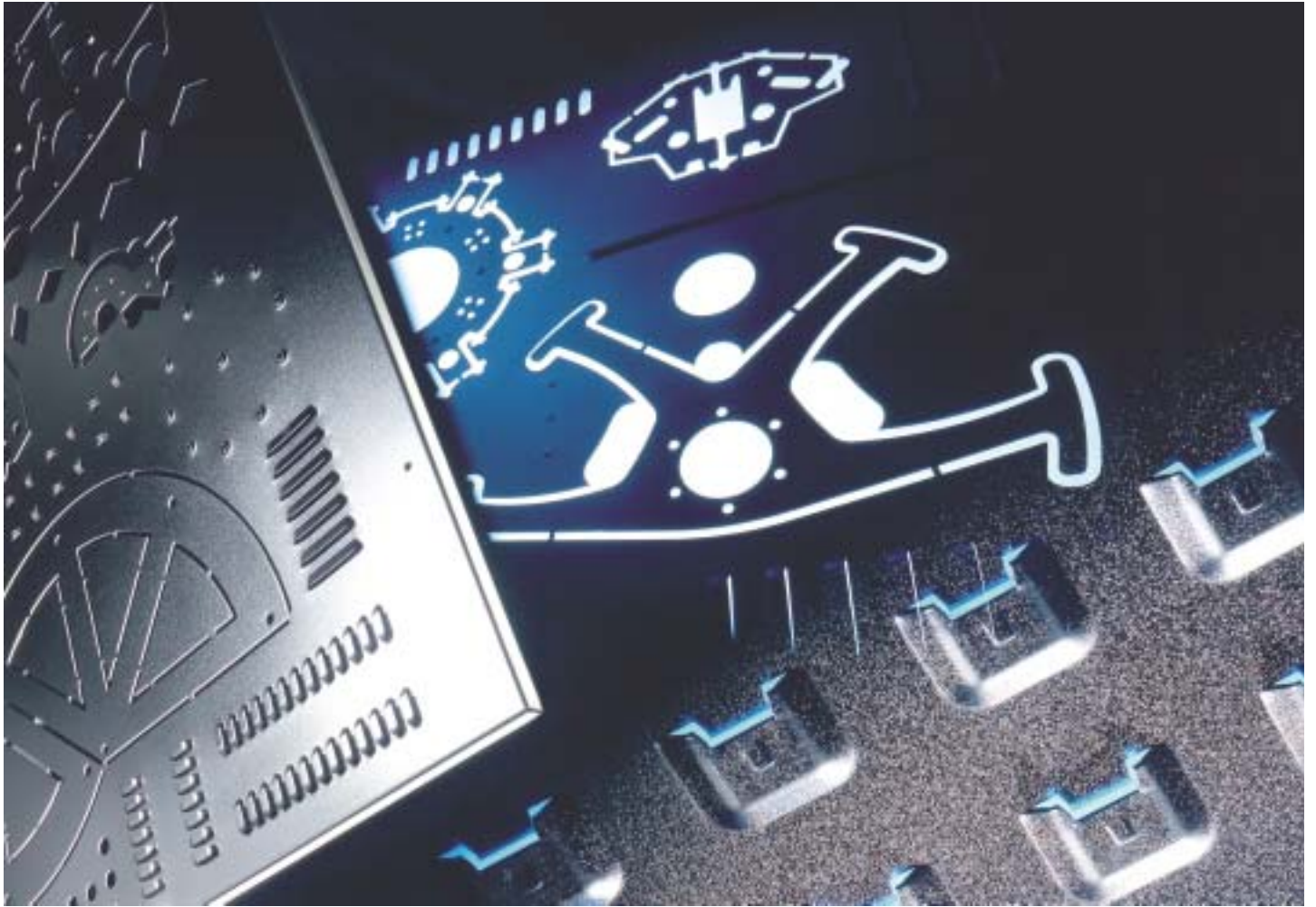
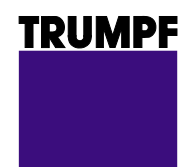


## Compact Punching Machine



Punching, Nibbling and Forming  
with Rotation of all Tools

**TRUMATIC 200 R**



## A compact classic



The goal of new production strategies is to coordinate tooling and material flow in order to reduce raw material requirements, work in process and inventories. This requires a productive and flexible machine concept. The TRUMATIC 200 ROTATION has been designed with these demands in mind. It offers the user high productivity and flexibility.

