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PRESS INFORMATION

	Inner	Outer
Work Capacity	545 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	

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PRESS INFORMATION (English)

	Inner	Outer
Work Capacity	600 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	

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AUTOMATION DEVICES USED

LOADER

Destacker / Rollcoater / 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
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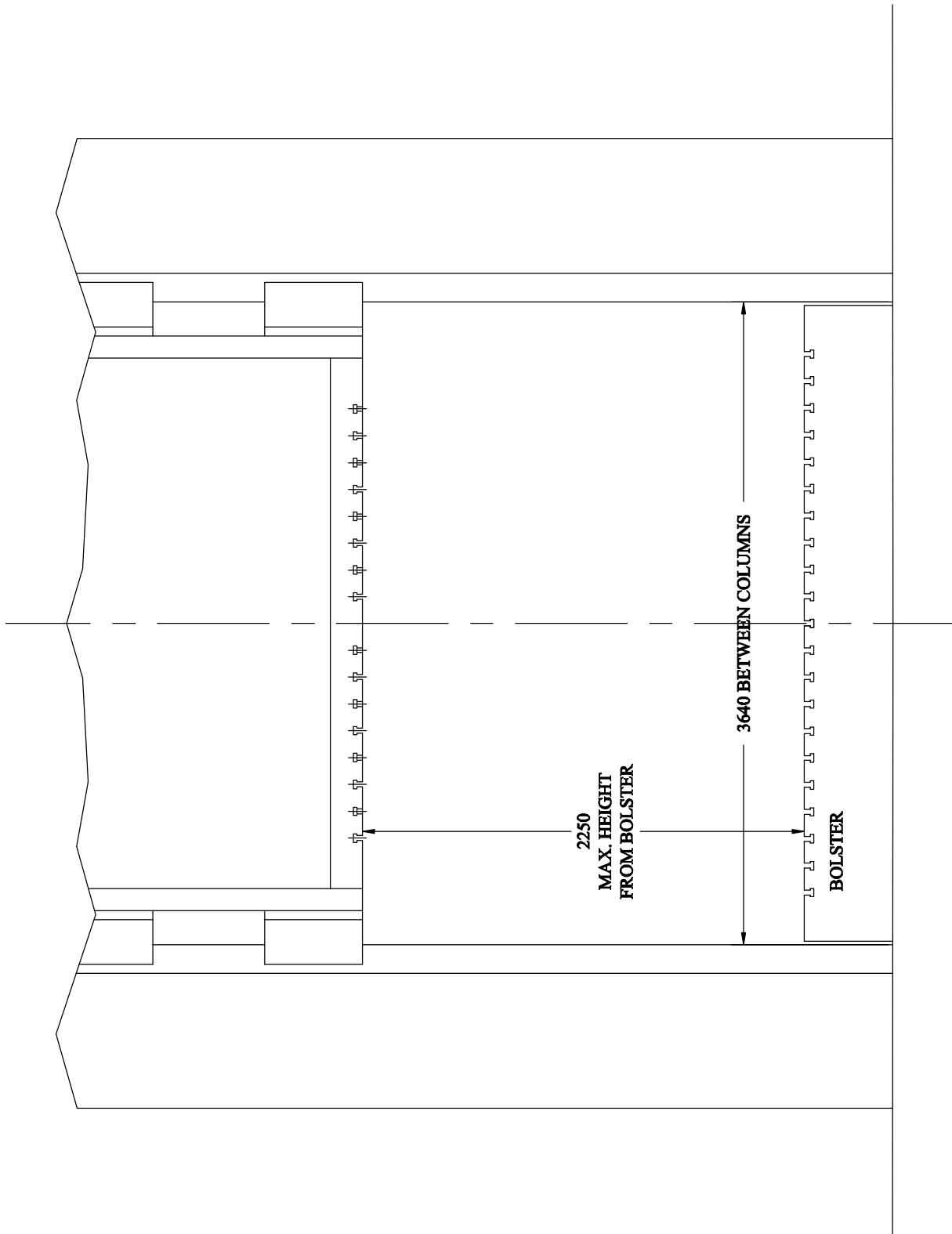
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PRESS INFORMATION GENERAL

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.

