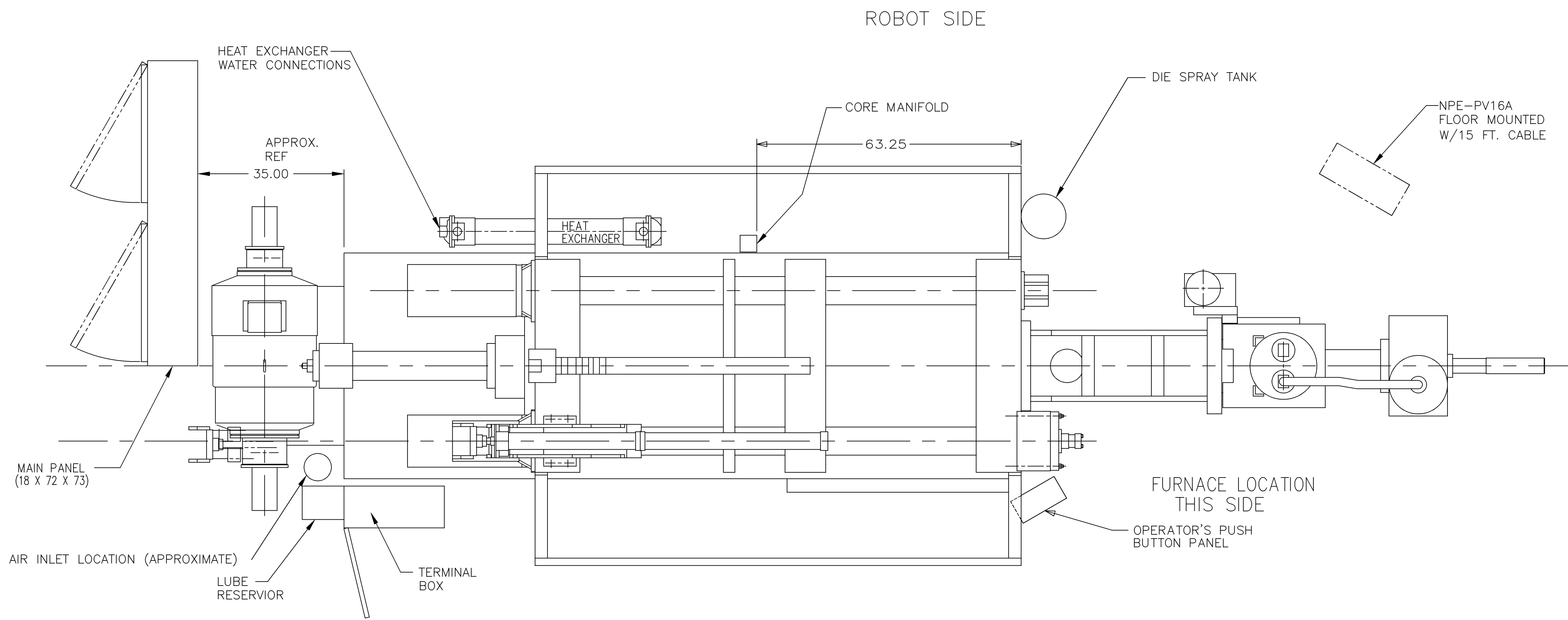


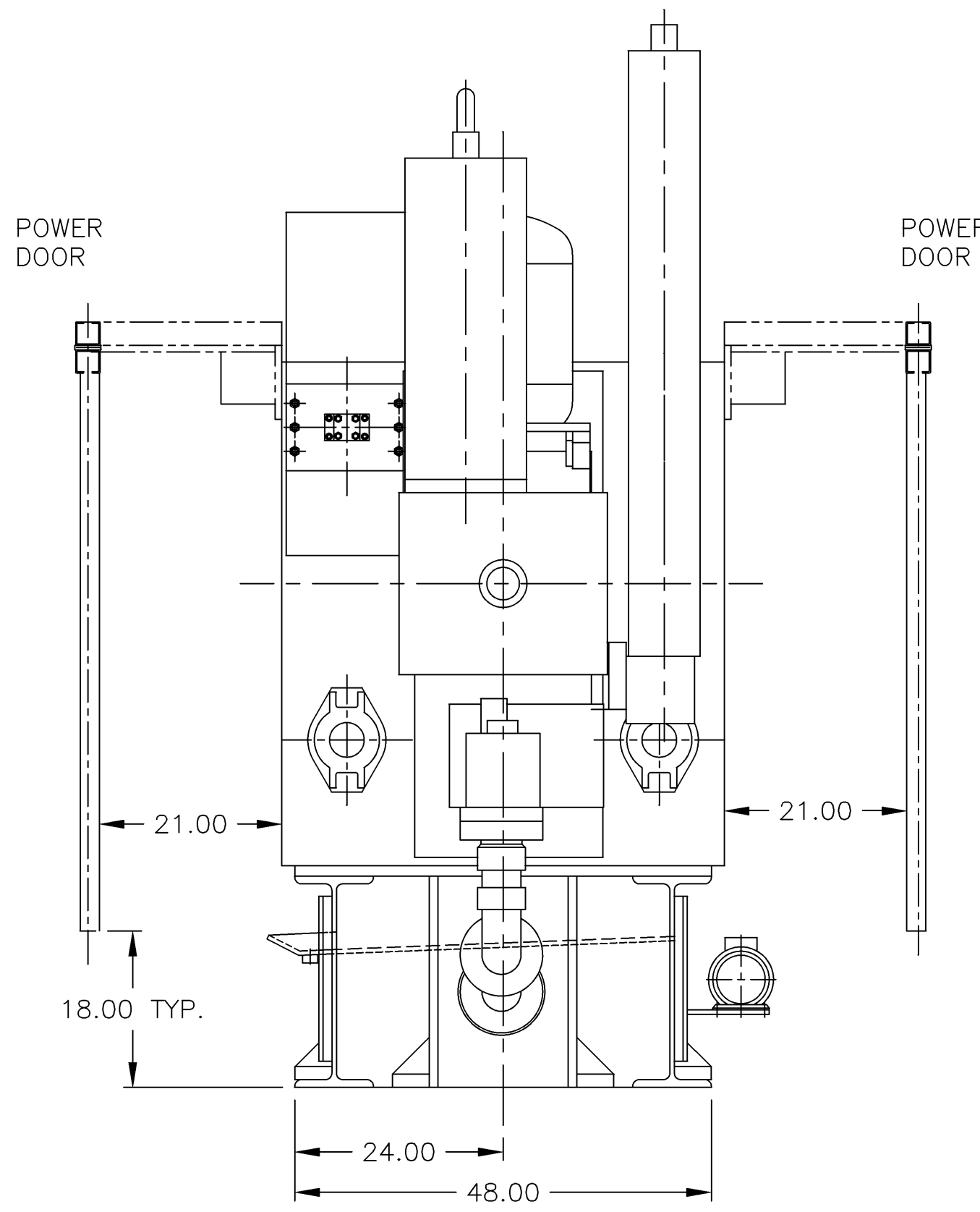
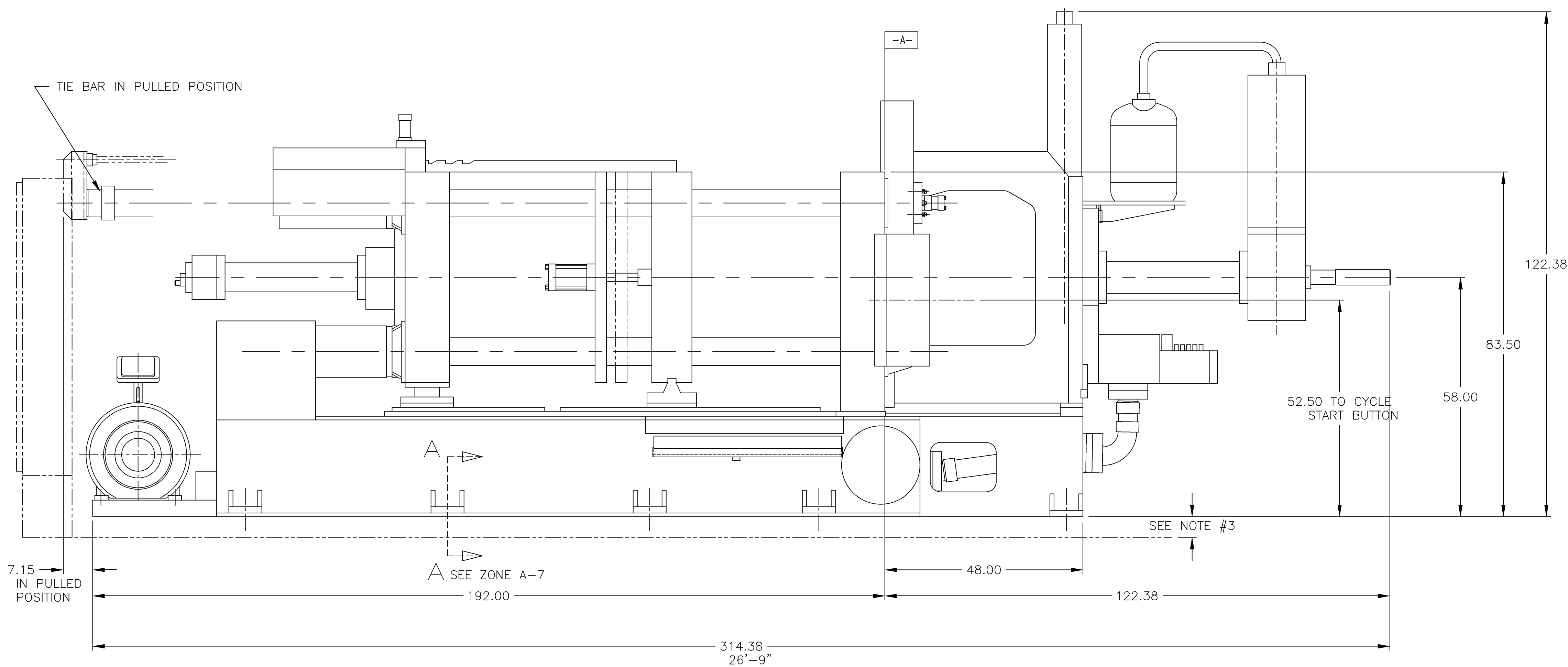
REVISIONS						
REV	DESCRIPTION	BY	DATE	ZONE	M	CK'D
A	ORIGINAL DRAWING					
B	7.15 WAS 1.53	JW	11/7/97	B8		
C	RE-POSITIONED NPE-PV16A UNIT	JW	3/5/98	E4		
	ADDED DIE SPRAY TANK LOC.	JW	3/5/98	E5		



