



# Strippit V/VX-Series

CNC TURRET PUNCH PRESSES



Sheet Metalworking, Our Passion, Your Solution

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STRIPPIT V/VX-SERIES

# Unsurpassed Productivity

When production applications demand high productivity, the Strippit V/VX-Series delivers. These exceptionally versatile, full-featured machines offer high hit rates, large turret capacity, large feed clearance, and powerful control capabilities in a robust design engineered for long life.

- Flexible tool configuration
- Energy efficient
- Full sheet utilization
- Heavy sheet carrying capacity
- High-speed processing





# Strippit V/VX-Series

- **High hit rates** of up to 425 HPM at 25 mm pitch (Strippit V-Series), up to 530 HPM at 25mm mm pitch (Strippit VX-Series)
- 200 kN (Strippit VX-Series) or 300 kN (Strippit V-Series) **configurations**
- ERS – **Energy reduction system** reduces energy consumption by up to 15%
- **Versatile mix** of 48 turret stations with four 88,9 mm indexable stations
- Finished part **accuracy** of  $\pm 0,1$  mm with a repeatability of  $\pm 0,05$  mm over the entire table
- **Programmable and relocatable** work clamps
- **Programmable** parts chute
- Patented **Smart Stroke®** automatically optimizes the ram stroke
- **Smart Clamp™** adjusts the no-punch zone in relation to the tool size which ensures the smallest possible no-punch zone
- **Durable, reliable** and easy to set-up
- PC-based **Fanuc CNC control**
- Optional offline programming software, **CADMAN® P**
- Modular **automation** options

## KEY FEATURES

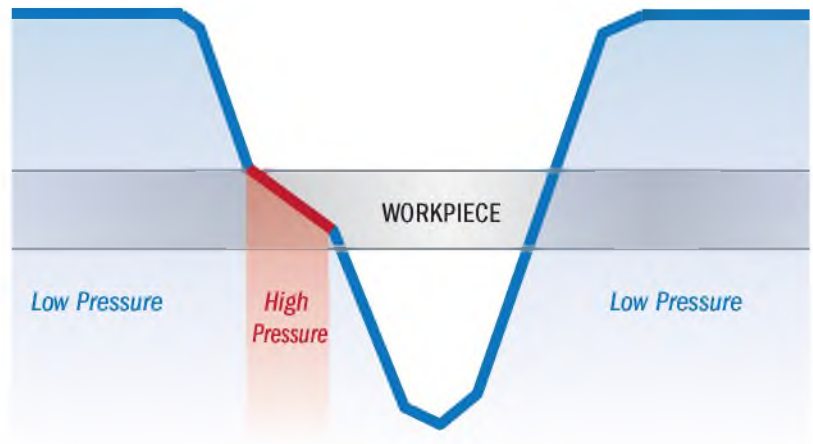
# High-Speed, Energy-Friendly Ram



## EFFICIENT PRESS DRIVE

A unique Hi-Lo pressure system provides the best power efficiency during machine operation. Using two pressure circuits, the system applies low pressure, high flow for lower tonnage high hit rate tools and high pressure, low flow for those applications requiring higher tonnage tools.