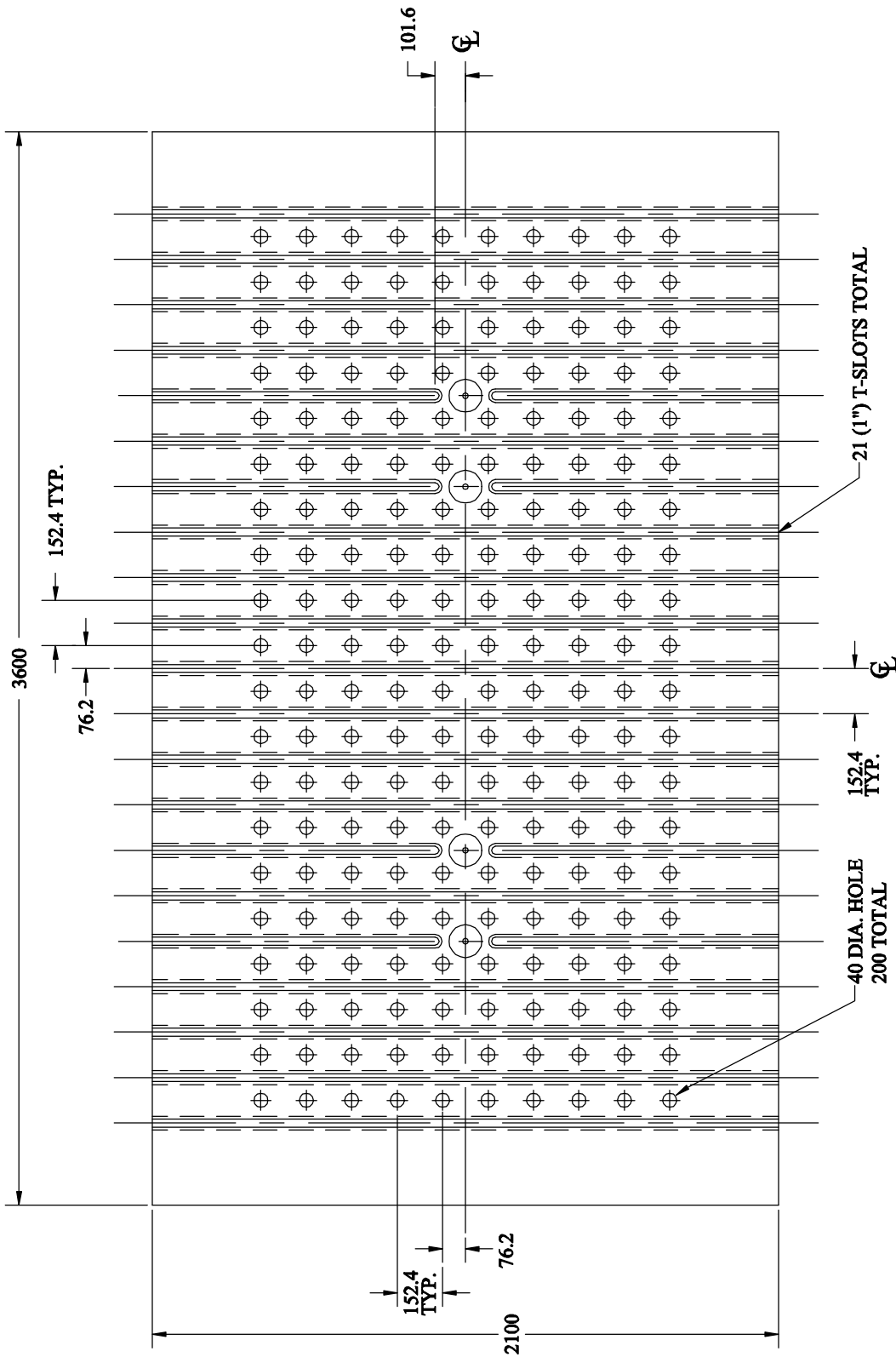
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FRONT VIEW

