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# DRM





# DIE REMOVING MACHINE<sup>®</sup> facilitates the expulsion of the die from the die holder in complete safety for operator and die.

The work carried out safely and correctly represents a clear cost saving.

## THE DIFFICULTY TO REMOVE DIE FROM DIE-HOLDER

In order to remove the die from the die-holder often improper means are used such as bats or iron bars that affect the die, causing serious damage to it and creating triggers cracks that threaten even the operator's safety. No less dangerous can be the equipment that uses a hydraulic or pneumatic piston generally built without the minimum security features. Consequently often the eject operation of the die becomes complex especially when aluminium is caught between the pieces to be split or the same are offset with respect to the inner die holder. This can create seizing and deformation preventing the smooth output of the die.

## New DRM

With the new DRM with contrast piston and die supporting slide at the end of the cycle everything becomes all the more simple and safe.

## CYCLE

After depositing the complete die holder in its base and exactly in axis with the thrust center, the ejection piston and the contrast piston, that has less power than the main piston, move simultaneously for the ejection of the die. At the end of the cycle the die, always retained by the two pistons, will be deposited on a special slide ready to be transferred. The two pistons return to the starting position, ready for a new cycle.





## 1 • FEATURES

### • SAFETY

This new system is designed precisely to improve even more operator's safety. The die retained between two pistons will be evacuated without any sudden shocks and deposited on the appropriate slide, thus avoiding even the problem of the dies dropping at the end of the cycle due to various differences in size. It remains mandatory the use of the machine board and the protections on the loading side. All safety guards are fitted with microswitches.

### • CONSTRUCTION AND USE

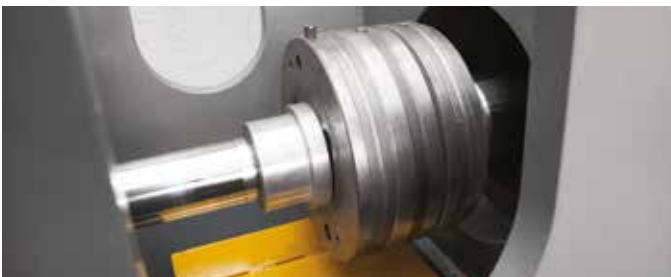
The frame is made of thick steel plates to counter the power of the machine.

In the standard configuration DRM is available in three versions: the small one (DRM 80) for die holders with diameter up to 420 mm (16,5"), the intermediate one (DRM 100) up to 600 mm (23,6") and the big one (DRM 140) up to 800 mm (31,5").

It can be constructed with adequate power and structure even for very large diameters.

The machine can be used also for die holders equipped with incorporated feeder plate.

Upon request we can design and produce a special version that allows multiple uses on the same machine.





## 2 • TECHNICAL SPECIFICATIONS

		<b>DRM 80</b>	<b>DRM 100</b>	<b>DRM 140</b>
<b>Ejection power</b>		80 Ton	100 Ton	140 Ton
<b>Hydraulic capacity</b>		70 l	70 l	70 l
<b>Pump</b>			Low and High pressure	
<b>Installed power</b>		6.4 kW	6.4 kW	6.4 kW
<b>Maximum pressure</b>		300 bar	300 bar	300 bar
<b>Ejection cylinder</b>	Bore	Ø 180 mm	Ø 200 mm	Ø 250 mm
	Piston diameter	Ø 120 mm	Ø 120 mm	Ø 140 mm
	Stroke (*)	650 mm	650 mm	650 mm
<b>Contrast cylinder</b>	Bore	Ø 100 mm	Ø 100 mm	Ø 100 mm
	Piston diameter	Ø 70 mm	Ø 70 mm	Ø 70 mm
	Stroke (*)	550 mm	600 mm	650 mm
<b>Die releasing cylinder</b>	Bore	Ø 100 mm	Ø 100 mm	Ø 100 mm
	Piston diameter	Ø 70 mm	Ø 70 mm	Ø 70 mm
	Stroke (*)	150 mm	150 mm	150 mm
<b>Maximum die-holder outside Ø (*)</b>		406 mm	560 mm	762 mm
<b>Maximum die-holder height (*)</b>		200 mm	300 mm	350 mm
<b>Machine weight</b>		2200 Kg	4100 Kg	5000 Kg
<b>Overall dimensions</b>		2900 x 920 h 1300	3100 x 1150 h 1450	3300 x 1200 h 1550

The machine is supplied in compliance with CE standards or alternative ones.

**DRM - DIE REMOVING MACHINE ® : a CO.M.P.ES. S.p.A. trademark**

Compes reserves the right to apply without prior notification any technical modification deemed necessary or as a function of specific requests.

