

SECTION 2 - WS-200 Track Press Specifications

DIMENSIONS

Weight ... 5916 lbs (2690 kg)	Width (Depth) (without conveyors)..... 48 inches (1,2 m)
Length 88 inches (2,2 m)	Height 46 inches (1,1 m)

RAMS

Capacity ... 200 tons (182 t), each ram	Speeds -	
Travel 5-7/8 inches (149 mm)	<u>50 Cycle</u>	<u>60 Cycle</u>
Ram Diameter: 7.5 inches (190 mm)	Approach 63 IPM (1,6 m/min)	76 IPM (1,9 m/min)
Piston Diameter: 8 inches (203 mm)	Pressing 7 IPM (0,4 m/min)	21 IPM (0,5 m/min)
	Return 45 IPM (3,7 m/min)	171 IPM (4,3 m/min)

JAW

The Retractable Jaw is raised and lowered hydraulically. Manual fine adjustment aligns the Jaw with tooling.

HYDRAULIC PUMP UNIT

Pumps -

High Pressure Pump 4.76 gpm (18,0 lpm) 7960 psi (545 atm.) max.
Low Pressure Pump 12.00 gpm (45.5 lpm) 2000 psi (136 atm.) max.

Reservoir -

Total - 50 US gallons (190 l)
Usable - 35 US gallons (132 l)

Electric Motor -

20 Hp (14.9 kW) 3 Phase electric.	
Standard Voltages:	
<u>50 Hz (1500 rpm)</u>	<u>60 Hz (1800 rpm)</u>
440V/29A,	460V/27A
380V/30A	230V/54A
220V/56A	208V/60A
Other voltages available	

POWER WINCH

Hydraulically operated power winch has a 8,000 pound (3640 kg) pulling capacity.

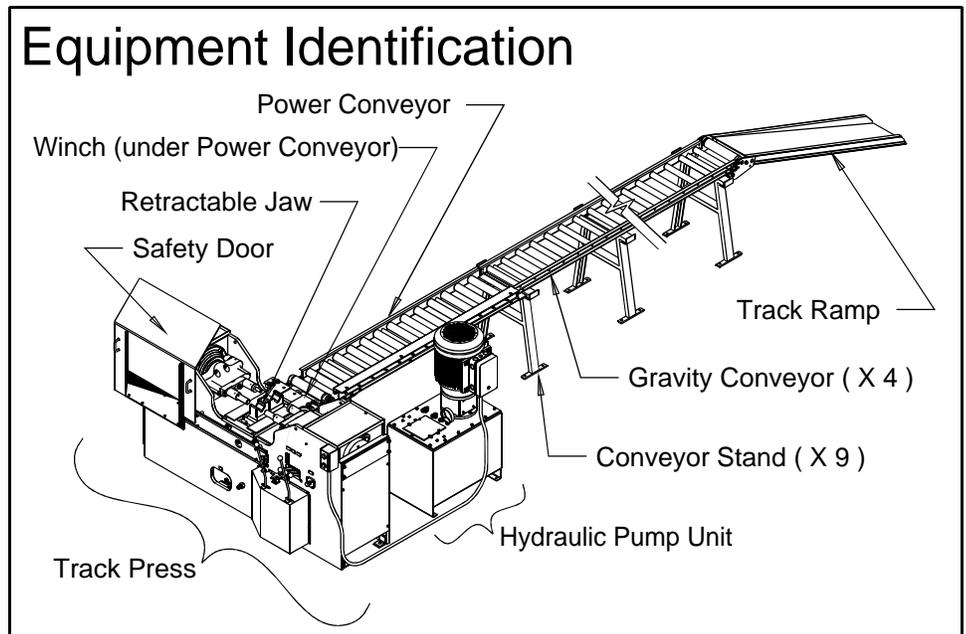
POWER CONVEYOR

Hydraulically operated power conveyor moves track in and out of work area.