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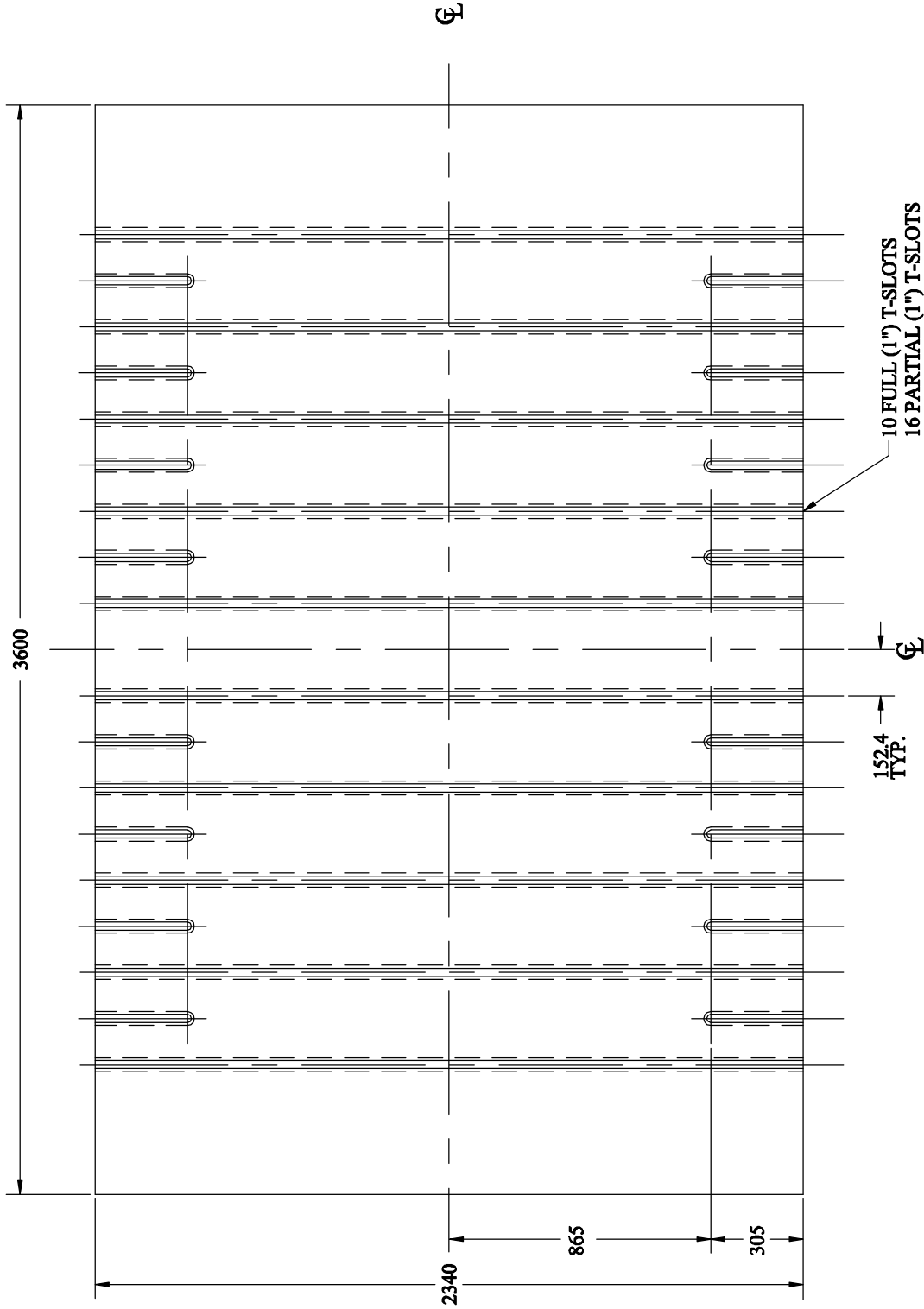
NOTE: ALL T-SLOTS AND HOLES
ARE SYMMETRICAL ABOUT
BOTH CENTERLINES



