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Pressmate Two-Row Stagger Feed Conversion to a Single-Row Feed

To begin conversion from two-row to single-row you **must** change from a 30° cam to a 45° cam.

Figure I: Disconnect eight hoses to the carriage.
Remove carriage by taking out six ¼-inch bolts at ➡ .

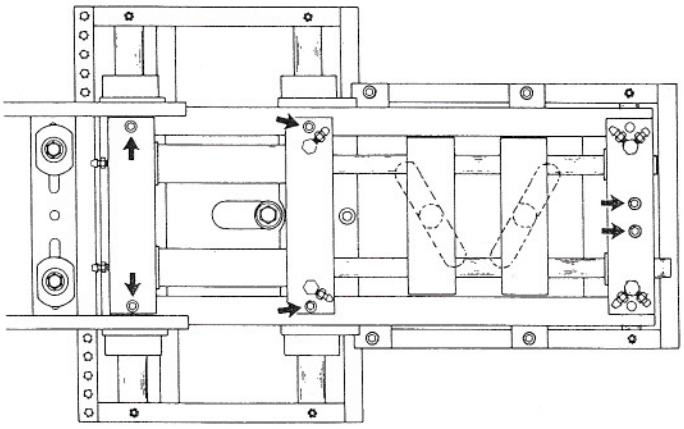


Figure II: After carriage is off, remove 30° cam by taking out four ¼-inch bolts at ➡ .

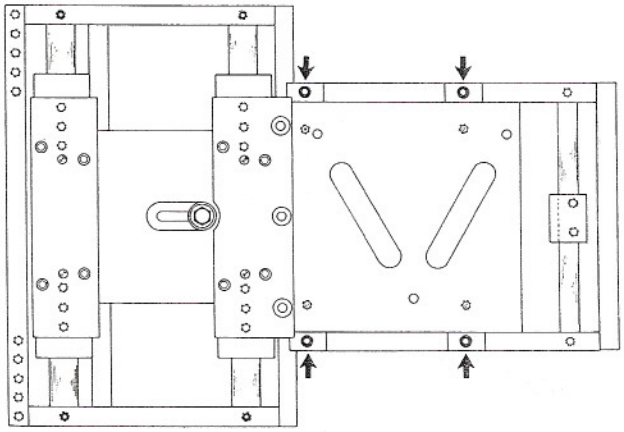
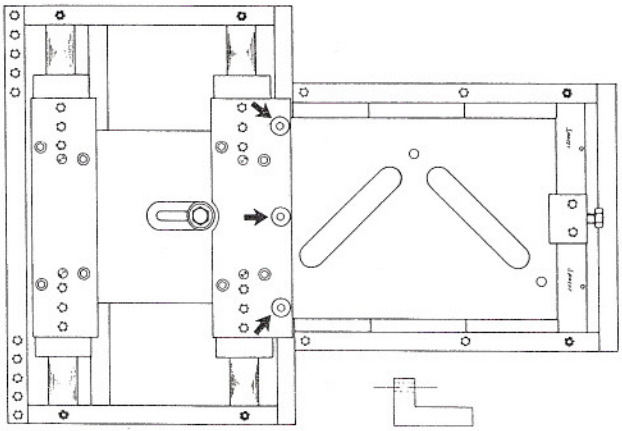
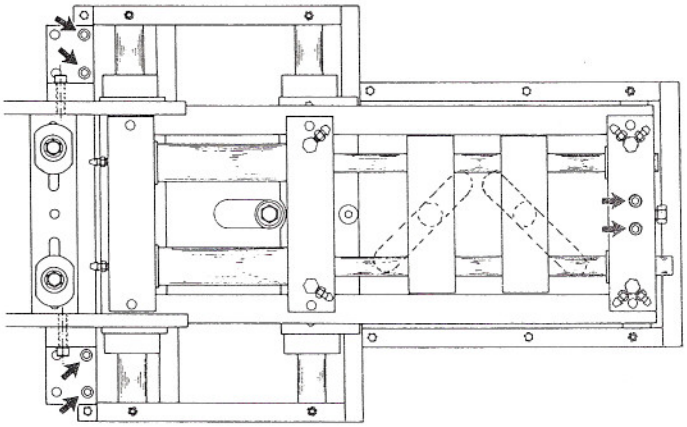


Figure III: Install 45° cam with three ¼-inch flat head screws to the guide spacer at ➡ .
Insert two spacers in front and lock slides in center with one ¼-20 x ½ lg bolt.



Add two carriage blocks to the rear of the carriage using two ¼-28 x 1 lg cap screws.

Figure IV: Carriage will then be mounted to its three new locations using six ¼-inch bolts at ➡ .
Connect eight hoses to former location.



Conversion is now completed and ready for single row feeding.