- A stable C-frame, consisting of a FEM-computed welded construction, forms the basis of the machine.
- With 15 tool stations, the linear magazine sets the standard for economical production. The number of tools available can be greatly increased through the use of Multitools (multiple tools).
- Wear-free AC motors make for high axis travel speeds.
- Hydraulic punching head with 360° rotation of all tools. This reduces tool requirements and means that fewer tool changes are needed.
- The rigid coordinate guide with bi-lateral drive, coupled with the hydraulic clamps, provides for precise and safe positioning of the workpiece.

## Intelligent Head

Clutch-free, electro-hydraulic ram drive

Time and power-optimized punching process

- Automatic tool length compensation
- Stroke length compensation depending on sheet thickness

High process safety

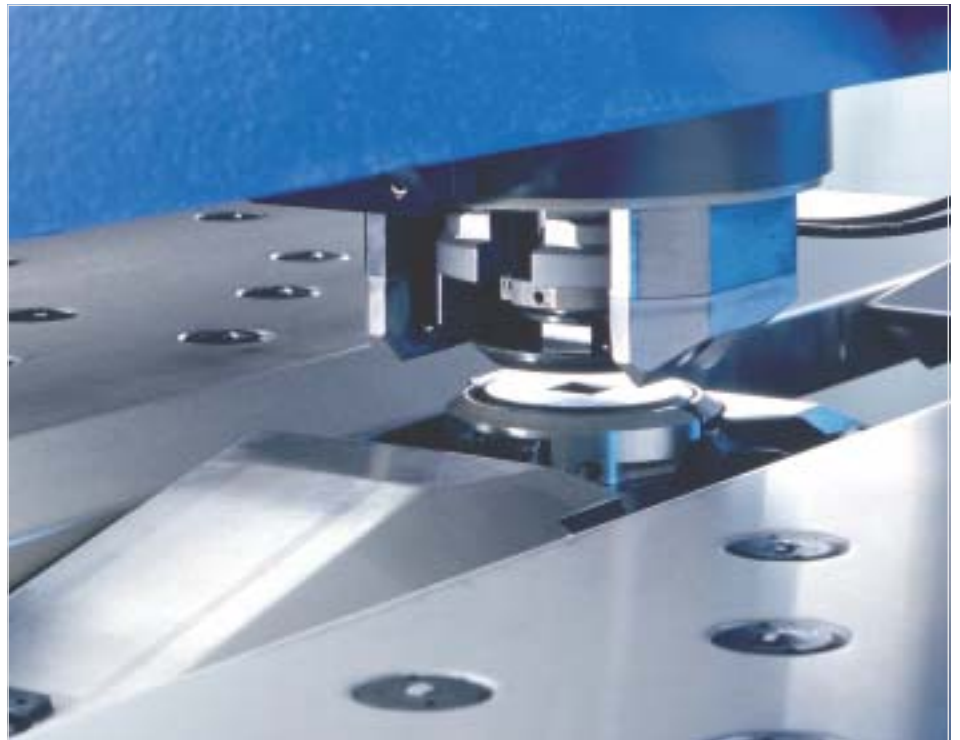
- Active punch retraction

Hydraulic tool clamping

- Precise alignment between punch and die
- Long tool life

Excellent tool guidance

- Hydrostatically guided ram
- Long guidance length
- High eccentric loads possible (notching, forming)



## Integrated Linear Magazine

17 magazine station  
of which

- 15 stations for tools  
(number of tools can be greatly increased through the use of Multitools)
- 2 stations for clamps

