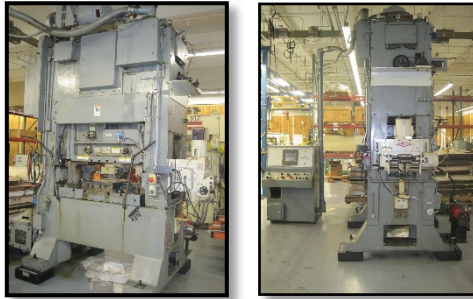




## Minster PM2-100-48 Straight Side High Speed Press

New 1980 – Remanufactured 2003

NPA Stock #100249P - s/n 24701



Photos of actual machine

### Press Specifications:

- 100 U.S. Tons Capacity (890 kN)
- 1.00 in. Stroke (25 mm)
- 2.00 in. Slide Adjustment (51 mm)
- 20.12 in. Shutheight, SDAU, on Bed (511 mm)
- 48.00 x 20.50 in. Slide (1219 mm x 521 mm)
- 48.00 x 32.00 in. Bed Area (1219 mm x 813 mm)
- 38.00 in. Distance, Floor to Top of Bed (965 mm)
- 50.00 in. Between Gibs (1270 mm)
- 15.00 in. Upright Opening (381 mm)
- 0 – 900 SPM (full energy above 300 spm)
- 40 HP, 1800 RPM Drive Motor (28.83 kW)
- 480 VAC, 60 hz, 3 ph incoming power
- 156.00 in. Overall Height (3962 mm)
- 134.00 in. Motor/guard removed (3404 mm)
- 31,400 lbs. Approximate Press Weight (14,243 kg)

### Equipped With:

- Flywheel Type
- Left hand drive with extension on opposite end
- Minster Hydraulic Clutch and Brake
- Air Operated flywheel brake electrically interlocked
- Frame of cast four piece tie rod construction
- 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, Ex Works, Minster, OH: ..... Price On Request

### Contact:

Richard S. Ruck, Used Equipment Manager  
567-644-5037 • richard.ruck@nidecpa.com

### Nidec Press & Automation

240 West Fifth Street  
Minster, OH 45865  
419-628-2331 • [www.nidecpa.com](http://www.nidecpa.com)



## Minster PM2-100-48 Straight Side High Speed Press

New 1980 – Remanufactured 2003

NPA Stock #100249P - s/n 24701

### 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

**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



### Minster PM2-100-48 Straight Side High Speed Press

New 1980 – Remanufactured 2003

NPA Stock #100249P - s/n 24701



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

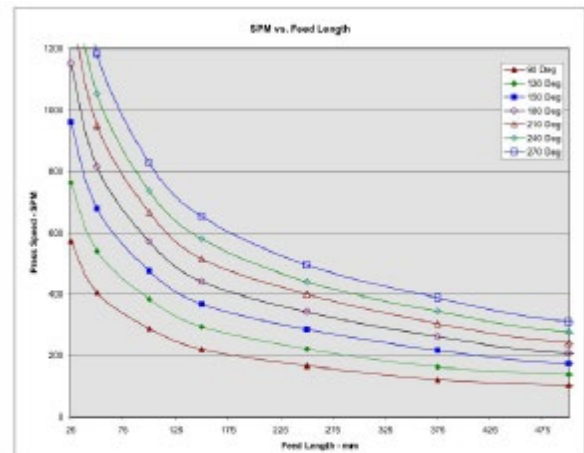
Maximum feed speed: ..... 155m/min

#### 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

#### Quantum 250-65-75

Feed Length (mm)	Feed Angle						
	90 Deg	120 Deg	150 Deg	180 Deg	210 Deg	240 Deg	270 Deg
25	57.5	105	149	193	237	281	325
50	42.5	78.5	112	146	180	214	248
75	33.5	61.5	86	110	134	158	182
100	27.5	51.5	71	91	111	131	151
125	23.5	44.5	61	78	95	112	129
150	20.5	39.5	53	68	83	98	113
175	18.5	36.5	48	61	74	87	100
200	17.5	34.5	45	57	69	81	93
225	16.5	33.5	43	54	65	76	87
250	16.5	33.5	43	54	65	76	87



Formulas for deriving speed chart for material effects

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

Wt = weight of material in kg  
 $Wt = .012 \times Th \times Th \times Wd$   
 Th = material thickness in mm  
 Wd = material width in mm