

BRUDERER

Leading technology for punching techniques



BSTA 25 UL

BRUDERER
High performance automatic punching press
BSTA 25

The BRUDERER high performance automatic punching press BSTA 25 belongs – together with the BSTA 50, 80, 125 and 160 presses – to a series of extremely robust, high precision presses with universal application opportunities and identical design characteristics. Since being introduced to the market, the presses have been further developed, and have proved to be a competent solution for a variety of stamping applications.

BSTA 25

- **Precision automatic punching press with perfected mass counterbalance system and adjustable stroke.**
- **Press force 250 kN. Speeds of 100 to 1425 spm.**
- **Drive with frequency-controlled three-phase current motor.**
- **Modular design concept with 2 different table dimensions. Tool clamping area: BSTA 25 L 640 x 530 mm BSTA 25 SL 730 x 530 mm.**
- **High performance press control that is easy to operate and expandable.**
- **High precision mechanics, universal application possibilities for various tasks, optimum cost/benefit relationship.**

The ultimate in mechanical engineering

The special drive concept of the BRUDERER high performance automatic punching presses has contributed considerably to the success of the company. It is characterised by: driving gear with transverse eccentric shaft, double connecting rods, lever system, crosshead guiding, ram with push rods, and a perfected mass

counterbalancing system. The press housing is made of grey cast iron, the guide supports and base plate have been designed in spheroidal graphite iron and screwed onto an exceptionally rigid press frame. All bearings are lubricated by the centralised oil circulation system. The frequency-controlled three-phase current motor for the main drive has been flanged onto the side of the press housing. The flywheel is driven by a flat belt and is combined with the clutch and brake unit to form a single assembly.

Ram with quality guiding

High quality ram guidance is one of the most important prerequisites for manufacturing precision punched parts while, at the same time, ensuring long tool life. The BRUDERER solution: an extremely rigid ram made of spheroidal graphite iron, four circular guides, also in rigid design, and low-clearance guiding elements on the strip inlet level with quasi-hydrostatic lubrication.

BRUDERER strip feed unit

The BRUDERER BBV strip feed units have set the standards for precision and reliability for many years, yet they are still in a class of their own. The system: oscillating roll feed combined with gripper feed, cardan drive, positive gear without clutch and freewheeling, infinitely adjustable feed lengths.

Universal control technology

The demand for more economical production has led to punching presses being optimally designed to meet the needs of their principle areas of application. This also applies to the press controls. BRUDERER therefore developed a simple and operator-friendly PLC control for the BSTA 25. It is a high performance control that is expandable (see product information enclosed).

A full range of accessories

An extensive range of standard accessories and customer-specific equipment paves the way for the most economical solution, also to meet your individual requirements.



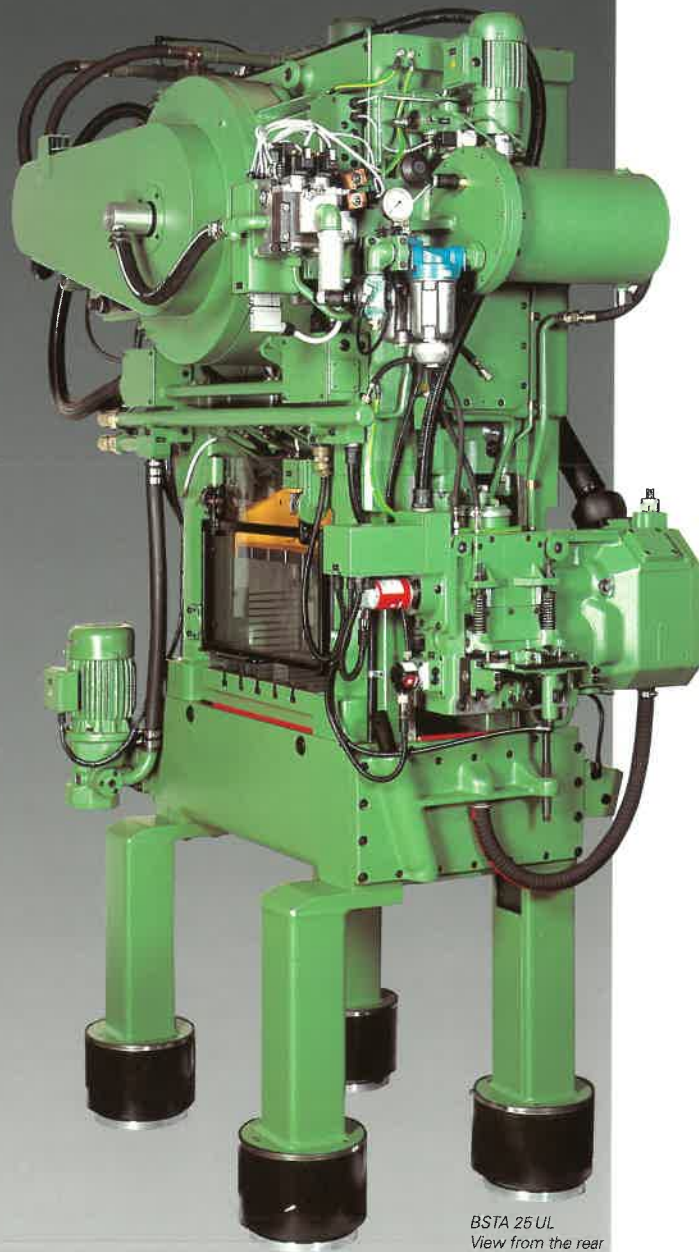
Oil/air cooler with electrically-driven cooler fan. An oil preheating device with additional heating elements is also available as an option.



