



# Heim Maxi-Stamper II Single Point Gap Frame



STAMPING OUT DOWNTIME™

# Setting new standards for speed, accuracy and performance.

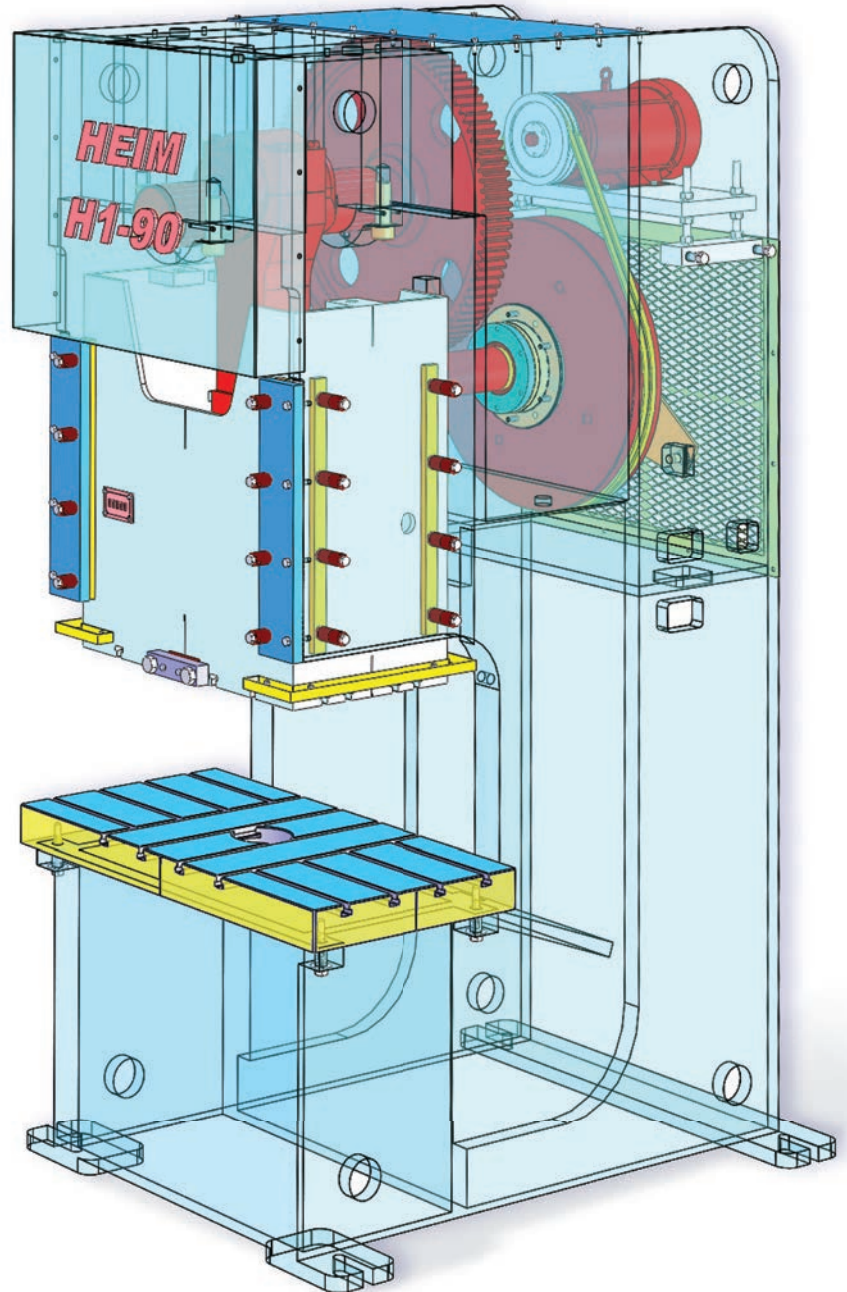
Designed to state-of-the-art specifications, Maxi-Stamper II offers you exceptional accuracy and performance. This fabricated steel power press is the result of over 60 years of engineering and press building experience. It's packed with valued standard features such as 8 point gibbing, gears running in oil, hydraulic overload and variable speed drive. And since the Maxi-Stamper II is made in the USA, rapid replacement parts and responsive service are never a problem.

