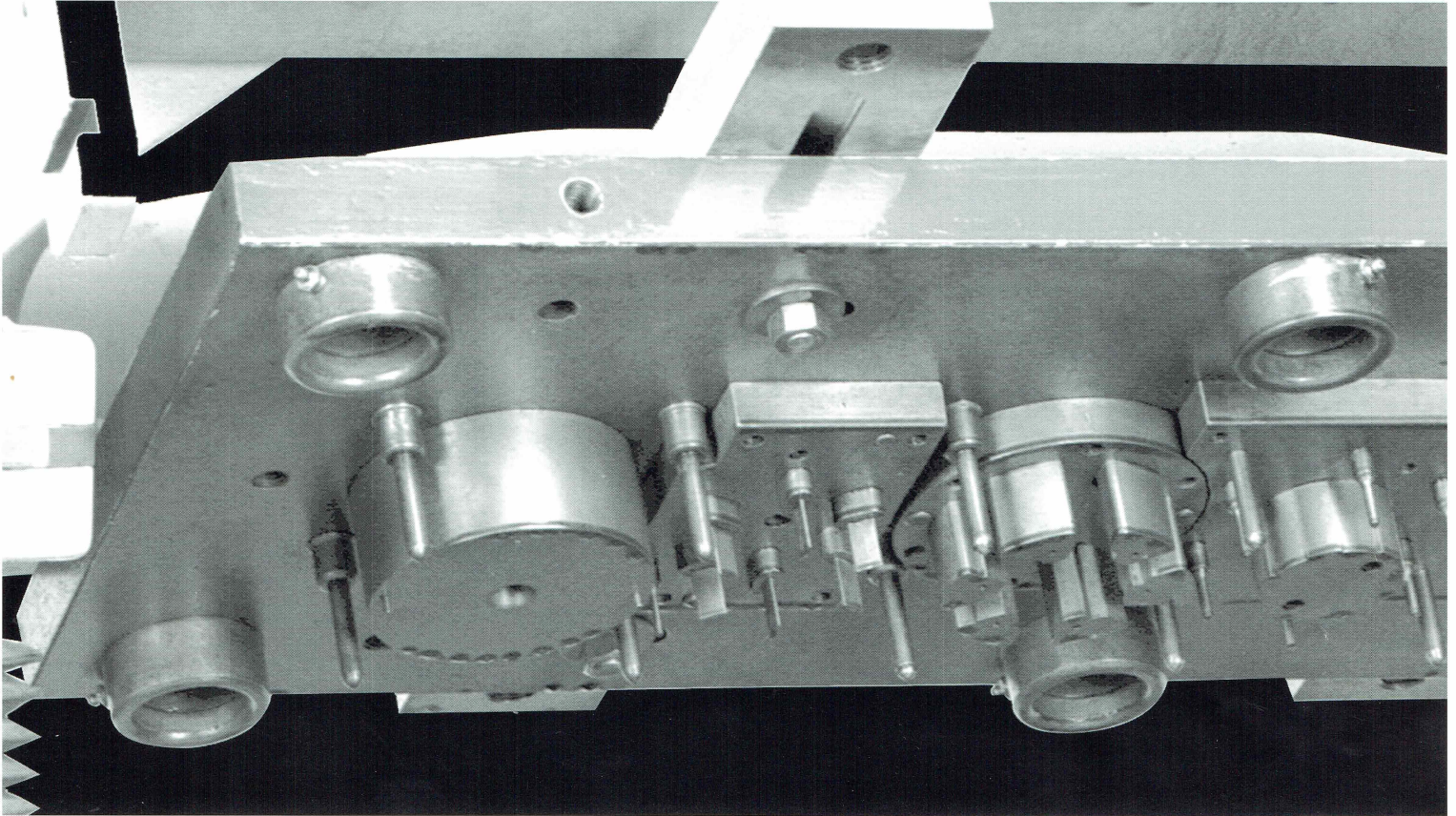


H A N S F O R D   D I E   H A N D L E R S



P r o t e c t   Y o u r   I n v e s t m e n t



E X P E C T   E X C E L L E N C E

For 25 years, Hansford Die Handlers have been recognized by metal stampers world-wide as the most efficient machines for servicing die sets. These rugged machines will make your metal stamping operations more efficient and more productive.

**Protect Your Investment**

- Service your expensive dies safely
- Eliminate the hazards of slipping and jamming valuable dies with precise, lead screw design
- Maintains parallelism of platens during operation (.003" T.I.R.)

