

PRESS MASTERS

Solutions for the Metalforming Industry

Remanufactured Minster PM2-200-54 Straight Side, Eccentric Shaft, Dynamically Balanced Progressive Die Press

New 1978

Press Masters Stock #100170P

Photo of actual press, prior to removal



Press Specifications:

Tonnage, Heavy Duty Rating:	200 tons	Distance, Floor to Top of Bed:	42.00"
Dia. of Ecc. Shaft at Bearings and Eccentric:	7 - 9.50"	Distance, Floor to Bottom of Bed:	16.00"
Stroke:	1.25"	Distance Between Gibs, to Clear:	56.00"
Shut height, on bolster SDAU:	22.00"	Opening in Bed (23" left of center):	44.00" x 12.00"
Slide Adjustment:	3.00"	Opening in Upright:	19.00"
Area of Slide R-L x F-B:	54.00" x 25.00"	Speed (Full Energy above 200SPM):	500 SPM
Area of Bolster R-L x F-B:	54.00" x 39.00"	Drive Motor/HP:	50/1800
Area of Bed R-L x F-B:	54.00" x 39.00"	Incoming Voltage:	480VAC/60hz/3ph
		Approximate Press Weight:	65,000 lbs.

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

Price, FCA Ohio: Contact Press Masters

Corporate Office

55 Realty Drive, Suite 100 • Cheshire, CT 06410

(203) 271-0644 • (203) 439-9116 Fax

www.pressmasters.com

Request Quote

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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 for system voltage: (Voltage to be determined by customer)

Main control panel located in pedestal located off left hand front of press. Pedestal has standpipe and flexible overhead conduit to swivel box on front of crown. (Customer's power drop to be to pedestal.)

Set-up units located on operator's pedestal include:

- Clutch Selector Switch to select Inch, Set-Up or Continuous
- Two Guarded Run Buttons to operate press.
- Continuous Arm Illuminated Button
- Two Set-Up Cycle Buttons
- Set-Up Cycle Arm Illuminated Pushbutton
- Power Off-On Locking Selector Switch
- Supervisory Control Lock Selector Switch
- Function Enable Illuminated Pushbutton
- Master Stop Button
- Top 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 two (2) inch buttons located on left front upright.

Includes preset slow start and inch speed controls.

Additional Stop button located:

- ON R.H. FRONT UPRIGHT
- ON L.H. REAR UPRIGHT
- ON R.H. REAR UPRIGHT

MINSTER PRODUCTION MANAGEMENT CONTROL

- Color Touch Screen
- Allen Bradley "SLC 5/05" PLC
- 16-Pole Programmable Limit Switch
- Brake Monitor/Press Stopping Time Readout
- 200 Tool Storage Capacity with 24 Alpha Numeric I.D. Codes
- System Prompts and Diagnostic Messages
- Press Lubrication System Indicator
- 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
- Blow-off Valve Interface Output
- Production Counters – Totalizers/Preset/Batch
- Maintenance Reminders – Triggers via Predetermined Hours or Clutch Engagements, or Number of Parts Made
- Press Lifetime Prod. Record – Hours/Cycles/Clutch Engagements
- Relay based Primary Machine Control

Dual clutch valves with detector switches and monitor unit.

Includes Press control resolver drive system.

Includes Hour Meter located internally in control panel to monitor clutch engagement time.

Includes two die safety block receptacles mounted on side of pedestal

Clutch and motor control circuits, including pushbuttons operate on 110 VAC from control transformer which has a minimum of 350 VA extra capacity for machine lighting.

DRIVE MOTOR

New ABB 50 hp, variable frequency drive system. Includes a new inverter duty drive motor.

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REMANUFACTURED SCOPE OF WORK PROFILE

- 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 and balancer 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.

NOTE: Crankshaft will be sent to a qualified testing service and checked for fractures using magnetic particle inspection process. No warranty implied on crankshaft inspection.

- Press tie rods will be tested for fractures.
- Submit quote for any additional parts or services, if required.
- Sand and prime paint major parts to prepare for finish paint.
- Remachine slide to resquare. Includes new bronze wear plates.
- Re grind main and auxiliary gibs flat.
- Remachine 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 rebore connections. Includes modification of connection lubrication system to provide increased oil flow to upper connection bushing and wrist pin bushing

- Refit balancer connection cap and rebore balancer connection. Includes modification of balancer connection lubrication system to provide increased oil flow to upper connection bushing and wrist pin bushing.
- Bore and sleeve balancer weight connection pin bore, if required.
- Replace all bronze bearings to latest MINSTER specifications and assembly fitting procedures.
- Replace all seals and taper and roller bearings.
- Rebuild 28-CFC air clutch and brake unit, replacing all normal wear parts and the parts listed on the following pages.
- Rebuild existing 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.
- Install new press electrical control with new ABB variable frequency drive system.
- 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.

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