Free choice of tool and clamp positions

Minimum clamp dead area

Good accessibility for setup

Quick, easy and safe setup



## Parts Removal with System

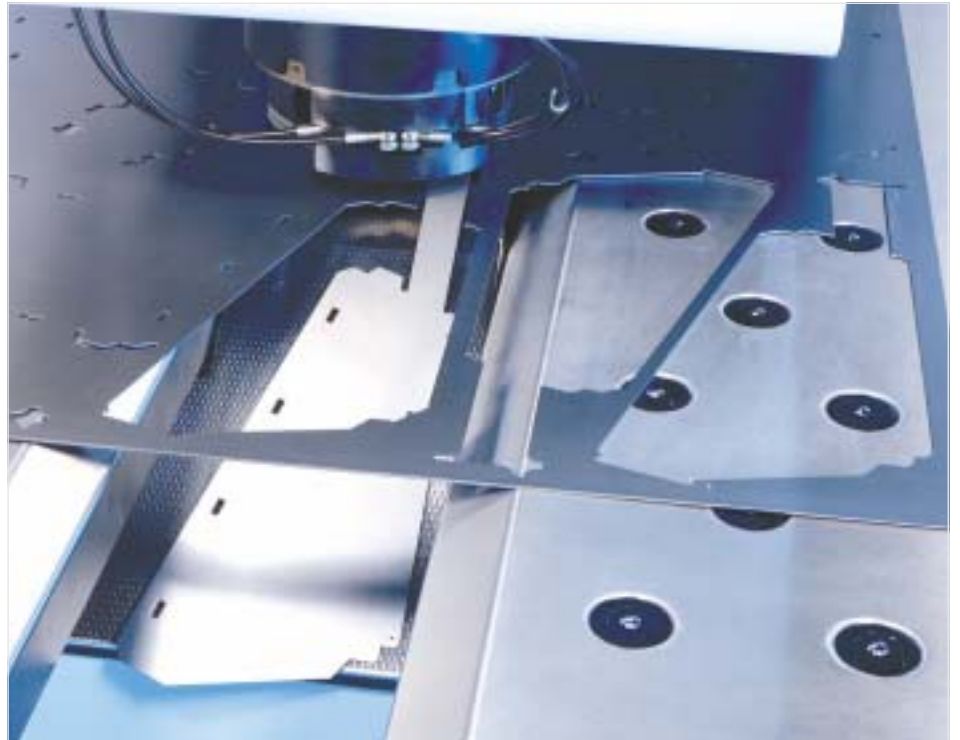
### Variable removal

- Chute for parts up to 180 x 150 mm
- Can be upgraded up to 500 x 500 mm
- Directly into a parts container
- No operator intervention needed

### High process reliability

- Vacuum assisted slug removal
- Removal possible with light barrier monitoring

Support table provides good workpiece support and operating safety



## Application-Oriented Tool Ideas

### TRUMPF Multitool

- Punching tool with 2, 4 or 6 stations, or 12-station embossing tool
- Increased tool storage capacity
- Faster tool change
- Fewer tool sets
- Short setup time

### TRUMPF MultiCut tools

- Large circular cutouts can be produced with just a few strokes

### TRUMPF Slitting tools

- Fast processing of straight contours

### 3D Punching with Forming tools

- Programmable depth feed
- Numerous problem solutions (louvers, extrusions, beading etc.)





