
	<p align="center">SPARTANBURG STEEL PRODUCTS PRESS LINE SPECIFICATION PRESS 2648 (72" x 42" 220 Ton – Single Action)</p>	Document No.: S02.018 Issue Date:08-Feb-06 Revision: 02 Page 2 of 13
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PRESS INFORMATION (ENGLISH)

	Inner	Outer
Work Capacity	220 Tons	N/A
Ram Size L/R – F/B	72" – 42"	N/A
Ram Spacer Thickness	None	N/A
Length of Stroke	6"	N/A
Slide Adjustment	6"	N/A
Shut Height S.D.A.U. (From Q.D.C. Plate)	23"	N/A
Target Die Height (From Q.D.C. Plate)	22"	N/A
Bolster Size L/R – F/B	72" – 42"	
Bolster Thickness	2"	
Rolling Bolster	N/A	
Carriage Thickness	N/A	
Bolster Spacer	N/A	
Bolster Spacer Thickness	N/A	
Positive Knockout	N/A	
Quick Die Change Sub-Plates	Yes	
Sub-Plate Thickness	3"	
Cushions (Number)	N/A	
Tons Each	N/A	
Tons Total	N/A	
Stroke	N/A	
Quantity @ Size L/R – F/B	N/A	
Distance From Bolster To Drip Pots5"	
Distance Between Drip Pots L/R	74"	
Strokes Per Minute	50 - 100	

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PRESS INFORMATION (METRIC)


	Inner	Outer
Work Capacity	200 MT	N/A
Ram Size L/R – F/B	1829mm – 1067mm	N/A
Ram Spacer Thickness	None	N/A
Length of Stroke	153mm	N/A
Slide Adjustment	153mm	N/A
Shut Height S.D.A.U. (From Q.D.C. Plate)	585mm	N/A
Target Die Height (From Q.D.C. Plate)	559mm	N/A
Bolster Size L/R – F/B	1829mm – 1067mm	
Bolster Thickness	51mm	
Rolling Bolster	N/A	
Carriage Thickness	N/A	
Bolster Spacer	N/A	
Bolster Spacer Thickness	N/A	
Positive Knockout	N/A	
Quick Die Change Sub-Plates	Yes	
Sub-Plate Thickness	77mm	
Cushions (Number)	N/A	
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	13mm	
Distance Between Gibbs L/R	1880mm	
Strokes Per Minute	50 - 100	

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AUTOMATION DEVICES USED (Continued)

COIL LINE

Coil Feeder	Yes	
Material Thickness vs. Material Width021" x 24"	.187" x 24"
Feed Pitch Peek Velocity	N/A	
Coil Inner Diameter (Min. & Max.)	20" – 24"	
Coil Outer Diameter (Max.)	72"	
Material Feed Height <i>(From Top Of Q.D.C. Plate)</i>	15"	
Max. Coil Weight	10,000#'s	
Roll Lift	Yes	
Uncoil	Off Top	

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PRESS INFORMATION GENERAL

Comments:

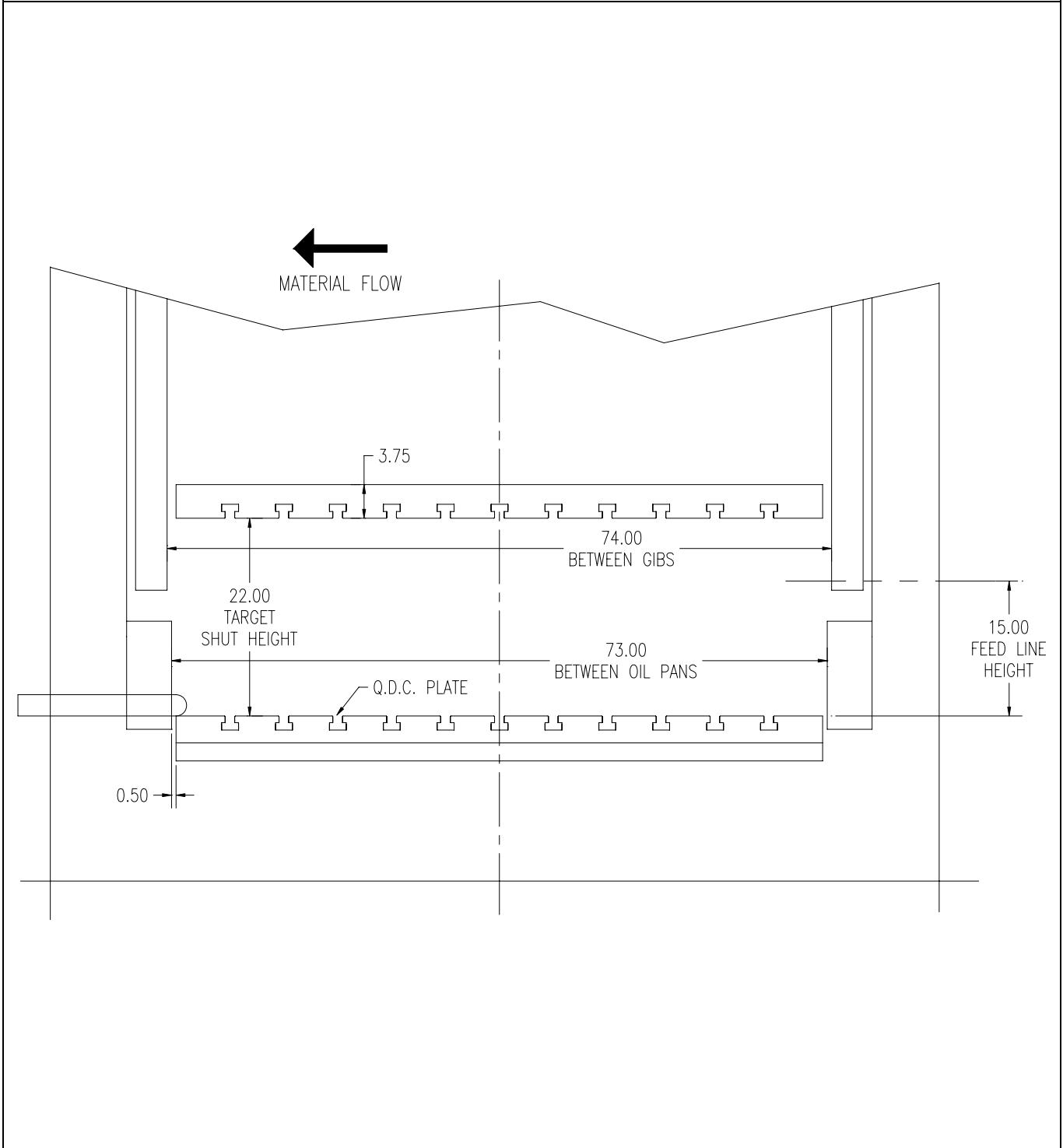
- 1) N/A
- 2) N/A



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Front View of Press

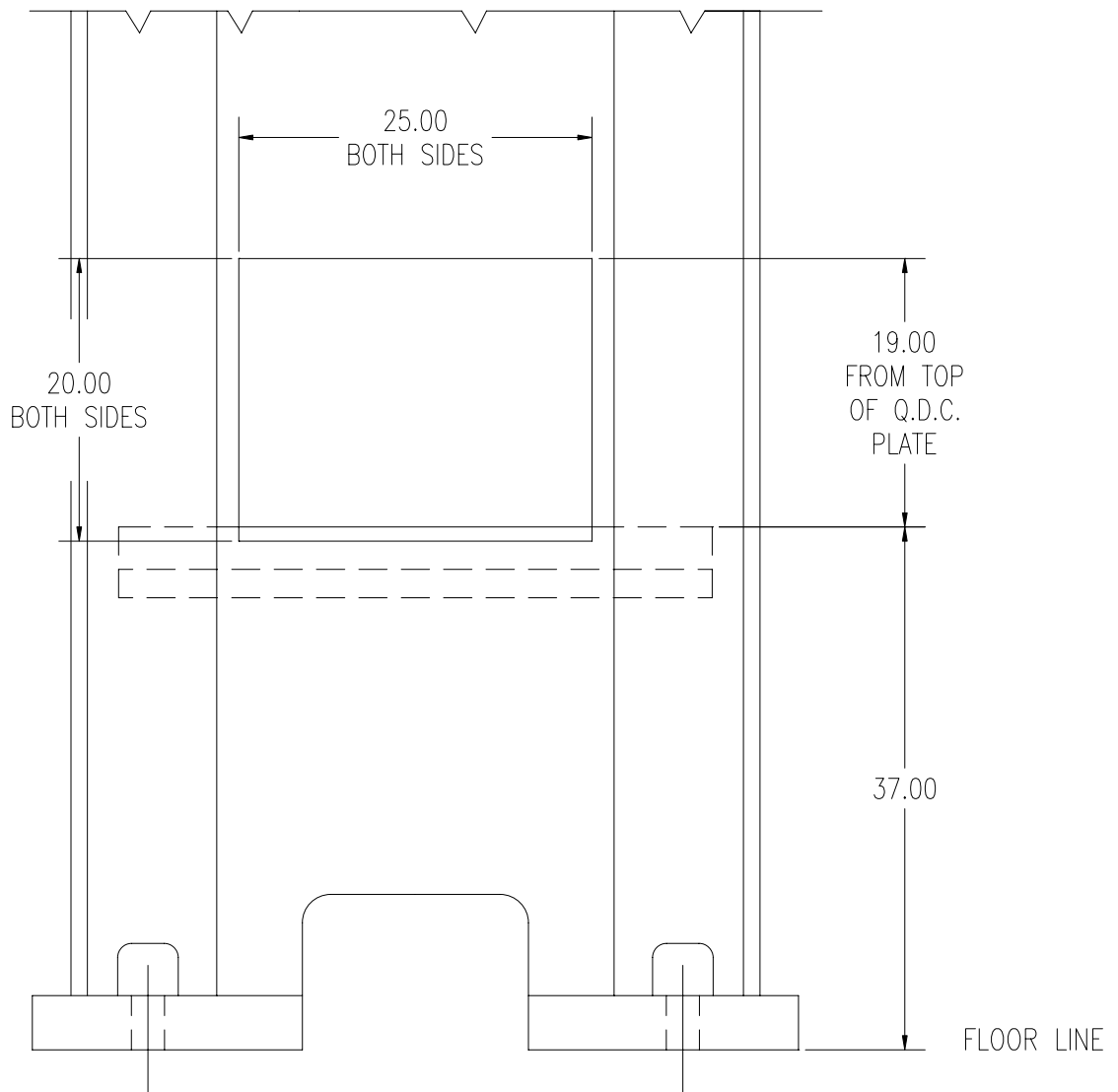




