



JMT

STRONG ON SERVICE

TURRET PUNCHES



**It's difficult to compete in today's
world with yesterday's technology.**

We have solutions.



JMTUSA.com

Email: JMT@JMTUSA.com

Toll Free: **855-773-7727**
(855-PRESS-BRAKE)

JMT machines are built by the largest volume fabrication machine tool producer and the most respected manufacturer of sheet metal machinery in the world. This factory is one of the world's most contemporary production plants, with a 1.5 million square foot footprint and over 1500 dedicated employees.

JMT machines are built to extremely stringent standards and the factory has maintained continuous product research and development since 1956. With 75 R&D and product engineers on-staff at the plant, **JMT** products utilize the most modern techniques in design and engineering, and are equipped with proven quality components to fulfill a customer's most exacting requirements. **JMT** combines "accuracy, speed, flexibility, durability, reliability and advanced technology" with the highest performance/price ratio in the world.

A nationwide network of **JMT** distributors and technical support personnel are in place to assist you.

Our machines are built with world-renown components such as Rexroth, Siemens and Schneider, which are available off the shelf from your local supplier, your dealer, or direct from **JMT**.

For more information please visit JMTUSA.com.

You can also email us at JMT@JMTUSA.com or call toll free to **855-773-7727** (855-PRESS-BRAKE).



JMT's U.S. HEADQUARTERS



PLANTS BUILDING OUR JMT MACHINES



MACHINE PARTS INVENTORY

JMT Punch Press Machines

Thousands of **JMT** Punch Presses all around the world attest to the quality, reliability, and stability of our machines ; their stress relieved steel construction, modern design, state of art control system, software suite, and quality proven hydraulics are the distinctive characteristics that set out machinery apart in the world.

Auto-clamping, strong and flexible turret structures, simple and perfectly designed standardized & supplementary equipment set the standard of what to seek in the industry. The user friendly CAD/CAM software rounds out our machines to offer perfect full package to our clients.

Possible software and parameter problems can be checked via “ Remote diagnostic” function of our control unit.

Loading and unloading systems can be integrated for efficient and lean operations

- High performance/price ratio
- Low maintenance costs

JMT Punch Presses are designed and produced for value add operations' for long lifetime.

TP Series

Turret Punch

Flexible and strong punching processes for each sheet formats



RP Series

Rotational - Head Punch

Durable punching operation for cost effective processes

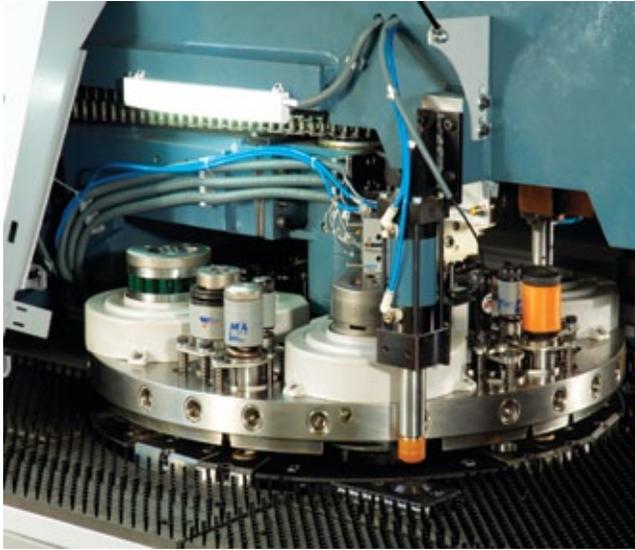


JMT TP SERIES



- *Small, medium and large format sheet processing*
- *Punching, forming, tapping, and wheel technology capabilities*
- *Stress relieved O-frame*
- *Flexible turret configurations to eliminate tool setups*
- *Auto lubrication of moving parts*
- *Rigid guides*
- *One of the best controller with functionality & flexibility*
- *Powerful control with user friendly CAD-CAM Software*
- *Programmable sheet clamping system decreases set-up times and scrap ratio*
- *Automation can be easily integrated for efficient and lean operations while also increasing operator safety and as well as decreasing operator fatigue.*

FEATURES



Precise and High Speed Turret

The punching head stroke rates of 1200 strokes per minute during punching and 1800 per minute during marking. Also can be forming at punching speed. The machine control adjusts stroke travel speed and position.

