

# PRESS SPECIFICATION

S02.001

P1505

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14

**Author:**  
J Martin

**Reviewer**  
R Grimes

**Approver**  
R WISE

**Issue Date:**  
26-Mar-2009

**Rev. No.:**  
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## REASON FOR REVISION

- See Archive K:\06 - Specifications\SSP Specifications\Archived SSP Specifications
- 7 - Changed coil inner diameter from 711mm and 406mm
- 8 - Document format change and thickness chart added
- 9 -
- 10 -
- 11 -

## PURPOSE

The purpose of this specification is to establish the standard by which Production Stamping Tooling is to be built.

## SCOPE

This procedure will apply to all Production Stamping Tooling.

## GENERAL PRESS INFORMATION

- 1 The A-riser (page 10) is a riser plate that is 381mm (15") thick and as large as the bolster F-B & L-R. This riser will then reduce the target shut height, of dies that use it, by 381mm (15"). Along with the reduced target shut height, the A-riser will also reduce the material feed height by the same amount
- 2 The A-riser has 6 Q.D.C. locator pin bushings. Die locator pins can be placed in these bushings in various combinations for die positioning.
- 3 When using the A-riser, the through the bolster scrap configuration changes. The A-riser has a 381mm (15") wide slot running down the 180" [4572mm] R-L center line. This slot allows scrap to fall through the riser plate into scrap shaker trays that transport the scrap out the back of the press. When using the A-riser's center scrap slot, try to avoid directing any scrap onto the parallels that span this area.

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8**PRESS INFORMATION ENGLISH**

Work Capacity	600 Ton [545 MT]	
Ram Size L/R - F/B	186"-96" [4572mm -2438mm]	
Ram Spacer Thickness	None	
Length of Stroke	16" [406mm]	
Slide Adjustment	16" [406mm]	
Shut Height S.D.A.U.	48" [1219mm]	
Target Die Height	46" [1168mm]	
Bolster Size L/R-F/B	180"-96" [4572mm-2438mm]	
Bolster Thickness	10" [254mm]	
Rolling Bolster	Yes	
Carriage Thickness	19" [483mm]	
Bolster Spacer	None	
Bolster Spacer Thickness	N/A	
Positive Knock-Out	Yes	
Quick Die Change	None	
Cushions	None	
Dist. from Bolster to Drip Pots	32" [812mm]	
Dist. Between Drip Pots L/R	181.25" [4603mm]	
Strokes Per Minute	20-40	

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8**AUTOMATION DEVICES USED****LOADER**

Coil Feeder	Yes
Material Thickness vs. Material Width	.093" x 72.05" [2.35mm x 1830mm]
Feed Pitch Peek Velocity	N/A
Coil Inner Diameter (Max. and Min.)	24.49" & 19.49" [622mm & 495mm]
Coil Outer Diameter (Max.)	71.97" [1828mm]
Material Feed Height (From Top of Bolster)	35.04"-37.01" [890mm-940mm]
Max. Coil Weight	
Roll Lift	Yes
Uncoil	Over Top

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**Thickness Capacity Chart: 72 HDD7**

Material Width (in.)	Maximum Thickness (in.)					
	45 ksi	50 ksi	55 ksi	60 ksi	75 ksi	90 ksi
1						
2						
3						
4						
5						
6						
7						
8						
9						.125
10						.121
11						.117
12						.114
13						.111
14						.108
15						.105
16					.124	.103
17					.121	.101
18					.119	.099
19					.117	.097
20					.115	.096
24					.108	.090
30				.125	.100	.084
36				.118	.094	.079
40			.124	.114	.091	.076
48			.117	.107	.086	.072
50			.115	.106	.085	.071
54		.124	.113	.103	.083	.069
60		.120	.109	.100	.080	.066
72	.125	.113	.102	.094	.075	.063



The maximum thickness that can be processed is .125" due to the size of the looping area. The shaded area represents a .125" thickness:

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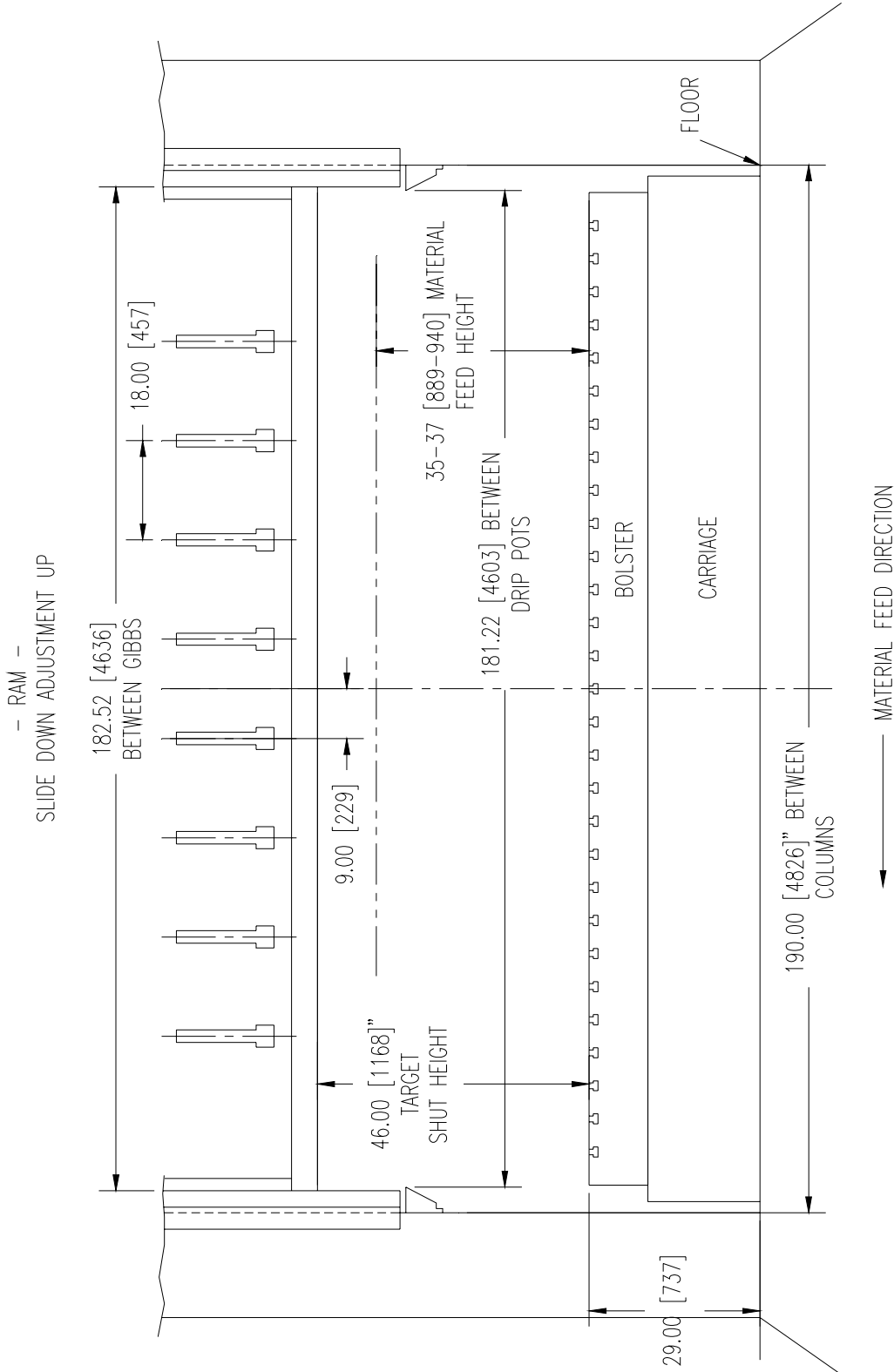
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## FRONT VIEW OF PRESS



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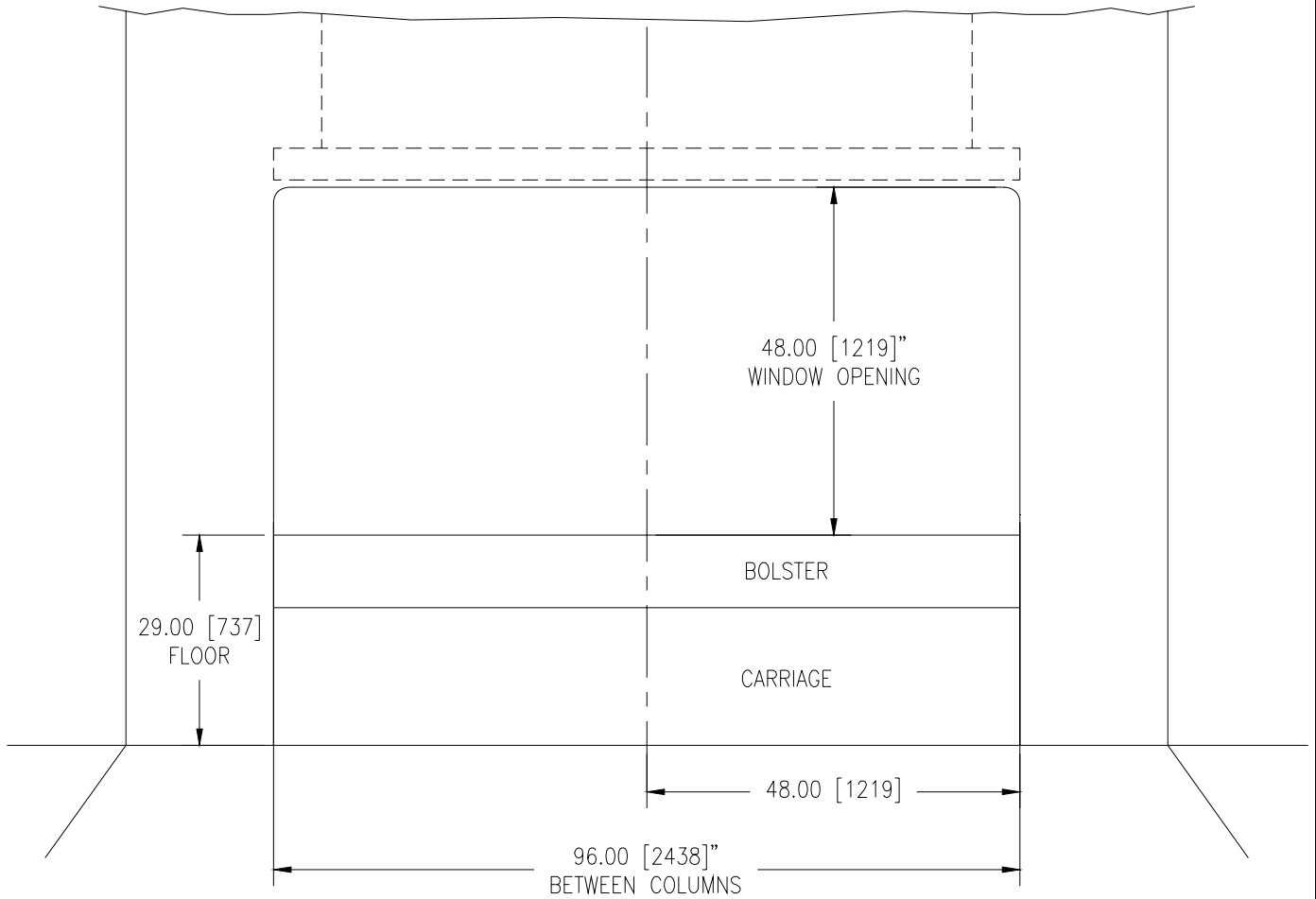
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**SIDE VIEW**



