

Strippit V/VX-Series

CNC TURRET PUNCH PRESSES



Sheet Metalworking, Our Passion, Your Solution

STRIPPIT V/VX-SERIES

Unsurpassed Productivity

When production applications demand high productivity, the Strippit V/VX-Series delivers. These exceptionally versatile, full-featured machines offer high hit rates, large turret capacity, large feed clearance, and powerful control capabilities in a robust design engineered for long life.

- Flexible tool configuration
- Energy efficient
- Full sheet utilization
- Heavy sheet carrying capacity
- High-speed processing





Strippit V/VX-Series

- **High hit rates** of up to 425 HPM at 25 mm pitch (Strippit V-Series), up to 530 HPM at 25mm mm pitch (Strippit VX-Series)
- 200 kN (Strippit VX-Series) or 300 kN (Strippit V-Series) **configurations**
- ERS – **Energy reduction system** reduces energy consumption by up to 15%
- **Versatile mix** of 48 turret stations with four 88,9 mm indexable stations
- Finished part **accuracy** of $\pm 0,1$ mm with a repeatability of $\pm 0,05$ mm over the entire table
- **Programmable and relocatable** work clamps
- **Programmable** parts chute
- Patented **Smart Stroke®** automatically optimizes the ram stroke
- **Smart Clamp** adjusts the no-punch zone in relation to the tool size which ensures the smallest possible no-punch zone
- **Durable, reliable** and easy to set-up
- PC-based **Fanuc CNC control**
- Optional offline programming software, **CADMAN® P**
- Modular **automation** options

KEY FEATURES

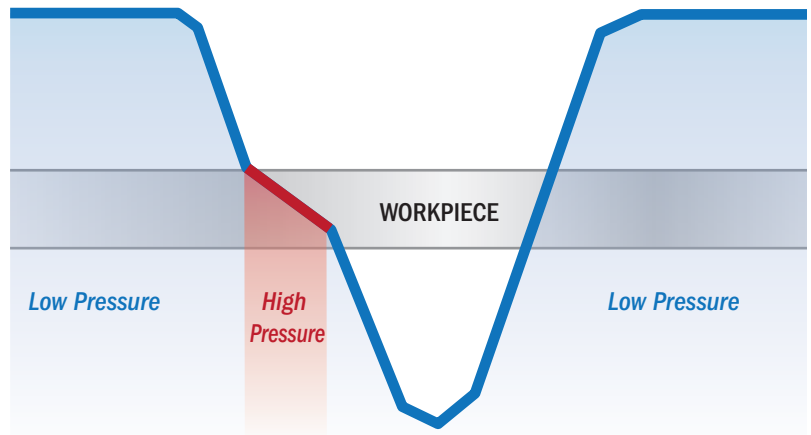
High-Speed, Energy-Friendly Ram



EFFICIENT PRESS DRIVE

A unique Hi-Lo pressure system provides the best power efficiency during machine operation. Using two pressure circuits, the system applies low pressure, high flow for lower tonnage high hit rate tools and high pressure, low flow for those applications requiring higher tonnage tools.

Hi-Lo pressure system provides significant energy savings

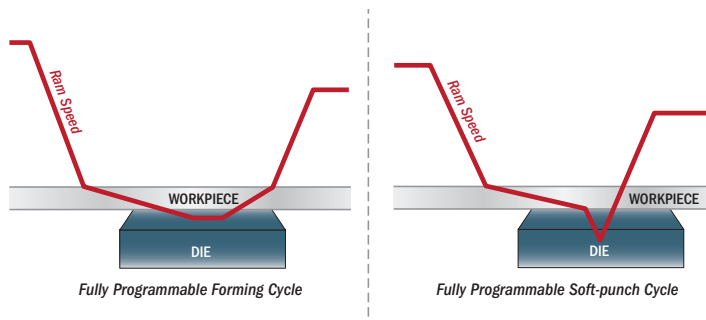


Average energy consumption in punching: 6,7 kW.

Energy consumption in Stand-by: 0,9 kW.

