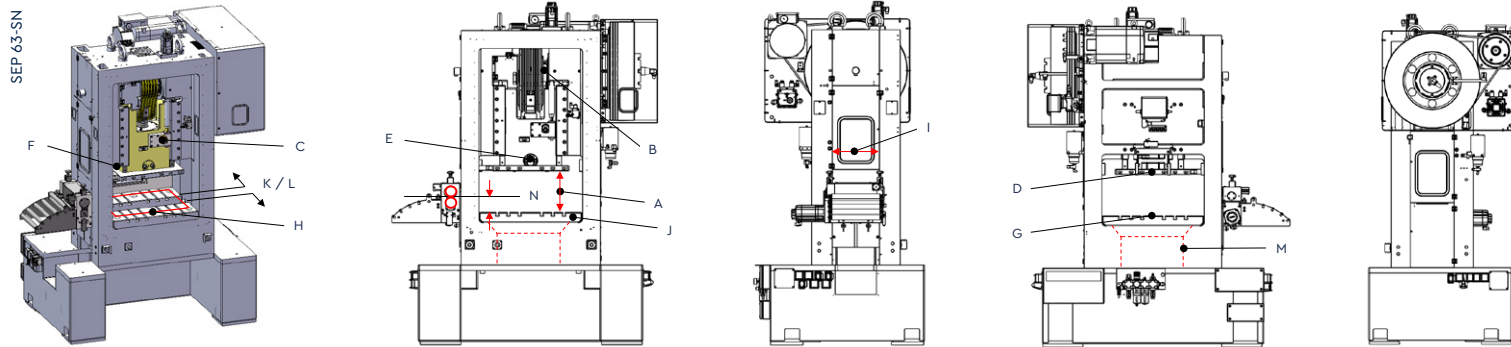


# Technical data stamping presses SEP



07 2022

Stamping press/models		SEP 12	SEP 25N	SEP 40N	SEP 40S-810	SEP 63N	SEP 63SN	SEP 63SN-950	SEP 80N	SEP 100	SEP 100S
		model SEP 12	model SEP 25N	model SEP 40N	model SEP 63N with main drive mechanism SEP40N	model SEP 63N	model SEP 80N with main drive mechanism SEP 63N	model SEP 80N with main drive mechanism SEP 63N and extended working range	model SEP 80N	model SEP 100	model SEP 100S with extended working range
		fly wheel	fly wheel	fly wheel	fly wheel	fly wheel	fly wheel	fly wheel	planetary gear	planetary gear	planetary gear
available press force at a stroke rate of 100spm (SEP12 / SEP25N starting at a stroke rate of 150 spm/min)	KN	120	250	400	400	630	630	630	800	1000	1000
max. stroke rate (adjustable)	strokes/min	600 (800)	500 (800)	500	500	500	500	500	320	320	320
distance between table and ram (with mounting table) largest stroke and bottom, height adjustment on the top		-	-	-	with/without ram mounting plate	with/without ram mounting plate	with/without ram mounting plate	with/without ram mounting plate	with/without ram mounting plate	-	-
	mm	215	240	270	250 / 275	250 / 275	325 / 370	325 / 370	325 / 370	320	320
ram stroke - adjustable	mm	8 - 40	8 - 60	8 - 70	8 - 80	8 - 80	8 - 80	8 - 80	8 - 80	10 - 100	10 - 100
		stroke table (all single strokes of the ram) with the respective mould installation heights - see individual data sheets stamping presses SEP									
continuous ram height adjustment	mm	0 - 40	0 - 60	0 - 70	0 - 80	0 - 80	0 - 80	0 - 80	0 - 80	0 - 100	0 - 100
ram size L x W		225 x 140	280 x 260	340 x 320	500 x 293	500 x 293	500 x 293	500 x 293	500 x 293	-	-
ram mounting plate size L x W x H	mm	-	-	-	620 x 400 x 25	500 x 400 x 25	620 x 500 x 45	620 x 500 x 45	620 x 500 x 45	800 x 600 x 50	960 x 600 x 50
mounting hole in ram	mm	Ø 32	Ø 40	Ø 40	Ø 50	Ø 50	Ø 50	Ø 50	Ø 50	-	-
ram keyway	mm	16 H7	30 H7	30 H7	30 H7	30 H7	30 H7	30 H7	30 H7	30 H7	30 H7
mounting table size L x W	mm	370 x 440	490 x 560	610 x 690	810 x 710	710 x 710	830 x 710	950 x 710	830 x 710	1050 x 860	1210 x 860
