



	<b>SPARTANBURG STEEL PRODUCTS</b> <b>PRESS LINE SPECIFICATION</b> <b>1600 PRESS LINE</b> <b>P1601-1603-1605</b> (144" x 84" 600 Ton – Single Action)	Document No.: S02.012  Issue Date: 14-Nov-00 Revision: 7 Page 2 of 10
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**PRESS INFORMATION**

	Inner	Outer
Work Capacity .....	600 Tons	N/A
Ram Size L/R – F/B .....	144" – 84"	N/A
Ram Spacer Thickness .....	None	N/A
Press <b>1601 &amp; 1603</b> Length of Stroke .....	24"	N/A
Press <b>1605</b> Length of Stroke .....	30"	
Press <b>1601 &amp; 1603</b> Slide Adjustment .....	12"	N/A
Press <b>1605</b> Slide Adjustment .....	18"	N/A
Shut Height From Q.D.C. S.D.A.U. ....	45" - 57"	N/A
Target Die Height (Measured from Q.D.C. Plate) .....	46"	N/A
Bolster Size L/R – F/B .....	144" – 84"	
Bolster Thickness .....	8"	
Rolling Bolster .....	None	
Carriage Thickness .....	N/A	
Bolster Spacer .....	None	
Bolster Spacer Thickness .....	N/A	
Positive Knockout .....	None	
Quick Die Change Sub-Plates .....	Yes	
Sub-Plate Thickness .....	3"	
Cushions (Number) .....	None	
Tons Each .....	N/A	
Tons Total .....	N/A	
Stroke .....	N/A	
Quantity @ Size L/R – F/B .....	N/A	
Distance From Bolster To Drip Pots .....	45"	
Distance Between Gibbs L/R .....	146"	
Strokes Per Minute .....	18 Intermittent 22 Continuous	

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**PRESS INFORMATION (Metric)**

	Inner	Outer
Work Capacity .....	545 MT	N/A
Ram Size L/R – F/B .....	3658mm – 2134mm	N/A
Ram Spacer Thickness .....	None	N/A
Press <b>1601 &amp; 1603</b> Length of Stroke .....	610mm	N/A
Press <b>1605</b> Length of Stroke .....	760mm	
Press <b>1601 &amp; 1603</b> Slide Adjustment .....	355mm	N/A
Press <b>1605</b> Slide Adjustment .....	457mm	
Shut Height From Q.D.C. S.D.A.U. ....	1143 - 1448mm	N/A
Target Die Height (Measured from Q.D.C. Plate) .....	1168mm	N/A
Bolster Size L/R – F/B .....	3658mm – 2134mm	
Bolster Thickness .....	203mm	
Rolling Bolster .....	None	
Carriage Thickness .....	N/A	
Bolster Spacer .....	None	
Bolster Spacer Thickness .....	N/A	
Positive Knockout .....	None	
Quick Die Change Sub-Plates .....	Yes	
Sub-Plate Thickness .....	76mm	
Cushions (Number) .....	None	
Tons Each .....	N/A	
Tons Total .....	N/A	
Stroke .....	N/A	
Quantity @ Size L/R – F/B .....	N/A	
Distance From Bolster To Drip Pots .....	1134mm	
Distance Between Gibbs L/R .....	3708mm	
Strokes Per Minute .....	18	

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**AUTOMATION DEVICES USED**

**LOADER**

Destacker / Rollcoater / Loader	.....	None
Max. Sheet Thickness	.....	N/A
Min. Sheet Thickness	.....	N/A
Max. Sheet Size L/R – F/B	.....	N/A
Min. Sheet Size L/R – F/B	.....	N/A
Max. Loader Pass Height <i>(From Top Of Bolster)</i>	.....	N/A
Min. Loader Pass Height <i>(From Top Of Bolster)</i>	.....	N/A
Max. Stack Height <i>(Including Pallet)</i>	.....	N/A

**UNLOADER**

- 1) The unloader of this press does not have the ability to manipulate the part in any way.
- 2) The parts must pass from one press to another without being re-oriented.

