



## Rebuilt Minster E2-400-84 Straight Side Press

New 1992 – To be rebuilt 2019  
Nidec Press & Automation Stock #100326P

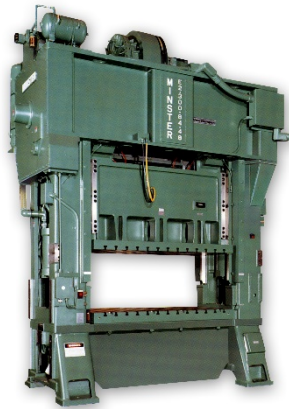


Photo of similar machine

### Press Specifications:

- 400 U.S. Tons Capacity (3559 kN)
- 2.00 in. Stroke (51 mm)\*
- 3.00 in. Slide Adjustment (76 mm)
- 24.25 in. Shutheight, SDAU, on Bed (616 mm)\*
- 84.00 x 54.00 in. Slide Area (2134 mm x 1371 mm)
- 84.00 x 54.00 in. Bed Area (2134 mm x 1371 mm)
- 66.50 x 25.00 in. Bed Opening (1689 mm x 635 mm)
- 86.00 in. Between Gibs (2184 mm)
- 42.00 in. Upright Opening (1067 mm)
- 58.00 in. Floor to Top of Bed (1473 mm)
- 0 - 120 SPM\*
- 75 HP Drive Motor\*
- Incoming Voltage as required\*
- 134,000 lbs. Approx. Weight, Press Only (60,900 kg)

\* changeable at rebuild

### Equipped With:

- Single Geared, Extension on both sides
- Minster Combination Air Clutch & Brake
- Air Operated Flywheel Brake, electrically interlocked
- Power off Manual Bumping
- Recirculating Lubrication System
- Long Barrel Manual Shutheight Adjustment\*
- Double Lockup
- Variable Frequency Drive
- Minster Production Management Control
  - 18" Color Touch Screen
  - 16 Pole PLC
  - 200 Tool Storage Capacity
  - Production Counters
  - PMC 4 Channel Load Monitor
  - PMC 16 Channel Load Monitor
  - PMC Automatic Counterbalance Adjustment

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

Price, FCA Minster, OH: ..... Price On Request

### Contact:

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### Nidec Press & Automation

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### Electrical Control Upgrade

#### Main Control Pedestal

Includes:

- MINSTER Ergonomically Designed Pedestal Enclosure
- Paint Color – Standard Minster Color Choice
- Main Fused Disconnect Switch
- Drive, Lubrication, and Slide Adjust Motor Starters and Fuses for 480-3-60V
- Eddy Current Motor Control Components for a 40 HP 480V Motor
- Supply voltage 480/3/60
- Production Management Control (PMC) System
- English Language Operator Interface Screen
- Operator Controls Located on Pedestal Top Include:
  - Clutch Function Selector Switch for Inch, Set-Up, and Continuous Operation
  - Power: Off/On Locking Selector Switch
  - Function Enable Light
  - PMC Supervisory Control Selector Switch
  - Two Guarded Run buttons
  - Continuous Arm & Ready Illuminated Button
  - Inch Control Buttons
  - Top Stop Button
  - Stop Control Button
  - Master Stop Button
- (2) Die Safety Block Receptacles to be mounted on side of cabinet.

#### Press Mounted Components

To be furnished new by Minster to include (4) Stop Control Buttons, and (2) safeguarding interlock connections. If safeguarding is purchased with the press, these connection are removed and the safeguarding is hard wired to the press.

**Note:** Customer to wire components & supply NEMA enclosure, mounting hardware, and fittings for components.

#### Suggested Locations

L.H. Front Upright

Following components to be located on L.H. Front Upright includes:

- (1) Stop Control Button

#### Suggested Locations (cont'd)

R.H. Front Upright

Following components to be located on R.H. Front Upright:

- (1) Stop Control Button
- (1) Safeguard interlock connection

R.H. Rear Upright

Following components to be located on R.H. Rear Upright:

- (1) Stop Control Button

L.H. Rear Upright

Following components to be located on L.H. Rear Upright:

- (1) Stop Control Button
- (1) Safeguard interlock connection

#### Resolver/Limit Switch

The Minster PMC control and the included Programmable Limit Switch board requires an AMCI resolver to complete the programmable limit switch system. If the existing press does not currently have an AMCI resolver, please select this option. Included components:

- (1) AMCI Resolver
- (1) Resolver Cable
- (1) Resolver Mounting Bracket and Drive Assembly

#### Clutch Valve

A new dual clutch valve will be supplied to include valve detector switches.

#### VFD Controls

Includes a (Press Duty) variable frequency motor, an ABB variable frequency drive control mounted in a NEMA enclosure, high speed fuses with holders, shielded motor cable, ground bushing, control cable, relay, suppressor and labels. This standard diagram along with the provided ABB manual and ABB start-up instructions gives the necessary information to allow customers to install the drive onto the press.

The standard warranty for the ABB Drive is one (1) year. The warranty may be extended by an additional one (1) year if Minster Customer Service commissions the drive at startup. Minster's ABB certified servicemen along with Minster's experience for commissioning the ABB drive per specific press type allows for this extended warranty.



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### Minster Production Management Control (PMC) Upgrade

#### **Production Management Control (PMC) Operator's Interface.**

Includes the Following Features:

- 18" Color Touch Screen
- Allen Bradley CompactLogix PLC
- 16-Pole Programmable Limit Switch
- Brake Monitor/Press Stopping Time Readout
- 200 Tool Storage Capacity with 24-Digit Alpha Numeric I.D. Codes
- System Prompts and Diagnostic Messages
- Lube Pump On/Off Indicator
- Slide Adjust Up/Down Control
- Motor Start/Stop Control
- Motor Speed Control
- Motor Speed and Load Display
- Dual Clutch Valve Monitor
- Stock Lubricator Interface Output
- Blowoff Valve Interface Output
- Auxiliary output interface for secondary control elements (2<sup>nd</sup> blowoff, lubricator, diverter tables, etc.)
- Production Counters - Totalizers/Preset/Batch
- Maintenance Reminders - Activated by Predetermined Hours or Clutch Engagements, or Number of Parts Made
- Press Lifetime Production Record - Hours/Cycles/Clutch Engagements
- Relay Based Primary Machine Control

**Die Protection** module features sixteen (16) independent, high-speed inputs which can detect event changes within 1 degree at speeds up to 1800 SPM. Protects your press and tool investment by greatly reducing or eliminating costly die crashes. AutoTune die protection comes standard with the Die Protection option, and allows for automatic setup of sensor parameters. Provides actual position of sensor turn-on and off, and compensates for process variation as the job is run.

**Automatic Counter Balance** sets counterbalance pressure to the predetermined tool storage value based on pneumatic pressure or tool weight.

**Automatic Counter Balance** sets counterbalance pressure to the predetermined tool storage value based on pneumatic pressure or tool weight.

**Load Monitor** displays press tonnage at designated press uprights and allows for tonnage alarm settings. Provides trend analysis enabling improved quality through part-to-part tonnage monitoring. Also maintains a history of peak overloads and records maximum tonnages for all channels.



Photo of similar device