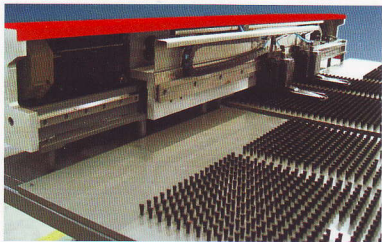


CNC Hydraulic Turret Punch Press



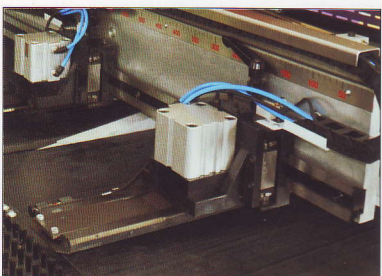
LEK T3

LEK LFK MACHINERY CO., LTD



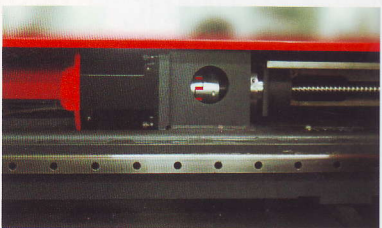
Sheet carriage

The carriage slides by means of preloaded ball screw and high precision linear guide way. The carriage adopts high rigid rectangular pipe structure for long lasting stability and high loading capacity ensuring high positioning accuracy at high speed



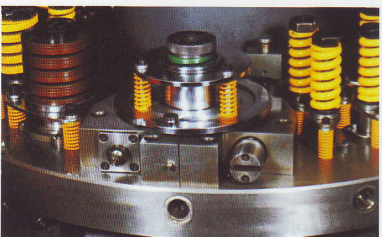
Sheet clamps

Extended pneumatic clamps adopt up-down floating construction, suited for different station height to eliminate plates' deformation. The clamps are fitted into the dovetail slide for easy movement and have high capacity to bear the load



Servo motor

Direct drive design of X-axis servo motor use , can work with high speed and precision



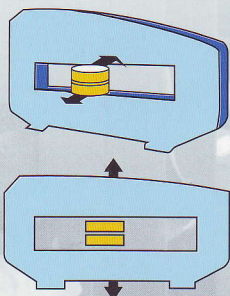
Auto-Index station

The indexing device can rotate different angles of the punch and die to fit the machining demand of complex parts and greatly reduce the amount of tooling and shorten the machining time



Lubrication

All sliding and moving parts of the machines, bearings and sliding blocks are lubricated automatically. The lubrication is managed directly by the CNC

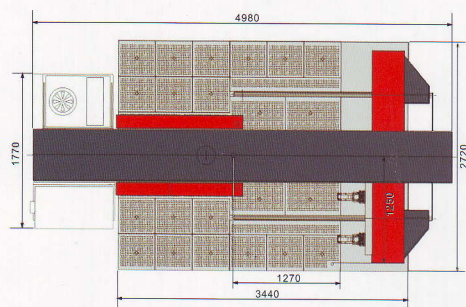


"O" Frame Construction

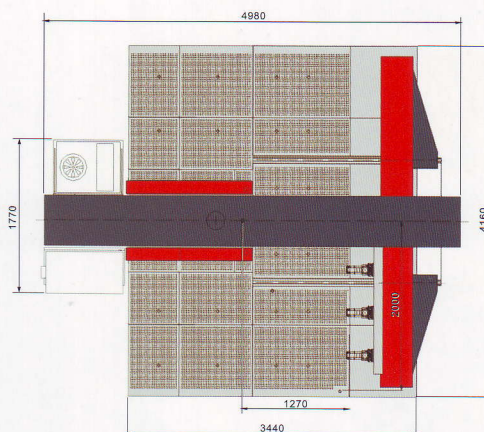
- Fully welded steel frame, stress relieved by vibratory process, with high strength and rigidity
- The closed "O" frame construction is stable and rigid which eliminates any flexing or yawing of the frame during processing

