

MN SERIES (Metric) Forging Presses for the 21st Century



7 MN to  
120 MN  
  
700 to  
12,000  
Metric  
Tons

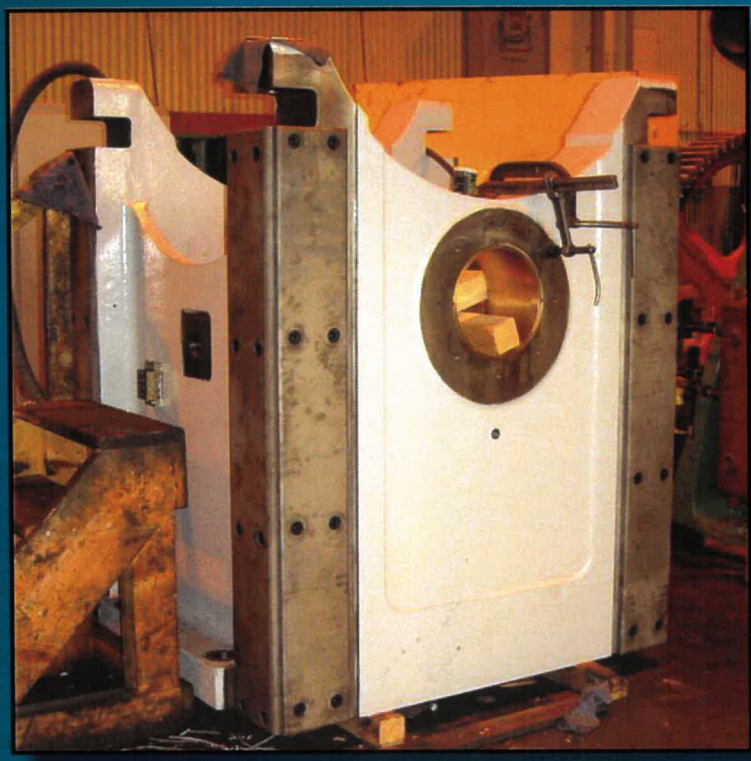
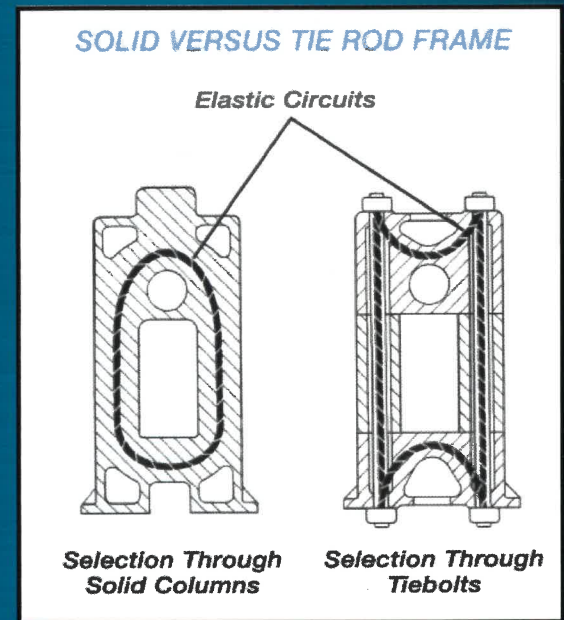


*The Leader in Forging Since 1875*

**HOT, WARM AND COLD FORGING MACHINERY**

# Forging Press Productivity Begins Here

The Ajax-CECO MN Series of forging presses is a modern design for the 21st century. They offer unmatched process control and precision. This series is designed to hold closer tolerances than ever before available. The one-piece solid steel frame with large columns, integral bearing housing and increased frame material around the bearings and crown means the MN series has an elastic circuit which stretches less than half that of a press built with tie rods. The low frame stretch allows close tolerances and consistent forgings.



