

## LF-Series

Compound - Link Sheet Metal Forging Presses

# LF Series



220 . 330 . 440 . 550 . 650 tons

# LF1 Series

## Compound - Link Sheet Metal Forging Presses

Stamtec LF1-Series Forging Presses are ideal for sheet materials in Cold Forging, Drawing, Fine Blanking, Near-Net-Shaping (Net shape) and Press Forging.

With models ranging from 200 - 650 tons, LF1-Series Presses are suitable for light compound materials such as magnesium, aluminum, or sheet steel, and high-tension steels.

- Super rigid, low-deflection steel frame.
- Link-motion drive combined with knuckle-joint transmission system creates a unique slide motion curve with low slide velocity during the working portion of the stroke and a dwell at the bottom of the stroke.
- Adaptable to Fine Blanking for knives, hardwares and auto parts.



### SPECIFICATIONS

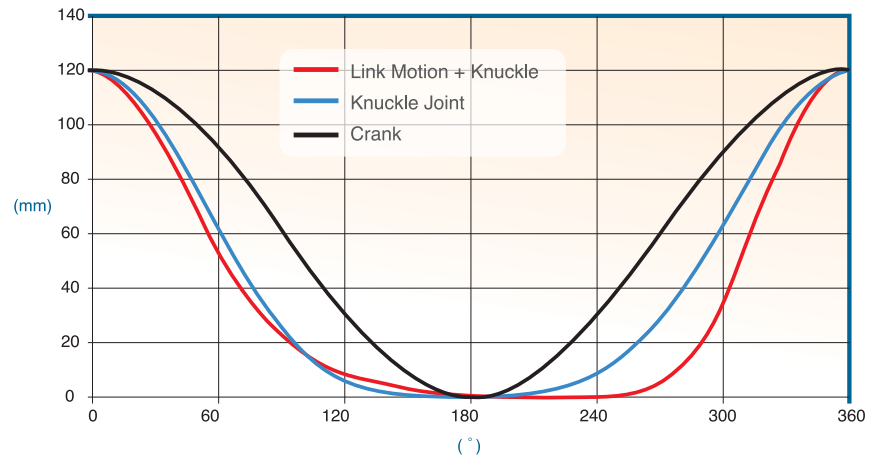
		LF1-200	LF1-300	LF1-400	LF1-500	LF1-650
Capacity	US Tons	220	330	440	551	716
	Metric Tons	200	300	400	500	650
Rated tonnage point	in	0.18	0.31	0.31	0.31	0.31
	mm	4.8	8	8	8	8
Stroke length	in	4.72	5.90	5.90	5.90	5.90
	mm	120	150	150	150	150
Strokes per minute	SPM	20 ~ 45	20 ~ 40	20 ~ 40	20 ~ 40	20 ~ 40
Die height	in	17.71	17.71	17.71	17.71	17.71
	mm	450	450	450	450	450
Bolster area	in	51.18 x 38.19 x 6.30	51.18 x 38.19 x 6.30	51.18 x 39.37 x 7.48	51.18 x 39.37 x 7.48	51.18 x 39.37 x 7.48
	mm	1300 x 970 x 160	1300 x 970 x 160	1300 x 1000 x 190	1300 x 1000 x 190	1300 x 1000 x 190
Slide area	in	51.18 x 38.18	51.18 x 38.18	51.18 x 39.37	51.18 x 39.37	51.18 x 39.37
	mm	1300 x 970	1300 x 970	1300 x 1000	1300 x 1000	1300 x 1000
Slide adjustment	in	1.96	3.14	3.14	3.14	3.14
	mm	50	80	80	80	80
Side opening	in	16.53 x 15.74	17.71 x 17.71	17.71 x 17.71	18.30 x 17.71	18.30 x 17.71
	mm	420 x 400	450 x 450	450 x 450	465 x 450	465 x 450
Working height	in	35.03	35.43	37.40	39.36	39.36
	mm	890	900	950	1000	1000
Max. upper die weight	lbs	2204	3306	3306	3306	3306
	kg	1000	1500	1500	1500	1500
Main motor	HP x P	15 x 6	25 x 6	30 x 6	40 x 6	50 x 6
Slide adjusting motor	HP x P	2 x 4	2 x 4	2 x 4	2 x 4	2 x 4

