

VAN-ROB STAMPINGS

TYPE OF PRESS..... SE4-1200-180-84
 SERIAL NO..... E40-1200-24-84
 CAPACITY OF PRESS..... 1200 TONS @ 1/2 ABOC
 FULL WORK ENERGY..... 13 SPM AND ABOVE
 STROKE OF PRESS..... 22"
 SHUT HEIGHT (SDAU)
 OVER ROLLING BOLSTER..... 44"
 ADJUSTMENT..... 12"
 STROKES PER MINUTE..... 10-22
 INTERMITTENT TRIP RATE
 FOR 3000 HRS. LINING LIFE..... 8 @ 10 SPM
 9 @ 15 SPM
 5 @ 20 SPM
 SLIDE ADJUSTMENT SPEED..... 3.1 IN/MIN
 INDIVIDUAL ASSEMBLY WEIGHTS:
 CROWN ASS'Y..... 160,000
 COLUMN ASS'Y. 2 @ 30,000..... 60,000
 SLIDE ASS'Y..... 85,000
 BED ASS'Y..... 90,000
 LADDER & PLATFORM ASS'Y..... 5,000
 TIE RODS & NUTS 4 @ 7,500..... 30,000
 MOTOR DRIVE ASS'Y..... 5,000
 ROLLING BOLSTER ASS'Y..... 40,000
 MISCELLANEOUS..... 5,000

TOTAL PRESS WEIGHT..... 480,000 LBS.
 NOTE: THESE WEIGHTS ARE APPROX. ONLY

ELECTRICAL SERVICE REQUIREMENTS:

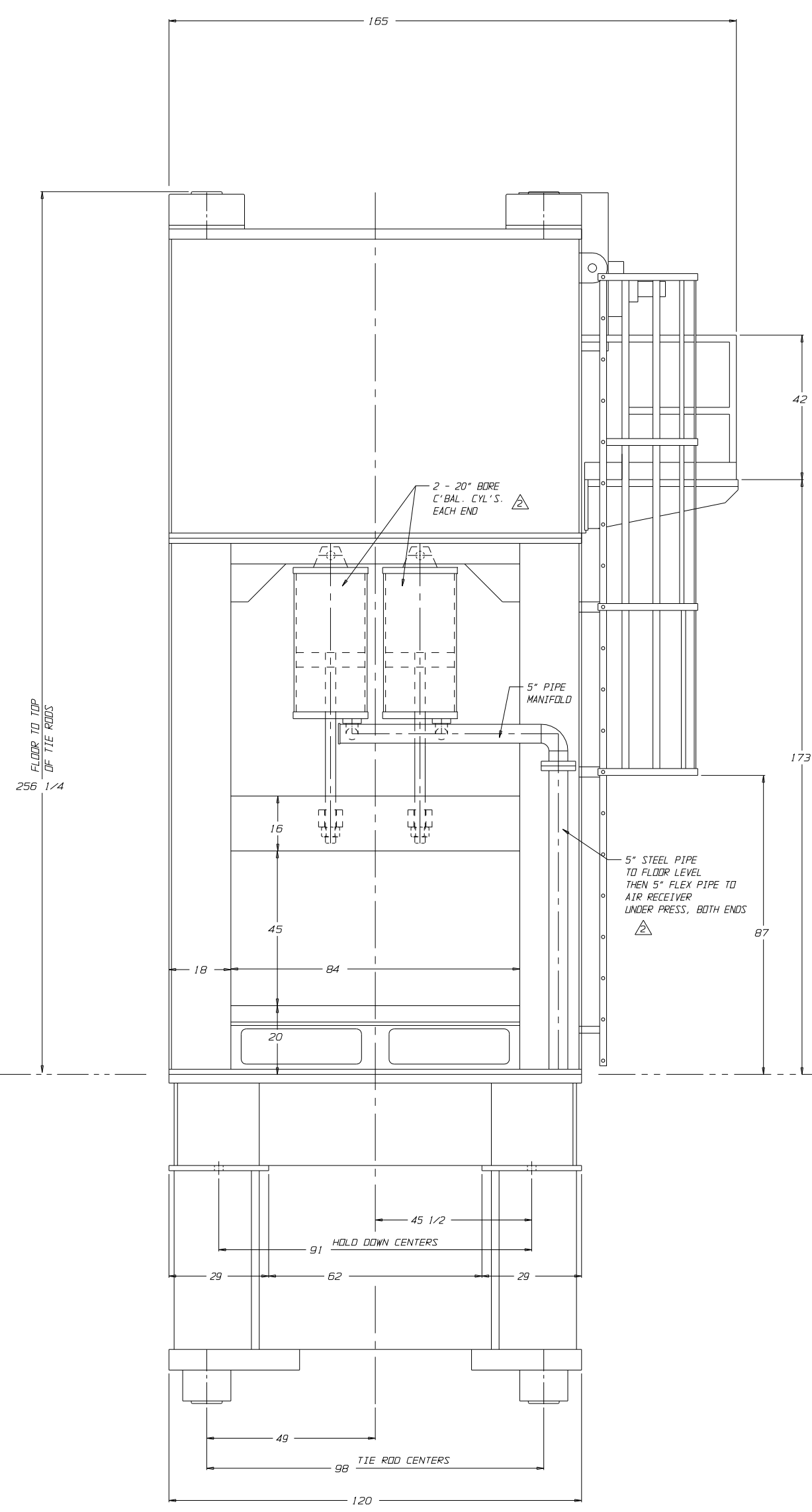
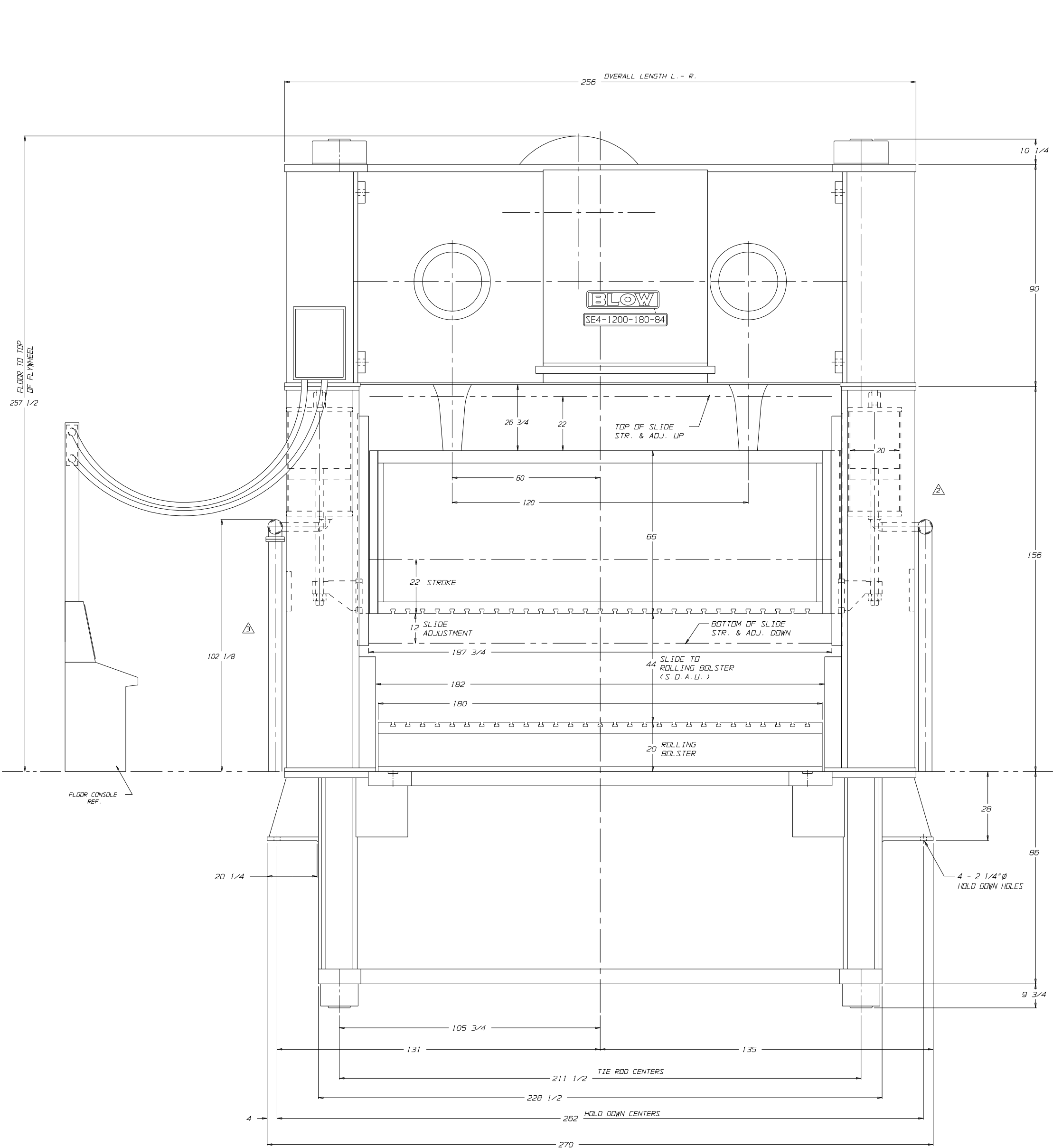
LINE VOLTAGE..... 480 V.
 PHASE & CYCLE..... 3-60 Hz.
 MAIN MOTOR HP & RPM..... 150 HP. & 300 TO 1750 RPM
 SLIDE MOTOR HP & RPM..... 15 HP. & 1750 RPM
 LUBE PUMP MOTOR HP & RPM..... 1/3 HP. & 1725 RPM

