

## Technical Data

### Working area

Multipunch 1000 x 2000 mm	1060 x 2080 mm
Multipunch 1250 x 2500 mm	1310 x 2580 mm
Multipunch 1500 x 3000 mm	1560 x 3080 mm

### Performance

Max. sheet thickness	Choose Material Clamps for either 7 mm (¼") or 12.7 mm (½")
Max. sheet length	Revoltool: 4 mm (5/32")
Max. hydraulic punching power	9999 mm by repositioning
Max. workpiece weight	280 kN 200 kg

### Speeds

Max. positioning speed X- axes	60 m/min
Max. positioning speed Y- axes	60 m/min
simultaneous X & Y	85 m/min
Max. strokes standard hydraulic	250 strokes/min
Max. strokes fast hydraulic	800 strokes/min

### Tooling

Trumpf® tooling system

Max. punching diameter	70 mm or any shape within 70 mm
Revoltool	4 / 6 / 8 stations, Shapes fitting within 25 / 20 / 16 mm diameter
Time of tool changing	1-5 sec.

### Axes accuracy during punching process

Positioning difference	+ - 0,10 mm
Repeatability	+ - 0,03 mm

### Space requirement and weights <sup>1</sup>

Multipunch 1000 x 2000 weight	6100 x 5338 x 2100 mm 12500 kg
Multipunch 1250 x 2500 weight	7000 x 5963 x 2100 mm 14000 kg
Multipunch 1500 x 3000 weight	8060 x 6588 x 2100 mm 15800 kg

### Electrical Values

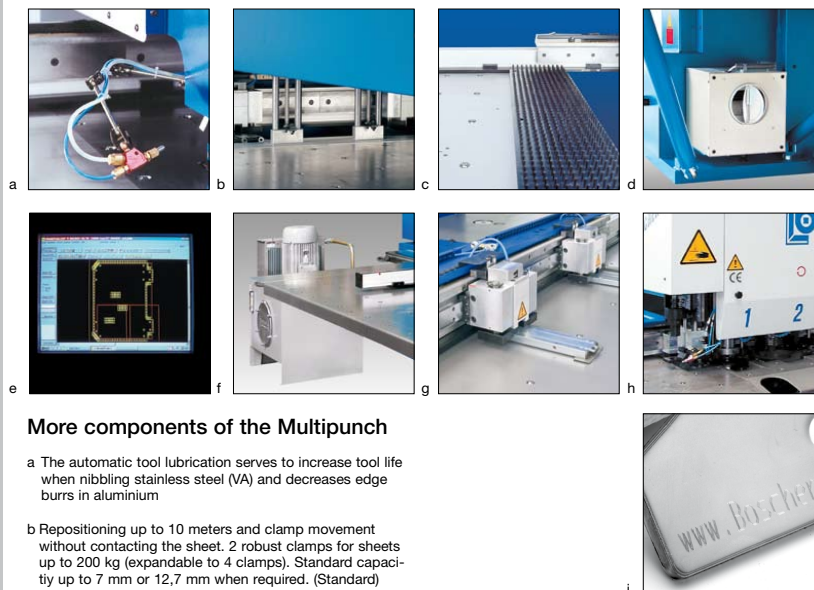
standard hydr./fast hydr.

Electrical connecting value	20 / 25 kVA
Hydraulic motor	4,8 / 11 kW
Electrical consumption 2 mm sheet thickness continuous operation	4,9 / 7,7 kW/h
Electrical consumption 4 mm sheet thickness continuous operation	5,4 / 8,75 kW/h
Required fuse	3 x 25 A / 3 x 35 A
Pneumatic connecting value	min. 4 bar
Hydraulic oil	115 / 160 litre

