

# Rousselle Single Point Gap Frame (Cast Iron)

## Standard Features

- Cast Frame
- Air Clutch and Shoe Brake
- Crankshaft Motion (40 Ton and Up)
- Eccentric Shaft Motion (15 and 25 Ton Models)
- Wrist Pin Connection
- V Gibbing
- Air Counterbalance System (60 Ton and Up)
- Bolster Plate
- Manual Grease Lubrication
- Solid State Press Control (ANSI B11.1)
- Nema 12 Enclosure Mounted on Press
- Operator Station with Dual Run, Emergency Stop and Stop on Top Palm Buttons
- Supervisory Key Selector Switch for Off, Single Stroke, Inch or Continuous Mode
- Brake Monitor
- Motion Detector
- Dual Air Valve
- Pressure Switches for Clutch/Brake and Counterbalance
- Forward/Reverse Feature
- Stroke Counter

## Optional Features

- One Shot Lubrication System
- Self-Monitoring Automatic Lubrication System
- Stroke Lengths other than Standard
- Additional Shut Heights
- T-Slotted Bolster
- Bolster Burnout
- Special Drilling and Machining
- Die Cushions
- Pneumatic Flywheel Brake
- Shaft Extension
- Custom Speeds
- Variable Speed Drive
- Bar Turnover with Key Selector Switch
- Pedestal for Operator Station
- Tonnage Monitor
- Remote Mounted Controls
- Additional Operator Station



Model 6A



STAMPING OUT DOWNTIME™

# Specifications

Model Number		2/2E	3/3E	4/4E	6A	8	10
Capacity (Tons) Near B.D.C.		15	25	40	60	85	110
Bed Area (Left-to-Right x Front-to-Back)		16 ¼ x 11	20 x 14	26 x 16	30 x 18	36 x 24	40 x 28
Strokes Per Minute	Non-Geared	160	135	105	110	100	90
	Geared	–	–	45	50	50	45
Shut Height S.D.A.U.		Refer To Shut Height Chart					
Bolster Thickness		1 ¼	1 ½	1 ¾	2	3 ½	4
Slide Adjustment		1 ½	2	3 ½	3 ½	4	4
Bed Opening	Rectangular	8 ½ x 5 ½	12 x 7	14 ½ x 10 ½	16 x 10 ½	17 ¾ x 13 ¾	22 x 16
	Round (Diameter)	8 ½	10	12 ½	12 ½	17	19
Width of Opening Through Back		8 ½	13 ½	16	16	15 ½	20
Depth of Throat from Center Line of Slide		5 ¾	7 ½	9 ½	10 ½	13	14 ¾
Width Across Slide Ears		6 ½	8 ¾	12	16	16	18
Crankshaft Diameter	Main Bearing	1 ½	2 ½	3 ¾	4 ¾	5	5 ½
	Connecting Rod	3 ¾	5 ¾	5	5	6 ½	7 ½
Flywheel Diameter	Non-Geared	18 ½	24	33	38	44	50
	Geared	–	–	21 ¾	21 ¾	33	33
Flywheel Weight (lbs.)	Non-Geared	200	370	800	1250	1900	2150
	Geared	–	–	280	280	565	565
Die Shank Hole Diameter	Standard	1 ⅞	1 ⅞	2	2	2 ½	2 ½
	Maximum	2	2	2 ½	2 ½	2 ½	2 ½
Motor Horsepower		1	2	3	5	7 ½	10
Motor Speed (RPM)	Non-Geared	1750	1175	1175	1175	1175	1175
	Geared	–	–	1750	1750	1750	1750
Floor Space at Base	Left-to-Right	28 ½	34 ¾	39	41	47	52
	Front-to-Back	38 ½	42 ½	55 ½	55 ½	67 ½	68 ½

## Shut Height Chart

Shut Height S.D.A.U.													
Stroke	2	2E	3	3E	4	4E	6A	6A + 6	8 STD	8 + 6	10 STD	10 + 4	10 + 8
1"	–	–	–	–	13	19 ¾	13 ½	19 ½	–	–	15	19	23
1 ¼"	–	–	–	–	–	–	–	–	–	–	–	–	–
1 ¾"	–	–	–	–	–	–	–	–	–	–	–	–	–
2"	7 ¾	12	10 ¾	16 ¾	12 ½	19 ¾	13	19	13	19	14 ½	18 ½	22 ½
3"	6 ¾	11	9 ¾	15 ¾	12	18 ¾	12 ½	18 ½	12 ½	18 ½	14	18	22
4"	–	–	8 ¾	14 ¾	11	17 ¾	11 ½	17 ½	12	18	13 ½	17 ½	21 ½
5"	–	–	–	–	10	16 ¾	10 ½	16 ½	11 ½	17 ½	13	17	21
6"	–	–	–	–	9	15 ¾	9 ½	15 ½	11	17	12 ½	16 ½	20 ½
7"	–	–	–	–	–	–	–	–	–	–	12	16	20
8"	–	–	–	–	–	–	–	–	10	16	11 ½	15 ½	19 ½

Standard shut heights shown in green type with standard stroke. Values in inches unless otherwise noted. Machines may vary slightly from those shown.

www.theheimgroup.com • 6360 West 73rd Street, Chicago, IL 60638

Sales/Service: 708-496-7400 • 800-927-9393 • Fax: 708-496-7428 • Parts Fax: 708-496-0708 • Email: sales@theheimgroup.com

The Heim Group reserves the right to change design or detail of its products without notice. Point of operation safety guarding or devices are the sole responsibility of the employer (user) of the machine as provided in ANSI B11.1 (2001) as published by the American National Standards Institute, Inc. and OSHA regulations. "Heim" and "Rousselle" are Reg. TMs; "Stamping Out Downtime" is a TM of The Heim Group. ©THG, 2008. All Rights Reserved.

# Rousselle Single Point Gap Frame (Steel Fabricated)



Model G1-55

## Standard Features

- Steel Fabricated
- Combination Air Clutch and Brake
- Crankshaft Motion
- Ball Type Adjustment Screw with Bronze Seat
- Multiple V Gibbing
- Air Counterbalance System (55 Ton and Up)
- Bolster Plate
- One Shot Lubrication
- Slide Adjustment Powered by Air Wrench (Except 32 Ton Model)
- Solid State Press Control (ANSI B11.1)
- Nema 12 Enclosure Mounted on Press
- Operator Station with Dual Run, Emergency Stop and Stop on Top Palm Buttons
- Supervisory Key Selector Switch for Off, Single Stroke, Inch, or Continuous Mode
- Brake Monitor
- Motion Detector
- Dual Air Valve
- Pressure Switches for Clutch/Brake and Counterbalance
- Forward/Reverse Feature
- Stroke Counter

## Optional Features

- Deep Throat
- Self-Monitoring Automatic Lubrication System
- Stroke Lengths other than Standard
- Additional Shut Heights
- Custom Bed Sizes
- T-Slotted Bolster
- Bolster Burnout
- Special Drilling and Machining
- Die Cushion
- Pneumatic Flywheel Brake
- Shaft Extension
- Custom Speeds
- Variable Speed Drive
- Bar Turnover with Key Selector Switch
- Pedestal for Operator Station
- Tonnage Monitor
- Console or Remote Mounted Controls
- Additional Operator Station
- Shut Height Indicator (Except 32 Ton Models)



Model G1-95  
(Deep Throat)



# Specifications

Model Number	Frame	B1-32			B1-55			B1-70			B1-95			B1-120			
		G1-32			G1-55			G1-70			G1-95			G1-120			
		STD	+4"	+8"	STD	+4"	+8"	STD	+4"	+8"	STD	+4"	+8"	STD	+4"	+8"	
Capacity (Tons)		32			55			70			95			120			
Bolster Area (Left-to-Right x Front-to-Back)		24 x 15			28 x 18			32 x 20			36 x 26			40 x 30			
Strokes Per Minute	Non-Geared	140			120			110			100			90			
	Geared	70			60			55			50			45			
Shut Height S.D.A.U.	Stroke Length	1"	11	15	19	14	18	22	14	18	22	15	19	23	15	19	23
		2"	10 ½	14 ½	18 ½	13 ½	17 ½	21 ½	13 ½	17 ½	21 ½	14 ½	18 ½	22 ½	14 ½	18 ½	22 ½
		3"	10	14	18	13	17	21	13	17	21	14	18	22	14	18	22
		4"	9 ½	13 ½	17 ½	12 ½	16 ½	20 ½	12 ½	16 ½	20 ½	13 ½	17 ½	21 ½	13 ½	17 ½	21 ½
		5"	-	-	-	12	16	20	12	16	20	13	17	21	13	17	21
		6"	-	-	-	11 ½	15 ½	19 ½	11 ½	15 ½	19 ½	12 ½	16 ½	20 ½	12 ½	16 ½	20 ½
		7"	-	-	-	-	-	-	-	-	-	12	16	20	12	16	20
		8"	-	-	-	-	-	-	-	-	-	11 ½	15 ½	19 ½	11 ½	15 ½	19 ½
Bolster Thickness		1 ½			3			3			3			3			
Slide Adjustment		2 ½			4			4			4			4			
Bed Opening (Left-to-Right x Front-to-Back)		14 x 7			15 x 11			15 x 11			18 x 16			18 x 16			
Slide Area (Left-to-Right x Front-to-Back)		12 x 9			15 x 12 ¼			15 x 12 ¼			18 ½ x 13			18 ½ x 13			
Width of Opening Through Back		16			18			18			20			20			
Depth of Throat from Center Line of Slide	Standard OBI/OBS	8 ½			11			11			14			16			
	Deep Throat OBI	15			18			18			21			24			
	Deep Throat OBS	18			24			24			30			30			
Crankshaft Diameter	Main Bearing	3			4 ½			4 ½			6			6			
	Connecting Rod	4			6			6			8			8			
Flywheel Diameter	Non-Geared	29			36			40			42			45			
	Geared	19			24			25 ½			30 ½			34			
Flywheel Weight (lbs.)	Non-Geared	430			900			1100			2270			2700			
	Geared	240			640			720			800			1000			
Motor Horsepower		3			5			17 ½			10			10			
Motor Speed (RPM)	Non-Geared	1775			1175			1175			1175			1175			
	Geared	1750			1750			1750			1750			1750			
Floor to Top of Bed		32			32			32			35 ½			35 ½			
Die Shank Hole Diameter		2			2			2			2 ½			2 ½			
Overall Height		93	97	101	101	105	109	101	105	109	117	121	125	117	121	125	
Floor Space at Base (Left-to-Right x Front-to-Back)		35 x 51			51 x 60			51 x 60			56 x 85			56 x 85			
		37 x 36			39 x 43			39 x 48			40 x 65			40 x 71			
		37 x 59			37 x 76			37 x 76			50 x 100			50 x 100			
		37 x 49			39 x 61			39 x 73			42 x 75			42 x 95			

Specifications vary by frame only where indicated. Values in inches unless otherwise noted. Standard shut heights shown in green type with standard stroke. Machines may vary slightly from those shown.

www.theheimgroup.com • 6360 West 73rd Street, Chicago, IL 60638

Sales/Service: 708-496-7400 • 800-927-9393 • Fax: 708-496-7428 • Parts Fax: 708-496-0708 • Email: sales@theheimgroup.com

The Heim Group reserves the right to change design or detail of its products without notice. Point of operation safety guarding or devices are the sole responsibility of the employer (user) of the machine as provided in ANSI B11.1 (2001) as published by the American National Standards Institute, Inc. and OSHA regulations. "Heim" and "Rousselle" are Reg. TM's; "Stamping Out Downtime" is a TM of The Heim Group. ©THG, 2008. All Rights Reserved.

# Rousselle Single Point Gap Frame

## Standard Features

- Steel Fabricated
- Combination Air Clutch and Brake
- Crankshaft Motion
- Ball Type Adjustment Screw with Bronze Seat
- Adjustable 8 Point Gibbing
- Air Counterbalance System
- Bolster Plate
- Self-Monitoring Automatic Lubrication System
- Powered Slide Adjustment with Digital Position Indicator
- Solid State Press Control (ANSI B11.1)
- Nema 12 Enclosure Mounted on Press
- Operator Station with Dual Run, Emergency Stop and Stop on Top Palm Buttons
- Supervisory Key Selector Switch for Off, Single Stroke, Inch or Continuous Mode
- Brake Monitor
- Motion Detector
- Dual Air Valve
- Pressure Switches for Clutch/Brake and Counterbalance
- Forward/Reverse Feature
- Stroke Counter

## Optional Features

- Hydraulic Overload System
- Stroke Lengths other than Standard
- Additional Shut Heights
- Custom Bed Sizes
- T-Slotted Bolster
- Bolster Burnout
- Special Drilling and Machining
- Die Cushions
- Pneumatic Flywheel Brake
- Shaft Extension
- Custom Speeds
- Variable Speed Drive
- Pedestal for Operator Station
- Tonnage Monitor
- Console or Remote Mounted Controls
- Additional Operator Station



Model G1-200



STAMPING OUT DOWNTIME™

# Specifications

Model Number	Frame	OBI	B1-150				B1-200				—			—				
		OBS	G1-150				G1-200				G1-250			G1-300				
		Shut Height	STD	+4"	+8"	+12"	STD	+4"	+8"	+12"	STD	+6"	+12"	STD	+6"	+12"		
Capacity at ¼" (Tons) B.D.C.		150				200				250			300					
Bed and Bolster Area (Left-to-Right x Front-to-Back)		50 x 32				50 x 32				54 x 32			60 x 32					
Strokes Per Minute		Non-Geared		80				70				—			—			
		Geared		40				35				40			35			
Shut Height S.D.A.U.		Stroke Length		2"	20	24	28	32	20	24	28	32	20	26	32	20	26	32
				4"	19	23	27	31	19	23	27	31	19	25	31	19	25	31
				6"	18	22	26	30	18	22	26	30	18	24	30	18	24	30
				8"	17	21	25	29	17	21	25	29	17	23	29	17	23	29
				10"	13	17	21	25	13	17	21	25	13	19	25	13	19	25
				12"	12	16	20	24	12	16	20	24	12	18	24	12	18	24
				14"	—	—	—	—	—	—	—	—	—	11	17	23	11	17
Bolster Thickness		4				4				4			4					
Slide Adjustment		6				6				6			6					
Bed Opening (Left-to-Right x Front-to-Back)		22 x 20				22 x 20				24 x 20			24 x 20					
Slide Area (Left-to-Right x Front-to-Back)		31 ½ x 23 ½				31 ½ x 23 ½				36 x 23 ½			36 x 23 ½					
Width of Opening Through Back		24				24				28 ½			28 ½					
Depth of Throat from Center Line of Slide		Frame		OBI				16 ½				—			—			
		Frame		OBS				16 ½				16 ½			16 ½			
Crankshaft Diameter		Main Bearing		7 ½				7 ½				9 ¼			9 ¼			
		Connecting Rod		10				10				12			12			
Flywheel Diameter		Non-Geared		48 ½				54 ½				—			—			
		Geared		36				40				36			40			
Flywheel Weight (lbs.)		Non-Geared		2400				2890				—			—			
		Geared		850				1050				1700			2100			
Motor Horsepower		15				20				25			30					
Motor Speed (RPM)		Non-Geared		1175				1175				—			—			
		Geared		1750				1750				1750			1750			
Floor to Top of Bed		OBI		41 ½				41 ½				—			—			
		OBS		36 ½				36 ½				36 ½			36 ½			
Overall Height with Standard Shut Height		177	181	185	189	177	181	185	189	179	184	190	179	184	190			
Floor Space at Base (Left-to-Right x Front-to-Back)		Frame		50 x 108				50 x 108				—			—			
		Frame		50 x 73 ½				50 x 73 ½				50 x 84			50 x 84			

Values in inches unless otherwise noted. Machines may vary slightly from those shown. Standard shut heights shown in green type with standard stroke.

www.theheimgroup.com • 6360 West 73rd Street, Chicago, IL 60638

Sales/Service: 708-496-7400 • 800-927-9393 • Fax: 708-496-7428 • Parts Fax: 708-496-0708 • Email: sales@theheimgroup.com

The Heim Group reserves the right to change design or detail of its products without notice. Point of operation safety guarding or devices are the sole responsibility of the employer (user) of the machine as provided in ANSI B11.1 (2001) as published by the American National Standards Institute, Inc. and OSHA regulations. "Heim" and "Rousselle" are Reg. TM's; "Stamping Out Downtime" is a TM of The Heim Group. ©THG, 2008. All Rights Reserved.