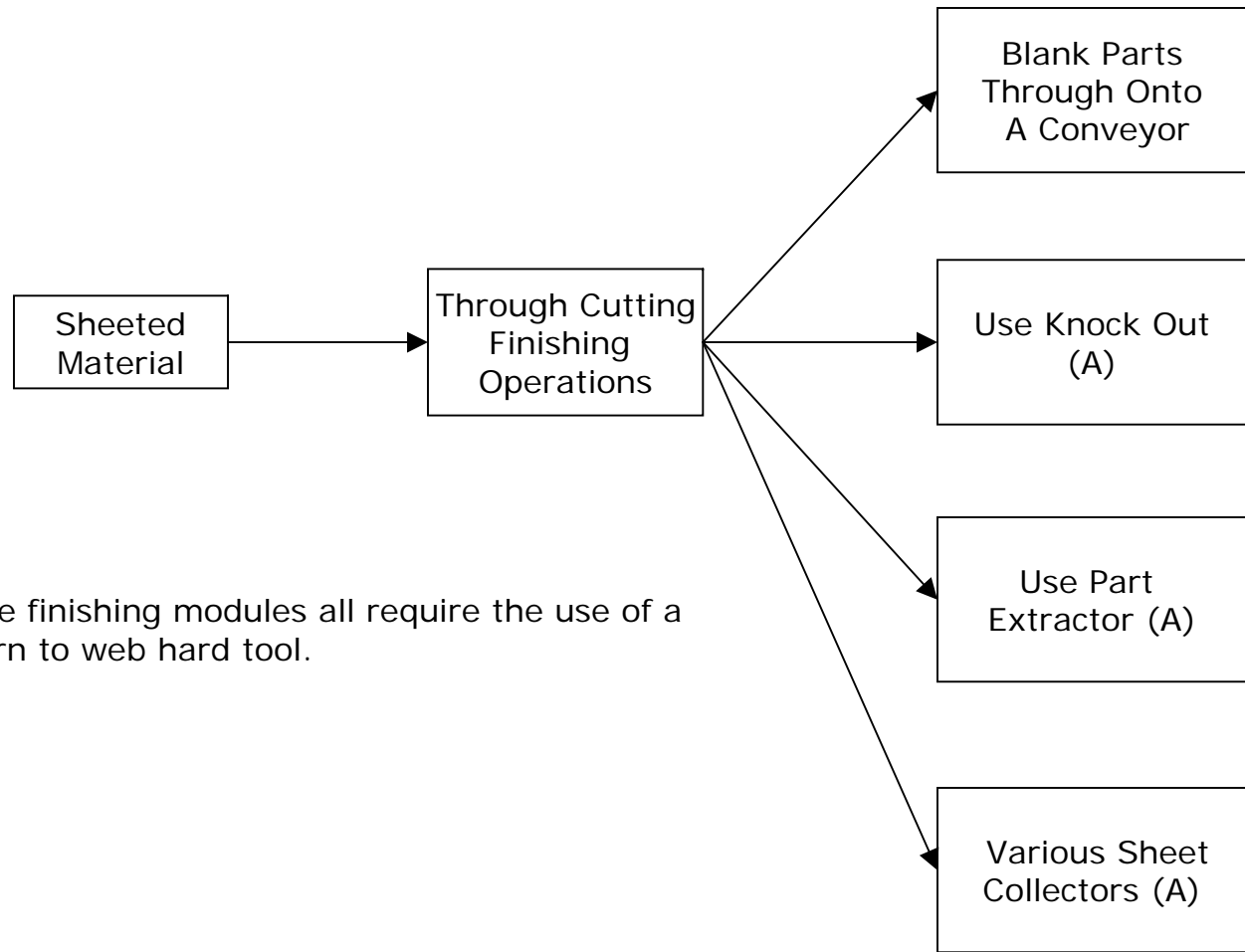


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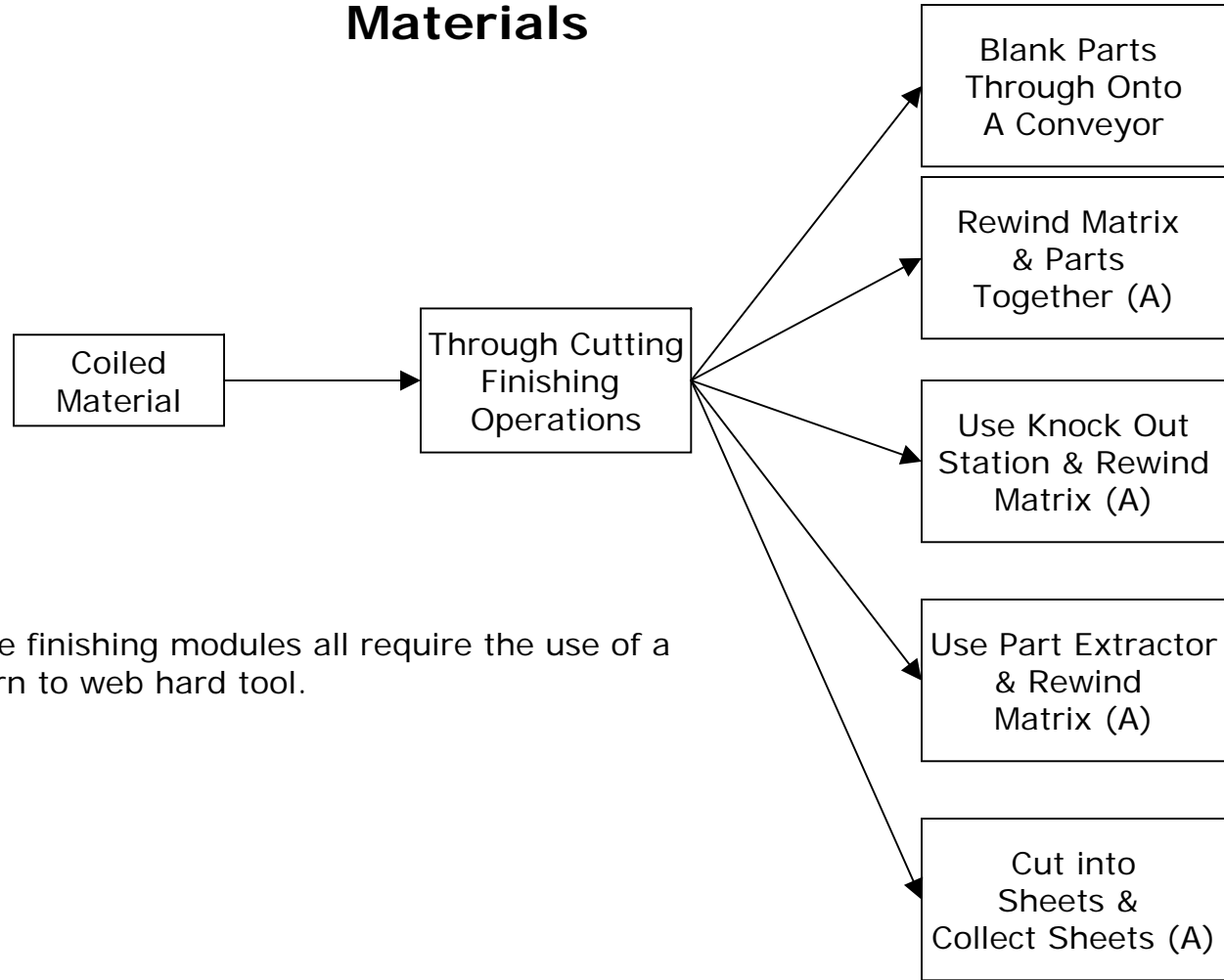
Hard Tool Punching & Die Cutting Sheeted Materials



(A) These finishing modules all require the use of a return to web hard tool.

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Hard Tool Punching & Die Cutting Coiled Materials



(A) These finishing modules all require the use of a return to web hard tool.

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M500 PRESS SPECIFICATIONS

	5 Ton ³	10 TonCE	15 TonCE	20 TonCE	30 TonCE	30 Ton DTCE	40 TonCE	50 TonCE	50 Ton DTCE	75 TonCE
Normally Stocked In Inventory¹	No	No	No	Yes	Yes	Yes	No	Yes	No	No
Strokes per Minute	285	190	165	155	145	145	145	140	140	120
Overload Protection	None	None	None	None	Mechanical	Mechanical	Mechanical	Hydraulic	Hydraulic	Hydraulic
Throat Depth (N)²	7.00"	5.12"	6.11"	6.11"	7.29"	15.0"	7.68"	9.06"	15.0"	10.24"
Bed dimensions										
Depth (L)	6.00"	9.46"	11.82"	11.82"	14.18"	30.00"	14.97"	17.34"	30.00"	19.70"
Width (M)	12.00"	14.18"	15.76"	17.73"	22.85"	22.85"	25.61"	29.55"	29.55"	31.52"
Distance between shoulders (O)	6.88"	4.53"	6.30"	6.93"	7.88"	7.88"	9.46"	12.20"	12.20"	14.18"
