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### PRESS INFORMATION

	Inner	Outer
Work Capacity .....	1090 MT	727 MT
Ram Size L/R – F/B .....	3000mm-2000mm	3600mm-2500mm
Ram Spacer Thickness .....	None	N/A
Length of Stroke .....	300mm	1010mm
Slide Adjustment .....	N/A	N/A
Shut Height From Bolster S.U. ....	2800mm	2500mm
Target Die Height <i>(Measured From Bolster Plate)</i> .....	1850mm	1550mm
Bolster Size L/R – F/B .....	3600mm-2500mm	
Bolster Thickness .....	500mm	
Rolling Bolster .....	Yes	
Carriage Thickness .....	None	
Bolster Spacer .....	None	
Bolster Spacer Thickness .....	N/A	
Positive Knockout .....	None	
Quick Die Change Sub-Plates .....	None	
Sub-Plate Thickness .....	N/A	
Cushions (Number) .....	Yes (1)	
Tons Each .....	227 MT @ 689.5 kPa	
Tons Total .....	227 MT @ 689.5 kPa	
Stroke .....	275mm	
Size L/R – F/B .....	3000mm-1750mm	
Distance From Bolster To Drip Pots .....	N/A	
Distance Between Gibbs L/R .....	3640mm	
Strokes Per Minute .....	Variable	

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**PRESS INFORMATION (English)**

	Inner	Outer
Work Capacity .....	1200 Ton	800 Ton
Ram Size L/R – F/B .....	118”-79”	141”-98”
Ram Spacer Thickness .....	None	None
Length of Stroke .....	11.8”	39.75”
Slide Adjustment .....	None	None
Shut Height From Bolster S.U. ....	110”	98.5”
Target Die Height <i>(Measured From Bolster Plate)</i> .....	72.8”	61”
Bolster Size L/R – F/B .....	141”-98.5”	
Bolster Thickness .....	19.6”	
Rolling Bolster .....	Yes	
Carriage Thickness .....	None	
Bolster Spacer .....	None	
Bolster Spacer Thickness .....	N/A	
Positive Knockout .....	None	
Quick Die Change Sub-Plates .....	None	
Sub-Plate Thickness .....	N/A	
Cushions (Number) .....	Yes (1)	
Tons Each .....	250 Tons @ 100 p.s.i.	
Tons Total .....	250 Tons @ 100 p.s.i.	
Stroke .....	10 7/8”	
Size L/R – F/B .....	118”-69”	
Distance From Bolster To Drip Pots .....	N/A	
Distance Between Gibbs L/R .....	143”	
Strokes Per Minute .....	Variable	

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**AUTOMATION DEVICES USED**

**LOADER**

Destacker / Rollcoater / Loader .....	Yes
Max. Sheet Thickness .....	5.00mm
Min. Sheet Thickness .....	.64mm
Max. Sheet Size L/R – F/B .....	2540mm – 1778mm
Min. Sheet Size L/R – F/B .....	1016mm – 610mm
Max. Loader Pass Height .....	1422mm
<i>(From Top Of Bolster)</i>	
Min. Loader Pass Height .....	864mm
<i>(From Top Of Bolster)</i>	
Max. Stack Height .....	533mm
<i>(Including Pallet)</i>	

**UNLOADER**

Unloader .....	Yes (1 Five axis Fanuc Robot)
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## **PRESS INFORMATION GENERAL**

