

T Series

NC Twin Roll Feeding Machine

**Model T20 / T30****Model TR50****Model TJ06 / TJ15**

## Specifications Note

### Cautions for Installation

1. The supply voltage for NC feeding machines are 3 phase / single 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.

## ▪ Specification

Specification		Unit	T20	T30	TR50	TJ06	TJ15
Max. Material width		mm	~200	~300	~500	~70	~150
Max. Material thickness		mm	~3.2			~1.2	~2.3
Max. press follow-up speed		spm	~200				
Feeding system			Roll system by servo motor				
Acceleration adjustment			Automatic calculation (by press speed and feeding angles)				
Feed length		mm	0.01~999.99				
Roll pressure system			Spring				
Roll pressure range *1		N	~1716		~1960	~784	~1470
Release system			Air cylinder			Air diaphragm cylinder	
Slid adjustment length *2		mm	160		N/A	130	
Min. passline height *2		mm	118		N/A	83	103
Press frame gap length *2		mm	210	260	N/A	115	170
Sheet material	Max. press shoot count		~999				
	Discharge length setting	mm	~999 (Setting in 1 mm increments)				
	Max. Feeding weight *3	kg	15		25	3	10
	Approximate dimensions *4 wid. * thick.	mm	200 × 3.2	300 × 3.2	500 × 3.2	70 × 1.2	150 × 2.3
Coil material	Approximate dimensions *4 wid. * thick.	mm	50 × 3.2	50 × 3.2	80 × 3.2	70 × 1.2	60 × 2.3
			200 × 1.6	300 × 1.6	300 × 1.6		150 × 1.6
Power supply voltage			3-phase / single phase 200V (±10%)·50/60Hz				
Weight feeder side (With controller)		kg	48	56	62	15	25
Weight pull side		kg	46	54	59	11	23
Protection circuit	Standard		1. 2circuit emergency stop output				
			2. Abnormal stop output				
		3. Continuous operation stop output					
		4. Self-diagnosis / Abnormal stop					
		5. Overload prevention stop					
		6. Emergency stop input circuit					
	Option *5		1. Work shortage sensor				
Controller model			450C				

\*1 When maximum thickness. \*2 In case of installing in the bolster inner side. \*3 At maximum acceleration

\*4 It may vary depending on material stress and surface roughness.

\*5 Applicable only in coil mode, single mode. In the sheet mode, it is used as a standard as a cycle stop output.

## ▪ Performance table

### T20 / T30

Press Speed	Feed Angle	
	180°	210°
SPM/Cons.	Unit(mm)	
200	22	31
180	28	39
160	36	51
140	48	68
120	68	94
100	100	138
80	160	221
60	283	367
40	534	659

### TR50

Press Speed	Feed Angle	
	180°	210°
SPM/Cons.	Unit(mm)	
200	23	32
180	29	41
160	38	53
140	50	71
120	71	98
100	104	145
80	167	230
60	296	383
40	557	688

### TJ06

Press Speed	Feed Angle	
	180°	210°
SPM/Cons.	Unit(mm)	
200	31	45
180	40	56
160	52	73
140	70	97
120	97	136
100	144	200
80	231	318
60	408	528
40	769	949

### TJ15

Press Speed	Feed Angle	
	180°	210°
SPM/Cons.	Unit(mm)	
200	31	44
180	39	56
160	51	72
140	69	96
120	96	134
100	142	197
80	228	314
60	403	522
40	760	939

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

### 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.

## ▪ Standard product and accessories

▪Electrical cable 1set-8m × 1
▪Mounting bracket for machining unit *1
▪Slide plate *2
▪Foot switch *3
▪Air regulator
▪Terminal, Mark tube
▪Instruction manual

\*1 Left and right common

\*2 T/TJ only, not applicable to TR50

\*3 For material grabbing after the second time in sheet mode.

## ▪ Option

▪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.

