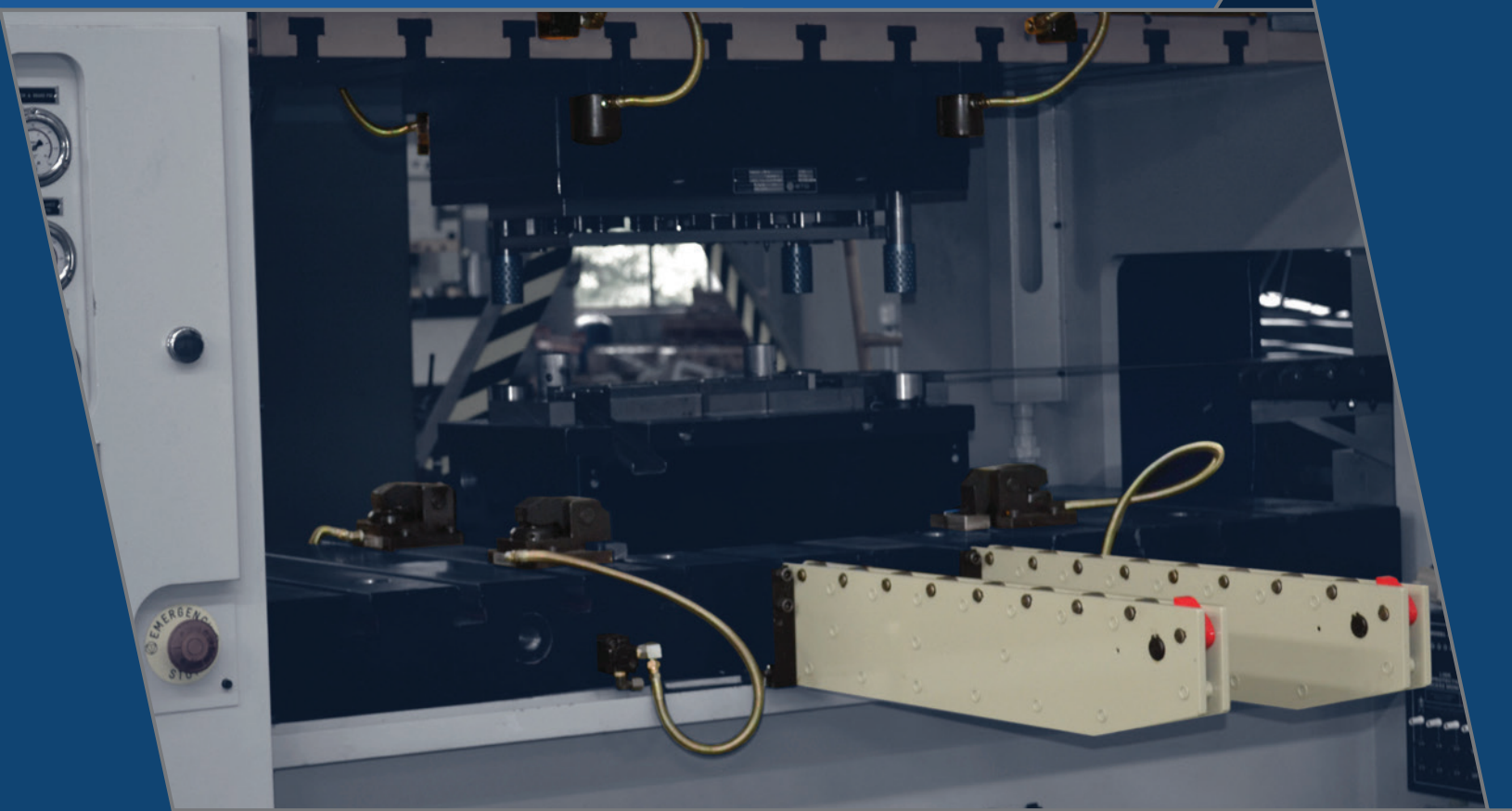




Quick Die Change System

Automatic Die Changing System for Presses and Production Lines



Quick Die Change System

Automatic Die Changing System for Presses and Production Lines

STAMTEC Quick Die Change (Q. D. C.) systems automate the die changing process and provide increased speed, efficiency and productivity. Q.D.C. systems not only reduce die change time, but promote diverse small batch production runs and streamline production management.

FEATURES

- Decreased die change time
- Designed for hydraulic and pneumatic presses
- Increased efficiency
- Reduced labor costs
- Safer operations

Quick Die Change systems are becoming a standard for large manufacturers looking to increase production efficiency, and improve overall working environments. Automated operations reduce labor expenses, but also reduce workshop accidents and the physical stresses on operators, making them more productive.



Die Clamp Series



Die Arm Series





Automating the die changing process and providing increased speed, efficiency and productivity.

- Die Arms
- Die Lifters
- Control Box
- Die Clamps
- Power Unit

In addition, all dies can be changed without any modification allowing for the use of standardized die and press equipment, SAVING COSTS.

Lastly, multiple presses can share a single Q. D. C. system, further economizing on costs and resulting in higher efficiency and productivity.

Die Lifter Series



Power Unit



HMI Control



Effects of introducing QDCS

Before and After

STAMTEC Quick Die Change System from Forwell is an automatic die changing system that can be specifically designed for hydraulic and mechanical power presses and press production lines. This system automates the die changing process and provides increased speed, efficiency and productivity to a workshop. The Quick Die Change System not only reduces die change time, but also promotes diverse small batch production runs and streamlines production management.



BEFORE

AFTER

Manual operation.

Automation

Die / mold changing takes a long time and manpower to tighten.

Only touch the buttons on the control panel.

Clamping force will be different by each operators.

The clamping force is the same.
Increased safety.

Operator time can be wasted, with an increased risk of injury.

Control panel operation saves time and reduces the risk of injury.

No alarm notification while loosening the screws.

Alarm device will stop the machine immediately.

Selection of system components

Compact, space-saving, wide range of applications

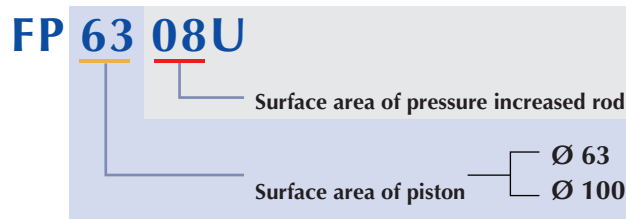
The Forwell Quick Die Change System boosts the efficiency and safety of small to large scale pressing operations. For the system configuration best suited to your needs, please refer to the following sections.

No. of Circuits	Circuit Code	System Configuration
1	C	One circuit for clamping the upper die One circuit for clamping the lower die
	D	One circuit for simultaneously clamping the upper and lower dies One circuit for the lifter
2	2C	One circuit for upper die One circuit for lower die
	CD	One circuit for simultaneously clamping the upper and lower dies One circuit for the lifter
3	2CD	Two circuits for clamping the upper and lower dies One circuit for the lifter
4	3CD	Two circuits for clamping the upper die One circuit for clamping the lower die One circuit for the lifter

★ The above list is planned according to the number of circuits and value plan based on usage.
In between circuit type "C" means ON at all times.
Circuit type "D" means OFF at all times.

FP 6308U - 1 - C

C: Die Clamp | D: Die Lifter



Selection of clamps

Die Clamps for secure clamping, quick mold changing and safe operation

Basic Clamp Selection

Select TX Clamp when die U-slots are provided.

Select TY Clamp when die U-slots are not provided.

Determine the required clamping force.

Clamping force = 20% of Press Tonnage.

Distribution of upper to lower die clamping force.

Higher press tonnage for the upper die.

Ratio of upper clamping force to lower clamping force=3:2

(Single die clamping force)=(upper or lower die clamping force)÷number of clamps

How to determine the number of clamps required.

Determine the number of clamps according to the dimensions and configuration of your die and the T-slot arrangement on the press.

Screw Bolt	M16	M18	M20	M24	M30	M38
Clamping Force	3	4	5	10	15	20

★ Determine the number of clamps according to the dimensions and configuration of your die and the T-slot arrangement on the press.

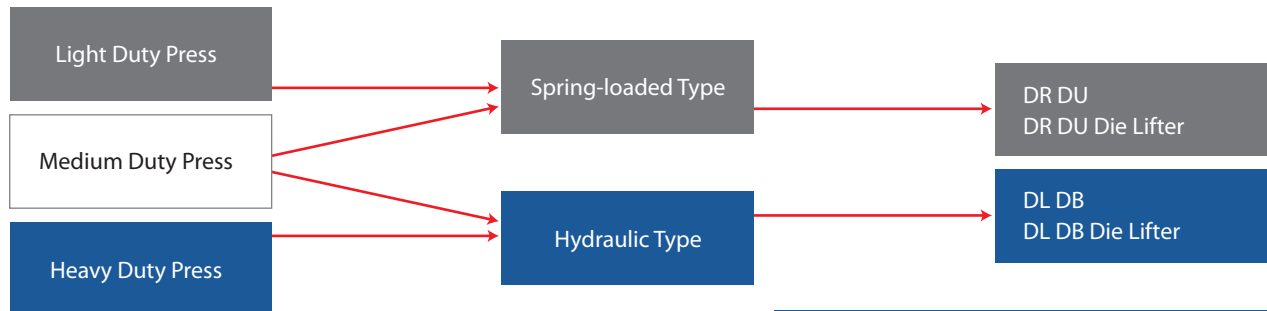


Selection of Die Lifters

Spring-Loaded or Hydraulic Die Lifters

Select Spring-loaded or Hydraulic Die Lifter

Select Spring-Loaded (DR DU) or Hydraulic (DL) Die Lifters according to the press tonnage, die weight and the die positioning accuracy required.



Selection Criteria

Die Lifter
Lift Capacity
Maximum Die Lifter Load Weight
U-slot Size
Accessories

Die Lifter Series

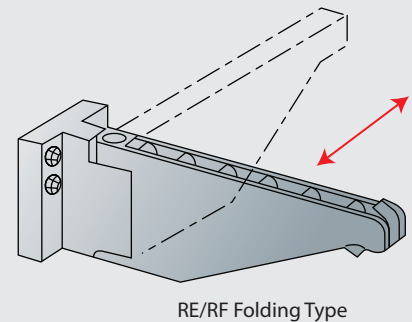
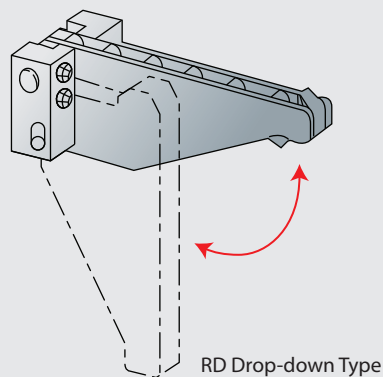
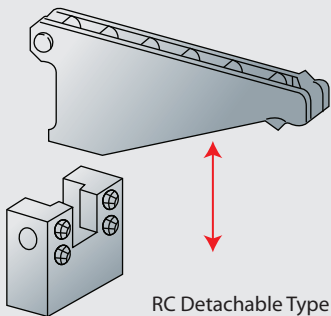


