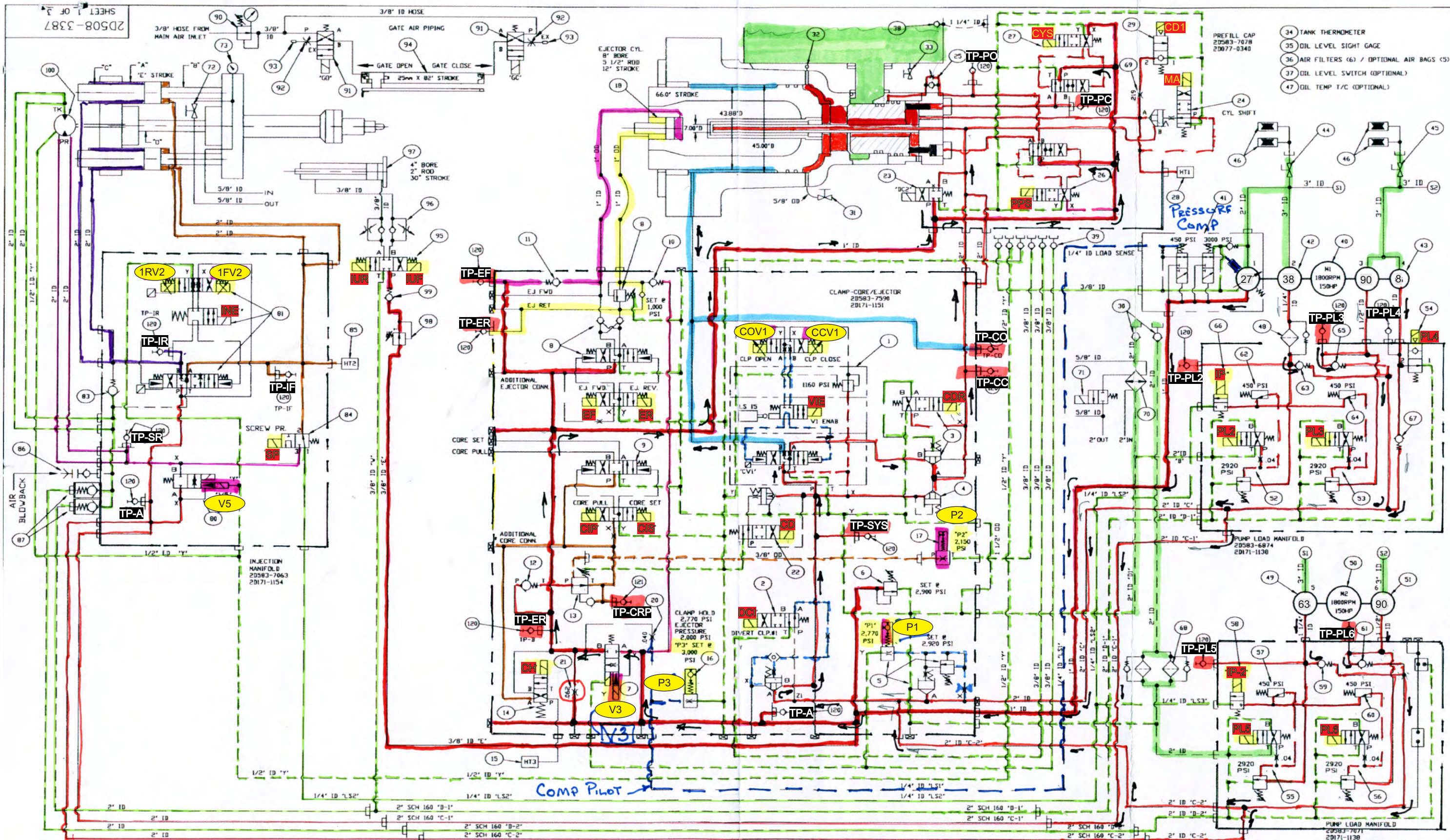


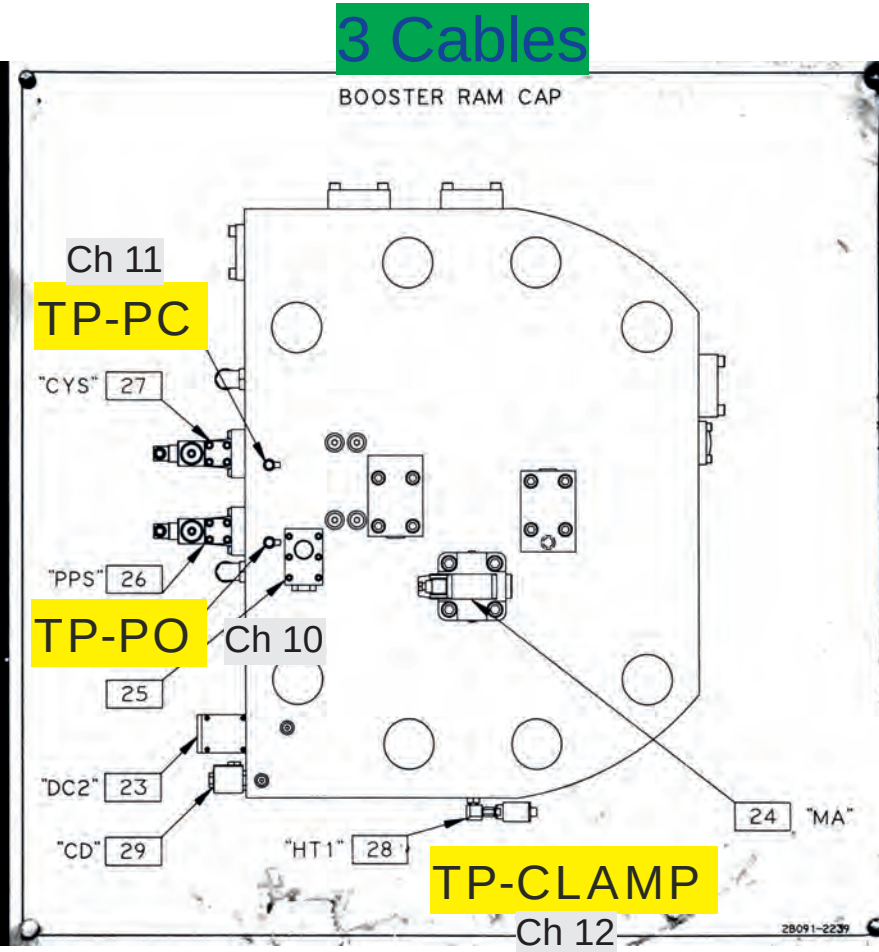
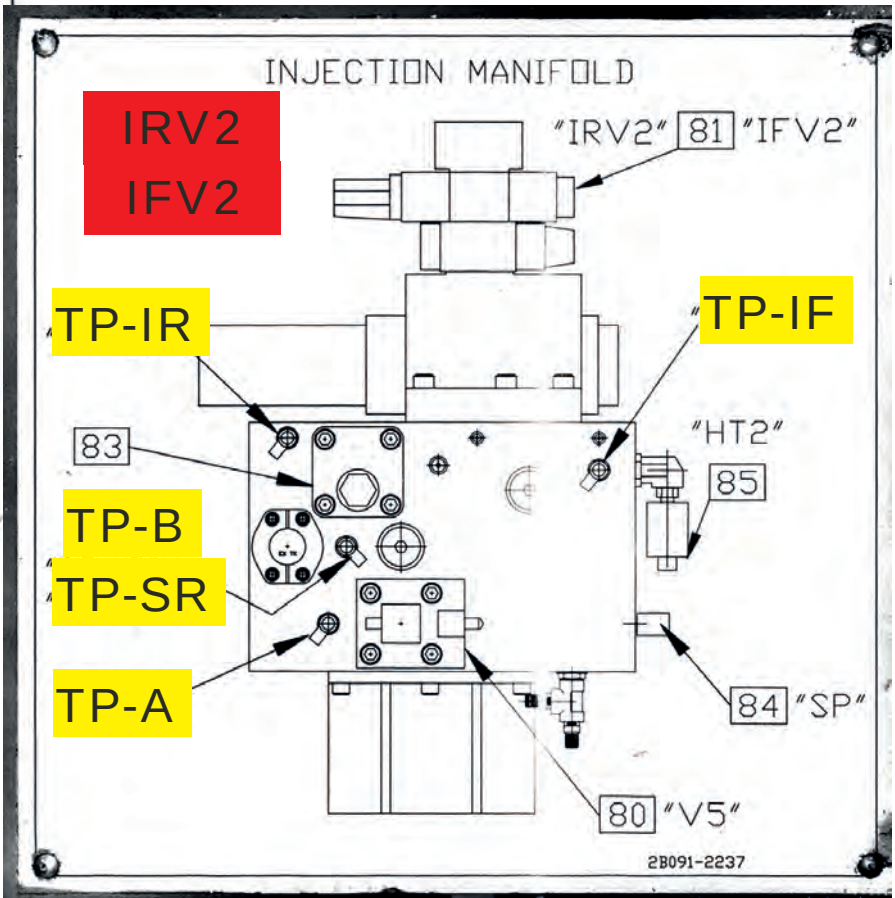
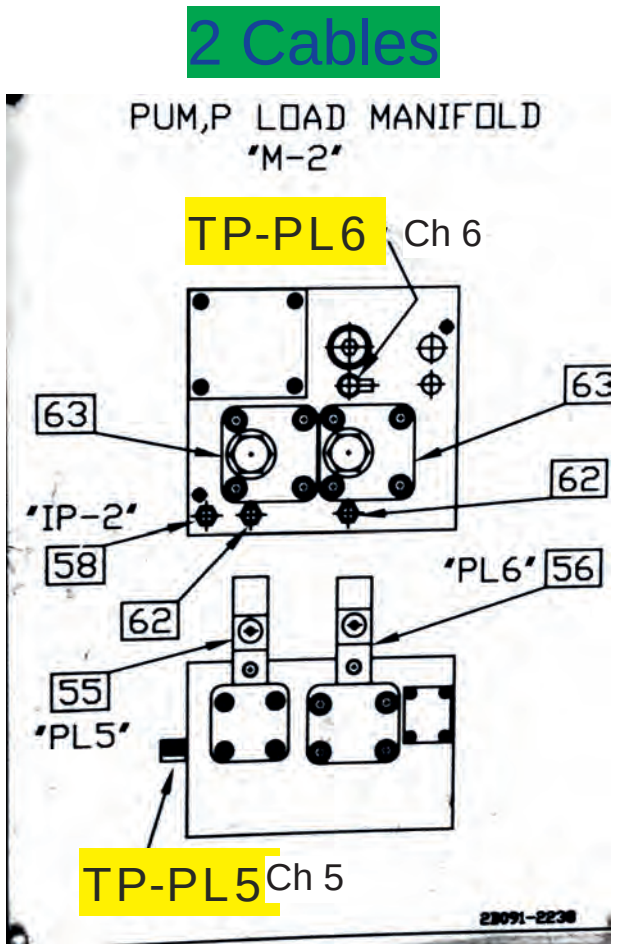
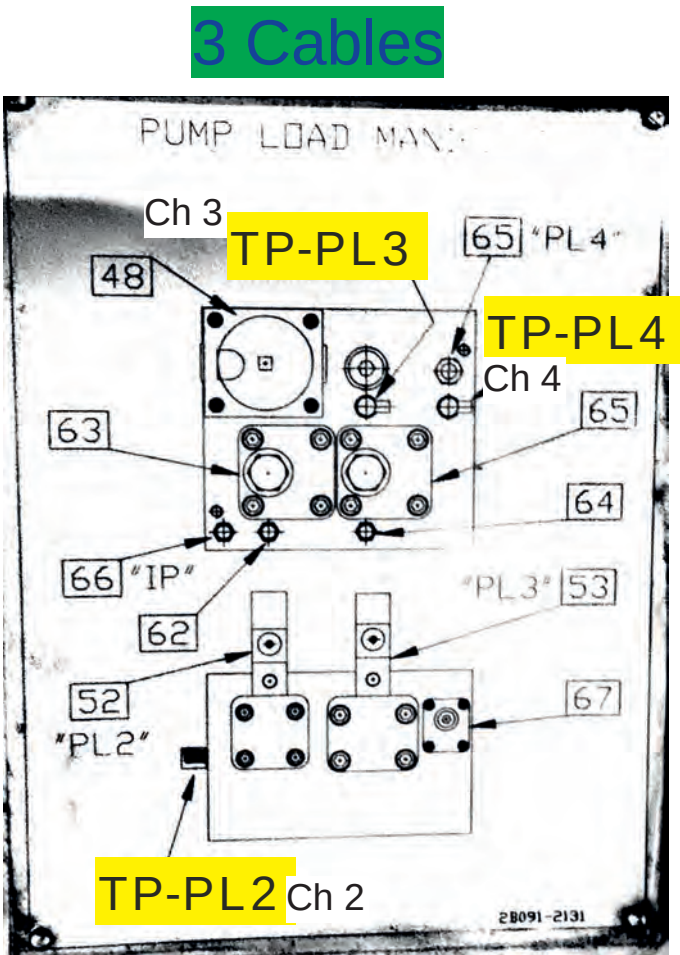
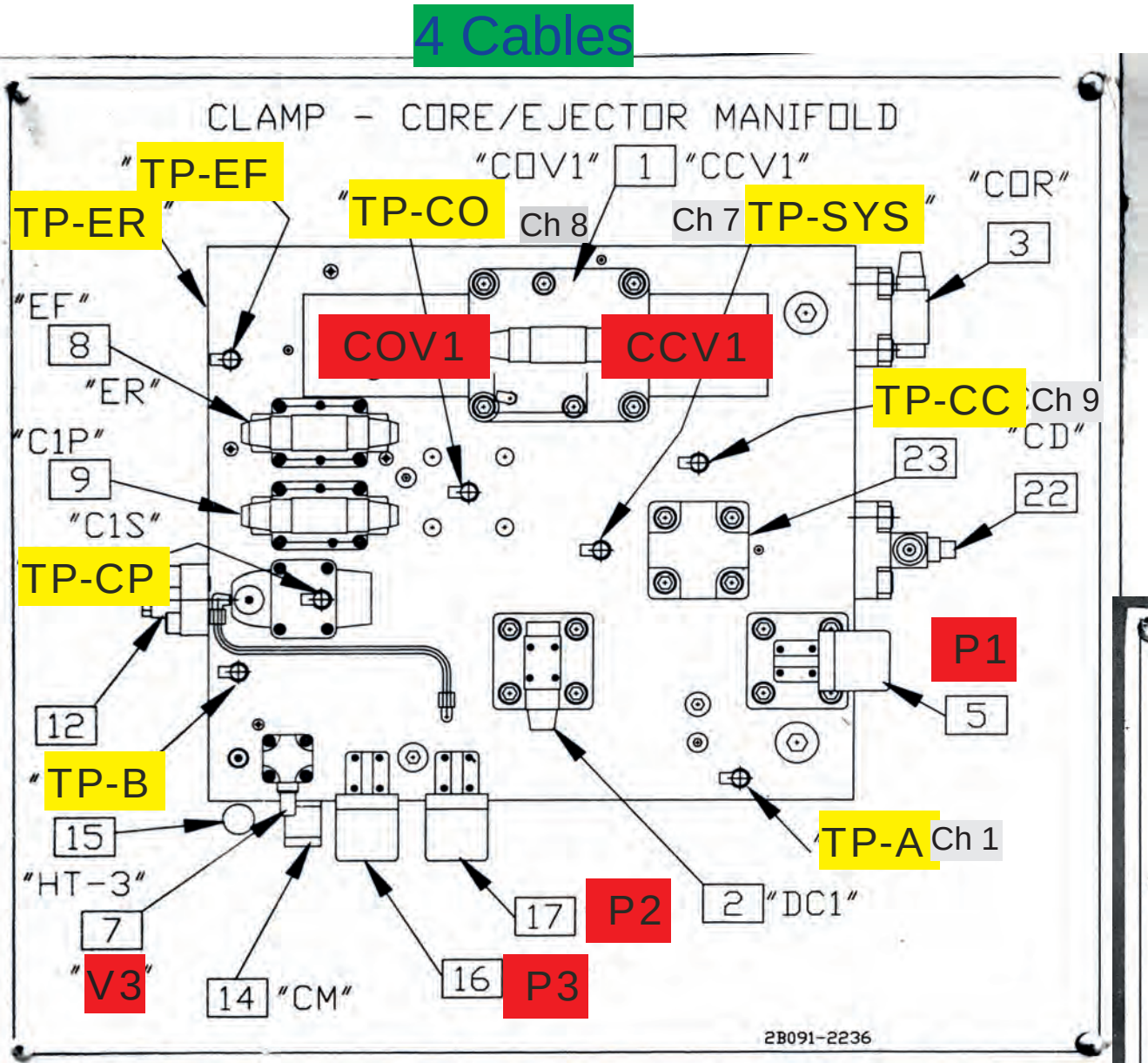