The BRUDERER drive concept: transverse shafts, double connecting rods, lever system, ram with push rods and mass counterbalance.



Tool loading area with view from the strip outlet side, with 2-part bolster plate and hydraulic **tool clamping system** (accessory).



BSTA 25 UL
View from the rear

BRUDERER strip feed unit BBV 190/85, control panel for 2-hand operation (left side), and **blow-out device** (accessory).



Strip guiding table with strip clamps for BRUDERER strip feed unit BBV 190/85 (view from tool loading area).



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Technical data			BSTA 25 L	BSTA 25 SL
Press force		kN	250	250
Speed	min.	spm	100	100
	max.	spm	1425	1400
Mains voltage (EN 60204) ^A		V	400	400
Mains frequency (EN 60204) ^A		Hz	50 60	50 60
Connected load ^B	max.	kVA	52	52
Control voltage		VDC	24	24
Drive power of main motor		kW	15	15
Compressed air connection R 1/2"	min.	bar	6	6
	max.	bar	10	10
Adjustable stroke (standard)		mm	13 16 19	13 16 19
		mm	25 32 38	25 32 38
Adjustable stroke (option)		mm	13 16 19 25	13 16 19 25
		mm	32 38 44 47	32 38 44 47
Fixed stroke ^A	max.	mm	47	47
Ram adjustment range		mm	51	51
Shut height (acc. to stroke - standard)	min.	mm	175,5	175,5
	max.	mm	239	239
Bolster area	L-R	mm	640	730
	F-B	mm	530	530
	height ^C	mm	1161	1171
Ram area	L-R	mm	530	630
	F-B	mm	360	360
Tool loading area	L-R	mm	650	750
Strip inlet height	min.	mm	50	50
	max.	mm	120	120
Strip inlet width (press)	max.	mm	210	210
Base plate opening	L-R	mm	590	690
	F-B	mm	180	180
Dimensions ^D :				
Press (standard BBV)	L-R	mm	1965	1965
– with manual stroke adjustment	F-B	mm	1148	1148
	height	mm	2657	2667
	weight	kg	appr. 4900	appr. 5300
Strip feed units	Standard	BBV 190	180°	
	Optional	BBV 195	90°	
		BBV 202	180°	
		BBV 205	90°	

^A Options on request

^B incl. standard sockets for peripheral equipment

^C above floor level

^D without electrical cabinet, oil cooler and peripheral equipment

Subject to change

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We set the rhythm for profitable punching:

The BRUDERER BSTA series offers a complete range of modern high performance automatic punching presses for press forces of 180 to 1600 kN.

The most important characteristics at a glance:

- extremely high accuracy
- high performance
- renowned reliability
- long life
- universal application

Interested in our products? Please contact us, we would be delighted to lend you our expert advice or send you further information on the BRUDERER product range.

