
	<p align="center">SPARTANBURG STEEL PRODUCTS PRESS LINE SPECIFICATION PRESS 1502 - 1504 (144" x 84" 600 Ton – Single Action)</p>	Document No.: S02.004 Issue Date: 06-Sep-07 Revision: 05 Page 2 of 11
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PRESS INFORMATION (ENGLISH)

	Inner	Outer
Work Capacity	600 Tons	N/A
Ram Size L/R – F/B	144" – 84"	N/A
Ram Spacer Thickness	None	N/A
Length of Stroke	30"	N/A
Slide Adjustment	18"	N/A
Shut Height S.D.A.U. <i>(From Bolster)</i>	55"	N/A
Target Die Height	46"	N/A
Bolster Size L/R – F/B	144" – 84"	
Bolster Thickness	10"	
Rolling Bolster	None	
Carriage Thickness	N/A	
Bolster Spacer	Yes	
Bolster Spacer Thickness	7"	
Positive Knockout	None	
Quick Die Change Sub-Plates	None	
Sub-Plate Thickness	N/A	
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	35.5"	
Distance Between Gibbs L/R	146"	
Strokes Per Minute	18	

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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
Length of Stroke	762mm	N/A
Slide Adjustment	457mm	N/A
Shut Height S.D.A.U. <i>(From Bolster)</i>	1397mm	N/A
Target Die Height	1168mm	N/A
Bolster Size L/R – F/B	3658mm – 2134mm	
Bolster Thickness	254mm	
Rolling Bolster	None	
Carriage Thickness	N/A	
Bolster Spacer	Yes	
Bolster Spacer Thickness	178mm	
Positive Knockout	None	
Quick Die Change Sub-Plates	None	
Sub-Plate Thickness	N/A	
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	902mm	
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

The un-loader of this press does not have the ability to manipulate the part in any way. The part must pass from one press to another without being reoriented.

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PRESS INFORMATION GENERAL

Comments:

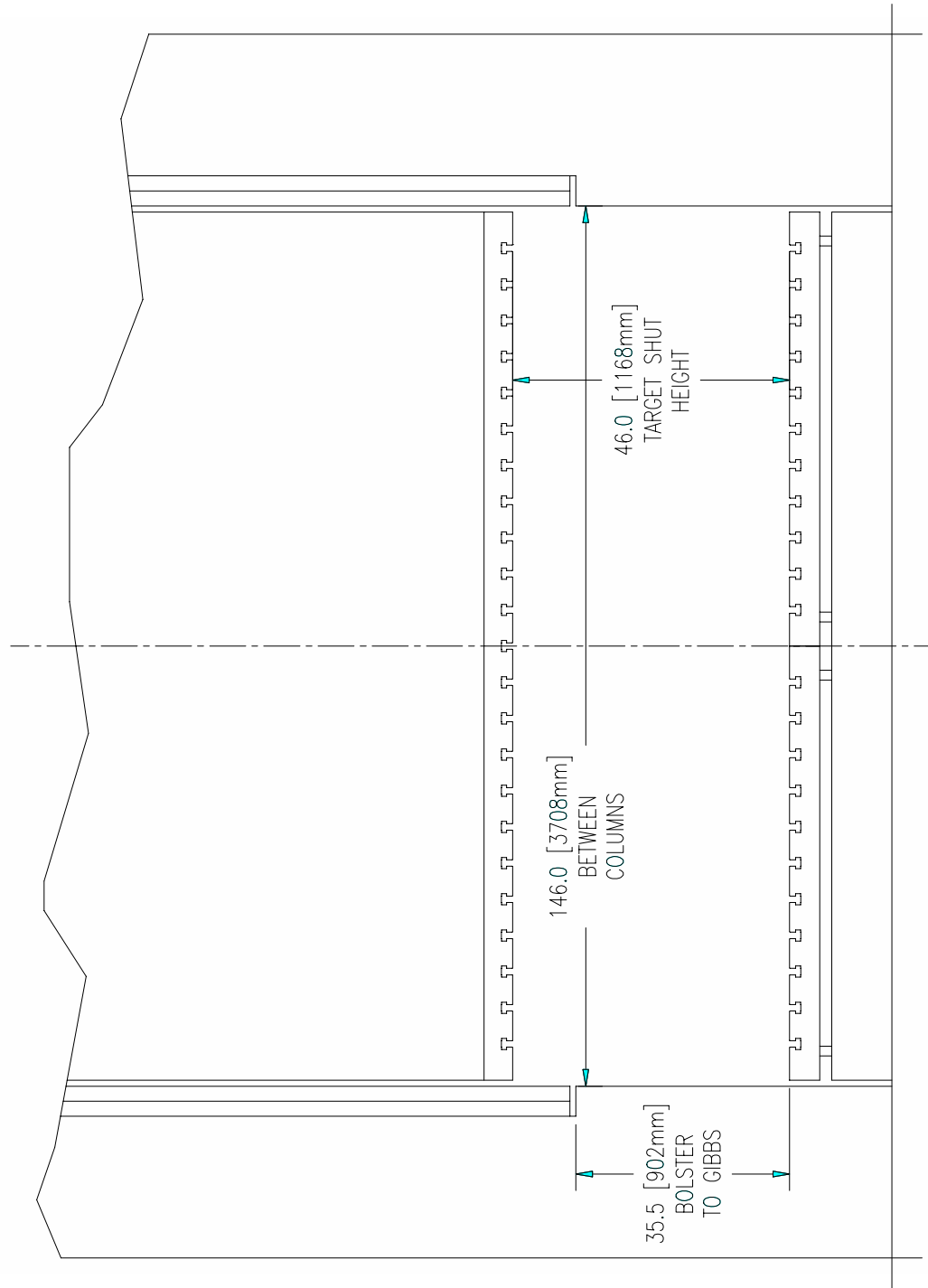
1. The bolster of these presses consists of (2) riser plates bolted to a common sub-plate. Because of this there is no center T-slot between the risers (see Bolster Plate drawing on page 7).



