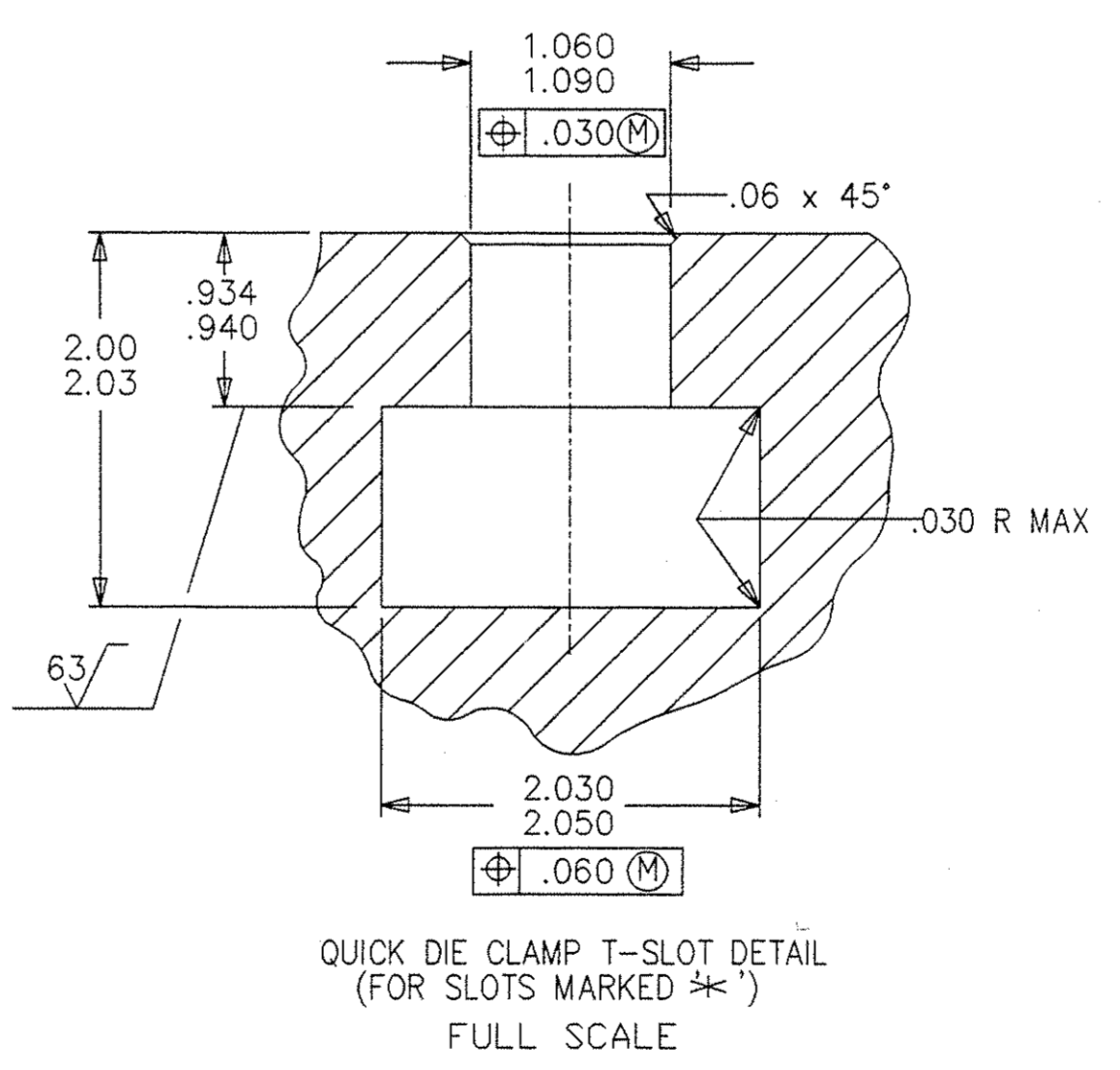
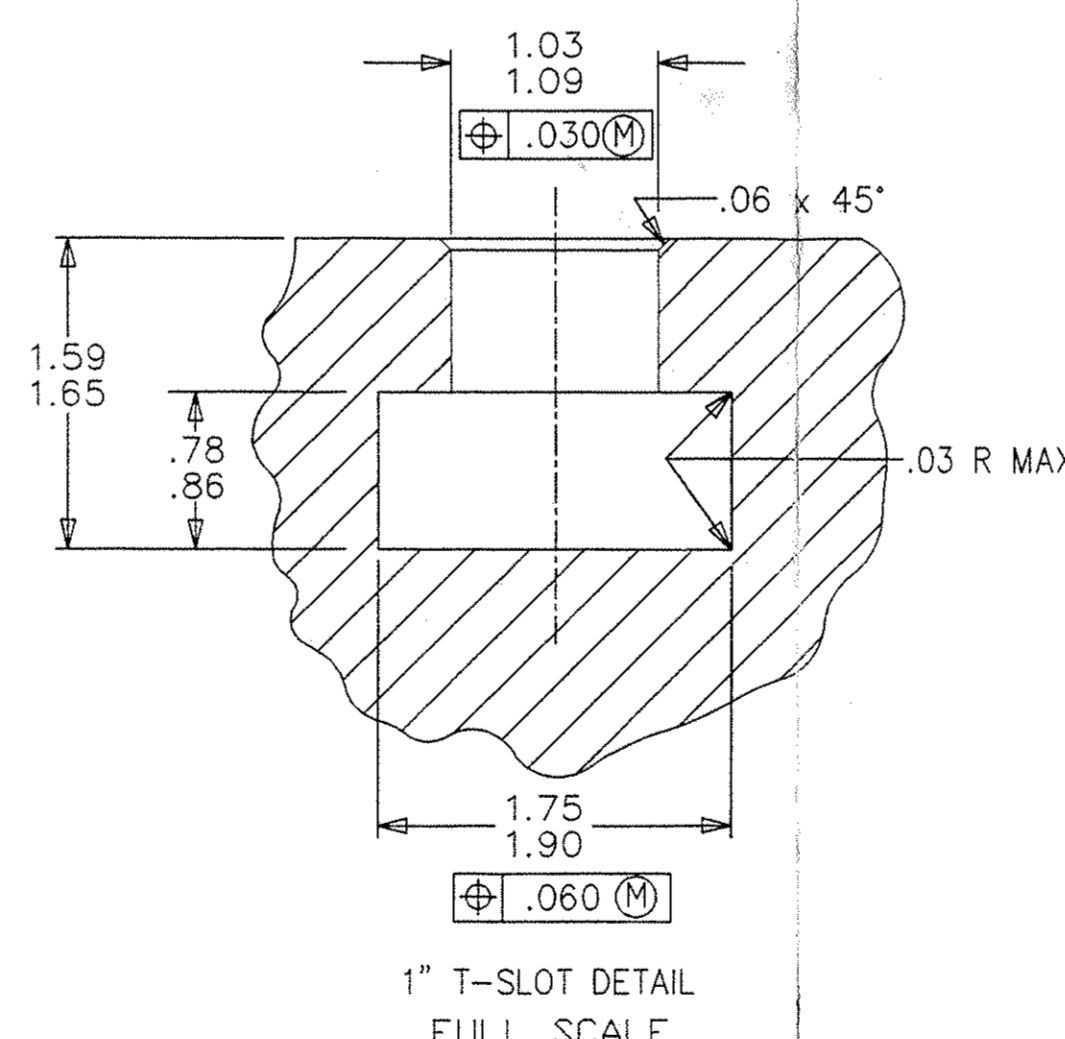
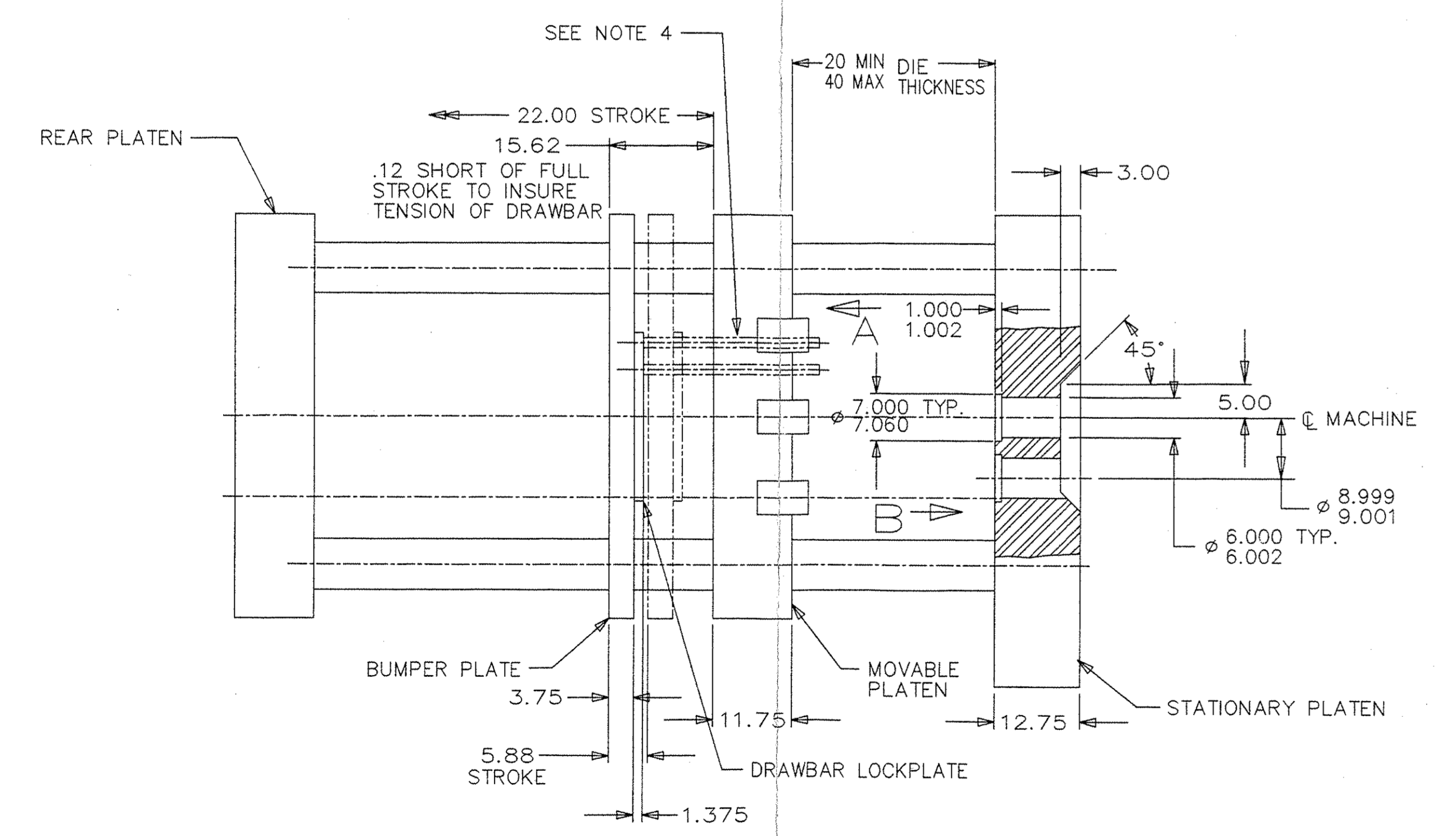