With its dynamic design, it is possible to obtain speeds of
96 m/min in X axis
80 m/min in Y axis
124 m/min simultaneously

High acceleration (1g) is possible across the whole working range without any restriction.



Intelligent Hydraulics

Advanced ram positioning control by closed loop hydraulic Hartmann Lammler, table axis drive by Siemens servo motors acquire $\pm 0,1$ mm positioning accuracy and $\pm 0,5$ mm repeatable accuracy. Accurate index incremental ($0,01^\circ$) is provided by very precision bevel gears. Upper and lower angular synchronization is acquired by backlash free 2 servo motor & 2 reducers.

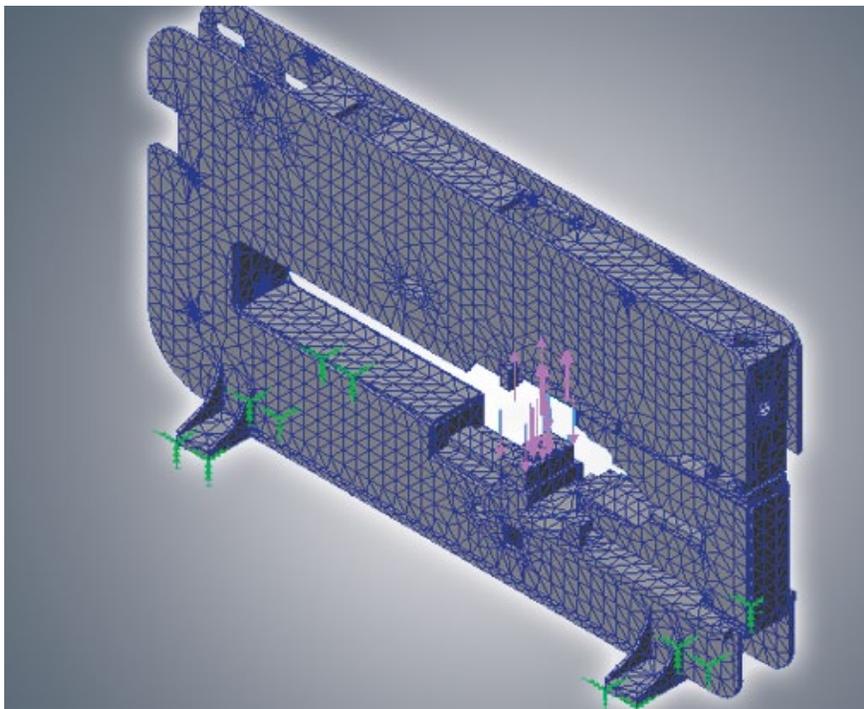


High Quality Forming

Variable dwell time at bottom of stroke provides high quality, forming, often eliminating secondary processing Electronic adjustment simplifies setup of progressive forms, flanges, and embossments.

With roller technology are possible not only on straight geometries but also on curved and round areas. This method is of particular interest for sectors such as air conditioning technology. (Wheel tools, tapping tools)

