

REQUEST FOR QUOTATION TRANSFER SERVO PRESS - FOR REGION POLAND KIELCE
Address: Zagnańska 27, 25-528 Kielce, Poland

Rev2 - 22/03/2023

Pos.	Transfer Line destination to KIELCE (POLAND)	CUSTOMER'S REQUEST	TO FILL UP BY SUPPLIER
Ref.			
1	MAIN DATA SHEET		
2	Blank length min-max (mm) (on Y axis direction) - cross feeding direction	200-2000	
3	Blank width min-max (mm) (on feed line) - feeding direction	100-1000	
4	Blank thickness (mm)	0,4- 3,5	
5	Double blank movement on x axis direction	yes	
6	Double blank sensor quantity	4	
7	Maximum blank weight (Kg)	30	
8	Maximum stack weight (Kg)	5000	
9	Maximum stack height (mm)	500	
10	Material	Steel	
11	Yeld Strenght (Re) (Mpa)	max 1500	
12	PRESS		
13	Drive System	Servo Eccentric (or equivalent)	
14	Designation /Ram Force (KN)	Single Action/16000	
15	Number of suspension Point (#)	indicate	
16	Rated tonnage point at distance in mm up from bottom dead center	indicate	
17	Rated energy at min and max s.p.m.	indicate graph	
18	Load distribution "Front-back" and "left-right"	indicate graph	
19	Speed min-max [SPM] in Crank motion	indicate (min >= 25 SPM)	
20	Speed min-max [SPM] in pendulum motion (at different stroke) indicate for max and min stroke	indicate Force stroke diagram (min >= 35 SPM)	
21	Type of servo motion curve available	indicate	
22	CONSTRUCTION FEATURES - MISCELLANEUS		
23	Crown	Describe the main choices made for : - materials - design - construction - surface treatments	
24	Cinematic		
25	Slide		
26	Bed		
27	Hydraulic Equipments	Rexroth (or equivalent)	
28	Pneumatic Equipments	Festo or SMC (or equivalent)	
29	Bearings	SKF or TIMKEN	
30	Air flowmeter in the pneumatic panel in the pit	indicate	
31	Flex hydraulic or pneumatic hoses maximum lenght	max 1000 (mm)	
32	Electrical Component	Siemens (or equivalent)	
33	Visualisation and Operating System	Tia Portal	
34	Safety System	Safety Siemens (or equivalent)	
35	Main Operator Panel	Siemens (or equivalent)	
36	UPRIGHT FRAME OPENING		
37	Front	indicate (mm)	
38	Side (front to back x height)	indicate (mm)	
39	Height from floor level to top of bed	indicate (mm)	
40	Height from floor to bolster top	indicate (mm)	
41	Overall height of Press from floor level	indicate (mm)	
42	Maximum depth of Foundation below floor level	indicate (mm)	
43	Maximum noise level	indicate (dB)	
44	Slide, Bed Deflection	indicate max 0,125 (mm/m)	
45	Total Weight approx.	indicate (Kg)	
46	SLIDE - WORK AREA		
47	Bolster area L / R [mm]	5000	
48	Bolster area F / B [mm]	2500	
49	Number of stations (Moving Bolster)	2 Bolsters, Front to Back	
50	Bolster Height	indicate	
51	Slide Stroke [mm]	750	
52	Slide adjustement [mm]	300	
53	Die Height min. [mm]	1100	
54	Die Height max. [mm]	1400	
55	UPPER DIE CLAMP		
56	Hydraulic clamps slide (movement automatic; clamping hydr. (#)	indicate	
57	Traveling System	indicate Yes/Not	
58	Rotate System (like option)	indicate	
59	Maker	indicate - (Pascal)	
60	Movement time for hydraulic clamps	indicate	
61	MOVING BOLSTER DEVICE		
62	Type	indicate	
63	Quantity	2	
64	Traveling speed	indicate	

