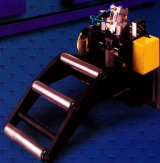




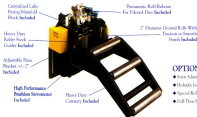
Electronic Servo Roll Feeds



PRESS ROOM EQUIPMENT CO.

PRE's P-20 SERIES OF SERVO FEEDS

Why Pay For Costly Options That Come Standard With PRE's Servo Feed?



OPTIONS:

- ◆ X-ray Adjustable Pin Mounting Bracket
- ◆ Hydraulic Jack Pin Mounting Bracket
- ◆ Special Roll Finishes
- ◆ Full-Flow Straighteners

Standard and Heavy-Duty Servo Feeds

STANDARD DUTY MODELS

| MODEL | MAX WIDTH | THICKNESS |
|--------|-----------|-----------|
| P20F06 | 6.5" | .105" |
| P20F12 | 12.5" | .092" |
| P20F18 | 18.5" | .072" |
| P20F24 | 24.5" | .062" |

HEAVY DUTY MODELS

| MODEL | MAX WIDTH | THICKNESS |
|----------|-----------|-----------|
| P20F06HD | 6.5" | .181" |
| P20F12HD | 12.5" | .144" |
| P20F18HD | 18.5" | .114" |
| P20F24HD | 24.5" | .101" |

Below is an illustrated example of our computerized performance chart for P20F06 Standard and Heavy Duty Feeds. PRE provides a performance chart with every quotation based on your job parameters. Request a quote today!

Typical Feed Rates at 180° of Feed Angle
P20F06 with .091" x 6" MS

| FEED LENGTH | HIT RATE |
|-------------|----------|
| INCHES | SPM |
| 1.00 | 199 |
| 2.00 | 139 |
| 3.00 | 107 |
| 4.00 | 117 |
| 5.00 | 109 |
| 6.00 | 101 |
| 7.00 | 95 |
| 8.00 | 89 |
| 9.00 | 84 |
| 10.00 | 80 |
| 11.00 | 76 |
| 12.00 | 72 |

Typical Feed Rates at 180° of Feed Angle
P20F06HD with .188" x 6" MS

| FEED LENGTH | HIT RATE |
|-------------|----------|
| INCHES | SPM |
| 1.00 | 200 |
| 2.00 | 180 |
| 3.00 | 159 |
| 4.00 | 132 |
| 5.00 | 116 |
| 6.00 | 104 |
| 7.00 | 94 |
| 8.00 | 84 |
| 9.00 | 79 |
| 10.00 | 73 |
| 11.00 | 68 |
| 12.00 | 64 |

SFM rates are for reference only. Precision Equipment will provide a performance chart for your specific application.

PRE's LARGE CAPACITY SERIES OF

Electronic Servo Roll Feeds

Press Room Equipment's Electronic Servo Driven Roll Feeds are designed to provide the metal stamping industry with an unbeatable combination of accuracy, reliability and flexibility with an excellent return on your investment.

- Three models available with 3.25 in., 4.50 in. and 5.50 in. diameter feed rolls.
- Accommodates stock width from 0 in. to 72 in.
- Handles stock thicknesses up to .281 in.
- Pull-Thru Straighteners available.



P325F12 - SERVO ROLL FEED With optional Hydraulic Lift Tracker



P450F24 - SERVO ROLL FEED With Optional Crank Operated Adjustable Height Cabinet

Note: Some photos in this brochure may be shown without guards in order to reveal details.



P550F48 - SERVO ROLL FEED With Standard Cabinet and Optional Powered Height Adjustment



P450F16 - SERVO ROLL FEED With Pull Through Straighteners (for more information, consult factory)

LARGE SERVO FEED SELECTION GUIDE

Please Note: The material thickness ratings shown below are for reference only. The capacity of a Servo Feed is determined by the material weight, feed length, SPM required, press time/feed angle available and other factors. The proper feed will be quoted based on your particular requirements.

| P325F | | P450F | | P550F | |
|----------------------|---------------|-------------|---------------|-------------|---------------|
| MAX WIDTH | MAX THICKNESS | MAX WIDTH | MAX THICKNESS | MAX WIDTH | MAX THICKNESS |
| 06 (152.4) | .210 (5.33) | 06 (152.4) | .250 (6.35) | N/A (N/A) | N/A (N/A) |
| 12 (304.8) | .195 (4.95) | 12 (304.8) | .220 (5.59) | N/A (N/A) | N/A (N/A) |
| 18 (457.2) | .180 (4.57) | 18 (457.2) | .195 (4.95) | 18 (457.2) | .281 (7.14) |
| 24 (609.6) | .165 (4.19) | 24 (609.6) | .180 (4.57) | 24 (609.6) | .250 (6.35) |
| 30 (762.0) | .150 (3.81) | 30 (762.0) | .165 (4.19) | 30 (762.0) | .235 (5.97) |
| 36 (914.4) | .135 (3.43) | 36 (914.4) | .140 (3.56) | 36 (914.4) | .210 (5.33) |
| 42 (1066.8) | .090 (2.29) | 42 (1066.8) | .105 (2.67) | 42 (1066.8) | .195 (4.95) |
| 48 (1219.0) | .062 (1.57) | 48 (1219.2) | .090 (2.29) | 48 (1219.2) | .165 (4.19) |
| | | 60 (1524.0) | .050 (1.27) | 60 (1524.0) | .135 (3.43) |
| INCHES (MILLIMETERS) | | | | 72 (1828.8) | .105 (2.67) |

Note: Pull-Thru Straighteners available for all PRE Servo Feeds. Actual stock width is approximately 1/2" (12.7mm) wider than shown.

ELECTRONIC SERVO ROLL FEEDS

Many of our Standard Design Features are listed only as Options by other manufacturers!

SERVO CONTROL FEATURES

PRE uses only the best quality controls and drives from industry leaders in servo feed technology. This attention to detail provides the components necessary for efficient production and long life in our equipment.

- Simple operator key-in of feed length
- Easy to use interface with press controls
- Storage for 99 unique 8 digit part numbers
- Four line, sixteen character display
- Accurate and consistent material feeding
- Diagnostic monitoring of machine functions
- RS-232, RS-422 and RS-485 communication interfaces
- Precise +/- .0025" Roll positioning for consistent feed length accuracy

CONSTRUCTION FEATURES

PRE's Electronic Servo Driven Roll Feeds incorporate an upper feed roll driven through a helical gear train by the lower roll. A high strength timing belt drives the lower roll providing quiet, zero backlash operation. The combination of heavy duty components and sophisticated controls provides precise control of feed speed and material position.

- Heavy duty blanchard ground steel plates machined to close tolerances on our CNC machining centers
- Parallelism and alignment of the roll drive components ensured by jeweled and belted roll housing assemblies
- Extreme rigidity for long life and minimal maintenance
- High torque brushless servo motor mounted in the open frame under the drive rolls

STANDARD FEATURES-ALL MODELS

- Adjustable Pass Line Mounting Cabinet -42" - 52" (P325 Models)
- Mounting Bracket with 4" Adjustment (P325 & P450 Models)
- Cascade Material Support Rolls
- Master Control Console
- Traction Finish on Feed Rolls (can be omitted)
- Hardened Entry Guide Rolls
- Pneumatic Pilot Release & Roll Lift
- Control Parameter Diagnostics
- Multiple Length & Batch Control
- Pneumatic Feed Roll Pressure Adjustment
- Pendant Control (Jog-Forward/Reverse) w/Coiled Cord
- Filter-Regulator-Lubricator
- 440 V/3PH/60HZ incoming voltage
- Centralized Lube Fitting Manifold

AVAILABLE OPTIONS - ALL MODELS

- Hydraulic Jack Lift Mounting Bracket (P325 & P450 Models)
- Floor Mount Pedestal w/Hydraulic Lift Bracket (P325 & P450 Models)
- Adjustable Pass Line Cabinet -42"-52" (P325 & P450 Models)
- Power Lift for adjustable mounting cabinets
- Anti-Back up Roll
- Multiple Part Pattern (Gagging) Control
- Crank Operated Stock Centering Guides
- Transformers for non-standard voltages
- Pull-Through Straighteners are available for all models (contact factory)

For performance information on your Servo Feed application, please call us at (417) 864-3636. Our engineering/sales staff will be happy to provide you with the information you need to make an informed decision on your next SERVO FEED purchase. You can also fax your quote request to 417-864-3667, or e-mail us at sales@pressroomequipment.com.

P325F12 .060 X 12" MS 180 deg. Feed Angle

| FEED LENGTH (inches) | HIT RATE (SPM) |
|-------------------------|-------------------|
| 1,000 | 246 |
| 2,000 | 190 |
| 3,000 | 163 |
| 4,000 | 145 |
| 5,000 | 132 |
| 6,000 | 122 |
| 7,000 | 114 |
| 8,000 | 108 |
| 9,000 | 102 |
| 10,000 | 98 |
| 11,000 | 93 |
| 12,000 | 89 |

P450F18 .187 X 18" MS 210 deg. Feed Angle

| FEED LENGTH (inches) | HIT RATE (SPM) |
|-------------------------|-------------------|
| 1,000 | 239 |
| 2,000 | 174 |
| 3,000 | 144 |
| 4,000 | 126 |
| 5,000 | 113 |
| 6,000 | 104 |
| 7,000 | 96 |
| 8,000 | 90 |
| 9,000 | 85 |
| 10,000 | 81 |
| 11,000 | 77 |
| 12,000 | 74 |

P550F48 .100 X 48" MS 180 deg. Feed Angle

| FEED LENGTH (inches) | HIT RATE (SPM) |
|-------------------------|-------------------|
| 1,000 | 187 |
| 2,000 | 139 |
| 3,000 | 116 |
| 4,000 | 102 |
| 5,000 | 92 |
| 6,000 | 84 |
| 7,000 | 78 |
| 8,000 | 74 |
| 9,000 | 70 |
| 10,000 | 66 |
| 11,000 | 63 |
| 12,000 | 61 |

Specifications above are based on mild steel.

For Metric conversion multiply inches x 25.4

SMALL, TOUGH & EFFICIENT

Standard-Duty

Heavy-Duty



Simple Data Entry Keypad Included

Log For/Bew. From Pendant and Keypad Included

Free Standing Cabinet Protected Included



Got A Few Minutes?



Note: To demonstrate the functionality to drive without position relief control device.

In a few minutes your operators can learn how to set up the feed parameters using PRE's comprehensive menu pads.

OTHER STANDARD FEATURES

- Accuracy to $\pm 0.0025"$ rail position is achieved through advanced servo control and position sensing.
- Powerful feeder operation with controlled acceleration profiles.
- Perforate free-running of feed length during pause operation is available with the control's manual adjust feature, enabling quick and easy setup.
- Rapid Direct Feeded & Keypad Connections.
- Medical Clear Drives Rolly with non-magnetic KETLAR® Roll to maintain feed accuracy.

P-20 SERVO FEED FEATURES

| | STANDARD DUTY | HEAVY DUTY |
|----------------------------------|---------------|------------|
| Servo Package | PRE | Industrom |
| Supply Voltage | 180V/3 PH | 440V/3 PH |
| Proportional Pilot Release | Yes | Yes |
| Inter-Matched | Yes | Yes |
| Medical Clearing | Yes | Yes |
| Clear Roll From The Motor | Yes | Yes |
| H.D. Break Buffer Chamber | Yes | Yes |
| Heavy Duty Carriage | Yes | Yes |
| Adjustment From Pendant & Keypad | Yes | Yes |
| Log Forward/Reverse Pendant | Yes | Yes |
| Rapid Direct Feed | Yes | Yes |
| R&L 11/485 Serial Port | No | Yes |
| Break Counting | Yes | Yes |
| Job Number Storage Quantity | 21 | 100 |
| Multiple Sequence Choice | No | Yes |
| Adjustable Feed Angle Distance | No | Yes |



OTHER PRE EQUIPMENT

**SINGLE AND DOUBLE GRIPPER
AIR FEEDS**



**SINGLE GRIPPER FEEDS 6" TO
36" WIDE, STROKES TO 40"**

**DOUBLE GRIPPER FEEDS FROM
6" UP TO 32" WIDE**



**CUT-TO-LENGTH MACHINES
WITH AIR OR SERVO FEEDS**



**SINGLE AND DOUBLE
ARROW REELS AND
DECOUPLERS FROM
300 TO 30,000 LBS**



**POWERED STRAIGHTENERS
TO 32" WIDE**



**LIGHT TO MEDIUM
DUTY PRIMO LINE**



**HEAVY DUTY SERVO
ROLL FEEDS**



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SEE US ON THE INTERNET AT www.pressroomequipment.com

PRE reserves the right to change specifications without prior notice.