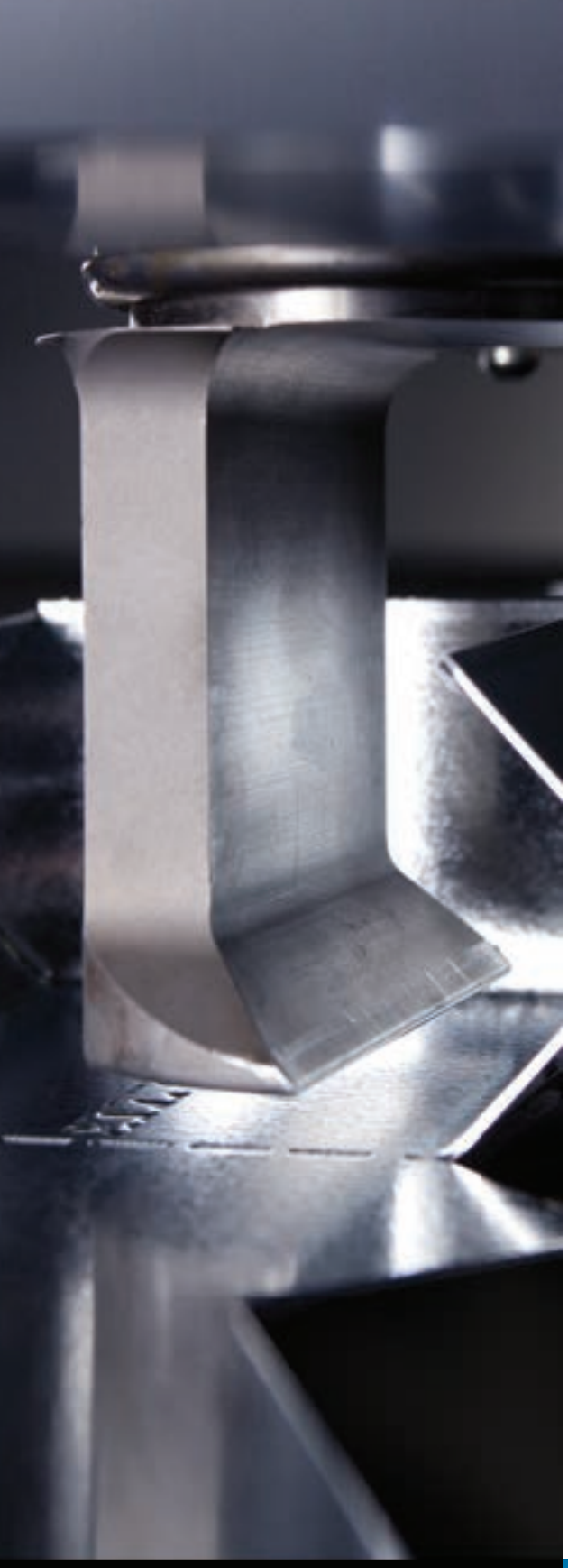


Pullmax Series

PUNCHING MACHINES

www.lvdgroup.com

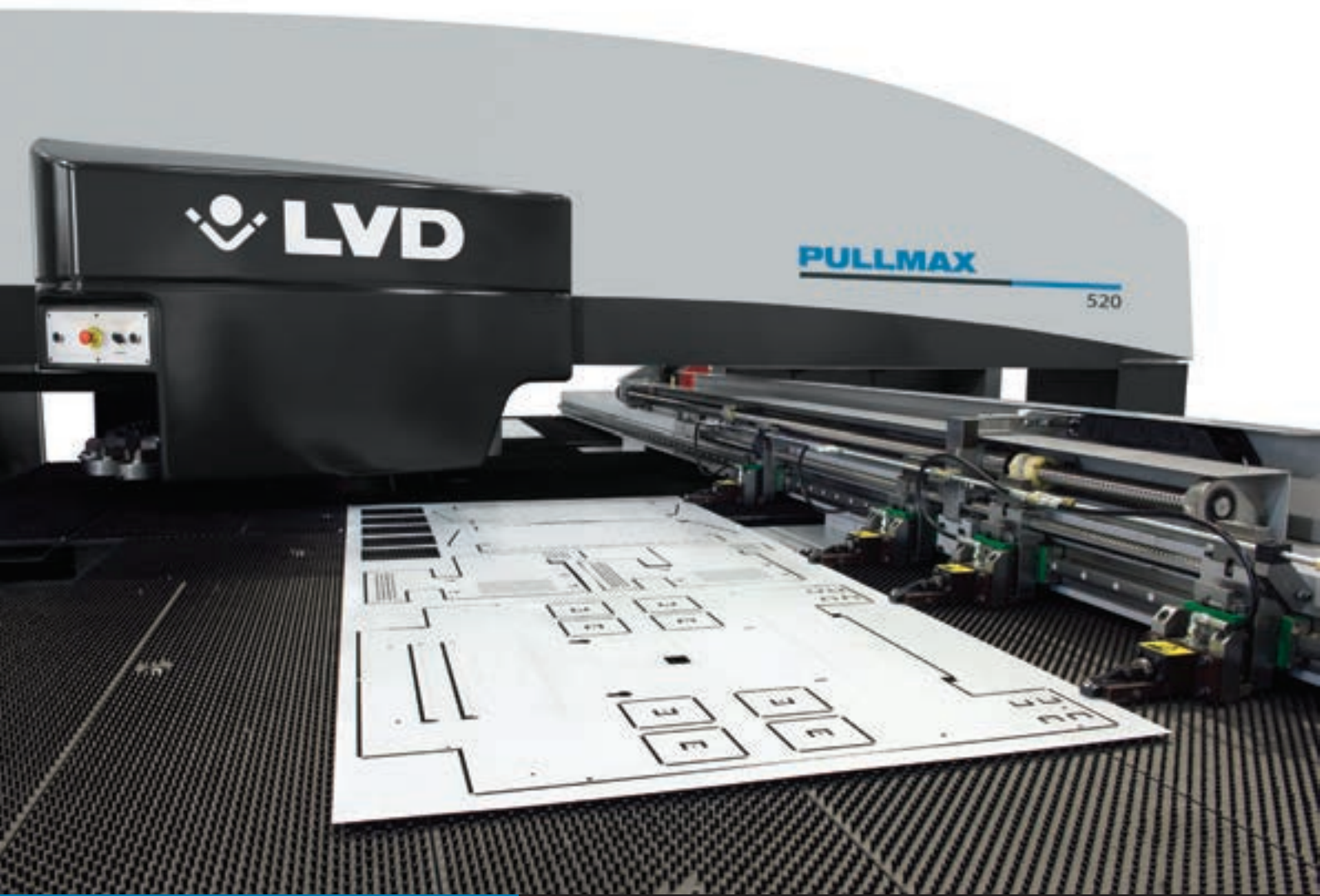
Sheet Metalworking, Our Passion, Your Solution

PULLMAX SERIES

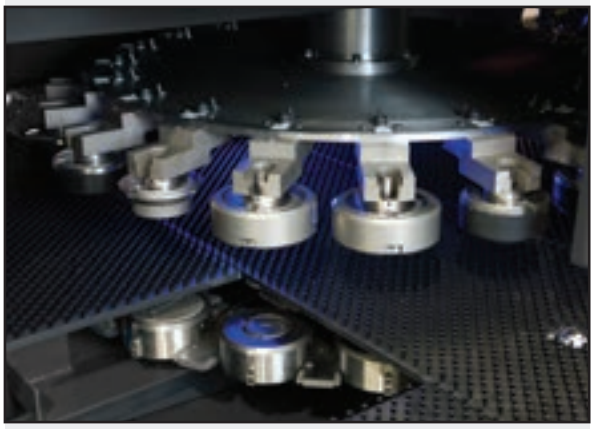
Punch, Form, Bend and Tap on a Single Machine

If you punch, form, bend and tap, there is no more efficient technology than Pullmax Series punch presses. With a Pullmax Series 200 or 300 KN model, multiple processes are completed on a single machine, including the processing of complex, three-dimensional parts. It's technology that makes short work of virtually any punching or forming requirement.

