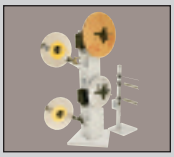
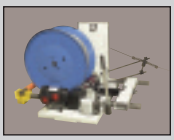
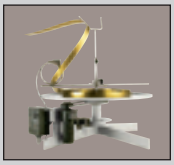
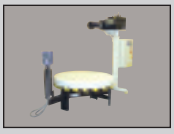
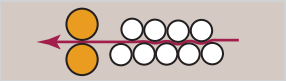
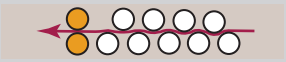
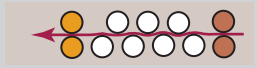
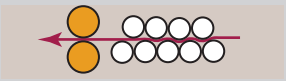
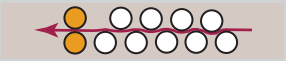
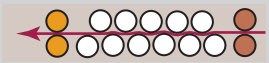
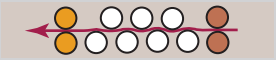
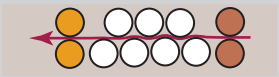
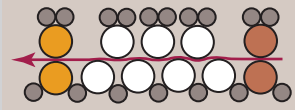
COIL HANDLING EQUIPMENT

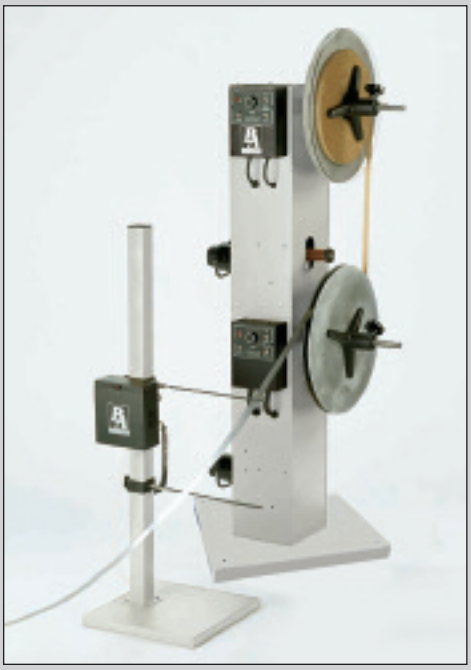
STOCK REEL SELECTION CHART

	Reel	Page Number	Max. Stock Width	Max. Coil Weight	Max. Coil OD	Coil ID Range
	FIXED SHAFT PAYOFF REELS	4	3"	100 Lbs.	42"	N/A
			75mm	45 Kg	1070mm	N/A
	PAPER INTERLEAF	5	10"	75 Lbs.	18"	N/A
			250mm	34 Kg	460mm	N/A
	**REWIND REELS**	6	3"	75 Lbs.	30"	0" – 00"
			75mm	34 Kg	760mm	00mm – 000mm
	LIGHT DUTY STOCK REELS	8	12"	600 Lbs.	48"	1" – 22"
			300mm	270 Kg	1220mm	25mm – 560mm
	MEDIUM DUTY STOCK REELS	10	32"	1600 Lbs.	60"	14.5" – 20.5"
			820mm	730 Kg	1525mm	370mm – 520mm
	HEAVY DUTY STOCK REELS	14	51"	20,000 Lbs.	60"	17" – 21"
			1300mm	9000 Kg	1525mm	430mm – 530mm
	**TRAVERSE SPOOL REELS**	16	N/A	3000 Lbs.	40"	N/A
			N/A	1360 Kg	1000mm	N/A
	**HORIZONTAL REELS**	17	5"	1200 Lbs.	56"	N/A
			125mm	540 Kg	1425mm	N/A
	PALLETIZER	18	6"	10,000 Lbs.	52"	N/A
			150mm	4500 Kg	1325mm	N/A
	**PALLET REEL STRAIGHTENER**	19	6"	10000 Lbs.	52"	N/A
			150mm	4500 Kg	1325mm	N/A

STOCK STRAIGHTENER SELECTION CHART

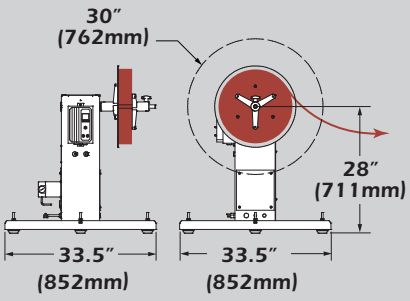
	Straightener	Page Number	Max. Stock Width	Thickness Range	Roll Arrangement
	PRECISION REEL STRAIGHTENERS	20	6" 150mm	.005" – .040" 0,1mm – 1,0mm	
	FLIP TOP REEL STRAIGHTENERS	21	12" 300mm	.015" – .068" 0,4mm – 1,7mm	
	SPACE SAVER REEL STRAIGHTENERS	22	24" 600mm	.015" – .135" 0,4mm – 3,4mm	
	PRECISION STOCK STRAIGHTENERS	24	6" 150mm	.005" – .040" 0,1mm – 1,0mm	
	FLIP TOP STRAIGHTENERS	25	12" 300mm	.015" – .083" 0,4mm – 2,0mm	
	MEDIUM DUTY STOCK STRAIGHTENERS	26	40" 1000mm	.015" – .135" 0,4mm – 3,4mm	
	HEAVY DUTY STRAIGHTENER	28	50" 1300mm	.030" – .256" 0,8mm – 6,5mm	
	MAGNUM STRAIGHTENERS	30	50" 1300mm	.040" – .276" 1,0mm – 7,0mm	
	EXTRA HEAVY DUTY STRAIGHTENERS	31	60" 1525mm	.050" – .375" 1,2mm – 9,5mm	