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END VIEW OF PRESS

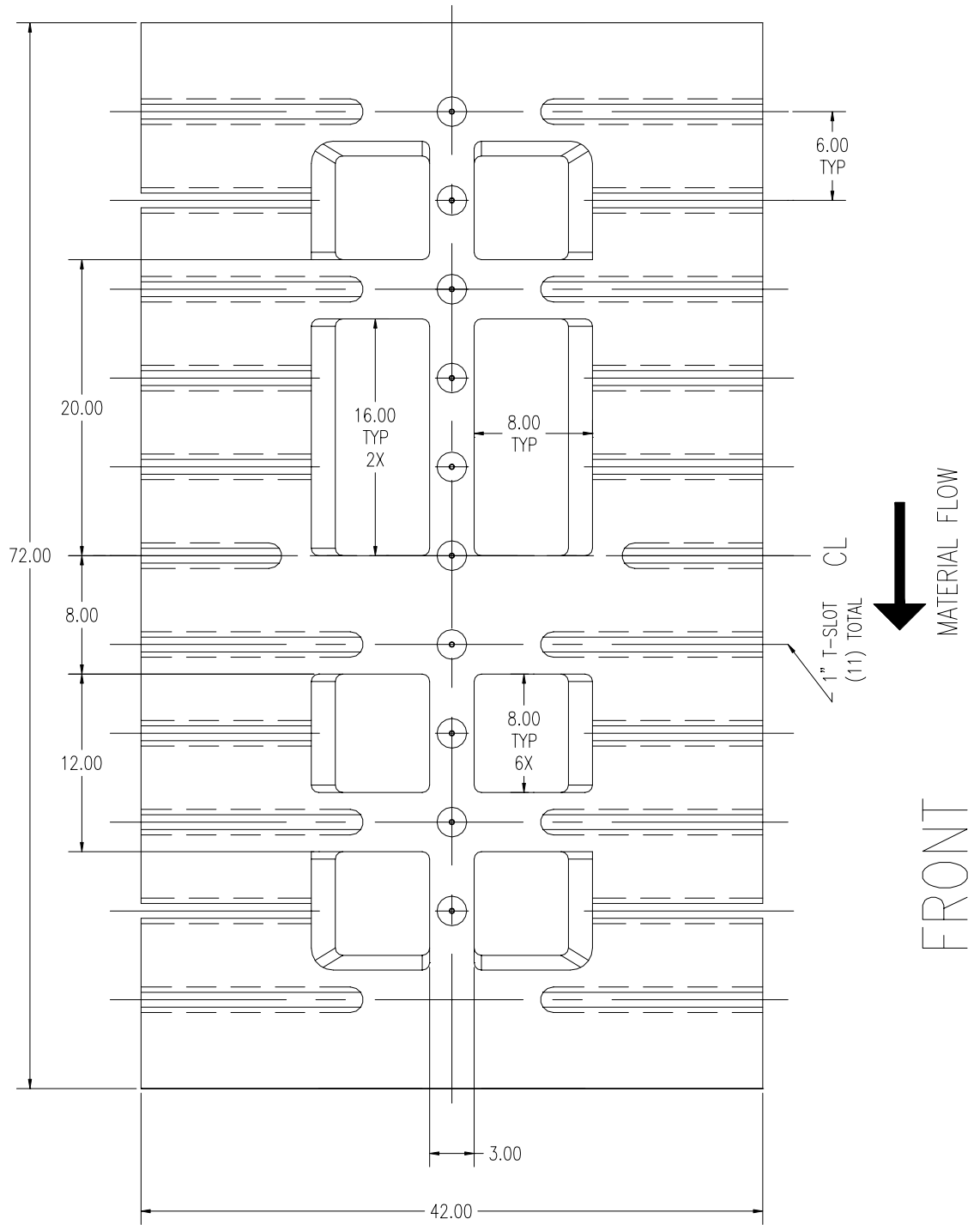