**Service Dies Efficiently**

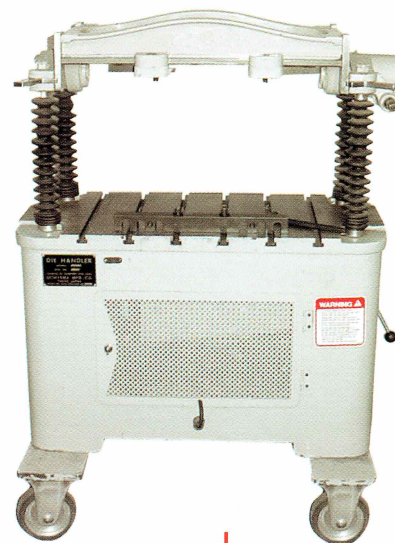
- Fast and safe one-man operation
- Try-out mode enables shearing, sharpening and spotting
- Separate and inspect die sets under power or manually
- Efficient operation increases productivity with less skill

**Three Models to Meet Your Needs**

- Rugged construction built with quality workmanship
- Designed for extreme precision and absolute reliability
- Manual, Try-out and Power Modes standard

Upper platen of all models rotates 360°

Model 1018



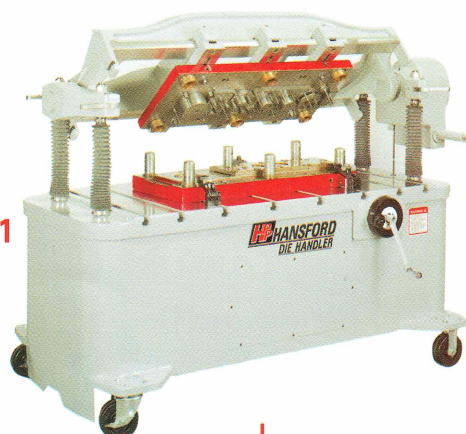
- Featuring:
- Rugged, portable machine for processing small dies or molds
  - T-slots for clamping lower die or mold
  - 400 lb. capacity
  - 1/4 HP motor

Model 1020

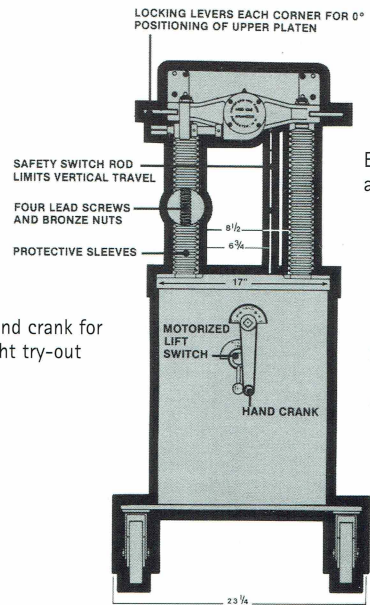
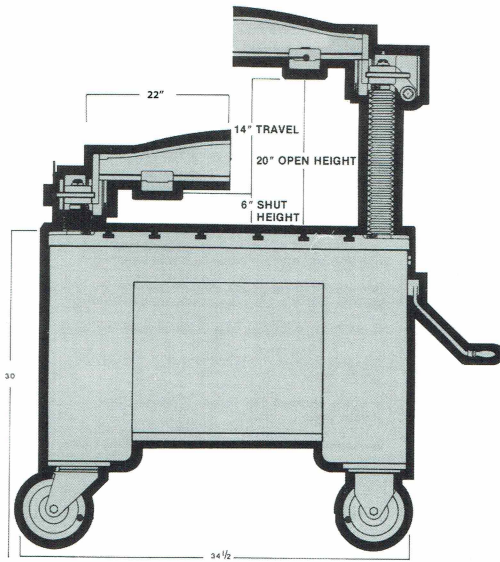


- Featuring:
- Designed for extreme precision and reliability
  - Open construction provides maximum access to top of die set
  - 1.5 HP motor
  - Special gear change dial for safety and ease of operation
  - 20 ton tryout force standard

Model 1021



- Featuring:
- 30" x 64" platen area
  - Raise a 3,000 lb. load at 13" per minute
  - 2 HP motor
  - 20 ton tryout force standard
  - Accessories available for increasing vertical travel and open height