tooling dimension L x W	mm	330 x 440	450 x 460	570 x 590	768 x 610	670 x 610	790 x 610	910 x 610	790 x 610	1010 x 760	1170 x 760
passage way (left to right) (*while using a gripper feed, passageway is reduced)	mm	210 (*160)	250 (*180)	320 (*260)	320 (*260)	320 (*260)	320 (*260)	320 (*260)	320 (*260)	420 (*260)	420 (*260)
mounting table - thickness	mm	50	50	60	80	80	80	80	80	100	100
opening for part exit in the mounting table L x W	mm	240 x 120	330 x 120	460 x 160	-	-	-	-	-	-	-
distance between clamping bars L x W (L = continuous / W = adjustable)	mm	-	-	-	W = 100 - 160	W = 130 - 190	W = 130 - 190	W = 130 - 190	W = 130-190	W = 100-220	W = 100-220
opening for part exit in the press body L x W	mm	300/240 x 160	420/340 x 160	540/460 x 200	640/520 x 200	640/520 x 200	640/520 x 200	640/520 x 200	640/520 x 200	840/720 x 260	1000/880 x 260
strip height above mounting table	mm	strip infeed heights with attachment of a gripper/roll feed - see table page 2									
driving power (main drive)	kW	5,5	11	18,5	18,5	22	22	22	22	22	22
weight (without feeding unit)	kg	1800	3400	5400	6000	6200	8000	8000	8400	13000	14000
dimensions L x W x H (approx.)	mm	940 x 740 x 1900	1180 x 950 x 2200	1420 x 1140 x 2400	1700 x 1240 x 2550	1700 x 1240 x 2550	1820 x 1240 x 2800	1820 x 1240 x 2800	1820 x 1240 x 2800	2400 x 1550 x 3000	2290 x 1400 x 3000

Technical changes reserved.

# Technical data feed systems (SZV + SWV)

gripper feed (SZV)		SEP 12	SEP 25N	SEP 40N	SEP 40S-810	SEP 63N	SEP 63SN	SEP 63SN-950	SEP 80N	SEP 100	SEP 100S
SZV = SCHAAL gripper feeder		attachment option & strip infeed height above mounting table/clamping bars									
N	SZV 2	mm	100	100	115	115	115	115	115	x	x
N	SZV 202 (with height adjustment)	mm	90 – 130	70 – 130	90 – 150	90 – 150	90 – 150	90 – 150	90 – 150	90 – 150	90 – 150
N	SZV 3	mm	x	105	120	120	120	120	120	125	125
N	SZV 302 (with height adjustment)	mm	x	90 – 150	90 – 150	90 – 150	90 – 150	90 – 150	90 – 150	90 – 150	90 – 150
	maximum strip width with SZV	mm	160	180	260	260	260	260	260	260	260

