

Innovative Technologies.



ETP

CNC Turret Punch Press

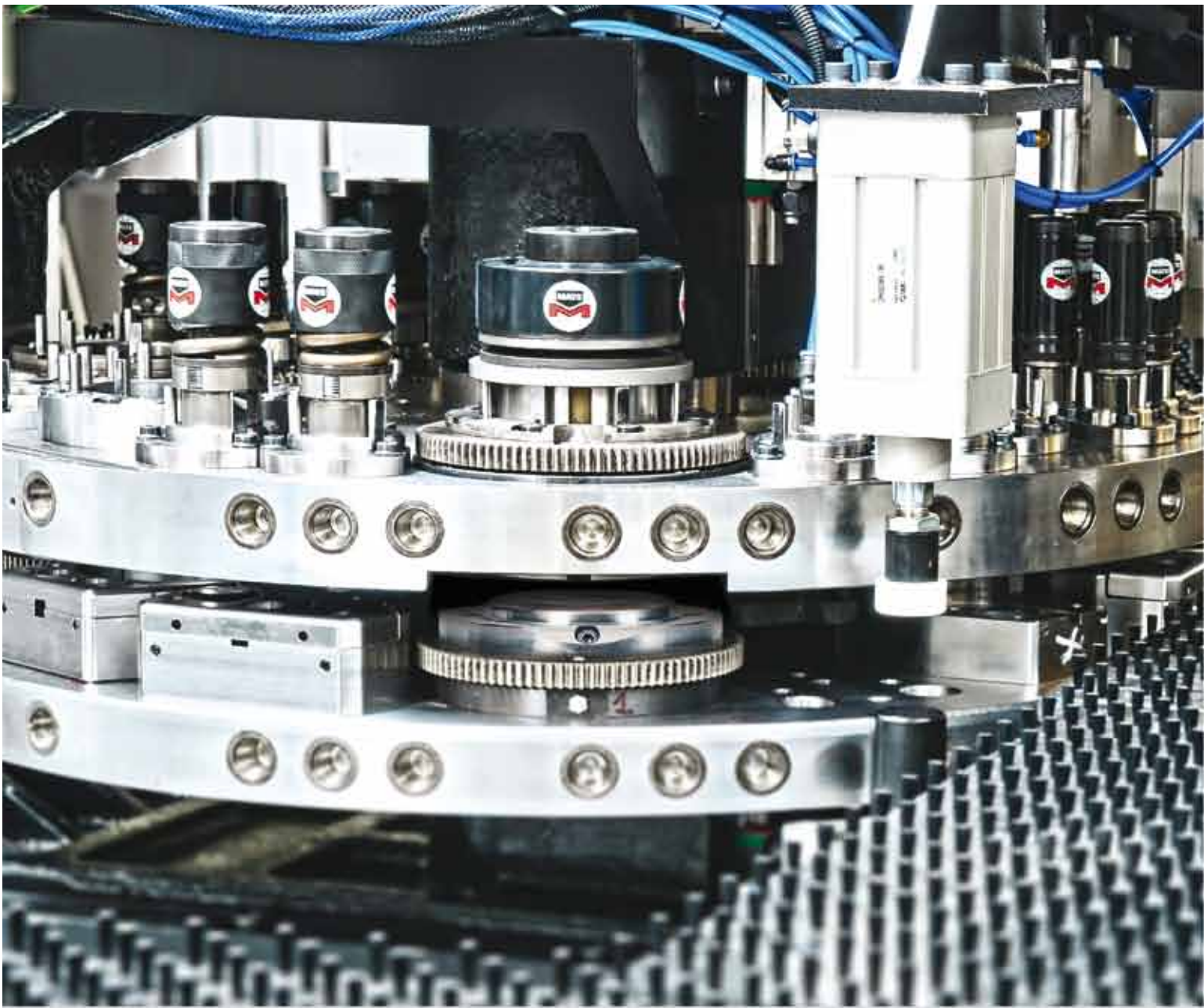
ETP Series manufactured by Ermaksan's proved quality and experience on production of sheet metal workbenches is being presented to the utility of our clients open to technology and continual innovation.

Strong mono-blok rigid O type body built up by stress relieved welded steel construction has high acceleration axes. Sheet processing can be done multi-directional and flexible until 6 mm thickness on ETP Turret Punch Press. Hydraulic, electronic, electric and mechanic components that are respected with its high quality worldwide have been used on the machine.



