

Introducing the **NEW Electric Punching Center for Coil.**



The punch press that fabricates directly from coil, consumes less energy, requires less maintenance and is friendlier to the environment.

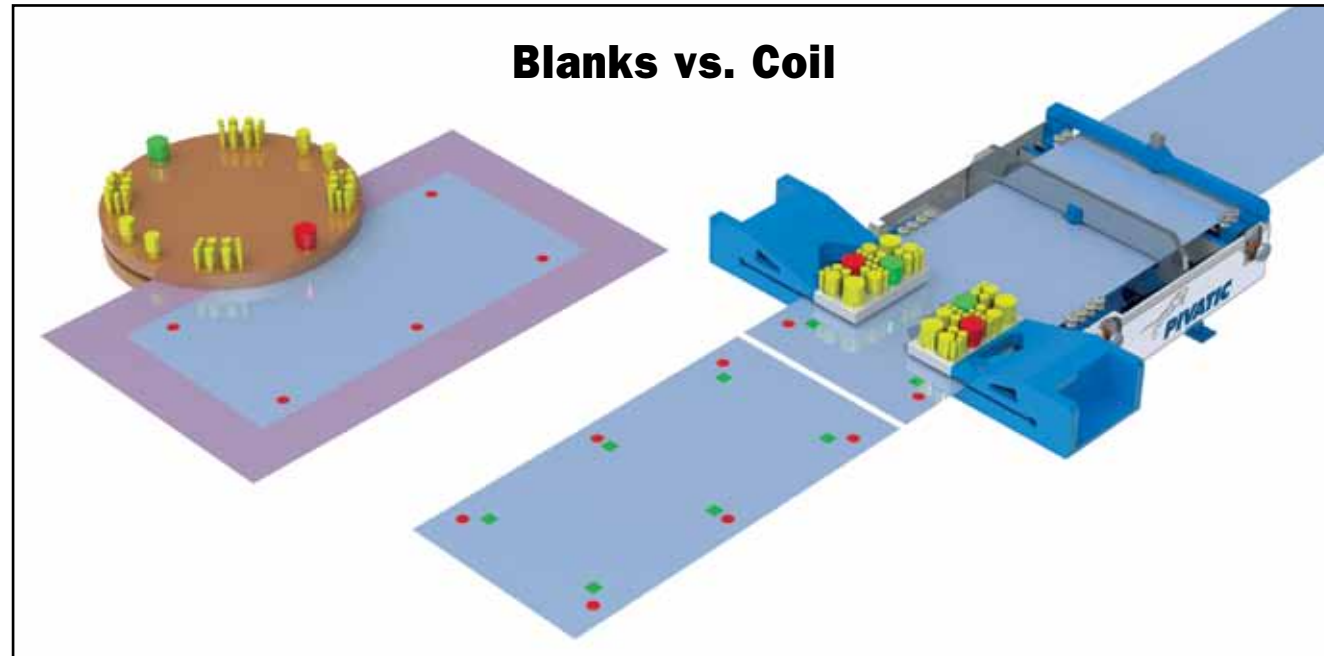


PIVATIC

Empowering productivity in sheet metal fabrication.

Pivatic's punching center, PivaPunch, creates a profitable leap for sheet metal manufacturers whether they produce high quantities or a variety of parts in small quantities.

Compared to turret punch presses, PivaPunch is substantially faster because the sheet metal runs straight through the punching tools. Using our method, hit rate is no longer critical in determining efficiency and output. Cycle times are exceptionally shorter and complete parts can be made in a single run.



PivaPunch method benefits:

- 100% of time is actual punching
- No tool change time – all tools active
- Strip fed from stroke to stroke non-stop
- No dead punching zones
- Double Tool Punch (DTP) feature: two holes or corners of a symmetrical pattern punched at the same time to minimize the cycle time (PCC125 and PCC150)
- No loading time with continuous coil feeding

- No unloading time with the stacker, stacking of punched blanks occurs during punching time
- True coil width utilization
- Includes enough tools to manage common coil width utilization

The Electric PivaPunch PCC-e

The electric model of PivaPunch has an electric high speed CNC controlled ram which has several advantages: no hydraulic system consuming energy and no maintenance required.

