

# AMADA VIPROS 255 CNC TURRET PUNCH PRESS

## 31 STATION TURRET WITH 3 AUTO INDEXING UNITS

### MACHINE SPECIFICATION

Model	...	Vipros 20-50-50
Frame Construction	...	Bridge Type
Press Capacity	...	20 Tonnes (196kN)
Press Type	...	Servo Controlled Hydraulic
Ram		
Axis Traverse Distance	...	1270 mm x 1270 mm
Workable Max. Sheet Size (with auto repositioning)	...	1270 mm x 2540 mm
Maximum Material Thickness	...	6.35 mm Mild Steel
Max. Material Weight	...	105 Kg
Max. Material Weight (Max Speed)	...	62 Kg
Max. Hole Dia.	...	88.9 mm
Number Of Stations	...	31 Stations: 19 x 12.7 mm 6 x 31.7 mm 1 x 50.8 mm 2 x 88.9 mm Auto Index 2 x 31.7 mm 1 x 50.8 mm
Axis Speed	...	82 m/min
Hits Per Minute (2mm Pitch)	...	1000 H.P.M./2.5mm Stroke (Vipros Tool)
(25.4mm Pitch)	...	340 H.P.M./8mm Stroke
Turret Speed Bi-Directional	...	35 R.P.M.
Punching Accuracy	...	± 0.07 mm
Punching Accuracy (High Accuracy Mode) ...	...	± 0.05 mm
Repeatability	...	± 0.015 mm
Ram Stroke Length (Maximum)	...	40 mm
Tool Lubrication	...	Air Blow System
Axis Drive	...	AC Servo Motor
Turret Drive	...	AC Servo Motor
Electric Power Required	...	22 kVA 400V +/- 10% 50 Hz
Air Pressure Required	...	5.0 kgf/cm <sup>2</sup>
Air Flow	...	250 l/min
Machine Length	...	5030 mm
Machine Width	...	2630 mm
Machine Height	...	2160 mm
Machine Weight	...	9200 kg

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### NC SPECIFICATION

Model of NC	...	FANUC 18-P
Axis	...	3 Axis Simultaneous + PHNC
Tape Code	...	EIA or ISO (Automatic Recognition)
Programming Mode	...	Absolute/incremental
Min. Input	...	0.01 mm (0.01°)
Max. Input	...	999999.99 mm
Preparatory Function	...	G - 2 Digit
T Function	...	T - 3 Digit
M Function	...	M - 3 Digit
Single Block	...	Yes
Block Delete	...	Yes
Optional Stop	...	Yes
Editing	...	Yes
Manual Data Input	...	Yes
Memory Capacity	...	64 Kb
No. Of Programs	...	200
Machine Operation	...	Memory
Interface	...	RS 232 C

### PHNC SPECIFICATION

Minimum Input	...	0.01 mm
Processing Patterns	...	377: Punching 2 Nibbling 1 Forming 350 Marking 10 Knockouts 10 Slotting 4

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## **31 STATION TURRET WITH 3 AUTO INDEXING UNITS**

### **AUTO INDEX SPECIFICATION**

Auto index allows independent rotation of 31.7 mm and 50.8 mm punch and die.

No. Of Auto Index Stations	...	3
Size	...	31.7 mm - 2 Stations
	...	50.8 mm - 1 Station
Angular Movement	...	Increments Of 0.01°
Max. Material Thickness	...	6.35 mm Mild Steel
Tool Rotation Speed	...	60 R.P.M.