PROGRAMMABLE RAM

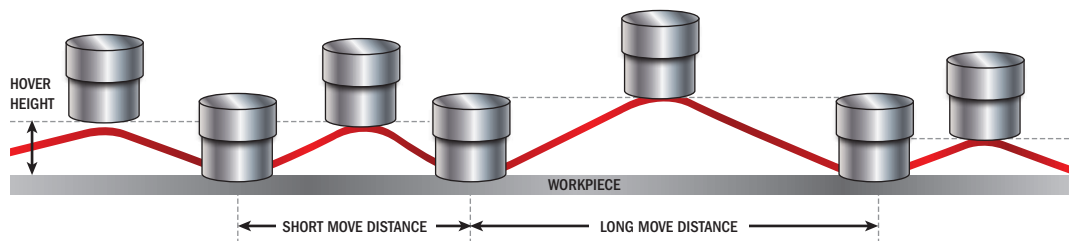
Machines feature a fully programmable ram control system. The system includes individual ram cycle profiles for punching and forming, Wilson “Wheel” tooling, tapping and Quiet Punch so users can easily, efficiently gain the most productivity from their V/VX machine.



PATENTED SMART STROKE® MAXIMIZES PRODUCTIVITY

The patented Smart Stroke® feature automatically optimizes the ram motion for the highest productivity. No program codes or operator intervention needed. Hover heights are automatically optimized which keeps the tool close to the material for short table moves. As hits move farther apart, Smart Stroke automatically increases the ram hover height to provide clearance for sheet warpage.

HOW SMART STROKE MAXIMIZES PRODUCTIVITY

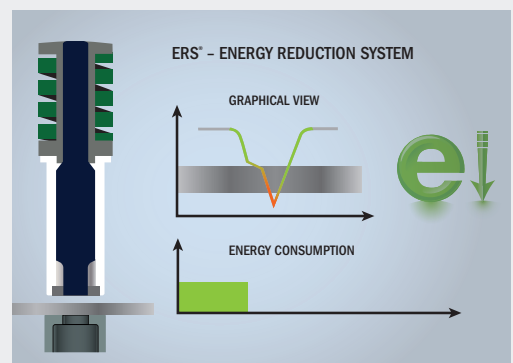


Strippit's Smart Stroke automatically selects the optimum hover height for each table move.

ERS reduces energy consumption by up to 15%

ERS - ENERGY REDUCTION SYSTEM

An energy reduction system automatically reduces power consumption when the machine is idle. ERS reduces energy consumption by up to 15% compared to previous Strippit punch presses.

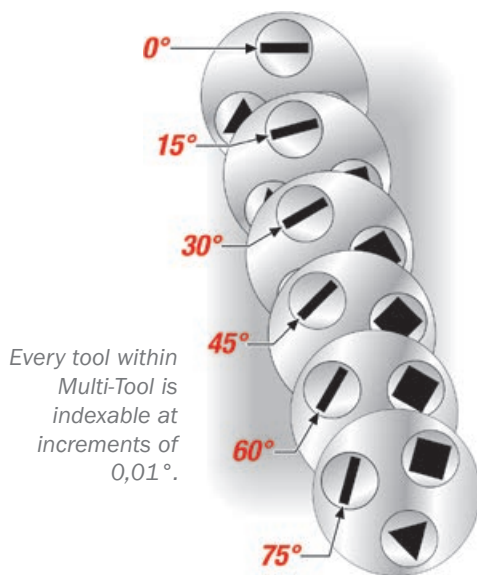


KEY FEATURES

Flexible Turret



A large capacity turret features 48 stations.



FLEXIBLE TURRET DESIGN

Strippit V/VX machines offer the most flexible turret configurations available. Large turret capacity – 48 stations – enables the use of a standard turret load. Large 88,9 mm auto-index stations accept indexable Multi-Tools to increase turret capacity to 76 tools.

- Large direct-driven, fully-indexable stations
- Bi-direction turret
- Generous feed clearance for forming
- Consistent accuracy
- Fast tool change

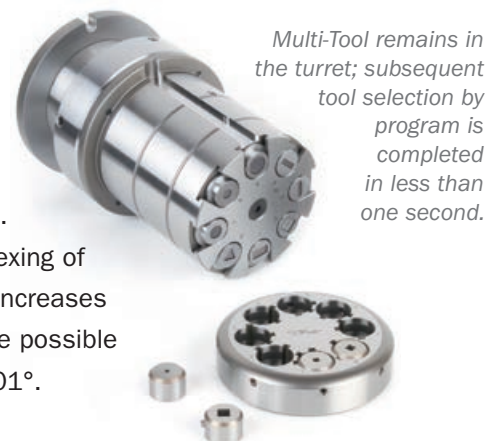
SLEEVED TURRET

Hardened turret sleeves ensure accurate punch and die alignment throughout the life of the machine. Sleeves can be easily replaced by the operator, eliminating the need for costly re-machining of the turret.