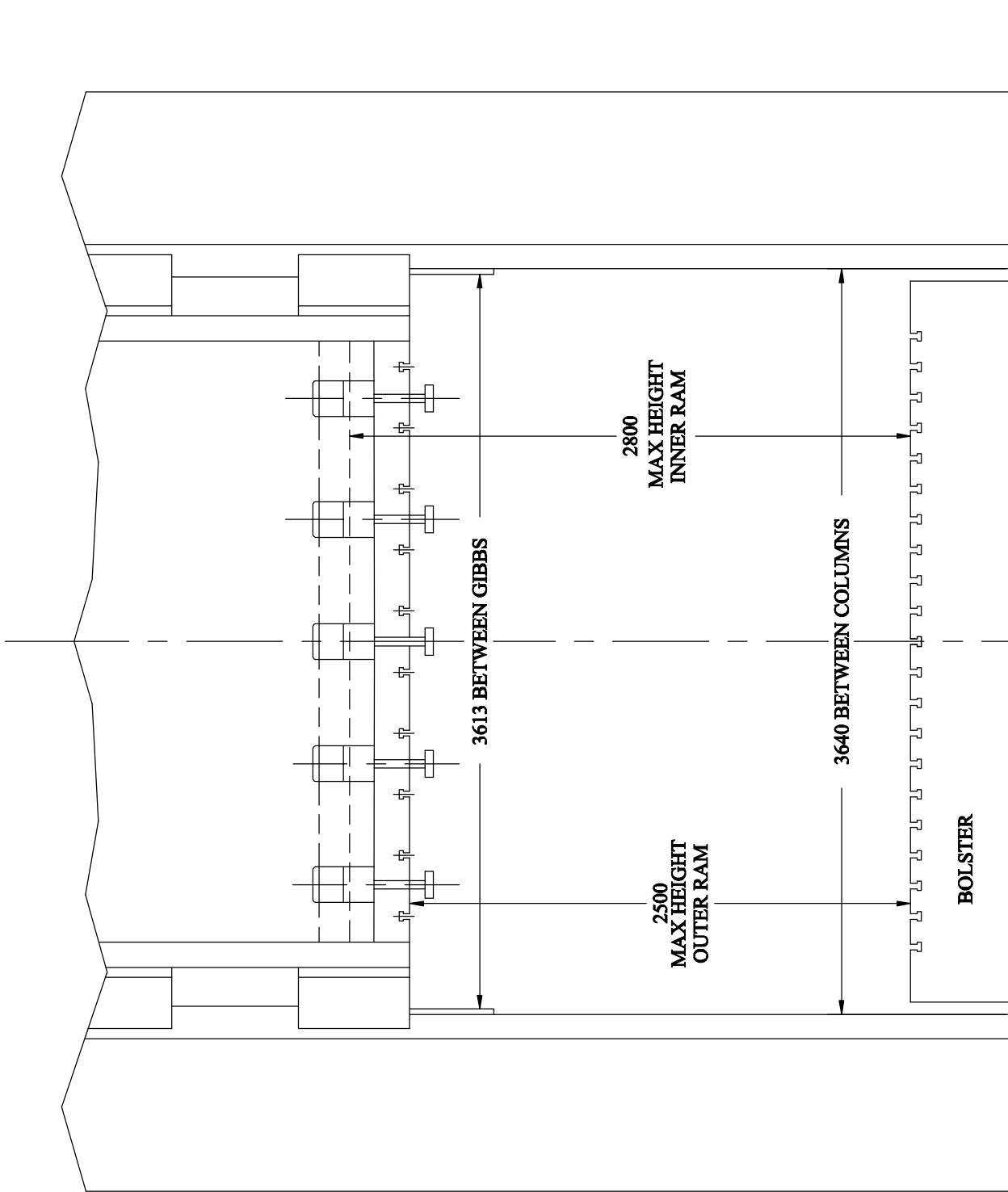
### Comments:

- 1) Between the 2100 press and the 2101 press there are two 5 axis Fanuc robots. These robots can either hand the part off to each other (which enables the part to be turned over), or the part may be placed on a jig between the presses (which will allow the part to be set in the next press without being turned over).
- 2) The 2100 press has double rolling bolsters which use locating pins for die placement.
- 3) The inner ram of this press has (10) locking mechanisms which pass through the upper die adapter plate, rotate 90 degrees, then pull upward to secure the plate to the inner ram (see detail).

Note: when the locks are in their locked position, they are perpendicular to the t-slots in the ram.

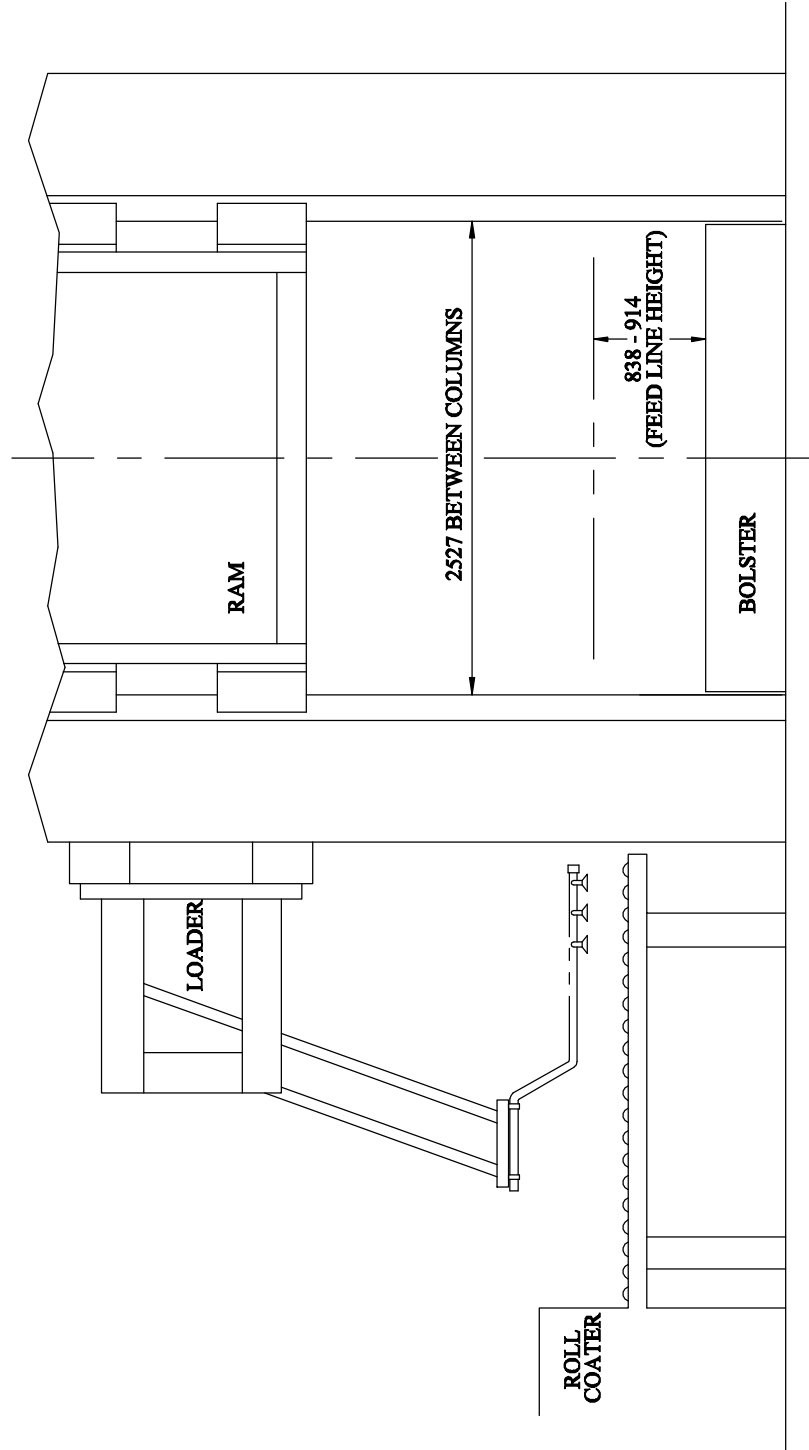
- 4) The outer ram of this press has (10) locking mechanisms which swing into position, then pull upward to clamp the bullring into place (see detail). These clamps do not slide in to reach the bullring, therefore the bullring must be wide enough (F/B) to reach the outer clamps.
- 5) Any set of dies with less than (6) operations must also include enough idle stations to allow part travel through the end of the press line.

