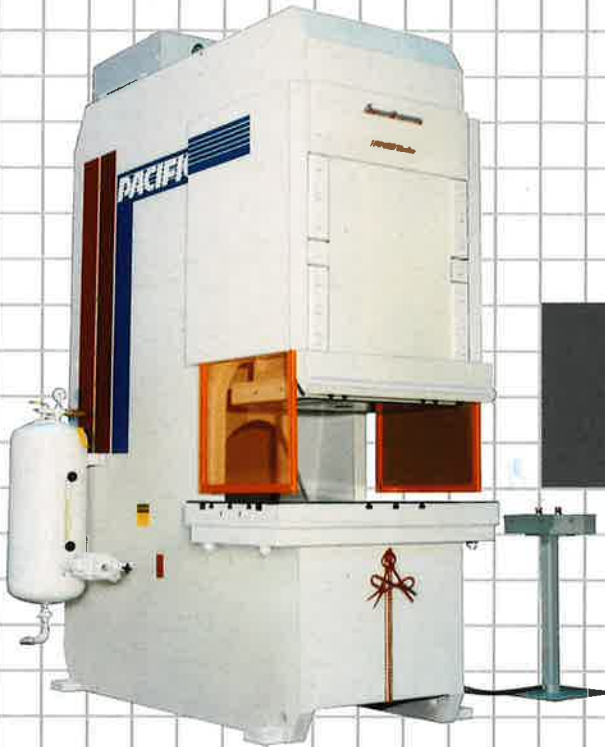


CERAMIC PRESSES

Series



Pressformer
OBS Series



Pressformer II





OBS-Series

Hydraulically designed to provide more flexibility than mechanical OBI presses

Pacific OBS-Series pressformers have been developed through years of field application experience to meet today's demanding high production metal stampers. They are designed to perform all of the traditional functions of mechanical OBI presses in terms of application and short run production output, but with the additional benefits of hydraulic controllability and versatility.

Best suited for most pressroom applications including punching,

blanking, coining, forming, bending, assembly work, drawing, or any work involving production parts. Simplified operation and fast setup capabilities makes short run applications more economical.

Standard features include:

- advanced high-speed hydraulic technology.
- long rigid gibbing (square-type, eight-point) that is typically found on larger straightside presses.
- complete adjustability of top and

bottom stroke settings via programmable logic control (PLC's).

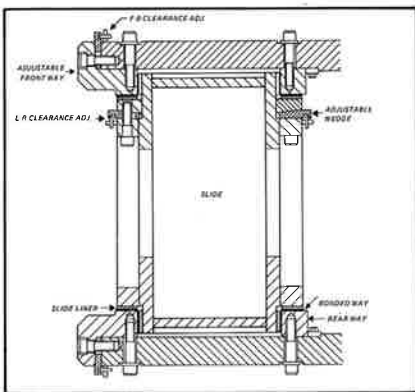
- the ability to set press speed combinations for any portion of the stroke.

Although special sizes and tonnage can be built to your specifications, Pacific offers three standard machines in 110, 150, and 250 ton models.

OBS Press Features

Construction

- 1 Rugged, welded steel frame construction** is designed to uniformly distribute the forces of capacity operations. Large accurately proportioned side housing provide front-to-back rigidity and maximum resistance to deflection.
- 2 Adjustable, 8-point, square-type gibbing/slide assembly** provides superior accuracies by guiding all four corners of the slide in both front-to-back and left-to-right directions. Extra long slide guiding surfaces maintain full bearing contact with non-metallic ways and are equipped with high pressure grease lubricated bronze liners. All slide clearances are adjustable from the front of the press.



- 3 Reinforced box-type bed** is internally reinforced to provide low deflection characteristics and is equipped to accept an optional die cushion for deep draw work.
- 4 Slide and bed bolsters** are machined with $\frac{3}{4}$ " center T-slots. **Optional** bolster designs and scrap chutes are available.
- 5 Guarding** includes adjustable throat guards and rear chain guard. Additional specially designed guarding needs are also available to fit any application.
- 6 Quick die change units (optional)** make setup easier and faster.
- 7 Increased open heights (optional)** are available in 3" increments.
- 8 Die cushion (optional)** for production drawing applications.

