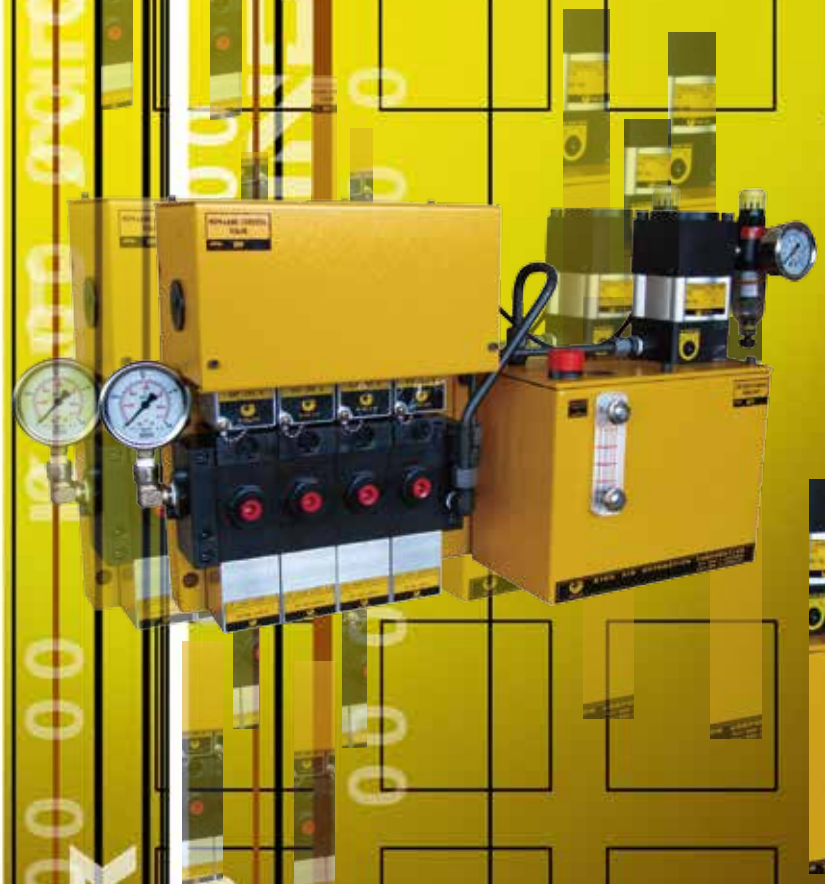

Quick Die Change Systems

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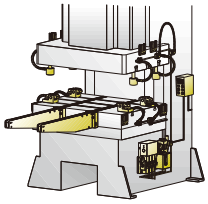
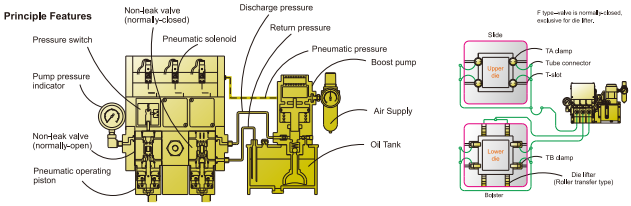
Program Summary

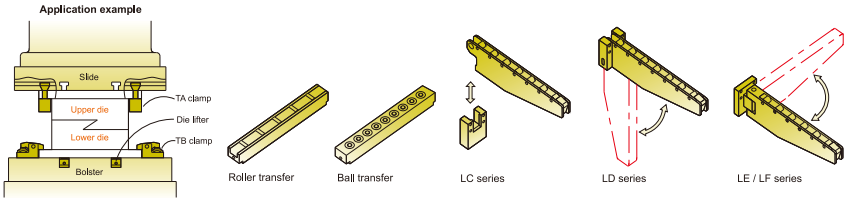
Introduction of Quick Die Change System
Data sheet P.1



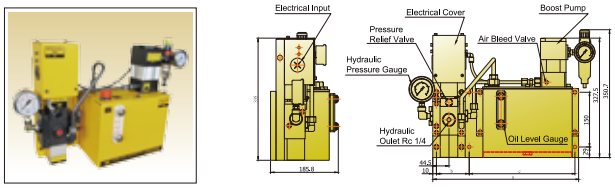
System Configuration
Data sheet P.2



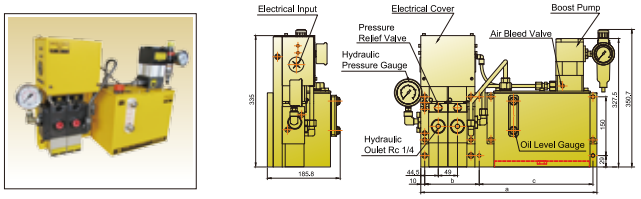
Selection Of The System
Data sheet P.3



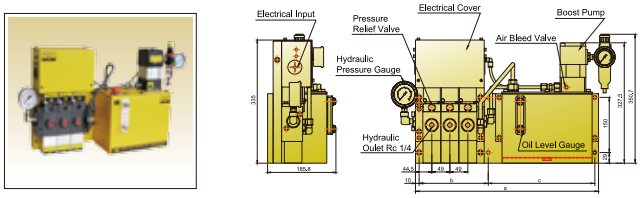
Single Circuit Power Unit
Data sheet P.4



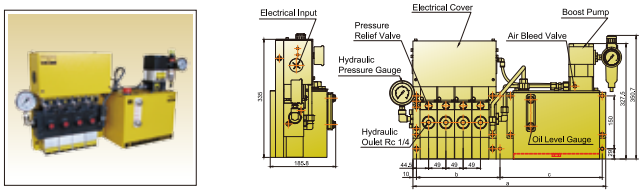
Two Circuits Power Unit
Data sheet P.5



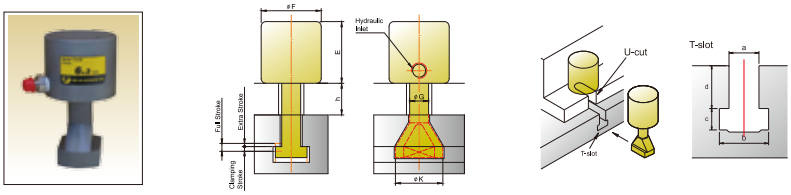
Three Circuits Power Unit
Data sheet P.6



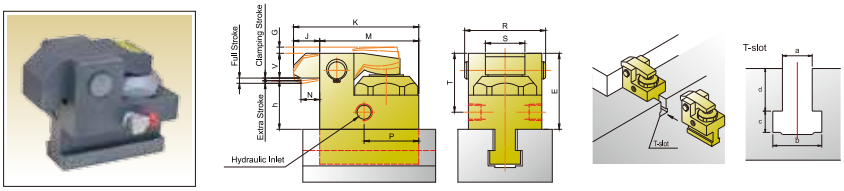
Four Circuits Power Unit
Data sheet P.7



TA Clamp
Data sheet P.8



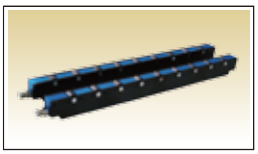
TB Clamp
Data sheet P.9

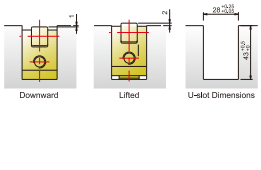


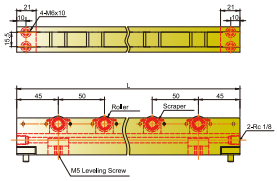
KING AIR

Program Summary

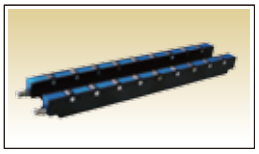
Roller Type Die Lifter *LA28 series*
Data sheet P.10

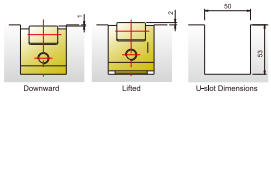


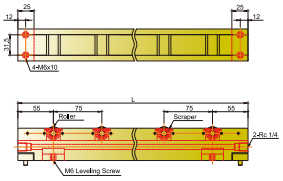




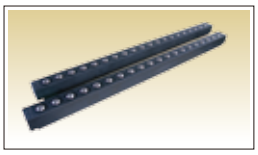
Roller Type Die Lifter *LA50 series*
Data sheet P.11

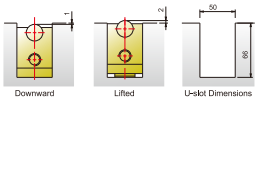


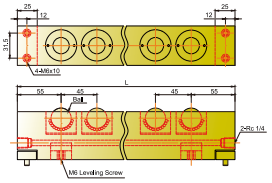




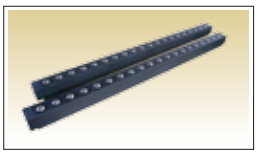
Ball Type Die Lifter *LWB50 series*
Data sheet P.12

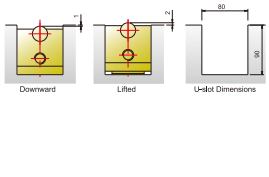


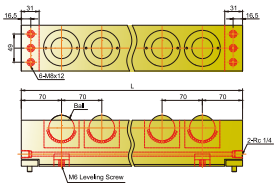




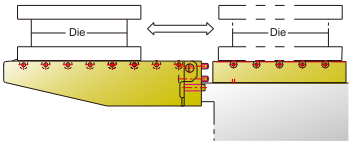
Ball Type Die Lifter *LWB80 series*
Data sheet P.13

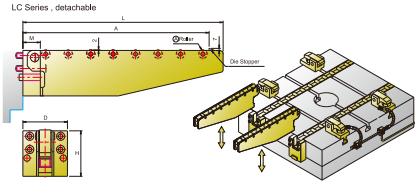




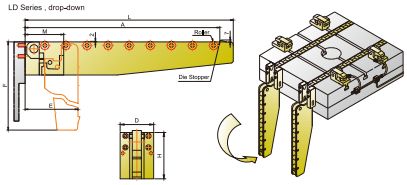


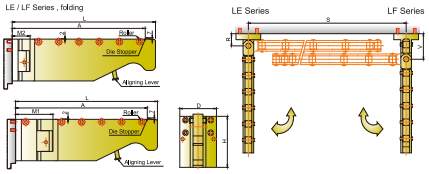
Bolster Extensions *LC series*
Data sheet P.14



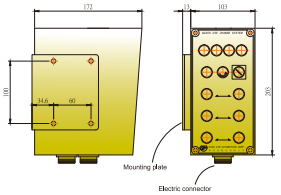


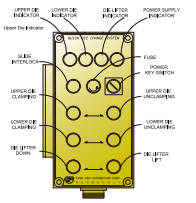
Bolster Extensions *LD series* *LE / LF series*
Data sheet P.15



