



SPARTANBURG STAINLESS PRODUCTS

Document No.:
S02.?

PRESS LINE SPECIFICATION
PRESS P2600
(120" x 72" 800 Ton Single – Action)

Issue Date: 1/15/01
Revision: 3
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PRESS INFORMATION

	Inner	Outer
Work Capacity	800 Tons	N/A
Ram Size L/R – F/B	120" – 72"	N/A
Ram Spacer Thickness	None	None
Length of Stroke	12"	N/A
Slide Adjustment	12"	N/A
Shut Height From Bolster S.D.A.U.	28.94"	N/A
Target Die Height	22"	N/A
Bolster Size L/R – F/B	120" – 72"	
Bolster Thickness	7.87"	
Rolling Bolster	Yes	
Carriage Thickness	16.14"	
Bolster Spacer	No	
Bolster Spacer Thickness	N/A	
Positive Knockout	None	
Quick Die Change Sub-Plates	N/A	
Sub-Plate Thickness	N/A	
Cushions (Number)	None	
Tons Each	N/A	
Tons Total	N/A	
Stroke	N/A	
Quantity @ Size L/R – F/B	N/A	
Distance From Bolster To Drip Pots	N/A (Drip Pots Do Not Overhang Bolster)	
Distance Between Gibbs L/R	122.83"	
Strokes Per Minute	20-60	



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PRESS INFORMATION (Metric)

	Inner	Outer
Work Capacity	725 MT	N/A
Ram Size L/R – F/B	3048mm – 1829mm	N/A
Ram Spacer Thickness	None	None
Length of Stroke	305mm	N/A
Slide Adjustment	305mm	N/A
Shut Height From Bolster S.D.A.U.	736mm	N/A
Target Die Height	559mm	N/A
Bolster Size L/R – F/B	3048mm – 1829mm	
Bolster Thickness	200mm	
Rolling Bolster	Yes	
Carriage Thickness	410mm	
Bolster Spacer	No	
Bolster Spacer Thickness	N/A	
Positive Knockout	None	
Quick Die Change Sub-Plates	N/A	
Sub-Plate Thickness	N/A	
Cushions (Number)	None	
Tons Each	N/A	
Tons Total	N/A	
Stroke	N/A	
Quantity @ Size L/R – F/B	N/A	
Distance From Bolster To Drip Pots	N/A (Drip Pots Do Not Overhang Bolster)	
Distance Between Gibbs L/R	3120mm	
Strokes Per Minute	20-60	



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AUTOMATION DEVICES USED (Continued)

COIL LINE


Coil Feeder	Yes
Material Thickness vs. Material Width	0.028" to 0.25" x 24"
Material Thickness vs. Material Width		0.028" to 0.219" x 30"
Feed Pitch Peek Velocity	20-100 fpm
Coil Inner Diameter (Max. & Min.)	20.50" & 15.50"
Coil Outer Diameter (Max.)	60"
Material Feed Height <i>(From Top Of Bolster)</i>	15"
Max. Coil Weight	20,000 lbs. / Coil
Roll Lift	Yes
Uncoil	Over Top
Feed Tolerance		± 0.002 "
Lubrication		Roll Coater

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PRESS INFORMATION GENERAL

Comments:

- 1) Parts must exit die onto SSP part conveyor with no exception (see pages 11 & 12).
- 2) All scrap must exit through bolster (see page 9).