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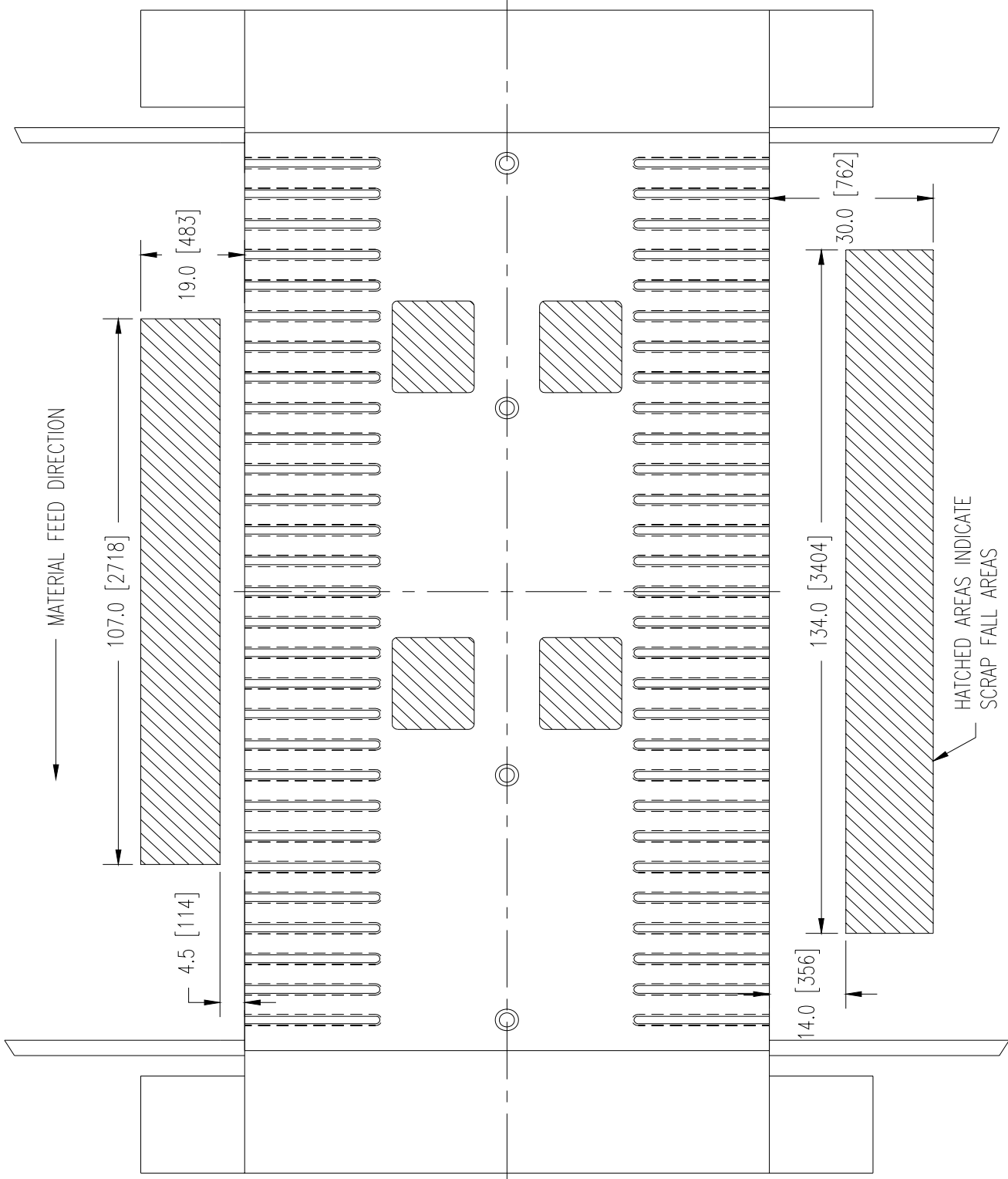
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**TOP VIEW**



