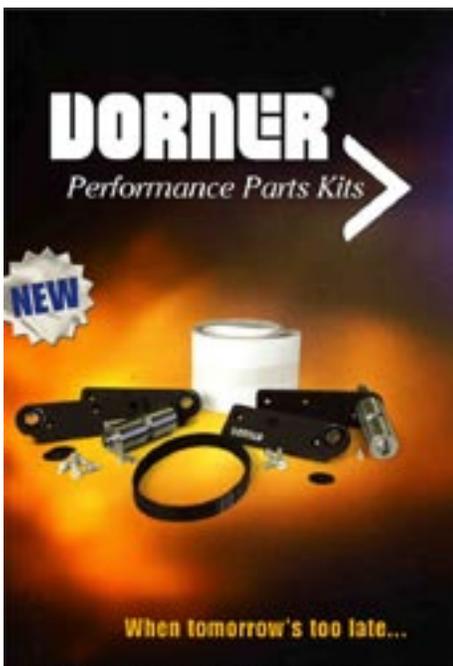


## Announcement!

**Dorner Parts Kits** are now available from Production Resources for the following series conveyors: 2100, 2200, 3200, 6200, LPZ and MPB conveyors.



While Dorner has the ability to ship parts quickly, keeping these kits in stock eliminates the need for down time while waiting for shipments. Dorner kits are designed for fast installation to ensure you can get your conveyor back in operation as fast as possible.

Call PRI at 800/863.3614 to order. Please have your conveyor model number and serial number available.

## Introducing the SpaceMaster Compact Coil Line Series

### Combination Reel/Straightener/Feeder Now Available in a Single Space-Saving Unit

Coe Press Equipment introduces the SpaceMaster Series Compact Coil Lines, a new line of space-saving, multi-functioning coil lines combining the three functions of unwinding, straightening and feeding of coil stock...all on a single unit. In total, 18 different model and size configurations are available.

The SpaceMaster's key benefit is a substantial floor space reduction on the stamping room floor, but without compromise in processing speed, reliability and overall performance. The system is mounted on a common machine base, helping to maximize rigidity during the feeding process. It includes a combination straightener/feeder unit and eliminates the need for an excessive slack loop area or loop pit. **The overall footprint of a SpaceMaster model can be 12-15 feet**—compared to the required length for a similar conventional line that can measure over 25-45 feet.

The SpaceMaster Series has been designed and built for precision coil stock feeding to all types of stamping presses. **It is competitively priced for as much as a 20% savings to conventional coil handling/feeding systems.**

#### SpaceMaster Series Features

SpaceMaster Series comes in four model sizes to process maximum coil



widths of 12" to 64", coil weights to 15,000 lbs., and stock thickness to .250".

#### Features/Specifications Found Across All Models

- Faster and safer operations can be achieved with "hands free" threading capability.
- An air-operated coil hold-down arm prevents coil clockspring.
- Increased processing speeds are provided by the "closed loop" AC servo feed drive/motor and AC inverter-duty uncoiler motor, both combining to deliver fast 60-80 FPM line speeds and coil strip placement accuracy of +/- .005".
- Simple, yet powerful control comes from our ServoMaster Controller. It features a 4-line x 80 character alpha numeric display screen, 500 job memory capacity, batch counter to 999,999 cycles, single cycle push-button control, feed length setting to 999.999 inches, inch or

SPACE MASTER Continued from Page 1

metric display and other operational features—all providing for easier job set-up and troubleshooting.

- Other standard efficiency-enhancing features include a motorized coil payoff reel, hydraulic mandrel expansion feature, a true pilot release feature, power driven straightener rolls, and many others.

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## Available For Sale

### BROWN BOGGS STOCK

### 400 TON

### STRAIGHT SIDE PRESS

Model # SS2 - 400 - 120" x 60"  
 BROWN BOGGS 400 ton capacity  
 Double Crank Straight Side Press,  
 Single Back Geared, Twin End  
 Driven, having the following  
 specifications:

Capacity ½" off bottom	<b>400 tons</b>
Stroke of slide	<b>12"</b>
Adjustment of slide	<b>10"</b>
Opening in uprights (F-B)	<b>40"</b>
Area of face of slide and bolster (R-L x F-B)	<b>120" x 60"</b>
Shut Height strike <u>bolster</u> to slide, stroke down, adjustment up	
<b>Customer specified</b>	
Thickness of bolster plate	<b>8"</b>
Strokes per minute	<b>25 - 60 SPM</b>
Size of drive	<b>75 HP</b>



Approximate overall weight of press 179,000 Lbs.