Hydraulics

- 1 Compact, high-speed hydraulic system** offers three advance speeds, 10 micron oil filtration, overload protection, automatic decompression and many other built-in features assure reliability and efficiency.
- 2 Cylinder assembly** consists of a heavy cast main cylinder that is inverted and contained within the slide. The piston rod is attached to the upper press frame, allowing non-binding alignment with the slide clearance adjustments. This design leads to overall press heights that are significantly lower than comparable mechanical and hydraulic presses.
- 3 Modular stacked valves** and hydraulic circuitry takes into account the loading requirements of punching and blanking applications. Modular design eliminates interconnecting piping and the need for a manifold block. **Non-overload system** consists of an instant-response relief valve system that avoids possible overload damage to main members, cylinders and dies in the event of a tonnage overload.

- 4 Automatic centralized lubrication system** provides timed lubrication to slideways.
- 5 Hydraulic knock outs** consists of a single-acting cylinder (spring return-2" fixed stroke) and provides two tons of force on the knock-out bar.

Electrical

- 1 Standard Programmable Logic Control (PLC)** includes a two line display and keypad for data entry to program top, bottom, speed change point, knock-out, and tonnage control settings. Control has built in interlocks and safety systems to interface light guards and to allow unattended press operation. ➔



- 2 Optional CNC package** (PC interface with PLC) for faster setups and flexible programming. Featuring menu-driven screens, data storage/retrieval (10,000 stored dies/parts), floppy drive and Ethernet networking, and color monitor.
- 3 Two-hand controls.**
- 4 Stroke adjustments** of both top and bottom strokes allow short, high speed operation and accommodates any die setup within stroke range.
- 5 Speed selection** consists of three advance speeds (rapid advance/normal press, rapid advance/fast press, or normal press) and two return speeds that are adjustable throughout the stroke range.
- 6 Keyed mode selection switch** provides full controllability for setups and production applications in the following modes: off, inch, single-stroke manual return, and single-stroke automatic return.
- 7 Pressure reversal** controls automatic slide reversal when preset tonnage is reached.
- 8 Continuous run mode (optional)** allows automatic cycles used with coil-fed systems. Provided with a key selector switch and three side light guard system.





Pressformer II Series

Hydraulic C-Frame press built for speed and versatility

Pacific's DO EVERYTHING pressformer version has an outstanding performance record in virtually unlimited field applications, making it ideal for production work as well as short run applications like Just-in-Time manufacturing.

Deep side housings, box-bed construction and flanged cylinder mounting serve to minimize deflections and maintain high accuracies. Its compact, functional power unit provides built-in over-

load protection and automatic decompression.

Full rated tonnage can be used at any point of the long standard stroke, as opposed to mechanical presses having it available near the bottom of the stroke. This "bonus capacity" provides greater flexibility and forming functions (including the use of thicker materials and larger female dies) than mechanical competitors. The fully adjustable top and bottom stroke

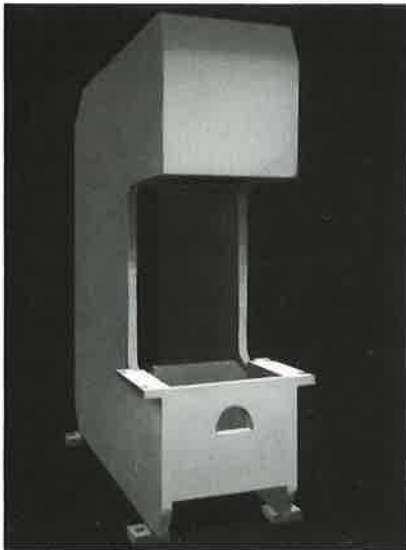
setting and mode selection allows quick setups.

The versatile Pressformer II will perform jobs into almost every area of press working technology including straightening, bending, forming, punching, blanking, stamping, and even limited draw work through an optional die cushion. Although special sizes and tonnage can be built to your specifications, Pacific offers nine standard machines ranging from 100 ton to 1,000 ton models.

Pressformer II Features

Construction

① **Rigid steel frame construction** has been carefully designed to uniformly distribute the forces of capacity operations that needs maximum rigidity and minimum deflection.



② **Reinforced box-type bed**, designed for heavy applications, is internally reinforced (to provide low deflection characteristics) and is equipped to accept an optional die cushion for deep draw work.

③ **Slide and bed bolsters** are machined with T-slots and optional bolster designs and scrap chutes are available.

④ Other optional equipment include **quick die change, die cushions, additional open height, longer strokes, deeper throats.**

Hydraulics

① **Compact, high-speed hydraulic system** is a self-contained power unit that surpasses most comparable mechanical double crank presses. Three advance speeds, 10 micron oil filtration, overload protection, automatic decompression and many other built-in features assure reliability and efficiency.