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Q.D.C.PLATE

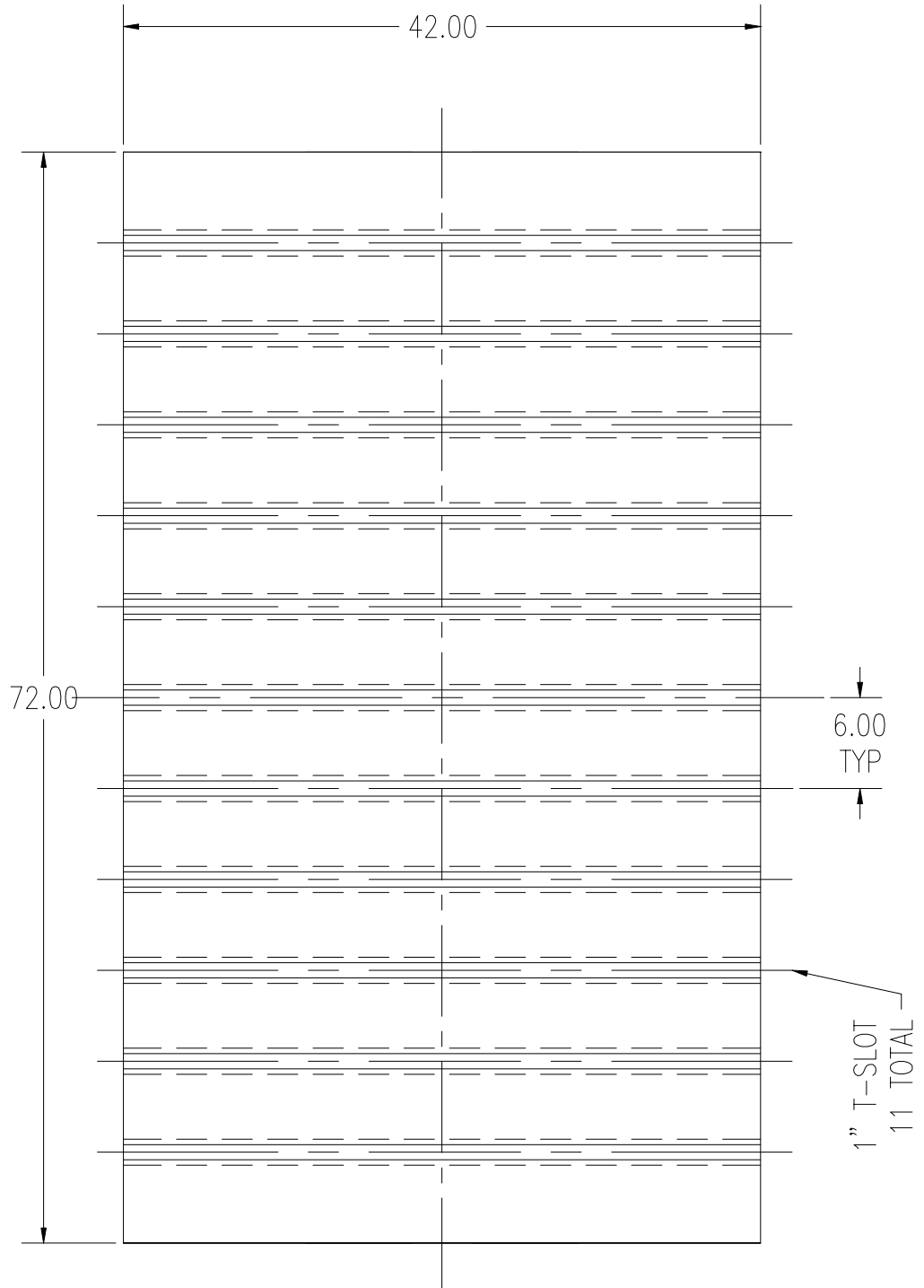




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RAM PLATE