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**FRONT VIEW**

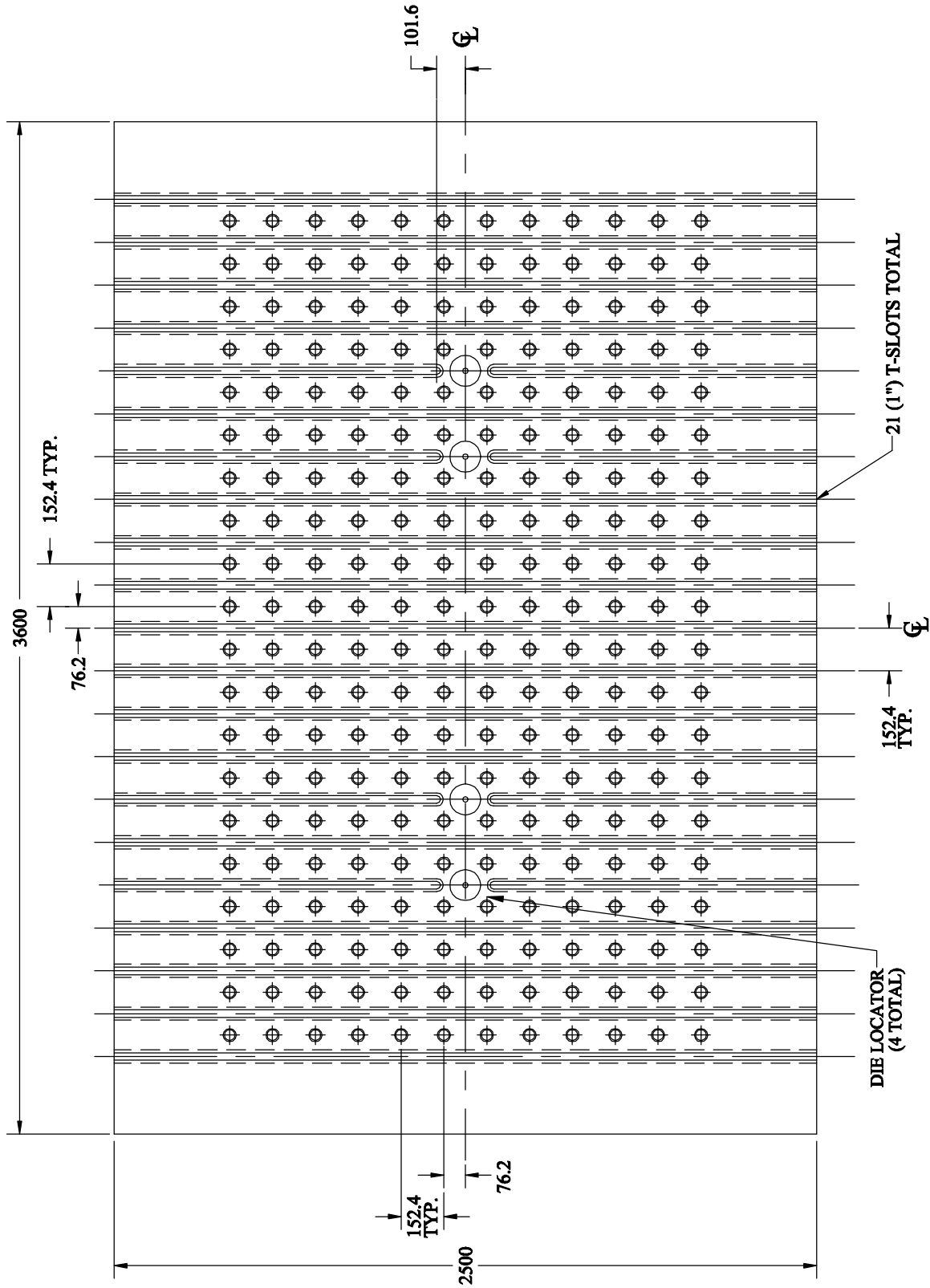
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# SIDE VIEW (LOADER)