*Hi-Lo pressure system provides significant energy savings*

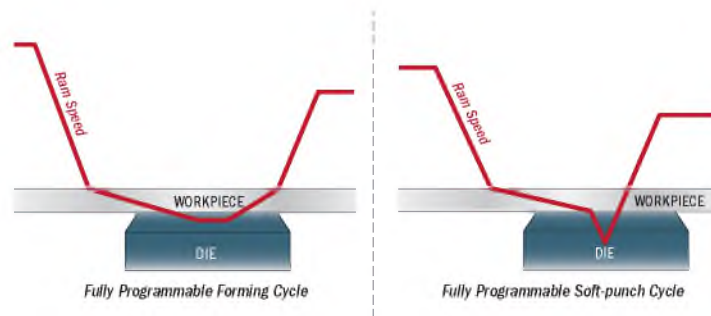


**Average energy consumption in punching: 6,7 kW.**

**Energy consumption in Stand-by: 0,9 kW.**

## PROGRAMMABLE RAM

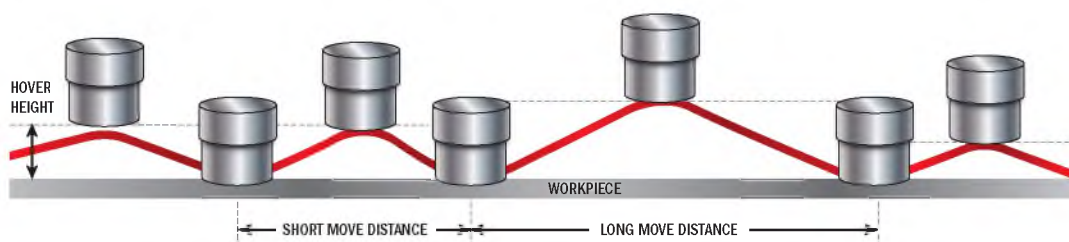
Machines feature a fully programmable ram control system. The system includes individual ram cycle profiles for punching and forming, Wilson "Wheel" tooling, tapping and Quiet Punch so users can easily, efficiently gain the most productivity from their V/VX machine.



## PATENTED SMART STROKE® MAXIMIZES PRODUCTIVITY

The patented Smart Stroke® feature automatically optimizes the ram motion for the highest productivity. No program codes or operator intervention needed. Hover heights are automatically optimized which keeps the tool close to the material for short table moves. As hits move farther apart, Smart Stroke automatically increases the ram hover height to provide clearance for sheet warpage.

### HOW SMART STROKE MAXIMIZES PRODUCTIVITY

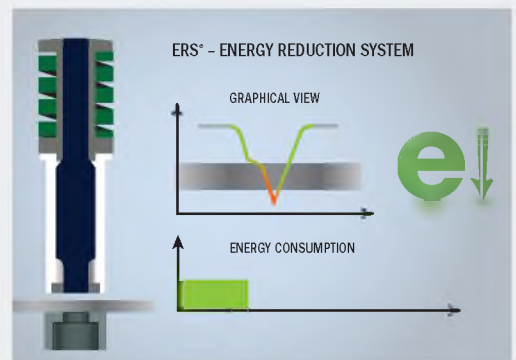


*Strippit's Smart Stroke automatically selects the optimum hover height for each table move.*

*ERS reduces energy consumption by up to 15%*

## ERS - ENERGY REDUCTION SYSTEM

An energy reduction system automatically reduces power consumption when the machine is idle. ERS reduces energy consumption by up to 15% compared to previous Strippit punch presses.



## KEY FEATURES

# Flexible Turret



A large capacity turret features 48 stations.

## FLEXIBLE TURRET DESIGN

Strippit V/VX machines offer the most flexible turret configurations available. Large turret capacity – 48 stations – enables the use of a standard turret load. Large 88,9 mm auto-index stations accept indexable Multi-Tools to increase turret capacity to 76 tools.

- Large direct-driven, fully-indexable stations
- Bi-direction turret
- Generous feed clearance for forming
- Consistent accuracy
- Fast tool change

## SLEEVED TURRET

Hardened turret sleeves ensure accurate punch and die alignment throughout the life of the machine. Sleeves can be easily replaced by the operator, eliminating the need for costly re-machining of the turret.

## INDEXABLE MULTI-TOOL

The Strippit V/VX-Series can be equipped with optional indexable Multi-Tool units in 3- or 8-station configurations.

These Multitools provide indexing of any tool at any angle, which increases flexibility and productivity. The possible indexable increments are 0,01°.



*Multi-Tool remains in the turret; subsequent tool selection by program is completed in less than one second.*



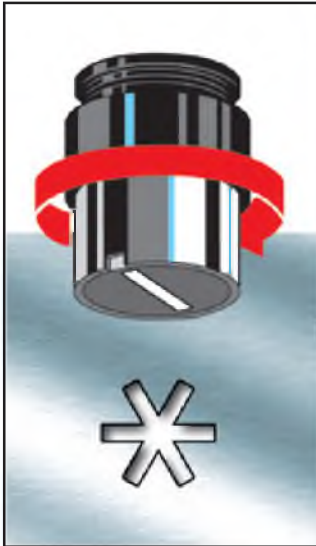
## TOOLING TECHNOLOGY

Strippit V/VX-Series machines feature Thick Turret tooling allowing users to exploit a world of advanced tooling applications with forming, embossing, louvering, Wheel and tapping tools.



