



North Central Stamping Specifications

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PRESS SPECIFICATIONS																			
PRESS NO.	Tonnage	Press	Type	Stroke	Adjustment Up Ram Down S.H.	Ram Adj.	Bolster		Ram		T - Slot	Pass Line Height	Strokes Per Min.	Die Protection	Sensor Channels	Cam Channels	Feeder Information		
							RL x FB	RL x FB	Max. Width	Material Thickness							Progressive Feedline		
1	150	Minster OBI	Gap Frame	9 3/4"	23.875"	6"	54" x 30" x 2 7/8"	36" x 24"	6" Ctr Lines	---	---	---	---	---	---	---	---	---	No Feeder
2	600	Brown & Bogg SS	Straight Side	14"	32"	12"	144" x 60"	144" x 60"	6" Ctr Lines	Adj	20 to 50	NPN /PNP	16	16	52"	0.125" x 52"	Yes		
3	100	Clearing	Straight Side	4"	15 3/4"	8"	48" x 30" X 4 1/2"	48" x 30"	Tap Hole Pattern	---	20 to 100	TBD	---	---	TBD	No Feeder			
4	100	Minster SS	Straight Side	6"	12.955	6"	30" x 24" X 4"	30" x 22"	Tap Hole Pattern	---	---	---	---	---	---	No Feeder			
5	300	Minster SS	Straight Side	10"	26"	6"	96" x 48"	96" x 48"	6" Ctr Lines	3 1/2" - 15"	14 to 80	NPN /PNP	8	8	26 3/4"	.015" x 30" ; .187" x 18"	Yes		
6	400	Brown & Bogg SS	Straight Side	10"	26"	10"	96" x 48"	96" x 48"	6" Ctr Lines	20 3/4" Adj	25 to 60	NPN /PNP	16	16	36"	.015" x 36" ; .312" x 12"	Yes		
7	200	Minster SS	Straight Side	12	26 1/2"	8"	36" x 60" X 2 7/8"	36" x 60"	Tap Hole Pattern	---	---	---	---	---	---	No Feeder			
8	100	Bliss	Straight Side	10"	19.132	6"	84" x 36" X 3 7/16"	84" x 36"	Tap Hole Pattern	---	---	---	---	---	---	No Feeder			
9	200	Minster 7 1/2	Straight Side	6"	19.625"	6"	34" x 46" X 6"	27 3/4" x 40"	6" Tap Hole Pattern	---	---	---	---	---	---	No Feeder			
10	75	Brown & Bogg SS	Gap Frame	6"	11 5/8"	3"	26" x 36" x 4"	28" x 20 1/2"	Tap Hole Pattern	---	---	---	---	---	---	No Feeder			
11	90	Cleveland	Gap Frame	6"	13.2	6"	38" x 26" x 3 7/8"	26" x 20"	Tap Hole Pattern	---	---	---	---	---	---	No Feeder			
12	200	BLISS	Straight Side	8"	17.270"	10"	60" x 48" x 5"	60" x 48"	6" Ctr Lines	---	20-40	NPN	8	8	12"	.020" TO .185"	Yes		
13	300	Bliss	Straight Side	12"	33 1/4"	10 1/2"	84" x 48" X 5 1/2"	84" x 48"	6" Ctr Lines	---	---	---	---	---	---	No Feeder			
14	200	Warco	Gap Frame	6"	15 3/4"	6"	48" x 30" X 7 1/2"	51" x 28"	Tap Hole Pattern	---	---	---	---	---	---	No Feeder			
15	400	Niagra	Straight Side	9"	18.442	14"	54" x 96" x 8"	54" x 96"	4 7/8" Ctr. Lines	---	0-23	NPN/PNP	8	8	24"	.020" x 24" ; .125" x 12"	Yes		

All measurements are in English inches All presses are mechanical All presses include knockouts S.H. MEANS SHUT HEIGHT MAXIMUM (MINIMUM SHUT SUBTRACT RAM ADJUSTMENT)

RESISTANCE WELDER SPECIFICATIONS										
Welder No.	Style	Brand	Type	KVA Size	Throat Depth	Platens	Controls	PSI Sensor	Error Proofing	Max Force(lbs.)
RW1	Press	Standard	PP1	100	12"	6" x 6"	Entron - EN6001	Yes	Keyence Vision	3100
RW4	Press	Standard	PP1	100	12"	6" x 6"	Entron - EN6001	Yes	Keyence Vision	3100
RW3	Press	Standard	PP1	100	15"	6" x 6"	Entron - EN6001	Yes	Keyence Vision	3100
RW2	Press	Federal	PA-2-12	150	12"	8" x 8"	Entron - EN6001	Yes	Keyence Vision	5500
RW5	Press	Taylor Winfield	ERC	150	12"	7" x 8"	Entron - EN6001	Yes	Keyence Vision	5500

ROBOTIC WELD CELL SPECIFICATIONS				
Welder No	Brand / Model	Power Source	Controls	Table Size
No. 1	Fanuc Arc Mate 100iB	Lincoln Powerwave F355i	Fanuc RJ-3iB	2 @ 36"D x 42"W

MULTI SENSOR MEASURING MACHINE (CMM) SPECIFICATIONS						
BRAND	MODEL	STYLE	MEASURING RANGE	SENSORS / FEATURES	ACCURACY	SOFTWARE
ZEISS	O-INSPECT 863	BRIDGE	31" x 23" x 11"	ZEISS VAST XXT (contact) ZEISS DISCOVERY V.12 ZOOM LENSE (optical) CONFOCAL WHITE LIGHT DISTANCE SENSOR (optical	1.9 µm	CALYPSO
ROMER	ABSOLUTE	ARM	6.6 ft	RS4 PROBE SCANNER RS4 INTERGRATED LASER SCANNER	.0024"	RDS POLYWORKS DEZIGNWORKS