Pressmate Single-Row Feed

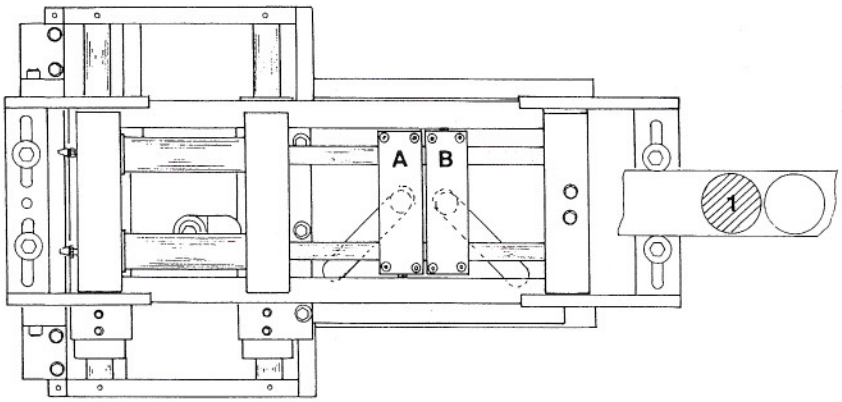


Figure 1 - Feedhead A has moved the material to punching position 1, as shown. A camvalve then switches clamping pressure from feedhead A to feedhead B, ready for the next stroke.

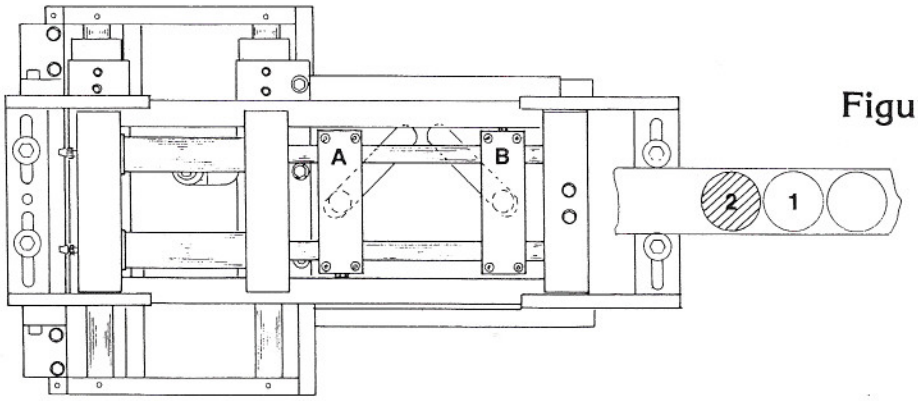


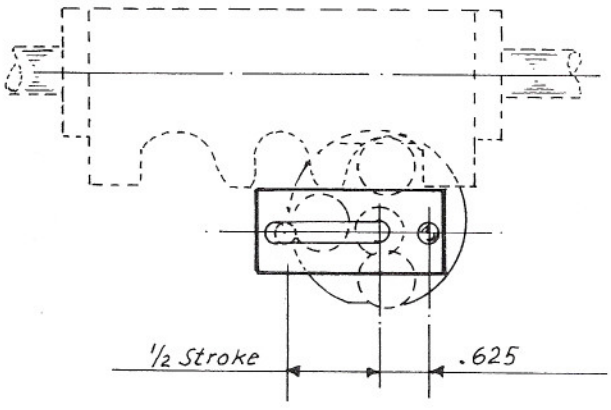
Figure 2 - Feedhead B has moved the material directly to the next punching position 2. The cam valve then reverses clamping back to feedhead A, and so on.

Setting the Feed for various blank sizes of single-row feeding

As the feedheads are guided to travel in the correct relationship (at 45° to the feedline), changing blank sizes is just a matter of changing the distance they travel.

This distance is precisely controlled by the throw of a crank which indexes back and forth 180° for each feeding movement. A simple stroke plate insures the correct movement for each job. No adjustments are necessary. Job changes are simple - and scientific.

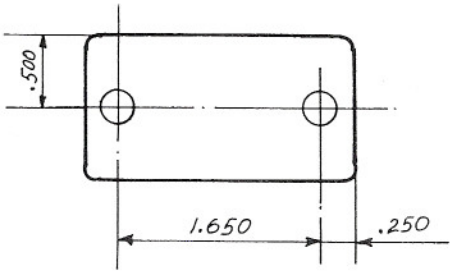
Woodbury Mechanism



Sample: 2" blank with a web or bridge of .050

Formula: (Blank + Bridge) ÷ 2 + .625

2" + .050 ÷ 2 = 1.025 + .625 = 1.650



A stroke plate is a piece of steel 3/32 x 1" and 2-1/4" long in which you locate two .250" diameter holes in this case 1.650" apart. Making the plate is quicker then making adjustments.