Selection of Die Arms

RC Detachable Type, RD Drop-down Type, RE/RF Folding Type

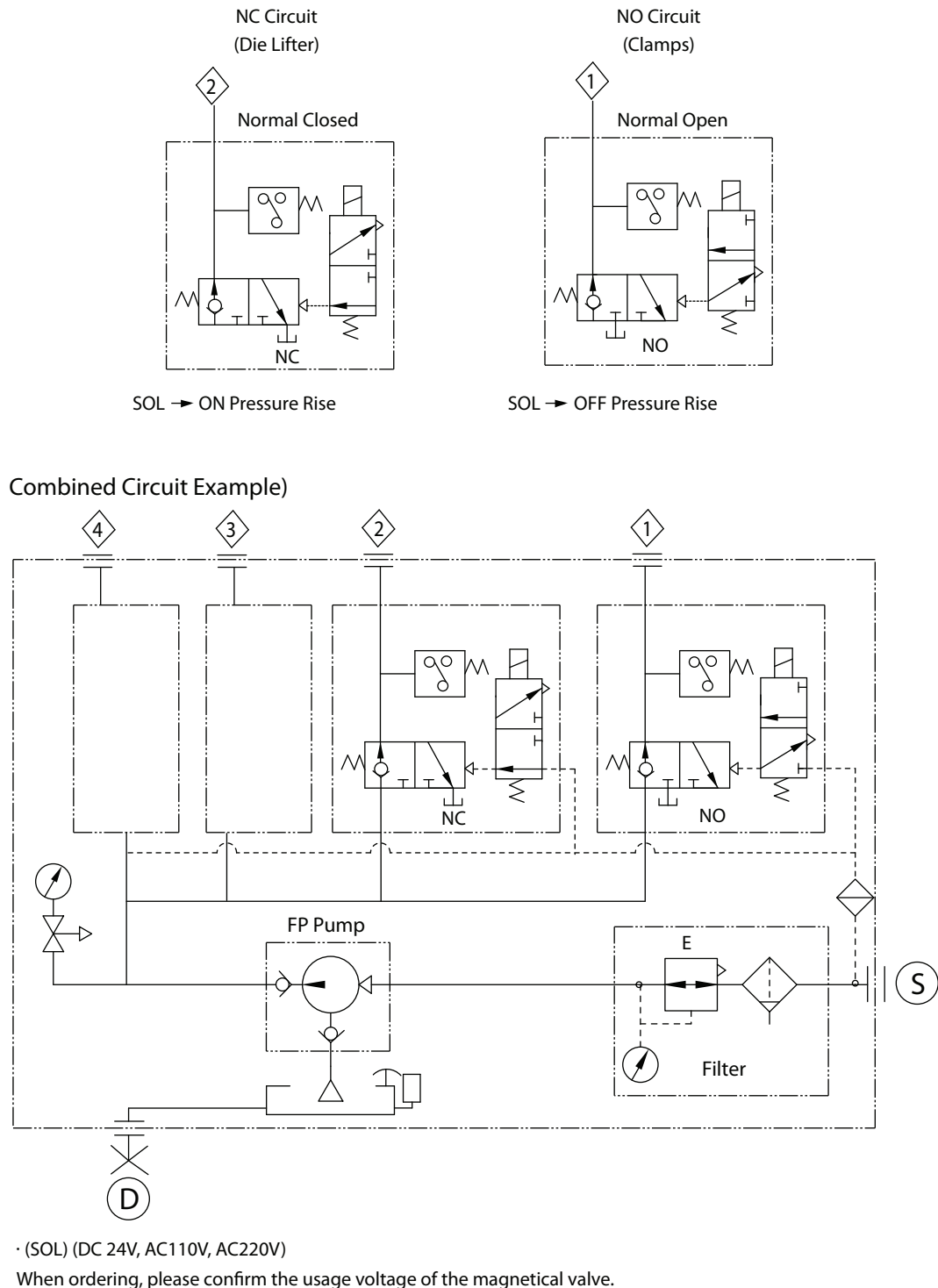
Selection Criteria

Die Dimensions
Maximum Die Arm Load Weight
Type



Selection of Power Unit

Typical Hydraulic Schematics



Hydraulic Power Units

Very secure and stable clamping

The hydraulic pump ensures tight and stable die clamping and allows the system to maintain clamping pressure on the mold even when there is a power failure or air pressure drops. The PCB Fine Piercing System uses air-driven hydraulic pumps resulting in very high clamping pressures, high energy efficiency and convenient automated operations. Forwell's hydraulic pump units also feature an easy to adjust air pressure valve to effectively control the systems air pressure.

FP 6308U-1-C



FP 6308U-2-2C



FP 6308U-3-2C



FP 6308U-4-3CD



FP 1014U-4-3CD

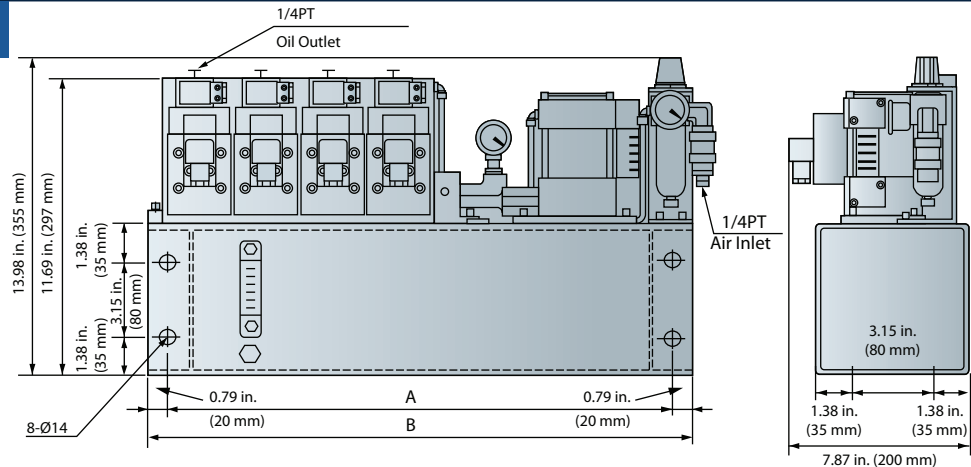


FP63	At 5kg/cm ² Air Pressure	Pressure Ratio
06	420 (kg/cm ²)	1 : 84
07	300 (kg/cm ²)	1 : 60
08	250 (kg/cm ²)	1 : 50
09	200 (kg/cm ²)	1 : 40
10	150 (kg/cm ²)	1 : 30
12	100 (kg/cm ²)	1 : 20
14	80 (kg/cm ²)	1 : 16
16	50 (kg/cm ²)	1 : 10
20	40 (kg/cm ²)	1 : 8
24	26 (kg/cm ²)	1 : 5

Hydraulic Power Units

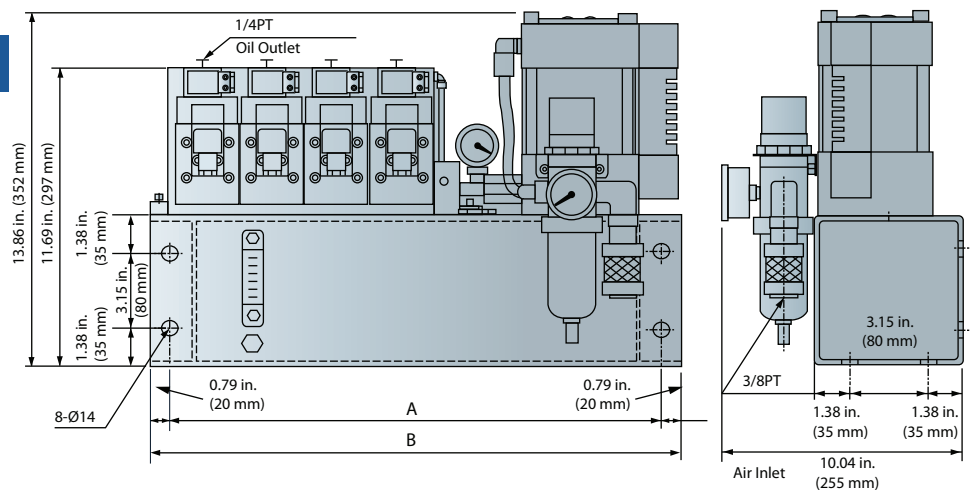
FP63 and FP100 Pump Specifications

Model : FP63 Pump



Model	Total Circuits	A	B	Reservoir Capacity	Available Lubricant	Weight	Lubricant
FP6308U	1	13.90 in. (353 mm)	15.47 in. (393 mm)	6	4.7	50.71 lbs. (23 kg)	ISO VG32- VG68
FP6308U	2	13.90 in. (353 mm)	15.47 in. (393 mm)	6	4.7	59.53 lbs. (27 kg)	
FP6308U	3	16.65 in. (423 mm)	18.23 in. (463 mm)	7.5	5.9	77.16 lbs. (35 kg)	Standard hydraulic oil
FP6308U	4	19.41 in. (493 mm)	20.98 in. (533 mm)	9	7.1	94.80 lbs. (43 kg)	

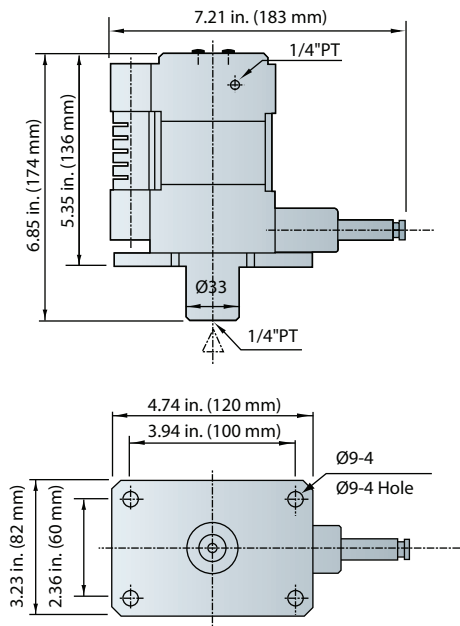
Model : FP100 Pump



Model	Total Circuits	A	B	Reservoir Capacity	Available Lubricant	Weight	Lubricant
FP1014U	1	13.90 in. (353 mm)	15.47 in. (393 mm)	6	3.8	66.14 lbs. (30 kg)	ISO VG32- VG68
FP1014U	2	13.90 in. (353 mm)	15.47 in. (393 mm)	6	3.8	74.96 lbs. (34 kg)	
FP1014U	3	16.65 in. (423 mm)	18.23 in. (463 mm)	7.5	4.8	92.59 lbs. (42 kg)	Standard hydraulic oil
FP1014U	4	19.41 in. (493 mm)	20.98 in. (533 mm)	9	5.8	110.23 lbs. (50 kg)	

Power Units

FP63 Power Unit Specifications



Drive Fluid	Air
Air Pressure	2~6 kg / cm ² (2~6 bar)
Operating Temperature	-5°~60°C
Lubricant	(ISO VG32-VG68) Standard hydraulic oil
Weight	8.82 lbs. (4 kg)

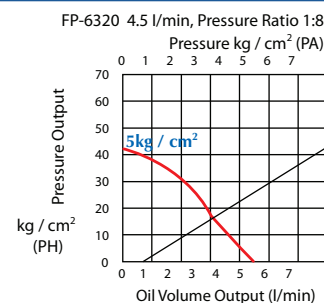
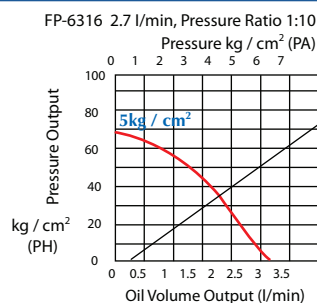
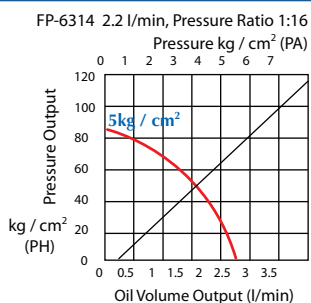
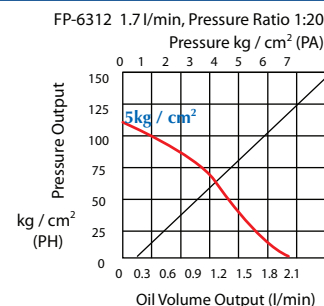
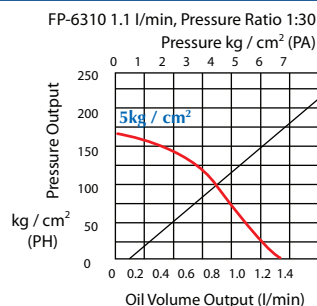
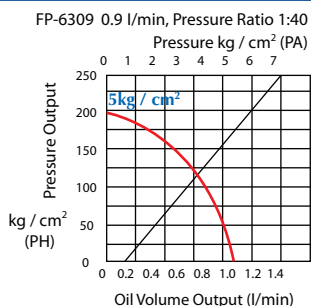
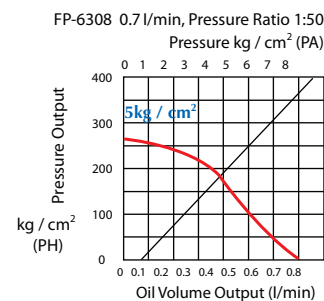
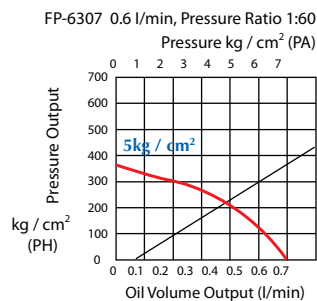
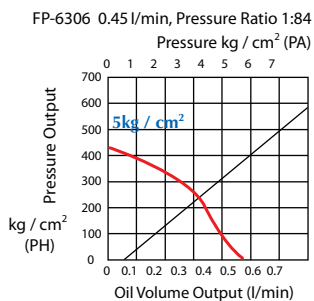
• Pressure : Flow characteristics tables provided below for your reference.