Faster and
maximum accuracy





TURRET HEAD

Thick Turret type Wilson or Mate brand high quality tools in 33 stations, 3 of them indexable D stations may include 8A or 3B or 1C stationed tools upon to your request. Thus the tool quality may be increased up to 54.

Hardened steel coated tool adaptor system assures maintenance free long life-time working.

Many operations are possible to make as forming with functional tools, perforating various diameters and special evacuating.

TURRET (33 STATION) Tooling Permutation:

- 15 x A station 1/2" fixed 1,6-12,7 mm round
- 12 x B station 1-1/4" fixed 12,8-31,7 mm round
- 2 x C station 2" fixed 31,8-50,8 mm round
- 1 x D istation 3-1/2" sabit 50,9-88,9 mm round
- 3 x D station 3-1/2" indeks 50,9-88,9 mm round

SPEED and ACCURACY

Maximum punch stroke for 1 mm step movements on X and Y axes processing 1 mm thick mild steel is 1100 per minute and marking speed is 1800 stroke/min. X + Y dependent velocity 120 m/min. Positioning accuracy is $\pm 0,05$ mm.

AUTOMATIC INDEX STATIONS

Different contours at required angles can be cut with 3 pieces automatic index stations. These stations may include 8A or 3B or 1C stationed tools upon to customers request and so wide range of tooling combinations are possible.

Index positioning accuracy is $0,01^\circ$

HDDL HYDRAULIC SYSTEM

Optimized adjustable movement gap according to cutting necessities for different applications as punching, forming, soft punching and marking etc.

Stroke configurable punch pattern feature for different punching functions.

Intelligent punching pressure.

No wearing and maintenance free punch cylinder system.

AIR BLOW

Provides automatic tool lubricating and extends tool life-time. Avoids return up of scraps and heating up of tools during working.

CNC CONTROLLER

GE FANUC 18i-PB

- Part program memory, 256 kb
- Memory C, FROM / SRAM, 16 mb / 1 mb
- CPU CARD, PENTIUM, DRAM 16 mb
- Inch / metric conversion
- Workpiece coordinate system
- Reader / Puncher interface 1
- External message
- Cutter compensation C
- Registered programs, 125
- Extended part program editing
- Run hour & parts count display
- Graphic display
- Multi-piece machining
- Multiple tool control
- Safety zone check
- Clamp zone avoidance function
- Safety zone area expansion





LANTEK or METALIX SOFTWARE

EASY TO LEARN

Designed to reduce learning time to a minimum. Simple, user-friendly menus guide users at all times, enabling them to produce parts from the first day.

INTEGRATION

Integrates part design, nesting and manufacturing technology in just one programme. This integration reduces the time and effort required to generate numerical control programmes.

