



Revision 4	Date 07-Feb-00	Page 2 of 11	Specification No. S 02.015
---------------	-------------------	-----------------	-------------------------------

### PRESS INFORMATION

	Inner	Outer
Work Capacity .....	727 MT	N/A
Ram Size L/R – F/B .....	3600mm-2430mm	N/A
Ram Spacer Thickness .....	None	N/A
Length of Stroke .....	1220mm	N/A
Slide Adjustment .....	None	N/A
Shut Height From Bolster S.U. ....	2250mm	N/A
Target Die Height <i>(Measured From Bolster Plate)</i> .....	1168mm	N/A
Bolster Size L/R – F/B .....	3600mm-2100mm	
Bolster Thickness .....	350mm	
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-1450mm	
Distance From Bolster To Drip Pots .....	N/A	
Distance Between Columns L/R .....	3640mm	
Strokes Per Minute .....	Variable	

Revision 4	Date 07-Feb-00	Page 3 of 11	Specification No. S 02.015
---------------	-------------------	-----------------	-------------------------------

**PRESS INFORMATION (English)**

	Inner	Outer
Work Capacity .....	800 Ton	N/A
Ram Size L/R – F/B .....	141”-95.5”	N/A
Ram Spacer Thickness .....	None	N/A
Length of Stroke .....	48”	N/A
Slide Adjustment .....	None	N/A
Shut Height From Bolster S.U. ....	88.6”	N/A
Target Die Height <i>(Measured From Bolster Plate)</i> .....	46”	N/A
Bolster Size L/R – F/B .....	141”-82.5”	
Bolster Thickness .....	13.75”	
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 .....	10.8”	
Size L/R – F/B .....	118”-57”	
Distance From Bolster To Drip Pots .....	N/A	
Distance Between Columns L/R .....	143”	
Strokes Per Minute .....	Variable	

Revision 4	Date 07-Feb-00	Page 4 of 11	Specification No. S 02.015
---------------	-------------------	-----------------	-------------------------------

**AUTOMATION DEVICES USED**

**LOADER**

<del>Destacker / Rollcoater /</del> Loader .....	1 Five Axis Fanuc Robot
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 .....	N/A
<i>(From Top Of Bolster)</i>	
Min. Loader Pass Height .....	N/A
<i>(From Top Of Bolster)</i>	
Max. Stack Height .....	N/A
<i>(Including Pallet)</i>	

**UNLOADER**

Unloader .....	1 Five Axis Fanuc Robot
----------------	-------------------------