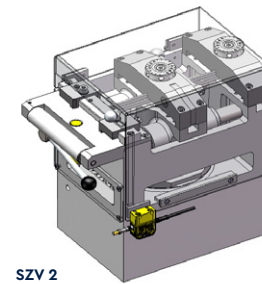
gripper feed (SZV)		SZV 2	SZV 202	SZV 3	SZV 302
feed length (1)	mm	2 – 80*	3 – 100	4 – 150	4 – 160
feed length (2)	mm	–	30 – 130	–	70 – 230
strip width	mm	8 – 160	8 – 160	8 – 250	8 – 250
strip thickness	mm	0,1 – 2	0,1 – 2	0,1 – 4	0,1 – 4
strip crosssection	mm <sup>2</sup>	200	200	400	400
clamping force/feeding gripper	kN	1,6	1,6	4	4
clamping force stationary gripper	kN	0,8	0,8	2	2
feeding angle	°	180	180	180	180
feeding accuracy	mm	+/- 0,01	+/- 0,02	+/- 0,02	+/- 0,03
feeding speed	m/min	30	30	30	30
infeed unit height adjustment		on request	+/- 30	on request	+/- 30

\* in case of a stroke rate of > 600spm the feeding length is limited to 2-60mm

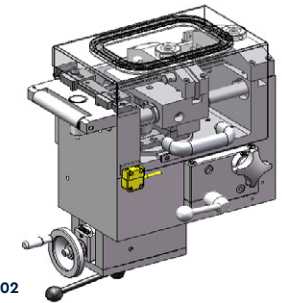
- Attachment to stamping press left or right
- Working method pushing or pulling
- Continuously adjustable intermediate lifting

**Optional**

- Thin strip guide
- Special clamping pieces



SZV 2



SZV 202

roller feeder (SWV)		SEP 12	SEP 25N	SEP 40N	SEP 40S-810	SEP 63N	SEP 63SN	SEP 63SN-950	SEP 80N	SEP 100	SEP 100S
SWV = SCHAAL roll feeder		Attachment option & strip infeed height above mounting table/clamping bars									
N	SWV 1	mm	100	120	120	120	120	120	120	120	120
N	SWV 2	mm									
N	SWV 202	mm									
N	SWV 302	mm	x								
	mechanical feeding height adjustment possible	mm	+/- 30	+/- 30	+/- 30	+/- 30	+/- 30	+/- 30	+/- 30	+/- 30	+/- 30
	maximum strip width	mm	210	250	320	320	320	320	320	420	420

customized solutions for the transporting width of the roller feeder are possible; their working range can be extended if they are mounted on the front or the back of the press

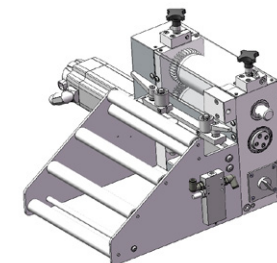
roller feeder (SWV)		SWV 1	SWV 2	SWV 202	SWV 302
strip width*	mm	160 (300 max.)	250 (700 max.)	250 (700 max.)	300 (1000 max.)
strip thickness	mm	0,1 – 2	0,1 – 3	0,1 – 3	0,1 – 4
max. strip crosssection	mm <sup>2</sup>	100	400	400	800
feeding length	mm	0 – 9.999,9	0 – 9.999,9	0 – 9.999,9	0 – 9.999,9
feeding accuracy	mm	+/- 0,05	+/- 0,05	+/- 0,02	+/- 0,02
smallest unit to adjust feeding length	mm	0,01	0,01	0,01	0,01
roller diameter	mm	72	100	110	165
contact pressure	kN	0 – 4	0 – 6	0 – 8	0 – 12

\* customized strip width possible

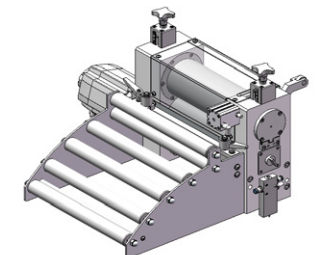
- Attachment to stamping press left/right/front/rear
- Feed rate up to 120 m/min
- Working method pushing or pulling
- Two feeds possible when using strip material (piece goods) (1x pushing and 1x pulling)

**Optional**

- Special rollers (profiled, rubberized)
- Height adjustment via angular gear with handwheel and position indicator



SWV 2



SWV 202