Overall Dimension

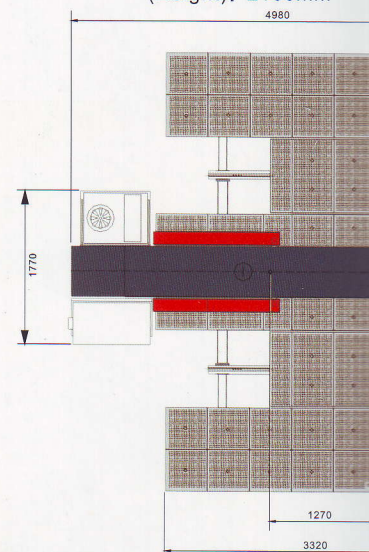
T3-1212
(Height): 2100mm



T3-1220
(Height): 2100mm



T3-1225
(Height): 2100mm

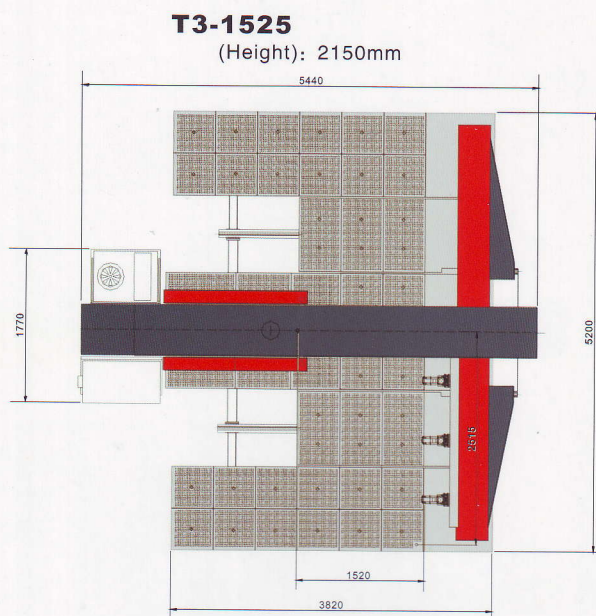
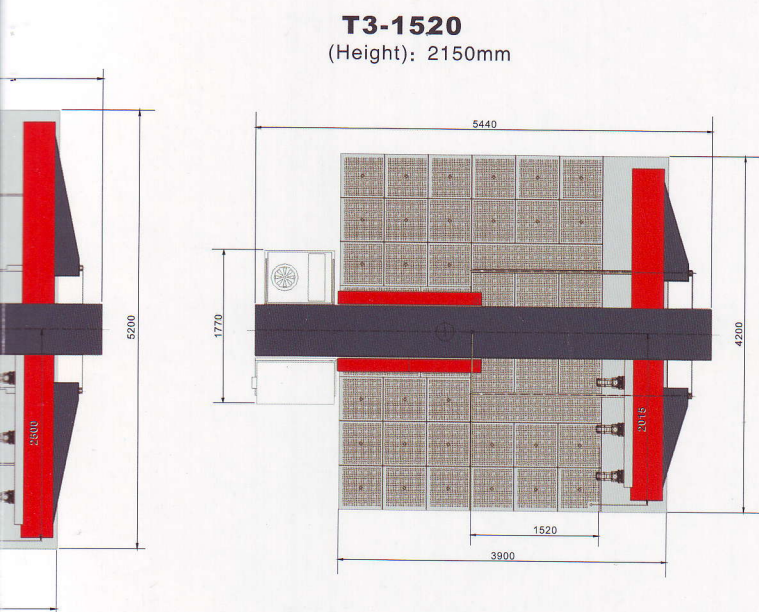


