



PRESSES

MECHANICAL • HYDRAULIC • SERVO

Hydraulic Die Spotting & Tryout Presses

HST Series

50T - 2000T



Safeties conform to:
CE (EN-16092 : 2018)
OSHA 1910.217
CSA-Z142
NR-12

ISO 9001:2015
ISO 14001:2015
OHSAS 18001:2007

Presses for Die & Mold Accuracy Verification, Finish & Startup

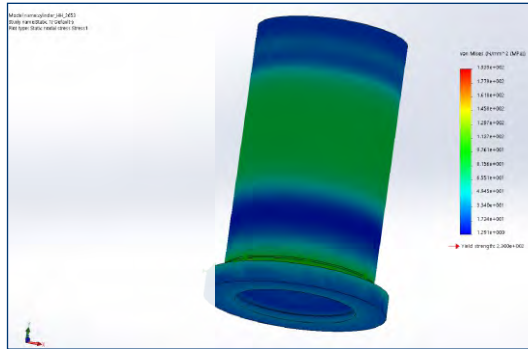
High Precision (Accuracy) • Superior Ergonomics • Enhanced Safety & Controls



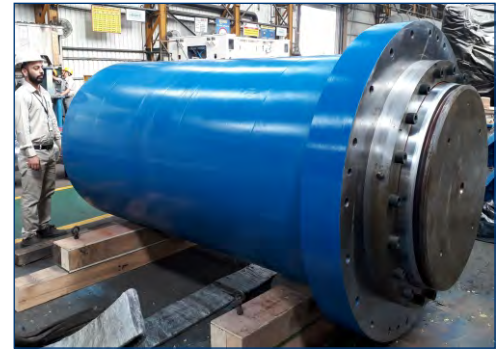
Isgec Die Spotting Presses are ideal for spotting work for a variety of dies in applications like Sheet Metal, Plastics, Die Casting etc. Further our in house experienced design & application engineering teams are committed to offer optimum solutions suiting customer's critical requirements.

Design & Engineering

- Press structure is designed and FEA is done to ensure low stresses in critical structural area
- Fabricated structure is **thermally stress relieved** to ensure long life.



Finite Element Analysis of Cylinder



Cylinder

Geometrical Accuracies



Zeiss Coordinate Measuring Machine



Waldrich Plano Miller

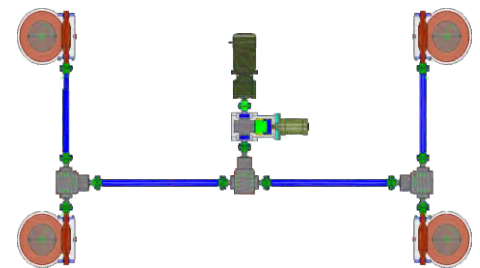
- Parts manufactured on high- precision CNC machines for built-in sustainable geometrical accuracies
- Best-in-class Geometrical Accuracies as per **JIS B 6403 Special Grade** with deflection upto 0.10mm/m or better as per customer demand
- Extra Long Guides to maintain accuracies for longer operation

High Accuracy & Precision

- Equalizer Beam to ensure Slide parallelism.
- Micro Inching Adjustment - accuracy of 0.05 mm per push for highly accurate spotting of dies.



Equalizer Beam



Mechanical Micro Inching Adjustment

Slide Bottom Plate Tilting (90° & 180°) for Ease of Operation and High Productivity

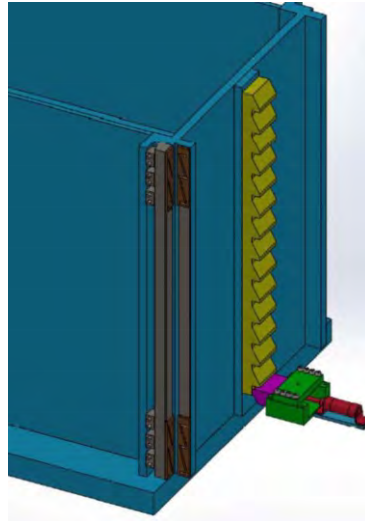
Die tilting by 90° or 180° for quick & easy repair of top die & low operator fatigue to ensure high productivity. Moving bolster movement from Center to Front for quick die change providing high uptime for press