High speed marking



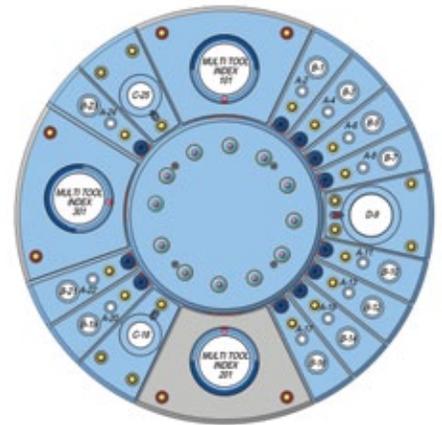
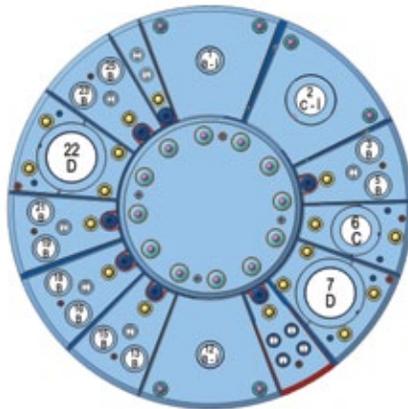
Robust Body Frame

Portal (O) type body frame consists of two fully enclosed box fabrications. Finite element analysis on high performance computers was used to simulate the design and thoroughly minimize openings, twist, deflection and shift of the frame. Body frame is also treated by high load and stress relieve during and after the welding.

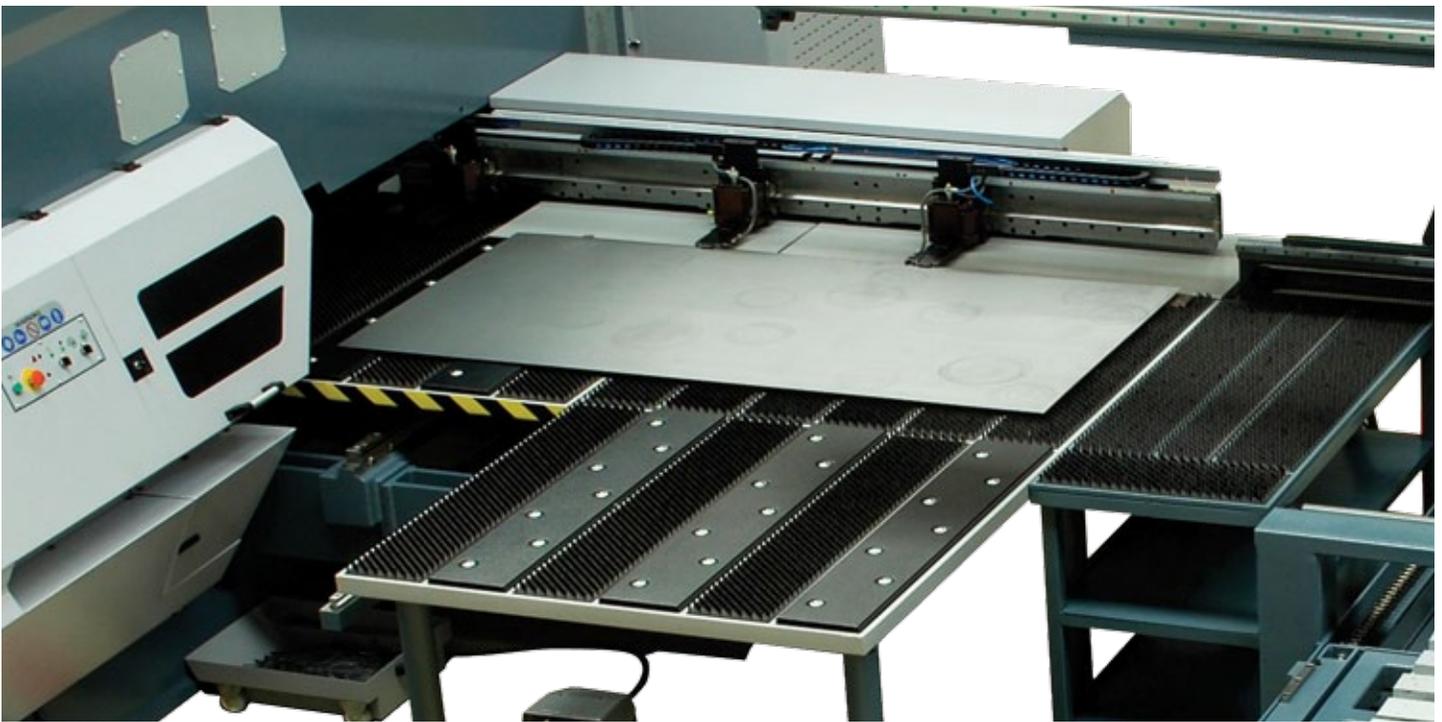
The result is rigid frame that keeps vibration to minimum, allowing greater precision in punching, while substantially reducing tool wears and lowering noise levels.

