

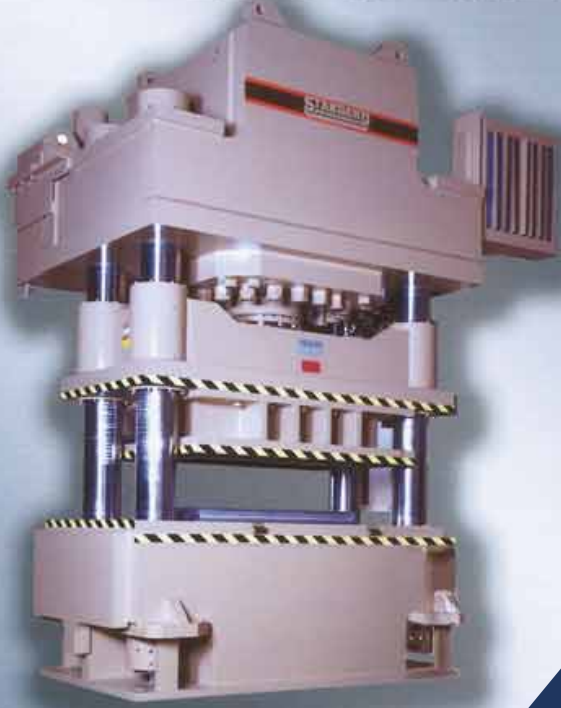


# STANDARD

INDUSTRIAL CORP



**100% MADE IN THE U.S.A.**



# AHB

TOOLING & MACHINERY, INC.

COMPLETE METALWORKING SOLUTIONS

(800) 991-4225

[www.ahbinc.com](http://www.ahbinc.com)

ISO Certified

[customerservice@ahbinc.com](mailto:customerservice@ahbinc.com)



**5 YEAR  
WARRANTY**

# PRESSES



## A U. S. Manufacturer

Thank you for this opportunity to offer our machinery. Standard Industrial offers a complete line of 100% U. S. made Four Column, C-Frame and Straight Side presses for traditional and non-traditional production facilities. The management/owner team of Standard Industrial has been manufacturing hydraulic press brakes, presses and shears since 1967 and has thousands of machines in service all over the world.

Standard Industrial is one of the last true U. S. machine manufacturers and we feel it is our honor and privilege to provide all of our customers with a quality built, dependable, precision machine that will make you proud to say that you "Bought American." We stand behind our machines with the best 5-year warranty available on the market today. Our unmatched 5 Year warranty covers all hydraulic and electric components, plus all bearings and assemblies and the structural integrity of the press for 5 years. This warranty is a firm testament to the dependability of all Standard Industrial equipment.

Coupled with the warranty is a machine of unmatched rigidity. The typical Standard Industrial machine dominates a press room floor with its sheer size and obvious strength. We welcome comparisons by any other manufacturer and are happy to put all of our claims in writing and back them up with over thirty years of customer references.

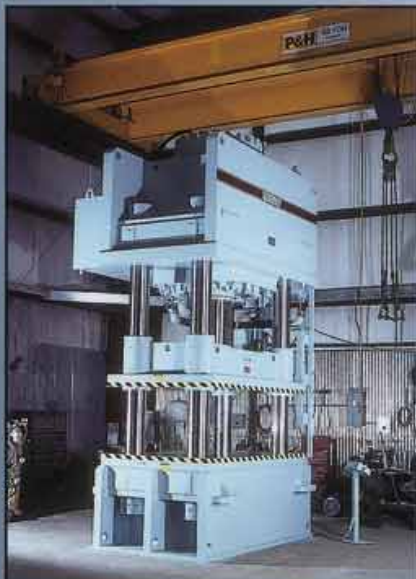
Even beyond our substantial warranty, all components on the press will be available to you locally for a lifetime supply of parts. Standard Industrial goes to great lengths to engineer all machines with "non-special" components. This means that in 20 to 30 years or longer you can simply refer to your owners manual or the component itself, find that components original manufacturers part number, call your local supplier and get the part you need. Unlike most press manufacturers who force their customers to buy special made, overpriced components only from them, we give our customers a choice to buy locally or from us here at the factory. This means you are back in business in hours instead of days or weeks as is the case with most imported and even some domestic manufacturers. There is no such thing as an "orphan" Standard Industrial machine because you will always be able to find parts anywhere in the USA and the world.



