

H Series

NC Roll Feeding Machine

Model H07 / H13 / H25**Specifications Note****Cautions for Installation**

1. The supply voltage for NC feeding machines are 3 phase 200V ($\pm 10\%$) \cdot 50/60Hz, and no adjustment is made to adapt to conditions of electricity at each installation site.
Note that a transformer to be installed independently is needed to adapt to the supplied voltage at the site where the feeder is going to be installed.
2. English characters and symbols are used to indicate operation panels on the controller.
3. The harmonic content included in the power circuit, which provides servo function, may cause radio hazards to AM radio, etc.
4. Installing a breaker may be required to work with to the inverter which is placed at the site where the Feeder is installed.
5. Conformity of the specifications depends on machining system, type of the mold, and conditions of equipment.
6. DIMAC NC Feeder is manufactured on the basis of specifications for domestic (in Japan) use. If the feeder is relocated to overseas or exported, be sure to start operation after safety requirement to observe in the country concerned is confirmed and necessary measures are taken.

* This specifications is subject to changes without notice.

The feeder is under warranty in accordance with DIMAC Quality Assurance Provisions as described below.

【1】 Warranty

(1) Scope

- 1) If DIMAC genuine parts are found to be faulty under normal conditions of operation described in the Manual due to defects in the material or in the manufacturing process, the parts are supplied free of charge.

(2) Term

- 1) 12 months from the date of shipment.
- 2) 12 months from the date within thirty (30) days of shipment and described in the export declaration, if used overseas.

(3) Method

- 1) Persons are not dispatched to an installed site for repair and service but maintenance products and /or repair parts are provided.

【2】 Warranty exclusions

(1) Cases listed below are excluded from the scope of warranty while in the terms of warranty.

- 1) Natural disasters such as earthquake, typhoon, flood, and thunder fall, or accidents, fire, etc.
- 2) Failure or malfunction due to repair, restoration, remodeling, etc. irrelevant to DIMAC.
- 3) Usage out of the scope described in the specifications and ill or incorrect maintenance.
- 4) Malfunction and failure due to other equipment connected to the feeder.
- 5) Defects, corrosion, etc. due to external factor.
- 6) Malfunction due to aging, wear from usage.
- 7) Changes to human sense irrelevant to function (operational noises from controller, motor, etc.).
- 8) Consequential damages to material, product, personal body, etc. due to installing this machine.

(2) Services below are provided at user's charge.

- 1) Inspection, maintenance, and cleaning.
- 2) Replacement of supply parts described in the Manual.

【3】 Repair after the term of warranty is expired.

- 1) Repair to the product whose warranty term is expired is provided at user's charge.
- 2) For the case where 13 years have passed since the date of shipment of this product, there might be cases where repair service can't be provided due to stock and procurement conditions of the parts.
- 3) When quality and performance assurance after repair is deemed to be impossible, there might be cases where repair service can't be provided.

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▪ Specification

Specification		Unit	H07	H13	H25
Max. Material width		mm	~75	~130	~250
Max. Material thickness		mm	~1.2	~1.6	
Max. press follow-up speed		spm	~1000		~700
Feeding system			Roll system by servo motor		
Acceleration adjustment			Automatic calculation (by press speed and feeding angles)		
Max. feed length		mm	~999.99		
Feed length setting unit		mm	0.01		
Roll pressure system			Electromagnet		
Roll pressure range		N	~1470	~2450	
Effective feed start angle			210° ~150°		
Effective feed finish check angle			210° ~150°		
Release system			Electromagnet		
Release start effective angle			60° ~180°		
Release finish effective angle			120° ~300°		
Power supply voltage		V·Hz	3-phase 200V (±10%)·50/60Hz		
Total weight		kg	34	52	66
Protection circuit	Standard		1. 2circuit emergency stop output 2. Abnormal stop output 3. Continuous operation stop output 4. Emergency stop input circuit 5. Self-diagnosis / Abnormal stop 6. Overload prevention stop 7. Check for the rotation sensor running		
	Option		1. Work shortage sensor 2. Feeder synchronization signal input circuit		
Controller model			430C		

▪ Performance table

Max. feed length by the feed angle and rotation speed (mm)