Technical Parameters

Technical Specifications	Unit	T3-1212
Punch Force	KN	300
X-axis travel	mm	1250
Y-axis travel	mm	1270
Accuracy (Tolerance of hole centers)	mm	±0.1
Max. Sheet size (with one repositioning)	mm	1270 X 2500
X traverse axis speed	M/min	100
Y traverse axis speed	M/min	60
Turret rotation speed	R/min	30
Max. punch stroke	mm	32
Max. sheet thickness	mm	6
Max. sheet weight	kg	120
Nibbling rates max. (4mm stroke)	HPM	500 ※ 900
Hit rates max. (1mm increment)	HPM	400 ※ 680
Hit rates max. (25mm increment)	HPM	250 ※ 320
Number of stations in turret		30
Maximum punch diameter	mm	88.9
Automatic repositioning		Yes
Main transmitting method		Hydraulic
Oil tank capacity	Litre	225
Control system		Fanuc 0i-PD
Controlled axis		4
Compressed air pressure, minimum	bar	6
Machine weight	kg	12000
Installed power	kW	30






(1) parameter of machine in static. (2) speed of X,Y axes are based on the weight of part to be work. (3) 5mm punch stroke.

N.B. Voltage stabilizer and hydraulic oil








Model			
T3-1220	T3-1225	T3-1520	T3-1525
300	300	300	300
2000	2500	2000	2500
1270	1270	1520	1520
±0.1	±0.1	±0.1	±0.1
1270 X 4000	1270 X 5000	1520 X 4000	1520 X 5000
100	100	100	100
60	60	60	60
30	30	30	30
32	32	32	32
6	6	6	6
120	120	120	120
500 ※ 900	500 ※ 900	500 ※ 900	500 ※ 900
400 ※ 680	400 ※ 680	400 ※ 680	400 ※ 680
250 ※ 320	250 ※ 320	250 ※ 320	250 ※ 320
30	30	30	30
88.9	88.9	88.9	88.9
Yes	Yes	Yes	Yes
Hydraulic	Hydraulic	Hydraulic	Hydraulic
225	225	225	225
Fanuc 0i-PD	Fanuc 0i-PD	Fanuc 0i-PD	Fanuc 0i-PD
4	4	4	4
6	6	6	6
13000	13500	13500	14000
30	30	30	30

Turret configuration (30 Stations)

Turret Configuration				
Tool Configuration	No.	AI	Sizes	
A 	16 (4)		Ø1.6~12.7mm	
B  	8 (8)	2 (2)	Ø12.8~31.7mm	
C 	2 (2)		Ø31.8~50.8mm	
D 	2 (2)		Ø50.9~88.9mm	

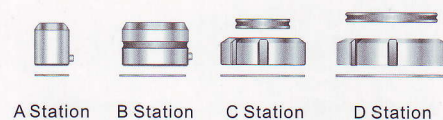
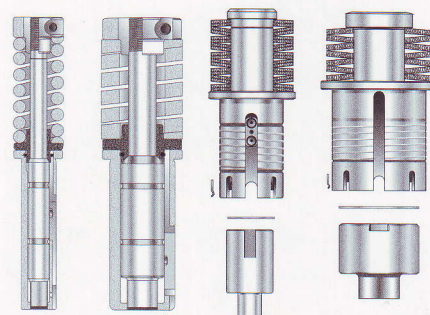
() keyed stations

Turret configuration (42 Stations)

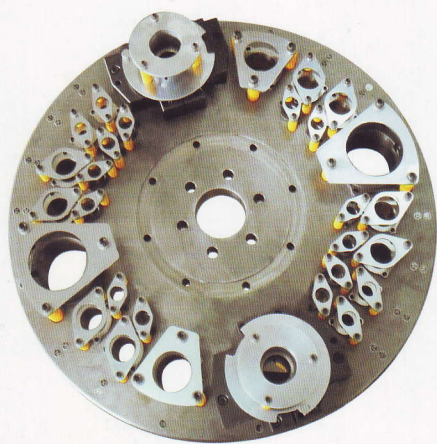
Turret Configuration				
Tool Configuration	No.	AI	Sizes	
A 	26 (8)		Ø1.6~12.7mm	
B  	10 (10)	2 (2)	Ø12.8~31.7mm	
C 	2 (2)		Ø31.8~50.8mm	
D 	2 (2)		Ø50.9~88.9mm	

