

**Knuckle Joint Link Drive 2-Point
Cold Forging Press**

KL2



400 . 630 . 800 . 1000 . 1200 . 1600 . 2000 ton

KL2 Series

Knuckle-Joint / Link-Drive 2-Point Cold Forging Press

The KL2 features a long stroke length above 400 mm and high rating point. It can be applied in drive shaft forging formation with long rod / shaft dimension, especially for the automotive industry requiring production quality and high stamping efficiency.

For instance, the drive shaft formation (CV-JOINT) for RV series of 4-wheel drive vehicle can be suitably formed with KL2 equipped with 3-axis automation device.

Tonnage Range: 440 - 2204



Model KL2 Specifications		KL2-400	KL2-630	KL2-800	KL2-1000	KL2-1200	KL2-1600	KL2-2000
Capacity	US Tons	440	694	881	1102	1322	1763	2204
	Metric Tons	400	630	800	1000	1200	1600	2000
Rated tonnage point	in.	0.59	0.59	0.59	0.98	0.98	0.98	0.98
	mm	15	15	15	25	25	25	25
Stroke length	in.	15.75	15.75	15.75	19.69	19.69	23.63	23.63
	mm	400	400	400	500	500	600	600
Speed	SPM	25 ~ 45	25 ~ 40	25 ~ 35	15 ~ 30	15 ~ 30	15 ~ 25	15 ~ 25
Die height (S.D.A.U.)	in.	39.37	39.37	43.31	43.31	47.24	47.24	47.24
	mm	1000	1000	1100	1100	1200	1200	1200
Bolster area (L.R. x F.B.)	in.	39.37 x 27.56	47.24 x 31.50	47.24 x 31.50	55.11 x 35.43	55.11 x 35.43	59.06 x 39.37	62.99 x 47.24
	mm	1000 x 700	1200 x 800	1200 x 800	1400 x 900	1400 x 900	1500 x 1000	1600 x 1200
Slide area (L.R. x F.B.)	in.	39.37 x 27.56	47.24 x 31.50	47.24 x 31.50	55.11 x 35.43	55.11 x 35.43	59.06 x 39.37	62.99 x 47.24
	mm	1000 x 700	1200 x 800	1200 x 800	1400 x 900	1400 x 900	1500 x 1000	1600 x 1200
Bed Knockout Device								
Capacity	US Tons	22	33	44	55	66	88	110
	Metric Tons	20	30	40	50	60	80	100
Stroke Length	in.	5.91	5.91	5.91	6.30	6.30	7.87	7.87
	mm	150	150	150	160	160	200	200



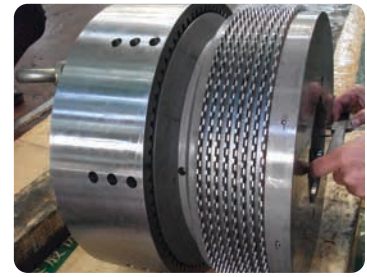
Multiple Link-drive mechanism:

1. Optimized mechanical and structural design with high-rigidity link structure.
2. Larger capacity atop of BDC than traditional crank drive mechanism.



Cam device (option):

Teeth surface allows knocking out timing setting for different parts so as to improve the applicability for the peripheral equipment.



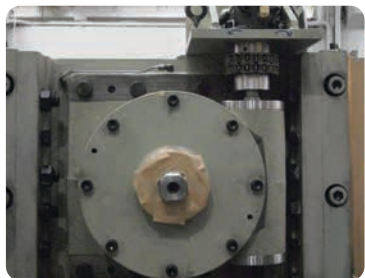
Hydraulic clutch and brake (option):

High production efficiency
Operation safety.



