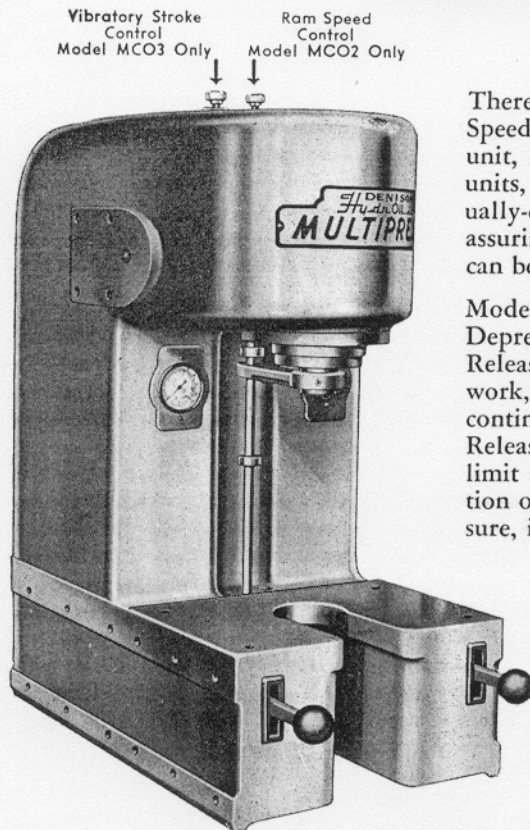


MANUALLY-CONTROLLED MULTIPRESS

M-



There are three models of manually-controlled MULTIPRESS—Basic, Multi-Speed and Vibra-Pres. Each of these models is available as either a 4 or 6-ton unit, identical in all physical dimensions and differing only in their pump units, maximum tonnages, and ram speeds. Unless specified otherwise, manually-controlled Multipresses are furnished with dual hand-lever controls, assuring maximum safety for the operator. Upon customer specification, they can be furnished with single hand-lever (right or left) or foot-pedal control.

Model MCO1, "Basic" MULTIPRESS offers throttle-type ram control. Depressing the hand levers causes the ram to descend from its upstroke limit. Releasing either of the levers causes the ram to stop or, if the ram is on the work, pressure to be relieved. Depressing that lever again, causes the ram to continue its downward travel, or pressure to be re-applied on the work. Releasing both levers, at any time, causes the ram to return to its upstroke limit and stop. Slow movement of the hand levers effects gradual acceleration or deceleration of ram movement—gradual increase or decrease of pressure, if the ram be on the work. Adjustable stop-collars, on the ram-control

shipper rod, permit close limitation of upward and downward ram travel anywhere between a 1/16-inch minimum and six-inch maximum stroke. The 4-ton unit affords close regulation of ram pressures anywhere between 300 and 8,000 pounds; maximum downward ram speed is 200 inches per minute, upward speed 300 ipm. Ram pressures of the 6-ton unit may be regulated between 300 and 12,000 pounds; maximum downward ram speed is 180 inches per minute, upward speed 270 ipm.

Model MCO2, "Multi-Speed" MULTIPRESS features rapid ram speed for the approach portion of its stroke and regulative speed for the pressing portion. Raising the hand levers slightly and momentarily, at any point in their downward travel, achieves this change of ram speed for the remainder of the stroke. Pressing

speed is regulative by means of a simple knurled knob adjustment screw. The 4-ton unit offers a rapid ram speed of 200 inches per minute, a pressing speed regulative between 20 and 200 ipm, an upward ram speed of 300 ipm, and ram pressures regulative between 800 and 8,000 pounds. The 6-ton unit offers a rapid ram speed of 180 ipm, a pressing speed regulative between 20 and 180 ipm, an upward ram speed of 270 ipm, and ram pressures regulative between 800 and 12,000 pounds. Both units have adjustable stop-collars on their shipper rods, for limiting upward and downward ram travel, or stroke, anywhere between 1/16-inch and 6 inches.

Model MCO3, "Vibra-Pres" MULTIPRESS presents the patented Vibratory HydroILic Pressure principle. Upon depressing the hand levers, the ram descends, exerts pre-set maximum pressure upon the work, reverses, and immediately makes short, repeated, uniform-pressure strokes upon the work until the hand levers are released; whereupon, the ram rises to its upstroke limit and stops. The short repeat strokes are regulative in length between .004" and 1/2", and the ram will follow the work downward as it compacts, or sinks, under the effect of ram pressure. Downward ram speed of the 4-ton unit is 200 ipm, upward speed 300 ipm, ram pressures regulative between 1600 and 8,000 pounds. Ram speed downward of the 6-ton unit is 180 ipm, upward speed 270 ipm, and ram pressures adjustable between 1600 and 12,000 pounds. Full upstroke limits are regulative between 1/16-inch and 6 inches by means of a single stop-collar on the ram control shipper rod. Downstroke is limitable by reversal upon attaining pre-set maximum pressure.