	<p style="text-align: center;"><b>SPARTANBURG STEEL PRODUCTS</b> <b>PRESS LINE SPECIFICATION</b> <b>1600 PRESS LINE</b> <b>P1601-1603-1605</b> (144" x 84" 600 Ton – Single Action)</p>	<p>Document No.: S02.012</p> <p>Issue Date: 14-Nov-00 Revision: 7 Page 5 of 10</p>
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### **PRESS INFORMATION GENERAL**

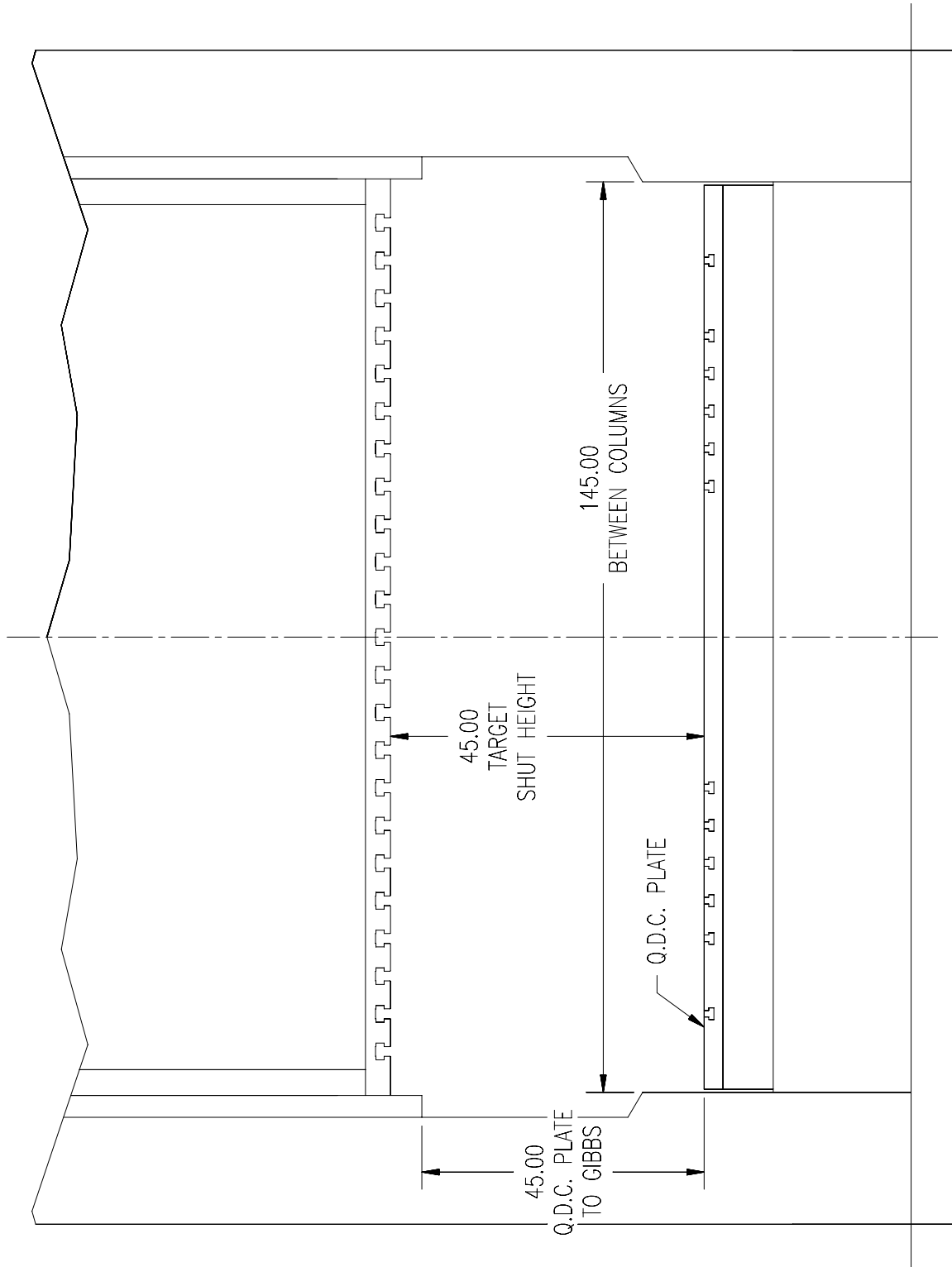
Comments:

- 1) The rams of 1601-1603-1605 have 1-1/2" T-slots. Therefore the clamp slots will need to be wide enough to accommodate the bigger T-bolts.



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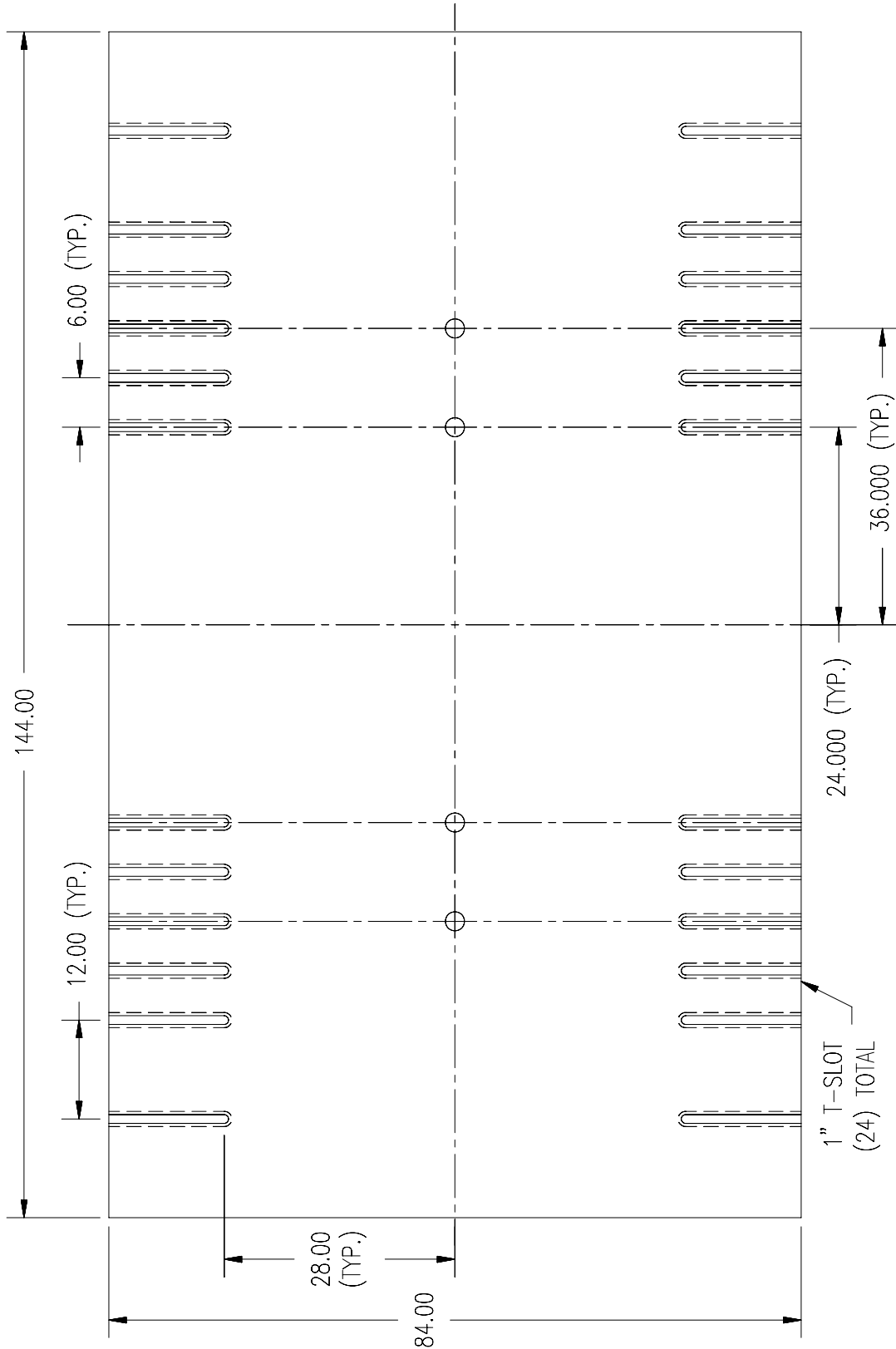


