

STAMTEC®

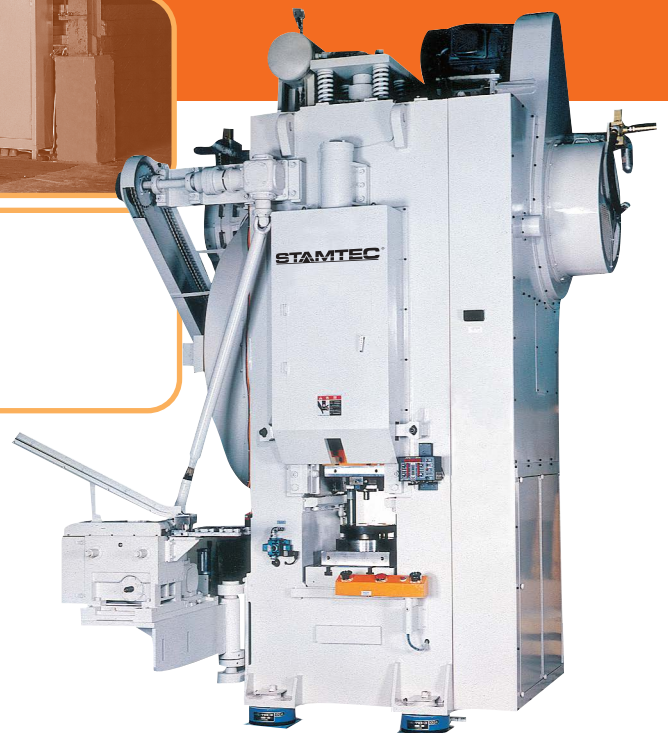
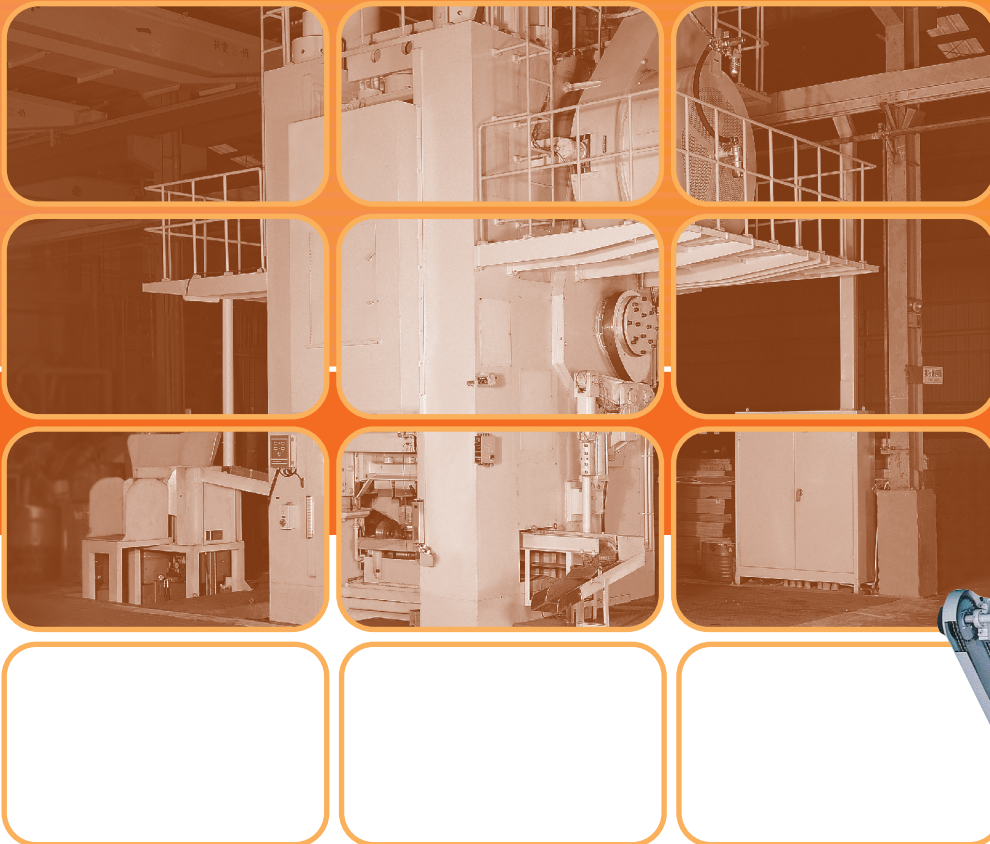
METAL STAMPING & FORMING EQUIPMENT

