




|   |  |  |
|---|--|--|
|  | <p align="center"><b>SPARTANBURG STEEL PRODUCTS</b><br/>PRESS LINE SPECIFICATION<br/><b>PRESS 2883</b><br/>was <b>1600</b><br/>(144" x 84" 2000 Ton – Single Action)</p> | <p align="right">Document No.:<br/>S02.011<br/>Issue Date: 25-Apr-06<br/>Revision: 0<br/>Page 2 of 8</p> |
|---|--|--|

**PRESS INFORMATION ENGLISH & (METRIC)**

Inner      (Metric)

|  |                                 |                      |
|--|---------------------------------|----------------------|
|  |                                 |                      |
| Work Capacity                              | 2000 Tons (1815 MT)             |                      |
|  | <u>Press Capacity @ 1/2" UP</u> |                      |
| Ram Size L/R – F/B                         | 144"– 96" (3658mm-2438.4mm)     |                      |
| Ram Spacer Thickness                       | None                            |                      |
| Length of Stroke                           | 36" (914.4mm)                   |                      |
| Slide Adjustment                           | 22" (558.8mm)                   |                      |
| Shut Height S.D.A.U.<br>(From Q.D.C.)      | 60" (1524mm) <b>Now is 55"</b>  |                      |
| Target Die Height<br>(From Q.D.C.)         | 46" (1168.4mm)                  |                      |
| Bolster Size L/R – F/B                     | 144"– 96" (3658mm-2438.4mm)     |                      |
| Bolster Thickness                          | 12" (304.8mm)                   |                      |
| Rolling Bolster<br>Carriage Thickness      | No<br>N/A                       |                      |
| Bolster Spacer<br>Bolster Spacer Thickness | NO<br>0                         |                      |
| Positive Knockout                          | None                            |                      |
| Quick Die Change                           | Yes                             |                      |
|  | PASCAL MANUAL CLAMPS            | Designed for 3" shoe |
| Cushions                                   | No (prevision for cushions)     |                      |
| Stroke                                     | 0"                              |                      |
| Quantity @ Size L/R – F/B                  | none                            |                      |
| Distance From Bolster To Drip<br>Pots      | 35 1/8" (893.7mm)               |                      |
| Distance Between Gibbs L/R                 | 163" (4140.2mm)                 |                      |
| Strokes Per Minute                         | 6 - 18                          |                      |



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**AUTOMATION DEVICES USED**

**LOADER**

**(METRIC)**

|   |                            |
|---|----------------------------|
| Destacker / Rollcoater / Loader                         | Yes                        |
| Max. Sheet Thickness                                    | .059" (1.52mm)             |
| Min. Sheet Thickness                                    | .025" (.635mm)             |
| Max. Sheet Size L/R – F/B                               | 120" – 75" (3048mm-1905mm) |
| Min. Sheet Size L/R – F/B                               | 36" – 30" (914mm-762mm)    |
| Max. Loader Pass Height<br><i>(From Top Of Bolster)</i> | 64.5" (1638mm)             |
| Min. Loader Pass Height<br><i>(From Top Of Bolster)</i> | 45.5" (1156mm)             |
| Max. Stack Height<br><i>(Including Pallet)</i>          | 20" (508mm)                |

**UNLOADER**

The un-loader of this press can not turn the part over a maximum of 180 degrees.

**PRESS INFORMATION GENERAL**



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Comments:

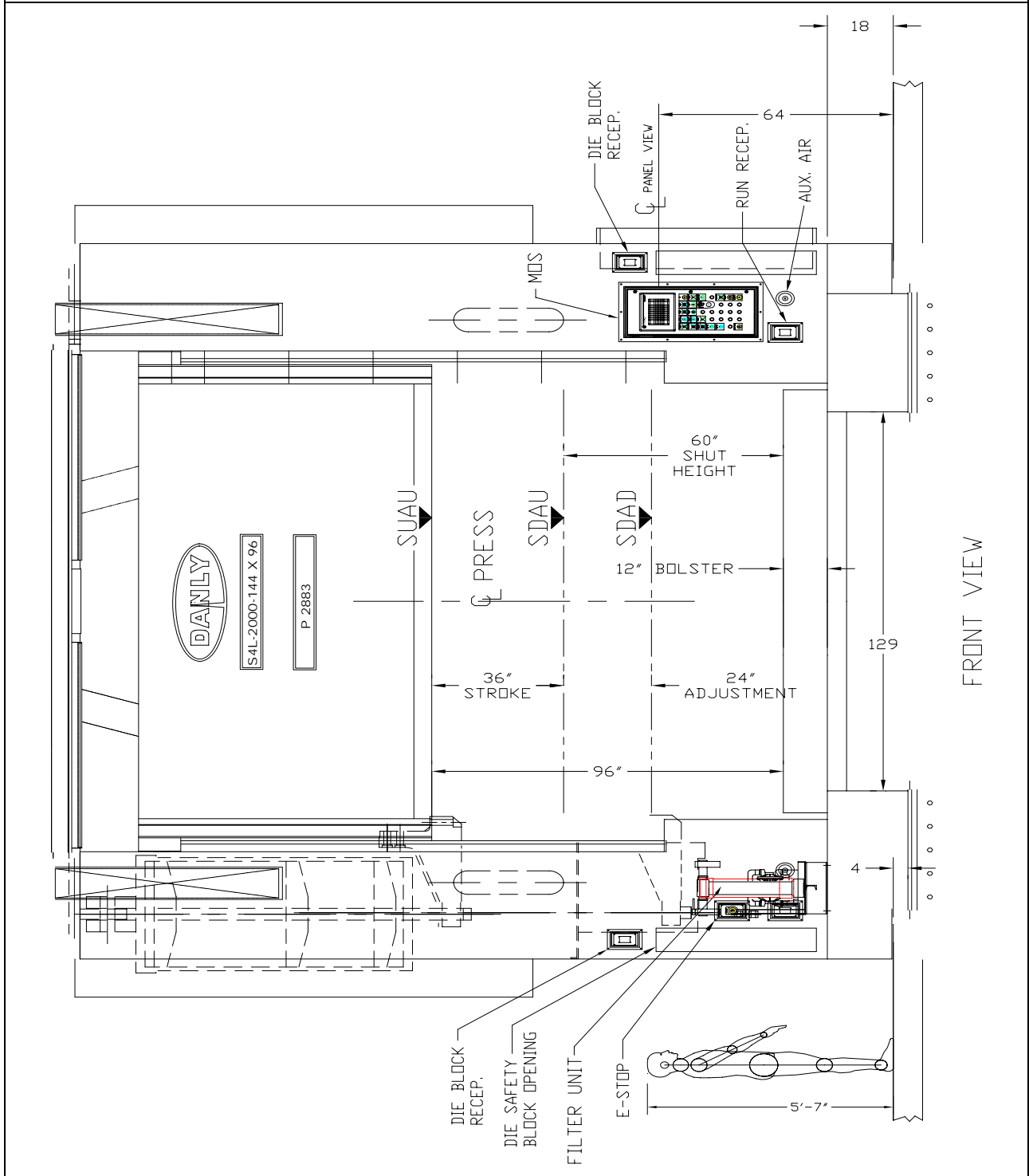
1. All jobs for this press line should be processed in five dies or less. Any deviation will require writer authorization.
2. The parts can be turned over (180 degrees max.) between press 2883 (*1600*) and press 1601. Using the floor standing FLEX-4.10 programmable transfer/turnover system. The FLEX-4.10 transfer is a four axis system, which features:
  - a. 2100mm of horizontal programmable travel
  - b. 200mm of manual height adjustment
  - c. +/- 10 degrees of manual angular gripper head adjustment
  - d. 360 degrees of programmable part tip (front to back)
3. Pass-line and orientation are not to change throughout the press line.