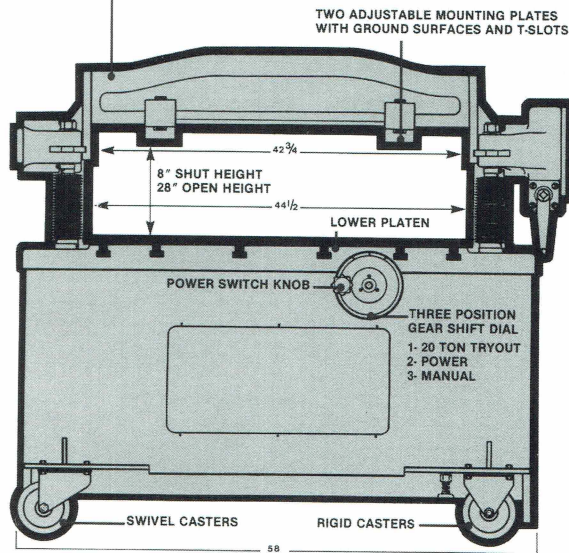


Ensures accuracy and rigidity

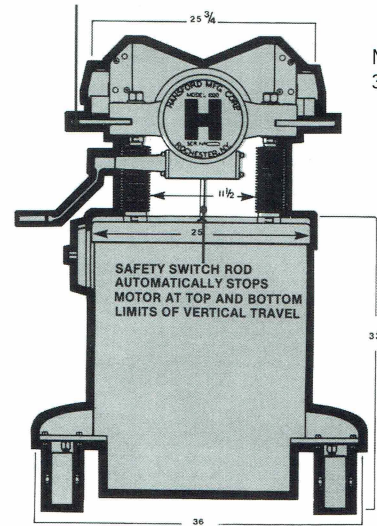
Hand crank for light try-out

Small footprint with net weight of 525 lbs.

OPEN UPPER PLATEN CAN BE ROTATED 360°

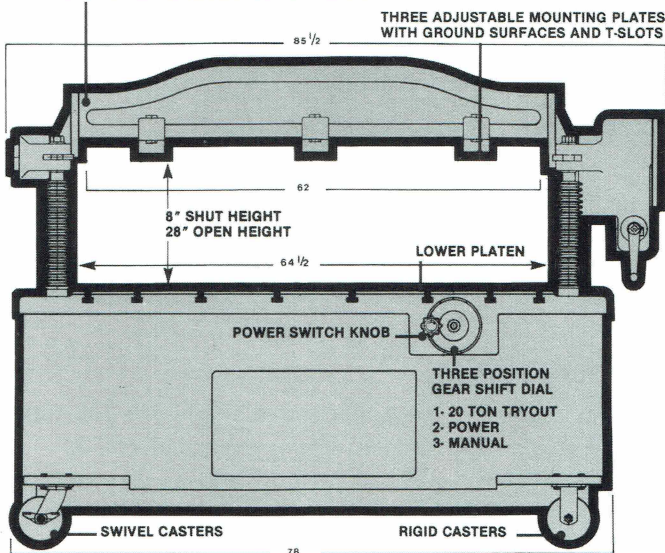


LOCKING LEVERS EACH CORNER TO POSITIVELY LOCATE UPPER PLATEN AT 0°

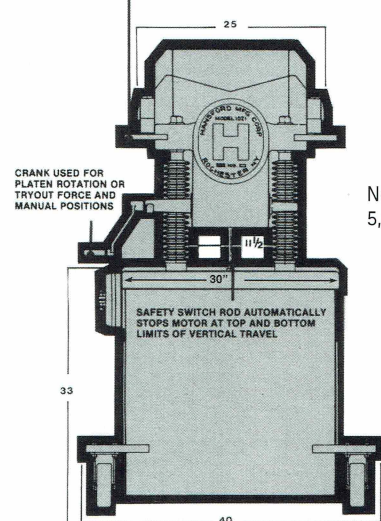


Net weight: 3,350 lbs.

OPEN UPPER PLATEN CAN BE ROTATED 360°



LOCKING LEVERS EACH CORNER TO POSITIVELY LOCATE UPPER PLATEN AT 0°



Net weight: 5,000 lbs.