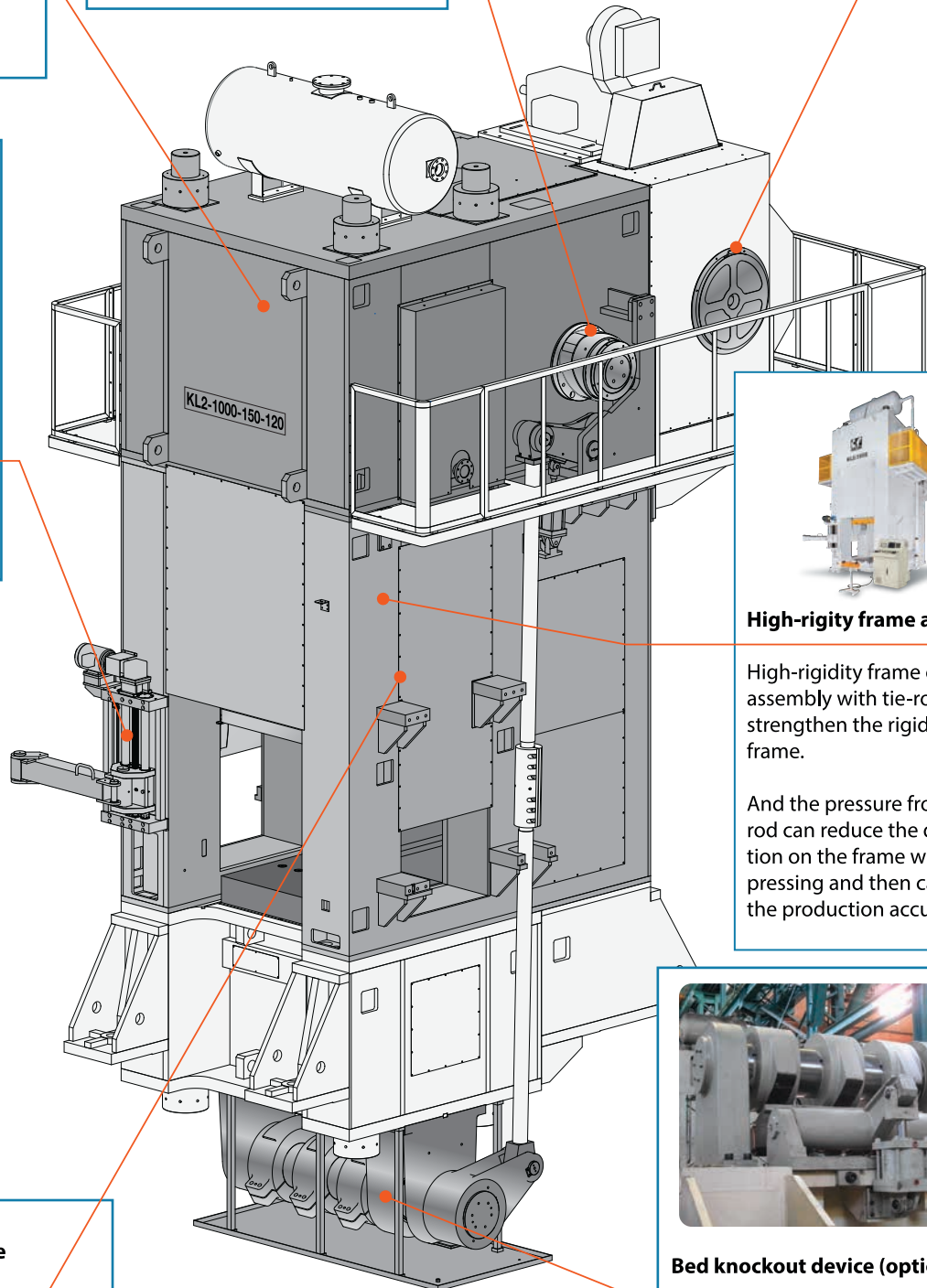
Quick die core change (option):

Provision of the quick motion in die core change for ensuring the operation security.



Slide adjustment and locking device (option):

High torque locking and adjusting device to ensure the stability of pressing.



High-rigidity frame and tie-rod:

High-rigidity frame design and assembly with tie-rod to strengthen the rigidity of the frame.

And the pressure from the tie rod can reduce the deformation on the frame while pressing and then can improve the production accuracy.

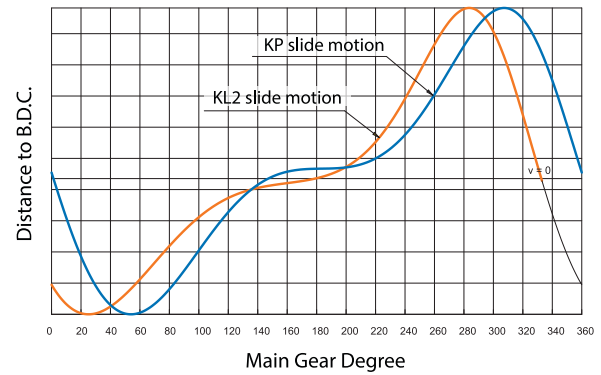
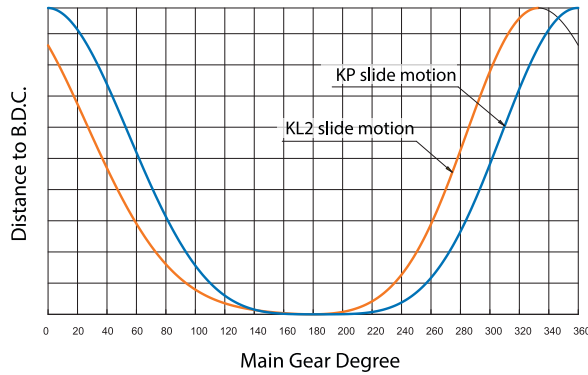


Bed knockout device (option):

High-rigidity mechanical knockout device with cylinder to prevent parts jumping out and make sure the operation safety.