Automatic Lubrication	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Adjustable stroke	1" only	0.24"-1.58"	0.28"-2.36"	0.24"-2.36"	0.35"-2.99"	0.35"-2.99"	0.32"-3.07"	0.47"-4.33"	0.47"-4.33"	0.55"-5.52"
Ram Adjustment	1.50"	1.18"	1.58"	1.97"	2.36"	2.36"	2.36"	2.76"	2.76"	2.76"
Ram Surface										
Depth (R)		3.54"	4.09"	7.48 "	9.84"	9.84"	9.84"	11.81"	11.81"	14.96"
Width (S)		4.33 "	9.06"	10.95"	19.78"	19.78"	19.78"	17.72"	17.72"	22.05"
Shut height (H)⁴	8.00"	7.48"	9.06"	10.63"	12.28"	12.28"	13.29"	13.58"	13.58"	14.96"
Bolster plate thickness (G)	None	1.42"	1.77"	1.97"	2.36"	2.36"	2.36"	2.36"	2.36"	2.56"
Optional Variable Speed Motor	No	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Type of Clutch	Roller	Air	Air	Air	Air	Air	Air	Air	Air	Air
Height of work surface (F)	33.00"	32.31"	31.32"	31.10"	31.52"	31.52"	31.52"	31.52"	31.52"	33.49"
Net weight	N/A	992 lbs	1,388 lbs	2,203 lbs	3,965 lbs	4,295 lbs	4,846 lbs	7,049 lbs	8,635 lbs	11,454 lbs
Overall Press Dimensions										
Height (A)	60.00"	63.0"	64.4"	74.8"	88.7"	88.7"	91.0"	98.8"	98.8"	110.2"
Width (B)	40.00"	51.2"	64.2"	49.6"	51.1"	51.1"	57.5"	64.2"	64.2"	70.9"
Depth (C)	27.00"	51.8"	41.3"	40.0"	45.3"	59.3"	48.4"	48.8"	64.2"	56.3"

