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▶ BSTA 810

BRUDERER High Performance Stamping Press

BRUDERER Stamping Press BSTA 810.

Nothing less than 100 % Precision.

Advantage through Innovation and Technique.

The BRUDERER high performance stamping press BSTA 810, combines brilliant precision mechanics, modern electronics and trend-setting innovations. Its unique cost-benefit ratio sets new standards in the market. The drive mechanism of the BSTA 810 embodies traditional BRUDERER technology in its most advanced form. The heart of the machine is the short and rigid main shaft that is mounted in transverse direction. The power transmission through connecting rods and the unique lever system in combination with the perfected mass counterbalancing system guarantees unsurpassed life time and perfect precision. The hardened and ground spindles of the ram height adjustment are mounted outside the power flow and hence allow a precise setting of the ram during the punching process.

As the mechanism does not generate lateral forces being transmitted into the ram guides, the guides are placed exclusively in the strip level which prevents deflection of the punches due to eccentric loads in the die. The above facts result in a safe and cost-effective stamping process.

Future orientated Process Control.

The BRUDERER press control with its big touch screen offers the operator a logic overview on all relevant process data. An easy handling is ensured by means of the operating mode selector switch and the logic touch keys on the screen. The memory function for die parameters guarantees a fast and trouble-free retooling from one die to the other. The retooling and other operations can also be individually tailored to the users needs. Furthermore an easy connection and integration of peripheral equipment into the B-control is guaranteed by using the most common bus systems.

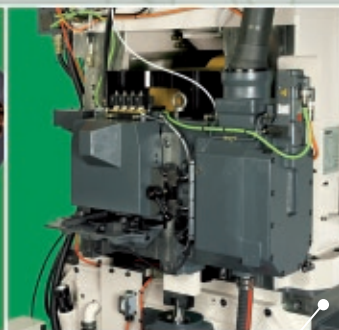
BSTA 810

- ▶ High performance stamping press with perfected mass balancing system and adjustable stroke.
- ▶ Press force 810 kN.
Speeds ranging from 100 to 1000 spm.
- ▶ Modular design, bolster plate dimensions:
BSTA 810-124 1220 x 910 mm
BSTA 810-145 1430 x 910 mm
- ▶ Press control on PC-basis, touch screen with clearly arranged graphics for easy handling, memory function for die parameters and integration of measuring and control function for increased process safety.
- ▶ Precision mechanics, versatile – can be used for a number of different applications, optimum cost-benefit ratio.



Ram Height Adjustment.

Each of the hardened and ground ram adjustment spindles need to absorb only 20 % of the load due to the lever system. The unique design permits the ram to be adjusted during the stamping operation while maintaining closest tolerances in the BDC.



Strip Feed Unit.

The mechanical drive system used in the BRUDERER roller feeders distinguishes itself by its top-precision in combination with high performance and outstanding life time. Depending on the application there is also an optional choice of either gripper feeders or servo feeders.



Stroke Change.

The straight forward stroke change procedure enables quick and reliable adjustment of up to 8 different strokes. This guarantees high flexibility and makes the press suitable for a wide range of applications. The timing of the feed angle is also synchronised during the stroke change.



High performance stamping press
BSTA 810.



A Multitude of Possibilities.

The choice of possibilities range from integrated process controls, like tool and press force monitoring systems, to closed loop ram height measuring and adjustment systems which are integrated into the B-control. Other options like hydraulic tool clamping or automatic stroke change systems, among many other choices, complete the adaptation to the individual customers needs.