GRAVITY CONVEYORS AND STANDS

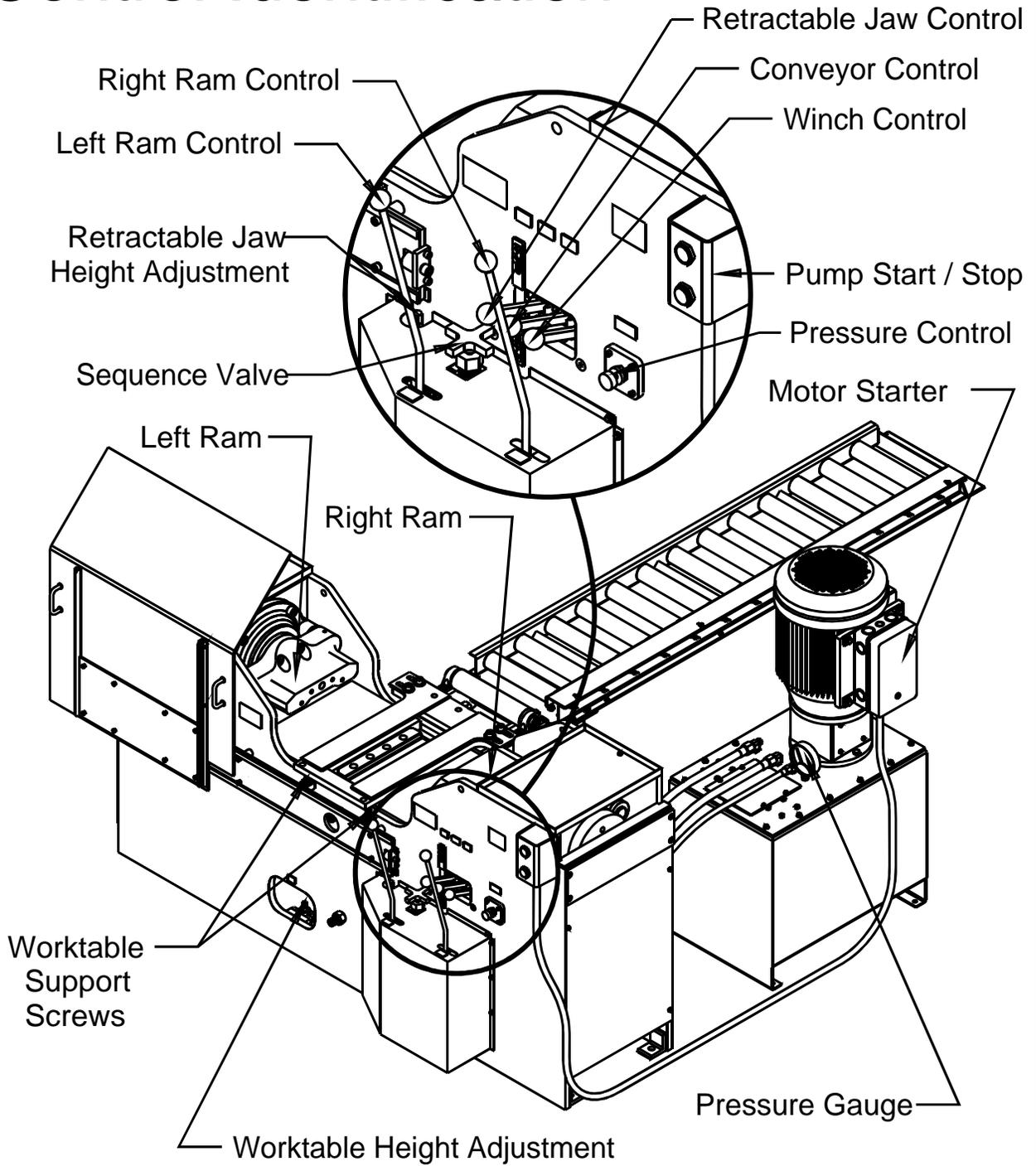
Standard Duty Conveyor - nine Conveyor Stands support four Conveyor Sections

Optional Shoe Lifting Device - eleven Conveyor Stands support five Conveyor Sections



SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE

Control Identification



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Left Ram Control - extends and retracts the Left Ram (or retracts both rams if the Sequence Valve is open)

With the Sequence Valve closed (fully clockwise), moving the Left Ram Control to the **right** extends the Left Ram, and moving the Left Ram Control to the **left** retracts the Left Ram.

With the Sequence Valve open (fully counterclockwise), moving the Left Ram Control to the **left** retracts both the Left Ram and the Right Ram.

Right Ram Control - extends and retracts the Right Ram (or extends both if the Sequence Valve is open)

With the Sequence Valve closed (fully clockwise), moving the Right Ram Control to the **left** extends the Right Ram, and moving the Right Ram Control to the **right** retracts the Right Ram.

With the Sequence Valve open (fully counterclockwise), moving the Right Ram Control to the **left** extends both the Left Ram and the Right Ram.

Sequence Valve - allows both rams controls to act separately (when closed) or together (when open)

With the Sequence Valve **closed**, the Left and Right Ram Controls act independently.

When the Sequence Valve is **open**, the Left Ram Control retracts both the Left and the Right Ram, and the Right Ram Handle extends both the Left and the Right Ram.

Retractable Jaw Control - raises and lowers the Jaw for track chain movement

Pulling up on the Retractable Jaw Control lifts the Retractable Jaw.

Pushing down on the Retractable Jaw Control lowers the Retractable Jaw.

(Note: if the Retractable Jaw moves too quickly, adjust the Retractable Jaw Control Stops)

Conveyor Control - moves the Power Conveyor rollers which moves the track chain

Pulling up on the Conveyor Control moves the track chain toward the operator.

Pushing down on the Conveyor Control moves the track chain away from the operator.

Winch Control - pays out and reels in the winch cable, which pulls the track chain onto the Conveyor

Pulling up on the Winch Control retracts the Winch Cable.

Pushing down on the Winch Control pays out the Winch Cable.

Pump Start / Stop - starts and stops the Electric Motor which power the Track Press

Pressing the **Start** Push Button starts the Electric Motor.

Pressing the **Stop** Push Button stops the Electric Motor.

Remote Control Valve - sets the system pressure, and the ram force

Turning the Remote Control Valve's knob **clockwise** increases the operating pressure.

Turning the Remote Control Valve's knob **counterclockwise** decreases the operating pressure.

The jam nut behind the adjustment knob is used to lock the valve at a particular setting.

Pressure Gauge - shows the system pressure

The Track Chart shows the proper pressures for the assembly of selected types of track chain.

Retractable Jaw Height Adjustment - sets the height of the Retractable Jaw

Turning this (using a 5/8" wrench or socket) raises or lowers the Retractable Jaw and the track chain it holds. Use this adjustment to bring the track chain into vertical alignment with the tooling.

Worktable Height Adjustment - raises and lowers the Worktables and the track chain links they support

Turning this (with a 5/8" wrench or socket) raises or lowers the Worktables. Use this during the track chain's reassembly to bring track chain links into vertical alignment with the pins and bushings.

Worktable Support Screws - support the front end of the Worktable

Adjust these (using a 5/8" hex key or Allen wrench) to touch the Worktables' underside, whenever changing the height of the Worktables. Always adjust these down before lowering the Worktables.