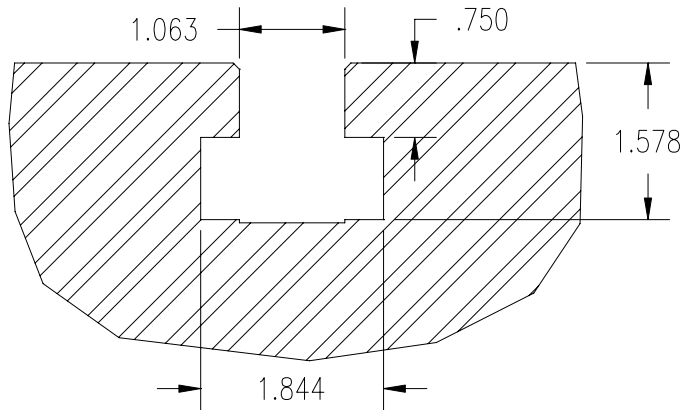




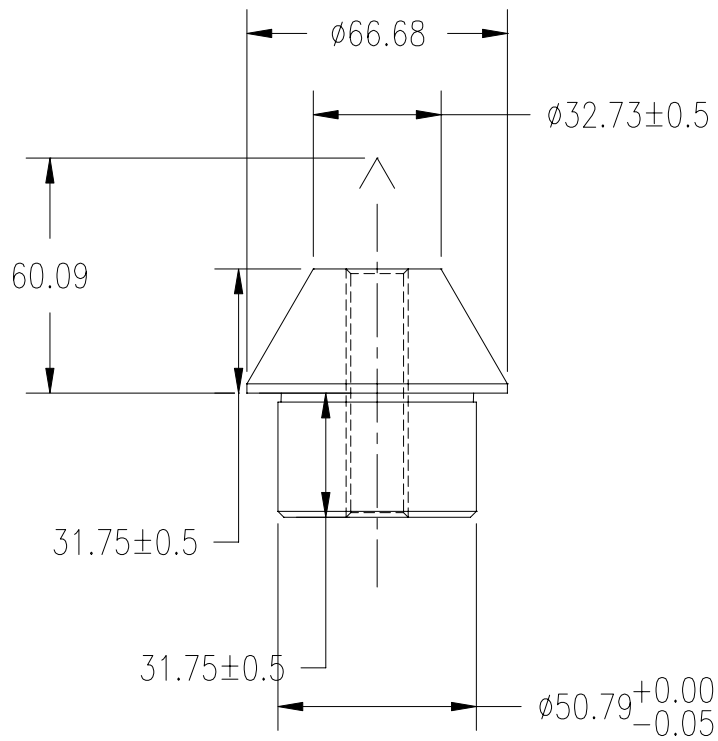
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LOCATOR PIN & T-SLOT DETAILS