AIR SERVICE REQUIREMENTS:

C'BAL. SUPPLY PIPE SIZE..... 3/4" NPT
 CLUTCH SUPPLY PIPE SIZE..... 1 1/2" NPT
 CLUTCH AIR CONSUMPTION
 WITH WORN LININGS..... 1.5 SCF PER ENGAGEMENT
 CLUTCH AIR PRESSURE..... 85 PSI

HYDRAULIC TIE ROD NUT PUMP REQUIREMENTS:

8950 PSI FOR 600 TONS OF PRELOAD
 STRETCH TIE RODS .277



PRESS CODE: 507 PLOTTING SCALE: .028

DO NOT SCALE DRAWING

UNLESS OTHERWISE SPECIFIED:
 MACHINED SURFACE TOLERANCES:
 ALL 3 PLACE DECIMALS: +/- .005
 ALL FRACTIONAL DIM'S TO MACHINED SURFACES: +/- .015
 FRACTIONAL TOLERANCES:
 UNDER 5 FEET: +/- 1/16
 OVER 5 FEET: +/- 1/8

DRAWN BY: R. J. J. DATE: 05 MAY 94
 CHECKED BY: DATE:

SCALE: NOT TO SCALE MADE FROM:

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BLOW PRESS LIMITED
 GUELPH ONTARIO

DESCRIPTION:
 SE4-1200-180-84

DRAWING NAME:
 GENERAL ASSEMBLY

DRAWING NUMBER: 0082-C-0001 REV. 3

REVISIONS: 0	PRELIMINARY DWG. FOR REF. OR QUOTATION	1	DRAWING WAS A PROPOSAL ONLY	2	17 MAY 94 RJJ CHG'D C'BAL CYL'S AND R.H. AIR RECVR. LOCT'N	3	08 JUNE 94 RJJ MOVED L.H. AIR RECVR. TO BENEATH PRESS
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