② **Flange mounted cylinder assembly** provides a large area under the piston for maximum hydraulic support. Oil under pressure on both the top and bottom of the pistons allows a steady, controlled movement of the piston and tool holder serves to cushion the shock of heavy plate punching.

③ **Modular stacked valves** and hydraulic circuitry takes into account the loading requirements of punching and blanking applications. Modular design eliminates interconnecting piping and the need for a manifold block. **Non-overload system** consists of an instant-response relief valve system that avoids possible overload damage to main members, cylinders and dies.

④ **Automatic decompression system** provides a controlled power release that relieves oil pressure in the cylinder before the tool holder's return stroke.

⑤ **Tonnage control and indicator** enables presets of press output from 25% to 100% capacity and includes pressure reversal that controls automatic slide reversal when pre-set tonnage is reached. **(optional feature)**

Electrical

① **Optional OIU (Operator Interface Unit)** package provides a key selector switch with off, inch and single stroke settings. Control has built-in interlocks and safety systems to interface light guards and to allow unattended press operation.

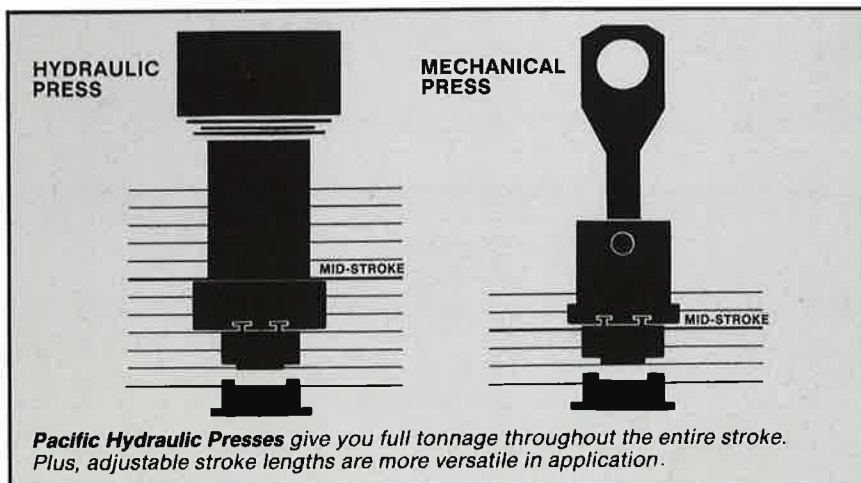


② **Two-hand controls.**

③ **Stroke adjustments** allow short, high speed operation and accommodates any die setup within stroke range. A micrometer type bottom stroke setting is adjustable to within .001".

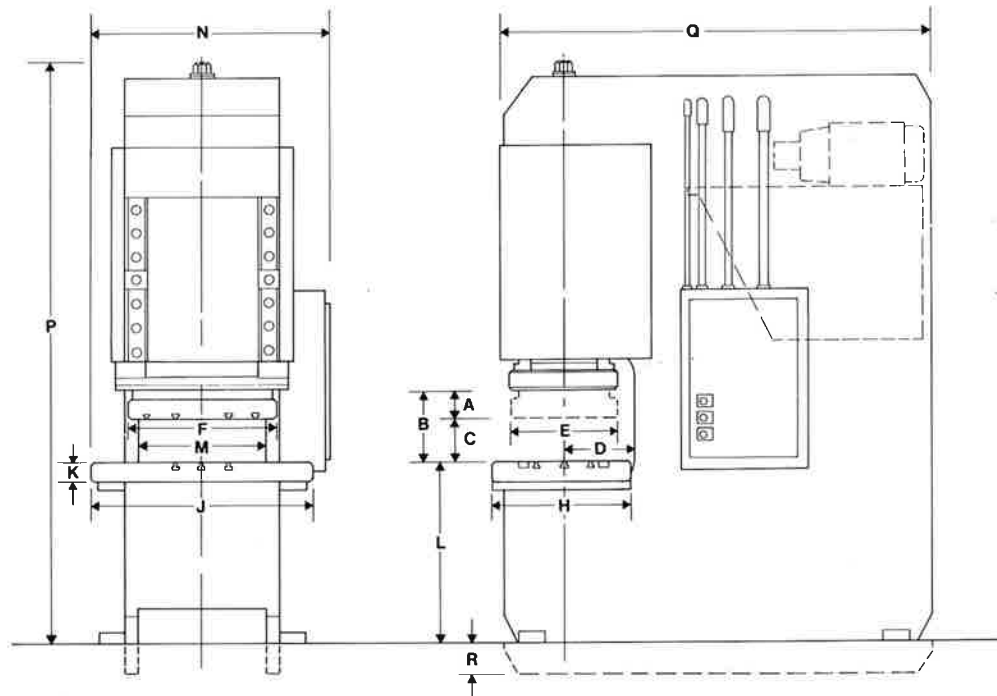
④ **Speed selection** consists of two advance speeds that are adjustable through the stroke range.

