-hardened	High Frequency	High Frequency
Minimum Bend Radius	.039"	.039"	.039"	.039"	.039"
Maximum Angle at the Minimum Bend Radius	85°	85°	85°	85°	85°
Standard Heights	.937"	.937"	.937"	.937"	.937"
Height Tolerance	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"
Pricing	\$\$	\$\$	\$\$	\$\$	\$\$
Special Notes					

Tsukatani Hamono Mfg. Co. Telephone (630) 766 6226 USA 81-72-996-8770 Japan

Rule Type or Name	Superblade	Superblade Hard	Superblade J1	Superblade Self Leveling	# 70	MH
Bevel Angle	30°, 42°, 58°	58°	30°, 42°	42°	58°	58°
Edge Type	Ground	Ground	Ground	Ground	Ground	Ground
Body Rockwell	36	45	36	36	46	41
Cutting Edge Rockwell	53	60	53	53	46	41
Body Coating	Rust Preventing Resin on all rules					
Edge Coating	None	None	None	None	None	None
Decarb. Thickness	N/A	N/A	.002"	.002"	N/A	N/A
Cut Edge Hardening Method	Induction	Induction	Induction	Induction	Induction	Induction
Minimum Bend Radius	.020"	.020"	.020"	.020"	.020"	.020"
Maximum Angle at the Minimum Bend Radius	120°	90°	120°	120°	90°	100°
Standard Heights	.918", .923", .937"	.937"	.918", .937"	.937"	.918", .923", .937"	.918", .923", .937"
Height Tolerance	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"	±.0008"
Pricing	\$\$	\$\$	\$\$	\$\$	\$	\$
Special Notes	Special attention paid to consistency especially for use in automatic benders.					

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Zimmer Industries Telephone (973) 427 8000 USA

Rule Type or Name	Sharp One	TXB	MicroCut	MicroNik
Bevel Angle	60° or 42°	60° or 42°	42°	42°
Edge Type	Ground	Ground	Ground	Ground
Body Rockwell	37, 42, 50	40-43	42-45	42-45
Cutting Edge Rockwell	Same as Body	Same as Body	Same as Body	Same as Body
Body Coating	None	None	None	None
Edge Coating	None	None	None	None
Decarb. Thickness	.001"	N/A	.001"	.001"
Cut Edge Hardening Method	None	None	None	None
Minimum Bend Radius	.062"	.016"	.062"	.062"
Maximum Angle at the Minimum Bend Radius	180°	20°	180°	180°
Standard Heights	.918", .937"	.918", .937"	.937"	.937"
Height Tolerance	+.001"- .000"	+.001"- .000"	+.001"- .000"	+.001"- .000"
Pricing	\$	\$	\$\$	\$\$\$\$
Special Notes	Microscopic nicking is a specialty. TXB alloy steel has best bendability and needs the least amount of cutting pressure on the press.			

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