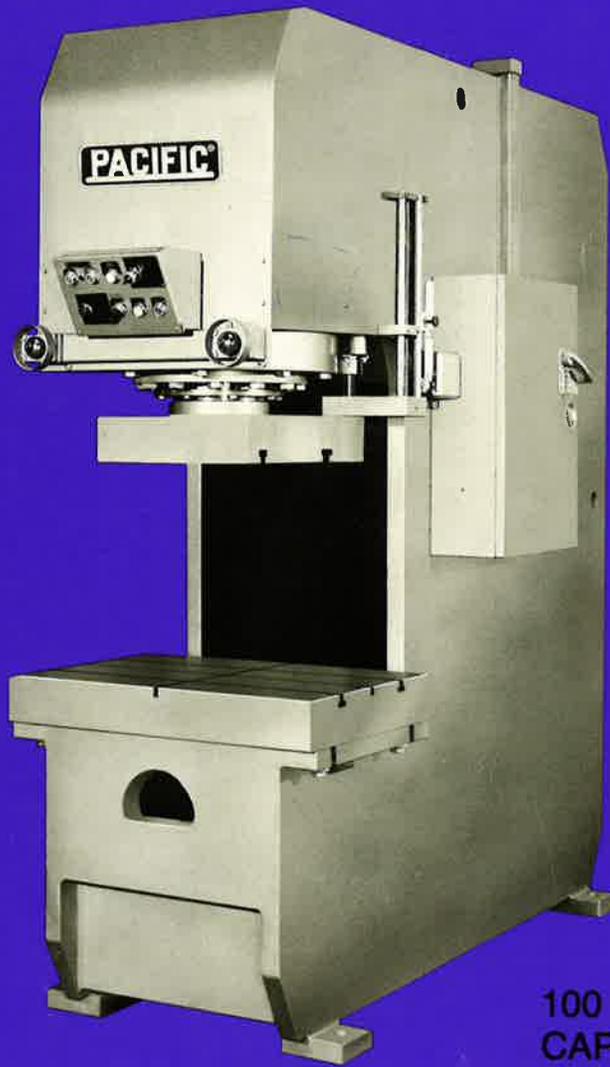


PRESSFORMER

II

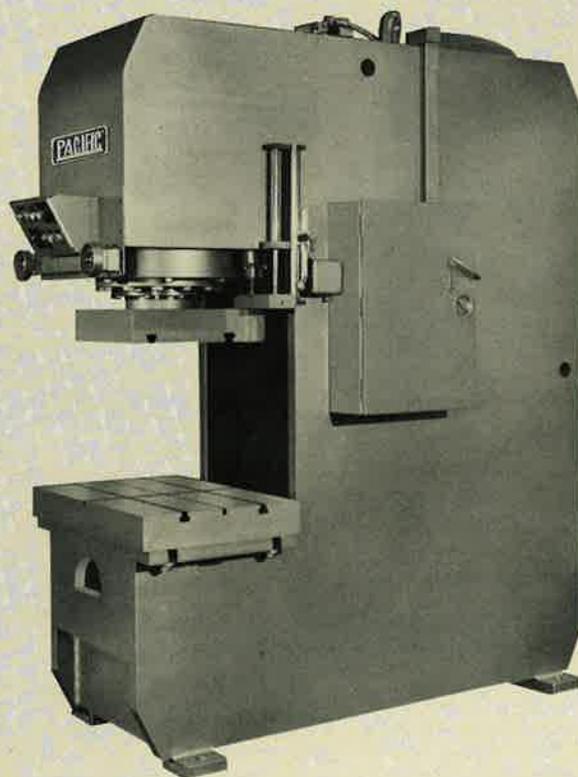


100 THRU 375 TON
CAPACITIES

PACIFIC

. . the safe, modern,
“do everything”
hydraulic production
press

PressFormer II



The Pressformer II represents the second generation of single cylinder Pressformers introduced by Pacific several years ago. The outstanding performance record of the original press in virtually unlimited field applications has culminated in the progressive development of the new Pressformer II to provide industry with a modern hydraulic press for high production work as well as a wide range of diversified short run applications.

The Pressformer II is the end product of all of the outstanding features that made its predecessor, the original Pressformer, a success. In addition, many new features have been incorporated to provide numerous advantages over conventional hydraulic and mechanical presses alike. As a result, the Pressformer II is contemporary in design, rugged, fast, safer and more adaptable to today's exacting press working requirements.

Here's a press designed to be application oriented. Engineered for high tonnage concentration, it's deep side housings, box-type bed construction and flanged cylinder mounting serve to minimize deflections and to maintain a high degree of accuracy during capacity operations.

Its compact, functional power unit reflects the latest and most advanced hydraulic press technology. With high speed performance the Pressformer II provides working strokes per minute, that in most applications, can exceed those of mechanical geared presses of comparable size. In addition, built-in overload protection and automatic decompression are but a few of the standard hydraulic features that help to assure reliability and efficiency.