MAX = 0.35Nm³ / min. (3.5e-22cm³ / min.)

Air consumption MAX = 0.35Nm³ / min. (3.5e-22cm³ / min.)

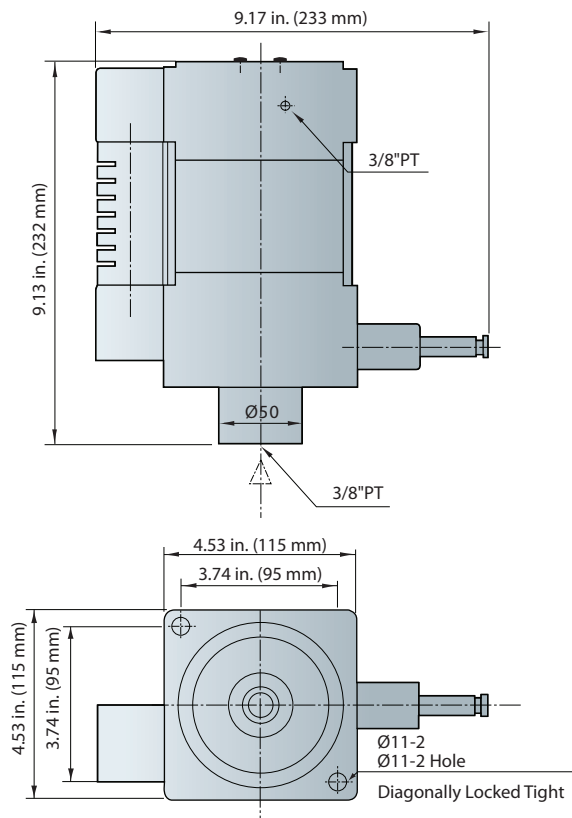
Please refer to instructions for large flow.

Specifications are subject to change. Please give us a call at 931-393-5050 to confirm values.



Power Units

FP100 Power Unit Specifications



Drive Fluid	Air
Air Pressure	2~6 kg / cm ² (2~6 bar)
Operating Temperature	-5°~60°C
Lubricant	(ISO VG32-VG68) Standard hydraulic oil
Weight	24.25 lbs. (11 kg)

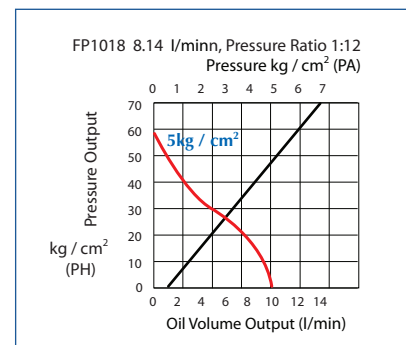
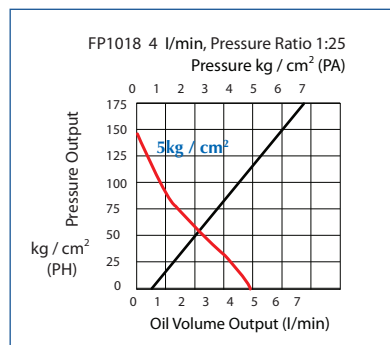
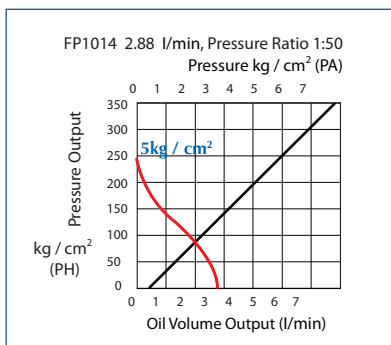
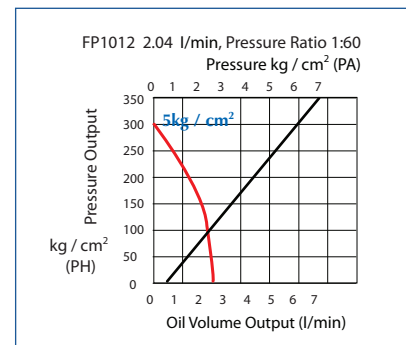
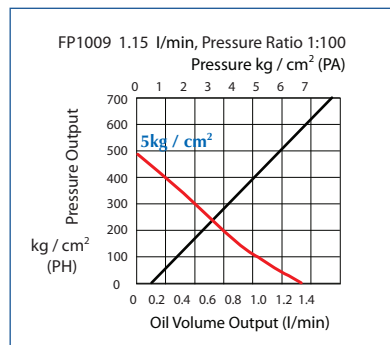
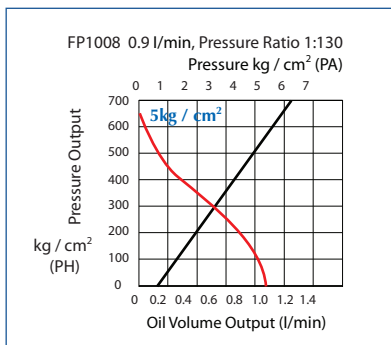
• Pressure : Flow characteristics tables provided below for your reference.

MAX = 0.8Nm³ / min. (8e-22cm³ / min.)

Air consumption MAX = 0.8Nm³ / min. (8e-22cm³ / min.)

Please refer to instructions for large flow.

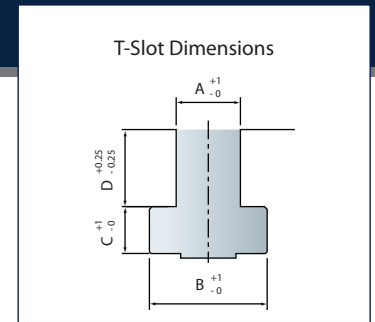
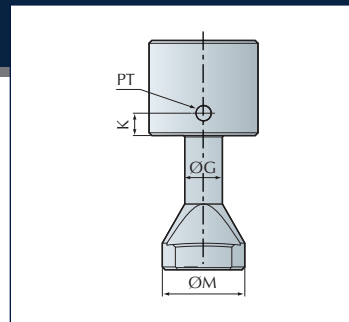
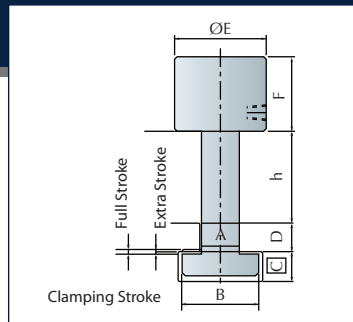
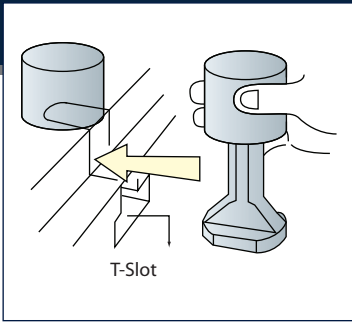
Specifications are subject to change. Please give us a call at 931-393-5050 to confirm values.



TX Die Clamps

Compact, space-saving, wide range of applications

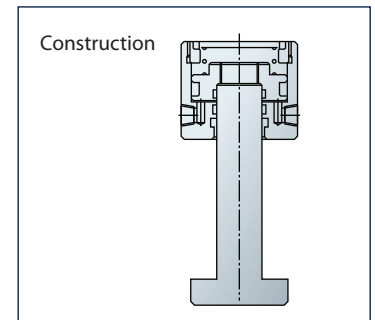
This compact, space saving, piston type clamp requires U-slots on the die shoe. The clamp leg is machined to fit the T-slot on the bolster. With the TX Die Clamp automatic slide model remote control is made possible.



Specifications

Model	Unit	TX-1	TX-2	TX-4	TX-6	TX-10	TX-16	TX-25
Clamping Force (at 250kgf / cm ²)	US Tons (Metric Tons)	1.10 (1)	2.21 (2)	4.41 (4)	6.95 (6.3)	11.02 (10)	17.64 (16)	16.54 (15)
Full Stroke (X)	in. (mm)	0.20 (5)	0.32 (8)	0.32 (8)	0.32 (8)	0.32 (8)	0.32 (8)	0.32 (8)
Clamping Stroke (Y)	in. (mm)	0.10 (2.5)	0.16 (4)	0.12 (3)	0.12 (3)	0.12 (3)	0.12 (3)	0.12 (3)
Extra Stroke (Z)	in. (mm)	0.10 (2.5)	0.16 (4)	0.20 (5)	0.20 (5)	0.20 (5)	0.20 (5)	0.20 (5)
Cylinder Capacity at Full Stroke	cc.	2.7	6.5	13	21	32	54	84

- Extra stroke is the difference between full stroke and clamping stroke with extra space allowed for safe operation.



Dimensions

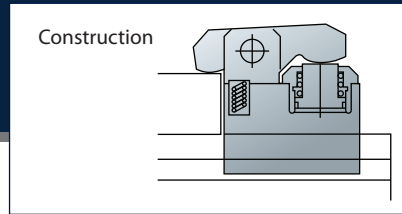
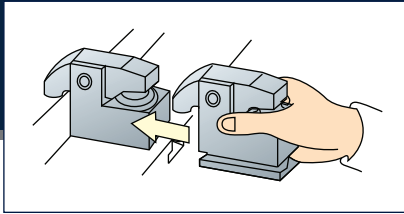
Model	E	F	G	M	K	MIN. C	PT	A	B	C	D	Power Unit Models
TX-1	1.50 (38)	1.46 (37)	0.55 (14)	1.38 (35)	0.43 (11)	0.31 (8)	1/8	0.87 (22)	1.46 (37)	0.63 (16)	0.95 (24)	FP6308U- □ □
TX-2	2.09 (53)	2.07 (52.5)	0.71 (18)	1.50 (38)	0.47 (12)	0.31 (8)	1/8	0.87 (22)	1.46 (37)	0.63 (16)	0.95 (24)	
TX-4	2.68 (68)	2.42 (61.5)	0.91 (23)	2.32 (59)	0.59 (15)	0.39 (10)	1/4	0.87 (22)	1.46 (37)	0.63 (16)	0.95 (24)	
TX-6	3.07 (78)	2.68 (68)	1.06 (27)	2.32 (59)	0.63 (16)	0.55 (14)	1/4	1.10 (28)	1.89 (48)	0.79 (20)	1.10 (28)	FP1014U- □ □
TX-10	3.86 (98)	2.80 (71)	1.50 (38)	3.11 (79)	0.63 (16)	0.67 (17)	1/4	1.10 (28)	1.89 (48)	0.79 (20)	1.10 (28)	
TX-16	5.00 (127)	3.09 (78.5)	1.89 (48)	3.47 (88)	0.63 (16)	0.79 (20)	1/4	1.10 (28)	1.89 (48)	0.91 (23)	1.10 (28)	
TX-25	5.83 (148)	3.94 (100)	2.28 (58)	3.68 (98)	0.59 (15)	0.91 (23)	1/4	1.42 (36)	2.21 (56)	0.98 (25)	1.10 (28)	

- in. (mm)
- Die shoe thickness (h) classify: 0.98in. (25mm), 1.18in. (30mm), 1.38in. (35mm), 1.57in. (40mm), 1.77in. (45mm), 1.97in. (50mm), 2.17in. (55mm), 2.36in. (60mm).
- Before purchase, please verify mold edge thickness (h) and T-slot (A. B. C. D.) has standard or special dimensions.