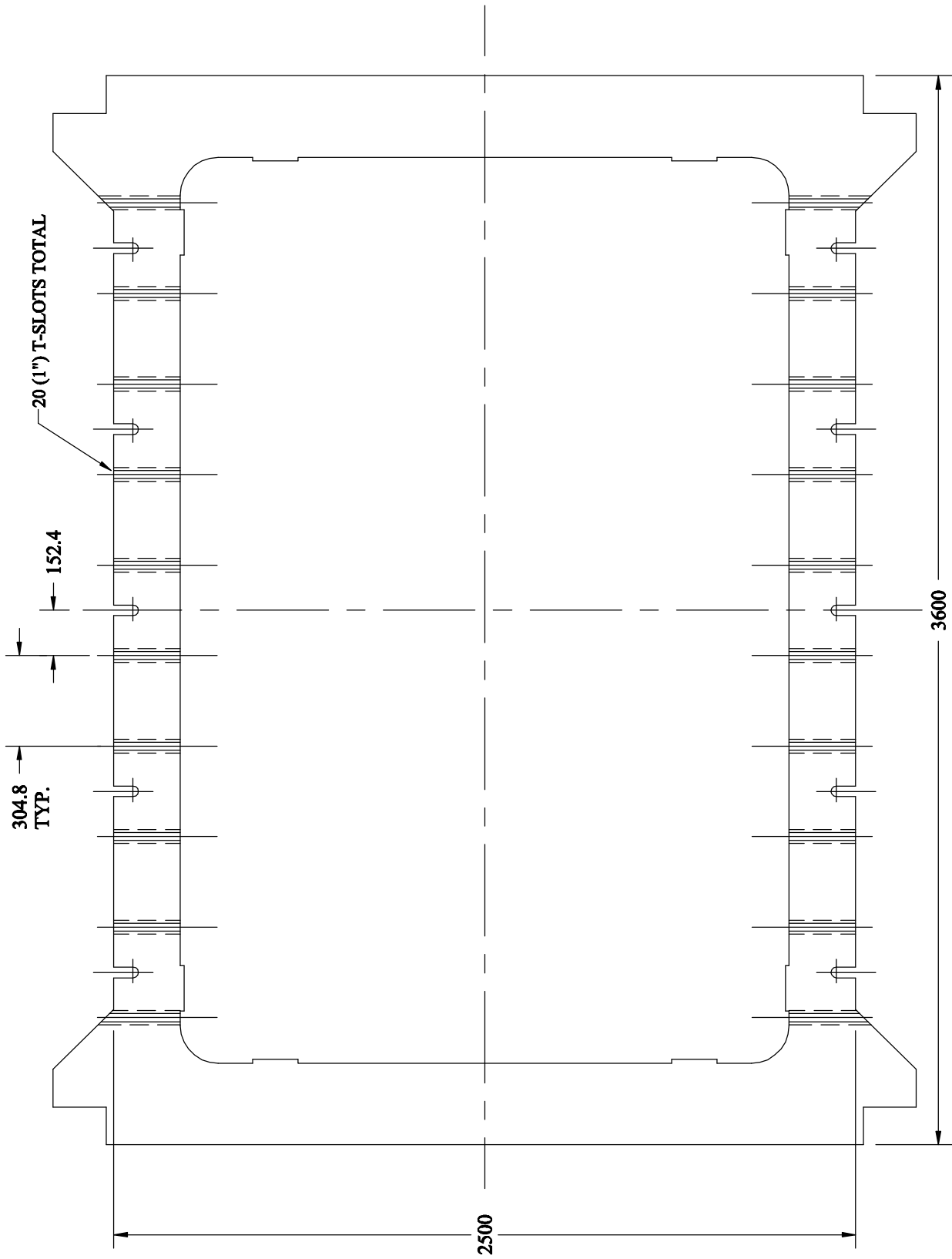
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NOTE: ALL T-SLOTS AND HOLES  
ARE SYMMETRICAL ABOUT  
BOTH CENTERLINES