**S p e c i f i c a t i o n s**

|   | Model 1021  | Model 1020  | Model 1018   |
|---|---|---|--|
| Shut Height   | 8"  | 8"  | 6"   |
| Open Height*  | 28"   | 28"   | 20"  |
| Lower Platen Area                                   | 30" x 64" long  | 25" x 44 1/2" long  | 17" x 26" long   |
| Upper Platen Area                                   | 30" x 62" long  | 25" x 42 3/4" long  | 17" x 22" long   |
| Mounting of Dies: Lower                             | 8-T slots 30" long, 3/4" bolts  | 6-T slots 24" long, 3/4" bolts  | 6-T slots 17" long, 1/2" bolts                         |
| Mounting of Dies: Upper ( <i>adjustable</i> )       | 6 slots 8.5" long, 3/4" bolts   | 4 slots 8 1/2" long, 3/4" bolts   | 4 slots 5 1/2" long, 1/2" bolts                        |
| Movement of Upper Platen:<br>Vertical Travel*       | 20"   | 20"   | 14"  |
| Vertical Movement by Hand Crank:<br>Manual Position | 48 turns/inch   | 48 turns/inch   | 37.5 turns/inch  |
| Try-out Position                                    | 384 turns/inch  | 384 turns/inch  |  |
| Vertical Movement (power)                           | 13"/min.  | 13"/min.  | 15.1"/min.   |
| Rotation of Top Platen                              | 240 turns/360°  | 48 turns/360°   | 30 turns/360°  |
| Motor   | 2 HP 220/440 Volts/3/60<br>1750 RPM,<br>Instantaneously Reversing                                 | 1.5 HP 220/440 Volts/3/60<br>1750 RPM,<br>Instantaneously Reversing                               | 1/4 HP 110 Volts/1/60<br><br>Instantaneously Reversing |
| Control   | Magnetic reversing starter<br>with 110 V @ controls   | Magnetic reversing starter<br>with 110 V @ controls   | 110 V  |
| JIC Standards                                       | Furnished at extra cost,<br>special voltages and frequencies<br>also available at additional cost | Furnished at extra cost,<br>special voltages and frequencies<br>also available at additional cost | N/A  |
| Capacity  | 3,000 lbs./6,000 lbs. optional  | 3,000 lbs./6,000 lbs. optional  | 400 lbs.   |
| Locking Position of Upper Platen                    | 0°  | 0°  | 0°   |
| Maximum Die Try-out Force                           | 20 tons   | 20 tons   | 1 ton  |
| Net Weight  | 5,000 pounds  | 3,350 pounds  | 525 pounds   |
| Shipping Weight                                     | 5,200 pounds  | 3,500 pounds  | 600 pounds   |

\* For increased vertical travel and open height, see accessory list below.

**A c c e s s o r i e s**

| Item Number | Product                                   | Description  |
|-------------|---|--|
| HSA-1       | Additional Die Holder Assembly            | Mounts to upper platen   |
| HA-2        | Leveling Jack Assembly                    | For lifting machine off casters and leveling                                 |
| HA-3        | Leveling Jack Assembly                    | For use with machine equipped with HA-17 Assembly                            |
| HA-6        | Left-Hand Engagement Safety Switch        | General purpose wiring   |
| HA-6A       | Left-Hand Engagement Safety Switch        | J.I.C. Wiring  |
| HA-7        | Die Mounting Plate Spacer                 | 5" thick, 1 required for each Die Holder                                     |
| HA-10       | Three Phase Electrics to J.I.C. standards | In lieu of general purpose type  |
| HA-17       | Set of 4 Extra Length Lead Screws         | Increases open height and vertical travel by 8" (machine on casters)         |
| HA-18       | Set of 4 Extra Length Lead Screws         | Increases open height and vertical travel by 8" (machine on stationary base) |
| HA-19       | Set of 4 Foot Extensions                  | Makes Die Handler stationary. Install in place of casters.                   |
| HA-25       | Set of 2" Lead Screws                     | Provides 20" vertical travel   |
| HA-25A      | Set of 2" Lead Screws                     | Provides 28" vertical travel   |
| HA-32       | Stationary Base for Die Handler           | Accommodates 6,000 lb. static die load for Model 1020                        |
| HSA-32      | Extra Strength Right-Hand Trunion         | Increases turnover torque to 9,000 in. lbs. (Prereq. for HA-36.)             |
| HA-33       | Stationary Base for Die Handler           | Accommodates 6,000 lb. static die load for Model 1021                        |
| HA-36       | Motorization of the Turn-Over Mechanism   | Provides rotation of the upper platen under power. HSA-32 required.          |
| HSA-16      | Export Crating                            | Model 1020   |
| HSA-17      | Export Crating                            | Model 1021   |

## Introduction

A Hansford Die Handler will make your metal stamping operations more productive because:

- It eliminates the hazards of slipping and jamming valuable dies.
- It enables one man to separate, service, and try-out dies.
- It is rugged and built with precision.