TY Die Clamps

Fits into the T-slot of the bolster for secure positioning.

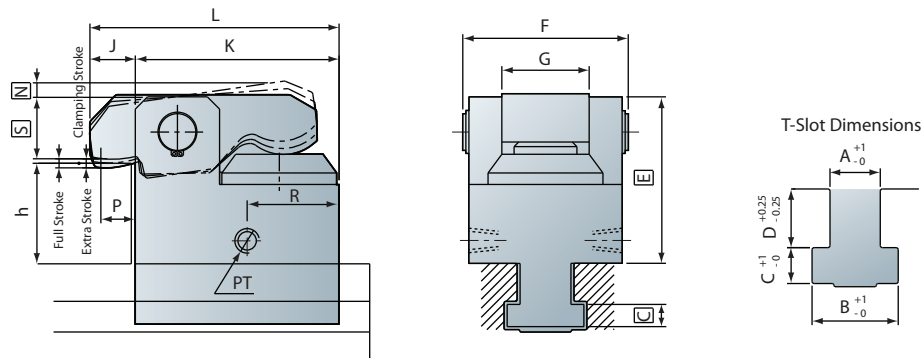
Because this lever-type clamp does not require a U-slot on the die shoe it may be used in a wide range of applications. The base of the clamp is machined to fit the T-slot on the bolster. The flange-mount model clamp may be bolted onto the bolster. The automatic slide model makes remote control possible.



Specifications

Model	Unit	TY-1	TY-2	TY-4	TY-6	TY-10	TY-16	TY-25
Clamping Force (at 250kgf/cm ²)	tons	1	2	4	6.3	10	16	25
(X) Full Stroke	in. (mm)	0.24 (6)	0.28 (7)	0.28 (7)	0.32 (8)	0.32 (8)	0.28 (7)	0.32 (8)
(Y) Clamping Stroke	in. (mm)	0.12 (3)	0.08 (2)	0.12 (3)	0.12 (3)	0.12 (3)	0.12 (3)	0.12 (3)
(Z) Extra Stroke	in. (mm)	0.12 (3)	0.20 (5)	0.16 (4)	0.20 (5)	0.20 (5)	0.16 (4)	0.20 (5)
Cylinder Capacity at Full Stroke	cc.	2	6.5	13.2	22.3	37	61	93

- Extra stroke is the difference between full stroke and clamping stroke with extra space allowed for safe operation.



Model	MIN. [E]	F	G	J	K	L	MAX. [N]	P	R	MIN. [S]	PT	MIN. [C]	A	B	C	D	Power Unit
TY-1	1.95 (49.5)	1.18 (46)	0.79 (20)	0.59 (15)	2.28 (58)	2.87 (73)	0.39 (10)	0.39 (10)	1.34 (34)	0.65 (16.5)	1/8	0.28 (7)	0.87 (22)	1.46 (37)	0.63 (16)	0.95 (24)	FP6308U- ☐ ☐
TY-2	2.32 (59)	2.48 (63)	1.10 (28)	0.87 (22)	3.35 (85)	4.21 (107)	0.39 (10)	0.49 (12.5)	1.89 (48)	1.06 (27)	1/8	0.37 (9.5)	0.87 (22)	1.46 (37)	0.63 (16)	0.95 (24)	
TY-4	3.35 (85)	3.43 (87)	1.58 (40)	0.98 (25)	4.72 (120)	5.71 (145)	0.39 (10)	0.63 (16)	2.28 (58)	1.30 (33)	1/4	0.47 (12)	0.87 (22)	1.46 (37)	0.63 (16)	0.95 (24)	
TY-6	3.70 (94)	3.82 (97)	1.73 (44)	1.16 (29.5)	5.24 (133)	6.40 (162.5)	0.43 (11)	0.79 (20)	2.68 (68)	1.58 (40)	1/4	0.55 (14)	1.10 (28)	1.89 (48)	0.79 (20)	1.10 (28)	
TY-10	4.13 (105)	4.33 (110)	1.97 (50)	1.10 (28)	6.50 (165)	6.65 (193)	0.43 (11)	0.79 (20)	3.22 (82)	2.09 (53)	1/4	0.65 (16.5)	1.10 (28)	1.89 (48)	0.79 (20)	1.10 (28)	FP1014U- ☐ ☐
TY-16	4.72 (120)	5.12 (130)	2.36 (60)	1.18 (30)	7.87 (200)	9.06 (230)	0.47 (12)	0.79 (20)	3.78 (96)	2.64 (67)	1/4	0.75 (19)	1.10 (28)	1.89 (48)	0.91 (23)	1.10 (28)	
TY-25	5.24 (133)	5.91 (150)	2.87 (73)	1.18 (30)	9.45 (240)	10.63 (270)	0.51 (13)	0.79 (20)	4.33 (110)	3.19 (81)	1/4	0.87 (22)	1.42 (36)	2.21 (56)	0.98 (25)	1.10 (28)	

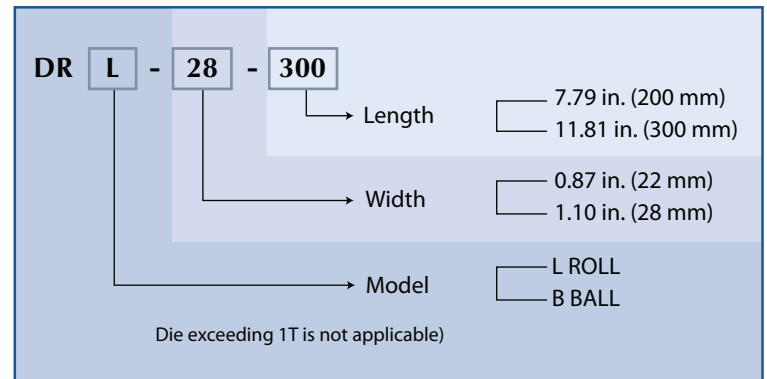
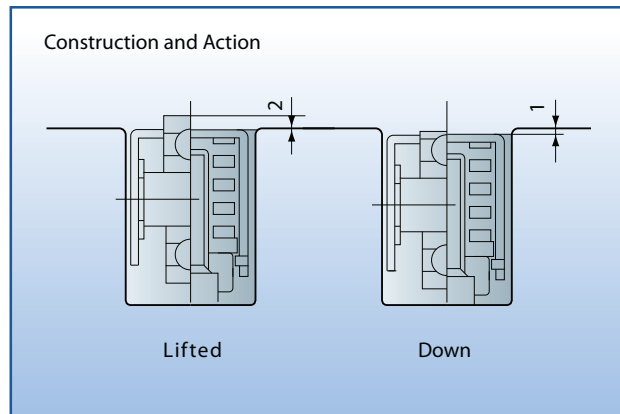
- in. (mm)
- 25 | 30 | 35 | 40 | 45 | 50 | 55 | 60 mm
- Before purchase, please verify mold edge thickness (h) and T-Slot (A.B.C.D.) has standard or special dimensions.

DR Die Lifters

Spring-Loaded or Hydraulic Die Lifters

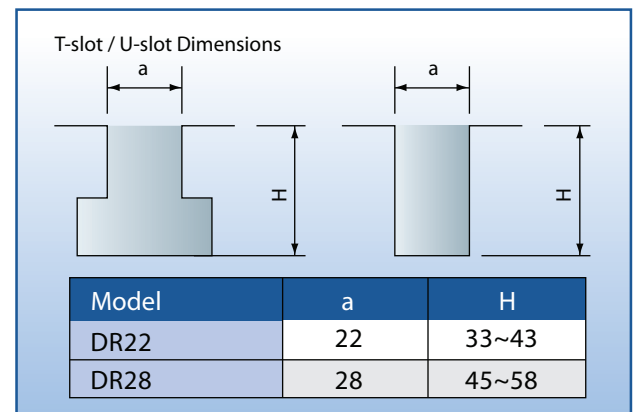
These spring-loaded die lifters easily fit to different sized T or U-slots on the bolster by adding spacers to the side walls of the die lifters.

Die lifters are available in standard lengths of 200mm and 300mm, any die lifters length can be constructed by combining these standard lengths in increments of 100mm.



Specifications	Width in. (mm)	Length in. (mm)	Springs (pcs)	Lift Force lbf (kgf)
DRL-22-200/ DRB-22-200	0.87 (22)	7.79 (200)	4	82.67 (37.5)
DRL-22-300/ DRB-22-300	0.87 (22)	11.81 (300)	6	82.67 (37.5)
DRL-28-200/ DRB-28-200	1.10 (28)	7.79 (200)	4	165.35 (75)
DRL-28-300/ DRB-28-300	1.10 (28)	11.81 (300)	6	165.35 (75)

- DRL-22/DRB-22 80°C
- DRL-28/DRB-28 150°C



DR-22 and DR-28 Specifications and Dimensions

Technical drawing of the front view of a 1200mm long steel beam. The drawing shows a top flange with 12 circular holes and a bottom flange with 12 circular holes. Dimensions are provided in inches and millimeters. Key dimensions include: total length L+32; top flange thickness 0.83 in. (21 mm); bottom flange thickness 0.47 in. (12 mm); web thickness 0.08 in. (2 mm); hole diameter 0.32 in. (8 mm); hole spacing 1.81 in. (46 mm); hole offset 0.63 in. (16 mm); and end plate dimensions. A note specifies "2-M8*35L Screw" for the end plate. A table at the bottom right lists dimensions A and B for different hole patterns.

Dimension	Value (inches)	Value (millimeters)
A	0.75	19
B	1.06	27

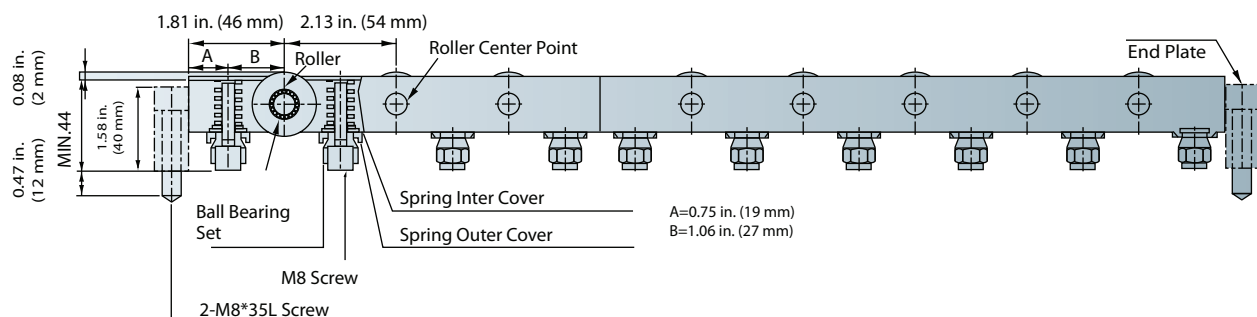
CR-28 Dimensions

Overall length: **L+32**

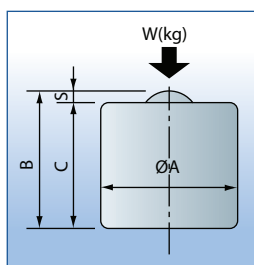
Dimensions (inches / millimeters):

- 0.32 in. (8mm)
- 0.63 in. (16 mm)
- 7.87 in. (200 mm)
- 11.81 in. (300 mm)
- 0.63 in. (16 mm)
- 0.32 in. (8mm)
- 0.59 in. (15mm)
- 1.81 in. (46 mm)
- 2.13 in. (54 mm)
- 2.13 in. (54 mm)
- 1.81 in. (46 mm)
- 1.65 in. (42 mm)
- 2.13 in. (54 mm)
- 2.13 in. (54 mm)
- 2.13 in. (54 mm)
- 2.13 in. (54 mm)
- 1.65 in. (42 mm)
- 1.08 in. (27.5 mm)
- A = 0.75 in. (19 mm)
- B = 1.06 in. (27 mm)

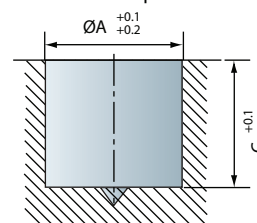
Internal dimensions: 19, 15, 27



(Model)	in. (mm)																			
	lbf. (kgf)	7.87 200	11.81 300	15.75 400	19.69 500	23.63 600	27.56 700	31.50 800	35.43 900	39.37 1000	43.31 1100	47.24 1200	51.18 1300	55.12 1400	59.06 1500	62.99 1600	66.93 1700	70.87 1800	74.80 1900	78.74 2000
DR22		330.69 150	496.04 225	661.39 300	826.73 375	992.08 450	1157.43 525	1322.77 600	1488.12 675	1653.47 750	1818.81 825	1984.16 900	2149.51 975	2314.85 1050	2480.20 1125	2645.55 1200	2810.894 1275	2976.24 1350	3141.59 1425	3306.93 1500
DR28		661.39 300	992.08 450	1322.77 600	1653.47 750	1984.16 900	2314.85 1050	2645.55 1200	2976.24 1350	3306.93 1500	3637.63 1650	3968.32 1800	4299.01 1950	4629.71 2100	4960.40 2250	5291.09 2400	5621.79 2550	5952.48 2700	6283.17 2850	6613.87 3000



	DU100	DU200
A	1.50 in. (38 mm) ⁺⁰ _{-0.05}	1.77 in. (45 mm) ⁺⁰ _{-0.05}
B	1.50 in. (38 mm)	1.77 in. (45 mm)
C	1.38 in. (35 mm) ⁺⁰ _{-0.05}	1.65 in. (42 mm) ⁺⁰ _{-0.05}
S	0.12 in (3 mm)	0.12 in (3 mm)
W	220.46 lbf (100 kgf)	440.93 lbf (200 kgf)



Quote Request For

Quotes for more than one press, please use this form for each machine.