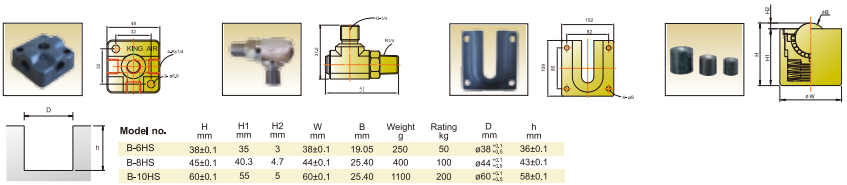


Control Panel
Data sheet P.16





Accessories
Data sheet P.17



Model no.	H mm	H1 mm	H2 mm	W mm	B mm	Weight g	Rating kg	D mm	h mm
B-6HS	38±0.1	35	3	38±0.1	19.05	250	50	ø38 +0.1 +0.4	36±0.1
B-8HS	45±0.1	40.3	4.7	44±0.1	25.40	400	100	ø44 +0.1 +0.4	43±0.1
B-10HS	60±0.1	55	5	60±0.1	25.40	1100	200	ø60 +0.1 +0.4	58±0.1

Quotation Information Form
Data sheet P.18

For a quotation, notify us of t he follow :

A. Press

A-1 New or existing ☐ New ☐ Existing

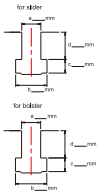
A-2 Type of press ☐ C frame ☐ Straight side ☐ High speed ☐ Transfer
☐ Others specify : _____

A-3 Tonnage _____ tf (☐ US, ☐ Metric)

A-4 Slide dimensions (L-R)_____ X (F-B) _____ mm(inch)

A-5 Bolster dimensions (L-R)_____ X (F-B)_____ mm(inch)

A-6 T-slot ☐ Yes ☐ No



B. Die

B-1 Maximum weight _____ kg(lbs)

B-2 Maximum dimensions (W) _____ X(L) _____ X(H) _____ mm(inch)

B-3 U-cut for bolting ☐ Yes ☐ No

B-4 Die shoe thickness _____ mm(inch)

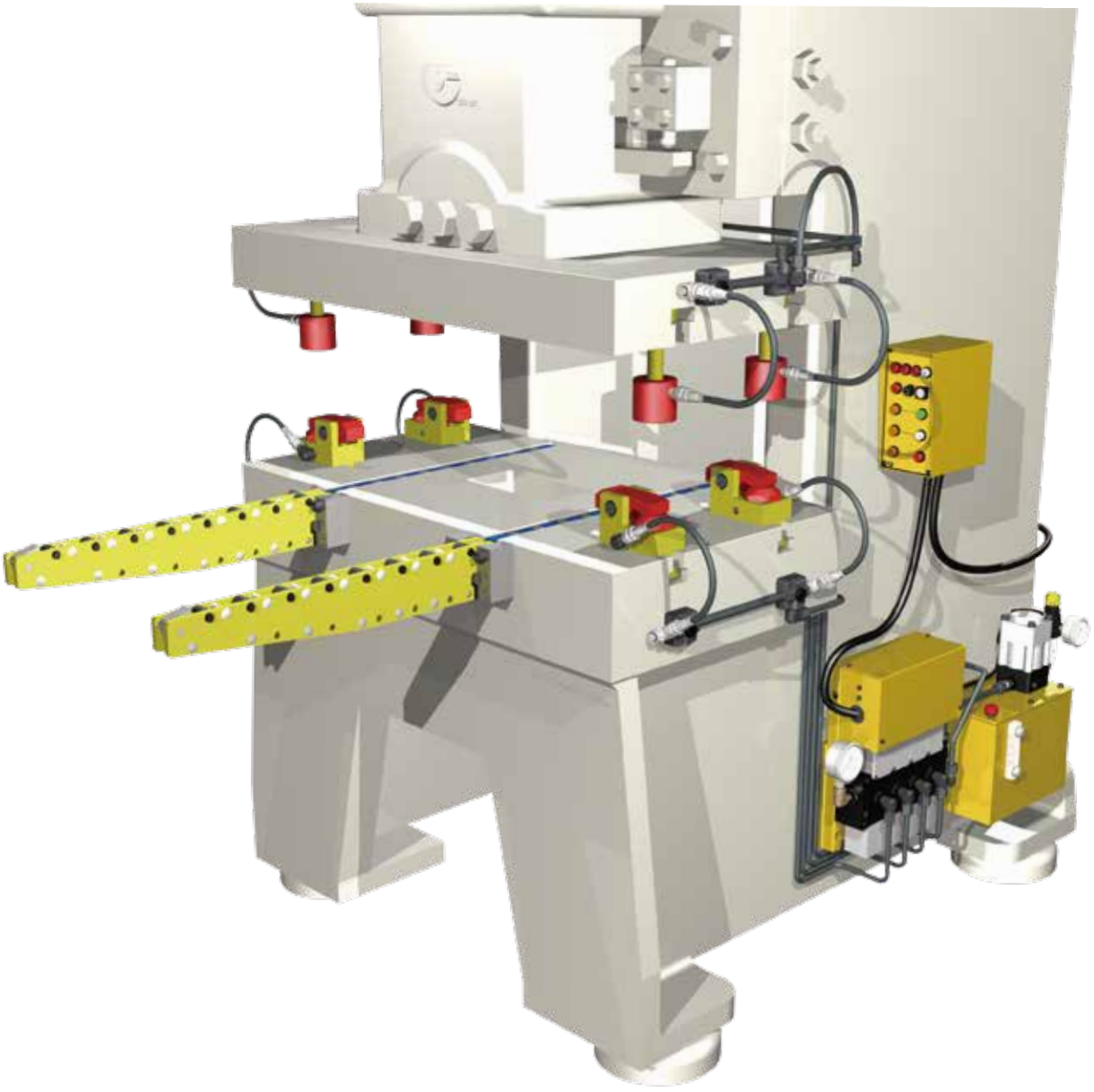
B-5 Special requirements _____

C. Die change system

C-1 Required components ☐ Clamp Model _____ X _____ pc(s)
☐ Die lifter Model _____ X _____ pc(s)
☐ Bolster extension Model _____ X _____ pc(s)
☐ Power unit Model _____ X _____ pc(s)

C-2 Valve operation Poewr supply ☐ AC ☐ DC ____V ____Hz

INTRODUCTION OF

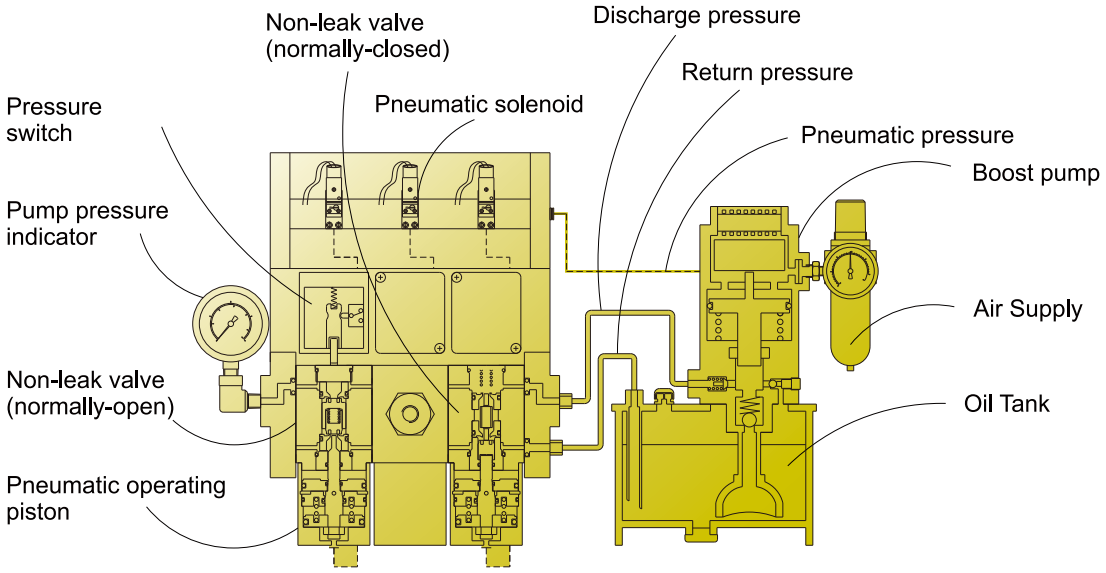


Quick Die Change System

Benefits

- Reduction in die change time
- Diverse products in small lots
- Reduces inventory levels
- Improvement on productivity and quality

Features



Description

The power unit is particulary suitable for die clamping system. Equipped with multiple safety characteristics assures reliable safe operation at all times.The power unit combines a balanced pneumatic -hydraulic boost pump and 3 hydraulic control valves (2 valves of normally-open and 1 valve of normally-closed). There is a pneumatic service unit with filter, regulator and pressure indicator connect to the boost pump and it's the power source supplier of the boost pump.

Features

Boost pump

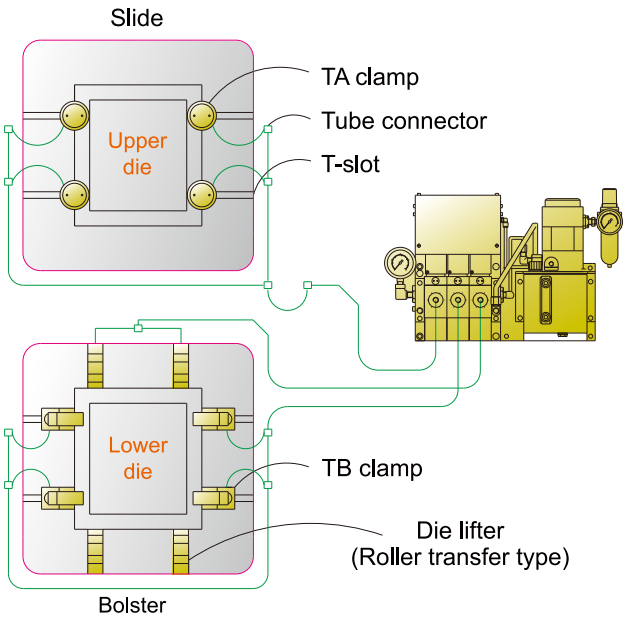
The boost pump is a balanced pneumatic-hydraulic reciprocating plunger pump.To always maintain a constant pressure and instantly responds to any-drop in hydraulic pressure When the preset pressure is reached and maintains the set pressure without power consumption.

