## TECHNICAL CHARACTERISTICS

CHAPTER 1°

## 1.2 - TECHNICAL CARD

Model	,	{	
Serial number	90-0022 2000		
Year of Construction		2000	
Total of Total			
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	
		<del></del>	
Min slide stroke	[mm]	250	
Max slide stroke	[mm]	250	
Number of strokes possible		1	
Slide adjustment	[mm]	110	
		<del></del>	
Minimum speed	[rpm]	18	
Nominal speed	[rpm]	42	
Max speed	[rpm]	5/4 0.71	
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]	402	
with flywheel irregularity	%	15	
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Energy with single stroke at nominal speed	[kJ]	209	
with flywheel irregularity	%	15	
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CLUTCH Torque at 0.55 MPa  Max insertions number at nominal speed  Max air pressure clutch  Air consumption for insertion at 0.55 MPa  Number max. insertions  at max. speed with single blow  Stopping angle  Stopping time  Stopping time  CLUTCH max. rotation speed  EXAME max. rotation speed  FLYWHEEL max. rotation speed  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE max. pressure  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE min. friction lining + support  Thickness of new friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  Bedplate dimensions (X x Y)  [mm]  1/4 00  [mm]  Imm]  Solide flange dimensions (X x Y)  [mm]  Imm]		T	
Max insertions number at nominal speed [i/min] 2.8  Max air pressure clutch [MPa] 0.55  Air consumption for insertion at 0.55 MPa [i/min] 2.6  Number max. insertions [i/min] 2.6  At max. speed with single blow [rpm] 4.6  Stopping angle [°]  Stopping time [mm]  CLUTCH max. rotation speed [rpm] 323  BRAKE max. rotation speed [rpm] 323  FLYWHEEL max. rotation speed [rpm] 323  CLUTCH-BRAKE min. pressure [MPa] 0,6  CLUTCH-BRAKE max. pressure [MPa] 0,5  Thickness of new 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] 1.400  Slide flange dimensions (X x Y) [mm] 2000  [mm] 1.500	BRAKE Torque	[Nm]	
Max air pressure clutch Air consumption for insertion at 0.55 MPa  Number max. insertions at max. speed with single blow  Stopping angle Stopping time Safety distance  CLUTCH max. rotation speed BRAKE max. rotation speed FLYWHEEL max. rotation speed FLYWHEEL max. rotation speed CLUTCH-BRAKE min. pressure CLUTCH-BRAKE min. pressure MPal CLUTCH-BRAKE min. pressure Imml Safety Clutch max. rotation speed Flywheel max. rotation speed Imml Safety Imml Safety Imml Safety Imml Safety Imml Safety Imml Safety Imml Inickness of new friction lining + support Inickness of min. friction lining + support Ining-plate play for two opposing surfaces Max. play (restore travel) Imml Inickness	CLUTCH Torque at 0.55 MPa	- <del></del>	
Max air pressure clutch Air consumption for insertion at 0.55 MPa Number max, insertions It max, speed with single blow  Stopping angle Stopping time Safety distance  CLUTCH max, rotation speed BRAKE max, rotation speed FLYWHEEL max, rotation speed FLYWHEEL max, rotation speed CLUTCH-BRAKE min, pressure FLUTCH-BRAKE min, pressure FLYCH-BRAKE min, pressure FLYCH-BRAKE min, pressure Imma 3.33  CLUTCH-BRAKE min, pressure Imma 3.55  Thickness of new friction lining + support Ining-plate play for two opposing surfaces Max, play (restore travel) Min, play (unwanted couplings)  Bedplate dimensions (X x Y)  [mm] 2000 [mm] 1.50  Slide flange dimensions (X x Y) [mm] 2000 [mm] 1.50  Slide flange dimensions (X x Y) [mm] 1.50  [mm] 1.50	Max insertions number at nominal speed	[i/min]	
Air consumption for insertion at 0.55 MPa  Number max. insertions  at max. speed with single blow  Stopping angle  Stopping angle  Stopping time  Safety distance  CLUTCH max. rotation speed  BRAKE max. rotation speed  FLYWHEEL max. rotation speed  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE max. pressure  MPal  6.5  Thickness of new friction lining + support  Thickness of min. friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  Slide flange dimensions (X x Y)  [mm]  1.5  [mm]  1.6  [m			
Number max. insertions at max. speed with single blow [rpm] 46  Stopping angle [°] [ms] [ms] Safety distance [mm] [rpm] 323  BRAKE max. rotation speed [rpm] 323  FLYWHEEL max. rotation speed [rpm] 323  CLUTCH-BRAKE min. pressure [MPa] 0,6  CLUTCH-BRAKE max. pressure [MPa] 0,5  Thickness of new friction lining + support [mm] 3,75  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] 2,000  Slide flange dimensions (X x Y) [mm] 1,1500	Air consumption for insertion at 0.55 MPa	[dm <sup>3</sup> ]	
Stopping angle Stopping time Safety distance  CLUTCH max. rotation speed  BRAKE max. rotation speed  FLYWHEEL max. rotation speed  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE min. pressure  MPal  CLUTCH-BRAKE max. pressure  [MPa]  C,5  Thickness of new friction lining + support  Thickness of min. friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  Bedplate dimensions (X x Y)  [mm]		[i/min]	