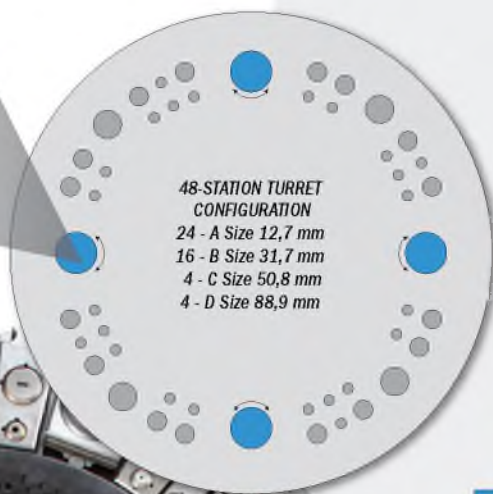
## AUTOMATIC INDEXING


*Rotates both the punch and die to any angle*



*Punch any tool at any angle  
anywhere on the sheet*

*Up to 76 tool capacity, with  
up to 32 fully indexable tools*

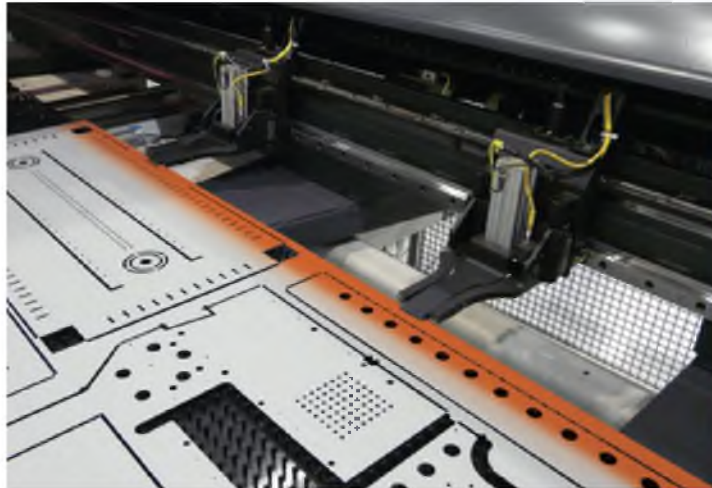
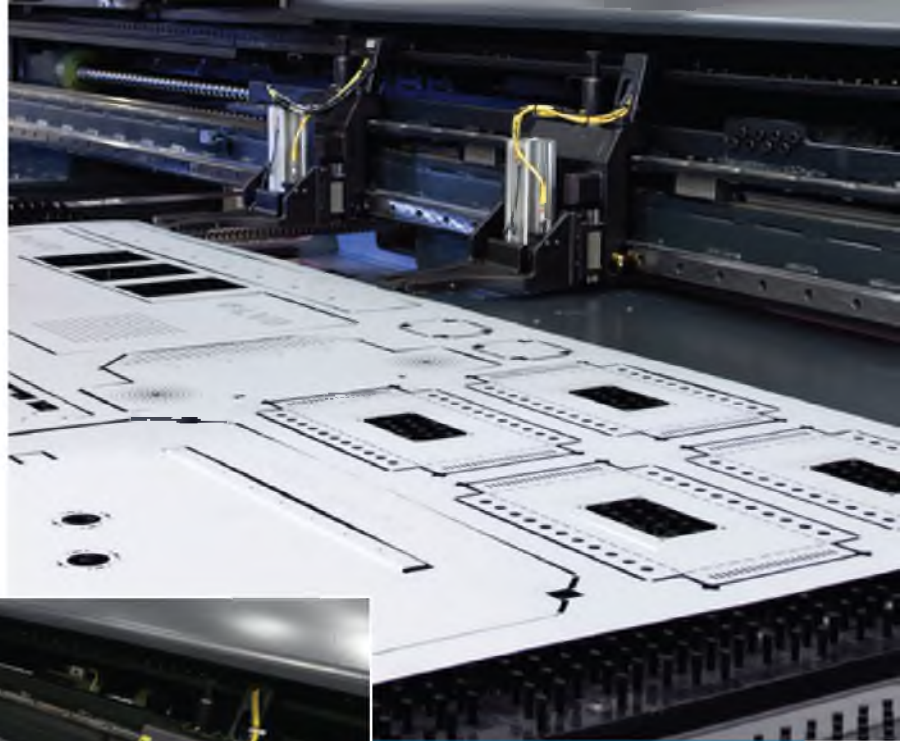


