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### PRESS INFORMATION

	Inner	Outer
Work Capacity .....	2000 UST	N/A
Ram Size L/R – F/B .....	5080mm-2438mm	N/A
Ram Spacer Thickness .....	None	N/A
Length of Stroke .....	712mm	N/A
Slide Adjustment (without transfer) .....	457mm	N/A
Slide Adjustment (with transfer) .....	185mm	N/A
Shut Height From Bolster S.D.A.U. ....	1295mm	N/A
Target Die Height <i>(Measured From Bolster Plate)</i> .....	1118mm*	N/A
Bolster Size L/R – F/B .....	5080mm-2438mm	
Bolster Thickness .....	410mm	
Rolling Bolster .....	Yes	
Carriage Thickness .....	See Bolster Drawing	
Bolster Spacer .....	None	
Bolster Spacer Thickness .....	N/A	
Positive Knockout .....	None	
Quick Die Change Sub-Plates .....	Yes (See Transfer Die Design Spec)	
Sub-Plate Thickness .....	N/A	
Cushions (Number) .....	None	
Tons Each .....	N/A	
Tons Total .....	N/A	
Stroke .....	N/A	
Size L/R – F/B .....	N/A	
Distance From Bolster To Drip Pots .....	685mm	
Distance Between Gibbs L/R .....	5220mm	
Strokes Per Minute .....	8-24	

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**PRESS INFORMATION (English)**

	Inner	Outer
Work Capacity .....	2000 US Ton 1" up	N/A
Ram Size L/R – F/B .....	200"- 96"	N/A
Ram Spacer Thickness .....	None	N/A
Length of Stroke .....	28"	N/A
Slide Adjustment Without Transfer .....	18"	N/A
Slide Adjustment With Transfer .....	7.28"	N/A
Shut Height From Bolster S.D.A.U. ....	51"	N/A
Target Die Height <i>(Measured From Bolster Plate)</i> .....	44"	N/A
Bolster Size L/R – F/B .....	200"- 95.67"	
Bolster Height .....	16.14"	
Rolling Bolster .....	Yes	
Cushions (Number) .....	None	
Distance From Bolster To Drip Pots .....	27"	
Distance Between Gibbs L/R .....	205.5"	
Strokes Per Minute .....	8-24	
Maximum Single Stroke .....	10 SPM	
Single Stroke Setup No Load .....	5 – 10 SPM	

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**AUTOMATION DEVICES USED  
LOADER**

Destacker / Spray System / Loader .....	Yes (Spray In Gage Station; 7 top & 7 Bottom) Use only in extreme draw conditions.
Sheet Thickness Max. - Min. ....	.125" - .020"
Max. Sheet Size L/R - F/B to flow .....	72" - 40"
Min. Sheet Size L/R - F/B to flow .....	17.5" - 8"
Maximum Blank Weight .....	60 pounds
Distance Between Blanks when Running Double Unattached .....	See Sketch On Page 17
Two Blanks L to R to Feed Direction .....	11.8"
Two Blanks F to B to Feed Direction .....	5.9"
Max. Loader Pass Height (From Top Of Bolster) .....	26"
Min. Loader Pass Height (From Top Of Bolster) .....	24"
Max. Stack Height .....	18"
Minimum Distance C/L Press to C/L Blank Station .....	117"
Max. Stack Weight .....	15,000 lbs.

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### TRANSFER

Standard Pitch Selection .....	30", 36", 40", 45", and 50"
Part Flow .....	Left to Right
Maximum Number of Stations .....	6
Minimum Number of Stations (less Idle) .....	4
Standard Clamp Stroke .....	8"
Maximum Lift Stroke .....	10" Use Min. for depth of draw
Standard Lift Stroke .....	3"
Pass Height(Point of pick up from tool or lifter) .....	24"
Maximum Part Weight .....	60#
All Stations have Pneumatic Gripper Capabilities on Each Rail .....	
All Stations have 2 Sensors, 1 on Each Rail .....	
Use In Die Lifters to Minimize Transfer Lift .....	
Dies are to have 2 sensors each sensing part in location at drop off and pick up by transfer	
<b>Transfer Maximum Capabilities</b>	
Advance—Reverse .....	0 to 50"
Lift .....	0 to 10"
Distance From bottom of Master Rail to Top of Bolster With Rails Down .....	21"
Maximum Opening of Master Rails .....	100"
Minimum Opening of Master Rails .....	35"
Maximum Weight to Transport (Parts, Grippers, and Sub-rails) .....	400 Pounds
Maximum Weight to Transport (Per Station) .....	80 Pounds

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**AUTOMATION DEVICES USED (Continued)**

**COIL LINE**

Coil Feeder .....	Yes
Material Thickness vs. Material Width .....	.125" x 72"
Feed Pitch Peek Velocity .....	0 - 300 fpm
Processing Velocity .....	0 - 150 fpm
Coil Inner Diameter (Max. & Min.) .....	24" & 19"
Coil Outer Diameter (Max.) .....	72"
Material Feed Height .....	24"
<i>(From Top Of Bolster)</i>	
Max. Coil Weight .....	40,000 lbs.
Roll Lift .....	Yes
Uncoil .....	Over Top
Feed Tolerance .....	± .002"

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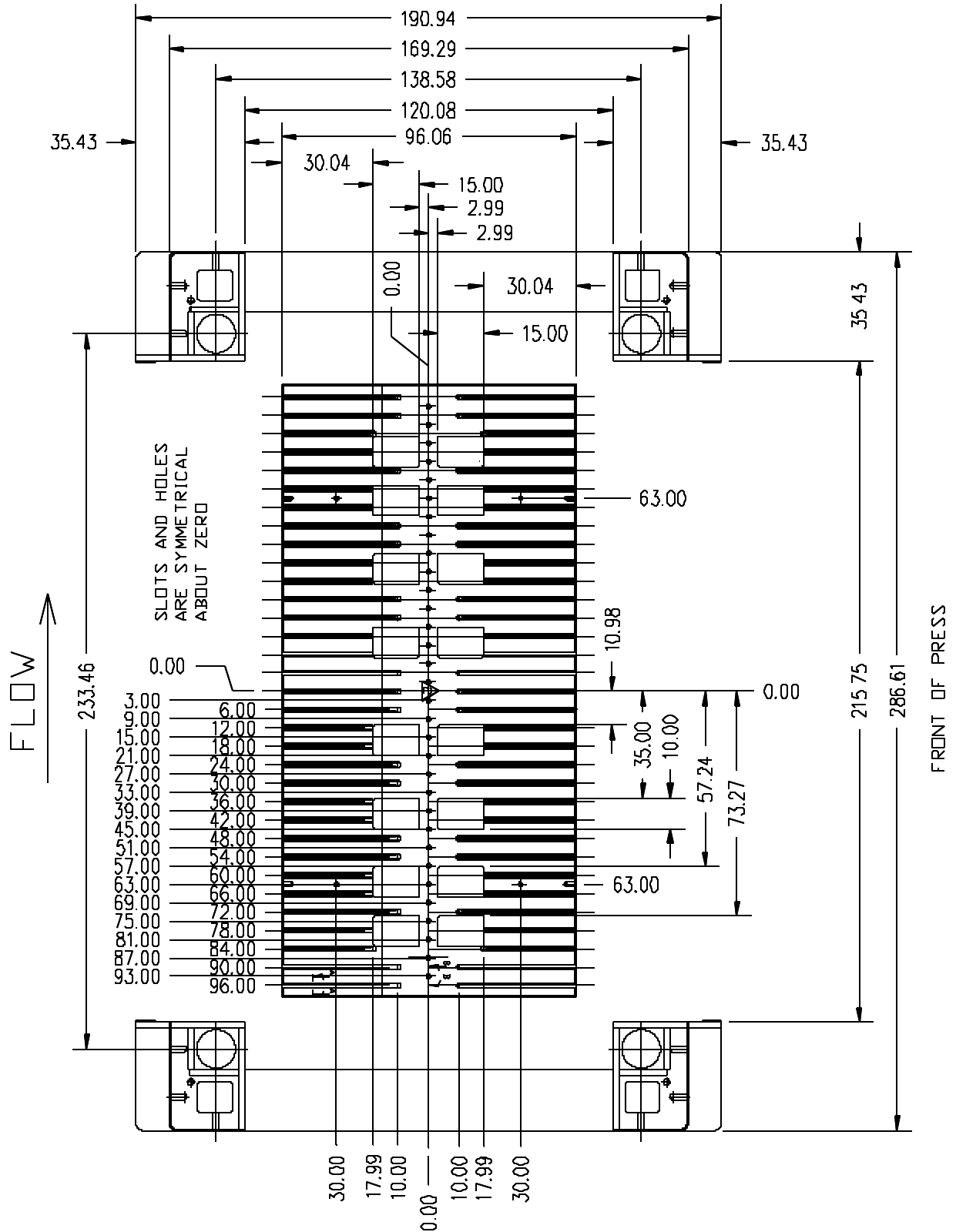
## **PRESS INFORMATION GENERAL**

