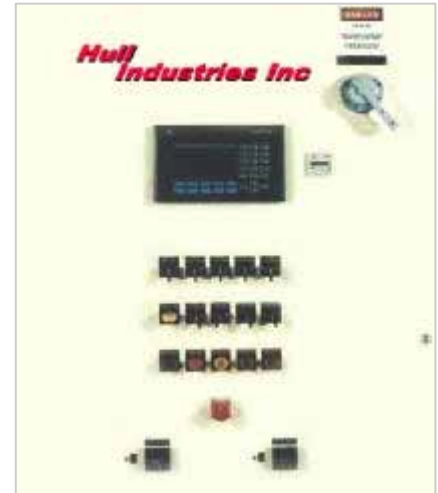


AUTOMATIC COMPRESSION PRESS



A PLC-based control system provides easy setup of breathe cycles and cure times. Up to five breathe cycles can be selected. To protect molds, clamp switches to low speed closing near end of stroke.

FULLY-AUTOMATIC PRESSES FOR MAXIMUM PRODUCTIVITY

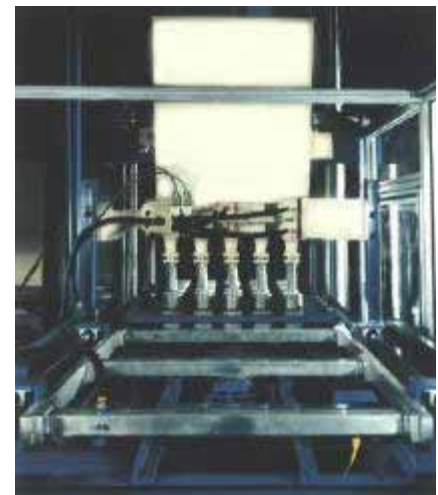
Fully automatic compression presses are available in models from 75 to 300 tons clamp force. Adjustable metering tubes deliver the precise amount of shot required for each mold cavity. Under the metering tubes, rows of cups on a moving platform index into position to re-

ceive the appropriate charge. When all cups are charged, the loading board moves in over the mold, a bottom plate retracts, and charges drop into the mold cavities. A new load of cups is charged while the previous load cures.

PRECISE CYCLE CONTROL ASSURES HIGH YIELD, CONSISTENT QUALITY

A PLC-based control system allows easy setup of breathe cycles and cure times. Up to five breathe cycles can be selected, from partially close, pause, fully close to close, pause, open and close with no pause.

To protect expensive molds, high speed closing cuts off near the end of the stroke, and the clamp switches to low speed closing. There is also an adjustable slow breakaway speed before high speed opening.



Cups on moving platform move into position to receive charge from adjustable metering tubes. A new load of cups charges while previous load cures.

**Hull
Industries Inc**

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SPECIFICATIONS	75 TON	150 TON	200 TON	250 TON	300 TON
Clamp Tonnage (Tons)	75	150	200	250	300
Clamp System Pressure (PSI)	2700	3000	2800	2850	2600
Pullback Capacity (Tons)	20	31	41	60	70
Clamp Ram Stroke (In.)	13	15	15	18	18
Space Between Tie Rods L-R, F-B (In.)	20 x 16	24 x 20	24 x 20	28 x 24	30 x 26
Daylight, Press Open Max. (In.)	29	33	33	36	36
Ejector Stroke, Top and Bottom (In.)	3.5	3.5	3.5	4	4
Height to Platen Surface (In.)	38	38	38	40	40
Mold Height, Min. (In.)	16	18	18	18	18
Loading Board Cap; Standard (Extra Rows & Cups Available)	12 Cups @ 96cc ea.	12 Cups @ 175cc ea.	12 Cups @ 175cc ea.	20 Cups @ 175cc ea.	24 Cups @ 175cc ea.
Pump Motor (HP)	7.5	15	20	20	25
Oil Capacity (Gal.) (Oil Not Supplied)	75	105	105	150	150
Shipping Weight (Approx; Lbs.)	8500	13,500	16,000	18,000	20,000
Platen Speeds (In./Min.) Fast Approach	406	373	360	360	360
Pressing	5-20	5-20	5-18	5-15	5-12
Opening	232	200	220	260	260
Mold Heat KW/Mold Half	5	7.5	7.5	7.5	10

ELECTRICAL & MECHANICAL REQUIREMENTS

Pump Motor: 230/460V, 3PH, 60Hz
 Platen Heaters: 230V, 3PH, 60Hz
 Controls: 115V, 1PH, 60Hz

Water Vol. Max @ 85F 10 GPM
 Water Connections ¾ In. NPT (Min.)
 Air Connections ½ In. NPT (Min.)

Specifications subject to change. Specifications can be modified for specific application requirements.

Settings at the control panel determine acceleration, deceleration, breathe, upper and lower ejection. Standard controls include indicat-

ing, proportional temperature controllers for accurate mold temperature control. A cycle counter is included as standard equipment.

Proportional pressure and speed control are available.

SHORTEN CYCLE TIME WITH PARTING LINE MODULE

Cycle time can be reduced by adding Hull Industries Parting Line Screw Injection Module. This unit, coupled to the automatic compression

press, pre-plasticizes material for faster curing. Material is injected through a sprue bushing at the mold parting line. The process

is particularly suitable for epoxies, silicones, melamines, ureas, phenolics and alkyds.

INDEPENDENT EJECTION MECHANISMS FOR VIRTUALLY ANY APPLICATION

Independent upper and lower hydraulic ejection mechanisms are a standard feature on all Hull Industries automatic compression presses.

This feature allows top or bottom ejection; top ejection with bottom hold-up or bottom ejection with top hold-down. This range of ejection

options provides positive, efficient ejection regardless of type of part molded.

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