PivaPunch PCC-e benefits:

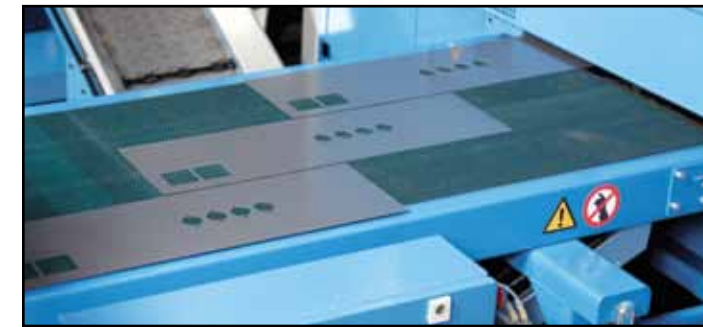
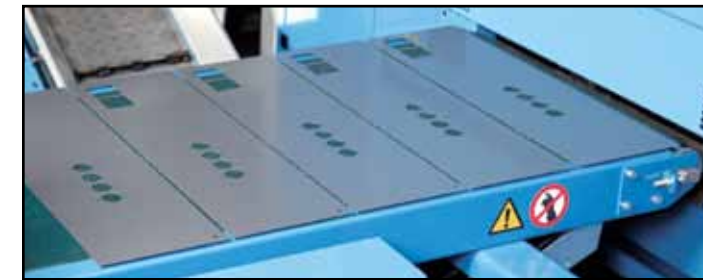
- Low energy consumption thanks to the all electric drives:
 - PCC60-e < 5 kVA
 - PCC125-e and PCC150-e < 10 kVA.
- Low maintenance costs
- Operator friendly environment
- Compact design and easy to relocate



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PivaPunch offers a variety of methods to ensure maximum material utilization when manufacturing straight from coil.



True Coil Width Utilization:

- Full material utilization – minimum waste
- The shortest possible cycle times – no time wasted in cutting to width
- Families of parts and high quantities run to order

Common Coil Width Utilization

- Families of parts punched and trimmed from the same coil non-stop
- Similar parts nested side by side on the common coil width
- Parts punched to width and trimmed from the same coil non-stop
- No set up times between small batches
- Purchase bigger quantities of common coils to lower cost

PivaPunch electric punch presses come in three sizes: PCC60-e, PCC125-e and PCC150-e. The numbers stand for the coil width that the press is made to handle.

PivaPunch PCC60-e

- Coil width 60 to 610 mm / 2.36" to 24"
- Coil weight up to 5,000 kg/11,000 lbs
- Sheet thickness 0,5 to 2 mm / 0.019 to 0.078", material strength up to 400 N/mm²
- Punching tonnage 300 kN/33 tons
- Number of tool cassettes 1 pc (2 on request)
- Stacker capability 1,250 mm/50" up to 6,000 mm/237" long blanks



Increased manufacturing speed and decreased energy consumption are achieved by combining Pivatic's simple machine layout with its advanced technology.

PivaPunch can be equipped with a complete line of fully automatic equipment allowing for automatic 24/7 manufacturing. Below set up features a common system that requires very little maintenance, works straight from coil and stacks finished parts fully automatically.

Stacker

Parts are stacked on pallets using either a fast stacker for stacking straight behind the shear without any delay or a pick & place time device to stack in multiple locations.

Shear

The cut-to-length shear reduces cycle times and gives straight leading and trail edges. The shear is programmed according to the way blanks are produced: a full stroke for true coil width utilization and partial cuts for nested parts.

Tool Cassettes

Tool cassettes with fixed tools only and tool cassettes with fixed and auto-indexing tools are used in the same attachment of the slide. The servo drives for the auto-index stations are options.

Additional presses for dedicated press tools or large F-station thick turret type tools available.

Strip Feeders

PCC60-e features a servo controlled roll feeder with adjustable pinch force and both driven upper and lower rolls to ensure highly accurate positioning of the strip for punching & cut-to-length.

PCC125-e and PCC150-e features a servo controlled clamp feeder to ensure highly accurate positioning of the strip regardless of thickness, coil width and type of material.

Straightener

Equipped with feeding rolls and 9 straightening rolls to eliminate the coiling tension. Leveller is available upon request.



- PivaPunch PCC125-e - PCC150-e**
- Coil width 60 to 1,250 mm / 2.36" to 49.21" - 60 to 1,525 mm/ 2.36" to 60"
 - Coil weight up to 10,000 kg/ 22,000 lbs
 - Sheet thickness 0.5 to 2 mm / 0.019 to 0.078", material strength up to 400 N/mm²
 - Punching force 300 kN/33 tons
 - Number of tool cassettes 2 pc
 - Stacker capability 1,250 mm/50" up to 6,000 mm/237" long blanks

Electric Punching Stations

In the punching station of the PCC60-e, there is one slide with one tool cassette attachment whereas in PCC125-e and PCC150-e there are two of them set one on each side of the strip.

The electric punching station features a linear servomotor drive for freely programmable stroke length and speed. The accuracy of the stroke length makes forming, embossing and tapping jobs accurate and reliable. The heavy duty ram is guided in all four corners by precision prismatic linear guides for asymmetric loads. The striker pin of the tool selector automatically directs the punching force from the ram plate on to the punching tools set in the tool cassette.

The PivaCam Software Package Includes:

- Modules for part programming straight from DXF drawings
- Production order lists
- Post processor and data transmission
- PivaPunch is equipped with a state of the art Siemens numerical controller and PLC.