## Standard Features

- Front to Back Drive
- Gears Running in Oil
- Rating Point .200/.250 B.D.C.
- Rigid Frame Deflection
- Hydraulic Overload
- Variable Speed Drive
- Combination Clutch and Brake
- Deep Slide Construction
- 8 Point Gibbing
- Power Ram Adjustment
- Die Height Indicator
- Bronze Gib Liners
- Recirculating Oil Lubrication
- Steel Fabricated Design
- Die Heights as Required
- Keyless Connections
- T-Slotted Bolster/Slide
- Counterbalance System
- Stroke Lengths 2" to 10"
- Dynamic Braking
- Solid State Controls
- Brake Monitor
- Motion Detector
- Stroke Counter
- Forward/Reverse
- Operation Gauges

## Optional Features

- H. Frame
- Wet Clutch
- Link Motion
- Horizontal Model



MADE IN THE USA

## What's Inside.

### Durable Construction

The Maxi-Stamper II frame is constructed from thick, welded steel plate. It features a reinforced bed and integral bolster to ensure deflection will not exceed .0015" per inch of throat depth.

### Front to Back Main Drive

This compact configuration helps minimize deflections within the rigid frame. A one-piece alloy steel driveshaft, running on anti-friction bearings, meshes up with a spur type main gear. It drives a precision ground crankshaft which is solidly supported in the frame.

### Quill Mounted Flywheel with Combination Air Clutch and Brake

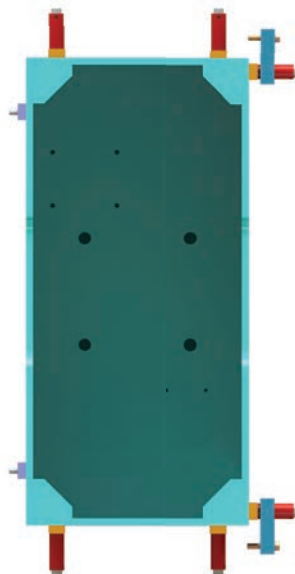
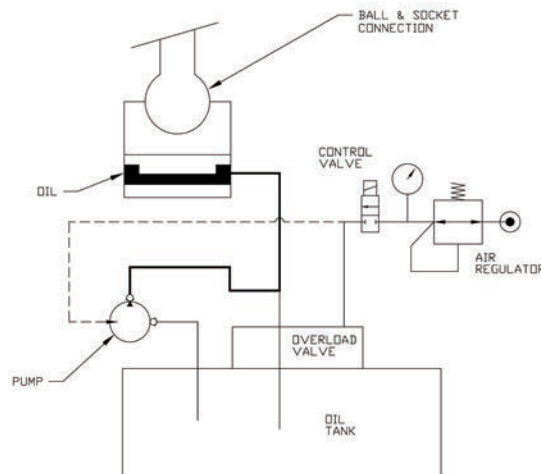
Maxi-Stamper II's solenoid-operated air friction clutch and brake is mounted on the flywheel for easy access to parts that routinely need to be replaced, such as friction pads. This low inertia unit is designed for maximum heat dissipation, significantly reducing wear due to frequent starts and stops.

### 8 Point Gibbing

The deep slide design is guided by bronze liners attached to gibs located in each corner of the slide. The 8 point guiding maintains the tightest bed to slide parallelism.

### Hydraulic Overload Protection

Incorporated in each ball seat (knuckle box) housing is a hydraulic cylinder. When an overload is encountered pressure rises in the cylinder to the setting of the relief valve causing it to open, allowing the oil to flow from the hydraulic cylinder. Because oil can flow out of the cylinder, space becomes available for the ball seat to stroke. This stroking allows the press drive to continue down, while the slide stands still, thus relieving the overload condition. When an overload is sensed a signal is sent to stop the press.



### Automatic Lubrication

The press is furnished with an automatic oil recirculating system which keeps all major drive bearings lubricated, as well as gibs and adjusting screws. The system also continuously monitors for pump or electrical failure, low oil level and low line pressure, and stops the press if necessary.

### Carbon Fiber Air Counterbalance Cylinders

These ultra-rugged cylinders, an innovative Heim design, offer maximum performance with minimal component wear. Mounted to the crown structure, they counterbalance the slide, ensuring smooth operation through the entire stroke as well as reducing wear.