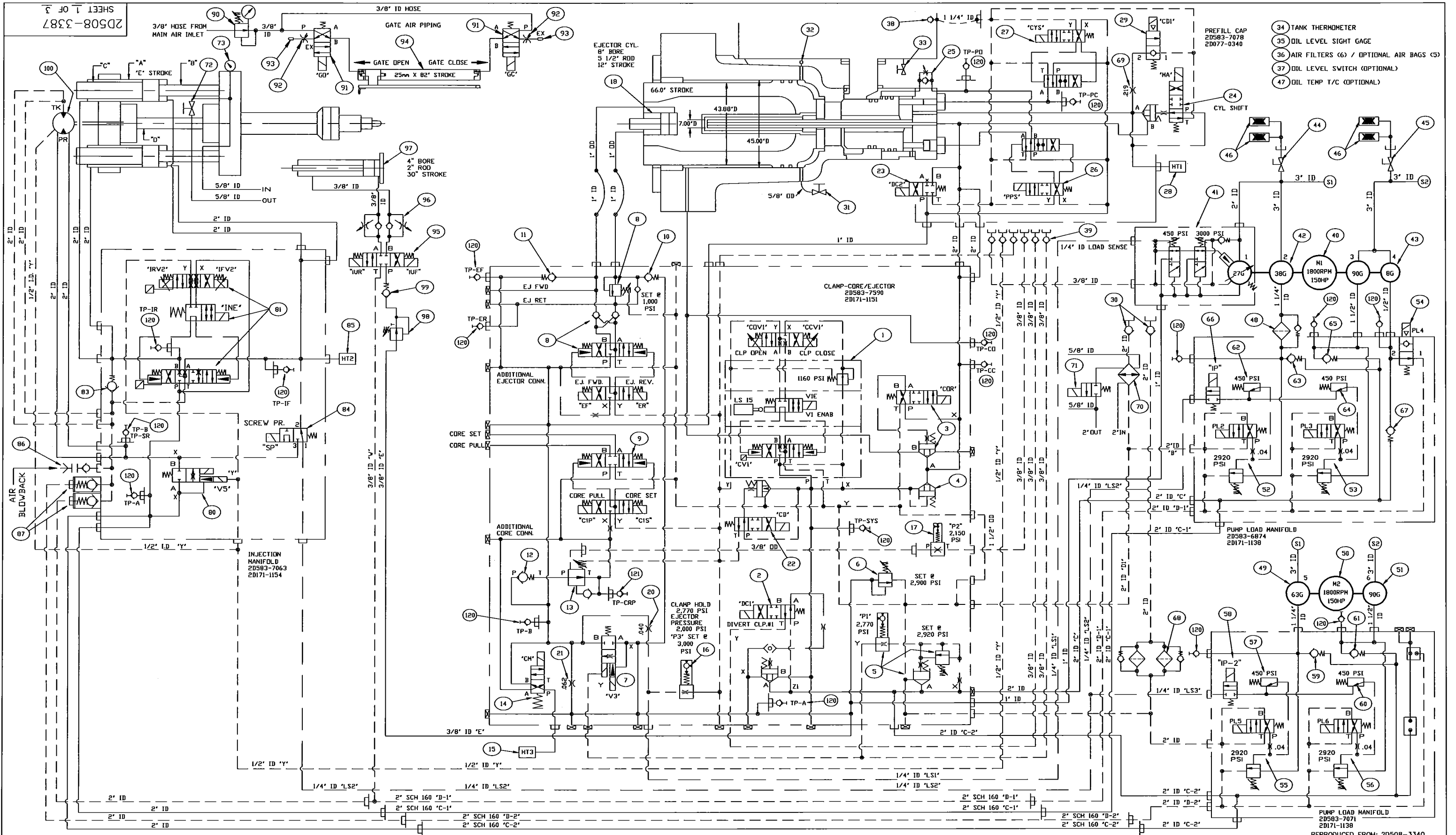
NOTE:
THE GATE CYLINDER IS PRESSURIZED EQUALLY ON BOTH ENDS. BY ENERGIZING THE APPROPRIATE SOLENOID THE CYLINDER WILL BE EXHAUST THE AIR MOVING THE GATE IN THE PROPER DIRECTION.

- 34 TANK THERMOMETER
- 35 OIL LEVEL SIGHT GAUGE
- 36 AIR FILTERS (6) / OPTIONAL AIR BAGS (5)
- 37 OIL LEVEL SWITCH (OPTIONAL)
- 47 OIL TEMP T/C (OPTIONAL)

TOLERANCE EXCEPT AS NOTED X.X.05 XXXX.005 X.XX.015 XXXX.0005				DRAWN: LVS DATE 2/14/01		NAME: HYDRAULIC DIAGRAM MLH2200-400	
SURFACE ROUGHNESS (PER MIL - STD. - 10) HPM ENG. STD. SEC. 2				CHECKED: LVS DATE 2/14/01		FILE NAME: 2508-3387_1	
WELDING SPECIFICATION HPM ENG. STD. SEC. 59				WT. SCALE = 1 FT.		NOTICE	
CHG. REVISIONS - WAS				E.C. NO. BY DATE FILMED		THIS DRAWING AND COPIES THEREOF, CONTAINS DESIGN AND MANUFACTURING INFORMATION WHICH IS CONFIDENTIAL AND PROPRIETARY TO HPM CORPORATION. USE AND REPRODUCTION OF THIS INFORMATION IS PROHIBITED EXCEPT AS AUTHORIZED BY HPM CORPORATION. HPM IS NOT RESPONSIBLE FOR ANY REPRODUCTION OR MODIFICATION OF THIS INFORMATION BY ANY OTHER PARTY. HPM, HPM CORPORATION, HPM LOGO, HPM SYMBOLS AND HPM TRADEMARKS ARE THE PROPERTY OF HPM CORPORATION.	
						HPM CORPORATION 520 MARION ROAD MOUNT CLEON, OHIO 43338	
						2508-3387 SHEET 1 OF 3	

22,000 Ton HPM PRESS
Press 3 and 4





NOTE:
THE GATE CYLINDER IS PRESSURIZED EQUALLY ON BOTH
ENDS, BY ENERGIZING THE APPROPRIATE SOLENOID THE
CYLINDER WILL BE EXHAUST THE AIR MOVING THE GATE
IN THE PROPER DIRECTION.

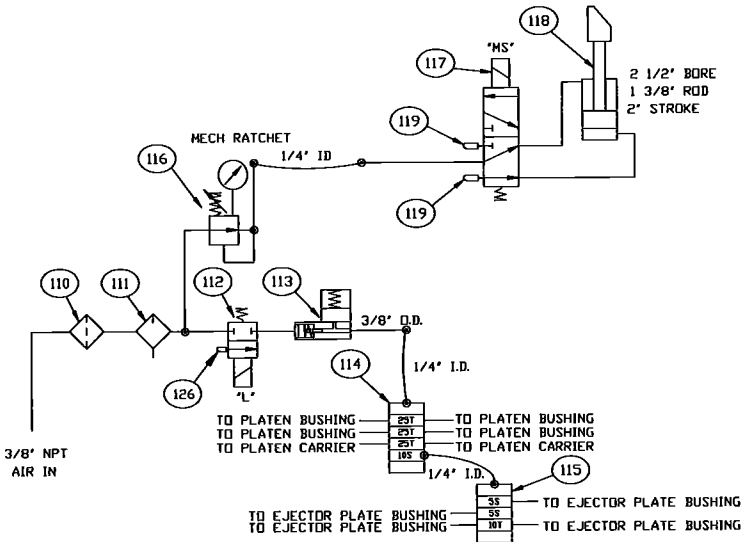
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REPRODUCED FROM: 2D508-3340