FRONT OF PRESS



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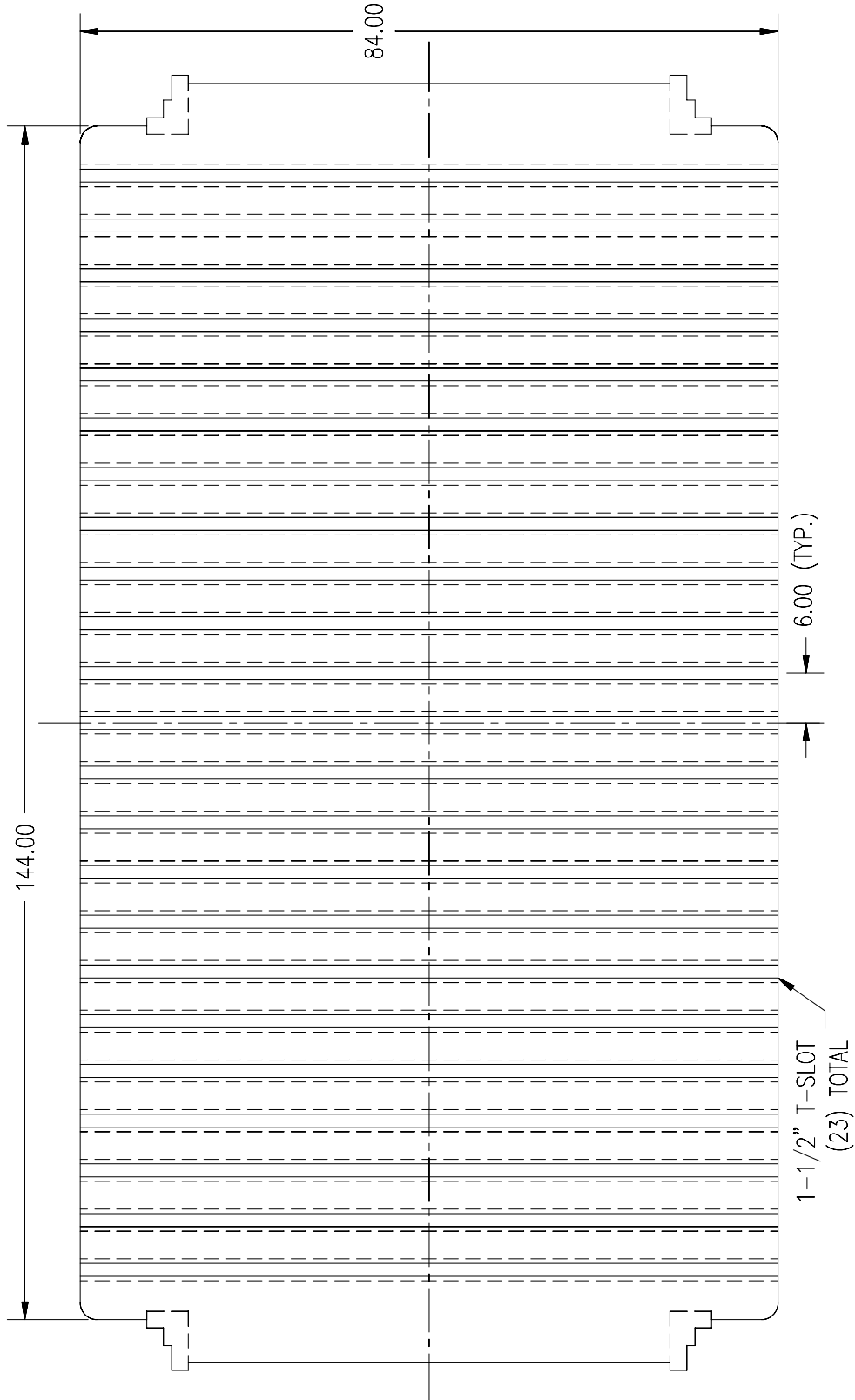