BENEFITS

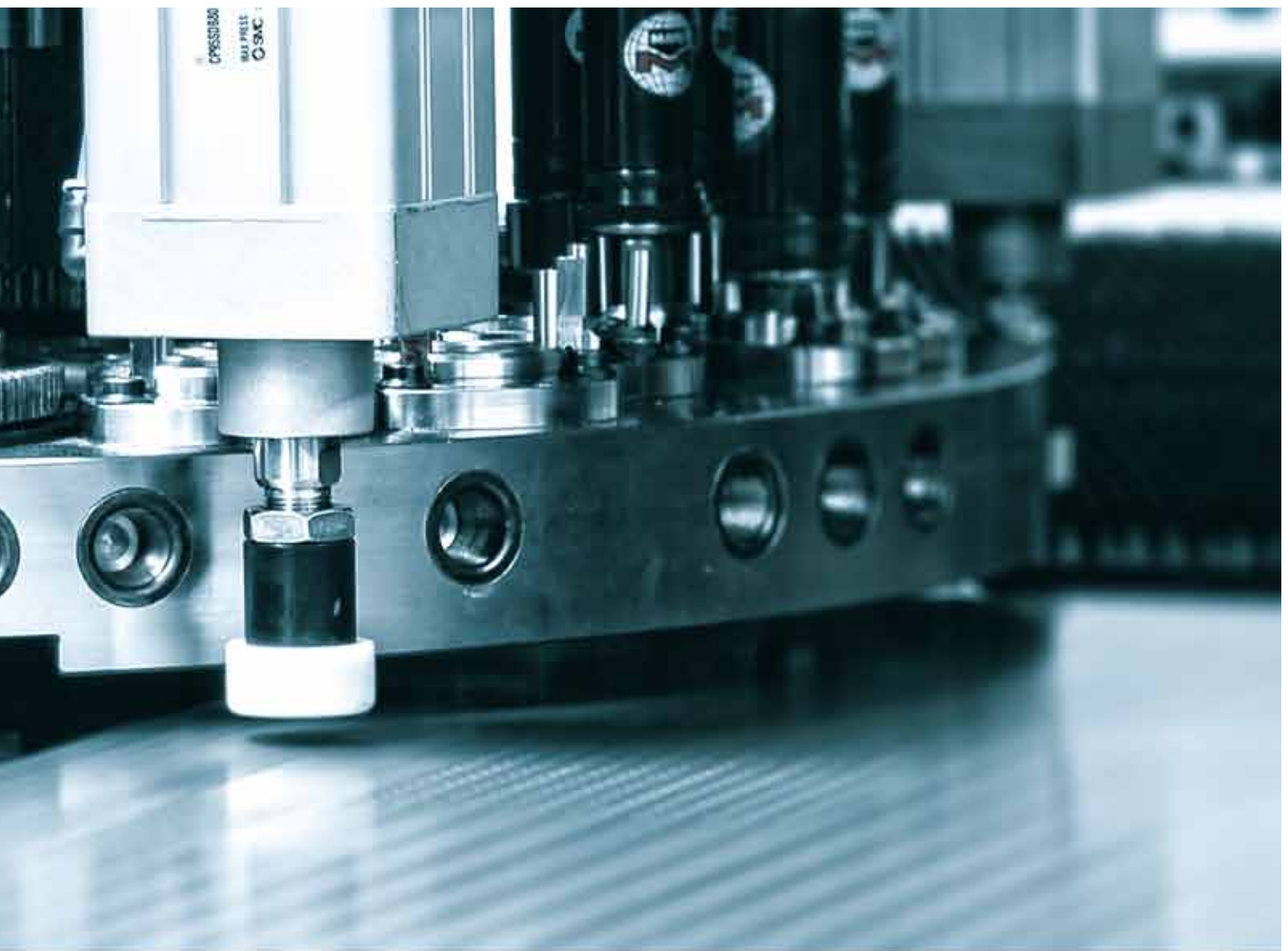
Excellent integration reduces data entry significantly. Excellent nesting features including best sheet selection reduces scrap. Excellent costing and time calculation including all consumable and raw material, improves efficiency and allows accurate scheduling. Integration into the sheets database allows efficient tracking and control of inventory. Advanced machining options allow for very efficient machining. Fully automatic tooling saves on setup times.

SHEET CLAMPING SYSTEM

Automatic repositioning of sheets to process sheets wider than 2500 mm and automatic repositioning of clamps to process sheets also under the clamps

Three pieces of sheet holder clamp operating with pneumatic pressure and pinching sheet without causing any deformation thanks to spherical shaped holders.

Clamp safety check system prevents collisions between clamps and tools by comparing the clamps positions with part program.



BRUSHED and/or BALL BEARING TYPE TABLE

A sheet plate with 2500 x 1500 mm dimension processing big table and brushed and/or ball bearing type table for easy sheet feeding.

Interpolation of sheet weight - acceleration by CAD/CAM (CNC controlled automatic axis acceleration calculation according to the sheet thickness and dimensions while CAD is being prepared).

Sensitive linear bearing equipments, guides without gap, sensitive screw axles and dynamic servo motors, intelligent drivers are used on X and Y axes. The dynamic buffer designed with these equipments does not make a concession from its sensitivity even at high accelerations.



WORK CHUTE

Punched parts automatically being transferred to outside of working area.