This literature is an excellent tool to show how four different style of presses can best match your requirements. Each type of press is individually suited for certain applications and die set-up and should be adhered to. Please also feel free to contact us here at the factory and talk directly to the people who manufacture these machines. We also would like to invite you here to our facility in Clarksdale, MS so we can show you first hand how our machines are made.

- ✓ 100% Made In The U. S. A
- ✓ Unmatched Rigidity And Dependability
  - ✓ 5 Year Parts and Limited Labor Warranty
  - ✓ A Lifetime Of Readily Available Components

## Standard Industrial Corporation



Model AP1000 Four Column Press with optional color



Model AM300-10 Straight Side Press

# 100% MADE IN THE U.S.A.

## Press Application

As with all manufacturers, each style of Standard Industrial press has a particular strength or attribute that makes it more acceptable for a particular application. To a certain degree all of our styles of presses can perform similar applications, but it is very important to identify what your particular application is before you buy. For example, the model AM straight side presses are typically used by customers who require a varying amount of tonnage across the bed of the press. Progressive die set ups are perfect for straight side presses due to the single cylinder hydra-mechanical drive system that generates full tonnage all the way across the bed. In one die you may have a light forming operation, then next die may require heavy punching and the next may have a guillotine shearing action. With a Standard Industrial straight side press it doesn't matter where the tonnage occurs along the bed as long as the overall tonnage requirement does not exceed the machines overall tonnage. The AM series is also used in virtually every other pressing type application as well.

On the contrary a model AP four column press is designed for center load applications and/or applications that require little variation of tonnage across the bed and ram. Four columns are especially good for long stroke and deep draw applications where the ram must travel a considerable distance to complete an operation and then retract out of the way.

The model DCSS style is a more compact version of the straight side press providing a staggering amount of rigidity due to the enclosed end-frames and compact bed sizes. Even with enclosed end frames the DCSS can allow material flow through with windows in the end frames. The DCSS is excellent for all types of press applications including center and off-center loading.

The model DC C-frame style press is a gap frame press which lends itself to a wide variety of forming applications as well. It is particularly good for applications where the workpiece is larger than the bed and/or the material needs to be fed from the left or right. All four styles of machines and their strengths are explained in more detail in this literature.

## Standard Press Operation

Standard Industrial offers an incredibly simple and easy to operate base machine. We believe in starting with a good solid foundation and building from there by adding features based on the customers needs. We offer a wide variety of options and features that will provide each customer with their particular level of sophistication, while providing an uncomplicated base machine as the power plant. This simplicity drastically cuts down on your troubleshooting efforts by being able to operate the base machine independent of an add-on type of control.

All 4 types of presses use the same base functions to operate. All machines typically have the controls on the right hand side located on a main control panel. Each machine will also come with (2) anti-tie down buttons to actuate the machine. There is also an emergency stop button and a "normal-inch" switch. This switch controls the ram and allows it to return to the upper limit in "normal" mode when the buttons are released or in "inch" mode the ram stays in the exact position you want when the buttons are released.

The machine's (3) limits are controlled through a very simple limit switch assembly that controls the upper limit (top of stroke), the speed change point and the lower limit (bottom of stroke). In order to develop full tonnage and provide precision results it is necessary to set the speed change point or "pressing" speed limit so the ram slows down before it strikes the material. More sophisticated programmable features can be added to control all the base functions of the press, but you will always have this simple, precision mechanical back-up in case of computer failure. This assembly is particularly favorable in heavy forming and punching applications when the machine is under an atypical "shock" condition such as heavy punching and bottoming.

The main control panel includes an on-off switch for the main motor, and a timer (for duration) for the decompression system which is necessary during bottoming applications. All presses also come standard with a counterbalance valve that allows you to punch or blank to up to 2/3 of the machines overall tonnage for the model DC, DCSS and AM and 1/2 of the machines overall tonnage for the model AP. All presses come standard with a hydraulic pressure tonnage control to allow you to vary your pressure. Each style of press comes standard with many features as well as a wide variety of optional features.



Any size facility can benefit from a Standard Industrial press from the price conscious smaller facility that does piece by piece work, up to the 3 shifts a day high volume manufacturers that require dependable, low maintenance machines with readily available components for minimal downtime.