The body is robust and very strong, consists of two different parts. Because of its special design, the turret and tools are not affected from punching force even at maximum tonnage. No deflection occurs on the turret and tools, so the tool life become longer.

Turret



Station	Sizes	TP6-9	TP93-123
A -fix	0.8 - 12.7 mm	11	11
B - fix	12.8 - 31.7 mm	10	11
C - fix	31.8 - 50.8 mm	1	2
D - fix	50.9 - 88.9 mm	2	1
B - index	12.8 - 31.7 mm	2	-
C - index	31.8 - 50.8 mm	1	-
D - index	50.9 - 88.9 mm	-	3



Reposition

It is possible to process sheet length over table length without need to reposition.



3 Auto Index Stations

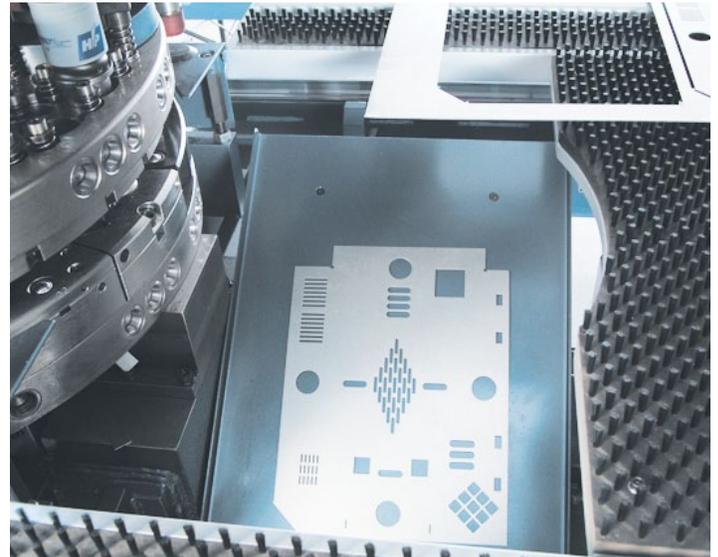
Provide maximum flexibility by simplifying tooling inventories and reducing tool setup time.

Tools are rotatable in 0.01° increments enabling the processing of complex shaped parts with the minimum number of tools.

Tool change takes less than 3 seconds to complete total turret movement and just 0,6 seconds for single tool.

Forming almost at punching speed by closed loop hydraulic by Bosch - Rexroth. A variable forming position ensures that forming operations can be carried out with minimal stroke travel.

The dies are positioned below the table surface, preventing sheets from being scratched or caught, therefore micro tags can be reduced to minimum for more precision parts.



Workchute

To evacuate parts during punching also with sorting and stacking capacity.

The parts chute, small parts up to 400 x 600 mm can be ejected directly into a parts container. An optional conveyor system. (TP6, TP9 standard, rest optional)



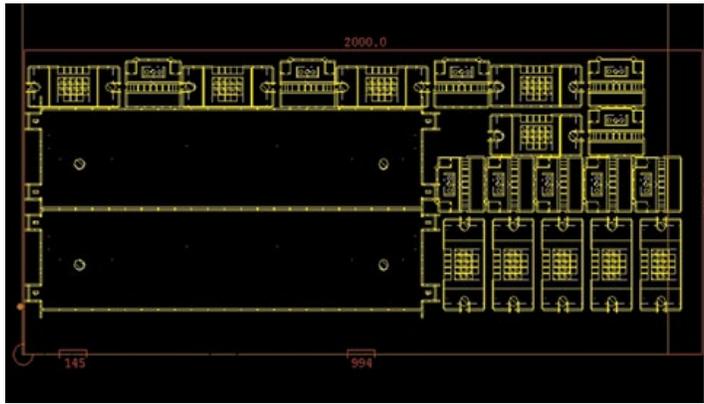
Motion and Table

A new design of X and Y axis, direct drive technology is used. This will increase the performance and eliminates any losses from belts, gears or any transmission systems.