 Indicates Standard  
Auto-Index Station



KEY FEATURES

# Complete Sheet Utilization



*Programmable work clamps increase sheet utilization by up to 5,5% on a 3 x 1,5m sheet*

*Punch up to 85 mm from the edge of the sheet for full sheet usage.*

## PROGRAMMABLE AND RE-LOCATABLE CLAMPS

Automating work clamp movement between jobs and during a punching cycle reduces setup time and increases productivity. The Strippit V/VX-Series features three programmable and relocatable work clamps with sheet pull out sensors as standard. Work clamps automatically position and can be automatically relocated during the program for total sheet utilization and beneficial material savings. Programmable work clamps never require manual adjustment.

## SMART CLAMP™

Smart Clamp™, another standard Strippit V/VX-Series feature, automatically determines exact clamp locations to provide the smallest possible no punch zones in combination with the selected tool station.



## INTEGRATED FANUC CONTROL & MOTOR DRIVE PACKAGE

All Strippit punch presses are equipped with an integrated Fanuc motor drive and control package for full control of the punching process. The control allows the machine operator to edit, input or output programs during machine operation to reduce setup and improve productivity. The Strippit V/VX-Series features direct-drive AC servo motors for fast acceleration and dynamic operation.

## BRUSH BED DESIGN

Strippit V/VX-Series machines feature a full bristle bed construction ideally suited for processing of scratch-sensitive materials. The bristle bed configuration also minimizes punching noise levels.

## FRAME CONSTRUCTION

Strippit punch presses feature a robust, closed-welded frame construction for high stability, speed and punching accuracy.

## WORK CHUTE

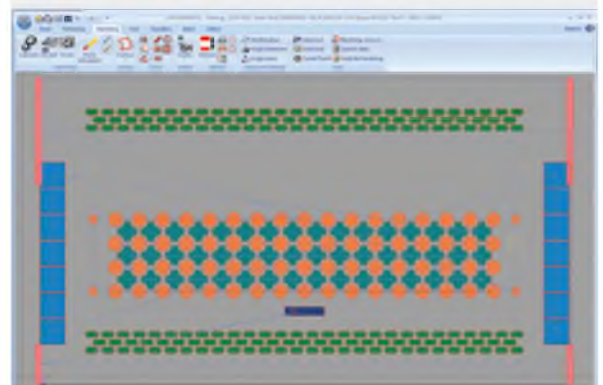
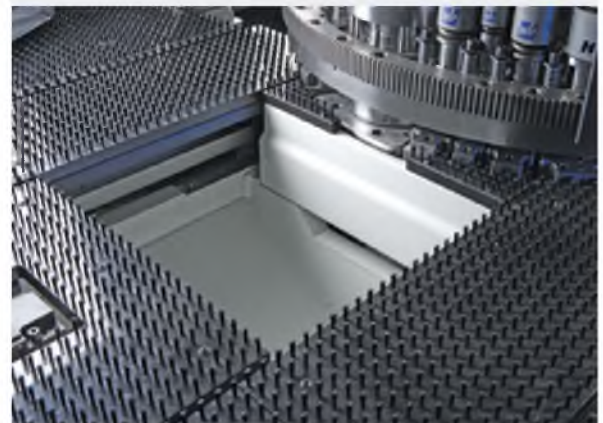
For the removal of smaller piece parts, Strippit V/VX-Series machines are equipped with a programmable parts removal chute. Parts up to 450 x 500mm can be evacuated from the sheet into a parts bin directly under the machine table or to an optional bin-sort system.



