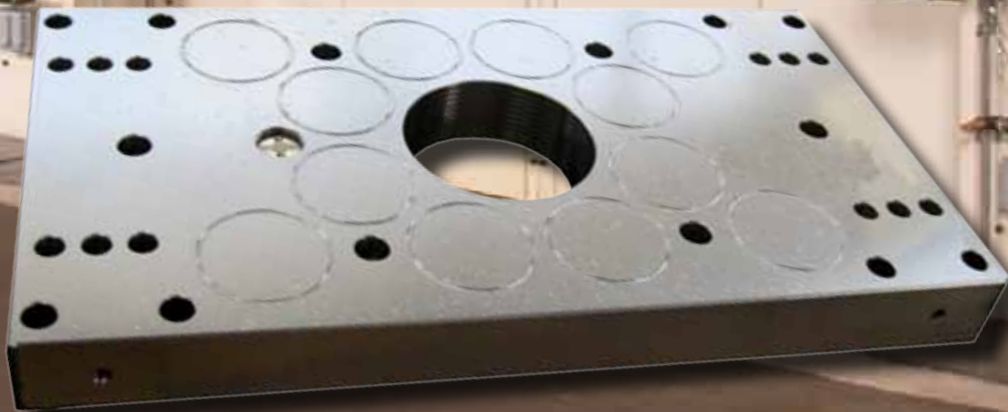


**Magnetic system
for quick die clamping
on metal presses**

**Lemmezalakító préseken
mágneses gyors
szerszámrögzítő rendszer**

StampTec



- **Easy in use** **Egyszerű használat**
- **Quick & safe clamping** **Gyors és biztonságos rögzítés**
- **Suitable for dies of any size** **Minden szerszámmérethez megfelelő**

A quick die clamping system changes the entire production process allowing for lean production and small batches.

StampTEC is in the heart of this change with no hidden time to fix clamps, make adjustments or test between 2 production batches.



TECNOMAGNETE®
Safety through power

Easily adaptable on all presses

Composed by 2 magnetic modules, it's easy to install and integrate into the existing machine and controls.

Its modularity allows adaptability for any need.

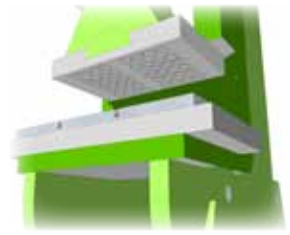
No modification to the press is required.

StampTEC is made to fit your press.

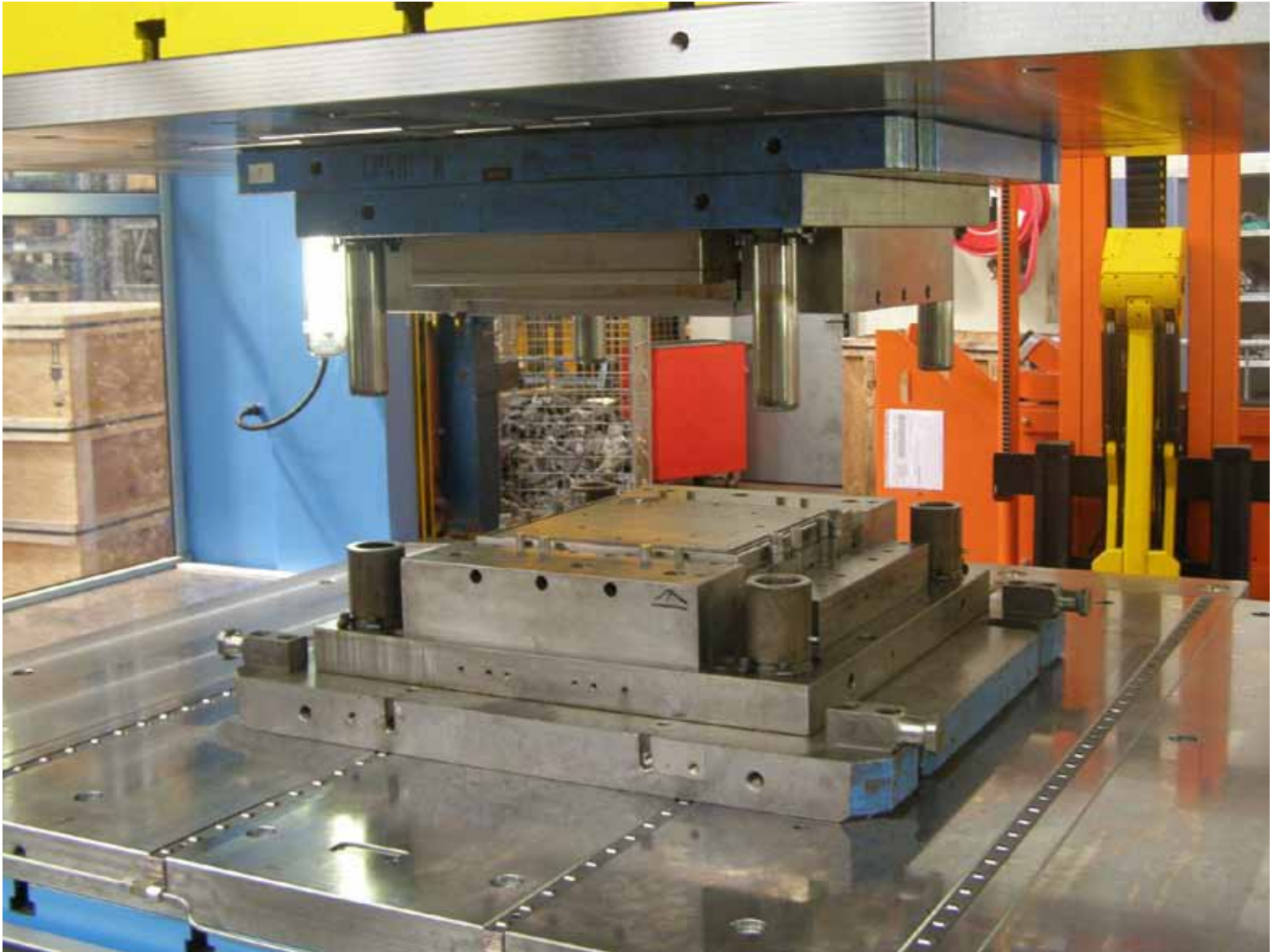
The new reduced thickness of the modules allows to save daylight.