Knuckle-Joint Cold Forging Presses

KP series

&

KT series



250 . 400 . 650 . 850 . 1000 . 1200 . 2000 ton

KP SERIES

Knuckle-Joint 1-Point Cold Forging Presses

Stamtec Cold Forge Technology

Stamtec cold forging press technology provides particular advantages for producing steel components, improving strength and consistency. Near net shape forming, improved mechanical characteristics, superior plasticity, higher surface quality, and increased productivity are just some of the benefits of cold forging presses.



KP-2000 Knuckle-Joint Press



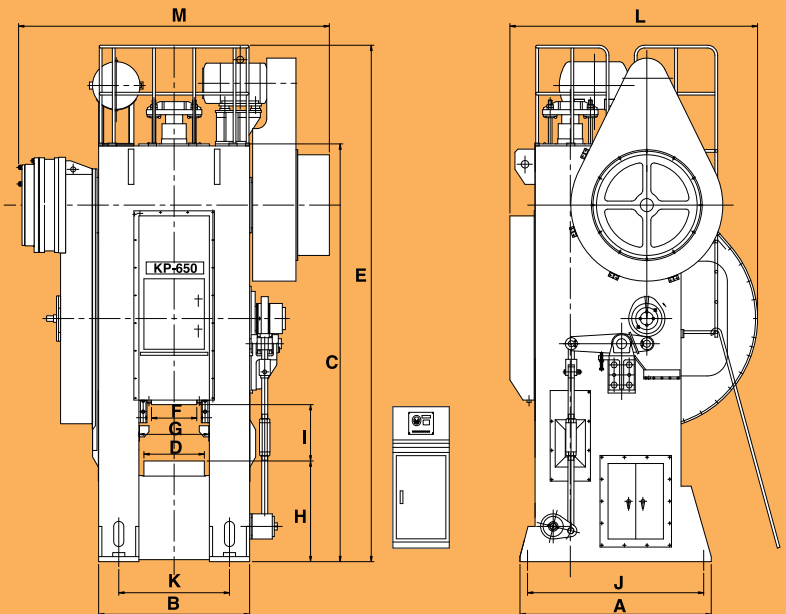
K Knuckle Joint Series

The KL, KP, KT, and KW2 forging presses are specially designed for cold forging and are ideal for near net-shape forming. The cold forge technology forms steel components without cutting metal fibers, giving the product a more consistent and durable strength.

Tonnage Range: 250-2,000

OUTLINE DIMENSIONS

	MODEL						
	KP-250	KP-400	KP-650	KP-850	KP-1000	KP-1200	KP-2000
A	1650	1700	1900	2140	2750	3050	2950
B	1000	1250	1500	1500	1720	2000	3200
C	3015	3540	4150	4340	5155	6075	7080
D	500	550	600	600	700	800	1000
E	3850	4500	5060	5460	6234	7280	8000
F	400	400	450	450	480	800	800
G	570	590	700	700	820	1000	1300
H	700	820	1000	1030	1300	1455	2030
I	490	560	560	580	660	850	730
J	1530	1570	1750	1990	2590	2890	2450
K	780	950	1100	1100	1270	1500	2900
L	1850	2125	2460	2735	3160	3450	5470
M	2100	2640	3095	3420	4980	5060	6480



Type		KP-250		KP-400		KP-650		KP-850		KP-1000		KP-1200		KP-2000	
Main Specifications		S	V	S	V	S	V	S	V	S	V	S	V	S	V
Capacity	Tons	250		400		650		850		1000		1200		2000	
Rated tonnage point	mm	4		6		8		8		8		8		8	
Stroke length	mm	120		160		160		180		160		250		180	
Strokes per minute	S.P.M. Continuous	40	30-50	32	25-40	30	25-35	30	25-35	30	25-35	30	25-35	25-35	22-32
Die height (S.D.A.U.)	mm	370		400		400		400		500		600		550	
Maximum upper die weight	kg	500		800		1000		1000		1200		1200		1200	
Bolster area (L-R x F-B)	mm	500 x 600		550 x 660		600 x 700		600 x 700		700 x 800		800 x 1000		1000 x 800	
Slide area (L-R x F-B)	mm	400 x 420		400 x 500		450 x 550		450 x 550		480 x 650		800 x 800		800 x 700	
Slide adjustment	mm	15		15		15		15		15		15		15	
Bolster thickness	mm	100		120		150		180		180		200		250	
Air Pressure Requirement	kg/cm ²	5		5		5		5		5		5		5	
Main motor	HP	20	25	40	50	50	75	75	100	75	100	100	100	100	150

