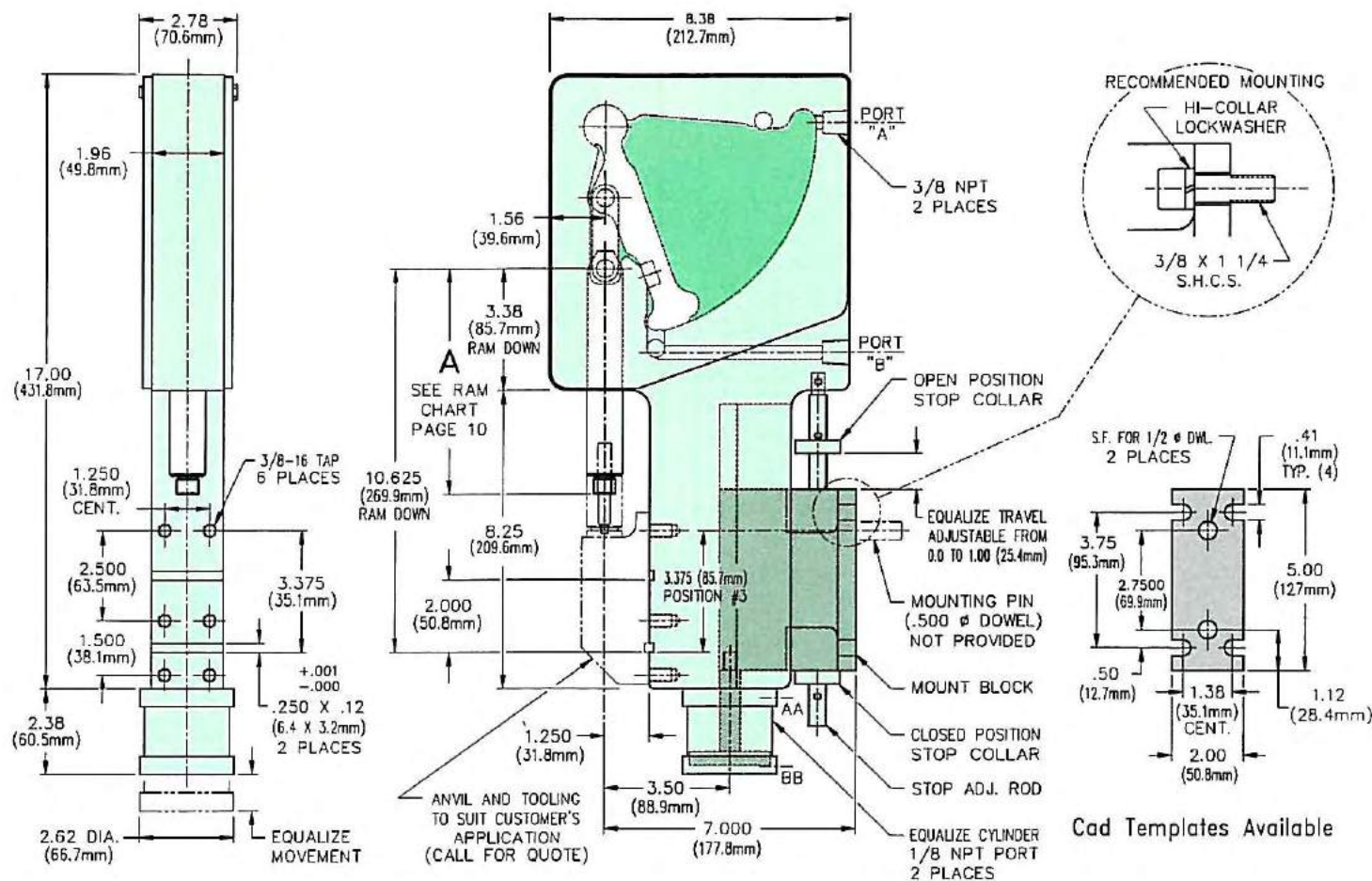


2 Ton Equalizing (2 Position) Presses

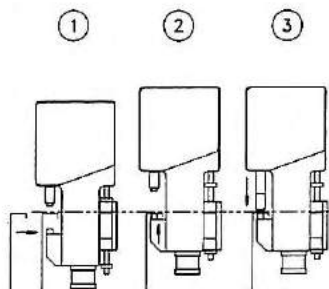
EU Models (Equalizing Unit)

P2EU x 1.50 (38.1mm) Stroke 012878 - 30 lbs. (13.6 kg)

P2EU x 2.25 (57.2mm) Stroke 006210 - 30 lbs. (13.6 kg)



How Equalizing Works (Standard - Punch on Ram)



- ① Open Position - Part load and unload.
- ② Equalize Position - Die advanced to part.
- ③ Closed Position - Ram extended to perform work.

How to Order Presses

6	P2EU x 2.25	PT100	BC	TC	EPRL	EPEL	SS-1	TOOLING
Quantity	Model	Stroke 1.50, 2.25 or Special	Ram Style See Page 10	• Bottom Cushion	• Top Cushion	• Proximity Switches See Page 28	• Strippers See Page 11	• Consider Tooling See Page 11

How to Order Components

Qty.	Piston Description	000117 BTM No.
------	--------------------	-------------------

- Denotes Options

Contact BTM's Sales Department for equalize strokes greater than 1.00 (25.4 mm)

For further information, see pages 33–35 in the technical section.