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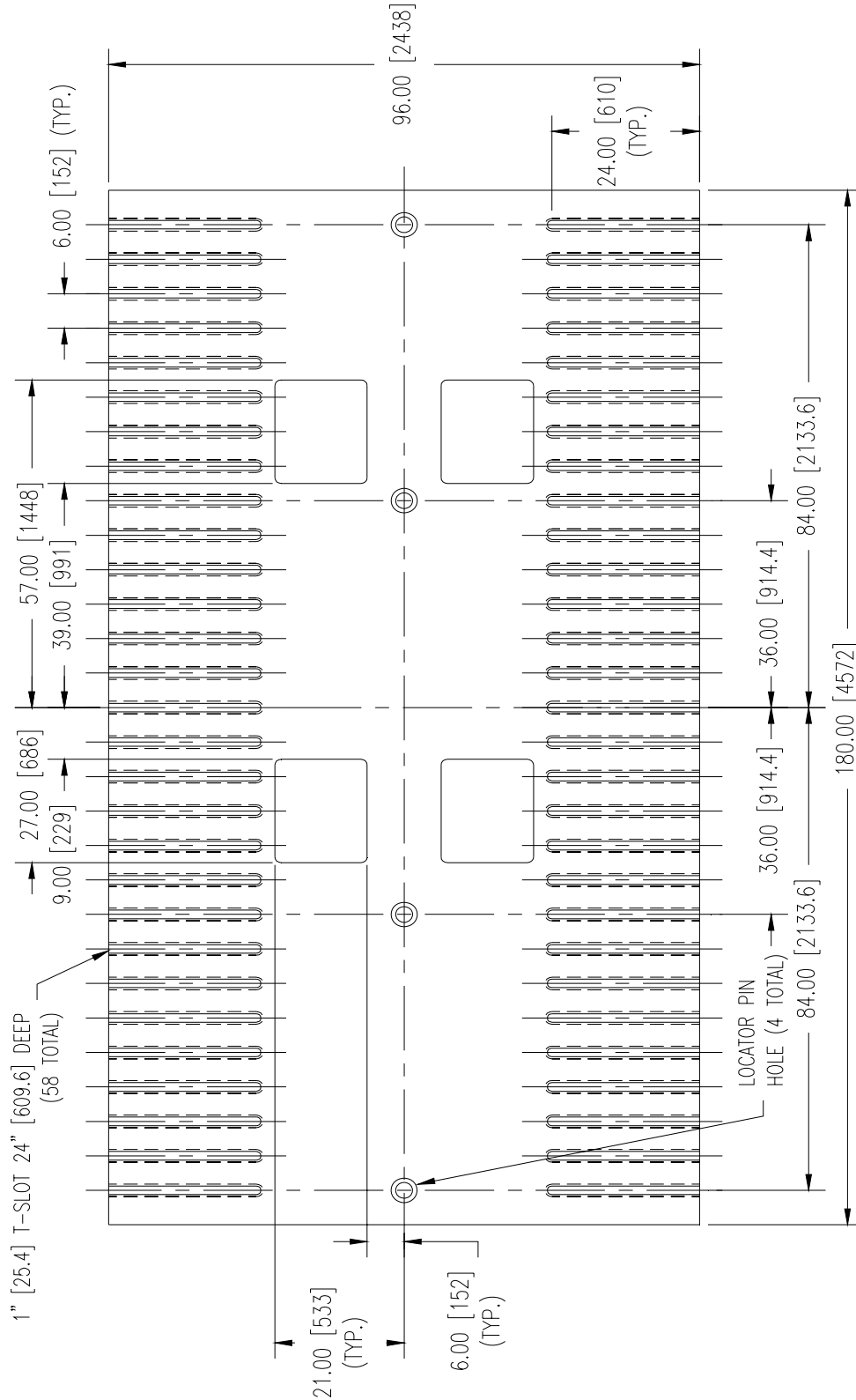
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### BOLSTER PLATE



