

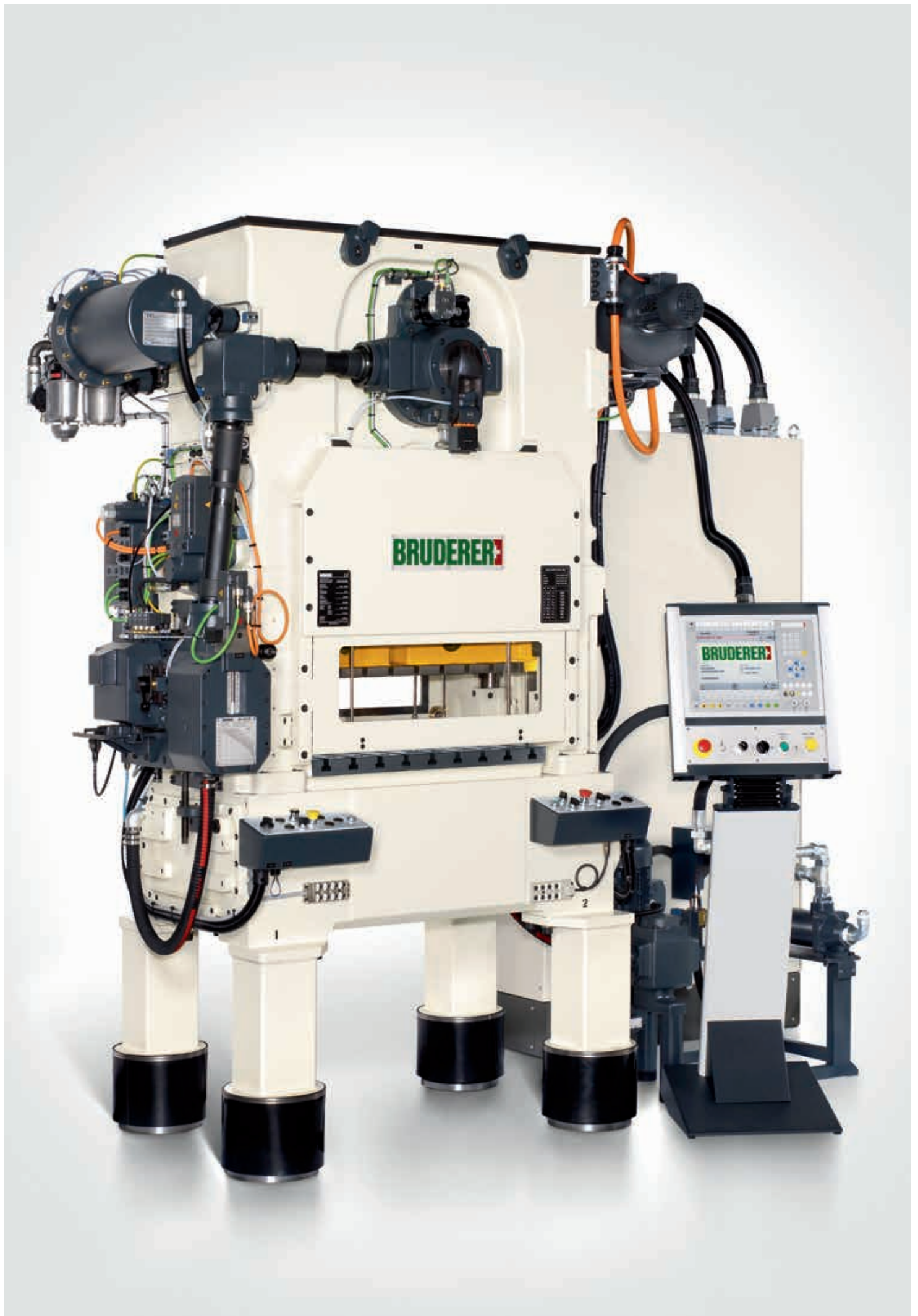
BSTA 280

BRUDERER+

PRECISION – SWISS MADE

**Innovations and
experience bringing
success to your
products.**





Our experience – for your benefit.

Every BSTA stamping press contains decades of experience that we have built up, in responding to the demands of ambitious customers.

Important innovations and solutions which pay attention to the little details are designed to help you produce more efficiently using our machines. Try them out for yourself.

The advantages of the BSTA 280 at a glance.