Comments:

- 1) The traveling clamps, for a given T-slot, work in pairs consisting of both the front and rear clamps. Clamps must be selected in pairs. Example: If clamps 1, 3 & 5 are used on the front, then clamps 1, 3 & 5 must be used on the rear.

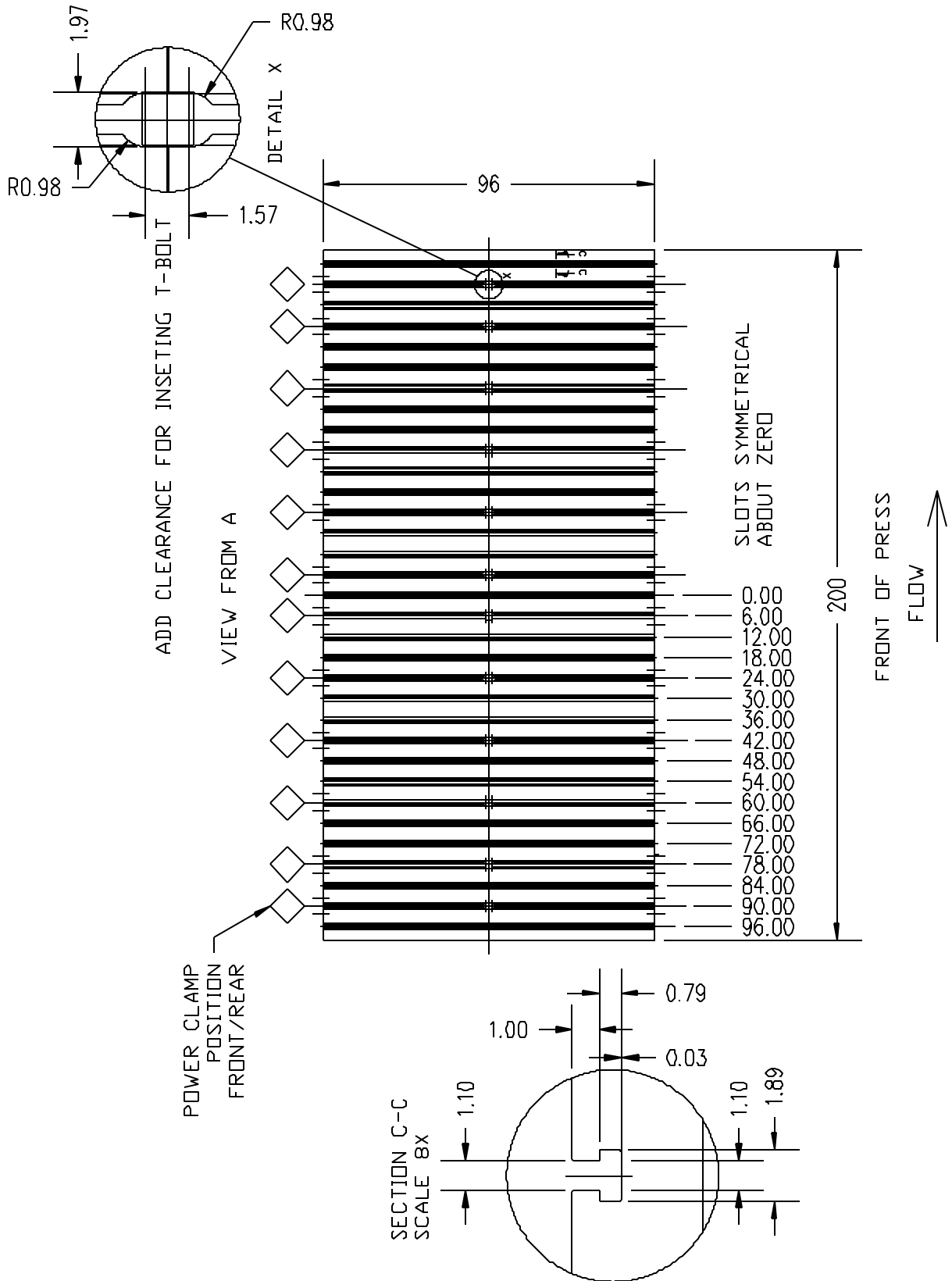
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**PLAN VIEW OF BOLSTER**



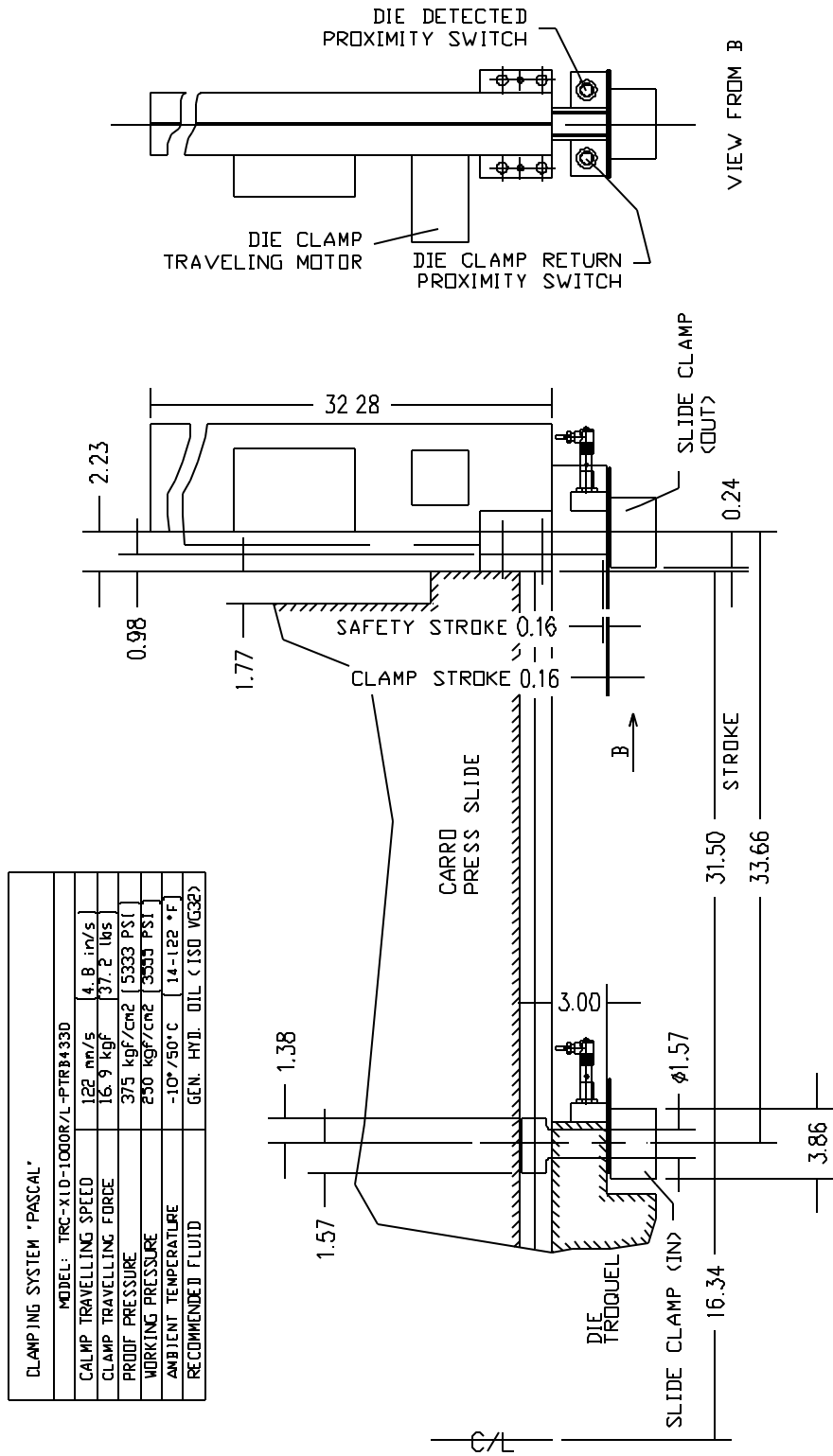
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**PLAN VIEW OF SLIDE**



