



**MET-TECH | Product Data Sheet**  
**EXTRUSION PRESS - 2500 MT - 8" & 9" & FLAT BILLETS**

**Ref. No.:** EXTRUSIONPR170501

**Year:** 1990

**Brand:** SMS

**Qty.** 1 Second-hand extrusion press

**Mfc.:** SMS - Hasenclever Force

**Container for flat billets Width:** 375 mm Height

**Billet length:** 1000 mm Stem length, max.

**Consist of:** Extrusion Press Body Cylinders Motors Hydraulic tank

**Qty.** 2 Containers (8? & 9?)

**Technical data:**

Extrusion force, nominal 25 MN Operating pressure 250 bar

Main ram Extrusion force 22.06 MN Feed ram Extrusion force 3.08 MN

Total Extrusion force, max. 25.14 MN Recentering force 1.5 MN

Stem lifting 2200 mm Stem speed 23.8 mm/sec.

At total Extrusion force 27.2 mm/sec. Main ram Extrusion force 3.08 MN

Container Sealing force 2.31 MN Container inside diameter 200 & 250 mm

Container for flat billets width 375 mm height 140 mm

Billet length 1000 mm Stem length, max. 950 mm

Cutting force for butt-end removal 0.79 MN Auxiliary shear cutting force 0.38 MN

Profile circle, max. 225 mm Profile width, max. 315 mm

Tool pack ? Ø 475 mm Tool pack ? height 500 mm

Total volume flow at 250 bar 1440 L/min.

Installed capacity for high pressure pumps 3 x 200 kW

Dead cycle time - cutting program 18 sec. +/- 5% Oil tank filling 12 500 L

**Extrusion press dimensions:**

Max. overall height above shears 4870 mm Max. overall height above oil tank 4750 mm

Max. lifting height pump with motor 5750 mm Required height for crane hook  
5950 mm

Max. width of tool change 3700 mm

Max. overall length 11280 mm Center of press above area 1000 mm

Scope of supply

Qty. 3 Drive units

**High-pressure oil pump gear, consist of:**

Qty. 3 High-pressure axial-piston pump («Brueninghaus»)

Type A2V 500 HM OL S EP, with continuous volume flow rate, open type, for vertical installation in press oil tank, with hydraulic control device with position indicator and regulated variable potentiometric sensor.

**Technical data:**

**Operating pressure:** 250 bar Volume flow rate

**Drive power:** 200 kVA Drive speed

Qty. 1 Feeding pump

for pressing loader to die during extrusion; in the form of a gear pump with internal gears, with a constant volume flow rate and cyclic control

**Technical data:**

**Operating pressure:** 250 bar Volume flow rate

**Drive power:** 7.5 kVA Drive speed

Qty. 3 Hydraulic control valves for adjusting the high-pressure pump

Qty. 4 Mounting plate for vertical high-pressure pumps in the oil tanks with internal piping

separate pumping systems.

Qty. 4 Flexible couplings

**Oil hydraulic low-pressure drive, consist of:**

Qty. 1 Double vane pump

**Stage 1:** In conjunction with low-pressure oil pump suction manifold, a serial connection to the oil pressure system, auxiliary devices operated valve control unit high pressure, as well as control devices for high pressure pumps

**Stage 2:** For the circulation of working oil on the filter and heat exchanger designed for vertical installation in the oil tank

**Technical data:**

**Stage 1:** working pressure

**Stage 2:** working pressure

**Drive power:** 22 kW Drive speed

Qty. 1 Mounting plate to the pump with internal piping pump installation

Qty. 1 Flexible coupling

Qty. 1 Cyclic control device (to be checked whether it has to be replaced or reconditioned)

Qty. 3 Low pressure oil pump suction manifold

**Technical data for each unit:**

**Working pressure:** 100 bar Net volume

Qty. 1 Angle valve for hopper emptying

Qty. 1 Filling device and control

Qty. 3 Three-phase motors to high pressure oil pump

**Power:** 200 kW Speed

Qty. 1 Three-phase motor to feeding pump

**Power:** 7.5 kW Speed

Qty. 1 Three-phase motor to double vane pump low pressure

**Power:** 22 kW Speed

Low-voltage switchgear (to be checked whether it has to be replaced or reconditioned)

with power supply by means of automatic circuit breaker having a thermally slow and fast-acting magnetic circuit breakers and trip through the under voltage release.

Switching circuit for engines of high pressure pumps are provided for "star-delta" connection.

Engines with a capacity of over 100 kW have the full protection of the motor.

Delayed start automatically pump motors is operated with the press control.

Control systems (hydraulic and electric) (to be checked whether it has to be replaced or reconditioned)

High pressure control system

**Block design, dual-line Systems:** supply control high pressure pump and press high pressure cylinder movements

**consist of:**

Qty. 1 Pump power switch with valves to pressure limit

Qty. 1 Valve control unit for control of Main ram and feed cylinders and return cylinders

Qty. 1 Valve control unit to control loader, shears and switch valve for tool change (die tools)

Qty. 1 Filling valve for control sucked or circulating oil at a fast out-in traverse of main ram

Qty. 1 Feeding valve to feed cylinder during pressing only with main pressing ram

Low pressure Control system (to be checked whether it has to be replaced or reconditioned)

**to control auxiliary devices consist of:**

Qty. 2 Directional control valve for loader control, 2-piece design

Qty. 1 Directional control valve to operate the cassette moving table

Qty. 1 Magnetic on-off valve for separating oil low-pressure system from

auxiliary devices

Qty. 1 Directional control valve

Device for lubricating of dummy block

Low-voltage switchgear for the press control (to be checked whether it has to be replaced or reconditioned)

Qty. 1 Control cabinet

Designed to install indoors over cable channel

Possible freestanding installation of cabinet

Suitable for installation against the wall

Door located on the front side, lockable

Controller doors (PLC) has panels with glass inserts making possible the recognition of the signal outside

Cabinet panels have internal lighting and socket