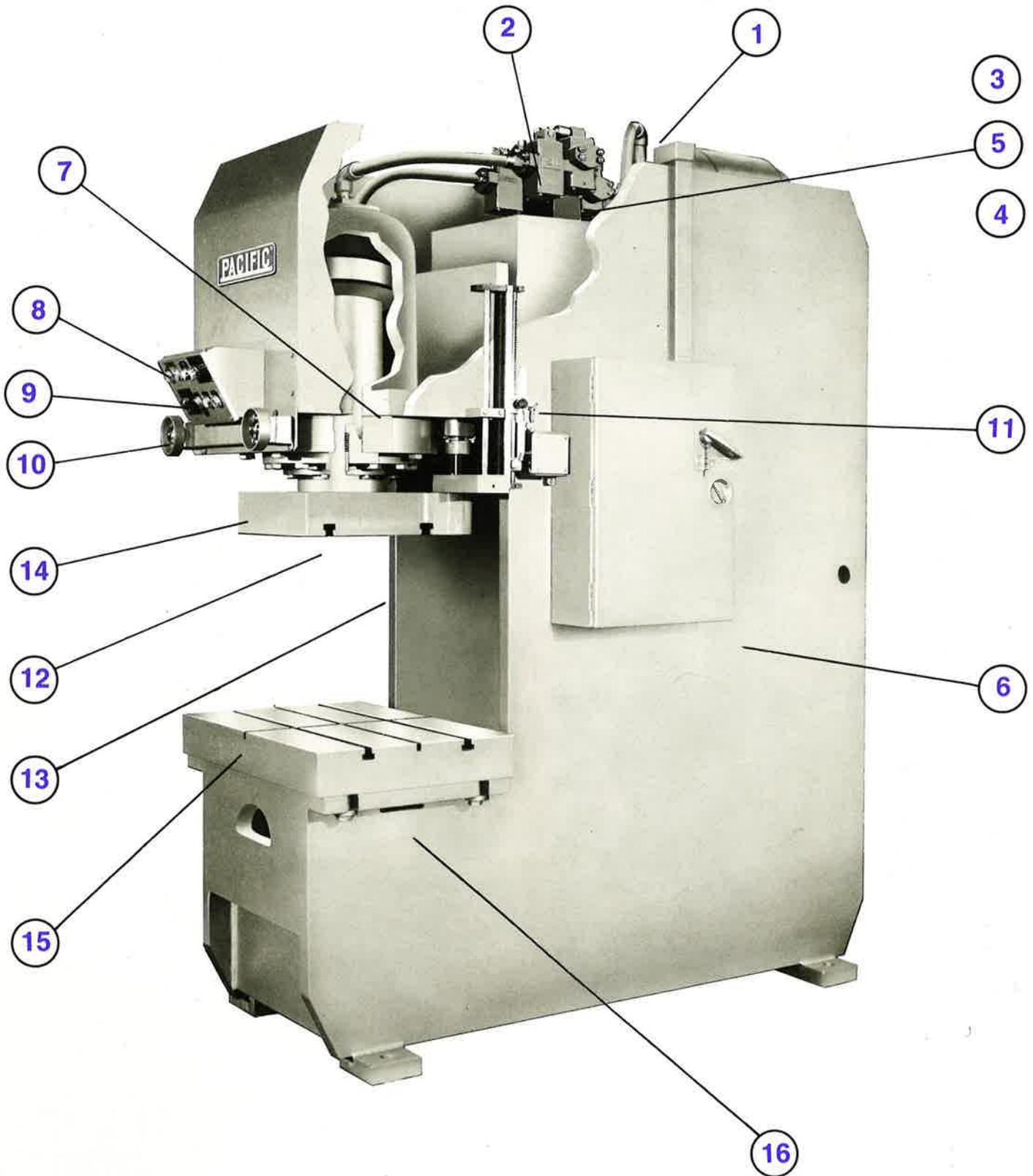
With full tonnage available throughout the long stroke, larger tooling can be used, giving the Pressformer II bonus capacities that are not usually available with its mechanical counter-parts. Also, because of the fully adjustable top and bottom stroke setting and mode selection, the press can be set-up for almost any operation in record-breaking time. What's more, its controllability enables the ram to be stopped or returned to the top at any point in the stroke, keeping the operator in complete control of the press at all times.

While the Pressformer II is ideally suited to perform many jobs normally assigned to OBI presses, its versatility extends into almost every area of press working technology. It has the capability of performing a wide variety of operations on the same press, such as: bending, forming, punching, blanking, stamping, forging, broaching and assembly work. All, and more, can be included within the performance range of the Pressformer II. In addition, the box-type bed construction and removable bed bolster have been engineered for an optional die cushion, thereby extending the press's capability to deep draw production work. Other optional modifications enable the use of cut-off tools and dies for special applications. What's more, the Pressformer II can readily be adapted to complete automated production systems.

Pressformer II will give you a new horizon in metal fabrication when you discover how this press can do the job of two or three conventional presses — and do them better. You will forget all about the usual application restrictions as you search for new jobs to assign to this "do everything" press.

Look over the Pressformer II and see why there has never been anything like it on the market before.

Standard Features

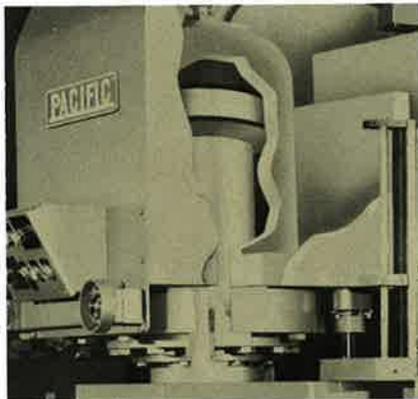


- 1. COMPACT, HIGH SPEED HYDRAULIC SYSTEM**
Two-speed, low heat power unit is self-contained with pump and motor and mounted between side housings. Two advance speeds are adjustable for any portion of the stroke. A high return speed is standard.
- 2. MODULAR STACKED VALVES**
Eliminates need for extra piping and special manifolding. Can be serviced without removal.
- 3. NON-OVERLOAD SYSTEM**
Overloading or jamming of the press is prevented by Pacific's instant response relief valve system.
- 4. AUTOMATIC DECOMPRESSION SYSTEM (patented)**
Provides controlled pressure release of hydraulic system to reduce up-stroke shock when forming with polyurethane dies, spring-type die cushions and heavy plate.
- 5. 10 MICRON OIL FILTRATION**
Full flow oil filter with visual indicator. Filters out impurities to 10 microns. Allows "throw-away" element to be easily replaced from top of tank.
- 6. RIGID STEEL FRAME CONSTRUCTION**
All main frame components are accurately proportioned from heavy steel plate to provide maximum rigidity and minimum deflection for capacity operations. Open back design facilitates part removal and/or tool shortage.
- 7. FLANGE-MOUNTED CYLINDER ASSEMBLY**
Heavy, cast, one-piece cylinder requires minimum oil seals. Large oil area under piston helps absorb break-through shock when punching. Cylinder is flange-mounted for greater stability and contains internal rod guiding.
- 8. CONVENIENT CONTROLS**
All operating controls are located in compact panel and mounted on front of press for convenience and safety. A simple mode selector provides for: Continuous Run, Single Stroke, Jog (inching), and Set-Up (inching with .001" increments).
- 9. EMERGENCY STOP**
Button mounted in center of control panel instantly cuts power to the press.
- 10. PALM BUTTONS**
Two palm buttons are provided for safe press operation.
- 11. STROKE AND SPEED ADJUSTMENTS**
Stroke length adjustment with micrometer bottom stroke setting infinitely adjustable to within .001". Two advance speeds adjustable throughout stroke range.
- 12. EXTENDED OPEN HEIGHT**
For ready accessibility to tooling and for fast set-ups.
- 13. DEEP THROAT**
Provides large die space for maximum versatility.
- 14. LARGE TOOL HOLDER**
Equipped with anti-rotation guide and two longitudinal T-slots.
- 15. BED BOLSTER**
Large removable bolster machined with .505"/.515" wide center slots in the left-to-right and front-to-back directions. Two longitudinal T-slots correspond with tool holder slots. A wide variety of bolster configurations are available as optional features.
- 16. BOX-TYPE BED CONSTRUCTION**
Designed for high tonnage concentration and minimum deflection. Can easily accommodate a single die cushion for deep draw work.

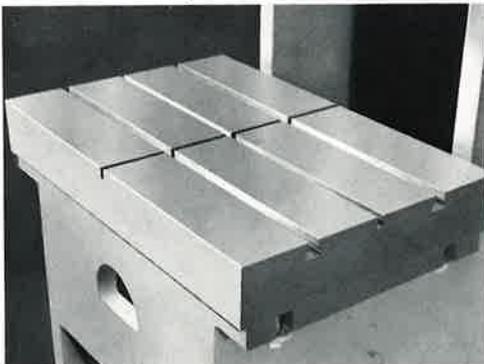
rugged construction assures greater rigidity, minimum deflection



RIGID STEEL FRAME CONSTRUCTION



FLANGE-MOUNTED CYLINDER



REMOVABLE BED BOLSTER

RIGID STEEL FRAME CONSTRUCTION

The ruggedness of the Pressformer II is characterized by its heavy welded steel frame construction. All main frame members have been carefully designed to assure that each press more than adequately absorbs and uniformly distributes the forces of full capacity operations. Large, accurately proportioned side housings not only provide front-to-back rigidity but are incorporated as integral structural members of the bed and cylinder housing for the maximum resistance to deflection that is essential to accurate press performance.