## ***Ram Guiding System***

### **LONG RAM GUIDES**

- Eight-point guiding with individual adjustment on each surface

### **GUIDES INCLUDE TOP BOLSTER**

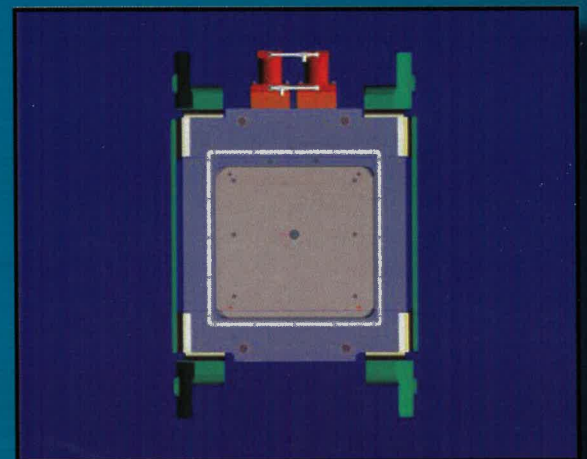
- No need for bolster guide pins
- Less ram tilt on off-center loading

### **NO TAIL ON RAM**

- Simple ram removal for inspection and clearance setting
- Eliminates the risk of breakage
- Four balance cylinders

## ***Ram and Tool Guiding***

- Ram guides are long enough to include the bolster
- Same datum as ram guide

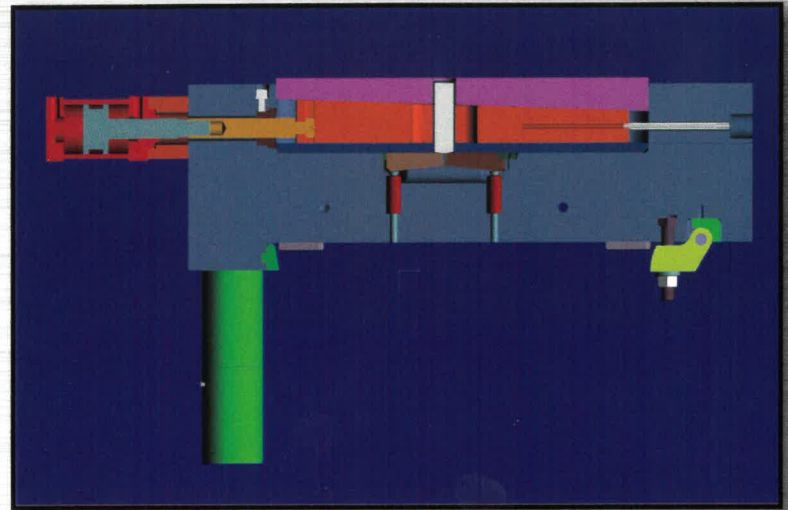
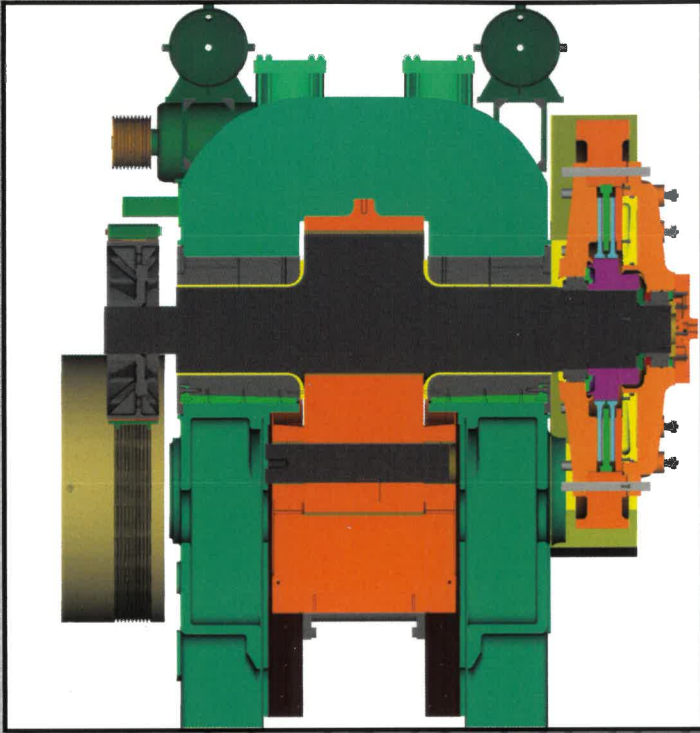


