Dishing Unit with NC PLAYBACK control Brand:SMT Schleifstein

Hydraulic Frame Press Type **RHP400/5 CL**
Serial number :1.1989.0 Year 2001

Technical data of the press:

Max. pressure	about 4000 kN
Max. retraction force	about 347 kN
Rapid motion downwards	about 250 mm/sec.
Pressing motion downwards	about 26.2 – 16 mm/sec.
Idling stroke upwards	about 300 mm/sec.
Maximum working pressure	about 251 bar
Clear width of frame	about 5000 mm
Dimensions of standard table plate	about 1200 x 1200 mm
Dimensions of ram clamping plate	about Ø 800 mm
Press frame	manufactured in two parts
Max. plate thickness to be dished: (recommended, with big Ø 1400mm die)	
a) with boiler plate	about 26mm
b) with stainless steel	about 19mm
Max. diameter of the flat round	about 4900mm
Installed power	about 75 kW
Service voltage (supposed)	3x 400 V, 50 Hz,N,PE
Control voltage	24 V DC
Valve voltage	24 V DC
Weight of the press	about 30.000 Kg

Manipulator **VMB 4926CL**
Serial number :1.1990.0 Year 2001

Technical data of the manipulator

Max. dimensions of the flat round or	about Ø4900x26mm
Max. allowed weight of workpiece	about 4000 Kg
Min. diameter of the flat round:	
with table size 1200 x 1200 mm (standard)	about 1950mm
with table size 700 x 700 mm (optional)	about 1300mm
Installed power	about 18 kW
Service voltage (supposed)	3x 400V, 50 Hz,N,PE
Control voltage	24 V DC
Valve voltage	24 V DC
Weight of the manipulator	about 13.500 Kg

NC PLAYBACK Control

For the full automatic control of the dishing unit in PLAY-BACK-Mode, including Automatic setting of the dishing unit on a new round (disc) diameter in max. 3 minutes, including: proportional electric control and visualisation via a Siemens Touch Panel; all distance and position measuring systems; hydraulic swivel beam locking; proportional hydraulic valves for the swivel beam distance; cable drum, cable chains, etc.
The PLAY-BACK-control is connected with the standard electric control and is installed in one shared switch cabinet. It is a software and visualisation package on top af the standard control. The operation is done by means of a mobile control panel with an Siemens Industrial-PC and all necessary control devices. All axes have analog position sensors (no reference run necessary). A hydraulic locking stops the swivelling beam in the corresponding holes of the two round guides.