The contemporary design of the Pressformer II has been oriented to accommodate the greatest possible variety of potential applications. The open height and deep throat allows the use of large dies, permits ready access to tooling from the front and sides for fast set-ups and facilitates adaptation to complete automation. In addition, the open back design provides a means for scrap removal or for convenient tool storage between the side housings.

FLANGE-MOUNTED CYLINDER

The hydraulic cylinder of a Pressformer II is flange mounted to the frame, similar to the cylinder mounting on larger Pacific Straightside presses, to assure ram stability and high repeat accuracy.

The cylinder is a heavy, cast, single-piece, domed-head cylinder which eliminates high stresses and potential oil leakage areas on the high pressure side of the cylinder.

The piston and rod is a one-piece, wear resistant, meehanite casting, honed and polished to 10 microinches. A large bronze guide provides internal rod guiding and insures long life with minimum packing wear. The oil retaining rod surface is an aid to proper lubrication.

BOX-TYPE BED CONSTRUCTION

Designed specifically to accommodate the largest possible range of applications, the box-type bed is internally reinforced to provide low deflection characteristics for capacity operations.

The large bed bolster is removable thereby allowing the addition of an optional die cushion for deep draw work. The bolster is machined with .505"/.515" wide center slots in the left-to-right and front-to-back directions as standard. Two longitudinal T-slots are also provided, corresponding with T-slots in the upper tool holder.

industry's most advanced hydraulic system

COMPACT, HIGH SPEED HYDRAULIC SYSTEM

The compact, self-contained power unit of the Pressformer II provides high speed performance with overload protection, automatic decompression and many built-in features that assure reliability and production efficiency. A high volume, vane-type pump is direct-mounted to the motor for trouble-free performance. The large capacity reservoir, together with Pacific's exclusive modular valve system means cooler operation and eliminates the need for an oil cooler under normal conditions. Oil under pressure on both the top and bottom of the piston provides a steady, controlled movement of the piston and ram during every phase of the stroke.

MODULAR STACKED VALVES

Because the valve system of a hydraulic is the heart of the press, all valves on a Pressformer II are designed and built by Pacific to assure their operating characteristics of being completely compatible with the press itself. Pacific valves, unlike most commercial, "off-the-shelf" valves, provide improved accuracy and the special characteristics necessary for modern hydraulic press design.

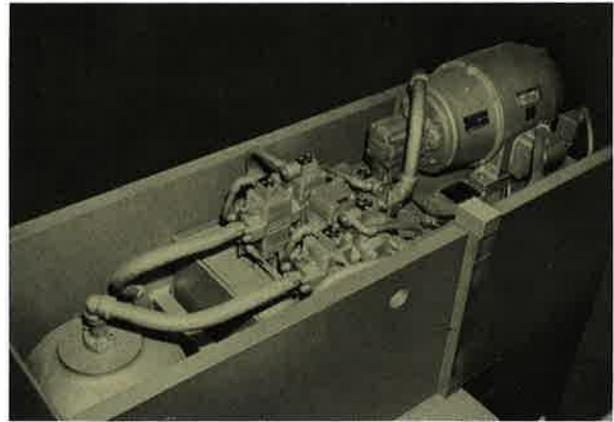
Pacific-built, heavy duty valves are specially designed for long, rugged service with the minimum of maintenance. They are "manifolded" in modular form to eliminate interconnecting piping and to avoid the necessity of a massive, heat producing, manifold block.

10 MICRON OIL FILTRATION

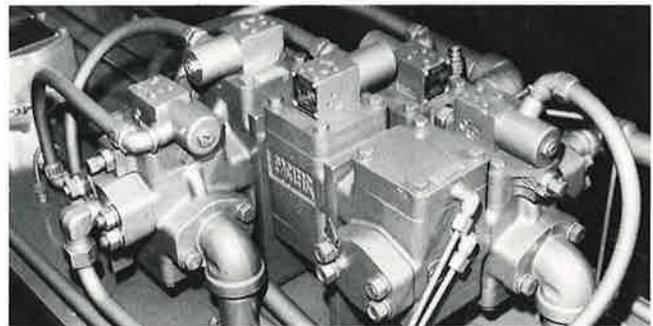
To assure trouble-free performance of the hydraulic system, every Pressformer II is equipped with a Pacific oil filter mounted on the tank top for easy inspection. Contaminants as small as 10 microns are removed from the oil. An indicator gauge shows when to replace the throw-away type element.

NON-OVERLOAD SYSTEM

Overloading or jamming of the press is prevented by Pacific's instant response relief valve system. Should the tonnage requirement of the job exceed the press capacity before reaching the bottom of the stroke, the ram will automatically stop and hold position. Upon releasing the palm buttons, the ram will return to the top of the stroke. Possible overload damage to main frame members and the cylinder is avoided.



COMPACT, HIGH SPEED POWER UNIT



PACIFIC MODULAR STACKED VALVES



10 MICRON OIL FILTER

AUTOMATIC DECOMPRESSION (Patented)

"Controlled power release" is a standard feature that provides decompression of the oil in the main cylinder before the ram starts its return stroke. This system reduces the high velocity, uncontrolled return shock when working on jobs having a large build-up of stored energy such as in rubber pad forming, special spring pad dies, or high tensile material when there is a considerable amount of "spring."