¹ Presses that are not normally stocked might be in inventory, but frequently must be ordered from the press manufacturer with a 3 month to 5 month lead time.

² The alpha characters refer to the Sangiacomo press catalog drawings.

³ The 5 ton press is manufactured by Kenco.

⁴ The Shut Height of the presses is measured at bottom dead center with 0 stroke and the ram adjustment in the maximum upward position. This measurement is made without the bolster plate in place.

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M500 PRESS SPECIFICATIONS

	5 Ton ³	10 TonCE	15 TonCE	20 TonCE	30 TonCE	30 Ton DTCE	40 TonCE	50 TonCE	50 Ton DTCE	75 TonCE
Normally Stocked In Inventory ¹	No	No	No	Yes	Yes	Yes	No	Yes	No	No
Strokes per Minute	285	190	165	155	145	145	145	140	140	120
Overload Protection	None	None	None	None	Mechanical	Mechanical	Mechanical	Hydraulic	Hydraulic	Hydraulic
Throat Depth (N) ²	178 mm	130 mm	155 mm	155 mm	185 mm	380 mm	195 mm	230 mm	380 mm	260 mm
Bed dimensions										
Depth (L)	152 mm	240 mm	300 mm	300 mm	360 mm	760 mm	380 mm	440 mm	760 mm	500 mm
Width (M)	305 mm	360 mm	400 mm	450 mm	580 mm	580 mm	650 mm	750 mm	750 mm	800 mm
Distance between shoulders (O)	175 mm	115 mm	160 mm	176 mm	200 mm	200 mm	240 mm	310 mm	310 mm	360 mm
Automatic Lubrication	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Adjustable stroke	25.4 mm only	6-40 mm	7-60 mm	6-60 mm	9-76 mm	9-76 mm	8-78 mm	12-110 mm	12-110 mm	14-140 mm
Ram Adjustment	38 mm	30 mm	40 mm	50 mm	60 mm	60 mm	60 mm	70 mm	70 mm	70 mm
Ram Surface										
Depth (R)		90 mm	104 mm	190 mm	250 mm	250 mm	250 mm	300 mm	300 mm	380 mm
Width (S)		110 mm	230 mm	278 mm	350 mm	350 mm	350 mm	450 mm	450 mm	560 mm
Shut height (H) ⁴	203 mm	190 mm	230 mm	270 mm	312 mm	312 mm	336 mm	345 mm	345 mm	380 mm
Bolster plate thickness (G)	None	36 mm	45 mm	50 mm	60 mm	60 mm	60 mm	60 mm	60 mm	65 mm
Optional Variable Speed Motor	No	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Type of Clutch	Roller	Air	Air	Air	Air	Air	Air	Air	Air	Air
Height of work surface (F)	838 mm	820 mm	795 mm	790 mm	800 mm	800 mm	800 mm	800 mm	800 mm	850 mm
Net weight	N/A	450 kg	630 kg	1000 kg	1800 kg	1950 kg	2200 kg	3200 kg	3920 kg	5200 kg
Overall Press Dimensions										
Height (A)	1525 mm	1600 mm	1635 mm	1900 mm	2250 mm	2250 mm	2310 mm	2510 mm	2510 mm	2800 mm
Width (B)	1015 mm	1300 mm	1630 mm	1260 mm	1350 mm	1350 mm	1460 mm	1630 mm	1630 mm	1800 mm
Depth (C)	685 mm	1315 mm	1050 mm	1000 mm	1150 mm	1500 mm	1230 mm	1240 mm	1630 mm	1430 mm

¹ Presses that are not normally stocked might be in inventory, but frequently must be ordered from the press manufacturer with a 3 month to 5 month lead time.

² The alpha characters refer to the Sangiacomo press catalog drawings.

³ The 5 ton press is manufactured by Kenco.

⁴ The Shut Height of the presses is measured at bottom dead center with 0 stroke and the ram adjustment in the maximum upward position. This measurement is made without the bolster plate in place.

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M500 Conveyors For Hard Tool Card Punching Systems

	2-Up Card Layout	3-Up Card Layout	4-Up Card Layout	5-Up Card Layout
No. of Divided Lanes	2	3	4	5
Width of Lanes				
<i>Short Step Up (Portrait)</i>	3.5"	3.5"	3.5"	Contact Office
<i>Long Step Up (Landscape)</i>	2.3"	2.3"	2.3"	2.3"
Working Length of Conveyor ¹	67"	67"	67"	67"
Variable Speed Motor	Optional	Optional	Optional	Optional
Approximate Working Height	37"	37"	37"	37"
Operator Working Surface				
<i>Length</i>	45"	45"	45"	45"
<i>Width</i>	8.5"	8.5"	8.5"	8.5"

¹ Defined as the approximate distance from the discharge side of the die set to the end of the conveyor.

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M500 Conveyors For Hard Tool Card Punching Systems

	2-Up Card Layout	3-Up Card Layout	4-Up Card Layout	5-Up Card Layout
No. of Divided Lanes	2	3	4	5
Width of Lanes				
<i>Short Step Up (Portrait)</i>	88.9 mm	88.9 mm	88.9 mm	Contact Office
<i>Long Step Up (Landscape)</i>	58.4 mm	58.4 mm	58.4 mm	58.4 mm
Working Length of Conveyor ¹	170 cm	170 cm	170 cm	170 cm
Variable Speed Motor	Optional	Optional	Optional	Optional
Approximate Working Height	94 cm	94 cm	94 cm	94 cm
Operator Working Surface				
<i>Length</i>	114 cm	114 cm	114 cm	114 cm
<i>Width</i>	21.6 cm	21.6 cm	21.6 cm	21.6 cm

¹ Defined as the approximate distance from the discharge side of the die set to the end of the conveyor.

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M500 Conveyors For Hard Tool Card Punching Systems

