



travel ejector pin, located within the Bar Feed Pusher, or by a momentary jet of air from the Air Eject Unit.

At this time, the Pusher immediately retracts to the rear of the Bar Feed, a new bar drops into the stock tube, and the Pusher feeds the bar forward through the open collet to the Swing Stop. The clutch is then automatically engaged and full cycle operation is resumed. Total time for reloading is approximately five seconds.

These magazines will accommodate practically every shape of stock, in any length from 4' (1.2m) to 12'2" (3.7m), and any diameter from 1/16" (1.6mm) to 1 5/8" (41.3mm) (depending on size of magazine). In a single feed-out operation, using second operation clutching (to keep the collet open sufficiently long) feed out can be any length. There is no rebound of the bar from the machine stop. With a qualified set-up and operation, accuracy of the work piece length can be held within $\pm 0.001"$ ($\pm 0.03\text{mm}$) tolerance.

Set-up time for the bar feed unit varies from 5 to 15 minutes.

Feed cylinder air pressure is 12 to 35 P.S.I. (.84 to 2.46 k p/cm^2).

Included as standard equipment with these magazines is one Stock

Pusher Assembly selected for solid bars or one specific size of tubular stock, one spindle liner where required, Air Eject Unit, Multi-Swing Stop Control Unit, all necessary fittings, air hose, etc., for installation.

The Bar Feed with standard equipment will feed bars varying in length up to approximately 12" (305mm). For lengths of greater variation an attachment for random length stock is necessary.

For shorter than average piece lengths, it is recommended that a *Turret Swing Stop and Eliminator* be used in conjunction with the *Multi-Swing Stop Control* and *Air-Eject* units. Purchase of this combination with the magazine will anticipate the needs of the widest variety of work.

Where stock is used at a very rapid rate, the *Extended Stock Guide* provides up to 75% more capacity than the standard stock rack. Stock is stored directly above the magazine thus eliminating stand-by storage in the busy production area.

Square Stock requires a set of *Stock Guides* altered to allow the lowest bar in the magazine to tilt slightly so that the stock holding pins can enter between this bar, which is about to be loaded into

the stock tube, and the other bars in the guides.

When small diameter stock is used on long runs, the stock tube and breach section of the magazine should be replaced with the stock tube and breach section nearest in size to the stock diameter plus 1/8" (3.2mm). A matching spindle liner and stock pusher assembly is also required. As the frames of the Nos. 25 AML, 56 AML and 62 AML magazines are identical, the stock tubes are interchangeable.

Available for the 00 machine is a *High Speed Spindle Feeding Auxiliary* for use with high speed non-reversing spindle and for use at high speeds on fast cycle reversing spindle jobs. This unit is used with the model No. 43 AML magazine for stock up to 5/16" (7.9mm) diameter (bars must be straight).

When soft materials such as aluminum and brass or thin wall tubing are used at high spindle speeds, *Cone Head Ejectors* are recommended. This will avoid excessive wear at the bar ends and the subsequent accumulation of chips in the stock tube and spindle liner.

Special stock pushers, supplementary accessory units, etc. are other items of extra equipment—available where set-up and operation require a selection.