



**TPV AUTOMOTIVE d.o.o.**

Brezina 101; 8250 BREŽICE; SLOVENIJA

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# **TECHNICAL INFORMATION OF MECHANICAL EQUIPMENT**

## **TPV AUTOMOTIVE d.o.o. FACTORY-BREZINA**



## SERVO PRESS FAGOR – 2500 T (DM 128112)

### PRESS DATA

Press type	TSED4-3000-7000-2500
Stroke (min <sup>-1</sup> )	3 – 25 (38 in pendulum mode, 100mm stroke)
Nominal press force (kN)	25000
Available energy per stroke (kJ)	900
Workbench dimension (mm)	7000 x 2500
Tool instalation dimension (mm)	1000 - 1400
Stroke (mm)	100 - 750
Scrap opening in table	YES
Min. width of the tool (mm)	1060
Thickness of die clamping plate for automatic clamps	50



### DIE DATA

Tooling type	Progressive		Transfer	
	Tooling lenght (mm)	7000		
Tooling width (mm)	2500			
Die height (mm)	1000-1400	1100-1400		
Material entrance height	500-800	650-800		
Max. weight of upper of part of die (kg)	25000			
Max. Weight of die (kg)	50000			
Overhead crane capacity (kg)	40000			

### RAW MATERIAL DATA

Band width (mm)	200 - 1600
Band thickness (mm)	1 – 5
Coil diameter - inner (mm)	475 - 530
Coil diameter - outer (mm)	1000 - 2000
Feeding (mm)	0 - 9999,9
Coil weight max. (kg)	20000
The largest section of flattening (mm <sup>2</sup> )	4800 (Re = 800 N/mm <sup>2</sup> )



**HYDRAULIC CUSHION DATA**

Force (kN)	300 – 3000
Stroke (mm)	300
Pre-acceleration (mm)	30
Area (mm)	1875 x 1600
Max. Speed at stroke 150mm	20

**TRANSFER DATA**

Ajustable feed (mm)	0 – 1250
Lift motion (mm)	300 + 30
Closing motion (mm)	900 – 2600
Dimensions of transfer bars (mm)	200 x 250
Height from bolster to bottom of transfer bars (mm)	595

**DESTACKER DATA**

Blank width (mm)	120 – 1600
Blank length (mm)	300 – 900
Blank thickness (mm)	0,5 – 5
Max. Blank weight (kg)	8
Blank feeding height (mm)	650 – 800
Max. Blank pack height (mm)	600
Max. Blank pack height (kg)	4000



## SERVO PRESS FAGOR – 1000 T (DM 128111)

### PRESS DATA

Press type	TSED4-1000-4500-1500
Stroke (min <sup>-1</sup> )	3 – 50
Nominal press force (kN)	10000
Workbench dimension (mm)	4500 x 1800
Die height (mm)	600-950
Machine opening (mm)	350
Scrap opening in table	YES
Band entrance regulation (mm)	500 +/- 150
Feeding and regulating line	YES
Slide stroke	350
Min. width of the tool (mm)	800
Thickness of die clamping plate for automatic clamps	50



### TOOLING DATA

Type of die	Progressive
Max. Die length (mm)	4500
Max. Die width (mm)	1800
Die height (mm)	600-950
Min. tooling height (mm)	650
Max. weight of upper part of tooling (kg)	15000
Tooling length (mm)	25000

### RAW MATERIAL DATA

Band width (mm)	200 - 1200
Band thickness (mm)	1 – 6
Coil diameter - inner (mm)	475 - 630
Coil diameter - outer (mm)	1000 - 2000
Feeding (mm)	0 - 9999,9
Coil weight max. (kg)	25000
The largest section of flattening (mm <sup>2</sup> )	3200 (Re = 800 N/mm <sup>2</sup> )