



SOCIETÀ BULLONERIA EUROPEA S.p.A.

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VESCOVINI GROUP

# TECHNICAL SPECIFICATION BOLT FORMER BM 1 S1 4D

Serial N° 28984

Let us reassume the major technical specification:

|                              |                                      |
|------------------------------|--------------------------------------|
| Built year                   | 1991                                 |
| Forging stations             | 4                                    |
| Finger's number              | 4                                    |
| Production ppm               | 40/min                               |
| MIN. bolt diam/length        | M-20x40 DIN 933                      |
| MAX. bolt length             | M-20x270 DIN 931<br>M-33x230 DIN 912 |
| MAX. bolt diameter           | M-33x260 DIN 960<br>M-36x230 DIN 912 |
| Max. diameter of wire        | 34 mm (Res.450 N/mm <sup>2</sup> )   |
| MIN/MAX. length of cutoff    | 64/318 mm                            |
| Die k.o. stroke              | 40/254 mm                            |
| MAX. punch k.o. stroke       | 60 mm                                |
| DIES DIAM. x LENGTH          | 191x305mm – see enclosure            |
| PUNCHES DIAM. x LENGTH       | 150.9x244 mm – see enclosure         |
| DIAM. Quill (DIAM. x LENGTH) | 127x150 mm – see enclosure           |
| CUT-OFF KNIFE (Dx L)         | 80x48.3 mm – see enclosure           |
| Dies pitch                   | 228.6 mm                             |
| Max finger open up-setting   | 65 mm                                |
| Motor                        | 150/75 Kw                            |
| Net weight (Approx)          | 6400 kN                              |



## DRAWING ON LINE

This forging machine will be sold with his own drawing on line machine as per enclosed picture.



## TOOLING DRAWINGS

Just for reference we'll give you Feeding roller drawing for the main sizes.

### 12.2 TECHNICAL AND CONSTRUCTIVE SPECIFICATION USED FOR REBUILD THE FORGING MACHINE ON 1999 BASED ON SBE STANDARD SPEC.

#### 12.2.1 The equipment should be build in SUPPLIER plant by his own staff, as specified below:

The electrical equipments of the supplied machines should be build in conformity to the existing EU Regulations updated to the order's date.



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The voltage supply should be 400 V 50 Hz.

The control logic should use a SIEMENS – S7 programmable controller and the PLC input/output voltage should be 24 Vdc.

## **13.1 DRAWINGS AND DOCUMENTATION**

SBE will delivery the document available that will be showed during inspection meeting.