Components
P2EU

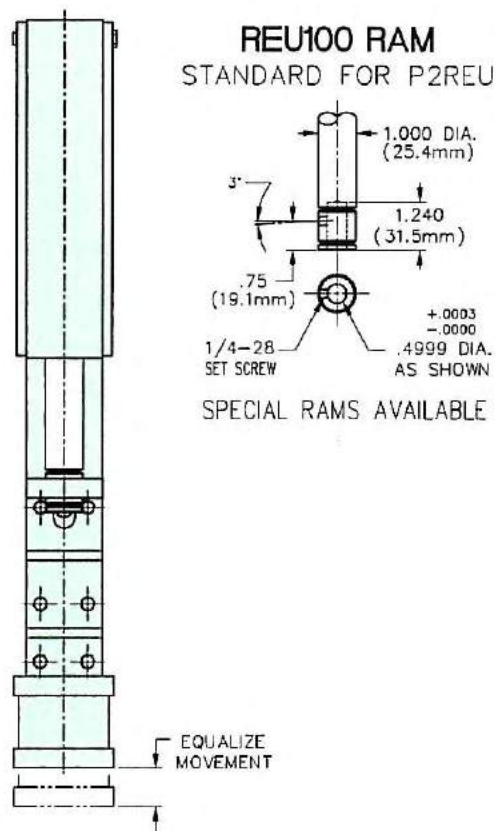
Description	No. Req'd	BTM No.
P2EU x 1.50 (38.1mm) Body	1	012879
P2EU x 2.25 (57.2mm) Body	1	006211
Piston	1	000117
Piston Seal	2	000058
Link	1	000120
Link Pin	2	000124
Link Pin Retainer	2	000121
Ram - 100 Series	1	See Pg. 10
R.H. Cover	1	000125
L.H. Cover	1	000126
Cover Screw	13	000129
Cover Nut	13	000078
Ram "O" Ring	1	000150
Grease Fitting	2	000050
Sealant	1	000273
Seal Kit	1	000800
Top Cushion	1	001271
Bottom Cushion	1	000591
Stroke Limiter	1	000828
Equalizing Air Cylinder	1	006157
Stop Adjust Rod	1	013079
Stop Adjust Collar	2	006162
Mount Block	1	006139
3/16 Dia. x 1/2 Roll Pin	2	013088
3/16 Dia. x 1 3/4 Roll Pin	1	013087

2 Ton Reverse Equalizing (2 Position) Presses

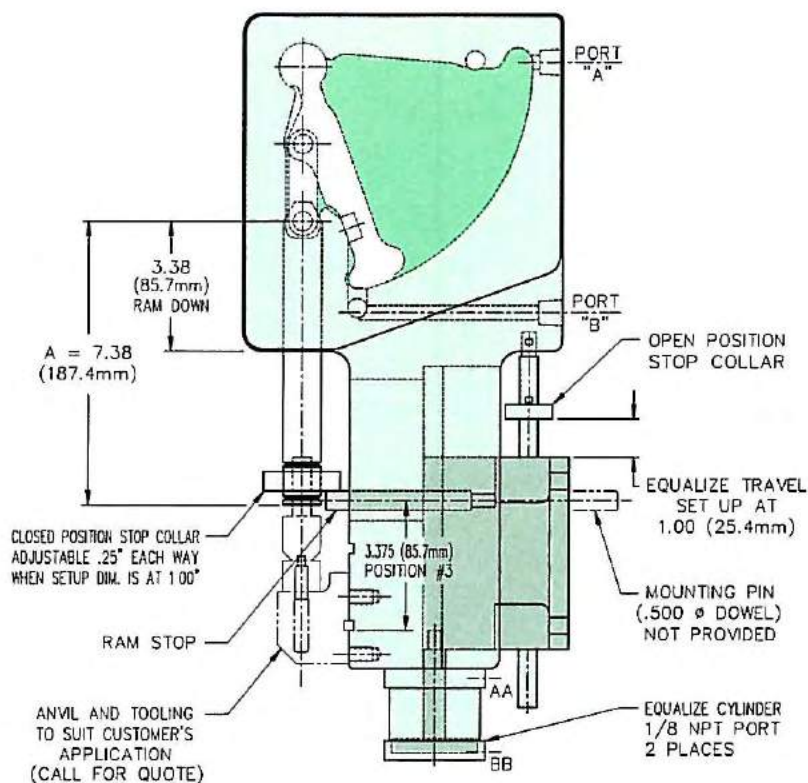
BTM

REU Models
(Reverse Equalizing Unit)

P2REU x 1.50 (38.1mm) Stroke 013126 - 30 lbs. (13.6 kg)
P2REU x 2.25 (57.2mm) Stroke 013076 - 30 lbs (13.6 kg)

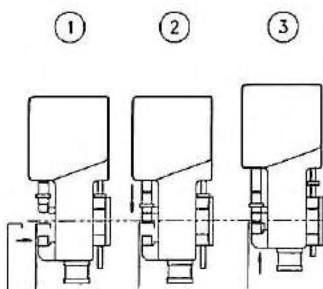


Cad Templates Available



For dimensions and items not shown, see P2EU, page 8.

How Equalizing Works (Reverse - Die on Ram)



- ① Open Position - Part load and unload.
- ② Equalize Position - Die advanced to part.
- ③ Closed Position - Ram extended to perform work.

How to Order Presses

Quantity	Model	Stroke 1.50, 2.25 or Special	Standard Ram Style	Bottom Cushion	Top Cushion	Proximity Switches See Page 28	Consider Tooling See Page 11
6	P2REU x 2.25	REU100	BC	TC	EPRL	EPEL	TOOLING

How to Order Components

Qty.	Piston Description	BTM No.
1	Piston	000117

* Denotes Options

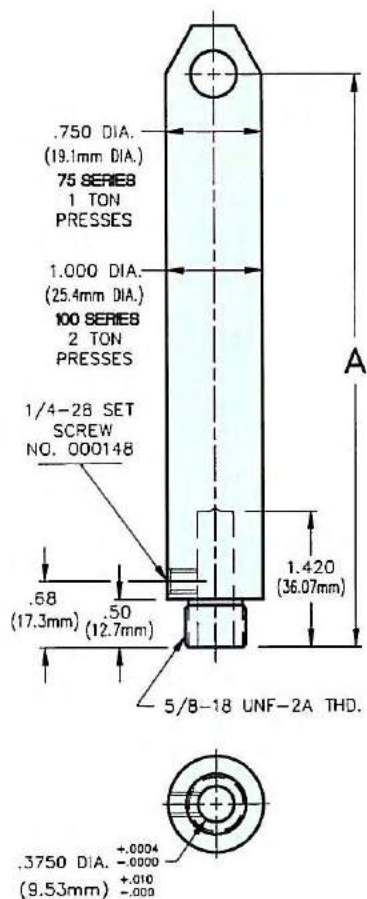
Contact BTM's Sales Department for equalize strokes greater than 1.00 (25.4 mm)

For further information, see pages 33-35 in the technical section.

