AIR FEED SPECIFICATIONS

USA

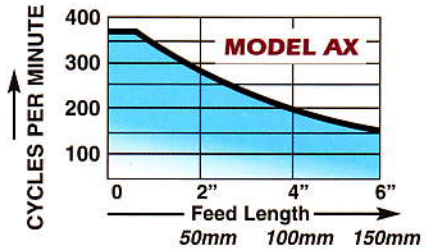
Model	Max. Stock Width (In.)	Feed Length (In.)	Pulling Power at 100 PSI (Lbs.)	Thickness (In.)	Speed See Note 3 (SPM)	Air Consumption Per Cycle (CF)	Shipping Weight (Lbs.)
AX2	1.5	0-2	25	.050	280	.001	7.5
AX4	1.5	0-4	25	.045	220	.002	9
AX6	1.5	0-6	25	.040	180	.003	11
CX3	3	0-3	50	.080	220	.003	20
CX6	3	0-6	50	.075	160	.005	25
CX9	3	0-9	50	.070	110	.008	29
CX12	3	0-12	50	.065	95	.010	32
DX4	4	0-4	50	.075	195	.004	25
DX6	4	0-6	50	.070	145	.006	30
DX12	4	0-12	50	.065	85	.012	38
FX4	6	0-4	110	.085	160	.006	38
FX6	6	0-6	110	.080	140	.008	40
FX9	6	0-9	110	.075	110	.011	45
FX12	6	0-12	110	.070	80	.014	51
HX4	9	0-4	110	.075	145	.006	55
HX6	9	0-6	110	.070	125	.008	60
HX9	9	0-9	110	.065	100	.011	65
HX12	9	0-12	110	.065	70	.014	70
LX6	12	0-6	175	.090	100	.013	130
LX12	12	0-12	175	.080	60	.023	155

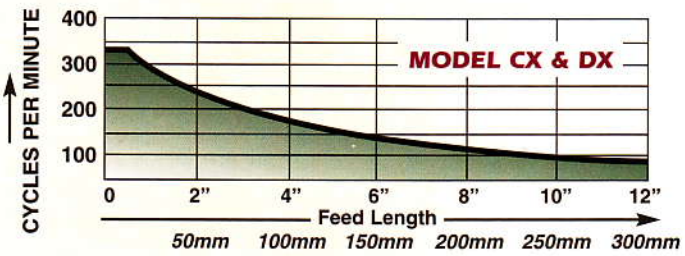
METRIC

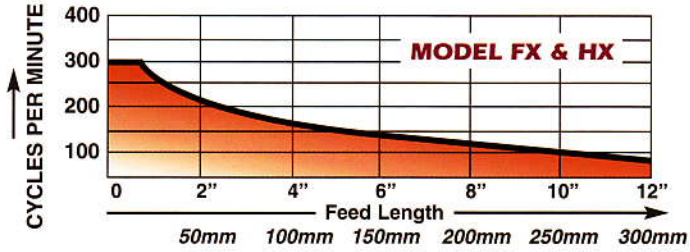
Model	Max. Stock Width (mm)	Feed Length (mm)	Pulling Power at 7 Bar (Kg)	Thickness (mm)	Speed See Note 3 (SPM)	Air Consumption Per Cycle (LTR)	Shipping Weight (Kg)
AX2	38	0-50	11,4	1,2	280	0,03	3,5
AX4	38	0-100	11,4	1,1	220	0,06	4,0
AX6	38	0-150	11,4	1,0	180	0,09	5,0
CX3	76	0-76	23	2,0	220	0,09	9,0
CX6	76	0-150	23	1,9	160	0,14	11,0
CX9	76	0-230	23	1,8	110	0,23	13,0
CX12	76	0-300	23	1,7	95	0,28	14,5
DX4	100	0-100	23	1,9	195	0,11	11,0
DX6	100	0-150	23	1,8	145	0,17	13,5
DX12	100	0-300	23	1,6	85	0,34	17,0
FX4	150	0-100	50	2,1	160	0,17	18,0
FX6	150	0-150	50	2,0	140	0,23	19,0
FX9	150	0-230	50	1,9	110	0,31	20,0
FX12	150	0-300	50	1,8	80	0,40	23,0
HX4	230	0-100	50	2,0	145	0,17	25,0
HX6	230	0-150	50	1,9	125	0,23	27,0
HX9	230	0-230	50	1,8	100	0,31	29,5
HX12	230	0-300	50	1,7	70	0,40	31,8
LX6	300	0-150	80	2,3	100	0,37	59,0
LX12	300	0-300	80	2,0	60	0,65	70,0

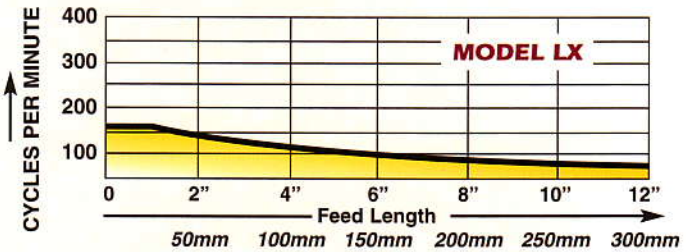
Note 1: Recommended Operating Pressure 80 to 120 PSI (6 to 8 Bar).
Note 2: Capacity for stock thickness increases as stock width decreases to a maximum of 150%.
Note 3: Approximate speed at maximum feed length. Speed will decrease as the weight of the material being fed increases.

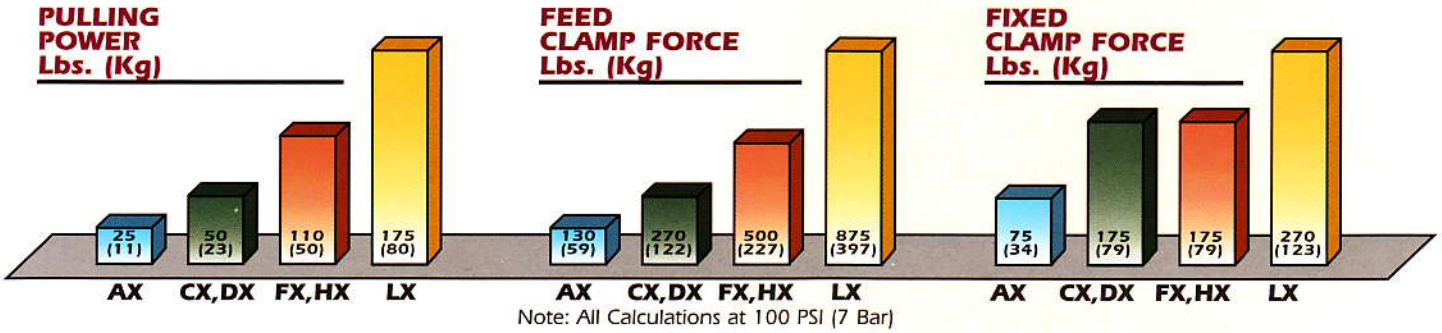
SAFE WORKING SPEEDS AT VARYING LENGTHS





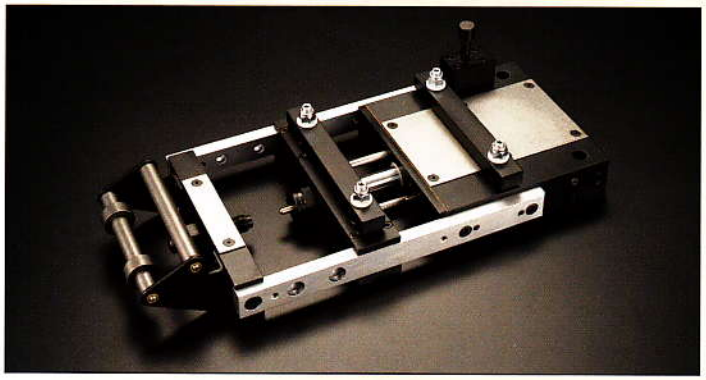


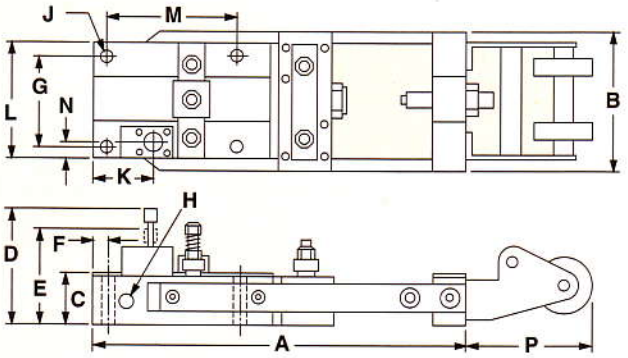




Note: All Calculations at 100 PSI (7 Bar)

AIR FEED DIMENSIONS





DIMENSIONS – inches

Model	A	B	C	D	E	F	G	H	J	K	L	M	N	P
AX2	9.38	3.62	1.29	3.55	2.84	.83	2.62	1/8 NPT	.33	2.17	3.46	–	.50	3
AX4	13.38	3.62	1.29	3.55	2.84	.83	2.62	1/8 NPT	.33	2.17	3.46	–	.50	3
AX6	17.38	3.62	1.29	3.55	2.84	.83	2.62	1/8 NPT	.33	2.17	3.46	–	.50	3
CX3	12.25	6.50	1.79	4.61	3.64	.83	4.5	1/4 NPT	.39	2.33	5.50	–	.56	3
CX6	18.25	6.50	1.79	4.61	3.64	.83	4.5	1/4 NPT	.39	2.33	5.50	–	.56	3
CX9	24.25	6.50	1.79	4.61	3.64	.83	4.5	1/4 NPT	.39	2.33	5.50	–	.56	3
CX12	30.25	6.50	1.79	4.61	3.64	.83	4.5	1/4 NPT	.39	2.33	5.50	–	.56	3
DX4	14.61	7.75	1.79	4.61	3.64	.90	5.5	1/4 NPT	.53	2.65	6.75	–	.56	3
DX6	18.61	7.75	1.79	4.61	3.64	.90	5.5	1/4 NPT	.53	2.65	6.75	–	.56	3
DX12	30.61	7.75	1.79	4.61	3.64	.90	5.5	1/4 NPT	.53	2.65	6.75	–	.56	3
FX4	17.25	9.75	2.04	4.89	3.92	.97	7.5	3/8 NPT	.66	2.80	8.75	6	.56	3
FX6	19.25	9.75	2.04	4.89	3.92	.97	7.5	3/8 NPT	.66	2.80	8.75	6	.56	3
FX9	25.25	9.75	2.04	4.89	3.92	.97	7.5	3/8 NPT	.66	2.80	8.75	6	.56	3
FX12	31.25	9.75	2.04	4.89	3.92	.97	7.5	3/8 NPT	.66	2.80	8.75	6	.56	3
HX4	17.25	12.75	2.04	4.89	3.92	.97	10.5	3/8 NPT	.66	2.80	11.75	6	.56	3
HX6	19.25	12.75	2.04	4.89	3.92	.97	10.5	3/8 NPT	.66	2.80	11.75	6	.56	3
HX9	25.25	12.75	2.04	4.89	3.92	.97	10.5	3/8 NPT	.66	2.80	11.75	6	.56	3
HX12	31.25	12.75	2.04	4.89	3.92	.97	10.5	3/8 NPT	.66	2.80	11.75	6	.56	3
LX6	21.12	16.75	2.30	5.15	4.18	1.00	14.0	1/2 NPT	.66	3.00	15.75	6	.56	3.62
LX12	33.12	16.75	2.30	5.15	4.18	1.00	14.0	1/2 NPT	.66	3.00	15.75	6	.56	3.62

DIMENSIONS – mm

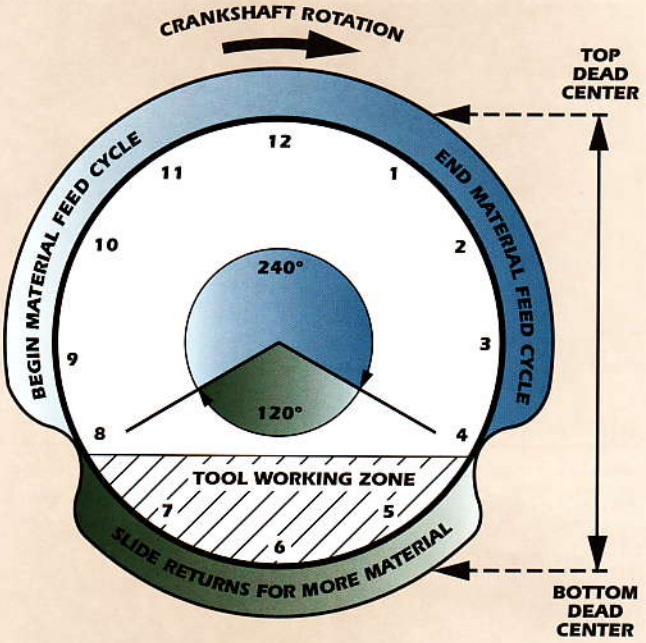
Model	A	B	C	D	E	F	G	H	J	K	L	M	N	P
AX2	238	92	33	90	72	21	66,5	1/8 NPT	8,4	55	88	–	13	80
AX4	339	92	33	90	72	21	66,5	1/8 NPT	8,4	55	88	–	13	80
AX6	441	92	33	90	72	21	66,5	1/8 NPT	8,4	55	88	–	13	80
CX3	311	165	45,5	117	92	21	114	1/4 NPT	10	59	140	–	14	80
CX6	464	165	45,5	117	92	21	114	1/4 NPT	10	59	140	–	14	80
CX9	616	165	45,5	117	92	21	114	1/4 NPT	10	59	140	–	14	80
CX12	769	165	45,5	117	92	21	114	1/4 NPT	10	59	140	–	14	80
DX4	371	197	45,5	117	92	23	140	1/4 NPT	13,5	67	172	–	14	80
DX6	473	197	45,5	117	92	23	140	1/4 NPT	13,5	67	172	–	14	80
DX12	777	197	45,5	117	92	23	140	1/4 NPT	13,5	67	172	–	14	80
FX4	438	248	52	124	100	24,6	190,5	3/8 NPT	16,7	71	223	152,4	14	80
FX6	489	248	52	124	100	24,6	190,5	3/8 NPT	16,7	71	223	152,4	14	80
FX9	641	248	52	124	100	24,6	190,5	3/8 NPT	16,7	71	223	152,4	14	80
FX12	794	248	52	124	100	24,6	190,5	3/8 NPT	16,7	71	223	152,4	14	80
HX4	438	329	52	124	100	24,6	267	3/8 NPT	16,7	71	299	152,4	14	80
HX6	489	329	52	124	100	24,6	267	3/8 NPT	16,7	71	299	152,4	14	80
HX9	641	329	52	124	100	24,6	267	3/8 NPT	16,7	71	299	152,4	14	80
HX12	794	329	52	124	100	24,6	267	3/8 NPT	16,7	71	299	152,4	14	80
LX6	536	425	58,4	131	106	25,4	355,6	1/2 NPT	16,7	76	400	152,4	14	92
LX12	841	425	58,4	131	106	25,4	355,6	1/2 NPT	16,7	76	400	152,4	14	92

PRESS FEED TIMING & SEQUENCE

The Reciprocating Linear Motion of the Feed Slide must be timed to the press crankshaft rotation for optimum performance. The Actuating Valve's vertical motion initiates the sequencing of the Stock Clamp, Feed Clamp, and the Feed Slide.

To understand how the rotary crankshaft and linear Feed Slide motion work together in a Press Feed Cycle, it might be helpful to visualize a Clock Face. The position "Top Dead Center" of the Ram Stroke would be 12 o'clock, half way down would be 3 o'clock, "Bottom Dead Center" is 6 o'clock, and moving half way up would be 9 o'clock.

The optimum Feed cycle requires two thirds of the crankshaft rotation (240 degrees) to feed the material into position. During the remaining 120 degrees, the Feed Slide returns to the Stop Screw for more Material. As soon as the Stamped Part has been **ejected** and the Punches are clear of the Die (approximately 8 to 8:30 on the clock), the Feed Clamp will grip the Stock and then the Feed Slide will begin moving towards the Feed Body.

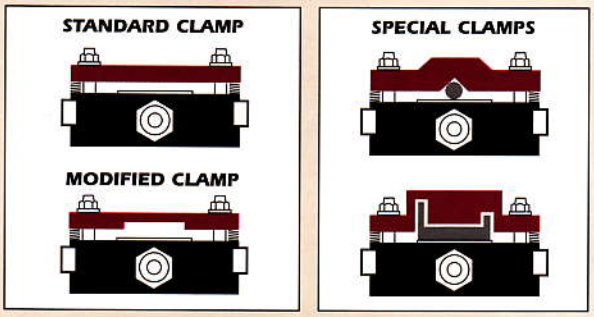


FEEDING SHAPED MATERIAL

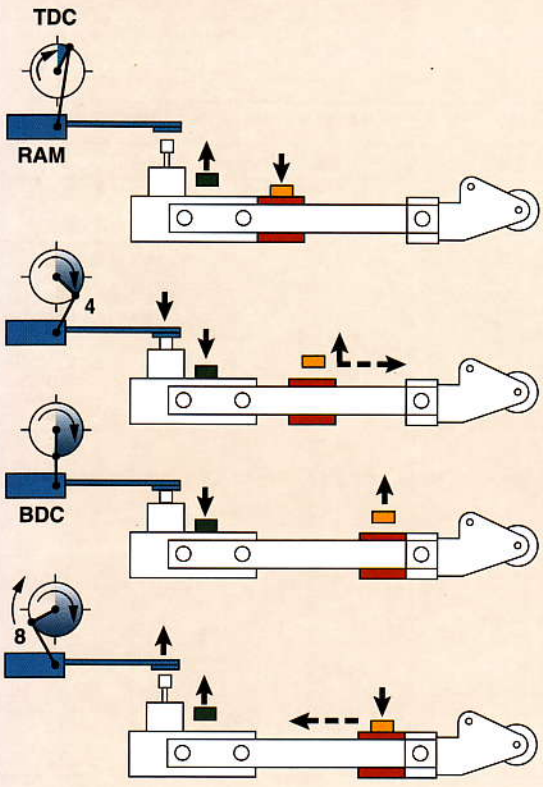
The Feed and Stock Clamps can be modified by machining to accommodate different material shapes and configurations. Round or square tubing, wire, or any pre-stamped product like electrical terminals and contacts can be easily handled.

Damage to delicate, pliable materials can be avoided by inserting leather, rubber or nylon into the machined clamps.

You can fabricate oversized clamps for special materials such as channel, extrusions, bars and other irregularly shaped materials.



AIR FEED SEQUENCE



Actuating Valve up
Feed Slide forward
Stock Clamp open
Feed Clamp closed

AT TOP OF PRESS STROKE

Actuating Valve down
Stock Clamp closes
Feed Clamp opens
Feed Slide moves back

AT BEGINNING OF NON-FEED STROKE

Feed Slide rests against Stop Screw
Stock Clamp closed
Feed Clamp open

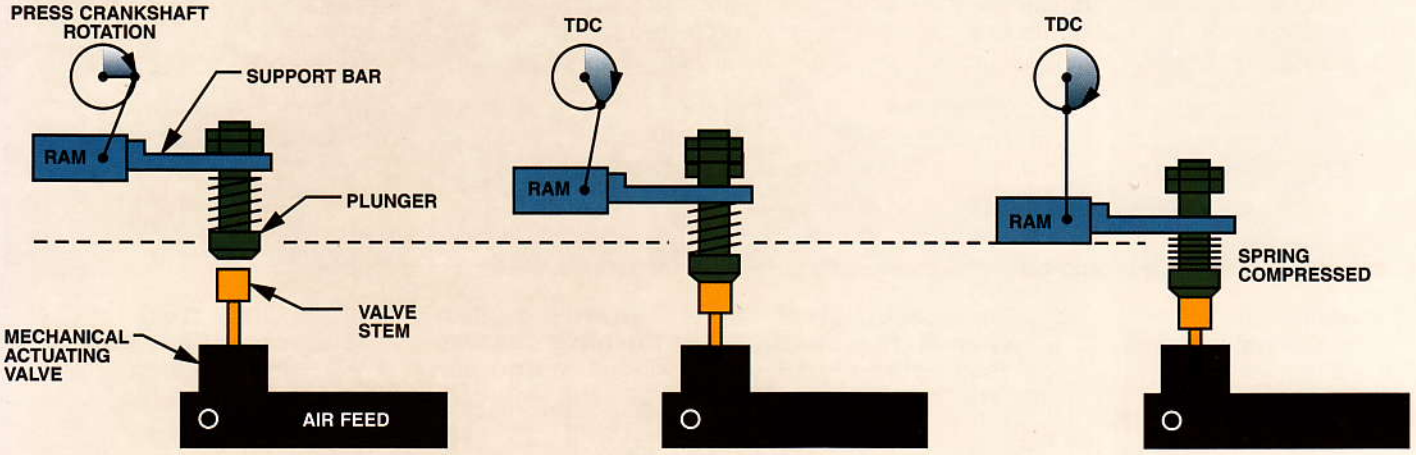
AT END OF NON-FEED STROKE

Actuating Valve up
Feed Clamp closes
Stock Clamp opens
Feed Slide moves forward

AT BEGINNING OF FEED STROKE

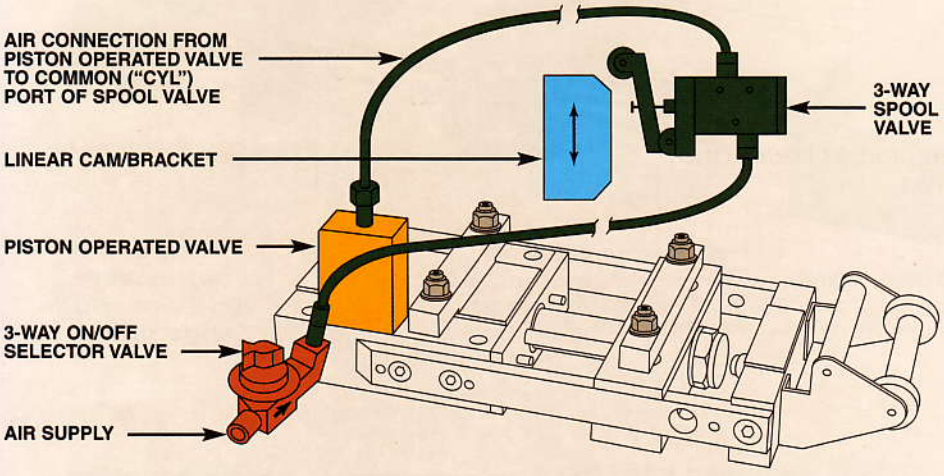
METHODS OF CONTROLLING THE FEED

1. MECHANICAL ACTUATION

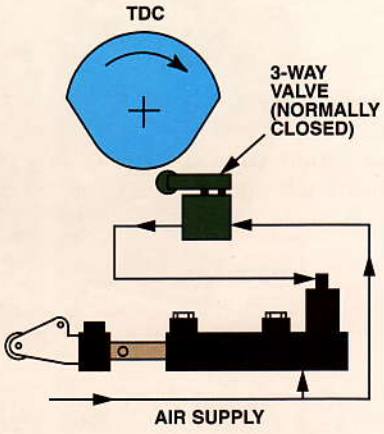


2. REMOTE PNEUMATIC ACTUATION

LINEAR CAM OPERATION

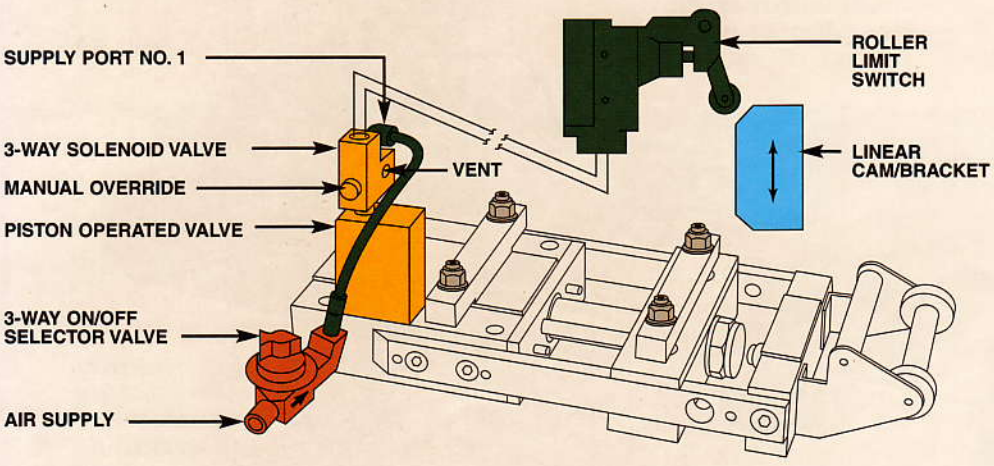


ROTARY CAM OPERATION

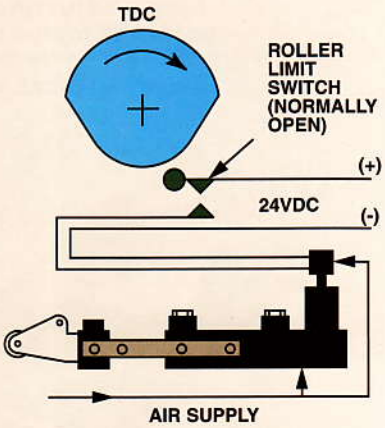


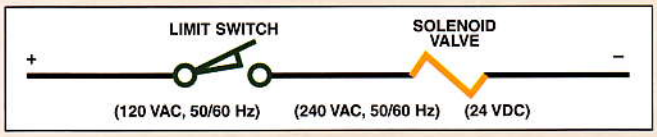
3. REMOTE ELECTRIC ACTUATION

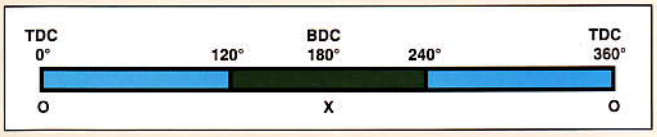
LINEAR CAM OPERATION



ROTARY CAM OPERATION







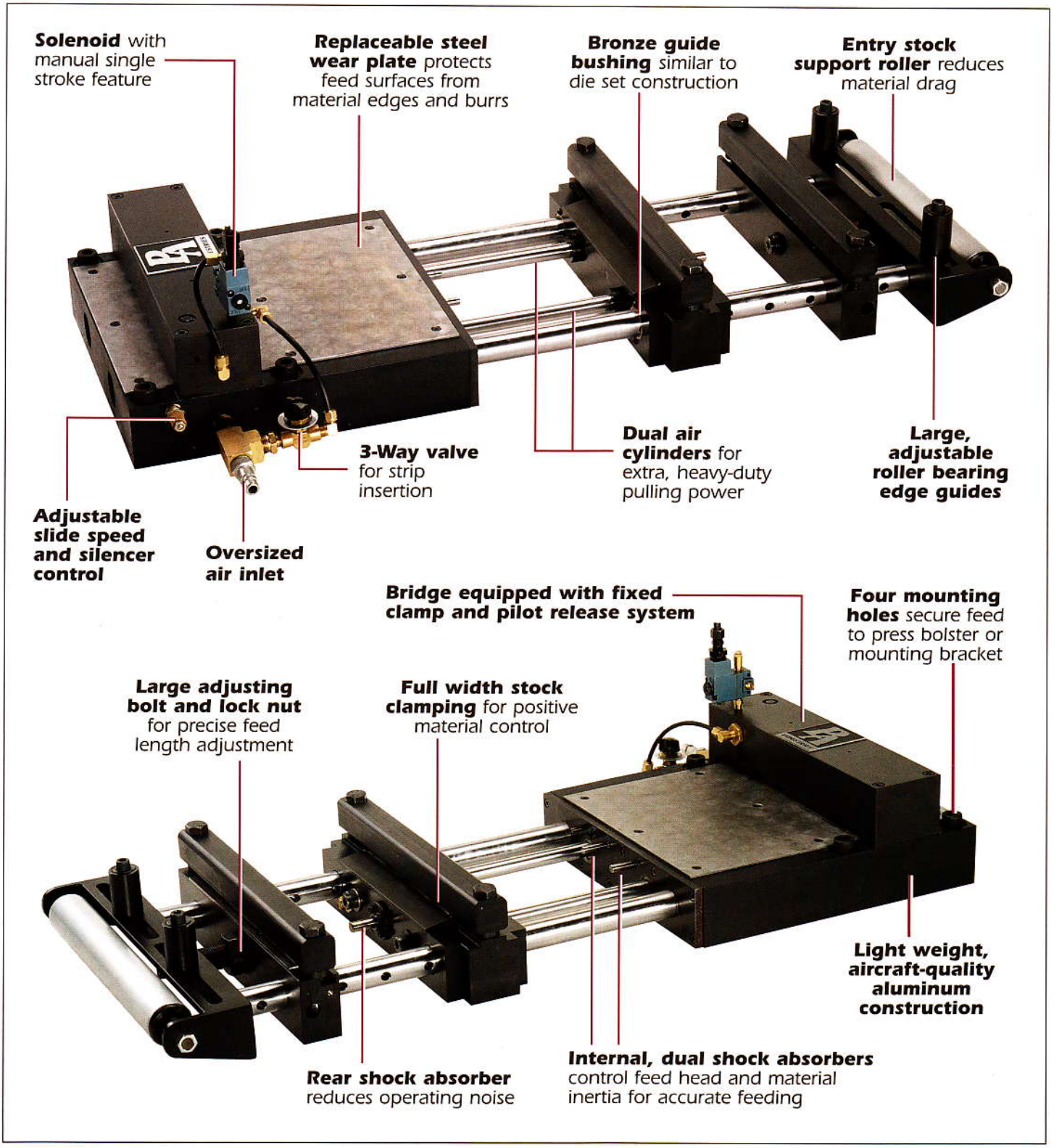
HEAVY DUTY AIR FEED

After a decade of research, this revolutionary feeding device was introduced in 1992 by P/A, the world leader in developing high performance, low maintenance, precision Air Feeds.

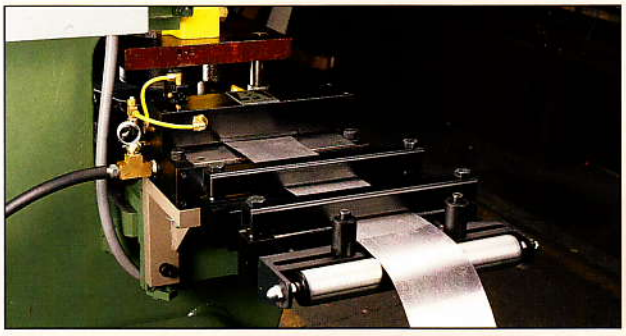
The compact construction utilizes a **patented, automatic control** that synchronizes all feeding functions with a momentary signal from a limit switch.

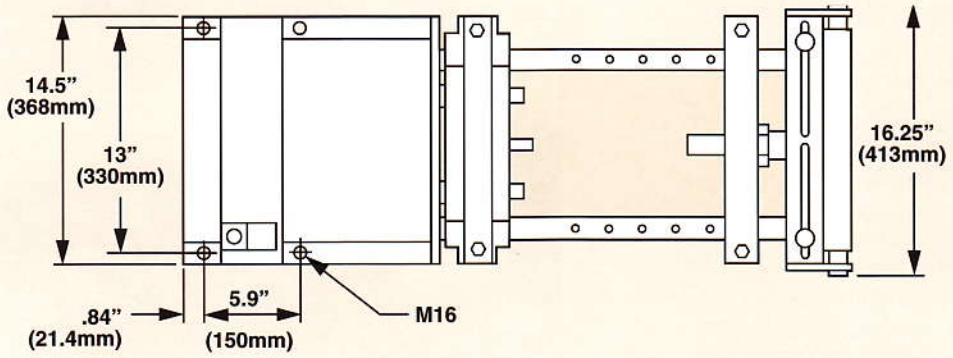
The Heavy Duty Air Feed was computer designed with the latest pneumatic technology for optimal performance and is protected by U.S. Patents No. 4,329,897, No. 4,140,261, and No. 5,125,550.

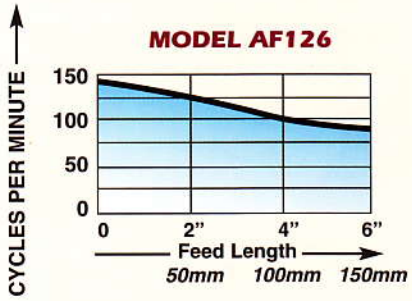
This feed represents the latest generation of advanced technology for heavy duty performance and low maintenance.

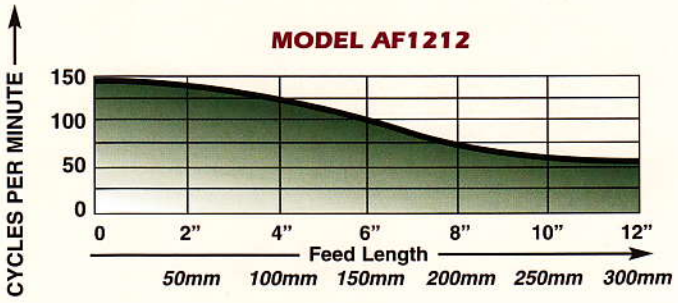


HEAVY DUTY AIR FEED DIMENSIONS & SPECIFICATIONS









SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Feed Length (In.)	Pulling Power Note 1 (Lbs.)	Max. Stock Thickness Note 2 (In.)	Feed Grip Force (Lbs.)	Fixed Clamp Force (Lbs.)	Speed Note 3 (SPM)	Air Consumption Per Cycle (CF)	Shipping Weight (Lbs.)
AF126	12	0-6	295	.128	1200	330	85	.023	135
AF1212	12	0-12	295	.128	1200	330	65	.035	155

SPECIFICATIONS – METRIC

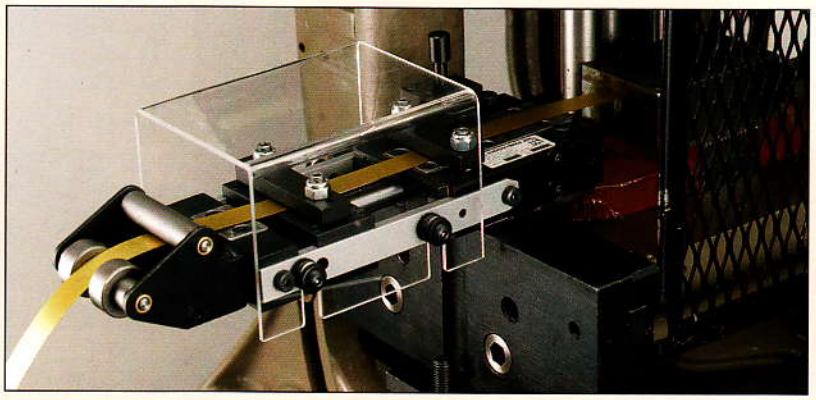
Model	Max. Stock Width (mm)	Feed Length (mm)	Pulling Power Note 1 (Kg)	Max. Stock Thickness Note 2 (mm)	Feed Grip Force (Kg)	Fixed Clamp Force (Kg)	Speed Note 3 (SPM)	Air Consumption Per Cycle (L)	Shipping Weight (Kg)
AF126	300	0-150	135	3.25	565	150	85	0.64	65
AF1212	300	0-300	135	3.25	565	150	65	0.98	70

Note 1: Recommended operating pressure 80 – 120 PSI (6 – 8 Bar).
Note 2: Maximum clearance .150" (3.8mm).
Note 3: Approximate speed at maximum feed length with light weight material. Speed will decrease as the weight of cross sectional strip area being fed increases.

PROTECTIVE COVER

P/A Industries **strongly recommends** our see-through cover of Plexiglas or expanded metal for operator protection. Pre-drilled holes in the Guide Rail accept the Slip-Fit Fasteners that secure the Cover over the top and sides of the Feed. The Protective Cover further protects the Feed from dirt, oil, chips, and other harmful materials.

AX, CX, DX, and FX models are Plexiglas while HX and LX models are made of rugged, expanded metal.



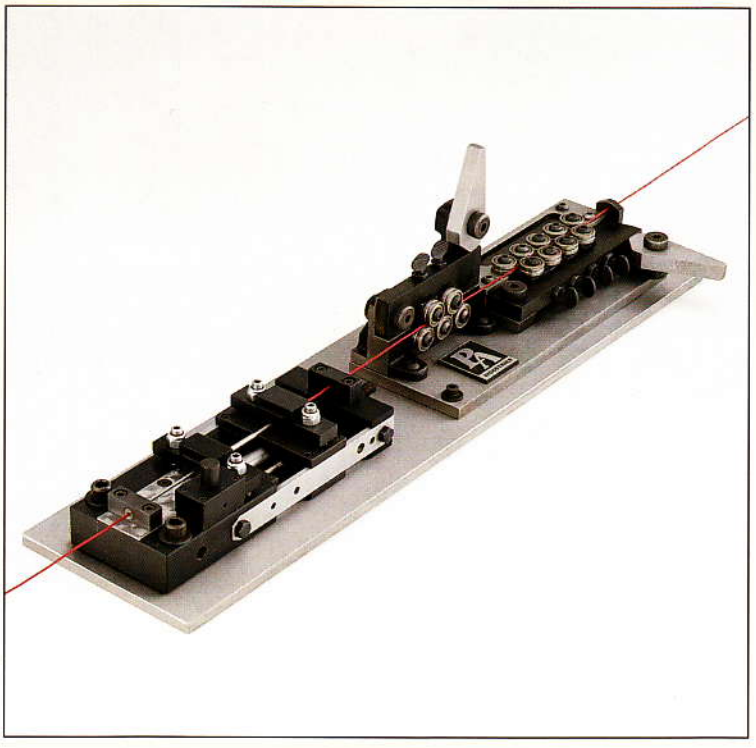
COIL SET ELIMINATOR

The Coil Set Eliminator uses a unique method of removing the natural curve from coiled materials. Steel mills use the same principle of bending the material beyond its yield point to remove the set. This is different from conventional stock straighteners. These inexpensive units can be mounted on the back of any type of press feed and require very little pulling power. Specify material width and thickness with order. Note: This unit is no recommended for material thickness greater than .030" (0.7mm).

WIRE FEED

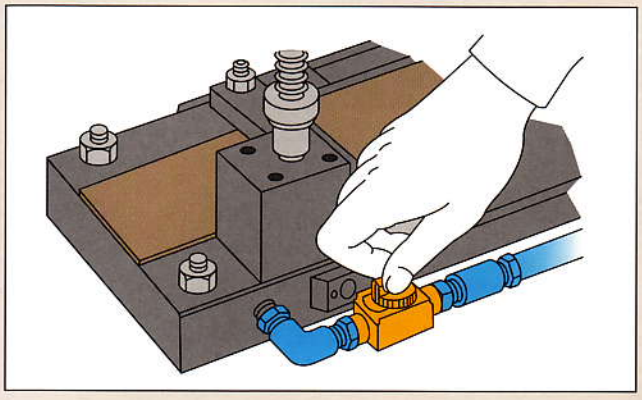
The installation of stainless steel telescoping tubes with specially sized guide bushings, enable the Air Feed to carry wire smoothly and accurately to the machine. Whip and buckling problems disappear when using the Wire Feed for round, or nearly round materials, over both long and short progressions. Used on AX and CX models only. Wire Straightener sold separately.

Model	Bushing Size (In.)	Max. Feed Length (In.)	Bushing Size (mm)	Max. Feed Length (mm)
AX2	.014 – .023	1.750	0,35-0,59	44
AX2	.024 – .035	1.750	0,60-0,89	44
AX2	.036 – .059	1.750	0,90-1,50	44
AX4	.014 – .023	3.500	0,35-0,59	89
AX4	.024 – .035	3.500	0,60-0,89	89
AX4	.036 – .059	3.500	0,90-1,50	89
AX6	.014 – .023	5.375	0,35-0,59	136
AX6	.024 – .035	5.375	0,60-0,89	136
AX6	.036 – .059	5.375	0,90-1,50	136
CX3	.036 – .059	2.625	0,90-1,50	66
CX3	.060 – .090	2.625	1,50-2,29	66
CX3	.085 – .132	2.625	2,15-3,35	66
CX6	.036 – .059	5.500	0,90-1,50	139
CX6	.060 – .090	5.500	1,50-2,29	139
CX6	.085 – .132	5.500	2,15-3,35	139
CX9	.036 – .059	8.000	0,90-1,50	203
CX9	.060 – .090	8.000	1,50-2,29	203
CX9	.085 – .132	8.000	2,15-3,35	203
CX12	.036 – .059	11.375	0,90-1,50	289
CX12	.060 – .090	11.375	1,50-2,29	289
CX12	.085 – .132	11.375	2,15-3,35	289



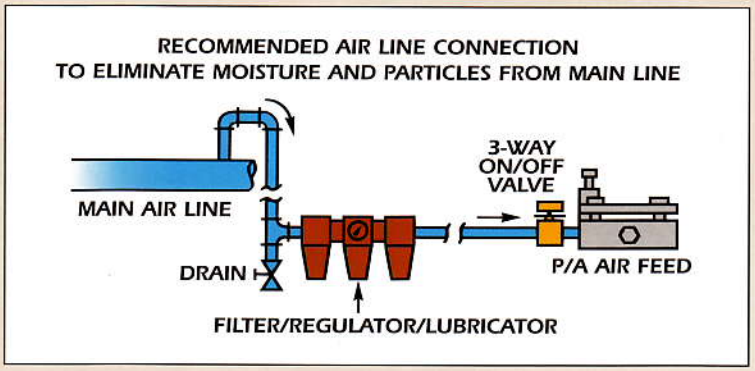
3-WAY ON/OFF EXHAUST VALVE

The use of a 3-Way On/Off Exhaust Valve will make minor adjustments and strip insertion easier.



FILTER/REGULATOR/LUBRICATOR

The Filter/Regulator/Lubricator (FRL) supplies clean filtered air, regulates pressure, and provides oil mist lubrication for maintenance-free operation.



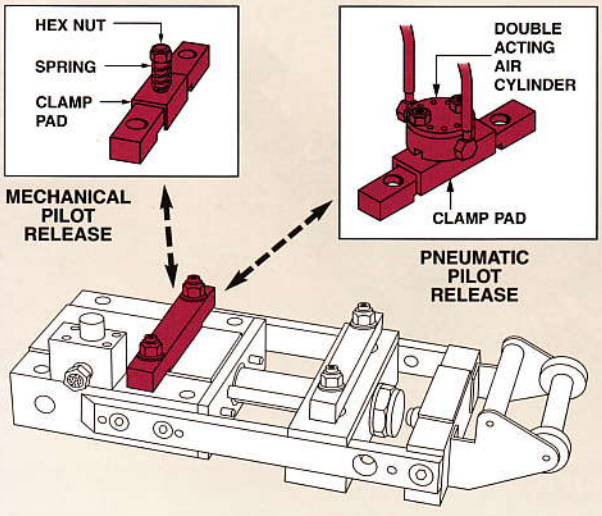
PILOT RELEASE METHODS

Mechanical Pilot Release

Standard on P/A Air Feeds, this Adjustable Spring Clamp provides pressure to the material, holding it until the pilot pin pulls into position. Note: Not available on LX models.

Pneumatic Pilot Release

For those applications that require more sensitive clamping pressure, or that the Clamp pad be completely free of the material, use the Pneumatic Pilot Release with all P/A Air Feeds. The Clamp Pad is fitted with a quick-response cylinder for positive stock grip and release. Timing is controlled by a 4-Way Solenoid Valve or Spool Valve.

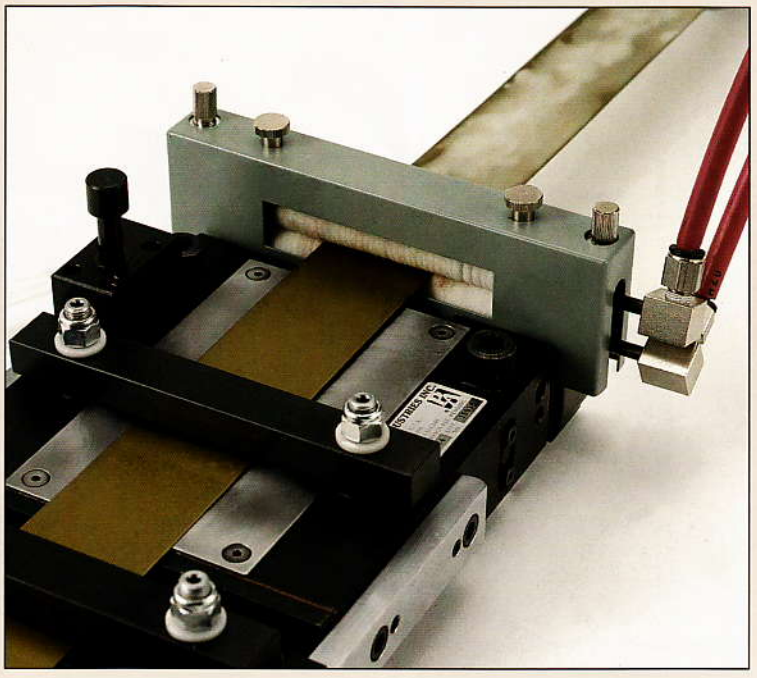


Internal Pilot Release

This internal valving system provides up to 270 lbs. (120 Kg) of clamping force with the standard clamp and is available on the LX model. The Internal Pilot Release controls the release of the Stock Clamp with a timed air signal connected to the 1/8" NPT port. This feature gives you the option of using pilot release, or not,without the downtime necessary for changing clamps. One switch turns the system on or off.

SLIM LINE STOCK OILER

A Gravity Fed Stock Oiler can be mounted on the main body of the Feed to apply stamping and drawing oils to the material as it is fed into the die. When you apply an even coat of oil on the strip after the material passes through the feed clamps, the misfeeding caused by hydroplaning is avoided. The Slim Line Oilers were designed specifically for our Air Feeds and come with feed mounting brackets for CX, DX, FX, and HX Models.



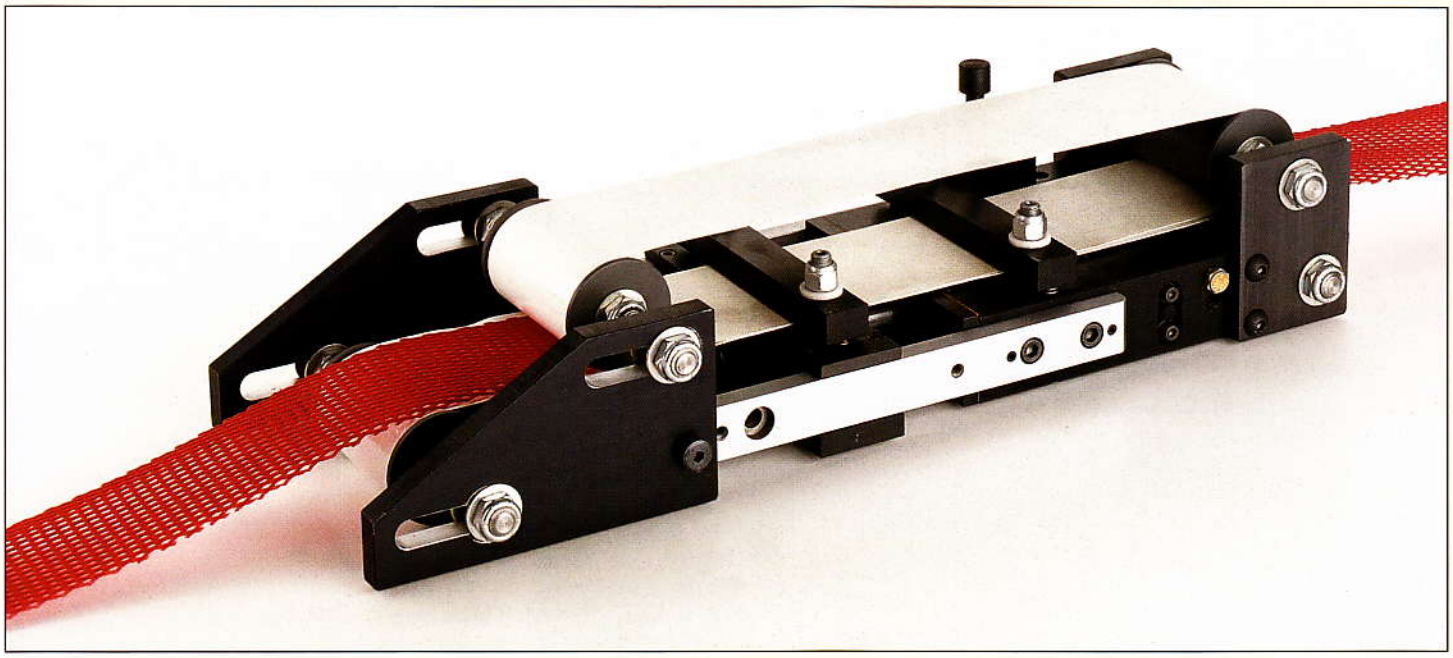
REPEATER CONTROL SYSTEM

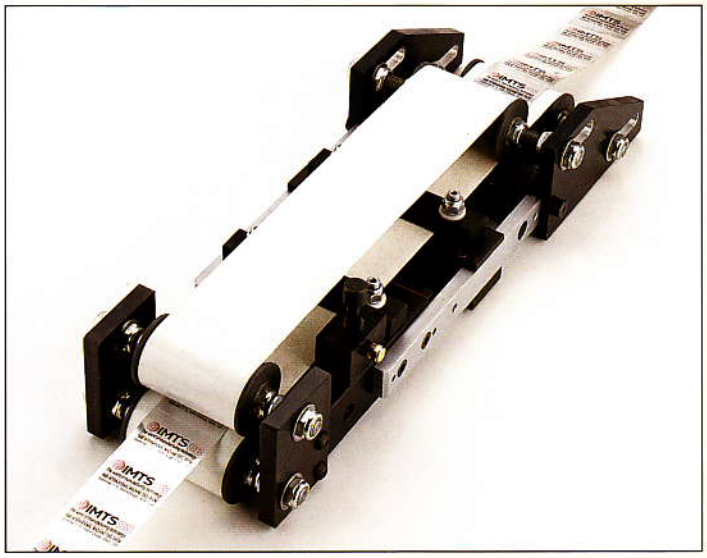
The Air Feed can be multiple stroked for each cycle of the Press to obtain greater feed length increments than the Air Feed's maximum feed stroke capacity. The Repeater Control has a digital counter and Key Lock Selector Control for Feed Control Press" or "Press Control Feed". Used with Remote Electric Actuation and 120 VAC, 50/60 Hz Power Supply. Transformers for other voltages are available.

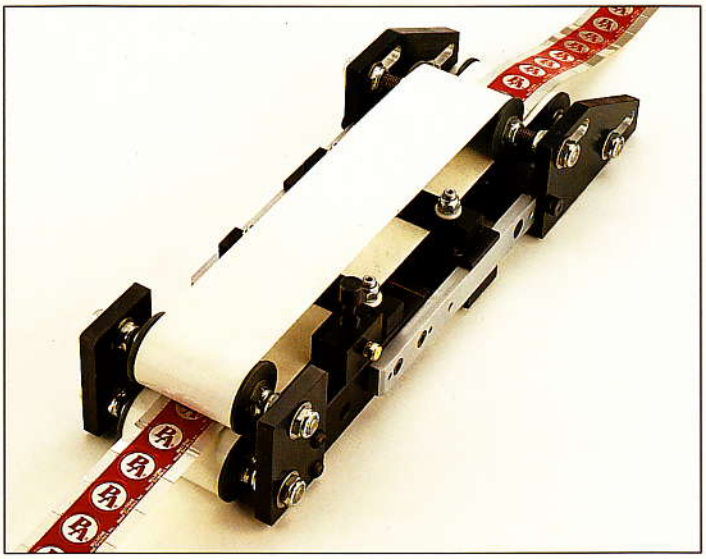
BAND FEED

Over two decades ago, P/A engineers came up with this innovative approach to solving the problems of indexing very limp and delicate materials. Material such as foil, film, paper, fabric, mylar, and teflon are easily handled by the Band Feed.

Thin, delicate material is sandwiched between two endless belts which the Air Feed then clamps and feeds. Marking, tearing, and buckling are completely eliminated while moving the material into, or out of, the work station accurately — cycle after cycle.







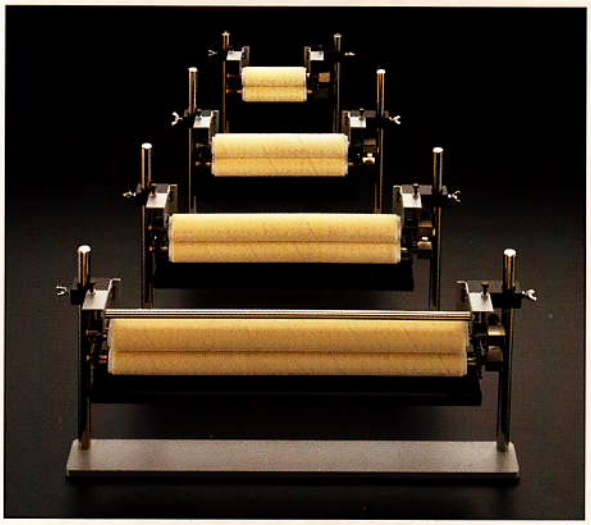
SPECIFICATIONS – USA

Model	Width (In.)	Length (In.)	Pulling Force (Lbs.)	Speed (SPM)
BFCX3	3	3	50	180
BFCX6	3	6	50	120
BFCX9	3	9	50	80
BFCX12	3	12	50	70
BFFX6	6	6	110	100
BFFX9	6	9	110	70
BFFX12	6	12	110	60
BFHX6	9	6	110	80
BFHX12	9	12	110	50

SPECIFICATIONS – METRIC

Model	Width (mm)	Length (mm)	Pulling Force (Kg)	Speed (SPM)
BFCX3	76	76	23	180
BFCX6	76	150	23	120
BFCX9	76	230	23	80
BFCX12	76	300	23	70
BFFX6	150	150	50	100
BFFX9	150	230	50	70
BFFX12	150	300	50	60
BFHX6	230	150	50	80
BFHX12	230	300	50	50

STOCK OILER



The Stock Oiler has been designed to accommodate any type or thickness of material. Its revolutionary roller assembly pivots to accommodate material movement and crown, camber, or unstraightened stock.

Any kind of liquid lubricant is evenly distributed to the absorbent felt roller by a predrilled PVC inner tube that rides in an oil bearing bath.

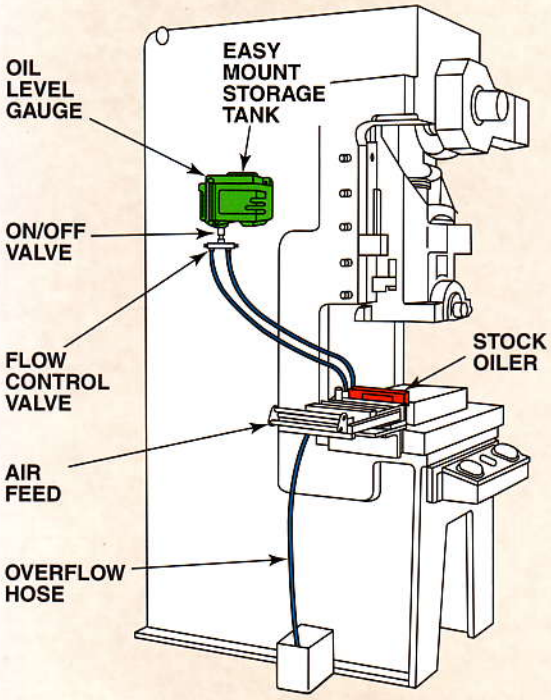
Oil flow to each roller is individually controlled by metering valves which are installed on a reservoir tank that is equipped with an oil level gauge.

Adjustable tension springs help to apply the right oil film by supplying enough pressure to squeeze off any excess which is then recycled to the unit.

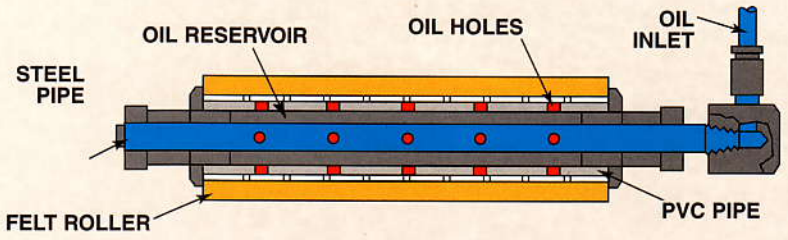
Mounting the compact Stock Oiler between the press feed and tool is easily done by attaching a magnet on the steel base, or drilling two holes. Two wing nuts allow for quick pass line height adjustment to suit different tools.

The use of the Stock Oiler increases die life and eliminates the "coffee-can" mess which makes your operation safer and more efficient.

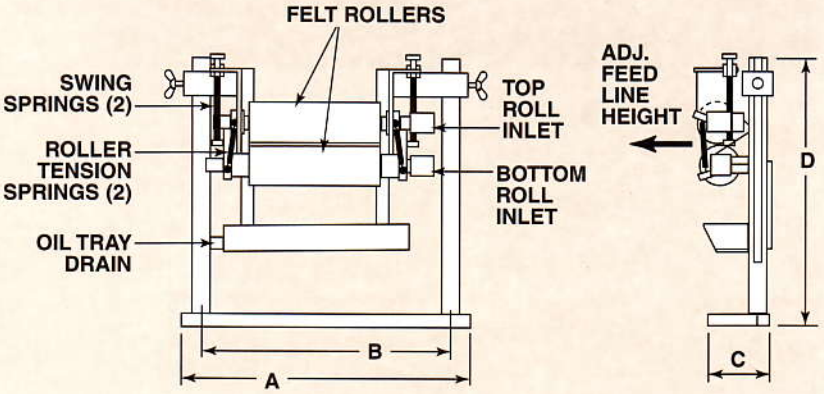
OIL FLOW SYSTEM



OIL FLOW TO ROLLER



DIMENSIONS



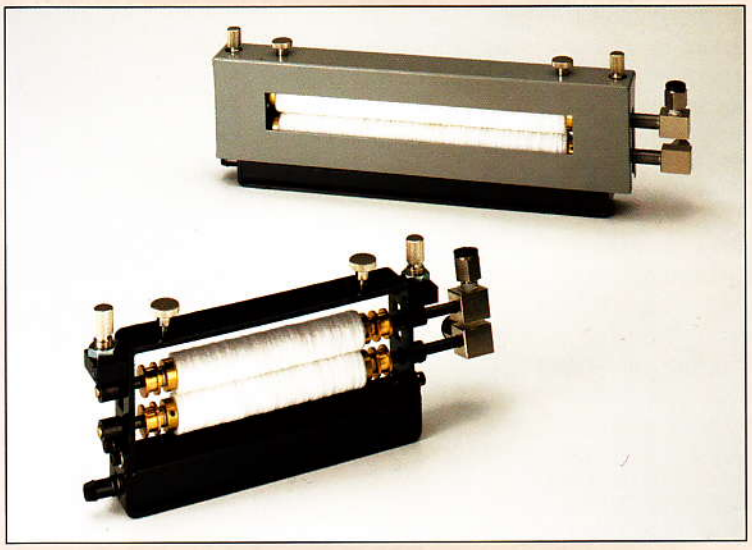
SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Thickness Range (In.)	Tank Size (Gal.)	Shipping Weight (Lbs.)	Shipping Weight with Tank (Lbs.)	Dimensions (Inches) A	B	C	D
SO-100	4	.001 – .187	1	7	11	9.25	7.97	2	7.87
SO-200	8	.001 – .187	1	8	12	13.07	11.87	2	9.84
SO-300	12	.001 – .187	1	10	14	17.20	16.00	2	9.84
SO-400	16	.001 – .187	1	12	16	21.06	19.90	2	9.84
SO-600	24	.001 – .187	1	16	20	29.13	27.93	2	9.84

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Thickness Range (mm)	Tank Size (Ltr)	Shipping Weight (Kg)	Shipping Weight with Tank (Kg)	Dimensions (mm) A	B	C	D
SO-100	100	0.03 – 4.68	3.8	3.2	5.0	235	202	51	200
SO-200	200	0.03 – 4.68	3.8	3.6	5.4	332	301	51	250
SO-300	300	0.03 – 4.68	3.8	4.5	6.4	437	406	51	250
SO-400	400	0.03 – 4.68	3.8	5.4	7.3	535	505	51	250
SO-600	600	0.03 – 4.68	3.8	7.3	9.1	740	709	51	250

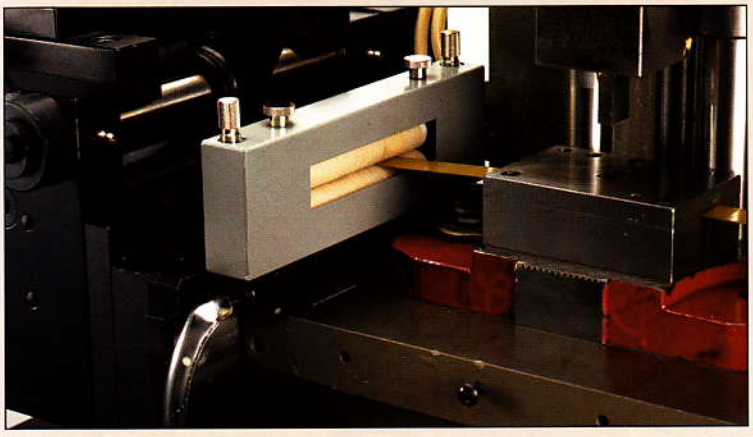
SLIM LINE OILER



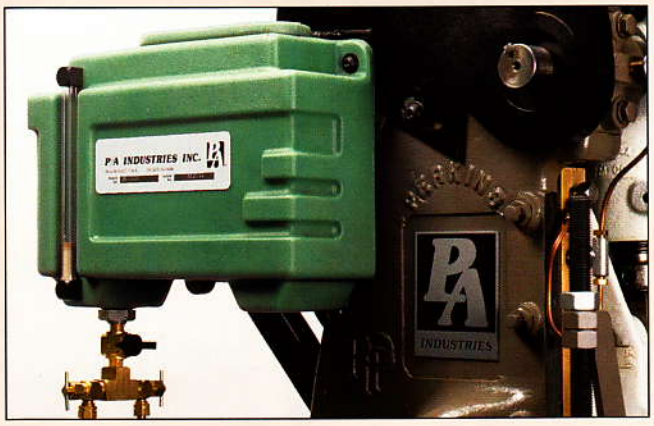
Improve die life by applying the right amount of oil just before the material enters the die set. Clean up the press area by installing "Slim Line" gravity fed stock oilers.

A durable storage tank mounts to the side of the press and is equipped with a liquid sight gauge, screen filter, removable fill lid, on/off valve, and separate flow control valves for top and bottom rollers.

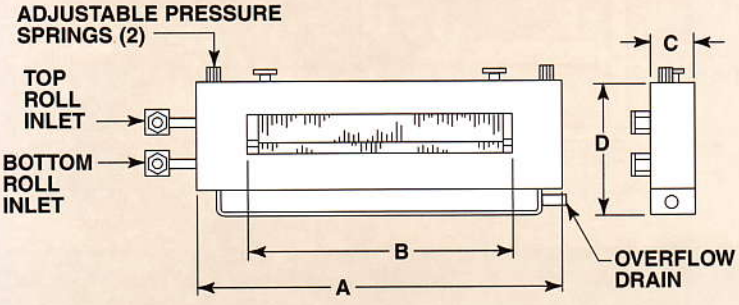
The head assembly is designed for compactness and allows mounting very close to the tool. Oil flow is delivered to predrilled manifolds with extra absorbent felt roller washers providing uniform film on coil stock. Upper roll pressure is applied by adjustable springs. Overflow return line handles excess oil which is then reusable.

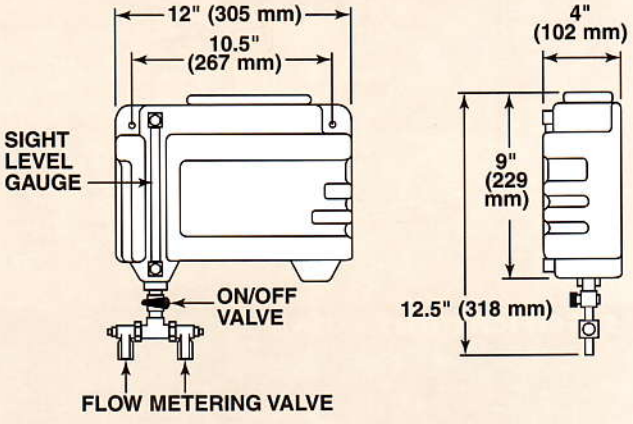


OIL STORAGE TANK



DIMENSIONS





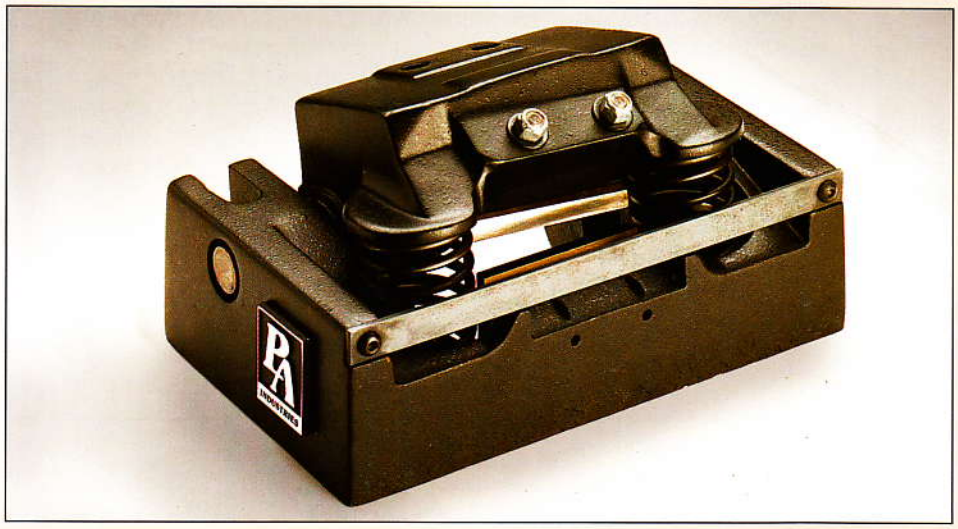
SPECIFICATIONS – USA

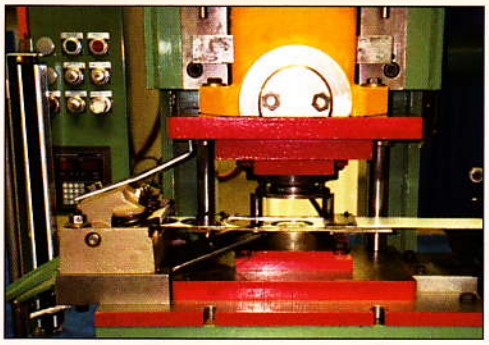
Model	Max. Stock Width (In.)	Thickness Range (In.)	Tank Size (Gal.)	Shipping Weight (Lbs.)	Shipping Weight with Tank (Lbs.)	Dimensions (Inches) A	B	C	D
SL-100	4	.001 – .060	1	8	12	8	4.5	1	3.5

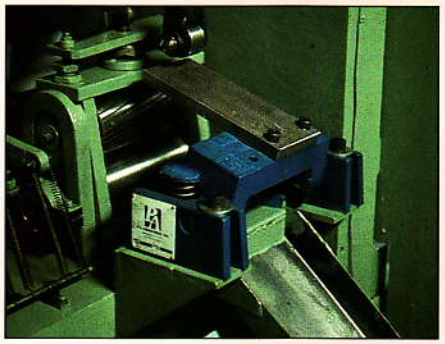
SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Thickness Range (mm)	Tank Size (Ltr)	Shipping Weight (Kg)	Shipping Weight with Tank (Kg)	Dimensions (mm) A	B	C	D
SL-100	100	0.03 – 1.50	3.8	3.6	5.4	203	114	25	89

MECHANICAL SCRAP CHOPPER







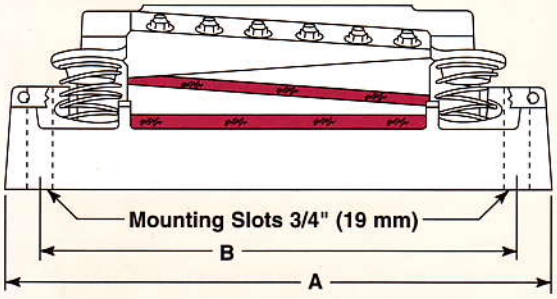
The P/A Scrap Chopper has a unique helical-ground blade which chops a wide variety of materials from .004" (0.1mm) paper to 3/16" (4.8mm) CRS without adjustment. Once installed, any number of stock thicknesses and widths can be fed into the chopper without any additional set-up time.

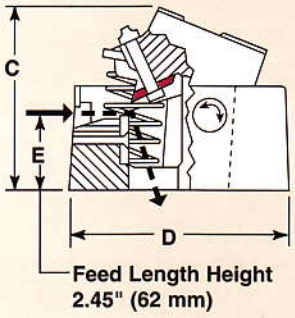
With a P/A Scrap Chopper mounted on your machine, you eliminate the need for air blow-offs, sheet metal chutes, conveyors and rakes used by operators to get the scrap out of the tool area and into containers.

Providing one chopper per press can save the cost of designing and building guillotine choppers for every die.

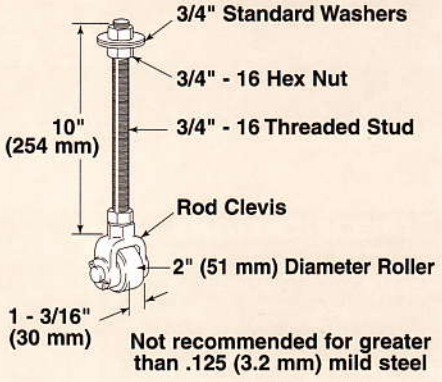
Rugged cast iron construction with few moving parts assures maintenance-free production. The Reel-Type scissor action reduces off center loading by chopping a width of only 14 times the maximum material thickness at one time regardless of total stock width.

DIMENSIONS





ROLLER ACTIVATION



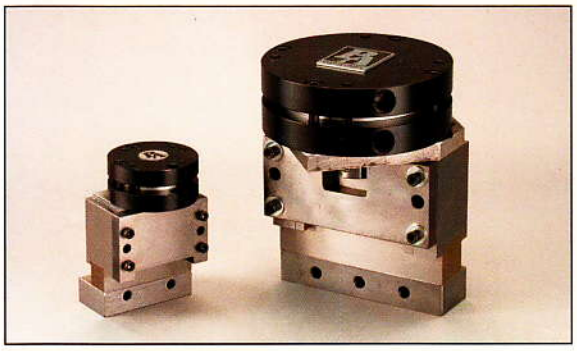
SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Max. SPM Full Width	Shipping Weight (Lbs.)	Dimensions (In.)				
					A	B	C	D	E
SC-3	3	.004 – .187 CRS	750	45	10.6	8.5	5.75	6.8	2.45
SC-6	6	.004 – .187 CRS	650	52	13.6	11.5	5.84	6.8	2.45
SC-9	9	.004 – .187 CRS	550	60	16.6	14.5	5.94	6.8	2.45
SC-12	12	.004 – .187 CRS	450	68	19.6	17.5	6.03	6.8	2.45

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Max. SPM Full Width	Shipping Weight (Kg)	Dimensions (mm)				
					A	B	C	D	E
SC-3	76	0.1 – 5.0 CRS	750	20	269	216	146	173	62
SC-6	152	0.1 – 5.0 CRS	650	24	345	292	148	173	62
SC-9	229	0.1 – 5.0 CRS	550	27	422	368	151	173	62
SC-12	305	0.1 – 5.0 CRS	450	31	498	445	153	173	62

PNEUMATIC STOCK CUTTER



Compact Design. This precision shear is equipped with two steel blades to handle paper thin and thicker material.

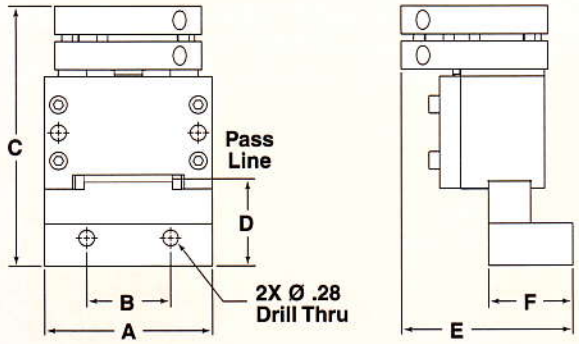
The shearing blade has two cutting surfaces and the stationary lower blade has four. After the blade gets dull, simply rotate the blades to expose a new sharp edge.

Long life, double acting cylinders come in three bore sizes, 1-1/2 , 4 and 6 inch (38, 100 and 150 mm), to provide different cutting capacity.

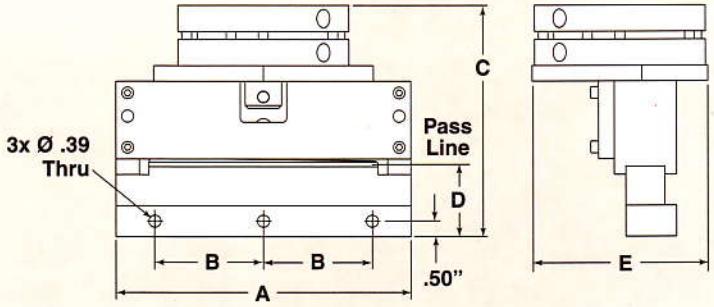
Optional carbide blades, multi-stroke counters and solenoid valve (24 VDC, 120 VAC, 50/60 Hz) are available.

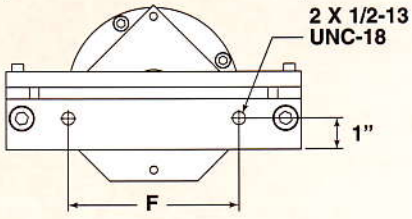
DIMENSIONS

PSC-1.5



PSC-3, PSC-5, PSC-7





Model	A	B	C	D	E	F
DIMENSIONS – Inches						
PSC-1.5	3.0	1.5	4.63	1.5	3.06	1.5
PSC-3	5.5	1.5	7.44	2.25	5.66	1.5
PSC-3X	5.5	1.5	9.31	2.25	5.66	1.5
PSC-5	7.5	2.5	7.44	2.25	5.66	3.5
PSC-5X	7.5	2.5	9.31	2.25	5.66	3.5
PSC-7	9.5	3.5	7.44	2.25	5.66	5.5
PSC-7X	9.5	3.5	9.31	2.25	5.66	5.5

Model	A	B	C	D	E	F
DIMENSIONS – Metric						
PSC-1.5	76	38	118	38	78	38
PSC-3	140	38	189	57	144	38
PSC-3X	140	38	236	57	144	38
PSC-5	190	63.5	189	57	144	89
PSC-5X	190	63.5	236	57	144	89
PSC-7	241	89	189	57	144	140
PSC-7X	241	89	236	57	144	140

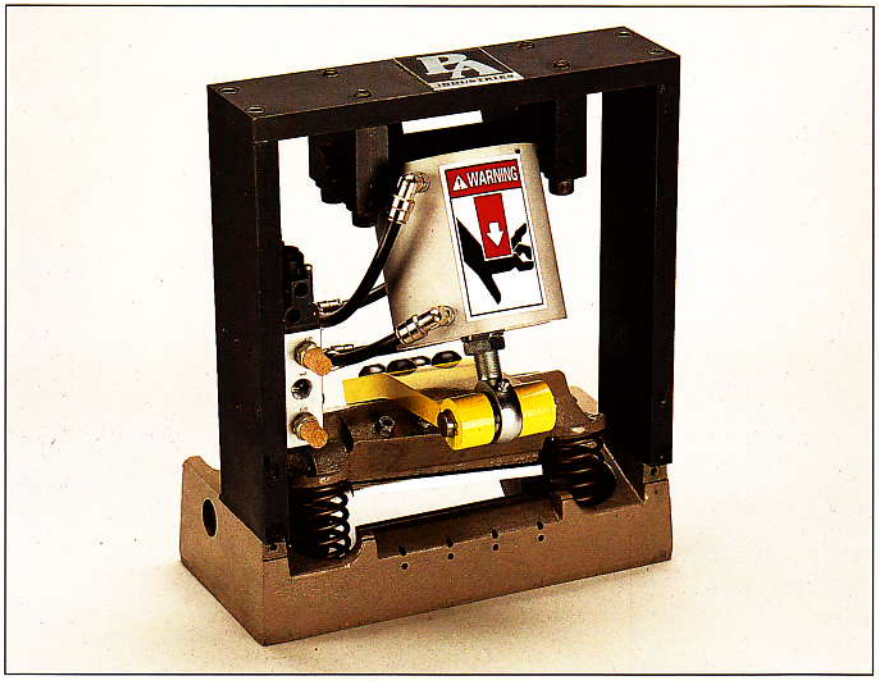
SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Max. Material Thickness at Full Width (In.) Aluminum Brass	C.R. Steel	Stainless Steel	Cylinder Diameter (In.)	Stock Max. Force (Lbs.) at 100 PSI	Air Consumption at Max. SPM and 100 PSI	Shipping Weight (Lbs.)
PSC-1.5	1.5	0.021	0.011	0.009	1.5	176	3 CFM	5.5
PSC-3	3	0.057	0.030	0.024	4	1256	14 CFM	25.5
PSC-3X	3	0.085	0.044	0.036	6	2764	25 CFM	26.0
PSC-5	5	0.057	0.030	0.024	4	1256	14 CFM	31.0
PSC-5X	5	0.085	0.044	0.036	6	2764	25 CFM	31.5
PSC-7	7	0.057	0.030	0.024	4	1256	14 CFM	36.5
PSC-7X	7	0.085	0.044	0.036	6	2764	25 CFM	37.0

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Max. Material Thickness at Full Width (mm) Aluminum Brass	C.R. Steel	Stainless Steel	Cylinder Diameter (mm)	Stock Max. Force (N) at 6.8 Bar	Air Consumption at Max. SPM and 6.8 Bar	Shipping Weight (Kg)
PSC-1.5	38	.53	0.3	0.2	38	778	1.4 L/sec	2.5
PSC-3	76	1.58	0.8	0.6	100	5600	6.6 L/sec	11.6
PSC-3X	76	2.2	1.1	0.9	150	12300	11.8 L/sec	11.8
PSC-5	127	1.5	0.8	0.6	100	5600	6.6 L/sec	14.1
PSC-5X	127	2.2	1.1	0.9	150	12300	11.8 L/sec	14.3
PSC-7	178	1.5	0.8	0.6	100	5600	6.6 L/sec	16.6
PSC-7X	178	2.2	1.1	0.9	150	12300	11.8 L/sec	16.8

AIR SCRAP CHOPPER

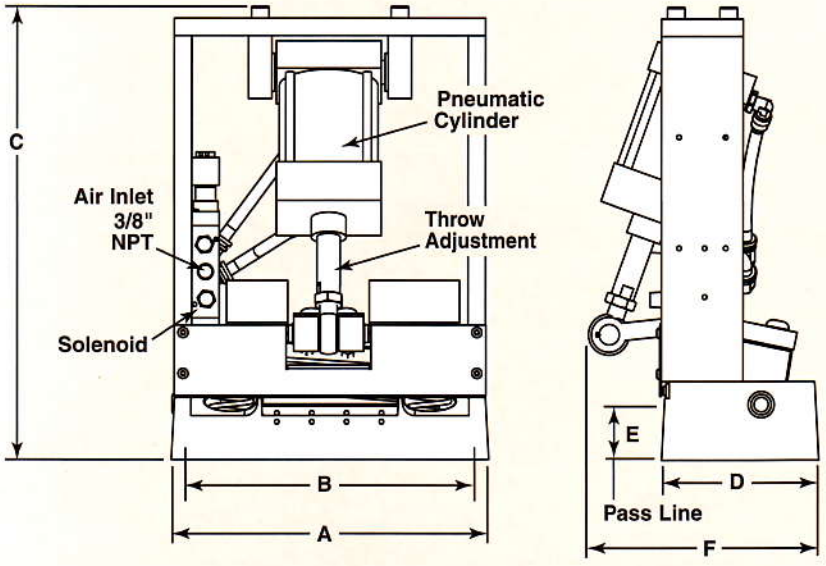


Using the same principle as our Ram Driven Scrap Chopper, this pneumatically powered chopper is designed to shear scrap material from .004" (0.1mm) to .074" (1.8mm) thick mild steel.

A powerful, double acting air cylinder provides controlled chopping while integral dampeners absorb snap through shock. The helically ground upper blade, made of high chrome tool steel, shears any kind of material.

A four-way solenoid valve controls the sequencing and can be synchronized with any machine by a limit switch, proximity sensor or programmable rotary limit switch. If a timing relay or counter is used, every other press stroke operation is possible for longer scrap pieces or extremely high speed operations. (Guard removed for photo)

DIMENSIONS



Model	A	B	C	D	E	F
DIMENSIONS. – Inches						
ASC-6	13.6	11.5	19.4	6.8	2.45	9.9
ASC-9	16.6	14.5	19.4	6.8	2.45	9.9
ASC-12	19.6	17.5	19.4	6.8	2.45	9.9
DIMENSIONS. – Metric						
ASC-6	345	292	493	173	62.2	251
ASC-9	422	368	493	173	62.2	251
ASC-12	498	445	493	173	62.2	251

SPECIFICATIONS – USA

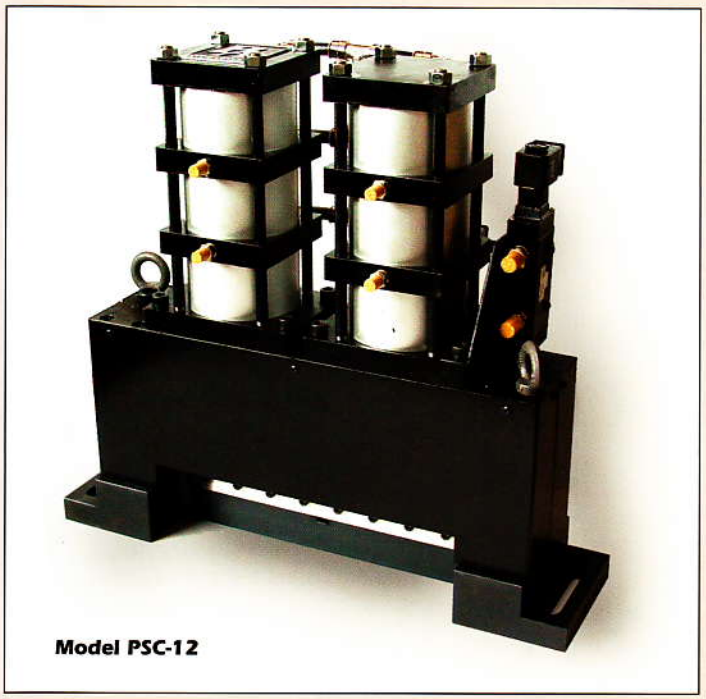
Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Max. Force (Lbs.) at 100 PSI	Max. Cycles/Min. No Load	Air Consumption at Max. SPM and 100 PSI	Shipping Weight (Lbs.)
ASC-6	6	.004 – .074 CRS	2800	200	72 CFM	80
ASC-9	9	.004 – .074 CRS	2800	190	66 CFM	90
ASC-12	12	.004 – .074 CRS	2800	180	73 CFM	100

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Max. Force (N) at 6.8 Bar	Max. Cycles/Min. No Load	Air Consumption at Max. SPM and 6.8 Bar	Shipping Weight (Kg)
ASC-6	152	0.1 – 1.8 CRS	12450	200	34 L/sec	36
ASC-9	228	0.1 – 1.8 CRS	12450	190	31 L/sec	40
ASC-12	305	0.1 – 1.8 CRS	12450	180	34 L/sec	45

Note: Solenoid Voltage is 120 VAC, Single Phase, 50/60 Hz. Other voltages available – 240 VAC, 24 VDC.

PNEUMATIC STOCK CUTTER



Model PSC-12

This Stock Cutter is designed to shear material with a clean edge. Fed by a programmable Servo Feed or Air Feed, it can be used in cut-to-length applications. Mounted on a press, it can be used as a scrap cutter or part cutoff.

Pneumatically powered, these stock cutters are designed to shear material at full width. The powerful three-stage, double acting air cylinders have a pancake profile for high speed operation. Integral stroke dampeners are used to handle snap-through shock loads, extending cycle life.

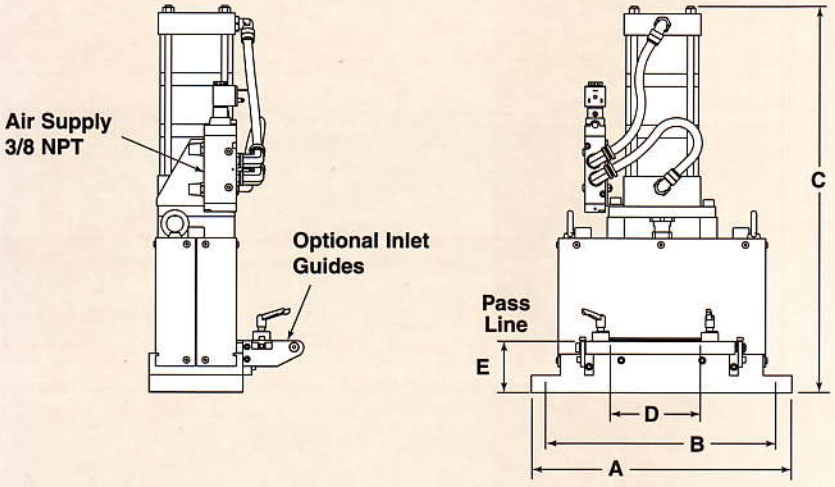
The four-way solenoid valve controls the sequencing and can be synchronized with a press. If a timing relay or counter is used, every other press stroke operation is possible for longer scrap pieces or work with high speed operations.

The compact, low profile construction allows for easy mounting and, if desired, portability.

Each cutter is equipped with air silencers and safety guard with fully adjustable material guides as an option.

Both upper and lower blades are vertically adjustable for wear compensation and sharpening. The lower blade is also horizontally adjustable to provide the correct blade clearance necessary to cut different materials. No other stock cutter has both of these features.

DIMENSIONS



Model	A	B	C	D	E
DIMENSIONS. – Inches					
PSC-6	15.5	13.50	22.56	6	3
PSC-12	21.5	19.75	22.56	12	3
DIMENSIONS. – Metric					
PSC-6	387	343	573	152	76
PSC-12	546	502	573	304	76

SPECIFICATIONS – USA

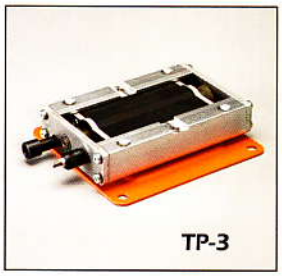
Model	Max. Stock Width (In.)	Max. Material Thickness at Full Width (In.) Aluminum Brass	C.R. Steel	Stainless Steel	Thickness Range (In.)	Stock Max. Force (Lbs.) at 100 PSI	Air Consumption at Max. SPM and 100 PSI	Shipping Weight (Lbs.)
PSC-6	6	.063	.046	.044	.001 – .064	3750	27 CFM	92
PSC-12	12	.089	.068	.063	.001 – .090	7500	69 CFM	160

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Max. Material Thickness at Full Width (mm) Aluminum Brass	C.R. Steel	Stainless Steel	Thickness Range (mm)	Stock Max. Force (N) at 6.8 Bar	Air Consumption at Max. SPM and 6.8 Bar	Shipping Weight (Kg)
PSC-6	152	1.6	1.2	1.1	0.04 – 1.6	16680	13 L/sec	42
PSC-12	305	2.3	1.7	1.6	0.04 – 2.3	33360	32 L/sec	73

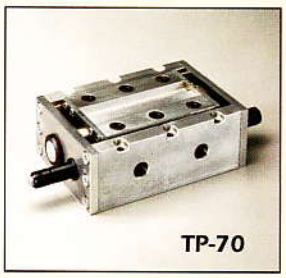
Note: Input power is 120 VAC, Single Phase, 50/60 Hz. Other voltages available – 240 VAC, 24 VDC.

TRANSPORTER


TP-3


TP-10


TP-40


TP-70


TP-140

The transporter is a unique, pneumatically driven feeder that was designed to solve scrap removal problems efficiently and inexpensively. This BELTLESS CONVEYOR transports the pieces of scrap with a shaking tray motion. A custom tray is fitted onto the body and the rhythmic, linear motion moves the tray slowly forward and then quickly backwards. The metal shavings, scrap, or finished parts are gently shuffled along the tray into a convenient container.

Although air operated, the air consumption is so low that it would be considered insignificant in a press shop environment. The noise level is well under acceptable standards for industrial uses.

Install the Transporter under any tool and problems with slugs, steel shavings and scrap disappear.

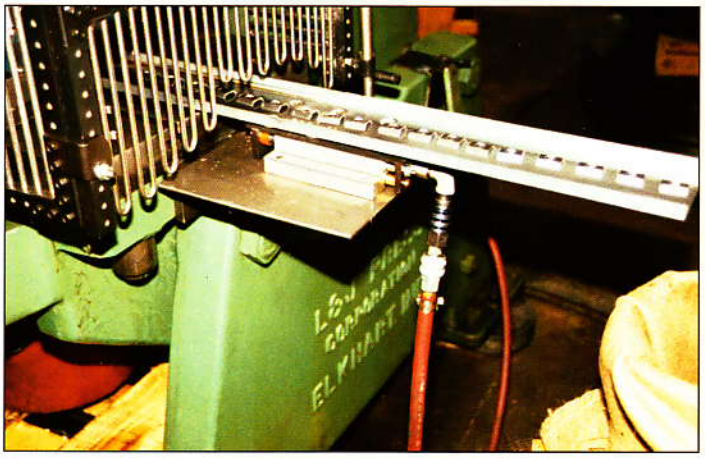
The Transporter costs a fraction of the price of motorized conveyors. The replacement cost of belts and rollers alone justifies the change from conventional conveyors.

Originally developed to remove scrap from presses, the Transporter is now being used in assembly-type operations to move parts.

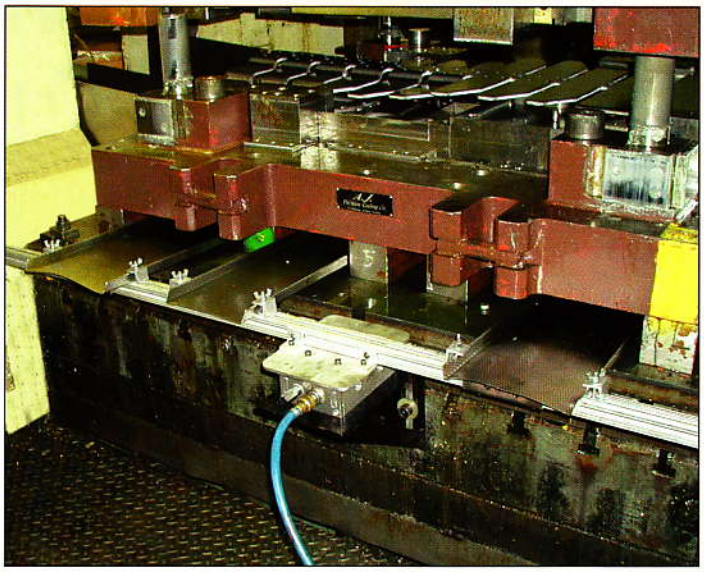
U.S. PATENT NO. 4,444,346

INSTALLATIONS

Easily installed outside the press area, a TP-10 conveys stamped parts into a shipping container.



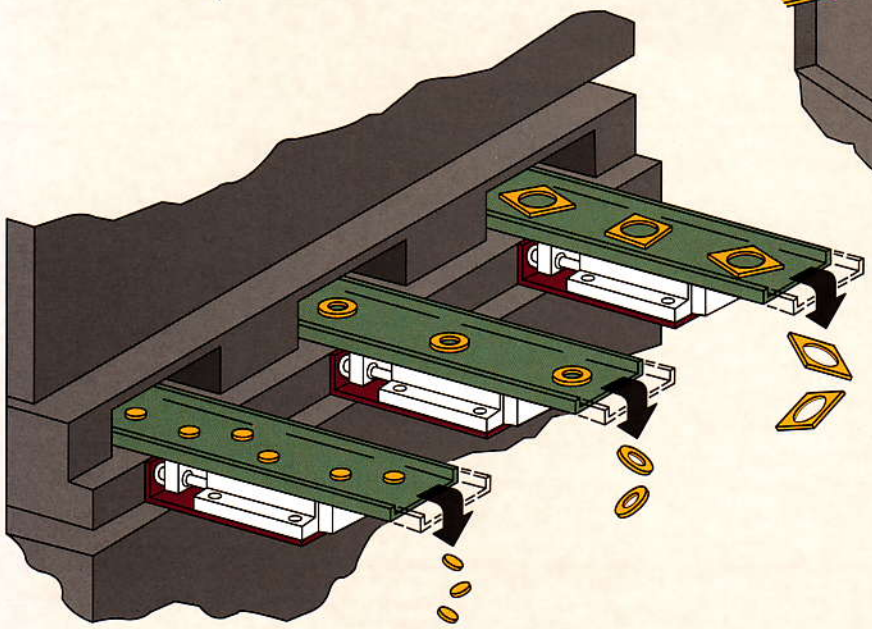
This TP-70 powers three metal trays

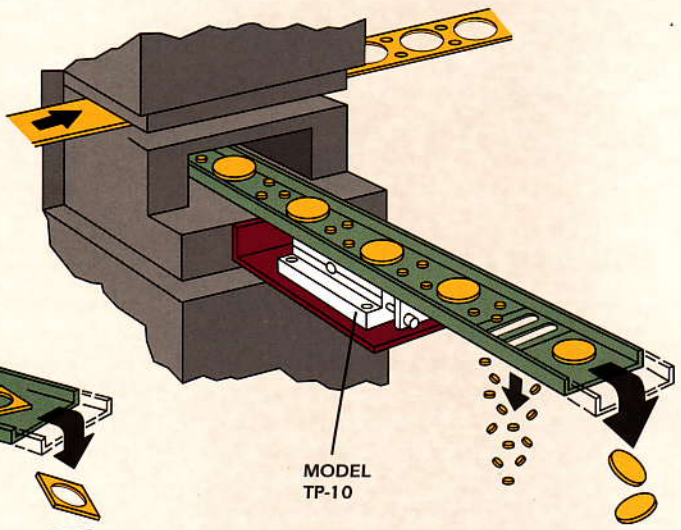


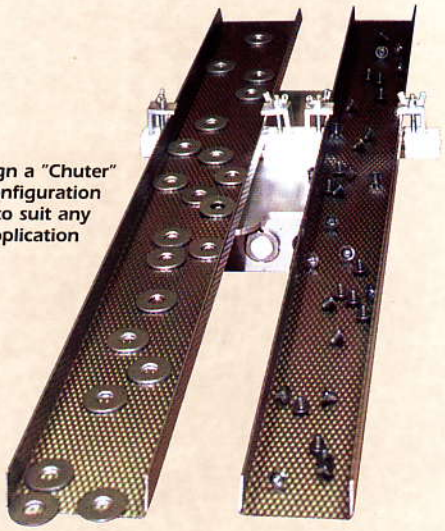
One TP-40 mounted on the bolster uses an upper tray to remove the chopped skeleton and a lower tray for finished parts.

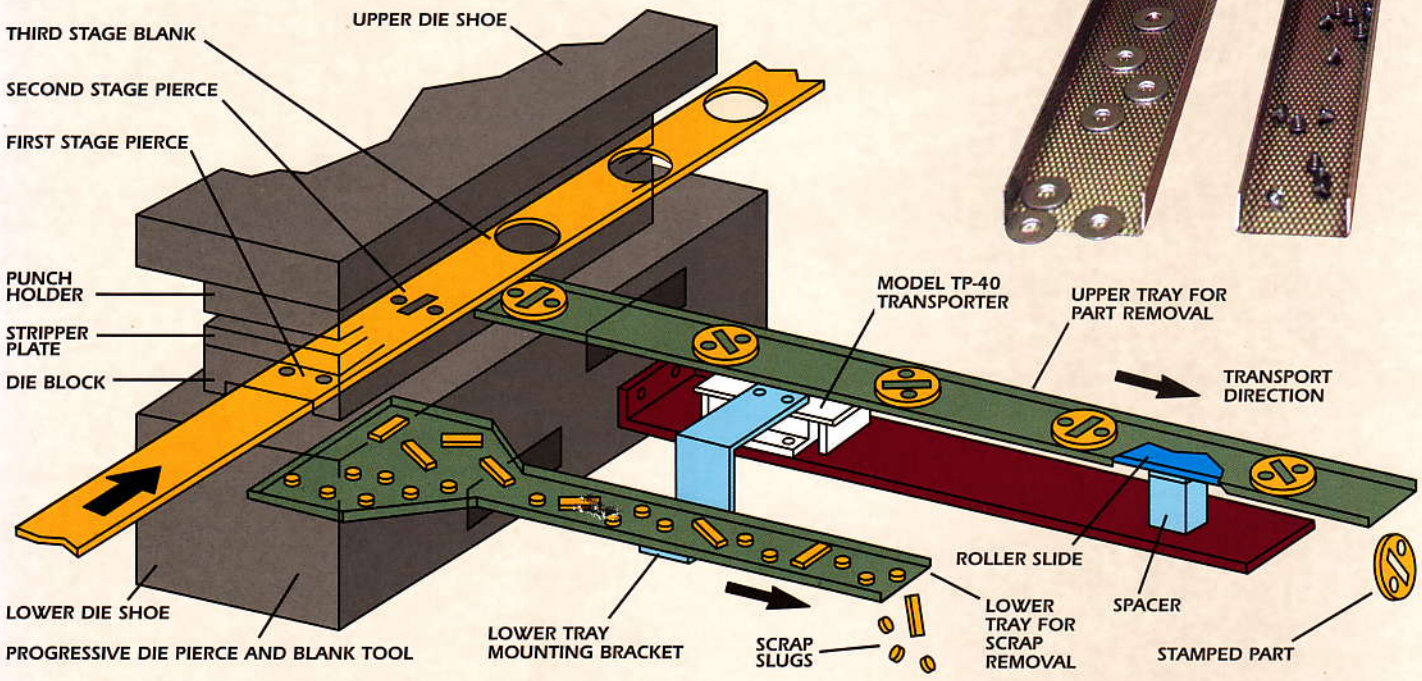
TRANSPORTER APPLICATIONS

These low profile, beltless conveyors are pneumatically powered. The vibrating, rhythmic motion will transport your parts and scrap and save you money. Trays can be fabricated to suit any size opening and to separate different sized scrap material.



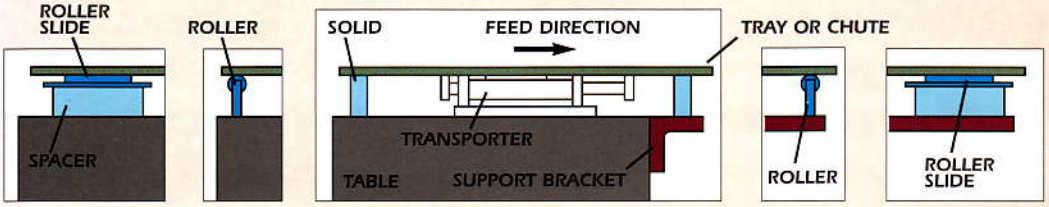






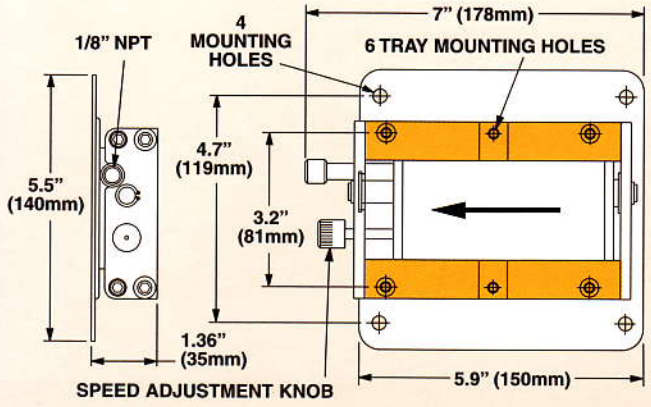
OPTIONAL TRAY SUPPORTS

Three methods for front and rear support of long trays or custom chutes. Recommended materials for low friction solid slides are Delrin (GP500) or Nylon and ball bearings for low rolling resistance.

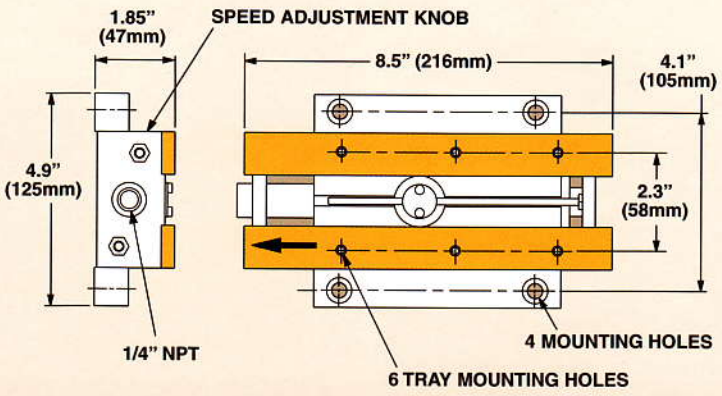


TRANSPORTER DIMENSIONS

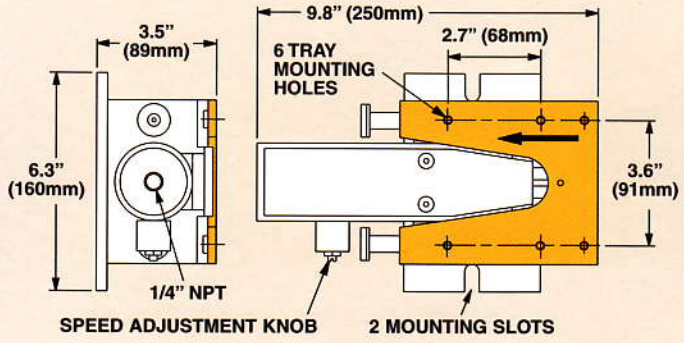
Model TP-3



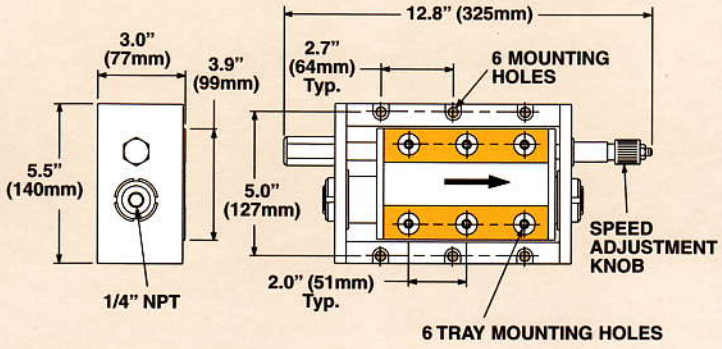
Model TP-10



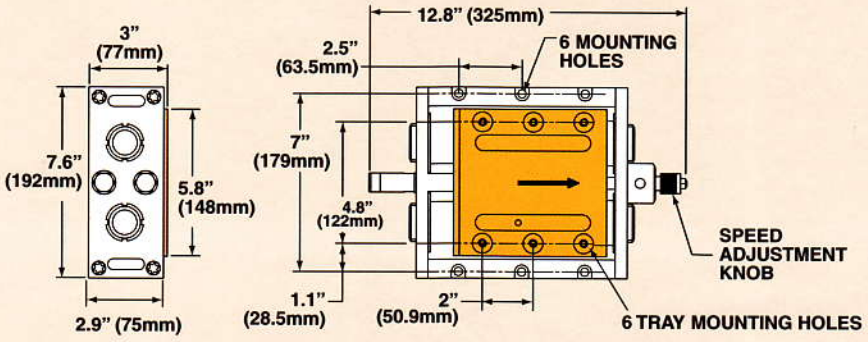
Model TP-40



Model TP-70



Model TP-140



SPECIFICATIONS – USA

Model	Load Capacity with Tray (Lbs.)	Air Consumption (CFM)	Sound Level (db-A)	Stroke Length (In.)	Max. Tray Weight (Lbs.)	Shipping Weight (Lbs.)
TP-3	6	0.5	68	0.91	3	3.5
TP-10	20	0.7	68	0.98	6	7.0
TP-40	80	1.4	70	1.06	12	16.5
TP-70	140	1.4	70	0.98	25	12.5
TP-140	300	2.8	62	0.98	45	17.6

SPECIFICATIONS – METRIC

Model	Load Capacity with Tray (Kg)	Air Consumption (L/Min.)	Sound Level (db-A)	Stroke Length (mm)	Max. Tray Weight (Kg)	Shipping Weight (Kg)
TP-3	3	14	68	23	1,4	1,4
TP-10	10	20	68	25	2,7	2,8
TP-40	40	42	70	27	5,4	7,2
TP-70	70	40	70	25	11,3	5,5
TP-140	140	80	62	25	20.4	8.0

Note: 1. Recommended speed: 120 SPM 2. Feed Rate: 26–34 FPM (8–10 m/min.) 3. Air Pressure Range: 50–75 PSI (4–6 bar) 4. Max. Incline of Tray 8°