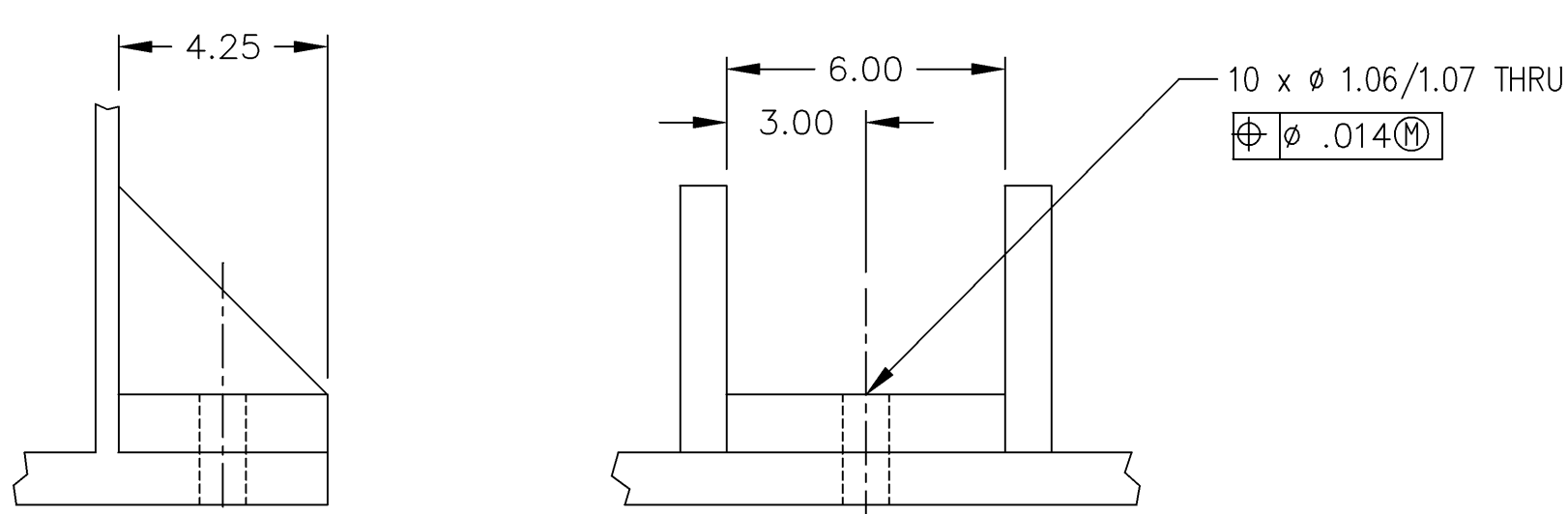
MACHINE SPECIFICATIONS	
MODEL	629
LOCKING TONNAGE	600 TONS
SPACE BETWEEN BARS	29.25" x 29.25"
TIE BAR DIAMETER	6.75"
TIE BAR CENTERS	36.00" x 36.00"
STATIONARY PLATEN (T X W X H)	10.75" x 51.00" x 58.00"
MOVABLE PLATEN (T X W X H)	9.75" x 51.00" x 51.00"
DIE STROKE	17"
DIE HEIGHT	16.00" MIN / 36.00" MAX
SHOT CYLINDER	5.5" BORE, 3.5" ROD, 19"/24" STROKE
SHOT POSITIONS	0 AND 6" BELOW
RESERVOIR CAPACITY	350 GALLONS
HYDRAULIC FLUID	CHEM TREND HF-28 FLUID MUST BE COMPATIBLE W/BUNA-N SEALS. SEAL MATERIAL SAMPLES ARE AVAILABLE FOR TESTING IF COMPATIBILITY IS UNCERTAIN.
SHIPPING WEIGHT	68,000 LBS.
LUBE SYSTEM	TRABON-OIL
RECOMMENDED LUBRICATION (TYPE & WEIGHT)	MOBIL VACTRA #4SLC
WATER REQUIREMENTS	25 GPM @ 85F
ELECTRICAL POWER REQUIREMENTS	SEE ELECTRICAL DRAWINGS