Components P2REU

Description	No. Req'd	BTM No.
P2REU x 1.50 (38.1mm) Body	1	013136
P2REU x 2.25 (57.2mm) Body	1	013077
Piston	1	000117
Piston Seal	2	000058
Link	1	000120
Link Pin	2	000124
Link Pin Retainer	2	000121
REU100 Ram	1	013117
R.H. Cover	1	000125
L.H. Cover	1	000126
Cover Screw	13	000129
Cover Nut	13	000078
Ram "O" Ring	1	000150
Grease Fitting	2	000050
Sealant	1	000273
Seal Kit	1	000800
Top Cushion	1	001271
Bottom Cushion	1	000591
Stroke Limiter	1	000828
Equalizing Air Cylinder	1	006157
Stop Adjust Rod	1	013079
Stop Adjust Collar	1	006162
Mount Block	1	006139
3/16 Dia. x 1/2 Roll Pin	1	013088
3/16 Dia. x 1 3/4 Roll Pin	1	013087
Ram Stop	1	013081

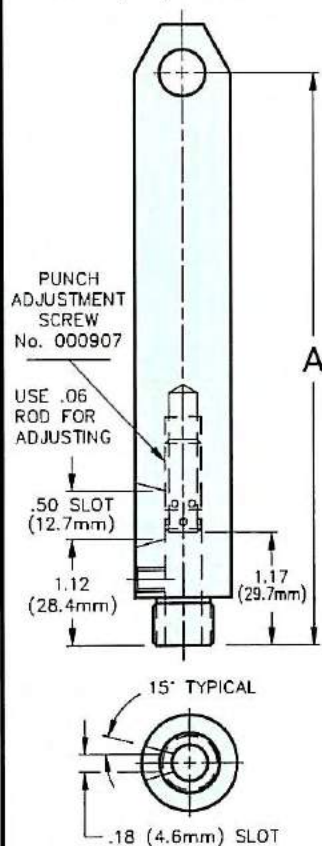
PT - 75
PT - 100



SEE PAGE 11 FOR PUNCHES AND STRIPPERS THAT CAN BE USED WITH THIS RAM
NOTE: A PUNCH LENGTH OF 2.50 (63.5mm) IS REQUIRED

PTA - 75
PTA - 100

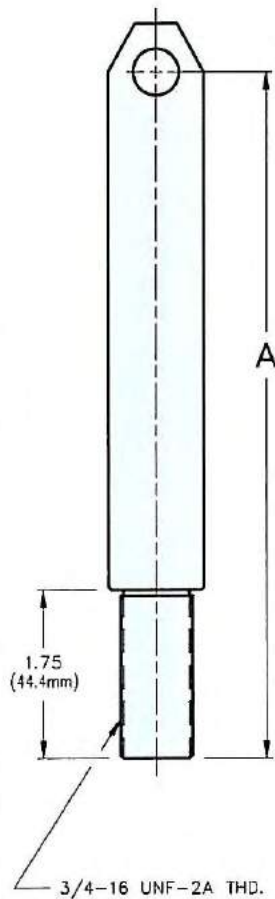
FOR $\pm .12$ (3mm) TOOL ADJUSTMENT



PTA RAMS ARE IDENTICAL TO PT RAMS EXCEPT AS SHOWN

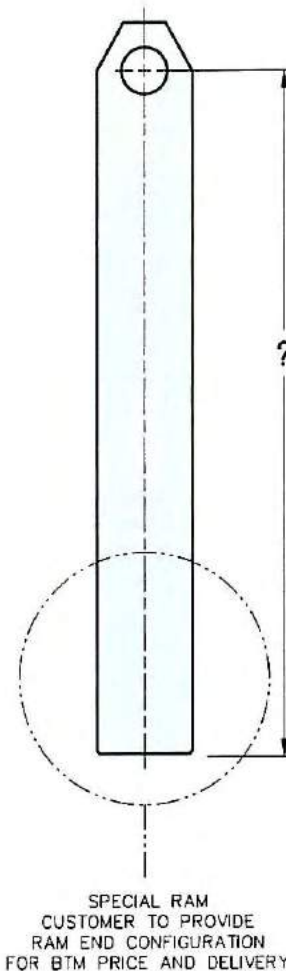
SEE PAGE 11 FOR PUNCHES AND STRIPPERS THAT CAN BE USED WITH THIS RAM
NOTE: A PUNCH LENGTH OF 2.25 (57.2mm) IS REQUIRED