H07

Press Speed	Feed Angle	
	180°	210°
SPM/Cons.	Unit(mm)	
1000	*5.8	*9.5
950	*6.8	*11.0
900	*8.1	*13.0
850	9.7	*15.3
800	11.6	*18.1
750	14.1	*21.6
700	17.1	25.9
650	20.9	31.4
600	25.9	38.6
550	32.5	47.9
500	41.4	59.3
450	53.3	73.3
400	68.3	90.8
350	87.6	113.3
300	113.3	143.2
250	149.2	185.2
200	203.2	248.2

H13

Press Speed	Feed Angle	
	180°	210°
SPM/Cons.	Unit(mm)	
1000	*5.1	*8.4
950	*6.1	*9.8
900	*7.2	*11.5
850	8.6	*13.5
800	10.3	*16.0
750	12.4	*19.1
700	15.1	23.0
650	18.5	27.8
600	23.0	34.1
550	28.8	42.4
500	36.7	53.5
450	47.6	68.3
400	63.0	86.9
350	83.5	110.8
300	110.8	142.7
250	149.1	187.3
200	206.4	254.2

H25

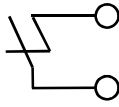
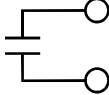
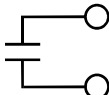
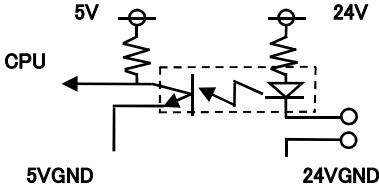
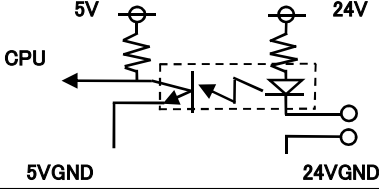
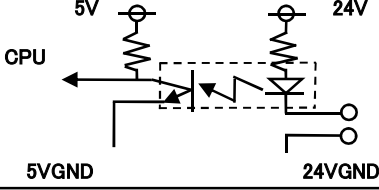
Press Speed	Feed Angle	
	180°	210°
SPM/Cons.	Unit(mm)	
700	11.3	*17.2
650	13.9	20.9
600	17.2	25.6
550	21.6	31.8
500	27.5	40.1
450	35.7	51.6
400	47.4	68.1
380	53.3	76.6
360	60.7	86.4
340	69.4	97.3
320	79.8	109.6
300	91.7	123.6
280	105.4	139.5
260	121.1	157.9
240	139.5	179.3
220	161.2	204.7
200	187.3	235.1

*The release operation may not be able to follow depending on the press start angle and acceleration.

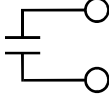
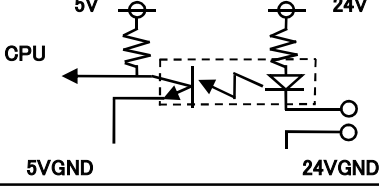
Note:

It may be impossible to finish workpiece feeding at the angle as specified on the feed performance table if the feeder is under a load resulting from material stress, etc.

Requirements for installing press

Press	H07	H13	H25
Power supply voltage	3-phase 200V ($\pm 10\%$) \cdot 50/60Hz		
Rated power consumption	1000W	1875W	
Emergency stop switch input 2-systems support	Emergency stop signal output This signal output directly from the emergency stop switch 1 A at 250 VAC or less 1 A at 30 VDC or less		
Abnormal stop input	Abnormal stop output 1 A at 250 VAC or less 1 A at 30 VDC or less		Output at open 
Continuous operation stop input	Continuous operation stop output 1 A at 250 VAC or less 1 A at 30 VDC or less		Output at open 
Emergency stop output Open collector output or contact output	Emergency stop input circuit 0.01 A at 24 VDC		
Press continuous operation output Open collector output or contact output	Press process input circuit 0.01 A at 24 VDC		
Synchronizing signal output Open collector output or contact output	Check for run the rotation sensor Feed signal input circuit Release signal input circuits		
Rotation shaft of press machine	Synchronizing rotation 1:1		

<Option>

Press	H07	H13	H25
Work shortage sensor input circuit	Work shortage sensor output circuit 1 A at 250 VAC or less 1 A at 30 VDC or less		Output at open 
Synchronizing signal output 2-Open corrector output or 2-Contact output	Feeder synchronization signal input circuit Feed signal input circuit Release signal input circuits		

