

# Zig Zag Feeder

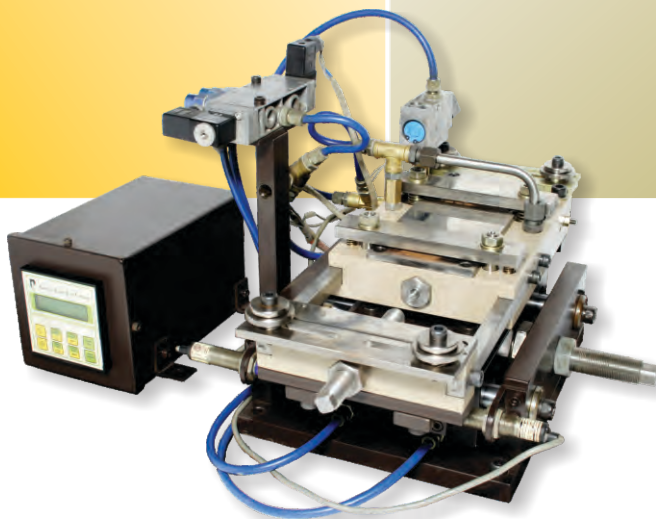
High Quality Product for  
Coil-Feeding in Press-Room



NC Servo Zig Zag Feeder  
Model SZZ - C1300



NC Servo Zig Zag Feeder  
Model SZZ - BH400



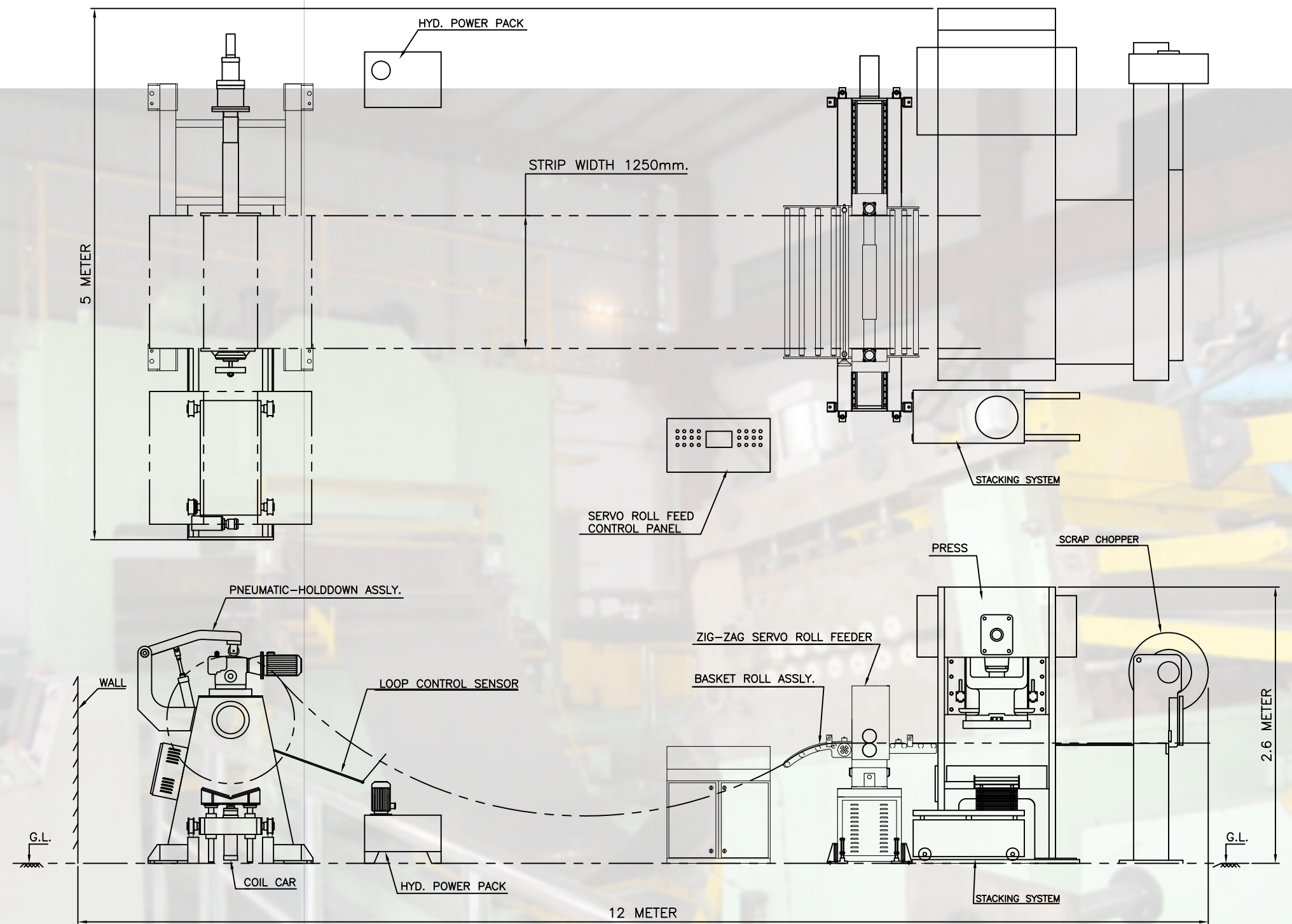
Pneumatic Zig Zag Feeder  
Model PZZ - 100



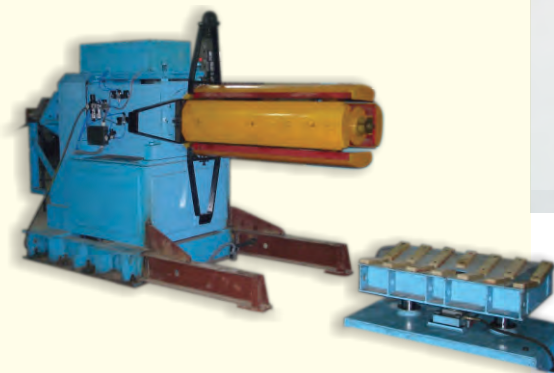
# Automatic Lines for Circle Cutting from Coil

Press Room Automation & Feed Fixtures Pvt. Ltd. manufactures automatic lines for circle cutting from coil with the aim of reducing the scrap quantity by exploiting the whole width of the coil. The technology used by Press Room is shifting of the coil below a fixed die. It is characterised by a **good production capacity, high flexibility and low tooling costs**. Line consists of decoiler with coil car, straightener, nc zig zag feeder, press, shear & stacker. Entire working sequence is directly managed from Control Panel which allows operator to have a single control of all the line functions.

The strip from the coil can have two movements, both NC servo controlled: the feeding movement (called longitudinal shifting) & the lateral movement (called transversal shifting). Thanks to these movements, each blanking is followed by the **lateral movement of the coil of a programmed step** and by the blanking of the next disk, up to the **realisation of a row of blanked disks along the coil width**. At the completion of the row, the strip is fed so that the blanking of a new row can start. Press Room has designed special programme which **automatically calculates position depending on stock width & circle diameter**. The program allows **optimizing the material use**, minimizing trimmings line functions.



NOTE – DIMENSIONS FOR REFERENCE ONLY.



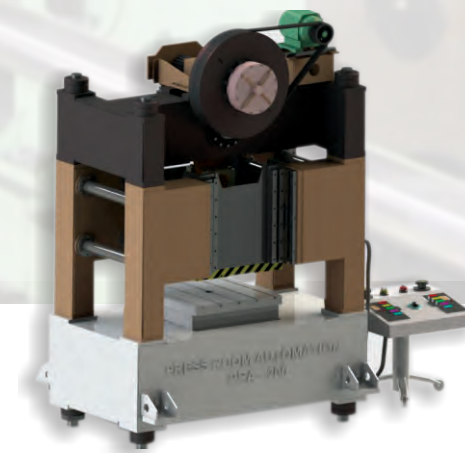
Decoiler with Coil Car



Straightener



Control Panel



H Frame Press



Deep Throat Press

## NC Servo Zig Zag Feeder

Designed for blanking out circles, zig/zag servo feeds can be programmed to perform from two to multiple rows / pattern, typically saving at least 8% in material costs.