FIXED SHAFT PAYOFF REELS 50-100 Lbs.

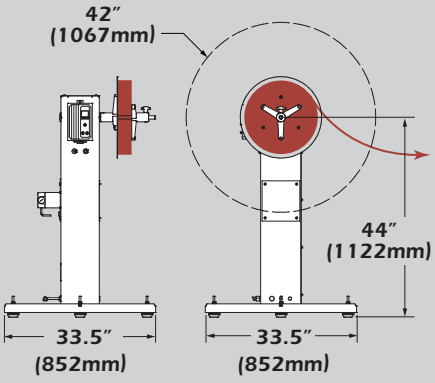


- Pay off fragile prestamped, plated or polished materials
- Motorized spindle with an adjustable slip clutch is used to rewind the paper interleaf
- Space saving design also allows the rewind of delicate materials
- Optional non-motorized paper interleaf with tensioning device
- Standard touch probe loop control on motorized models
- Optional dancer arm, proportional loop control or any no-touch sensor
- Recommended stainless steel shafts in corrosive environments
- Motorized and non-motorized models available

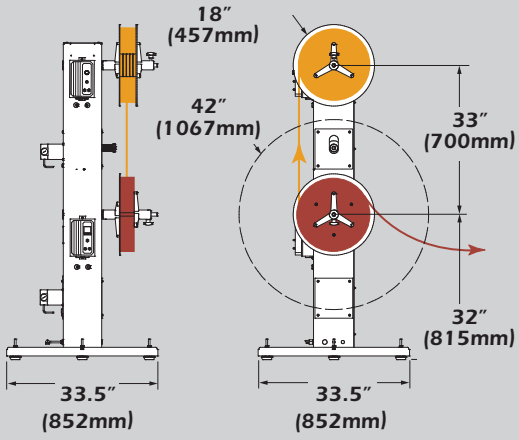
DIMENSIONS



Model SR50



Model SR75 / 100



Model SR50 / 75 / 100 w/Optional Paper Interleaf

SPECIFICATIONS – USA

Model	Max. Spool Weight (Lbs.)	Max. Stock Width (In.)*	Shaft Dia. (In.)	Max. Spool OD (In.)	Speed Range (RPM)	DC Drive Motor (HP)	Input Power VAC/Phase/Hz
SR50	50		.75	30			
SR75	75	3	.75	42	0 – 50	1/8	120 / 1 / 60
SR100	100		1	42			

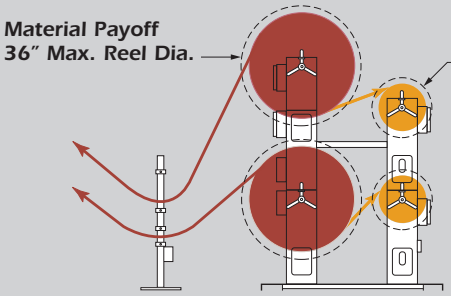
SPECIFICATIONS – METRIC

Model	Max. Spool Weight (Kg)	Max. Stock Width (mm)*	Shaft Dia. (mm)	Max. Spool OD (mm)	Speed Range (RPM)	DC Drive Motor (kW)	Input Power VAC/Phase/Hz
SR50	23		19	760			
SR75	34	75	19	1070	0 – 50	0,1	Specify Ordering
SR100	45		25,4	760			

*Wider widths available. Consult factory for higher speeds. See page 32 for Sensor Options. Dual and custom models available.
Paper rewind option decreased OD to 30″. Non-motorized available.

DUAL FIXED SHAFT PAYOFF REELS 75-100 Lbs.