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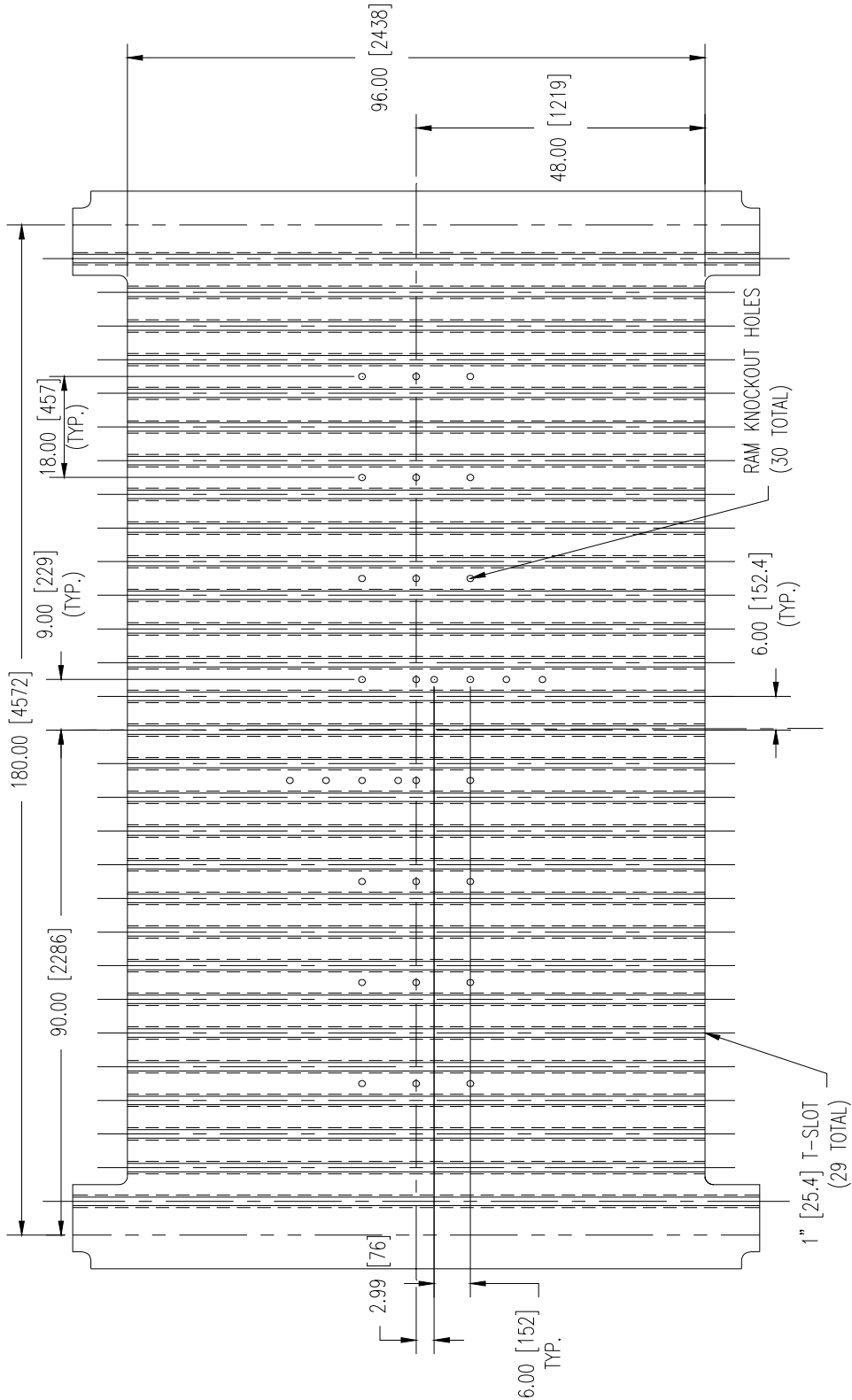
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**RAM FACE**