full controllability for greater versatility, higher performance and safety

LONG, FULL POWER STROKES

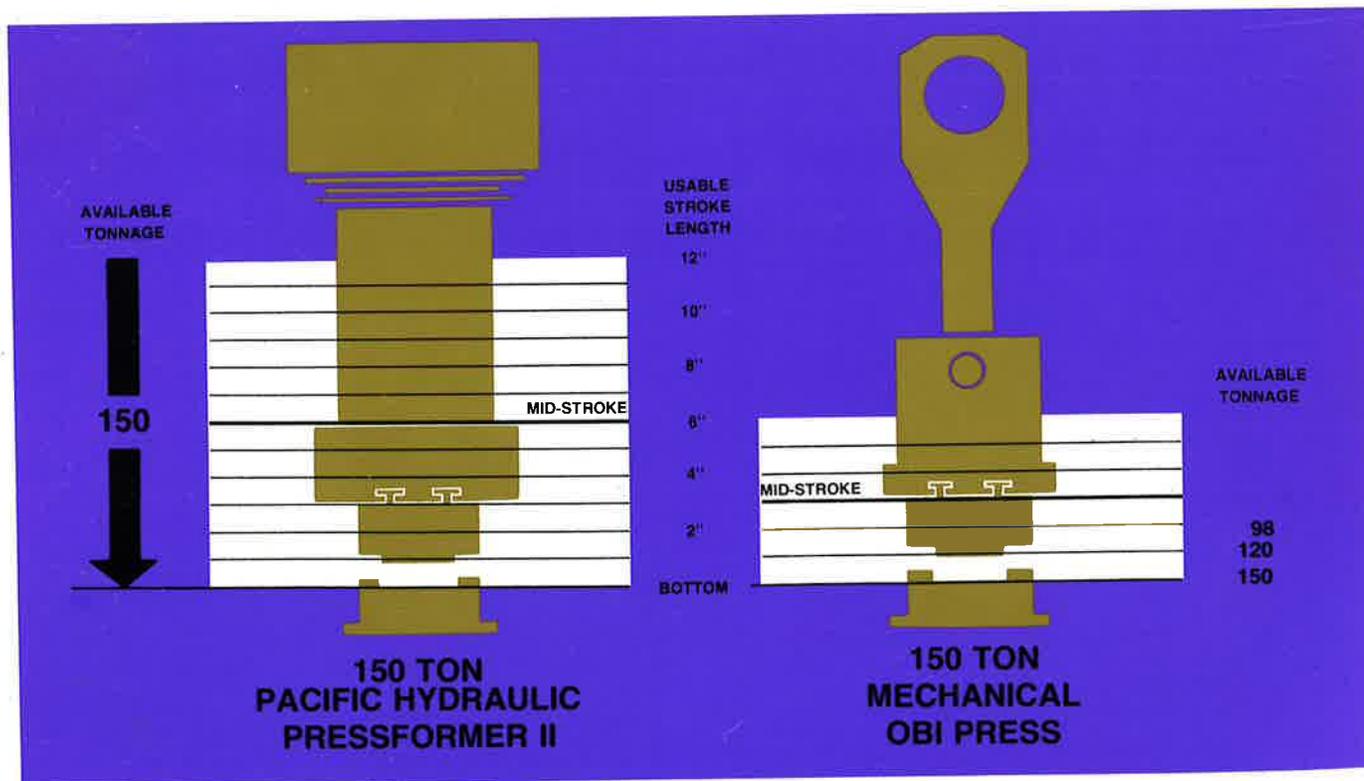
With a Pressformer II full rated tonnage can be used throughout the long standard stroke. By comparison, mechanical presses have shorter strokes with full rated tonnage available only at or near the bottom of the stroke. Mid-stroke is normally only two-thirds of rated capacity. The longer stroke of a Pressformer II is completely adjustable with full tonnage available at *any point* in the stroke. This provides greater flexibility and forming capacities than those of similar tonnage mechanicals. Heavier material can be formed due to the long power stroke being compatible with larger female dies and thicker materials. Mechanical presses can't match this capacity because thicker materials require a longer power stroke than is normally available. With Pacific's hydraulic Pressformer II, you get "bonus capacity" at no additional cost. And "bonus capacity" means greater versatility in the type of applications which can be assigned to the press.

FAST SET-UPS

Fast set-ups are a key to high production and often are the only means for greater profits in short run operations. To assure fast set-up time the Pressformer II has been designed with generous open heights and convenient controls for stroke and speed adjustments to greatly simplify and shorten the set-up procedure. In addition, a special Mode Selector Switch enables the operator to choose between four types of ram control for set-up or production runs.

STROKE ADJUSTMENTS

Stroke length settings can be adjusted instantly by means of a simplified slide-type control conveniently mounted on the right side of the press. A micrometer-type bottom stroke setting is adjustable to within .001". The top stroke setting is also completely adjustable to allow short, high speed operation.



SPEED ADJUSTMENTS

A major factor contributing to the great versatility of the Pressformer II is its efficient hydraulic system which permits the selection of a combination of speeds during the downstroke. This choice of advance speeds combined with a high return speed and adjustable stroke settings gives the Pressformer II its capability for high production performance.

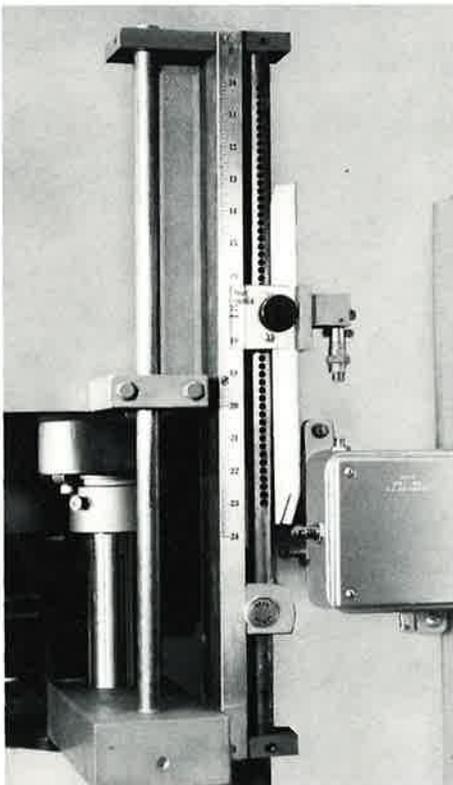
A selector switch enables the operator to choose the combination of speeds best suited to his job requirements. He may select either Rapid Advance/Normal Press or Normal Press/Normal Press. An adjustable cam and speed change switch enables the speeds to be adjusted to automatically change from one advance speed to another at any point in the stroke.

MODE SELECTOR SWITCH

To maintain positive ram control, the Pressformer II's four-position, keyed Mode Selector Switch, in conjunction with the palm buttons, provides full controllability for set-ups or any type of production application.

CONTINUOUS RUN (Key-type Selector Position)

Depressing the palm buttons will move the ram down until the bottom stroke setting (depth limit switch) is reached. The ram will then automatically return to the top stroke setting and continue to "cycle" as long as the palm buttons are depressed. Releasing the palm buttons at any point in the stroke allows the ram to reverse and return to the top position and stop.



STROKE AND SPEED ADJUSTMENT

SINGLE-STROKE CONTROL

Ram will operate in the same manner as "Continuous Run," except the ram will make a complete cycle and stop at the top of the stroke. The ram will not cycle again until the palm buttons are released and reactivated.

JOG CONTROL (Inching)

Depressing the palm buttons will move the ram down, however, the ram will hold position when the palm buttons are released. This allows "jogging" during the downstroke as an aid when bending to a line, or with lay-out work. When the bottom stroke setting is reached, the ram will then automatically return to the top stroke setting.