Available for light compound materials  
(magnesium, aluminum), sheet steel  
and high-tension steels



## Unique Press Slide Motion Curve

Link-Motion with Knuckle Joint transmission structure creates a unique slide motion curve which is able to extend the time for forming from 180° - 240° crank angle. This slide motion is ideal for complex sheet metal forging.



## STANDARD Features

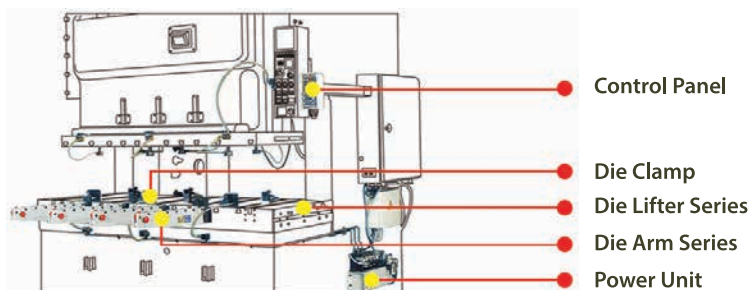
- OmniLink 5100-APC Press Controls
- Motorized Slide Adjustment
- Digital Die Height Indicator (unit 0.1mm)
- Wet Clutch and Brake
- Load Monitor Detector
- Automatic Lubrication System
- Slide and Die Balance Device
- Inverter and Main Motor Reverse Device
- Power receptical (Single phase, 110V)

## OPTIONAL Features

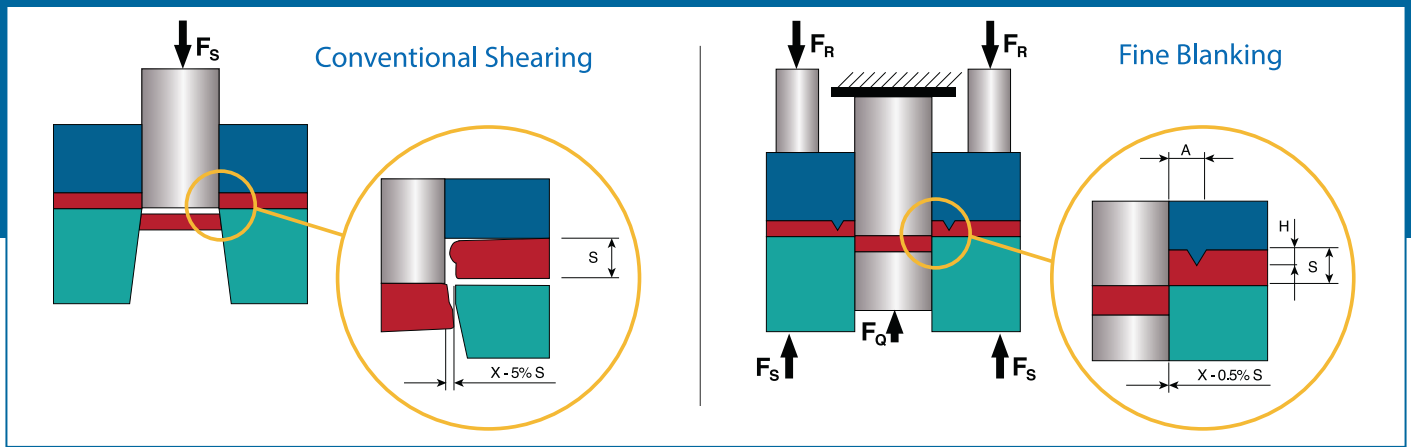
- Bottom Scrap tank (Front side)
- VS Motor (APC optional)
- Photo electronic safety guard
- Anti Vibration Mount
- Foundation Plate and Anchor Bolts
- Safety Block and Plug
- Die Room Light
- Hydraulic Slide Knock-out Device
- Hydraulic Die Cushion