TE - 75
TE - 100



USE WITH DIE SET ADAPTER PAGE 13

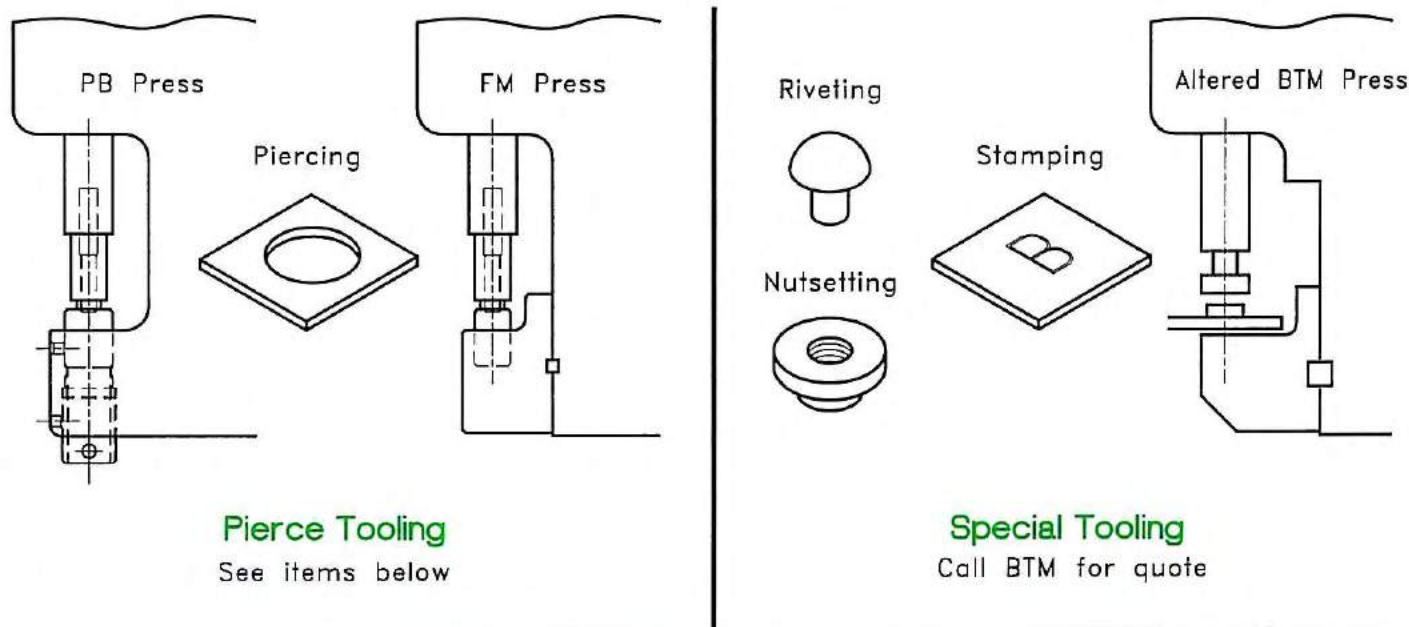
S - 75
S - 100



SPECIAL RAM CUSTOMER TO PROVIDE RAM END CONFIGURATION FOR BTM PRICE AND DELIVERY

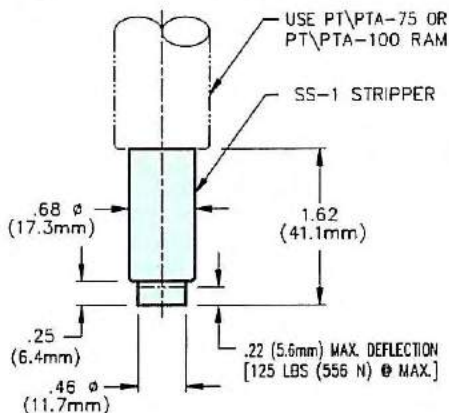
SERIES	PRESS MODEL	RAM STYLE	STROKE	A DIM.	BTM NO.
75 SERIES RAMS 1 TON PRESSES	PB PB6 FM H	PT	1.50 (38.1mm)	5.94 (150.9mm)	000130
			2.25 (57.2mm)	6.25 (158.8mm)	000131
		PTA	1.50 (38.1mm)	6.25 (158.8mm)	000904
			2.25 (57.2mm)	7.12 (180.8mm)	000144
		TE	1.50 (38.1mm)	7.88 (200.2mm)	000145
			2.25 (57.2mm)	PER CUSTOMER	TO BE ASSIGNED
100 SERIES RAMS 2 TON PRESSES	PB PB6	PT	1.50 (38.1mm)	5.94 (150.9mm)	000334
			2.25 (57.2mm)	6.25 (158.8mm)	000335
	FM H 2EU	PT	1.50 (38.1mm)	5.94 (150.9mm)	000133
			2.25 (57.2mm)	6.25 (158.8mm)	000134
		PTA	1.50 (38.1mm)	6.25 (158.8mm)	000905
			2.25 (57.2mm)	7.12 (180.8mm)	000146
	ALL	TE	1.50 (38.1mm)	7.88 (200.2mm)	000147
			2.25 (57.2mm)	PER CUSTOMER	TO BE ASSIGNED
		S	1.50 (38.1mm)	PER CUSTOMER	TO BE ASSIGNED
			2.25 (57.2mm)	PER CUSTOMER	TO BE ASSIGNED

Examples of Tooling Set-Ups

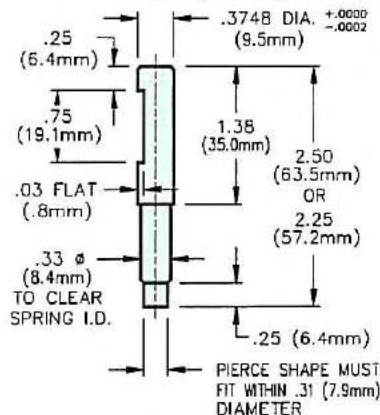


Standard Strippers, Punches and Dies

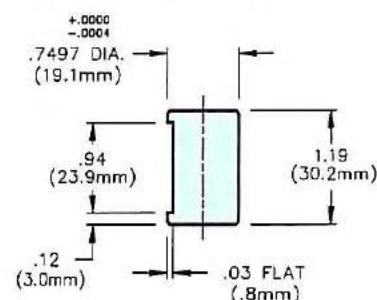
SS-1 STRIPPER
BTM ASS'Y NO. 000157



SS-1 PIERCE PUNCH
BTM No. 013137 (2.50 LG.)
013729 (2.25 LG.)

