

Danly Pneumatic Press Feed Units provide a compact and accurate method of feeding coil or strip material in many widths and pitches.

They can be fitted in any position on the press or on the die set and are supplied complete with the necessary valves needing only a single air line connection.

The design is such that the feed head moves between two dead stops along ground shafts, achieving a high degree of accuracy.

In the majority of cases pilots of the press tool are not needed, a press feed repeatability of $\pm 0.03\text{mm}$ being achieved. A clamping assembly is available that will hold the material under a light spring pressure and allow the pilot pins to align the strip. An alternative method to spring pressure is the pilot release system, whereby clamping is momentarily released just as the pilots enter the strip, then clamping is re-applied immediately the strip has been correctly located. All models are fitted with a cushioning device and speed control valves which allow precise speeds to be obtained with the press stroke.

All Danly Mark II feeds incorporate a reversing action as standard, enabling them to be positioned either way round on the press.

The units can be controlled mechanically from the ram or the die set; pneumatically or electrically.

Danly Pneumatic Feed Units are designed to work at pressures between 6-7 Bar (80-100 PSI).

1 Mechanically operated by a striker fitted to the press ram or die set. An alternative is to use the Danly pneumatic or electrically operated remote control system.

2 Steel wear plate along the entire length.

3 Forward operation and speed adjustment screw.

4 Reverse operation and speed adjustment screw.

5 Ground steel shafts maintain feed head alignment throughout the stroke.

6 Adjustable rollers fitted into a 'T' slotted stop block to ensure accurate guiding of material.

7 Single air inlet.

8 Shock absorbing, cushioned dead stops at both ends of the stroke.

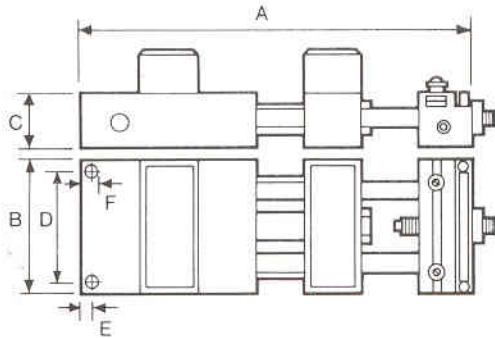
9 Adjusting bolt and lock nut provide positive feed length control.

10 Holes for mounting to a die set, press or mounting block.

PRESS FEEDS



NOTE: Length = A + 2 x stroke of chosen Model



* Note long feeds of this size are fitted with support rails which increase C by 57mm

	4115 SERIES mm	4125 SERIES mm	4130 SERIES mm	4140 SERIES mm	4180 SERIES mm	4180 SERIES mm	41100 SERIES mm	41120 SERIES mm
A	120	120	175	175	210	210	210	279
B	82.5	108	140	165	235	286	337	387
C	32	32	44	44	49.6	49.6	49.6	63
D	67	92	114	140	190.5	241	292	343
E	9.5	9.5	12.7	12.7	16	16	16	16
F	8	8	9.5	9.5	16	16	16	16

	41140 SERIES mm	4230H SERIES mm	4260H SERIES mm	4260X SERIES mm	42120H SERIES mm	42160H SERIES mm	42200H SERIES mm	42240H SERIES mm
A	279	218	279	396	322	322	322	322
B	438	140	235	235	406	406	610	711
C	63	49.6	63	86	86*	86*	86*	86*
D	394	114	190	191	362	464	565	667
E	16	12.7	16	16	22	22	22	22
F	16	9.5	16	20	19	19	19	19

Overall length of Feed Unit is A dim. + 2 x Max-Stroke of Model required.

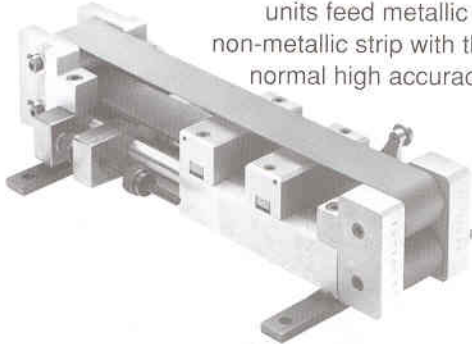
EG: Model 41152 has 50mm Stroke A dim. = 120mm. Therefore 120 + (2 x 50) = 220mm overall length.