## Quick Die Change System

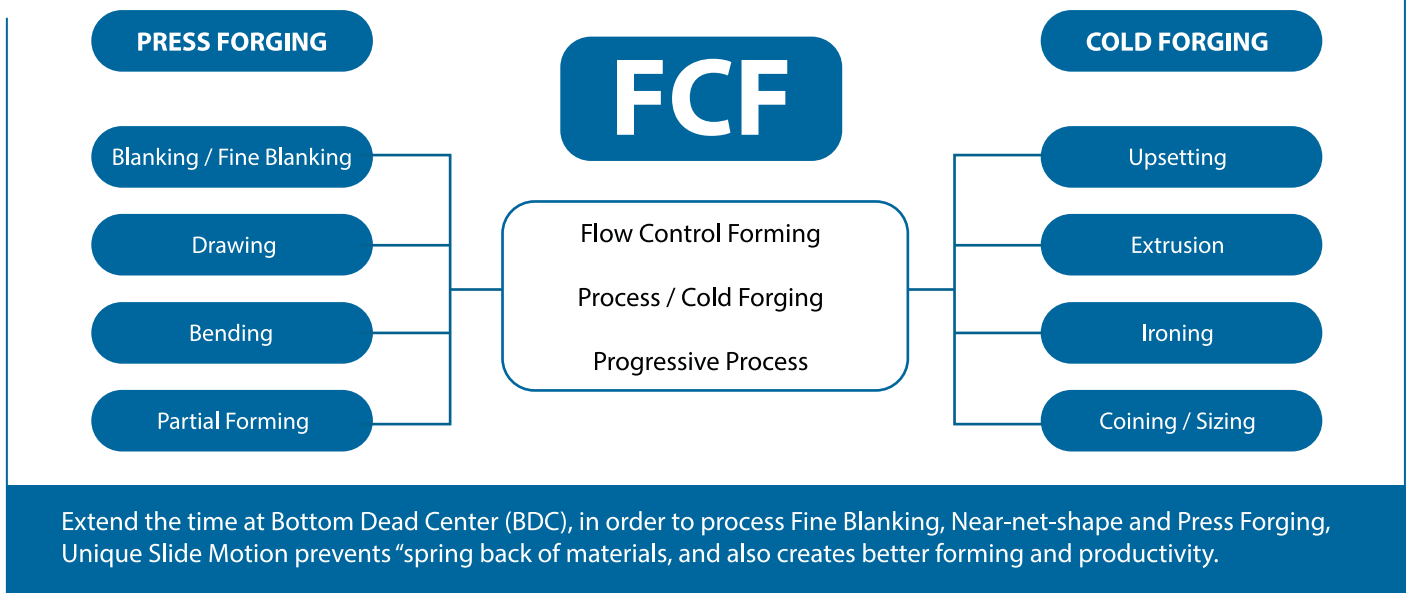
Increase uptime by adding a Quick Die Change System to any NEW or EXISTING STAMTEC Press.