Bed knockout device

Capacity	Tons	10	15	30	30	50	50	80
Stroke length	mm	50	60	70	70	70	100	80

2 / 3 Axis transfer unit

Model		KTF-3-14530	KTF-3-170	KTF-3-200
Feed pitch	mm	145	170	200
Clamping stroke	mm	35	35	60
Lifting stroke	mm	15	15	20
Inner distance between feeds	mm	110	110	270
Stokes per minute	S.P.M.	40	40	30
Feeding direction (front - to - rear)		front - to - rear		left - to - right

KT SERIES

Knuckle-Joint Auto-Transferring Presses

Press Advantages

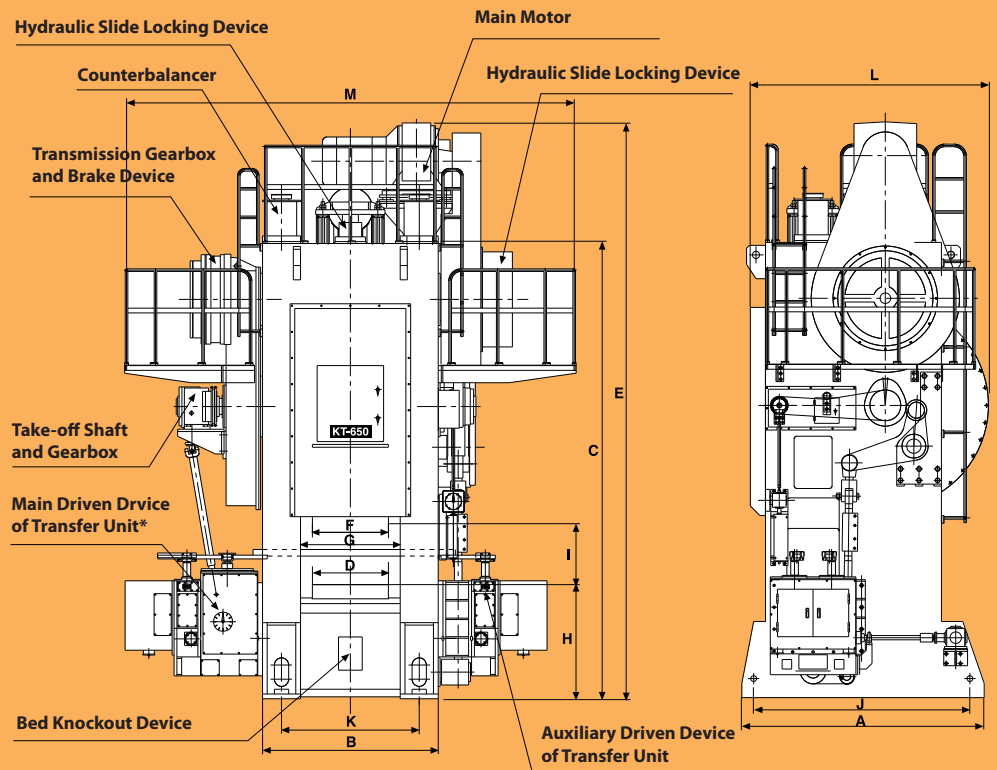
Slide is connected to crankshaft by a linked knuckle mechanism that modifies the motion of the slide, achieving a mechanical advantage and dwell that supplies very high tonnage near the bottom of the stroke.