FEED MODEL No.	MAX. STRIP WIDTH (mm)	MAX. STRIP THICKNESS (mm)	MAX. STROKE (mm)	STROKES/ MIN. (AT MAX. STROKE)	PULLING POWER (SUPPLY AT 6.8 BAR/100 psi.) kg.	FEED MODEL No.	MAX. STRIP WIDTH (mm)	MAX. STRIP THICKNESS (mm)	MAX. STROKE (mm)	STROKES/ MIN. (AT MAX. STROKE)	PULLING POWER (SUPPLY AT 6.8 BAR/100 psi.) kg.				
41152	38	1.0	50	270	9	411406	356	2.0	152	70	66				
41154			100	200					4114012	305		40			
41156			152	160					4114016	406		30			
41158			203	130					4114024	610		15			
411510			254	110					42303H	76		2.3	45	76	200
411512			305	90										42306H	152
41252	50	230	423010H	254	95										
41254	100	175	423012H	305	80										
41256	152	140	423016H	406	45										
41258	203	110	423020H	508	35										
412510	254	95	423024H	610	20	42606H	152	2.3	152	110	66				
412512	305	80	426010H	254	80										
41303	76	200	426012H	305	70										
41306	152	140	426016H	406	40										
41308	203	110	426020H	508	25										
413010	254	95	426024H	610	18										
413012	305	80	42606X	152	4.0	136	152	60							
413016	406	50					426010X	254	50						
413020	508	35					426012X	305	45						
413024	610	20					426016X	406	35						
41404	102	180					426020X	508	25						
41406	152	140					426024X	610	15						
41408	203	110	421206H	305	3.2	136	152	70							
414010	254	95					4212010H	254	45						
414012	305	80					4212012H	305	40						
414016	406	50					4212016H	406	30						
414020	508	35					4212020H	508	20						
414024	610	20					4212024H	610	16						
41604	152	170	421606H	406	2.3	136	152	70							
41606	152	120					4216010H	254	50						
41608	203	100					4216012H	305	45						
416010	254	80					4216016H	406	35						
416012	305	70					4216020H	508	25						
416016	406	40					4216024H	610	16						
416020	508	25	422006H	508	1.9	136	152	50							
416024	610	18					4220010H	254	36						
41804	102	150					4220012H	305	30						
41806	152	120					4220016H	406	26						
41808	203	100					4220020H	508	20						
418010	254	80					4220024H	610	15						
418012	305	70	422406H	610	1.5	136	152	46							
418016	406	40					4224010H	254	30						
418020	508	25					4224012H	305	26						
418024	610	15					4224016H	406	20						
411004	102	150					4224020H	508	14						
411006	152	120					4224024H	610	10						
4110010	254	80	* NOTE H = HEAVY DUTY X = EXTRA HEAVY DUTY				254	80							
4110012	305	70					4110016	406	40						
4110016	406	40					4110020	508	25						
4110020	508	25					4110024	610	15						
411206	152	70					4112010	254	45						
4112010	254	45					4112012	305	40						
4112012	305	40	4112016	406	30										
4112016	406	30	4112020	508	20										
4112020	508	20	4112024	610	15										

ROLLBAND FEEDS

(Brit Patent No. 1285763)

Rollband Feeds completely eliminate 'buckling' when feeding very thin or flimsy materials. They are modified versions of standard units with two endless bands fitted. The material is 'sandwiched' between the bands over a large area, and these units feed metallic or non-metallic strip with the normal high accuracy.



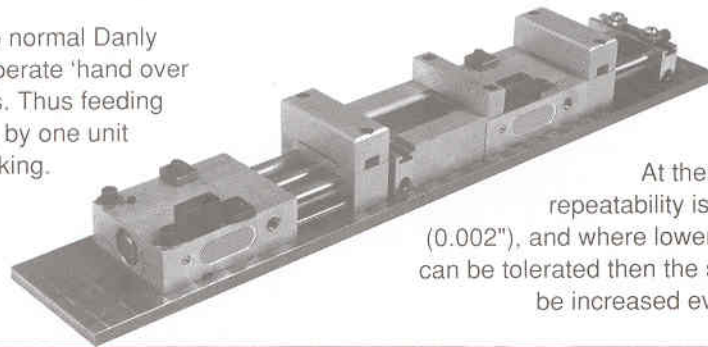
OPEN THROAT FEEDS

For applications where a variety of strip widths must be accommodated. Danly can supply specially-strengthened open-side units. These operate in synchronised pairs, one on each edge of the strip, and provide double the pulling power. Apart from being able to space them apart to any width within the limits of the particular model, the units operate exactly as standard Feeds, providing full stroke variation and the usual $\pm 0,03\text{mm}$ (0.001") repeatability.



HIGH SPEED FEEDS

In the High Speed arrangement, two normal Danly Feeds are linked together so they operate 'hand over hand' on the infeed side of the press. Thus feeding can be speeded up by at least 50%, by one unit feeding while the other is return stroking.



At these speeds repeatability is $\pm 0.05\text{mm}$ (0.002"), and where lower accuracy can be tolerated then the speed can be increased even further

TRIGGER OPERATION



Danly Feeds can be arranged for trigger actuation, where the trigger is operated by a striker fitted to the press ram. The trigger remains deflected during the down stroke and keeps the material firmly clamped, then as it is released on the upstroke it initialises the feeding sequence.