# Model AP Four Column Press

Hydraulic system with continuous filtration

Massive welded frame

Large chromed columns

T-slots in bed and ram

Permanently mounted electric heaters for column maintenance

Oil Cooler

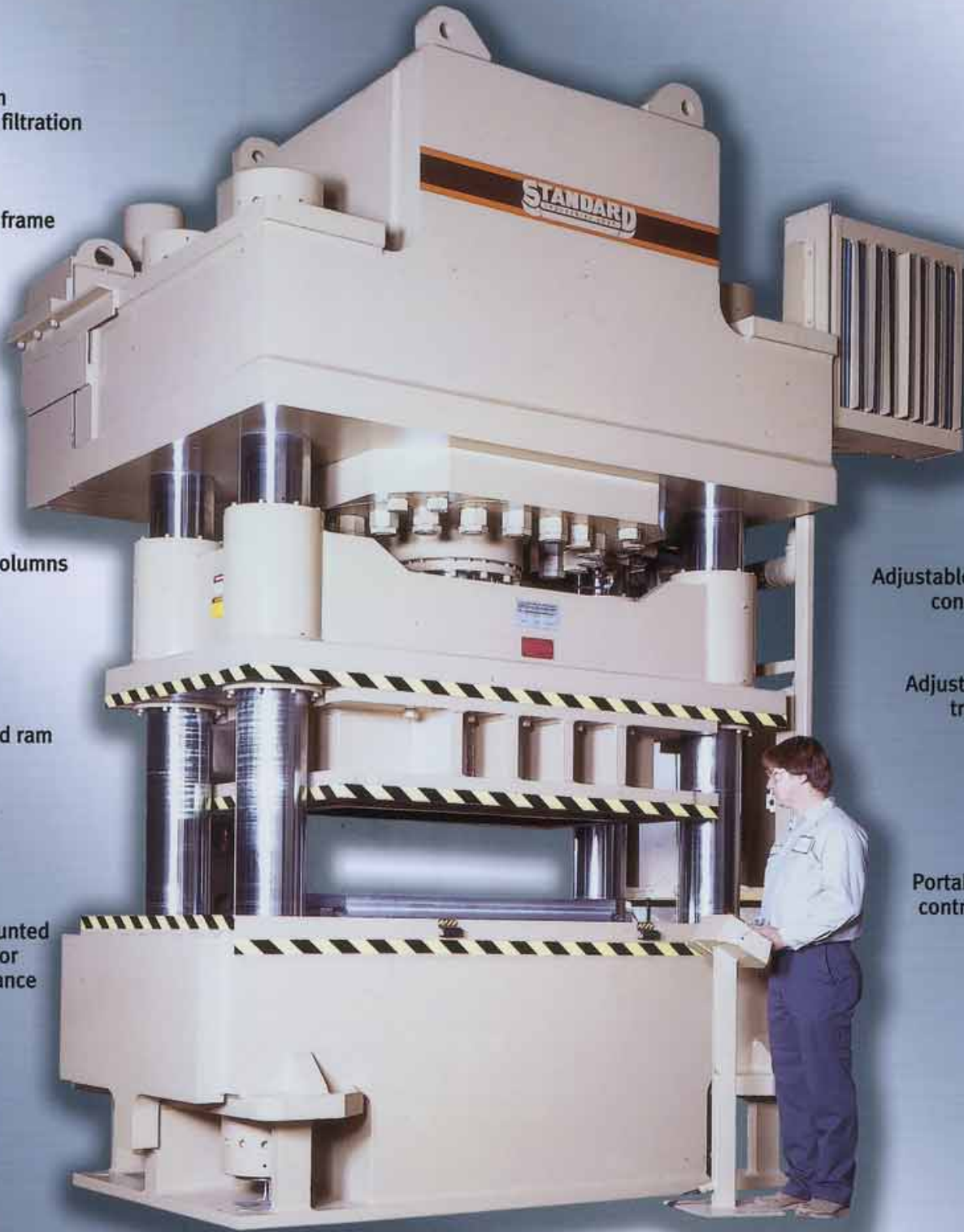
Adjustable shaft packing

Heavy guide bearings

Adjustable tonnage control

Adjustable ram travel

Portable 2 hand control station

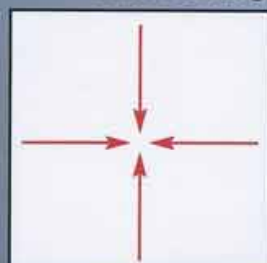


Model AP300  
(300 ton capacity)

Model AP1000 (1,000 ton) shown with optional rubber pad enclosure mounted under ram. All other features shown are standard equipment.