NO.	PART NUMBER	DESCRIPTION	
1		'CCV1'--'CCV1'	CLAMP SPEED CONTROL
	0C780-9993	1 1/4" PROPORTIONAL 4-WAY VALVE	REXROTH 4WRKE-35-W2-0000-2X/6A24E29/D3MR-609-5043A-1401
2		'DC1'	DIVERT TO CLAMP #1
	0C782-0008	CARTRIDGE VALVE INSERT 40MM	VICKERS CV1-40-D20-2-M-1M
	0C782-9023	CARTRIDGE VALVE COVER 40MM	VICKERS CVCS-40-W31-S2-10
	0C780-0035	MINI 4-WAY VALVE	VICKERS DG4V-3-2A-M-U-B-6-6M
3		'CDR'	CLAMP OPEN RUNAROUND
	0C782-0008	CARTRIDGE VALVE INSERT 40MM	VICKERS CV1-40-D20-2-M-1M
	0C782-0235	CARTRIDGE VALVE COVER 40MM	VICKERS CVCS-40-D1-S2-1M
	0C780-0036	MINI 4-WAY VALVE	VICKERS DG4V-3-2AL-M-U-B-6-6M
4		0C782-0008	CARTRIDGE VALVE INSERT 40MM
	0C782-0223	CARTRIDGE VALVE COVER 40MM	VICKERS CV1-40-D20-2-M-1M
			VICKERS CVCS-40-N-S2-1M
5		'PI'	CLAMP TRAVERSE, INJECTION, INJECTION REVERSE, & EXTRUDER PRESSURE
	0C782-0509	CARTRIDGE VALVE INSERT 40MM	VICKERS CV1-40-D10-2-H-30
	0C782-0323	CARTRIDGE VALVE COVER 40MM	VICKERS CVCS-40-C1-S2-W245-1M
	0C553-1200	EHST VALVE	VICKERS EHST-3-FVE-30
6		0C782-0717	RELIEF VALVE MODULAR INSERT
			VICKERS RV11-12-S-D-30
7		'V3'	CORE - EJECTOR SPEED CONTROL
	0C782-0916	PROPORTIONAL VALVE 16MM	VICKERS CVU-16-EFPI-B29-19-3M
8		'EF' - 'ER'	EJECTOR DIRECTIONAL VALVE
	0C782-9867	SEQUENCE MODULE VALVE	SUN HYD RSHC-LAN-BKG
	0C782-9854	PDC SANDWICH	REXROTH Z2S16-1-SX
	0C780-0439	1/2" 4-WAY VALVE	VICKERS DG5S4-046C-M-U-B-6-7M
9		'CIS' - 'CIP'	CORE DIRECTIONAL VALVE
	0C780-0436	1/2" 4-WAY VALVE	VICKERS DG5S4-042C-M-U-B-6-7M
10		0C782-0718	CHECK VALVE CARTRIDGE
			VICKERS CV11-12-P-D-5.0
11		0C782-0718	CHECK VALVE CARTRIDGE
			VICKERS CV11-12-P-D-5.0
12		0C583-0003	1 1/4" CHECK VALVE
			VICKERS C5G-825
13		0C579-0001	PRESSURE REDUCING VALVE
			VICKERS XG-06-3F-M
14		'CH'	CORE MONITOR
	0C780-0036	MINI 4-WAY VALVE	VICKERS DG4V-3-2AL-M-U-B-6-6M
15		0C273-XXXX	HYDRAULIC PRESSURE TRANSDUCER 'HT3'
			SEE ELECTRICAL DRAWINGS FOR PART NUMBER
16		'P3'	CLAMP HOLD & EJECTOR PRESSURE CONTROL
	0C553-1200	EHST VALVE	VICKERS EHST-3-FVE-30
17		'P2'	CORE PRESSURE & CORE HOLD PRESSURE
	0C553-1200	EHST VALVE	VICKERS EHST-3-FVE-30
18		2B506-5241	HYDRAULIC CYLINDER - EJECTOR
			PARKER 8JB-2H-TS23A X 12"
19			
20		1A036-0005	ORIFICE PLUG .040" DIA
			HPM - PROVIDES PILOT OIL FOR PISTON PUMP
21		2A036-0350	ORIFICE PLUG .062" DIA
			HPM
22		'CD'	CLAMP DECOMPRESSION
	0C782-0008	CARTRIDGE VALVE INSERT 40MM	VICKERS CV1-40-D20-2-M-1M
	0C782-0235	CARTRIDGE VALVE COVER 40MM	VICKERS CVCS-40-D1-S2-1M
	0C780-0035	MINI 4-WAY VALVE	VICKERS DG4V-3-2A-M-U-B-6-6M
23		'DC2'	DIVERT TO CLAMP #2 (HOLDING PUMP)
	0C780-0218	1/8" 4-WAY VALVE	VICKERS DG4S4-012B-UB-6M
24		'HA'	SHIFT TO MAIN AREA
	0C782-0009	CARTRIDGE VALVE INSERT 40MM	VICKERS CV1-40-D20-2-H-1M
	0C782-0235	CARTRIDGE VALVE COVER 40MM	VICKERS CVCS-40-D1-S2-1M
	0C780-0035	MINI 4-WAY VALVE	VICKERS DG4V-3-2A-M-U-B-6-6M
25		0C634-1200	3/4" FLOW CONTROL
			PARKER FSI200-S
26		'PPS'	PREFILL PRE-SHIFT
	0C780-0403	1/2" 4-WAY VALVE	VICKERS DG5S4-040AL-T-M-U-B-6-70
27		'CYS'	CYLINDER SHIFT TO MAIN AREA
	0C780-0403	1/2" 4-WAY VALVE	VICKERS DG5S4-040AL-T-M-U-B-6-70
28		0C273-XXXX	HYDRAULIC PRESSURE TRANSDUCER 'HT1'
			SEE ELECTRICAL DRAWINGS FOR PART NUMBER
29		'CD1'	CLAMP DECOMPRESSION
	0C782-0720	CARTRIDGE 2-WAY VALVE N.C.	VICKERS SV3-12-C-D-115AG
30		0C197-0160	2" CHECK VALVE
			UNITED BRASS 62S
31		0C307-1004	1/2" ANGLE NEEDLE VALVE
			DRAGON 10M-7-1
32		0C474-7930	3/8" AIR BLEED VALVE
			HPM
33		0C130-0016	2" GLOBE VALVE - TANK DRAIN
			CRANE #1
34		0C0405-0040	THERMOMETER 0 - 200 DEGREES
			AMERICAN BI-METALS
35		0C343-0100	3/4" ID PVC CLEAR TUBING
			NORTON NT-80 FLEXIBLE REINFORCED 08687AA
36		0C084-5501	AIR BREATHER STANDARD
	2C506-4738	AIR BAG OPTIONAL	SOLBERG MANUFACTURING CO F-35-400
37		0C287-3537	OIL LEVEL SWITCH OPTIONAL
			GEMS 153575
38		0C197-5006	1 1/4" CHECK VALVE
			UNITED BRASS 50T
39		0C197-0030	3/8" CHECK VALVE
			UNITED 62S
40		2A506-5860	150 HP ELECTRIC MOTOR
			RELANCE 444TSC, 1800 RPM, 230/460 VOLT 60 CYCLE
41		0C713-2019	PISTON PUMP 27 GPM PL1
			VICKERS PVH57QIC-LF-2S-10-C25V-31-D27
42		0C592-0306	VANE PUMP 38 GAL PL2
			VICKERS 35VQHTC25A-2203A-A-2M-L

43	0C592-4008	VANE PUMP 90 GAL PL3 & 8 GAL PL4	VICKERS 4520VQH60A5-86AB-2M
44	0C131-8003	4" 1/4-TURN VALVE	DEMCO 22131-1115311
45	0C131-8003	4" 1/4-TURN VALVE	DEMCO 22131-1115311
46	0C441-7001	3" SUCTION STRAINER	VICKERS DF3-24-3RV-10
47	0C273-3258	OIL TEMP T/C OPTIONAL	PYROMATION JP-33-06-15-72642U
48	0C441-8027	PRESSURE FILTER	SCHROEDER KF30-1KS7-050-D7
49	0C592-0406	VANE PUMP 63 GAL PL5	VICKERS 45VQH42A-86D-2M-L
50	2A506-5860	150 HP ELECTRIC MOTOR	RELANCE 444TSC, 1800 RPM, 230/460 VOLTS 60 CYCLE
51	0C592-0407	VANE PUMP 90 GAL PL6	VICKERS 45VQH60A-86B-1M
52		'PL2'	PUMP LOAD #2
	0C553-0321	3/4" SOLENOID CONTROLLED RELIEF VALVE	VICKERS CG5-060A-F-M-U-B-6-P10-110
	0C780-7040	ORIFICE PLUG .040" DIA	VICKERS DG4V-3, 60 SERIES, #694344
53		'PL3'	PUMP LOAD #3
	0C553-0320	1 1/4" SOLENOID CONTROLLED RELIEF VALVE	VICKERS CG5-100A-F-M-U-B-6-P10-110
	0C780-7040	ORIFICE PLUG .040" DIA	VICKERS DG4V-3, 60 SERIES, #694344
54		'PL4'	PUMP LOAD #4
	0C782-9843	CARTRIDGE VALVE - SOLENOID 2 POSITION	VICKERS SV3-10-0-0-115AG
55		'PL5'	PUMP LOAD #5
	0C553-0321	3/4" SOLENOID CONTROLLED RELIEF VALVE	VICKERS CG5-060A-F-M-U-B-6-P10-110
	0C780-7040	ORIFICE PLUG .040" DIA	VICKERS DG4V-3, 60 SERIES, #694344
56		'PL6'	PUMP LOAD #6
	0C553-0320	1 1/4" SOLENOID CONTROLLED RELIEF VALVE	VICKERS CG5-100A-F-M-U-B-6-P10-110
	0C780-7040	ORIFICE PLUG .040" DIA	VICKERS DG4V-3, 60 SERIES, #694344
57	0C782-9844	CARTRIDGE VALVE MODULAR RELIEF VALVE	VICKERS RV1-10-S-0-27
58	0C782-0709	CARTRIDGE VALVE MODULE N.C. SOL	VICKERS SV4-10-C-D-115AG
59	0C583-0006	1 1/4" CHECK VALVE 75 PSI C.P.	VICKERS C5G-825-S8
60	0C782-9844	CARTRIDGE VALVE MODULAR RELIEF VALVE	VICKERS RV1-10-S-0-27
61	0C583-0006	1 1/4" CHECK VALVE 75 PSI C.P.	VICKERS C5G-825-S8
62	0C782-9844	CARTRIDGE VALVE MODULAR RELIEF VALVE	VICKERS RV1-10-S-0-27
63	0C583-0006	1 1/4" CHECK VALVE 75 PSI C.P.	VICKERS C5G-825-S8
64	0C782-9844	CARTRIDGE VALVE MODULAR RELIEF VALVE	VICKERS RV1-10-S-0-27
65	0C583-0006	1 1/4" CHECK VALVE 75 PSI C.P.	VICKERS C5G-825-S8
66	0C782-0709	CARTRIDGE VALVE MODULE N.C. SOL	VICKERS SV4-10-C-D-115AG
67	0C583-0007	3/8" CHECK VALVE	VICKERS C5G-805
68	0C614-5008	FILTER MANIFOLD - 250 GPM 1 1/2" SAE	VICKERS DFRM-12-20-1M
	0C614-1005	FILTER UNIT - 120 GPM	VICKERS DFR-120-F-V03-E-3M
	0C614-5007	FILTER ELEMENT	VICKERS V405-1-B-6-V-03
69	2A036-0428	ORIFICE PLUG .219 DIA	HPM - PREFILL
70	0C116-6018	HEAT EXCHANGER	THERMAL TRANSFER SLE-1760-88984
71	0C130-0016	2" GLOBE VALVE STANDARD	CRANE #1
71	0C425-0014	1 1/4" MODULATING VALVE OPTIONAL	PENN CONTROLS V47AE-12
71	0C576-0079	2" SOLENOID WATER VALVE OPTIONAL	ASCO SC-8221G13
72	0C130-0004	1/2" GLOBE VALVE	CRANE #1
73	0C405-0040	THERMOMETER	AMERICAN BI-METAL
74			
75			
76			
77			
78			
79			
80		'V5'	EXTRUDER SPEED CONTROL
	0C782-0914	PROPORTIONAL CARTRIDGE VALVE 40MM	VICKERS CVU-40-EFPI-B29-90-3M
81		'IRV2' - 'JFV2'	INJECTION VELOCITY CONTROL VALVE
	0C780-9976	PROPORTIONAL VALVE	REXROTH 4WRTE-32-02-600P-3X/68G24Z31/WB173MR
82			
83	0C583-0006	1 1/4" CHECK VALVE 75 PSI C.P.	VICKERS CG5-825-S8
84		'SP'	SCREW ROTATE PRESSURE SELECTOR VALVE
	0C782-9828	CARTRIDGE VALVE MODULE #10	VICKERS SV1-10-3-0-115AG
85	0C273-XXXX	HYDRAULIC PRESSURE TRANSDUCER 'HT2'	SEE ELECTRICAL DRAWINGS FOR PART NUMBER
86		AIR BLOWBACK	
	0C024-1006	REDUCER BUSHING 1/4" X 9/16"-18	
	0C578-0004	COUPLING BODY 1/4" NPT	SNAP-TITE VHC4-4F
	0C577-0004	DUST BODY 1/4"	SNAP-TITE AMPH-4-V
	0C612-0004	NIPPLE BODY 1/4" NPT	SNAP-TITE VHN4-4F-V
87		INJECTION TANK CHECK	
	2B150-2334	CHECK VALVE FLANGE	HPM
	0C616-5013	CHECK VALVE INSERT TYPE 15 PSI	INSERTA PRODUCTS, INC ICT-B-32-N15
	2B150-2335	CHECK VALVE FLANGE COVER	HPM
88			
89			
90	0C533-8010	AIR REGULATOR 160 PSI	NORGREN REGULATOR P74G-6AK-RMG
91	0C625-0009	3/8" AIR VALVE 'GD' & 'GC'	HAC 811C-PH-111CA152
92	0C634-9007	AIR FLOW CONTROL	PARKER FC702-4