Adjustable stroke with mass balancing system together with latest control technology:

- for a multitude of applications
- for a wide variety of stroke heights

Thermoneutral ram-guiding system with tilting point control at strip level:

- for long tool life
- for optimum part quality

Ram adjustment during operation under production conditions:

- for an optimized tool set-up

Powerful clutch and brake unit

- for improved first and last strikes and therefore reduced waste

Micro-tolerances maintained in the bottom dead center (BDC):

- for increased process stability

Precision engineering and the unique BRUDERER drive and lever system:

- for improved reliability and durability across the whole mechanical system

Integrated measuring and monitoring function:

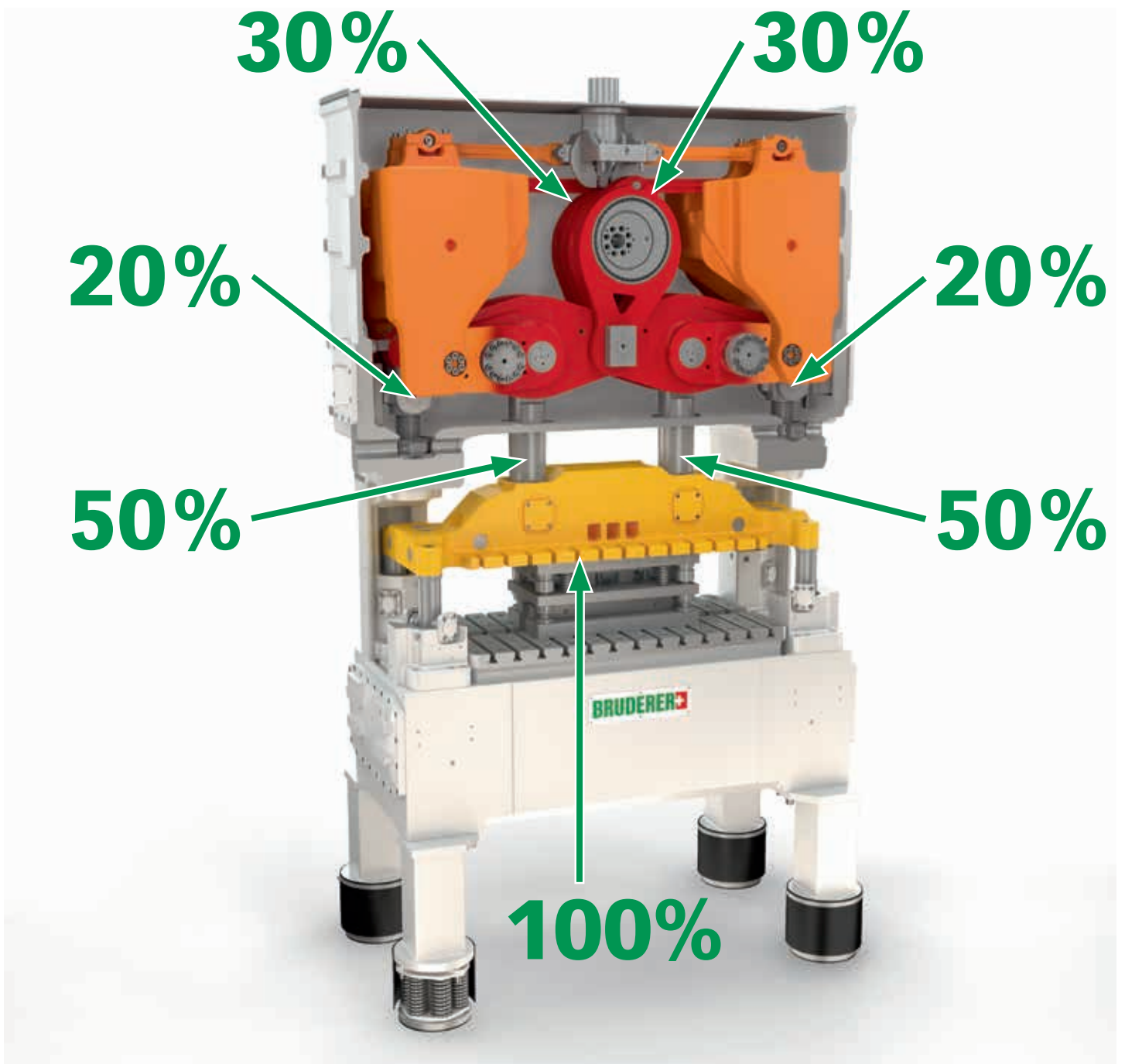
- improved process optimisation by means of simple control system usability

Easy attachment of peripheral devices:

- for quicker integration and maximum productivity

Power put to work in the right place.

Thanks to the unique lever system of the BSTA stamping press, the load acting on the ram is distributed across the system. This load distribution, together with the absolute minimum clearance and the efficient lubrication system, is a crucial factor in the high durability and consistent precision of the machine.



Making sure you can produce quicker, for longer and with more precision.

Regular stamping processes.

