

Dyna-Feed- Short Bar/Tube/Rod Feeder



Manual Loaded Magazine Short Bar Feeder

Each manually loaded magazine feeder provide a means to store parts ranging in size from 1/4" to 2-1/2" diameter and 4" to 48" in length. The parts will be stacked by hand into a magazine. The magazine escapement will then meter a single rod, tube or bar the parts to a conveyor which will feeds parts to (upstream process) as needed. The Magazine and discharge conveyor are mounted on a common stand, which is attached to a movable base. The movable base is designed to allow ease of movement from one (upstream process) to the next.

Description of Equipment :

Magazine consist of two side plates constructed of 1/4" thick Blanchard ground steel for flatness. The parts will rest on hardened lower rails mounted to the side plates at 15 degrees. One side plate will be stationary at the in-feed end of the conveyor. The opposite side plate will move along two shafts with linear bearings to adjust for part widths. This adjustment is made with a simple turn of a handle connected to a lead screw. No tools will be required for setup. The front part rails are adjustable for the different part diameters. It will only be necessary to move this when parts change in diameter. A motor driven cam mounted under the parts will rotate opposite of the direction of the parts to prevent bridging and release parts. As this cam turns a part will be able to roll under the front rail and into the lift cylinder escapement. The lift cylinder will lift the parts to the final rails leading to the 72" conveyor mounted to the accumulator stand. The lift cylinders will only escape parts when the conveyor photo-optic eye is not blocked. All logic controlled by means of a PLC.

Heavier diameters can be accommodated on our Steep Feeder Series. The series can handle diameters from 1/4" to 2-3/4". Non-Marking features can be added to handle parts in pre-heat treat form or finished parts.

Controls: The standard package includes a variable frequency drive, which powers the escapement and can be set to match your production requirements. This motor controller can easily be controlled by your PLC with a simple demand signal via relay. A through beam sensor is mounted in the bottom of the hopper and will automatically shut the system off when the hopper is empty. A signal light can be incorporated to notify operator of low hopper status. Manual operator controls are mounted near the hopper and include e-stop, and control power on buttons.