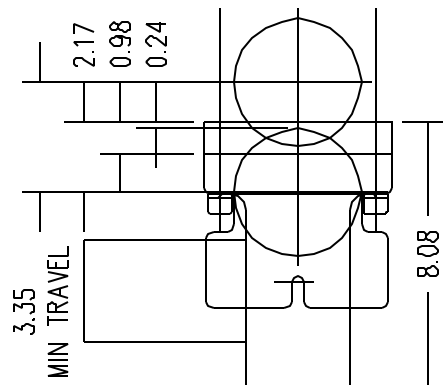
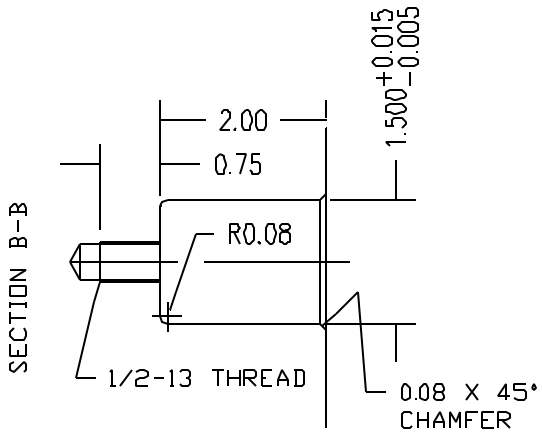
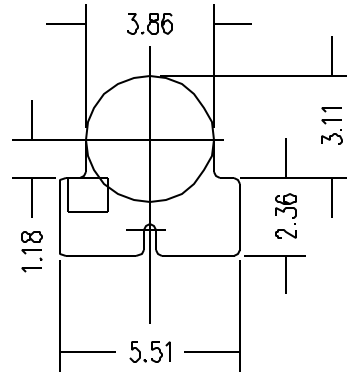
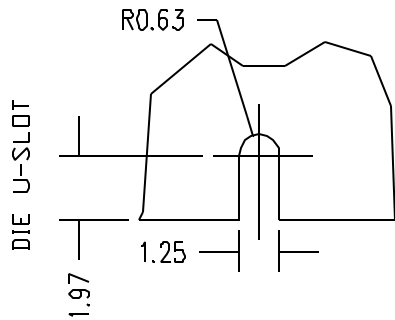
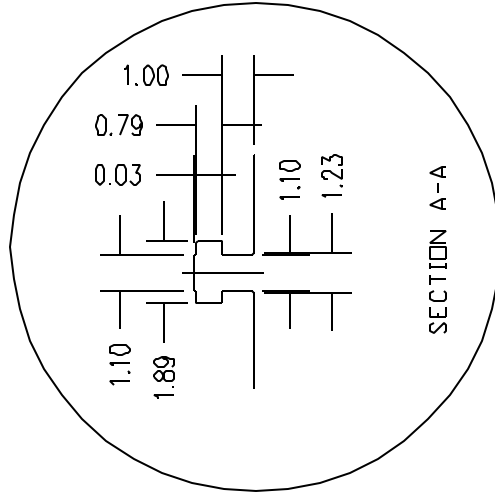
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### POWER CLAMP DETAIL



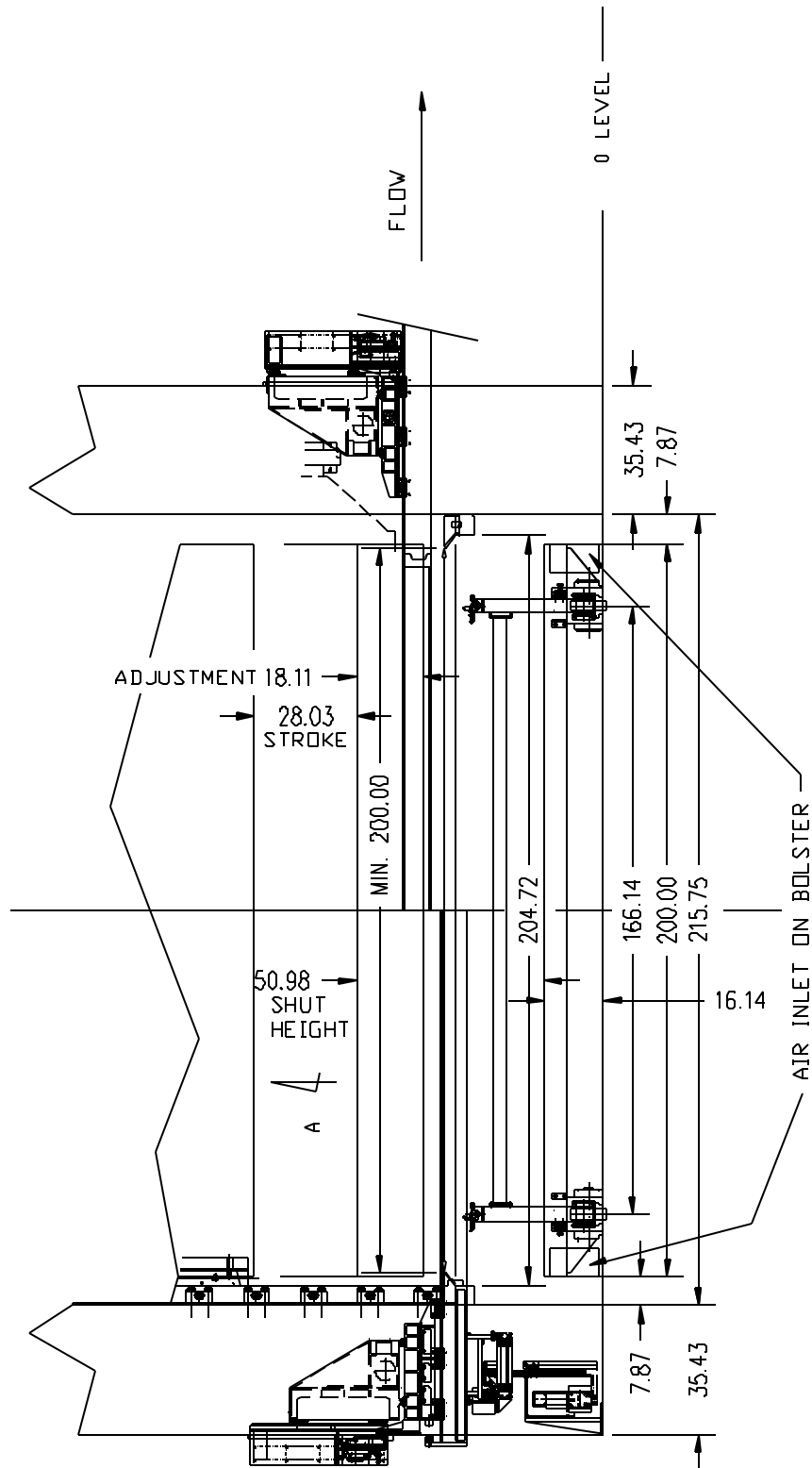
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**ASSOCIATED SECTION VIEWS**