Q.D.C. PLATE



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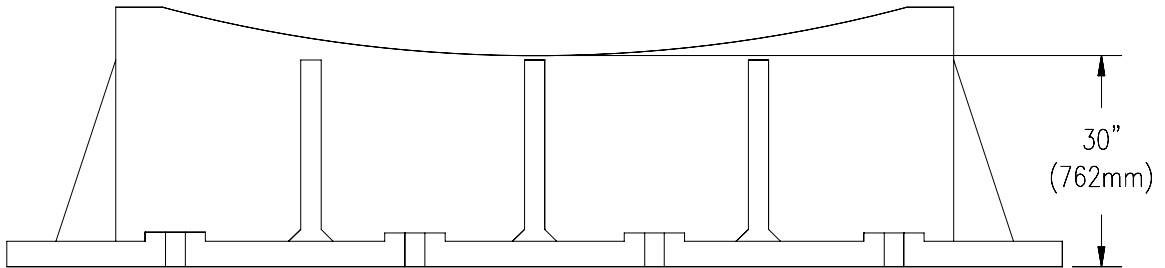
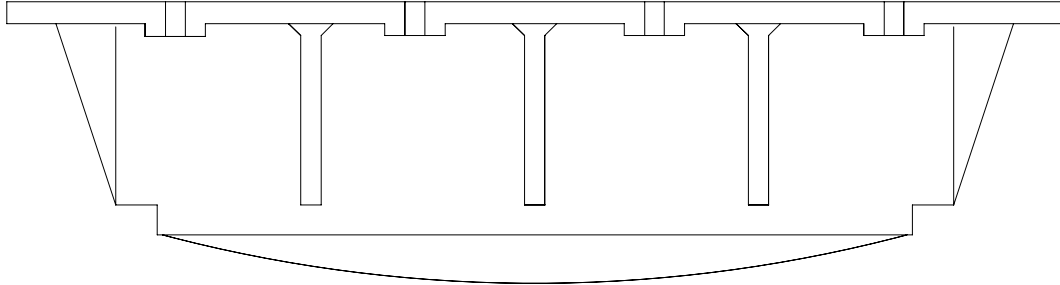