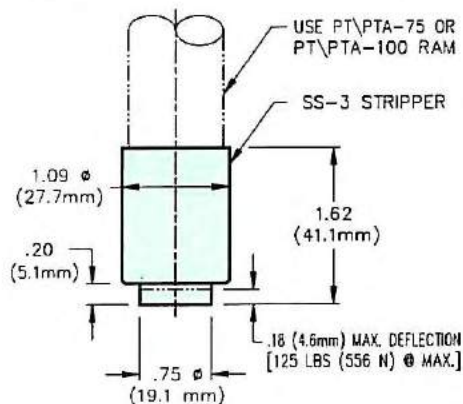


1 TON PIERCE DIE
BTM NO.013138

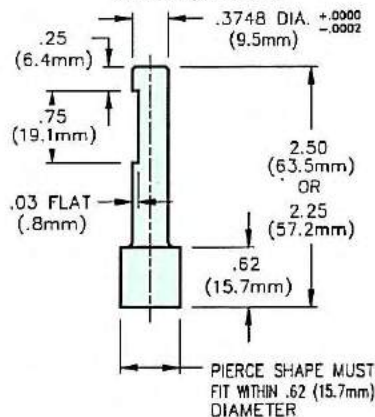


Matched Punch & Die Sets - Fax Pierce
Punch Shape For Quote To Punch Tech, Inc.
(Division of BTM) Fax: 810-364-6030

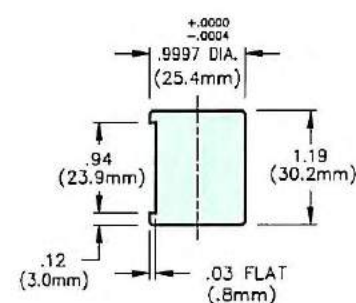
SS-3 STRIPPER
BTM ASS'Y NO. 000168



SS-3 PIERCE PUNCH
BTM No. 013139 (2.50 LG.)
013730 (2.25 LG.)



2 TON PIERCE DIE
BTM No. 013140



Matched Punch & Die Sets - Fax Pierce
Punch Shape For Quote To Punch Tech, Inc.
(Division of BTM) Fax: 810-364-6030

B and T Models

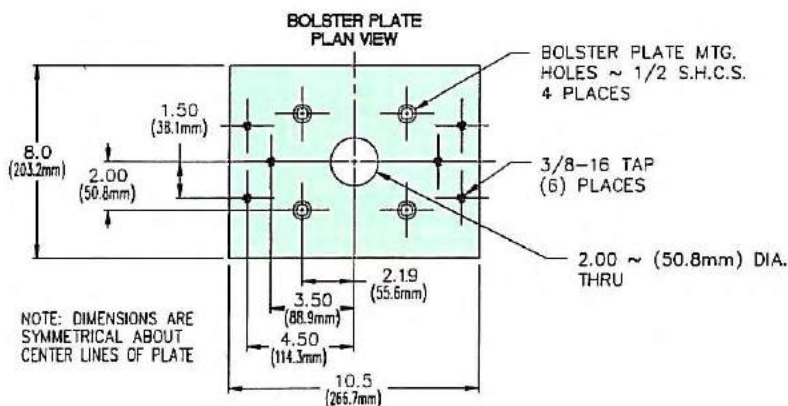
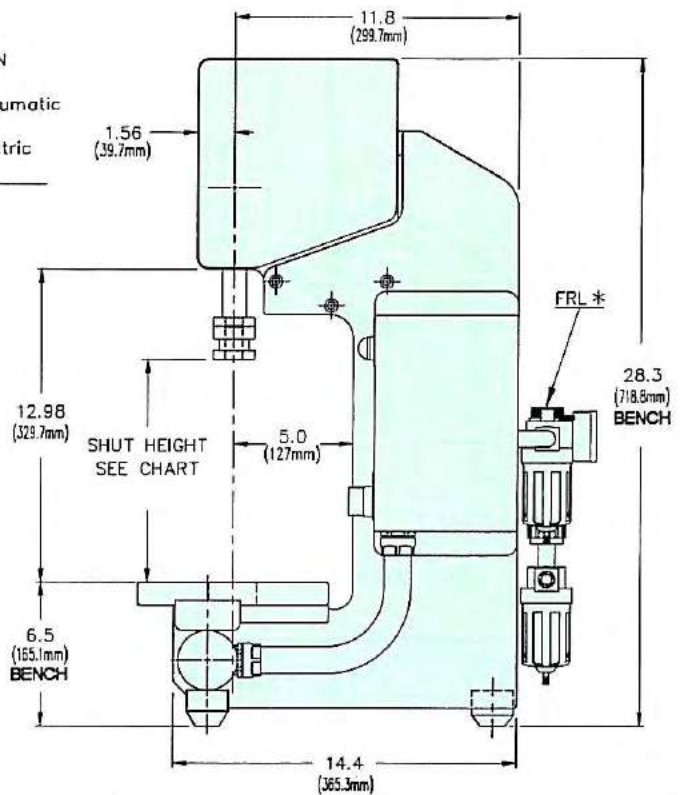
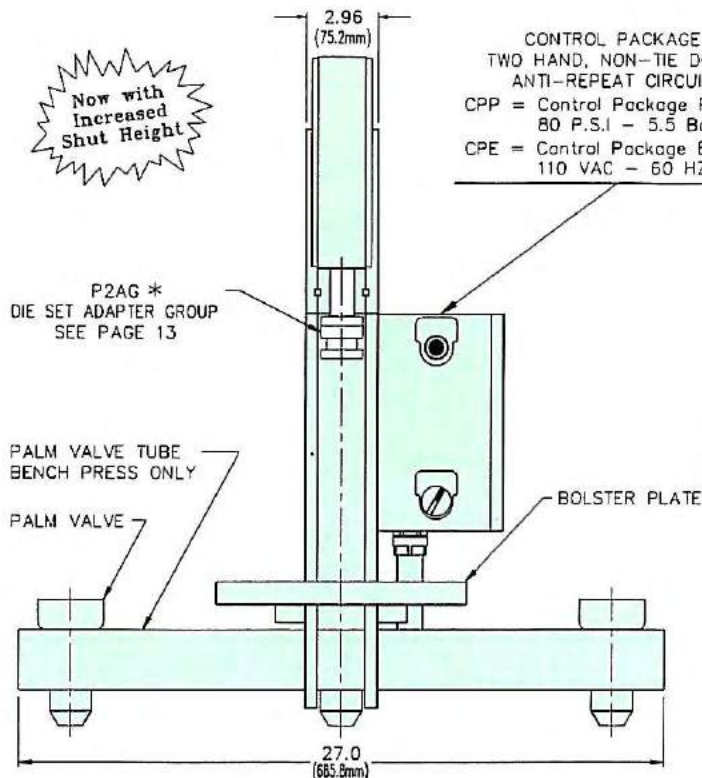
(Bench and Tooling)