KT-800 Knuckle-Joint Press

OUTLINE DIMENSIONS

	MODEL			
	KT-400	KT-650	KT-800	KT-1000
A	2100	2500	3250	3400
B	1620	1850	2250	2250
C	4215	4830	6070	6205
D	700	800	1100	1100
E	5250	5952	7220	7040
F	700	800	1080	1080
G	920	1050	1350	1350
H	1050	1200	1250	1300
I	730	730	900	920
J	1900	2300	3090	3240
K	1270	1450	1800	1800
L	2240	2505	3275	3410
M	4510	4750	5305	5345



Type		KT-400	KT-650	KT-800	KT-1000
Main Specifications					
Capacity	Tons	400	650	800	1000
Rated tonnage point	mm	8	8	8	8
Stroke length	mm	180	180	250	250
Strokes per minute	S.P.M. Continuous	25-40	25-35	25-35	25-35
Die height (S.D.A.U.)	mm	550	550	650	400
Bolster area (L-R x F-B x T.)	mm	700 x 700 x 120	800 x 800 x 150	1100 x 800 x 170	1100 x 800 x 180
Slide area (L-R x F-B)	mm	680 x 700	780 x 800	1080 x 800	1080 x 800
Slide open (F-B x H.)	mm	500 x 500	550 x 630	700 x 730	700 x 730
Slide adjustment	mm	15	15	15	15
Air Pressure Requirement	kg/cm2	5	5	5	5
Main motor	HPXP	V.S.50X4	V.S.100X4	V.S.100X4	V.S.125X4

Bed Knockout Device

Capacity	Tons	10 x 3 = 30	15 x 3 = 45	12 x 5 = 60	12 x 5 = 60
Stroke length	mm	60	70	70	70

3-Axis Transfer Unit

Model		VTF-170	VTF-200	VTF-200	VTF-200
Feed pitch	mm	170	200	200	200
Clamping stroke	mm	50	60	60	60
Lift stroke	mm	20	20	25	25
Inner distance of feed bars	mm	240	270	360	360
Feed line height	mm	270	300	300	300
Strokes per minute	S.P.M.	30	30	30	30
Feed bar sectional profile	mm	70 x 70	75 x 80	100 x 100	100 x 100
Feed direction (left to right)	Left to Right				

KP and KT Series

Standard Features / Accessories

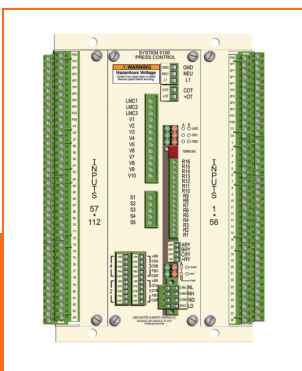
- Air counterbalance system
- Motorized slide adjustment with hydraulic locking unit
- Centralized re-circulating lubrication device
- Overrun protection device
- Load monitor
- OmniLink 5100-MPC press control system
- 4-digit die height indicator
- Misfeed detection circuit
- Air Ejector (3/8")
- Air receptacle (3/8")
- Maintenance tool kit
- Operating manual and inspection report (English)
- Portable 2-hand pushbutton t-stand

Optional Features / Accessories

- Flywheel brake device
- Bed knockout device
- Motorized grease lubrication system
- Additional electronic rotary cam switches
- Variable frequency drive
- Foot switch
- Lights for tooling area
- 1-phase 100V and 220V power receptacle
- Anti-vibration mounts
- Anchor bolts and plates
- Quick die change system
 - » Upper die clamp
 - » Lower die clamp
 - » Die lifter
 - » Extension arm
- Auto feeding system
- Remote monitoring & control system

