



- SAFETY
- STABLE
- PRECISION
- ENERGY SAVING
- AUTOMATION

**25-315TONS**

**Performance Features**

ST series presses is C-Frame single crank press designed for small stamping applications but with high performance outputs.

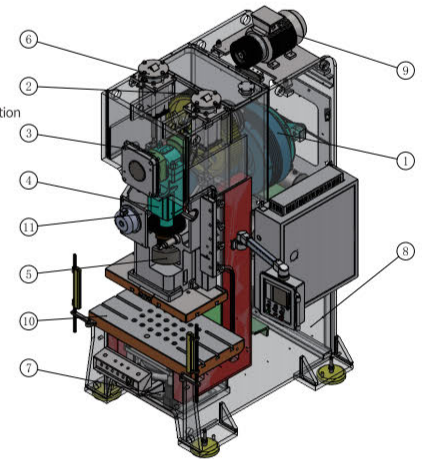
ST series presses are produced by Qiaosen presses, which built to meet or exceed JIS Class 1 accuracy standards. Qiaosen adopt high strength steel frames and Quenching & Grinding Process for Slide-Guide, which can make the press machine have minimizing deflection and high accuracy and provide increased tool life.

Forged 42CrMo alloy material crankshaft, precision-machined gears and other drive train components are designed for smooth power transmission, quiet operation and long life. ST series presses are dry clutch system, It has longer service life of the clutch system, high single stroke rate and high torque outputs performance.

Siemens based control platform and user-friendly touch screen operation interface are standardized in all QIAOSEN's presses, it provides ease of operation and expandable capabilities. Easy to integration with other automation system. Other brands of control can be furnished upon request.

① Flywheel+Dry Clutch Brake+Gear Shaft (Transmission System)

- ② Main gear
- ③ Crankshaft
- ④ Connecting Rods
- ⑤ Hydraulic Overload Protection
- ⑥ Balancer
- ⑦ Die Cushion
- ⑧ Frame
- ⑨ Main Motor
- ⑩ Bolster
- ⑪ Slide Frame



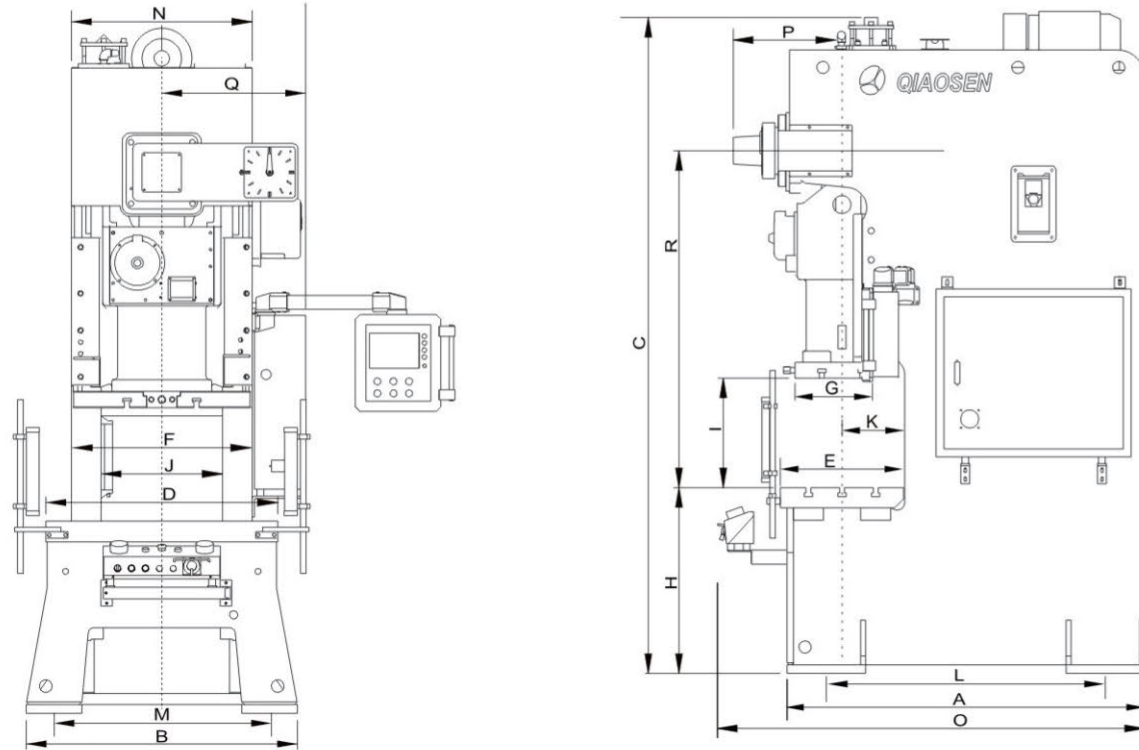
- ◆ Heavy one-piece steel frame, minimizing deflection, high accuracy.
  - ◆ OMPPI pneumatic dry clutch brake, longer service life.
  - ◆ 6 points slide guiding, Adopt Quenching & Grinding Process for Slide-Guide, which can make the press machine higher accuracy & low wear and provide increased tool life.
  - ◆ Forged 42CrMo alloy material crankshaft, its strength is 1.3 times higher than that of #45 steel, and service life is longer.
  - ◆ Copper sleeve is made of tin phosphorus bronze ZQSn10-1, which has a strength 1.5 times higher than that of ordinary BC6 brass.
  - ◆ Highly sensitive hydraulic overload protection device, effectively protect the service life of the presses and tools.
- Built to JIS Class I accuracy standard.
- ◆ Optional Die Cushion.

