



PRESS & AUTOMATION

USED MACHINERY



Minster PM2-100-48 Double Eccentric “Lamination” “Piece Maker” Straight Side High Speed Press

New 1981 – Remanufacture TBD

NPA Stock #100248P - s/n 24704



Photos of actual machine, prior to removal

Press Specifications:

- 125 U.S. Tons Capacity (1125 kN)
- 1.25 in. Stroke (32 mm)
- 2.00 in. Slide Adjustment (51 mm)
- 15.00 in. Shutheight, SDAU, on Bed (381 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 – 700 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
- Right hand drive with extension on opposite end
- Minster Air Operated 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.

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



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Pedestal Control Enclosure is ergonomically designed to include illuminated indicators and operator/set-up buttons as well as to use minimal floor space. Also included is the press motor and clutch control circuit with a disconnect switch. The pedestal is located on the right-hand side and is wired with rigid standpipe and flexible overhead conduit to junction box on front of crown.

Control Station Includes:

- Mounted on pedestal
- Clutch Selector Switch to select Control Operator Mode
- (Inch-Setup-Continuous)
- Power Off-On Locking Selector Switch
- Supervisory Control Lock Selector Switch
- Function Enable Illuminated Pushbutton

Set-up Station:

- Mounted on left hand upright. Facilitates material threading and die set-up and includes:
- Two Hand Inching Arrangement
- Stop Button

Run Station includes:

- Two Guarded Run Buttons to operate press
- Continuous Arm Illuminated Pushbutton
- Top Stop Button
- Stop Button
- Master Stop Button

Two (2) Die Safety Block Receptacles (less blocks) located on side of control pedestal

Clutch and Motor Control Circuits including pushbuttons, operate on 110 VAC from control transformer.

IEC High Voltage Control Components

Variable Frequency Press Drive Motor System New ABB 40HP variable frequency drive system. Features the latest in press drive technology with Auto-Tune Setup, improved torque response, and high efficiency throughout the operating speed range.

MINSTER PRODUCTION MANAGEMENT CONTROL includes the following features:

- High Resolution Industrial 15” Flat Panel Touchscreen Display with “Blind Node” PC
- Allen Bradley PLC Processor
- 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
- Motor Start/Stop/Speed/Load Control
- 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



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REBUILD PROFILE

- Unload press from carrier’s truck at the Minster, Ohio
- press remanufacturing facility.
- Dismantle press complete.
- Clean all parts.
- Inspect all parts and compare to original machining prints.
- Check main bearing bore alignment, bore concentricity, and inspect crown for fractures.
- Check slide adjusting nut seats for wear and galling.
- Check slide connection bores and wrist pin bores for proper dimensions and concentricity.
- Check crown and connection bearing cap locators and mating surfaces for proper fit.
- Inspect crankshaft for straightness and wear and oil polish bearing surfaces.
- Crankshaft will be checked for fractures using magnetic particle inspection process.
- Press tie rods will be checked for fractures.
- Submit quote for any additional parts or services, if required.
- Sand and prime paint major parts to prepare for finish paint.
- Re-machine slide to re-square. Includes new bronze wear plates.
- Regrind main and auxiliary gibs flat.
- Re-machine bed top flat.
- Refit main bearing caps and align bore crown.
- Includes adding lip type seals to main bearing end caps.
- Refit connection caps and re-bore connections.
- Includes modification of connection lubrication system to provide increased oil flow to upper connection bushing and wrist pin bushing
- Replace all bronze bearings to latest **MINSTER** specifications and assembly fitting procedures.
- Replace all seals and taper and roller bearings.

REBUILD PROFILE(cont’d)

- Refit connection caps and rebore connections. Includes modification of connection lubrication system to provide increased oil flow to upper connection bushing and wrist pin bushing
- Rebuild clutch and brake assemblies, replacing all normal wear parts and the parts.
- Rebuild press lubrication system. Includes all new tubing, hoses and fittings.
- Rebuild dynamic balancer.
- Install new press pneumatic system. Includes all new hoses and fittings. Existing clutch air tank will be used.
- Rebuild flywheel brake assembly.
- Reassemble press to **MINSTER** specifications applicable to press type.
- Provide and install new press electrical controls.
- Install new 40 HP variable frequency drive motor system for 480-3-50 operation.
- Test and run-in press.
- Perform final inspection and record results.
- Paint press to customer’s specifications.
- Install new English language legend plates and warning tags. Includes safety lockout tag.
- Load press on truck for transport to designated location.
- Record all work performed and any parts added, changed, or updated, and place in the existing permanent press record for future reference.

