



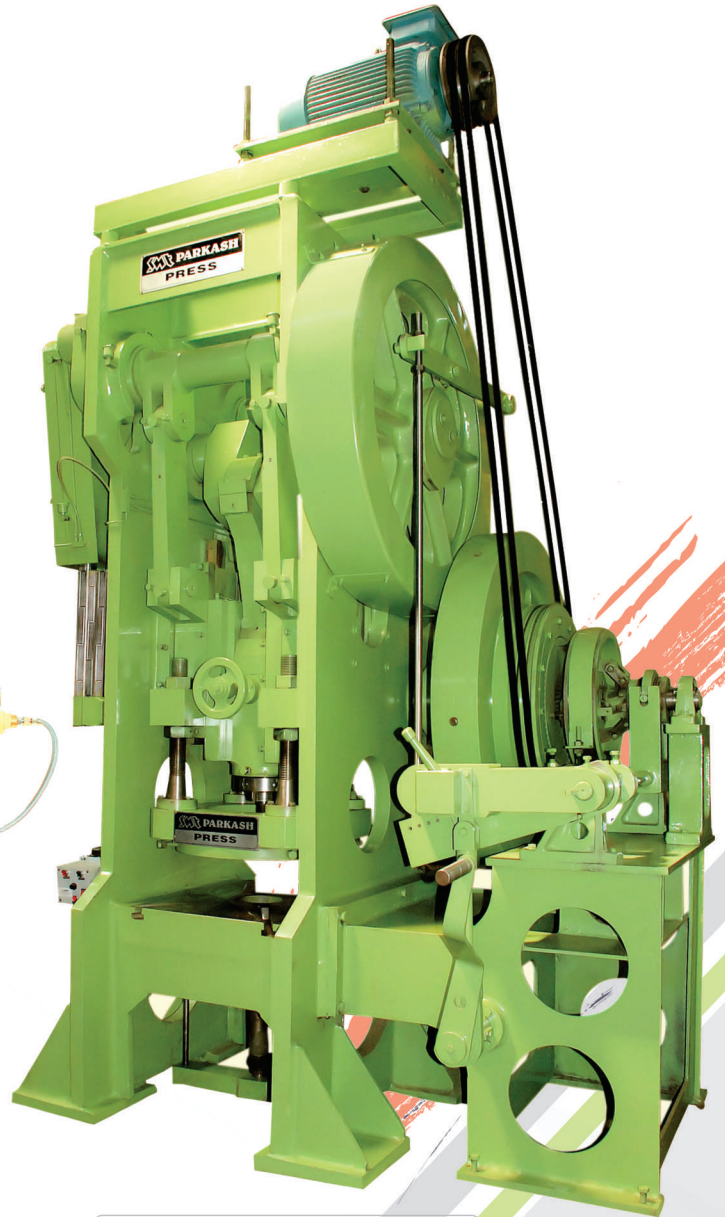
Leading the Way in  
Precision and Quality