Hydraulic control valve

The hydraulic control valve is equipped with a non-leak valve and a pressure switch.The non-leak valve is operated a pneumatic solenoid for remote control, and prevent loss of hydraulic pressure. The pressure switch interlock function for the emergency stop circuit of the press.
There are two types of the hydraulic control valve for selection:
LE type–valve is normally-open, exclusive for die clamp.
LF type–valve is normally-closed, exclusive for die lifter.

Application example

The 3 hydraulic circuits of power unit are available typically for die change system.Two of the normally-open hydraulic control valve.
one is for upper die clamp;the other is for lower die clamp.
The normally-closed hydraulic control valve is for die lifter.
There are four TA clamps installed in the upper die with U-cuts for clamping; four TB clamps are installed in the lower die without U-cuts for clamping and Two die lifters are installed in the Bolster with U-cuts for liftting.



Clamps

Determine the clamping force

The clamping force (force of a clamp x number of clamps) equals to 10% or more of the press tonnage for each of the upper and lower dies.

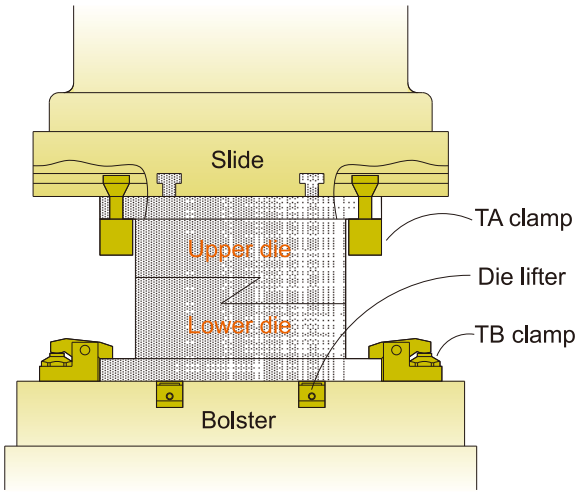
Determine the number of clamps

The number of the clamps are according to the dimensions and configurations of the dies and the T-slot arrangement on the press.

Select the types of clamps

TA series – The die is provided with U-cuts.
TB series – The die is provided without U-cuts.

Application example



Hydraulic circuits

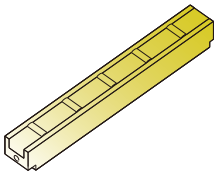
Number of circuit	circuit code	Application examples	
1	LE	One	circuit for clamping the upper or lower die or for simultaneously clamping the upper and lower dies
1	LF	One	circuit for the die lifter
2	LELE	One	circuit for clamping the upper die
		One	circuit for clamping the lower die
2	LELF	One	circuit for clamping the upper or lower die or for simultaneously clamping the upper and lower dies
		One	circuit for the die lifter
3	LELELF	One	circuit for clamping the upper die
		One	circuit for clamping the lower die
		One	circuit for the die lifter
4	LELELELF	Cross dual	circuits for clamping the upper die
		One	circuit for clamping the lower die
		One	circuit for the die lifter

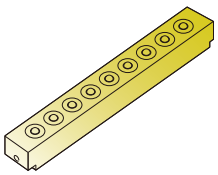
Die lifter

Selection of the type
LA Series - Roller transfer
LWB Series - Ball transfer

Select criterion

Transfer length
Lift capacity
Maximum load weight
U-cut dimensions


Roller transfer


Ball transfer

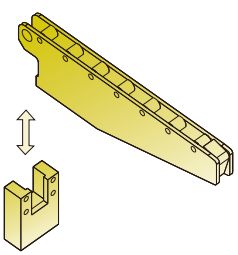
Bolster extensions

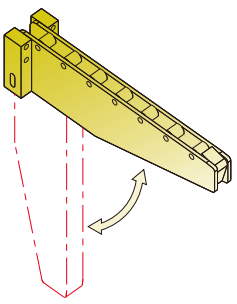
Selection of the type

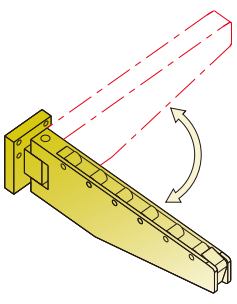
LC Series – detachable type
LD Series – drop - down type
LE / LF Series – folding type

Select criterion

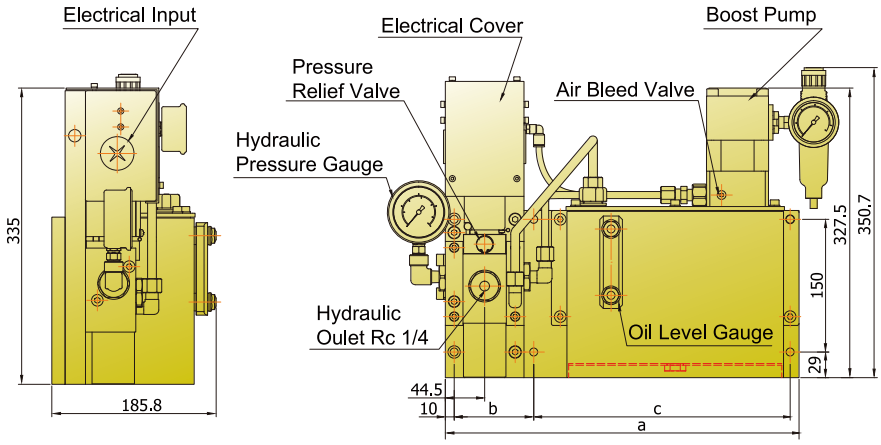
Die dimensions
Maximum roller load weight


LC series


LD series


LE / LF series

Single Circuit Power Unit



Application

The power unit is equipped with a balanced pneumatic-hydraulic boost pump and single hydraulic control valve.There are two types of the hydraulic control valve for selection.The valve of LE type is normally-open(N.O), exclusive for die clamp, LF type is normally-closed(N.C), exclusive for die lifter.

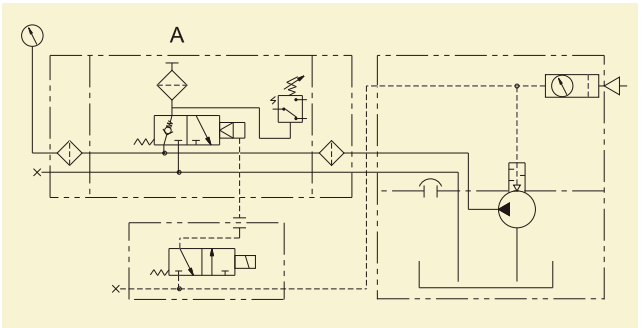
Important note

The hydraulic control valve is operated a pneumatic solenoid for remote control.The hydraulic control valve is built in a high pressure filter with inlet and outlet port. It's necessary to have to make sure the fluid clean through the valve to the clamp.

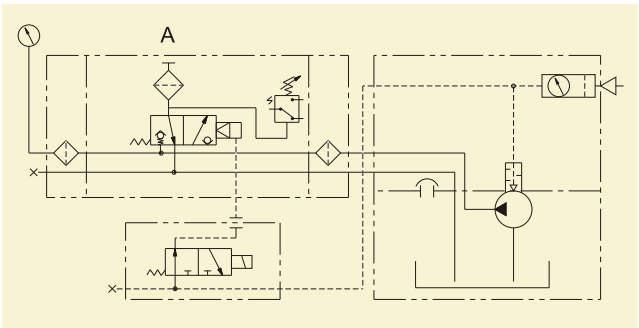
Technical data

Model no.	BPT-62-LE-1-5	BPT-62-LF-1-5
Transmission pressure ratio	1 : 62	1 : 62
Hydraulic working pressure (bar)	250	250
Pneumatic supply pressure (bar)	4.2	4.2
Valve type	N.O 1pc	N.C 1pc
Solenoid operating voltage	AC 110V 50/60 Hz	AC 110V 50/60 Hz
Hydraulic oil	ISO-VG-32 or equivalent	ISO-VG-32 or equivalent
Usable oil volume (l)	5	5
Versions		
a	400 mm	400 mm
b	100 mm	100 mm
c	290 mm	290 mm

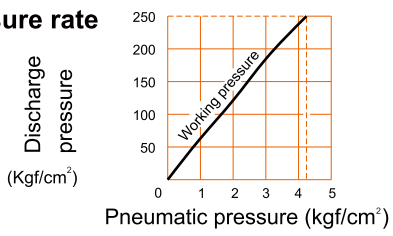
Circuit diagram (valve LE)



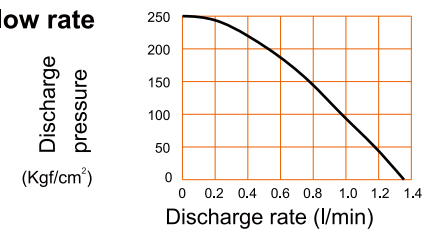
Circuit diagram (valve LF)



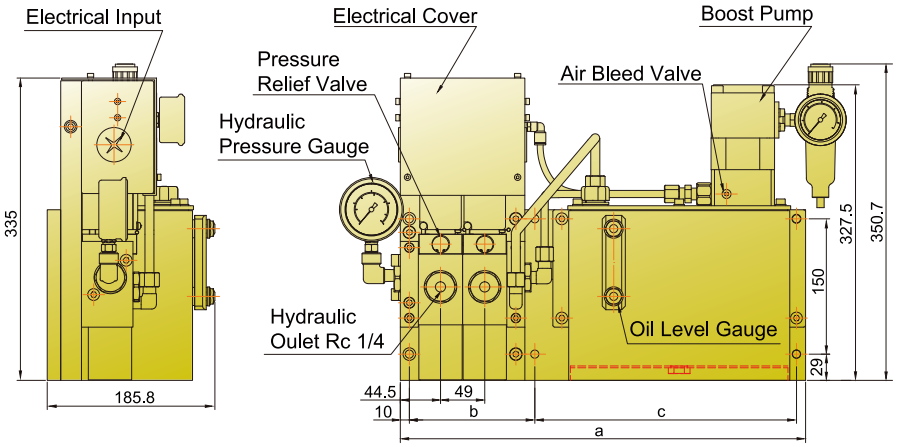
Transmission Pressure rate



Discharge flow rate



Two Circuits Power Unit



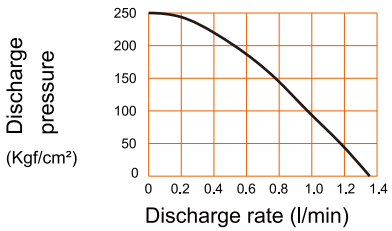
Application

The power unit is equipped with a balanced pneumatic-hydraulic boost pump and two hydraulic control valves.There are two types of the hydraulic control valve for selection.The valve of LE type is normally-open(N.O), exclusive for die clamp, LF type is normally-closed (N.C), exclusive for die lifter.