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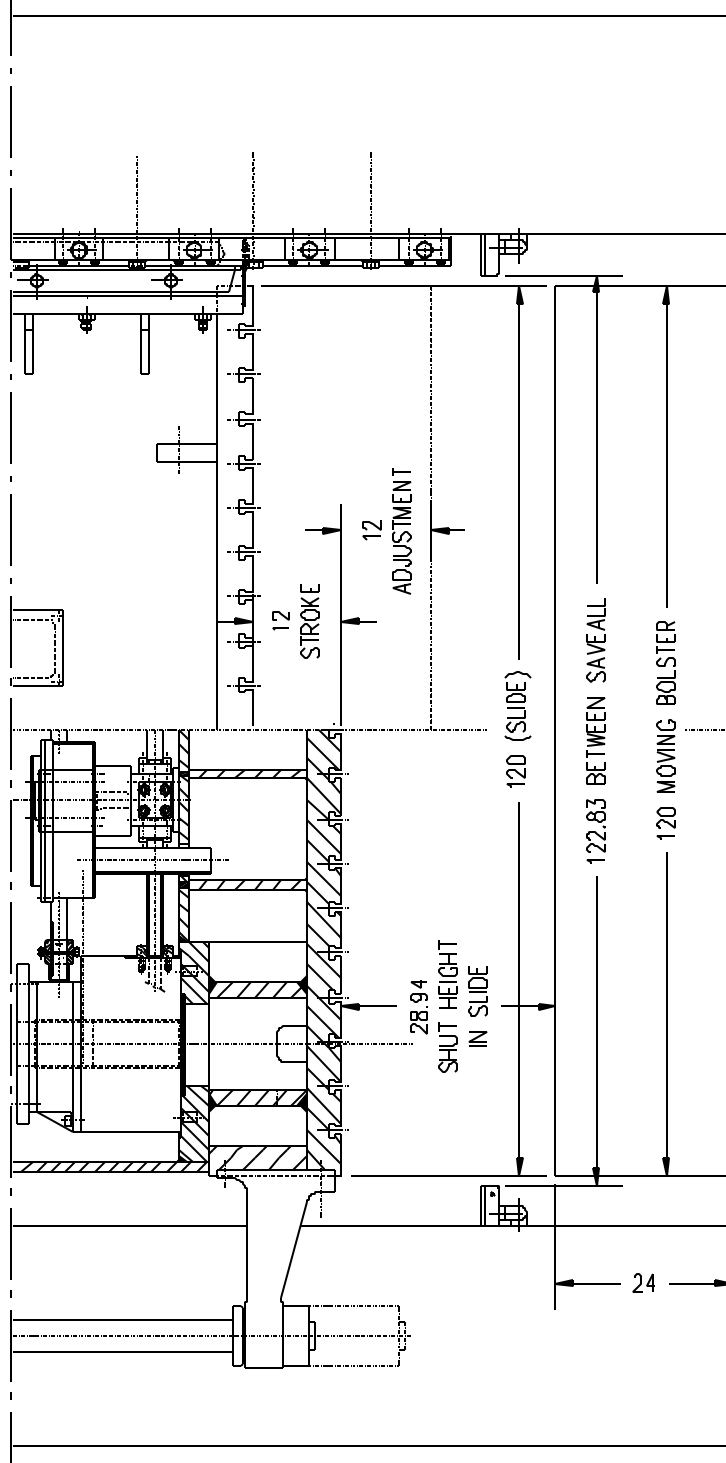
SPARTANBURG STAINLESS APPROVED SENSOR LIST

Press Lines

Press 2500
Press 2600
Press 2700

Item	Manufacturer	Part Number	Description
Junction Box (if 3 or less sensors use 4 port box)	ifm efector	W91004	4 Port, PNP block
Junction Box (if 4 or more sensors use 8 port box)	ifm efector	W91006	8 Port, PNP block
Patch Cord	Syron	SCE12022	2 [ft] patch cord
Patch Cord	Syron	SCE12042	4 [ft] patch cord
Patch Cord	Syron	SCE12062	6 [ft] patch cord
Sensor (progression check @ fringe notch, & part present)	ifm efector	IF5775	Flush mount, 12[mm] body, 4[mm] range, prox.
Sensor (progression check @ end of die, & part present)	Syron	STS18001	Flush mount, 18[mm] body, 5[mm] range, prox.
Sensor (part exit)	ifm efector	OG5053	Diffuse sensor, 18[mm] body, 130[mm] range, background suppression
Sensor (part present) note: must have written SSP approval before using	Syron	SPS11188	Spring loaded, prox. Switch, 1[in] travel