## DEEP DRAWING DOUBLE ACTION TOGGLE TYPE POWER PRESSES



**with Pneumatic Clutch**  
(safety sensors)



**with Mechanical Clutch**



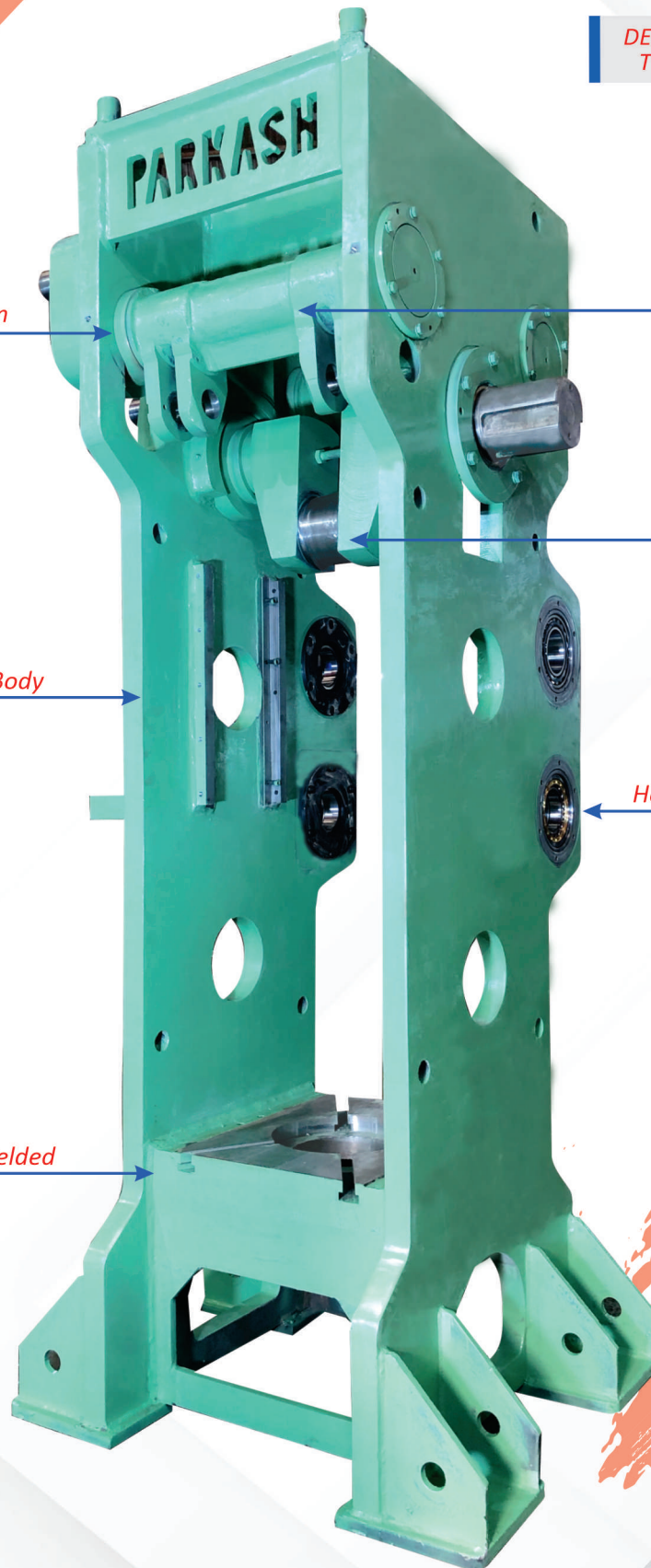
For Drawing Stainless Steel, Aluminium, Brass,  
Copper Utensils & Automotive Components.

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# RIGIDITY

increases die life

DEEP DRAWING DOUBLE ACTION  
TOGGLE TYPE POWER PRESSES



No CAP (topi) System

Forged Steel One Piece  
Toggle Shaft

Forged Steel One Piece  
Crank Shaft

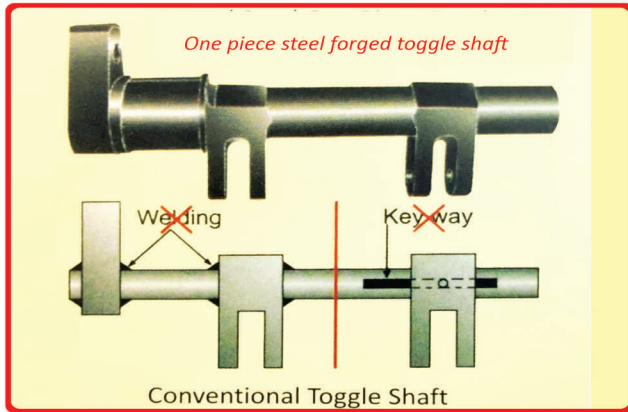
Solid Steel Plate Body

Heavy Duty Roller Bearings  
for Flywheel Shaft

Bed Groove fitted and Welded

PARKASH Deep Drawing  
Double Action Presses are  
popular for producing parts  
in :  
- Utensil Industry  
- Automotive Industry  
- Manufacturing of  
Household Goods

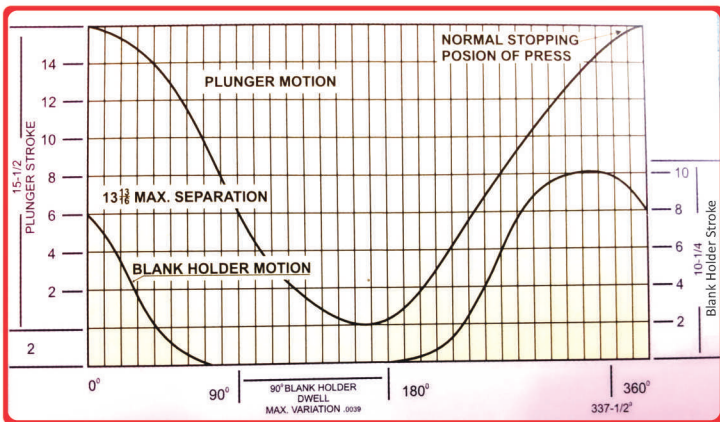
PARKASH PRESSES with solid steel plate body have higher rigidity and strength which reduces deflection in the frame and increases the die life. The use of solid body plates instead of hollow box type frame eliminates excessive welding stresses, reducing vibration and making it suitable to work in both higher and lower gauges. The bed is groove fitted in the seat and welded which is only possible in solid plates and therefore elimination of welding getting cracked on heavy loads.