Press Parts A	A1	New or Existing	☐ New	☐ Existing
	A2	Manufacturer and Model	Manufacturer	Model
	A3	Type of Press	☐ C Frame	☐ Straight Side
			☐ Transfer	☐ Other Specify
	A4	Tonnage	☐ tf	☐ US ☐ Metric
	A5	Slide Dimensions	(L-R) X (F-B) mm (inch)	
	A6	Bolster Dimensions	(L-R) X (F-B) mm (inch)	
A7	T-slot	☐ Yes ☐ No		
Die Parts B	B1	Max. Weight	kg (lbs)	
	B2	Max. Dimensions	(W) x (L) x (H) mm (inch)	
	B3	U-slot for Bolting	☐ Yes ☐ No	
	B4	Die Shoe Thickness	mm (inch)	
	B5	Bottom	☐ Plain ☐ Lattice	
	B6	Special Requirements		
Die Change System Parts C	C1	Required Components	Clamp Model X pcs	
		Die Lifter Model X pcs		
		Die Arm Model X pcs		
		Power Unit Model X pcs		
	C2	Valve Operation	☐ Manual ☐ Automatic	
		☐ Power Supply ☐ AC ☐ DC ☐ Volt ☐ Hz		

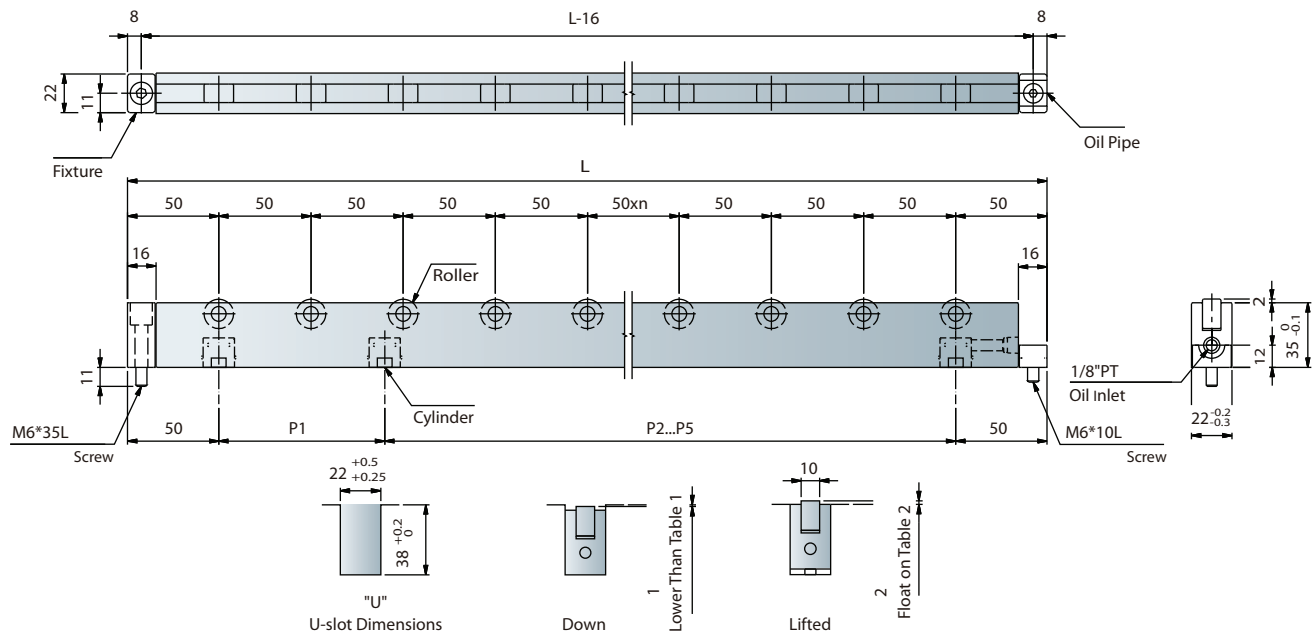
Your Information

COMPANY :	NAME :
ADDR :	
TEL :	FAX :

DL Die Lifter (Roller Type)

DL-22 Specifications and Dimensions

Basic Model	Unit	DL22	DL28	DL50
Lifting Force Per cylinder	tons	0.25	0.5	1.1
Working Hydraulic Pressure	kgf/cm ²	250	250	250
Total Stroke	mm	3	3	3
One Cylinder Capacity	cc.	0.3	0.6	1.4

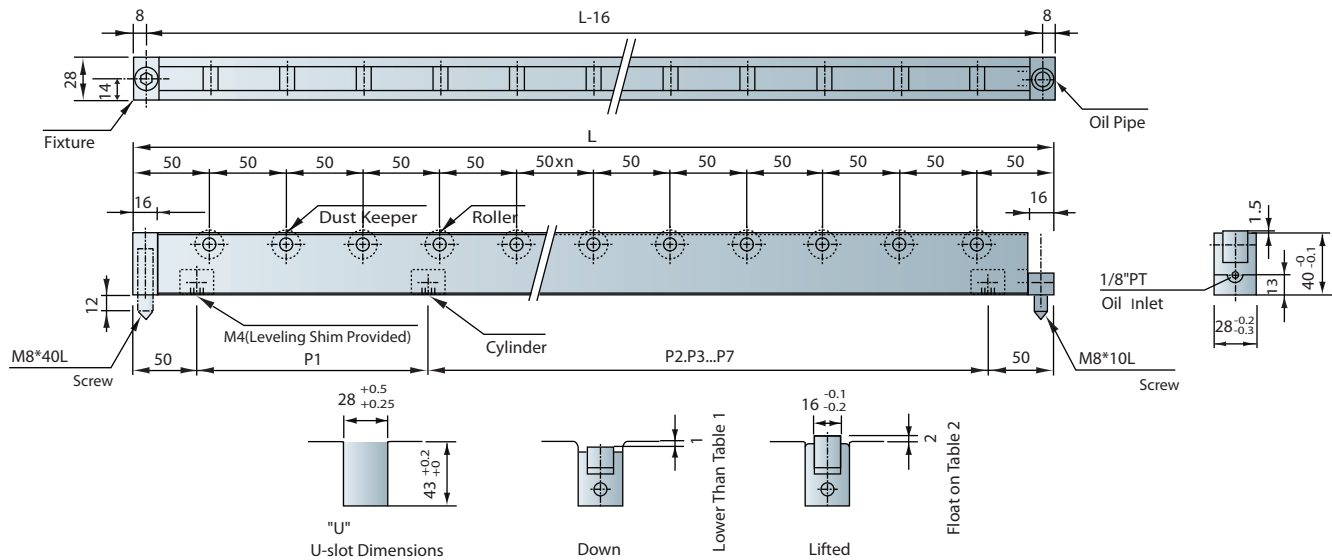


Model	Overall (mm)	Roller Q'ty	Die Load Capacity (kg)	Lift Cylinder		Lift Cylinder Pitch (mm)				
				(pcs)	Lift Force	P1	P2	P3	P4	P5
DL-22-300	300	5	300	2	500	200				
DL-22-400	400	7	420	3	750	90	210			
DL-22-500	500	9	540	4	1000	90	220	90		
DL-22-600	600	11	660	5	1250	90	160	160	90	
DL-22-700	700	13	780	5	1250	90	210	210	90	
DL-22-800	800	15	900	6	1500	90	150	220	150	90

- For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom.

DL Die Lifter (Roller Type)

DL-28 Specifications and Dimensions

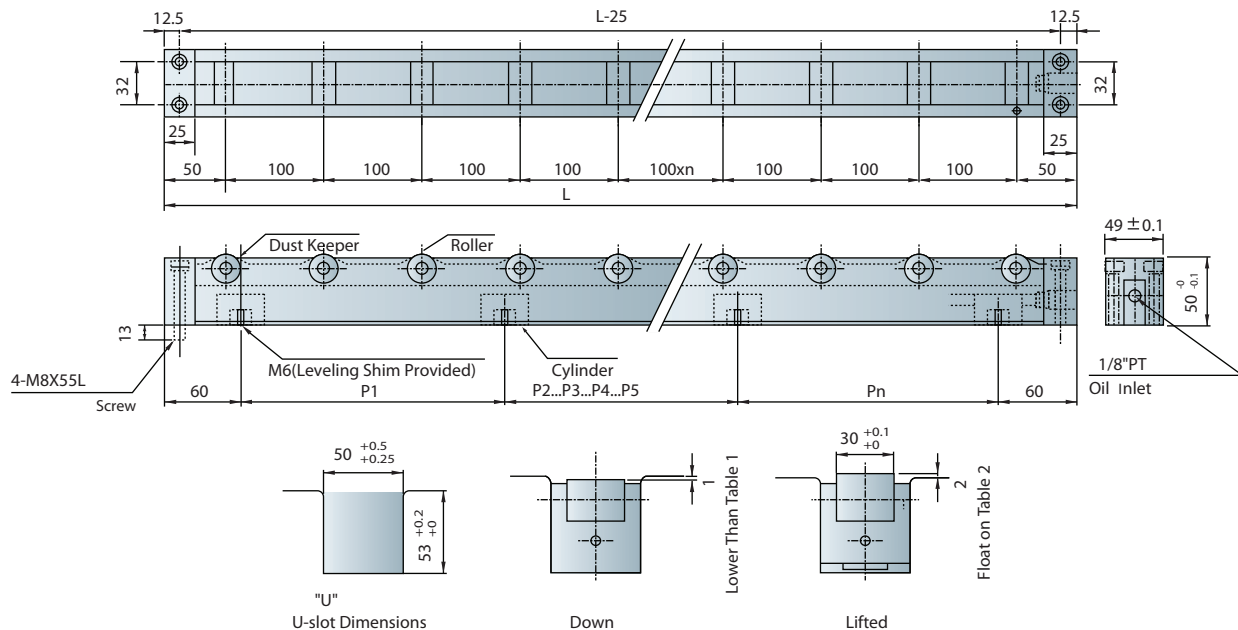


Model	Overall (mm)	Roller Q'ty	Die Load Capacity (kg)	Lift Cylinder		Lift Cylinder Pitch (mm)						
				(pcs)	Lift Force	P1	P2	P3	P4	P5	P6	P7
DL-28-400	400	7	560	2	1000	300						
DL-28-500	500	9	720	3	1500	90	310					
DL-28-600	600	11	880	4	2000	100	340	60				
DL-28-700	700	13	1040	4	2000	150	350	100				
DL-28-800	800	15	1200	5	2500	95	95	390	120			
DL-28-900	900	17	1360	5	2500	110	110	410	170			
DL-28-1000	1000	19	1520	6	3000	130	130	420	110	110		
DL-28-1100	1100	21	1680	6	3000	150	150	460	120	120		
DL-28-1200	1200	23	1840	7	3500	100	150	150	200	200	300	
DL-28-1300	1300	25	2000	7	3500	150	150	300	300	150	150	
DL-28-1400	1400	27	2160	8	4000	100	100	150	150	200	250	350
DL-28-1500	1500	29	2320	8	4000	100	100	150	150	200	350	350

• For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom.