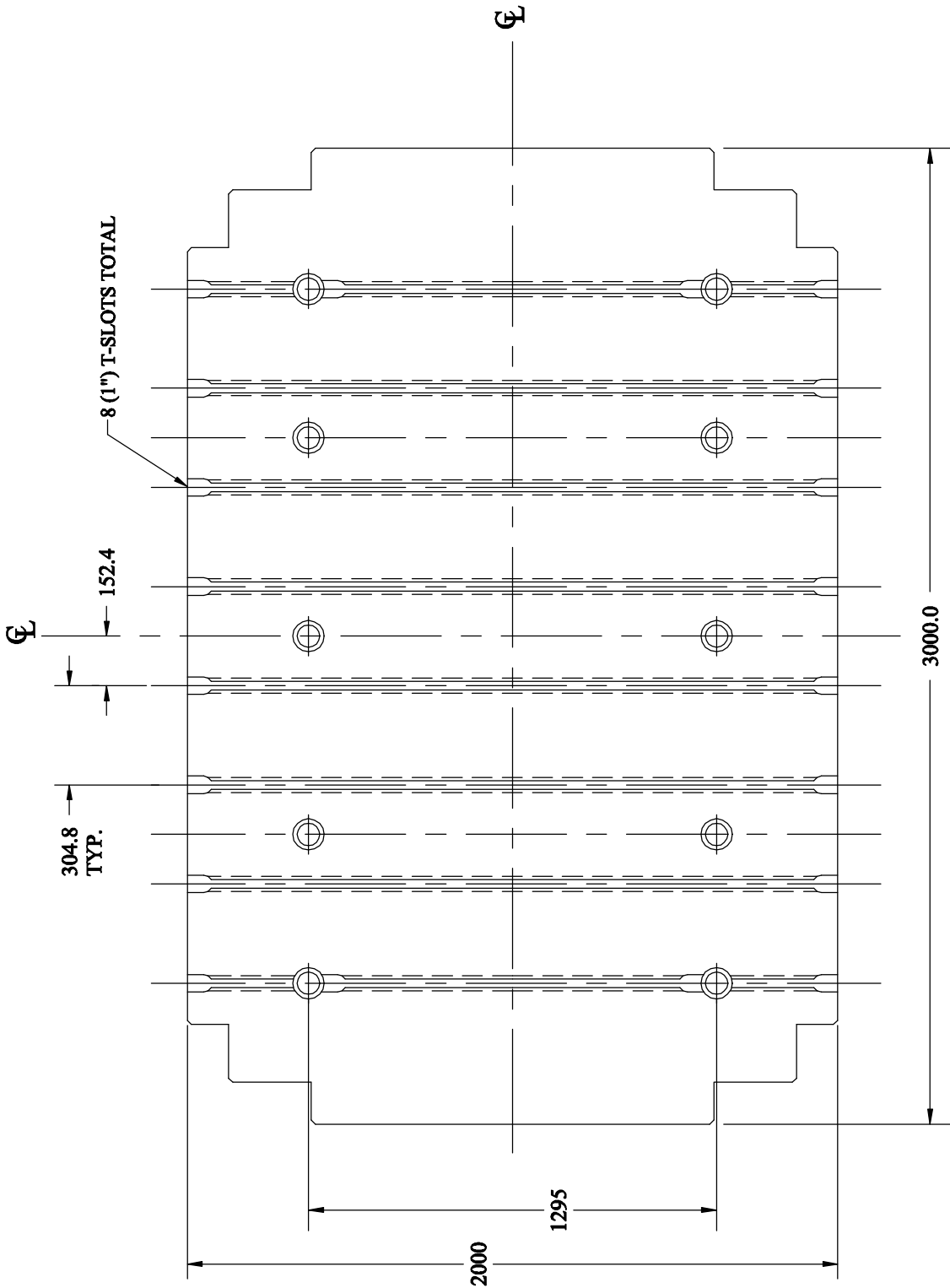
# BOLSTER PLATE

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# OUTER RAM FACE

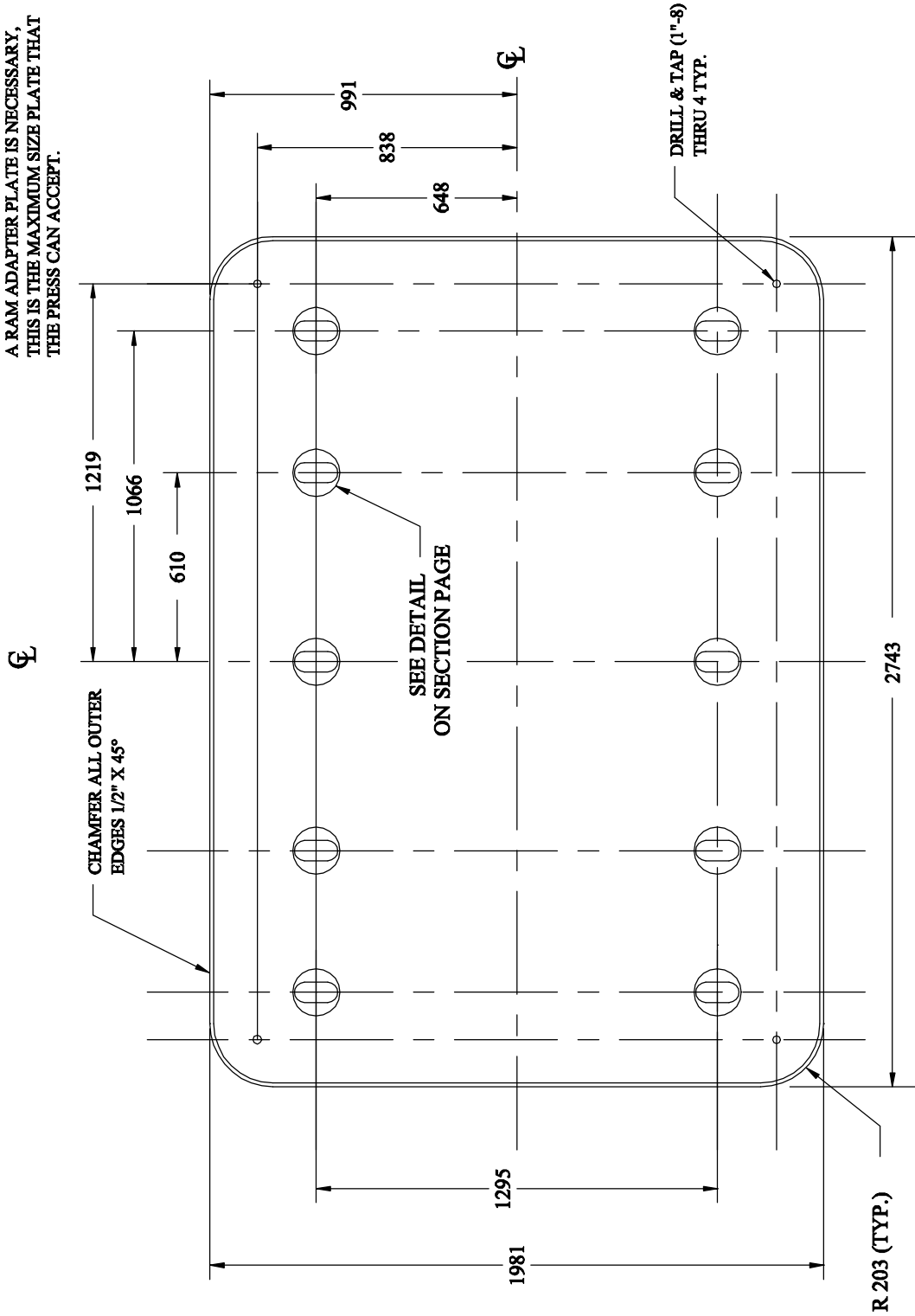
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INNER RAM FACE

