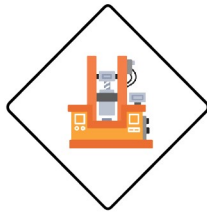


Double Action Deep Drawing Press



TL PATHAK GROUP Hydraulic Deep Draw Press are designed and developed through years of experience in sheet metal working machines. THEY are widely accepted in industries for continuous production runs and in areas requiring accuracy and respectability coupled with high production.

- ▶ Five cylinders double action deep draw press with mechanical eject system.
- ▶ Two cylinders single action pin type deep draw press.

Uses & Application :- Electric motor fan cover, Every type of penal boxes, special type of furniture and tube light boxes, Kitchen ware products, S.S. Kitchen sinks, S.S. washbasin, pressure cooker, etc.

Frame :- Column and Bottom are Fabricated from heavy mild steel with facing and machining.

Cylinder :- Hydraulic cylinders are made out from seamless pipe with accurate boring, grinding, honing and piston from special rigid steel with same accuracy with U-cup / chevron packing, and rubber O-Ring, etc.

Power pack :- Required power pack is provided with Gear pump, Vane pump, Plunger pump, Control valve, Connecting hoses pipes, Pressure meter, etc.

System of operating :- Hydraulic deep draw press is available in Hand Lever Direction Control valve and Automatic Electric penal with push button operating.



SPECIFICATION

| Technical Data | PDDP 30 | PDDP 60 | PDDP 100 | PDDP 150 | PDDP 250 |
|---|--------------|--------------|--------------|--------------|--------------|
| Maximum Pressure Force | 30 M.T. | 60 M.T. | 100 M.T. | 150 M.T. | 150 M.T. |
| Maximum Opening Force | 15 M.T. | 30 M.T. | 50 M.T. | 50 M.T. | 1000 M.T. |
| Size of platen table | 380 X 380 mm | 500 X 500 mm | 600 X 600 mm | 700 X 700 mm | 900 X 900 mm |
| Maximum Daylight | 450 mm | 600 mm | 700 mm | 800 mm | 1000 mm |
| Minimum Daylight | 250 mm | 300 mm | 350 mm | 400 mm | 500 mm |
| Difference between side column | 400 mm | 530 mm | 640 mm | 750 mm | 950 mm |
| Maximum stroke of piston | 200 mm | 300 mm | 350 mm | 400 mm | 500 mm |
| Capacity deep draw | 125 mm | 150 mm | 150 mm | 200 mm | 250 mm |
| Maximum working pressure | 320 ATM | 320 ATM | 320 ATM | 320 ATM | 320 ATM |
| Downward piston speed under low pressure | 75 mm/sec | 70 mm/sec | 50 mm/sec | 60 mm/sec | 50 mm/sec |
| Downward piston speed under high pressure | 4 mm/sec | 2.2 mm/sec | 1.3 mm/sec | 1.6 mm/sec | 3.2 mm/sec |
| Upward piston speed under low pressure | 75 mm/sec | 70 mm/sec | 50 mm/sec | 60 mm/sec | 50 mm/sec |
| Upward piston speed under high pressure | 7 mm/sec | 4 mm/sec | 2.2 mm/sec | 4.5 mm/sec | 6.4 mm/sec |
| Electric Motor | 3 H.P. | 5 H.P. | 7.5 H.P. | 10 H.P. | 15 H.P. |