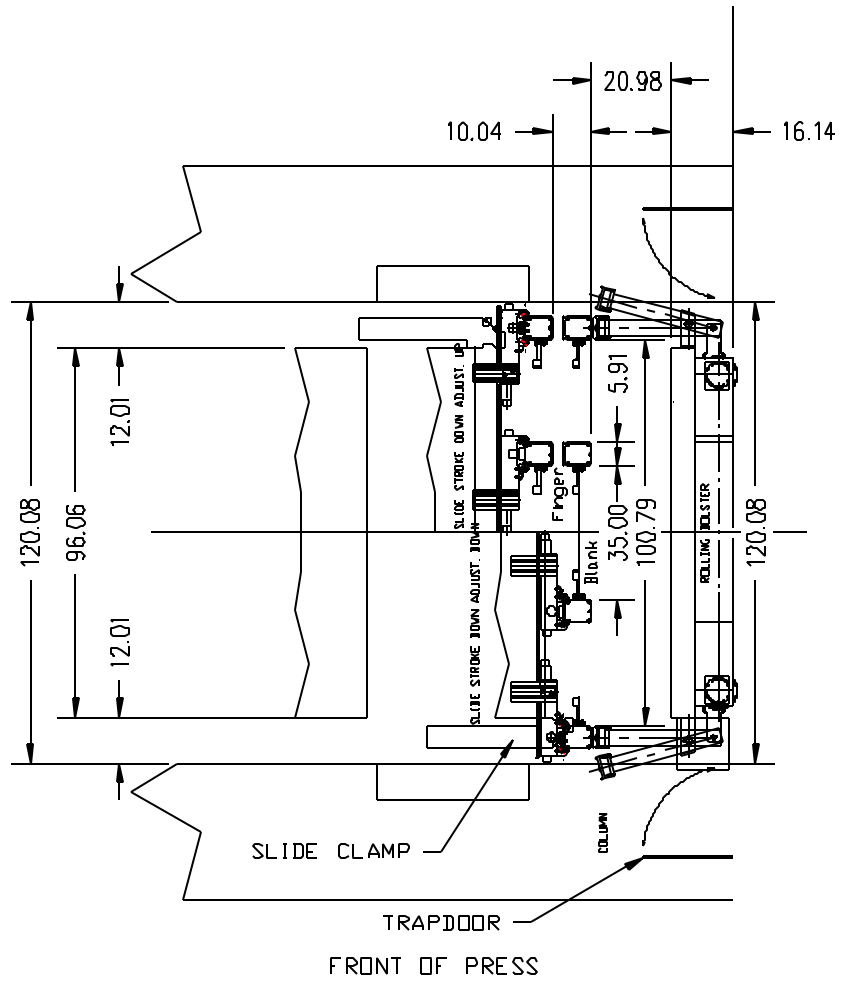
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**FRONT ELEVATION OF PRESS**



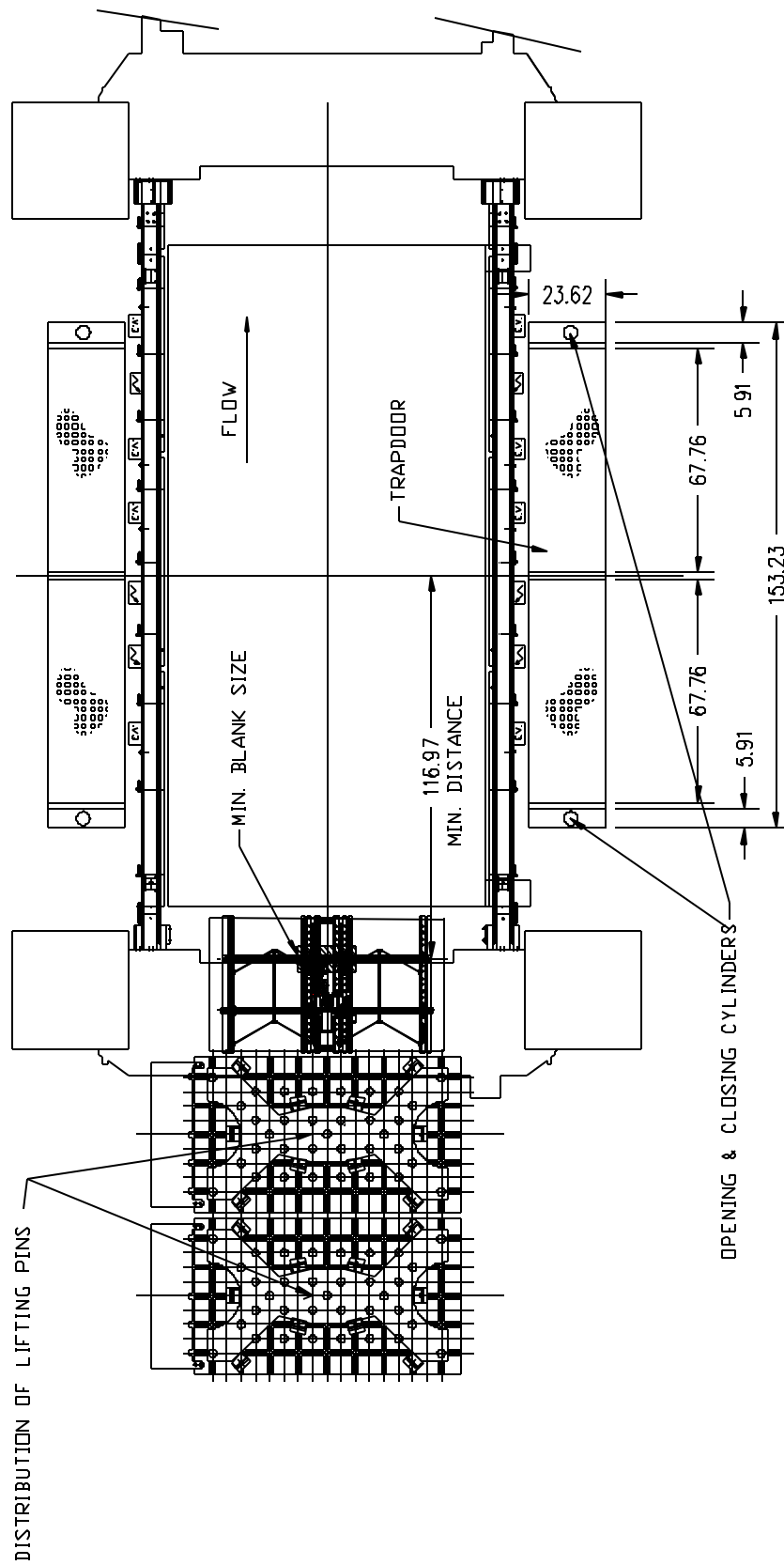
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### SIDE ELEVATION OF PRESS