**Technical Parameters**

Name	Unit	ST-25		ST-35		ST-45		ST-60	
		V-type	H-type	V-type	H-type	V-type	H-type	V-type	H-type
Mode		V-type	H-type	V-type	H-type	V-type	H-type	V-type	H-type
Press capacity	Ton	25		35		45		60	
Rated tonnage point	mm	3.2	1.6	3.2	1.6	3.2	1.6	4	2
Slide strokes per minute	S.P.M	60~140	130~200	40~120	110~180	40~100	110~150	35~90	80~120
Slide stroke length	mm	60	30	70	40	80	50	120	60
Max die height	mm	200	215	220	235	250	265	310	340
Slide adjustment amount	mm	50		55		60		75	
Slide size	mm	470*230*50		520*250*50		560*340*60		700*400*70	
Bolster size	mm	680*300*70		800*400*70		850*440*80		900*500*80	
Slide center to machine distance	mm	155		205		225		255	
Platform to floor distance	mm	795		790		790		785	
Shank hole	mm	Φ38.1		Φ38.1		Φ38.1		Φ50	
Main motor power	KW*P	3.7*4		3.7*4		5.5*4		5.5*4	
Slide adjust device	/	Manual		Manual		Manual		Manual	
Air pressure	kg*cm <sup>2</sup>	6		6		6		6	
Press accuracy grade	Grade	JIS 1		JIS 1		JIS 1		JIS 1	
Press dimension(L*W*H)	mm	1280*850*2200		1380*900*2400		1575*950*2500		1595*1000*2800	
Press weight	Tons	2.1		3		3.8		5.6	
Die cushion capacity	Ton	/		2.3		2.3		3.6	
Die cushion stroke	mm	/		50		50		70	
Die cushion active area	mm <sup>2</sup>	/		300*230		300*230		350*300	

ST-80		ST-110		ST-160		ST-200		ST-260		ST-315	
V-type	H-type	V-type	H-type	V-type	H-type	V-type	H-type	V-type	H-type	V-type	H-type
80		110		160		200		260		315	
4	2	6	3	6	3	6	3	7	3.5	7	3.5
35~80	80~120	30~60	60~90	20~50	40~70	20~50	50~70	20~40	40~50	20~40	40~50
150	70	180	80	200	90	200	100	250	150	250	150
340	380	360	410	460	510	460	510	500	550	520	570
80		80		100		110		120		120	
770*420*70		910*470*80		990*550*90		1130*630*90		1250*700*100		1300*750*100	
1000*550*90		1150*600*110		1250*800*140		1400*820*160		1500*840*180		1600*840*180	
280		305		405		415		430		430	
830		830		900		995		1030		1030	
Φ50		Φ50		Φ65		Φ65		Φ65		Φ65	
7.5*4		11*4		15*4		18.5*4		22*4		30*4	
Electric		Electric		Electric		Electric		Electric		Electric	
6		6		6		6		6		6	
JIS 1		JIS 1		JIS 1		JIS 1		JIS 1		JIS 1	
1800*1180*2980		1900*1300*3200		2315*1400*3670		2615*1690*4075		2780*1850*4470		2780*1870*4470	
6.5		9.6		16		23		32		34	
3.6		6.3		10		14		14		14	
70		80		80		100		100		100	
450*310		500*350		650*420		710*480		810*480		810*480	