Loading Applications for the model  
AP Four Column Press

Center Loading



Even Tonnage across bed



OR



Model AP1000  
with optional color  
(1,000 ton capacity)

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Standard Industrial model AP Four column presses are manufactured for a variety of applications in metalworking and other fields. Four column presses are best utilized for center load applications and/or for evenly distributed tonnage applications like embossing and rubber pad forming. Off center loading applications can be done on four column presses, but they will require optional load balancing devices like stroke dampers or nitrogen cylinders.

Available from 100 to 1,000 tons the model AP four column press is available with a wide variety of options that will make it one of the most versatile presses on your floor.



Two AP300 Presses

## Applications for Model AP

- Embossing
- Drawing
- Stamping
- Die Try-out
- Sizing
- Rubber Pad Forming
- Forming
- Swedging
- Trimming
- Punching\*
- Blanking\*



Model AP with optional bolster/die rollout arms and rubber pad holder and paint color



All model AP presses are available with longer open height and stroke.

**\*Punching/Blanking**  
Due to the overall weight of the ram and the drive system, when punching or blanking with a four column press, you should limit your overall tonnage to 50% unless stroke dampers are used.



AP300 press with optional light curtains and interlocking side barriers & with special low bed height



Model AP600 press with optional die bolster rollout arms; light curtain safety systems and air actuated quick change die system located in t-slots rubber pad box and paint color



Two Twin AP1000 presses with optional color

The model AP Four column press is a vertical, down acting direct hydraulic press with a guided platen powered by an extremely heavy duty machine tool quality hydraulic cylinder. The precision machined platen is fitted with bearings made of A660 bronze and rides on 4 columns of turned, ground & polished chrome steel. The massive structure is fabricated from heavy sections of prime steel plate. This press is designed for heavy production work for all sizes of facilities. The self contained hydraulic system uses a hi-low circuit using directional valves for speed control. As with all Standard Industrial machines, the model AP comes with our unmatched 5 year warranty, plus T-slots in the bed and ram, a decompression system, overload protection and many more impressive standard features.

# Model DC C-Frame Press

Self contained hydraulic system with oil cooler and filter

Machine tool quality direct hydraulic cylinder.

Full length EIGHT way ram guides

Box type ram

T-slots in the bed and ram

Adjustable shaft packing

Two hand control station

Tonnage control

Completely adjustable open height, stroke and speed change point

A counterbalance valve for punching and a decompression system for bottoming applications are standard equipment on all Standard Industrial presses

Extremely heavy duty welded frames

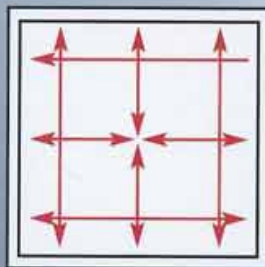
\*\*For Punching Or Blanking applications De-Rate The Overall Press Tonnage By 1/3

DC400 400 Ton C-Frame Press



Model DC400

Loading Applications for the Model DC C-Frame Press



Center/Off-Center/Front to Back and/or Left to Right loading



Special 200 ton C-frame style straightening press

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DC100 shown with optional scrap chute

## Model DC C-Frame Press

The model DC C-frame press is one of the most versatile presses we manufacture. It is designed to accept off-center and center loads as well as progressive die set ups for smaller bed applications. The DC is available in tonnages up to 600 tons and can be used for metalworking, plastics, fabrics and many other materials as well. Virtually any type of press application can be accomplished on a DC style press.

The model DC has an open gap frame and an extremely heavy duty box ram guided by 8 way gibbing.

This combination is the most effective way to guide the ram and provide the precision most facilities require.

The ram is powered by a very efficient hydraulic power plant utilizing low pressure (under 3,000 psi) to guarantee long life of the system. This system powers the single machine tool quality cylinder shaft made of turned ground and polished chrome.