INDEXABLE MULTI-TOOL

The Strippit V/VX-Series can be equipped with optional indexable Multi-Tool units in 3- or 8-station configurations.

These Multitools provide indexing of any tool at any angle, which increases flexibility and productivity. The possible indexable increments are 0,01°.



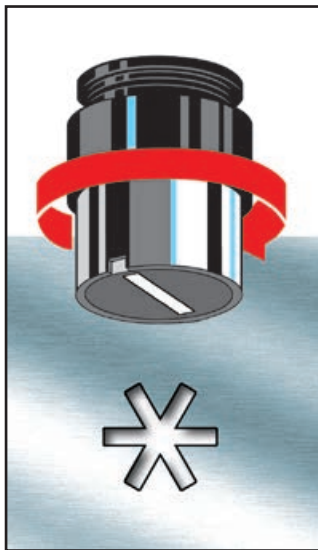
TOOLING TECHNOLOGY

Strippit V/VX-Series machines feature Thick Turret tooling allowing users to exploit a world of advanced tooling applications with forming, embossing, louvering, Wheel and tapping tools.



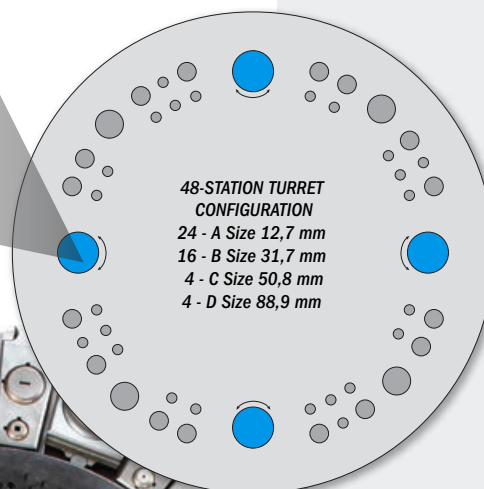
AUTOMATIC INDEXING


Rotates both the punch and die to any angle



*Punch any tool at any angle
anywhere on the sheet*

*Up to 76 tool capacity, with
up to 32 fully indexable tools*

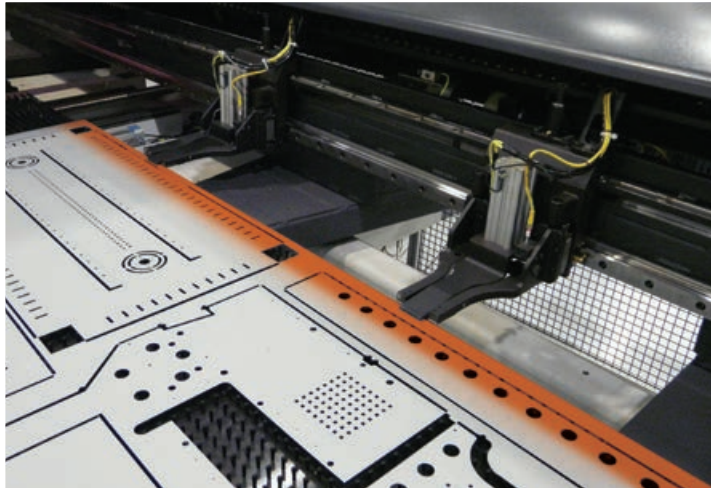


 Indicates Standard
Auto-Index Station



KEY FEATURES

Complete Sheet Utilization



Punch up to 85 mm from the edge of the sheet for full sheet usage.