External Dimensions



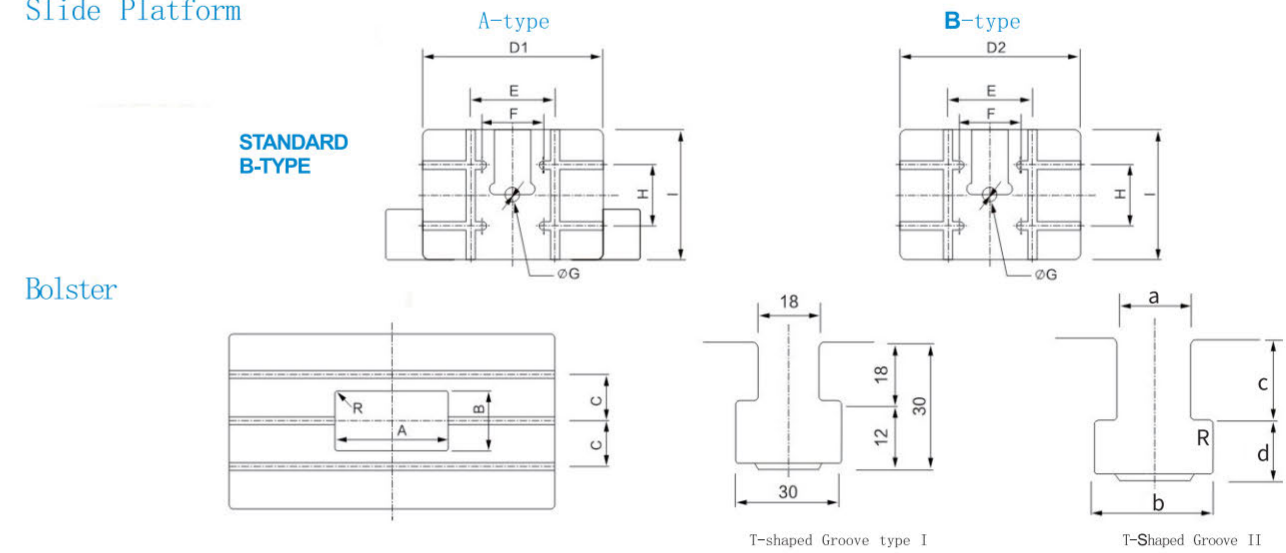
Specification	ST-25	ST-35	ST-45	ST-60	ST-80	ST-110	ST-160	ST-200	ST-260	ST-315
A	1100	1200	1400	1420	1595	1720	2140	2440	2605	2605
B	840	900	950	1000	1170	1290	1390	1690	1850	1870
C	2135	2345	2425	2780	2980	3195	3670	4075	4470	4490
D	680	800	850	900	1000	1150	1250	1400	1500	1500
E	300	400	440	500	550	600	800	820	840	840
F	470	520	560	700	770	910	990	1130	1130	1130
G	250	285	340	400	420	470	550	630	700	700
H	800	790	800	795	830	830	910	1030	1030	1030
I	260	290	320	420	480	530	650	650	750	770
J	444	488	502	526	534	616	660	790	900	900
K	160	205	225	255	280	305	405	415	430	430
L	980	1040	1170	1180	1310	1420	1760	2040	2005	2005
M	700	800	840	890	980	1100	1200	1400	1560	1580
N	540	620	670	720	780	920	1000	1160	1300	1320
O	1275	1375	1575	1595	1770	1895	2315	2615	2780	2780
P	278	278	313	333	448	488	545	593	688	688
R	935	1073	1130	1378	1506	1650	1960	2188	2460	2480