Ball table mainly easy movement of the sheet, brush table is generally for sensitive and soft material punching for not to scratch the sheet. Both is available according to customer demands.

Automatic Clamps

When punching thinner material, one of the problem is to control the sheet movement at non-clamping area. To eliminate this matter 3 clamps or more is available.



CAD-CAM Software

Programming time minimized by using fast and easy CAD-CAM software (cncKAD) metalix or LanTek. By choosing the effective position of the tool automatically to use maximum area of the sheet, additional reposition and work strips is eliminated.



Control System

Siemens Sinumerik 840 DSL control system is applied for punching. Controls and screen are mounted on a mobile control panel. The control system and other hardware are mounted in a separate cabinet. Machining can be started with just a few steps. Network (Ethernet) connection is available as well as programming on the control panel. UPS system prevents the control unit from the voltage fluctuations and cuts.

Integrated online help messages answer all questions at the location they arise. The diagnostic concept provides visual depictions of any function faults. Remote diagnostics is a matter of course over Internet for diagnostics for machine controller.

TP Series	Unit	TP6	TP9	TP63	TP93	TP123	TPL93
Maximum tonnage	ton	30	20	30	20	20	20
Frame type	-	0 frame					
X axis movement	mm	2000 + R	2000 + R	2500 + R	2500 + R	2500 + R	3000 + R
Y axis movement with single tool	mm	1250	1250	1250	1250	1250	1500
Automatic Repositioning range *	mm	10000*	10000*	10000*	10000*	10000*	10000*
Speed of Y axis	m/min	60	70	60	70	80	70
Speed of X axis	m/min	75	90	75	90	96	90
Lateral speed Y + X	m/min	90	114	90	114	124	114
Max. Hit rate (1 mm pitch, 1mm thickness)	1/min	600	900	600	900	1200	900
Max. Hit rate (25 mm pitch, 1mm thickness)	1/min	300	350	250	300	400	300
Max. Hit rate : Marking	1/min	850	1200	900	1200	-	1200
Main cylinder stroke	mm	40	40	40	40	40	40
Maximum punching stroke	mm	25	25	25	25	25	25
Max. cutting thickness	mild steel	6 mm					
	Stainless steel	3 mm					

Turret (without tool and holder)	Unit	TP6	TP9	TP63	TP93	TP123	TPL93
A - fix 0.8 -12.7 mm		11	11	11	11	11	11
B - fix 12.8 - 31.7 mm		10	10	11	11	11	11
C - fix 31.8 - 50.8 mm		1	1	2	2	2	2
D - fix 50.9 - 88.9 mm		2	2	1	1	1	1
B - index 12.8 - 31.7 mm		2	2	-	-	-	-
C - index 31.8- 50.8 mm		1	1	-	-	-	-
D - index 50.9 mm to 88.9 mm		-	-	3	3	3	3

