



**PRESSES**

MECHANICAL • HYDRAULIC • SERVO

## *Hot Stamping Press*

*HSP Series*

800T – 1800T



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

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

**Value for Money - Make in India with European Technology**

**High Reliability • High Endurance • High Productivity**

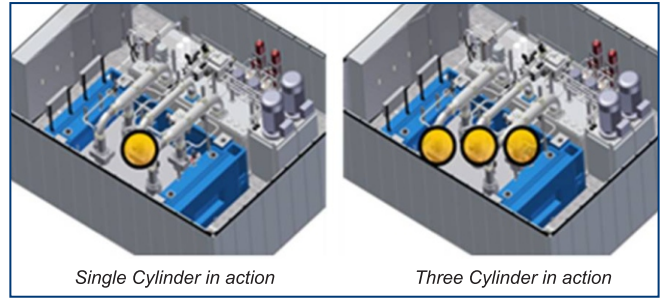


The terms Hot Stamping and Press Hardening are commonly known and used in the Automotive industry. The benefit of using ultra high-strength steels; such as Boron Steels, allows car manufacturers to build lighter yet stronger and safer vehicles. Before the hot stamping process, the blanks for the components are cut from coiled material - Boron steel that have initial yield strength of 500MPa. Then the blanks are heated to approximately 950 Deg. C or 1740 Deg. F. The red hot parts are placed in Press Dies.

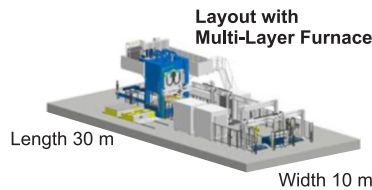
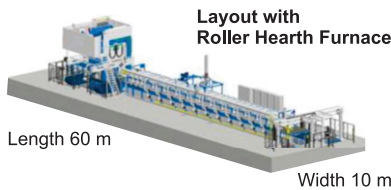
This is followed by forming and quenching within the Die. When Die is pressed in the Press within a short period of time, the parts are formed & cooled to about 200 Deg. C or 400 Deg. Fusing Rapid Controlling that is achieved by passing cold water through water flow cavities in top and bottom tool sections. The result is an austenitic grain structure, which gives the parts yield strength of around 1500MPa.

### Salient Features

- Multi-Cylinders that operate as per speed & force requirement to optimise press operations
- High Approach Speeds up to 750 mm/sec
- Equipped with Superior Slide Parallelism System
- Rigid Design & Guide System to counter off-center forces
- Slide & Bolster have provisions for Die Cooling water supply
- Media interface for measurement of Die Cooling water & flow
- Moving Bolster for Quick Die Change (QDC)



### Types of layout & Composition of an Automated Hot Stamping Line



#### Composition of Automated Hot Stamping Line

- De-Stacking and Marking Station
- Furnace Loading and Unloading
- Component Loading into Press
- Press
- End of Line Station with Racking

### Technical Specifications

Press Tonnage	Unit	800T	1000T	1200T	1600T	1800T
Press Model		HSP800	HSP1000	HSP1200	HSP1600	HSP1800
Daylight	mm	2200	2200	2200	2200	2200
Slide Stroke	mm	1200	1200	1200	1200	1400
Bolster / Slide Size	mm	3000 x 2200	3000 x 2500	3000 x 2500	3000 x 2500	5000 x 2500
Bolster Capacity	Ton	25	28	32	32	45

**Technical Alliance with AP&T for Complete Hot Stamping Lines**

ISGEC APT  
AUTOMATION · PRESSES · TOOLING

### Wide Range of Presses

Servo Presses • Transfer Presses • Progressive Presses • High Speed Presses • Hot Stamping & Hot Forming Hydraulic Presses  
Standard Straight Sided Mechanical & Hydraulic Presses • Blanking Lines • Tandem Press Lines - Mechanical & Hydraulic  
Cold Forging Presses • Tryout & Die Spotting Presses • Gap Frame & Ring Frame Power Presses • Special Purpose Presses



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E-mail: smpbawal@isgtec.com

**Eagle Press & Equipment Co. Ltd.**  
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Malaysia • Mexico • Russia • South Africa • Spain • Thailand • 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.