*AIR REQUIREMENTS
60 PSI
5 CFM CONTINUOUS

* INCLUDES REQUIREMENTS FOR MACHINE LUBRICATION AND SAFETY DEVICE.
DOES NOT INCLUDE ANCILLARY EQUIPMENT SUCH AS TRIM PRESS, SPRAY,
QUENCH AND PLUNGER LUBE.



REFERENCE DRAWINGS	
DWG NO	DRAWING NAME
54942-D	SUPPORT POINTS AND FLOOR LOADING LAYOUT
67206-D	DIE INTERFACE
67227-D	SHOT END LAYOUT
67226-D	LADLE AND FURNACE INTERFACE



SECTION A-A
TYPICAL LEVELING PAD DETAIL
SCALE: 1:4
SEE ZONE B-6

3. IT IS RECOMMENDED THAT THE MACHINE BE INSTALLED WITH THE BOTTOM OF THE BASE APPROXIMATELY 5 INCHES ABOVE THE FLOOR. THIS WILL ALLOW ROOM FOR JACKING AND LEVELING DEVICES. THE EXACT AMOUNT OF ROOM REQUIRED WILL DEPEND UPON THE EQUIPMENT YOU USE.
2. DIMENSIONS ARE NOMINAL WITH NO TOLERANCE IMPLIED. DISREGARD TITLE BLOCK TOLERANCE INFORMATION
- NOTES: 1. DO NOT SCALE DRAWING

PROPRIETARY				MATERIAL			
THIS MATERIAL IS THE EXCLUSIVE PROPERTY OF PRINCE MACHINE CORPORATION AND MUST BE RETURNED TO PRINCE IMMEDIATELY UPON REQUEST. THIS MATERIAL AND THE INFORMATION ILLUSTRATED OR CONTAINED HEREIN MAY NOT BE REPRODUCED, COPIED, USED OR TRANSMITTED IN WHOLE OR IN PART IN ANY WAY WITHOUT THE PRIOR WRITTEN CONSENT OF PRINCE MACHINE CORPORATION.				HEAT TREATMENT			
FINISHED SIZE				TEST WEIGHT			
TOLERANCES				CATEGORY			
XX ±.08 XXX ±.05 XXX ±.005 XXXX ±.001				CLASS			
D88032				DRAWN BY			
JW				DATE			
10/13/1997				REF			
57128-E				SCALE			
1:16				DRAWING NO.			
1 OF 1				67207-E			
NO MANUAL CHANGES				REVISION LEVEL			
LA63061				C			