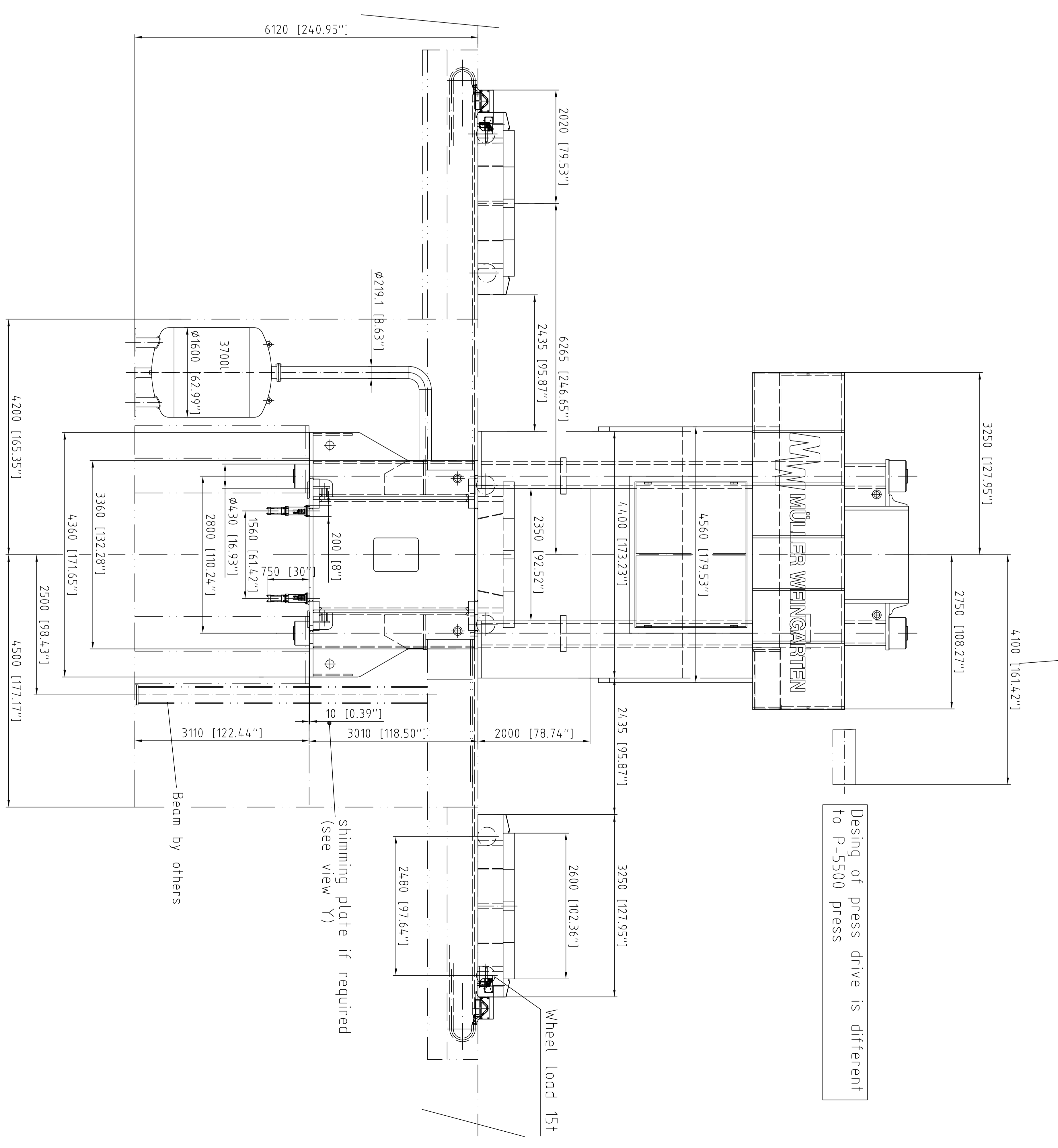
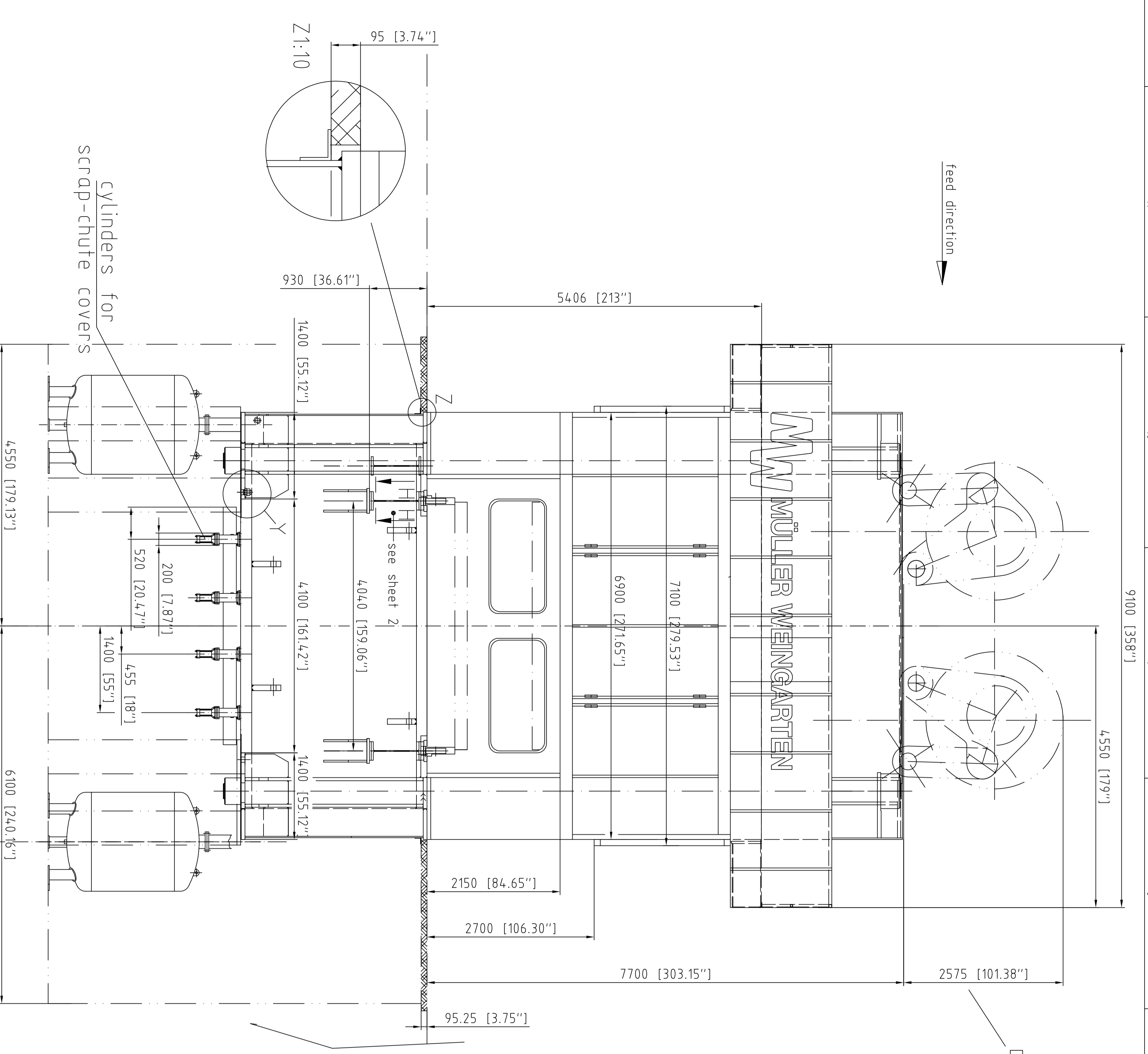