⑤ **Keyed mode selection switch** provides full controllability for setups and production applications in the following modes: off, inch, single-stroke manual return, and single-stroke automatic return.

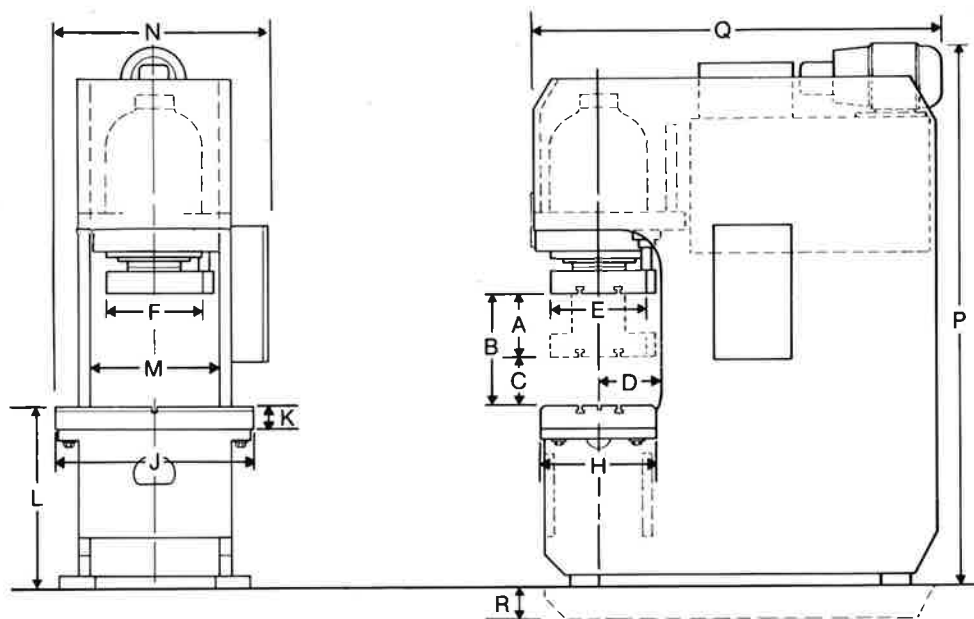


Specifications

OBS



Pressformer II



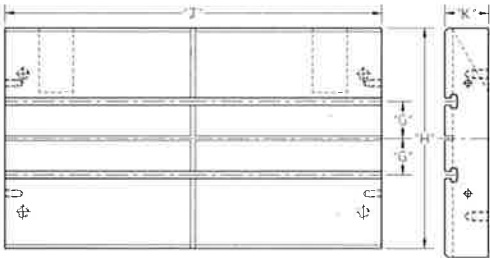
MODEL NO	CAPACITY (US Tons)	Stroke Length	Open Height	Closed Height	Throat Depth	Tool Holder Size	Bed Bolster Size	Bed Bolster Ht.	Distance Between Housings	Width	Height	Depth	Housing Projection Below Floor	Motor HP	Approximate Shipping Weight (Lbs.)			
	A	B	C	D	E	F	H	J	K	L	M	N	P★	Q	R			
100 PF II	100	12"	20"	8"	10"	15"	15"	18"	35"	4.25"	34"	23"	40"	93"	61"	-	25	10,000
150 PF II	150	12"	22"	10"	13"	18"	18"	24"	38"	4.75"	36"	26"	43"	102"	83"	-	30	13,000
200 PF II	200	12"	23"	11"	13"	20"	20"	24"	41"	4.75"	37"	27"	45"	105"	85"	-	40	17,000
250 PF II	250	12"	24"	12"	14"	22"	22"	26"	47"	4.75"	39"	31"	51"	114"	92"	-	40	24,000
300 PF II	300	12"	24"	12"	16"	24"	24"	28"	50"	5.75"	36"	34"	56"	116"	106"	9"	50	29,000
375 PF II	375	12"	26"	14"	16"	24"	24"	28"	51"	5.75"	36"	34"	57"	119"	110"	11"	60	39,000
500 PF II	500	12"	26"	14"	18"	26"	26"	32"	56"	6.75"	36"	38"	64"	128"	128"	20"	60	53,000
750 PF II	750	12"	34"	18"	22"	28"	28"	38"	66"	6.75"	36"	46"	77"	148"	154"	30"	75	101,000
1000 PF II	1000	12"	34"	18"	24"	30"	30"	42"	82"	7.5"	36"	52"	88"	153"	157"	33"	75	157,000
110PF OBS	110	10"	15.25"	5.25"	14.5"	21"	24"	27"	42"	4"	40"	29"	53"	126"	87"	-	30	28,000
150PF OBS	150	10"	17.25"	7.25"	16"	24"	34"	30"	50"	4.5"	40.5"	31"	59"	132"	98"	-	30	35,000
250PF OBS	250	12"	21.34"	9.75"	18"	28"	36"	34"	58"	5.5"	41.5"	36"	67"	159"	115"	7"	40	60,000