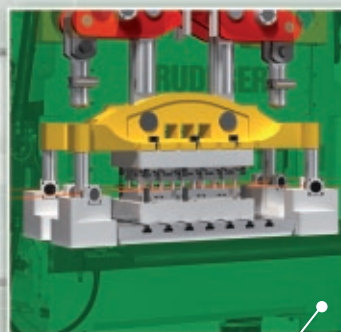
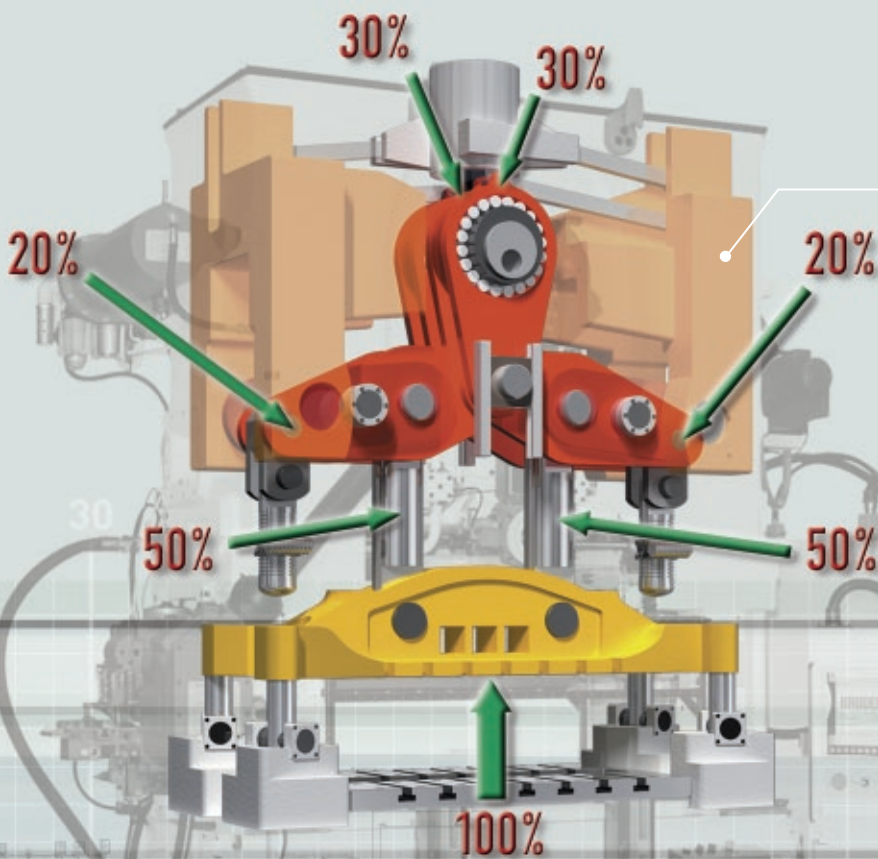
Top-Quality for an accurate Process.

Diverse Areas of Applications.

The BSTA 810 is suitable for a wide range of applications in the field of high performance stamping. For instance it is successfully used in the field of industrial applications, the lamination and lead frame industry as well as for stamping various connectors. Not only the outstanding accuracy and high performance but also the renowned reliability and life time of the stamping press are characteristics which make this machine your perfect choice.

The Advantages of the System.

Thanks to the unique lever system of the BSTA series the load from the stamping operation is distributed in the mechanism. This load distribution, together with the perfected mass counterbalancing system, the absolute minimum clearances in all bearings and the oil lubrication system are decisive factors for its long life and high precision.



Ram Guides in the Strip Level.

In order to prevent deflection of the punches due to eccentric loads, the ram guide elements are placed exclusively in strip level. Another advantage results from the plain bearings which compensate the thermal influences acting on the ram guides. Both features result in an increased tool service life.

Technical data BSTA 810

			BSTA 810-124	BSTA 810-145
Press force		kN	810	810
Tool loading area	L-R	mm	1240	1450
Speed	min.	spm	100	100
	max.	spm	1000	1000
Mains voltage (EN 60204) ^a		V	400	400
Mains frequency (EN 60204) ^a		Hz	50/60	50/60
Connected load ^b	max.	kVA	105	105
Control voltage		VDC	24	24
Drive power of main motor		kW	37	37
Compressed air connection R 1/2"	min.	bar	7	7
	max.	bar	10	10
Adjustable stroke (standard)		mm	16 19 26 35	16 19 26 35
		mm	43 51 58 63	43 51 58 63
Adjustable stroke (option)		mm	19 26 36 47	19 26 36 47
		mm	57 66 73 82	57 66 73 82
Fixed stroke ^a	max.	mm	82	82
Ram adjustment range		mm	76	76
Shut height ^a (according to stroke)	min.	mm	240,5	240,5
	max.	mm	340	340
Bolster area	L-R	mm	1220	1430
	F-B	mm	910	910
	height ^c	mm	1245	1295
Ram area	L-R	mm	1060	1270
	F-B	mm	510	510
Strip inlet height ^a	min.	mm	70	70
	max.	mm	160	160
Strip inlet width (machine)	max.	mm	380	380
Base plate opening	L-R	mm	1190	1400
	F-B	mm	320	250
Dimensions:				
Press (standard BBV)	L-R	mm	2875	2980
– with semi-automatic stroke adjustment	F-B	mm	1648	1648
	height	mm	3560	3610
	weight	kg	ca. 18000	ca. 18950
– with automatic stroke adjustment	F-B	mm	1717	1717
	height	mm	3671	3721
	weight	kg	ca. 18000	ca. 18950
Strip feed unit	standard	BBV 260		
	option	BSV 170		
		BSV 300		

