Response form

Please return the questionaire by fax or as email attachment:

- **Fax: + 49 (0) 71 61/66-6 23**
- **Email: nicoline.leins@schulergroup.com**

If you have questions, we will be pleased to help you by phone. You can reach us at the following number:

- **Tel.: + 49 (0) 71 61/66-7 56**

Your inquriy will be processed promtly!

Questionnaire for sheet metal forming

1. Information about the inquirer and company

Last name, first name _____
Position _____
Company _____
Street address, P.O. Box _____
City, state, ZIP code _____
Country _____
Telephone _____
Telefax _____
eMail _____

Line of business

- ☐ OEM
- ☐ OEM supplier
- ☐ Tool & die manufacturer
- ☐ Household appliance industry
- ☐ Other _____

2. Which type of press are you interested in?

- ☐ Single press
- ☐ Tryout press
- ☐ Progressive die press
- ☐ Transfer press
- ☐ Press lines
- ☐ Other type of press: _____

3. Which part category should the new press or line be able to process?

- ☐ Smaller to medium-sized structural parts
- ☐ Support or larger structural parts
- ☐ Outer skin panels
- ☐ Other parts: _____

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4. Which materials do you plan to process?

☐ Steel - Re/Rm from/to: _____

☐ Aluminum

☐ Other materials: _____

5. What is the required production rate?

Parts per minute (not including doubles) _____ ppm

Number of changeovers _____ per hour

Number of die sets _____

6. What kind of die will be used?

☐ Single die

☐ Transfer/multi-station _____ % Station spacing: _____ mm

☐ Progressive die _____ %

☐ Blanking operations _____

7. Please provide the following technical specifications.

Press

Press capacity _____ kN

Nominal force travel (for mech. presses) _____ mm

Work energy (for mech. Presses) _____ kJ from _____ spm at _____ % Drop

Dies

Dimension of smallest die (l x w)		_____ mm	_____ mm	
Dimension of largest die (l x w)		_____ mm	_____ mm	
Die overall height from/to		_____ mm	_____ mm	
Part transport level from/to		_____ mm	_____ mm	
Drawing depth from/to		_____ mm	_____ mm	
Die weight total		_____ t		
Die weight, upper die		_____ t		
Die clamping method		_____		
Number of upper die clamps per station		_____ Qty.		
Number of lower die clamps per station		_____ Qty.		
Clamping flange height of die clamps	from	_____ mm to	_____ mm	

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Press bed

Bed dimensions (l x w)	_____	mm	_____	mm
Bed height above floor	_____	mm		

Slide

Slide dimensions	_____	mm	_____	mm
Slide stroke	_____	mm		
Slide adjustment (mech. presses)	☐ yes	☐ no		
Slide locking	☐ in TDC		☐ in increments	
Slide adjustment (mech. presses)	_____	mm		
Slide cushion	☐ pneumatic		☐ hydraulic	
Slide-side ejectors	_____	number	_____	force(s)
Number of ejector pins	_____	x	_____	
Opening betw. uprights in part flow direction	_____	mm		
Opening betw. uprights at right angle to flow direction	_____	mm		

Bed drawing cushions

Drawing cushions (number)	☐ yes	☐ no	_____	Qty.
Spacing between outside pressure pins	_____	mm	_____	mm
Drawing cushion force	_____	kN		
Drawing cushion travel	_____	mm		
Pre-acceleration	☐ yes	☐ no		
Return stroke in BDC	☐ yes	☐ no		
Pick-up position	☐ yes	☐ no		
Hydraulic dampening	☐ yes	☐ no		
Pad function	☐ yes	☐ no		
Pressure pins in scope of delivery	☐ yes	☐ no		
Drawing cushion type	☐ pneumatic		☐ hydraulic	
Impact shock dampening	☐ yes	☐ no		

8. How should material feeding and component transport be performed?

for single presses

- ☐ Manual feeding
- ☐ Coil line
- ☐ Destacker/blankloader

for transfer presses

- ☐ Coil line, blanking in the first station, transfer
- ☐ Coil line and progressive die technology
- ☐ Destacker/blankloader and transfer
- ☐ Blank washer
- ☐ Blank lubrication unit
- ☐ Other type of blank feeding: _____

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for press lines

- ☐ Destacker/blankloader
- ☐ Blank washer
- ☐ Blank lubrication unit
- ☐ Preferred component transfer: _____
- ☐ Finished part stacking

9. How is scrap removal to be performed?

- ☐ Out of the die by means of scrap chutes left and right
- ☐ Out of the die by means of scrap chutes front and rear
- ☐ Through the interior of the die / through the press bed

Number of scrap chute covers _____ Qty.

Number of scrap opnings per bed _____ Qty.

10. How is die change to be performed?

- ☐ left/right ☐ front/rear
- ☐ Die change frames
- ☐ Die change carts
- ☐ Moving bolsters ☐ T-Track ☐ L-Track

Number of moving bolsters _____ Qty.

Energy supply ☐ open duct ☐ hinged covers ☐ moving cable carrier required

☐ without energy supply

11. Details about the installation site.

Maximum height under hook _____ mm

Proposed foundation depth or existing foundation _____

Type of vibration-dampening elements _____

Are foundation plates to be supplied? ☐ yes ☐ no

May rails be installed on floor? ☐ yes ☐ no

May cable ducts be installed on floor? ☐ yes ☐ no

Other limitations or restrictions? _____

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12. What are the environmental conditions at the installation site?

- ☐ High temperatures above 40° C (104° F)
- ☐ Extreme temperature variations of more than 25° C (approx. 45 ° F)
- ☐ Extreme amount of dirt particles in the air
- ☐ Other: _____

13. What equipment are you considering at the present time?

☐ Hydraulic single press	max. capacity	____	max. clamping area	____
☐ Hydraulic press line(s)	max. capacity	____	max. clamping area	____
☐ Hydraulic transfer press	max. capacity	____	max. clamping area	____
☐ Combination hydraulic and mechanical presses in one line	max. capacity	____	max. clamping area	____
☐ Mechanical press line(s)	max. capacity	____	max. clamping area	____
☐ Suction cup presses	max. capacity	____	max. clamping area	____
☐ Mech. transfer press(es) with eccentric drive	max. capacity	____	max. clamping area	____
☐ Mech. Transfer press(es) with link drive	max. capacity	____	max. clamping area	____
☐ Mech. progressive die press(es) with eccentric drive	max. capacity	____	max. clamping area	____
☐ Mech. progressive die press(es) with link drive	max. capacity	____	max. clamping area	____
☐ Other: _____	max. capacity	____	max. clamping area	____

14. Please enter any additional information that might be useful for quotation preparation: