



Used PULLMAX P5000 FCP MACHINE

Year: 2003

Used: Good condition

C500 control

Warranty & service contacts available

In accordance with the relevant technical specification enclosed



## Frame

	<u>UK</u>	<u>US</u>
Machine's major dimensions	See layout drawing	See layout drawing
Weight	11 200 kg	25.000 lb
Number of feet	2	2
Area of each foot	1350 x 300 mm	54x12 in.
Pressure under feet	14 N/cm <sup>2</sup>	20 psi
Max. dynamic load under feet	± 1.9 N/cm <sup>2</sup>	±2.8 psi

## XY table

X travel	2590 mm <sup>1)</sup>	102 in.
Y travel	1425 mm <sup>2)</sup>	56 in.
Max. size of plate at max. acceleration	2500x1250x2 mm	48x96x0.08 in.
Max. plate thickness	6.4 mm	0.25 in
Min. plate thickness	0.7 mm	0.03 in.
Max. size of plate without repositioning	2500x1250 mm	48x96 in.
Reposition (x axis )	Yes	Yes
Max. weight of plate ( max. acceleration)	50 kg	110 lb
Max. weight of plate ( reduced acceleration)	150 kg	330 lb
Number of clamps	4pc	4pc
Grip width of each clamp	30 mm	1.2 in.
Clamp force	3000 N	660 lb
Table speed, along x axis	95 m/min	3740 IPM
- " - along y axis	90 m/min	3540 IPM
- " - diagonally	130 m/min	5150 IPM
Nibbling	Yes	Yes
Positioning accuracy over 1 m measured length	± 0.1 mm	± 0.004 in.
Repeat accuracy	± 0.03 mm	± 0.002 in.
Min. programmable length	0.01 mm	0.001 in.
Max Acceleration	17m/s <sup>2</sup>	670 in./s <sup>2</sup>

<sup>1)</sup> Includes 45 mm (1.77 in.) overrun at each end.

<sup>2)</sup> Includes 150/25 mm (6/1 in.) overrun.

## Press unit

Max. press force	300 kN	32 ton
Stroke length	35 mm	1.4 in.
Stroke rate (continuous)	500 rpm	500 rpm

## Tool changer

Number of tools in magazine	15	15
Largest tool diameter	76.4 mm	3 in.
Largest stripper diameter	110 mm	4.4 in.
Magazine rotation speed	40 rpm	40 rpm
Time for tool change	0.2 - 4 sec	0.2 - 4 sec
Distance from plate under toolmagazine - dielevel	17 mm	0.68 in.

### OptiTool

Number of rotating tools  
Minimum programmable rotation  
Positioning accuracy  
OptiTool rotation speed  
Max. rotation at 250 rpm

#### UK

all  
0.01 degree  
± 0.1 degree  
80 rpm  
20 degrees

#### US

all  
0.01 degree  
± 0.1 degree  
80 rpm  
20 degrees

### OrbitTool

Number of tool in cassette  
  
Max. press force  
Max. plate thickness  
  
Min. plate thickness

4 Dia. 0-12 mm  
4 Dia. 12-20 mm  
6 ton  
4 mm Dia. 0-12 mm  
2.5 mm Dia. 12-20 mm  
0.7 mm

4 Dia. 0 - 0.48 in.  
4 Dia. 0.48 - 0.8 in.  
6 ton  
0.157 in. Dia. 0 - 0.48 in.  
0.1 in. Dia. 0.48 - 0.8 in.  
0.028 in.

### Trap door

Size of trap door  
Max. part size  
Min. part size  
Max. plate thickness  
Min. plate thickness

525 x 450 mm  
450 x 400 mm  
50 x 50 mm  
6.4 mm  
1 mm

21x18 in.  
18x16 in.  
2x2 in.  
0.250 in.  
0.04 in.

### Electrical system

Max. permissible voltage fluctuation

±5 %

±5%

POWERkVa	VOLTAGE V	MAX. CONT. CURRENTA	REC. MAIN FUSE	MIN CABLE SECTIONmm²
40	220	95	100	35
	380	60	63	16
	415	56		
	440	53		
	460	50		
	500	46		
	550	42		

### Air system

Working pressure  
Max. air consumption  
Min. size of supply pipe

0.6 MPa (=6bar)  
50 Nm³/h  
3/4"

85 psi  
30 ft³/min  
3/4 in.

### Hydraulic system

Working pressure  
Pump flow  
Tank capacity  
Oil

6.0 MPa (=60 bar)  
12/16 l/min  
60 l  
ISO VG 22

850 psi  
3.2/4.2 ft³/min  
15.8 gallons  
ISO VG 22



### Lubrication system

	<u>UK</u>	<u>US</u>
Dose volume (adjustable)	0 - 0.033 cm <sup>3</sup> /stroke	0 - 0.033 cm <sup>3</sup> /stroke
Lubrication interval Punch position - Power on	150 strokes in 1.5 min	150 strokes in 1.5 min
During operation	1 stroke/10 hit	1 stroke/10 hit
Lubrication interval X-Y screws	1 stroke/ 2.5 min	1 stroke/ 2.5 min
Tank capacity	1.5 l	0.4 gallons



**Loading equipment**

	<b><u>255 501 70</u></b>	<b><u>255 701 70</u></b>
Max. sheet dimension	2500 x 1250 mm	3000 x 1250 mm
Min. sheet dimension	1000 x 500 mm	
Max. sheet thickness	6 mm	
Min. sheet thickness	0.7 mm	
Max. sheet weight	150 kg	180 kg
Positional tolerance of sheet in loading position	+25 -0	
Max. stack height	200 mm	
Double sheet pick-up control	Yes	
Positioning speed	100 m/min	
Cycle time for loading	10* sec	
Number of vacuum pads	17	19
Vacuum pad diameter	100 mm	

**Unloading eq. incl. roll-top table**

Number of clamps	4
Max. sheet weight	150 kg
Max. stack height (at del. with carriage)	230 mm
(del. on pallet)	500 mm
Positioning speed, programmable	100 m/min
Cycle time for unloading	abt 9 sec
Cycle time for loading/unloading	abt 22 sec

**Wagon loading equipment**

	<b><u>255 81X XX</u></b>
Number of carrier	1 or 2
Max. sheet dimension	2500 mm x 1250 mm or 3000 mm x 1250 mm
Min. sheet dimension	1000 x 500 mm
Max. sheet thickness	6 mm
Min. sheet dimension	0.7 mm
Max. sheet weight on pallet	2500 kg
Max. stacking height of pallet	200 mm
Unloading station	Optional

**Pick part unit**

	<b><u>255 304 70</u></b>
Max. size of picked part	2500 x 800 mm
Min. size	100 x 100 mm
Positioning speed, programmable	110 / 80 m/min
Max. weight of parts	75 kg
Cycle time, (time for stopping the machine)	9* sec

\* = The time can various slightly, according to varios driving