



VAPRESS

BY VAPTECH

Metal Packing

Automatic production lines and solutions for metal packing industries



VAPTECH

Make what the Planet Needs!

Celebrating
100th
ANNIVERSARY
*in industrial engineering
and manufacturing*



- ⦿ Solid welded steel structure of the press frame, heat treated, sand blasted and painted
- ⦿ Eccentric shaft made of forged steel alloy:
 - Roller bearings between the eccentric shaft and the press frame
 - Roller bearings between the connecting rod and the eccentric shaft
- ⦿ Connecting rod with pivot bolt, allowing slide position adjustment
- ⦿ Cast iron flywheel, providing the necessary energy for all kind of cold-press operations, such as cutting, stamping, punching, etc



- ⦿ Clutch-brake unit with pneumatic control and quick exhaust valve for minimum stop time of the press
- ⦿ Direct flywheel drive
- ⦿ Slide with rail linear guides, providing high precision and accuracy:
 - 8 rails attached to the press frame, individually adjustable.
 - Equipped with oil collection slots which return the used oil into the lubrication system.
 - Manual slide height adjustment



- ⦿ Balancing cylinders of the slide, guaranteeing smooth operation of the press
 - Cylinders mounted inside the press frame
 - Flexible coupling between the cylinders and the slide providing self-adjustment
- ⦿ Bolster plate designed to the requirements of the customer



- ⦿ Individual air tanks for the balancing cylinders and the clutch brake unit
- ⦿ Hydraulic overload safety device with completely automatic discharge, providing immediate stop of the press in case of overload is available as an option
- ⦿ Press force measurement with tension sensors installed on the press frame
- ⦿ Centralized automatic lubrication, providing oil to all necessary points like bearings, slide guides and pivot bolt
 - Oil recirculation
 - Inline oil filter with electrical indicator
 - Oil level indication
 - Oil pressure indication
 - Oil temperature monitoring
 - Lubrication of every point via progressive distributor, providing individual feedback

Electronic control panel with check control, completed with EU produced components:

- PLC controller SIEMENS for the main functionality of the presses
- Safety controller PILZ
- Electronic resolver with 3600 signals per revolution, monitoring the angle of the eccentric shaft
- Counters:
 - Infinite stroke counter without Reset;
 - Infinite counter for work hours without;
 - Individual stroke counters with password protected reset;
- Photocell barrier guard:
- “Two hands” control unit for operation of the press in single stroke mode or automatic stroke mode
- Pedal for operation of the press in single stroke mode or automatic stroke mode
- Frequency control of the motor via inverter, providing speed variation
- Touch screen, visualizing general information regarding the current operation



Automatic sheet aligning and loading

Maximum sheet size 1200 x 1200 mm

Aluminium and steel sheets

Sheet thickness from 0.15 to 0.4 mm

Two axis feeding system with AC servo motors with zero clearance ball screw drive or linear drive

Pneumatic ejectors for the manufactured components

Automatic sheet lubrication available as an option



TECHNICAL CHARACTERISTICS		PE30MO	PE45MO	PE63MO	PE80MO	PE100MO
Nominal press force	kN	300	450	630	800	1000
Stroke length	mm	100	120	120	150	150
Slide height adjustment	mm	50	50	50	50	50
Max width between columns	mm	2100	2100	2100	2100	2100
Distance bolster plate-slide*	mm	550	570	570	600	600
Table dimensions	mm	1400x400	1400x400	1400x450	1400x500	1400x520
Slide dimensions	mm	800x400	800x400	880x450	800x500	800x520
Work height of the table	mm	750	750	750	750	750
Speed (strokes per minute)	min ⁻¹	60÷200	60÷200	80÷200	100÷200	100÷200



Automated press line based on 315 tons mechanical H-frame press • Berevoesti, Romania



Automated press line based on 315 tons hydraulic H-frame press • Tosno, Russia



Automated press line based on 315 tons mechanical H-frame press • Tolyatti, Russia



Automated press line based on 630 tons mechanical H-frame press • Erfurt, Germany



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