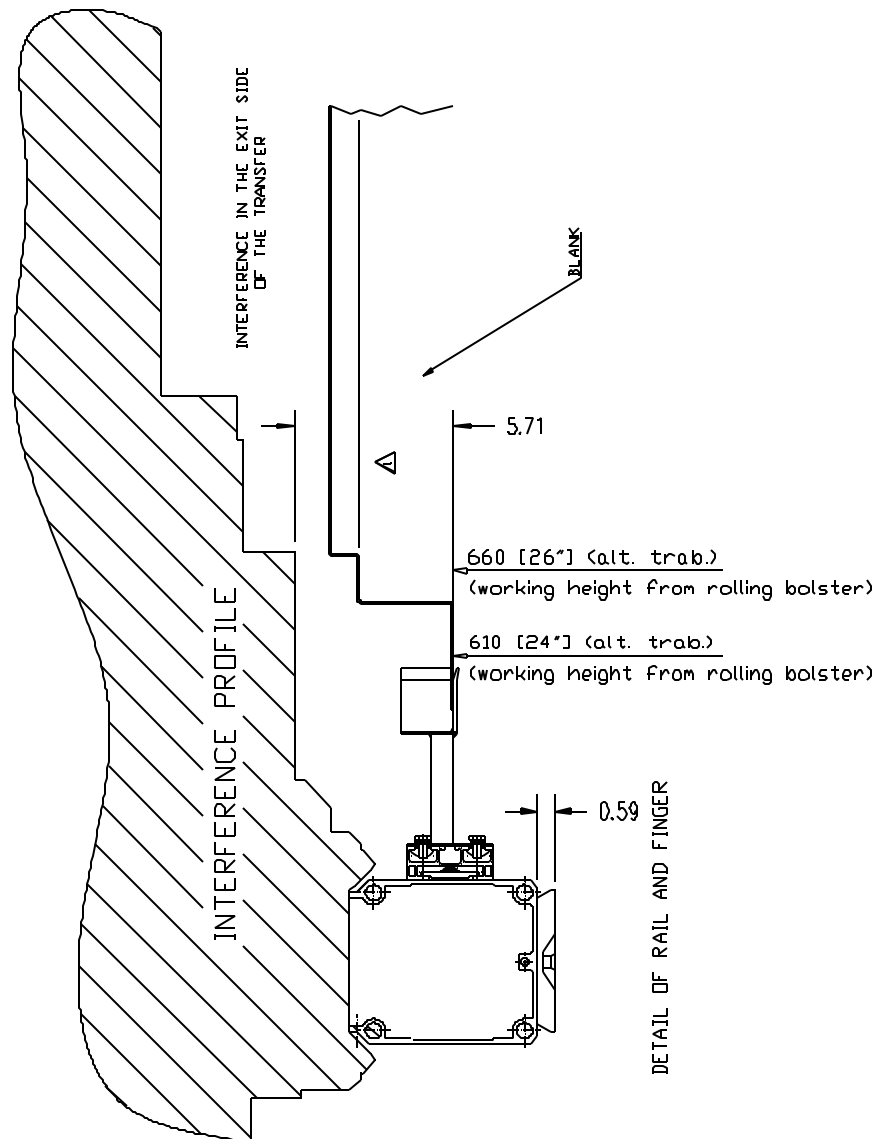
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**PLAN OF GAGE STATION AND TRANSFER BASE RAIL**



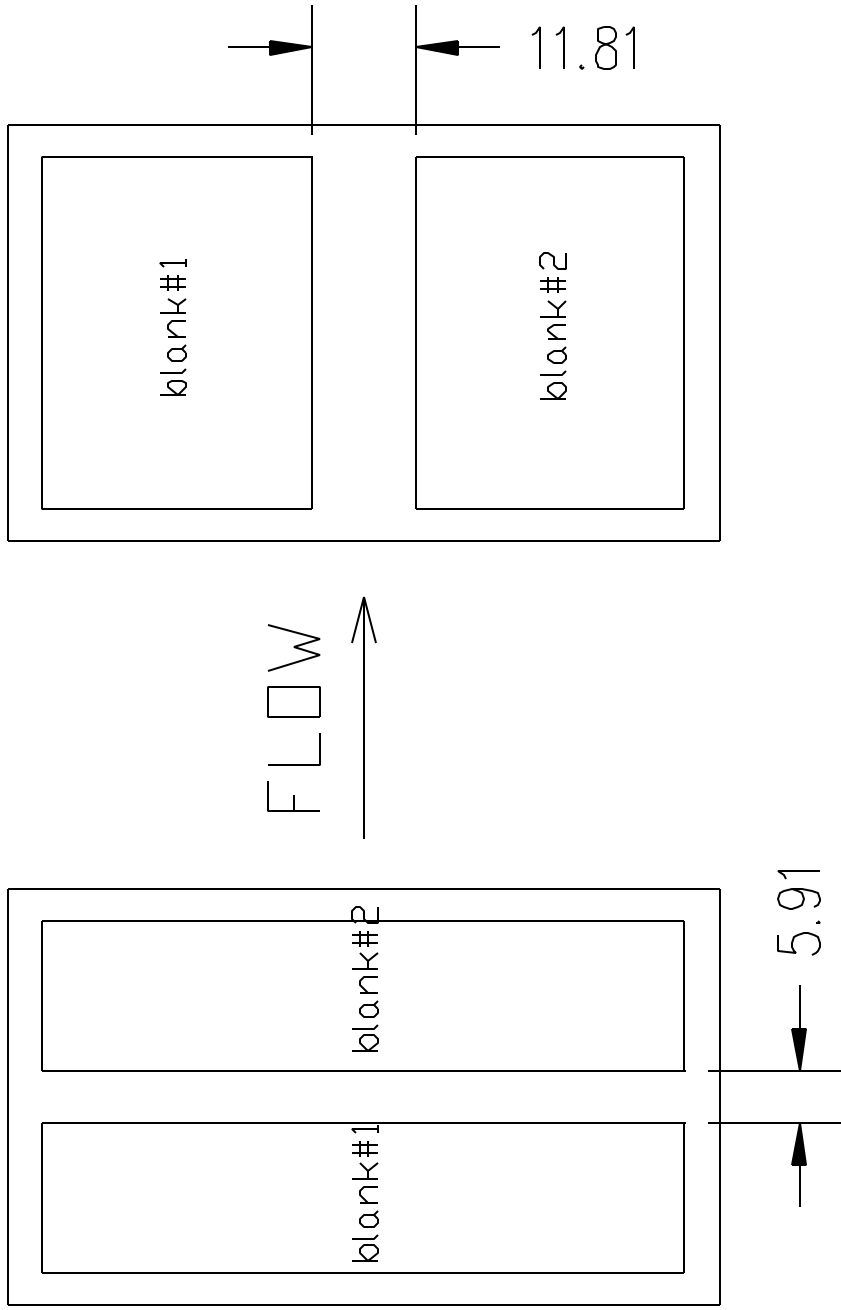
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### POWER CLAMP INTERFERENCE WITH BASE RAIL