	Unit	TP6	TP9	TP63	TP93	TP123	TPL93
Positioning accuracy	mm	± 0.1	± 0.1	± 0.1	± 0.1	± 0.1	± 0.1
Repeatable accuracy	mm	± 0.05	± 0.05	± 0.05	± 0.05	± 0.05	± 0.05
Turret rotation speed	rpm	30	30	22	22	22	22
Auto index rotational speed	rpm	150	150	150	150	150	150
Max. weight of sheet	kg	100	120	120	120	120	200
Hard disk	Gbyte	40	40	40	40	40	40
RAM	Mb SDRAM	256	256	256	256	256	256
Network system	-	Windows XP					
LCD colorscreen Super VGA	-	15"	15"	15"	15"	15"	15"
USB	-	2.0	2.0	2.0	2.0	2.0	2.0
Ethernet	-	10/100	10/100	10/100	10/100	10/100	10/100
Machine dimension							
Height (H)	mm	2500	2500	2500	2500	2310	2310
Width (without light barrier) (W)	mm	4200	4200	4300/5360	4300/5360	4270	6300
Width (with light barrier)	mm	6200	6200	6270/7260	6270/7260	6270	8300
Length (without light barrier) (L)	mm	5200	6000	5750	5750	4800	6650
Length (with light barrier)	mm	6200	7000	6800	6800	5800	7650
Table height	mm	940	940	940	940	940	940
Weight approx.	kg	12500	12500	12500	12500	13800	19500
Motor	kw	11	7.5	11	7.5	15	7.5
Oil tank	lt	180	200	180	180	180	200
Air pressure	bar	6	6	6	6	6	6
Number of Clamps	pcs.	2	2	3,00	3,00	3	4
Holding force of clamps	kg	1000	1000	1000	1000	1000	1000
Table type	-	Brush	Brush	Brush	Brush	Brush	Brush

* : Special table must be added to the machine and the light barriers must be located the correct position. Max.weight 100 kg.

TP

STANDARD EQUIPMENTS

Command pedal
CAD-CAM software & Activator
Control unit, Siemens Sinumerik 840 D SL Windows XP operating system
Remote diagnostic function
Programming on the control panel
Automatic clamp positioning.
Sheet set switches on clamps
Network, Ethernet communication.
Automatic tool lubrication
UPS for control panel
Movable scrap box
Brush table
Oil Cooler
USB Driver
Web cam for service
Reposition on X axis
Alignment Tools for Index Stations (C+B Station) - (for TP6, TP9)
Alignment Tools for Index Stations (D Station) - (for TP63, TP93, TPL93, TP123)
Manual nesting

OPTIONAL EQUIPMENTS

Light barriers for CE
Additional clamps
Table (brush&ball)
Tools, Tool holders, reducers
CAD-CAM SW Second activator (dongle)
SW for Autonesting, Wheel and Tapping tools
Warning lamp
Sheet deformation alert switch
Turret cover for perforated sheets
Vacuum slug remover
Workchute
Automatic lubrication for the machine
Air condition for electrical box
Additional oil cooler
Loading- Unloading preparation
Loading- Unloading system
Additional table
Special table
Transformator
UPS for machine (30KvA - 10 min)
Additional allignment tool

JMT RP Series Punch Presses



- ***Single rotational head machines with versatile C-frame construction***
- ***Stress relieved steel construction***
- ***Powerful Siemens controller with user friendly CAD-CAM Software***
- ***Fast and simple operation***
- ***High quality and well known hydraulic and electronic components***

FEATURES



Control System

Siemens Sinumerik 840 DSL control system is used for punching for precision accuracy. Controls and screen are mounted on a mobile control panel. The control system and other hardware are mounted in a separate cabinet. Machining can be started with just a few steps. Network (Ethernet) connection is also available, as well as direct programming on the control panel. UPS system prevents the control unit from the voltage surges, fluctuations, and power outages.

