

Minster PM2-100-48 Straight Side Eccentric Shaft High Speed Press

New 1980 - Remanufactured 2003
Nidec Press & Automation Stock #100249P



Photos of actual press, prior to removal

Press Specifications:

Features:

Tonnage, Heavy Duty Rating:100 tons
 Stroke:1.00"
 Shut height, on bed SDAU:20.12"
 Slide Adjustment:2.00"
 Area of Slide R-L x F-B:48.00" x 20.50"
 Area of Bolster R-L x F-B:48.00" x 32.00"
 Area of Bed R-L x F-B:48.00" x 32.00"
 Distance, Floor to Top of Bed:38.00"
 Distance Between Gibs, to Clear:50.00"
 Opening in Upright:15.00"
 Speed (Full Energy above 300SPM):0 - 900 SPM
 Drive Motor/HP:40/1800
 Incoming Voltage:480VAC/60hz/3ph
 Overall Height:156.00"
 Overall Height, motor/guard removed:134.00"
 Approximate Press Weight:31,400 lbs.

Left hand drive with extension on opposite end
 Flywheel type
 Flywheel and belt drive enclosed with protective cover
 Minster Hydraulic Clutch and Brake
 Air Operated flywheel brake electrically interlocked
 Frame of cast four piece tie rod construction
 Minster air operated friction clutch and brake
 Minster "Monitorflow" recirculating oil lubrication system
 Long barrel type manual slide adjustment arranged for detachable
 air operated wrench
 Eight adjustable bronze lined gibs, F and B Includes
 hydrostatic gibs
 Auxiliary locking arrangement on each connection screw
 Minster integral dynamic balancing unit located on top of press
 which will permit operating up to full speed without being bolted
 down. Balancing unit is based on upper die weight of 500 lbs.
 Sump Oil Heater - Controlled by PMC

Note: All specifications contained herein are as the machine was originally manufactured and are subject to change at time of inspection.

Price, FCA Ohio:On Request

Contact:

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Corporate Office

240 West Fifth Street • Minster, OH 45865
 (419) 628-2331
www.nidec-pa.com

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ELECTRICAL CONTROL

MINSTER CENTRALIZED MOTOR AND CLUTCH CONTROL PANEL, NEMA Type 12 enclosure, built to MINSTER'S interpretation of ANSI – B11.1, and to NFPA Specifications.

Main panel contains the Minster Production Management Control with a fused disconnect, reversing drive starter.

Main panel also includes Minster Eddy Current drive motor controller, speed control, and speed indicator. Includes torque limit controller.

Main control panel located in pedestal located off right hand front of press. Pedestal has standpipe and 6 ft. of flexible overhead conduit to swivel box on front of crown. (Customer's power drop to be to pedestal.) Distance from bottom of press foot to centerline of overhead conduit to be approximately 129".

Set-up units located on operator's pedestal include:

- Power Off-On Locking Selector Switch
- Supervisory Control Lock Selector Switch
- Clutch Selector Switch to select Inching, Set-Up Cycle, or Continuous Operation.
- Continuous Arm Illuminated Button
- Set-Up Cycle Arm Illuminated Pushbutton
- Master Stop Button
- Top Stop Button
- Stop Button

NOTE:

The **SETUP CYCLE** mode is a means of single cycling the press slide for die setup and stock threading purposes. It is not intended for production purposes.

Includes preset slow start and inch speed controls.

MINSTER PRODUCTION MANAGEMENT CONTROL includes the following features:

- Color Touch Screen
- Allen Bradley SLC 504/C PLC
- 16-Pole Programmable Limit Switch
- Brake Monitor / Press Stopping Time Readout
- 75 Tool Storage Capacity with 7-Digit Alpha Numeric I.D. Codes
- System Prompts and Diagnostic Messages
- Press Lubrication System Indicators
- Motor Start/Stop Control
- Motor Forward/Reverse Control
- Motor Speed Control
- Motor Speed and Load Display
- Dual Clutch Valve Monitor
- Stock Lubricator Interface Output
- Auxiliary output interface for secondary control elements
 - 2nd blowoff
 - lubricator
 - diverter tables, etc.
- Blowoff Valve Interface Output
- Production Counters
 - Totalizers
 - Preset/Batch
- Maintenance Reminders
 - Activated by Predetermined Hours
 - Clutch Engagements
 - Number of Parts Made
- Press Lifetime Production Record
 - Hours
 - Cycle
 - Clutch Engagements
- Minster PMConnect Production Monitoring System Interface capability
- Relay Based Primary Machine Control
- PMC 16 Channel Die Protection Module
- PMC 2 Channel Load Monitor

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Photo of actual machine

Vamco Q250 High Speed Electronic Roll Feed

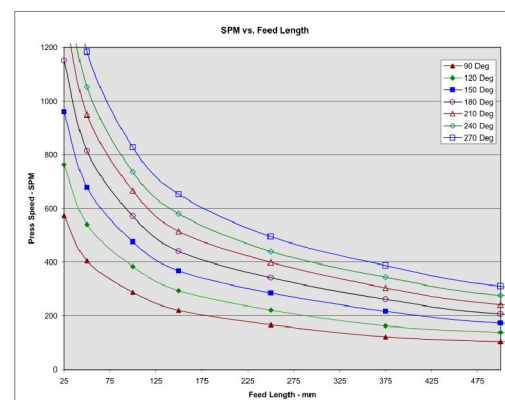
Maximum material width:250 mm
Maximum material thickness:4 mm
Maximum indexes/minute:1800/min
Maximum feed speed:155m/min

Quantum 250-65-75

Feed Length (mm)	Feed Angle						
	90 Deg	120 Deg	150 Deg	180 Deg	210 Deg	240 Deg	270 Deg
25	573	764	960	1152	1200	1200	1200
50	405	540	679	815	950	1052	1184
100	288	354	476	572	657	736	828
150	221	294	368	441	515	580	653
250	167	222	286	342	399	440	495
375	122	162	218	261	305	344	387
500	104	138	173	207	242	276	311
750	84	112	140	168	196	220	248
1000	83	84	105	126	147	168	189

Features:

- User friendly Graphical Operating System
- Programmable Variables
 - Feed Length
 - Feed Angle
 - Roll Separation Amount
 - Roll Separation Angle
 - Material Grip Force
 - Material thickness
- Servo Controlled Pilot Release
- Remote Pendant
- Automatic pilot Timing Set Up



Formulas for derating speed chart for material effects

$$\text{SPM} = \frac{\text{Value From Chart}}{\text{SQRT}(1 + (.212 \times \text{Wt}))}$$

Wt = weight of material in kg
Wt = .012 x Th x Th x Wd
Th = material thickness in mm
Wd = material width in mm