Stopping angle Stopping time Safety distance  CLUTCH max. rotation speed  BRAKE max. rotation speed FLYWHEEL max. rotation speed FLY	at max. speed with single blow	[rpm]	16_
Stopping time  Stopping time  Safety distance  CLUTCH max. rotation speed  BRAKE max. rotation speed  FLYWHEEL max. rotation speed  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE max. pressure  [MPa] 0,6  CLUTCH-BRAKE max. pressure  [MPa] 0,5  Thickness of new friction lining + support  Thickness of min. friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  Bedplate dimensions (X x Y)  [mm] 2000  Slide flange dimensions (X x Y)  [mm] 1/450  [mm] 1/450			
Stopping time [ms] Safety distance [mm]  CLUTCH max. rotation speed [rpm] 323 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] 8,12-9 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 Slide flange dimensions (X x Y) [mm] 14500	Stopping angle	[°]	
Safety distance [mm]  CLUTCH max. rotation speed [rpm] 323  BRAKE max. rotation speed [rpm] 323  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  Slide flange dimensions (X x Y) [mm] 1.150		[ms]	
CLUTCH max. rotation speed [rpm] 323 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] 8,72-9 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 Slide flange dimensions (X x Y) [mm] 1450		[mm]	
BRAKE max. rotation speed  FLYWHEEL max. rotation speed  FLYWHEEL max. rotation speed  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE max. pressure  [MPa] 0,6  CLUTCH-BRAKE max. pressure  [MPa] 0,5  Thickness of new friction lining + support  [mm] 8,42-9  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  Bedplate dimensions (X x Y)  [mm] 2000  Slide flange dimensions (X x Y)  [mm] 1/400  [mm] 1/50			
BRAKE max. rotation speed  FLYWHEEL max. rotation speed  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE min. pressure  [MPa] 0,6  CLUTCH-BRAKE max. pressure  [MPa] 0,5  Thickness of new friction lining + support  Thickness of min. friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  [mm] 2,6  Bedplate dimensions (X x Y)  [mm] 2,6  Slide flange dimensions (X x Y)  [mm] 1,50  [mm] 1,50	CLUTCH max. rotation speed	[rpm]	333
FLYWHEEL max. rotation speed  CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE max. pressure  CLUTCH-BRAKE max. pressure  Thickness of new friction lining + support  Thickness of min. friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  [mm] 5.5  Bedplate dimensions (X x Y)  [mm] 2000  Slide flange dimensions (X x Y)  [mm] 1/500		[rpm]	333
CLUTCH-BRAKE min. pressure  CLUTCH-BRAKE max. pressure  [MPa] 0,6  CLUTCH-BRAKE max. pressure  [MPa] 0,5  Thickness of new 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] 1400  Slide flange dimensions (X x Y)  [mm] 1.50		[rpm]	
CLUTCH-BRAKE max. pressure  [MPa] 0,5  Thickness of new friction lining + support  [mm] 3,5  Thickness of min. friction lining + support  [mm] 3,5  Lining-plate play for two opposing surfaces  [mm] 1.12-1.2  [mm] 5.5  [mm] 0,6  Bedplate dimensions (X x Y)  [mm] 2000  [mm] 1400  Slide flange dimensions (X x Y)  [mm] 1.150		[MPa]	
Thickness of new friction lining + support  Thickness of min. friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  [mm] 5.5  [mm] 5.5  [mm] 0.6  Bedplate dimensions (X x Y)  [mm] 2000  [mm] 1400  Slide flange dimensions (X x Y)  [mm] 1/50		[MPa]	0,5
Thickness of min. friction lining + support  Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  [mm] 5.5  [mm] 6,6  Bedplate dimensions (X x Y)  [mm] 2000  [mm] 1400  Slide flange dimensions (X x Y)  [mm] 1/50		[mm]	8,42-9
Lining-plate play for two opposing surfaces  Max. play (restore travel)  Min. play (unwanted couplings)  [mm] 5.5  [mm] 5.6  Bedplate dimensions (X x Y)  [mm] 2000  [mm] 1/400  Slide flange dimensions (X x Y)  [mm] 1/50		[mm]	3,5
Max. play (restore travel)  Min. play (unwanted couplings)  [mm] 5.5  [mm] 6,6  Bedplate dimensions (X x Y)  [mm] 2000  [mm] 1400  Slide flange dimensions (X x Y)  [mm] 1/50		[mm]	1.12-1.2
Min. play (unwanted couplings)  [mm] 0,6  Bedplate dimensions (X x Y)  [mm] 1400  Slide flange dimensions (X x Y)  [mm] 1/50		[mm]	5.5°
Bedplate dimensions (X x Y)       [mm]       2000         [mm]       1400         Slide flange dimensions (X x Y)       [mm]       2000         [mm]       1150		[mm]	_0,6
[mm]	Trian pic (annual con page 5)		
Slide flange dimensions (X x Y)   [mm]   1450   [mm]   1450	Bedplate dimensions (X x Y)	[mm]	2000
Slide flange dimensions (X x Y)  [mm] 2000  [mm] 1/50	, , , , , , , , , , , , , , , , , , ,	[mm]	1400
[mm] //50	Slide flange dimensions (X x Y)	[mm]	
	The same same same same same same same sam	[mm]	1150
	Max. die dimensions (X x Y)	[mm]	1900
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## TECHNICAL CHARACTERISTICS