DL Die Lifter (Roller Type)

DL-50 Specifications and Dimensions



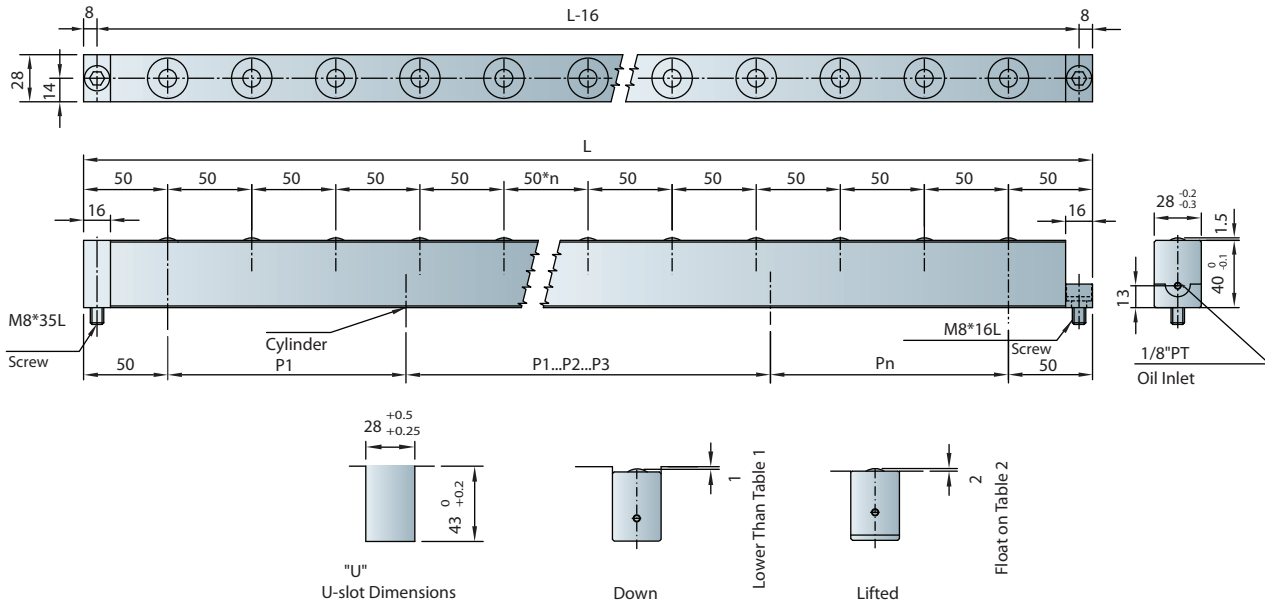
Model	Overall (mm)	Roller Q'ty	Die Load Capacity (kg)	Lift Cylinder		Lift Cylinder Pitch (mm)						
				(pcs)	Lift Force	P1	P2	P3	P4	P5	P6	P7
DL-50-400	400	4	800	2	2200	280						
DL-50-500	500	5	1000	3	3300	90	290					
DL-50-600	600	6	1200	4	4400	90	330	60				
DL-50-700	700	7	1400	4	4400	140	340	100				
DL-50-800	800	8	1600	4	4400	170	390	120				
DL-50-900	900	9	1800	4	4400	210	400	170				
DL-50-1000	1000	10	2000	5	5500	125	125	410	220			
DL-50-1100	1100	11	2200	5	5500	150	150	400	280			
DL-50-1200	1200	23	4600	5	5500	150	150	400	380			
DL-50-1300	1300	25	5000	6	6600	150	150	200	400	280		
DL-50-1400	1400	27	5400	6	6600	150	150	200	400	380		
DL-50-1500	1500	29	5800	7	7700	150	150	200	300	300	280	
DL-50-1600	1600	31	6200	7	7700	100	150	250	400	300	280	
DL-50-1700	1700	33	6600	8	8800	100	100	150	250	300	300	380
DL-50-1800	1800	35	7000	8	8800	100	100	150	250	300	300	480

- For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom.

DB Die Lifter (Ball Type)

DB-28 Specifications and Dimensions

DB-28 for Dies 800kg or Less



Model	Overall (mm)	Ball Q'ty	Lift Cylinder (kg)		Lift Cylinder Pitch (mm)						
			(pcs)	Lift Force	P1	P2	P3	P4	P5	P6	P7
DB-28-400	400	7	2	1000	300						
DB-28-500	500	9	3	1500	90	310					
DB-28-600	600	11	4	2000	100	340	60				
DB-28-700	700	13	4	2000	150	350	100				
DB-28-800	800	15	5	2500	95	95	390	120			
DB-28-900	900	17	5	2500	110	110	410	170			
DB-28-1000	1000	19	6	3000	130	130	420	110	110		
DB-28-1100	1100	21	6	3000	120	120	460	150	150		
DB-28-1200	1200	23	7	3500	300	200	200	150	150	100	
DB-28-1300	1300	25	7	3500	150	150	300	300	150	150	
DB-28-1400	1400	27	8	4000	350	250	200	150	150	100	100
DB-28-1500	1500	29	8	4000	350	350	200	150	150	100	100

- For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom.

DB-50 Specifications and Dimensions

The technical drawing illustrates the U-slot assembly in three views:

- Top View:** Shows a long rectangular assembly with a total length L . It features a central section of length $50 \times N$ and end sections of length 50. The width is 32. Dimensions 12.5, 25, and 50 are indicated for specific features and segments.
- Side View:** Shows the assembly's profile with a total height of 13. It includes labels for "M6 (Leveling Shim Provided)", "Cylinder", and "P1", "P2...P3...P4....", "Pn". End sections are 60 units long. A detail view shows a cross-section with dimensions 49 ± 0.1 and 50 ± 0.1 , and a label "1/8\" PT Oil Inlet".
- U-Slot Dimensions:** Three cross-sectional views of the U-slot:
 - "U" View:** Shows a U-slot with a width of $50^{+0.25}_{+0.5}$ and a height of $53^{0}_{+0.2}$.
 - Normal Status View:** Shows the U-slot with a width of 50 and a depth of 1.
 - Lifted View:** Shows the U-slot with a width of 50 and a depth of 2.

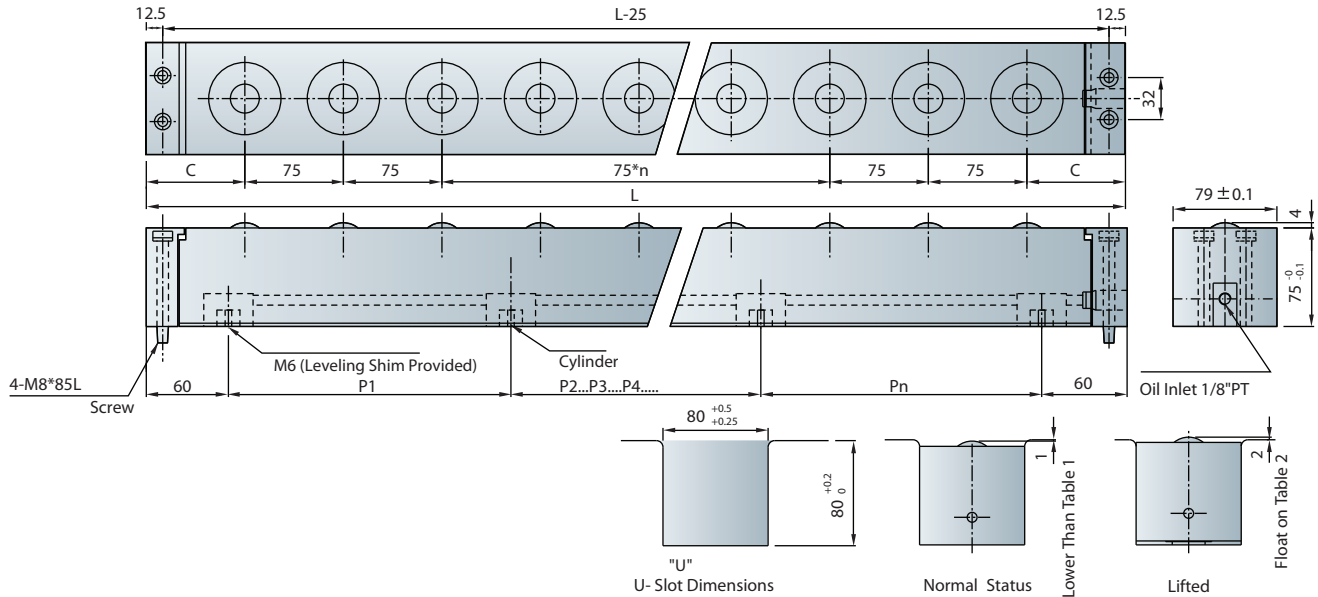
Additional labels include "Screw" and "4-M8X55L".

- For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom.

DB Die Lifter (Ball Type)

DB-28 Specifications and Dimensions

DB-80 for Dies 1500kg or More



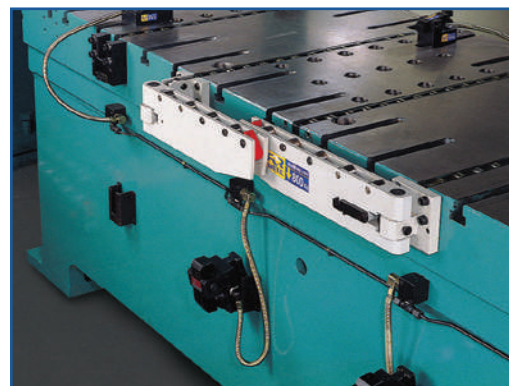
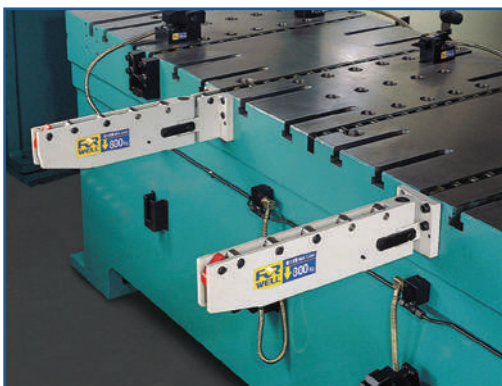
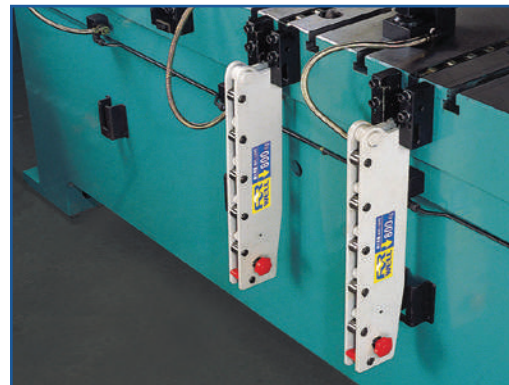
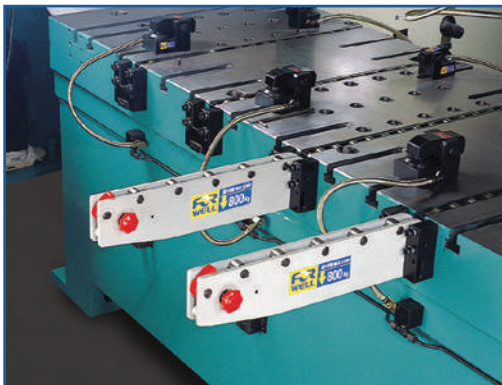
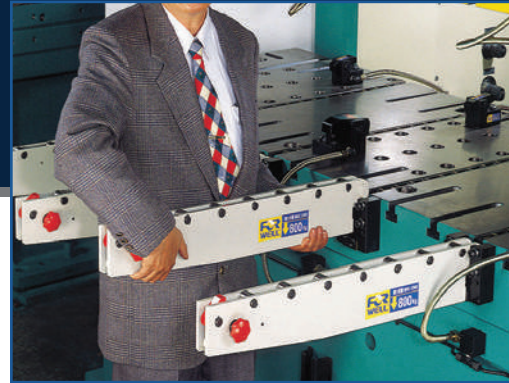
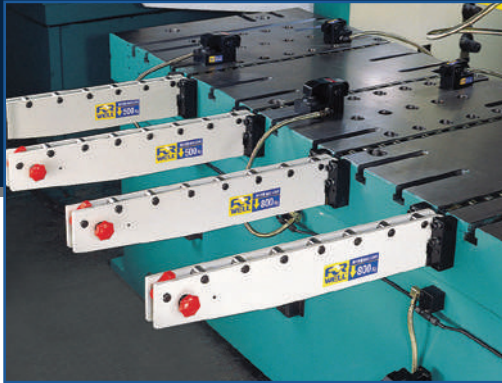
Model	Overall (mm)	Ball Q'ty	Lift Cylinder (kg)		Lift Cylinder Pitch (mm)															Margin
			pcs	Lift Force	P1	P2	P3	P4	P5	P6	P7	P8	P9	P10	P11	P12	P13	P14	P15	C
DB-80-400	400	4	3	4400	80	120	80													87.5
DB-80-500	500	6	3	4400	90	200	90													62.5
DB-80-600	600	7	4	6600	80	80	160	80	80											75
DB-80-700	700	9	4	6600	90	90	220	90	90											87.5
DB-80-800	800	10	6	8800	80	80	80	200	80	80	80									62.5
DB-80-900	900	11	6	8800	90	90	90	240	90	90	90									75
DB-80-1000	1000	13	6	11000	80	80	80	80	240	80	80	80	80							87.5
DB-80-1100	1100	14	8	11000	90	90	90	90	260	90	90	90	90							62.5
DB-80-1200	1200	15	8	11000	100	100	100	100	280	100	100	100	100							75
DB-80-1300	1300	16	8	13200	90	90	90	90	90	280	90	90	90	90	90					87.5
DB-80-1400	1400	18	10	13200	100	100	100	100	100	280	100	100	100	100	100					62.5
DB-80-1500	1500	19	10	15400	90	90	90	90	90	90	300	90	90	90	90	90	90			75
DB-80-1600	1600	20	10	15400	100	100	100	100	100	100	280	100	100	100	100	100	100			87.5
DB-80-1700	1700	22	12	17600	90	90	90	90	90	90	90	320	90	90	90	90	90	90	90	62.5