NOTE: ALL T-SLOTS AND HOLES  
ARE SYMMETRICAL ABOUT  
BOTH CENTERLINES



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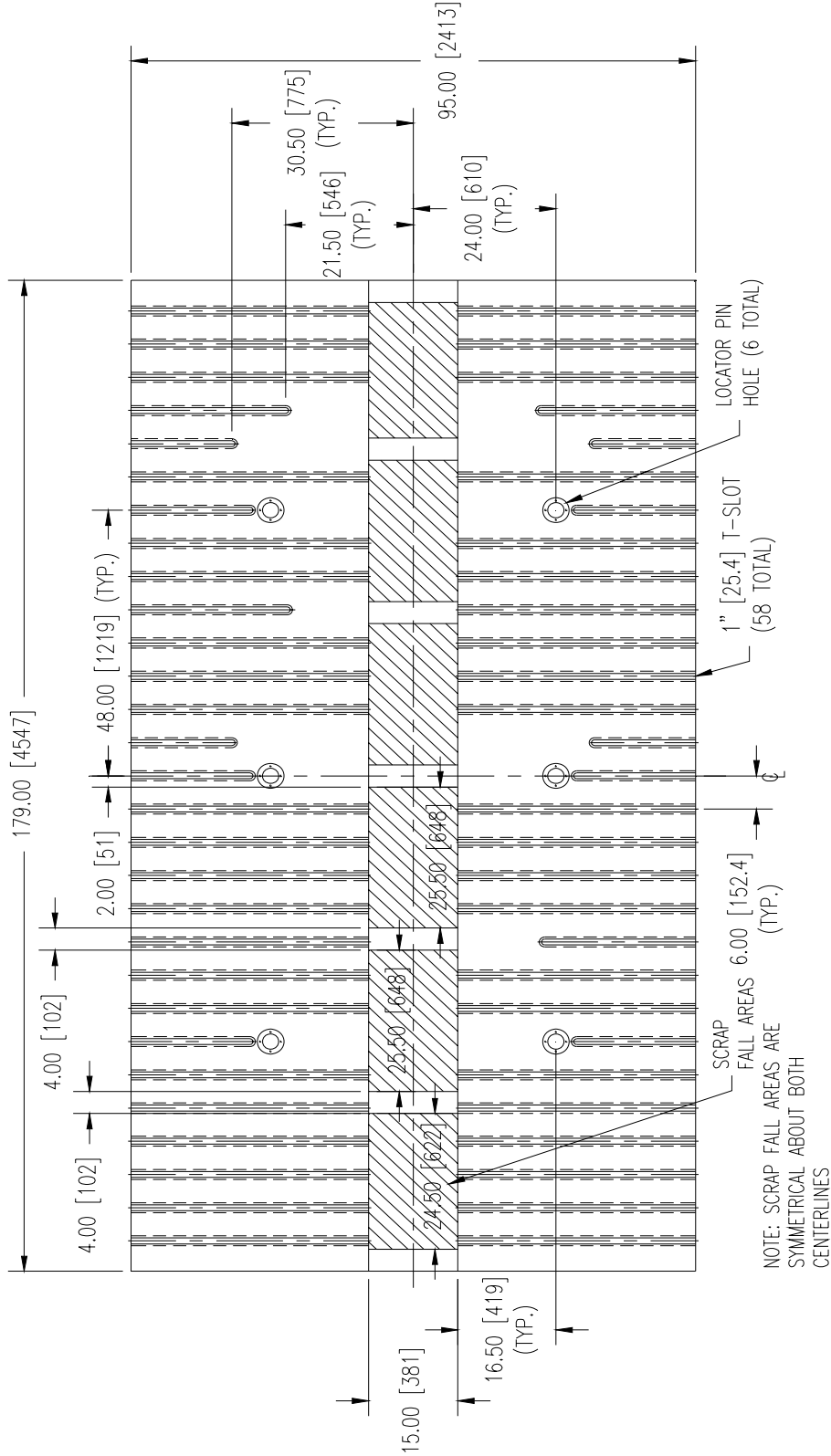
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**A-RISER**



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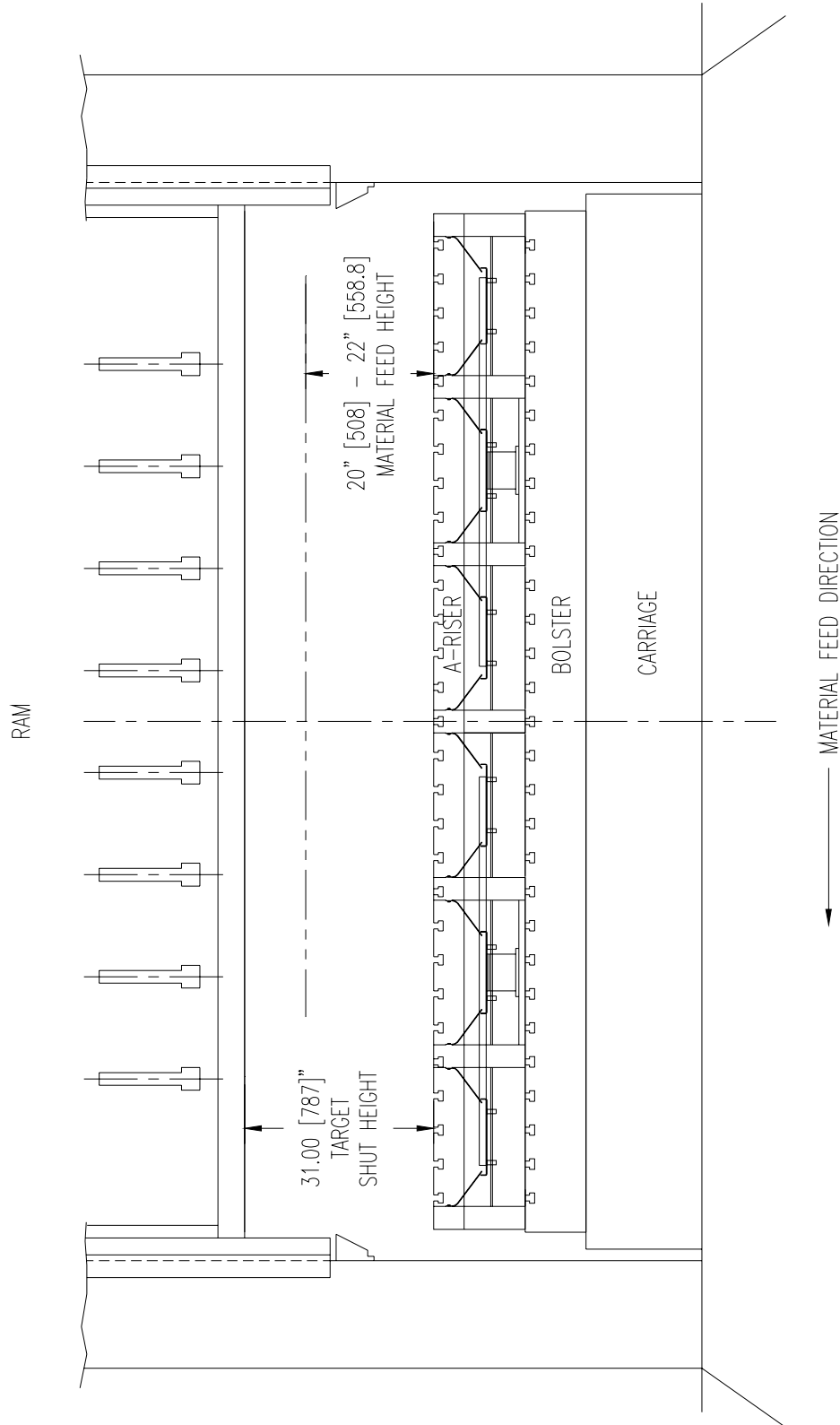
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### A-RISER (IN PRESS POSITION)