<sup>1</sup> The exact values can be found in each specific installation plan

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## More components of the Multipunch

a The automatic tool lubrication serves to increase tool life when nibbling stainless steel (VA) and decreases edge burrs in aluminium

b Repositioning up to 10 meters and clamp movement without contacting the sheet. 2 robust clamps for sheets up to 200 kg (expandable to 4 clamps). Standard capacity up to 7 mm or 12,7 mm when required. (Standard)

c Sandblasted, corrosion resistant surface as standard. Balls in the table for heavier sheets and easy handling, brushes in the table for thin or scratch sensitive sheets are also available.

d Vacuum slug removal

e CNC/CAD software to import DXF-files into machine language, calculated punch time, graphic simulation

f Nibbling up to 800 strokes / min with integrated oil cooling

g Programmable repositioning of the clamps for faster set up of the machine. (Standard)

h Tapping and drilling attachment for threads M3 up to M12 and smaller drilled holes in thicker sheets.

i Marking apparatus for marking parts in 10 different fonts.



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## MULTIPUNCH

Punching  
Nibbling  
Forming  
Marking  
Tapping



*simply better!*

## Boschert Multipunch Auto Tool Change

The Multipunch tool carousel is mounted at the front of the machine, below table level. The vertical and horizontal axis movements are controlled by ball screws with linear ball guides using double carriages. The rotary axis positions the eight cassettes with a rack and pinion drive. The Multipunch uses Trumpf style tools up to size II (3") and Boschert Revotools. It is possible to have up to 64 individual tools, all fully indexable, in the machine.



With more than 60 years experience we can guarantee the Boschert quality users worldwide have come to expect.

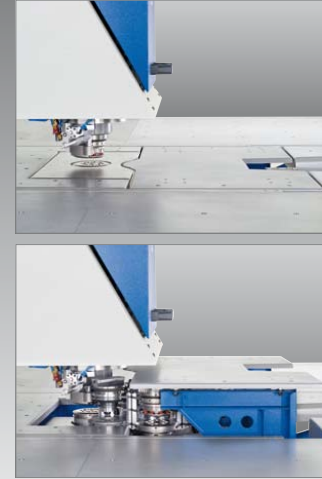
## Rotation Index

360 degree stepless rotation of all tools, including Revotools. Maximum diameter of tools is 76.2 mm (3"). Driven by two brushless DC servo motors. The Revotools are changed by a pneumatic cylinder.



8 station tool carousel with cassettes that hold punch, die and stripper or Revotool head with 4, 6 or 8 tools.

## Tool Changer

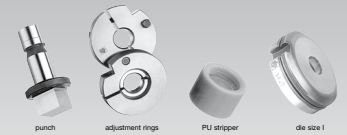


The Multipunch changes tools in 3-5 seconds. Revotools within the same cartridge are changed in less than 3 seconds.

## Tooling



Quick change tool cassettes hold the punch, die and stripper and are set off-line so as not to limit machine run time.



### Trumpf® standard tooling

- easy handling
- low cost
- long tool life
- long regrind length



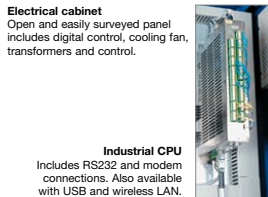
**Frame**  
Solid welded steel construction guarantees the highest stability for punching sheets up to 12,7 mm thickness.



**Robust construction**  
Widely spaced ball screw and linear guides guarantee positioning accuracy and repeatability.



**Electrical cabinet**  
Open and easily surveyed panel includes digital control, cooling fan, transformers and control.



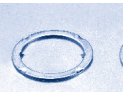
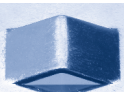
**Industrial CPU**  
Includes RS232 and modem connections. Also available with USB and wireless LAN.



**Control panel**  
10.5" TFT colour screen, ergonomically designed, it is adjustable and mounted on casters. USB, dual palm buttons, tool change position button, emergency-off. The powerful graphic and conversational software guarantees simple and fast programming. It is also available in a PC version.



The programmable small parts chute measures 200 mm x 300 mm. The movement of the chute is controlled by a pneumatic cylinder.



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