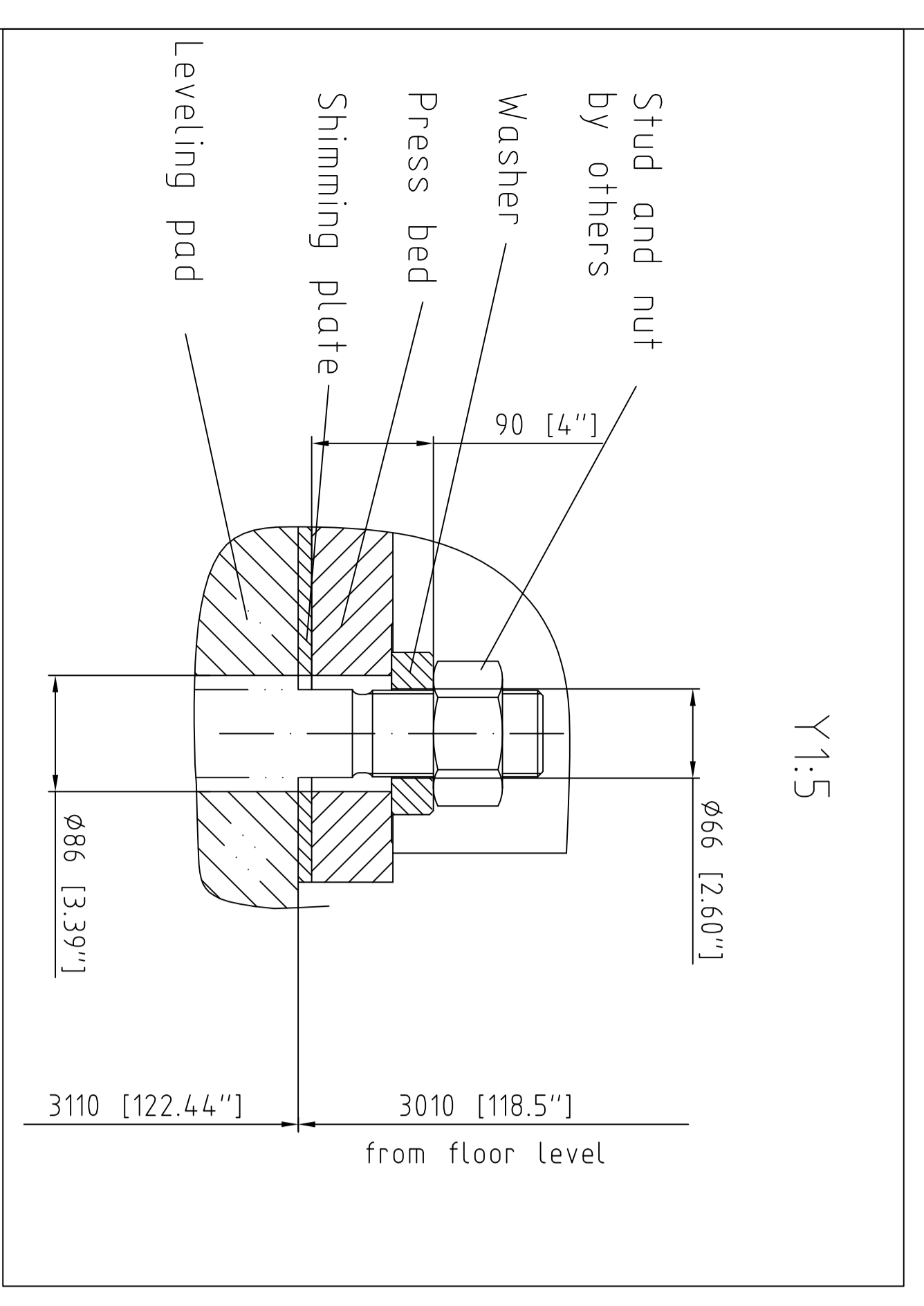
AUTH.	DATE	SYM.	REVISION RECORD	DWG. NO.