*WE'RE TURNING THE ART OF FORGING INTO THE SCIENCE OF FORGING*

# New Pitman and Ram Design

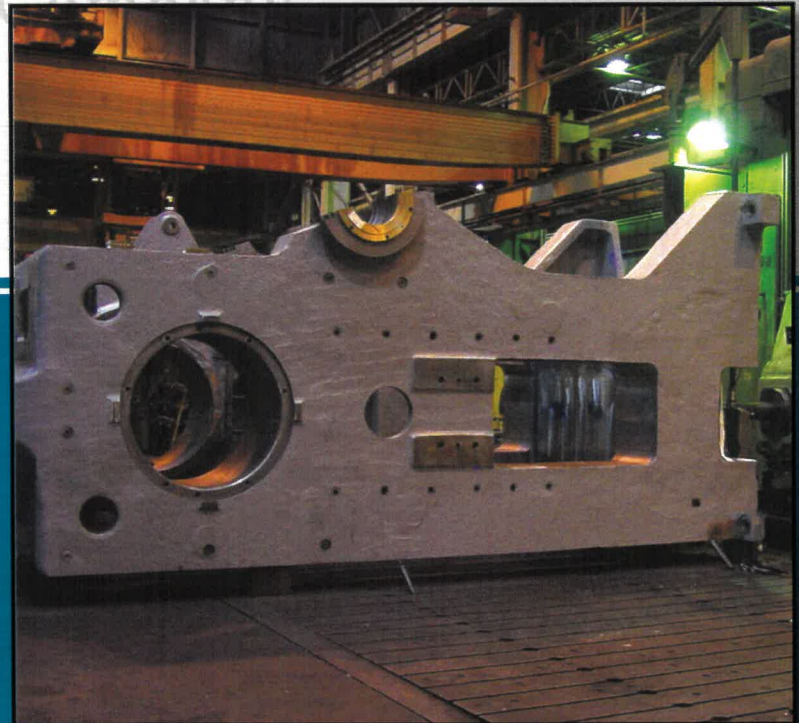
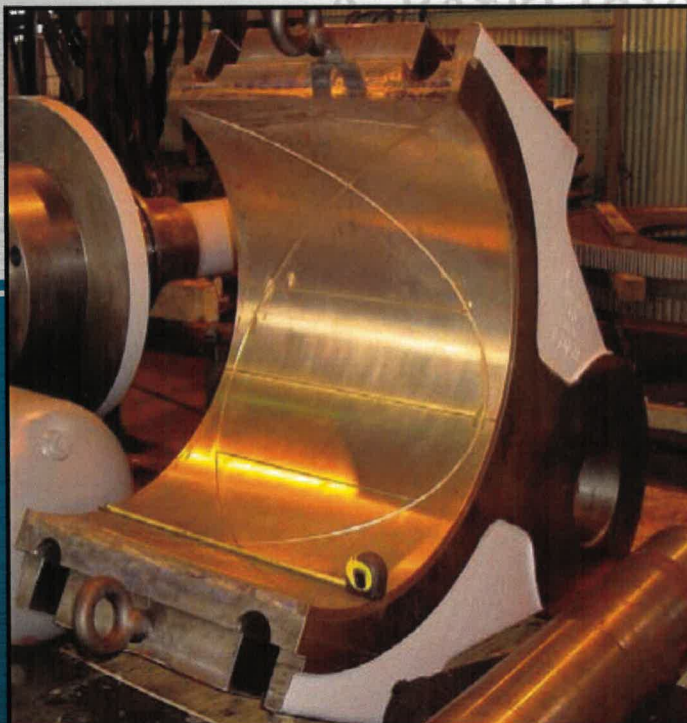
## Wide Pitman

- 50% wider than the old version
- Less deflection at full load
- Larger radii
- Wide eccentric shaft



## Simple Shut Height Adjustment System

- The MN series comes with an upper wedge cap, now an integral part of the ram. A conventional bolster or FDI Precision Forming System can be keyed to the wedge cap.
- 3mm (.125") of shut height adjustment, as standard, using a hydraulic adjustment cylinder
- Allows the continued use of the nose thrust bearing
- Simple to maintain.