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**Front View of Press**



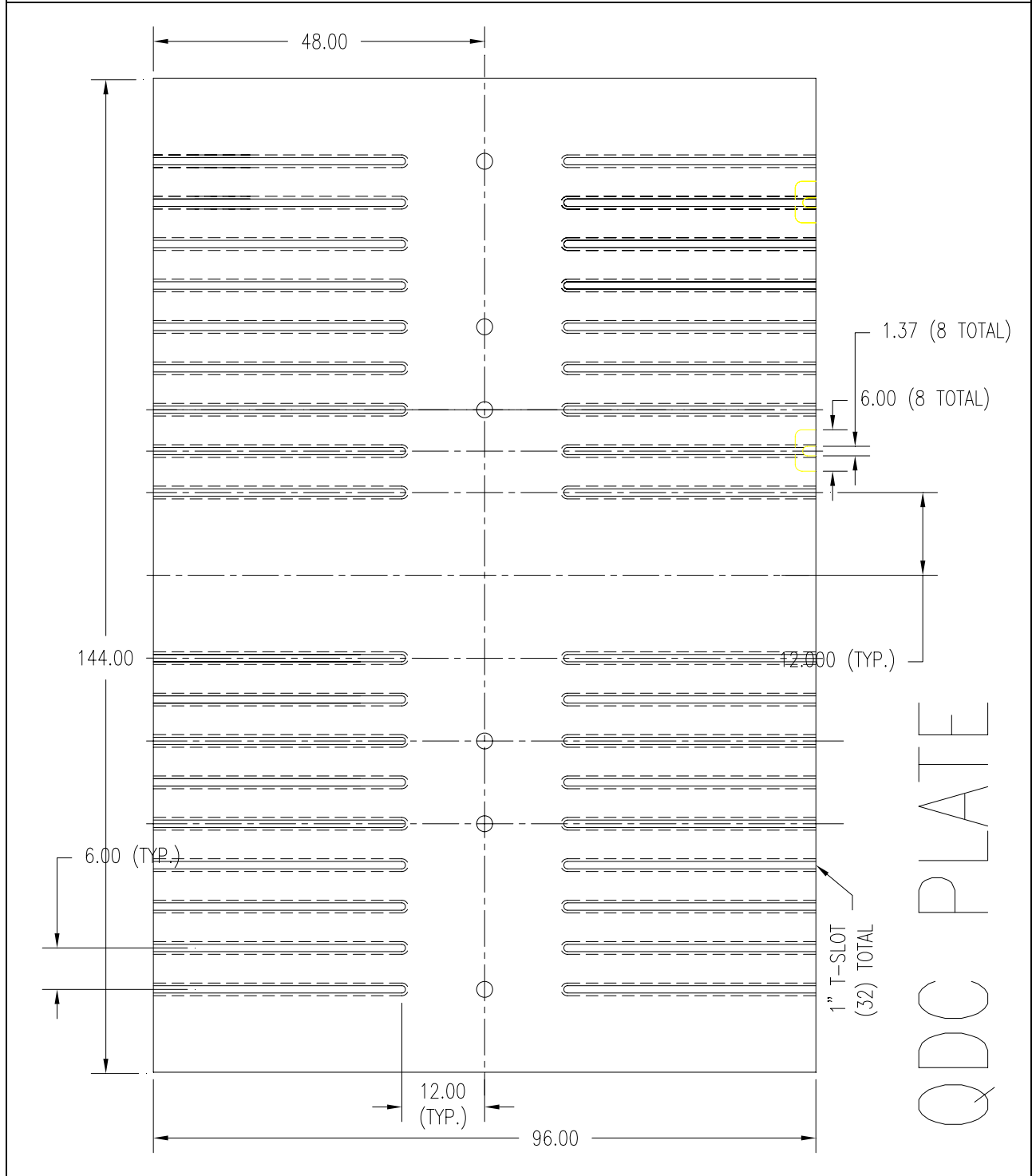




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**QDC Plate**

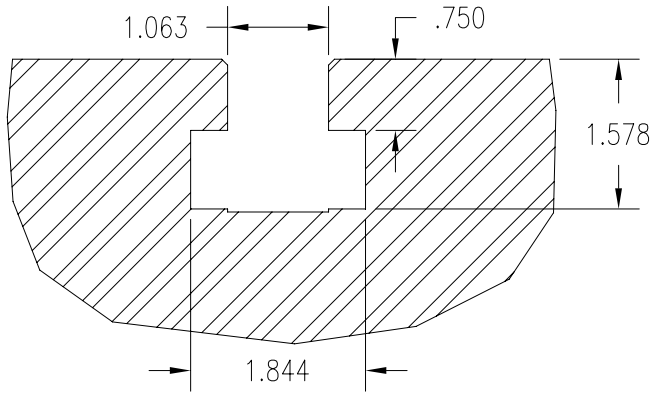




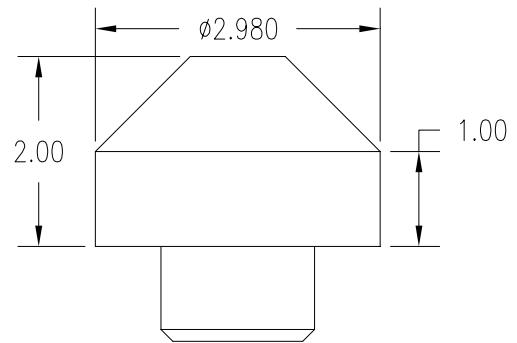
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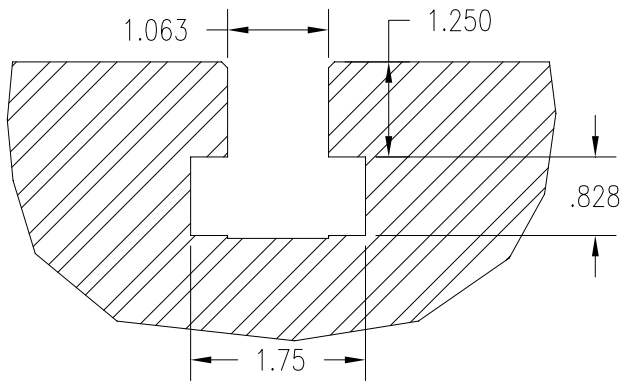
### Locator Pin & T-Slot Details



SECTION OF  
Q.D.C. T-SLOT



DETAIL OF DIE  
LOCATOR PIN



SECTION OF  
RAM T-SLOT