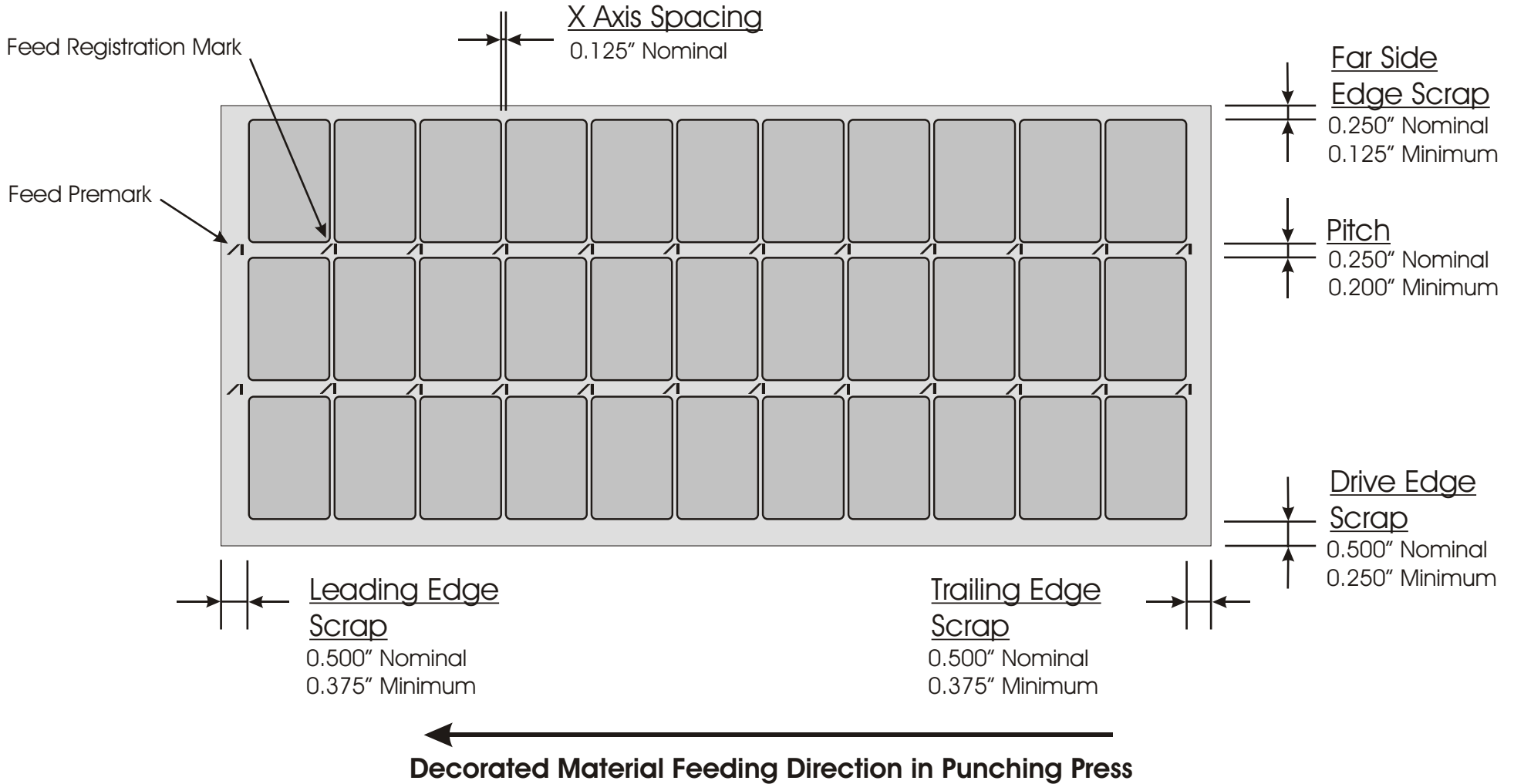
	2-Up Card Layout	3-Up Card Layout	4-Up Card Layout	5-Up Card Layout
No. of Divided Lanes	2	3	4	5
Width of Lanes				
<i>Short Step Up (Portrait)</i>	88.9 mm	88.9 mm	88.9 mm	Contact Office
<i>Long Step Up (Landscape)</i>	58.4 mm	58.4 mm	58.4 mm	58.4 mm
Working Length of Conveyor ¹	170 cm	170 cm	170 cm	170 cm
Variable Speed Motor	Optional	Optional	Optional	Optional
Approximate Working Height	94 cm	94 cm	94 cm	94 cm
Operator Working Surface				
<i>Length</i>	114 cm	114 cm	114 cm	114 cm
<i>Width</i>	21.6 cm	21.6 cm	21.6 cm	21.6 cm

¹ Defined as the approximate distance from the discharge side of the die set to the end of the conveyor.

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M500 Punching System

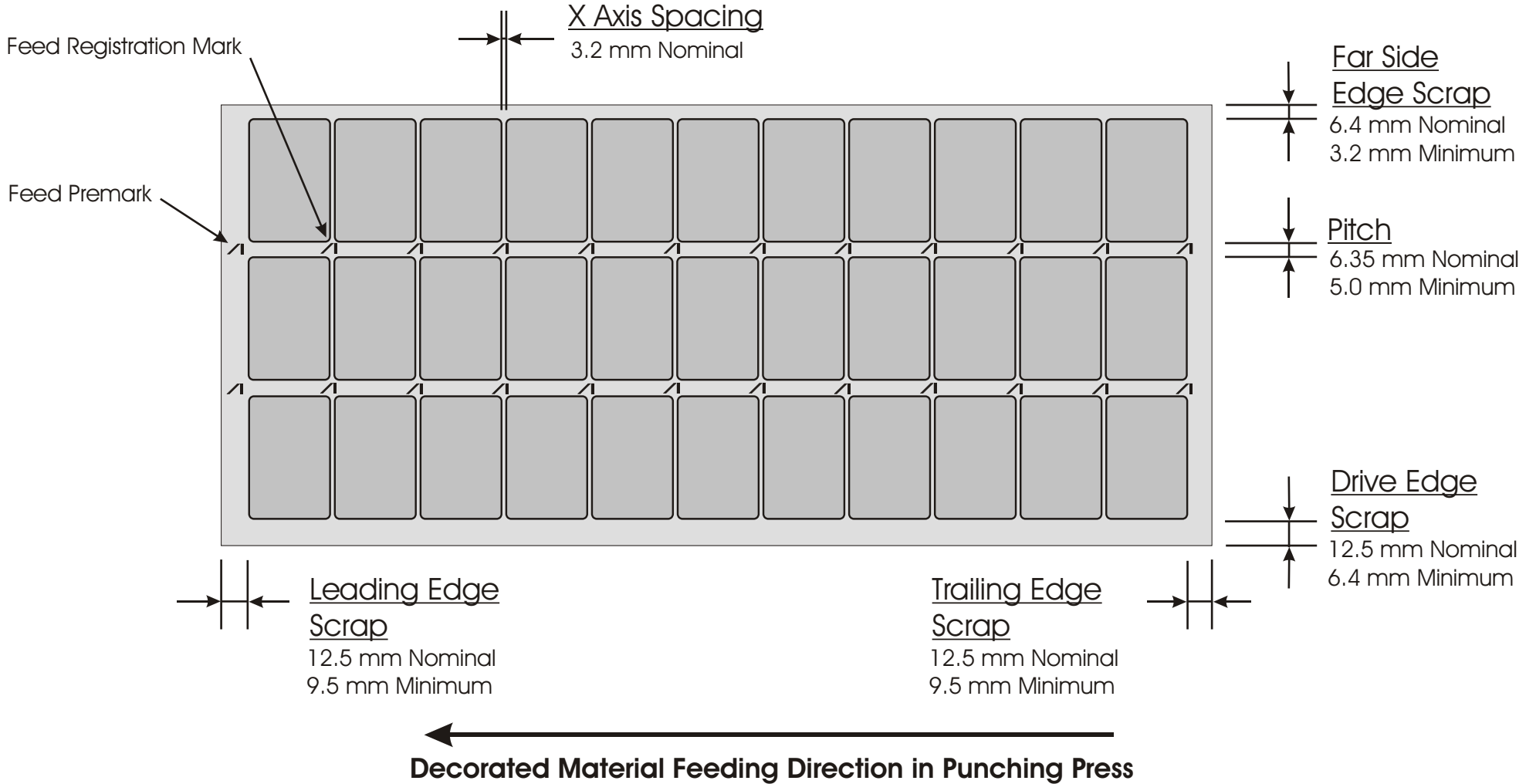
Typical Card/Part Spacing and Scrap Allowances for Hard Tools