The model DC comes with all the standard features listed on page 10 as well as our 5 year parts warranty and excellent service.



Cylinder Shaft for 600 ton C-frame



DC40 with special paint



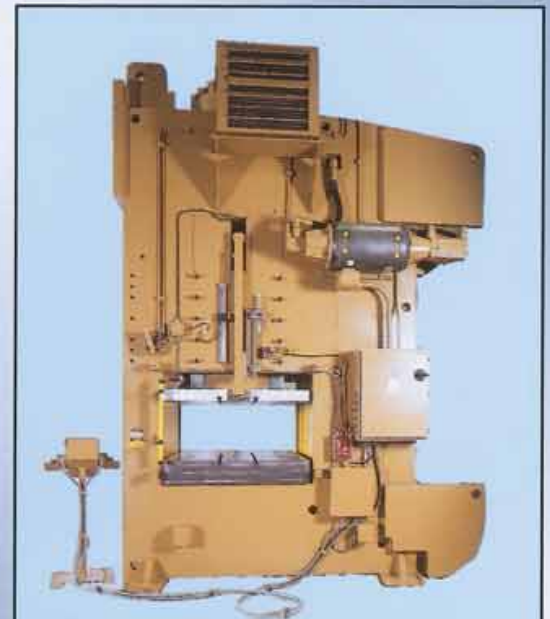
DC500 shown with optional paint and light curtains

## Model DCSS Straight Side Press



Model DCSS500

Built similarly to the DC style press, the DCSS takes yet another step toward providing the most frame strength available on any press on the market. The DCSS has enclosed end frames in lieu of the gap therefore allowing the least amount of deflection and the most rigidity. The operator can still however have material or die pass through with windows located in the end frames. Built with the same hydraulic system and solid welded construction as the DC, the DCSS gives you another layer of strength for even the most punishing applications. Typically the bed and ram would stay within the frames, but optionally you can order the DCSS with ram and/or bed extensions to extend beyond the frames to give you even more die area. The DCSS is also available up to 600 tons and is perfect for center load and off center loads left to right and/or front to back as well as virtually any other press application.



Model DCSS600 with optional light curtain

# Model DCSS Straight Side Press

Self contained hydraulic system with oil cooler and filter

Full length EIGHT way ram guides

Solid end frames to provide the most rigid design of any press

T-slots in the bed and ram

Windows for material and die pass through

Two hand control station

A counterbalance valve for punching and a decompression system for bottoming applications are standard equipment on all Standard Industrial presses

\*\*For Punching Or Blanking applications De-Rate The Overall Press Tonnage By 1/3

Machine tool quality direct hydraulic cylinder.

Box type ram

Adjustable shaft packing

Tonnage Control

Completely adjustable open height, stroke and speed change point

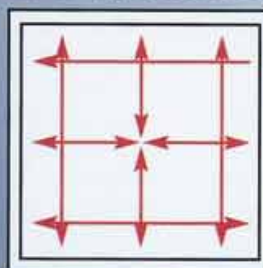
Extremely heavy duty welded frames

Model DCSS600 shown with optional light curtain and pneumatic die cushion air tank



Typical window for model DCSS, shown with air tank for die cushion and an automatic lubrication system

Loading Applications for the Model DCSS Straight Side Press



Center/Off-Center/Front to Back and/or Left to Right loading



Model DCSS500





## Model AM Straight Side Press



Model AM200-10

The model AM straight side press is a more traditional style of straight side with much more left to right bed and ram area. The AM is able to hold tolerance left to right much better than a direct hydraulic design due to its bellcrank linkage that gives the press full tonnage from one end of the press to the other.

This single cylinder design develops full tonnage anywhere along the bed left to right and front to back. The bellcrank linkage system is actuated with a single cylinder utilizing A660 bronze at the bearing points.