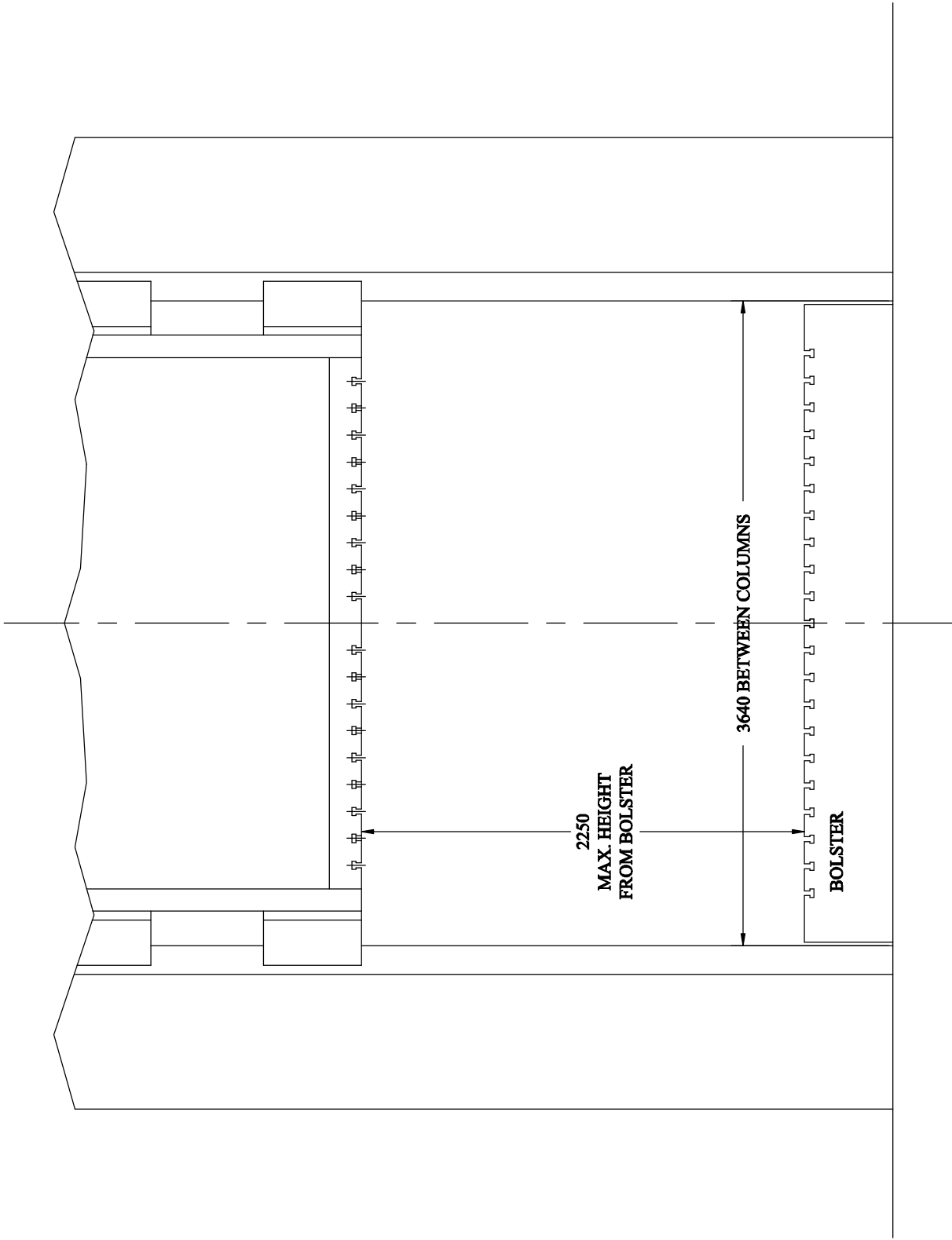
Revision 4	Date 07-Feb-00	Page 5 of 11	Specification No. S 02.015
---------------	-------------------	-----------------	-------------------------------

## **PRESS INFORMATION GENERAL**

### Comments:

- 1) Between each press there is only one Five Axis Fanuc Robot. This robot does not have the ability to turn the part over.
- 2) Each press has double rolling bolsters which use locating pins for die placement.
- 3) The ram of each press has (8) hydraulic die clamps. There must be sufficient clearance, around each clamp slot area, to allow room for the head of the die clamp.
- 4) Any die sets with less than (6) operations must also include enough idle stations to allow part travel through the end of the press line.