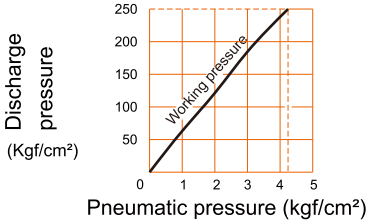
Important note

The hydraulic control valve is operated a pneumatic solenoid for remote control.The hydraulic control valve is built in a high pressure filter with inlet and outlet port. It's necessary to have to make sure the fluid clean through the valve to the clamp.

Discharge flow rate



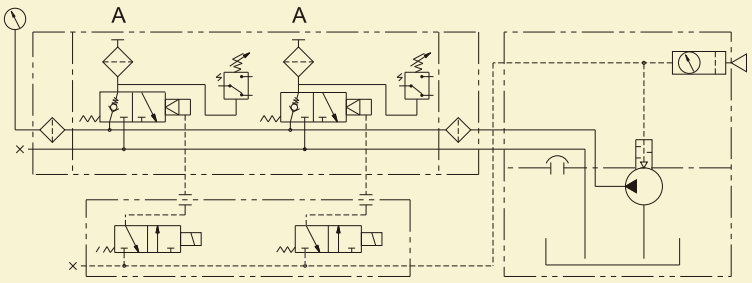
Transmission pressure rate



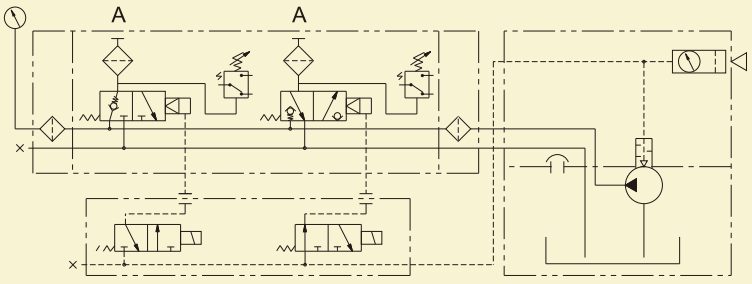
Technical data

Model no.	BPT-62-LELE-1-5	BPT-62-LELF-1-5
Transmission pressure ratio	1 : 62	1 : 62
Hydraulic working pressure (bar)	250	250
Pneumatic supply pressure (bar)	4.2	4.2
Valve type	N.O 2pcs	N.O 1pc, N.C 1pc
Solenoid operating voltage	AC 110V 50/60 Hz	AC 110V 50/60 Hz
Hydraulic oil	ISO-VG-32 or equivalent	ISO-VG-32 or equivalent
Usable oil volume (l)	5	5
Versions		
a	449 mm	449 mm
b	139 mm	139 mm
c	290 mm	290 mm

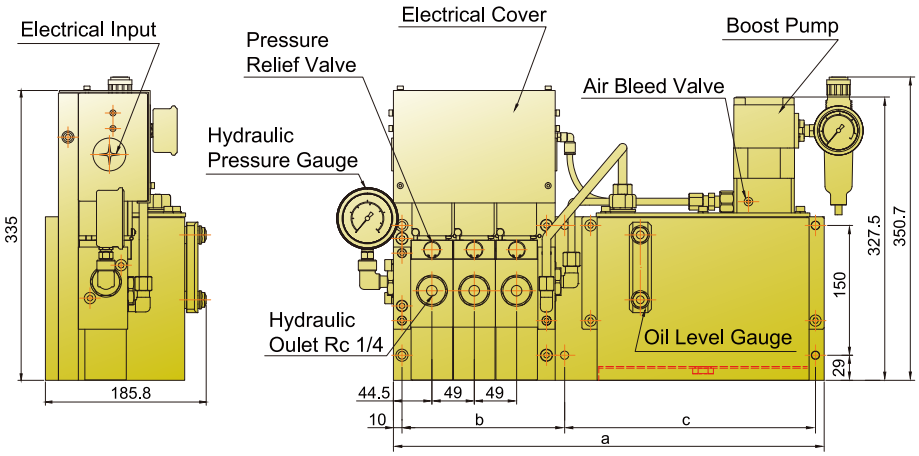
Circuit diagram (valve LE LE)



Circuit diagram (valve LE LF)



Three Circuits Power Unit



Application

The power unit is equipped with a balanced pneumatic-hydraulic boost pump and three hydraulic control valves.There are two types of the hydraulic control valve for selection.The valve of LE type is normally-open(N.O), exclusive for die clamp, LF type is normally-closed (N.C), exclusive for die lifter.

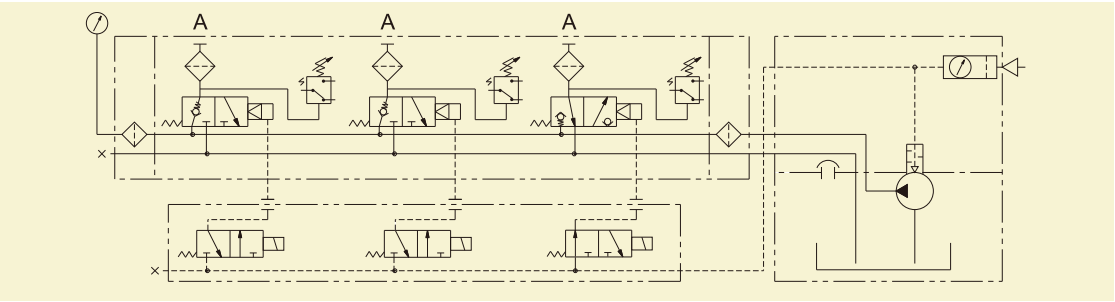
Important note

The hydraulic control valve is operated a pneumatic solenoid for remote control.The hydraulic control valve is built in a high pressure filter with inlet and outlet port. It's necessary to have to make sure the fluid clean through the valve to the clamp.

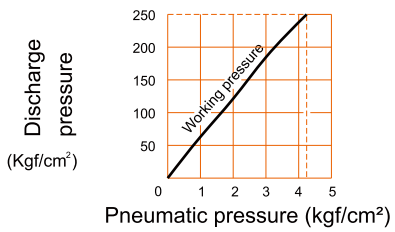
Technical data

Model no.	BPT-62-LELELF-1-5
Transmission pressure ratio	1 : 62
Hydraulic working pressure (bar)	250
Pneumatic supply pressure (bar)	4.2
Valve type	N.O 2pcs, N.C 1pc
Solenoid operating voltage	AC 110V 50/60 Hz
Hydraulic oil	ISO-VG-32 or equivalent
Usable oil volume (l)	5
Versions	
a	498 mm
b	188 mm
c	290 mm

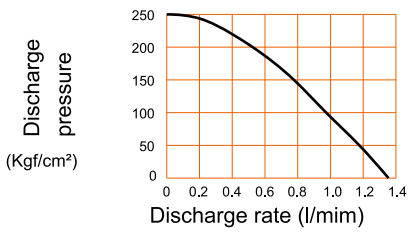
Circuit diagram (valve LE LE LF)



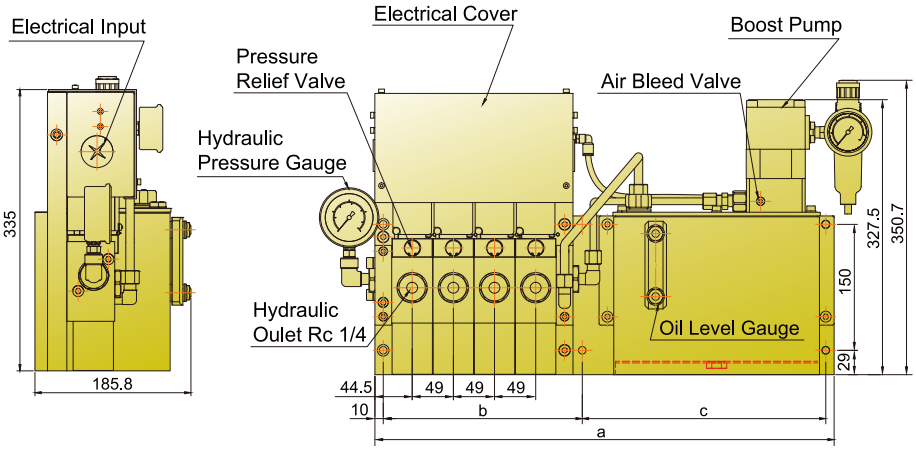
Transmission pressure rate



Discharge flow rate



Four Circuits Power Unit



Application

The power unit is equipped with a balanced pneumatic-hydraulic boost pump and four hydraulic control valves.There are two types of the hydraulic control valve for selection.The valve of LE type is normally-open(N.O), exclusive for die clamp, LF type is normally-closed (N.C), exclusive for die lifter.

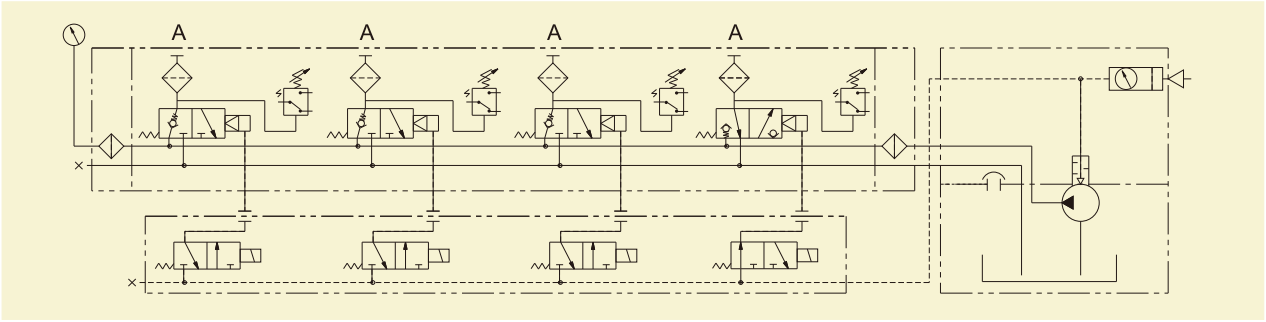
Important note

The hydraulic control valve is operated a pneumatic solenoid for remote control.The hydraulic control valve is built in a high pressure filter with inlet and outlet port. It's necessary to have to make sure the fluid clean through the valve to the clamp.