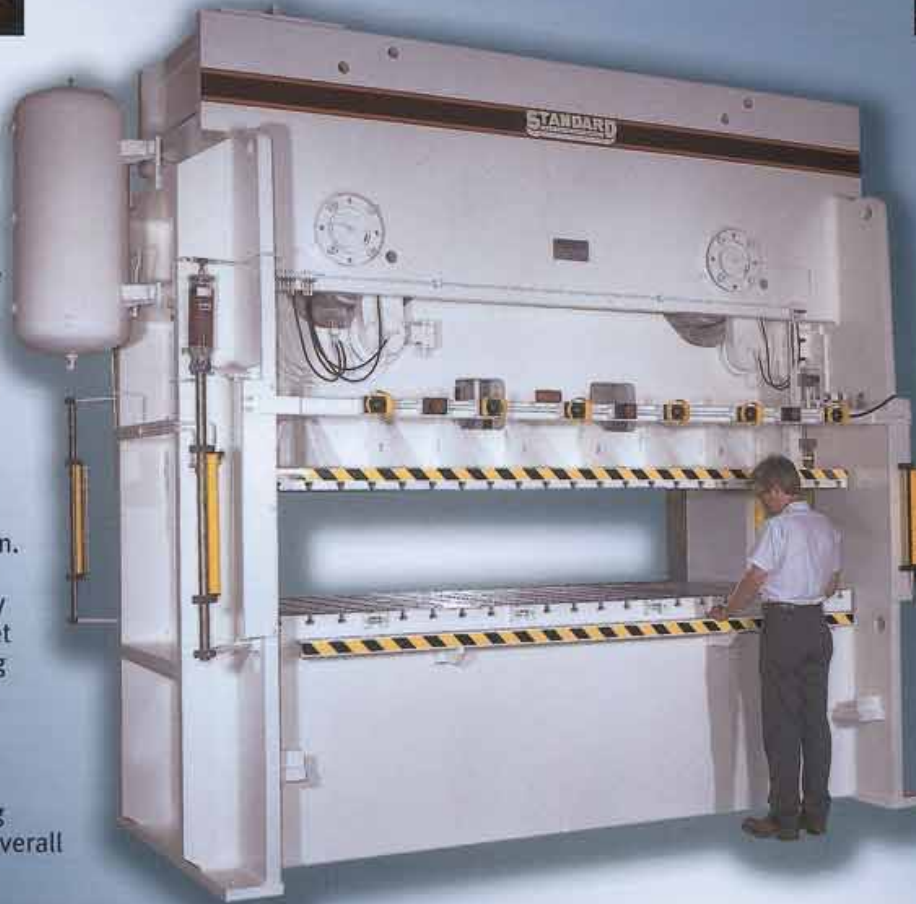


200 ton press in automated feed line & optional paint

These bearings are designed to withstand up to 6 times the machines overall tonnage and they are covered by our extensive 5 year parts warranty. The model AM is truly designed to accept virtually all forms of press applications whether it is punching, forming, blanking, coining, swedging, die tryout, trimming, drawing and so on.

The AM is available up to 600 tons and particularly excels at progressive die set ups where you have varying amounts of tonnage being applied across the bed all in the same stroke.

\*\*For Punching Or Blanking applications De-Rate The Overall Press Tonnage By 1/3



400 ton straight side press with optional light curtains, extra t-slots in the bed and ram, automatic lubrication system and air counterbalance system with air tank and optional white paint

Massive unitized welded frame

Extremely simple low pressure hydraulic system with cooler

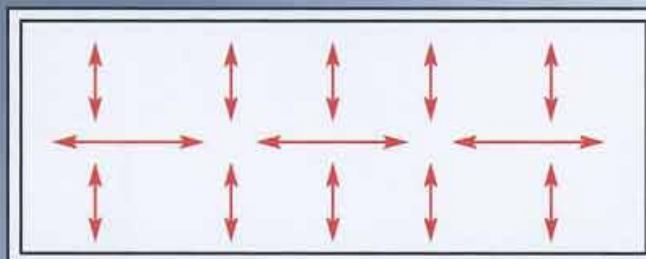
Ram mounted controls and/or pedestal controls are available

Enclosed end frames with windows for pass thru of material, dies, feeding equipment, etc.



Single cylinder bellcrank linkage system generates full tonnage all across the bed and ram.