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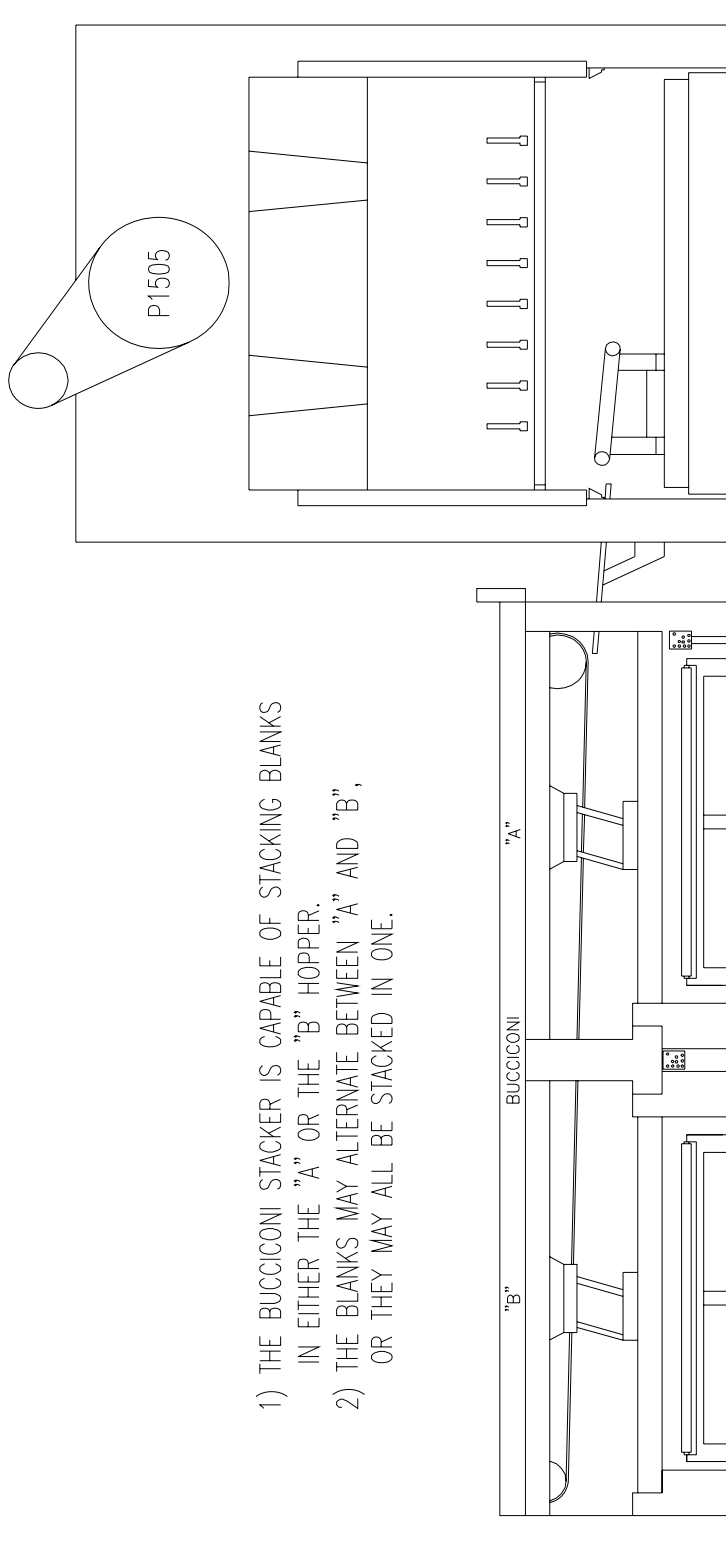
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## COMPLETE VIEW



- 1) THE BUCCICONI STACKER IS CAPABLE OF STACKING BLANKS IN EITHER THE "A" OR THE "B" HOPPER.
- 2) THE BLANKS MAY ALTERNATE BETWEEN "A" AND "B", OR THEY MAY ALL BE STACKED IN ONE.