★ (P) - Standard oil cooler adds 24" to overall height (unit removable).
Optional bolster designs available - consult factory.

Specifications subject to change without notice.

Bed Bolster Designs

PF II Series

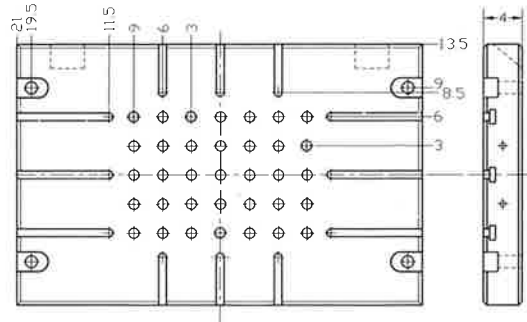


PF-II MODEL	H	J	G	K
100	18"	35"	4"	4.25"
150	24"	38"	4"	4.75"
200	24"	41"	4"	4.75"
250	26"	47"	6"	4.75"
300	28"	50"	6"	5.75"
375	28"	51"	6"	5.75"
500	32"	56"	6"	6.75"
750	38"	70"	6"	6.75"
1000	42"	82"	8"	7.5"

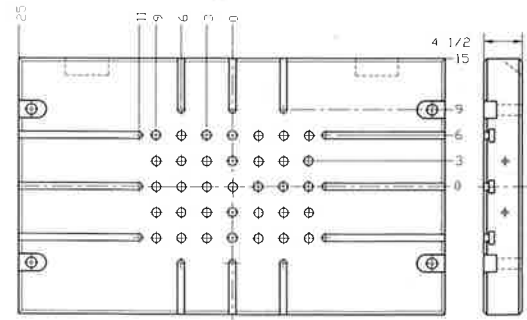
Tool holders feature two T-slots corresponding with bed bolster T-slots.

OBS Series

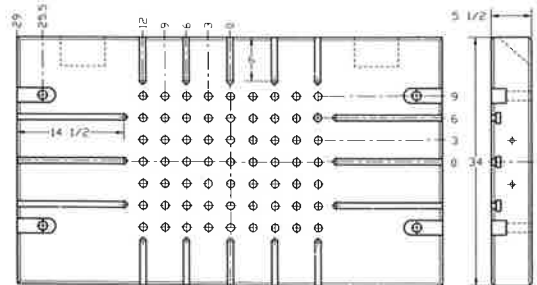
110 ton



150 ton



250 ton



For detailed dimensions, consult factory.



Pacific Press & Shear, Inc. has been a leading builder of hydraulic metalforming equipment since 1945. With manufacturing based in our Mt. Carmel, Illinois headquarters, Pacific builds machines for three primary market groups. They include:

- **Brake & Shear Market**

- Pacific K-Series Press Brake models from 175-3,000 tons.
- Pacific G-Series Shear 1/2"-2" capacity, up to 40' lengths.

- **Hydraulic Press Market**

Pacific manufactures C-Frame (OBS and Pressformer Series) and straight-side (D, M and OBL Series) hydraulic presses which range in size from 100 tons to 3,000 tons in various standard bed sizes. Pacific will also custom design and build a press to fit your production requirements.

- **Composite Press Market**

An emerging advanced composite marketplace is demanding quality capital equipment, and Pacific is geared to be the leader in spe-

cialty composite molding presses. Composite press lines include post-type, "D", "M", "C", and "N" models that fit the thermoplastic and thermoset molder's needs. Our hydraulic press building experience strengthens our ability to fill your composite press requirements.

It is our commitment to provide you with equipment that you can count on part-after-part, job-after-job, year-after-year. What needs can we help you with?



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GTA 5M/6/95

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