P2B x 1.50 (38.1mm) Stroke 000842 - 100 lbs. (45 kg)

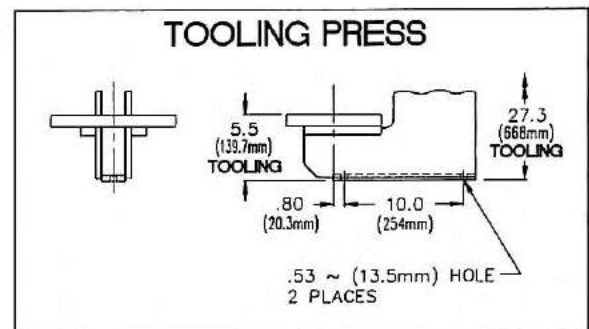
P2B x 2.25 (57.2mm) Stroke 000843 - 100 lbs. (45 kg)

P2T x 1.50 (38.1mm) Stroke 000844 - 100 lbs. (45 kg)

P2T x 2.25 (57.2mm) Stroke 000845 - 100 lbs. (45 kg)



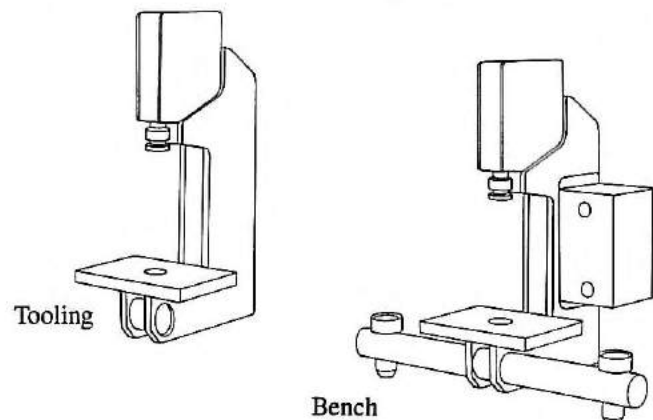
NOTE: DIMENSIONS ARE
SYMMETRICAL ABOUT
CENTER LINES OF PLATE



STROKE	SHUT HEIGHT
1.50 STROKE (38.1mm)	9.25 (235mm) MAX. 8.25 (209.5mm) MIN.
2.25 STROKE (57.2mm)	8.50 (216mm) MAX. 7.50 (190.5mm) MIN.

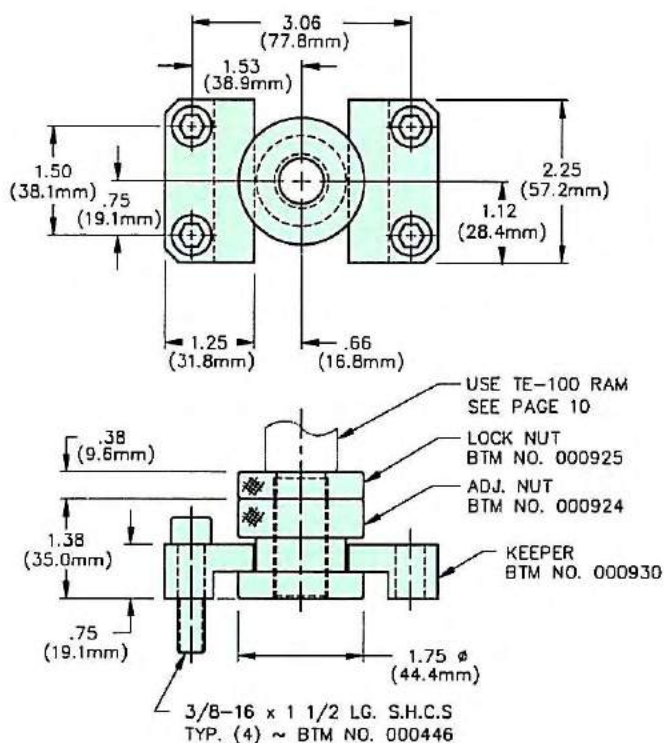
How to Order Presses										
6	P2B x 2.25	TE-100	DSAG	BC	TC	CPP	EPRL	EPRL	FRL	TOOLING
Quantity	Model	Stroke 1.50, 2.25 or Special	Ram Style See Page 10	Die Set Adapter See Page 13	Bottom Cushion	Top Cushion	Control Package Specials Available	Proximity Switches See Page 28	Filter, Regulator Lubricator	Consider Tooling See Page 11

* Denotes Options

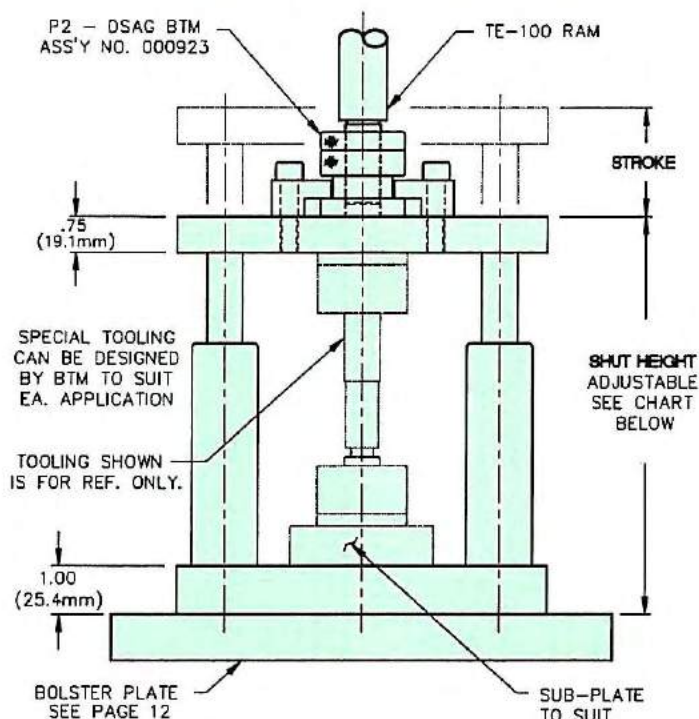


P2 - DSAG

(DIE SET ADAPTER GROUP)
BTM ASS'Y NO. 000923
(USED TO ADJUST SHUT HEIGHT)



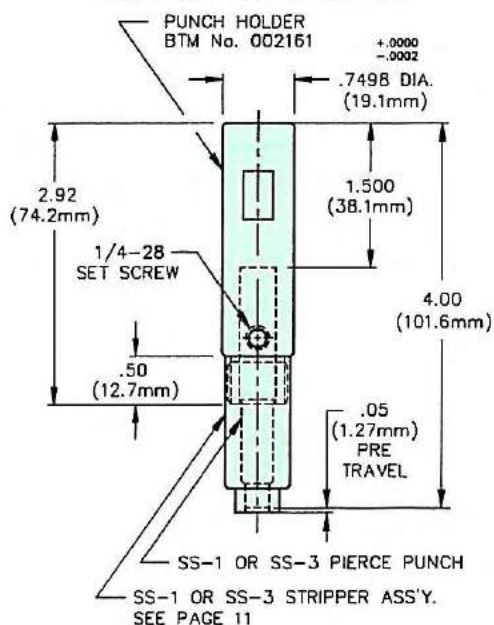
DIE SET INFORMATION



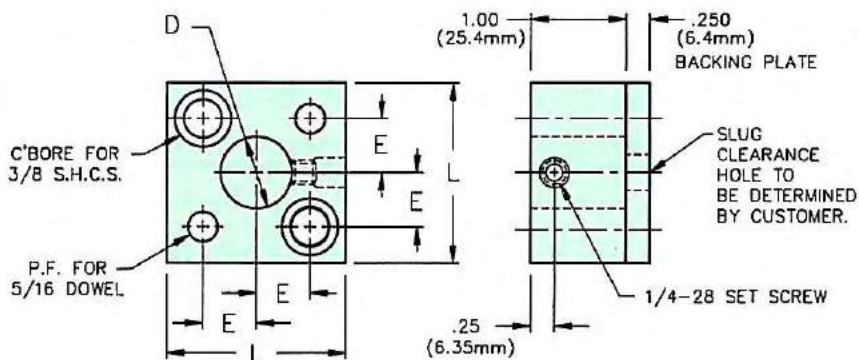
STROKE	SHUT HEIGHT
1.50 STROKE (38.1mm)	9.25 (235mm) MAX. 8.25 (209.5mm) MIN.
2.25 STROKE (57.2mm)	8.50 (216mm) MAX. 7.50 (190.5mm) MIN.

PUNCH HOLDER ASS'Y.