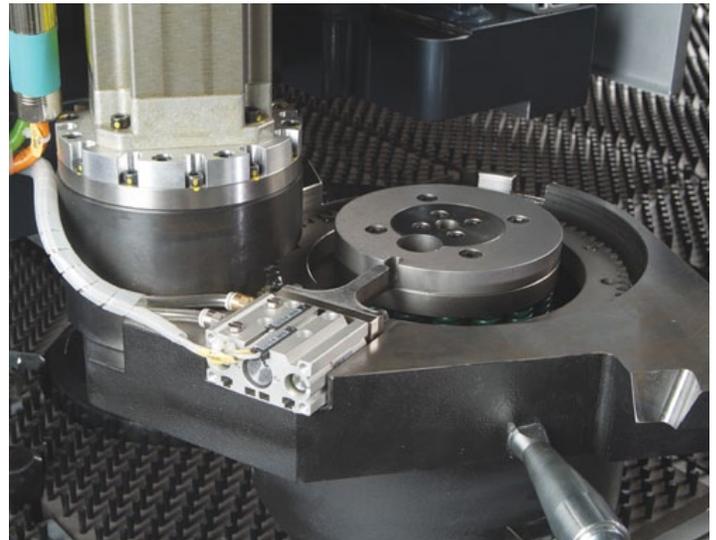
Integrated online help messages answer all questions on-site as they arise. The diagnostic concept provides visual depictions of any function faults. Remote diagnostics is possible over Internet for diagnostics for remote analysis of machine controller.

The control ensures that optimal acceleration values can be attained at every stage of machining, depending on the actual masses that need to be moved.



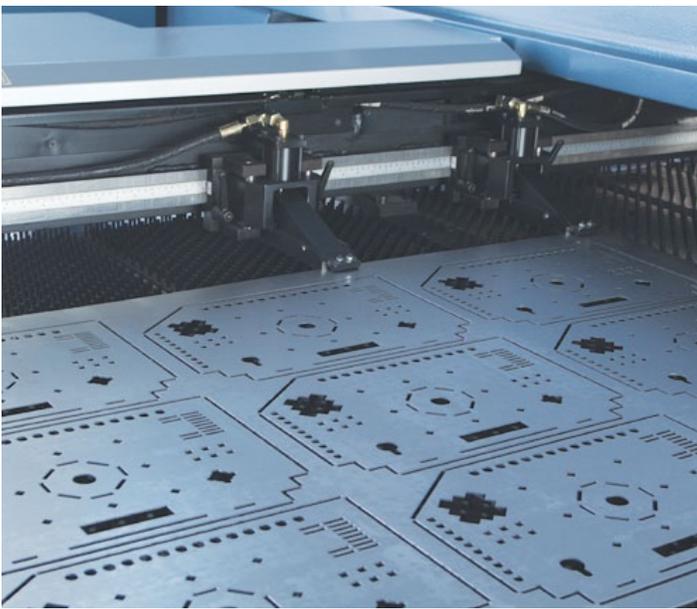
Multi Tooling

JMT rotation punch press top and bottom tools work synchronize to obtain all required angular pitch can be $\pm 0,02^\circ$. Upper and lower index groups have no mechanical connections which means they can be perfectly aligned, even defects in the tools can be adjusted. It has a wide tooling usage capacity with 3, 6, 8, 10 tools multi-tool selection.



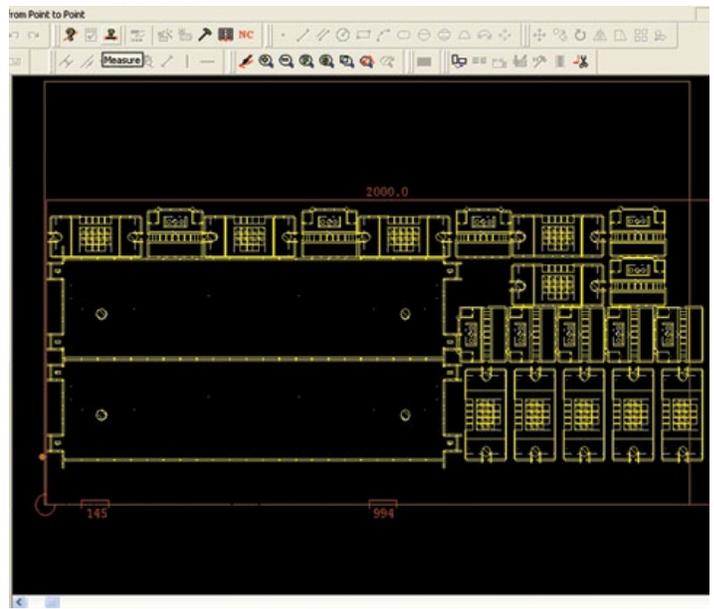
Rotational Head

- High rotational speed 40 rpm makes the machine fast.
- Zero backlash Harmonic Drive Gear system for index position punching.
- Automatic repositioning in the X axis enables to punch longer than 2 meters and eliminate the dead area on the sheet.