93	0C442-1002	AIR MUFFLER 1/4" NPT	
94	2A506-5467	RODLESS AIR CYLINDER	MILLER SRL 25mm 82" STROKE
95		'IUF' - 'IUR'	PULL-IN-CYLINDER CONTROL VALVE
	0C780-0034	MINI 4-WAY VALVE	VICKERS DG4V-3-2C-M-U-B-6-6M
96	2A506-3133	FLOW CONTROL VALVE	VICKERS DGMFN-3XA2VB2V-4M
97	2C506-4243	PULL-IN-CYLINDER	PARKER 4HB-2HKT33A X 30"
98	0C780-5651	PRESSURE REDUCING VALVE MODULE	VICKERS DGMX2-3-PP-CV-S-4M
99	0C780-5450	CHECK VALVE MODULE - 'P' PORT	VICKERS DGMX2-3-PYL-2M
100	0C599-4008	HYDRAULIC PISTON MOTOR	KAWASAKI HMB400/S3/30/PL597
101			
102			
103			
104			
105			
106			
107			
108			
109			
110	0C442-3010	AIR FILTER	NORGREN F74G-6AN-0D3
111	0C635-0105	AIR LUBRICATOR	NORGREN L74M-6AP-0DN
112	0C636-0028	AIR VALVE	NORGREN P74C-NAC-SJA
113	2D506-4548	LUBE PUMP PACKAGE	TRABON 'E' S21-300-690
114	0C671-0010	FEEDER BLOCK	TRABON MSP4-25T-25T-10S
115	0C671-0009	FEEDER BLOCK	TRABON MJ3-5S-5S-10T
116	0C533-8010	AIR REGULATOR 160 PSI	NORGREN P74G-6AK-RMG
117	0C625-0010	3/8" MAC AIR VALVE	HAC 811C-PH-111JA152
118	2B506-5242	AIR CYLINDER	PARKER 2.50-C-2A-U-V-4-3-2.75
119	0C442-2002	AIR MUFFLER 1/4" NPT	
120	0C426-1002	MINICHECK COUPLER #6 SAE	SCHROEDER 2101-01-53.00
121	0C426-1003	MINICHECK COUPLER 1/4" NPT	SCHROEDER 2101-01-44.00
122	0C426-1001	GAGE ADAPTOR 1/4" NPT	SCHROEDER 2101-07-23.62
123	0C308-4031	GAGE 2 1/2" 0-3000 PSI 1/4" NPT	NOSHOK 25.300-3000-GL
124			
125			
126	0C442-2021	AIR MUFFLER 1/2" NPT	
127			
128			



REPRODUCED FROM: 20508-3340

						TOLERANCE EXCEPT AS NOTED .XX±.05 .XX±.015	DRAWN: LVS CHECKED: LVS FILE NAME: 2508-3387_2	DATE: 2/14/01 SCALE: = 1 FT.	NAME: HYDRAULIC DIAGRAM MLH2200-400	HPM HPM CORPORATION 820 MARION ROAD MOUNT GLEAD, OHIO 43338 2D508-3387 SHEET 2 OF 3	REV.
						SURFACE ROUGHNESS (PER MIL - STD. - 10) HPM ENG. STD. SEC. 2	NOTICE THIS DRAWING, AND COPIES THEREOF, CONTAINS DESIGN AND MANUFACTURING INFORMATION WHICH IS CONFIDENTIAL AND PROPRIETARY TO HPM CORPORATION. USE AND DISCLOSURE OF THIS INFORMATION IS PROHIBITED EXCEPT AS EXPRESSLY AUTHORIZED BY HPM CORPORATION, AND IS RESTRICTED TO HPM CORPORATION EMPLOYEES, CUSTOMERS, LICENSEES AND SUPPLIERS IN TRANSACTIONS FOR THE BENEFIT OF HPM CORPORATION.				
						WELDING SPECIFICATION HPM ENG. STD. SEC. 59					
CHG.						REVISIONS - WAS	E.C. NO.	BY	DATE		

⊕ PUMP ON STROKE
V VARIABLE SETTING
+ ENERGIZED
FS FACTORY SET

1. CLAMP OPEN - GATE OPEN
2. CLAMP OPEN - GATE CLOSED
3. CLAMP FORWARD FAST SEL #1
CLAMP FORWARD FAST SEL #2
CLAMP FORWARD FAST SEL #3
CLAMP FORWARD FAST SEL #4
4. CLAMP SLOW CLOSE
5. MOLD TOUCH / CYLINDER SHIFT
6. PRESSURE BUILD TO - IPS
7. CLAMP FULL PRESSURE
8. INJECTION SEL #1
INJECTION SEL #2
INJECTION SEL #3
INJECTION SEL #4
9. PACK
10. HOLD
11. PRE-DECOMPRESSION
12. SCREW ROTATE SEL #1
SCREW ROTATE SEL #2
SCREW ROTATE SEL #3
SCREW ROTATE SEL #4
13. POST DECOMPRESSION
14. COOL/CURE TIME
15. CLAMP DECOMPRESSION
16. CLAMP BREAKAWAY (2PS RELEASED)
17. CLAMP FAST OPEN SEL #1
CLAMP FAST OPEN SEL #2
CLAMP FAST OPEN SEL #3
CLAMP FAST OPEN SEL #4
18. CLAMP SLOW OPEN TO ILS
19. CLAMP FULL OPEN AT ILS

MOLD SET CLAMP CLOSE
MOLD SET CLAMP OPEN
PRESSURE BUILD

[illegible]

MACHINE SPECIFICATIONS

CLAMP SPECIFICATIONS MLH2200

CLAMP FUNCTION	PUMP NO.	GPM	VELOCITY "/SEC./PRESSURE				
			CLOSE	%	OPEN	%	PSI
CLAMP FAST #1	4-5	71	6.4	24%	6.2	24%	2,770
CLAMP FAST #2	2-4-5	108	9.8	38%	9.5	38%	2,770
CLAMP FAST #3	2-3-4-5	198	17.5	69%	17.5	69%	2,770
CLAMP FAST #4	2-3-4-5-6	288	25.4	100%	25.4	100%	2,770
CLAMP SLOW	4-5	71	6.4	25%	--	--	1,000
TONNAGE BUILD	2-3-4-5-6	288	--	--	--	--	2,770
CLAMP BREAK	4-5	71	--	--	3.2	24%	2,770
MOLD SET	4-5	71	6.4	24%	3.2	24%	2,000
CALIBRATION	4-5	71	--	--	--	--	2,770
CLAMP HOLD	1	27	--	--	--	--	2,770

MACHINE PUMP DESIGNATIONS & VOLUMES

PUMP NUMBER	1	2	3	4	5	6
PUMP GPM	27V	38	90	8	63	90

HYDRAULIC EJECTOR SPECIFICATION (8' BORE - 5 1/2' ROD)

EJECTOR FUNCTION	GPM	"/SEC.	PSI
EJECTOR FORWARD EJECTING	27	1.9	2,000
EJECTOR TRAVERSING FWD.	27	3.9	1,000
EJECTOR RETRACT	27	3.5	1,000

HYDRAULIC CORES SPECIFICATION

CORE FUNCTION	GPM	'/SEC.	PSI
CORE SET	27	---	2000
CORE PULL	27	---	2000

INJECTION RATES

400 OUNCE - 2,570

INJECTION SELECTION	NOMINAL GPM	IN ³ /SEC.	IN/SEC.	%
1.) 4-5	71	32.8	1.16	24%
2.) 2-4-5	108	50.2	1.78	38%
3.) 2-3-4-5	198	92.1	3.26	69%
4.) 2-3-4-5-6	288	133.9	4.74	100%

EXTRUDER TORQUE AND RPM

400 DUNCE - 2,500

EXTRUDER SELECTION	NOMINAL GPM	RPM	%	TORQUE IN/LBS
1.) 4-5	71	33	24%	156,750
2.) 2-4-5	108	51	38%	156,750
3.) 2-3-4-5	198	94	69%	156,750
4.) 2-3-4-5-6	288	137	100%	156,750

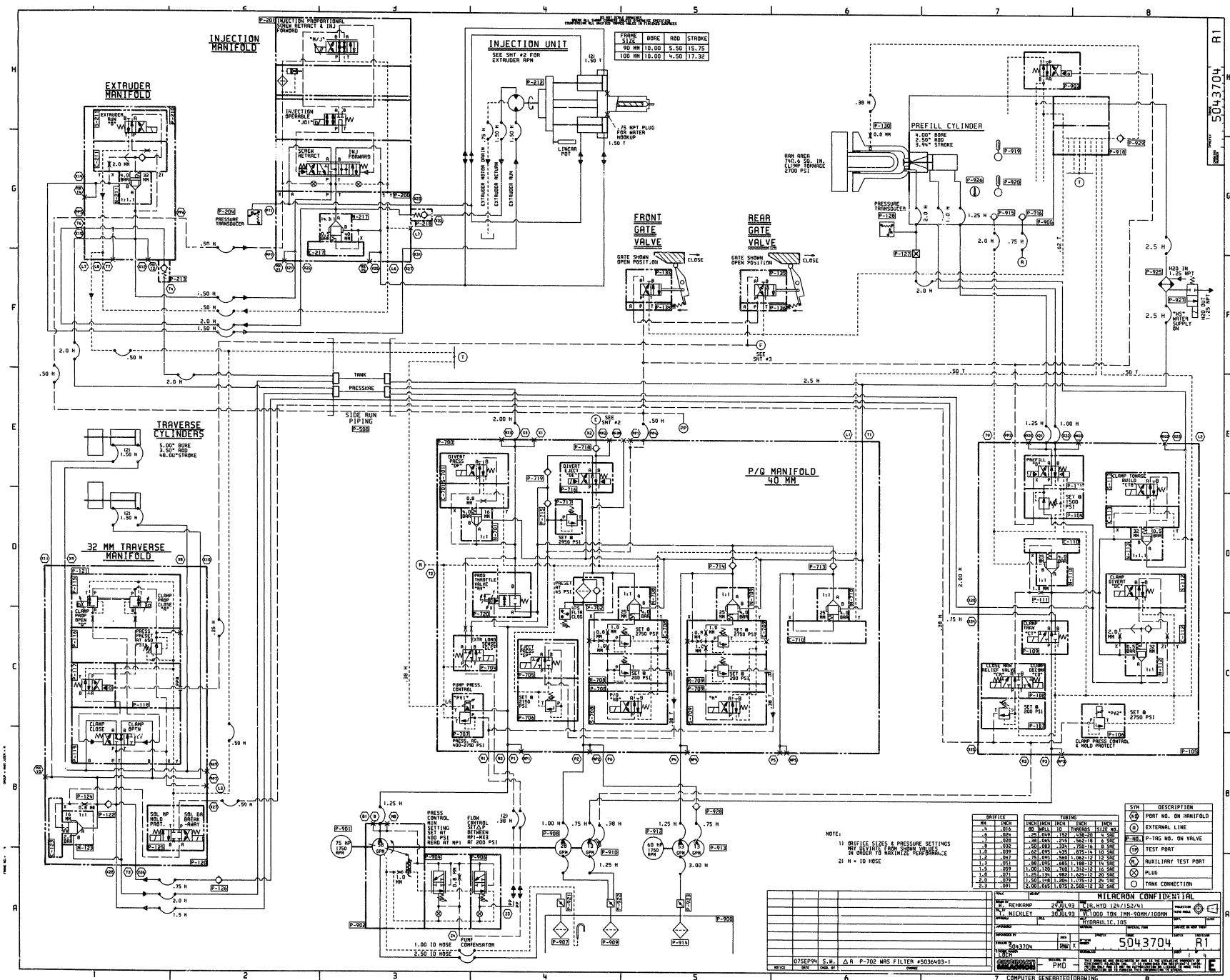
INJECTION UNIT SPECIFICATIONS

400 POUNCE UNIT

A	13.75	DIA
B	7.00	DIA
C	11.00	DIA
D	6.00	DIA
E	26.12	STROKE
MOTOR	HMB-400 0C599-4008	

REPRODUCED FROM: 2D508-3340

							TOLERANCE EXCEPT AS NOTED	DRAWN: LVS	DATE 2/14/01	NAME: HYDRAULIC DIAGRAM	 HPM CORPORATION 820 MARION ROAD MOUNT GILEAD, OHIO 43338
							.X&.05 .XXX&.005	CHECKED: LVS	2/14/01	MLH2200-400	
							.XX&.015 .XXXX&.0005	FILE NAME: 2508-3387_3			
							SURFACE ROUGHNESS (PER MIL - STD. - 10)	WT.	SCALE = 1 FT.	NOTICE	
							HPM ENG. STD. SEC. 2	MAT'L.		THIS DRAWING, AND COPIES THEREOF, CONTAINS DESIGN AND MANUFACTURING INFORMATION WHICH IS CONFIDENTIAL AND PROPRIETARY TO HPM CORPORATION. USE AND DISCLOSURE OF THIS INFORMATION IS PROHIBITED EXCEPT AS EXPRESSLY AUTHORIZED BY HPM CORPORATION. IT IS RESTRICTED TO HPM CORPORATION EMPLOYEES, CUSTOMERS, LICENSEES AND SUPPLIERS IN TRANSACTIONS FOR THE BENEFIT OF HPM CORPORATION.	
							WELDING SPECIFICATION HPM ENG. STD. SEC. 59				
CHG.	REVISIONS - WAS	E.C. NO.	BY	DATE	FILMED						REV.
										2D508--3387	SHEET 3 OF 3