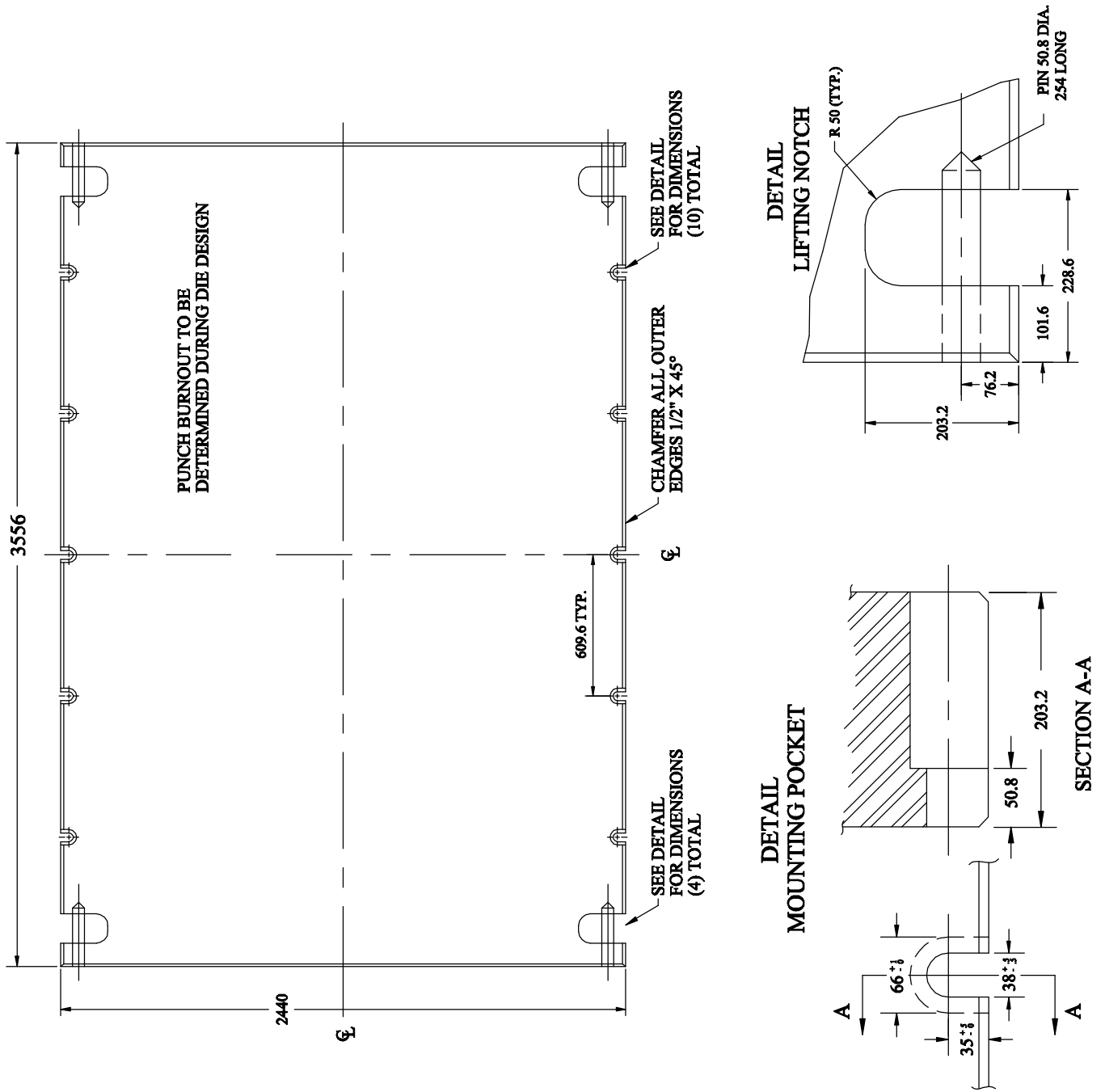
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IF THE DIE DESIGN DETERMINES THAT  
A RAM ADAPTER PLATE IS NECESSARY,  
THIS IS THE MAXIMUM SIZE PLATE THAT  
THE PRESS CAN ACCEPT.