- Efficient hydraulic punching unit combined with table accelerations and speeds that match high hit rates and lower the cost of per part production
- Knockouts, louvers and countersinks are accurately produced, flanges up to 75 mm high can be formed in a variety of angles; internal as well as external bends can be achieved
- All-tool rotation allows each tool to rotate a full 360 degrees for complete versatility



- All 20 tool stations are designed to hold any size tool, up to a maximum diameter of 90 mm, with a capacity of up to 200 tools through use of indexable Multi-Tools
- A Fanuc PC-based control features an intuitive man-machine interface with full network capacity
- Material handling options allow for unmanned production 24 hours a day, 7 days a week

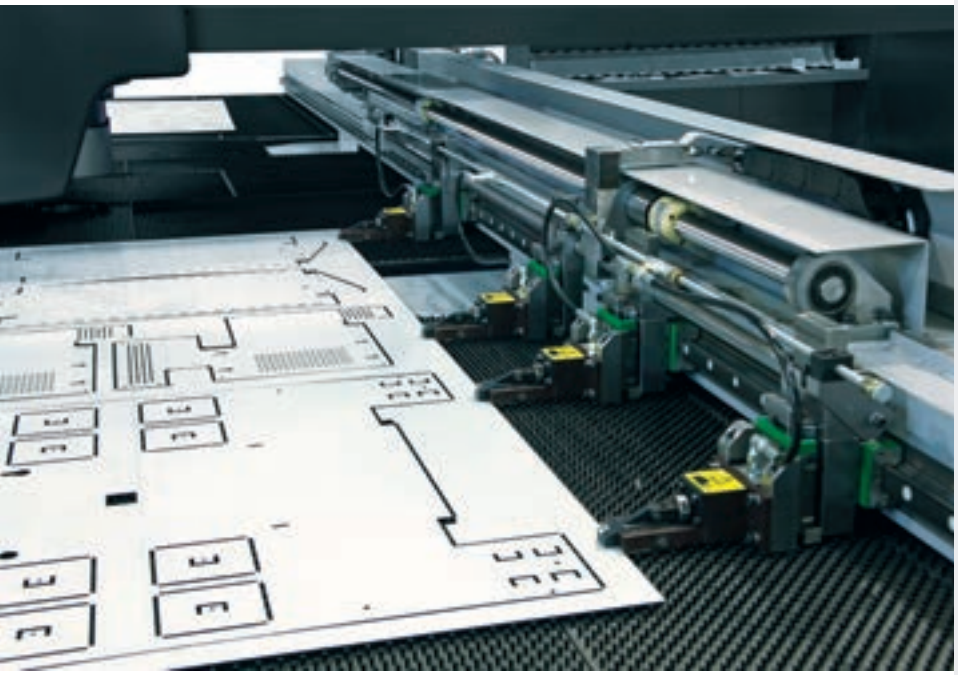


75mm **360°** **24/7**

PULLMAX SERIES

Versatile, High-speed and Energy Efficient

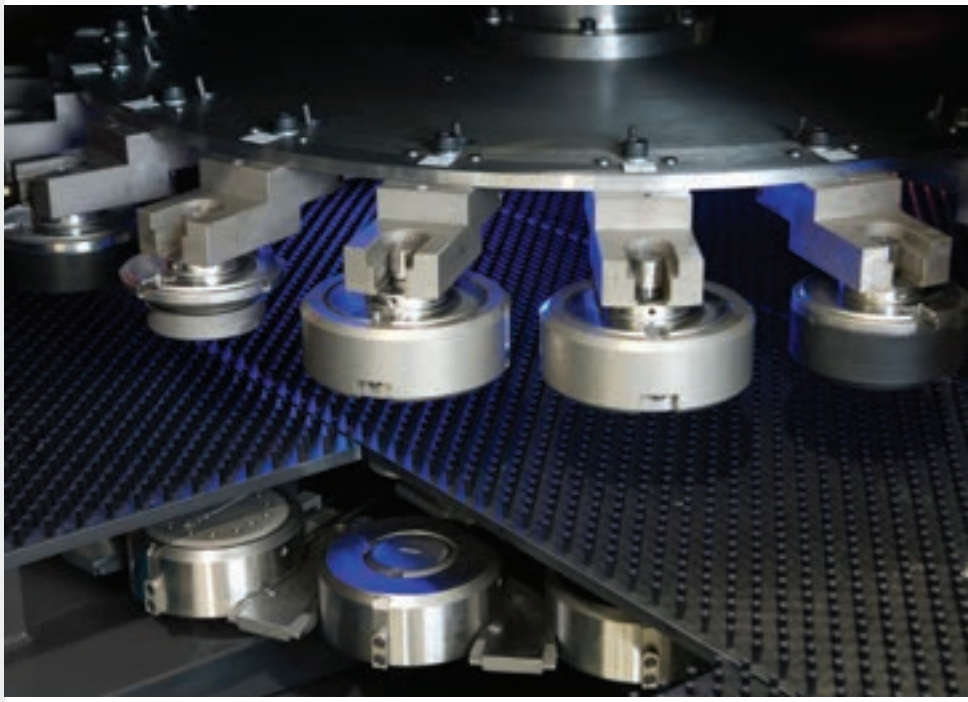
- Advanced forming capabilities, bend flanges up to 75 mm high
- All-tool 360 degree rotation
- Table speed of 128 m/min; up to 505 HPM on 25 mm centers
- 200 KN or 300 KN (20 or 30 metric ton) configurations
- Process workpieces up to 1500 x 3000 mm without reposition
- 20 tool stations accept tools up to 90 mm diameter, up to 200 tools through use of indexable Multi-Tools
- Indexable Multi-Tool compatibility
- Stable, closed frame design