5043704	R1
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1

COMPUTER GENERATED DRAWING

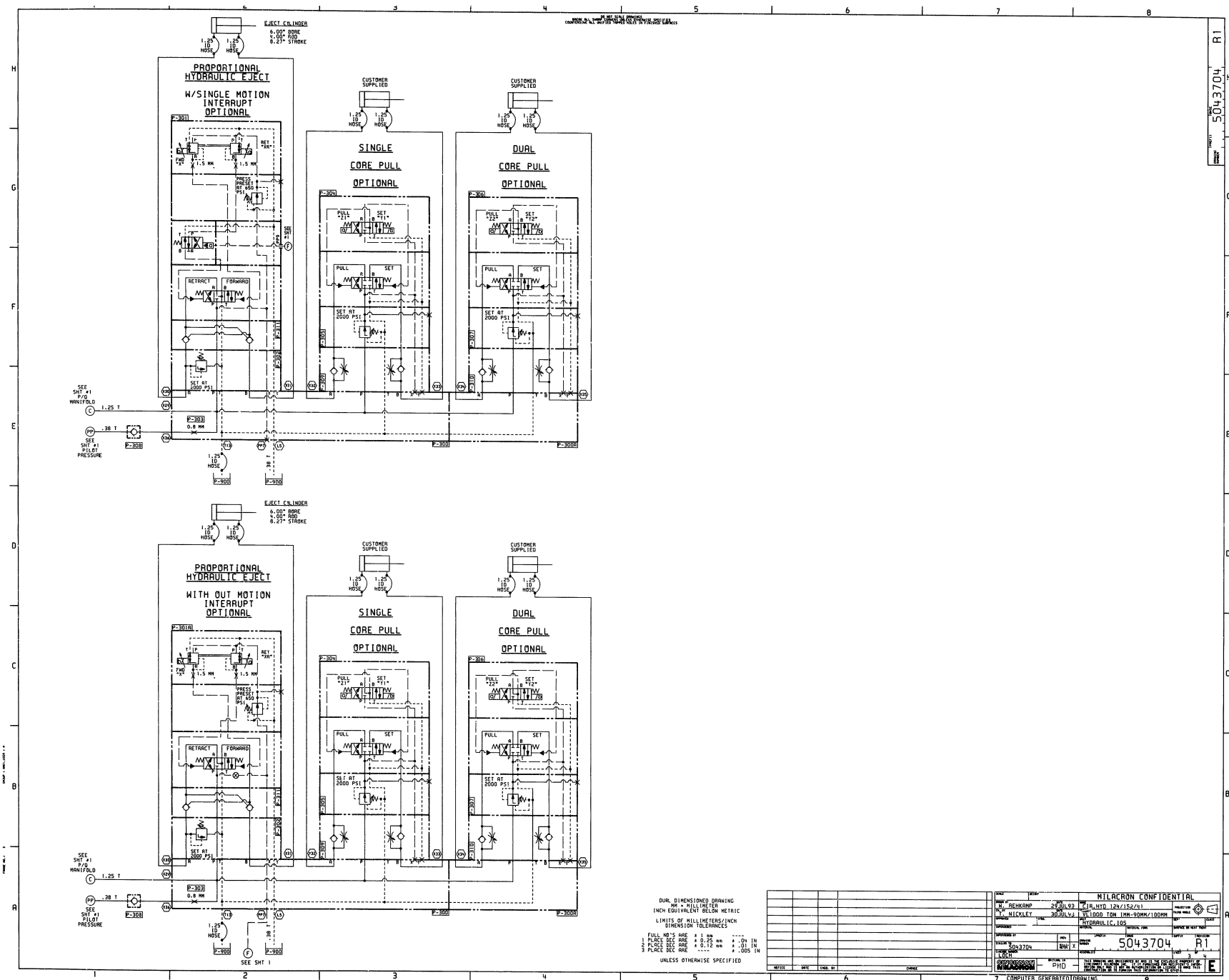
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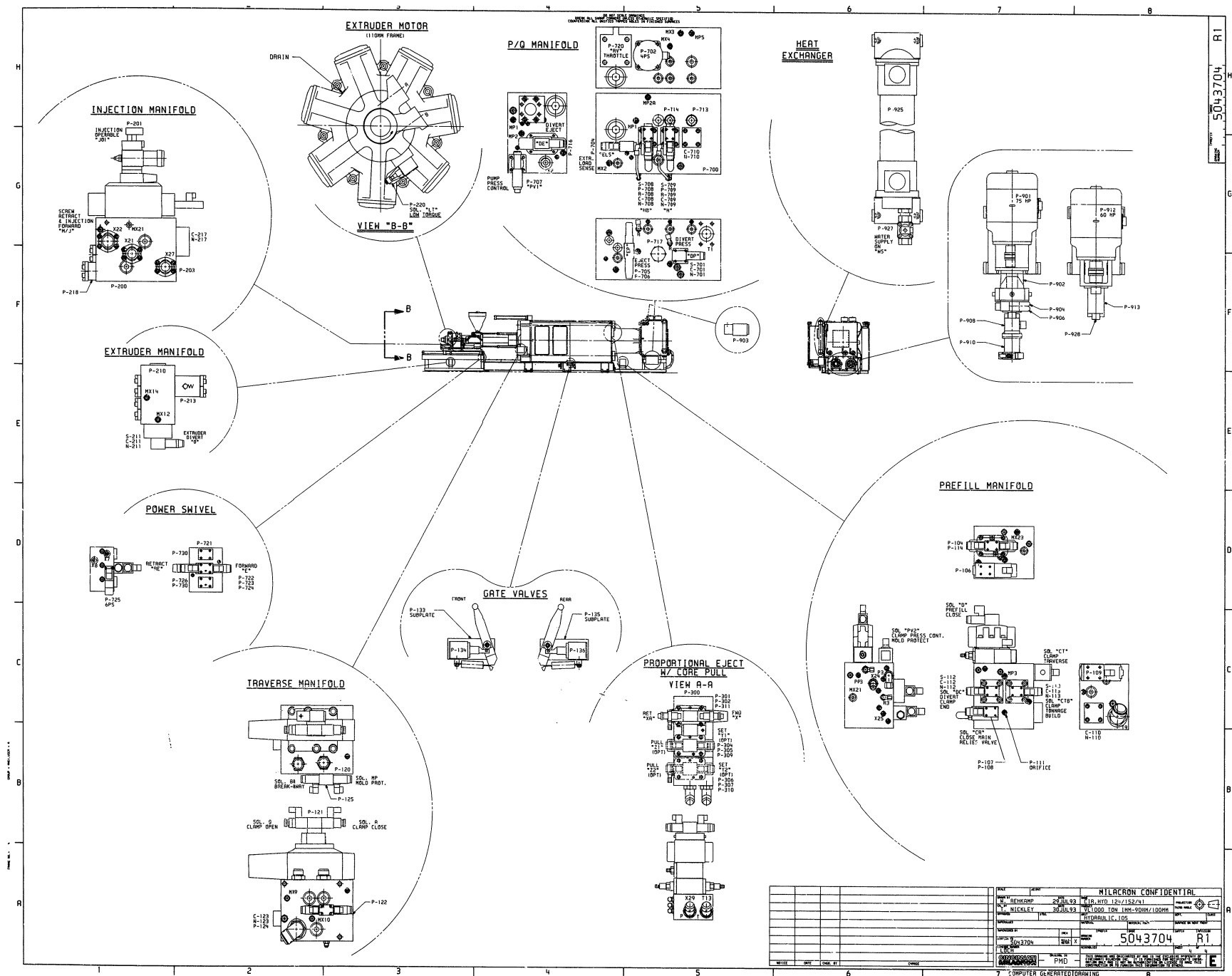
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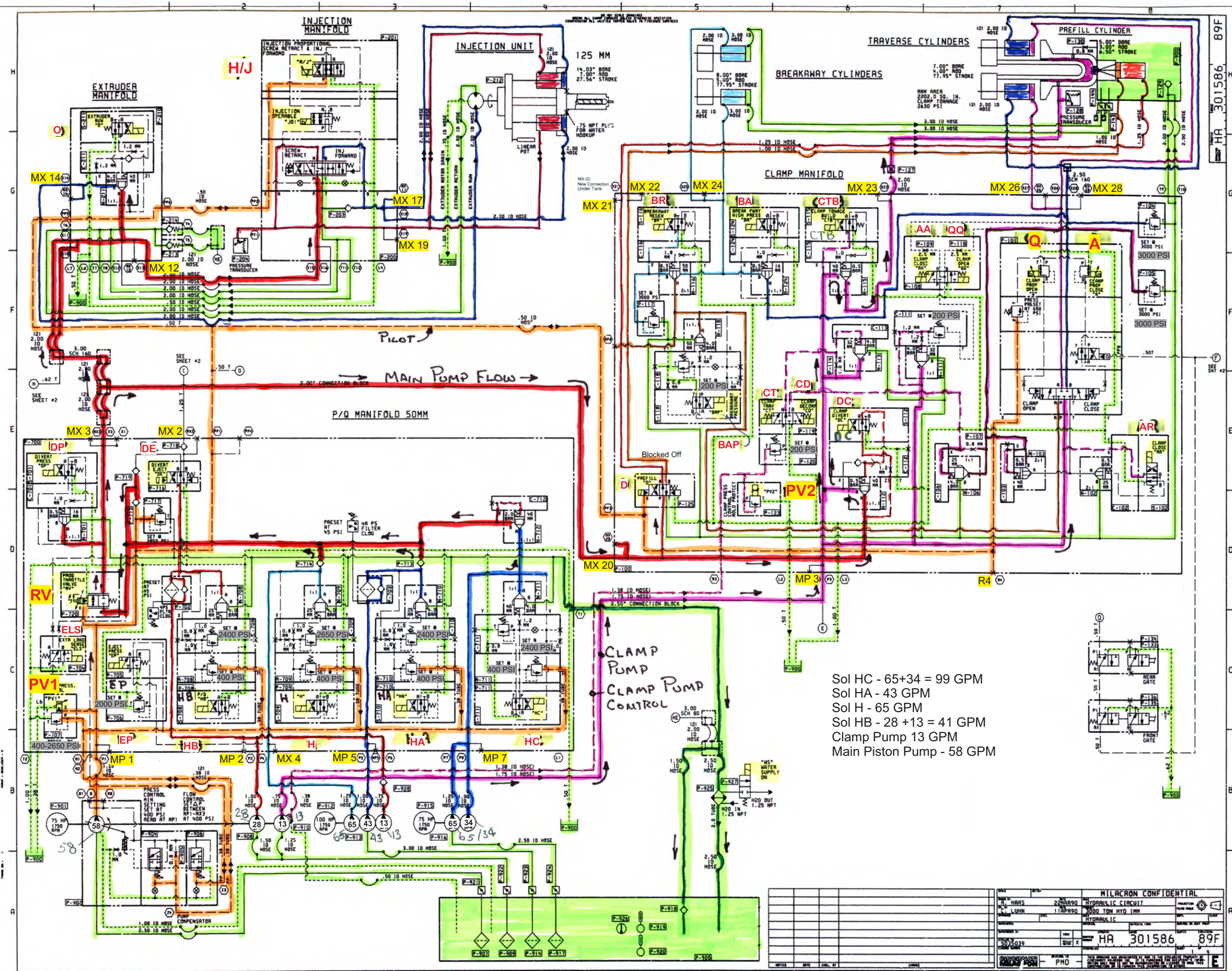
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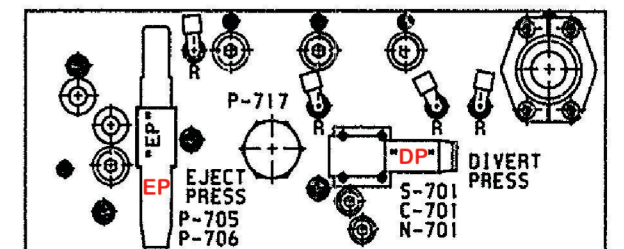
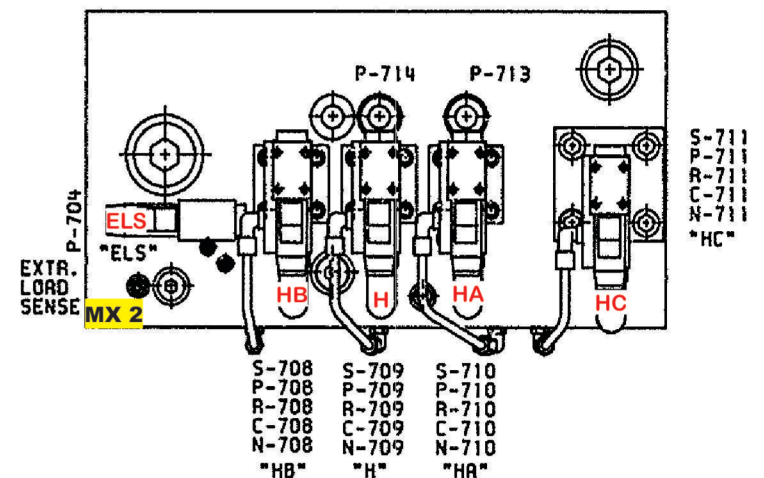
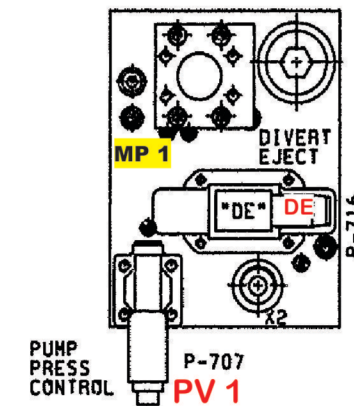
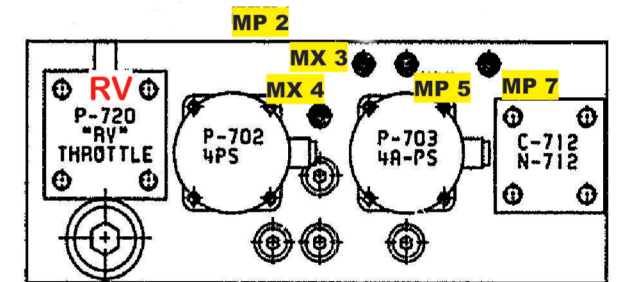