# INNER RAM (ADAPTER PLATE)

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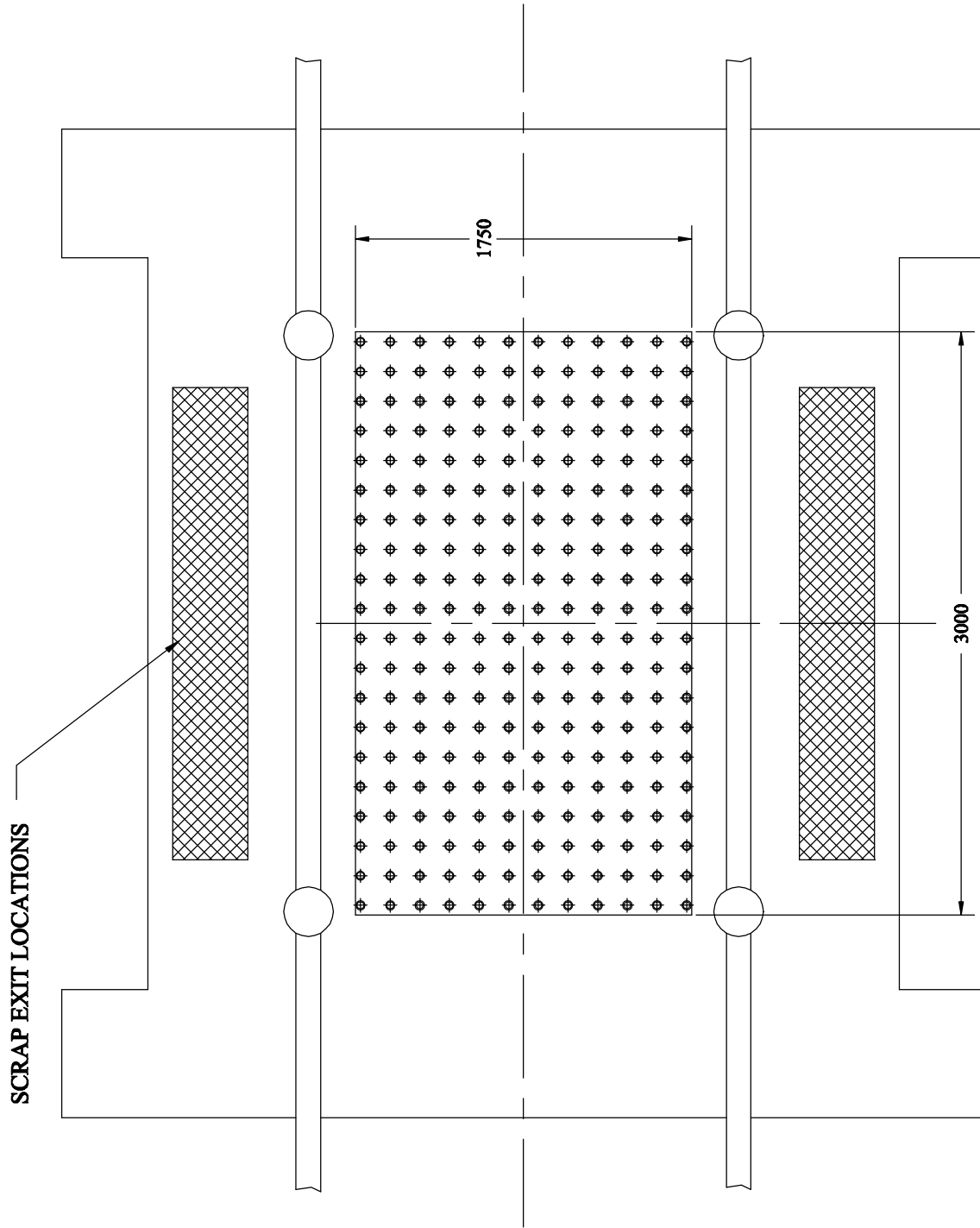