BOLSTER PLATE

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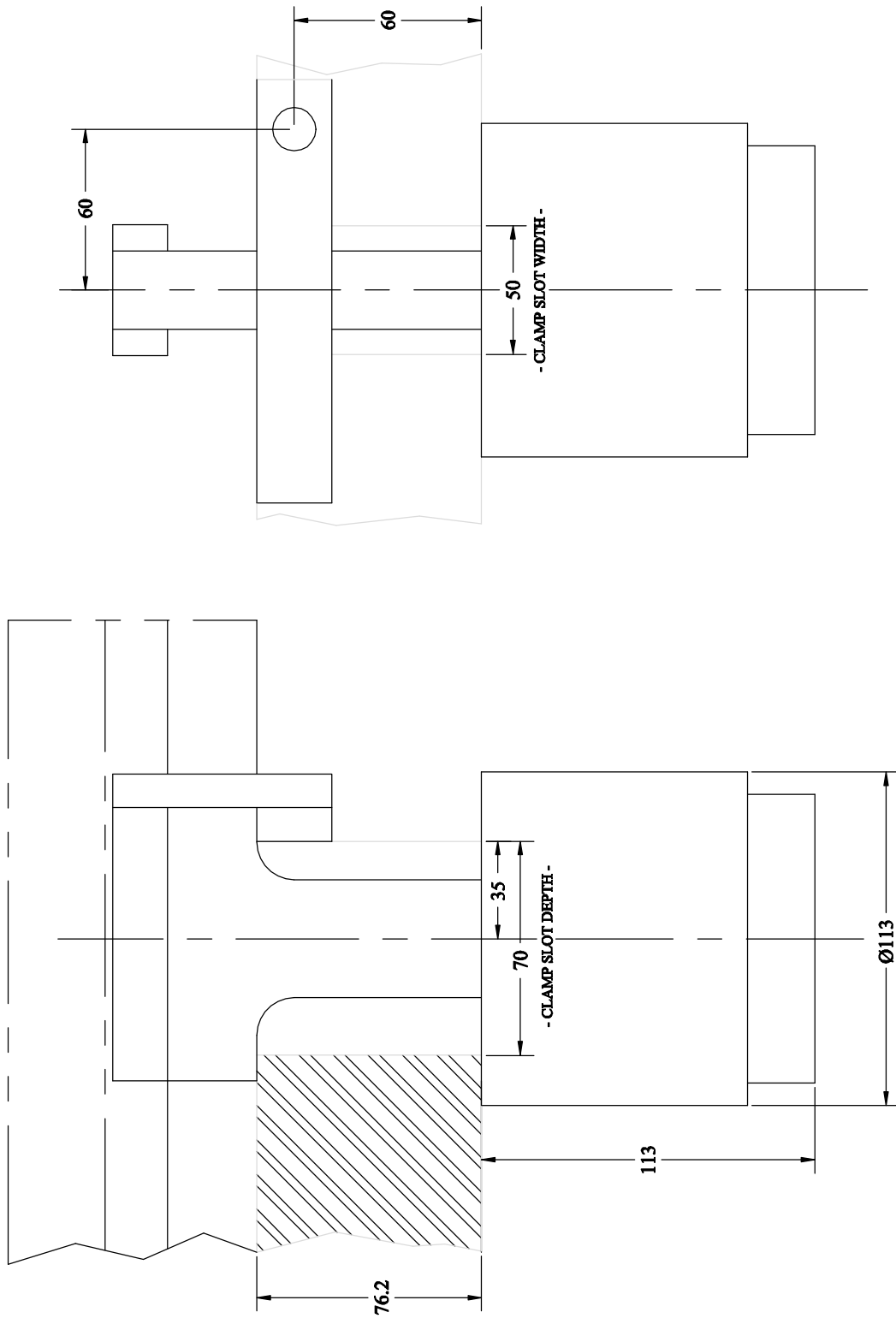
NOTE: ALL T-SLOTS ARE
SYMMETRICAL ABOUT
BOTH CENTERLINES



