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Straight-sided high-speed mechanical power presses -- Types and basic parameters

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Foreword

This Standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This Standard uses redrafting method to modify and adopt ISO 9189.1993 "Machine tools - Straight-sided high-speed mechanical power presses from 250kN up to and including 4000kN nominal force - Characteristics and dimensions".

Compared with ISO 9189.1993, this Standard made structural adjustment to Clause 3, setting subclauses of 3.1 and 3.2.

The technical differences and reasons between this Standard and ISO

9189.1993 are as follows.

- the scope of application was extended to 6300kN so as to adapt to the development of closed high-speed press industry in China;
- added the "nominal force stroke" parameters so as to meet the needs of China's stamping process;
- added the "number of strokes" parameter so as to meet the needs of China's stamping process;
- added the parameter value of 6300kN specification in Table 1 so as to guide the design and manufacture of closed high-speed press products in China;
- modified the parameter value of mold height adjustment amount hv so as to adapt to the requirements of China's stamping process.

This Standard also made the following editorial modifications.

- modified the standard name.

This Standard was proposed by China Machinery Industry Federation.

This Standard shall be under the jurisdiction of National Technical Committee on Forging Machinery of Standardization Administration of China (SAC/TC 220).

The drafting organizations of this Standard. Jiangsu Xuzhou Forging Machine Tool Group Co., Ltd., Shandong Laien Photoelectric Technology Co., Ltd., Zhejiang Yi Forging Precision Machinery Co., Ltd., Shenzhen Huace Testing Co., Ltd., Fujian Haoxuan Technology Co., Ltd., Quanzhou Zhongzheng Standardization Research Institute Co., Ltd.

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Straight-sided high-speed mechanical power presses - Types and basic parameters

1 Scope

This Standard specifies the types and basic parameters of straight-sided high-speed mechanical power presses of which the nominal force range is 250kN~6300kN.

This Standard is applicable to straight-sided high-speed mechanical power presses of general use.

2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

2.1 high-speed press

a high-speed automatic press of which the slider has a multiple number of strokes per minute than the universal press with the same nominal force; not suitable for the press with single stroke, manual feeding operation, that requires automatic feeding device to work together

2.2 nominal force, Fn

the maximum force allowed on the slider over a distance before the bottom dead center

2.3 shut height normal slide stroke, en

the distance between the bottom of the slider and the plane on the pad of the table when the height of the mold is adjusted to the upper limit and the slider is at the bottom dead center

2.4 adjustable feed height, hf

the height measured from the plane of the table pad

NOTE. The following formula can be used to determine the fixed feed height.

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