

## 9. Technical data

Machine designation	hydraulic automatic press
Type of machine	TPA 250 H
System	hydraulic withdrawal process resp. freely programmable sequence of movements
Pressing force	max. 2500 kN
Withdrawal force	max. 1500 kN
Counterholding force in pressing position	max. 1800 kN
Counterholding force in filling position	max. 1800 kN
Die return force	max. 600 kN
Upper punch travel	max. 350 mm
Die travel (max. filling height)	max. 250 mm
Stroke rate at 50 mm filling height	about 15 min <sup>-1</sup>

### Upper punch hold-down:

Upper punch hold-down travel	max. till end of withdrawal
Upper punch hold-down force	0 - 2500 kN

### Core rod (with mechanically adjustable travel limitation)

Actuation via auxiliary cylinder

Travel	max. 100 mm
Force f. moving out (at 200 bar)	max. 40 kN
Force f. moving in (at 200 bar)	max. 27 kN
Locking force	
moving-out side (at 300 bar)	max. 59 kN
Locking force	
moving-in side (at 210 bar)	max. 28 kN

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# DORST-MASCHINEN-UND ANLAGEN-BAU

## Upper punch release mechanism

(centrally in the release block)

Actuation via auxiliary cylinder 4

Travel		max.	60 mm
Force f. moving out (at 200 bar)		max.	56 kN
Force f. moving in (at 200 bar)		max.	40 kN
Locking force			
moving-out side	(at 300 bar)	max.	85 kN
Locking force			
moving-in side	(at 210 bar)	max.	42 kN

## Upper punch release mechanism

(laterally in the release block)


Actuation via auxiliary cylinder 5

Values for both pistons

Travel		max.	70 mm
Force f. moving out (at 200 bar)		max.	124 kN
Force f. moving in (at 200 bar)		max.	74 kN
Locking force			
moving-out side	(at 300 bar)	max.	186 kN
Locking force			
moving-in side	(at 210 bar)	max.	78 kN

## Motors: at 60 Hz

Motor for hydr. circ. of upper piston:	P = 42,5 kW
	n = 1800 min <sup>-1</sup>
Motor for hydr. circ. of lower piston:	P = 42,5 kW
	n = 1800 min <sup>-1</sup>
Motor for control oil:	P = 25,3 kW
	n = 1800 min <sup>-1</sup>
Motor for cooling and filtering circuit:	P = 7,5 kW
	n = 1800 min <sup>-1</sup>
Total connected load	about 120 kW

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# DORST-MASCHINEN-UND ANLAGEN-BAU

Air connection: R 1/2 "  
Air pressure 6 bar  
Air consumption: max. suction air 1 l/min.  
- with vibrator 20 l/min  
- when using the units  
freely available to the  
customer: depending on "consumption"

Cooling water connection: R 1 "  
Water consumption:  
at max. 15 °C (58 °F) water temper. 2500 l/h  
at over 15 °C (58 °F) water temper. 5000 l/h

Dimensions: (refer also to foundation plan)

Height: approx. 6000 mm  
Width: approx. 3000 mm  
Depth (with hydr. unit) approx. 5000 mm

Weights:

Machine incl. hydraulic unit  
Electric switch cabinet with accessories  
(without adaptor)  
Net approx. 15 000 kg

Noise emission values:

Sound level: at the working place  
at the press 80 dB(A)


Measuring technique: Measurement with integrating  
impulse sound level meter, class 2  
Type 2226, Brüel & Kjaer

Mode of measurement: slow

Set up of instruments: point measurement at 1 m distance  
to front of press.

Measuring point 1,6 m above working platf.

Measurement: in mode of operation "continuous operation"

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