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| Address: | |
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| **PRESS DATA** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| a) Type | | | | | | | | Mechanical (attach motion law) | | | | | | | | | | | | | | | | | | | | | |  | | Hydraulic | | | | | | | | |  | | | |  | | | | | | | | | | | |
| b) Structure | | | | | | | | C frame | | | | | | | | | | | | | | | | | | | | | |  | | 4columns(a) | | | | | | | | |  | | | | 4columns (b) | | | | | | | | | |  | |
| F2  F2  A  A  B  Type (a)  Type (b)  D  D  B  F  F1  F1  F  G  H  C  C  E  E  Y  X  G  B  H  A  Feed direction | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| c) Feeding direction | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | F1 | | | F2 | | |
| d) Table dimensions | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | A | | | | | | | | | | | | B | | | | | | | | | | | | | | |
| e) Daylight between columns | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | C | | | | | | | | | | | | D | | | | | | | | | | | | | | |
| f) Press overall footprint | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | E | | | | | | | | | | | | F | | | | | | | | | | | | | | |
| g) Slide to table daylight at TDC | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | G (min) | | | | | | | | | | | | G (max) | | | | | | | | | | | | | | |
| h) Table level from floor | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | H | | | | | | | | | | | | | | | | | | | | | | | | | | |
| i) Slide stroke | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | (min) | | | | | | | | | | | | (max) | | | | | | | | | | | | | | |
| j) Slide adjust (only mechanical press) | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | (min) | | | | | | | | | | | | (max) | | | | | | | | | | | | | | |
| k) Part orientation | | | | | | | | | | | | | | | | | | | | | | (mm) | | | | | | | | **Y** | | | | | | | | | | | | **X** | | | | | | | | | | | | | | |
| **Die change** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| a) Extractable table | | | | | | | | | | | | | | | Y | | | | N | | | | | b) Table/Bolster exit | | | | | | | | | | | | | | | Left | | | | Right | | | | | Front | | | Back | | | | | |
| c) Moving bolster | | | | | | | | | | | | | | | Y | | | | N | | | | | d) Bolster rails | | | | | | | | | | | | | | | Left | | | | Right | | | | | Front | | | Back | | | | | |
| e) Die centering tang on press table | | | | | | | | | | | | | | | | | | | | | Y | | | | | N | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| f) Automation flanges | | | | | | | | | | | | | | | | | | | | | Y\* | | | | | N | | | \* attach drawings | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **DIES** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| a) Number of steps per press | | | | | | | | | | | | | | | | | |  | | | | | | | b) Steps centerline distance | | | | | | | | | | | | | | | | | | | | | | | (mm) | | |  | | | | | |
| c) Closed die height | | | | | | | | | | | | | | (mm) | | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| d) Upper half die height min. | | | | | | | | | | | | | | (mm) | | | |  | | | | | | | e) Lower half die height min. | | | | | | | | | | | | | | | | | | | | | | | (mm) | | |  | | | | | |
| f) Upper half die height max. | | | | | | | | | | | | | | (mm) | | | |  | | | | | | | g) Lower half die height max. | | | | | | | | | | | | | | | | | | | | | | | (mm) | | |  | | | | | |
| h) Daylight between columns | | | | | | | | | | | | | | (mm) | | | |  | | | | | | | i) Daylight while die open | | | | | | | | | | | | | | | | | | | | | | | (mm) | | |  | | | | | |
| j) Required stroke to remove part from lower die | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | (mm) | | |  | | | | | |
| k) Scrap removal with automation (if yes, specify where it have to dropt) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | Y | | | | N | |
| **LINE DATA** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| a) Centerline distance to next press (mm) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |
| b) Press only for automated production (no manual feeding from operator) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | Y | | | N | |
| **NOTE** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| **PRODUCTION** | | | | | | | | | |
| a) Day shifts: | |  | | b) Weekly working days: | | |  | | |
| **Parts to be produced:** | | | | | | | | | |
| No. | a) Description | | b) Avg. Lot | | c) Hourly production | d) Hourly efficiency | | e) Press cycle t.(s) | f) Material type |
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**Note:** if available please attach drawings

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| **FEEDING** | | | | | | | | | | | | | | | | |
| **Pre cutted blanks** | | | | | | a) Dimension | | | | b) Thickness | | | | | | |
| min. (mm) | | max. (mm) | | min. (mm) | | max. (mm) | | | | |
| Shapes | | c) Disk | | | |  | |  | |  | |  | | | | |
| d) Square | | | |  | |  | |  | |  | | | | |
| e) Shaped | | | | Attach drawing | | | |  | |  | | | | |
| **Stack feeding** | | | | | | | | | | | | | | | | |
| a) Material direct feeding | | | Y | N |  | | | | | | | | | | | |
| b) Feed from europallet | | | Y | N | c) Material exceed pallet edges | | | | | | | | | Y | | N |
| d) Feed from custom pallet | | | Y | N | e) Material exceed pallet edges | | | | | | | | | Y | | N |
| f) Other | | | Y | N |  | | | | | | | | | | | |
| **Note:** If more than one stack per pallet is fed, attach stacks positioning schema | | | | | | | | | | | | | | | | |
| **Material fed mode** | | | | | | | | | | | | | | | | |
| a) Manual stacking | | | Y | N | b) Forklift | | | | | | | | | Y | | N |
| c) Crane | | | Y | N | d) Transpallet | | | | | | | | | Y | | N |
| e) Other | | |  | | | | | | | | | | | | | |
| a) **Double sheet evacuation** | | | | | | | Automatic | | | Manual | | | | | | |
| **Band feed** | | | | | | | | | | | | | | | | |
| a) Cut to length | | | | | | | In line shear | | | Into 1st die | | | | | | |
| b) Material thickness | | | | | | | Min(mm) | | | Max(mm) | | | | | | |
| c) Blank wide | | | | | | | Min(mm) | | | Max(mm) | | | | | | |
| d) Feed step | | | | | | | Min(mm) | | | Max(mm) | | | | | | |
| e) Tilting shear | | | | | | | | | | | | | Y | | N | |
| **LUBRICATION** | | | | | | | | | | | | | | | | |
| **Lubricants:** | | | | | | | | | | | | | | | | |
| No: | a) Type | | | | | | | | b) Application | | | | | | | |
| 1 |  | | | | | | | | Upper | | Lower | Uniform | | | | |
| 2 |  | | | | | | | | Upper | | Lower | Uniform | | | | |
| 3 |  | | | | | | | | Upper | | Lower | Uniform | | | | |
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| **NOTE:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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