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FLOW → FRONT VIEW

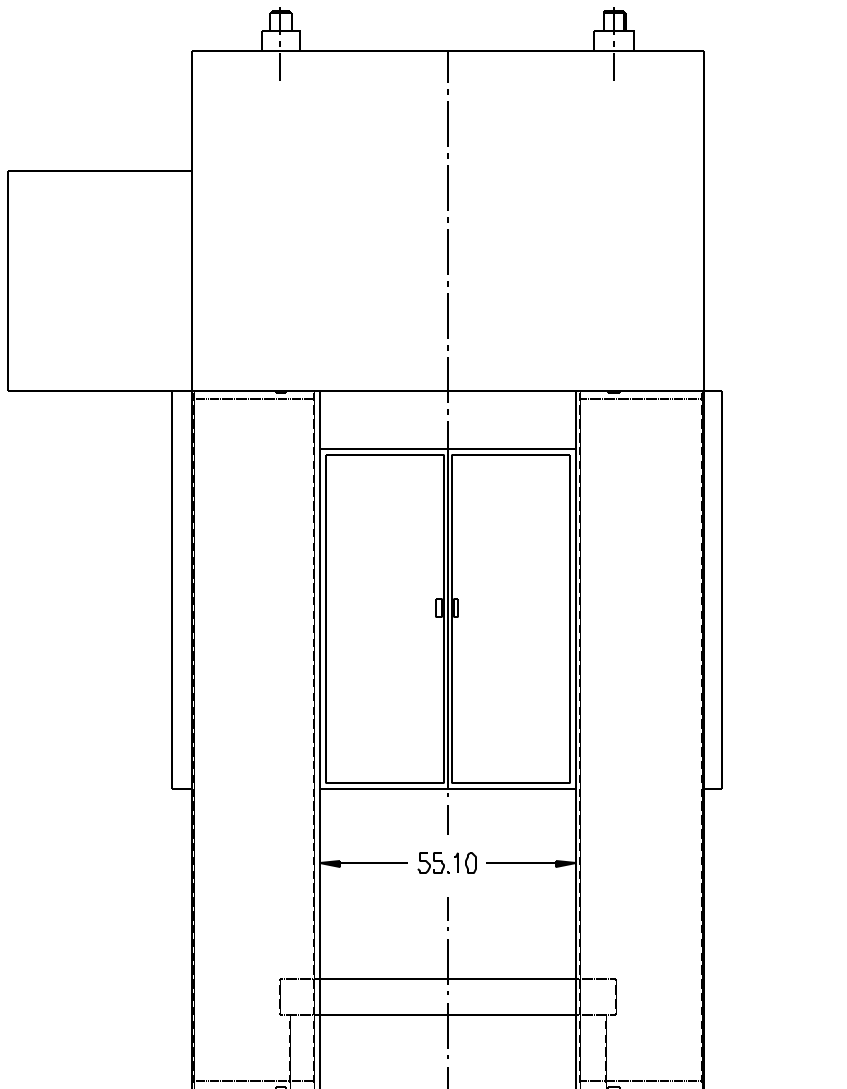