Safety



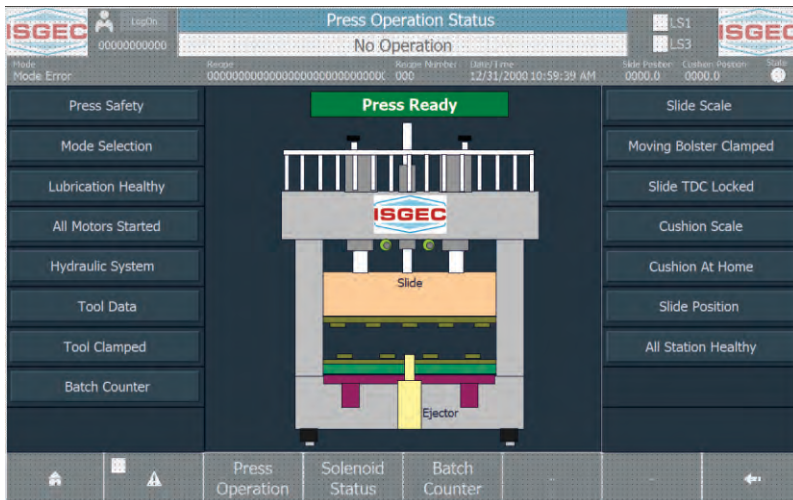
Automatic Swing Arm assembly duly interlocked with Slide Movement Photoelectric Guards & Two Hand Run Button Station for Operator Safety



Slide Locking at selected pitch for Operator Safety & ease of reworking of upper Dies



300T Die Spotting Press supplied to Japanese OEM in India



Ease of Operation

Programmable Logic Controller with User Friendly Operator Interface through Ergonomically designed operator screens.

HMI (Human Machine Interface) screens with Diagnostic features developed through constant feedback from Press users.

1000T Tryout Press with 300T Spotting option supplied to Japanese Stamping Die Manufacturer in India



Standard Accessories

- Slide Locking at TDC
- Slide Locking at selected Pitch
- Safety Blocks
- Photoelectric Safety Guards
- PLC & HMI including Self Diagnostics
- Moving Bolster in Centre to Front Direction
- Oil Filtering & Magnetic Particle Capturing (Built in Circuit)

Optional Accessories

- Mechanical Micro Inching
- Hydraulic Micro Inching
- Equalizer Beam for Slide Parallelism
- Slide Plate Tilting - Angle of Rotation 90 deg & 180 deg
- Automatic Swing Arm
- Electronic Force Monitoring with Signature Analysis

Technical Specifications

Hydraulic Die Spotting								
Model		HST-50	HST-100	HST-150	HST-200	HST-300	HST-400	HST-500
Capacity	kN	500	1000	1500	2000	3000	4000	5000
Stroke	mm	1500	1500/2000	1500/2000	1500/2000	1500/2000	1500/2000	1500/2000
Day Light	mm	2000	2000/2500	2000/2500	2000/2500	2000/2500	2000/2500	2000/2500
Bolster Size-Alt1	mm	2500 x 1600	2800 x 1600	3400 x 1900	3400 x 1900	3400 x 1900	4000 x 2500	4000 x 2500
-Alt2	mm	3100 x 1900	3400 x 1900	4000 x 2500	4000 x 2500	4000 x 2500	4600 x 2500	4600 x 2500
-Alt3	mm	3400 x 1900	4000 x 2500	4600 x 2500	4600 x 2500	4600 x 2500	5000 x 2800	5000 x 2800
Fast Approach	mm/s	60	60	60	60	60	60	60
Pressing Speed	mm/s	1-10	1-10	1-10	1-10	1-10	1-10	1-10
Return Speed	mm/s	60	60	60	60	60	60	60

Customized Solutions & Speeds specifically suitable for Application & Cycle Time can be provided on request

Hydraulic Tryout / Spotting Press						
Model		HST-800	HST-1000	HST-1200	HST-1500	HST-2000
Capacity Tryout-Spotting	kN	8000-2000	10000-3000	12000-3000	15000-3000	20000-4000
Stroke	mm	1500	1500	1500	2000	2000
Day Light	mm	2000	2000	2000	2500	2500
Bolster Size-Alt1	mm	3400 x 1900	4000 x 2500	4000 x 2500	4000 x 2500	4600 x 2500
-Alt2	mm	4000 x 2500	4600 x 2500	4600 x 2500	4600 x 2500	5100 x 3100
Fast Approach	mm/s	265	265	265	265	265
Pressing Speed Tryout-Spotting	mm/s	10-20/ 1-10	10-20/ 1-10	10-20/ 1-10	10-20/ 1-10	10-20/ 1-10
Return Speed	mm/s	235	235	235	235	235
Die Cushion	kN	1600	2000	2400	3000	4000

Customized Solutions & Speeds specifically suitable for Application & Cycle Time can be provided on request

Wide Range of Presses

Tandem Press Lines • Transfer Press Lines • Progressive Die Press Lines • Blanking Press Lines • High-Speed Mechanical Presses
 Deep Draw Hydraulic Presses • High-Speed Hydraulic Presses • Hot Forming Press Lines • Tryout Mechanical Presses
 Die Spotting/Tryout Hydraulic Presses • Refractory Press Solutions • Hot/Cold Forging Presses • Special Application Presses



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 Turkey • USA • Vietnam

Some of the accessories / fitments shown in the reference photograph may not be part of Standard equipment supplied.

Isgec reserves the right to change specifications without prior notice.

Details given in this Brochure are indicative & may change.