

**BSTA 1250**

**BRUDERER+**

PRECISION – SWISS MADE

**Precision strength  
for major tasks.**





# Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

## The advantages of the BSTA 1250 at a glance.

### **Adjustable stroke with mass balancing system together with latest control technology:**

- for a multitude of applications
- for a wide variety of stroke heights

### **Thermoneutral ram-guiding system with tilting point control at strip level:**

- for long tool life
- for optimum part quality

### **Ram adjustment during operation under production conditions:**

- for an optimized tool set-up

### **Powerful clutch and brake unit**

- for improved first and last strikes and therefore reduced waste

### **Micro-tolerances maintained in the bottom dead center (BDC):**

- for increased process stability

### **Precision engineering and the unique BRUDERER drive and lever system:**

- for improved reliability and durability across the whole mechanical system

### **Integrated measuring and monitoring function:**

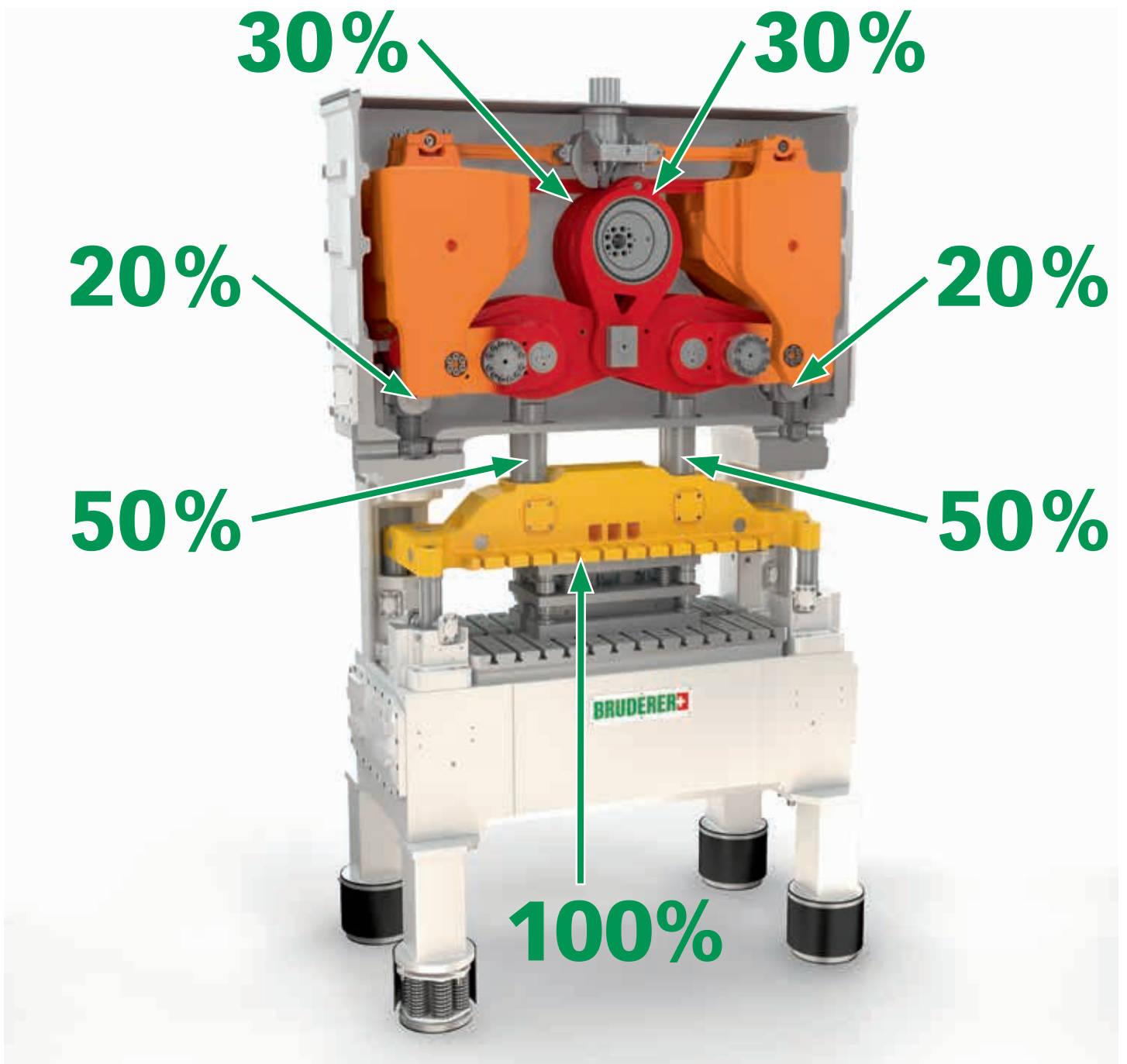
- improved process optimisation by means of simple control system usability

### **Easy attachment of peripheral devices:**

- for quicker integration and maximum productivity

# Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



# Making sure you can produce quicker, for longer and with more precision.

## Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

## Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

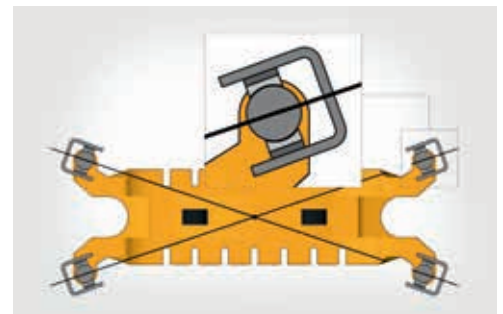
## More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

# Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



# Technical data

## BSTA 1250.

			BSTA 1250-117	BSTA 1250-151	BSTA 1250-181
Press force		kN	1250	1250	1250
Tool loading area	L - R	mm	1170	1510	1810
Speed	Min.	spm	100	100	100
	Max.	spm	850	850	850
Mains voltage (EN 60204) <sup>A)</sup>		V	400	400	400
Mains frequency (EN 60204) <sup>A)</sup>		Hz	50/60	50/60	50/60
Connected load <sup>B)</sup>	Max.	kVA	105	105	105
Control voltage		VDC	24	24	24
Drive power of main motor		kW	37	37	37
Compressed air connection R 1/2"	Min.	bar	7	7	7
	Max.	bar	10	10	10
Adjustable stroke (standard)		mm	16/19/26/35/43/	16/19/26/35/43/	16/19/26/35/43/
		mm	51/58/64/70/75	51/58/64/70/75	51/58/64/70/75
Adjustable stroke (option)		mm	19/26/40/55/68/	19/26/40/55/68/	19/26/40/55/68/
		mm	80/90/96/100	80/90/96/100	80/90/96/100
Fixed stroke <sup>A)</sup>	Max.	mm	100	100	100
Ram adjustment range		mm	89	89	89
Shut height <sup>A)</sup> (according to stroke)	Min.	mm	268	268	268
	Max.	mm	386,5	386,5	386,5
Bolster area	L - R	mm	1150	1490	1790
	F - B	mm	1070	1070	1070
	Height <sup>C)</sup>	mm	1245	1270	1270
Ram area	L - R	mm	1060	1400	1700
	F - B	mm	600	600	600
Strip inlet height <sup>A)</sup>	Min.	mm	80	80	80
	Max.	mm	180	180	180
Strip inlet width (machine)	Max.	mm	440	440	440
Base plate opening	L - R	mm	1120	1460	1760
	F - B	mm	350	350	350
<b>Dimensions</b>					
Press (standard BBV)	L - R	mm	2970	3246	3469
- With semi-automatic stroke adjustment	F - B	mm	1818	1818	1818
	Height	mm	4015	4040	4040
	Weight (app.)	kg	25550	27950	29750
- With automatic stroke adjustment	F - B	mm	1887	1887	1887
	Height	mm	4146	4171	4171
	Weight (app.)	kg	25650	28050	29850
<b>Strip feed unit</b>					
	Standard Variations	BBV 260 BBV 450 BBV 455 BSV 300 BSV 500			

<sup>A)</sup> Options on request. <sup>B)</sup> Incl. standard sockets for peripheral equipment. <sup>C)</sup> Above floor level.  
Subject to change.

## Competence centres:

### BRUDERER GMBH

Kieferstrasse 28, D - 44225 Dortmund  
☎ +49 231 79 20 22-0, 📠 +49 231 71 91 53  
info.de@bruderer.com

### BRUDERER MACHINERY INC.

1200 Hendricks Causeway, Ridgefield, NJ 07657, USA  
☎ +1 201 941 2121, 📠 +1 201 886 2010  
info@brudereramericas.com

### BRUDERER MACHINERY (SUZHOU) CO., LTD.

No. 485 Suhong Middle Road, Suzhou Industrial Park  
Jiangsu Province, P.R. China 215027  
☎ +86 512 6258 8292, 📠 +86 512 6258 8293  
info.cn@bruderer.com

### BRUDERER PRESSES (FAR EAST) PTE LTD.

65 Loyang Way, Singapore 508755  
☎ +65 6546 8121, 📠 +65 6546 8131  
info.sg@bruderer.com

### BRUDERER PRESSES K.K.

Yakou 2306-2, Sakae-Machi, Inba-Gun, Chiba-Ken Japan 270-1502  
☎ +81 476 801 788, 📠 +81 476 851 277  
info.jp@bruderer.com

### BRUDERER UK LTD.

Cradock Road, GB-Luton, Bedfordshire LU4 0JF  
☎ +44 1582 56 03 00, 📠 +44 1582 57 06 11  
info.uk@bruderer.com

## Sales and service:

### BRUDERER (DONGGUAN) MACHINERY CO., LTD.

Unit E1-22, Changrong International Machinery  
Hardware Business Mansion  
ZhenAn Avenue WuSha Road, ChangAn Town  
Dongguan City, P.R. China 523859  
☎ +86 769 8188 8180, 📠 +86 769 8188 7797  
info.bdg@bruderer.com

### BRUDERER IBERICA, S.L.

Pol. Ind. Magarola Sud, C/. Cerámica 5 - Nave B-1  
E-08292 Esparraguera (Barcelona)  
☎ +34 93 770 84 60, 📠 +34 93 779 51 15  
info.es@bruderer.com

### BRUDERER PRESSES FRANCE S.A.R.L.

Z.I. du Petit Parc, F - 78920 Ecquevilly  
☎ +33 1 34 75 00 40, 📠 +33 1 34 75 52 36  
info.fr@bruderer.com

### BRUDERER PRESSES INDIA PVT LTD.

2, Chandragupta Estate, Ground Floor, Andheri Link Road  
Near Monginis Andheri West, Mumbai 400 053, India  
☎ +91 22 6695 1945/46, 📠 +91 22 6695 1948  
info.in@bruderer.com

## Distribution Partners:

See [www.brunderer.com](http://www.brunderer.com)

### BRUDERER AG

Egnacherstrasse 44, CH-9320 Frasnacht, Switzerland  
☎ +41 71 447 75 00, 📠 +41 71 447 77 80

For more information about BRUDERER and our products,  
services and subsidiaries, visit [www.brunderer.com](http://www.brunderer.com)

**BRUDERER** 

PRECISION – SWISS MADE