

UPRIGHT AUTOMATIC SIZING PRESS

This press is designed for complex part applications where precise radial orientation is needed. The rigid upright design makes this machine readily adaptable to custom automation. Some features included with this design are:

Pneumatic Stripper Head permits pin-in-head capability for sizing with the core pins in the upper punch.

Dial Wheel Rotary Index Feed System for automatic loading of complex parts. Cavities in the wheel can be changed to accommodate a wide range of parts.

Ejection is a lower punch push-up design utilizing a cam and lift arm system to push the part out of the die.



Upright Automatic Sizing Press Index System

INCLINED AUTOMATIC SIZING PRESS

This press provides for very high speed sizing, coining, and restriking. It is suitable for parts requiring little radial orientation. The inclined design is ideal for use with automatic part feeding systems. Main features of this design are:

Inverted "Die in Head" configuration provides very high cycle times. This is accomplished by loading and ejecting parts simultaneously.

Swing-Type Automatic Part Feeder Arm is fully adjustable for a wide variety of parts. The arm is cam actuated for complete synchronization with the press at all speeds.

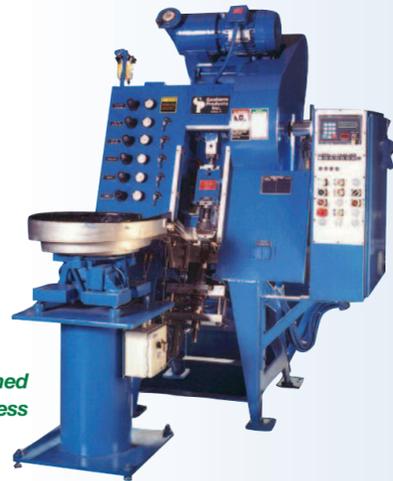
Lower Snag Pin System is also cam driven and precisely positions each part for entering the die.

Ejection is accomplished by means of an adjustable knockout bar system located in the upper ram of the press.

Upright Sizing Presses

Tonnage (U.S. Tons)	Stroke		Max. Part Length		Strokes Per Minute
	inches	mm	inches	mm	
15	4.50	114	1.50	38	10-50
30	5.00	127	1.50	38	8-40
45	7.00	178	2.25	57	8-35
60	7.00	178	3.00	76	10-40
100	7.00	178	3.00	76	8-26
200	7.00	178	3.00	76	7-21
300	7.00	178	3.00	76	7-19
500	7.00	178	3.00	76	7-17
750	7.00	178	3.00	76	7-13

*Inclined
Sizing Press*



Inclined Sizing Presses

Tonnage (U.S. Tons)	Stroke		Max. Part Length		Strokes Per Minute
	inches	mm	inches	mm	
5	2.00	50	0.50	12	50-190
10	3.00	76	0.63	15	50-170
15	4.50	114	1.25	31	50-170
30	5.00	127	1.50	38	30-150
45	7.00	177	1.75	44	30-100
60	10	254	3.0	76	15-80
100	10	254	3.0	76	10-55



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REMANUFACTURING AND REBUILD SERVICES

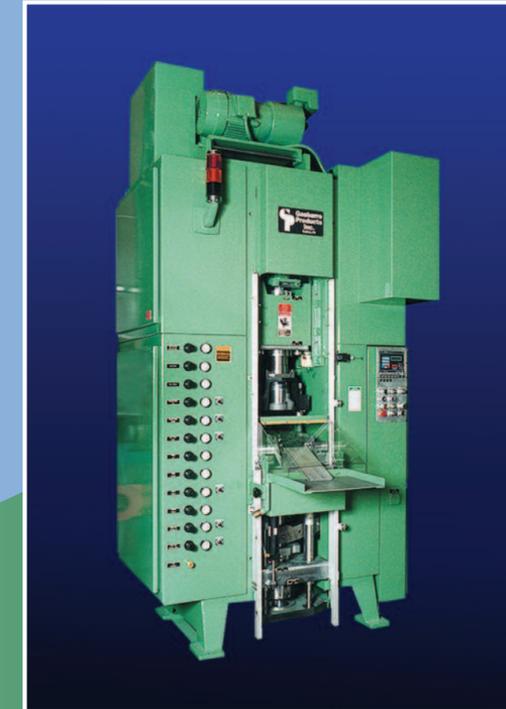
We offer a complete range of services for Gasbarre presses, as well as other manufacturers. Our rebuild team can disassemble and clean your press unit, evaluate wear surfaces, check for structural damage, remanufacture components, and fit them to the press. These processes are followed by a thorough quality check to ensure that the machine performs to your specifications.

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MECHANICAL COMPACTING & SIZING PRESSES



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Gasbarre Products is an international supplier of mechanical powder compacting and sizing presses for simple to complex parts. Gasbarre designs are engineered for rugged, reliable operation and backed by our reputation for quality and customer service.



*Standard Series
Compacting Press*



*Performance Series
Compacting Press*

STANDARD SERIES

The Standard Series Press features an economical design providing the capability to compact a wide range of parts - single level, two level and even multilevel, depending on tool design and options selected. The following are some of the features of this series:

Floating Die Platen is utilized to achieve the lower action. A fixed die table stop permits the use of shelves in the die.

Die Control Rods assist with achieving uniform density within the compacted part.

Four Post Design Die Set is a fixed unit mounted in the press. The die plate and core rod plate float together.

Adjustable Lower and Upper Rams accommodate varying punch lengths.

Gear Driven Adjustments for precise control.

Ejection System is bottom punch push-up utilizing an ejection cam and pushrod.

Shuttle-Type Filler Shoe System is fully adjustable by use of worm gear driven split cams.

Core Rods can be mounted in a stationary position or floating to permit synchronous motion with the die plate. Mounting adaptors are provided for both types of installation.

PERFORMANCE SERIES

The Performance Series Press design is an evolution of the Standard Series Press. It has enhancements to improve tool alignment as well as ease of maintenance. All the functions and options available on the Standard Series are also available on this series. The following are some of the design enhancements:

Crosshead Style Upper Punch Guidance System provides very precise punch to die alignment. This precision alignment enhances tool life.

Lower Ram Guide Plate gives superior lower punch guidance. The adjustable lower ram does not protrude through the guide plate. This creates a solid barrier protecting the adjustments from powder contamination.

Die Control Adjustment is located in the upper ram providing easy accessibility for adjusting and maintenance.

Core Rod Adaptor Mounts are bolted in for ease of removal and installation.

Enhanced Guarding System includes solid fully enclosed hinged side guards as well as hinged interlocked guarding on the front and rear of the press.

DIE SET SERIES

The Die Set Series Press utilizes readily removable die sets. These die sets are available in one lower punch and two lower punch configurations. Optional two upper punch capability can be provided for either style die set. The interchangeability and quick removal and installation of these die sets make remote set up as well as ease of maintenance possible. Some of the features provided in this series:

Floating Die Platen is utilized to achieve the lower action.

Adjustable Die Table Molding Stops enable process adjustments and tool redressing without modifying tool adaptors.

Fill, Ejection, and Molding Stops are worm gear-driven for easy accessibility and precise control.

Adjustable Lower Punch Rams provide individual independent adjustment of lower punches.

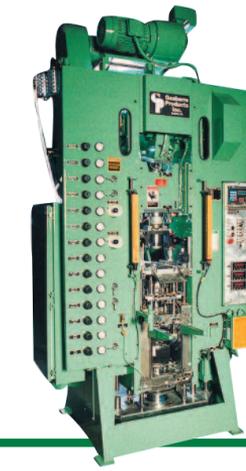
Crosshead Style Upper Punch System provides precise adjustability as well as precision alignment.

Shuttle-Type Filler Shoe System is fully adjustable by use of worm gear driven split cams.

Withdrawal Ejection System sequentially ejects tool levels using synchronized dual cams and push rods.

Modular Pneumatic Core Rod System has adjustable mold stops. Positions and motions are controlled independently of the die set. A fixed core rod which is mounted directly in the die set is also included.

Density Control Rods on the die and intermediate punch plates are independently adjustable permitting precise density control.



*Die Set Series
Compacting Press*



*Multi-Action Series
Compacting Press*

MULTI-ACTION SERIES

The Multi-Action Series Press uses state-of-the-art technology for compacting complex multi-level parts. This exclusive system offers both selective molding and selective ejection functions. This capability eliminates the need for expensive bridging of tools. Some of the features included in this series are:

Three Independent Lower Punch Platens provide total independent adjustability of each level.

Adjustable Selective Molding Stops are provided on the die platen as well as the #1 and #2 punch platens.

Adjustable Selective Withdrawal Ejection on the die platen, along with the #1 and #2 punch platens. Permitting the use of any lower punch platen as the stationary level. This simplifies tool design and adaptation for complex part geometries.