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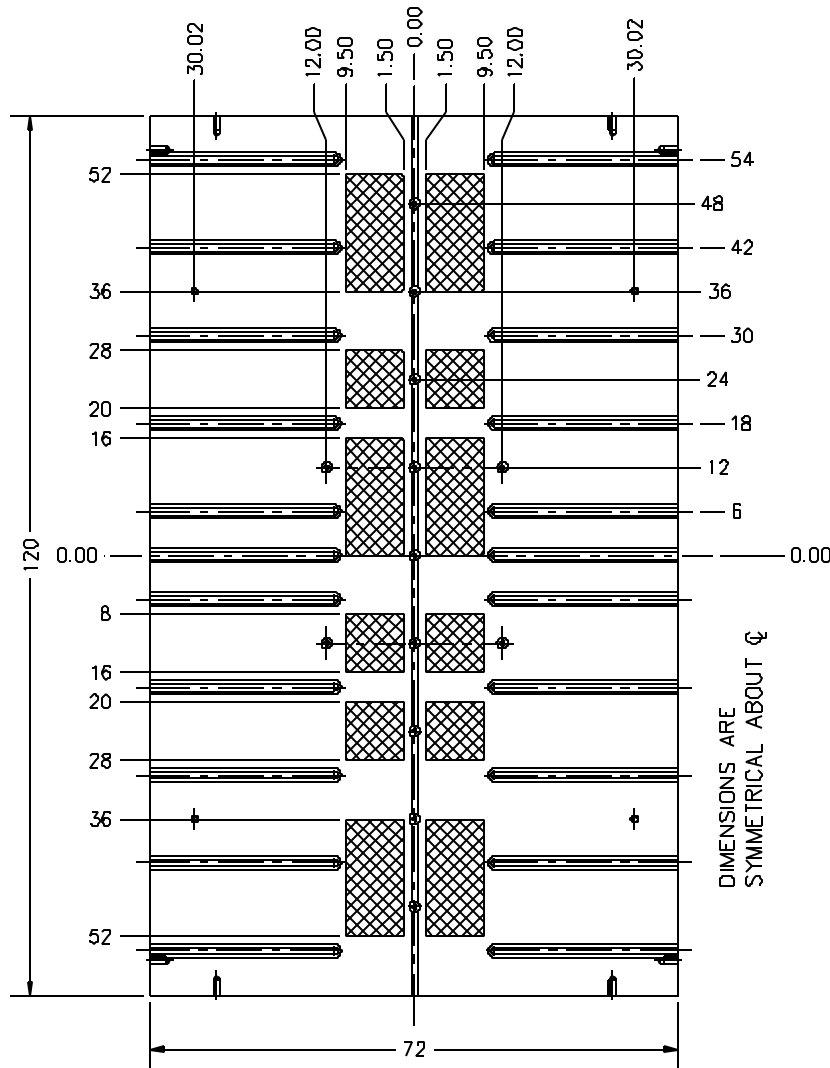
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END VIEW

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NOTE: HATCHED AREAS ARE SCRAP EXIT THROUGH BOLSTER

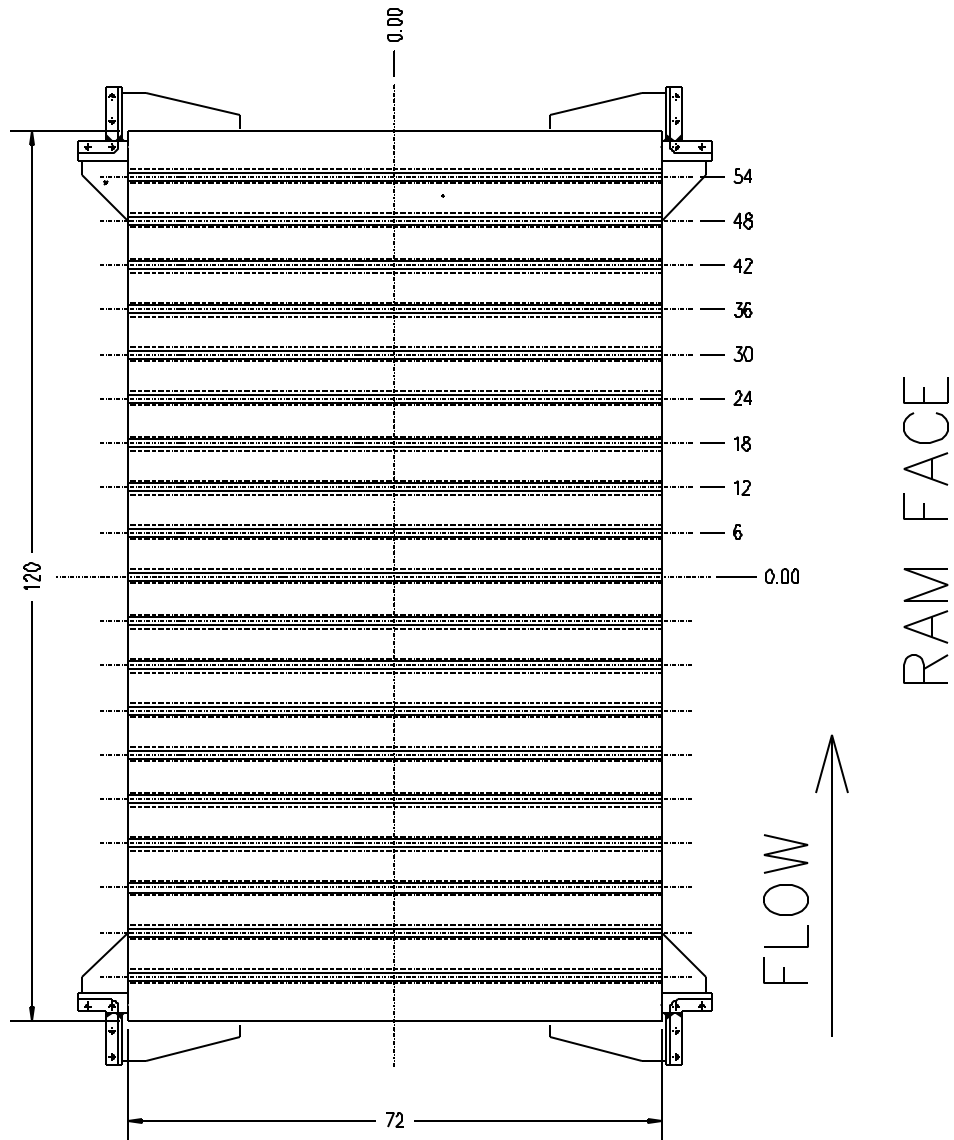


