



# iPunch

CNC TURRET PUNCH PRESS





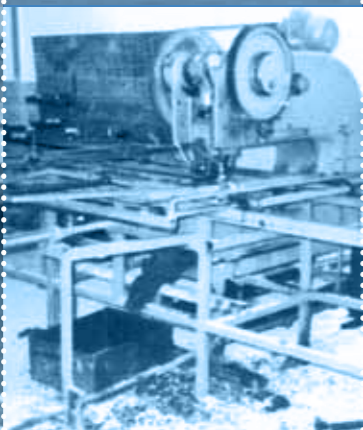
# 1950

MVD produced its first machine .



# 1971

The first sheet metal working machine “perforation press” was presented to the market.



# 1974

The production of “Heavy-duty Press Brakes and Guillotine Shears” started and MVD had the distinction of being the first Turkish manufacturer for heavy press brakes and shears.



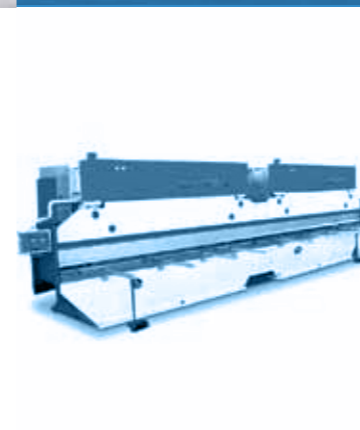
# 1981

Moved to second factory and added the production of 4 roll bending machines and Expanded Metal presses in the next years. Thus, a great variety of machines were presented in sheet metal working industry.



# 1994

MVD produced the first tandem press brake in Turkey.



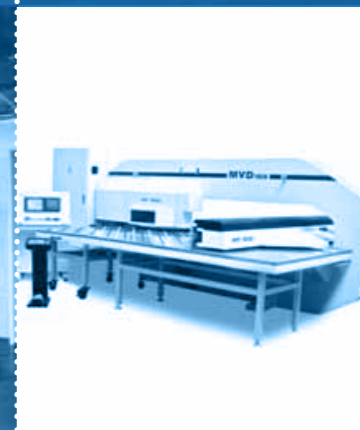
# 2001

Finalised the CE conformity procedures and had its machines CE marked.



# 2003

CNC Hydraulic Turret Punch machine was presented to the market.



# 2011

Plasma cutting machine and Fiber Laser Cutting machines were presented to the market.







## Quality High Technology

**Quality and service support is accepted as principle. Designing and manufacturing are based on reliability, durability and precision.**

Machines are easy to use and are built to be ready for user errors. Machines are designed and analyzed with 3-D supported computer aided programs, precisely machined in moving column CNC machining centres, equipped with world-known equipments and presented to the customers' use after quality control.





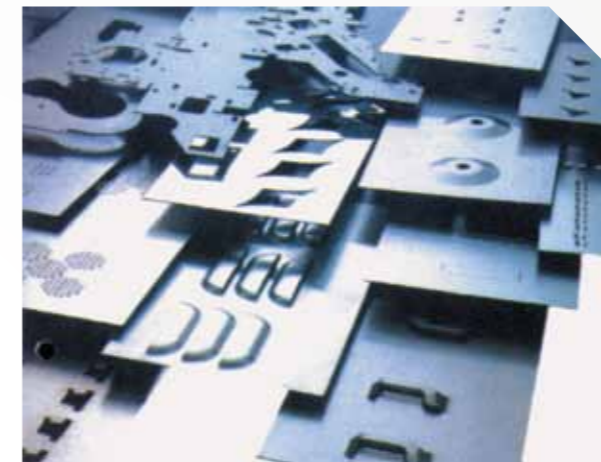
# iPunch

## CNC TURRET PUNCH PRESS



## General Features

- ▶ MVD Inan Turret Punch, presses are produced as a closed type rigid steel constructions in to a robust structure to allow minimum deflection during operation.
- ▶ Operating System is CNC and hydraulic.
- ▶ MVD Turret Punch 4 axes controlling; X, Y axes for movement of sheet, T axes: Turret rotation, C axis: Auto-index station rotation for indexing tools.
- ▶ 32 station Turret as to allow punching complicated, multi and different size holes parts in a single operation.
- ▶ Auto –index stations can punch to required angle for various angle shape parts with CNC controller.
- ▶ Precision forming and roller tools can be use on the Turret, therefore HTP Turret punch provides
- ▶ Complete solutions with effective costs.