REMOTE AIR & SOLENOID



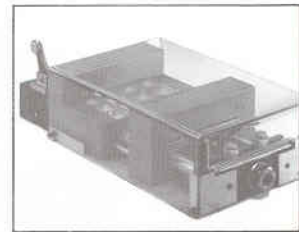
Where there are frequent set-up changes which would mean resetting the tripping action with Trigger Operation, an alternative is to use a Danly remote control feed. In this case either an electrical switch or a pneumatic valve mounted from the press frame is tripped by a cam added to the end of the crankshaft. Thus the action is independent of the press stroke setting or the tools being used.

REPEATER CONTROL



Where feed lengths are required in excess of the maximum stroke setting of a particular unit. Danly can supply an electronic repeater control system which is capable of initiating up to 99 feed movements for each stroke of the press. The system also allows normal single stroking operation, being readily switchable between the two.

SAFETY GUARDS



As with all other moving machinery, Danly Feeds must be fitted with safety guards, and these are supplied. They completely enclose the moving parts, yet allow full access for adjusting the stroke; they can easily be removed when necessary.

PULL THROUGH STRAIGHTENERS WITH RELOAD RELEASE

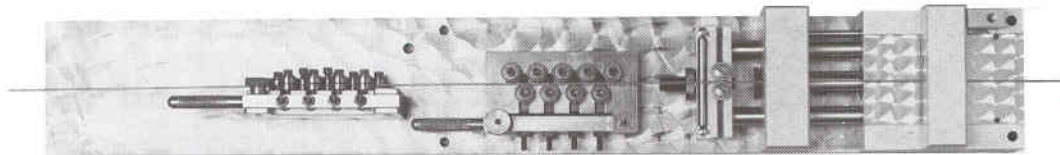
Danly offers two types of Pull-Through Straighteners, one for flat stock and the other for wire.

Flat Stock Straighteners, mounted 'up stream' from the feed unit, normally comprise a 5-roll format comprising three bottom rolls and two at the top; these being adjustable for height to suit different thicknesses of material. A unique camlock mechanism allows the top rolls to be raised for loading and then lowered again without disturbing the thickness setting.

Wire Straighteners, for mounting 'up stream' of a feed unit, normally have two 5-roll clusters, one operating in the horizontal plane and the other vertically. Individual rolls can be grooved to suit particular wire sections and can easily be changed as required.

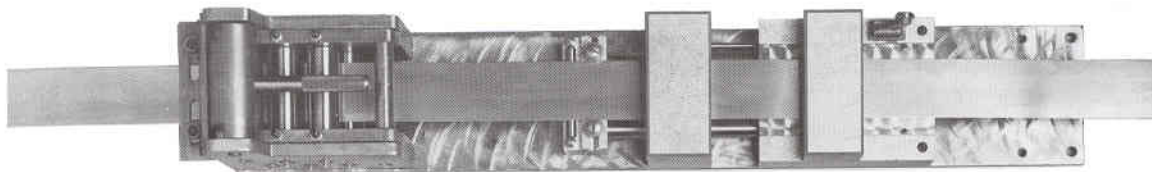
A special camlock mechanism opens the rolls for loading without disturbing the setting. Both types of Straighteners can be supplied with other roll configurations as alternatives to the normal 5-roll systems.

FOR WIRE & RIBBON



MODEL No.	40515A	405210A	40717A	407214A	40919A	409218A	40515B	405210B	40717B	407214B	40919B	409218B	40515C	405210C	40717C	407214C	40919C	409218C
Max. Wire Dia. mm	0.4 - 1.6						1.6 - 5.0						3.8 - 7.6					
Max. Ribbon Width mm	9.52	9.52	9.52	9.52	9.52	9.52	12.7	12.7	12.7	12.7	12.7	12.7	19.05	19.05	19.05	19.05	19.05	19.05
Roll Centres mm	25.4	25.4	25.4	25.4	25.4	25.4	38.1	38.1	38.1	38.1	38.1	38.1	57.1	57.1	57.1	57.1	57.1	57.1
Roll Dia. mm	19	19	19	19	19	19	25.4	25.4	25.4	25.4	25.4	25.4	41.3	41.3	41.3	41.3	41.3	41.3
No. of Rolls	5	10	7	14	9	18	5	10	7	14	9	18	5	10	7	14	9	18
No. of Planes	1	2	1	2	1	2	1	2	1	2	1	2	1	2	1	2	1	2

FOR FLAT STOCK



MODEL No.	46350	46351	46352	46353	46650	46651	46652	46653	46851	46852	46853	461051	461052	461053	461252	461253
Max. Width mm	76	76	76	76	152	152	152	152	203	203	203	254	254	254	305	305
Max. Thickness mm	0.76	1.52	2.28	3.81	0.76	1.52	2.28	3.81	1.52	2.28	3.81	1.0	2.0	3.0	1.52	2.28
Roll Dia. mm	22.2	31.7	44.4	63.5	22.2	31.7	44.4	63.5	31.7	44.4	63.5	31.7	44.4	63.5	44.45	63.5