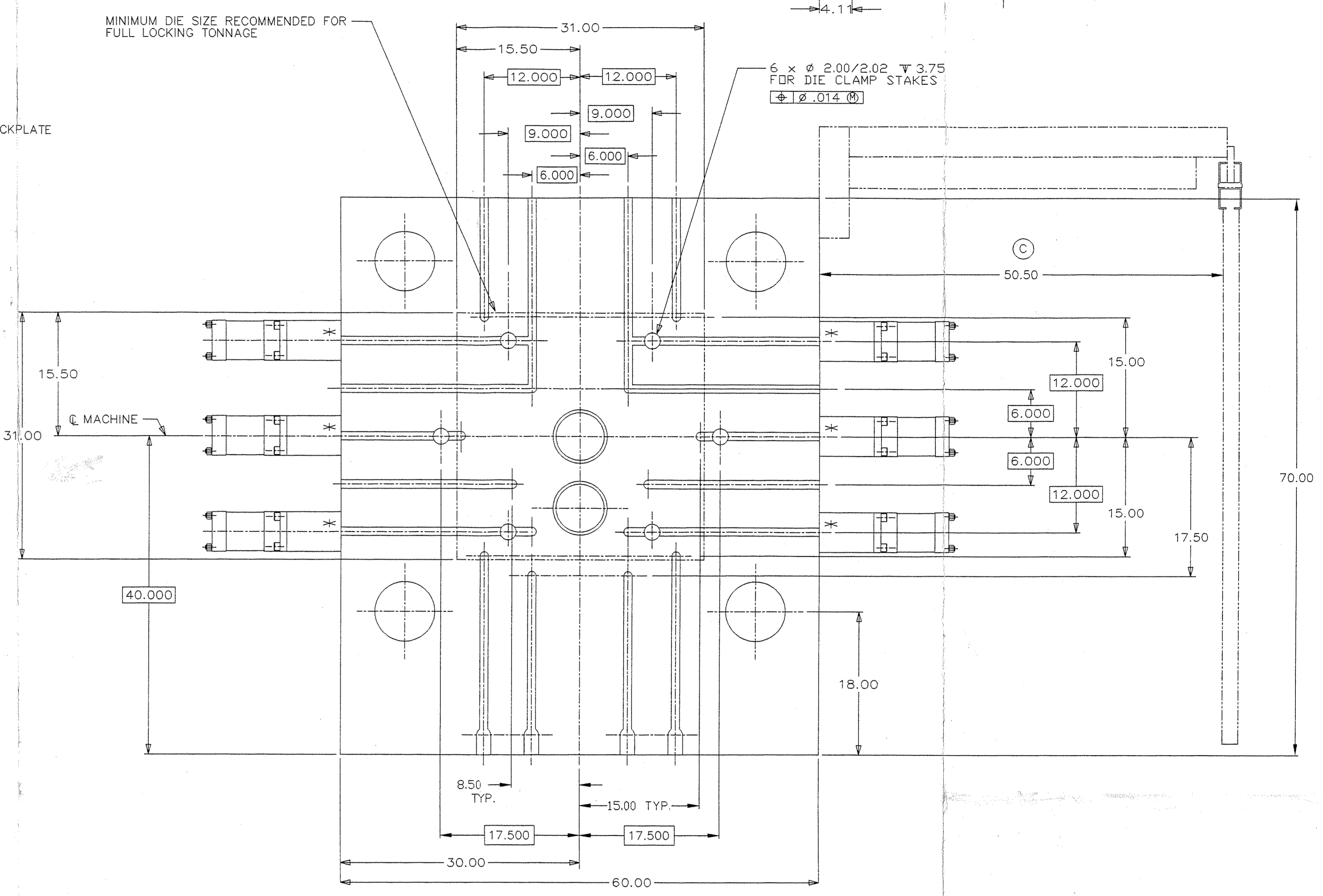
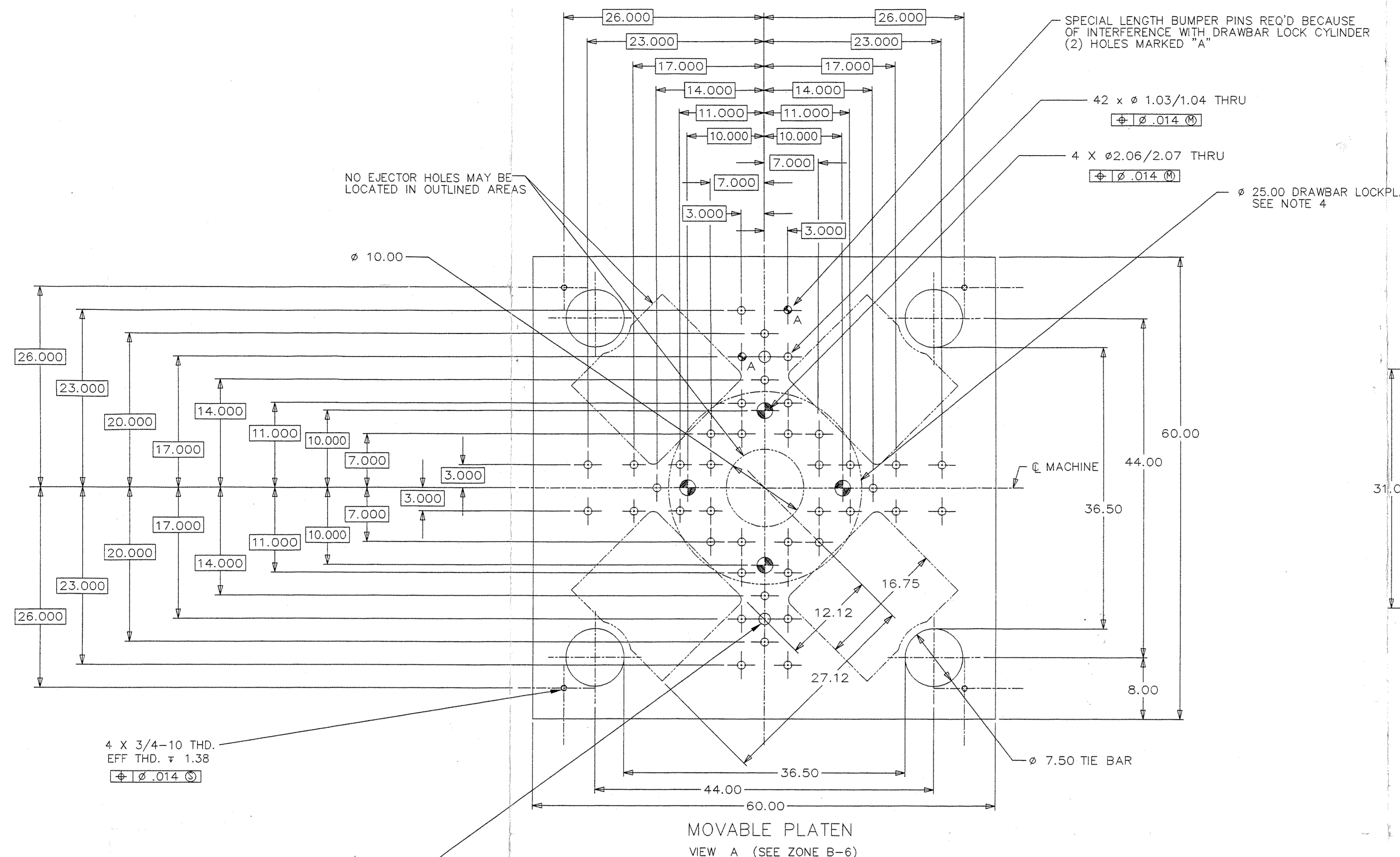


REVISIONS				
REV	DESCRIPTION	BY	DATE	ZONE
