



PRESS 12 INFORMATION

4500 SUTTON

TOOLING STACK Ø24x26.378" THICK (WEIGHS 3300 LBS)

STANDARD DIE THICKNESSES 10 & 12"

STANDARD BOLSTER SIZE - 24x10

RUN-OUT TABLE LENGTH - 150 FEET

MINIMUM WT/FT = 2.250 LBS/FT.

STRETCHER PULLS 15-18 LBS. MAX

(4" ROD = 15 LBS/FT)

POSSIBLE 2 HOLE DIE

MINIMUM 0.125 WALL THICKNESS

CAN NOT RUN "F" TEMPER

MAXIMUM MATERIAL CUT LENGTH = 750"

MINIMUM CUT LENGTH = 87"

MINIMUM CUT TOLERANCE = +1/4"/-0

(OR +1/16"/-3/16)

BILLET DIAMETER - 12"

BILLET AREA - 113.00

SHORTEST BILLET LENGTH 29.527",

LONGEST BILLET LENGTH 59"

12" BILLET X 1" WEIGHS 11.059 LBS.

EXAMPLES:

12 X 5 I-BEAM

12.75 X 4.75 RECT. TUBE

0.500 X 17.000 FLAT STOCK

EXTRUSION RATIO

HOLLOWS

NO LESS THAN 12:1

(MAX AREA 9.4167)

EXTRUSION RATIO =

AREA OF BILLET / AREA OF PROFILE

SOLIDS

NO LESS THAN 10:1

(MAX AREA 11.3000)



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