# BULL RING

## (VIEW DOWN THROUGH RAM)



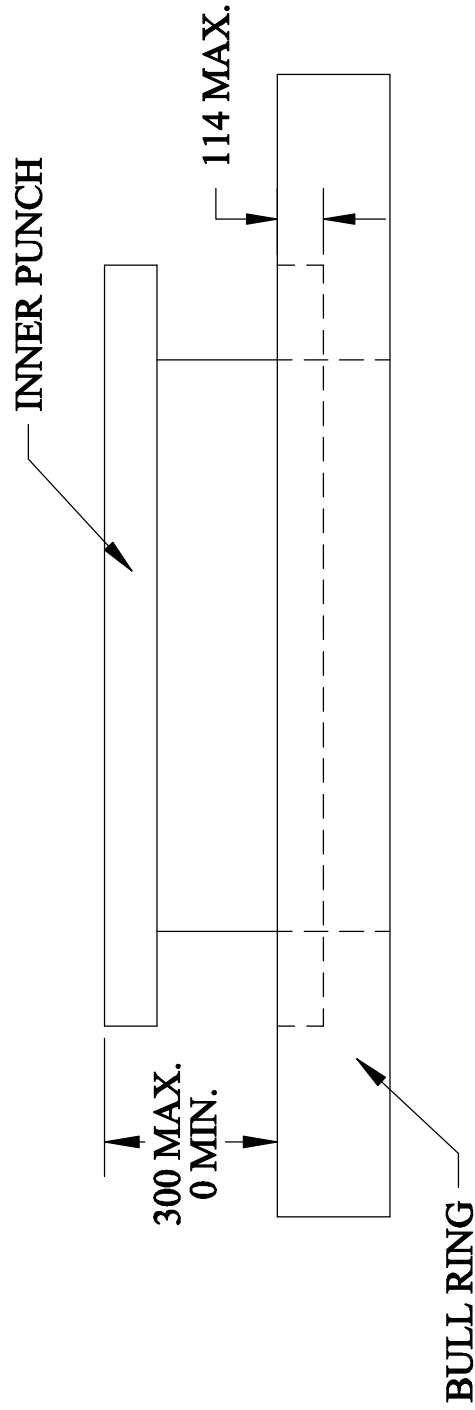
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# TOP VIEW OF CUSHION

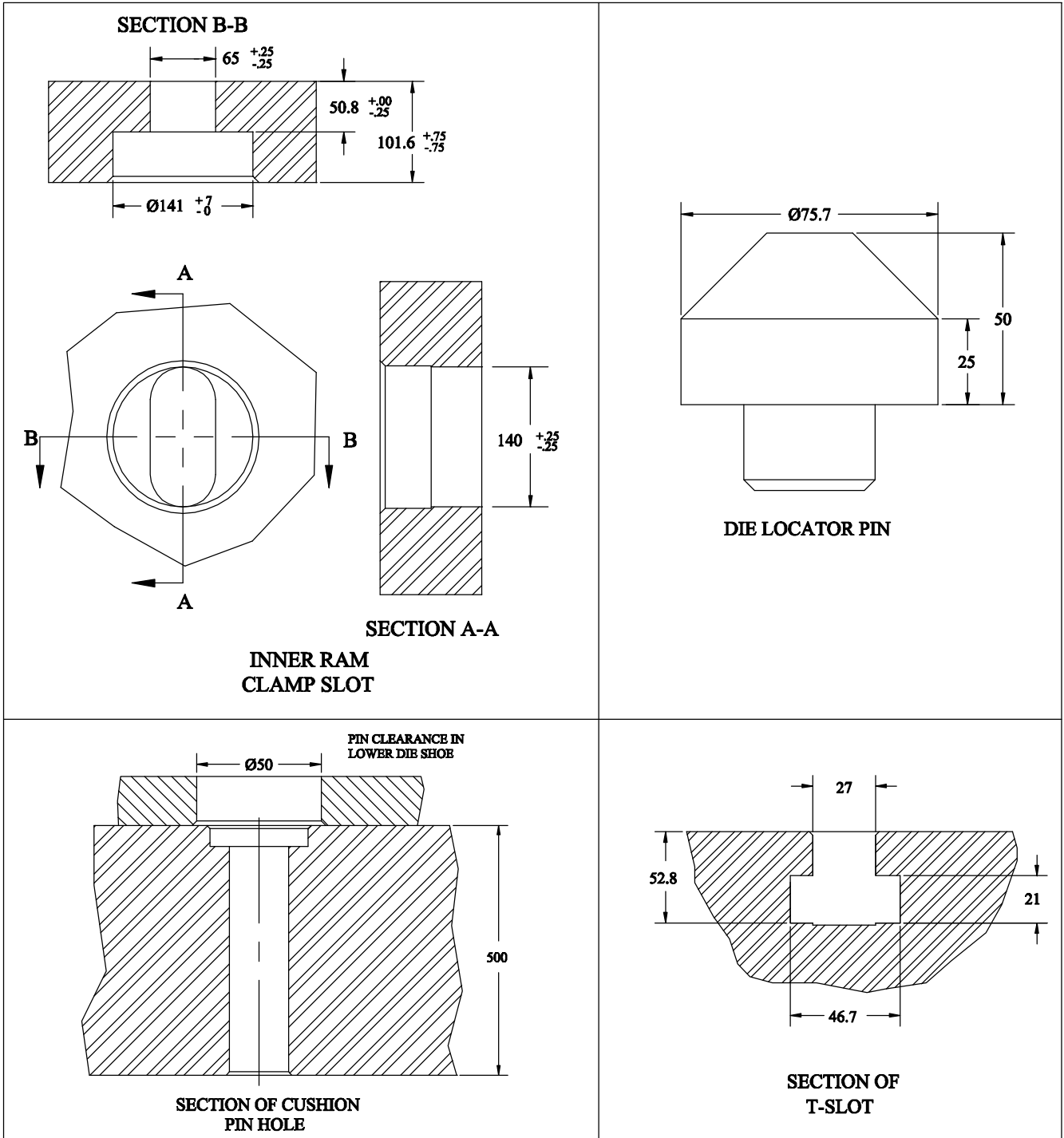
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NOTE: THE BULL RING MAY BE POCKETED OUT TO A MAXIMUM DEPTH OF 114 MM. TO ALLOW FULL TRAVEL (300mm) OF INNER RAM.



# UPPER DIE STROKE

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# SECTIONS