## Design to Production;

- ▶ Metalix CNCCAD CAD/CAM software offers an integrated system cover to the user which includes the complete cycle of CNC operation.

## Punch Technology;

- ▶ Special Tool drawing
- ▶ Auto-index functions
- ▶ Auto clamp positioning
- ▶ Automatic Sheet Repositioning
- ▶ CNCCAD provides automatic or manual nesting for effective use of sheet metal
- ▶ Roller Tools usable
- ▶ Common cut function
- ▶ Ribbon cutting for splitting sheet
- ▶ Auto index reducing cycle time functions with rotations to nearest position
- ▶ Tools punch sequence selection
- ▶ Takım punch sırası seçimi





# iPunch Standard Equipments

- ▶ 4 Axes CNC System
- ▶ FANUC PC CNC unit, servo motors and drivers
- ▶ Rexroth and HL hydraulic unit
- ▶ 32 Stations Turret
  - 10 A Stations
  - 16 B Stations
  - 2 C Stations
  - 4 D Station (2 of them Auto Index)
- ▶ Repositioning of Clamps
- ▶ Automatic reference
- ▶ CAD/CAM program
- ▶ Automatic Clamping

# Optional Equipments

- ▶ Tool Adaptors
- ▶ Extra D index station
- ▶ Thin & Thick Turret Tools



## ▶ Technical Table

| iPunch series  | 30322-600   | 30322-900   |          |
|--|---|---|----------|
| Press Capacity   | 30  | 30  | ton      |
| max. Sheet Dimensions, Table size                              | 1250 x 4000   | 1250 x 5000   | mm       |
| X Axis Stroke  | 2000+Reposition   | 2500+Reposition   | mm       |
| Y Axis Stroke  | 1250  | 1250  | mm       |
| Maximum Sheet thickness (mildsteel)                            | 6,0   | 6,0   | mm       |
| Maximum Sheet Weight   | 160,0   | 160,0   | kg.      |
| Biggest tool hole diameter                                     | 88,9  | 88,9  | mm       |
| Turret options   | 32  | 32  | station  |
| Turret Stations Feature  | "10 A stations øMax:12,7 mm<br>16 B stations øMax:31,7mm<br>2 C stations øMax:50,8mm<br>4 D stations øMax:88,9mm" | "10 A stations øMax:12,7 mm<br>16 B stations øMax:31,7mm<br>2 C stations øMax:50,8mm<br>4 D stations øMax:88,9mm" | station  |
| Auto index   | 2 D stations ( 4 D optional)  | 2 D stations ( 4 D optional)  | station  |
| Table  | Brush and Roller  | Brush and Roller  | type     |
| Positioning accuracy   | ± 0,1   | ± 0,1   | mm       |
| Hits per minute  | 600   | 900   | hpm      |
| X, Y axial speeds  | 70  | 70  | m/min.   |
| X,Y axial vectorel speed                                       | 100   | 100   | m/min.   |
| Manual Clamp Quantity  | 3 Manual (auto clamp optional)  | 3 Manual (auto clamp optional)  | quantity |
| Turret Rotations per minute                                    | 30  | 30  | rpm      |
| Tool Change Time   | 2,5   | 2,5   | second   |
| Number of axis   | 4   | 4   | pcs.     |
| Control Unit   | FANUC   | FANUC   | type     |
| CAD/CAM  | Metalix   | Metalix   | type     |
| Oil Tank   | 200   | 200   | lt       |
| Main Motor   | 11  | 11  | kW       |
| Air pressure   | 0,85  | 0,85  | Mpa      |
| Overall dimensions (L x W x H)                                 | 5500x4500x2100  | 5500x5500x2100  | mm.      |
| Approx. Weight   | 15.000  | 15.500  | kg.      |
| Technical specifications are subject to change without notice. |   |   |          |

## ▶ iPunch





# EXPANDED METAL PRESS



“600-2500mm  
Width  
150-1000 rpm  
various size.”



## General Features

- ▶ Easy and precise blade gap adjustment
- ▶ Specially designed European origin blades made of abrasion resistant steel, provides long operating life
- ▶ Motorized upper beam adjustment allows accurate blade height and parallelism





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