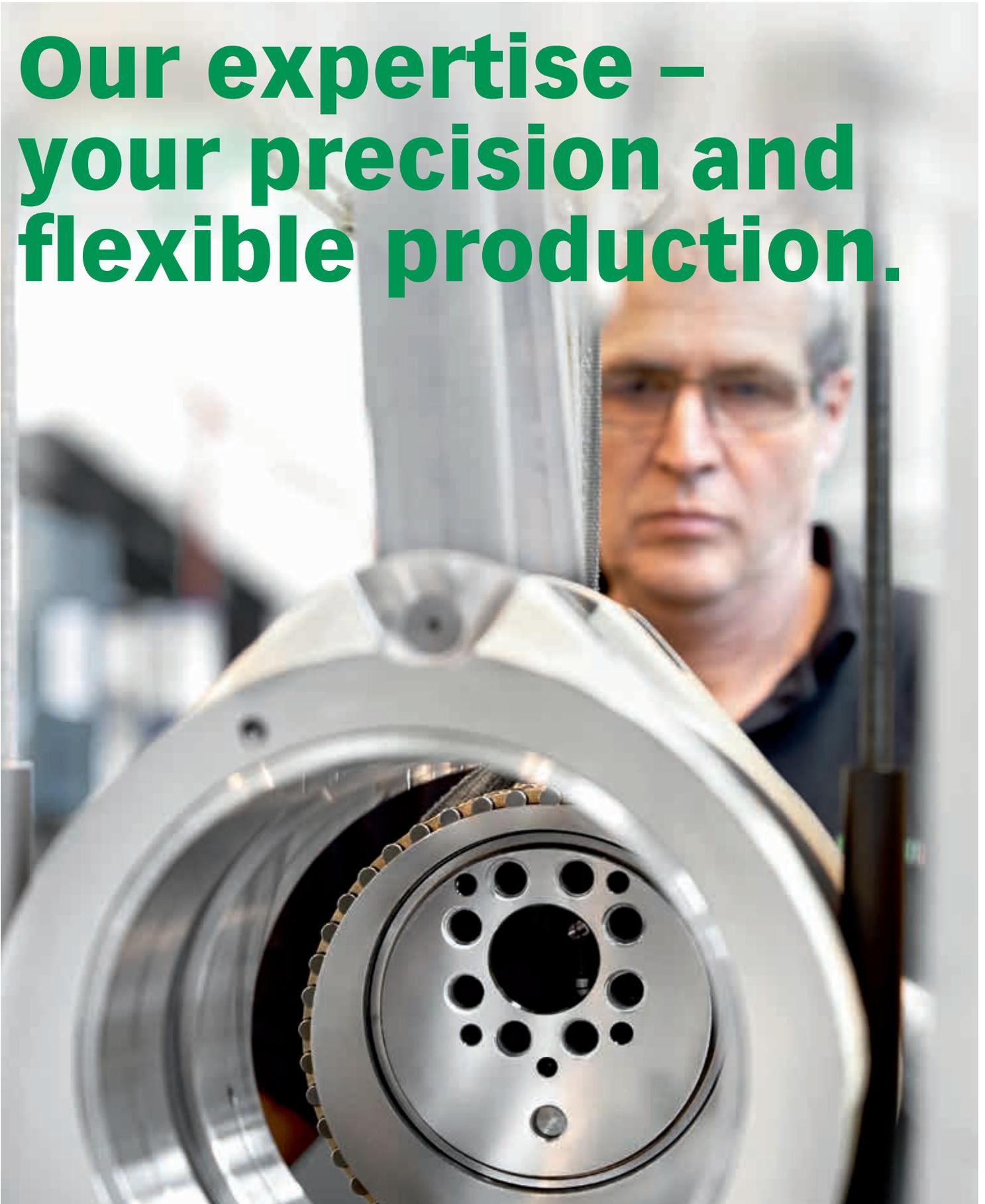


BSTA 510

BRUDERER+

PRECISION – SWISS MADE

**Our expertise –
your precision and
flexible production.**





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 510 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:

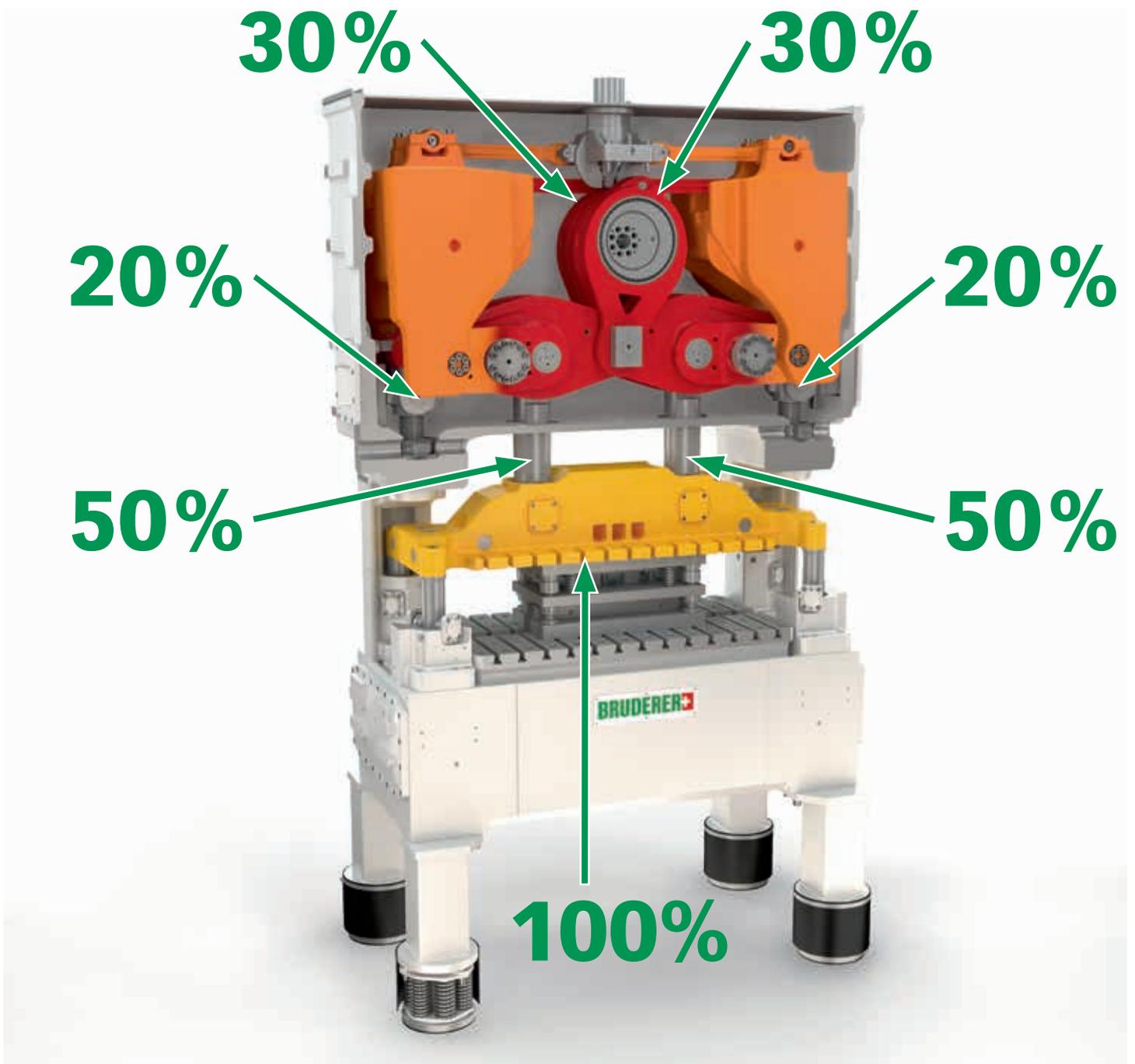
- improved process optimisation by means of simple control system usability

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.