- Efficient low power consumption of only 6.9 kW (average)
- Single punch head design provides superior tool life
- 4 programmable hydraulic clamps with vertical float to handle sheet distortion
- Sheet clamps independent from the tool positions
- Bristle table for high finished part quality
- Powerful Fanuc PC-based control

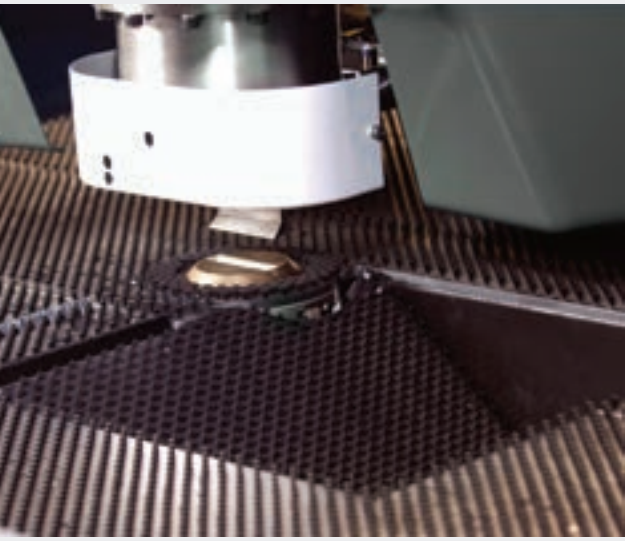
PULLMAX SERIES

Features and Options



SINGLE HEAD DESIGN

- 20 indexable tool stations with 90 mm maximum diameter
- Each station is fully indexable 360 degrees
- Minimizes tool change and set-up time
- All stations can be equipped with punching, forming, bending or tapping tools
- Quick change punch and die holders
- Standard Trumpf® style tooling system
- Indexable Multi-Tool (5 or 10 stations)



EXTENDED TOOL MAGAZINE (ETM)

- Optional extended tool magazine provides additional 40 stations (60 total)

PARTS CHUTE

- Programmable 500 x 525 mm parts chute
- Ideal for offloading of small parts
- Optional bin sort system

OPTIBEND

- Bend small boxes, brackets, knockouts, louvers and countersinks with flange heights up to 75 mm
- Reduces set-up time and part handling
- Facilitates forming operations in the punch press
- Reduces cost per part
- Parts located at any angle on the sheet can be formed
- Safer small parts bending

OPTITAP

- Fully automatic tapping system (with optional tooling)
- Decreases production cost per part; adds part value
- Extrusions in material thicknesses up to 3 mm
- Machine threads from M3 to M10
- Compatible with Wilson style tapping tool
- Optional single or multi-spindle external tapping units

OPTIMARK

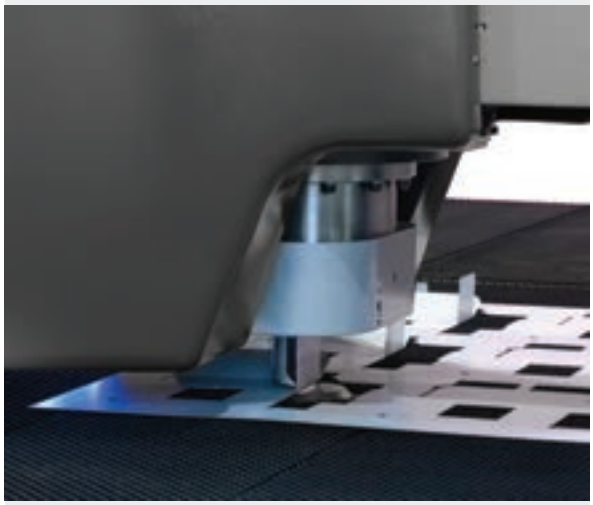
- 40 character ID stamp tool
- Eliminates secondary part marking operations
- Character set includes: A to Z inclusive; 0 to 9 inclusive; hyphen; forward slash; comma; full stop
- Special characters available

