

Automatic Bar Feed Magazines

For 00, 2 and 3 Ultramatic Screw Machines

The Brown & Sharpe Automatic Bar Feed Magazine (made for B & S by Lipe-Rollway Corp.) is an air-operated feeding device for automatically feeding bars, rods or tubing to the machine spindle. As the stock is completely enclosed within the stock tube, there is no danger from whipping bar ends and the need for expensive guarding is eliminated.

Up to 8 hours supply of stock can be loaded in the magazine (9-1 1/4" (31.8mm) bars to 192-1/16" (1.6mm) bars can be accommodated). This stock is fed automatically, one bar after another until the supply is exhausted. The magazine can be re-loaded at any time without interfering with the feeding cycle. The time required to completely restock the magazine is 2 to 3 minutes.

When the bottom bar from the gravity-feed magazine drops into the split stock-tube it is pushed by air pressure into the machine spindle and up to a stop. The forward end of the bar is chucked in the machine collet and the

trailing end is supported in a revolving cup-center. As there is little surface contact at any point between the stock bar and the stock tube, stock is fed with a minimum of scratching or marring.

A pusher, with a cup center, behind the stock bar feeds the stock through the spindle and collet, thus dispensing with the conventional feed finger. On the first feed-out, when required, the stock is fed to the swing stop for the cut-off to square the bar. From then on, the stock is fed to the stock stop in the turret each time the collet opens (.2 to .5 second on the 00 machine and .5 to 1 second on the 2 and 3).

The stock bar will be moved forward each time the collet opens, until the last full length workpiece has been machined and cut off.

Then, as the screw machine approaches the reloading position, the machine clutch will automatically be disengaged. With the spindle revolving and the collet open, the remnant or bar end will be ejected by either an extended

Capacities and Shipping Weights

Machine Used With**	Model No. of Magazine	Magazine Stock Capacity				No. of Standard Collet Used in Machine	Standard Collet Capacity Range				Shipping Weight (Approx.) Lbs. kg	
		Min. Inches	mm	Max. Inches	mm		Min. Inches	mm	Max. Inches	mm		
00 (1/2") (12.7mm)	25 AML	1/16	1.6	3/16	4.8	00	1/16	1.6	3/8	9.5	1325	601
	43 AML	3/32	2.4	5/16	7.9	10	1/16	1.6	1/2	12.7		
						00	1/16	1.6	3/8	9.5		
	56 AML	1/8	3.2	3/8	9.5	00	1/16	1.6	3/8	9.5		
						10	1/16	1.6	1/2	12.7		
62 AML	1/8	3.2	1/2	12.7	10	1/16	1.6	1/2	12.7			
00 or 2 (3/4") (19.1mm)	87 AML	3/16	4.8	3/4	19.1	11	1/16	1.6	5/8	15.9	1775	805
						11C	2 1/32†	16.7†	3/4	19.1		
2 or 3	125 AML	5/16	7.9	1	25.4	22	1/8	3.2	1	25.4	1775	805
	156 AML	3/8	9.5	1 1/4	31.4	22C	1 1/32†	26.2†	1 1/4	31.4		
	181 AML	1/2	12.7	1 1/2 Tubing	38.1	22D	1 1/32†	26.2†	1 1/2	38.1		
1/2											12.7	1 1/4 Bars

**When ordering magazine, specify the Size, Style and Serial Number of the machine with which it will be used.
†Special collet is necessary for stock below the minimum diameter accommodated in the standard collet.