Steel Forged Crank Shaft

### Steel Forged Toggle Shaft and Crank Shaft

The Crankshaft and Toggle Shaft are one-piece, solid made from tested forged steel. The shape and size of toggle shaft is designed in such a way, so that it is able to withstand heavy loads, provide longer life and is maintenance free. As compared to Conventional toggle shafts which faces breakdown because of welding and keyways present in it and require more maintenance frequently.



The diagram represents the relative motion of the blankholder and plunger of a typical single-crank toggle press. Blankholder dwells during entire drawing portion of press cycle.

### Design Features

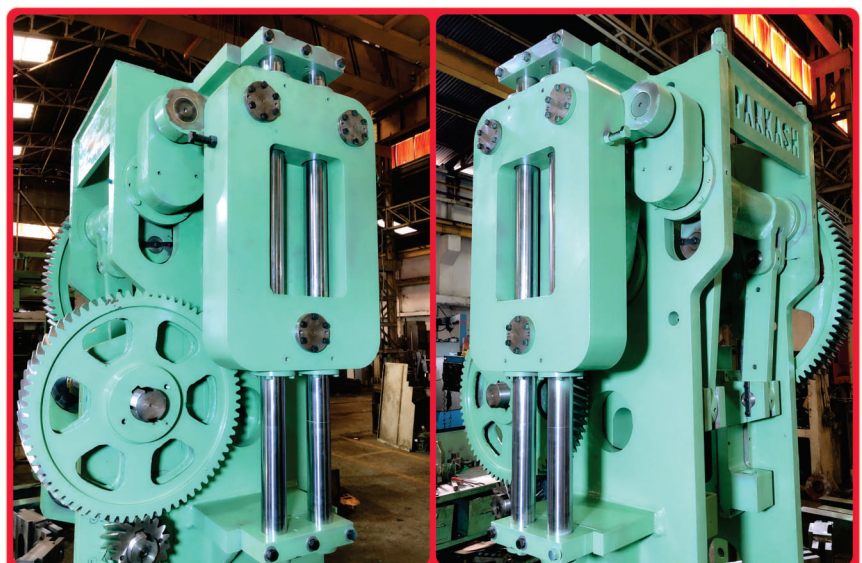
Toggles operation the blank holder and relieve the crankshaft of the blankholding strain which is then carried directly to the press frame. Thus, nearly all the crankshaft power comes to bear on the drawing operation. The toggle linkage provides ninety degree of blankholder dwell during which the pressure on the blank is steady. Four independent adjustments, one at each corner permits individual corner adjustment of blankholder pressure.

### Outer Slide Design (Rod Type)

PARKASH PRESSES has a unique outer slide design consisting of two hardened, grinded and chromed steel rods running in bronze bushes which increases the slide life and reduces maintenance. This rod design has proved to be way better than the rectangular steel bar design.

### Hardened and Grinded - Gears and Pinions

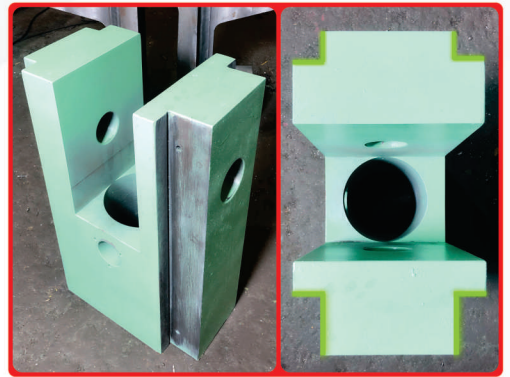
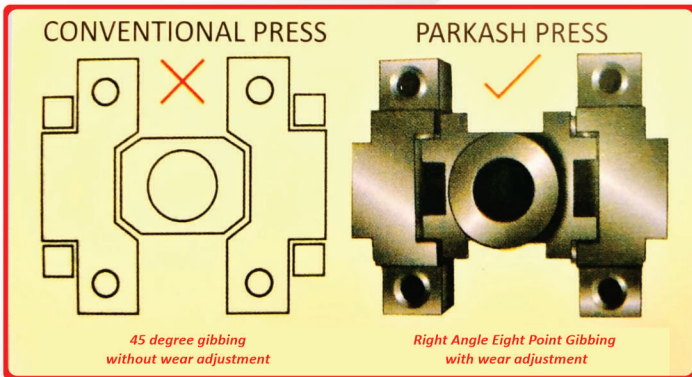
All the gears & pinions in the press are hardened and grinded which increases the life of machine and reduces noise during the running cycle.