() keyed stations

Thick turret tooling



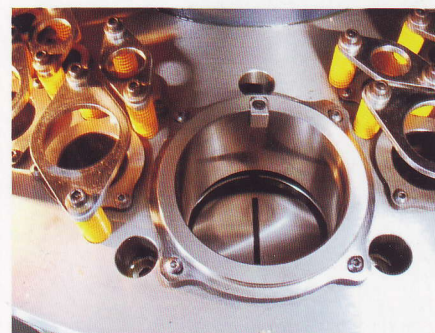
Self centering device, guide assembly, punches and dies (Option)



Thick turrets

The tool holding turrets are made of high grade cast iron.

All stations in the turret are fitted with special sleeves which guarantee long lasting perfect co-axiality between punches and dies.



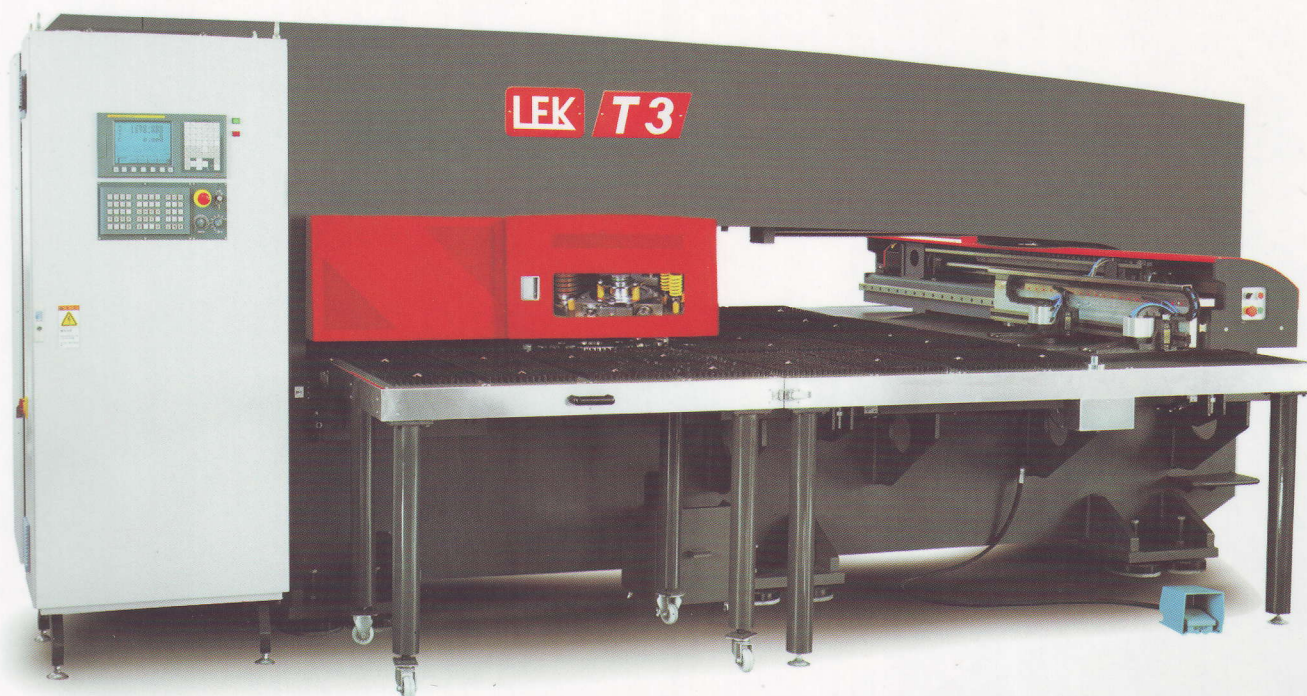
Turret design

Double-Track thick turret is good for standard toolings and high precision of tool guidance.