RAM FACE

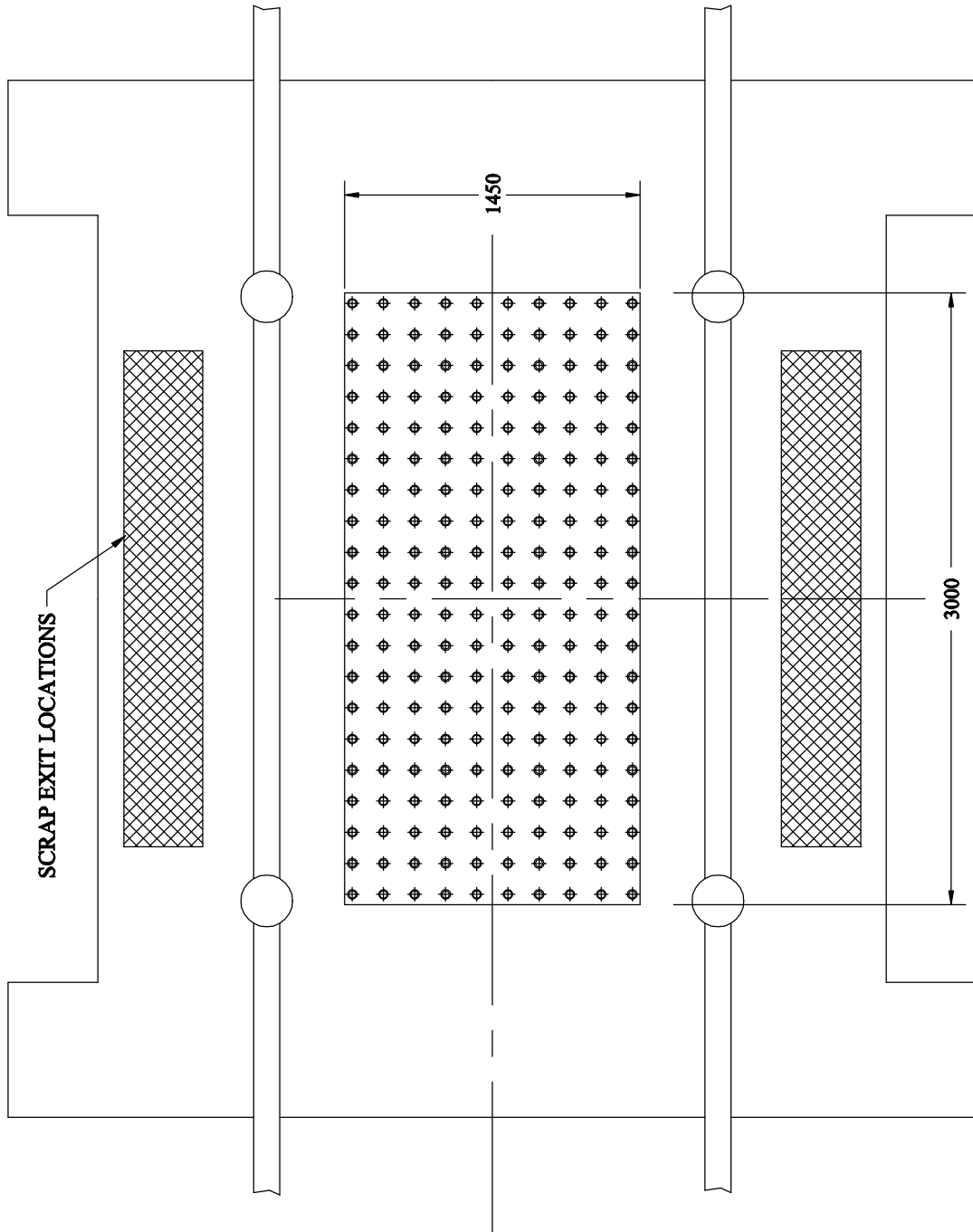
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HYDRAULIC DIE CLAMPS
97.8 kN (11 TONS) EACH
8 CLAMPS TOTAL



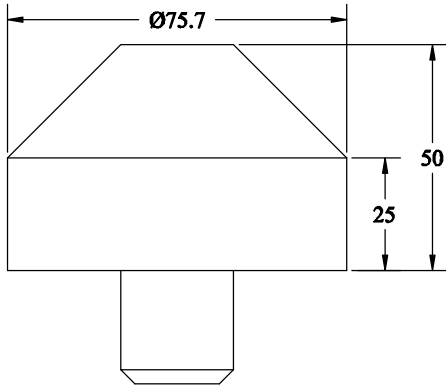
CLAMP SLOT DETAIL

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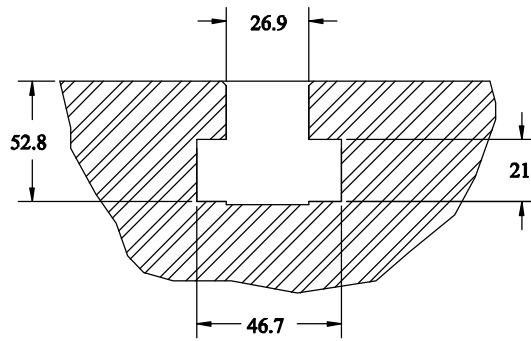


TOP VIEW
(CUSHION LAYOUT)

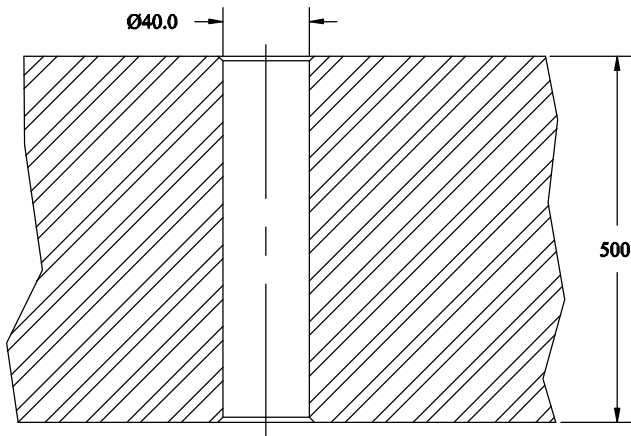
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DIE LOCATOR PIN



**SECTION OF
T-SLOT**



**SECTION OF
CUSHION PIN
HOLE**

SECTIONS