### Solid State Press Control

This solid-state device is engineered specifically for mechanical power presses. Two microprocessors perform clutch/brake control logic independently, then cross-communicate to ensure accuracy. Clutch/brake air valve power passes through three separate output relays, which are doublechecked by the dual microprocessors. A built-in motion detector and brake monitor are included in the system, as well as a user-friendly operator interface with color display and keypad.



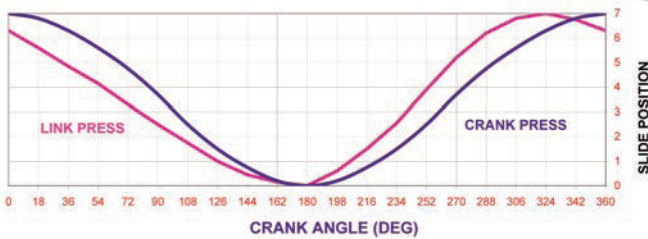
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# Optional Features

## Link Motion

A link connection is added to the main drive assembly. This connection creates the motion which is a slow down through the working stroke and quick movement through the approach and return cycle of the press stroke. This creates a more efficient press offering increased production speed, consistent slide velocity during draw application, a slower speed when work is contacted and longer die life. Additional benefits to the stamper are a higher quality part, less snap through shock, less noise and vibration in the press and allows for a more versatile range for stamping applications.

**SLIDE MOTION CURVE**



## H-Frame

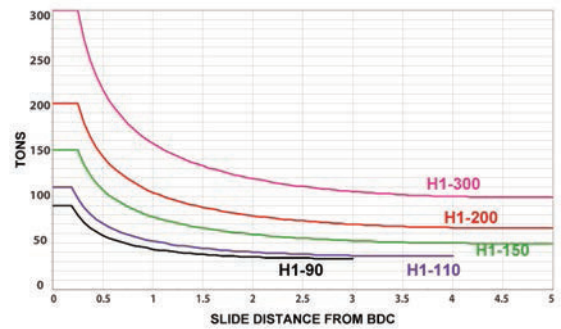
Also known as solid frame, straight side frame is offered for users who need a more rigid frame requirement than the deflections associated with a "C" frame press. This frame has a bed deflection of .0015" per foot of bed area. This frame design coupled with the 8 point slide guiding system offers an extremely rigid frame with minimal deflection and tight bed to slide parallelism for running close tolerance dies.



## Wet Clutch

This optional feature permits the end user to cycle the press at higher intermittent trip rates without detrimental effects on the clutch and brake unit. The clutch and brake plates are constantly lubricated and cooled in a bath of oil. The entire clutch unit is sealed from outside contaminations. Heat is effectively transferred from the clutch and brake plates to the oil. The heat is dissipated and the oil cooled by special design air fins on the unit.

**TONNAGE CURVES**



# Specifications

Model Number	H1-90	H1-110	H1-150	H1-200	H1-300
Capacity (U.S.) B.D.C.	90	110	150	200	300
Tonnage Rating Point	.200	.200	.250	.250	.250
Bed and Bolster Area	46 x 26	46 x 26	57 x 26	57 x 30	66 X 36
Slide Area	32.75 x 20	32.75 x 20	39.25 x 20	39.25 x 24	43.25 X 28
Stroke Length	2 - 4 - 6	4 - 6 - 8	6 - 8 - 10	6 - 8 - 10	6 - 8 - 10
Die Height S.D.A.U. OVER BOLSTER	14 - 13 - 12	13 - 12 - 11	14 - 13 - 12	16 - 15 - 14	20 - 19 - 18
Variable Speed	70-140 50-100 35-70	50-100 35-70 35-70	35-70 30-60 25-50	35-70 30-60 25-50	30-60 25-50 20-40
Depth of Throat	14.5	14.5	16.5	16.5	18.5
Opening Thru Back	31	31	39.25	39.25	42
Slide Adjustment	4	4	4	4	4
Bolster Thickness	4	4	6	6	8
Floor to Top of Bolster	36	36	40	40	44
Main Motor HP	10HP	15HP	20HP	25HP	30HP
Floor Space (Left-to-Right x Front-to-Back)	49 x 69	49 x 69	68 x 83	68 x 86	72 X 95
Overall Height	139	139	144	144	156
Weight	19,500	21,000	30,000	33,000	55,000

Values in inches unless otherwise noted. Machines may vary slightly from those shown.

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