Programmable work clamps increase sheet utilization by up to 5,5% on a 3 x 1,5m sheet

PROGRAMMABLE AND RE-LOCATABLE CLAMPS

Automating work clamp movement between jobs and during a punching cycle reduces setup time and increases productivity. The Strippit V/VX-Series features three programmable and relocatable work clamps with sheet pull out sensors as standard. Work clamps automatically position and can be automatically relocated during the program for total sheet utilization and beneficial material savings. Programmable work clamps never require manual adjustment.

SMART CLAMP

Smart Clamp, another standard Strippit V/VX-Series feature, automatically determines exact clamp locations to provide the smallest possible no punch zones in combination with the selected tool station.

INTEGRATED FANUC CONTROL & MOTOR DRIVE PACKAGE

All Strippit punch presses are equipped with an integrated Fanuc motor drive and control package for full control of the punching process. The control allows the machine operator to edit, input or output programs during machine operation to reduce setup and improve productivity. The Strippit V/VX-Series features direct-drive AC servo motors for fast acceleration and dynamic operation.

BRUSH BED DESIGN

Strippit V/VX-Series machines feature a full bristle bed construction ideally suited for processing of scratch-sensitive materials. The bristle bed configuration also minimizes punching noise levels.

FRAME CONSTRUCTION

Strippit punch presses feature a robust, closed-welded frame construction for high stability, speed and punching accuracy.

WORK CHUTE

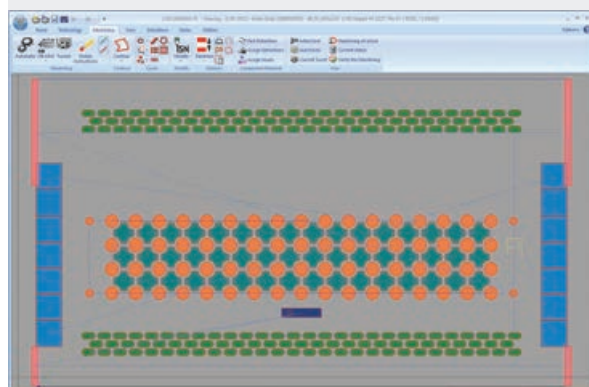
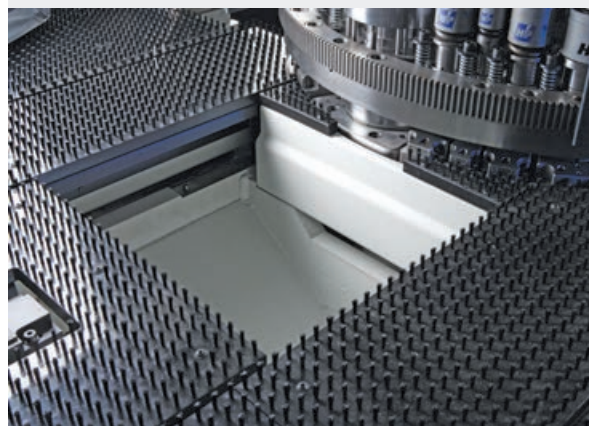
For the removal of smaller piece parts, Strippit V/VX-Series machines are equipped with a programmable parts removal chute. Parts up to 450 x 500mm can be evacuated from the sheet into a parts bin directly under the machine table or to an optional bin-sort system.

CADMAN®

OFFLINE PROGRAMMING

LVD's optional CADMAN® software package offers the ideal solution to quickly prepare and execute offline programs and integrate production processes for greater productivity.

*Edit, input or output programs
during machine operation*



KEY FEATURES

Modular Automation



Load/unload system features full brush table for reduced part scratching.



Pick-Sort system loads full size sheets and automatically retrieves and stacks individual punched parts.

Enhance the efficiency of a Strippit V/VX-Series machine with a modular automation solution designed to eliminate up to 80% of manual sheet handling and increase productivity up to 50%. Automation options are retrofitable or factory installed.

AUTOMATIC LOAD/UNLOAD

A patented automatic load/unload system reduces manual worksheet handling time as much as 80% and provides efficient processing of materials up to 3,5 mm. The compact, space-saving design loads and unloads material from the same side of the machine.

COMPACT TOWER (CT-P)

A Compact Tower (CT-P) 6 or 10 pallet provides full capabilities for loading, unloading, and storage of raw material and finished parts, enabling automated production from stored raw material to stacked finished parts.