Thanks to the unique lever system, the hardened ground ram adjustment spindles only take up 20% of the total load each. This construction makes it possible to adjust the ram height during stamping and to maintain the BDC to the closest of tolerances throughout.

Longer tool life thanks to good guidance.

To prevent deflection of the punches when running the press with eccentric loads, the ram guide elements are placed exclusively on the same level as the strip. The guide bearings ensure that the thermal influences acting on the ram guides are compensated for, which in turn increase tool life.

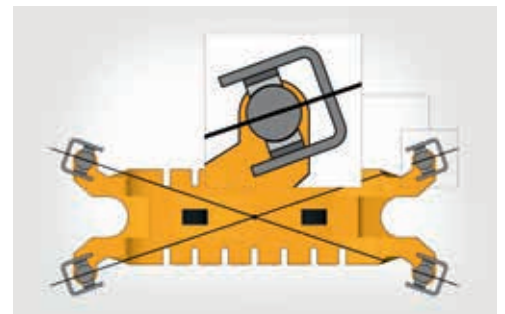
More flexibility thanks to the right setting.

The quicker stroke change enables different stroke height settings to be set quickly and safely, thus ensuring high levels of flexibility and a wide variety of implementations.

The feed timing of the strip feeder is thus synchronised without additional procedures



Ram adjustment during operation under production conditions.



Thermoneutral ram-guiding to compensate for horizontal expansion due to fluctuations in temperature.



Quicker stroke change for more flexibility.

Proven solutions.

Leading companies around the world have come to rely on the advantages that BRUDERER fully-automated stamping presses can provide, implementing their manufacturing expertise with our machines to make high-precision parts for products that have become indispensable in our everyday lives.

Wherever the ultimate in availability and precision is required at high and low stroke rates, BRUDERER is there to provide what is needed – for suppliers in the automotive industry, for the manufacturing of connectors for the electronics, electrical engineering and computer industries, for parts for watches and metal packaging for the food industry, to cite just a few examples.

This is how we support our customers, with our expertise and the added precision that our stamping presses provide when it comes to manufacturing quality products.



Technical data

BSTA 280.

			BSTA 280 -75	BSTA 280 - 88
Press force		kN	280	280
Tool loading area	L - R	mm	750	880
Speed	Min.	spm	100	100
- Adjustable stroke machine (standard)	Max.	spm	1500	1500
- Adjustable stroke machine ¹⁾	Max.	spm	2000 ¹⁾	2000 ¹⁾
Mains voltage (EN 60204) ^{A)}		V	400	400
Mains frequency (EN 60204) ^{A)}		Hz	50 / 60	50 / 60
Connected load ^{B)}	Max.	kVA	73 / 86 ¹⁾	73 / 86 ¹⁾
Control voltage		VDC	24	24
Drive power of main motor		kW	18,5 / 28 ¹⁾	18,5 / 28 ¹⁾
Compressed air connection R 1/2"	Min. Max.	bar bar	7 10	7 10
Adjustable stroke (standard)		mm mm	13 / 14 / 16 / 19 / 25 / 32 / 38 / 44 / 47	13 / 14 / 16 / 19 / 25 / 32 / 38 / 44 / 47
Adjustable stroke (option) ¹⁾		mm mm	6,5 / 8 / 10 / 13 / 16 / 19 / 25 / 35 / 40,5	6,5 / 8 / 10 / 13 / 16 / 19 / 25 / 35 / 40,5
Fixed stroke ^{A)}	Max.	mm	47	47
Ram adjustment range		mm	51	51
Shut height ^{A)} (according to stroke)	Min. Max.	mm mm	171 239	171 239
Bolster area	L - R F - B Height ^{C)}	mm mm mm	740 536 1154	870 536 1154
Ram area	L - R F - B	mm mm	646 360	776 360
Strip inlet height ^{A)}	Min. Max.	mm mm	50 120	50 120
Strip inlet width (machine)	Max.	mm	230	230
Base plate opening	L - R F - B	mm mm	700 180	830 180
Dimensions				
Press (standard BBV)	L - R	mm	2057	2057
- With semi-automatic stroke adjustment	F - B Height Weight (app.)	mm mm kg	1195 2730 5600	1195 2730 5800
- With automatic stroke adjustment	F - B Height Weight (app.)	mm mm kg	1230 2888 5650	1230 2888 5850
Strip feed unit				
	Standard Variations	BBV 180 BSV 75 BSV 170 BZV 61		

^{A)} Options on request. ^{B)} Incl. standard sockets for peripheral equipment. ^{C)} Above floor level.

¹⁾ Adjustable stroke machine with 2000 spm available as option.

Subject to change.

Competence centres:

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