FRONT

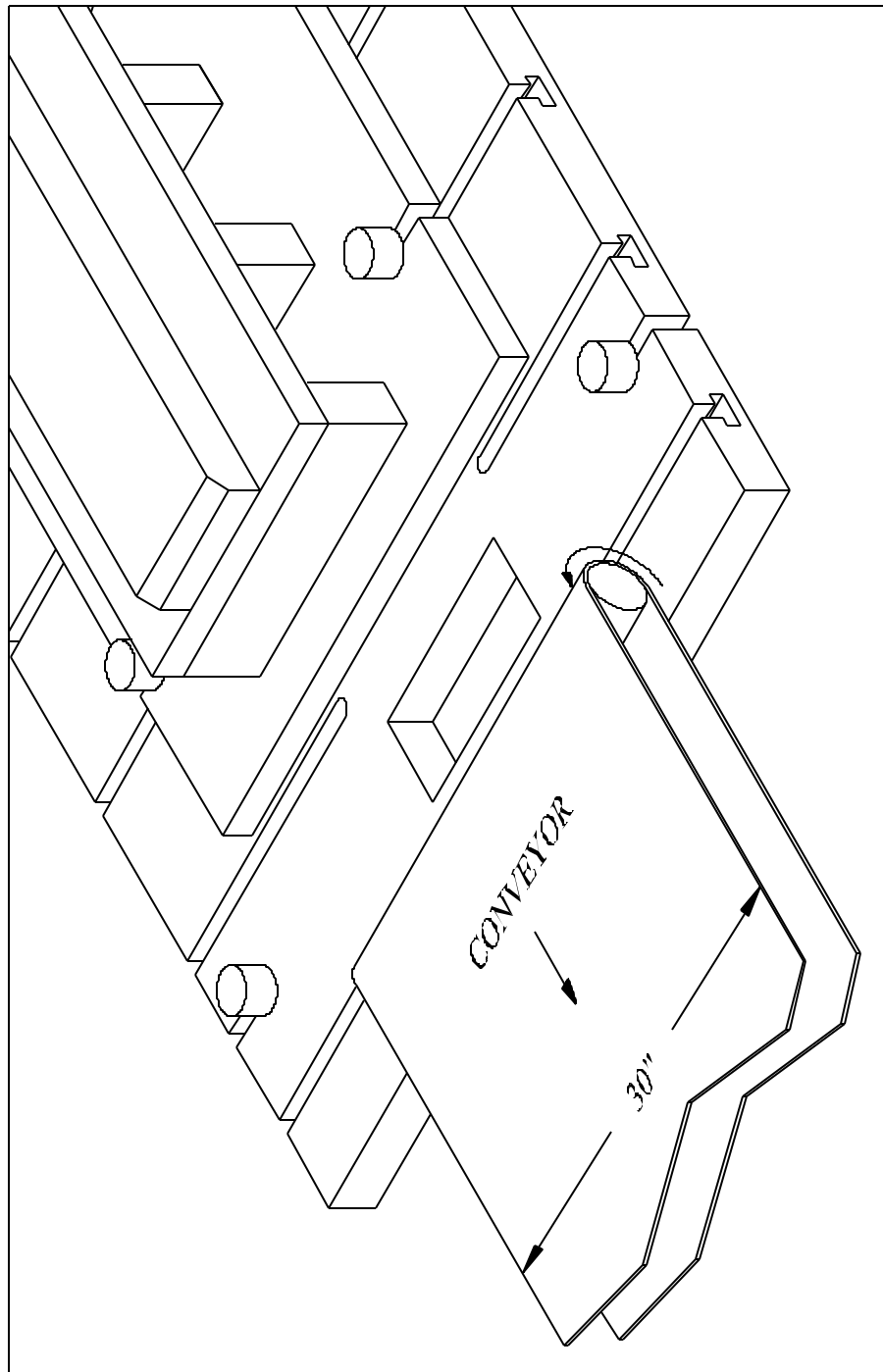
FLOW

BOLSTER PLATE
 (DIE LOCATOR PIN LOCATIONS)
 (SCRAP EXIT LOCATIONS)