Lower platen



Upper platen



No die modifications

StampTEC is suitable for dies of any shape and size, with no modification.

Die standardization is not necessary: savings in engineering time and overall cost.

If the die is not magnetic or when the contact surface die/magnet is too small, the die can be equipped with a common steel backplate.

The die face and part are not magnetized, allowing scrap removal without interference.

Even during a power failure, the system remains operative with constant clamping force.



User friendly

One operator, with no tools, can operate all the die-clamping procedure easily and in total safety, outside the press.



Load the die



close the press



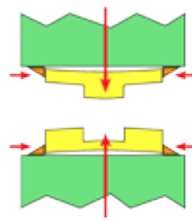
push the button for the upper, then the lower



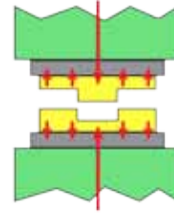
open the press... ready!

Uniform Clamping

This uniform clamping force allows repeatability and constant quality of the stamping process by eliminating any flexing of die shoe.



Traditional clamping



Clamping with StampTEC

Completely customizable

Reference pins can be added to speed-up the positioning of the die.
 The lower magnet can have a through hole for scrap removal.
 The system is prearranged for "U" slots for the insertion of rollers on the machine platen.
 Magnets can be made of different thickness to accommodate shut height issues.

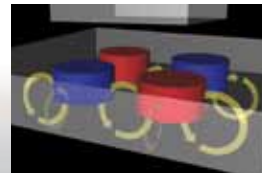


Exclusive technology

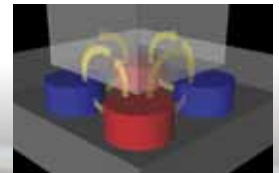
Firstly applied on machine tools, then for the handling of ferrous loads and to clamp molds in IMMs, the Quadsystem technology is now available for metal stamping presses.

The patented double magnet circuit Quadsystem is composed of poles in chessboard configuration machined into a solid block of steel. Each pole generates a constant, uniform and predefined force, proportional to the number of poles in contact with the die surface.

The Quadsystem technology is not affected by electrical breakdowns; the die stay in position even without power supply, with the same strength indefinitely.



MAG phase



DEMAG phase



An impenetrable shield

The Quadsystem MONOLITE technology allows to create magnetic modules with full-metallic clamping surface, without any sealing resin and any filling part. This surface acts as a mechanical shield, impossible to penetrate, to achieve maximum durability without maintenance.

Control unit

The control interface is small and easy to install.

StampTEC is available in 2 versions:

- StampTEC EASY, for dies with a Max weight of 1800kg, equipped with simplified electronic control unit ST110P
- StampTEC ST, for any size of dies, equipped with ST400 control unit.



ST110P

“Error-proof” system

A set of electronic safety systems are provided to supervise all the operations and in case of failure stop the press.

Both control units present several safety devices to avoid accidental MAG or DEMAG:

- The buttons must be activated simultaneously (SAFE function).
- The interlock key to prevent MAG / DEMAG by unauthorized personnel.
 - Bottom dead center channel enable.
 - UCS current detecting system
 - FCS system for magnetic flux detection
 - Proximity sensors to check die presence and its correct positioning on magnet



ST400 - Pushbuttons



IPC Control

On request StampTEC ST can be supplied with IPC Interactive Power Control push-button.

Through a touch-screen it is possible to control all the system functions and display the actual force generated by the magnet on each different die.

Technical characteristics

	StampTEC Model	
	EASY	ST
Magnetic force on the polar area	up to 16 kg/cm ²	up to 16 kg/cm ²
Magnetic force on the die contact area	up to 90 tons/m ²	up to 90 tons/m ²
Upper module thickness	47mm	47mm
Lower module thickness	47mm	47mm
“U” rollers prearrangement on lower module	standard	standard
Central hole for scrap removal on lower module	standard	standard
Clamping holes	standard	standard
Control Unit type	ST110P	ST400
UCS current detecting system	standard	standard
Voltage	230V / 50-60 Hz	200-480V / 50-60 Hz
FCS flux detection system	-	standard
Digital push-button for MAG/DEMAG cycles	built-in	remote
Machine enable	standard	standard
IPC - touch screen control	-	on request
Additional enable key DCM (Die Change Mode)	standard	standard
Control unit-modules connection, interface and power supply cables	standard	standard
Proximity sensors (1 each module)	standard	standard
Set of fixing bolts	standard	standard
Instruction book and CE certification	standard	standard

With StampTEC is easy to achieve the maximum efficiency and a quick return on investment.

Tecnomagnete’s commercial network and our experience are at your disposal for any comparison in terms of convenience and efficiency.

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