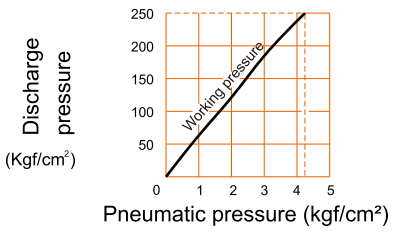
Technical data

Model no.	BPT-62-LELELELF-1-5
Transmission pressure ratio	1 : 62
Hydraulic working pressure (bar)	250
Pneumatic supply pressure (bar)	4.2
Valve type	N.O 3pcs, N.C 1pc
Solenoid operating voltage	AC 110V 50/60 Hz
Hydraulic oil	ISO-VG-32 or equivalent
Usable oil volume (l)	5
Versions	
a	547 mm
b	247 mm
c	290 mm

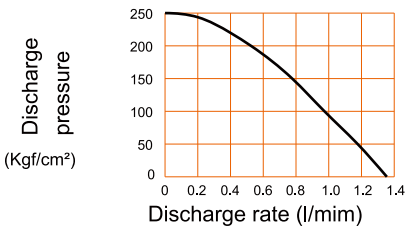
Circuit diagram (valve LE LE LE LF)

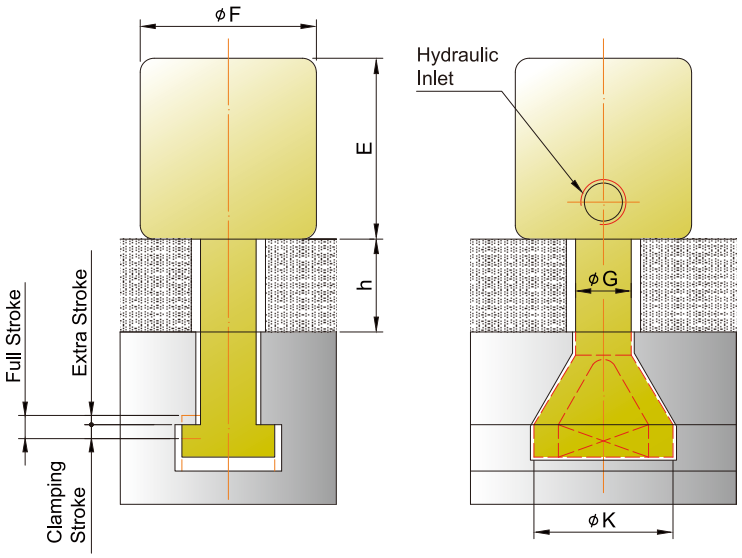


Transmission pressure rate



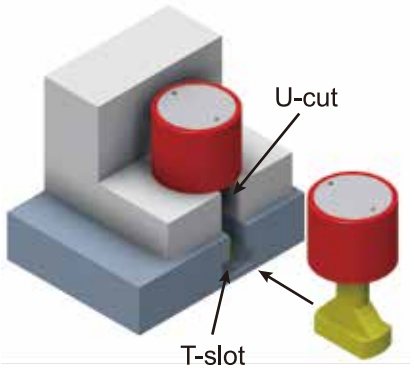
Discharge flow rate

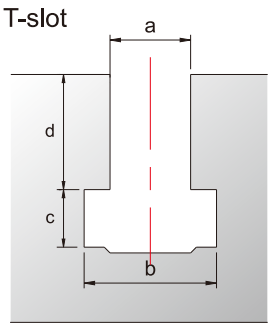




Application

This compact piston type clamp is for clamping dies on press bolster and slider with space-efficient. It requires U-cuts on the die shoe.The leg of the clamp is machined to fit T-slot on the bolster and slider.

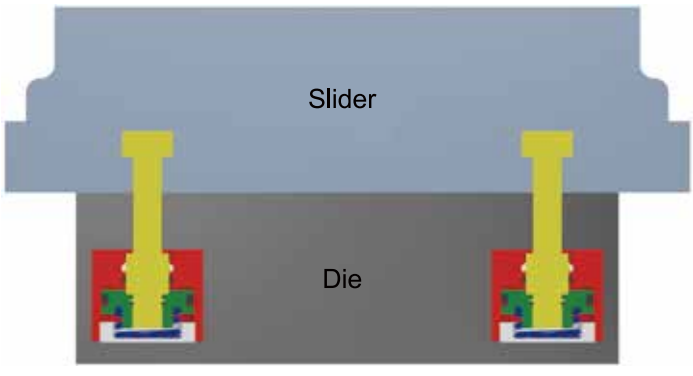


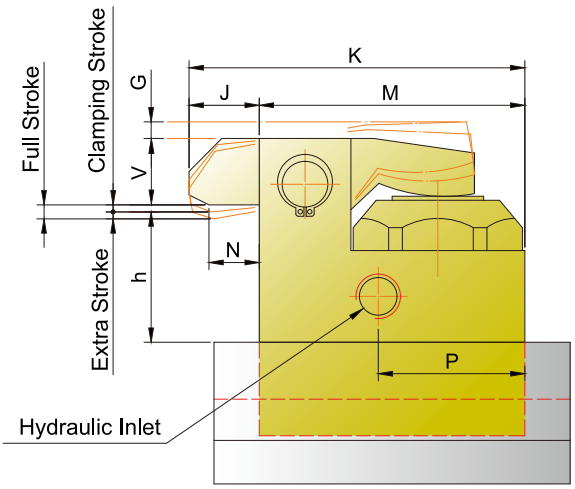


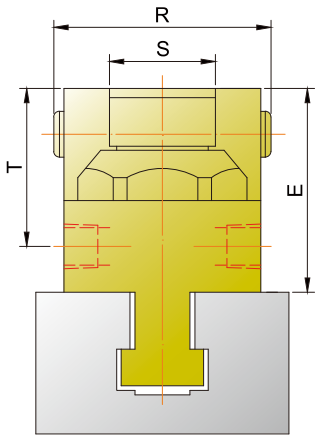
Important note

- Clamping stroke and extra stroke are for standard press dies.
- Custom stroke available on request.
- Specify T-slot dimension (a,b,c,d) and clamping height (h) when ordering.

Model no.		TA-01	TA-02	TA-03	TA-04	TA-06	TA-10	TA-16	TA-25
Clamping force at 250 bar	(tf)	1	1.5	2.4	4	6.3	10	16	25
Full stroke		6	8	8	8	8	8	8	8
Clamping stroke		4	5	5	5	5	5	5	5
Extra stroke		2	3	3	3	3	3	3	3
Total oil requirement	(cm^3)	2.6	5.8	8	13	21	32	54	80
E	(mm)	39	48	52	58	65	71	80	103
ØF	(mm)	38	45	53	62	78	98	128.5	154
ØG	(mm)	12	15.5	19	23	28.5	39	48.5	58.5
ØK	(mm)	30	38	48	58	68	78	88	98
Hydraulic Inlet	(Rc)	1/8	1/8	1/4	1/4	1/4	1/4	1/4	1/4

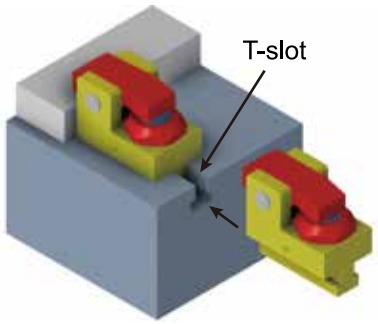


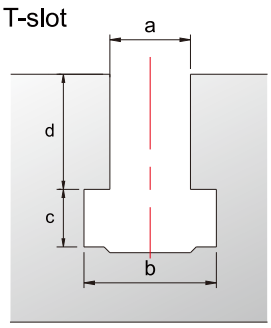




Application

This lever type clamp is available as a single acting spring return and it may be used in a wide range of applications.The base of the clamp is machined to fit the T-slot on the bolster and slider

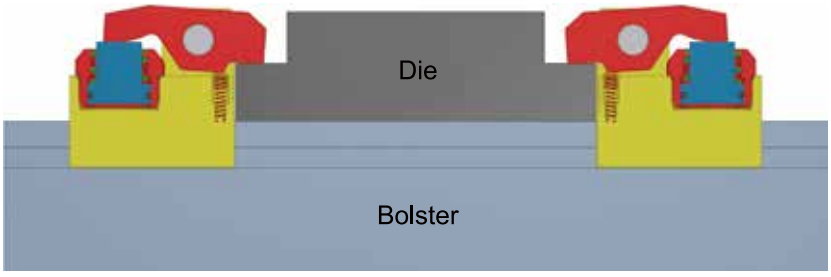




Important note

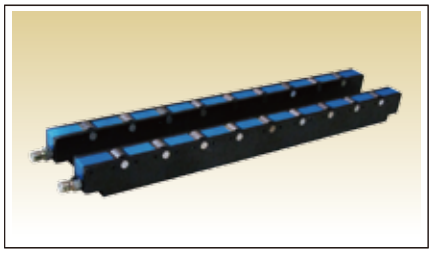
- Clamping stroke and extra stroke are for standard press dies.
- Custom stroke available on request.
- Specify T-slot dimension and clamping (a,b,c,d) height (h) when ordering.

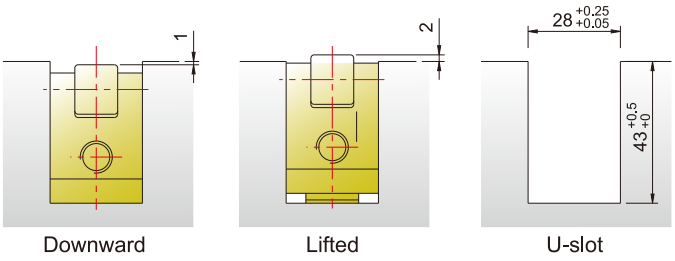
Model no.		TB-01	TB-02	TB-03	TB-04	TB-06	TB-10	TB-16	TB-25	TB-30	TB-50
Clamping force at 250 bar	(tf)	1	1.5	2.4	4	6.3	10	16	25	30	50
Full stroke		6	10	7	7	8	8	8	9	10	10
Clamping stroke		3	5	4	4	4	4	4	5	5	5
Extra stroke		3	5	3	3	4	4	4	4	5	5
Total oil requirement	(cc)	2.7	7.7	9.1	13	24	38.6	71.2	100.5	125	226
E(MIN.)	(mm)	45	60.7	59	69	82	108	127	152	172	205
G	(mm)	7	10	7	7	8	8	10	10	8.5	14
J	(mm)	15	18	20	23	30	30	30	32	35	37
K	(mm)	75	99	105	129	161	190	230	272	301.5	377
M	(mm)	60	81	85	106	131	160	200	240	266.5	340
N	(mm)	10	14	14	16	20	20	20	24	23	23
P	(mm)	32	44.5	44.5	53	64	78	95	100	115	140
R	(mm)	43.8	58.4	63.9	73	93.3	104	125	153.6	178	200
S	(mm)	20	30	32	40	50	55	60	73	83	100
T	(mm)	39.5	49	51.5	60	70	95	117	136	150	179
V Min.	(mm)	16	17.5	21.5	29.5	29.5	44	61	78	114	147
Hydraulic Inlet	(Rc)	1/8	1/4	1/4	1/4	1/4	1/4	1/4	1/4	1/4	3/8