A	ORIGINAL DRAWING	---	---	---
B	REMOVED SECTION X-X	RH	1-4-93	C4
C	50.50 WAS 25.50	MLH	10-28-93	E-2



REFERENCE DRAWINGS	
DWS NO	DRAWING NAME
52561-E	GENERAL INFORMATION
52563-E	SHOT END LAYOUT
52564-E	LADLE AND FURNACE INTERFACE
49823-D	DRAWBAR
35022-B	DIE CLAMP STAKE
48982-C	DIE STAKE POCKET MACHINING REQUIREMENTS
50554-E	AUTO DRAWBAR LAYOUT

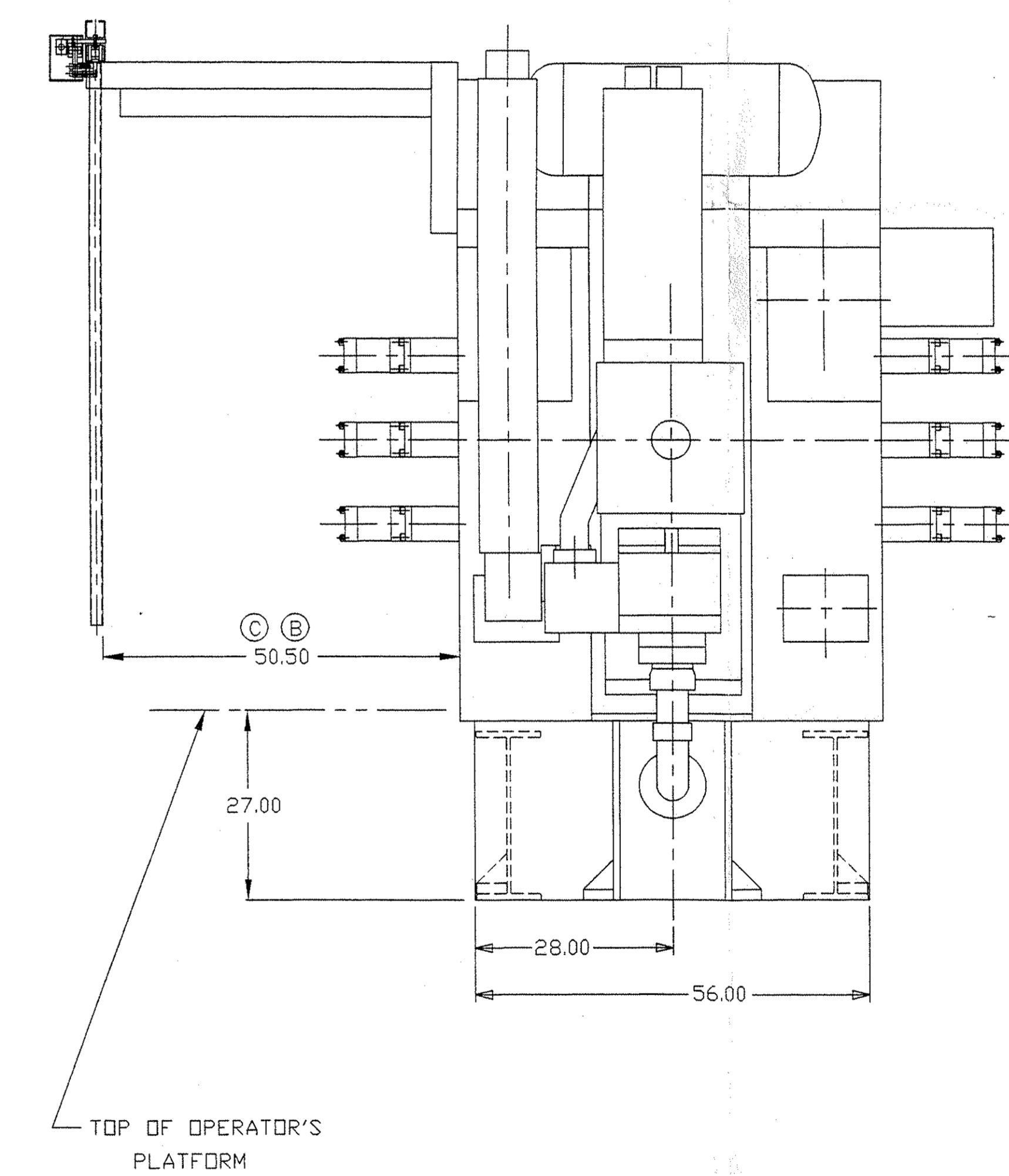
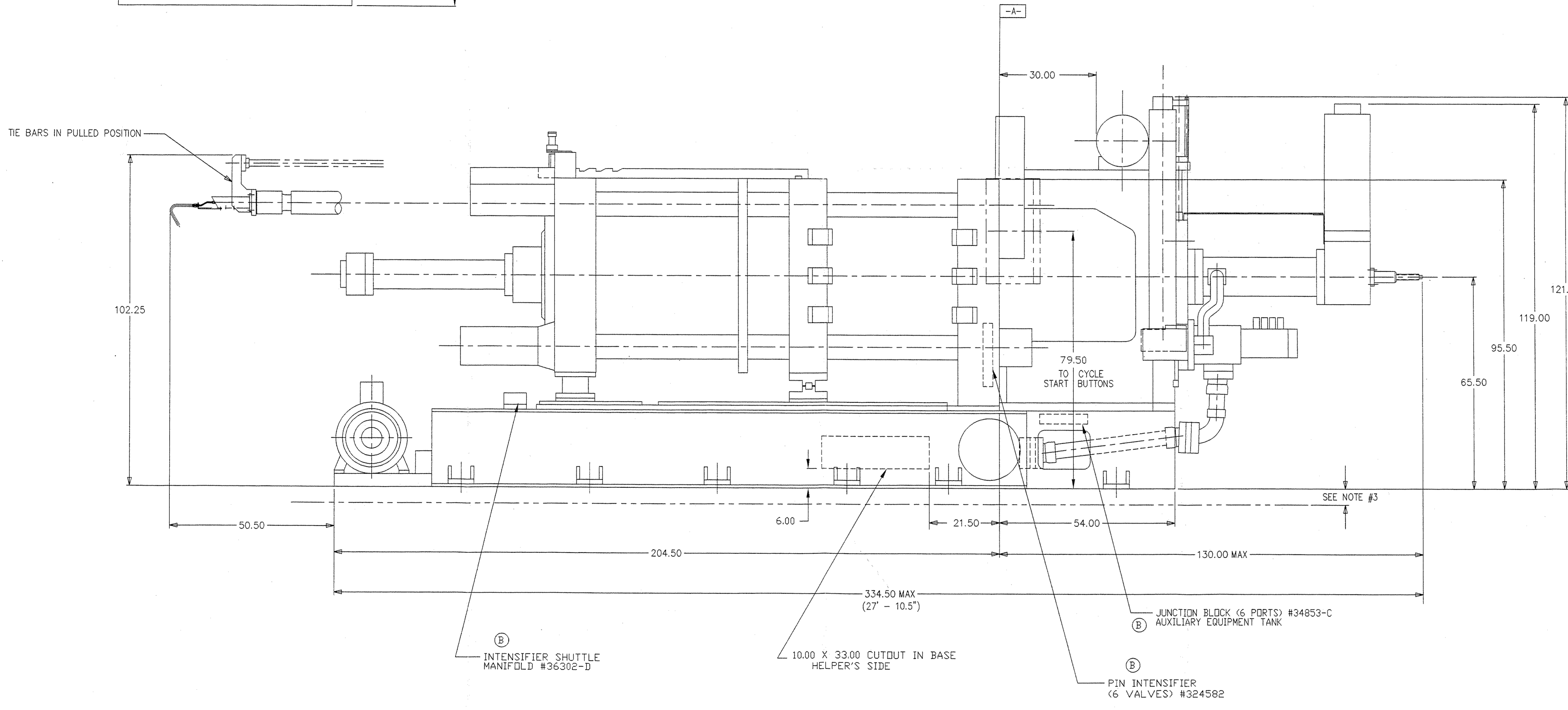
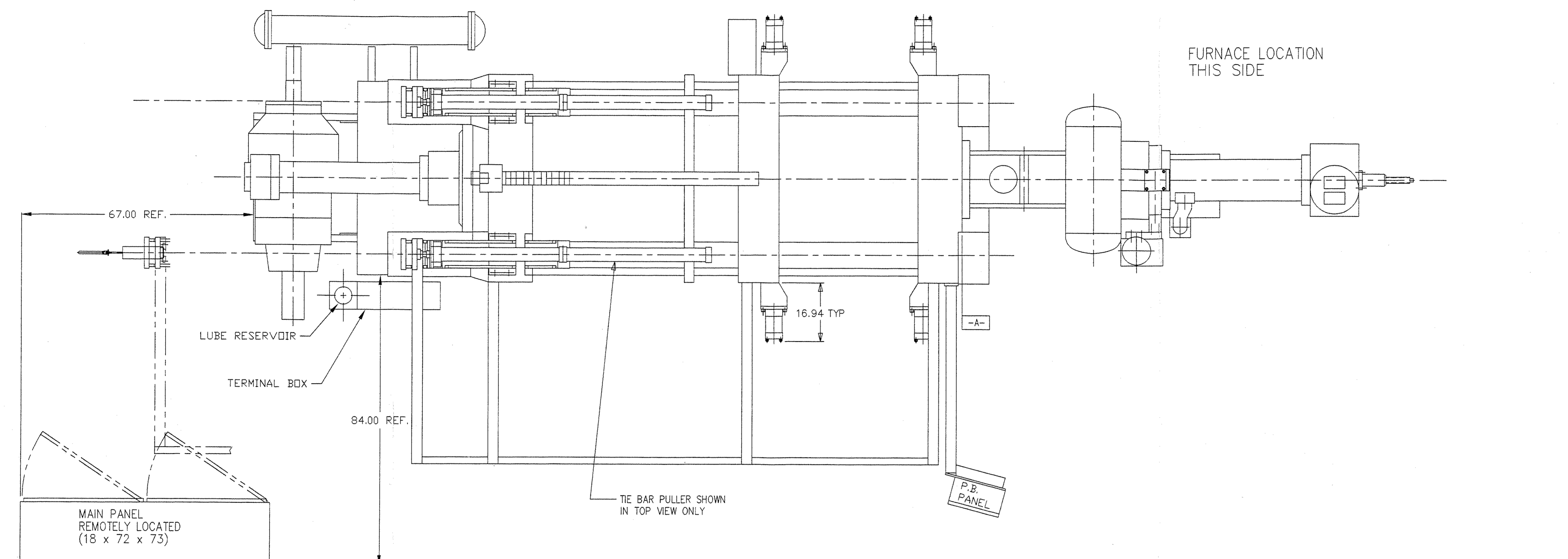
- PRINCE MACH.
- SPECIAL LENGTH REQUIREMENTS FOR BUMPER PINS WHICH FALL WITHIN THE  $\phi$  25.00 DRAWBAR LOCKING PLATE.
