TABLE II

SPECIFICATIONS FOR A 12-TON HYDRAULIC COMPACTING PRESS[a]

	Minimum	Maximum
Ram force-pressing		
Upper ram	1.0 ton	12.5 ton
Lower main ram	0.2	12.9
Lower auxiliary ram	02.	2.8
Ram force-withdrawal		
Upper ram	0.7	8.0
Lower main ram	0.7	8.2
Lower auxiliary ram	0.2	2.8
Powder fill depth		3 in.
Cycle rate		47 strokes/min
Operating pressure	250 psi	3000 psi
Cycling pressure	250	500
Upper ram speed-down (unloaded)		10.2 in./sec
(loaded)		1.5
Upper ram speed-up		16.4
Lower ram speed-up (unloaded)		10.2
(loaded)		1.5
Lower ram speed-down		16.4
Upper ram stroke		4 in.

[a] Model HC-12, Hydramet American Inc., Royal Oak, Michigan.

10 % fines material can impede the free pouring characteristics of the powder