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Front View of Press

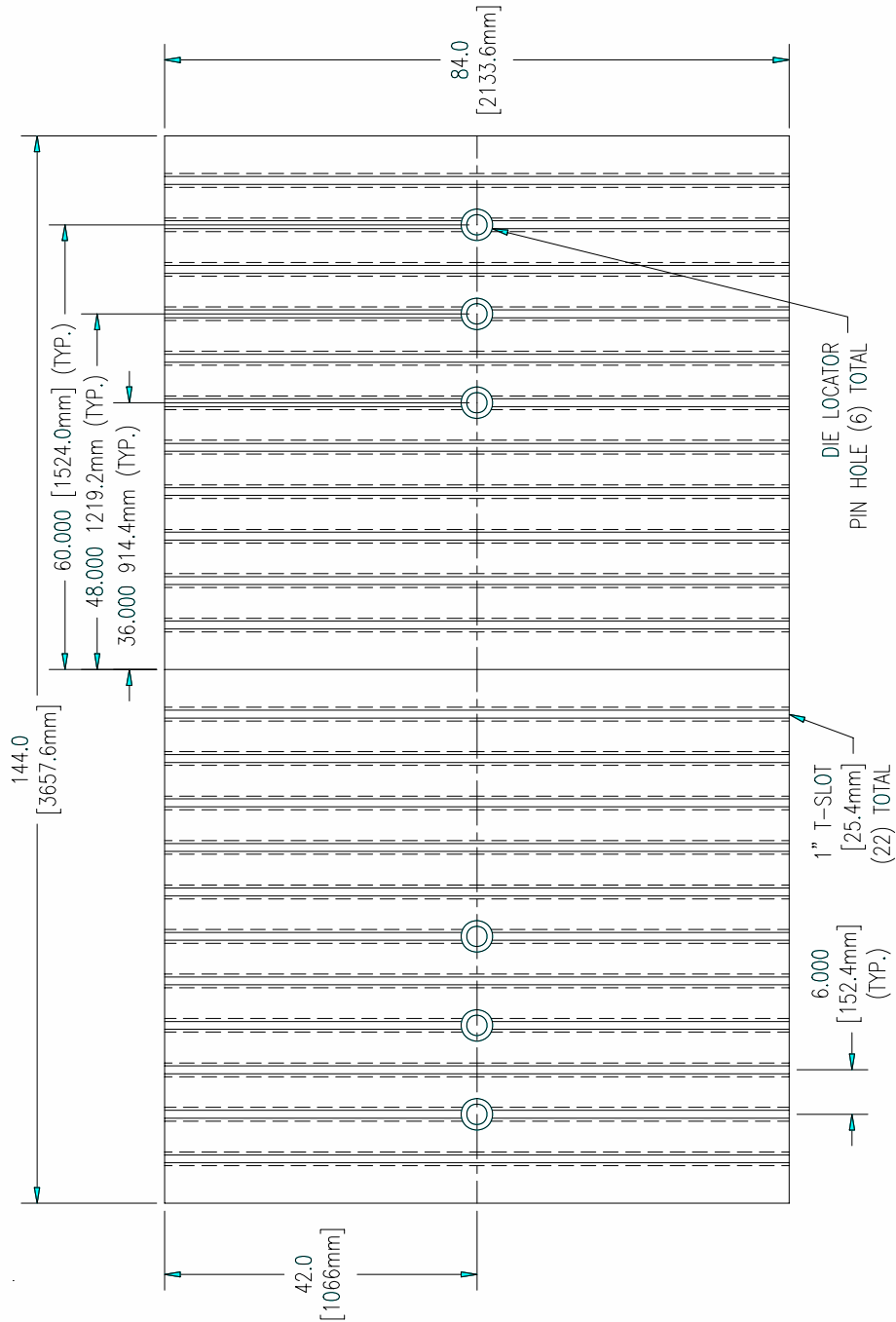




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Bolster Plate

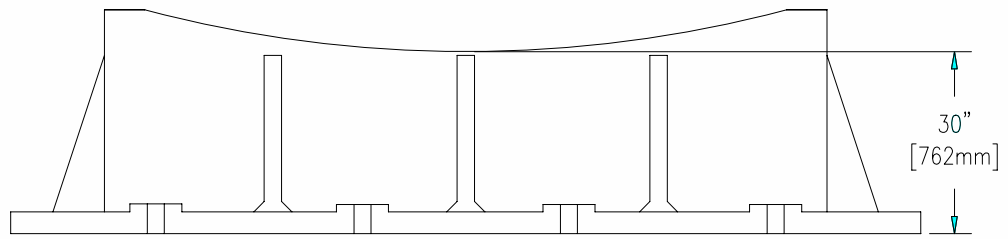
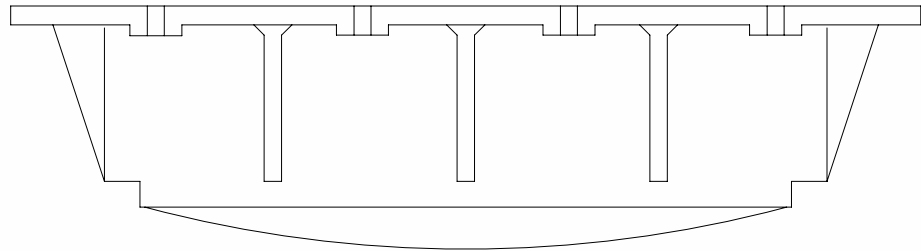