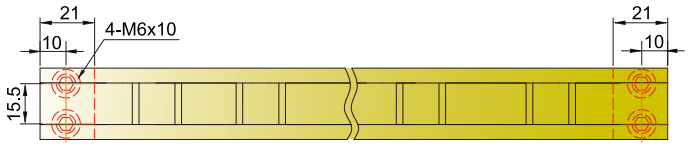


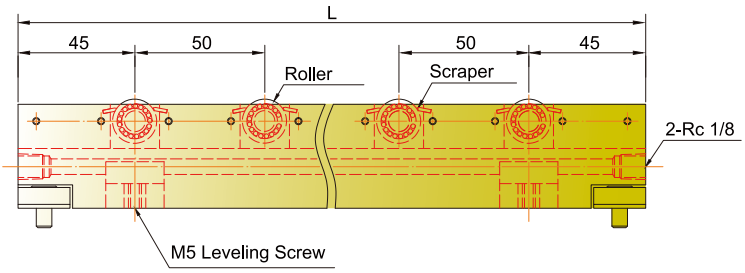
Roller Type Die Lifter

LA28 series









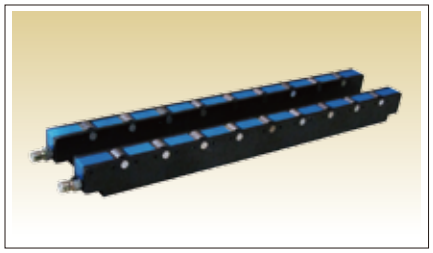
Description

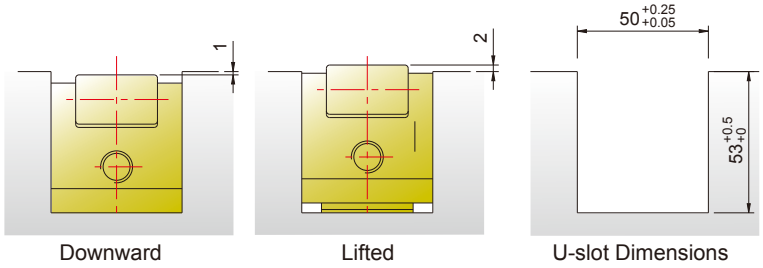
The LA roller type die lifter withstands heavy load weights and abuse. It meets the request of many customers for an element with linear movement and higher load carrying capacity. It's put into U-slot and particular for die change in connection with hydraulic die clamping.
As a result of the line contact of the rollers and the scrapers keeping the roller surfaces free, a smooth load transfer is achieved.
The size of LA28 series depends on U-slot dimentions and load requirements.

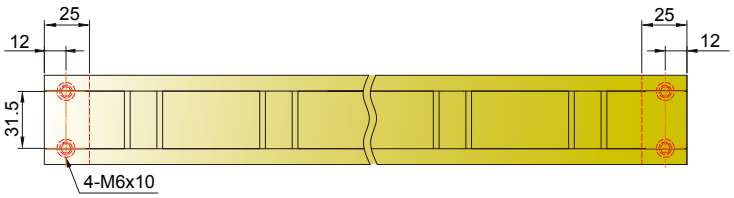
Model no.	L (mm)	Roller Qty	Lift cyl. pcs.	Lift force (kgf)	Working pressure (bar)	Total stroke (mm)
LA28-190	190	3	2	1000	250	3
LA28-240	240	4	2	1000	250	3
LA28-290	290	5	2	1000	250	3
LA28-340	340	6	2	1000	250	3
LA28-390	390	7	2	1000	250	3
LA28-440	440	8	3	1500	250	3
LA28-490	490	9	3	1500	250	3
LA28-540	540	10	3	1500	250	3
LA28-590	590	11	4	2000	250	3
LA28-640	640	12	4	2000	250	3
LA28-690	690	13	4	2000	250	3
LA28-740	740	14	4	2000	250	3
LA28-790	790	15	5	2500	250	3
LA28-840	840	16	5	2500	250	3
LA28-890	890	17	5	2500	250	3
LA28-940	940	18	6	3000	250	3
LA28-990	990	19	6	3000	250	3
LA28-1040	1040	20	6	3000	250	3
LA28-1090	1090	21	6	3000	250	3
LA28-1140	1140	22	7	3500	250	3
LA28-1190	1190	23	7	3500	250	3
LA28-1240	1240	24	7	3500	250	3
LA28-1290	1290	25	7	3500	250	3
LA28-1340	1340	26	8	4000	250	3
LA28-1390	1390	27	8	4000	250	3
LA28-1440	1440	28	8	4000	250	3
LA28-1490	1490	29	8	4000	250	3

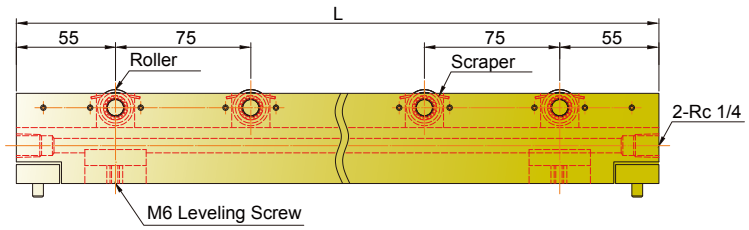
Roller Type Die Lifter

LA50 series









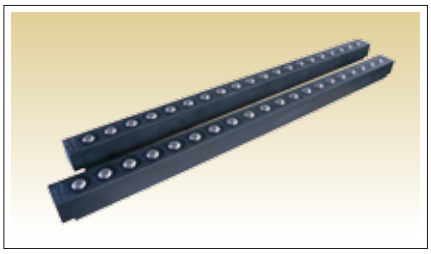
Description

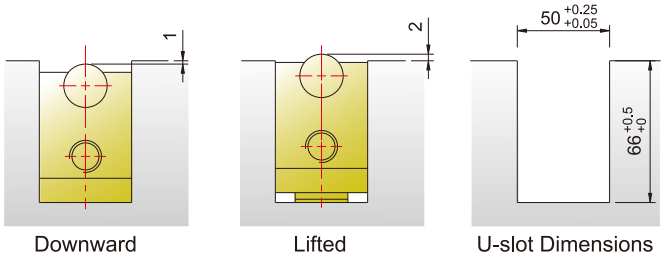
The LA roller type die lifter withstands heavy load weights and abuse. It meets the request of many customers for an element with linear movement and higher load carrying capacity. It's put into U-slot and particular for die change in connection with hydraulic die clamping.
As a result of the line contact of the rollers and the scrapers keeping the roller surfaces free, a smooth load transfer is achieved.
The size of LA50 series depends on U-slot dimentions and load requirements.

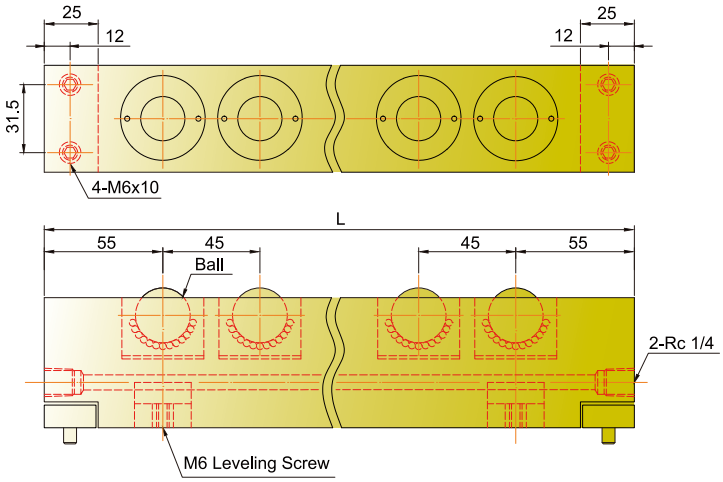
Model no.	L (mm)	Roller Qty	Lift cyl. pcs.	Lift force (kgf)	Working pressure (bar)	Total stroke (mm)
LA50-185	185	2	2	2240	250	3
LA50-260	260	3	2	2240	250	3
LA50-335	335	4	2	2240	250	3
LA50-410	410	5	2	2240	250	3
LA50-485	485	6	2	2240	250	3
LA50-560	560	7	3	3360	250	3
LA50-635	635	8	3	3360	250	3
LA50-710	710	9	3	3360	250	3
LA50-785	785	10	4	4480	250	3
LA50-860	860	11	4	4480	250	3
LA50-935	935	12	4	4480	250	3
LA50-1010	1010	13	4	4480	250	3
LA50-1085	1085	14	5	5600	250	3
LA50-1160	1160	15	5	5600	250	3
LA50-1235	1235	16	5	5600	250	3
LA50-1310	1310	17	6	6720	250	3
LA50-1385	1385	18	6	6720	250	3
LA50-1460	1460	19	6	6720	250	3
LA50-1535	1535	20	7	7840	250	3
LA50-1610	1610	21	7	7840	250	3
LA50-1685	1685	22	7	7840	250	3
LA50-1760	1760	23	8	8960	250	3
LA50-1835	1835	24	8	8960	250	3

Ball Type Die Lifter

LWB50 series



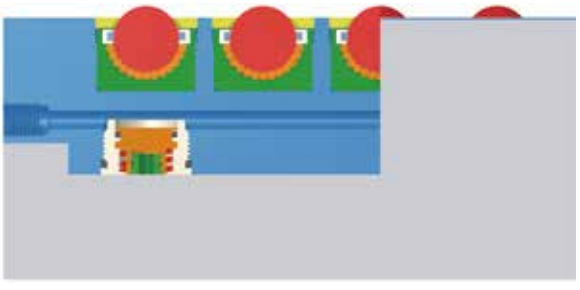


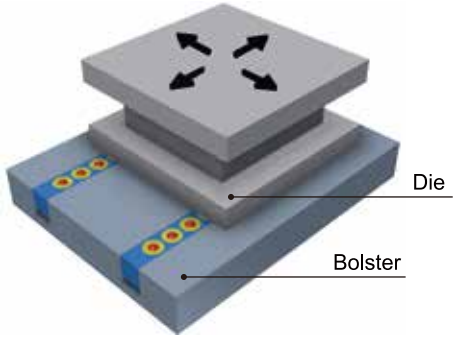


Description

The ball type die lifter enables movement in any direction to the die.
This type is designed to lift dies from bolster and provide a low rolling friction. It consists of a bar that is equipped with hydraulically operated liftting piston and supporting ball. It's put into U-slot and particular for die change in connection with hydraulic die clamping.The size of LWB50 series depends on the U-slot dimentions and load requirements.

