

## 1.3.5 H5 multi-press head

The H5 type head has been designed to allow particularly fast operation because the workpiece takes a very short time to move underneath the operating head. The special configuration of this symmetrically arranged head means that symmetrical tools can be installed in symmetrically opposite positions with the result that the sheet needs to be moved less because it can be taken under one of the two rows of 260 kN punches alternately. Like the H2 head, the H5 head is also very versatile because of the compromise that has been obtained between the number of 70 kN and 260 kN tools and the possibility of housing optional tools on the front and at the side.

The fixed stations in the H5 head include the following:

- 24 single-action hydraulic presses with a maximum force of 70 kN (where the maximum figure of the tool can be inscribed in a 33 mm diameter circle);
- 8 single-action hydraulic presses with a maximum force of 260 kN (where the

maximum figure of the tool can be inscribed in a 90 x 70 mm rectangle or, in the case of 4 of them, a 90 mm square).

The following options can be installed on the outside of the operating head:

- up to 5 PU\*\* hydraulic presses
- up to 5 PP\*\* hydraulic presses
- up to 5 BU\*\* hydraulic presses
- up to 5 MA\*\* stations
- up to 3 optional P2R\*\* double index punching units

Up to 3 optional lower-action hydraulic presses with a maximum force of 60 kN can also be installed in the same number of positions in the operating head. These can be used to make upward embossings or bends up to 6.5 mm high that can be inscribed in a 20 mm diameter circle.

A complete set of four-position cartridges for tools up to 33 mm in diameter, that are to be installed in the 70 kN stations, is supplied with the machine, together with a complete set of two-position cartridges for tools that are to be installed in the 260 kN stations.

\*\* can be put in any front position of the head.

TOOL STATIONS	LIMITING MEASURE	N. OF TOOLS IN EACH TYPE OF HEAD
Press specifications		H5
70 KN presses	ø max 33 mm	24
260 KN presses	90 x 90 mm max	8
PU - Optional 120 KN presses	ø max 60 mm	5
BU - Optional 80 KN embossing presses	ø max 60 mm	5
P2R - Optional double 120 KN indexing presses	ø max 60 mm	6
PP - Optional multiple 30 KN presses with 6 tools	ø max 33 mm cad.	30
EI - Optional 55 KN presses with lower embossing cylinder		3
MAXIMUM NUMBER OF PUNCHES IN THE HEAD		64

## Head H5 layout