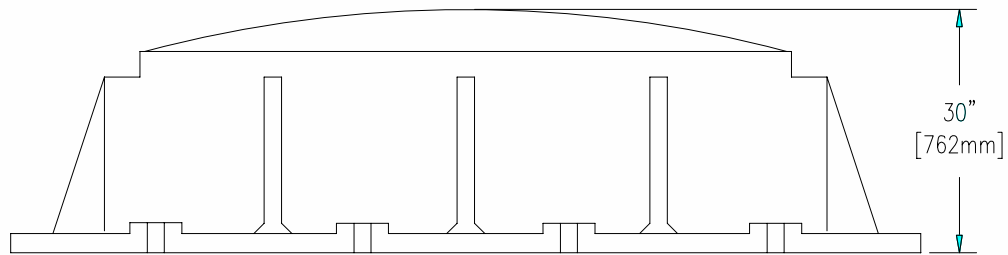
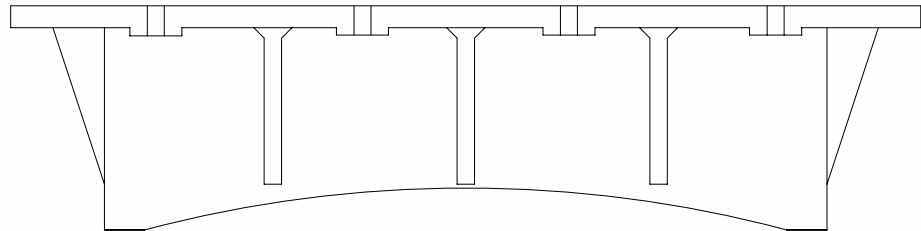
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Lower Die Height Diagram



CONCAVE CONDITION



CONVEX CONDITION

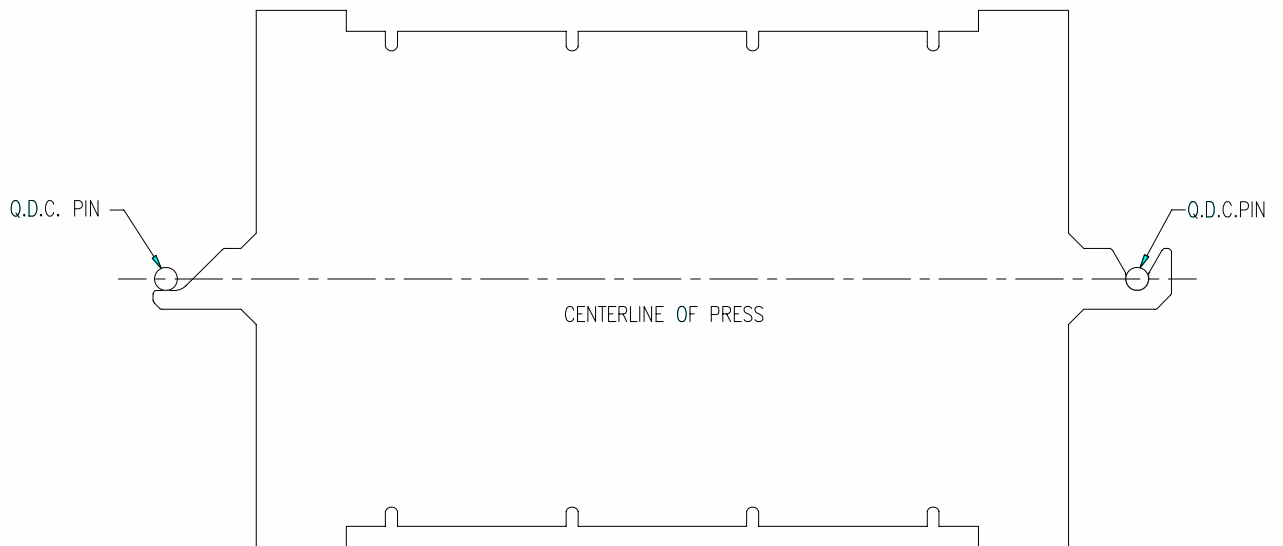


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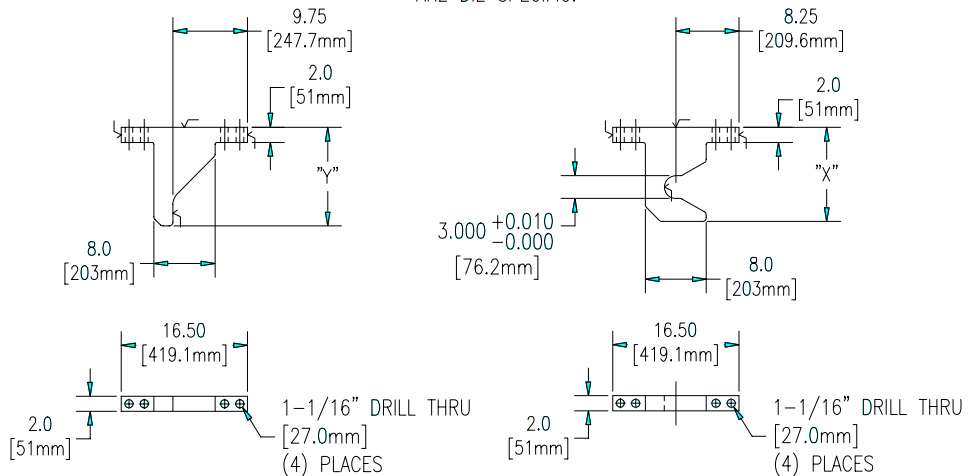
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Die Location Layout