SET-UP CONTROL (Inching Within .001" Increments)

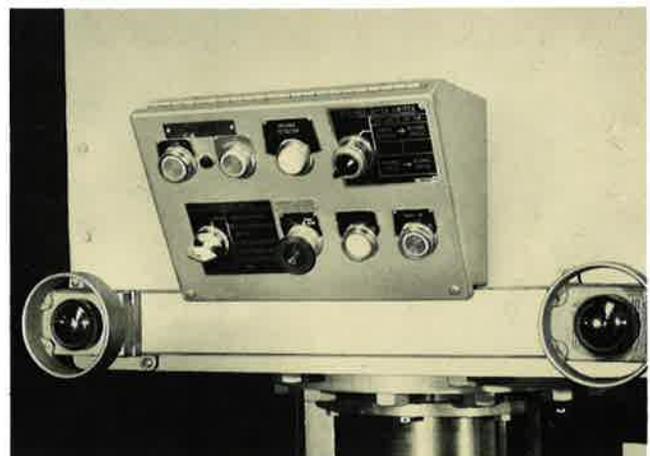
Depressing the palm buttons will move the ram down. The ram will hold position when the palm buttons are released (similar to jog control), *except* the ram will stop at the bottom stroke setting and not return *automatically*. Further stroke depth adjustments can then be made in very small increments of .001" by adjusting the micrometer depth setting. Changing the Mode Selector Switch to the Single Stroke position returns the ram to the top stroke setting. This type of control is invaluable in initial set-up operations, or when bending to a template.

CONVENIENT CONTROLS

All Pressformer II operating controls are grouped in a compact control panel mounted on the front of the press for convenience and safety. Push buttons, Selector Switches, indicators and the emergency stop button can be easily reached by the operator, yet are out of the work area.

PALM BUTTONS

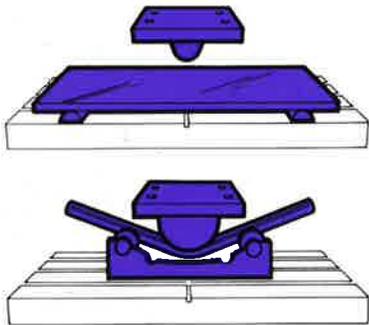
Two palm buttons are provided and are conveniently located for the safe operation of the press. Used in conjunction with the Mode Selector Switch, the palm buttons control the ram for both set-ups and production runs. Both palm buttons must be held in the depressed position in order for the ram to complete its stroke. If either button is released the ram will stop instantly. Releasing both palm buttons returns the ram to the up-position.



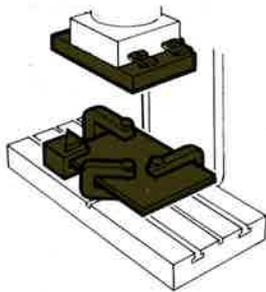
CONVENIENT CONTROL PANEL

the "do everything" production press for today's application needs

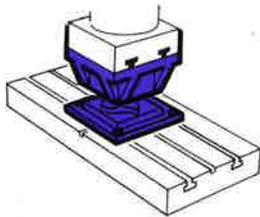
The almost unlimited capability of the Pressformer II plus Pacific's traditional dependability makes this outstanding press one of the most versatile, multiple function tools available. Precision controls and quick set-up capability puts a Pressformer II into operation fast, and once in production, its high speed performance, accuracy and bonus capacity means real productivity. Designed for versatility, the application oriented Pressformer II's performance range extends from OBI type operations to an endless number of special applications spanning almost every area of press working technology. This flexibility of performing such a wide variety of operations on the same press makes the Pressformer II the "do everything" production press for today's exacting metal working requirements.



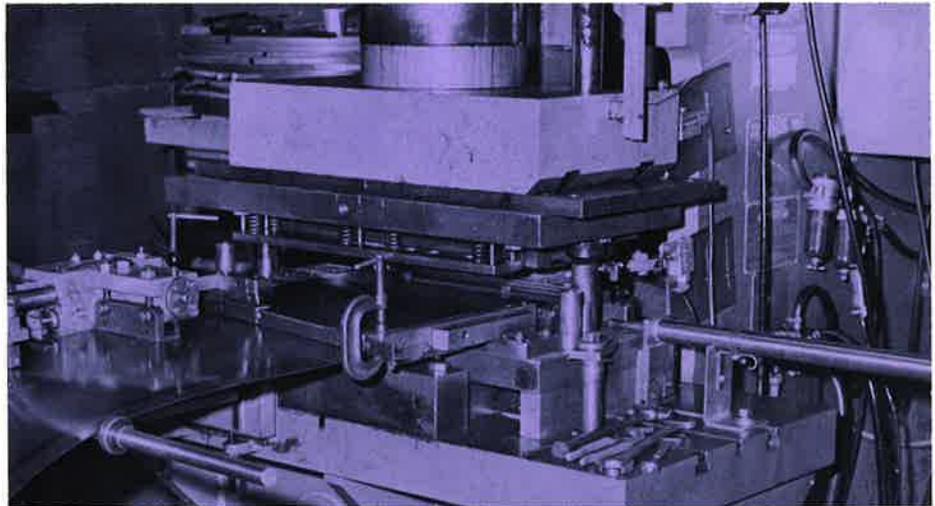
Micrometer controls greatly simplify bending or straightening shafts, bars, plates, pipe and tubing. Stroke depth repeats to within $\pm .001$ " of setting.



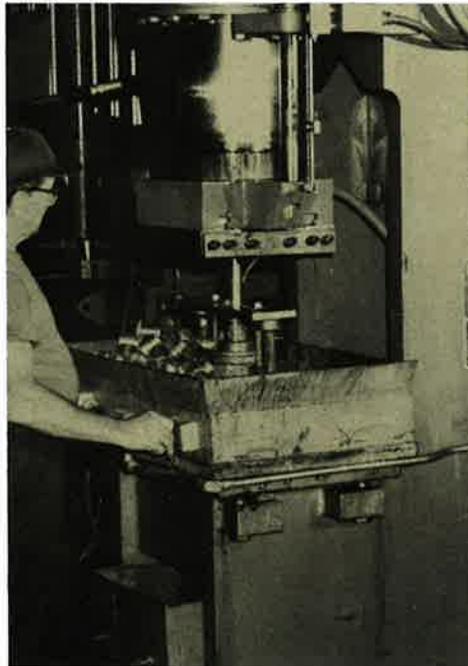
Punching, notching and blanking with unitized tooling. Note wear plate which protects tool holder.



The Pressformer II can be used for soft tool forming such as the Guerin Process. The form block fits into the die chase and traps the rubber. The rubber provides a universal die for shallow draw forming operations.



B. Walter & Company, Inc., Wabash, Indiana, mfg. of metal slide assemblies for dining tables utilizes a 200 ton Pressformer in a completely automated system. The press is equipped with an automatic coiler and three-station progressive dies to produce 5,200 components per day.



This 200PF II is used for continuous broaching operations in the manufacture of bushings. The press has an 18" stroke and increased open and shut heights.