RAM FACE

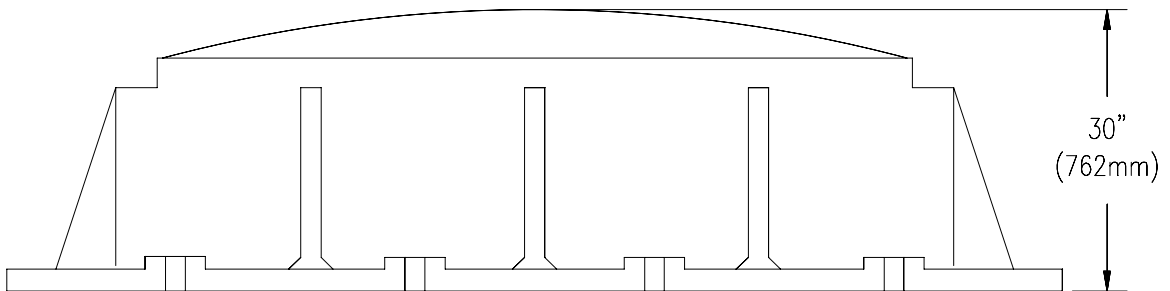
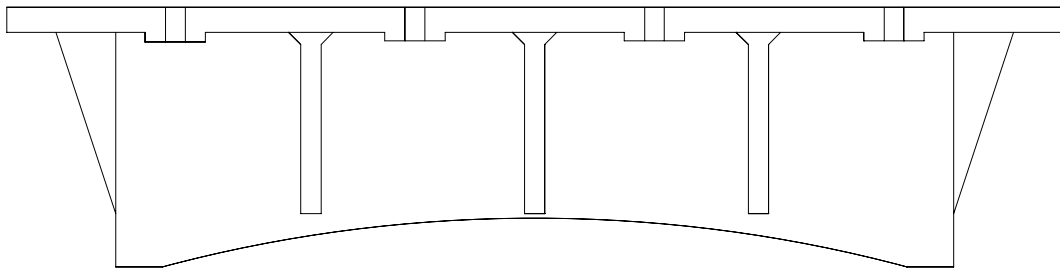


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CONCAVE CONDITION



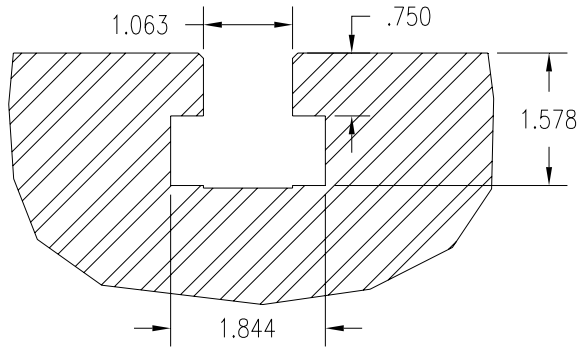
CONVEX CONDITION

**DIE HEIGHT DIAGRAM**

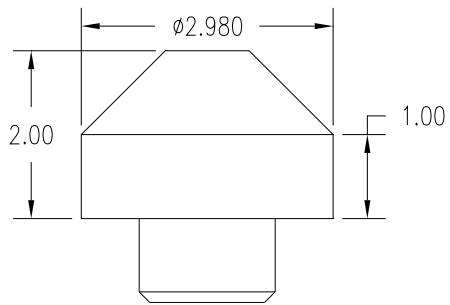


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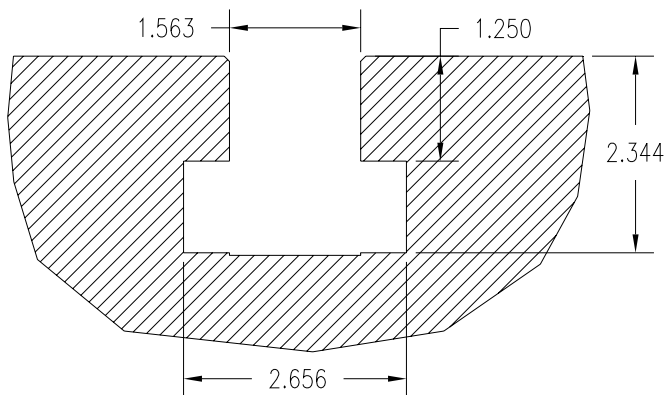
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SECTION OF  
Q.D.C. T-SLOT



DETAIL OF DIE  
LOCATOR PIN



SECTION OF  
RAM T-SLOT

**SECTIONS & DETAILS**