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M500 Punching System

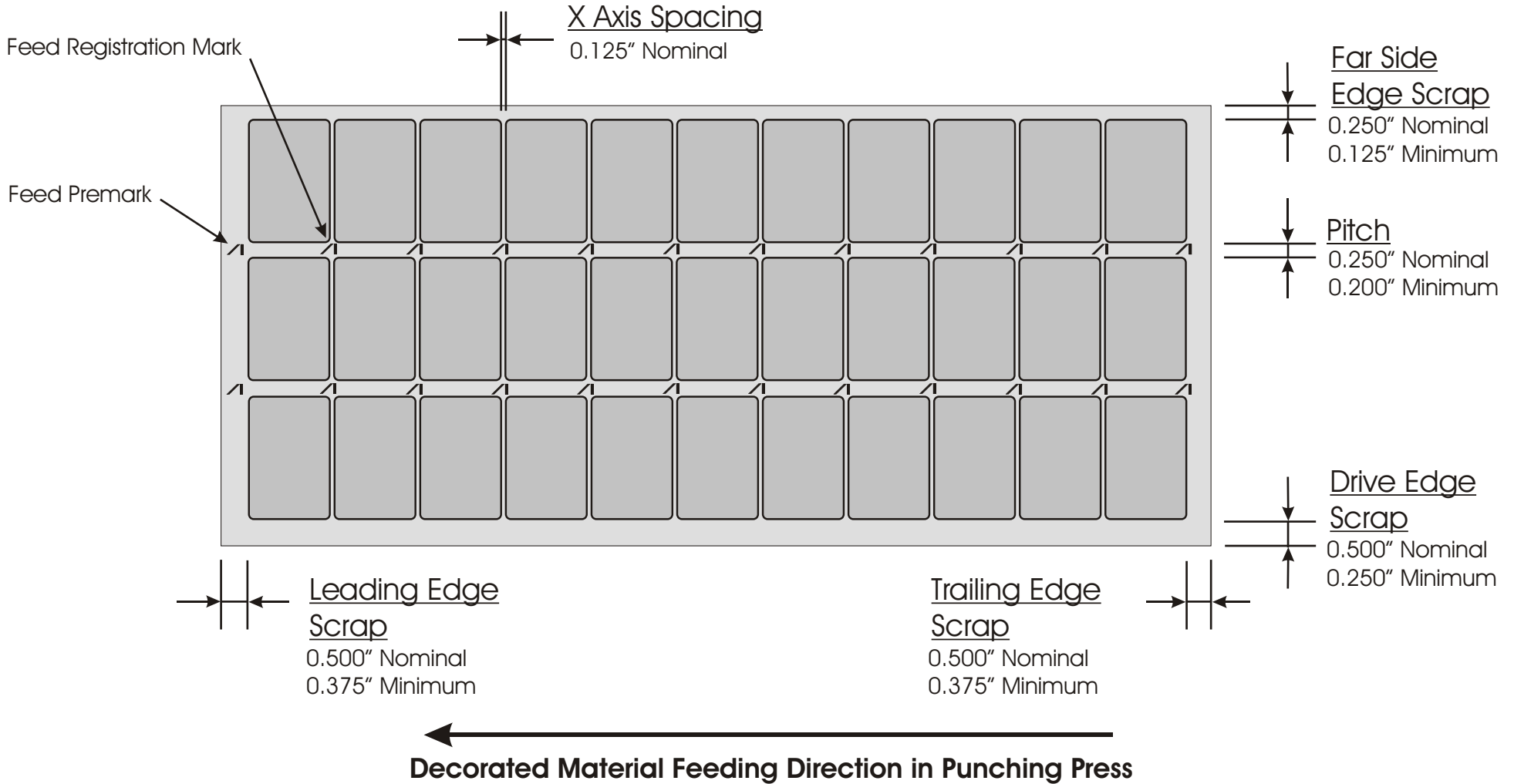
Typical Card/Part Spacing and Scrap Allowances for Hard Tools



Spartanics

M500 Punching System

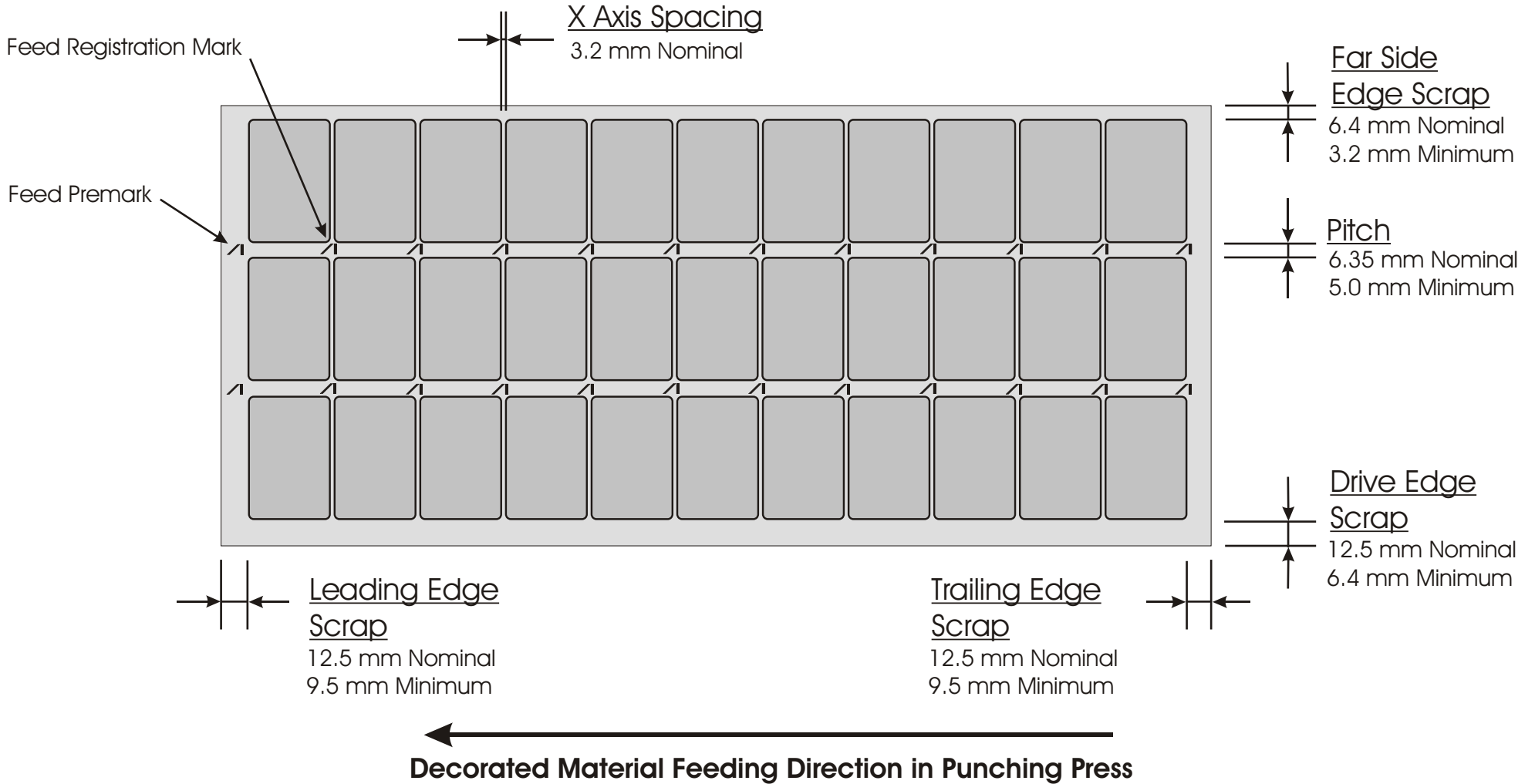
Typical Card Spacing and Scrap Allowances