Total price includes new listed mechanical parts, re-machining and reconditioning existing parts covered in profile, painting, labor, unloading and reloading press on truck, in our plant.

Price does not include press tear down or startup supervision in customer's plant.



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MINSTER.

REMANUFACTURED EQUIPMENT WARRANTY

EFFECTIVE ON ALL EQUIPMENT SHIPPED AFTER JANUARY 1, 2013

Nidec Minster Corporation provides the original purchaser (the “Purchaser”) with the following warranties for **new** parts and components **only** provided with an equipment rebuild:

2 Year New Major Parts Warranty

Minster promises to the Purchaser, to repair, or, at Minster’s option, replace any new mechanical part that proves to be defective in material or workmanship under normal use within two years of the original date of shipment from the Minster plant. Minster will provide all parts necessary to correct such defects. All labor, diagnosis and travel costs incurred by Minster in connection with any repair or replacement covered by this 2 Year Mechanical Parts Warranty for defects occurring during the first year following the original date of shipment from the Minster plant shall be paid by Minster; for defects occurring thereafter, all labor, diagnosis and travel costs shall be paid by the Purchaser.

1 Year New Electrical, Pneumatic and Hydraulic Parts Warranty

Minster promises to the Purchaser, to repair, or, at Minster’s option, replace any electrical, pneumatic or hydraulic part that proves to be defective in material or workmanship under normal use within one year of the original date of shipment from the Minster plant. Minster will provide all parts necessary to correct such defects. All labor, diagnosis and travel costs incurred by Minster in connection with any repair or replacement covered by this 1 Year Electrical, Pneumatic and Hydraulic Parts Warranty shall be paid by Minster.

Limitations and Exclusions

“Normal use” shall mean use within rated capacities, at the correct voltage with normal maintenance and operation in accordance with the applicable service and operating manuals. This warranty does not apply to (i) any equipment that has been altered or modified in any way by the Purchaser or anyone else other than an authorized service employee of Minster; (ii) any part or component not manufactured or designed by Minster; or (iii) any part that is subject to wear or consumption, such as filters, clutch and brake linings, wear surfaces (gibs, sliding or rotating bearings, etc.), feed rolls, scrap cutter blades, lubricants and relays. For parts or components not manufactured or designed by Minster, the Purchaser shall have only the warranty provided by the manufacturer of such part or component, a copy of which warranty will be provided to the Purchaser on request.

All costs for rigging, dismantling and reassembling the equipment, together with any building modifications required for any repair or replacement covered by this Warranty shall be the responsibility of the Purchaser. Minster’s obligations under the terms of the Warranty (but not the duration thereof) shall be suspended during any period when the Purchaser is in default of any obligation to Minster, regardless of whether the default is related to the equipment or any other matter.

EXCEPT AS SET FORTH HEREIN, IT IS EXPRESSLY AGREED THAT THERE IS NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, NOR OTHER WARRANTY, EXPRESS, IMPLIED OR STATUTORY, NOR ANY AFFIRMATION OF FACT OR PROMISE BY MINSTER WITH REFERENCE TO THE EQUIPMENT.

IN NO EVENT SHALL MINSTER BE LIABLE FOR ANTICIPATED PROFITS OR FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES. MINSTER’S LIABILITY ON ANY CLAIM OF ANY KIND, FOR ANY LOSS OR DAMAGE ARISING OUT OF, CONNECTED WITH OR RESULTING FROM THE DESIGN, MANUFACTURE, SALE, REPAIR OR OPERATION OF THE WARRANTED EQUIPMENT SHALL IN NO CASE EXCEED THE PRICE ALLOCABLE TO THAT EQUIPMENT OR THE PART THEREOF WHICH GIVES RISE TO THE CLAIM. THE ABOVE WARRANTY CONSTITUTES THE SOLE AND EXCLUSIVE REMEDY OF THE PURCHASER. MINSTER SHALL NOT BE LIABLE FOR PENALTIES OF ANY DESCRIPTION.