1.2 - TECHNICAL CARD

Model	
Serial number	90-0022
Year of Construction	2000

Nominal force	[kN]	3150
Structural yielding	[µm]	
Max. work height at max. stroke	[mm]	6,34

Mass	[kg]	44,500
Parts mass with alternate motion	[kg]	7211
Dynamic weight with die and max. speed	[daN]	57533

Min slide stroke	[mm]	250
Max slide stroke	[mm]	250
Number of strokes possible		1
Slide adjustment	[mm]	110

Minimum speed	[rpm]	18
Nominal speed	[rpm]	42
Max speed	[rpm]	54
Max linear velocity	[m/s]	0.71

Continuous energy at nominal speed	[kJ]	27.2
with flywheel irregularity	%	15
Total nominal energy	[kJ]	125,6

Continuous energy at minimum speed	[kJ]	4.2
with flywheel irregularity	%	15

Energy with single stroke at nominal speed	[kJ]	209
with flywheel irregularity	%	15

BRAKE Torque	[Nm]	17,400
CLUTCH Torque at 0.55 MPa	[Nm]	21500
Max insertions number at nominal speed	[i/min]	28
Max air pressure clutch	[MPa]	0.55
Air consumption for insertion at 0.55 MPa	[dm^3]	26,0
Number max. insertions	[i/min]	28
at max. speed with single blow	[rpm]	46

Stopping angle	[°]	
Stopping time	[ms]	
Safety distance	[mm]	

CLUTCH max. rotation speed	[rpm]	333
BRAKE max. rotation speed	[rpm]	333
FLYWHEEL max. rotation speed	[rpm]	333
CLUTCH-BRAKE min. pressure	[MPa]	0,6
CLUTCH-BRAKE max. pressure	[MPa]	0,5
Thickness of new friction lining + support	[mm]	8,92-9
Thickness of min. friction lining + support	[mm]	3,5
Lining-plate play for two opposing surfaces	[mm]	1.12-1.2
Max. play (restore travel)	[mm]	5.5
Min. play (unwanted couplings)	[mm]	0,6

Bedplate dimensions (X x Y)	[mm]	2000
	[mm]	1400
Slide flange dimensions (X x Y)	[mm]	2000
	[mm]	1150
Max. die dimensions (X x Y)	[mm]	1900
	[mm]	1150

Die closed max height at max stroke	[mm]	600
Upper 1/2 die max mass	[kg]	4500
Max width blanks from feeder	[mm]	900

Number balancers		2
Max pressure balancers	[MPa]	0,75
Min pressure balancers	[MPa]	0,4
Max extractor stroke	[mm]	
Front passage (at oil recovery tank)	[mm]	1868
Lateral passage	[mm]	900
Stopping point		
Min pressure compressed air	[MPa]	0,5
Min. diameter air inlet	["]	1

Guides clereance	[mm]	0,05
Driving torque cone clamping element (flywheel shaft) TLK 200 120x165	[Nm]	145
Driving torque cone clamping element (transmission shaft) TLK 400 120x165	[Nm]	
Driving torque cone clamping element (slide adjustment) TLK500 24x55	[Nm]	
Driving torquebelt tensioner screw	[Nm]	

LpAeq with single stroke	[dB(A)]	77,0
LpCpeak with single stroke	[dB(C)]	102
Noise level power with single stroke	[dB]	103
LpAeq continuous	[dB(A)]	72
LpCpeak continuous	[dB(C)]	92
Noise level power continuous	[dB]	

Clutch air reservoir capacity	[dm³]	50
Balancing cylinders air reservoir capacity	[dm³]	2X100
Lubrication oil reservoir capacity	[dm³]	110

Panel feed voltage ± 10%	[V]	380
Min installed power	[kVA]	40
Frequency ± 1%	[Hz]	50
Min section feed wires	[mm²]	25

Control motor power	[kW]	32
Feed voltage ± 10%	[V]	380
Nominal current	[A]	60
Frequency ± 1%	[Hz]	50
Motor rotation speed	[rpm]	2000

Slide adjustment self-braking motor power	[kW]	2,2
Feed voltage ± 10%	[V]	380
Nominal current	[A]	5,7
Frequency ± 1%	[Hz]	50
Motor rotation speed	[rpm]	1450

Lubrication motor power	[kW]	0,09
Feed voltage ± 10%	[V]	380
Nominal current	[A]	0,84
Frequency ± 1%	[Hz]	50
Motor rotation speed	[rpm]	1380

Angle to stop the slide at 12 mm from B.D.C. (down stroke) with max die mass		
new brake	[°]	
worn brake	[°]	