▪ **Standard product and accessories**

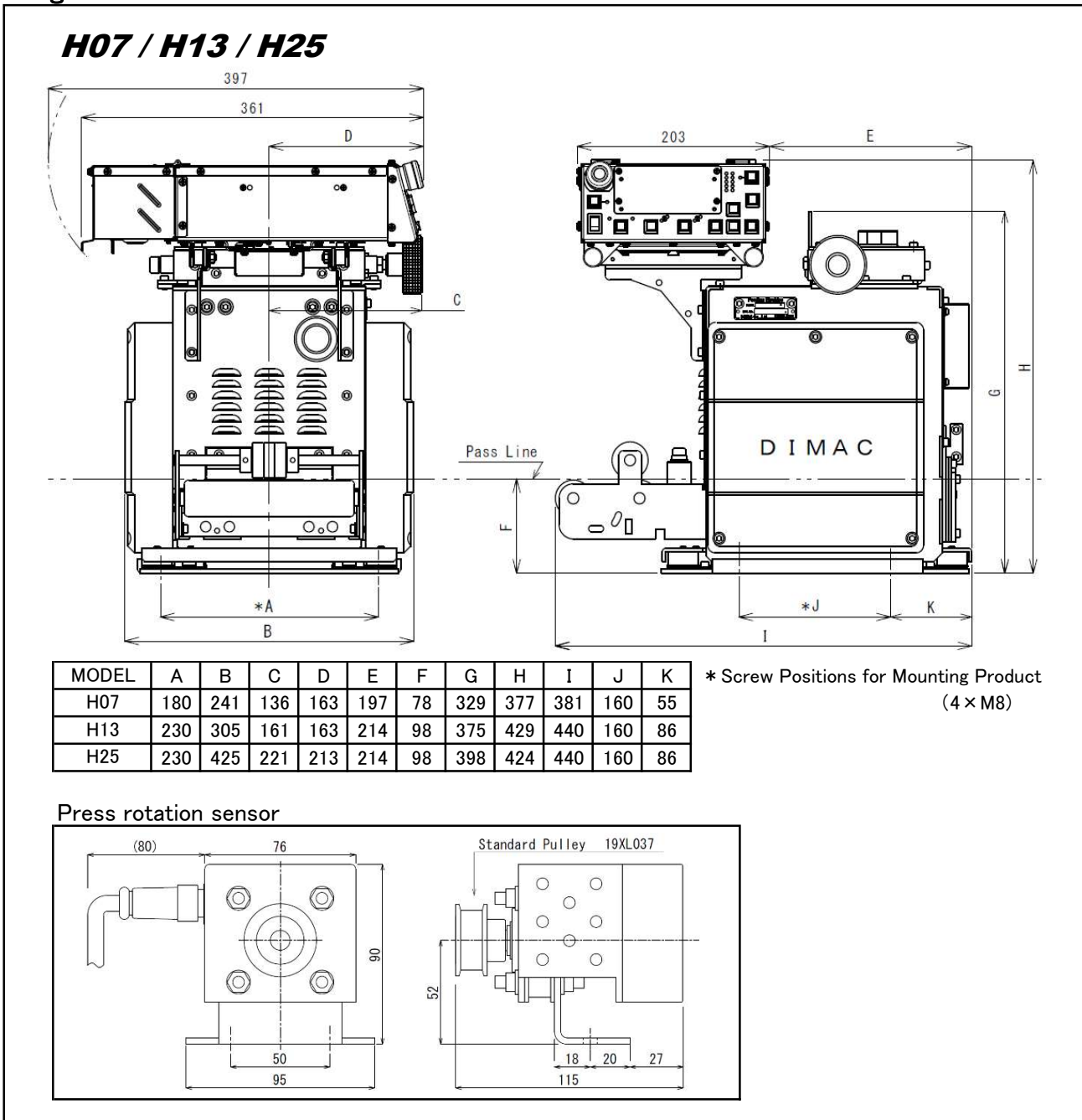
▪ Electrical cable	1 set-8m × 1
▪ Press rotation sensor	
▪ Cable for press rotation sensor	6m × 1
▪ Pulley for the press	
▪ Terminal, Mark tube	
▪ Fixing bolt washer	
▪ Instruction manual	

▪ **Option**

▪ Mounting bracket for machining unit
▪ Work shortage sensor
▪ DS6 / Feed direction change
▪ BS6 / Feed-during output
▪ FF6 / Feed complete output
▪ MP6 / Data bank
▪ TC6 / Feed conditions measurement
▪ RC6A / Remote box

*There are other options as well.

▪ **Figure of dimension**



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