# Ajax Forging Presses 7MN To 120MN "MN" (Metric) Series Specifications

SPECIFICATION	UNITS	SIZE									
		7MN	10MN	13MN	20MN	30MN	40MN	60MN	80MN	100MN	120MN
Rating	Newtons	7,000,000	10,000,000	13,000,000	20,000,000	30,000,000	40,000,000	60,000,000	80,000,000	100,000,000	120,000,000
	US Tons	787	1124	1461	2248	3372	4496	6744	8992	11240	13489
Strokes per min	spm	110	100	90	80	70	65	50	40	35	30
Stroke Length	in	10	10	12	14	14	16	18	20	20	20.47
	mm	254	254	305	356	356	406	457	508	508	520
Ram Face, L-R	in	24	27	31	36	52	56	66	74	80	84.65
	mm	610	686	787	914	1321	1422	1676	1880	2032	2150
Ram Face, F-B	in	24	27	31	39	49	52	60	68	80	98.43
	mm	610	686	787	991	1245	1321	1524	1727	2032	2500
Top K.O. Stroke	in	0.875	1	1.25	1.375	1.875	1.875	2.125	2.125	2.5	3
	mm	22	25	32	35	48	48	54	54	64	76
Ram to Table	in	25	25	30	35	41	45	48	54	62	70.87
	mm	635	635	762	889	1041	1143	1219	1372	1575	1800
Bottom K.O. Stroke	in	1.75	1.75	1.75	2	2.5	3	3.5	4	4	4
	mm	44	44	44	51	64	76	89	102	102	102
Table to Floor	in	26	26	30	33	39	43	55	55	36	36
	mm	660	660	762	838	991	1092	1397	1397	914	914
Die Seat, L-R	in	23	28	32	39	54	61	70	78	82	87.60
	mm	584	711	813	991	1372	1549	1778	1981	2083	2225
Die Seat, F-B	in	36	35	33	48	60	62	70	76	86	102.36
	mm	914	889	838	1219	1524	1575	1778	1930	2184	2600
Width between Columns, L-R	in	28.25	32.5	37.5	39.76	48	65.5	76	80	84	89.57
	mm	718	826	953	1010	1219	1664	1930	2032	2134	2275
Side Window Width	in	16	20	22	27.95	28	36	36	36	40	43.31
	mm	406	508	559	710	711	914	914	914	1016	1100
Floor Space, L-R	in	98	110	134	147.64	164	200	229	234	260	282.48
	mm	2489	2794	3404	3750	4166	5080	5817	5944	6604	7175
Floor Space, F-B	in	94	105	112	128.54	147	171	188	204	240	271.65
	mm	2388	2667	2845	3265	3734	4343	4775	5182	6096	6900
Height Above Floor	in	160	172	192	203.31	221	261	288	300	345	350.39
	mm	4064	4369	4877	5164	5613	6629	7315	7620	8763	8900
Motor	HP	40	60	75	100	150	250	400	500	600	800
	KW	29.8	44.8	56.0	74.6	111.9	186.5	298.4	373.0	447.6	596.8
Motor Speed	RPM	900	900	900	900	900	900	720	720	720	720
Gross Weight	lbs	81,000	109,000	148,000	250,000	330,000	585,000	918,000	1,250,000	1,900,000	2,450,000
	kg	36,818	49,545	67,273	113,636	150,000	265,909	417,273	568,182	863,636	1,113,636
Air Consumption	cu. Ft.	0.46	0.65	0.85	1.12	1.51	2.36	2.99	3.1	3.5	4.5
	cu. M.	0.013	0.018	0.024	0.032	0.043	0.067	0.085	0.088	0.099	0.127

Ajax reserves the right to change specifications at any time consistent with good engineering practice. Due to frame casting size, 80MN and larger are Tie Rod design. All specifications subject to change at discretion of manufacturer.



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