Deep drawing and trimming stainless steel floats on a 150PF II. Both copper and stainless steel floats are formed in sizes up to 10" in diameter.

optional features

DrawPressFormer II

DIE CUSHION

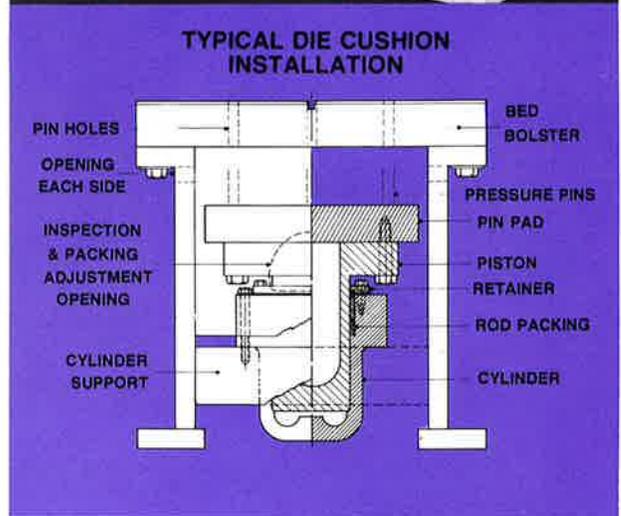
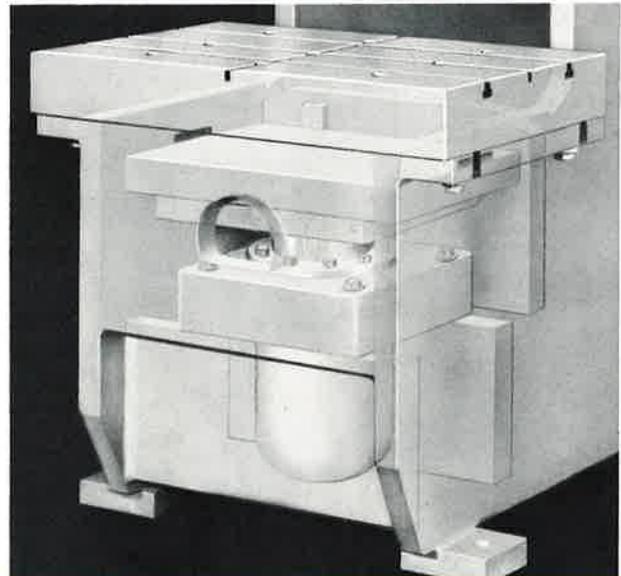
Pressformer II's box-type bed has been designed for the addition of a single die cushion to enable the press to be used for production deep drawing.

The system consists of a hydro-pneumatic cylinder connected to control valves and to an air/oil accumulator tank which provides the return force for the die cushion. Constant force is maintained on the metal blank during the drawing operation to control the flow of metal and to eliminate wrinkling.

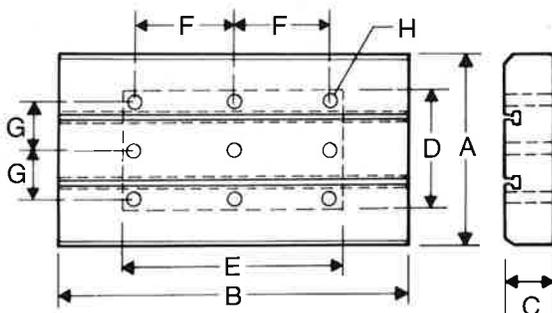
The force required on the blank holder can be controlled by the adjustment of a pressure control valve located in the piping system. This tonnage is adjustable from maximum tonnage to approximately 20% of maximum. The adjustment is conveniently located on the press and is provided with a pressure gauge.

The die cushion system is offered complete with a center-located die cushion having a 6" stroke. Included is the control valving, air/oil accumulator tank, piping, steel pressure pin pad and standard 9 hole drilling for pressure pins in the bed bolster.

The die cushion is of the internal guided type with a long bearing engagement. Both the cylinder and piston castings are ground and polished. The cylinder is designed with a bronze guide and has externally adjustable chevron-type packing and wiper. The heavy, removable, steel plate, pressure pad is bolted to the piston. The cylinder is mounted on cross plates welded between the box-type bed members.



TYPE "C" BED BOLSTER & PRESSURE PIN PAD ARRANGEMENT

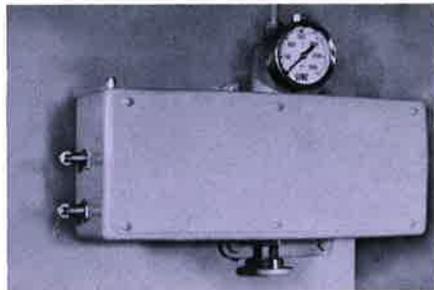


MODEL NO.	A	B	C	D	E	F	G	H (Dia.)
100PF II	18"	34"	4 1/4"	11"	20"	9 1/2"	5 1/2"	1"
150PF II	24"	36"	4 3/4"	17"	22"	10 1/2"	8"	1 1/4"
200PF II	24"	40"	5 3/4"	17"	24"	12 1/2"	8"	1 1/2"
250PF II	26"	46"	5 3/4"	17"	28"	13 1/2"	8"	1 1/2"
300PF II	28"	50"	6 3/4"	19"	32"	15 1/2"	9"	1 3/4"
375PF II	30"	50"	6 3/4"	21"	32"	15 1/2"	10"	2"

optional features

TONNAGE INDICATOR

Gauge indicates press tonnage under working load. Conversion chart mounted near gauge converts psi to tons.



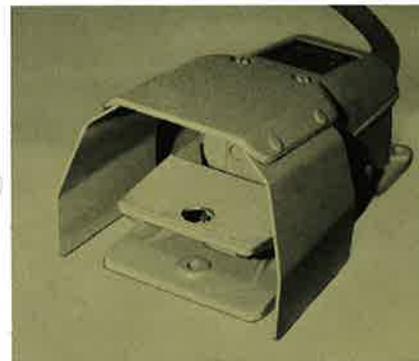
TONNAGE CONTROL AND INDICATOR

TONNAGE CONTROL AND INDICATOR

A single dial enables the operator to pre-set the tonnage output of the press from 20% to 100% of capacity.

FOOTSWITCH

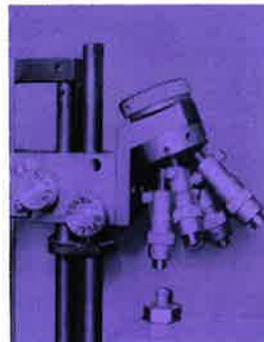
A portable electric footswitch has side guards and long electric cable. Ram returns to top position when operator's foot is removed from switch. Mid-position of switch enables the ram to be stopped and position held at any point in the stroke. Keyed selector switch is provided for choice of palm buttons or footswitch control.



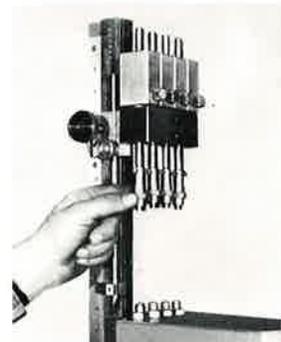
PORTABLE ELECTRIC FOOTSWITCH

TURRET DEPTH STOP (Manual)

Provides multiple pre-set bottom stroke settings for progressively forming different angle bends. Four micrometer stops can be separately adjusted. Turret can be manually rotated in any sequence.