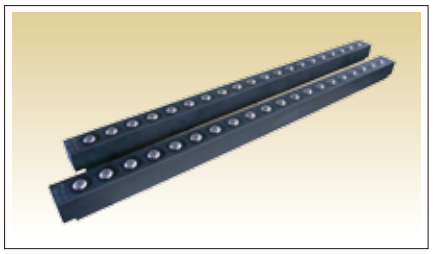
Model no.	L (mm)	Ball Qty	Lift cyl. pcs.	Lift force (kgf)	Working pressure (bar)	Total stroke (mm)
LWB50-425	425	8	3	3360	250	3
LWB50-470	470	9	3	3360	250	3
LWB50-515	515	10	4	4480	250	3
LWB50-560	560	11	4	4480	250	3
LWB50-605	605	12	4	4480	250	3
LWB50-650	650	13	4	4480	250	3
LWB50-695	695	14	5	5600	250	3
LWB50-740	740	15	5	5600	250	3
LWB50-785	785	16	5	5600	250	3
LWB50-830	830	17	5	5600	250	3
LWB50-875	875	18	6	6720	250	3
LWB50-920	920	19	6	6720	250	3
LWB50-965	965	20	6	6720	250	3
LWB50-1010	1010	21	6	6720	250	3
LWB50-1055	1055	22	6	6720	250	3
LWB50-1100	1100	23	7	7840	250	3
LWB50-1145	1145	24	7	7840	250	3
LWB50-1190	1190	25	7	7840	250	3

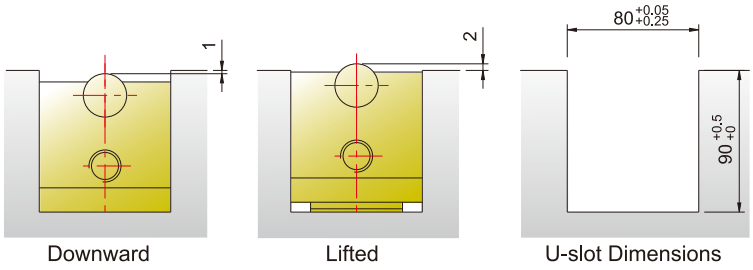


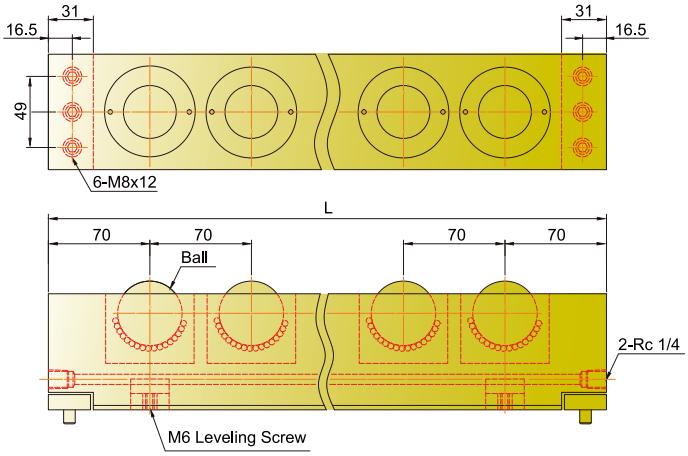


Ball Type Die Lifter

LWB80 series



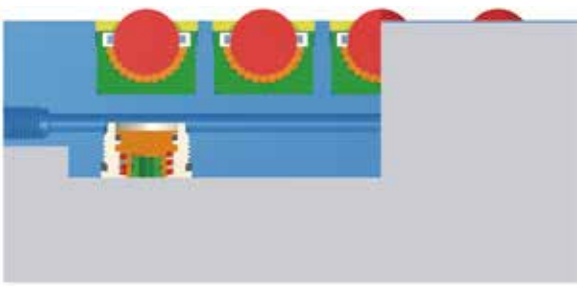


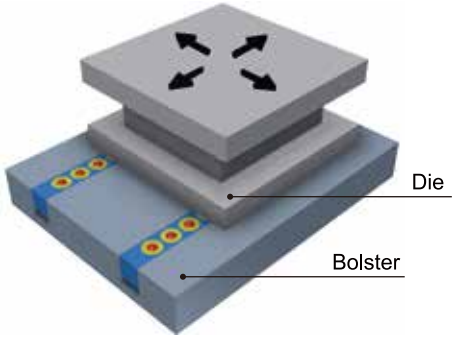


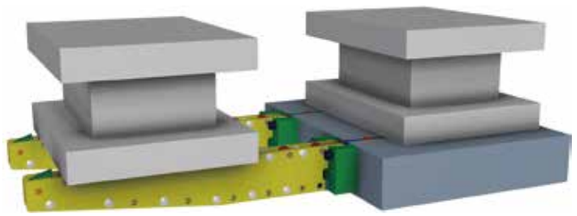
Description

The ball type die lifter enables movement in any direction to the die.
This type is designed to lift dies from bolster and provide a low rolling friction. It consists of a bar that is equipped with hydraulically operated liftting piston and supporting ball. It's put into U-slot and particular for die change in connection with hydraulic die clamping.The size of LWB80 series depends on the U-slot dimentions and load requirements.

Model no.	L (mm)	Ball Qty	Lift cyl. pcs.	Lift force (kgf)	Working pressure (bar)	Total stroke (mm)
LWB80-420	420	5	5	5600	250	3
LWB80-490	490	6	5	5600	250	3
LWB80-560	560	7	5	5600	250	3
LWB80-630	630	8	6	6720	250	3
LWB80-700	700	9	7	7840	250	3
LWB80-770	770	10	7	7840	250	3
LWB80-840	840	11	8	8960	250	3
LWB80-910	910	12	9	10080	250	3
LWB80-980	980	13	9	10080	250	3
LWB80-1050	1050	14	10	11200	250	3
LWB80-1120	1120	15	11	12320	250	3
LWB80-1190	1190	16	11	12320	250	3
LWB80-1260	1260	17	12	13440	250	3
LWB80-1330	1330	18	13	14560	250	3
LWB80-1400	1400	19	13	14560	250	3
LWB80-1470	1470	20	14	15680	250	3
LWB80-1540	1540	21	14	15680	250	3
LWB80-1610	1610	22	15	16800	250	3







Description

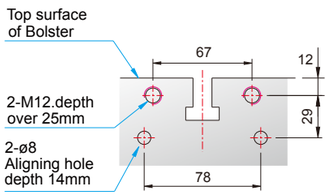
The bolster extensions represents the ideal additional attachment for rational die change on presses.There are equipped with hardened rollers on which the die is placed outside the press.According to carrying capacity, application and mounting conditions, a wide variety of design can be supplied. Available in three different designs :

. LC series , detachable
. LD series , drop-down
. LE / LF series , folding

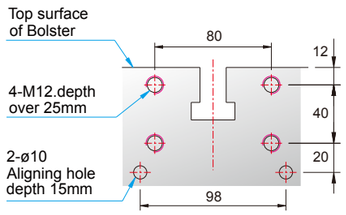
The bolster extensions are always used in pairs.

Mounting hole dimensions (for LC, LD, LE / LF)

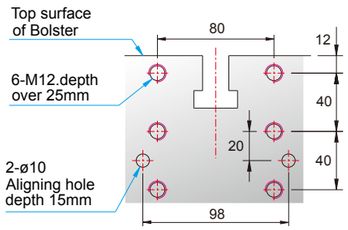
Common to 65,66



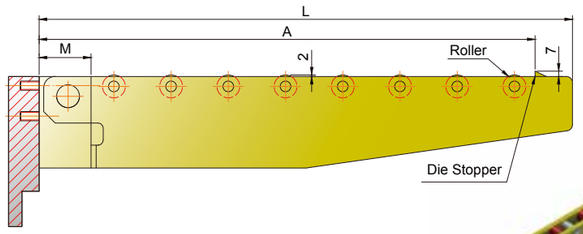
Common to 75,77,85,88

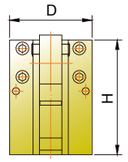


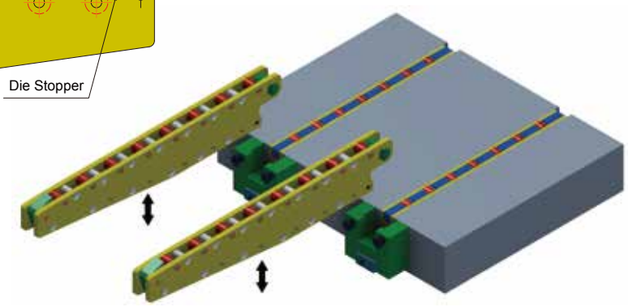
Common to 95,99



LC Series , detachable

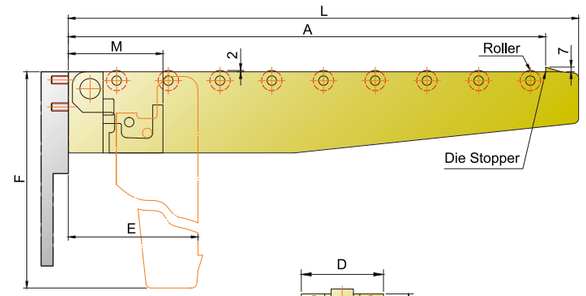


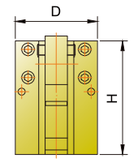


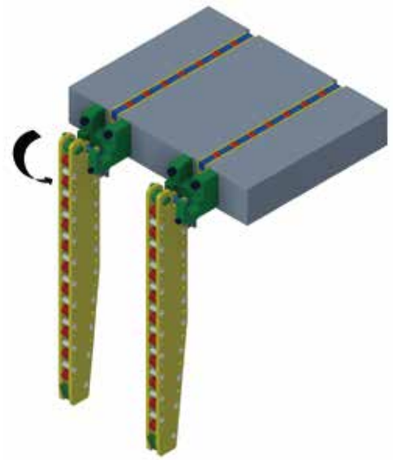


Model no.	Max.Load cap. roller W (kgf)	Die travel A (mm)	Over all. length L (mm)	Block height H (mm)	Block width D (mm)	Block thickness M (mm)	Roller Qty N
LC65	440	500	552	80	98	45	8
LC66	320	600	652	80	98	45	11
LC75	850	500	552	120	116	51	6
LC77	620	700	752	120	116	51	9
LC85	1280	500	552	160	116	51	6
LC88	850	800	852	160	116	51	10
LC95	1650	500	552	200	116	51	6
LC99	950	900	952	200	116	51	11

