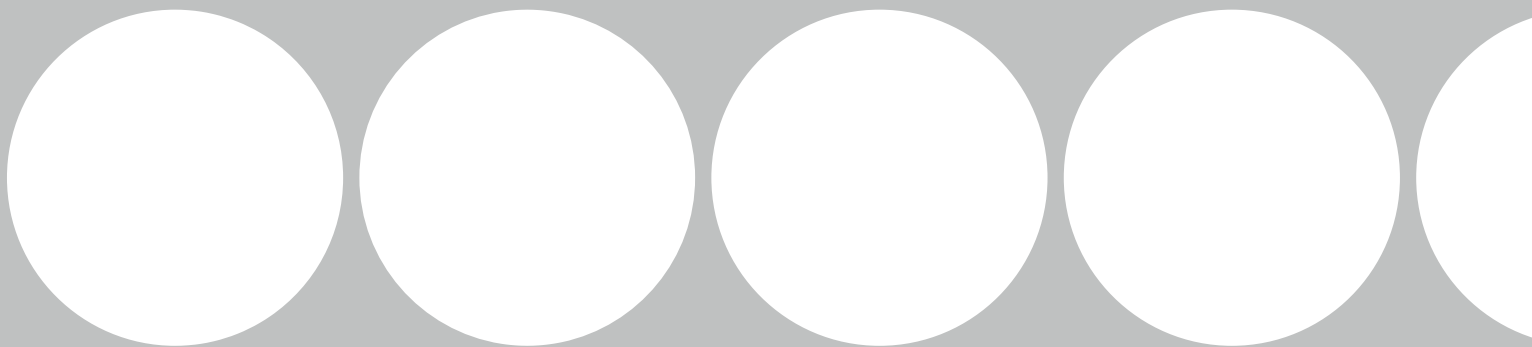
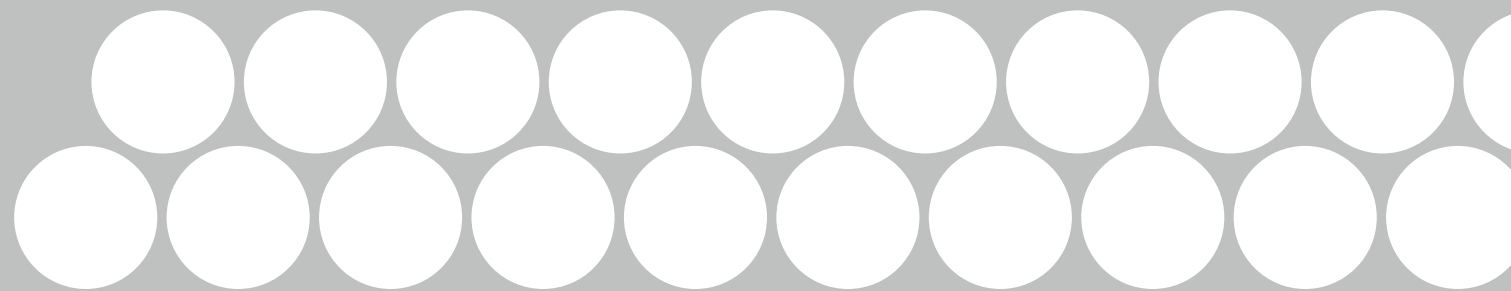
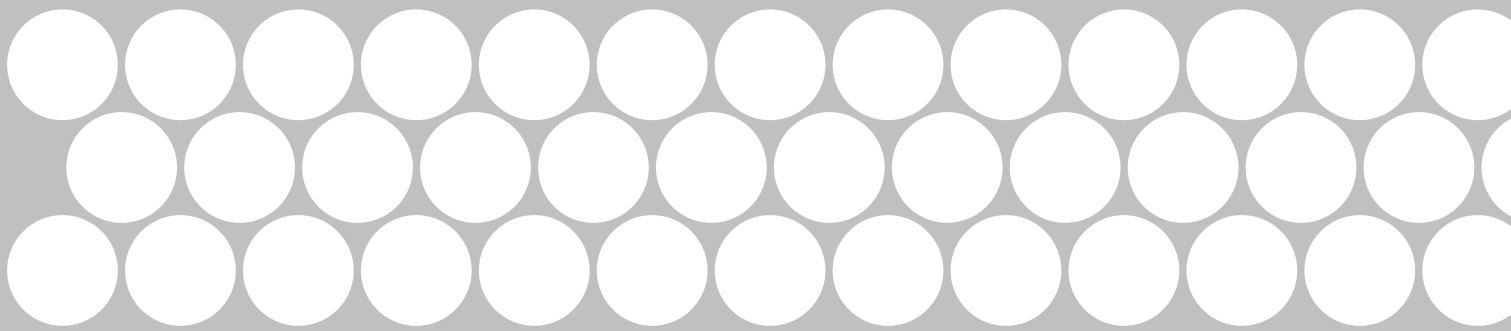




Double-Action Blank and Cup Press



Multiple-Row Blanking & Cupping

Double-Action Blank and Cup Press

... SIGNIFICANT MATERIAL COST SAVINGS

Waterbury Farrel Double Action Blank and Cup Presses are ideally suited for high volume production of cups to be used as input for downstream metal forming processes.

Available in five sizes, these presses are cam-actuated on the blank slide and crank actuated on the cupping slide. A cam-driven outer slide performs the blanking and holding operations. Blanking punches serve as a blank hold down mechanism and are individually adjustable for hold down pressure when multiple blanking.

The cam drive permits "dwell" at the bottom of the stroke. This dwell provides additional time to fully draw the metal from under the combination blanking punch and hold down sleeve. A crank actuated center slide carries the cup drawing tools and operates through the center of the combination blanking punch and hold down.

The action of the Press is purely mechanical with no pneumatic or hydraulic pads required. The full tonnage capacity of the Press is available for the work being performed, since no tonnage is lost overcoming reaction forces of pressure pads.

Waterbury Farrel Blank and Cup Presses are available with a series of customizable options, including a double crank design for heavier material and reduced holding pressure.

Typical Features

- 1 / Variable Speed Drive
- 2 / Positive Machine Lubrication System
- 3 / Roll Feed Mechanism
- 4 / Stock Lubrication System
- 5 / Scrap Chopper
- 6 / Extra Long Gibbing for Precision Guidance



Double-Action Blank and Cup Press Installation



Double-Action Blank and Cup Press Specifications

Machine Size		A	B	C	D	E
Max. Stock Thickness	In.	0.04	0.04	0.04	0.04	0.03
Shear Tonnage	ton	20	35	50	70	100
Draw Tonnage	ton	15	25	35	50	70
Blank Slide Sh. Ht.	In.	9	11	13	15	15
Blank Slide Stroke	In.	1¼	1¼	1¼	1¼	2
Blank Slide Adj.	In.	1	1	1	1	1
Cup Slide Sh. Ht.	In.	12	14	16	18	18
Cup Slide Stroke (Max.)	In.	5 ½	8	12	12	12
Cup Slide Adj.	In.	2	2	2	2	2
Bed Dim. (L-R x F. B)	In.	16 x 24	19 x 26	24 x 38	30 x 49	38 x 56
Max. Cup Length	In.	1 ¾	2 ¾	4 ¼	4 ¼	4 ¼
Overall Width	In.	50	58 ½	69	83 ½	96
Overall Length	In.	57	61 ½	78	96	104
Overall Height	In.	128	144 ½	162	178	205





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