#### FEATURES:

- Built in Canada by Brown Boggs with 115 years of press experience
- Ortlinghaus air clutch and brake
- Trabon recirculating lubrication system
- Bronze 8 point gibbing
- Saddle bushing connections
- Thermal sensors on all bearings
- Hydraulic tie rod nuts
- .0015 parallelism between slide and bed
- Clutch/brake control of customer choice.
- Control console with overhead wiring
- Operator T stand

Price 445,000  
 Availability: 8 weeks  
 ARO subject to prior sale.

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## Point of Operation Guarding Made Simple

If you use mechanical power presses in your operation it will pay you to know whether your presses comply with the Code of Federal Regulations Title 29, Part 1910.217. Failure to comply can result in a costly fine! Part 1910.217 is broken into several sections. *This article is intended to let you easily understand the requirements of 1910.217(c): "Safeguarding the Point of Operation."* Full revolution clutch presses are ignored since this type of machine is rapidly falling out of use.

It is the responsibility of the Employer to provide and insure the

usage of point of operation guards and or devices on every operation performed on a mechanical power press! The OSHA standard provides lots of alternatives and is particular about how they can be used. You should carefully review your applications to determine what type of guard and/or device will work best.

First it's important for you to determine how a given machine will be operated. Is it coil fed (automatic/continuous) or is it single stroked and/or hand fed? Sometimes a press will be used for both types of operations which may limit the point of operation guarding choices. There are several acceptable Point of Operation devices:

1. Guards.
2. Presence sensing devices.
3. Pullouts and restraints.
4. Two-hand controls.
5. Type A and B gates.
6. Moveable barrier devices.

In this first of several articles, guards will be covered.

#### Point of Operation Guards

prevent entry of hands or fingers into the point of operation (operator is prevented from reaching through, over, under, or around). Three types exist – fixed, adjustable, and interlocked.

- The guard needs to comply with the maximum permissible openings of table O-10.
- The guard itself cannot create a pinch point.
- Fixed barrier guards must be attached to the machine frame or bolster using fasteners not readily removable by an operator (requires a tool).

## Production Resources New Product Announcement

### BTM Tog~L~Loc Sheet Metal Joining Systems are now available from Production Resources, Inc.

BTM clinch joining technology:

- Eliminates rivets and welds
- Lowers parts manufacturing costs and increases profits
- Improves joint quality and increases productivity

materials. The joint button is measured as a reliable, non-destructive checking method. Galvanized coating remains intact over the joint, enhancing corrosion resistance of the product.



- Allows “dry firing” to facilitate setup and troubleshooting
- Joints are set to distance, not pressure, thereby preserving joint quality with metal thickness changes



- Tog~L~Loc works with any metal: plain, painted or galvanized.
- No sparks or fumes.
- Strong interlocking joints.
- Used worldwide in automotive,

appliance, lawn & garden, and water heater manufacturing.

The patented Tog~L~Loc system is a proven method of fastening

Because there are no cutting edges or weld tips to maintain, tool life is commonly in excess of 250,000 joints.

Joint sizes are classified by the



punch diameter. Standard sizes are: 3.0mm, 4.6mm, 5.5mm, and 6.4mm.

Call Production Resources at 800/863.3164 for more information on BTM sheet metal joining and punching products.

*GUARDING Continued*

- Interlocked barrier guards may have hinged or moveable sections that are interlocked with the press control so the clutch can't be energized unless the sections are properly in place. If the moveable section is opened during operation, the press should stop before die closure.

- Hinged sections shall not be used for manual feeding (manual feeding requires a type A or B gate).

- The guard needs to be easy to inspect and should offer maximum visibility.

- Adjustable guards need to be securely attached and adjusted to comply with Table O-10.