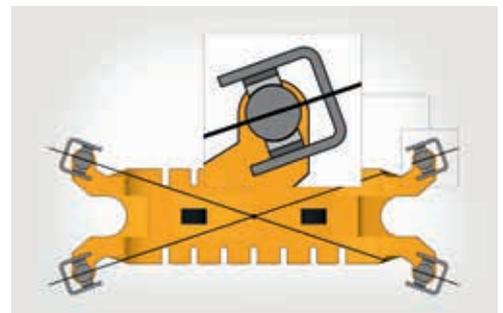
More flexibility thanks to the right setting.

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.



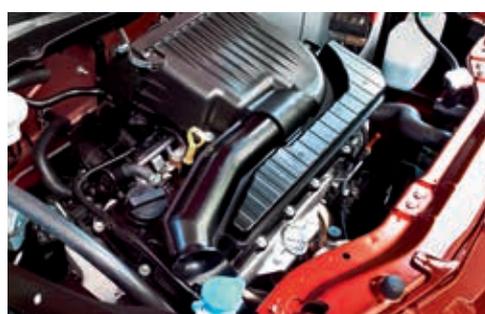
Quicker stroke change for more flexibility.

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 510.

			BSTA 510-95	BSTA 510-110	BSTA 510-125	BSTA 510-150
Press force		kN	510	510	510	510
Tool loading area	L - R	mm	950	1100	1250	1500
Speed	Min.	spm	100	100	100	100
	Max.	spm	1120	1120	1050	1050
Mains voltage (EN 60204) ^{A)}		V	400	400	400	400
Mains frequency (EN 60204) ^{A)}		Hz	50/60	50/60	50/60	50/60
Connected load ^{B)}	Max.	kVA	80	80	80	80
Control voltage		VDC	24	24	24	24
Drive power of main motor		kW	22	22	22	22
Compressed air connection R 1/2"	Min.	bar	7	7	7	7
	Max.	bar	10	10	10	10
Adjustable stroke (standard)		mm	16 / 19 / 25 / 32 /	16 / 19 / 25 / 32 /	16 / 19 / 25 / 32 /	16 / 19 / 25 / 32 /
		mm	38 / 44 / 51	38 / 44 / 51	38 / 44 / 51	38 / 44 / 51
Adjustable stroke (option)		mm	19 / 25 / 34 / 43 /	19 / 25 / 34 / 43 /	19 / 25 / 34 / 43 /	19 / 25 / 34 / 43 /
		mm	51 / 57 / 64	51 / 57 / 64	51 / 57 / 64	51 / 57 / 64
Fixed stroke ^{A)}	Max.	mm	64	64	64	64
Ram adjustment		mm	64	64	64	64
Shut height ^{A)} (according to stroke)	Min.	mm	206	206	206	206
	Max.	mm	294	294	294	294
Bolster area	L - R	mm	940	1080	1240	1490
	F - B	mm	650	650	650	650
	Height ^{C)}	mm	1221	1266	1266	1250
Ram area	L - R	mm	830	980	1160	1390
	F - B	mm	420	420	420	420
Strip inlet height ^{A)}	Min.	mm	60	60	60	60
	Max.	mm	140	140	140	140
Strip inlet width (machine)	Max.	mm	250	250	250	250
Base plate opening	L - R	mm	910	1060	1210	1410
	F - B	mm	200	200	200	200
Connectible BPG22 planetary gearbox	Optional		yes	yes	yes	yes
Dimensions						
Press (standard BBV)	L - R	mm	2366	2366	2670	2670
- With semi-automatic stroke adjustment	F - B	mm	1299	1299	1299	1299
	Height	mm	3120	3165	3230	3214
	Weight (app.)	kg	8160	8760	10050	10800
- With automatic stroke adjustment	F - B	mm	1393	1393	1393	1393
	Height	mm	3272	3317	3382	3366
	Weight (app.)	kg	8260	8860	10150	10900
Strip feed unit						
	Standard Variations	BBV 180 BBV 260 BSV 75 BSV 170 BSV 300 BZV 61				

^{A)} Options on request. ^{B)} Incl. standard sockets for peripheral equipment. ^{C)} Above floor level.
Subject to change.

Competence centres:

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