

POWDER COMPACTING PRESS

Multistep Die set



TSUKIMURA ENGINEERING INC.

Multistep Die Set

OUTLINE & CHARACTERISTIC

1. It is possible to adjust the pressing position of upper double punch portion and inner punch portion.
2. It is possible to stroke adjustment of both the outer/inner punch in upper ram punch portion
3. It is possible to adjust the pressing position of Lower #1, #2 punches.
(the adjustment amount is app. 1/2 of fill stroke).
4. The #1 and #2 ejection rods are linked both "right and left" and "front and rear".
It is adjusted by handle. (It is applied to the machines over 150 ton)

SPECIFICATION

	6ton	12ton	20ton	40ton	60ton	150ton	250ton	600ton	800ton
(1)Upper outer punch receiving capacity (KN)	60	120	200	400	600	1500	2500	6000	8000
(2)Upper inner punch receiving capacity (KN)	50	60	120	200	300	750	1250	3000	4000
(3)Die stop capacity (KN)	40	80	100	200	300	750	1250	2500	←
(4)Lower #1 punch receiving capacity (KN)	60	120	200	400	600	1300	2300	4500	5000
(5)Lower #2 punch receiving capacity (KN)	60	120	200	300	400	1100	2000	3500	4000
(6)Lower #3 punch receiving capacity (KN)	60	120	200	400	600	1500	2500	6000	8000
(7)Independent core receiving capacity(KN) ※	-	-	-	-	-	150	250	600	800
(8)Upper outer stroke adjustment (mm)	15	←	12.5	←	15	←	←	17.5	←
(9)Upper inner stroke adjustment (mm)	* 1	←	12.5	←	15	←	←	17.5	←
(10)Lower #1 stroke adjustment (mm)	30	50	70	80	90	100	←	110	←
(11)Lower #2 stroke adjustment (mm)	30	50	70	80	90	100	←	110	←
(12)Lower #3 stroke adjustment (mm) ※	-	-	-	-	-	25	←	30	←
(13)Upper inner pressing position adjustment (mm)	* 2	±1	←	←	±1.5	←	←	±2	←
(14)Lower #1 pressing position adjustment (mm)	15	20	30	35	40	50	←	←	←
(15)Lower #2 pressing position adjustment (mm)	15	20	30	35	40	50	←	←	←
(16)Independent core ejection amount (mm) ※	-	-	-	-	-	80	←	←	←
(17)Lower #1 surface position adjustment	Separate	←	←	←	←	Link	←	←	←
(18)Lower#2 surface position adjustment	Separate	←	←	←	←	Link	←	←	←
(19)Upper three-stage devise	-	-	-	-	-	○	○	○	○
(20)Cylinder operation system	Air	←	←	←	←	←	←	←	←
(21)Hydraulic cylinder operation	-	-	-	○	○	○	○	○	○

※ : Option

* 1 : 6ton, 12ton are not adjustable.

* 2 : Not inner but OUTER of 6ton is adjustable. The adjust amount is 15mm.



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