



PRESS & AUTOMATION

USED MACHINERY



Remanufactured Minster 90-1200 Knuckle Press

Reman 2020 – 2 available

NPA Stock #100335P

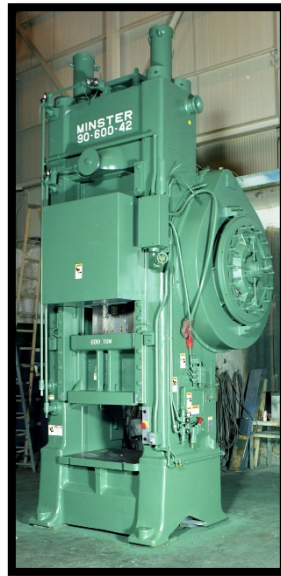


Photo of typical *Minster* knuckle press

Press Specifications:

- 1200 U.S. Tons Cap. at bottom of stroke (10,676 kN)
- 6.00 in. Stroke (152 mm)
- 0.50 in. Slide Adjustment (13 mm)
- 38.00 in. width between Uprights (965mm)
- 31.50 in. width between Gibs (800 mm)
- 30.25 in. Shutheight, SDAU, on Bed (768 mm)
- 21.00 x 13.25 in. Slide Area (533 mm x 794 mm)
- 40.00 x 38.00 in. Bed Area (1016 mm x 965 mm)
- 1.12 in. diameter Bed Opening (28 mm)
- 16 SPM
- 30 HP Drive Motor (22 kW)
- 480VAC/60Hz/3ph Incoming Voltage

Price, Ex Works, Minster, OH: Price On Request

Total price includes new listed mechanical parts, re-machining and reconditioning existing parts covered in profile, painting, labor, loading press on truck, in our plant. Price does not include startup supervision in customer's plant.

Contact:

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Remanufacture Scope of Work Profile:

- Unload press from carrier's truck in our plant.
- Dismantle press complete.
- Clean all parts.
- Inspect all parts and compare to original machining prints.
- Check upright crankshaft and driveshaft bores for proper alignment, dimensions and concentricity.
- Check all slide and knuckle parts to original machining prints.
- Inspect existing crankshaft for wear and straightness and oil polish bearing surfaces if necessary.
- Existing press tie rods will be tested by a qualified testing service and found to be free of fractures.
- Submit quote for any additional parts or services, if required.
- Prepare major parts for final paint.
- Re-machine slide to re-square.
- Regrind main and knuckle block gibs flat and parallel.
- Re-machine crown and top block.
- Re-machine slide adjusting wedge
- Re-machine bed top flat.
- Re-machine connection bores.
- Rebuild slide and knuckle assembly, replacing parts listed on following pages.
- Rebuild press drive system replacing all parts listed on following pages.
- Rebuild clutch/brake system replacing all normal wear parts and parts. (Non-Minster Clutch)
- Install new MINSTER press lubrication system.
- Rebuild counterbalance cylinders.
- Rebuild flywheel brake assembly.
- Install new 30 HP drive motor.
- Reassemble press to MINSTER specifications applicable to press type.
- Install new press pneumatic system. Original air tanks will be used.
- Test and run-in press.
- Perform final inspection and record results.
- Paint press (To Customer Specs.)
- Install new English Language legend plates and warning tags.
- Load press on truck for transport to designated location.
- Record all work performed and place in the existing permanent press record for future reference



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Included New Parts:

Slide & Knuckle Parts:

Connection Bushings
Bushings Pins
Knuckle Pins
Knuckle Pin Bushings
Block and Slide Pin Bushings
Knuckle Pin Connection Bushings
Link Strap Bushings
Link Strap Dowels
Brass Wear Plate Screws
Block Springs
Block Spring Rods
Block Spring guides
Block Lock Screw Bushing
New Gib Bolts

Crown, Bed & Uprights:

Main Bearing Bushings
Bushings Pins
Oil Seal, Driveshaft
Drive Belts
Main Bearing Cap Bolts
Intermediate Bearing Bolts
Driveshaft Bearing Bolts
Driveshaft Bearings
Intermediate shaft Bearings
Driveshaft Lock Nuts and Lock Washers
Drive Motor Sheave & Bushing
Drive Pinion Tapered Key
Flywheel bearings
Limit Switch Drive Crankshaft Sprocket
Limit Switch Drive Chain

Clutch & Brake (20-AFC):

Drive Facings
Brake Facings
Brake Anchor Brackets
Clutch Packings
Brake Springs, Stud and Nuts
Clutch Gear Bearings
Dual Clutch Air Valve, 1.25"
Air Distributor Bearing
Air Distributor Spindle
Air Distributor Packing

Counterbalance:

"U" Packings, 8"
Piston Rod Bushings
Piston Rod Packings
Piston Rod Flex Nuts
Wire Core Wicks

Flywheel Brake:

Brake Lining
O-Rings
Spring
Pressure Switch
Air Valve

Pneumatic System:

Install New Press Pneumatic System (Original air tanks will be reused.)

Lubrication System:

Install New Grease Lubrication System. Includes New Distribution Blocks.

Drive System:

New 30 HP Drive Motor System.



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Remachining:

Slide:..... Re-square, includes pin bore.
Knuckle:..... Re-machine.
Top block: Re-machine.
Slide adjustment wedge:Re-machine.
Main gibs:..... Re-grind to clean up square.
Knuckle block gibs:..... Re-machine square.
Bed: Re-machine flat.
Uprights: Re-machine.
Crown:..... Re-machine wedge guide

(SSP) Minster Electric Control:

Minster Centralized Motor & Clutch Control Panel, NEMA Type 12 enclosure, built to Minster's interpretation of ANSI –B11.1 and to NFPA Specifications.

Main panel contains the press clutch control circuit, plus a fused disconnect, and a reversing drive starter for system voltage: 480 Volts, 3 Phase, 60 Cycle

Main control panel located on left-hand side of press. (Customer's power drop to be to main panel.)

- The setup units include:
the motor control units
- motor on pilot light
- lube fault light
- clutch selector switch to select Inching, Single Stroke or Continuous operation.

Setup units located:

ON PEDESTAL TOP Basic set of operator buttons, including:

- two guarded Run Buttons to operate press
- Continuous "Arm/Ready" red illuminated pushbutton

(SSP) Minster Electric Control, cont'd:

- Two INCH buttons
- Top Stop button
- Stop Control pushbutton.

This group of buttons located: ON PEDESTAL TOP
Includes:

- one die safety block receptacle mounted on main control panel, less block and holder.

Safeguarding interlock connections located on the front and rear of press. If safeguarding is purchased with the press these connections are removed, and the safeguarding is hard wired to the press. Clutch and motor control circuits, including pushbuttons operate on 110 VAC from control transformer

Standard Control Features:

- 5.7" Color Touch Screen
- Dual Language (English\Spanish)
- Modes of Operation: Inch, Bar, Setup, Single Stroke, Continuous
- Configurable Inputs and Outputs
- Analog Module
- 4 Channel Die Protection (PNP or NPN)
- 4 Channel Programmable Limit Switch
- 6 Configurable Output Relays
- Resolver/Encoder

Clutch, Counter Balance and FW Brake Pressure Switch Assembly with FW Brake Valve Clutch Valve
A new dual clutch valve will be supplied to include valve detector switches and required cables.