DIES ARE LOADED INTO THE PRESS USING A FLATBED (DIE TRACTOR). THEREFORE DIES MUST BE LOCATED USING DIE PINS AND OUTRIGGERS. OUTRIGGERS MAY BE PART OF THE DIE SHOE OR REMOVABLE. IF OUTRIGGERS ARE REMOVABLE THEY MUST BE REPEATABLE.



NOTE: DIMENSIONS "X" AND "Y" ARE DIE SPECIFIC.

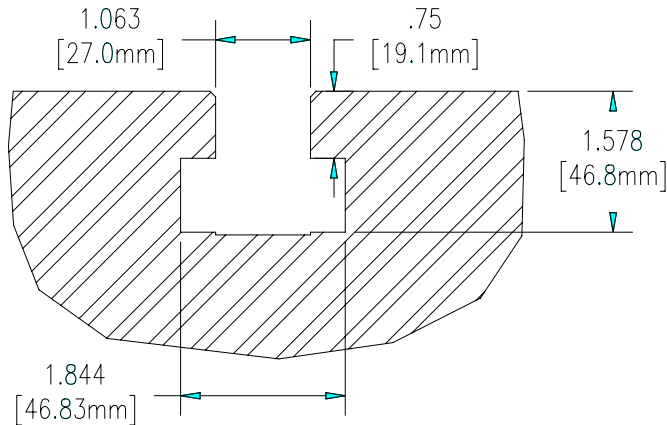




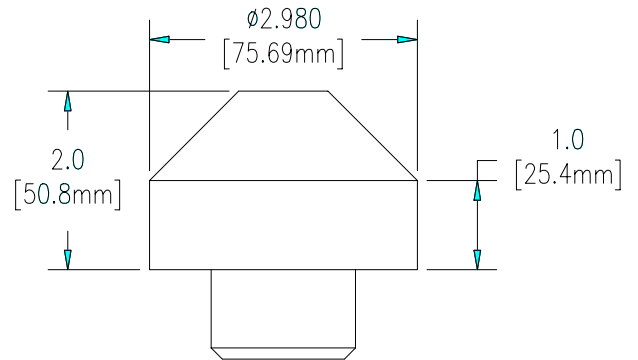
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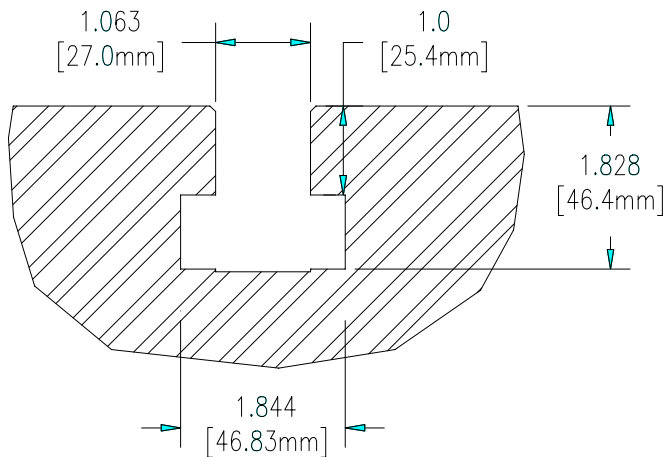
Locator Pin & T-Slot Details



SECTION OF
BOLSTER T-SLOT



DETAIL OF DIE
LOCATOR PIN



SECTION OF
RAM T-SLOT