OmniLink System

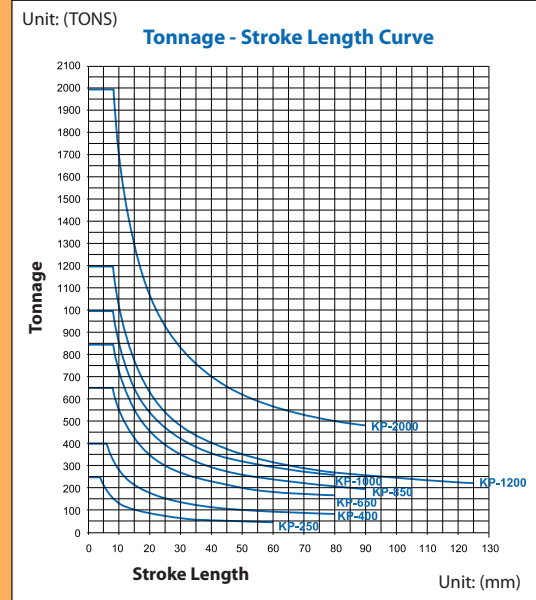
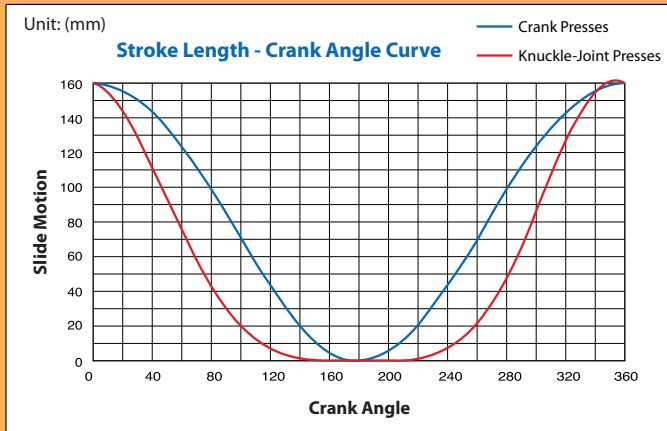
5100-MPC Press Controls



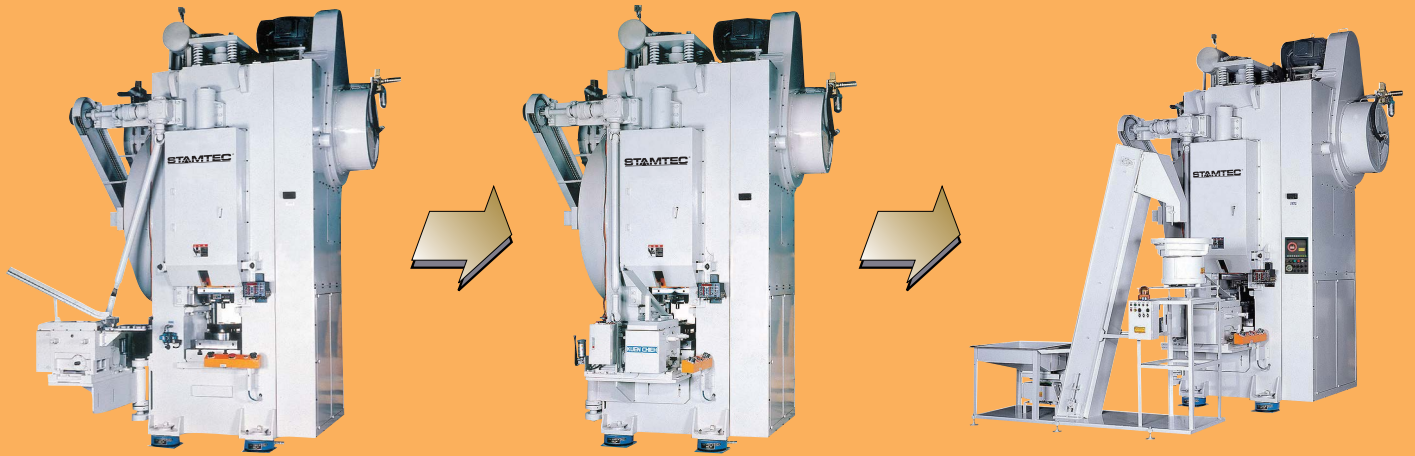
- Color touch screen displays all system information in English or Spanish and provides easy settings and selections for control configuration, PLS, die protection, counters, etc.
- Job storage and recall to provide quick, consistent set-ups.
- Four (4) Die Protection/Process Monitoring inputs located in the Operator Terminal. Nine monitoring modes are available for each die protection input.
- Four (4), (eight optional) programmable limit switch outputs are available to sequence and time automation with the press.
- 56 control inputs and 8 sets of dual-tracking safety control inputs (many of which are configurable) for superb performance and diagnostics.
- Outputs for clutch and brake, as well as optional output relays configurable for specific functions related to lube systems, motor controls, hydraulic overloads, flywheel brakes, automation, etc.
- Screens to display the state of every input and output, lube system diagnostics, OIT diagnostics, configuration memory, and an event log with date, time and reason for the last 256 stops.
- Stopping Time Performance (Brake) Monitor, Motion Detection, Clutch Engagement Time Monitor
- Stroking Modes- Off, Inch, Automatic Timed Inch, Setup/StopTime Test, Single Stroke (Cycle), and Continuous. (Optional modes- Automatic Single Stroke (Cycle), Maintained Continuous, and Continuous on Demand).
- Automatic Top Stop Compensation for use with variable speed presses.
- Four (4) nine-digit counters for Stroke, Parts, Batch, and Quality.
- Superior safety with powerful diversely redundant cross-checked dual micro-processor logic systems
- Lasting value with rugged modular design and Link technical support