## OFFLINE PROGRAMMING

LVD's optional CADMAN® software package offers the ideal solution to quickly prepare and execute offline programs and integrate production processes for greater productivity.

*Edit, input or output programs  
during machine operation*



## KEY FEATURES

# Modular Automation

Enhance the efficiency of a Strippit V/VX-Series machine with a modular automation solution designed to eliminate up to 80% of manual sheet handling and increase productivity up to 50%. Automation options are retrofitable or factory installed.

### AUTOMATIC LOAD/UNLOAD

A patented automatic load/unload system reduces manual worksheet handling time as much as 80% and provides efficient processing of materials up to 3,5 mm. The compact, space-saving design loads and unloads material from the same side of the machine.

### COMPACT TOWER (CT-P)

A Compact Tower (CT-P) 6 or 10 pallet provides full capabilities for loading, unloading, and storage of raw material and finished parts, enabling automated production from stored raw material to stacked finished parts.

### PICK-SORT ROBOTIC SYSTEM

A robotic Pick-Sort material handling system converts a Strippit V/VX-Series machine into a freestanding, lights-out production cell. Machine and robot are integrated for maximum productivity.



*Load/unload system features full brush table for reduced part scratching.*



*Pick-Sort system loads full size sheets and automatically retrieves and stacks individual punched parts.*



## STRIPPIT V/VX-SERIES

# Specifications

### STRIPPIT V30-1225

### STRIPPIT V30-1525

### STRIPPIT VX-1225

### STRIPPIT VX-1525

#### PUNCHING SPECIFICATIONS

Maximum Punching Capacity	300 kN	300 kN	200 kN	200 kN
Max. Material Thickness	6,35 mm	6,35 mm	6,35 mm	6,35 mm
Punching Accuracy	± 0,1 mm	± 0,1 mm	± 0,1 mm	± 0,1 mm
Maximum Hit Rate at 2 mm Working Stroke (1)				
1 mm Pitch	Up to 1000 HPM	Up to 1000 HPM	Up to 920 HPM	Up to 920 HPM
25 mm Pitch	Up to 425 HPM	Up to 425 HPM	Up to 530 HPM	Up to 530 HPM
Feed Clearance	25 mm	25 mm	25 mm	25 mm
Nominal Workpiece Size (2)	1250 x 2500 mm	1524 x 2500 mm	1250 x 2500 mm	1524 x 2500 mm

#### TABLE TYPE CAPACITIES

Brush Table (3)	Up to 150 kg	Up to 150 kg	Up to 150 kg	Up to 150 kg
Combo Ball/Brush (3)	Up to 150 kg	Up to 150 kg	N.A.	N.A.
Fully Programmable Work Chute (X,Y)	450 x 500 mm	450 x 500 mm	450 x 500 mm	450 x 500 mm
Clamps	3 CNC relocatable Part pull out sensing standard	3 CNC relocatable Part pull out sensing standard	3 CNC relocatable Part pull out sensing standard	3 CNC relocatable Part pull out sensing standard
Maximum Clamp Spread	2300 mm	2300 mm	2100 mm	2100 mm

#### TURRETS

Turret Configuration	48 Stations	48 Stations	48 Stations	48 Stations
Turret Layout (all models)	24 - 12,7 mm A Size / 16 - 31,7 mm B Size / 4 - 50,8 mm C Size / 4 - 88,9 mm D Size			
Auto-index Stations	4 - 88,9 mm D Size	4 - 88,9 mm D Size	4 - 88,9 mm D Size	4 - 88,9 mm D Size
Angular Positioning Accuracy	± 0,05 degrees	± 0,05 degrees	± 0,05 degrees	± 0,05 degrees
Axes Traverse Speeds	Up to 128 m/minute combined	Up to 128 m/minute combined	Up to 161 m/minute combined	Up to 161 m/minute combined

#### ELECTRICAL POWER CONSUMPTION

Average Power Consumption, approx.	6,7 kW	6,7 kW	6,7 kW	6,7 kW
Standby Operation, approx.	0,9 kW	0,9 kW	0,9 kW	0,9 kW

(1) Material thickness + tip recess + die penetration

(2) Larger workpiece sizes handled with clamp reposition

(3) at a reduced feed rate

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