^a) options on request ^b) incl. standard sockets for peripheral equipment ^c) above floor level

Economical stamping at our pace.

The BRUDERER BSTA series offer a complete range of modern high performance stamping presses for press forces of 180 to 2'500 kN.

Are you interested?

Feel free to contact us for a professional and detailed consultation. We will be pleased to send you further information upon request.

Special features:

- ▶ extremely high accuracy
- ▶ high performance
- ▶ renowned reliability
- ▶ long life
- ▶ universal application

www.bruderer-presses.com

Headquarter

BRUDERER AG Stanzautomaten

CH-9320 Frasnacht

Tel. +41 71 447 75 00 · Fax +41 71 447 77 80

info@ch.bruderer-presses.com

Competence Centres

BRUDERER GMBH

Kieferstrasse 28 · D-44225 Dortmund

Tel. +49 231 79 20 22-0 · Fax +49 231 71 91 53

info@de.bruderer-presses.com

BRUDERER MACHINERY INC.

1200 Hendricks Causeway

Ridgefield, NJ 07657, USA

Tel. +1 201 941-21 21 · Fax +1 201 886-20 10

info@bruderer.com

BRUDERER PRESSES (Far East) Pte Ltd.

65 Loyang Way · Singapore 508 755

Tel. +65 65 46 81 21 · Fax +65 65 46 81 31

info@sg.bruderer-presses.com

BRUDERER MACHINERY (Suzhou) Co., Ltd.

485 Suhong Road · Suzhou Industrial Park

Suzhou, Jiangsu Province, China 215027

Tel. +86 512 62 58 82 92 · Fax +86 512 62 58 82 93

info@cn.bruderer-presses.com

BRUDERER PRESSES K.K.

Yakou 2306-2, Sakae-Machi · Inba-Gun, Chiba-Ken
Japan 270-1502

Tel. +81 476 80-17 88 · Fax +81 476 85-12 77

info@jp.bruderer-presses.com

Sales and Service

BRUDERER UK LTD.

Cradock Road, GB-Luton · Bedfordshire LU4 0JF

Tel. +44 15 82 56 03 00 · Fax +44 15 82 57 06 11

info@uk.bruderer-presses.com

BRUDERER IBERICA, S.L.

Pol. Ind. Magarola Sud · C/. Cerámica 5 · Nave B-1
E-08292 Esparraguera (Barcelona)

Tel. +34 93 770 84 60 · Fax +34 93 779 51 15

info@es.bruderer-presses.com

BRUDERER PRESSES INDIA PVT LTD.

2, Chandragupta Estate · Ground Floor

Andheri Link Road, Near Monginis

Andheri West, Mumbai 400 053, India

Tel. +91 22 66 95 19 45/46 · Fax +91 22 66 95 19 48

info@in.bruderer-presses.com

BRUDERER NEDERLAND

Postbus 449 · NL-2980 AK Ridderkerk

Tel. +31 180 41 19 77 · Fax +31 180 41 79 31

info@nl.bruderer-presses.com

BRUDERER PRESSES FRANCE S.A.R.L.

Z.I. du Petit Parc · F-78920 Ecquevilly

Tel. +33 1 34 75 00 40 · Fax +33 1 34 75 52 36

info@fr.bruderer-presses.com