CNC Hydraulic Turret Punch Press



T3-1212

Characteristics

- ◎ The high precision German hydraulic punching head, with very low impact noise
- ◎ Each tool can set its own TDC, BDC and punching stroke, thus eliminating manual shimming of the punch, after regrinding
- ◎ Constant working power independent from the stroke position of the tool, providing greater capabilities in material thickness and hole sizes. Louvers and other forming operations are achieved with greater ease
- ◎ Intrinsic protection against overload can safely protect the machine and the tooling



T3-1525

CNC system

Japan FANUC 0iPD CNC Controller

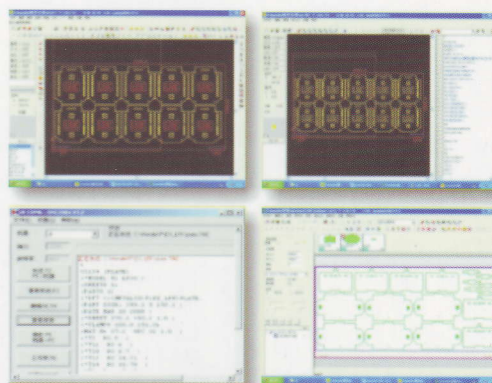
- ◎ Display: 10.4" TFT Color display
- ◎ Language: Chinese or English
- ◎ Communication port: RS232 port
- ◎ Resolution: 0.001mm
- ◎ Controlled axis: 5axes(X、Y、T、C、P axis)
- ◎ Working temperature: 0~45°C
- ◎ Relative humidity: 20~80%RH



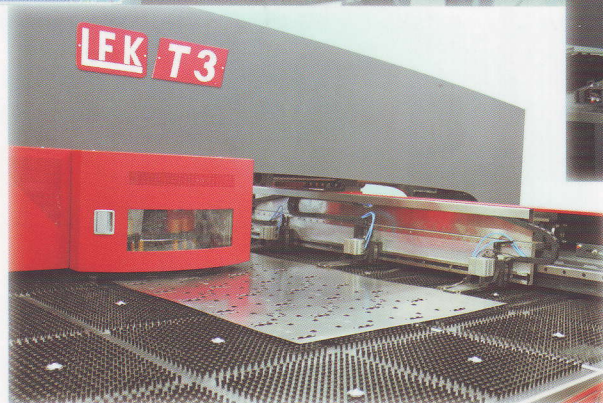
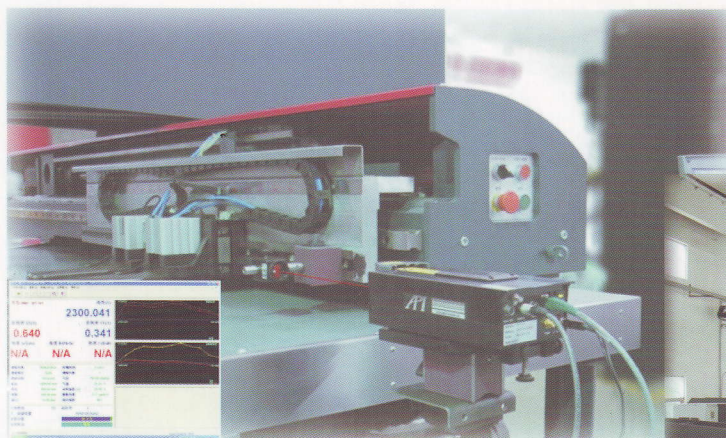
Off-line programming software (Option)

Main feature:

- ◎ Menu in Chinese or English
- ◎ Easy to learn and use
- ◎ Powerful function, great performance
- ◎ Tool library management
- ◎ Automatic tool selection
- ◎ Micro-joint function
- ◎ Automatic optimizing
- ◎ Automatic repositioning
- ◎ Nesting



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