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65	Carriage capacity	50 T	
66	Operation Mode	semi-automatic	
67	Working of the bolster for insert of the caps in the holes of cushion pin	indicate	
68	MOVING BOLSTER CLAMPER		
69	Type/Brand	indicate	
70	Quantity	indicate	
71	MOVING BOLSTER LIFTER		
72	Type/Brand	indicate	
73	Quantity	indicate	
74	Capacity	indicate	
75	Stroke	indicate	
76	Location	indicate	
77	MAIN MOTOR		
78	Type Main Servo Motor	indicate	
79	Main Servo Motor Qty	indicate (#)	
80	Main Servo Motor rate Power	indicate (KW)	
81	Energy Storage Motor Qty	indicate (#)	
82	Energy Storage Motor Power	indicate (KW)	
83	Type of inverter	indicate	
84	Maker	indicate	
85	CLUTCH AND BRAKE	N.A.	
86	Type	indicate (Hydraulic)	
87	Operation	indicate	
88	Control	indicate	
89	Maker	indicate (preferred Orthingauss)	
90	Oil cooling method	indicate/included	
91	ROTARY CAM LIMIT SWITCH	N.A.	
92	Gear box	indicate	
93	Type	indicate	
94	FLYWHEEL BRAKE	N.A.	
95	Type	indicate	
96	Flywheel stop time by flywheel brake	indicate	
97	Material of the Lining	indicate	
98	SLIDE MICRO INCH DEVICE		
99	Type/Brand	indicate	
100	Capacity	indicate	
101	Speed	indicate	
102	Operation	indicate	
103	OVERLOAD PROTECTION DEVICE		
104	Over load protection cylinder	indicate	
105	Type/Brand	indicate	
106	Stroke of hydraulic cylinder	indicate	
107	DIE HEIGHT ADJUSTMENT DEVICE		
108	Type/Brand	indicate	
109	Speed of adjustment	indicate	
110	Display of adjustment	indicate	
111	Operation	indicate	
112	Adjustment indicator	indicate	
113	SLIDE COUNTER BALANCE DEVICE		
114	Type	indicate	
115	Quantity	indicate	
116	Capacity	indicate	
117	Air pressure	indicate	
118	Air pressure regulation	indicate	
119	CUSHION IN THE BED	EXCLUDED	
120	Cushion Type (Hydraulic/Pneumatic)	hydraulic	
121	Cushion Force [kN]	2000	
122	Cushion stroke (adjustable) mm	250	
123	Cushion Preassure (adjustable)	indicate	
124	Cushion Area [mm] Indicative measures for each station	indicate	
125	Cushion locking device	indicate	
126	Cushion snubber function	indicate	
127	Availability of insert of the caps in the holes of cushion pin	Indicate Yes/Not	
128	CUSHION IN THE SLIDE	EXCLUDED	