Characteristics of Knuckle-Joint Presses

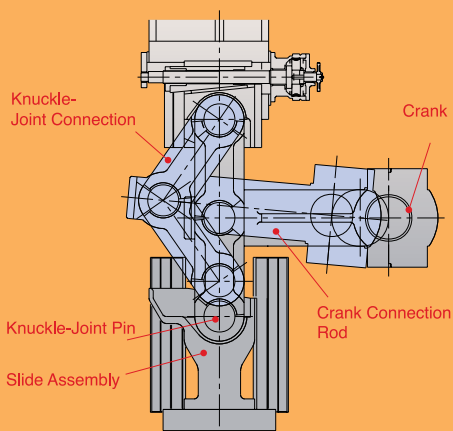
KT Series Knuckle-Joint mechanism can alter the motion velocity of Slide to a slow speed when Slide is driven approaching to Bottom Dead-end Center (BDC) point. This special feature applies for the production of extrusion, coining, upsetting, sizing, forging and heading.



The sequence of installation for fitting the automations to KP series



Slide Knuckle-Joint Mechanism

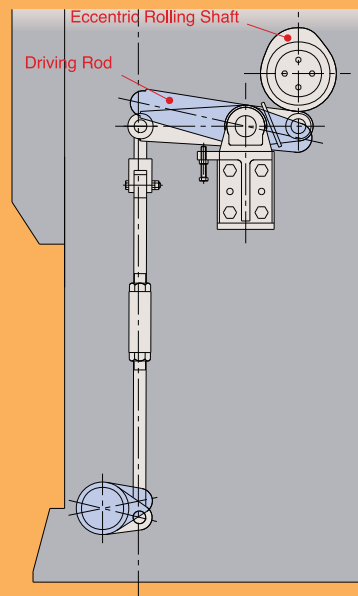


Slide Motion

Slide is connected to crank by two pieces of linked knuckle joints; its weight is offset by the adjustable pneumatic counterbalancer. This mechanism is to transit the revolution of crank to drive the slide for the movement of up and down strokes.

Bed Knockout Device

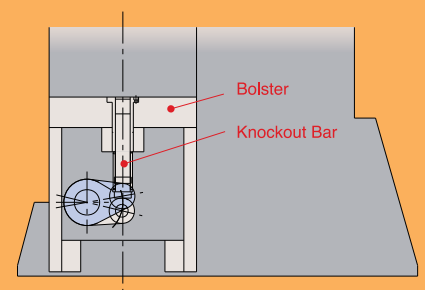
Side View from Frame Outer



Bed Knockout Device

The knockout device installing beneath bolster of bed for taking the work-piece out of the toolings is activated by a driving rod, which is connection to the crank-driving eccentric rolling shaft.

View to Frame Inside





STAMTEC®

METAL STAMPING & FORMING EQUIPMENT

Stamtec has been providing dependable, affordably priced metal stamping presses for almost 30 years in the North American market, and 60 years worldwide through our parent company Chin Fong. Our 72,000 sq. ft. sales, service, logistics, and assembly facility in Tennessee is home not only to North America's largest inventory of new presses and spare parts, but also our most important asset - our people. Our staff of engineering, sales, service, and support personnel are here to serve you in the most timely and professional manner. So, tap into our global strength, and grow with us as we grow with you!



KP SERIES

1-POINT



KT SERIES

AUTO TRANSFERRING



KW1 SERIES

COLD AND
SEMI-HOT



KW2 SERIES

HIGH PRECISION
PROGRESSIVE



STAMTEC®
METAL STAMPING & FORMING EQUIPMENT

U.S.A. - STAMTEC, INC.

4160 Hillsboro Highway | Manchester, TN 37355 U.S.A.

TEL: +1-931-393-5050 | FAX: +1-931-393-5060 | www.stamtec.com



www.STAMTEC.com