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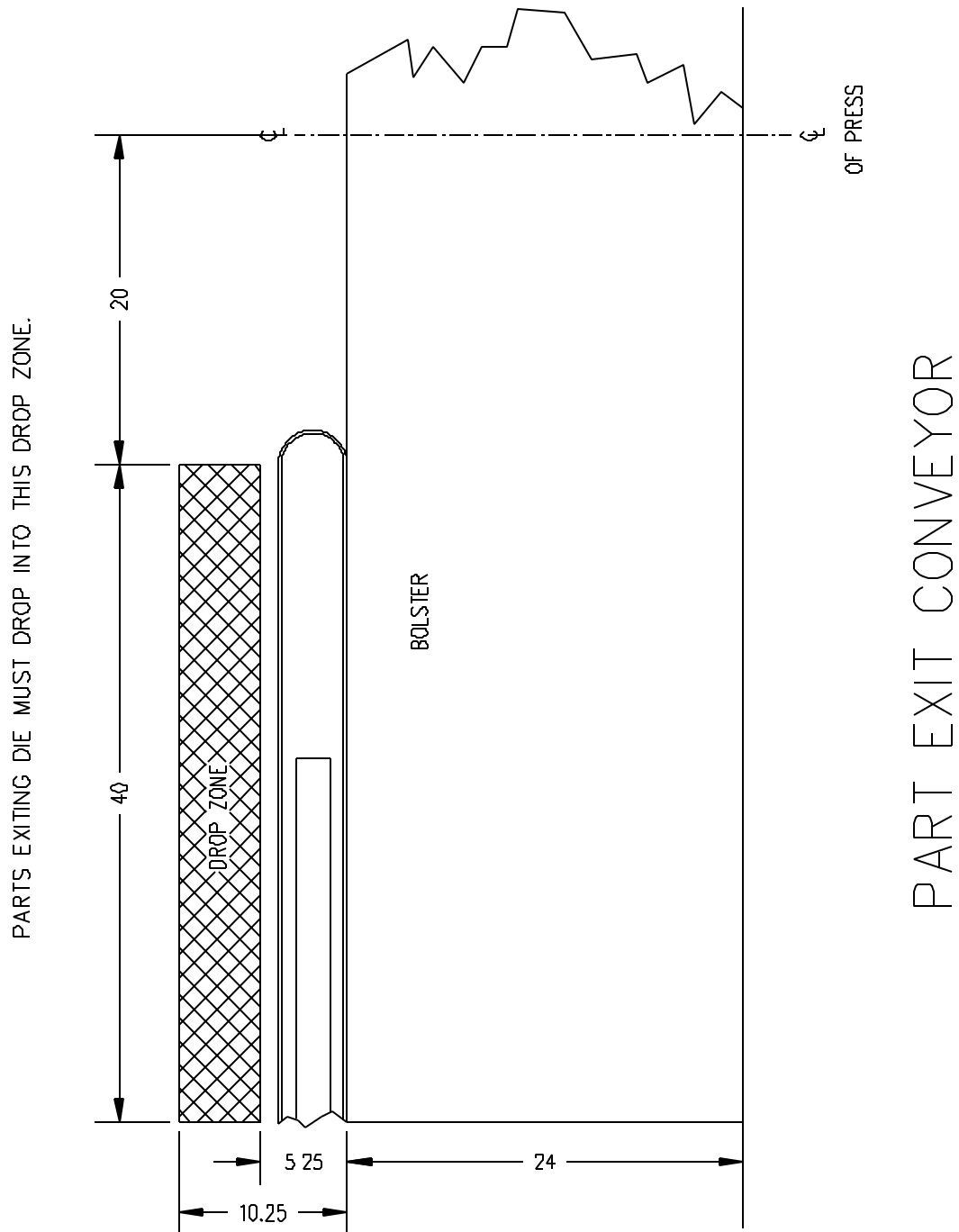