• For purchases please attach a bolster plate diagram for correct sizing of the waste material hole at the bottom.

RC / RD / RE / RF Die Arm

Detachable, Drop-down and Folding Series

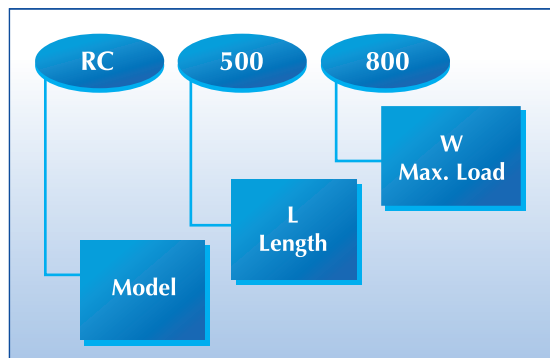
Die Arm makes it easy to move dies to an accessible area with a crane or forklift truck for convenient die changes. Three different designs are available: Detachable RC series, drop-down RD series (alternate model), and folding RE/RF series.



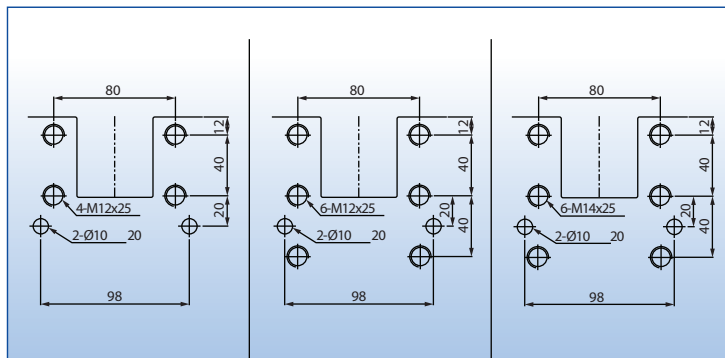
RC Bolster Extension Series

Light and Medium-Duty

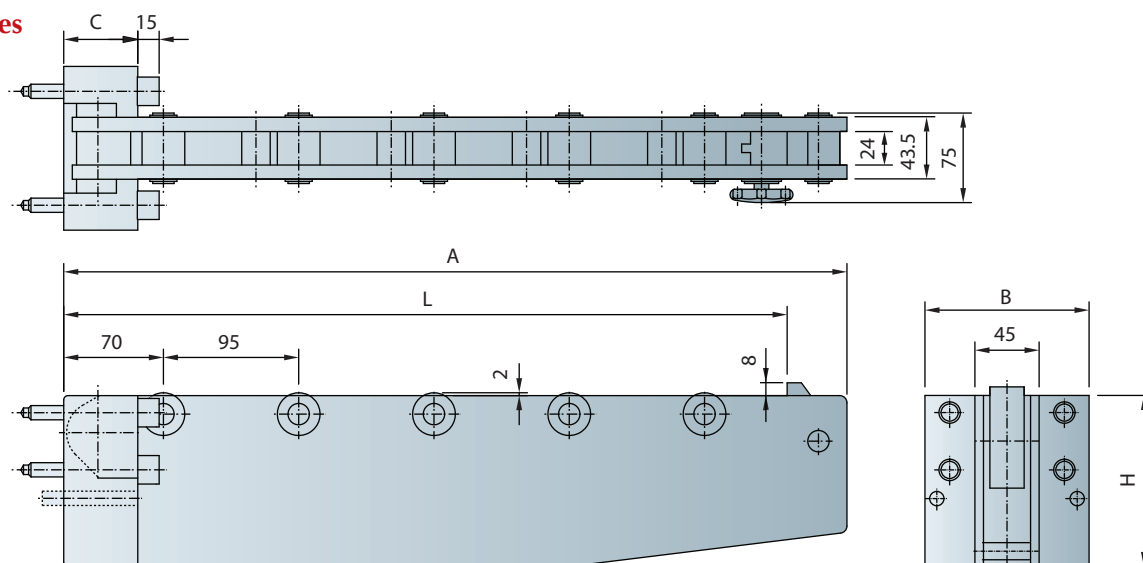
Model/Length/Max. Load



Mounting Hole Dimensions



RC Series

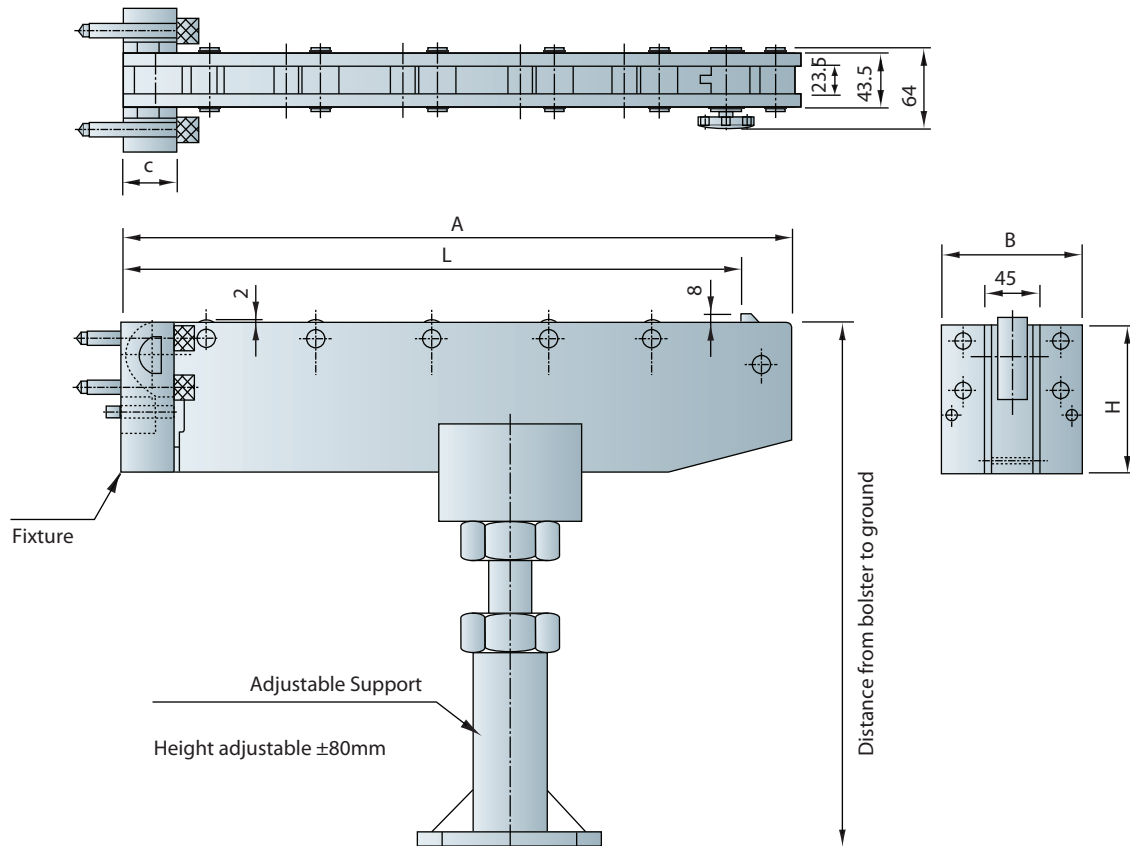


Model	Die Travel (L)	Max. Load (kg)	Overall Length (A)	Fixture			Rollers	Installed Dimensions	Fixture Model
				B	C	H			
RC-500-800	500	800	550	115	46	120	5	A	RC-120
RC-500-1250	500	1250	550			160			RC-160
RC-500-1600	500	1600	550		50	200		B	RC-200
RC-700-600	700	600	750		46	120	7	A	RC-120
RC-700-1000	700	1000	750			160			RC-160
RC-800-800	800	800	850			160	8		
RC-800-1600	800	1600	850		50	200	8	B	RC-200
RC-800-2000	800	2000	850			200	9	C	RC-200
RC-900-1600	900	1600	950			200	9	B	RC-200
RC-1000-1600	1000	1600	1050				10		