SECTION OF
Q.D.C. & RAM
T-SLOT



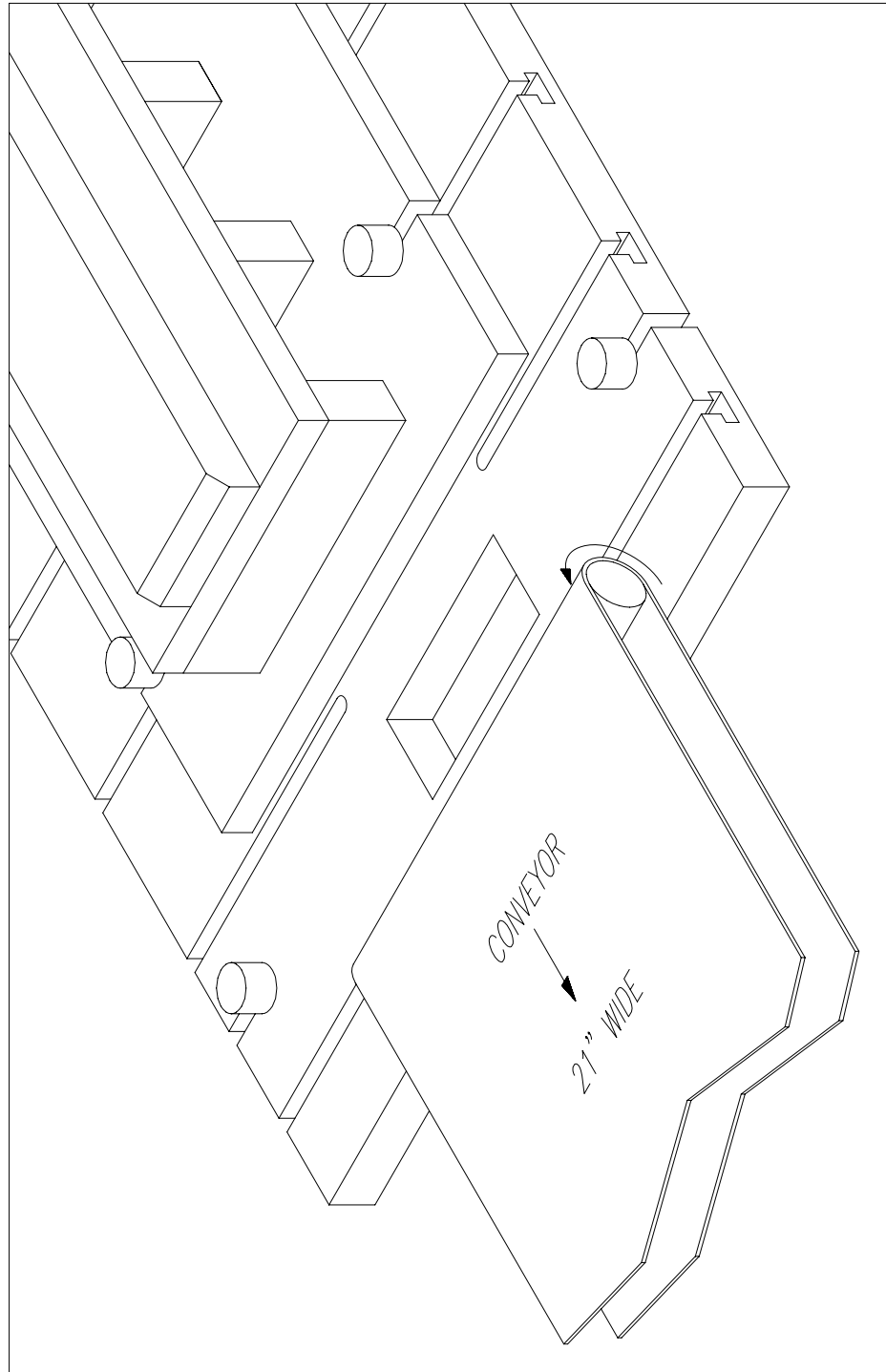
DETAIL OF DIE
LOCATOR PIN



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ISOMETRIC VIEW OF CONVEYOR

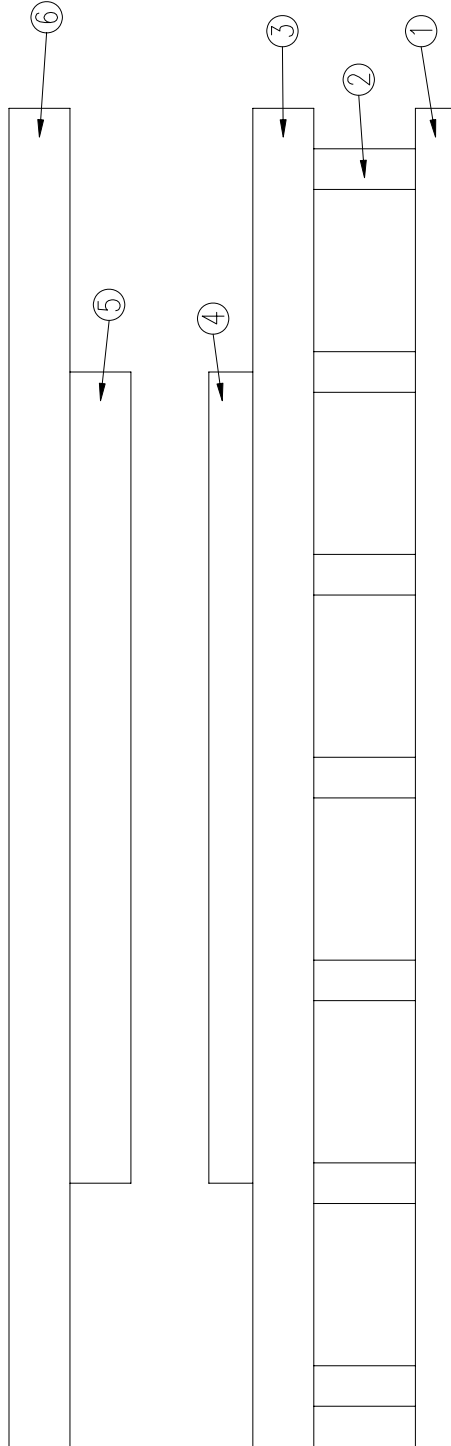




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DIE BUILDUP



MINIMUM DIE BUILD UP DIMENSIONS

1	LOWER PLATE	2.0
2	PARALLELS (CRS)	7.0
3	LOWER DIE SHOE	3.0
4	LOWER BUILD UP	3.0
5	UPPER BUILD UP	4.0
6	UPPER DIE SHOE	3.0

