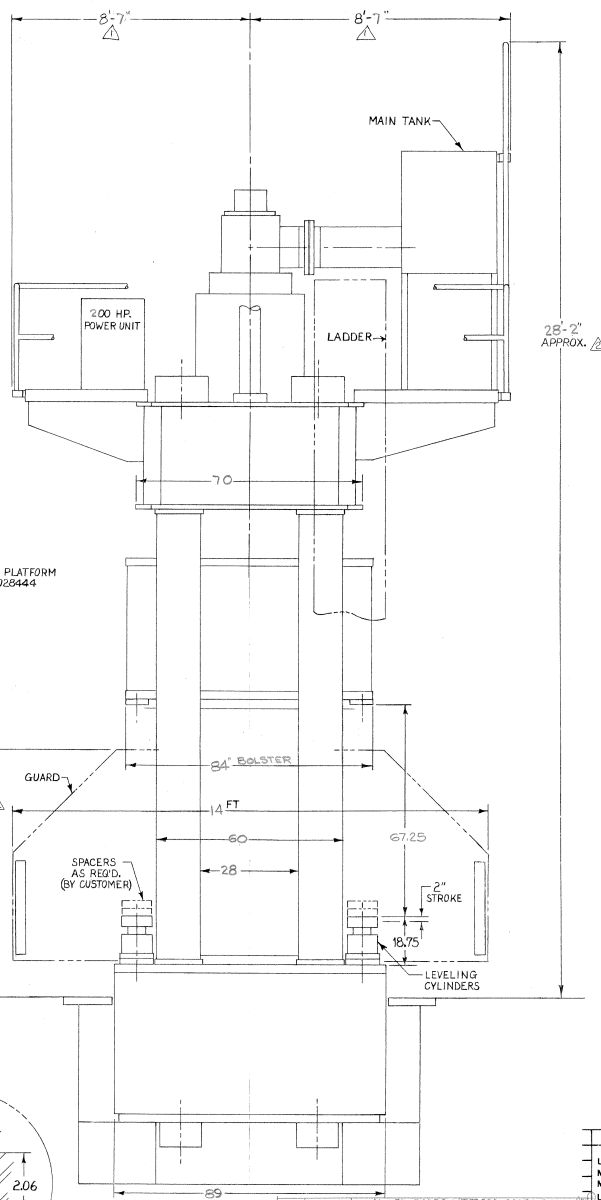
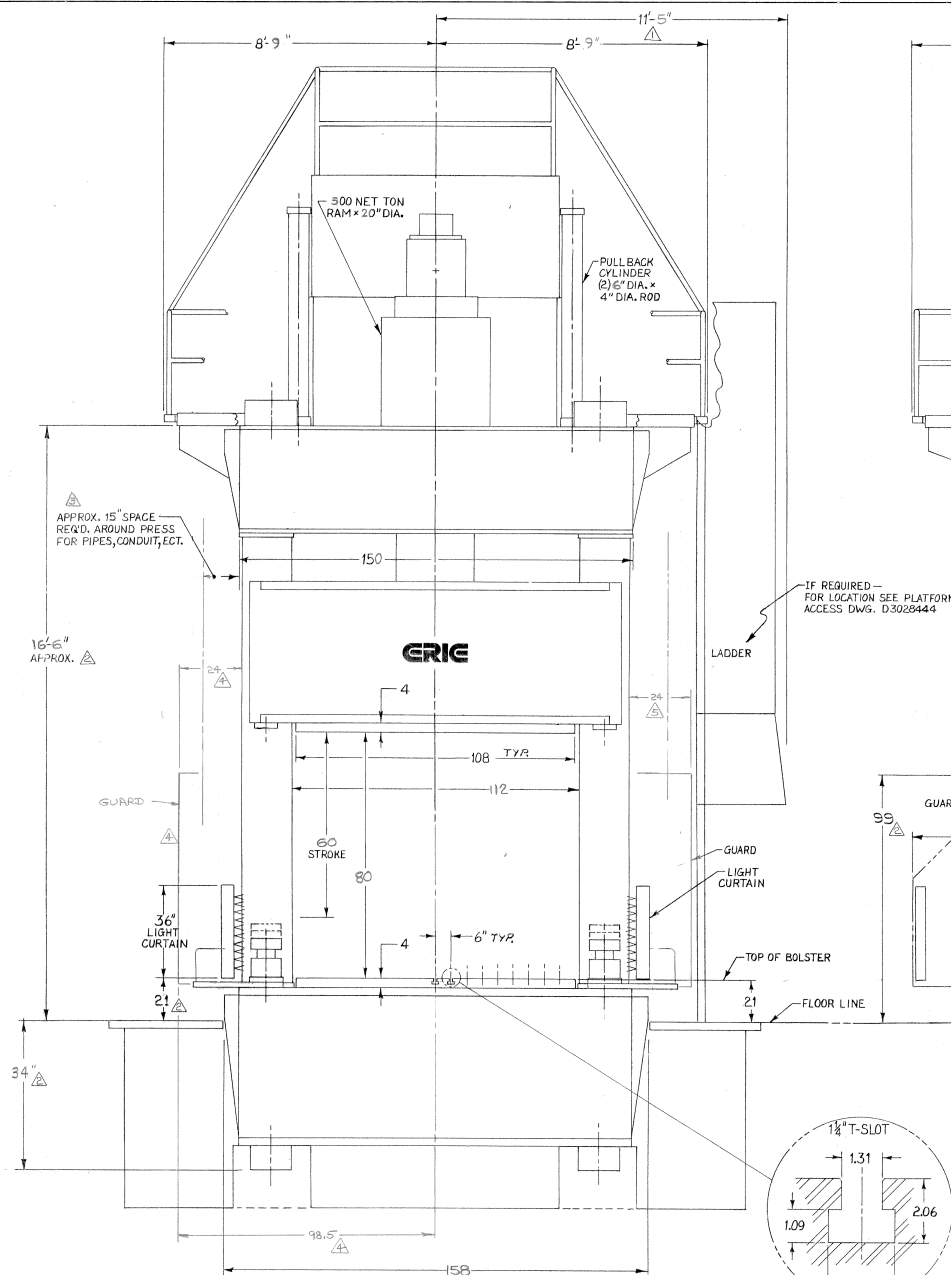