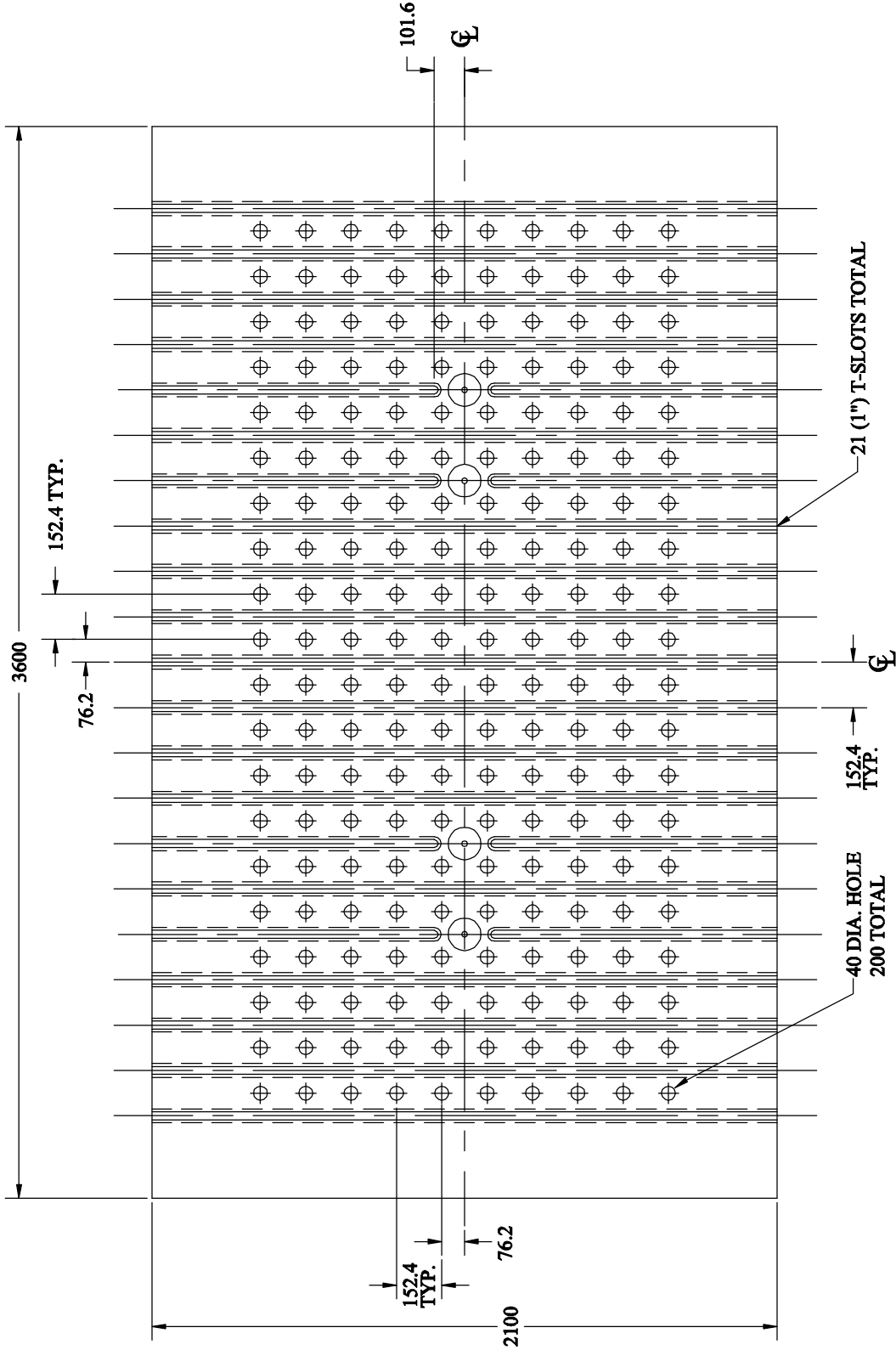
<b>Revision</b> 4	<b>Date</b> 07-Feb-00	<b>Page</b> 6 of 11	<b>Specification No.</b> S02.015
----------------------	--------------------------	------------------------	-------------------------------------



# FRONT VIEW

Revision 4	Date 07-Feb-00	Page 7 of 11	Specification No. S02.015
---------------	-------------------	-----------------	------------------------------