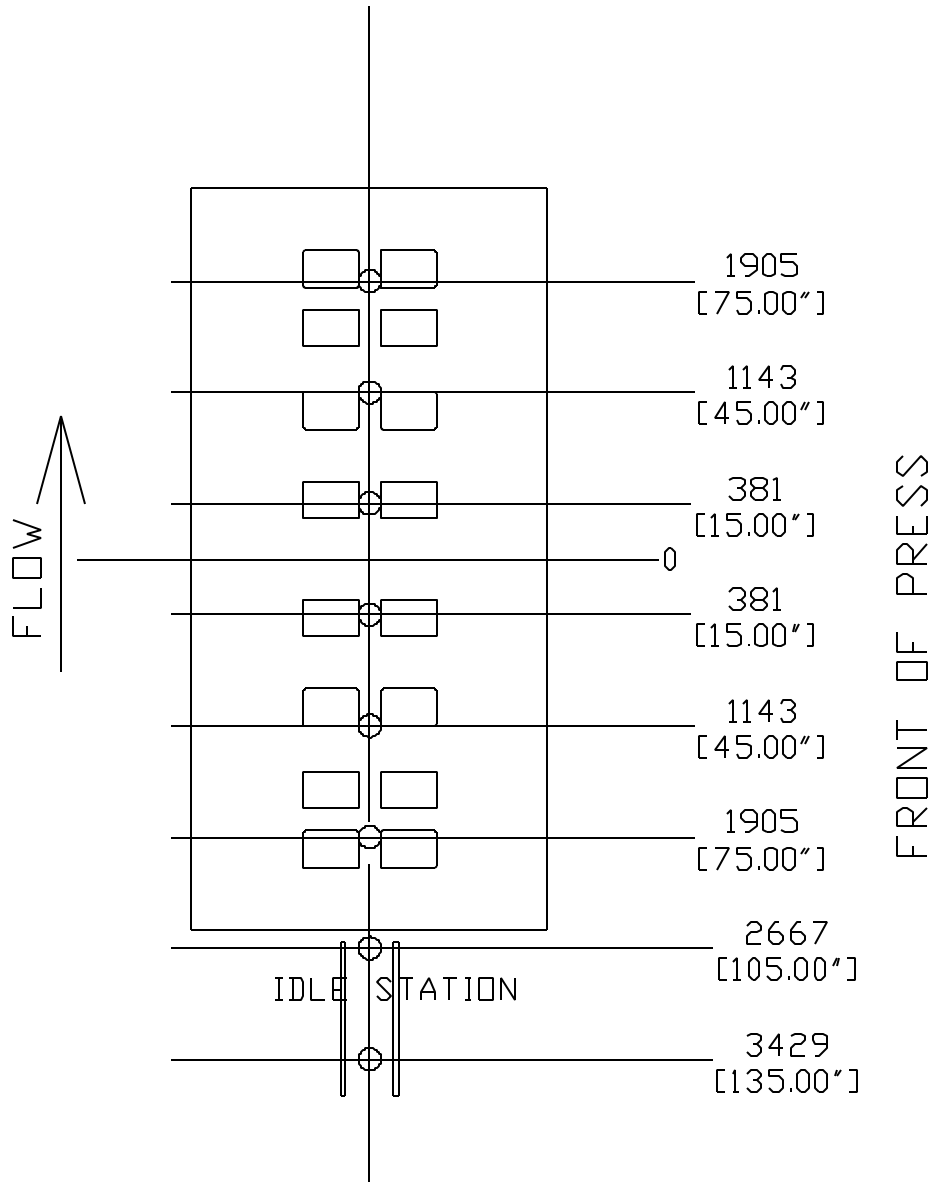
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DISTANCE BETWEEN BLANKS WHEN DOUBLE FEEDING

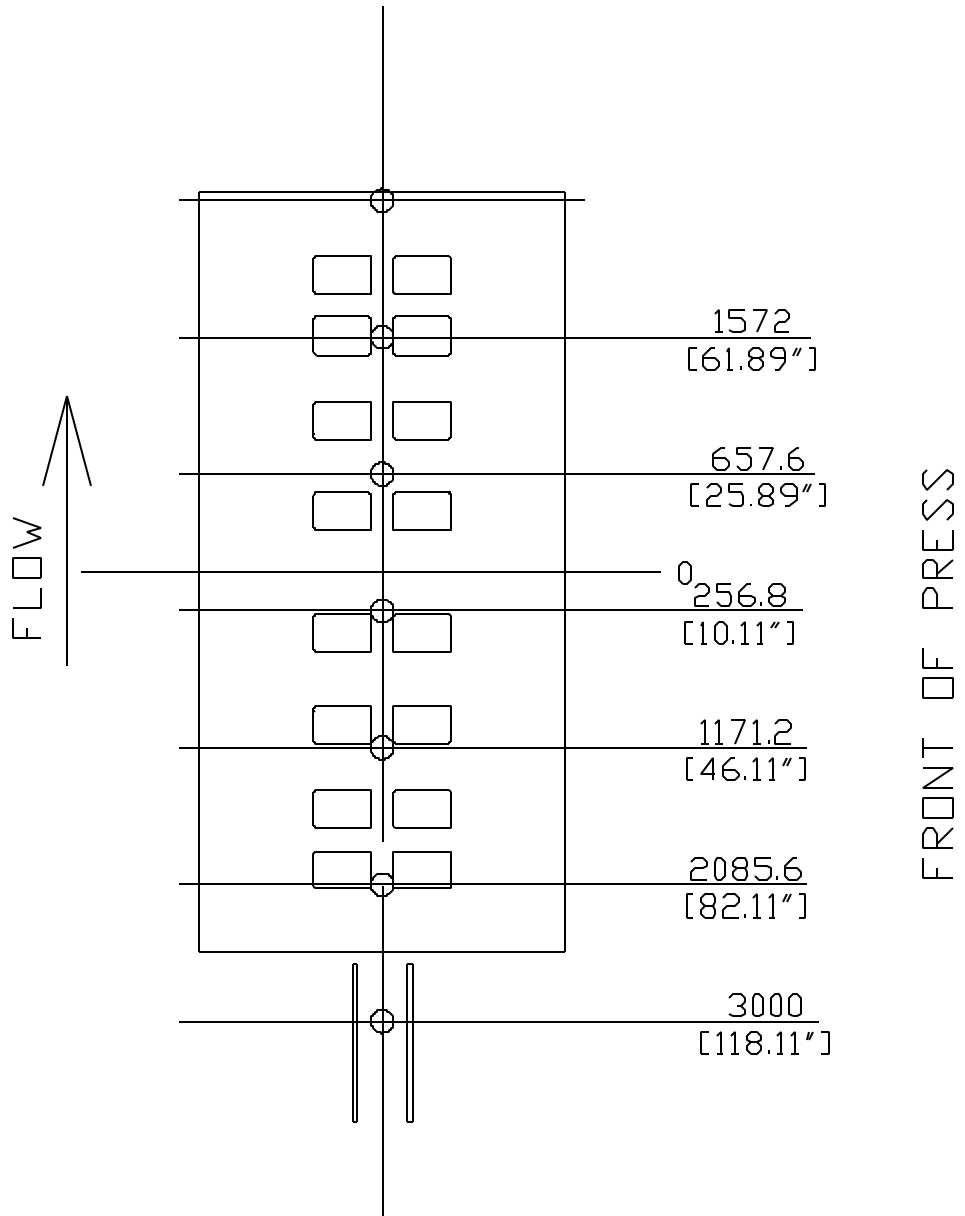
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**STATION CENTERLINES FOR DIE SET  
30" PITCH**