BTM No. 013426 W/SS-1
BTM No. 013427 W/SS-3
BALL LOCK RETAINERS AVAILABLE



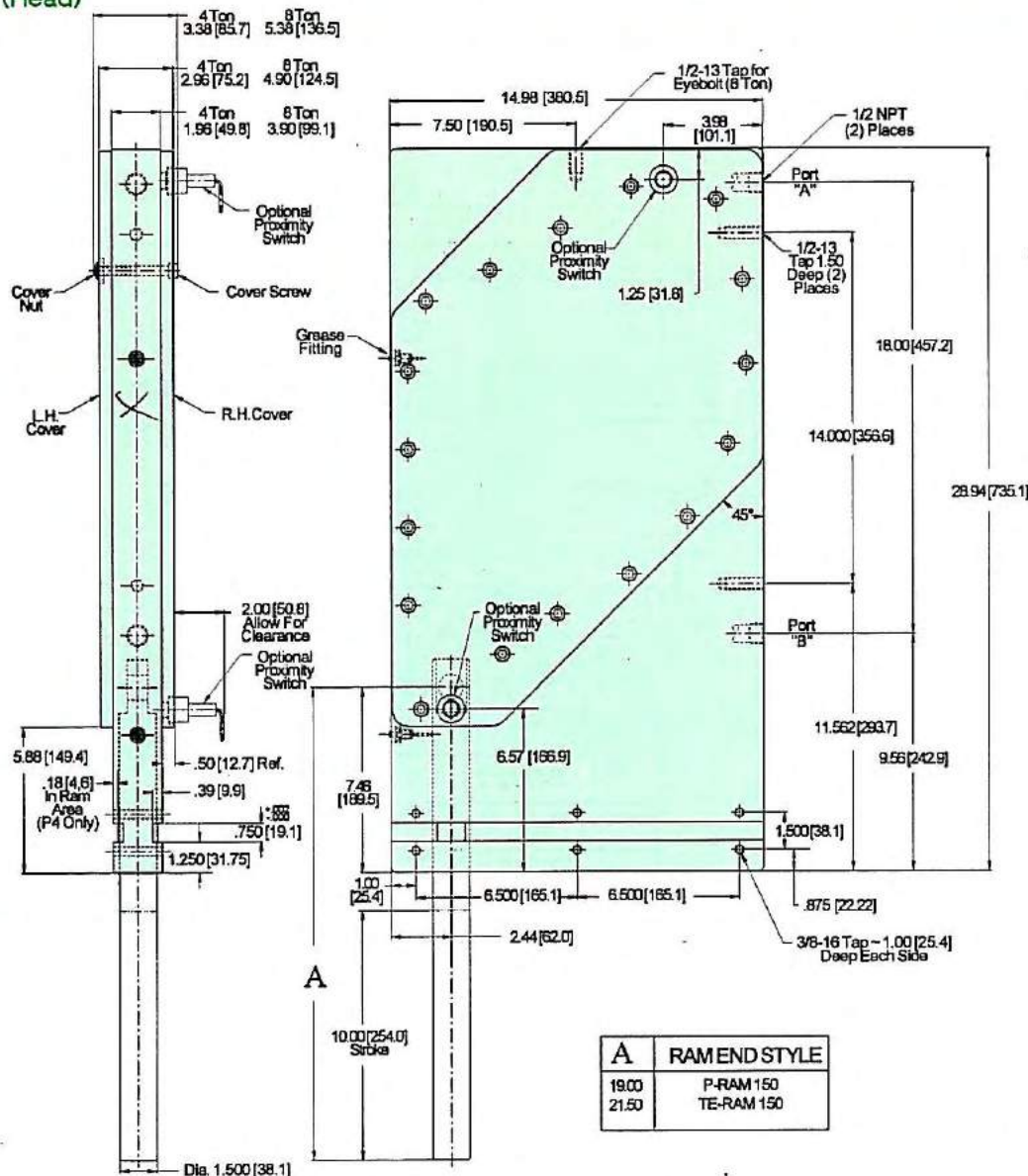
RETAINER ASSEMBLY (RETAINER AND BACKING PLATE) BALL LOCK RETAINERS AVAILABLE



BTM No.	D DIA. +.0003 -.0000	L	E ±.0005
013142	.7499 (19.1mm)	1.88 (47.8mm)	.5625 (14.2mm)
013143	.9999 (25.4mm)	2.25 (57.2mm)	.7500 (19.1mm)

Punch Holder Assembly and Retainers may be used in any size press
See "DIE SET INFORMATION" above for example.

H Models **P4H x 10" Stroke ~BTM No. 000440 - 104 lbs. (47 Kg.)** **P8H x 10" Stroke ~BTM No. 000454 - 180 lbs. (82 Kg.)**
(Head)



A	RAM END STYLE
19.00	P-RAM 150
21.50	TE-RAM 150

Force Exerted by Ram at Charted Distance from Bottom of Stroke

Distance from Bottom (inches)	Force (lbs.) P4	Air Consumption per single stroke (cu. in.) P4	Force (lbs.) P8	Air Consumption per single stroke (cu. in.) P8
0		RAM DOWN		RAM DOWN
0.01	48250	190	96500	380
0.02	20800	186	41600	372
0.03	12490	183	24980	366
0.04	10250	180	20500	360
0.06	8400	180	16800	360
0.12	6240	174	12480	348
0.24	4920	167	9840	334
0.50	4650	155	9300	310
0.75	3280	147	6560	294
1.00	2675	139	5350	278
1.25	2200	134	4400	268
1.50	2050	127	4100	254
1.75	1980	122	3930	244
2.00	1830	117	3660	234
2.25	1750	112	3500	224
2.50	1680	108	3360	216
3.00	1520	99	3040	198
3.50	1480	91	2960	182
4.00	1360	84	2720	168
4.50	1200	77	2400	154
5.00	1020	70	2040	140
6.00	950	57	1900	114
7.00	890	44	1780	88
8.00	840	31	1680	62
9.00	870	17	1740	34
10.00	890	RAM UP	1780	RAM UP

Components

P4H

Description	No. Req'd	BTM No.
P4H Body 10" Stroke	1	000441
Piston	1	000443
Piston Seal	2	000051
R.H. Link Plate	1	000444
L.H. Link Plate	1	000445
Link Pin	2	000264
Ram - 150 Series	1	See Pg. 15
R.H. Cover	1	000447
L.H. Cover	1	000448
Cover Screw	17	000268
Cover Nut	17	000270
Ram Wiper	1	000272
Ram "O" Ring	1	000271
Grease Fitting	2	000050
Sealant - Cover	1	000273
Top Cushion	1	004315
Bottom Cushion	1	000813

How to Order Presses

6	P4H x 10	P150	EPRL	EPEL	RL	SS-4	TOOLING
Quantity	Model	Stroke	Ram Style See Page 15	* Proximity Switches See Page 30	* Ram Latch See Page 21	* Strippers See Page 21	* Consider Tooling See Page 21

How to Order Components

2	P4 Piston	000443
Qty.	Description	BTM No.

* Denotes Options

Components

P8H

Description	No. Req'd	BTM No.
P8H Body 10" Stroke	1	000455
Piston	1	000457
Piston Seal	2	000060
R.H. Link Plate	1	000458
L.H. Link Plate	1	000459
Link Pin	2	000265
Ram - 150 Series	1	See Pg. 15
R.H. Cover	1	000447
L.H. Cover	1	000448
Cover Screw	17	000269
Cover Nut	17	000270
Ram Wiper	1	000272
Ram "O" Ring	1	000271
Grease Fitting	2	000050
Sealant - Cover	1	000273
Top Cushion	1	004316
Bottom Cushion	1	000813