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

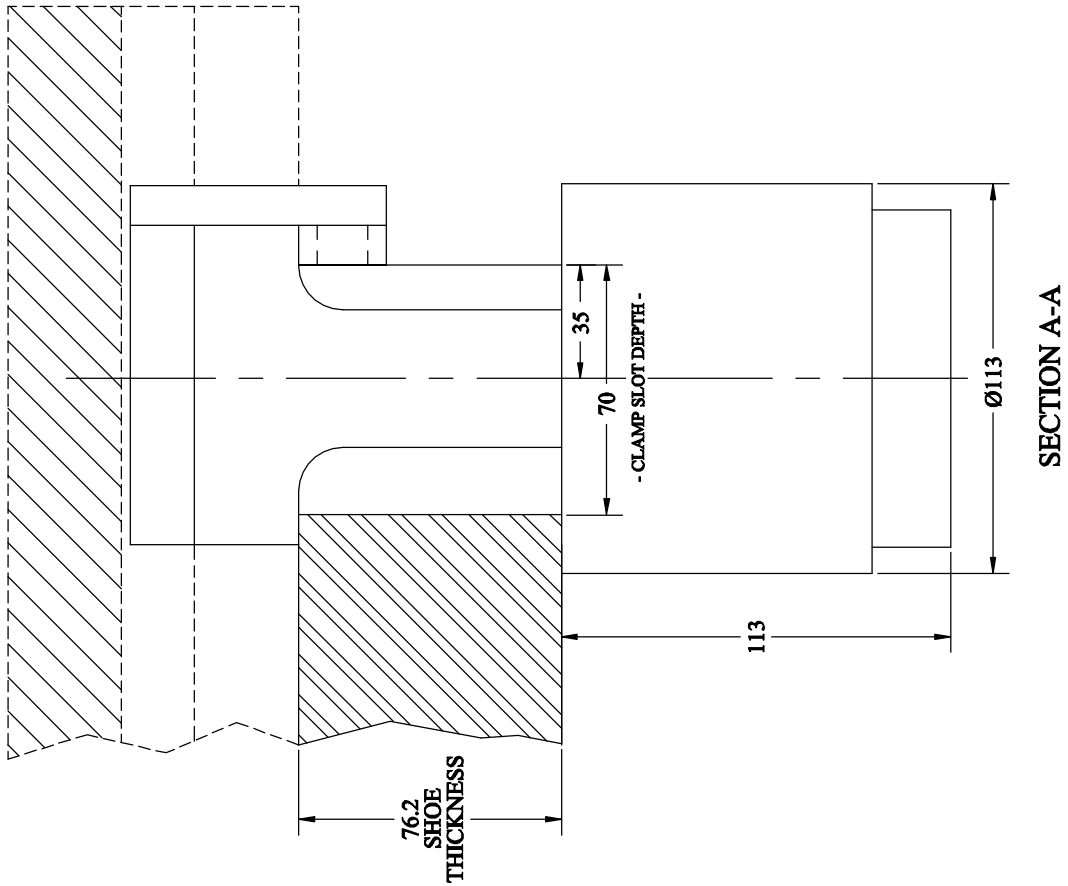
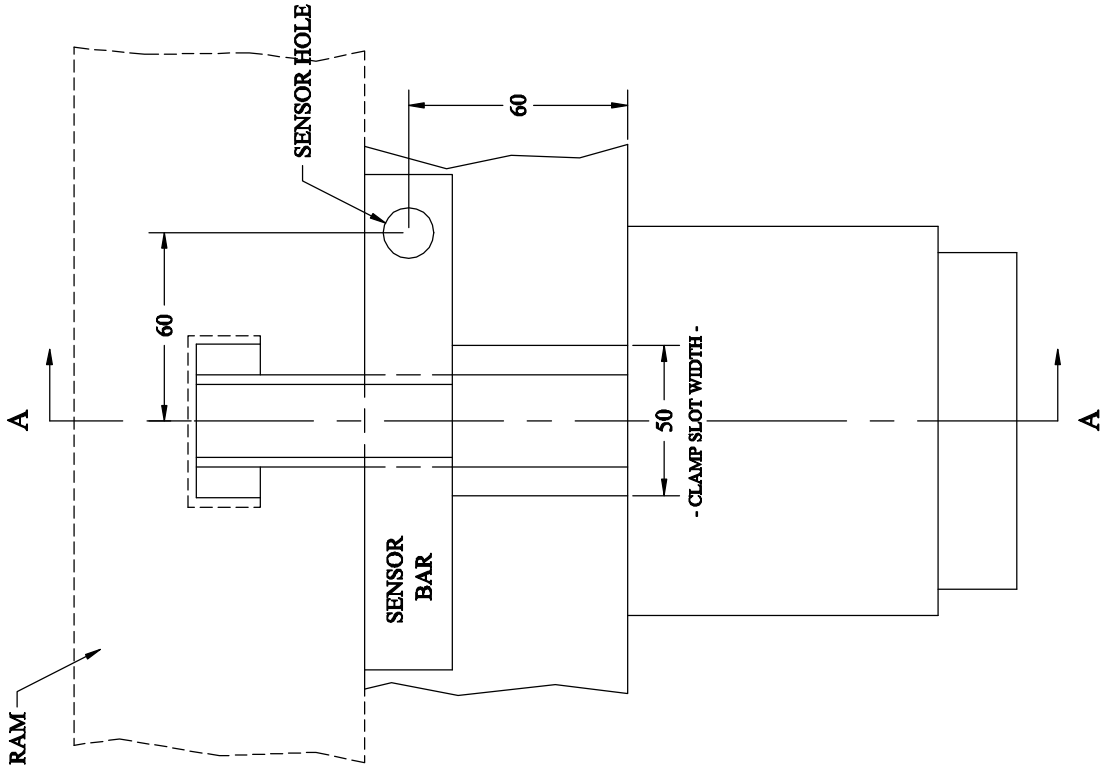