Die closed max height at max stroke	[mm]	600
Upper 1/2 die max mass	[kg]	4500
Max width blanks from feeder	[mm]	900
		-7
Number balancers	D (D . ]	2000
Max pressure balancers	[MPa]	0)/3
Min pressure balancers	[MPa]	-94
Max extractor stroke	[mm]	
Front passage (at oil recovery tank)	[mm]	1868
Lateral passage	[mm]	900
Stopping point		
Min pressure compressed air	[MPa]	05
Min. diameter air inlet	["]	/
Guides clereance	[mm]	0.05
Driving torque cone clamping element (flywheel shaft)		_0,05 145
TLK 200 120x165	[Nm]	
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)]	17,0
LpCpeak with single stroke	[dB(C)]	/02
	[dB]	103
Noise level power with single stroke	[dB(A)]	72
LpAeq continuous	[dB(C)]	92
LpCpeak continuous	1	
Noise level power continuous	[[dB]	
Clutch air reservoir capacity	[dm³]	50
Balancing cylinders air reservoir capacity	[dm³]	$2\times/00$
Lubrication oil reservoir capacity	[dm³]	110

## TECHNICAL CHARACTERISTICS

CHAPTER 1°

Panel feed voltage ± 10%	[V]	3 <i>8</i> 0
Min installed power	[kVA]	40
Frequency ± 1%	[Hz]	50
Min section feed wires	[mm²]	25
Control	[kW]	32
Control motor power	[V]	
Feed voltage ± 10%		380
Nominal current	[A]	60
Frequency ± 1%	[Hz]	
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]	2 80
Nominal current	[A]	Q 84
Frequency ± 1%	[Hz]	50
Motor rotation speed	[rpm]	1380
		••
Angle to stop the slide at 12 mm from B.D.C. (dow	n stroke) with m	ax die mass
new brake	[°]	· · · · · · · · · · · · · · · · · · ·
worn brake	[°]	