Auto Clamps

Automatic clamps (standard with RP9) position according to the CAM program, sheet remove sensors at clamps detects the sheet hold, in case any possible release machine stops to protect working environment.



CAD-CAM Software

Programming time minimized by using fast and easy CAD-CAM software (cncKAD) metalix or LanTek. By choosing the effective position of the tool automatically to use maximum area of the sheet, additional reposition and work strips is eliminated.



Work Chute

Discharges processed small work pieces without interruption or small manual manipulation. (Standard with RP9)



JMT Punch Press is equipped with infra-red barrier system according to CE conformity.

RP Series	Unit	RP6	RP9
Maximum tonnage	ton	30	20
X axis movement	mm	2000 + R	2000 + R
Y axis movement with multiple tool	mm	1250	1250
Y axis movement with single tool	mm	1285	1285
Max. Cutting thickness	mm	6	6
Automatic positioning range *	mm	10000	10000
Speed of Y axis	m/min	50	75
Speed of X axis	m/min	60	96
Speed of C axis index	rpm	40	40
Lateral speed Y + X	m/min	75	120
Max. Hit rate (1 mm pitch, 1mm thickness)	1/min	600	850
Max. Hit rate (25 mm pitch, 1mm thickness)	1/min	280	320
Max. Hit rate : Marking	Stroke/min	900	1250
Accuracy for positioning	mm	± 0.1	± 0.1
Max. weight of sheet	kg	100	120
Hard disk	Gbyte	40	40
RAM	Mb EDO	256	256
Network system	-	Windows XP	Windows XP
LCD colorscreen Super VGA	-	12.1"	12.1"
Working height	mm	980	980
Table width	mm	2400 x 3600	2400 x 3600
Machine sizes	mm	3600 x 4100 x 2450	3600 x 4100 x 2450
Motor	kw	11	7.5
Oil tank	lt	200	200
Weight approx.	kg	11600	12000
Main cylinder stroke	mm	20	30
Maximum punching diameter (for Multitool)	mm	24	24
Number of Clamps	pcs.	2	2
Holding force of clamps	kg	850	1000
Automatic Clamp Positioning	-	-	Standard
Table type	-	Brush	Brush

STANDARD EQUIPMENTS

Command pedal
CAD-CAM software & Activator
Control unit, Siemens Sinumerik 840 D SL Windows XP operating system
Remote diagnostic function
Programming on the control panel
Automatic clamp positioning (RP9)
Sheet set switches on clamps (RP9)
Network, Ethernet communication.
standart 6multi tool with punch and dies
6 pieces Durma tool and guide(gap 0.3 mm)
round Ø8
round Ø10
round Ø20
rectangle 4 x 20
square 7
square 17
Automatic tool lubrication
Alignment Tools for Index Stations (D Station)
Movable scrap box
UPS for control panel
USB driver
Brush table
Control panel
Oil Cooler
Reposition on X axis
Web cam for service
Manuel nesting

OPTIONAL EQUIPMENTS

Light barriers for CE
Additional clamps
Special table
Tools, Tool holders, reducers
CAD-CAM SW Second activator (dongle)
SW for Autonesting & Wheel tools
Additional table
Air condition for electrical box
Additional oil cooler
Warning lamp
Sheet deformation alert switch
Workchute for RP9
Automatic lubrication for the machine
UPS for machine (30KvA - 10 min)
Transformer
Auto Nesting and wheel soft



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