Outer Slide Design (Rod Type)

# RELIABILITY

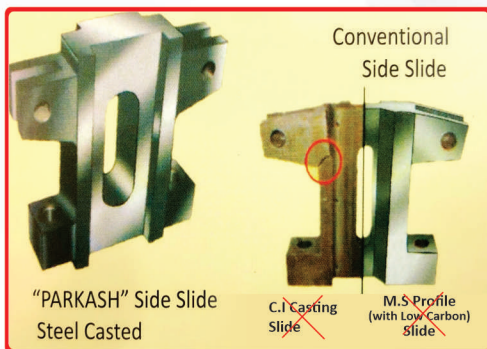
minimum maintenance



Steel Casted Center Slide

## Right Angle Eight Point Gibbing

PARKASH Press has eight point square gibbing slide arrangement ensuring accurate parallelism and perpendicular movement to produce quality and accurate drawn component. Non-ferrous adjustable liners are provided to ensure closer gib clearance which results in accurate and precise movement of the slide.



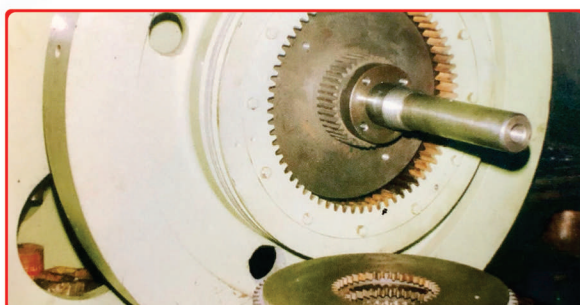
Steel Casted Side Slide

## Side Slide

PARKASH Press side slide and connecting rod are steel casted (grade 23-45), resistant to breaking and bending at high pressure thus maintaining the press life.

## Multi-plate Clutch System

PARKASH Presses are equipped with multi-plate clutch system both in mechanical and pneumatic clutch with wear adjustment for taking heavy torque/loads and thus providing maintenance free service for a longer period of time.



Multi-plate Clutch System



## Hardened & Grinded Pins and Oil less Bushes

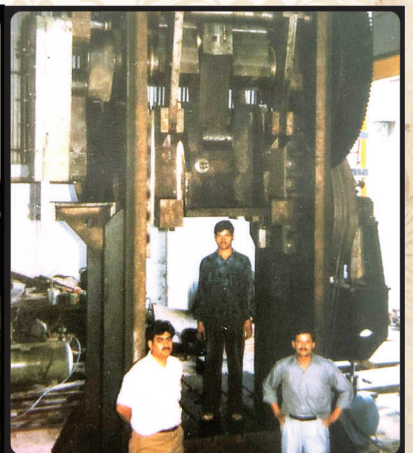
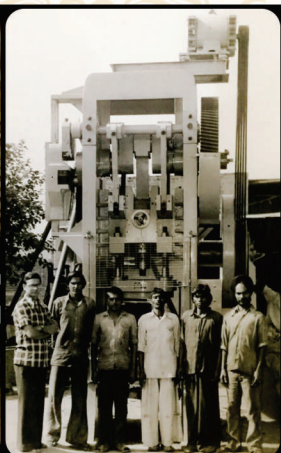
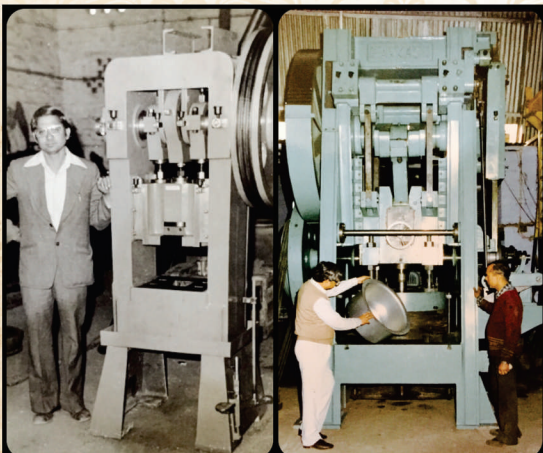
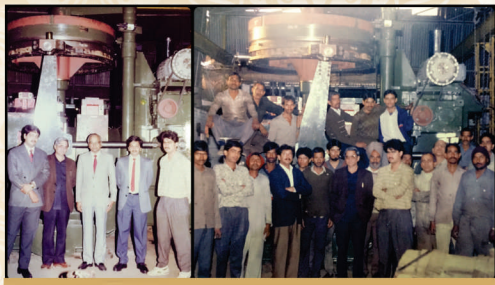
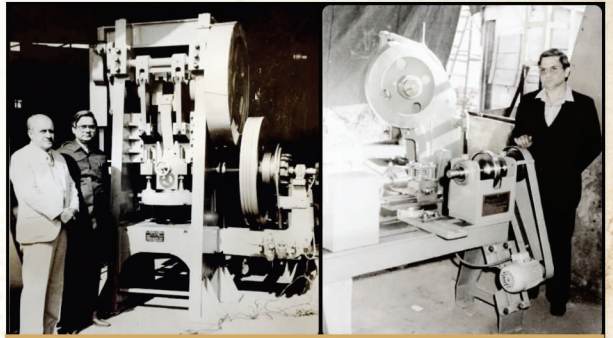
All pins are made from alloy carbon steel which is hardened and grinded within closed tolerances for 100% interchangeability. Oil less bushes are used which increases pins life and thus reducing maintenance.