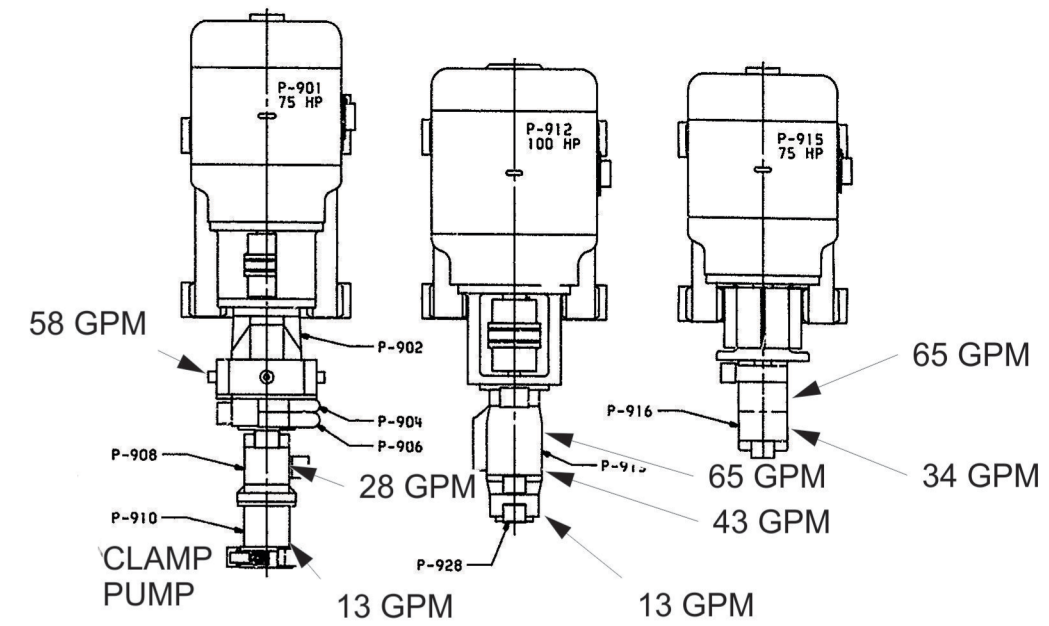
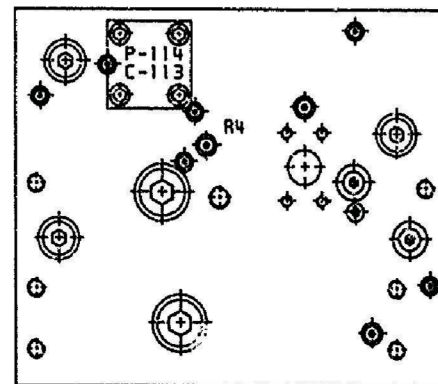
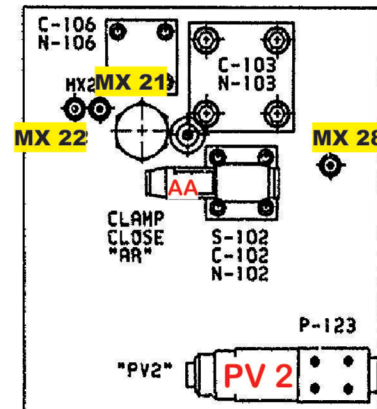
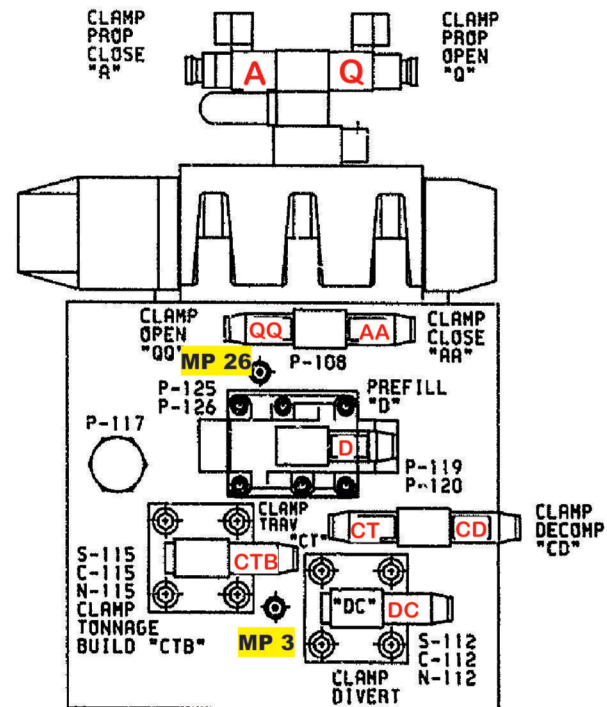
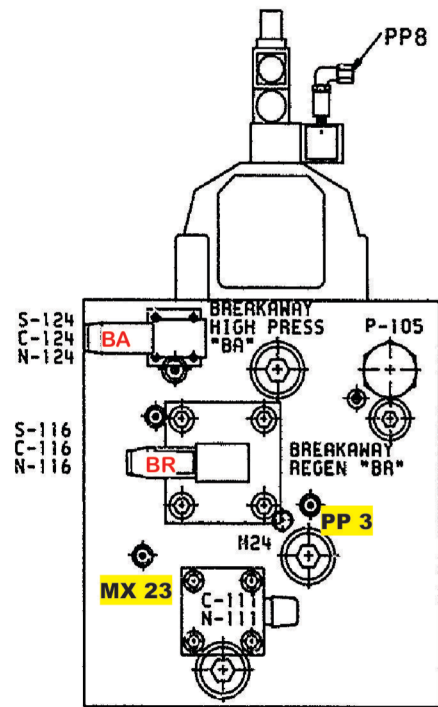
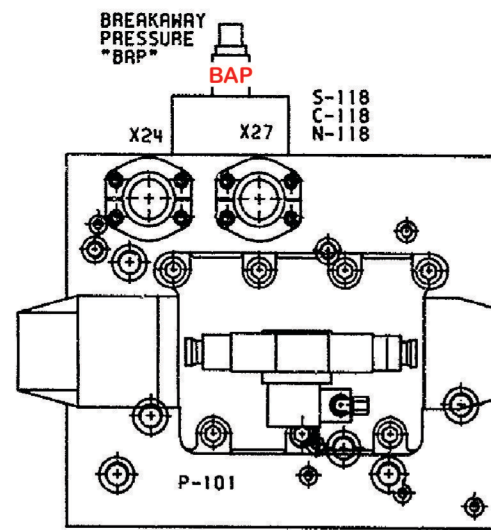
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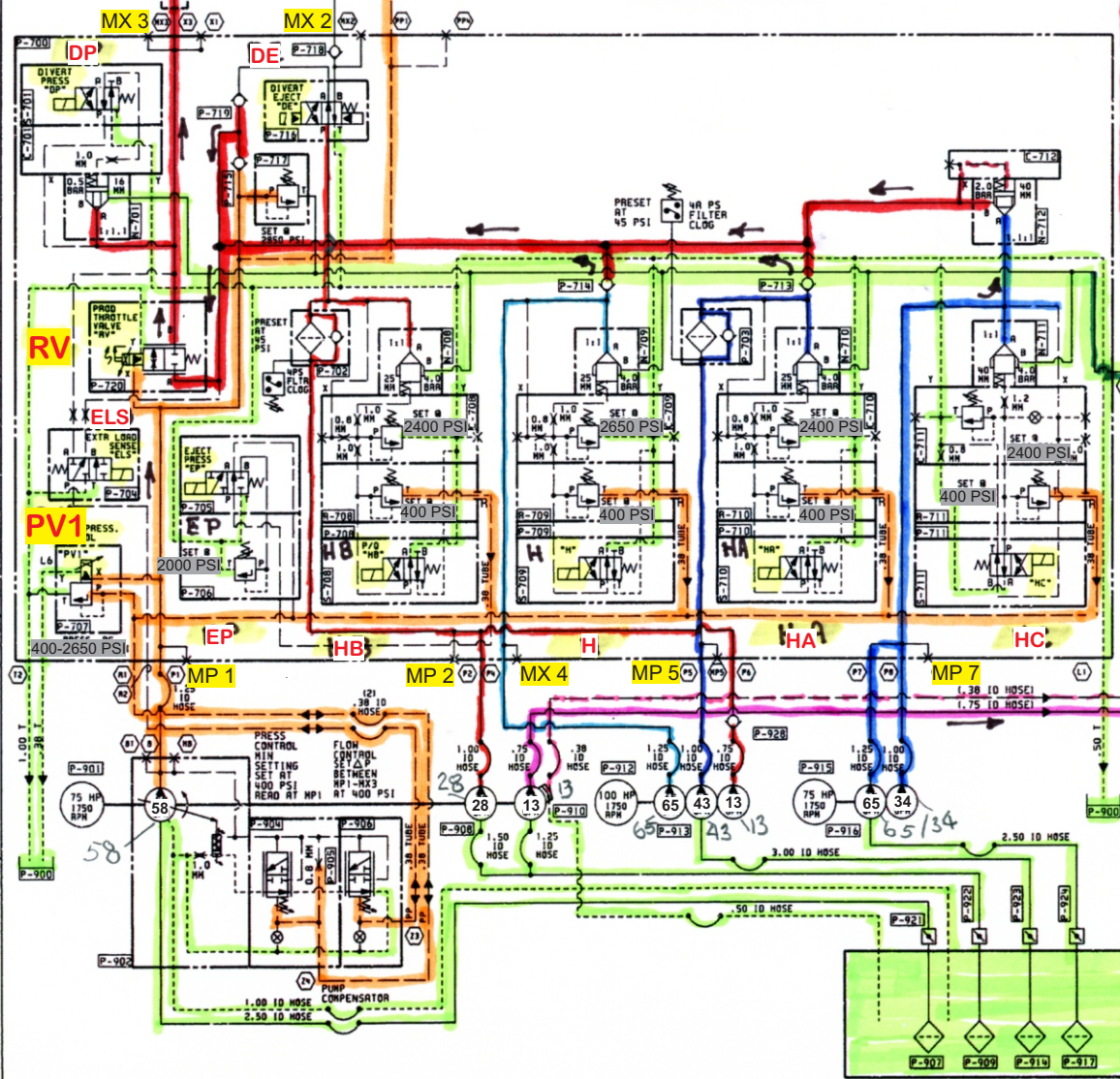
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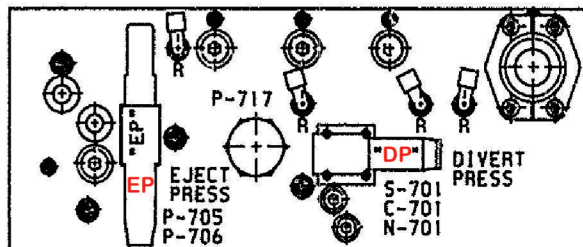
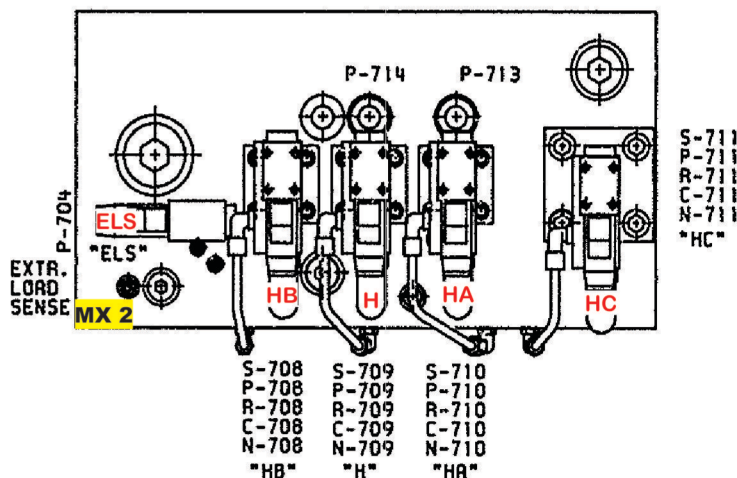
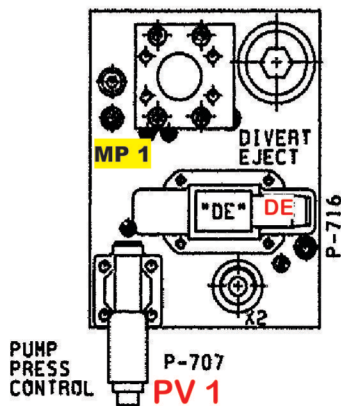


