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Commercial and technical offer for High-speed Blanking Line TSS 315/400

The production line is assigned to further processing of thin sheets supplied in coils, especially for cutting out stator, rotor and transformer sheets in transfer tool. Besides the lines are suitable for production of a variety of sheet-based components required in electrotechnic, radiotechnic and telecom industries. The line is also convenient in the production of measuring devices and watches components. A possible usage is also for punching, cutting and for shallow drawing.

The line consist of :

1. Eccentric press TK 315/400
 2. Feeding device QPPV 400
 3. Straightening device QRPV 400
 4. Unreeling device QODP 400
 5. Scrapping scissors QSMN 400
- see the schema of line TSS 315/400

Technical parameters of line:

1. Press TK 315/400

- Nominal shaping force3150 kN
- No. of strokes – n of the ram (continuously adjustable)75 – 275 1/min
- ram punch plate (WxL)1800 x 900 mm
- centring hole in the ram axis \varnothing 65 X7 mm
- longitudinal slot in the ram axis50 X7 x 8 mm
- stroke of the ram – fixed35 mm
- rearrangeability of the ram100 mm
- number of traverses.....6 pcs
- total ejector force320 kN
- constriction450 mm
- table thickness200 mm
- work plane span over the table150 – 200 mm
- table working surface /Wx L/.....1900 x 1200 mm
- weir opening in the table /WxL/.....1660 x 410 mm
- master drive output55 kW
- press weight.....52.000 kg

2. Feeding device QPPV 400

- sheet metal width, max400 + 2 mm
- sheet metall thickness0,5 – 0,65 mm
- feeding rate..... 50 m/min
- accuracy of the feseding rate \pm 0,05 mm



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3. Straightening device QRPV 400

- sheet metal width400 + 2 mm
- sheet metall thickness0,65 mm
- feed speed - continuously adjustable0,1 – 60m/min

4. Unreeling device QODP 400

- sheet metal width, max400 + 2 mm
- outside diameter of the coil, max.....1500 mm
- coil weighth, max3000 kg
- clamp diameter of the arbor480 – 630 kg
- device weight, circa2000 kg
- input power of the microabor drive.....1,5 kW

5. Scrapping scissors QSMN 400

- sheet metal width, max400 + 2 mm
- sheet metall thickness0,65 mm