



GREENERD PRESS & MACHINE COMPANY, INC.

41 Crown Street, P.O. Box 886, Nashua, NH 03061

(603) 889-4101

FAX (603) 889-7601

## PRESS SPECIFICATION

Customer: Eaton Yale Ltd  
Sales Order #: 8387  
Serial Number: 95T4915  
Model Number: HCA-100-57R27  
Customer Order #: 150061

### STANDARD SPECIFICATIONS FOR MODEL NO. HCA-100-57R27

- Tons of Ram Force.....adjustable from 20 to 100
- Table left to right.....34"
- Table front to back.....20"
- Throat.....13"
- Daylight (maximum open distance).....34"
- Stroke.....adjustable from 1" to maximum 34"
- Floor to Table.....34"
- Clearance between ribs under press bolster (table).....8"
- Overall height.....124"
- Front to back.....65"
- Width at floor.....34"
- Guiding System.....4 guide rods
- Upper tooling plate mounting surface left to right.....32"
- Upper tooling plate mounting surface front to back.....18"
- Hole pattern in upper tooling plate (4) 25/32" holes 9" x 18" pattern
- Pump Capacity.....57 gpm & 27 gpm
- Type of Hydraulic System...High Low regenerative cartridge valve
- Cylinder Bore.....8½"
- Ram Diameter.....6"
- Ram Speed: Close, inches per minute.....686
- Ram Speed: Press, inches per minute.....105
- Ram Speed: Open, inches per minute.....681
- Maximum System Pressure.....3524
- Motor Horsepower: 1800 RPM.....50
- Weight, approximate lbs.....15,000
- Voltage: 460-480/3 phase/60 Hz

### OPTIONAL EQUIPMENT

1. Automatic Cycle (Continuous Cycle). AUTO-CYCLE mode selected by keyed selector switch. Initiate AUTO-CYCLE with dual hand controls. Operator's hands remain on controls throughout one full stroke and a portion of the second stroke to maintain automatic. Control system includes cycle stop (top stop) and emergency open buttons. Presses equipped with auto-cycle include standard water cooled heat exchanger.



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NOTE: Circuit modified to have "Intended Motion Button", "Cycle Stop" and "Emerg Stop". "Emerg Stop" will stop all press motions and functions, including all controls and motor.

2. Lite Touch Dual Hand Controls
3. OMRON PLC: OMRON PLC model C60K-CPRA with 32 inputs and 28 outputs. This will provide 12 extra inputs and 20 extra outputs. Programming of PLC will be done by Eaton Yale before we can test press.
4. Tags: All hydraulic components will have metal tags with cross reference numbers on hydraulic circuit drawing.
5. CSA: All electrical devices shall be UL/CSA approved.
6. J.I.C.: Press systems will conform to J.I.C. standards.
7. Manual: Two manuals will include parts list, hydraulic circuit, electrical circuit and instructions for all press funtions and press cycles.
8. Run Off at Greenerd: Greenerd will provide one full eight hour day for training personnel and test run off.

## MODIFICATIONS

1. Daylight: 34" daylight in place of standard 24" daylight.
2. Stroke: 30" stroke in place of standard 18" stroke.
3. Press Frame: 2-1/2" thick side plates in place of standard 1-3/4" side plates.
4. Floor to Table: 36" in place of standard 34".



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5. Hi-Temperature Alarm System to monitor hydraulic oil.
6. Delta Wye Main Drive Motor Start Configuration.
7. Oversize Table & Tooling Plate: Upper tooling plate to be 48" left to right, 24" front to back, with larger 3-1/2" diameter guide rods. Table to be 48" left to right X 24" front to back.
8. Light Curtain: Preparation Only.
9. Reverse Draw Cylinder: Reverse draw up acting cylinder, mounted under press bed, adjustable to 20 ton capacity, with 10" adjustable stroke and programmed to cycle in "Run" mode only. Ram end provided with tapped hole to receive customer installed ram extension.
10. C/H Motor Starter Wired
11. T-Slots in Upper Ram
12. T-Slots in Lower Ram - to accept 5/8" T nut 104" per dwg. 18141

### OPERATING SEQUENCE IN "RUN" MODE

- A. Operator actuates dual "Down" buttons (maintained contact).
- B. Main ram cycles down, contacts stop blocks in tooling, builds up pressure, and actuates a pressure switch to latch and hold main ram down under pressure.

Note: If operator releases either one or both buttons, main ram will automatically return to its adjustable up position and stop.

- C. When pressure switch is actuated, reverse ram will automatically cycle up for reverse draw.



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- D. When adjustable limit switch for reverse draw stroke control is actuated, both the reverse draw ram and main ram will automatically retract to their open adjustable positions and stop.
- E. Press is now ready for recycling.
- F. NOTE: Circuit will have an "Emerg Stop" to stop all press motions and functions. Jog buttons provided to cycle reverse draw ram independently for set up. A selector switch provided to drop out reverse cylinder circuit when not required.