MANUAL TURRET DEPTH STOP



AUTOMATIC MULTIPLE DEPTH STOP

AUTOMATIC MULTIPLE DEPTH STOPS

Four bottom stroke settings can be pre-set for the automatic progressive forming of bends having different angles. Micrometer depth stops can be set to produce any angle bends. The sequence of operation is programmed by means of selector switches on a control panel. In operation, limit switches are automatically activated one at a time in sequence.

TOOL HOLDER WEAR PLATE

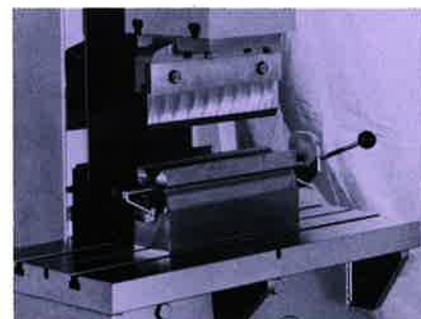
Heavy steel wear plate to protect the tool holder. Includes holder bars and bolts.

RAM ADAPTER AND CLAMP BAR

Mounts to upper tool holder. Accepts short press brake dies.

SHORT PRESS BRAKE DIES

Extends Pressformer II versatility to press brake type work.



SHORT PRESS BRAKE DIES



ANGLE CUT-OFF

SELF-CONTAINED CUT-OFF TOOLING

These compact, quick change tools can greatly extend the versatility of the Pressformer II. Engineered for heavy duty operation in terms of shearing capacity and duty cycle. High quality tool steel blades are self-contained with springs to return the knife upward. Holddowns or other clamping devices are not required. Each tool is ready for use with a recommended Pressformer II model to assure adequate tonnage for the maximum cut plus a reasonable reserve to accommodate variations in metal hardness and thickness.



FLAT BAR CUT-OFF



ROUND BAR CUT-OFF

ANGLE CUT-OFF

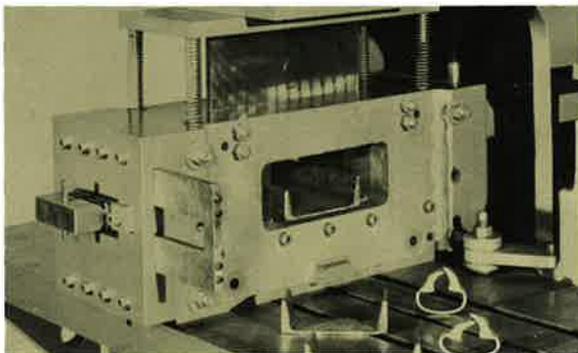
Shears a wide range of angles with zero distortion on both sides of cut. Distortion is absorbed in the slug.

FLAT BAR CUT-OFF

Shears a wide range of flat bar stock with little distortion.

ROUND BAR CUT-OFF

Quick, efficient shearing of most commonly used round bar stock from 1/2" to 2" in diameter. Each cut-off tool shears 4 sizes.



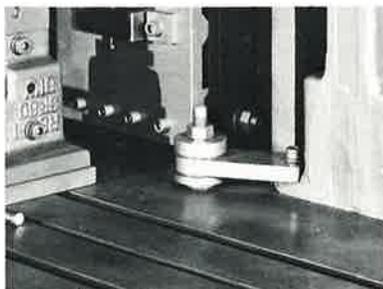
CHANNEL CUT-OFF

CHANNEL CUT-OFF

One size cut-off tool accommodates any channel from 2" to 10" wide. Knife adjustment slide permits set-up for shearing any size channel within this range. The channel is automatically centered and held under the knife by means of a hydraulic cylinder.

SWING AWAY ARMS FOR TOOLING

Arms mounted on either side of bed bolster. Enables cut-off or similar tools to be conveniently swung into position on the bolster or removed from the work area. Permits extremely fast set-ups. Provides convenient means of storing often used tools at the side of the press.



SWING-AWAY ARM FOR TOOLING

DIE SLIDE ASSEMBLY

Flush mounted to rear of bed bolster and extends between side housings. A .505"/.515" wide center slot corresponds with front-to-back center slot. Enables convenient storage of dies and cut-off tooling between side housings.

optional features

HIGHER SPEED POWER UNITS

Higher speed power units are available for each Pressformer II Model to provide the highest possible speeds without major alteration to the press design. All higher speed power units provide three advance speeds: Rapid Advance, Fast Press and Normal Press. Two return speeds include Fast Return and Normal Return. A Selector Switch allows the choice of speed combinations best suited to the job requirements.

VARIABLE PRESSING SPEED

Allows operator to vary the *Normal Press speed* to accommodate the job being performed.

MOTOR STARTERS

Motor starters, control transformer and main circuit breaker mounted in a single NEMA 1 enclosure. (Includes wiring between components and motor).

ADDITIONAL OPEN HEIGHTS

Increased open heights are available for each press model in 6" increments.

LONGER STROKES

Longer strokes of 18" and 24" are available for all Pressformer II Models.

DEEPER THROATS

Models 100PF II, 150PF II and 200PF II are available with optional 18" throats.

Models 250PF II and larger are available with optional 24" throats.

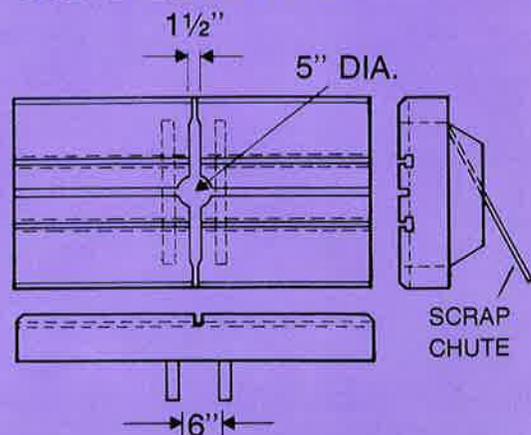
BED BOLSTER MODIFICATIONS SLUG SLOT

The bed bolster can be provided with a center slug slot and scrap chute for gravity removal of slugs and part pieces. This is a necessity when using self-contained cut-off tooling.