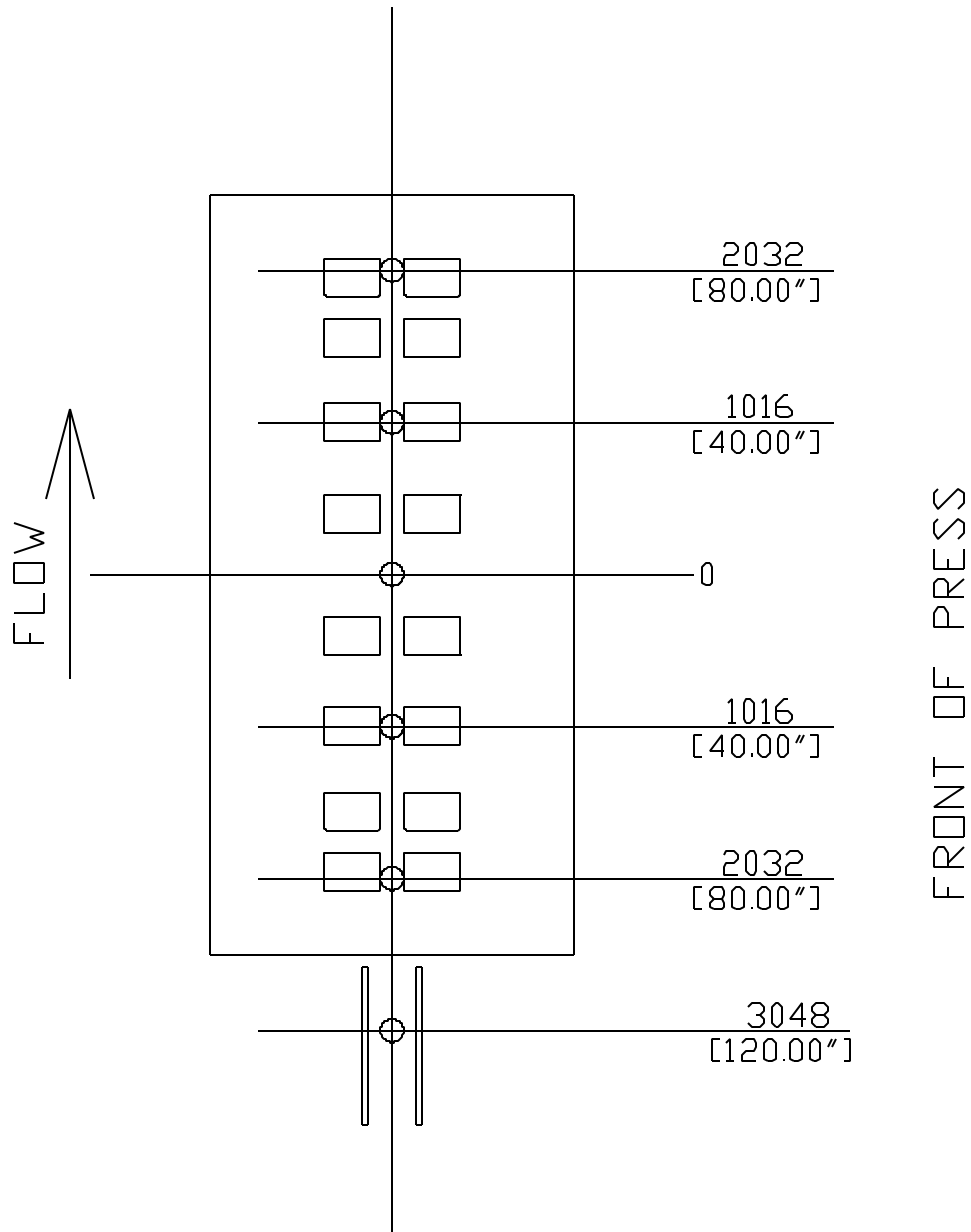
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**STATION CENTERLINES FOR DIE SET  
36" PITCH**



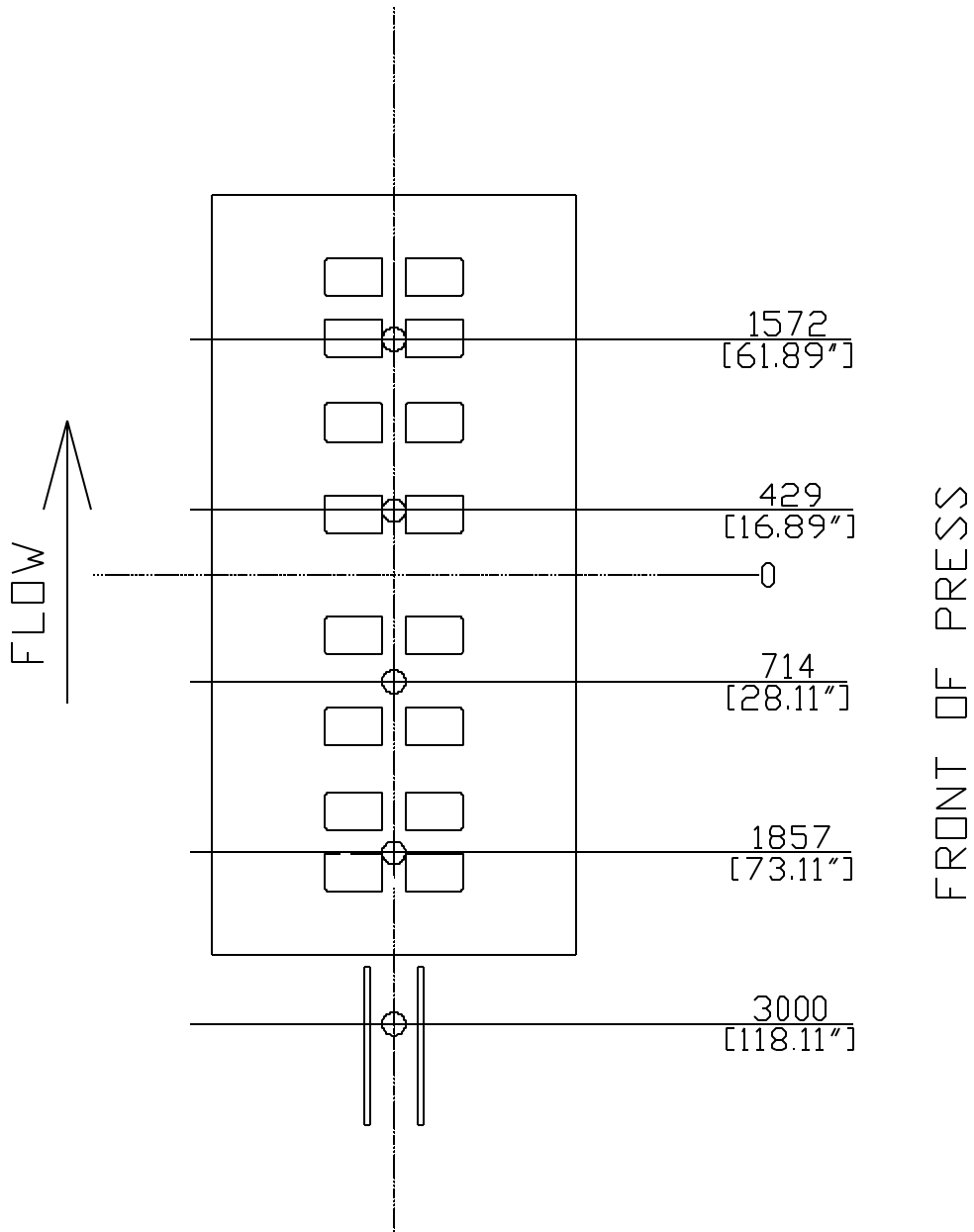
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**STATION CENTERLINES FOR DIE SET  
40" PITCH**