PICK-SORT ROBOTIC SYSTEM

A robotic Pick-Sort material handling system converts a Strippit V/VX-Series machine into a freestanding, lights-out production cell. Machine and robot are integrated for maximum productivity.



STRIPPIT V/VX-SERIES

Specifications

| | STRIPPIT V30-1225 | STRIPPIT V30-1525 | STRIPPIT VX-1225 | STRIPPIT VX-1525 |
|---|---|--|--|--|
| PUNCHING SPECIFICATIONS | | | | |
| Maximum Punching Capacity | 300 kN | 300 kN | 200 kN | 200 kN |
| Max. Material Thickness | 6,35 mm | 6,35 mm | 6,35 mm | 6,35 mm |
| Punching Accuracy | ± 0,1 mm | ± 0,1 mm | ± 0,1 mm | ± 0,1 mm |
| Maximum Hit Rate at 2 mm Working Stroke (1) | | | | |
| 1 mm Pitch | Up to 1000 HPM | Up to 1000 HPM | Up to 920 HPM | Up to 920 HPM |
| 25 mm Pitch | Up to 425 HPM | Up to 425 HPM | Up to 530 HPM | Up to 530 HPM |
| Feed Clearance | 25 mm | 25 mm | 25 mm | 25 mm |
| Nominal Workpiece Size (2) | 1250 x 2500 mm | 1524 x 2500 mm | 1250 x 2500 mm | 1524 x 2500 mm |
| TABLE TYPE CAPACITIES | | | | |
| Brush Table (3) | Up to 150 kg | Up to 150 kg | Up to 150 kg | Up to 150 kg |
| Combo Ball/Brush (3) | Up to 150 kg | Up to 150 kg | N.A. | N.A. |
| Fully Programmable Work Chute (X,Y) | 450 x 500 mm | 450 x 500 mm | 450 x 500 mm | 450 x 500 mm |
| Clamps | 3 CNC relocatable Part pull out sensing standard | 3 CNC relocatable Part pull out sensing standard | 3 CNC relocatable Part pull out sensing standard | 3 CNC relocatable Part pull out sensing standard |
| Maximum Clamp Spread | 2300 mm | 2300 mm | 2100 mm | 2100 mm |
| TURRETS | | | | |
| Turret Configuration | 48 Stations | 48 Stations | 48 Stations | 48 Stations |
| Turret Layout (all models) | 24 - 12,7 mm A Size / 16 - 31,7 mm B Size / 4 - 50,8 mm C Size / 4 - 88,9 mm D Size | | | |
| Auto-Index Stations | 4 - 88,9 mm D Size | 4 - 88,9 mm D Size | 4 - 88,9 mm D Size | 4 - 88,9 mm D Size |
| Angular Positioning Accuracy | ± 0,05 degrees | ± 0,05 degrees | ± 0,05 degrees | ± 0,05 degrees |
| Axes Traverse Speeds | Up to 128 m/minute combined | Up to 128 m/minute combined | Up to 161 m/minute combined | Up to 161 m/minute combined |
| ELECTRICAL POWER CONSUMPTION | | | | |
| Average Power Consumption, approx. | 6,7 kW | 6,7 kW | 6,7 kW | 6,7 kW |
| Standby Operation, approx. | 0,9 kW | 0,9 kW | 0,9 kW | 0,9 kW |

(1) Material thickness + tip recess + die penetration

(2) Larger workpiece sizes handled with clamp reposition

(3) at a reduced feed rate

HEADQUARTERS

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JOINT VENTURES

LVD-HD

Huangshi City,
Hubei Province, China

SUBSIDIARIES*

LVD BeNeLux nv

Gullegem, Belgium

LVD do Brasil Ltda.

Joinville, Brazil

LVD GmbH

Lahr, Germany

LVD Italia s.r.l.

Parma, Italy

LVD Korea

Inchon City, Korea

LVD Malaysia Sdn Bhd

Shah Alam, Malaysia

LVD Polska Sp. z o.o.

Kedzierzyn-Kozle, Poland

LVD Pullmax Limited

Oxfordshire, United Kingdom

LVD S2/S3

Tornala, Slovakia

LVD s.a.

Raismes, France

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Bangkok, Thailand

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Bangalore, India

P.T. LVD Center

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