# BOLSTER PLATE



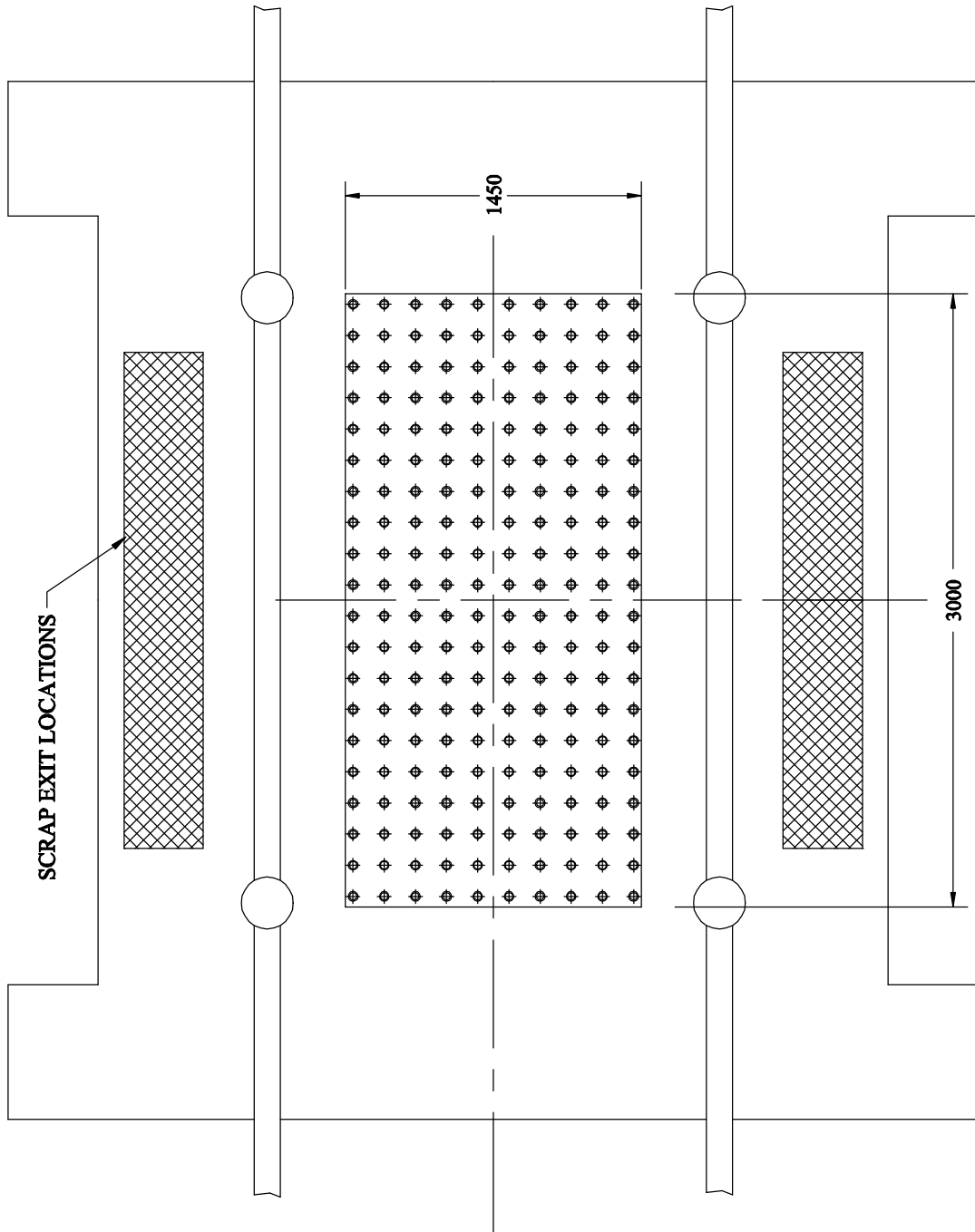
Revision 4	Date 07-Feb-00	Page 9 of 11	Specification No. S02.015
---------------	-------------------	-----------------	------------------------------