Your die sets are more expensive and complex than ever before, protect your investment by servicing them properly with a Hansford Die Handler.

Using chain hoists, lead mallets, and two or three toolmakers is not an efficient way to separate and service dies.

With a Hansford Die Handler, one man can separate and close a die under power and manually with speed and control. All models allow one man to rotate the upper half of a die 180° for ease of inspection and service.

The rugged construction utilizes precision lead screws to raise and lower the upper platen and maintain parallelism of the upper and lower platens.

Many accessories are available to arrange a Hansford Die Handler to suit your requirements.

### SEPARATION

The ability of a die handler to separate heavy die sets under power is its single greatest feature. Today's die sets are more complex and therefore, more care is needed to separate or close them without jamming. The rugged precision of the Hansford Die Handler eliminates problems of separation because the upper and lower platens are held parallel to each other within .003" T.I.R., and ground locks are provided on all four corners of the upper platen.

Sliding die holders are furnished on the open, upper platen to facilitate attachment to the upper half of a die or mold.

### SHEARING, SHARPENING, SPOTTING.

All models have a rated try-out force which is exerted by hand crank in the "Try-Out" mode. This is a squeeze-type force, which allows some plants to shear in blanking dies. With a die separated and positioned, sharpening can be easily accomplished. Similarly, a forming die requires spotting in order to assure the proper match of the two halves, and this can be accomplished just as easily as shearing in or sharpening operations.

### INSPECTION

Dies pulled from storage are usually separated and the punches, dies, and strippers are inspected before the die set is put in use. If a die set has been in storage for several months, it may need re-lubrication. A die handler helps make die set inspection a fast and safe one-man operation.

### ALIGNMENT

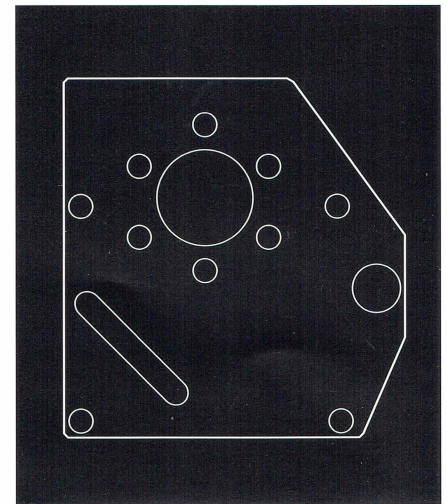
The increased complexity of dies today means that alignment is more critical than ever. Just as a press must maintain parallelism between its ram and bolster, a die handler must be rugged and precise. The rugged, cast upper platen and lead screws utilized in Hansford Die Handlers assure a positive, smooth vertical movement and the ability to withstand the forces involved without deflecting beyond acceptable limits.

### SAFETY

The separation of die sets by using chain hoists and lead hammers is potentially dangerous to personnel and can damage a valuable die unnecessarily. The Hansford Die Handler allows one man to safely separate and service a die set, as long as the die halves are properly and securely fastened to the machine.

### CHECKING PUNCH AND DIE CLEARANCE

Toolmakers use several methods to check punch clearances such as light, cutting shim stock, paper, or plastic. In some cases, the actual material being processed by the die can be used if thin enough.



One of the quickest methods is the "clear plastic marking procedure." A piece of plastic, about .020" thick, is placed on the die segment which is to be checked. The top platen is lowered under power until the punch is just above the plastic. The top platen is then lowered further by hand crank until the punch just touches the plastic. The plastic is mounted on an optical comparator and the mark of the punch on top of the plastic can be compared to the mark of the die on the bottom.

**W a r r a n t y**

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Hansford Parts And Products warrants the workability of the Die Handler under normal use, for a period of one (1) year. This warranty is limited to the replacement of defective parts and specifically excludes all claims for consequential damages as defined in Section 2-715 of the Uniform Commercial Code. There are no other warranties.

**WARNING**

To prevent serious bodily injury

- Never place any part of your body near moving parts of these machines.
- Never wear loose clothing that could become tangled or caught in moving parts.
- Never operate or maintain any of our machines without proper instructions.
- It is the employer's responsibility to implement the above and also to provide proper guards, devices, or means that may be necessary or required for any particular use, operation set-up, or service of these machines.

>  
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Visit our website at [www.hpproc.com](http://www.hpproc.com), or call 315-986-1000.  
Hansford Parts and Products, serving the manufacturing  
community with quality and integrity for more than 25 years.

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