# Operation Comfort

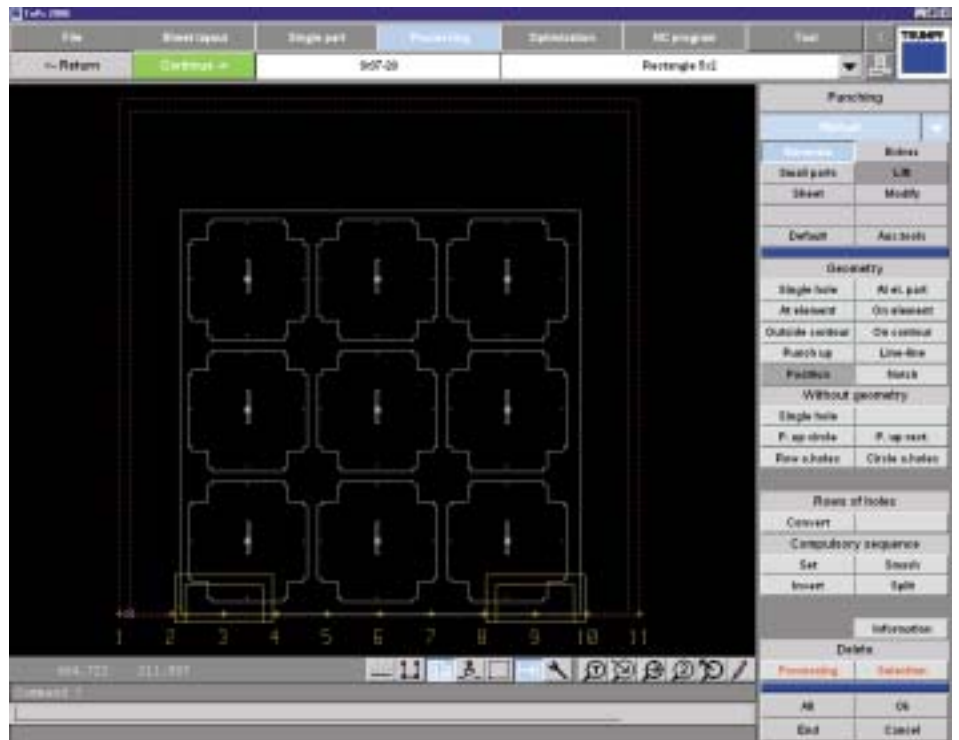
## TRUMPF CNC Control CC 220S

- Large memory for part programs
- Powerful standard memory
- Low block cycle times for fast block processing
- Teleservice, especially with detailed diagnostic possibilities for the hydraulic system
- User-friendly PC operator panel
- Setup-friendly location of color panel close to linear magazine
- Air-conditioned switch cabinet



# Technology-oriented programming system ToPs 2000

- Easy programming close to the machine in the workshop or externally in the office
- Interactive creation of programs while production is running
- Creation of drawings with easy-to-use geometry editor
- Flexible parts programming
- Semi-automatic processing functions
- Runs on PC
- Optional ToPs CAD converter enables import and use of CAD data

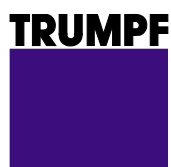


<b>Working area X x Y</b>	2070 x 1280 mm
<b>Capacities</b>	
Max. sheet thickness	6.4 mm
Max. punching force	165 kN
Max. punching diameter	76.2 mm
Max. workpiece weight	150 kg
<b>Speeds</b>	
X axis	80 m/min
Y axis	55 m/min
Simultaneous (X and Y)	97 m/min
C axis	360°/s full rotation
Max. stroke rate punching (E = 1)	500 1/min
Max. stroke rate marking	1300 1/min
<b>Tools</b>	
Linear magazine	15 tools with 2 clamps
No. when Multitool is used	15 – 90 tools
Multitool	4/6
<b>Tool change time</b>	1.5 – 6.5 s
<b>Accuracy<sup>1</sup></b>	
Positioning accuracy Pa	±0.1 mm
Repeatability Ps	±0.03 mm
<b>Control</b>	Basis Bosch CC 220S
Color monitor	10.4"
<b>Part chute</b>	
Max. part size	180 x 150 mm
<b>Space requirements<sup>2</sup></b>	
including safety light barriers	6000 x 5600 mm
<b>Connected loads</b>	
Electrical	14 kVA
Pneumatic	8 Nm <sup>3</sup> /h – 6 bar

<sup>1</sup> The attainable accuracy in the workpiece depends, amongst other things, on the type of workpiece, its pre-treatment, sheet size and its position in the work area.

In accordance with VDI/DGQ 3441, measured over a length of 1 meter.

<sup>2</sup> See installation plan for exact dimensions.



TRUMPF Werkzeugmaschinen  
GmbH + Co. KG  
P.O. Box  
D-71252 Ditzingen

Phone: +49 (0)7156 303-0  
Fax: +49 (0)7156 30 33 09  
E-mail: [info@de.trumpf.com](mailto:info@de.trumpf.com)  
Internet: <http://www.trumpf.com>