

# ST-Series

*CNC Turret Punch Presses*



# ST-Series

## Designed for Productivity & Flexibility

LVD Strippit's ST-1212 and ST-1225 CNC turret punch presses provide the flexibility to handle short to long production runs, punching and forming applications, and are equipped with advanced features to enhance machine productivity.

ST-Series machines provide up to 360 HPM on 1" (25,4 mm) centers, handle workpieces up to 49.2" x 98.4" (1250 x 2500 mm), and material thicknesses up to .250" (6,3 mm), depending on model.

A high/low servo controlled hydraulic ram system delivers 20 tons of punching force and provides increased hit rate and ram controllability. The exclusive Smart Stroke® feature automatically calculates the optimum ram hover height to maximize punching performance.

A stress relieved, one-piece bridge frame and widespread axis bearing system provide exceptional accuracy to meet tight punching tolerances.

ST-Series punch presses feature a 29-station turret with three large 3.5" (88,9 mm) stations and two 2" (50, mm) stations. Three direct drive 3.5" (88,9 mm) auto-index stations are standard and can accept 3.5" (88,9 mm) tooling, indexable Multi-Tools or wheel tooling. All stations are accept to accept shaped tooling.

A PC-based GE-Fanuc control provides powerful features such as diagnostics, increased program storage capacity, networking and more in a highly reliable package.

ST-Series machines have an innovative user interface that provides graphic tool images to aid with selections, making entering tool information easier than ever before. Full graphic help screens prompt the user through tool and job data input to increase throughput.

To further enhance machine productivity, the ST-1225 can be equipped with an optional automatic load/unload system.

Contact your LVD Strippit representative today to learn how an ST-Series punch press can improve the flexibility and productivity of your operation.



### SPECIFICATIONS

	ST-1212	ST-1225
Maximum Material Thickness	0.250" (6,35 mm)	0.250" (6,35 mm)
Punching Accuracy	± .004" (0,1 mm)	± .004" (0,1 mm)
Tonnage	22 U.S. tons (20 metric)	22 U.S. tons (20 metric)
Nominal Workpiece Size*	49.2" x 49.2" (1250 x 1250 mm)	49.2" x 98.4" (1250 x 2500 mm)
<b>Table Type Capacities</b>		
All Brush or Combo Ball Brush	136 lbs. (62 kg) at 100% speed	136 lbs. (62 kg) at 100% speed
Max. Thickness .137" (3,5 mm) Steel; .250" (6,35 mm) Aluminum	161 lbs. (73 kg) at 75% speed	161 lbs. (73 kg) at 75% speed
	187 lbs. (85 kg) at 50% speed	187 lbs. (85 kg) at 50% speed
	242 lbs. (110 kg) at 25% speed	242 lbs. (110 kg) at 25% speed
Floating Clamps	2 manual lock	2 manual lock, 1 optional
Maximum Clamp Spread	39.3" (1000 mm)	74.67" (1900 mm)
One Turret Station Change Time	0.7 sec.	0.7 sec.
Maximum Turret Station Change Time	2.4 sec.	2.4 sec.
Feed Clearance	0.826" (21 mm)	0.826" (21 mm)
<b>Turret Configuration (29 stations)</b>		
Thin Style Only	24 - 1.25" (31,7 mm) Size 2 - 2.0" (50,8 mm) Size 3 - 3.5" (88,9 mm) Size	24 - 1.25" (31,7 mm) Size 2 - 2.0" (50,8 mm) Size 3 - 3.5" (88,9 mm) Size
Auto-Index Stations (Standard)	3 - 3.5" (88,9 mm) Size	3 - 3.5" (88,9 mm) Size
Angular Positioning Accuracy	± .05 degree	± .05 degree
Axis Traverse Speed	Up to 3930 IPM combined	Up to 3930 IPM combined
<b>Maximum Hit Rate at .08" (2 mm) Working Stroke**</b>		
0.039" (1,0 mm) Feed Rate	Up to 900 HPM	Up to 840 HPM
1.00" (25,4 mm) Feed Rate	Up to 360 HPM	Up to 330 HPM
Marking Stroke (standard)	Up to 1700 SPM	Up to 1700 SPM

\*Larger workpiece sizes handled with clamp reposition. \*\*Material thickness + tip recess + die penetration.



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