Modern Hydraulic Technology

division of Newark Special Technology, Inc.

150 ton DAKE [Stock Number 4967]

Model Number	27-466,
Serial Number	154231
Construction	4 posts, approximately 4-1/2" diameter each
Stroke	42"
Daylight opening	60" (above 4-3/4" thick bolster)
Distance between posts	50" L-R x 30" F-B
Heated platens	(2) 43-1/2" x 43-1/2", 1800 degrees F., (9 controllable heat zones per platen)
Bed size overall	63" L-R x 43" F-B
Main ram	8" x 6" @ 6000 PSI

Die cushion

25.4 tons each, 22" x 43" pad area, (2) Dayton Rogers Model HC-18-8, air operated.

Bolster	(1) 43" x 50" x 4-3/4" thick

Hydraulics

10 HP, 1800 RPM, TEFC motor driving Dynex PF-2006 (4.2 GPM) and Vickers V235-11 (16.4 GPM) pumps, 90 gallon reservoir.

Speeds

Advance 150 IPM; pressing 17 IPM; breakaway 32 IPM, return 188 IPM

Micrion 823 Intelligent Distributed Controller

Base Dimensions	8'L-R x 4'F-B
Bed & Slide	63" L-R x 43" F-B
Clearance Between Tie Rods	50" L-R x 30" F-B
Cat Walk w/Power Unit	108"L-R x 92"F-B
Overall Height	16' 10"
Approximate weight	27,200 lbs.

Note: This press was modified and updated with all current technology in 1985 and used in fighter jet research & development for SPF & other hot forming applications in temperature ranges up to 1,700 DEG. F. Argon gas pressure up to 500 PSI for both platens, together with 18 different individually controlled heat zones makes this a very versatile press for all hot forming applications. This press can be used to form aluminum,
titanium and SPF metals.

Press is capable of this sequence of operations and operation times:

1) Cycle start: 1/3 - 1 second
2) Rapid advance adjustable stroke up to 150 IPM
3) High pressure: adjustable stroke up to 17 IPM
4) Timed hold: 2 - 60 minutes
5) Decompress: 0 to 60 seconds
6) Breakaway: 0 to 60 seconds @ 32 IPM
7) Return: adjustable stroke up to 188 IPM
8) Cycle ends.

F.O.B. truck, Philadelphia, PA