HYDRAULIC DIE CLAMPS  
97.8 kN (11 TONS) EACH  
8 CLAMPS TOTAL



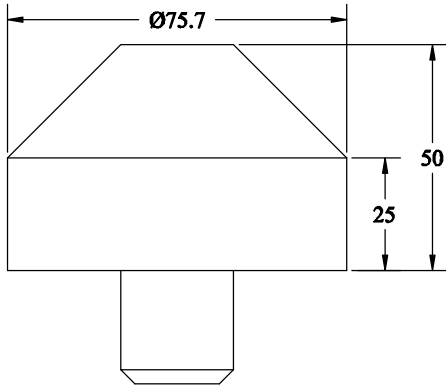
# CLAMP SLOT DETAIL

Revision 4	Date 07-Feb-00	Page 10 of 11	Specification No. S02.015
---------------	-------------------	------------------	------------------------------

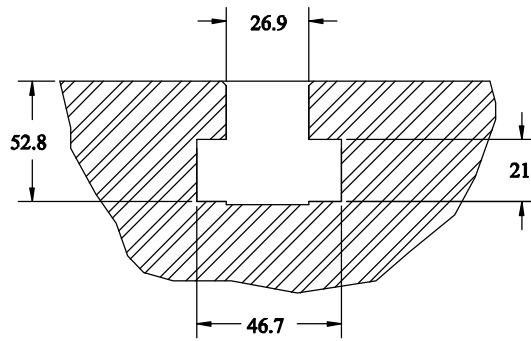


**TOP VIEW**  
(CUSHION LAYOUT)

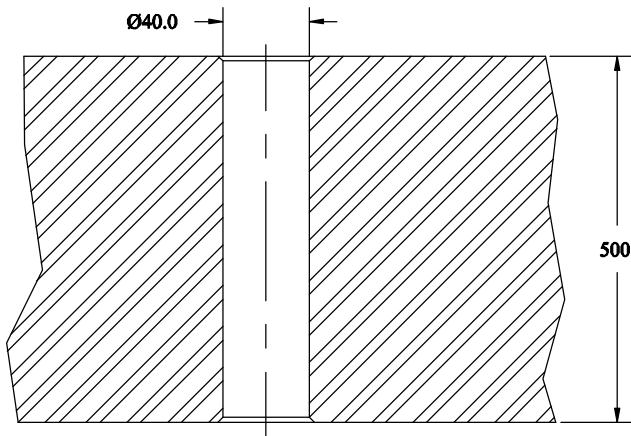
<b>Revision</b> 4	<b>Date</b> 07-Feb-00	<b>Page</b> 11 of 11	<b>Specification No.</b> S02.015
----------------------	--------------------------	-------------------------	-------------------------------------



**DIE LOCATOR PIN**



**SECTION OF  
T-SLOT**



**SECTION OF  
CUSHION PIN  
HOLE**

# SECTIONS