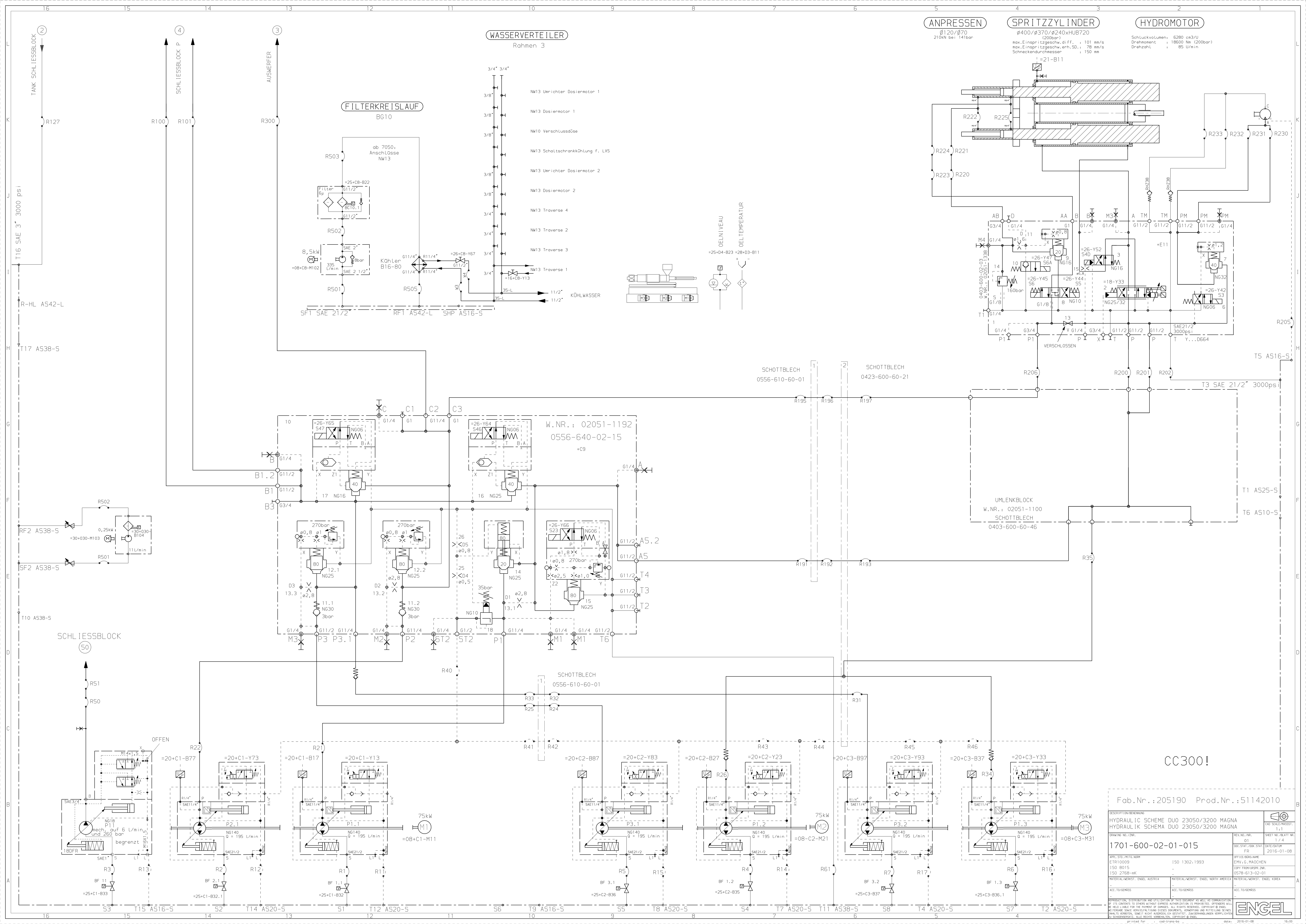


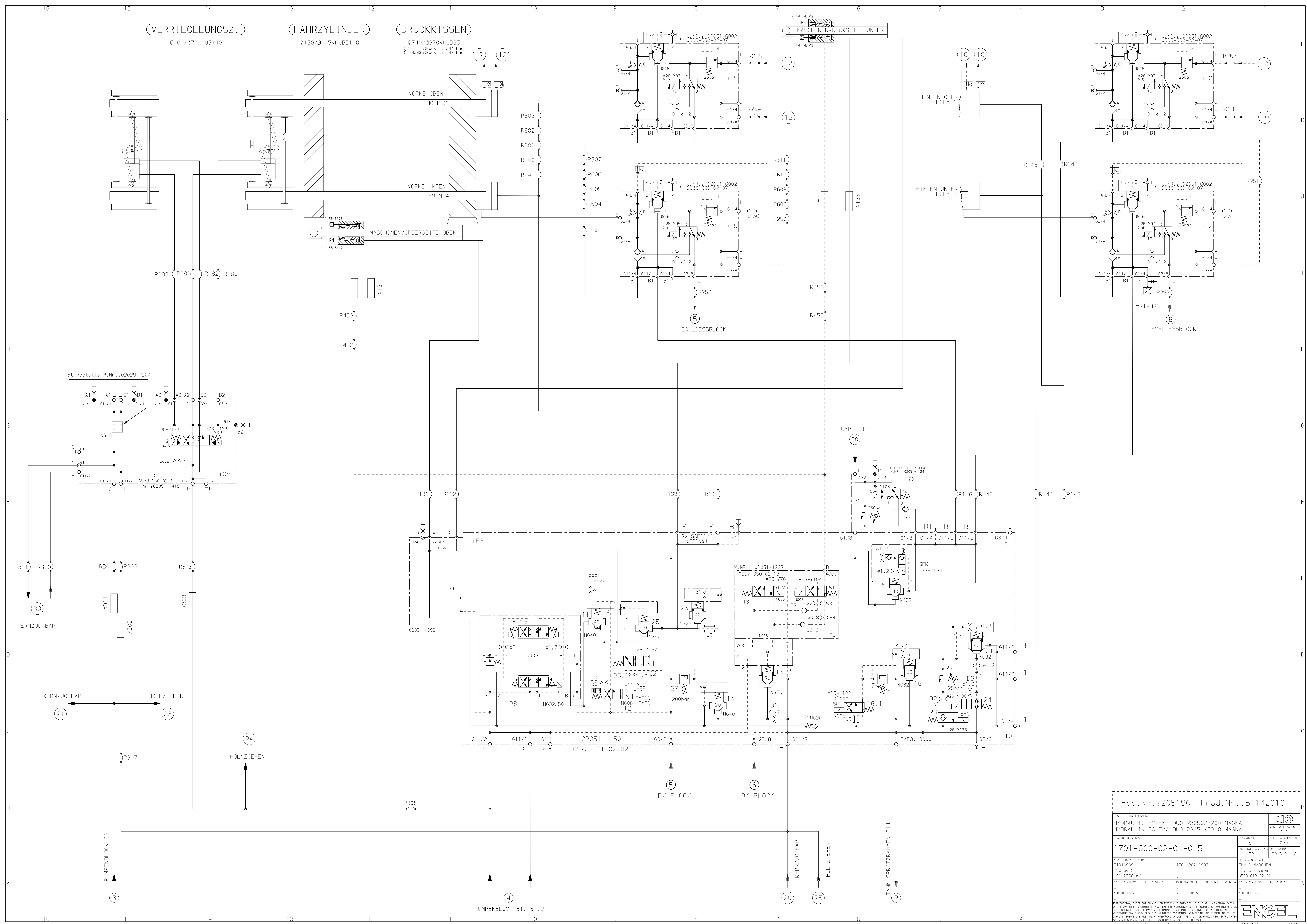


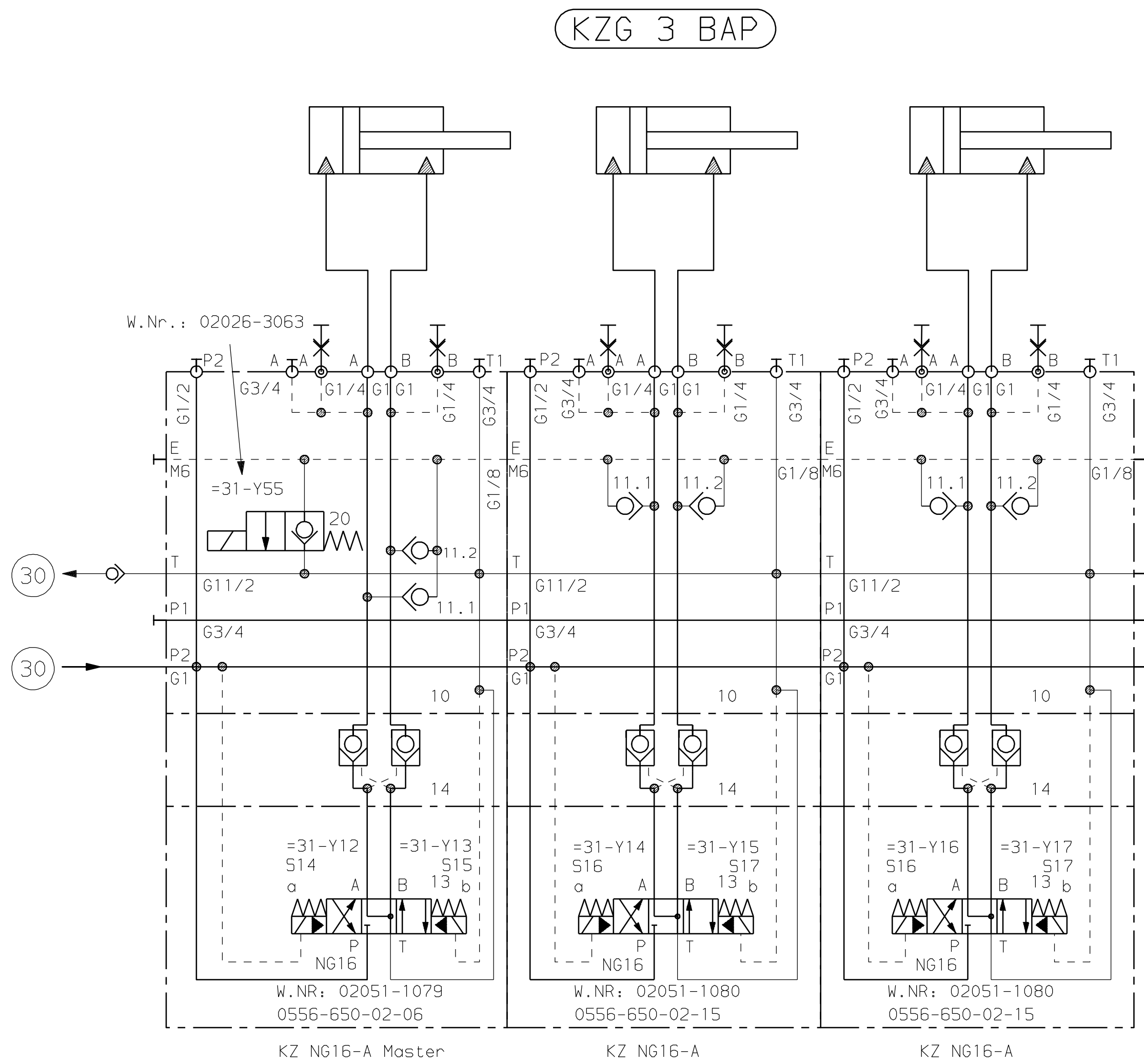






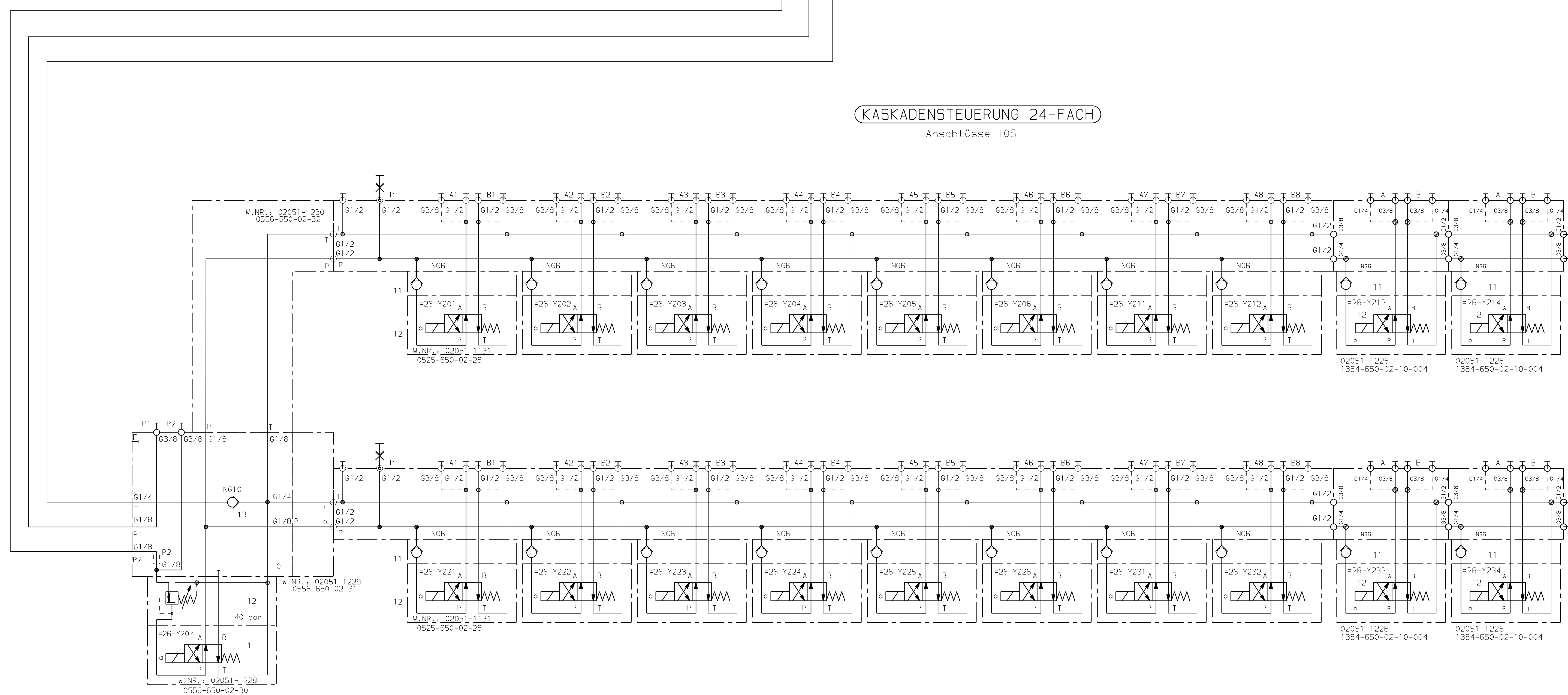
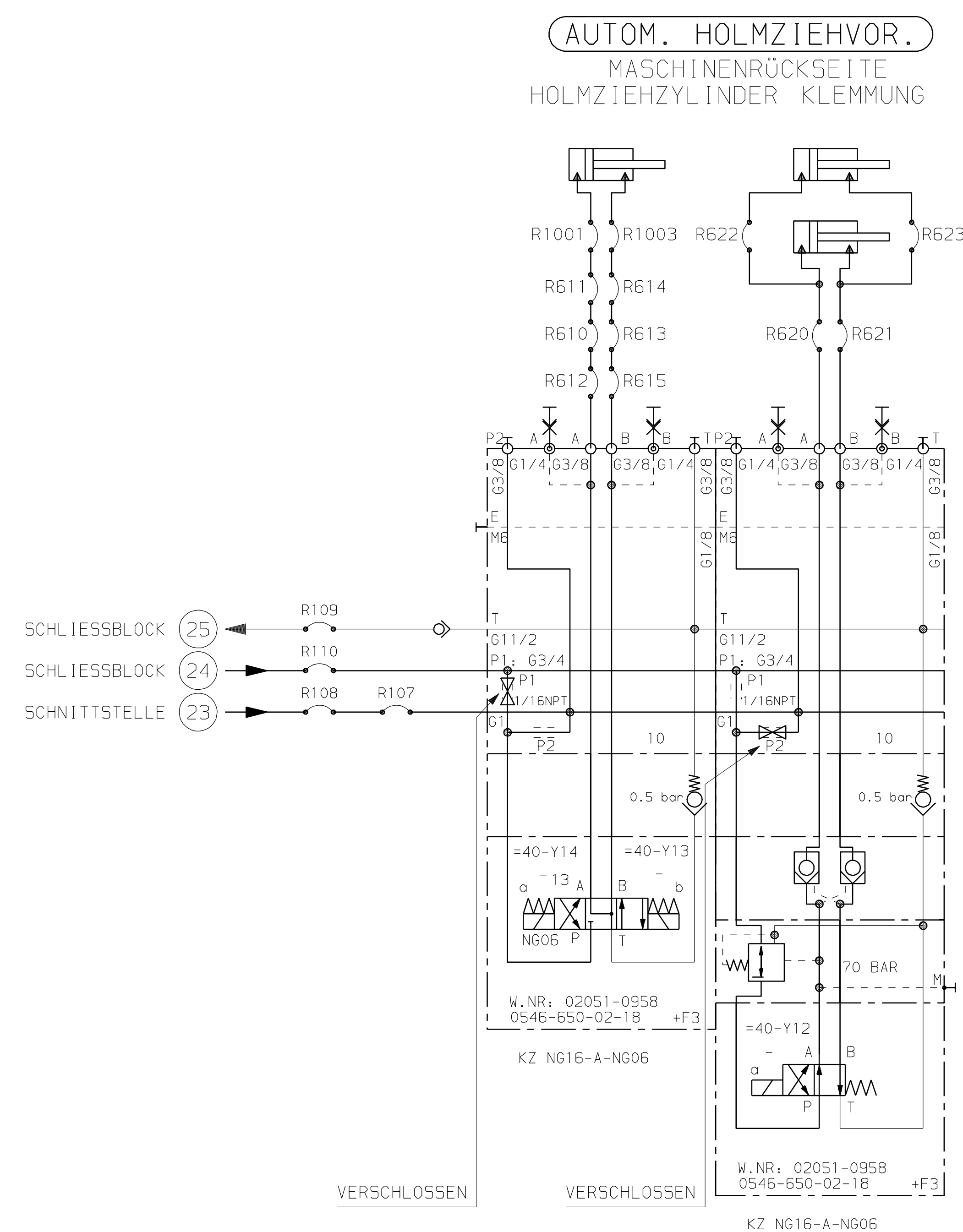
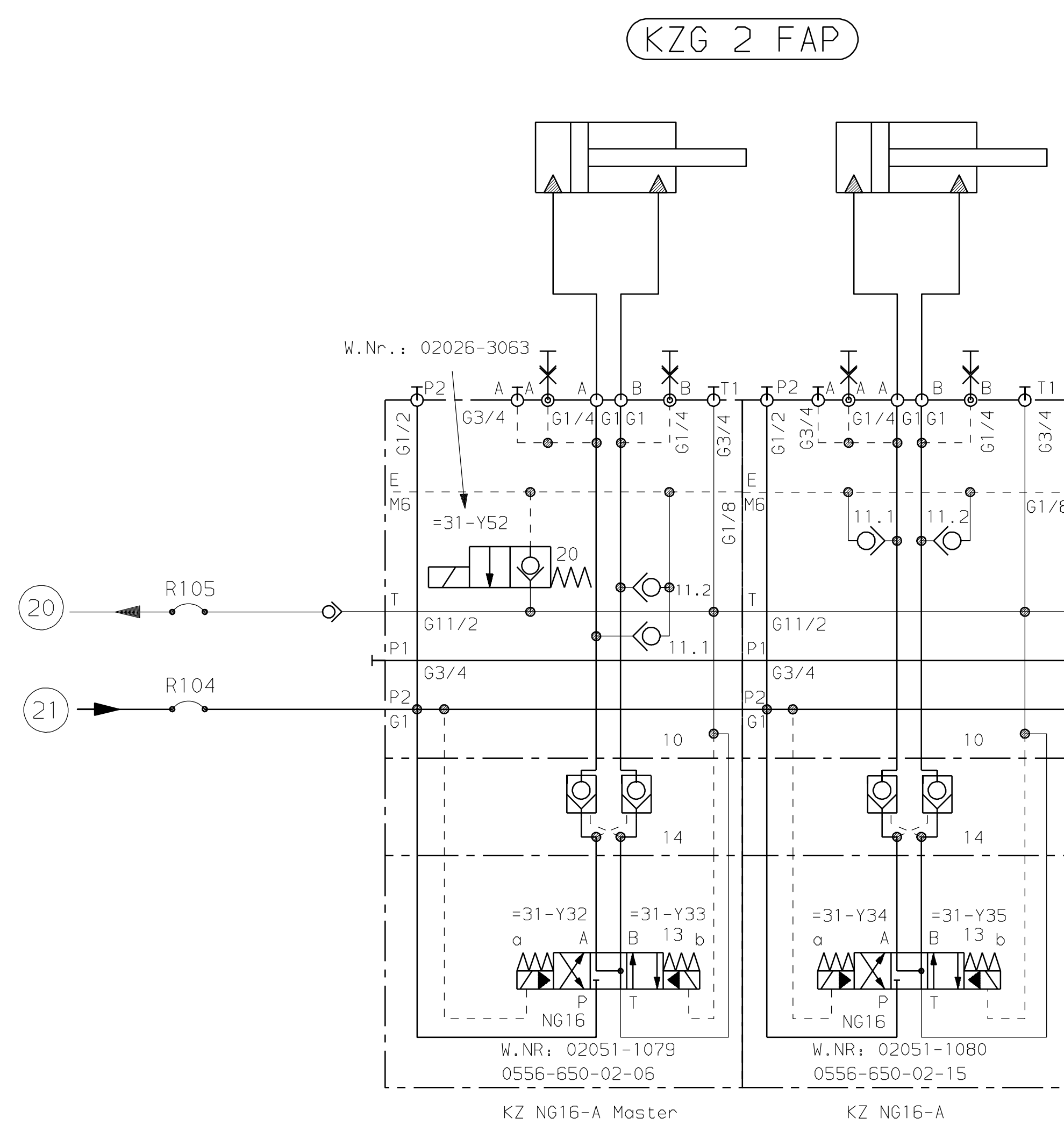




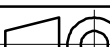


Fab.Nr.:205190 Prod.Nr.:51142010

DESCRIPTION/BEZEICHNUNG HYDRAULIC SCHEME DUO 23050/3200 MAGNA HYDRAULIK SCHEMA DUO 23050/3200 MAGNA		 CAD SCALE/MASSST. 1:1
DRAWING NO./ZNR. 1701-600-02-01-015	REV. NO./NR. 01 3/4	SHEET NO./BLATT NR. 3/4
APPL. STD./NHTO. NORM ETR 10003 ISO 8015 ISO 2768-mK	DOC. STAT./DOK. STAT. FR	DATE/DATUM 2016-01-08
MATERIAL/WERKST. ENGL. AUSTRIA -	MATERIAL/WERKST. ENGL. NORTH AMERICA -	OFFICE/ABT.NAMEN EMV/G. MÄDCHEN COPY FROM/ABT.NAMEN 0578-613-02-01
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Fab.Nr.:205190 Prod.Nr.:51142010

DESCRIPTION/REVENING		 ISO 9001:2015	
HYDRAULIC SCHEME DUO 23050/3200 MAGNA		CAD SCHEME 1	
HYDRAULIC SCHEME DUO 23050/3200 MAGNA		DATE OF FIRST ISSUE	
DRAWING NO./ZNR.		REV. NO./ZNR.	
1701-602-001-015		01	
APR. 520-PM10, N30R		DOW. STAT./ZOK. STAT.	
ETR10009		SPEC./REVISIONE	
150 8015		E.M.G., MADCHEN	
150 278B-mk		COPY FROM/ISSUE, ZNR.	
		1505-613-02-001	
MATERIAL/NERSTI, ENGEL AUSTRIA		MATERIAL/NERSTI, ENGEL NORTH AMERICA	
ACC. TO/GERMANS		ACC. TO/GERMANS	
		MATERIAL/NERSTI, ENGEL, KOREA	
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