## The Difference Between Conventional Shearing and Fine Blanking



## Fine Blanking, Near-Net Shaping and Press Forging for sheet Material



## Fine Blanking with Continuous Progressive Automatic Press Line

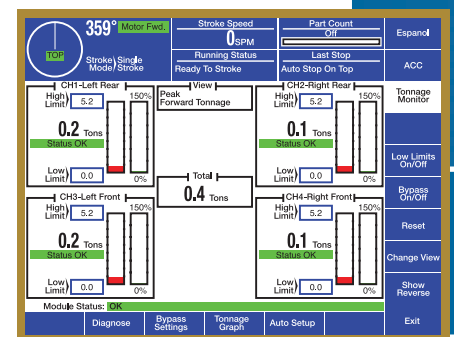
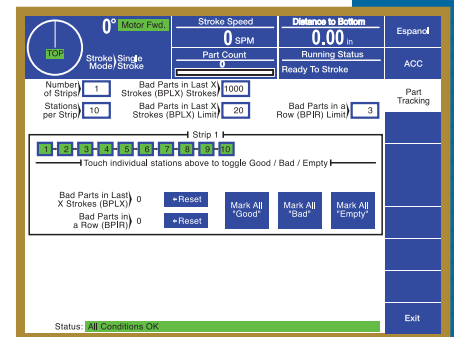
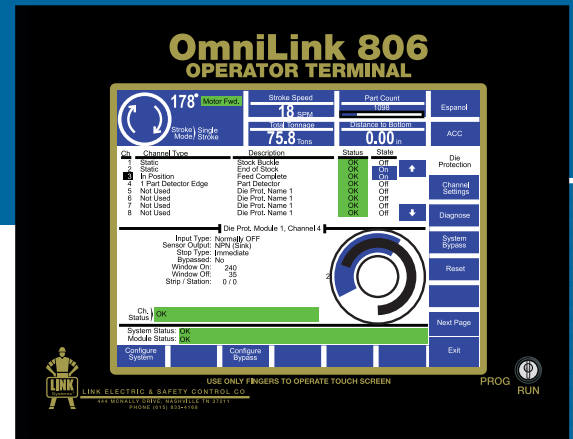
- The Automatic Fine Blanking Press Line is composed by:  
Press / Die / Upper and Lower Hydraulic Die Cushion / Material / 3 in 1 Feeding Machine (Coiler, Straightner and Feeder) Waster Recycler.
- Setting Fine Blanking Die and Hydraulic upper and lower die cushion:
  1. Pressing Capacity 135 ~ 145 tons
  2. **Upper Die Cushion:** 50 tons | **Lower Die Cushion:** 30 tons
- Confirm with Fine Blanking and Pressing
  1. Surface is smooth without fracture and with coining feature
  2. No need for secondary Processing



# Press Controls

## OmniLink 5100-APC (standard equipment)

- Model 806, 10.4" color touch screen with English or Spanish display, provides easy setting for control configuration, PLS, die protection, counters, etc.
- 1000 job storage and recall to provide quick, consistent set-ups.
- Eight (8) die protection / process monitoring inputs (up to 80 available optionally) located in the operator terminal. Nine monitoring modes are available for each die protection input.
- Eight (8) programmable limit switch outputs (up to 96 available optionally) are available to sequence and time automation with the press.
- 56 control inputs and 8 sets of dual-tracking safety control inputs (configurable) for performance and diagnostics with 56 additional inputs.
- Outputs for clutch and brake, as well as optional output relays configurable for specific functions related to lube systems, motor controls, hydraulic overloads, flywheel brakes, automation, etc.
- Screens to display the state of every input and output, lube system diagnostics, OIT diagnostics, configuration memory, and an event log with date, time and reason for the last 256 stops.
- Stopping time performance (brake) monitor, motion detection, clutch engagement time monitor.
- Stroking modes - Off, Inch, Automatic Timed Inch, Setup / Stop Time Test, Single Stroke (Cycle), and Continuous. (Optional modes - Automatic Single Stroke (Cycle), Maintained Continuous, and Continuous on Demand).
- Automatic Top Stop Compensation for use with variable speed presses.
- Four (4) nine-digit counters for stroke, parts, batch, and quality.
- Superior safety with powerful diversely redundant cross-checked dual micro-processor logic systems.
- Lasting value with rugged modular design and Link technical support.



## OPTIONAL Press Controls

from manufacturers including:

WINTRISS®

SIEMENS

MITSUBISHI  
ELECTRIC



Rockwell  
Automation  
Allen-Bradley



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