**Table O-10**

Distance of opening from point of operation hazard (in inches)	Maximum opening width (in inches)
1/2 to 1-1/2	1/4
1-1/2 to 2-1/2	3/8
2-1/2 to 3-1/2	1/2
3-1/2 to 5-1/2	5/8
5-1/2 to 6-1/2	3/4
6-1/2 to 7-1/2	7/8
7-1/2 to 12-1/2	1-1/4
12-1/2 to 15-1/2	1-1/2
15-1/2 to 17-1/2	1-7/8
17-1/2 to 31-1/2	2-1/8

**Advantages:**

- Guards are generally inexpensive.
- Guards are easy to understand.
- Guards are well suited to dedicated coil fed operations which run trouble free with infrequent die changes.

**Disadvantages:**

- Guards get in the way and are frequently misplaced or misadjusted.
- Guards are frequently damaged during die setup or troubleshooting.
- Guards are useless for hand fed operations.

This article will be continued in future newsletters. If you want a full copy of the article now, please call your Application Engineer listed on page four.

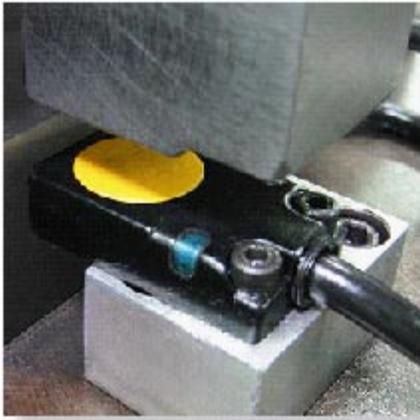
## New Application for SmartPAC Users

### Honeywell Wintriss Introduces Slug Detection Package

If any of your dies are used for piercing, you've probably had trouble with pulled slugs. Pulled slugs not only reduce part quality, but they can also seriously damage your die. Wintriss has created a package for SmartPAC and SmartPAC 2 with ProPAC that enables you to detect pulled slugs by monitoring the stripper position at bottom dead center using state-of-the-art, low-profile analog proximity sensors. Repeatability of .0008" can be achieved at high press speeds.

The Slug Detection package can be added to any SmartPAC or SmartPAC 2.

The Slug Detection package consists of :



- An 8-input ProPAC Process Monitoring Module w/integral connector.
- Four high-accuracy, low-profile analog proximity sensors and connectors.

- A ProPAC Die Plug (PDP) die-mounted junction block.
- A PDP cable to connect the PDP junction block to the control.

Wintriss is offering this package at a fraction of the cost of competitive systems. In

addition, unlike competitive systems, the ProPAC's extra inputs can be used for in-die measurement or other process monitoring applications. Special pricing is also available for other ProPAC configurations.

## FYI

Additional technical information is available at no charge on our website: [www.production-resources.com](http://www.production-resources.com). Just click on "Safety/OSHA" for information regarding:

- Application Guideline for Proper Use of Light Curtains
- Press Brake Alternative Guarding Method
- How to Determine if your Power Press Control Complies with OSHA Standards
- Light Curtain Application Issues—"Walk Thru Hazards"
- Safety Alternatives for Full Revolution Clutch Mechanical Power Presses
- Lockout—Tagout during Die Changes

Production Resources has Application Engineers available to help you at your facility. We can be reached at:

Phone: 800/863.3164

Fax: 615/371.3282

Email: [lcp@pri-mailbox.com](mailto:lcp@pri-mailbox.com).

### ***PRI Application Engineers***

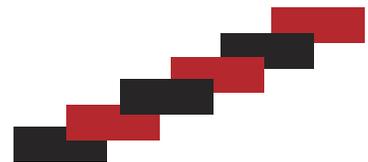
**Terry Bolser**—Southern Ohio, Northwest Ohio and Central Kentucky

**Steve Connolly**—Northern Ohio

**Phil Haskins**—West Tennessee, Paducah Kentucky area, Mississippi

**Chris Jones**—Central and Eastern Tennessee, Northern Georgia, Bowling Green Kentucky area

**John Kneynsberg**—Florida, Georgia, Alabama



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