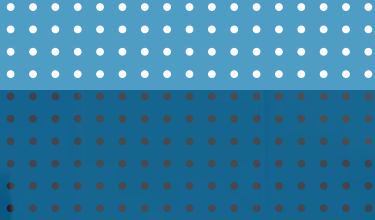


ST-1212 & ST-1225

CNC Punching

DESIGNED FOR PRODUCTIVITY & FLEXIBILITY



Key features

The 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 features that add up to higher productivity.



- 29-station thin turret equipped with three direct drive 3.5" auto-index stations. All stations are keyed to accept shaped tooling.
- Delivers up to 360 HPM on 1" centers
- 20 tons of punching force via a servo-controlled hydraulic ram system
- Exclusive Smart Stroke feature automatically calculates the optimum ram hover height to maximize punching performance
- Stress-relieved bridge frame and widespread axis bearing system provide exceptional accuracy
- PC-based Fanuc control offers diagnostics, large program storage capacity, networking
- Full graphic help screens prompt the user through tool and job data input
- Optional automatic load/unload system maximizes productivity

MACHINE SPECIFICATIONS	ST-1212	ST-1225
Maximum Material Thickness	0.250"	0.250"
Punching Accuracy	± .004"	± .004"
Tonnage	22 U.S. tons	22 U.S. tons
Nominal Workpiece Size*	49.2" x 49.2"	49.2" x 98.4"
Table Type Capacities		
- All Brush or Combo Ball Brush	Up to 136 lbs. at 100% speed	Up to 136 lbs. at 100% speed
- Max. Thickness .137" Steel; .250" Aluminum	Up to 161 lbs. at 75% speed Up to 187 lbs. at 50% speed Up to 242 lbs. at 25% speed	Up to 161 lbs. at 75% speed Up to 187 lbs. at 50% speed Up to 242 lbs. at 25% speed
Floating Clamps	2 manual lock	2 manual lock, 1 optional
Maximum Clamp Spread	39.3"	74.67"
One Turret Station Change Time	1.1 sec.	1.1 sec.
Maximum Turret Station Change Time	2.6 sec.	2.6 sec.
Turret Configuration (29 stations)		
Thin Style Only	24 'B' Size (1.25") 2 'C' Size (2.0") 3 'D' Size (3.5")	24 'B' Size (1.25") 2 'C' Size (2.0") 3 'D' Size (3.5")
Auto-Index Stations (Standard)	3 'D' Size (3.5")	3 'D' Size (3.5")
Angular Positioning Accuracy	± .05 degree	± .05 degree
Axis Traverse Speed	Up to 4095 IPM combined	Up to 3780 IPM combined
Maximum Hit Rate at .08" Working Stroke**		
- 0.039" Feed Rate	Up to 900 HPM	Up to 840 HPM
- 1.00" 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. Subject to change without notice.