Coil Handling and Threading of the Strip

- Dual coil cars for safe and quick coil change.
- Upender and coil storage available.
- To shorten the coil change overtime, it has automatic threading tables for hands off threading of strip into the punching station.



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Tools can be replaced by another pre-set cassette within a minute making PivaPunch ready for the next family of parts without losing valuable up-time.

Tool cassettes holding fixed tools



Type	Description	Type	Description	Type	Description	Type	Description
TT	Universal type, includes 26 fixed tools in sizes A to E	TTd	4 D stations improve capabilities for large holes, 16 fixed stations of A to E	TTf	The F station for notching of complex corners and for trimming, 21 fixed stations of A to F	TTfd	Large D and F stations for notching, cluster tools and slitting, 16 fixed stations of A to F

Tool cassettes for fixed and auto-indexing tools



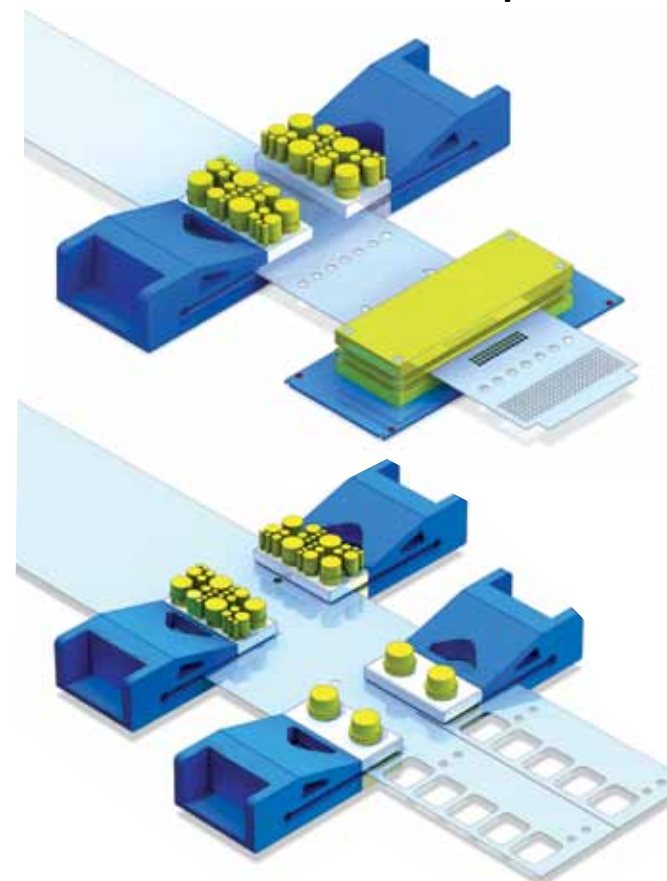
Type	Description	Type	Description
TTi	Versatile set of 16 fixed and 1 autoindexing D station for cutting in variable angles, etc.	TTii	The most versatile set of 16 fixed stations of A to E plus autoindexing B and C stations

Color Code	Diameter up to
•	A Ø 0.500" Ø 12.7 mm
○	B Ø 1.250" Ø 31.8 mm
●	C Ø 2.000" Ø 50.8 mm
●	D Ø 3.500" Ø 88.9 mm
●	E Ø 4.500" Ø 114.3 mm
●	F Ø 6.000" Ø 152.4 mm

Up stroking cylinders set in stations C, D or E provide forming capabilities for embossings higher than 4 mm/0.157".

Punching range is from the edge to the center of the strip. The cap of the cassette is min 625 mm/24.60".

Pivatic offers a complete line of components to satisfy all manufacturing needs.



PivaPunch presses set up in series allow for complete part manufacturing of complex products and reduced cycle times.

Punching station of type HT-e is set in front of the shear for press tools for dedicated jobs like perforation and notching.

Punching station of type LT is set for 2 large F station tools per side, set in tool cassettes for CNC punching, trimming and forming applications.



Coil Upender integrated with coil storage system. With a coil handling system, PivaPunch can run self sufficiently for a longer time period, for instance over the weekend.

Available upon request:

- Coil Storage System
- Leveller
- Thread Forming or Cutting Units
- Slitting Tools for Trimming
- Trim & Notch Station
- Automatic Cut-To-Width Station
- Stacker with multiple options
- Turning Drum



Empowering productivity in sheet metal fabrication.



Ursviken Group empowers productivity in sheet metal fabrication.

The Ursviken Group is a global provider of high-end solutions for sheet metal manufacturers. We base our service and solutions on more than 100 years of being on the forefront of the metal forming industry. Our solutions are at the top of today's industry and give our customers a leap in productivity that leads to a healthy return on their investments.

The Ursviken Group consists of two leading companies, Pivatic Oy and Ursviken Technology AB. The Finnish company Pivatic is a pioneer in manufacturing solutions based on coil. Ursviken is a Swedish company specializing in heavy plate metal working.



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