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129	Cushion Type	pneumatic	
130	Cushion Force [kN]	indicate	
131	Cushion Stroke [mm]	indicate	
132	Cushion Area [mm]	indicate	
133	DESTACKER FEEDER	OPTIONAL	
134	Destaker (# of arms)	1 or 2	
135	Feeding Station (n°)	2	
136	Brand/Manufacturer	Indicate	
137	Type	Indicate	
138	Speed Min - Max (SPM) at max and min size of sheet	Indicate	
139	Telescopic loading conveyor (Motorized and programmable pitch)	Indicate	
140	Telescopic loading conveyor in function like microfeeder	Yes	
141	Centering double blanks in cross feeding line	Yes	
142	Centering double blanks in feeding line	Yes	
143	ONLY CONVEYOR BELT TO BE USED WITH DECOILER LINE (IF DESTAKER WILL BE INSTALLED A YEAR LATER)	OPTIONAL	
144	Type (# belts)	indicate	
145	Adjustable Height on z axis from top of moving bolster (mm)	indicate (~600 mm-800 mm)	
146	Automatic programmable position of the belts with Servomotor (Motorized and programmable pitch)	indicate Yes/Not	
147	Function (progressive/transfer)	indicate Yes/Not	
148	Design of the conveyor must be made to work also only with Destacker. Destaker infrastructure should be added later. Hardware and Software must be ready	indicate Yes/Not	
149	Conveyor initially must be designed to work with the Decoiler Line (Magnets belts)	indicate	
150	Oiler (1 type of oil) programmable	Yes	
151	ELECTRONIC TRANSFER 3 AXIS		
152	Electronic Transfer 3 axis	Yes	
153	Antivibration System	Indicate Yes/Not	
154	Brand/Manufacturer	Indicate	
155	Max Load at max speed	Indicate	
156	X-Axis feed min.-max.stroke (programmable) (mm)	1200	
157	Y-Axis closing min.-max. stroke (programmable) (mm)	~600-3000	
158	Z-Axis total min.-max. stroke (programmable) (mm)	>=300	
159	Axis speed should be able to controlled separately	Indicate	
160	DIE AUTOMATION CONTROL DEVICE AIR COUPLER (TOOL FUNCTIONS)		
161	Type	Air connection (Tool functions)	
162	Composition	Four (4) Solenoid valves in the Bed, One (1) pair of air coupler in the Bed, Eight (8) pair of air coupler on the each M/B	
163	Size of air coupler	PT 1/2 nipple/coupling	
164	Location	Left & Right side of Moving bolster	
165	Control	By P.L.C and graphic panel display	
166	DIE AUTOMATION CONTROL DEVICE ELECTRIC (TOOL FUNCTIONS)		
167	Type	24 pin connector (Tool functions)	
168	Quantity	Two (2)	
169	Location	Left & Right side of Moving bolster	
170	DIE AUTOMATION CONTROL DEVICE ELECTRIC (TOOL IDENTIFICATIONS)		
171	Type	16 pin connector (Tool identifications)	
172	Quantity	Two (2)	
173	Location	Left & Right side of Moving bolster	
174	DIE AUTOMATION CONTROL DEVICE ELECTRIC (CONVEYOR FUNCTIONS)		
175	Type	6 pin connector (Conveyor functions)	
176	Quantity	Two (2)	
177	Location	On the each RF & LB Upright	
178	LADDER AND CATWALK		
179	Type	indicate	
180	Catwalk dimension	indicate	
181	Height of guard rail	indicate	
182	Back guard on ladder	indicate	
183	SCRAP CHUTE CENTER		
184	Scrap chute in Bed and Moving Bolster (Center)	indicate Yes/Not	
185	SCRAP CHUTE FRONT REAR		
186	Scrap chute in Bed (Front / Rear)	indicate Yes/Not	
187	Lateral scrap chutes angle opening (Front/Rear)	100°	
188	SAFETY		
189	Light Curtain Front & Rear Press	Light curtain is emergency stop device, which stops the slide immediately, if the operator violates the danger limit during operation	

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190	Clutch-brake unit	Safety valve, double body with large internal way parallel flow, rapid response and cyclical control, for clutch-brake unit activation.	
191	Cam switch	indicate	
192	Heat sensors	Temperature is controlled at different points of the press (indicate) Temperature is picked up by means of sensors connected to analog input cards. In the event of the temperature exceeding the preset limit, the press shall be stopped at the T.D.C. and a fault warning is displayed.	
193	Slide locking	Slide locking system with controlled drive light signaling to ensure the protection of workers during operations carried out under the press.	
194	SAFETY FENCE		
195	Type	indicate	
196	Quantity	indicate	
197	Location	indicate	
198	OTHER SAFETY DEVICE - LIFTING DOORS		
199	Type	indicate	
200	Quantity	indicate	
201	Location	indicate	
202	With window, reinforced with metalic net	indicate	
203	AUTOMATIC DIE CHANGING SYSTEM		
204	Full automatic setup	indicate	
205	Target for setup time (min)	5	
206	Semi-automatic Set up (option)	indicate like option alternative to Full automatic setup	
207	Die code must be included	Yes	
208	Intermediate bars changed automatically during die change	Yes	
209	Data logging should be avaiable on the display and also to be exported, for each die receipe, eg: (1 counter for total parts produced) (1 counter for last batch produced) historical SPM historical parameter modification backup receipe actual and previous batch	indicate	
210	ACCESSORY		
211	Monitoring	indicate	
212	Comunication with Automation	indicate	
213	Safety Device	indicate	
214	Utility	indicate	
215	AIR COUPLERS FOR SERVICE TOOLS		
216	Quantity	Two (2)	
217	Size	1/2 Quick joint	
218	Location	On the each RF & LB Up-right	
219	ELECTRIC RECEPTACLES FOR SERVICE TOOLS		
220	Quantity	Two (2) sets of below	
221	380V, 5A, 3 phase	One (1)	
222	220V, 5A, 1 phase	One (1)	
223	Location	On the each RF & LB Upright	
224	SPECIAL OPTION		
225	Load monitor	indicate	
226	Type	indicate	
227	Quantity	indicate	
228	Maker	indicate	
229	ANTIVIBRATION DEVICE		
230	Type	indicate	
231	Quantity	indicate	
232	Location	indicate	
233	SLIDE LOCKING DEVICE		
234	Type	indicate	
235	Quantity	indicate	
236	Locking position	indicate	
237	PNEUMATIC SYSTEM		
238	Pressure	indicate	
239	Temperature	indicate	
240	Main air supply for pipe size	indicate	
241	PNEUMATIC SYSTEM AIR TANK		
242	Type	indicate	
243	Quantity	indicate	
244	Capacity	indicate	
245	HYDRAULIC SYSTEM OIL TANK		
246	Type	indicate	
247	Quantity	indicate	
248	Capacity	indicate	
249	LUBRICATION OIL TANK		
250	Type	indicate	
251	Quantity	indicate	
252	Capacity	indicate	

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253	LUBRICATION SYSTEM		
254	Type	indicate	
255	Control	indicate	
256	Lubrication control points	indicate	
257	lubrication system	dual filter with quick changeover facility	
258	ELECTRIC SYSTEM		
259	Power	indicate	
260	Control	indicate	
261	CONTROL SYSTEM		
262	PLC type (Safety)	indicate	
263	HMI	indicate	
264	Communication protocol (Profi Net, Profi DP, enc....)	indicate	
265	STANDARD SPARE PARTS		
266	List	indicate	
267	GENERAL CONDITION ELECTRIC POWER SUPPLY		
268	Voltage	380 VAC ±10%	
269	Phase	3 ph. 4 wires	
270	Frequency	50 Hz ± 5%	
271	Max connecting Power for Press (KVA)	indicate	
272	Max Peak Power Servo converter (KVA)	indicate	
273	WATER SUPPLY		
274	Pressure	indicate	
275	Temperature	indicate	
276	Main water supply for pipe size	indicate	
277	Consumption Flow l/m'	indicate	
278	STANDARD AND REGULATION		
279	Poland	indicate	
280	INSPECTION AND TEST		
281	Preliminary test	indicate mode	
282	Final acceptance with production	tbd	
283	CE MARK	confirm	
284	WARRANTY		
285	Months	24	
286	MANUAL & NAME PLATE		
287	Manual	Italian/English/ Polish	
288	Name plate	Italian/English/ Polish	
289	AFTER SALES ASSISTANCE		
290	Teleservice	indicate	
291	The company that provides assistance	indicate	
292	The headquarters of service	indicate	
293	The time for action by calling	indicate	
294	TIMING		
295	Timing preliminary testing (EXV) (weeks/months)	indicate	
296	Timing of delivery FOB from Order (weeks/months)	indicate To choose in alternative	
297	Timing Sea transport CIF (weeks/months)		
298	Inland transport from the Harbor to the Polland Plant (weeks/months)		
299	Timing Delivery DAP Poland Kielce (weeks/months)		
300	Timing of Assembly (weeks/months)	indicate	
301	Timing Commissioning (weeks/months)	indicate	
302	Timing Buy off (weeks)	indicate	
303	Lead time Full project (weeks/months)	indicate	
304	PRICE (€)		
305	Press	Indicate	
306	Electronic Transfer 3 axis	Indicate	
307	Packing	Indicate	
308	Delivery EXV	Indicate To choose one of type of delivery	
309	Delivery FOB (To specify Harbour)		
310	Delivery DAP		
311	Sea transport CIF (To specify Harbour)		
312	Inland transport from the Harbor to the Polland Plant		
313	Crane & Lifting	Indicate	
314	Complete Assembly & Commissioning	Indicate	
315	Training (line operator - electric / electronic maintenance - mechanical) maintenance)	Indicate	
316	Option 1: Cushion in Bed	excluded	
317	Option 2: Destacker 1 or 2 arms	Indicate	
318	Option 3:Infeed Magnet Conveyor Belt to use with Decoiler	Indicate	
319	Option 4: Conveyor Belt to unload parts	Indicate	
320	Option 5: Technical Advisors after installation 2 weeks for 2 Shift	Indicate	
321	Option 6: Integration with Feeding line	Indicate	
322	Option 7: -	Indicate	
323	Option 8: -	Indicate	
324	TOTAL PRICE	Indicate	