### Loading Applications For the Model AM Straight Side Press



Center/Off-Center/Left to Right and or Front to Back Loading



Model AM500-10  
500 ton capacity x 10'



## Standard Features For Model AP, DC, DCSS and AM Presses

- 5 Year hydraulic and electric parts and limited labor warranty covering every standard component on the press (Optional PLC controls are subject to a two year warranty).
- 100% made in the USA
- (2) T-slots in the bed and (2) in the ram (more are available optionally)
- All parts on every Standard Industrial machine are available from your local suppliers and/or the factory
- Complete parts manual with all parts on machine listed as well as original manufacturers part number to provide you with easier part replacement
- Complete low pressure (under 3,000 p.s.i.) hydraulic systems with overload protection as well as fan/radiator type oil cooler, continuous filtration and manifold mounted valves to provide you with the least amount of tubing and hoses which mean less maintenance and downtime
- Electric disconnect with magnetic starter-Ready to accept power.
- A Decompression system with adjustable timer used to reduce shock at the end of each ram stroke during a bottoming operation
- Full tonnage throughout the stroke
- A Counterbalance system used to reduce shock to the system during punching applications and for safety to prevent ram free-fall
- Positive single cylinder drive designs for all model presses – Direct hydraulic for model AP, DC and DCSS and hydra-mechanical for model AM
- High speed approach, rapid return and low speed press limits controlled via a positive mechanical depth stop assembly, all fully adjustable (PLC controls available as an option)
- Shock-less quiet operation
- Lube fittings at all bearing points
- Pilot operated check valve to hold ram in position when ram is stationary
- Full power throughout stroke
- Anti tie down switches to actuate press
- All liquid tight electrical components
- Hydraulic pressure tonnage control to vary tonnage output
- Two hand control station mounted on a portable pedestal for model AP and AM and at the operator station for the model DC and DCSS. Optionally available in varying and multiple locations per your application.
- Incredibly simple and versatile hydraulic and electric controls



All presses come standard with a mechanical depth stop and tonnage control



DC500 w/ optional support  
Tie rods and paint colors



Base model AP600

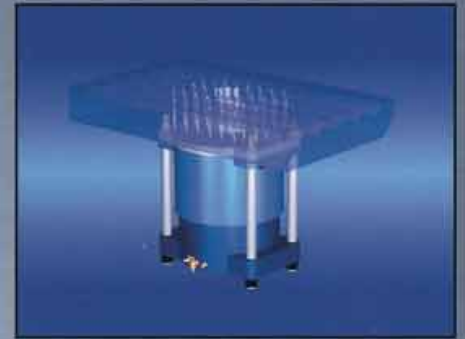


Precision machining & attention to detail are standard on all presses



## Available Options for Model AP, DC, DCSS and AM

- ◆ Programmable logic controller (PLC) to control the base functions of the press including multiple job storage, stroke length, open height, speed change point, tonnage, decompression, ram delay/dwell at bottom of stroke (not under tonnage) and pressure ram reversal. A mechanical depth stop is standard to control limits of the press and is also included even with PLC.
- ◆ Light curtain safety barrier system provides infra-red beam during operation and shuts machine down if penetrated to protect operator. Base optional light curtain covers front of press only – other optional curtains can be quoted per customer specification.
- ◆ Dwell under tonnage sustains desired tonnage for a set amount of time – typically used for manufacturers of plastics or fiberglass products
- ◆ Interlocking side barriers as physical barriers – can be used in conjunction with light curtains or alone
- ◆ Special single color paint
- ◆ Custom or special controls per user specifications
- ◆ Remote auto cycle for automated operations
- ◆ Special machining of bed and/or ram
- ◆ Removable bolster plates for bed
- ◆ Die cushions for drawing and/or part ejection
- ◆ Ejector cylinders for drops or parts
- ◆ Scrap chutes or knockouts to remove drops or parts
- ◆ Stroke dampers for punching or blanking operations allow more punching or blanking tonnage on a press – Dampers take up bed and ram area and may cause overall dimensions to increase
- ◆ Quick change tooling components such as air actuated die lifters and/or power die removal systems – increase productivity by decreasing die change and set-up time
- ◆ High speed or special hydraulic systems
- ◆ T-slots in bed and ram (2 are standard in bed and ram)
- ◆ Automatic lubrication systems to decrease maintenance operations
- ◆ Safety gear lock systems with interlocking posts provide even more operator safety (Model AP only)
- ◆ Additional open height (NOTE: Does not automatically increase stroke length)
- ◆ Additional stroke for model AP four column press (NOTE: Does not automatically increase open height)
- ◆ Low speed retract allows the ram to return slower than normal
- ◆ Pressure ram reversal allows the ram to return when a particular pressure is achieved.
- ◆ Ram delay at bottom of stroke (not under tonnage)
- ◆ Coil line processing and material feeding equipment
- ◆ Custom and standard die sets
- ◆ The model AM, DC and DCSS can have longer open heights but are limited to a maximum of 12" stroke as an option
- ◆ The model AM is available in longer lengths but not shorter lengths



