

Servo Transfer Systems & De-Stack Feeders

Linear Transfer Automation

PRI is pleased to announce its representation of Linear Transfer Automation. A leading global supplier of servo transfer systems, de-stack feeders and tandem lines, Linear provides superior service and commitment to the highest in quality, performance and competitive cost.

Reasons You Should Invest In A Linear Transfer System:

- **SPEED /UPTIME** Linear's transfer automation operates with high precision, typically 15-30% faster than other similar servo transfer systems on the market.
- **FLEXIBILITY** Our systems are fully programmable, unlimited recipe storage, easy die access, and can be parked out of the way. A variety of configurations and sizes.
- **24/7 SUPPORT.** Turn-key solutions including complete installation, start-up, maintenance and training. We can provide tooling startup and integration /coordination with die sources.
- Front to back and through the window designs.



Rapid-Air Cut-To-Length Machine

C-T-L With Servo

Where other C-T-L lines simply cut, Rapid-Air's Smart Control is designed to communicate with your other equipment to streamline the entire parts handling process. A Rapid-Air cut-to-length machine with servo feed, or servo feed straightener (KBX100), is



Model CTL FSC24S + MB30 + 224T

a real production booster for both long or short length stamping operations. Programmable blank lengths from .5" to 999.999", widths from 4" to 24", thickness from .005" to .080" flat, .250" round.

Consult our application engineers regarding special control programs and feed-cutter combinations.



Did You Know?


A significant number of used power presses have entered the used equipment market as a result of bankruptcies and plant closures. As a result, manufacturers requiring additional press capacity or those looking to replace broken equipment are more often looking to the used equipment market as a bargain source for their needs. Much of this equipment have safety systems that are suspect and out of compliance with OSHA and ANSI standards. Buyers often fail to properly evaluate the safety systems and incur significant unexpected post-purchase costs to upgrade the presses.

When considering the purchase of a used press, it's important to carefully evaluate the clutch/brake control system so you can budget properly. Operator safety, OSHA 1910.217 compliance, ANSI compliance, operational efficiency, and cost are all major considerations. To complicate matters ANSI is about to release its latest rewrite of ANSI B11.1 safety requirements for mechanical power presses. There is some rumor that OSHA may adopt some or all of the new and more stringent ANSI language.


OSHA compliance is not the only issue or objective in evaluating the clutch/brake control. The buyer needs to consider all the intended applications for the machine. Factors to consider: Available operating modes—off/inch/single/continuous are fairly standard; however, automatic single stroke, continuous on demand, or multiple operators may be required. Visual displays, operator interfaces, and automation options are also elements of the clutch/brake control that affect overall safety and productivity. Do you need automatic shut height control, counterbalance control, tonnage monitors, automatic speed control, programmable limit switches and die protection?

There are some simple items a potential buyer can look for to determine basic OSHA compliance:


- Press electrical schematic dated after June 1974.
- Air pressure switches for clutch and counterbalance.




Pax Pre-Pressurized Lubrication Systems



Model 2-2: All of Pax's Benefits in a Smaller Package

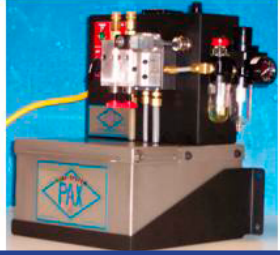


2 Distribution Pumps
2 Gallon Reservoir
1 Low Price

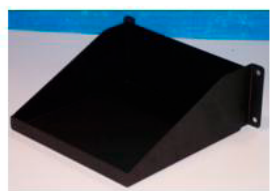


Standard System Features Include:

- Ability to spray both Low and High Viscosity Fluids.
- An "Airless" Spray that better adheres to the stock material.
- Non-contact Lubrication, which eliminates wear items.
- Ability to Fill the Reservoir while the system is in operation.
- Pre-Pressurized design Eliminates Priming issues.
- Provides exact volume of lubrication to each spray line.



Optional
Mounting
Bracket



(Did You Know? (continued))

- Supervisory control of mode and stroke selection.
- Red emergency stop and Yellow top stop.
- Two-hand control with anti-tie down provision.
- Continuous prior action function (automatic presses).
- Control reliability—single component failure safe response.
- Brake monitoring for hands in die operations.
- Dual safety valve for (hands in die operations).

Want help evaluating the status of a used press clutch/brake control system? Call your PRI Application Engineer for assistance. We can also provide written information (OSHA/ANSI compliance checklist) so you can be a better informed buyer.

Shadow® 8 Light Curtains

Easy-To-Use Product Can Safeguard Multiple Sides Of A Machine With One Control

Honeywell Wintriss introduced Shadow® 8, a slim, rugged, expandable safety light curtain. The latest product in the Shadow® light curtain series can be used to guard multiple sides of a machine.

Shadow® 8 light curtains are designed to allow customers to add a second, third or even fourth pair of optic heads to the same control. They also are easier to install and use.



The basic Shadow® 8 system includes a main pair of light curtains and cables for wiring the curtains to a WPC or to the optional Shadow® 8 Control. The main heads can be used as a stand-alone light curtain. Alternatively, users can connect one to three pairs of extension heads in series with the the main unit.

Extension heads can be added at any time. Quick-disconnect fittings on the pigtails are easily attached to the main unit or to another extension. Interconnect cables are also available for protection of larger areas.

Shadow® 8 standard features include a programmable fixed blanking window that allows fixtures such as conveyors or worktables to remain in the sensing field without triggering a machine stop. Users simply place a fixed object between the transmitter and the receiver and simultaneously turn two key-lock switches on the WPC or optional Shadow® 8 Control. Shadow® 8 senses the presence of the object and disables the obstructed beams. Users can also set a one-beam floating blanking window to allow small objects, such as air-ejected parts, to pass through the light curtain in a random pattern without interrupting operation. Floating and fixed blanking can be active at the same time.

Shadow® 8 complies with OSHA 1910.217, ANSI B11.1, ANSI B11.19, CSA Z142, and CSA Z432. The optic heads and optional control are both rated IP65.

COE Builds The Best ... And Services The Rest!

Pressroom Rebuild/Retrofit Services for Coil Feeding and Handling Equipment

Regardless of your press feed, straightener, or coil reel brand name, let us show you how the COE Service Team can bring new productive life to your existing equipment!

COE Press Equipment services all of the major brands. The COE Service Department has tons of experience over the last few years with the following brands of servo roll feeds, power straighteners, coil reels, and other related coil processing equipment. In addition to our COE and SESCO brands, we've provided rebuilds/retrofits for the following equipment:

- Dallas
- ROWE
- Littell
- Minster
- Feed Lease
- Perfecto
- and many more



Updating to the Latest in Servo Feed Controls

Many servo feeds in operation today were purchased in the late 80s and early 90s as servo technology was initially developing. These early



generation machines offered great advantages over air and mechanical feeds, but most were built on "unsupported" hardware and software platforms. You can face extended downtime in the event of the failure of a critical drive, motor or motion controller.

COE has developed a variety of "cost-effective" retrofit packages to upgrade your servo feed controls to

COE (continued from page 3)

current technology levels; and often, these solutions are available "in stock" for quick delivery. COE control retrofits can help you reduce setup, improve consistency and raise productivity. Upgrade packages can include: job storage recipes, operator prompts, servo feed diagnostics, multi-lingual programming, step programmable controls and direct downloading of job parameters from the press by serial communication.

Many original straighteners and reels in coil feeding systems were designed with simple drive mechanisms. These consisted of basic ON/OFF controls, clutch mechanisms, eddy current drives and DC drives.

Today's AC variable speed drives and motors provide the necessary torque for the uncoiling and straightening. Modern variable speed controls are programmable to allow custom parameters to be developed to optimize machine performance.



Better Control Of The Loop With COE's New "Loopmaster"

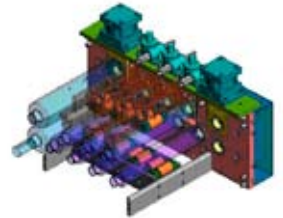
An effective loop control system is critical to the overall operation of the coil feeding system. Accurate sensing of the loop position and precise feedback to the straightener or reel drive are necessary for smooth supply

of the coil. Original loop control systems were often simple ON/OFF switches or Potentiometer devices.

COE has developed their new "LoopMaster" Loop Control as a PLC-based system with four programmable presets for various payoff requirements. In addition to variable speed feedback, it's capable of linespeed averaging and proportional brake control. The "LoopMaster" can be specified to work with either laser or ultrasonic sensing devices based on your application requirements.

Beefing Up The Straightener's Capacity

The increased use of higher strength materials in the stamping industry has created problems for many stampers. Original equipment may have been specified to straighten only mild steels with lower yield strengths. Today, it's common for the yield strength ratings to exceed 100,000 PSI.



Straighteners can be upgraded to meet the demand of high strength steels with higher HP drives and motors, improved reduction packages, and the addition of center back-up assemblies to prevent deflection of the straightening rolls.

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FYI

Additional technical information is available at no charge on our website: www.production-resources.com. Just click on "OSHA/Safety" or "Tech Information."

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