MIN. RECOMMENDED DIMENSIONS FOR PIT  
FRONT VIEW OF PRESS



Press anchoring



Y1:5

Specifications for foundation preparation

This drawing only covers the foundation requirement imposed by the connection-related dimensions of the equipment.  
The design of the foundation, such as foundation depth or layout, arrangement and strength of reinforcement, depends on the local situation, e.g. the floor carrying capacity.

Uniform ground pressure distribution must be ensured. The surface of the foundation should be designed oil-proof. The foundation dimensions related to non-MW supply items must be checked for the following:

1. Position of support beams
2. Static total weight of machine including dies approx. 480t. This results in a total weight G of approx. 4800 kN. This load G caused by the machine weight is increased by the dynamic loads F1 and F2 according to the table below!
3. The press support areas of the beams must be levelled to a tolerance of ±0.1 mm during assembly.
4. Settling of the foundation in the individual support beam areas must be avoided by adequate dimensioning.

If any settling should occur which results in a deviation of the individual support points, re-leveling is necessary. The maximum permissible deviation among the individual support points is 0.4 mm.

The foundation inspection must be carried out by customer.

Techn. Specification Type WK 1500.40.264.5

Total press tonnage	15000 kN
Slide press force from 12.5 mm above BDC	15000 kN
Slide stroke	450 mm
Total working at stroke rate 10 SPM	240 kJ
Stroke rate in continuous running mode	10-40 SPM

Air consumption

1. Automatic mode  
- for each single clutch engagement ..... 0.5 cuft -consumption of die set to be determined by customer
  2. Die change within 1.5min. .... 37cuft
- Electric power rating of machine ..... 425 KVA

Load on the individual support points

Foundation load	Location	1A	1B	2A	2B	Sum
1 Static weight of machine and dies (Weight G) in kN		940	1020	940	1020	3920
2 Dynamic inertia force F1 (ram + upper die) in kN		280	280	280	280	1120
3 Dynamic reaction powers F2 x), depending on load on machine and cushions (max. value in kN (F=100-140 Hz))		650	650	650	650	2600
4 Total load on foundation as a sum of 1+2+3 in kN		1870	1950	1870	1950	7640

x) The values have been extrapolated from actual measurements. The load of the floor coating has not been taken into account.

ref.: P4000P-rog Die Press  
GM P.O. NO. WHS-37221  
MW O.NO.112 2027/203/2071/208

Certified As Installed 10.12.99  
SCALE = 1:50  
P 4000 Press

ITEM	QUANT.	DESCRIPTION
BILL OF MATERIAL		
METAL FABRICATING DIVISION		

EQUIPMENT TYPE NO. SL4-1500-4000X2600		SERIAL NO.	
P.O. NO. WHS-37221	MAKE NO. 98-12	GM PLANT	112202/203/207/208
MWAG	CAD FILE SVI-150	DRAWING NO. 01754121 A0	SHEET 01 OF 04