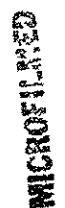
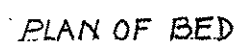


[illegible]



~~FOR BOLSTER~~ SEE W-21676

PRESS DATA:

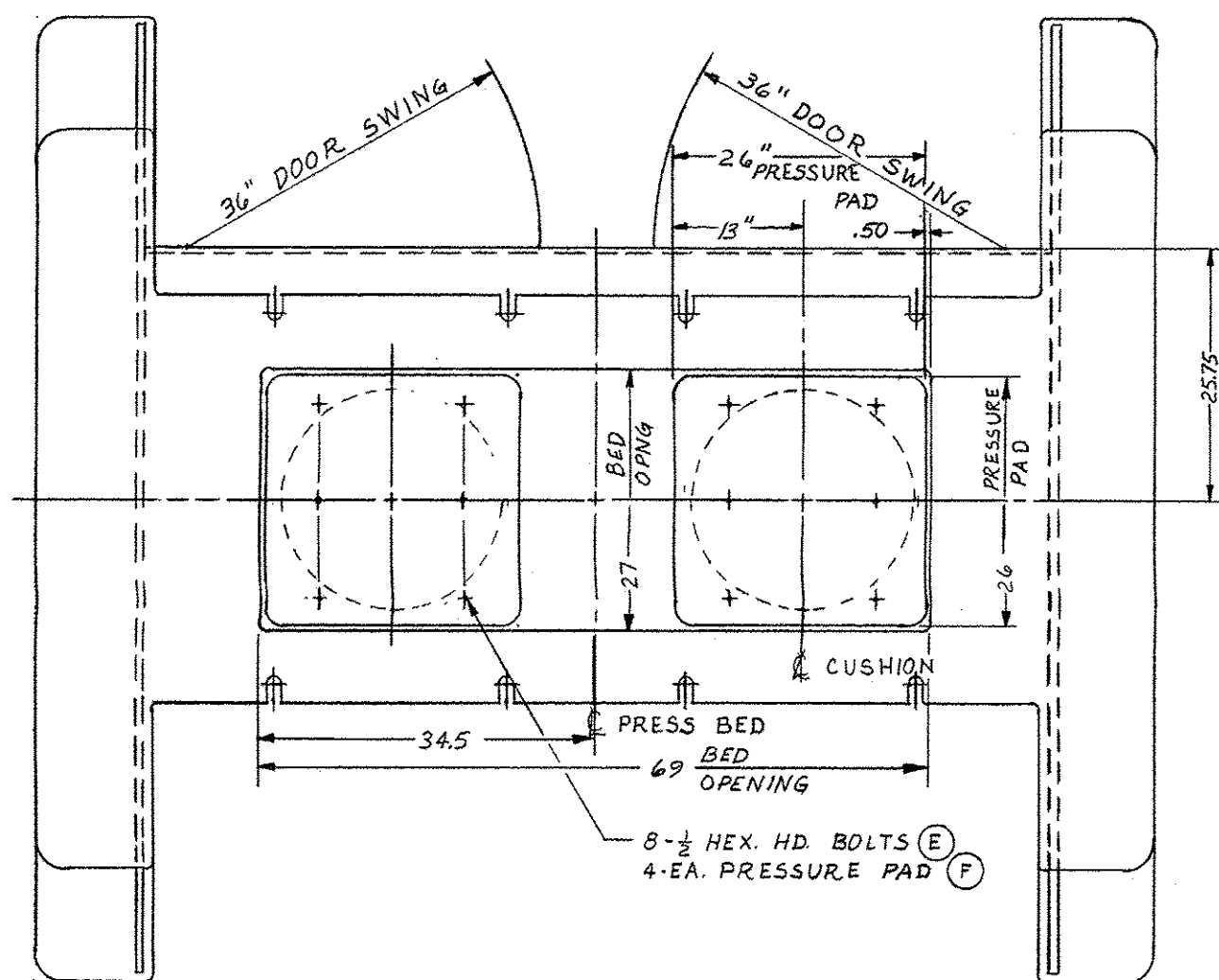
BED TO SLIDE - STROKE DOWN , ADJUSTMENT UP	33
-STROKE OF SLIDE-	10
ADJUSTMENT OF SLIDE	11

~~DIE SPACE DRAWING~~ O-24346



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TRANSPARENT FROM		UNLESS OTHERWISE SPECIFIED:		MODEL NO. 902-250-84-42 PRESS	
SURFACE FINISH ✓ TOLERANCES DIMENSION MACHINED WELDMENT ON CASTINGS		TITLE D/E SPACE DWG		DATE 7/24/78 DRINK/CPC	
		CHECKED <i>elk</i>		SHEET 1 OF 1	
REFERENCE		NO. WAS DATE NO. WAS DATE		NIAGARA MACHINES AND TOOL WORKS INCORPORATED 1000 W. 10TH AVE. SARASOTA, FL 34236 0-24346	