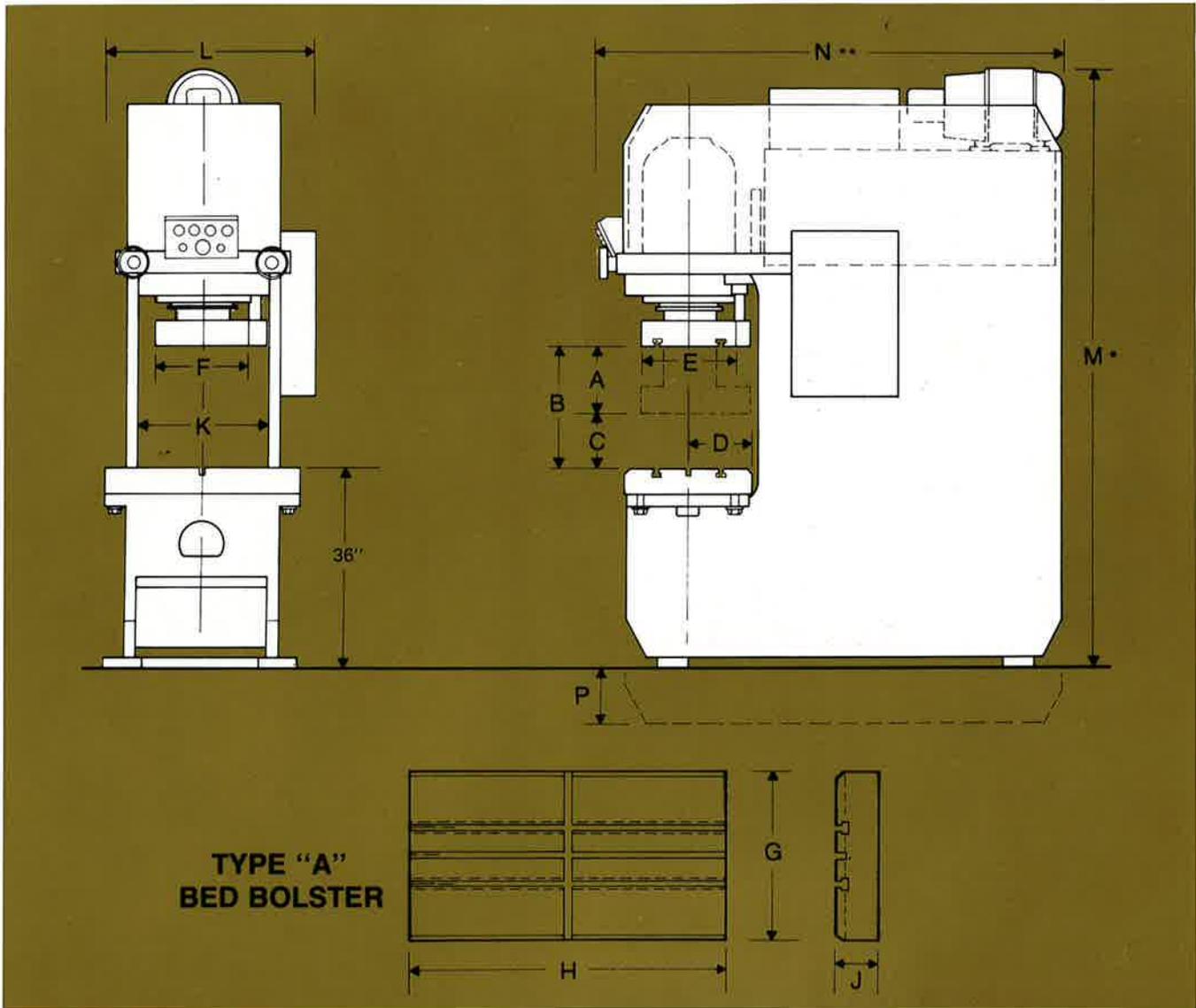
ADDITIONAL T-SLOTS

In addition to the standard T-slots, extra T-slots can be added to the tool holder or bed bolster.

TYPE "B" BED BOLSTER



specifications & dimensions

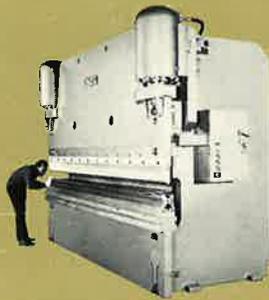


MODEL NO.	CAPACITY (U.S. Tons)	Stroke Length	Open Ht.	Closed Ht.	Throat Depth	Tool Holder Size	Bed Bolster Size	Distance Between Housings	Width	Height*	Depth**	Housing Projection Below Floor	Motor H.P.	Approximate Shipping Weight (Lbs.)			
	A	B	C	D	E	F	G	H	J	K	L	M	N	P			
100PF II	100	12"	20"	8"	10"	15"	15"	18"	34"	4 1/4"	22"	39"	98"	68"	-	25	10,000
150PF II	150	12"	22"	10"	13"	18"	18"	24"	36"	4 1/4"	24"	41"	102"	88"	-	30	13,000
200PF II	200	12"	23"	11"	13"	20"	20"	24"	40"	5 1/4"	26"	44"	104"	90"	-	30	17,000
250PF II	250	12"	24"	12"	14"	22"	22"	26"	46"	5 1/4"	30"	50"	111"	95"	-	40	23,000
300PF II	300	12"	24"	12"	16"	24"	24"	30"	50"	6 1/4"	34"	54"	122"	109"	-	50	29,000
375PF II	375	12"	26"	14"	16"	24"	24"	30"	50"	6 1/4"	34"	54"	126"	123"	14"	60	38,000

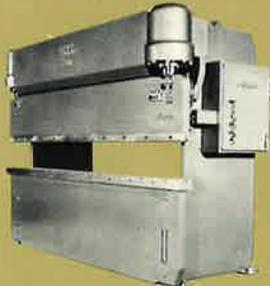
* Power unit will extend above side housings on most models.
 ** Power unit may extend beyond side housings on some models.

If either depth or height are critical factors, dimensions will be furnished on request from factory.

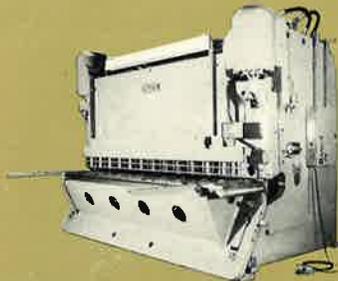
the Pacific hydraulic production line



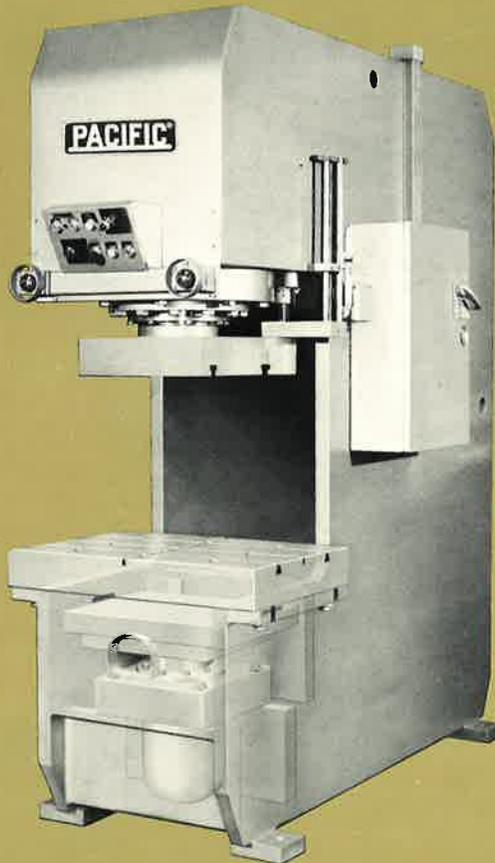
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