#3 Punch Platen has 1-1/2" of float for transfer in conjunction with a fixed mold position.

Motorized Position Adjustments with Digital Displays for ease of accessibility and precise control.

Pneumatic Dual Upper Punch System gives upper hub and counter bore capability.

Top Punch Hold Down Function controls the part during ejection.

Automatic Central Press Lubrication System insures that the correct amount of lubricant is applied at proper intervals.

Presslog Control System provides processor based press control with data storage through a touch screen monitor operator interface.

Servo Filler Shoe System gives total precise control of all shoe functions programmed through the touch screen monitor.

Tonnage Monitor digitally displays the tonnage on the monitor and provides high and low parameter settings.

Underfill/Overfill is used to reduce powder "splash out" from the die as well as aiding in difficult filling applications.

Pneumatic Up-Float/Down-Float Core Rod System has fully adjustable up, mold, and down positions. This modular core rod system can move independently of the die set and can also be tied to the die platen for synchronous motion.



PRESSLOG HMI

(Human Machine Interface & Control System)

The optional Windows®-based PressLog HMI uses a graphic touch-screen display. Operators know the machine's status at a glance. Password security allows operator, supervisor and maintenance levels of access. Users can check fault logs, store virtually limitless production process information and access online troubleshooting aids. PressLog retains a history of all setups. Controls display metric or Imperial units and are programmable for your language.

Powder Compacting Press Specifications

Tonnage	5		10		15		20		30		45		60		100		125		150		200 ³		300		350		400		550		600		750		800			
	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke	fill	stroke				
STANDARD SERIES¹	inch 1.125	2.50	1.50	3.00	2.50	4.50	3.25	4.50	3.25	5.25	4.50	7.00	6.25	9.00	6.25	9.00	n/a	n/a	6.25	9.00	6.25	9.00	6.25	9.00	n/a	n/a	n/a	n/a	6.25	10.00	n/a	n/a	6.25	10.00	n/a	n/a		
	mm 29	64	38	76	64	114	83	114	83	133	114	178	159	229	159	229	n/a	n/a	159	229	159	229	159	229	159	229	n/a	n/a	n/a	n/a	159	254	n/a	n/a	159	254	n/a	n/a
PERFORMANCE SERIES¹	inch n/a	n/a	n/a	n/a	2.50	4.50	n/a	n/a	3.25	5.25	4.50	7.00	6.25	9.00	6.25	9.00	n/a	n/a	n/a	n/a	6.25	9.00	6.25	9.00	6.25	9.00	n/a	n/a	n/a	n/a	6.25	10.00	n/a	n/a	n/a	n/a	n/a	
	mm n/a	n/a	n/a	n/a	64	114	n/a	n/a	83	133	114	178	159	229	159	229	n/a	n/a	n/a	n/a	159	229	159	229	159	229	n/a	n/a	n/a	n/a	159	254	n/a	n/a	n/a	n/a	n/a	
DIE SET SERIES²	inch 1.50	2.50	2.00	3.50	2.75	4.50	3.25	5.00	3.25	5.50	4.50	7.00	6.25	9.00	6.25	9.00	n/a	n/a	6.25	9.00	6.25	9.00	n/a	n/a	n/a	n/a	6.25	10.00	n/a	n/a	6.25	10.00	n/a	n/a	6.25	10.00		
	mm 38	64	51	89	70	114	83	127	83	140	114	178	159	229	159	229	n/a	n/a	159	229	159	229	n/a	n/a	n/a	n/a	159	254	n/a	n/a	159	254	n/a	n/a	159	254		
MULTI-ACTION SERIES²	inch n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	6.25	9.00	n/a	n/a	6.25	9.00	n/a	n/a	6.25	9.00	n/a	n/a	6.25	10.00	n/a	n/a	6.25	10.00	n/a	n/a	6.25	10.00	n/a	n/a		
	mm n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	159	229	n/a	n/a	159	229	n/a	n/a	159	229	n/a	n/a	159	254	n/a	n/a	159	254	n/a	n/a	159	254	n/a	n/a		
Range of Speed Adjustment Strokes Per Minute	15-60		10-50		10-50		8-40		8-40		7-30		7-25		7-25		7-25		7-22		7-22		7-19		7-19		7-17		7-17		7-17		7-13		7-13			

¹die platen float is 1/2 fill depth in push-up ejection press

²die platen float equals fill depth in withdrawal style press

³220 Ton available in Die Set Series