

Minster E2-200-96 "Hevi-Stamper" Straight Side Press

New 2002

Nidec Press & Automation Stock #100287P



Photos of actual machine

Press Specifications:

Model Number: E2-200-96X54-SG
Capacity at Distance off Bottom: 200 ton at 0.250 in
Crankshaft Extension Diameter: 5.00 in
Crankshaft Extension Location: Both Right and Left Sides
Drive Arrangement: Single Geared Twin Drive
Lube Unit Location: Left Hand Side
Approximate Press Mass: 80,000 lb.
Shutheight Indicator Readout: Inch

Press Slide Specifications:

Stroke Length: 14.0 in
Speed Range: 80 spm
Adjustment of Shutheight: 6.00 in
Area of Slide, R-L x F-B: 96.0 x 54.0 in
Slide Face Machining: Standard

Press Bolster Specifications:

Bolster Plate Material: Steel
Bolster Plate Thickness: 5.00 in
Area of Bolster, R-L x F-B: 96.0 x 54.0 in
Opening in Bolster, R-L x F-B: None
Bolster Plate Machining: Standard

Press Frame Specifications:

Upright Passline Opening, F-B: 25.0 in
Area of Bed, R-L x F-B: 96.0 x 54.0 in
Opening in Bed, R-L x F-B: 90.0 x 24.0 in
Bed Deflection at 67% of Die Area: 0.0018 in/ft
Shutheight, SDAU: 27.00 in, on Bolster (Rev 1.04)
Approx. Clearance, Foot to Bottom of Bed: 0.50 in
Approx. Distance Foot to Top of Bolster: 41.0 in
Approx. Distance Foot to Top of Bed: 36.0 in
Approx. Floor Space, R-L x F-B: 132 x 72.0 in
Drive Motor Power, Speed: 40 HP, 1200 rpm
Drive Motor Starter: Reversing
Incoming Power Drop: Control Pedestal
Control Pedestal Location: Right Hand Side
Control Station Location: Pedestal Mounted
Run Station Location: Pedestal Mounted/Continuous
Plug-in T-stand/Single Stroke
Setup Station Location: Right Hand Side
Limit Switch Type: 16-Pole Prog w/ 5-P Mech.
Control Operation Mode: Inch-Single-Continuous
Press Mounted Stop Control PB: (2) Front and (2) Rear
Note: All specifications contained herein are as the machine was originally manufactured and are subject to change at time of inspection.

Price, As Is, FCA Minster OH: 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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Four Piece High Tensile Cast Iron and/ or Steel Frame component materials chosen to reduce overall press vibration level. The open top of crown provides easy access to tie rods that are drilled to accept "Heatrex" heaters to release the tie rod nuts.

Bed Deflection designed for specified deflection between tie rod centers with maximum press tonnage distributed over the center two-thirds of the R-L bed area.

Die Lubricant Troughs machined in top of bed.

Feed Pads on right and left side of bed for convenience when cabinet style feeding equipment is furnished.

Hydraulic Tie Rod Nuts Set of (4) Nuts, air/oil pump and, manifold mounted on crown.

Two Point Eccentric Crankshaft forged of alloy steel reduces the stamping load deflection and thus, reduces the vibration from snap through shock.

Standard Slide Motion

Main Bearing Support Wedges reduce the eccentric shaft deflection from reverse loads encountered in heavy blanking applications.

Combination Hydraulic Flex Disc Clutch and Brake includes dual clutch valves providing quick starts and faster stopping times for higher production speeds.

Air Operated Flywheel Brake interlocked with stop circuit eliminates coasting resulting in quicker access to die area.

E2-MonitorFlow® The patented Minster MonitorFlow® System supplies a continuous flow of pressurized and filtered oil to all lubrication surfaces ensuring reliable operation. It monitors flow and pressure to individual points as well as the oil level and pressure within the entire system.

From the manifold in the press crown oil is channeled to the bearings, gibs, gears and counterbalances. Individual flow switches monitor oil flow to these locations through the sump line back to the reservoir. Monitoring flow and pressure in this manner enables fault detection from both broken and/or plugged lines. The press is stopped, and a diagnostic message is displayed on the control screen indicating the location of the fault should one occur. This aids the operator in pinpointing the problem area.

Eight Point Slide Guiding System provides a minimum clearance guide for the slide through its full height at all stroke and adjustment positions.

Saddle Bearings in the connection screw are precision machined for a full contact fit with the bottom of the connection to reduce snap through motion.

Counterbalance System in Uprights statically balances slide and upper die weight. It is not intended to provide a dynamic inertia balance.

Motorized Shutheight Adjustment with Digital Readout provides quick die set-up and adjustments. Slide Adjustment Control Buttons are located in the Set-up Station.

Slide Face Machined with 1.0 in. general purpose T-slots F-B on 6.0 in. centers starting on center.

Bolster Plate Machined with 1.0 in. general purpose T-slots F-B on 6.0 in. centers starting on center.

Two (2) Die Safety Blocks Length is shutheight on Bolster, stroke up, adjustment at MID range, bed mounted, one front, one rear.

Press Shock Mounts, Vibro Dynamic Set of (4) elastomer style press mounts.

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Minster Production Management Press Control V6 includes the following features:

- Color Touch Screen with Ethernet Communications
- Allen Bradley SLC 5/05 PLC
- 16-Pole Programmable Limit Switch
- Brake Monitor / Press Stopping Time Readout
- 75 Tool Storage Capacity with 7-Digit Numeric I.D. Codes
- System Prompts and Diagnostic Messages
- Lube Pump On/Off Indicator
- Motor Start/Stop Control
- Motor Speed Control
- Motor Speed and Load Display
- Slide Adjust Function Indicators
- Dual Clutch Valve Monitor
- Stock Lubricator Interface Output
- Auxiliary output interface for secondary control elements
 - †(2nd blowoff, lubricator, divertor tables, etc.)
- Blowoff Valve Interface Output
- 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

Pedestal Control Enclosure is ergonomically designed and includes illuminated indicators and operator/set-up buttons and uses minimal floor space. Includes press motor and clutch control circuit with a Square D Thru-the-Door disconnect switch (Non-IEC). Pedestal has standpipe and flexible overhead conduit to swivel box on front of crown.

Control Station Includes:

- Clutch Selector Switch to select Control Operator Mode
- Power Off-On Locking Selector Switch
- Supervisory Control Lock Selector Switch (PMC only)
- Function Enable Illuminated Pushbutton (PMC only)
- Slide Adjustment Control Buttons

Pedestal Mounted Run Station Includes:

- Two Guarded buttons to operate press/Continuous Only.
- "Arm" Push-button(s)
- Top Stop Button
- Stop Button

Two (2) Die Safety Block Receptacles (less blocks) located on press bed, one front, one rear.

Clutch and Motor Control Circuits including push-buttons, operate on 110 VAC from control transformer.

Eddy Current Main Drive Motor Without Brake is totally enclosed, fan cooled, variable speed, and provides proven durability and increased torque response.

Note: Main Drive Motor to include a lanyard attached to the press crown.

Minster Production Management Automatic Counterbalance Adjustment



Photo of actual PMC

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