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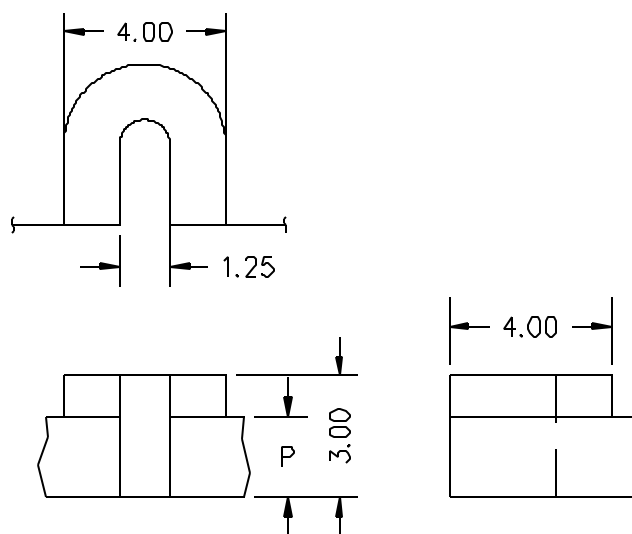
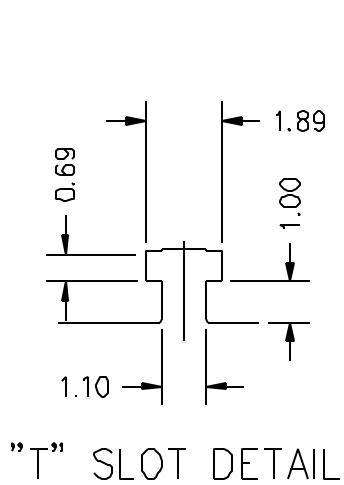
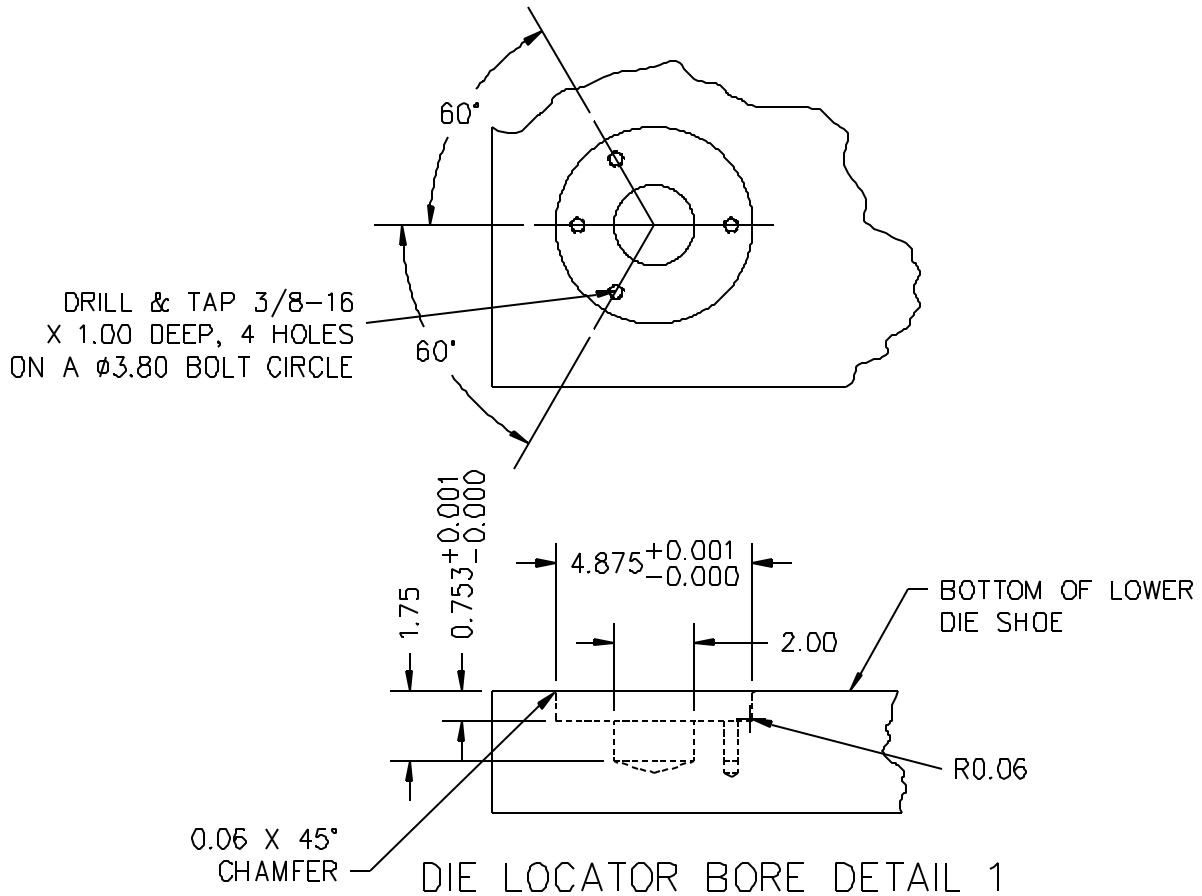


CONVEYOR LAYOUT

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DIE LOCATOR BORE DETAIL 2