  - \*# INDICATES SPECIAL T-SLOTS FOR QUICK DIE CLAMP.
  - LOCATION OF T-SLOTS AND CLAMP STAKE HOLES IN MOVABLE PLATEN SAME AS STATIONARY PLATEN.

NOTES: 1. DO NOT SCALE DRAWING

<b>PROPRIETARY</b> 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.		MATERIAL PART TREATMENT FINISHED SIZE CATEGORY TOLERANCES DIMENSIONS UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS, TOLERANCES AND DIMENSIONS SHALL CONFORM TO PRINCE SPECIFICATION 4000-1	THIRD ANGLE PROJECTION NAME DIE INTERFACE, MODEL 836A SCALE 1:8 SHEET 1 OF 1	DRAWN BY RH DATE 10-28-93 CHECKED BY MLH DATE 10-28-93 DWS NO 50549-E 36450-D	DRAWING NO. 52562-E SHEET 1 OF 1	PRINCE MACHINE 52562-E C
---	--	--	--	---	---	--------------------------------

(MCCDDM)M0836A.011052562E

REVISIONS				
REV	DESCRIPTION	BY	DATE	ZONE
A	ORIGINAL DRAWING			
B	25.50 WAS 19.50	RH	1-4-93	C-2
	ADDED MANIFOLDS			
C	50.50 WAS 25.50	MLH	10-20-93	C-2



MACHINE SPECIFICATIONS	
MODEL	836
LOCKING TONNAGE	800 TONS
SPACE BETWEEN BARS	36.5" x 36.5"
TIE BAR DIAMETER	7.50 DIA
TIE BAR CENTERS	44.00" x 44.00"
STATIONARY PLATEN (T x W x H)	12.75 x 60.00 x 70.00
MOVABLE PLATEN (T x W x H)	11.75 x 60.00 x 60.00
DIE STROKE	22.00
DIE HEIGHT	20" - 40"
SHOT CYLINDER	6.0" B, 3.5" R, 22-27" S
SHOT POSITIONS	0, & -9°
RESERVOIR CAPACITY (APPROX.)	400 GAL.
HYDRAULIC FLUID	PRI-MAR GLYCOL FR-40XD. FLUID MUST BE COMPATIBLE WITH BUNA-N SEALS. SEAL MATERIAL SAMPLES ARE AVAILABLE FOR TESTING IF COMPATIBILITY IS UNCERTAIN.
SHIPPING WEIGHT	95,000 lbs
LUBE SYSTEM	TRABON OIL
RECOMMENDED LUBRICATION (TYPE & WEIGHT)	CITGO SLIDERITE 220
WATER REQUIREMENTS	35 GPM @ 85 DEGREES F.
ELECTRICAL POWER REQUIREMENTS	480 VOLTS 107 AMPS 3 PHASE
AIR REQUIREMENTS	60 PSI 5 CFM CONTINUOUS 50 CFM INTERMITTENT (FOR SAFETY DOOR CYCLE)
OTHER REQUIREMENTS	INCLUDES REQUIREMENTS FOR MACHINE LUBRICATION AND SAFETY DEVICE. DOES NOT INCLUDE ANCILLARY EQUIPMENT SUCH AS TRIM PRESS, SPRAY, QUENCH, AND FLUNGER LUBE.

REFERENCE DRAWINGS	
DWG NO	DRAWING NAME
48936-D	SUPPORT POINTS AND FLOOR LOADING LAYOUT
52562-E	DIE INTERFACE
52563-E	SHOT END LAYOUT
52564-E	LADLE AND FURNACE INTERFACE

PRINTS RELEASED  
JAN 21 1994

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

<b>PROPRIETARY</b> 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.		<b>PRINCE MACHINE</b> GENERAL INFORMATION MODEL 836A	
MATERIAL: _____ TEST TREATMENT: _____ FINISHED SIZE: _____	CATEGORY: _____ DIMENSIONS: _____ TOLERANCES: X .005 .XX .005 .XXX .005 .XXX .005 .XXX .001	DESIGNED BY: _____ DRAWN BY: _____ DATE: 10-30-92	CHECKED BY: _____ DATE: _____ SCALE: 1/16 SHEET NO: 1 OF 1
CAD NO MANUAL CHANGES		PART NO: 42571-D DRAWING NO: 52561-E	

K:\VIBRA\011\02\002\011\01\01\02561E