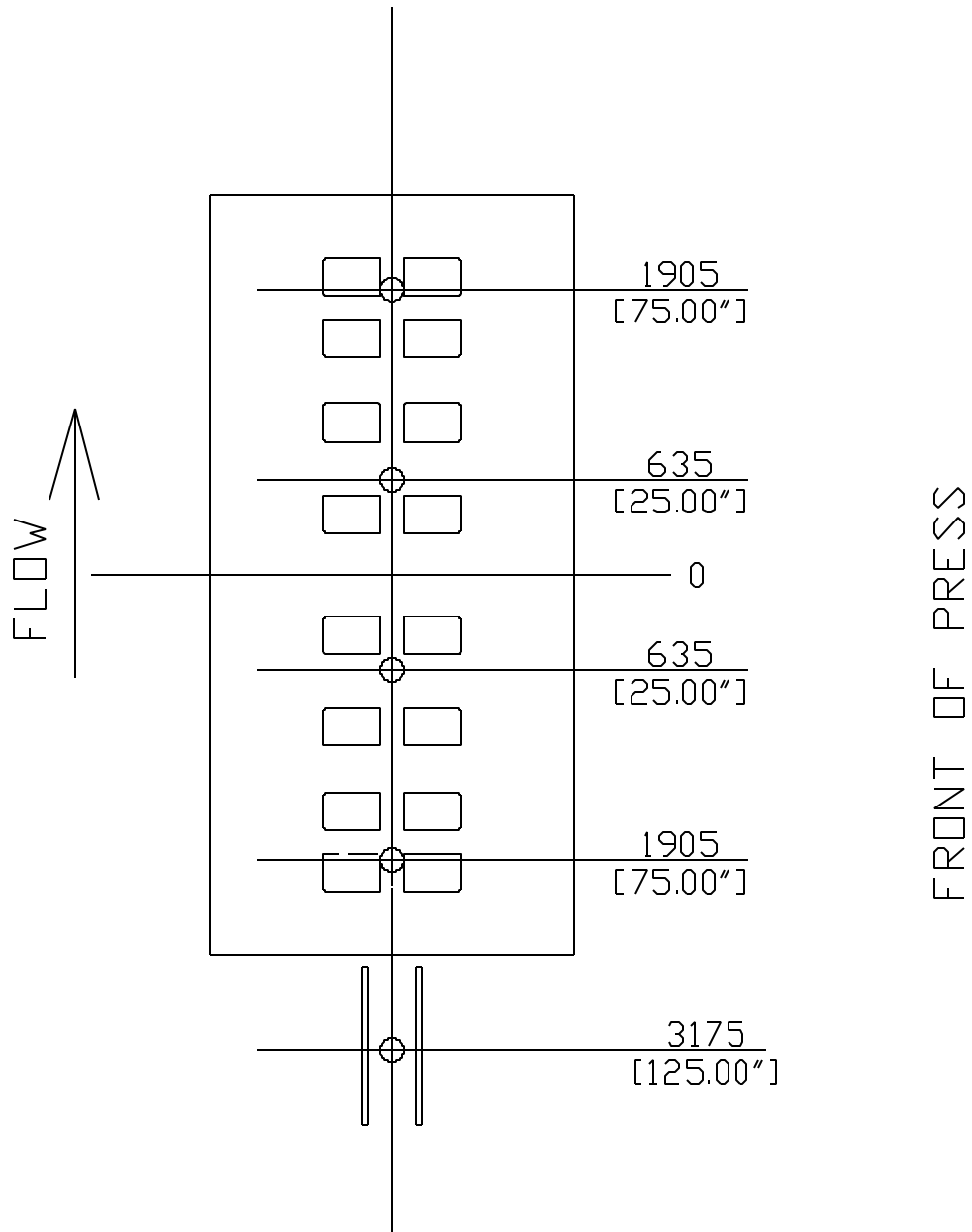
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**STATION CENTERLINES FOR DIE SET  
45" PITCH**



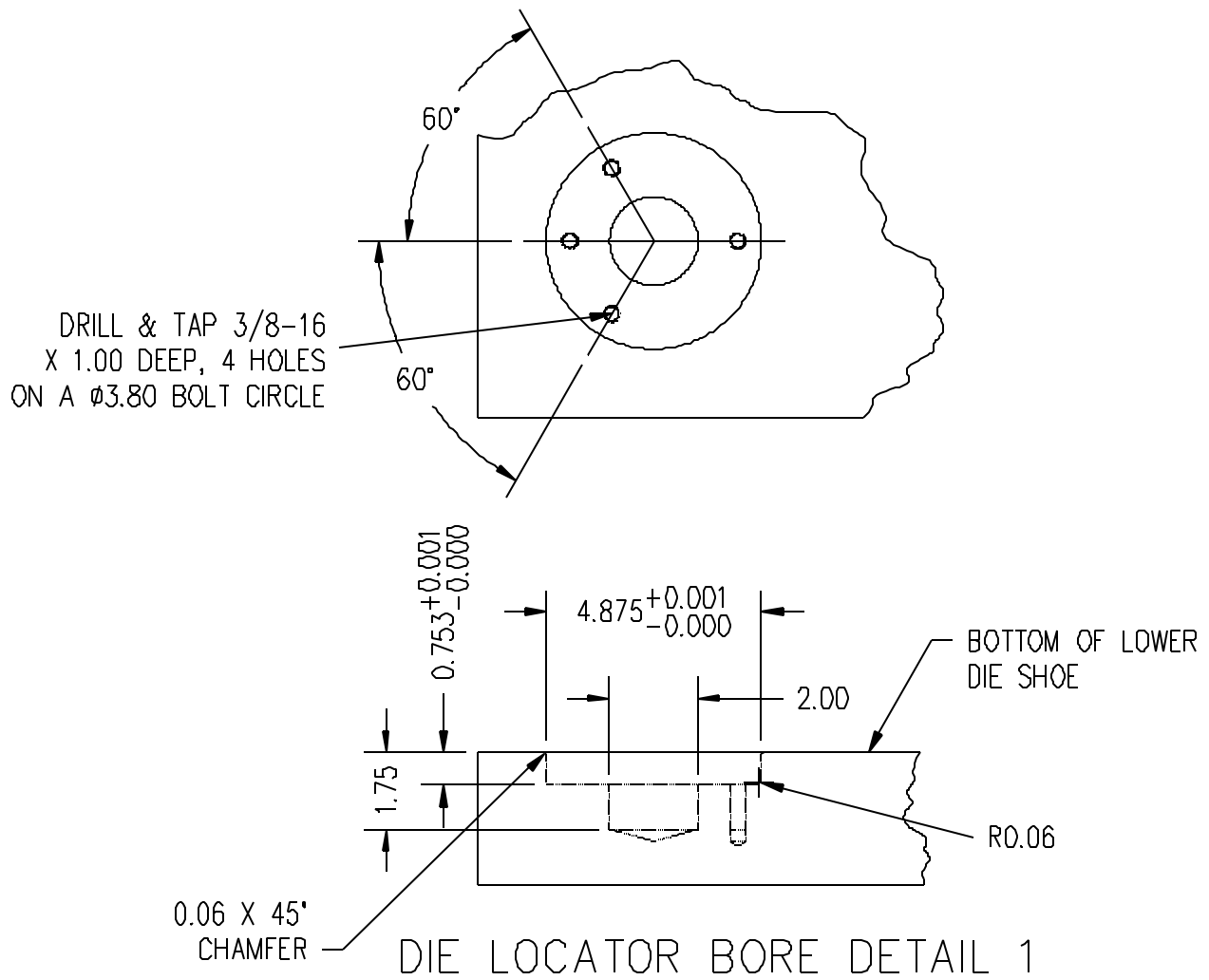
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**STATION CENTERLINES FOR DIE SET  
50" PITCH**



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**DIE LOCATOR BORE DETAIL 1**



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### DIE LOCATOR BORE DETAIL 2

