Triple Action Draw Press

The press in the photo is a Triple Action Press. It had a 600-ton capacity Main Ram/Punch, 300 ton Capacity Blankholder Platen and 125 Ton capacity Cushion. Press will be used for drawing sheet metal into Aerospace and Aeronautical components. The press has full functionality through the Touchscreen to be able to set up each of the cylinders for pressure, distance, speed and dwell. All programs are stored in the control with the ability to store up to 100 jobs on board. Specifications follow:

SPECIFICATIONS FOR TRIPLE ACTION HYDRAULIC PRESS

Model Number	4TA-600/300-52 x 52-52/52/10
Punch Force	Adjustable 120 to 600 tons
Blankholder Force	Adjustable 60 to 300 tons
Punch Diameter	12"
Blankholder Work Area: L-R between posts	52"
Blankholder Work Area: Front to Back overall	52"
Overall width, left to right	84"
Overall height above the floor	216"
Overall depth below the floor	24"
Punch Daylight = Maximum Open Distance	48"
Punch Stroke	Adjustable to maximum 38"
Punch Shut Height	10"
Punch Cylinder Bore Diameter	22"
Punch Ram Diameter	12"
Blankholder Daylight = Maximum Open Distance	48"
Blankholder Stroke	Adjustable to maximum 38"
Blankholder Shut Height	10"
Blankholder Cylinder Bore Diameter	10"
Blankholder Ram Diameter	7"
Bed to floor height	36"
Motor Capacity	150 HP, 1800 RPM
Pump capacity	52/52/10 GPM
Hydraulic System	Regenerative/Prefill
Reservoir Capacity	650 Gallons Minimum
Maximum System Pressure	3183 PSI
Punch Ram Speed:	
Close, inches per minute in run mode	624 IPM
Press, inches per minute in run mode	29 IPM
Open, inches per minute in run mode	600 IPM
Blankholder Ram Speed:	
Close, inches per minute in run mode	624 IPM
Press, inches per minute in run mode	61 IPM
Open, inches per minute in run mode	600 IPM

Cushion Specifications:

Cushion Force	Adjustable 25 to 125 Tons
Ejection Force	15 Tons max
Stroke	Adjustable to maximum 8"
Cylinder Bore Diameter	10"
Ram Diameter	7"
Platen Overall: Left to Right	32"
Platen Overall: Front to Back	32"

Ram Speed:

Extend with up to 15 tons of force	59 IPM
Retract, inches per minute	Punch Pressing Speed
Retract, inches per minute in jog mode	59 IPM

Included Equipment:

Allen-Bradley Panelview 1000 Plus Electronic Press Control: A powerful, compact control for digital control over press functions. Simple, user-friendly system, with keypad or touch screen entry of control functions and set-up parameters. Closed Loop Pressure Control compensates for temperature variation and allows repeatable accuracy of ± 2%.

With the electronic press control you can:

Set Digital Top Stop, Slow Down, and Bottom Stop stroke positions for Main Ram, Blankholder and Cushion.

Set Digital Pressure (Tonnage) set points for Main Ram, Blankholder and Cushion.

Counters: non resettable press stroke counter, resettable stroke counter and batch counter

Dwell timer, allows adjustable pressure dwells up to 10 seconds.

Trend display for Tonnage and Reversal Position; view the last ten (10) cycles.

Cycle rate displayed in cycles per minute.

Recipe storage. Stores set-ups for up to 100 recipes on board. Speeds press setup.

Diagnostic capability. All PLC I/O points can be monitored on the screen.

Hour Meter

Vibro Dynamics Micro Level Isolators

Banner Brand Light Curtain with Mirrors: An electronic barrier with the transmitter and receiver mounted at one corner of the press sending a signal through mirrors mounted at the other three corners of the press. This style of light curtain allows for access to all four sides of the work area. Light curtains also have Blanking Capabilities.

Closed Loop Speed Control: Adjusts the pressing speed from 10% to 100% of full speed at the touch screen. Included are a proportional directional valve   and   a   10-micron pressure line filter.

Low Oil Level Fault Indicator: Low oil level will trigger an alarm on the Touch Screen. The oil level will need to be restored before clearing the alarm.

High Oil Temperature Fault Indicator: High oil temperature will trigger an alarm on the Touch Screen. The oil temperature will need to be lowered before clearing the alarm.

Contaminated Oil Filter Fault Indicator: A clogged filter will trigger a warning indicator on the Touch Screen.

VPN Web Server: This will allow the customer to obtain feedback from the press via an Ethernet connection. The customer will have the ability to view and log data from the press. The following are the capabilities:

> Web HMI - view animated screens or tabular data through a standard web browser interface. This allows users to view maintenance reports, production data, and any other information available at the machine level. Greenerd will provide basic screens and software for the customer to add and modify the screens to fit their needs.

> Alarm Management - e-mail notifications can be sent if PLC variables are outside the predetermined limits. Examples could include cycle complete, batch complete, filter clogged, etc.

> Data Logging, Reporting, and Trending - data can be stored in an internal database for later review or real-time analysis. This data can be passed to a higher end management system based on timing, on alarm or by request.

> Remote Access - allows connectivity to the PLC and other devices with the same control as being on-site.

Bar Code Reader: Keyence LED Type Handheld Scanner, Bar Code Interface and DC Input Card. Bar Code Reader will allow the operator to scan the individual Bar Code on any particular tool or Router Card to determine the proper program to be called up to the Touchscreen.