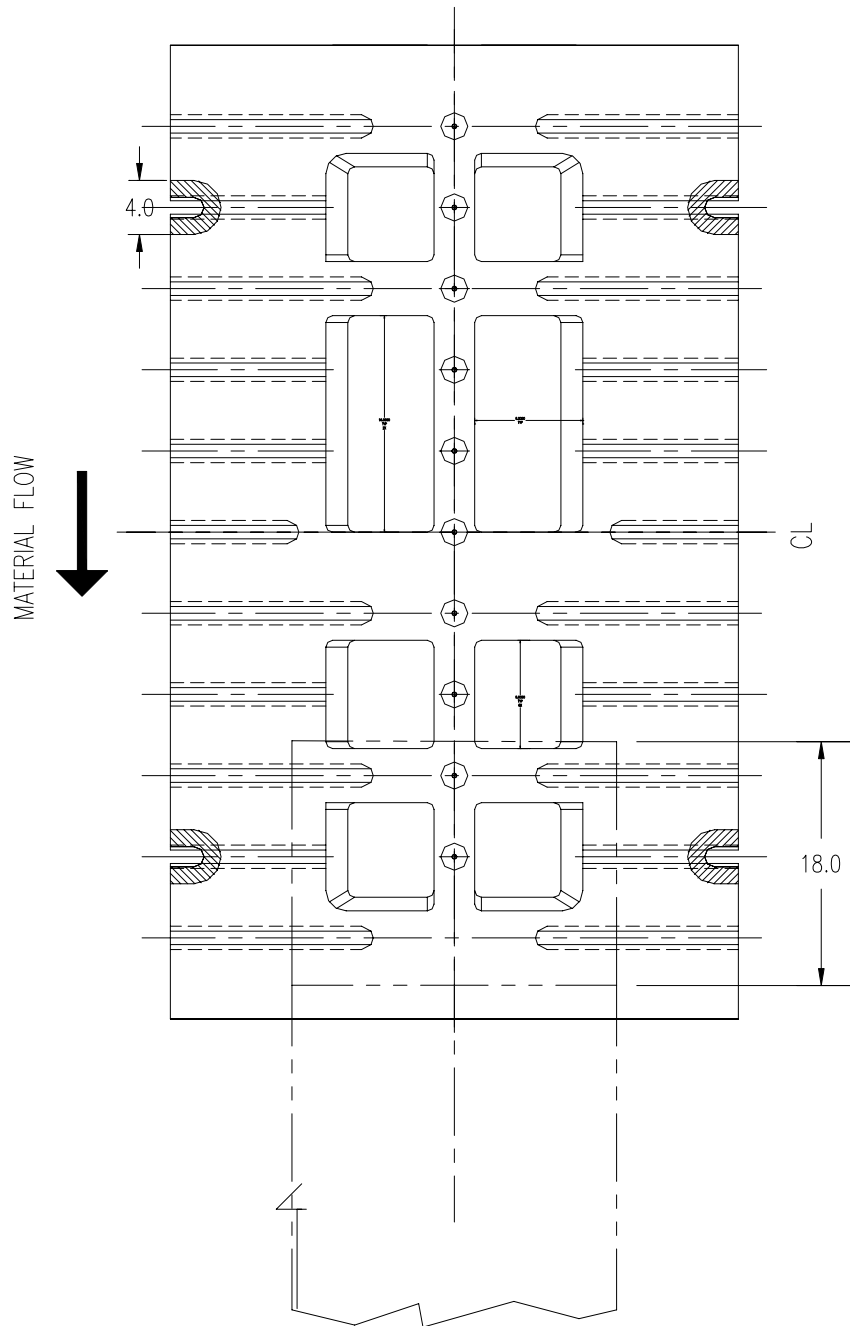


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Q.D.C.



FRONT OF PRESS

NOTE: THE HATCHED AREAS REPRESENT HYDRAULIC CLAMP AND QDC PLATE CLAMP AREAS. THE LOWER DIE PLATE CANNOT INTERFERE WITH ANY OF THESE AREAS.

THE TEN CIRCLES ON THE QDC PLATE REPRESENT THE POSSIBLE QDC PIN LOCATIONS.

THE AREA DENOTED BY THE PHANTOM LINES IS THE MAXIMUM CONVEYOR BELT DROP ZONE. THE CONVEYOR BELT CAN BE ROLLED INTO THE PRESS TO THE RIGHT TO REDUCE THIS AREA IF NEEDED.