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M500 Punching System

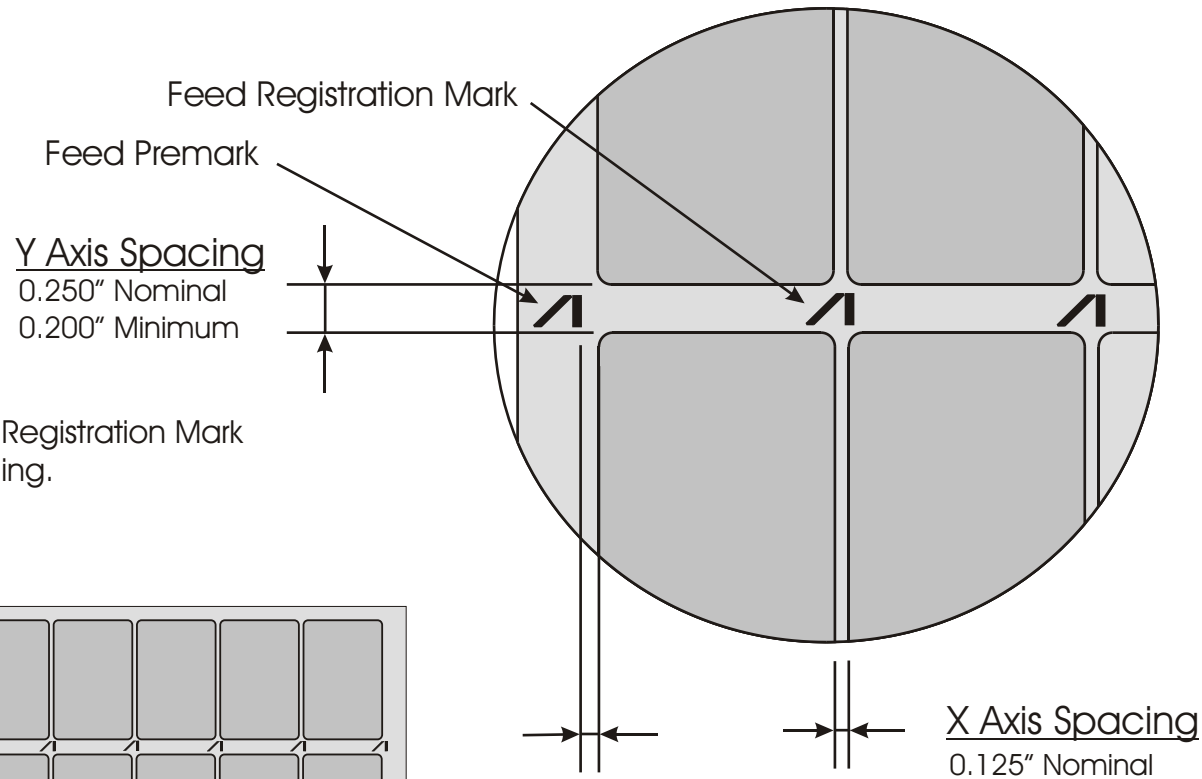
Typical Card Spacing and Scrap Allowances



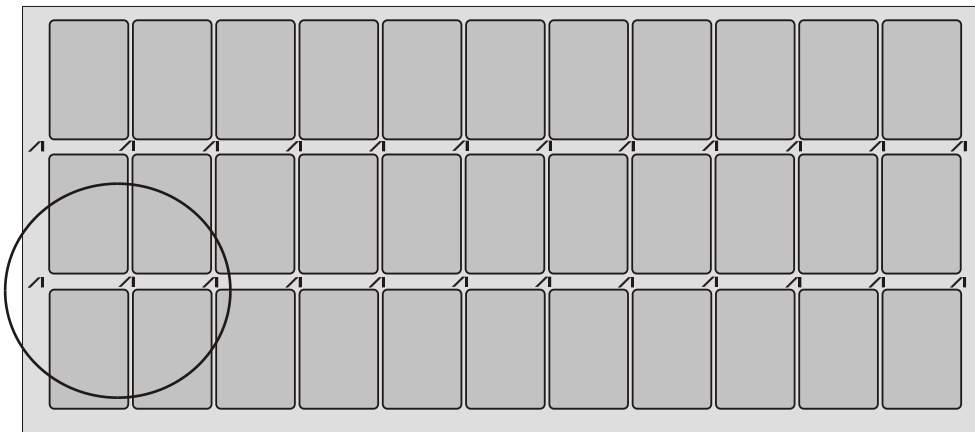
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M500 Punching System

Typical Feed Premark and Feed Registration Mark Postions



Both the Feed Premark and the Feed Registration Mark should be centered in the Y Axis Spacing.



Decorated Material Feeding Direction in Punching Press

The Feed Registration Mark should be approximately centered in the X Axis Spacing between the vertical columns of cards.

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M95 Autocutter Registration Marks