LD Series , drop-down

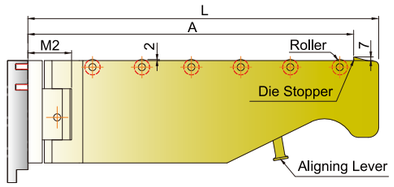


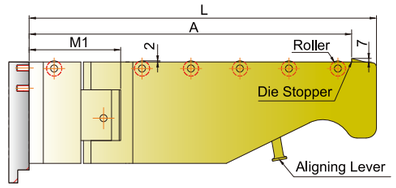


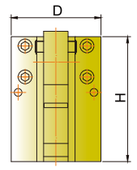


Model no.	Max.Load cap. roller W (kgf)	Die travel A (mm)	Over all. length L (mm)	Block height H (mm)	Block width D (mm)	Block thickness M (mm)	Roller Qty N	E (mm)	F (mm)
LD65	440	500	552	80	98	100	8	101	588
LD66	320	600	652	80	98	100	11	140	648
LD75	850	500	552	120	116	139	6	190	550
LD77	620	700	752	120	116	139	9	190	750
LD85	1280	500	552	160	116	147	6	181	663
LD88	850	800	852	160	116	147	10	234	870
LD95	1650	500	552	200	116	155	6	221	703
LD99	950	900	952	200	116	155	11	280	1005

LE / LF Series , folding

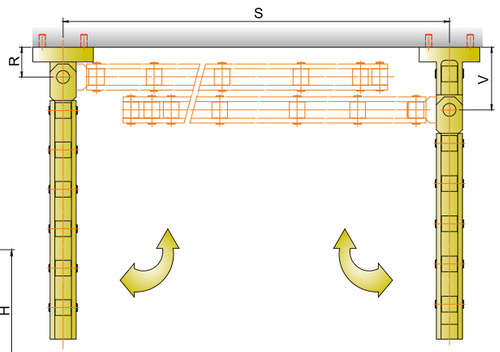






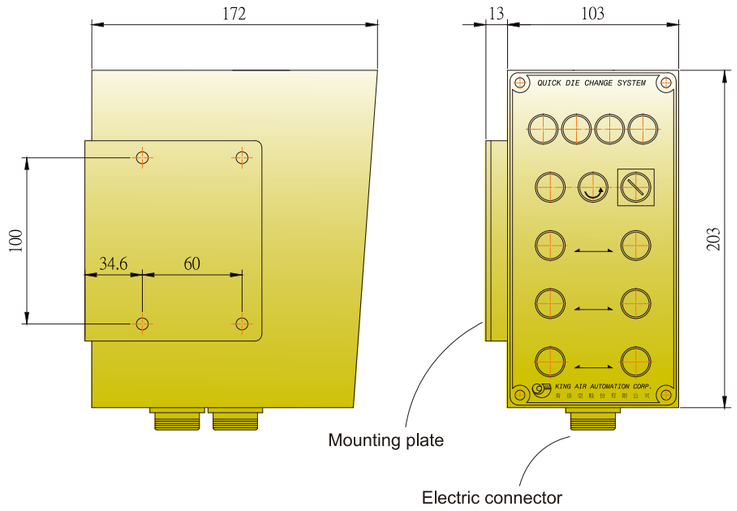
LE Series

LF Series



Model no.	Max.Load cap. (at roller A) W (kgf)	Die travel A (mm)	Over all. length L (mm)	Block height H (mm)	Block width D (mm)	Block thickness (mm) M1	Block thickness (mm) M2	Roller Qty N	Min. Mounting pitch S (mm)	V (mm)	R (mm)
LE , LF 65	440	500	552	100	116	119	69	8	530	100	50
LE , LF 66	320	600	652	100	116	119	69	10	630	100	50
LE , LF 75	850	500	552	120	116	145	82	7	527	120	57
LE , LF 77	620	700	752	120	116	145	82	9	727	120	57
LE , LF 85	1280	500	552	160	116	145	82	7	527	120	57
LE , LF 88	850	800	852	160	116	145	82	11	827	120	57
LE , LF 95	1650	500	552	200	116	145	82	7	527	120	57
LE , LF 99	950	900	952	200	116	145	82	11	927	120	57

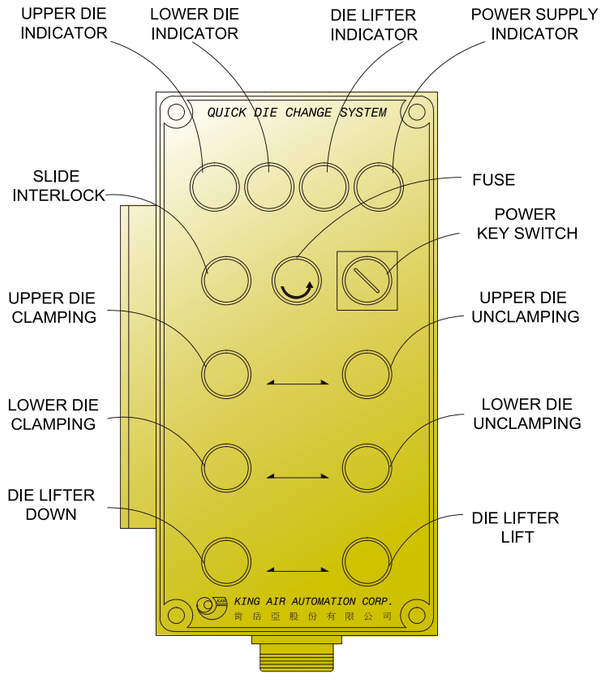
Control Panel



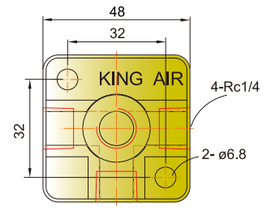
Description

This control panel is operated with safety and convenience to the Quick Die Change System on presses, and it consists of the electric supply key switch to prevents operation by anyone other than the operators. The system pressure indicator to show the situation of the clamp.
The clamp operated by push botton provides die change faster and easier.
The control panel contact with the pressure switch of power unit,cam switch and emergency stop switch of the press to create interlock circuit.
When the hydraulic pressure of power unit lower than the normal working pressure level,It causes the press to stop.

Model no.	EC-05
Supply voltage	AC 110V 50/60 Hz
Key actuated	ON - die change operation
	OFF- take the key from key switch after the die clamped



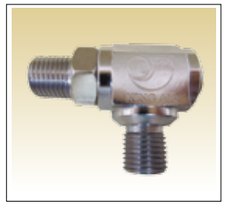
Accessories

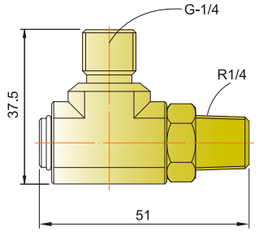


Connect block

Model no. CN-24

The connect block is a interface of steel tube and hydraulic hose. It is fixed on bolster and slider shoe to be hydraulic pressure passage of the press.

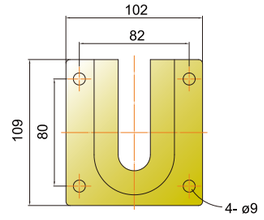




Rotary coupling

Model no. RC-22

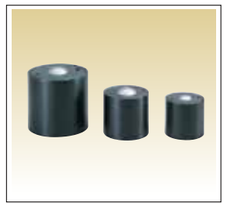
This rotary coupling is mounted in the hydraulic connect block and supply the pressure oil to the clamp by the high pressure hose. The rotating and swivelling installations can be satisfied.

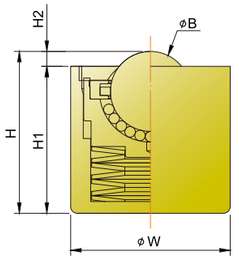


Clamp bracket

Model no. MU-01

The clamp bracket is fixed on bolster and slider shoe of the press. The leg or base of clamp should be mounted on it while die changing.

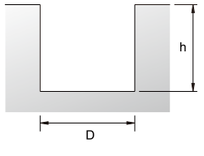




Ball transfer

This ball transfer is put into the hole on the bolster. The main assembly of it is high loading spring and steel ball. When a die on bolster mounted with this, the die will be raised above the bolster surface on the ball transfer by spring action inside. The die can be moved with smooth and easily.

Groove Dimensions



Model no.	H (mm)	H1 (mm)	H2 (mm)	W (mm)	øB (mm)	Weight (g)	Rating (kg)	D (mm)	h (mm)
B-6HS	38±0.1	35	3	38±0.1	19.05	250	50	ø38 $^{+0.1}_{+0.5}$	36±0.1
B-8HS	45±0.1	40.3	4.7	44±0.1	25.40	400	100	ø44 $^{+0.1}_{+0.5}$	43±0.1
B-10HS	60±0.1	55	5	60±0.1	25.40	1100	200	ø60 $^{+0.1}_{+0.5}$	58±0.1

Quotation Information Form

Company _____ Name _____

Address _____ Dep. _____

_____

Phone _____ Fax _____

For a quotation, notify us of the follow :

A. Press

A-1 New or existing ☐ New ☐ Existing

A-2 Type of press ☐ C frame ☐ Straight side ☐ High speed ☐ Transfer

☐ Others specify : _____

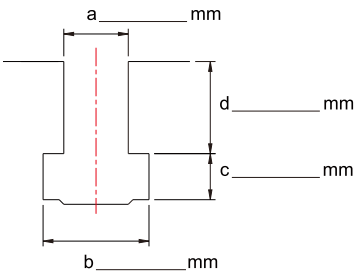
A-3 Tonnage _____ tf (☐ US, ☐ Metric)

A-4 Slide dimensions (L-R) _____ X (F-B) _____ mm (inch)

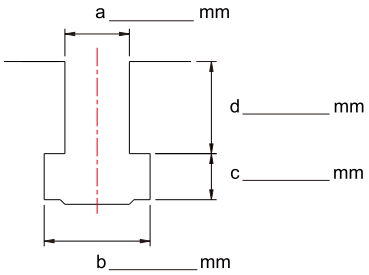
A-5 Bolster dimensions (L-R) _____ X (F-B) _____ mm (inch)

A-6 T-slot ☐ Yes ☐ No

for slider



for bolster



B. Die

B-1 Maximum weight _____ kg(lbs)

B-2 Maximum dimensions (W) _____ X(L) _____ X(H) _____ mm(inch)

B-3 U-cut for bolting ☐ Yes ☐ No

B-4 Die shoe thickness _____ mm(inch)

B-5 Special requirements _____

C. Die change system

C-1 Required components ☐ Clamp Model _____ X _____ pc(s)

☐ Die lifter Model _____ X _____ pc(s)

☐ Bolster extension Model _____ X _____ pc(s)

☐ Power unit Model _____ X _____ pc(s)

C-2 Valve operation Poewr supply ☐ AC ☐ DC _____ V _____ Hz

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