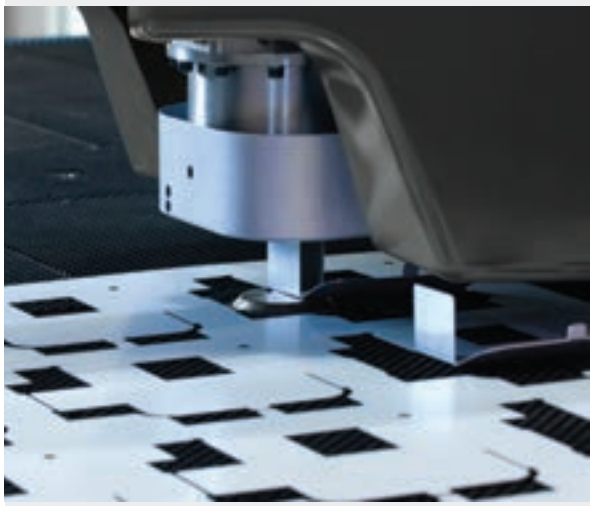
SCRAP CONVEYOR

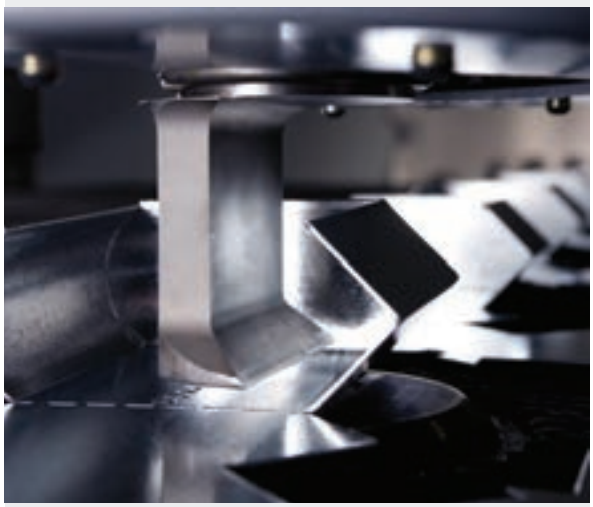
- Standard and custom solutions for scrap removal

SCRAP SORTING

- Optional scrap sorting system
- Slugs of varying material can be sorted into individual bins
- Finished parts and slugs can be sorted into individual bins
- Process controlled by the parts program







PULLMAX SERIES

Modular Automation Solutions

COMPACT AUTOMATION

- Automated material handling for workpieces up to 3000 x 1500 mm
- Handles raw materials and skeletons, punched and formed parts
- Compact, with a combined footprint of 70m²
- Handles sheet thicknesses up to 4,2 mm
- Material load capacity of up to 3 tons
- Load/unload time is approximately 25 seconds
- Part picking time of only 7 seconds
- 24/7 production of punched and formed components

PARTS SORTING

Sheet loader

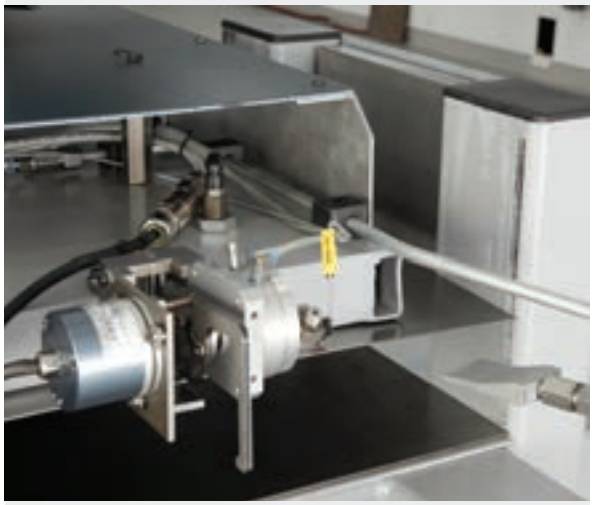
- Load and unload up to 3000 x 1500mm sheets
- Carriage system with AC-servo control
- Air-knife provides sheet separation
- Double sheet detection