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Technical Features

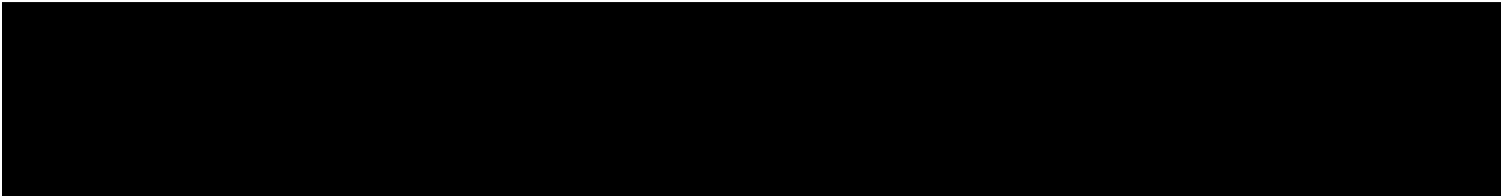
		ETP 1250 x 2000	ETP 1500 x 2500
MAXIMUM TONNAGE	TON	20	30
MAXIMUM CAPACITY (Thickness X, Y)	mm	2000x1250	2500x1500
MAX. PUNCH DIAMETER (Sheet is 1 mm thickness) (SINGLE TOOL)	mm	Ø88,9	Ø88,9
X AXIS TRAVEL	mm	2000 + R	2500 + R
X AXIS VELOCITY	m/min	120	80
Y AXIS TRAVEL	mm	1250	1500
Y AXIS VELOCITY	m/min	120	80
X + Y DEPENDENT VELOCITY	m/min	170	114
TURRET ROTATION VELOCITY	Rpm	27	20
AUTO INDEX ROTATION VELOCITY	Rpm	65	65
MAXIMUM PUNCH STROKE For Marking 1 mm Stroke	Stroke/min	1500	3000
MAXIMUM PUNCH STROKE Per minute For* 1mm step X Movement, 1mm step Y axes Movement, 1mm sheet thickness	Stroke/min	900	1100
MAXIMUM PUNCH STROKE Per minute For* 25mm step X Movement, 25mm step Y axes Movement, 1mm sheet thickness	Stroke/min	350	600
MAX. CUTTING THICKNESS WITH FIX STATION	Mild steel	6,35 mm	6,35 mm
	Stainless steel	3 mm	3 mm
MAX. CUTTING THICKNESS WITH AUTO INDEX STATION	Mild steel	4 mm	4 mm
	Stainless steel	2,5 mm	2,5 mm
REPETITION ACCURACY	mm	± 0,05	± 0,05
POSITIONING ACCURACY	mm	± 0,1	± 0,1
INDEX POSITIONING ACCURACY	°	0.01°	0.01°
MULTI TOOL CHANGE TIME	Sec	3	3
MAXIMUM SHEET WEIGHT	kg	120	200
MOTOR	kW	18,5	11
OIL CAPACITY	Lt	200	200
AIR PRESSURE	Bar	6 - 7	6 - 7
MAXIMUM STROKE	mm	40	40
SHEET CLAMPING (AUTOMATIC LOCATION CHANGEABLE)	Pieces	3	3
SHEET CLAMPING FORCE	kg	1200	1200
POWER SUPPLY	kVA	25	25
AIR SUPPLY	Liters/min	2.5	2.5
LINEAR AXES	X,Y	All axes absolute Ballscrew with Fanuc servo motor	All axes absolute Ballscrew with Fanuc servo motor
INDEX AXES		Absolute with Fanuc servo motor + Harmonic drive reductor	Absolute with Fanuc servo motor + Harmonic drive reductor
WORKING HEIGHT	mm	950	950
TABLE TYPE	Standard	Brushed	Brushed
	Option	Ball	Ball
	Option	Brushed+Ball	Brushed+Ball
MACHINE LENGHT	mm	5040	5520
MACHINE WIDTH	mm	4290	5000
MACHINE HEIGHT	mm	2220	2220
WEIGHT	kg	13000	20000
CAD/CAM Software		Lantek / Metalix	Lantek / Metalix
Standard Manual Nesting (1 pieces soft, 1 pieces dangle)	License	One license, Postprocessor	One license, Postprocessor
Optional Automatic Nesting		11 pcs A station Fix 1,6-12,7 10 pcs B station Fix 12,8-31,7 1 pcs C station Fix 31,8-50,8 2 pcs D station Fix 50,9-88,9 2 pcs B station Index 12,8-31,7 1 pcs C station Index 31,8-50,8	15 pieces A station Fix 1,6-12,7 12 pieces B station Fix 12,8-31,7 2 pieces C station Fix 31,8-50,8 1 pieces D station Fix 50,9-88,9 3 pieces D station Index 50,9-88,9
TURRET STATION FEATURES			

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