Typical Dayton die cushion mounted under press bed



W-Technologies stroke dampers allow more punching and blanking capacity without harming hydraulic system



DC150 C-frame presses with optional PRE brand material feeding system



Model AP100 with optional light curtains and physical barriers



Model AP300 with optional light curtain safety barrier



## The Standard Industrial 5 Year Warranty

As part of the purchase of a new Standard Industrial machine, a 5 year limited warranty will be included. The warranty begins at the point of initial shipment and will not automatically be passed along to second owners. The decision to repair or replace any part will be made by Standard Industrial management only. On all simple warranty repairs, Standard Industrial will provide instruction and parts (fob Clarksdale, MS). The customer or dealer involved will be invoiced for any replaced components and credit will be issued upon return of the defective component to Standard Industrial Corp.

**The Five Year Warranty Covers The Following:** Main hydraulic cylinder and seals • Drive components • Shafts • Bearings • Motors • Pumps • Valves • Backgauge components manufactured by Standard Industrial (not PLC components) • Structural integrity of non-removable parts of the machine • Hold down cylinders and seals • Fittings

**Labor:** Labor to repair structural integrity problems of non-removable parts which fail during the 5 year warranty may be furnished at the customers plant in the continental U.S. This labor is supplied at no charge only if Standard Industrial is in agreement that the problem is not due to improper use of the machine or wrongful tampering with the machine by customer or dealer. Labor to assist our service rep. and/or necessary services are to be furnished by the customer at no cost to Standard Industrial. Any approved warranty labor of removable components or the complete machine will be supplied and performed at the Standard Industrial factory. The user is responsible for all freight to and from the factory. Turn around time of the repair is dependant upon current backlog.

**The Warranty Does Not Include The Following:** Shear blades • Dies • Die Holder and accessories • Die compensators • Die cushions • Computer controls such as CNC or PLC control for the ram, backgauges or frontgauges or any other computer controlled device • Shear sheet support systems, conveyors, stackers • Or any other purchased accessory items that are not part of the base machine, these items are only subject to their manufacturers warranty.

The 5 year warranty excludes any damages caused by rigging, transportation, and incorrect use or modification by customer or dealer. The user must abide by the maintenance information provided in the service manual that is included with each machine. Maintenance items such as lubrication, bolt tightening, proper leveling of the machine and all other specified actions in the service manual must be adhered to in order for the 5 year warranty to be honored. Second users may be subject to the remainder of the 5 year warranty if they pay for full inspection of the machine by a Standard Industrial rep (contact us for details).

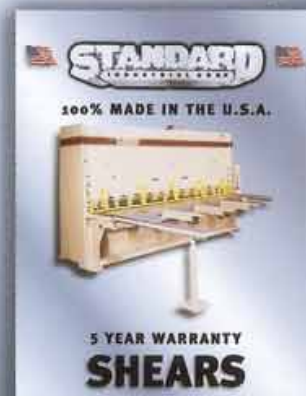
This equipment is manufactured and intended to operate as a component of a complete operating system. The complete system is to include the feeding equipment and/or guards or devices to protect all persons in the vicinity including the operators, depending on the work to be performed. The complete system is the sole responsibility of the owner/operator. The warranty is exclusive and may not be modified by verbal agreement. Other than those representations made expressly in this warranty, we exclude and disclaim all implied warranties of fitness for a particular purpose, and any other implied warranties.

### Also available from Standard Industrial –

Please contact us today for information and catalogs on our 100% U.S. made press brakes and shears.

#### Model AB Brakes

- Press brakes up to 1,000 tons
- Full tonnage across bed and ram
- From base machines up to 6 axis CNC control
- Heaviest, most dependable machines on the market



#### Model AS Shears

- Shears from 1/4" to 1 1/4" capacities
- 100% Guillotine drive system
- 36" travel PLC controlled backgauge
- 80,000 PSI steel capacity

## Standard Industrial Corporation

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