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SINCE 1952



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## Specifications for "PARKASH" Deep Drawing Double Action Toggle Type Presses

	<b>PARKASH PRESS NUMBER</b>	<b>units</b>	<b>4</b>	<b>4 1/2</b>	<b>5A</b>	<b>5B</b>	<b>5 1/2</b>	<b>6</b>	<b>6 1/2</b>	<b>7B</b>	<b>8</b>
1.	Capacity Total	Tons	75	100	125	150	200	250	300	500	600
2.	Capacity Plunger/Punch (1/4" above bottom)	Tons	50	65	90	100	125	165	200	325	400
3.	Capacity Blank holder (1/8" above bottom)	Tons	25	35	35	50	75	85	100	175	200
4.	Largest Blank Dia. Admitted	inches	16"	20"	24"	26"	28"	32"	36"	48"	60"
		mm	406	508	609	660	711	812	915	1220	1524
5.	Deepest Draw	inches	5"	7"	8"	9"	10.5"	11.5"	12.5"	18"	24"
		mm	127	177	203	228	266	292	315	457	610
6.	Max. Stroke of Pressure Plate	inches	7"	8"	10"	11"	12"	13"	14"	20"	26"
		mm	177	203	254	279	304	330	355	660	660
7.	Max. Stroke of Punch	inches	10"	14"	16"	18"	21"	23"	25"	36"	48"
		mm	254	355	406	457	533	584	655	915	1220
8.	Bed to Pressure Plate (adj. up-st. up)	inches	18"	21"	24"	25"	28"	31"	33"	43"	51"
		mm	457	533	609	635	711	787	840	1090	1295
9.	Bed to Punch Holder (adj. up-st. up)	inches	21"	24"	27"	30"	32"	36"	40"	64"	66"
		mm	533	609	865	762	812	914	1016	1625	1675
10.	Bed Between frames	inches	21"	24"	26"	30"	32"	34"	38"	54"	66"
		mm	533	610	660	762	812	870	965	1370	1675
11.	Bed front to back	inches	24"	28"	30"	34"	36"	38"	44"	72"	78"
		mm	609	711	760	860	915	965	1115	1828	1980
12.	Hole dia. Though bed	inches	6"	9"	9"	12"	15"	18"	21"	27"	36"
		mm	152	304	304	380	380	457	533	685	915
13.	Largest dia. Punch admitted	inches	15"	18"	20"	22"	24"	26"	28"	36"	42"
		mm	381	457	508	558	610	660	711	915	1065
14.	Adjustment to Pressure-Plate Adjustment to Punch-Holder	inches	5"	6"	7"	7"	8"	9"	9"	15"	18"
		mm	127	152	177	177	203	228	228	380	455
15.	Strokes per Minute	No.s	12	10	10	9	8	7	7	7	5
16.	Power required (960 rpm)	H.P.	10	15	20	25	30	35	40	50	70
17.	Overall Height (without Motor)	inches	100"	110"	115"	128"	138"	147"	155"	175"	210"
18.	Overall Height (with Motor)	inches	120"	132"	138"	156"	168"	180"	192"	204"	228"
19.	Overall Width	inches	80"	85"	90"	95"	105"	115"	125"	150"	180"
20.	Overall Depth	inches	50"	55"	60"	65"	70"	75"	80"	95"	145"
21.	Weight Approximate	Kgs	5,500	7,500	8,500	11,500	13,500	16,500	20,000	28,000	35,000



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### SHARMA PRESSES

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