REFERENCE DRAWING LIST	ITEM NO.
D3028506 GENERAL ARRANGEMENT	ITEM NO. 64374
D3028507 FOUNDATION	
E3028510 PRESS ASM.	
D3028508 HYDRAULIC DIAGRAM	
D3028511 LEVELING CYL. ASM.	
D3028441 GUARD, 4 LIGHT CURTAIN ASM.	
E3028442 PRESS PIPING	
E3028514 TANK PIPING & PLATFORM	
D3028444 PLATFORM ACCESS	
D3028445 LIMIT SWITCH ASM.	
E3028447 HOLD-UP MECH. ASM.	
B3028509 MAIN CYL. ASM.	
D3028449 MAJOR WEIGHTS & SIZES	
D3028450 AUXILIARY COMPONENT POSITIONS	

NOTES:

- 1) REFER TO INSTRUCTION MANUAL BEFORE OPERATING THIS EQUIPMENT AND FOR ASSEMBLY AND DISASSEMBLY.
- 2) MAXIMUM TONNAGE TO BE APPLIED ON AN AREA OF NOT LESS THAN 70" L-R, 60" F-B ON E OF PRESS.
- 3) PRESS SPEEDS AND TONNAGES:

	SPEED (MM/SEC)	SPEED (IN/MIN)	TONNAGE
FAST ADVANCE	592	1400	
FAST PRESS	42	100	
PRESS	5-19	12-45	500 NET
SLOW STRIP	5-19	12-45	250 GROSS
FAST STRIP	14.8-42	35-100	15 NET
FAST RETURN	460	1087	
- 4) BEFORE STARTING PUMPS, FILL TANK WITH 745 GAL. OF PETROLEUM BASE OIL 150 GRADE-46 HAVING A VISCOSITY OF 220 SUS. @ 100°F., MOBIL DTE 250 REQUIRED. IMPORTANT: ALL FLUID ADDED TO THIS TANK MUST BE FILTERED TO 3 MICRON ABSOLUTE.
- 5) AFTER RUNNING PRESS THROUGH SEVERAL CYCLES & PURGING AIR FROM PIPING, 4 CYLINDERS REFILL TANK TO LEVEL MARKED ON GAUGE. (APPROX. 80 GALLONS REQ'D. FOR THIS)
- 6) TOTAL OIL REQUIREMENT - APPROX. 82.5 GALLONS
- 7) APPROX. WEIGHT OF PRESS - 220,000 LBS. SEE FOUNDATION DWG. FOR FURTHER INFO.

CAUTION:

DO NOT APPLY ANY PRESS TONNAGE TO LEVELING CYLINDERS WHEN THEY ARE FULL DOWN

CAUTION:

LENGTH OF LEVELING SPACERS MUST PREVENT LEVELING CYLINDERS FROM BEING STROKED MORE THAN 2" MAX

6 2-4-91 GRC Tonnage - 250 WAS 125 & 15 NET WAS 80 5 1-31-88 GRC 20" L-R 60" F-B WAS 108 L-R 64" F-B, REVISION 001 TO 2-4-91		ERIC PRESS SYSTEMS AN EPD COMPANY ERIC, PA., U.S.A.	
UNLESS OTHERWISE SPECIFIED TOLERANCES UNMACHINED ± .060 MACHINED 0.00 ± .015 MACHINED 0.000 ± .005 UNMACHINED ANGLES ± 1 DEG. ALL DIMENSIONS IN INCHES CHECKED & RELEASED TO SHOP 12-2-87 ZL 9-8-87 DA MOVED PRESS UP 31" ON C/D ON REQ'D. 11-2-87 1-20-87 WJ STOPS 87/89/91 WAS 87-89-91 87-89-91 11-5 WAS 11-5		LAYOUT DATE 12/2/87 DRAWN 12/2/87 DRS 12/2/87 CHECKED 12/2/87 APPROVED 12/2/87 SCALE NONE DRAWING D3028506 REV. 5	
MACHINED PARALLELISM & SQUARENESS .001/FT.		GENERAL ARRANGEMENT 500 NET TON VALU-MOLD PRESS	