- The feed head is mounted on a base with linear bearing and rails.
- Coil Width from 100 mm - 1300 mm.
- Zig/zag base is incorporated into main cabinet to allow for pass line height adjustments of 100 mm from the mean.
- Travel of zig/zag is servo driven on a ball screw.
- All zig/zag motion is programmable through the main control.
- Accuracy is  $\pm 0.15$  mm.
- Blanking pattern is calculated based on circle diameter and stock width.
- Standard Mitsubishi Servo, Drive, PLC & HMI package is provided. Others on request.

## NC Servo Zig Zag Feeder Models

| Model              | SZZ A300  | SZZ B300  | SZZ BH400 | SZZ B600  | SZZ C800  | SZZ C1300  |
|--------------------|-----------|-----------|-----------|-----------|-----------|------------|
| Material Thickness | 0.3 - 2.0 | 0.3 - 3.0 | 0.3 - 3.0 | 0.5 - 2.0 | 0.3 - 1.5 | .03 - 1.2  |
| Width              | 100 - 300 | 100 - 300 | 150 - 400 | 200 - 600 | 250 - 800 | 400 - 1300 |
| Circle Diameter    | 30 - 159  | 30 - 159  | 40 - 212  | 60 - 320  | 80 - 427  | 100 - 695  |
| SPM                | 40 - 60   | 35 - 55   | 30 - 50   | 25 - 40   | 20 - 40   | 15 - 40    |

## Pneumatic Zig Zag Feeder

Designed for blanking out diameters, pneumatic zig/zag can be adjusted to perform from two blanks, typically saving of 6% in material costs.

- The feeder to feed strip is mounted on a pneumatic zig zag feeding mechanism.
- Coil Width from 100 mm – 300 mm & Thickness from 0.5 – 2.00 mm.
- Pneumatic zig zag feeding mechanism mounted on a rigid bas has a settable indexing for blanking double row using single station tool.
- Pneumatic Zig Zag Feeder is provided with pass line height adjustments of 100 mm from the mean.
- The Feeder & zig zag feeding mechanism is synchronized with Pneumatics & Electronic Panel & necessary Sensors & End Cushions for smoother Zig Zag indexing with the Press.
- Accuracy is  $\pm 0.15$  mm.

## Pneumatic Zig Zag Feeder Models

| Model                          | PZZ - 100    | PZZ - 150    | PZZ - 300    |
|--------------------------------|--------------|--------------|--------------|
| Material Thickness             | 0.5 - 1.5 mm | 0.5 - 2.0 mm | 0.5 - 2.0 mm |
| Width                          | 0 - 100 mm   | 0 - 150 mm   | 0 - 300 mm   |
| Zig Zag Indexing Pitch         | 0 - 55 mm    | 0 - 80 mm    | 0 - 160 mm   |
| Stroke / Pitch / Feed / Length | 0 - 100 mm   | 0 - 150 mm   | 0 - 300 mm   |
| SPM                            | 80           | 60           | 30           |

## Servo Pneumatic Zig Zag Feeder

- Offering an economical solution for Multi Blanking.
- Coil Width from 100 mm – 300 mm & Thickness from 0.5 – 2.00 mm.

*The above equipments are designed for Line speed of 12-15 Mtrs. Per Minute.  
Models of higher capacity or higher or lower line speeds are available on request.*

*Technical specifications are indicative and subject to change to suit end application.*

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