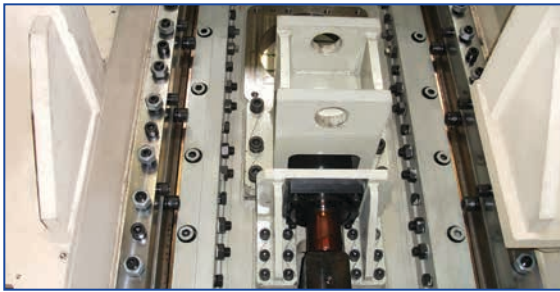
2-point deformed knuckle joint mechanism

Compared to knuckle-joint mechanism, in addition to the formation curve like KP, KL2's deformed knuckle joint further provides slow and steady curve for the production of the long shaft parts or higher rating point with heavily-loaded parts.



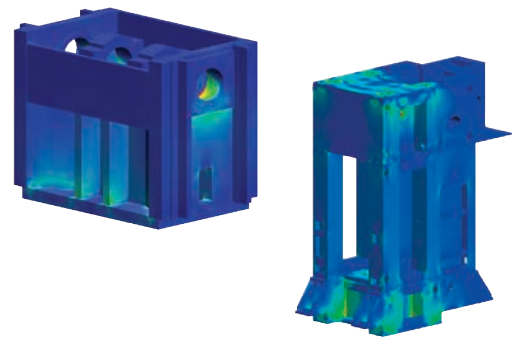
8 Face High-Rigidity Long Gibs

- Maintain high-accuracy and higher eccentric load for a long time to improve the die lifetime and production accuracy.
- Recirculation with oil decreases the abrasion and heat on bushing so as to provide the safe and stable gib accuracy.



Structure Stress Analysis

Main frame components are all analyzed with FEM to make sure the structure rigidity to achieve the optimized structure design.



User-Friendly and Multiple Functions Electrical Control System

1. Electrical system:

- Control system components are from leading manufacturers for easy acquirement for spare parts and system extension.

2. Operation monitor:

- Auto monitor on press drive to detect shaft break, brake lining over abrasion, C&B error, etc to make sure press operation safe.

3. Electrical angle control:

- Equipping with resolver for detection, anti-interruption, anti-vibration and not data loss after blackout
- Auto brake position correction can avoid the problems of lining abrasion, brake angle change, spm change, or inaccurate stop, etc.

4. Counter:

- Standard counter function include stroke counter, pre-set counter, life-time counter(mechanical), etc
- Batch counter, cutting counter (optional)
- Equipped with HMI, except for life-time counter, the other counters are all included in the HMI

5. Peripheral equipment:

- Die base and 3-axis transfer device available (option)
- Quick die core change arm (option)
- Quick die change system (option)



Stamtec KL2 Series presses are mainly applied for cold forging formation.

Equipped with 3-axis transfer and forging tool, KL2 press systems can satisfy the demand for achieving automatic production. Added with tool set make the production with more stable and higher accuracy.



STANDARD Features

- Slide and tool counterbalance device
- Oil recirculation lubrication device
- Overrun protection device
- Hydraulic overload protection device
- PLC (Mitsubishi FX series)
- Programmable limit switches (8 channel)
- Digital Die height indicator
- Misfeed detection receptacle
- Solenoid Valve
- Safety rail and ladder
- Air ejector (3/8")
- Air receptacle (3/8")
- Maintenance tool kit
- Operation manual and inspection report
- Portable 2-hand push button T-stand

OPTIONAL Features

- Flywheel brake
- Light curtain
- Slide and bed knockout device
- Quick die core change arm
- Motorized grease device
- Inverter-duty main motor
- Foot switch
- Tool lightening
- Anti-vibration mount
- Motorized slide adjusting device (hydraulic locking)
- Power receptacle (110V and 220V)
- Programmable logic control (PLC Mitsubishi Q series)
- Human Machine Interface (HMI- Mitsubishi)
- Anchoring screw and plate
- Quick Die Change

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