TO REMOVE CUSHION THRU DIE SPACE AREA

1. RELEASE AIR PRESSURE
2. DISCONNECT AIR TANK
3. DISCONNECT FLEX LUBE AND FLEX AIR LINES
4. REMOVE 8 BOLTS (B) & RETAINERS (C)
5. REMOVE 4 BOLTS (E) & REMOVE PRESSURE PAD (F)
6. REMOVE RATCHET WRENCH ASSEMBLY BY REMOVING BOLTS (D)
7. INSERT LIFTING RODS THRU 1" CLEARANCE HOLES AND THREAD INTO 3/4-10 N.C. TAPPED HOLES IN STUD (A)
8. CAREFULLY RAISE CUSHION INTO DIE SPACE AREA AND REMOVE FROM PRESS

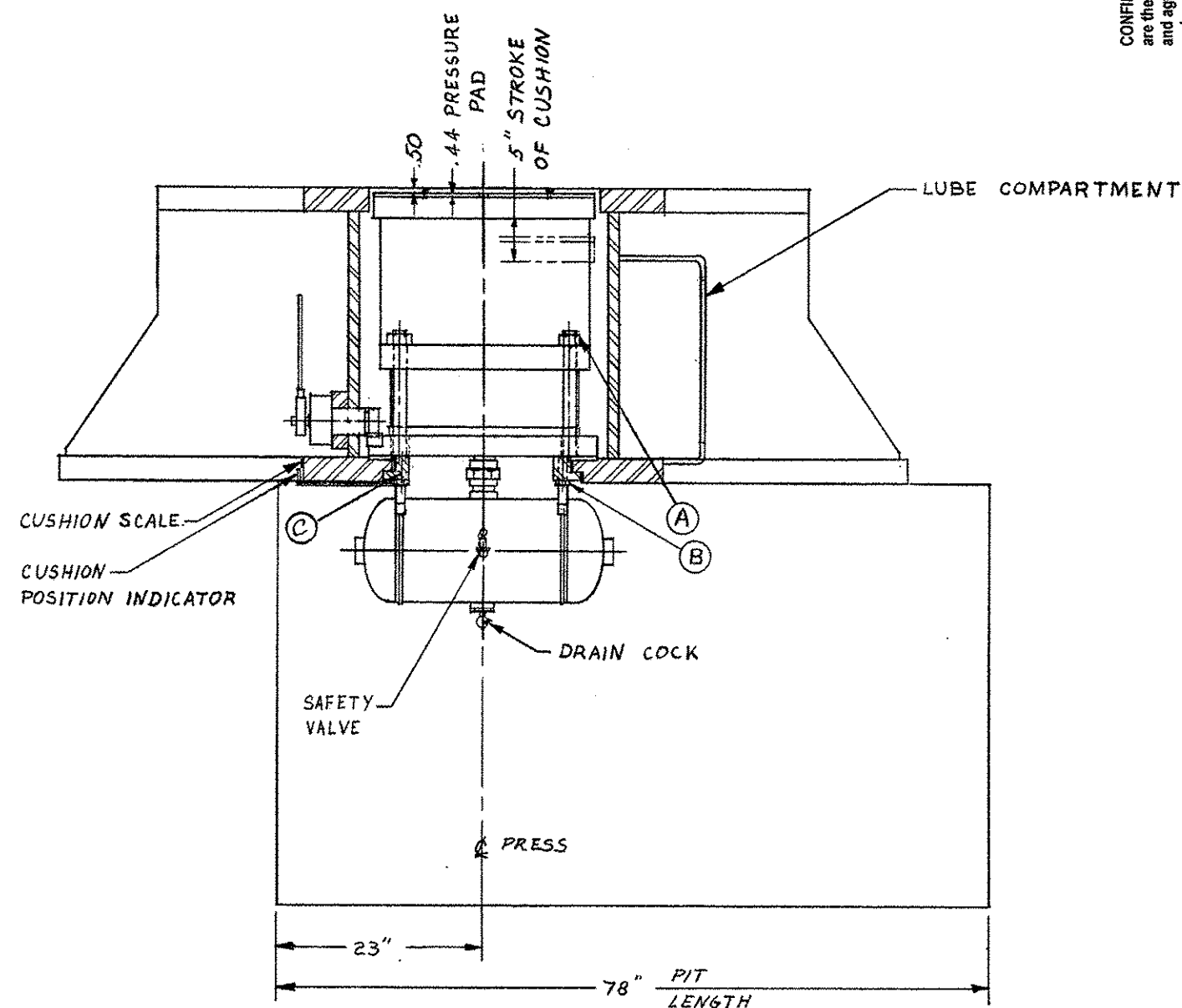
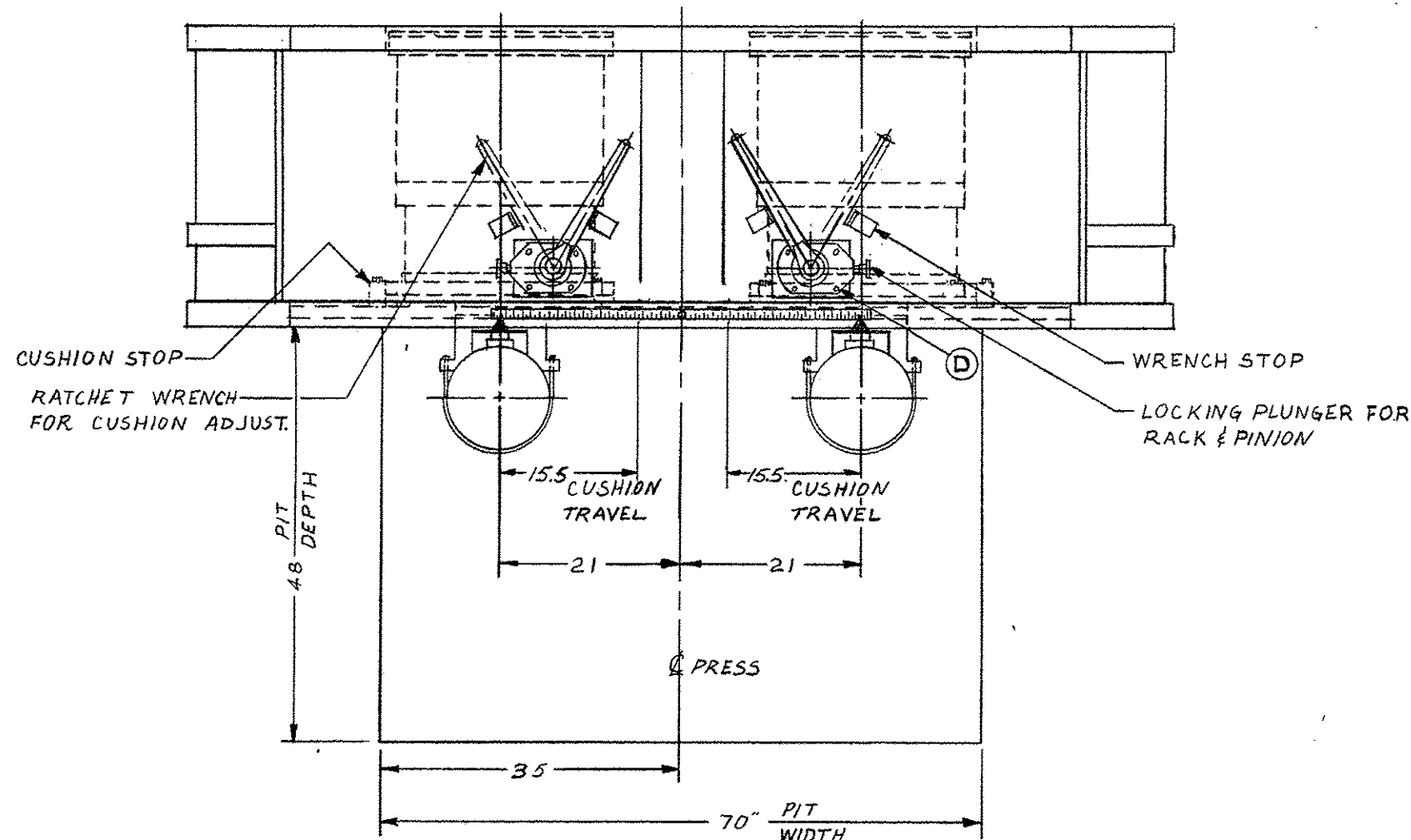
COLLAPSED HEIGHT OF CUSHION 24.50"

APPROXIMATE WEIGHT OF ONE CUSHION 1500 lbs

REF. FLOOR PLAN - 0-24309 SHT 1 & 2
FOUNDATION - 0-24308

CUSHION RATING IN TONS		
PSI	EACH CUSHION	BOTH CUSHIONS
60	11.4	22.8
80	15.2	30.4
100	19.0	38.0

CUSHION INSTALLATION DRAWING
DRAWING No. 0-24347



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MICROFILMED

MODEL NO. 5C2250-84-42 PRESS	TITLE CUSHION INSTALLATION DWG	CHECKED E272
DATE 7-26-78	DRAWN 240	SHEET OF
NIAGARA		0-24347
MACHINE AND TOOL WORKS		
UNLESS OTHERWISE SPECIFIED:		
SURFACE FINISH	TOLERANCES	
DIMENSION	MACHINED	WELDMENT
OR CASTING	± .005	± .005
OR X	± .005	± .005
XXX	± .01	± .01
XXXX	± .02	± .02
NO. 1 WAS	DATE	NO. 1 WAS
DATE	NO. 1 WAS	DATE
0-22591	0-22636	