**Requirements for installing press**

Press	T20	T30	TR50	TJ06	TJ15
Power supply voltage	3-phase / single phase 200V (±10%)·50/60Hz				
Rated power consumption	1600W		2000W	600W	1600W
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 Circuit specifications: Negative logic DC input Input current: 0.01 A at 30 VDC or less				
Press continuous operation output Open collector output or Contact output	Press process input circuit Circuit specifications: Negative logic DC input Input current: 0.01 A at 30 VDC or less				
Synchronizing signal output 2-Open corrector output or 2-Contact output	Feeder synchronization signal input circuit Feed signal input circuit Release signal input circuits Circuit specifications: Negative logic DC input Input current: 0.01 A at 30 VDC or less				
Air source spm200 ℓ/min.	0.4~0.5MPa (0.5MPa)	5.0		1.27	2.60

**Option**

Press	T20	T30	TR50	TJ06	TJ15
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 				

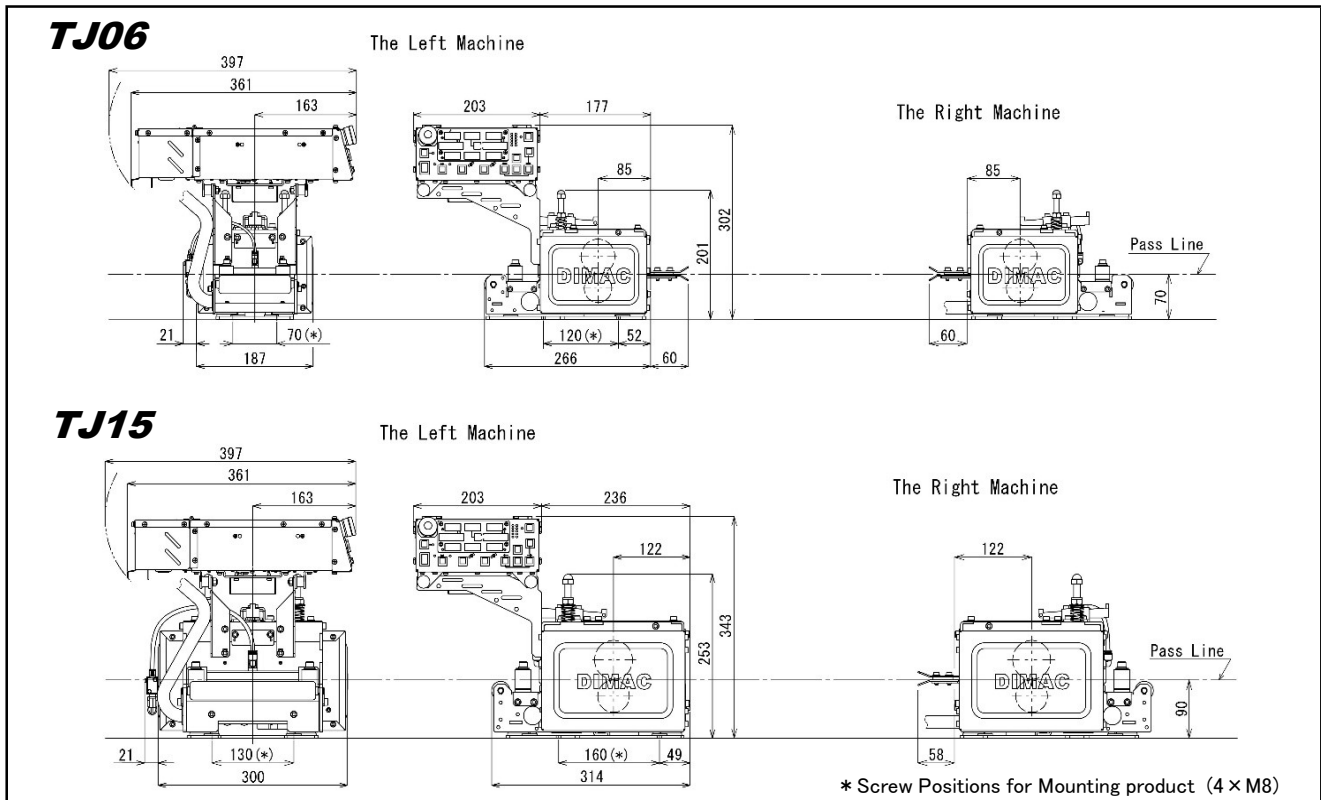
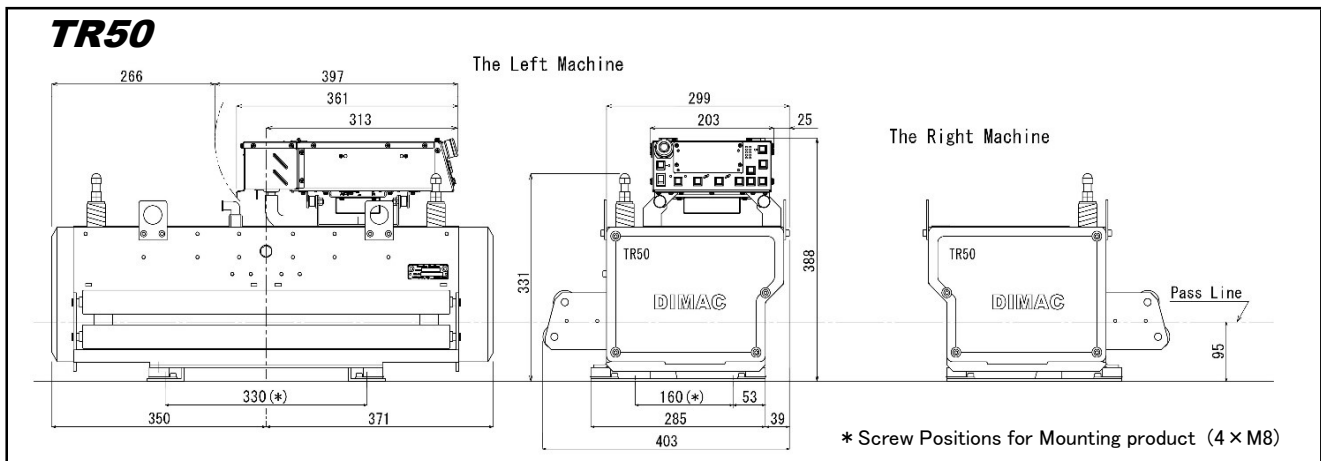
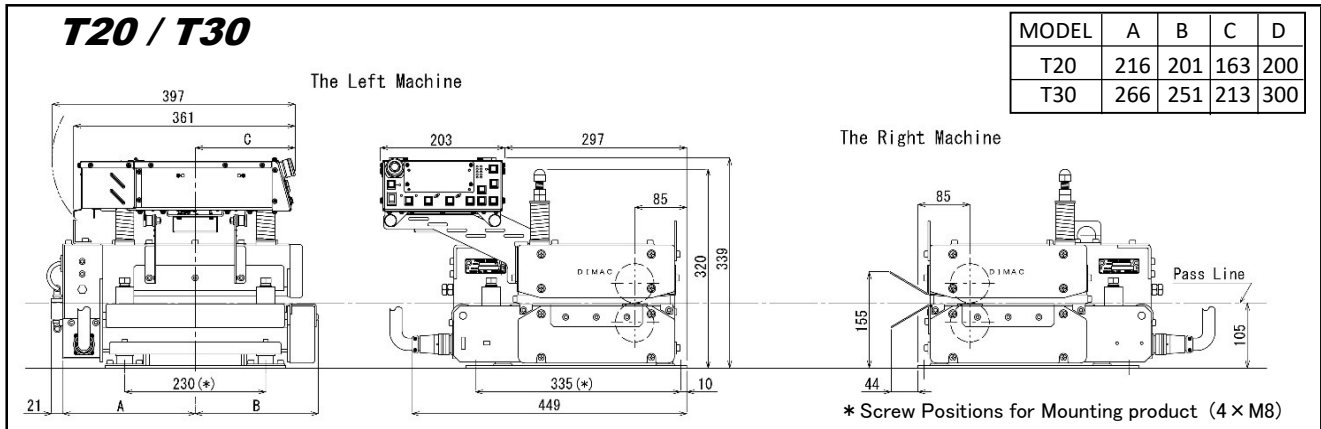
\* Applicable only in coil mode, single mode. In the sheet mode, it is used as a standard as a cycle stop output.

**Setting position : In case of installing in the bolster inner side.**

<p>• Max. slide position length T20 / T30 : 240mm ( Slide adjustment amount : 160mm) TJ06 / TJ15 : 120mm ( Slide adjustment amount : 130mm)</p> <p>• Min. pass line height T20 / T30 : 118mm TJ06 : 83mm TJ15 : 103mm</p>		<p>• Feeder depth from the roll center (Frame gap) T20 : 210mm T30 : 260mm TJ06 : 120mm TJ15 : 175mm</p>	
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\* TR50 is not applicable

• Figure of dimension



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