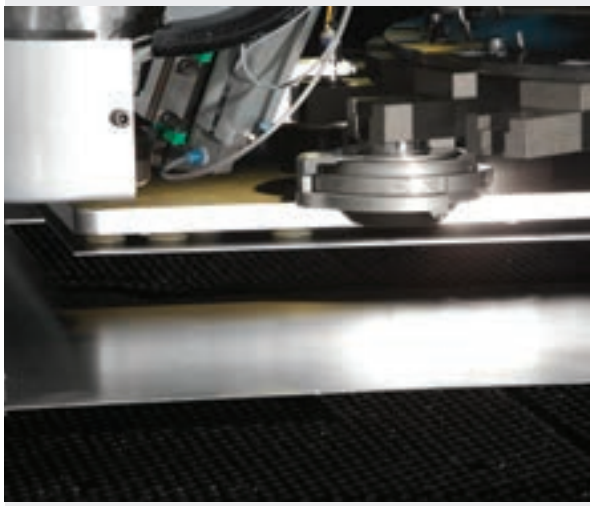
Sheet unloader

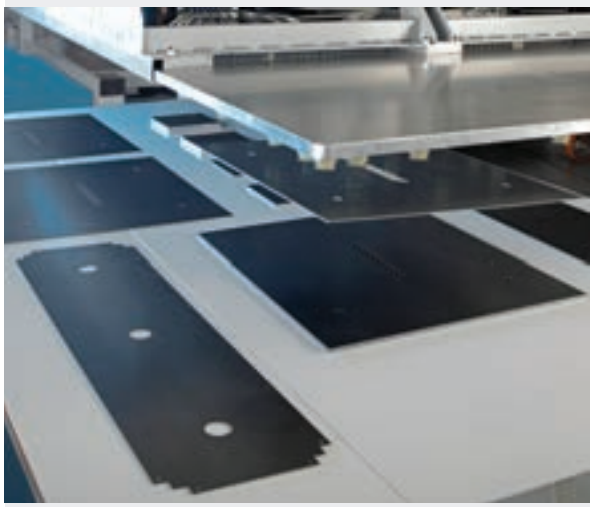
- Handles punched, nested parts and material skeletons
- Includes four material clamps to securely grip skeleton during removal

Part picker

- Two axis (X and Y) system sorts and stacks punched parts
- 15 m² of freely programmable sorting and stacking area
- Vacuum cup system automatically controlled through CNC







PULLMAX SERIES

Technical Specifications

	PULLMAX 520/720	PULLMAX 530/730
GENERAL SPECIFICATIONS		
Tooling system	Pullmax or Trumpf® style	Pullmax or Trumpf® style
Punch diameter, max.	90 mm	90 mm
Number of tool positions	20	20
Max. bending height	75 mm	75 mm
Number of tools	20-200*	20-200*
Tool changing time, inc. positioning	1*-5 sec	1*-5 sec
Working range		
X-travel	2590 mm/3090 mm	2590 mm/3090 mm
Y-travel	1425 mm/1725 mm	1425 mm/1725 mm
Max sheet size w/o repositioning		
X	2500 mm/3000 mm	2500 mm/3000 mm
Y	1250 mm/1500 mm	1250 mm/1500 mm
Axis speeds		
Simultaneous X-Y	128 m/min	128 m/min
Positioning accuracy, per 1 m	0,1 mm	0,1 mm
Sheet thickness, max.	8 mm	8 mm
Press capacity	200 KN	300 KN
Max sheet weight	230 Kg	230 Kg
Maximum hit rate		
1mm pitch	880 HPM	880 HPM
25mm pitch	505 HPM	505 HPM
Marking speed	1700 HPM	1700 HPM
Parts chute	505 x 525 mm	505 x 525 mm
CONTROL		
Make and type	Fanuc PC-based	Fanuc PC-based
Memory capacity for program	> 1 GB	> 1 GB
OPTIONS		
Extended tool magazine	no/yes	no/yes
Tapping units	yes	yes
Automated handling equipment	yes	yes
LAYOUT AND INSTALLATION DATA		
Footprint including safety light guards LxW	7000 x 5800/7800 x 6500 mm	7000 x 5800/7800 x 6500 mm
Average power consumption	6,9 kWh	6,9 kWh
Weight	14000 Kg/15000 Kg	14000 Kg/15000 Kg

**with indexable Multi-Tool*

Specifications subject to change without notice.

HEADQUARTERS

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Joinville, Brazil

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Lahr, Germany

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03.2012 Pullmax 1000 ENG Subject to alterations