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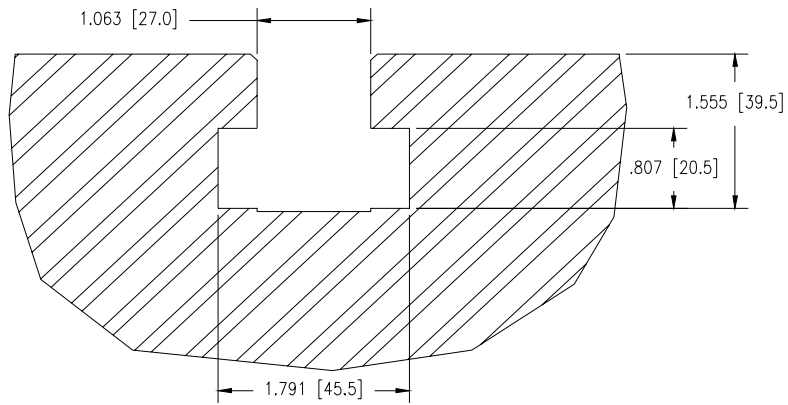
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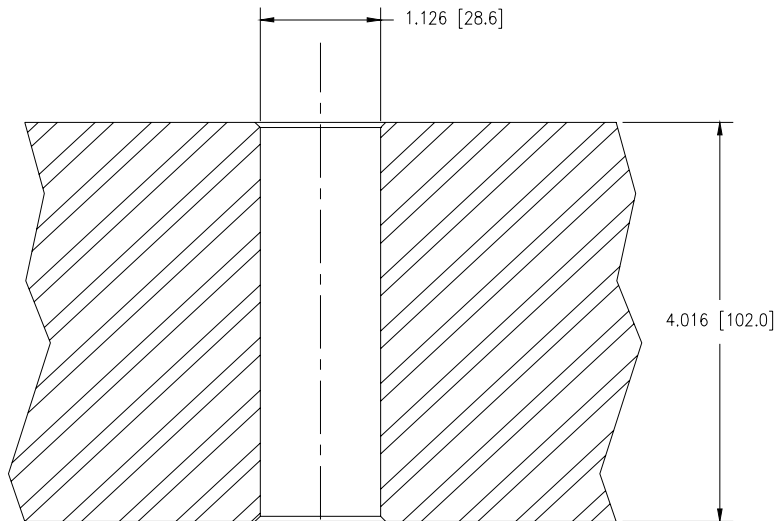
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### SECTIONS



SECTION OF  
T-SLOT



DETAIL OF DIE  
LOCATOR PIN

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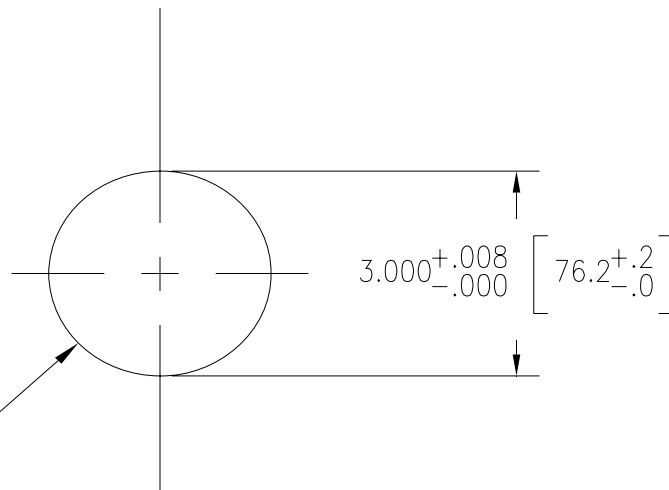
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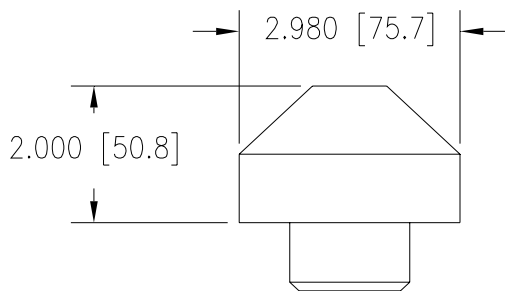
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BORE TO MINIMUM  
DEPTH OF 2.13 [54]



DETAIL OF DIE  
LOCATOR HOLES

REFERENCE



DETAIL OF DIE  
LOCATOR PIN

BORE TO MINIMUM  
DEPTH OF 2.13 [54]