Standard Configuration

- > Hydraulic overload protection device
- > Manual slider adjustment device (below ST60)
- > Electric slider adjusting device (above ST80)
- > Variable frequency variable speed motor (adjustable speed)
- > Mechanical die height indicator (below ST60)
- > Digital die height indicator (above ST80)
- > Slider and stamping tools balance device
- > Rotating cam controller
- > Crankshaft angle indicator
- > Electromagnetic counter
- > Air source connector
- > Second degree falling protecting device

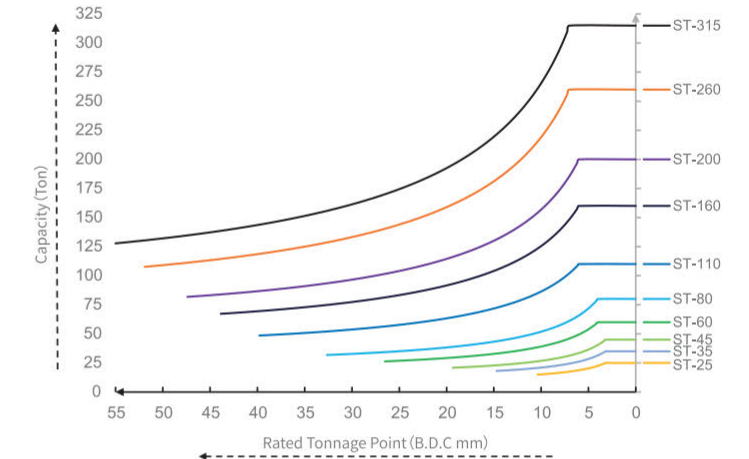
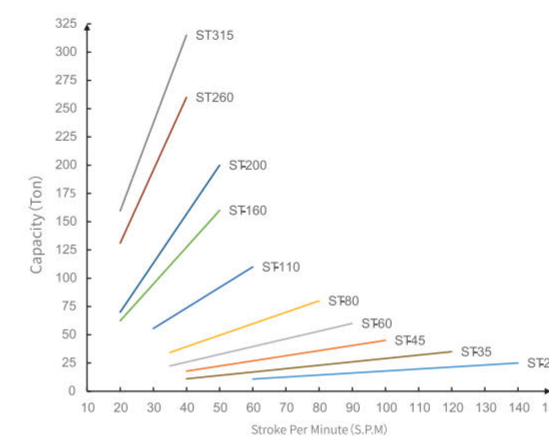
- > Air blowing device
- > Mechanical shockproof feet
- > Mis-feeding detection device reserved interface
- > Maintenance tools and toolbox
- > Main motor reversing device
- > Light Curtain (Safety Guarding)
- > Power outlet
- > Electric grease lubrication device
- > Touch screen (pre-break, pre-load)
- > Fixed two-handed operating console
- > LED die lighting

Slide Platform



Model	A	B	C	D1	D2	E	F	G	H	I	T Groove
ST-25	240	120	90	300	470	-	150	Φ38.1	80	230	I
ST-35	280	140	120	360	520	-	160	Φ38.1	100	250	I
ST-45	300	150	120	400	560	-	210	Φ38.1	120	300	I
ST-60	320	160	150	500	700	220	220	Φ50	160	360	II
ST-80	360	180	150	560	770	300	220	Φ50	180	420	II
ST-110	400	200	160	650	910	300	220	Φ50	220	470	II
ST-160	440	220	220	700	990	300	175	Φ65	220	550	II
ST-200	480	240	280	850	1130	420	200	Φ65	300	630	II
ST-260	520	260	290	950	1250	420	200	Φ65	300	700	II
ST-315	520	260	290	950	1300	420	200	Φ65	300	700	II

Capacity Graph



Optional Configuration

- > Customization Per Customer Requirement
- > Die Cushion
- > ST-60 die height electric adjusting device
- > Quick Die Change System
- > Slide knock out device
- > Turnkey System with Coil Feedline and Automation System

- > T-type movable two handed console
- > Re-Circulating Oil lubrication (Above ST-80)
- > Wet clutch
- > Anti-Vibration Isolator
- > Tonnage Monitor