RC Bolster Extension Series

Heavy-Duty

Detachable RC Series



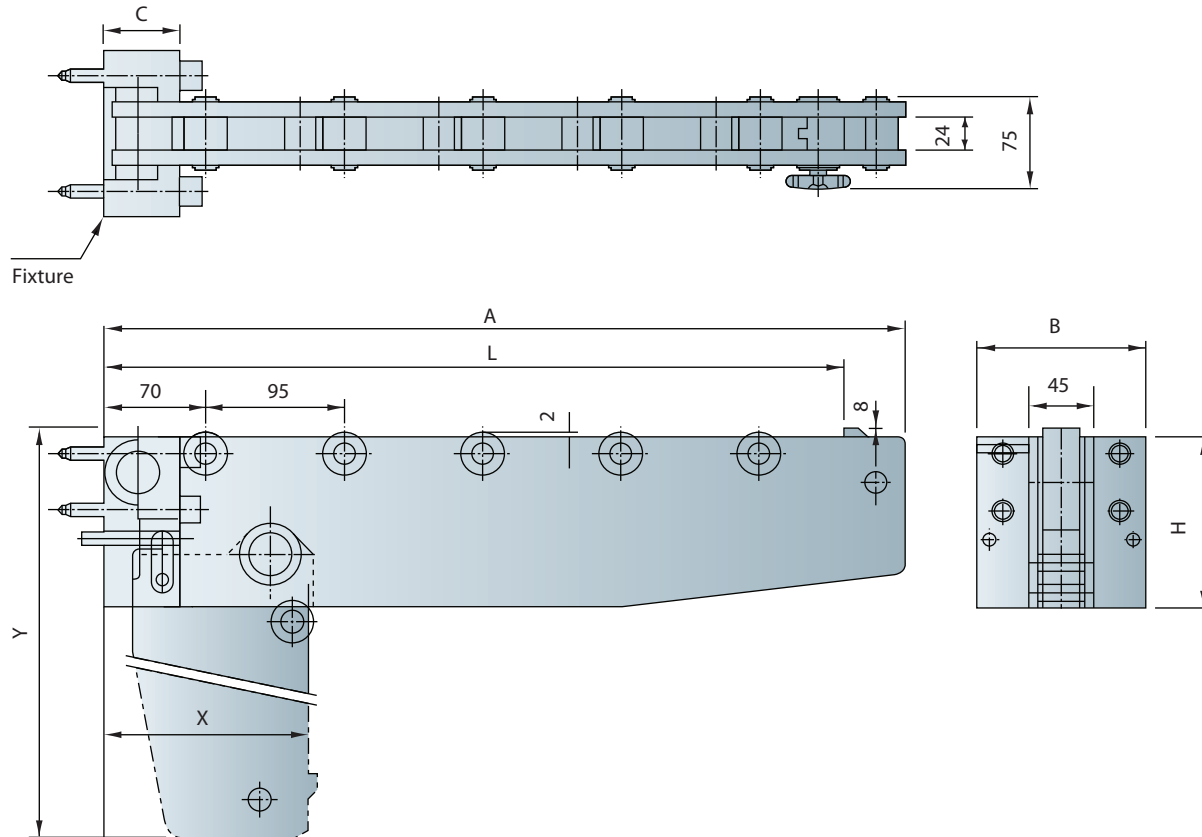
Model	Die Travel (L)	Max. Load (kg)	Overall Length (A)	Fixture			Rollers	Installed Dimensions	Fixture Model
				B	C	H			
RC-1200-2500	1200	2500	1250	115	46	120	14	A	RC-120
RC-1300-2500	1300	2500	1350				15		
RC-1400-2500	1400	2500	1450				17		
RC-1500-2500	1500	2500	1550				18		
RC-1600-2500	1600	2500	1650				19		
RC-1700-2500	1700	2500	1750				20		

- Requires adjustable support if die travels over 1000mm. These models come standard with adjustable support.
- Contact us for other specifications.

RD Bolster Extension Series

Drop-Down RD Series

Drop-Down RD Series

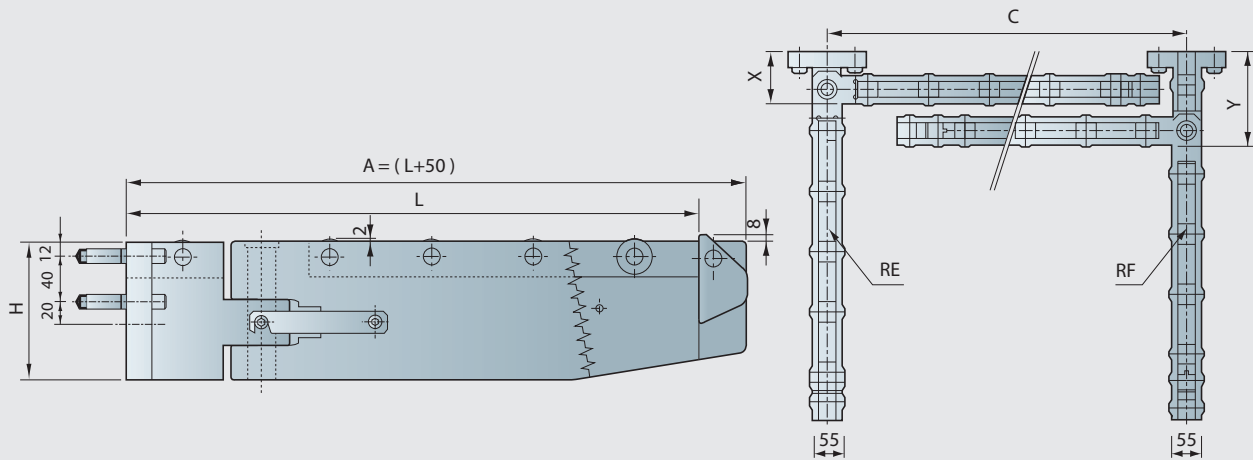
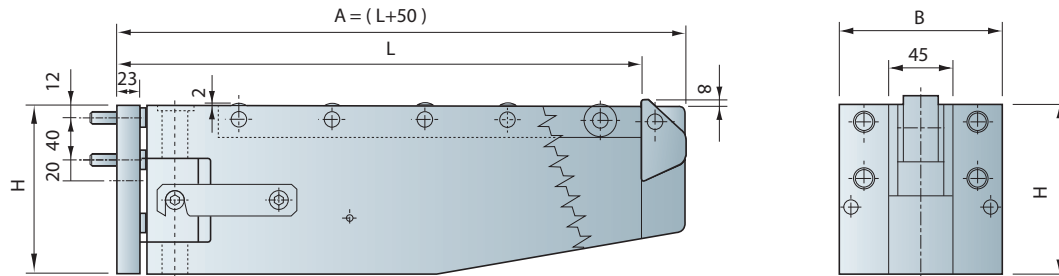


Model	Die Travel (L)	Max. Load (kg)	Overall Length (A)	Fixture			Rollers	Installed Dimensions	Drop Down	
				B	C	H			X	Y
RD-500-800	500	800	550	115	52	120	5	A	140	620
RD-500-1250	500	1250	550			160			180	660
RD-500-1600	500	1600	550			200		B	220	700
RD-700-600	700	600	750			120	7	A	140	820
RD-700-1000	700	1000	750			160			180	860
RD-800-800	800	800	850			160	8		180	960
RD-800-1600	800	1600	850			200	B	220	1000	
RD-800-2000	800	2000	850			200	9	C	220	1000
RD-900-1600	900	1600	950			200	9	B	220	1100
RD-1000-1600	1000	1600	1050				10			1200

RE / RF Bolster Extension Series

Folding RE / RF Series

Folding RE/RF Series



China Patent No: ZL 01 2 64184.7

Model	Die Travel (L)	Max. Load (kg)	Overall Length (A)	Fixture			Rollers	Installed Dimensions	Drop Down	
				B	C	H			X	Y
RE.RF-500-800	500	800	550	525	115	120	5	A	90	150
RE.RF-500-1250	500	1250	550	525		160				
RE.RF-700-600	700	600	750	725		120	7	B		
RE.RF-700-1600	700	1600	750	725		200	7	A		
RE.RF-800-800	800	800	850	825		160	8	B		
RE.RF-800-1600	800	1600	850	825		200	8			
RE.RF-500-1600	500	1600	550	525		200	5			
RE.RF-900-1600	900	1600	950	925			9			

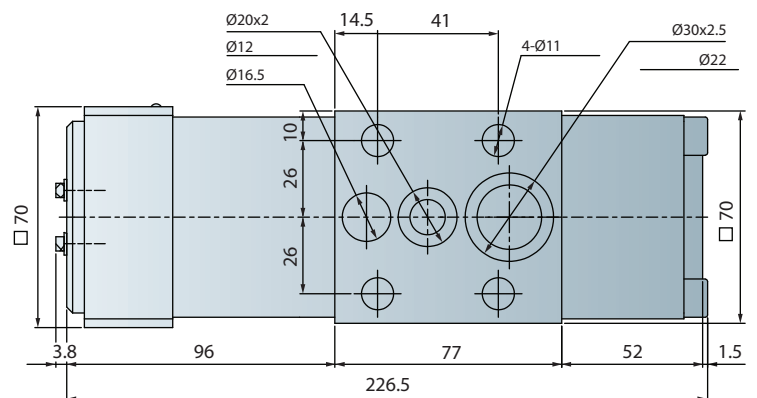
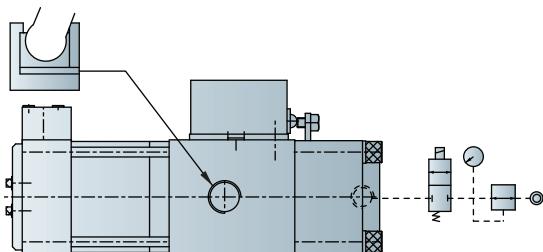
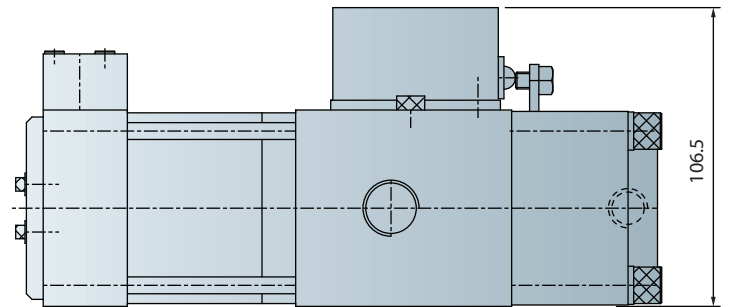
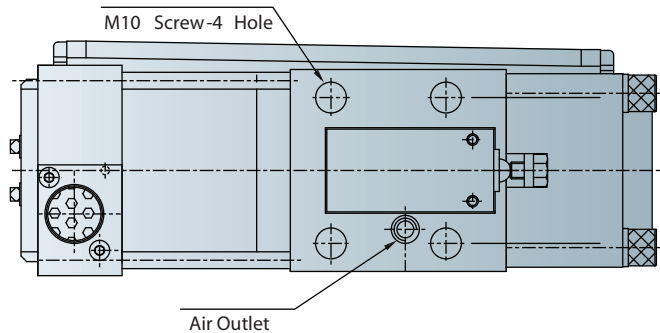
RC / RD / RE / RF Die Arm

Detachable, Drop-down and Folding Series

Besides die change systems Forwell offers a wide range of hydraulic and pneumatic controlled components and equipment for plastic injection molds and workpiece clamping systems for machine tools. The components shown below represent just a selection of what we have available. For related brochures and further details, don't hesitate to contact us.



Model	OL107
Air Supply	2.5~5.5 kg/cm ²
Power Ratio	Air Pressure x 70
Power Pressure	175~385 kgf/cm ²
Area of Air Outlet	0.42 cm ²



Related Products for Press Machines

Air Pump



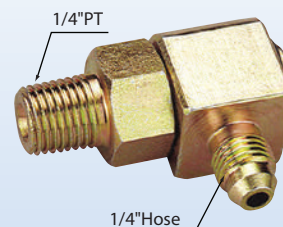
Model on P12~P13

	At Air 5kg/cm ²	Pressure Ratio
06	420 (kg/cm ²)	1:84
07	300 (kg/cm ²)	1:60
08	250 (kg/cm ²)	1:50
09	200 (kg/cm ²)	1:40
10	150 (kg/cm ²)	1:30
12	100 (kg/cm ²)	1:20
14	80 (kg/cm ²)	1:16
16	50 (kg/cm ²)	1:10
20	40 (kg/cm ²)	1:8
24	26 (kg/cm ²)	1:5

AV Air Control Valve



Rotary Unit



1/4"PT x 1/4"H

Pressure Resistance : 700kg/cm²

Example Die Cart Systems

Simultaneous 2-die change using two carts. The shortest die change time is achieved.				
Die change using a moving bolster and two stationary tables. Low cost type.				
Die change using a powered 2-die cart. Many applications are possible.				

Notes

Date:

[illegible]



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METAL STAMPING & FORMING EQUIPMENT

Stamtec has been providing dependable, affordably priced metal stamping presses for almost 40 years in North America, and almost 70 years worldwide through our parent company Chin Fong. Our 72,000 sq. ft. sales, service, logistics, and assembly facility in Tennessee is home not only to North America's largest inventory of new presses and spare parts, but also our most important asset - our people. Our staff of engineering, sales, service, and support personnel are here to serve you in the most timely and professional manner. So, tap into our global strength, and grow with us as we grow with you!



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1-POINT AND 2-POINT



STRAIGHT SIDE PRESSES
1-POINT, 2-POINT AND 4-POINT



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