- Available as standard and custom dual and quad payoff and rewind stands
- Engineering staff can design a system to provide more uptime for your operation



SPECIFICATIONS – USA

Model	Max. Spool Weight (Lbs.)	Max. Stock Width (In.)*	Shaft Dia. (In.)	Max. Spool OD (In.)	Interleaf Rewind	Speed Range (RPM)	DC Drive Motor (HP)	Input Power VAC/Phase/Hz
DSR75	75	3	.75	42	No	0 – 50	1/8	120 / 1 / 60
DSR75	75		.75	30	Yes			
DSR100	100		1	42	No			
DSR100	100		1	30	Yes			

SPECIFICATIONS – METRIC

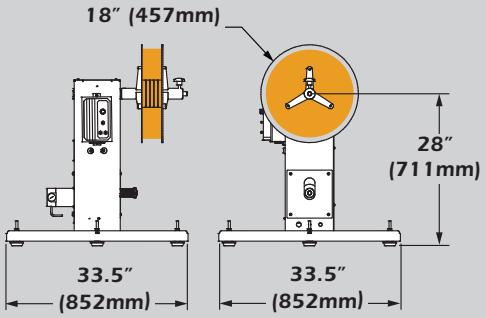
Model	Max. Spool Weight (Kg)	Max. Stock Width (mm)	Shaft Dia. (mm)	Max. Spool OD (mm)	Interleaf Rewind	Speed Range (RPM)	DC Drive Motor (kW)	Input Power VAC / Phase
DSR75	34	75	19	1070	No	0 – 50	0,1	Specify When Ordering
DSR75	34		19	760	Yes			
DSR100	45		25,4	1070	No			
DSR100	45		25,4	760	Yes			

*Wider widths available. Consult factory for higher speeds. See page 32 for Sensor Options. Custom models available.

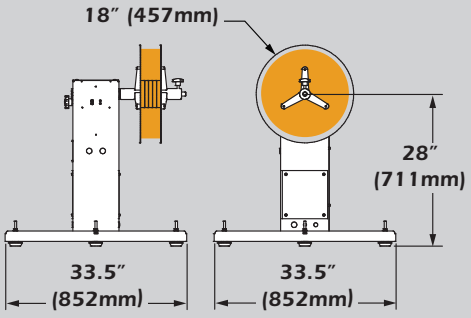
PAPER INTERLEAF

- Large reels may be fitted with paper interleaf options
- Self-contained units are designed to be mounted on our motorized reels
- Payoff Assembly is used when material is to be rewound and needs paper, plastic, or cloth to be interleaved between each layer. Adjustable tension is set by a hand knob which controls a caliper disc brake
- The Rewind Assembly eliminates the housekeeping problem of paper all over the floor by rewinding it onto a spool while material is being payed off. The fractional HP motor runs continuously and drives a 3/4 inch (19mm) diameter shaft through an adjustable slip clutch. The torque is set by a hand knob and allows the shaft to maintain tension on the interleaf material being rewound

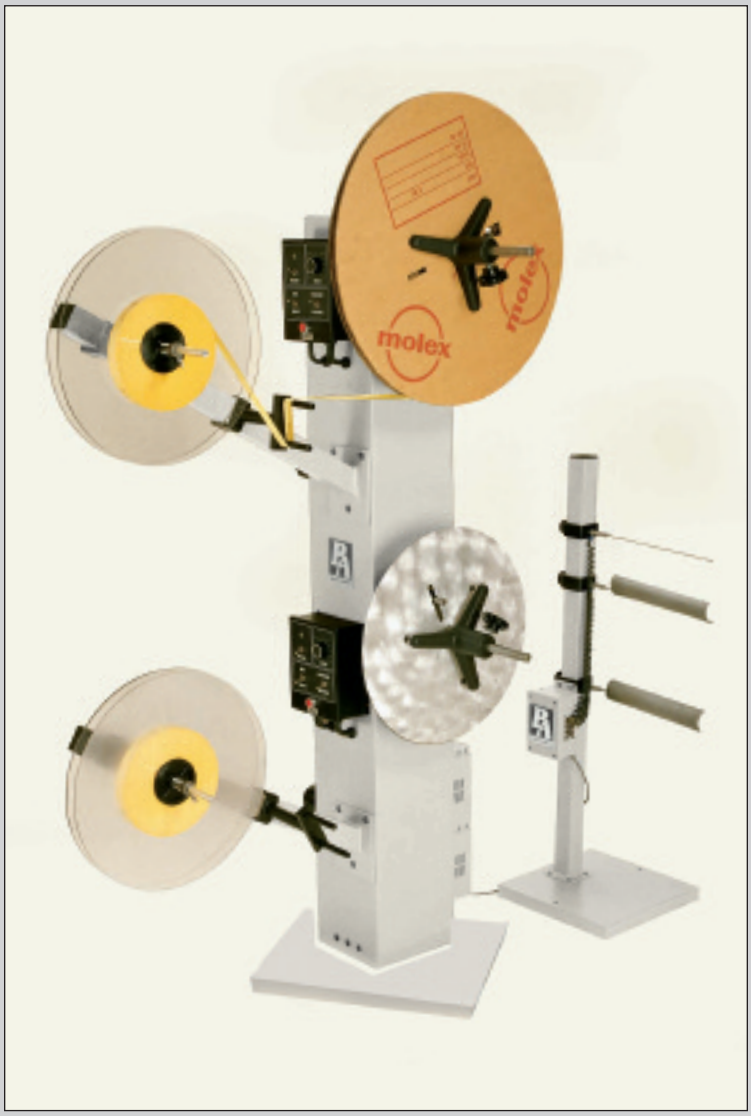
Rewind Motorized Assembly

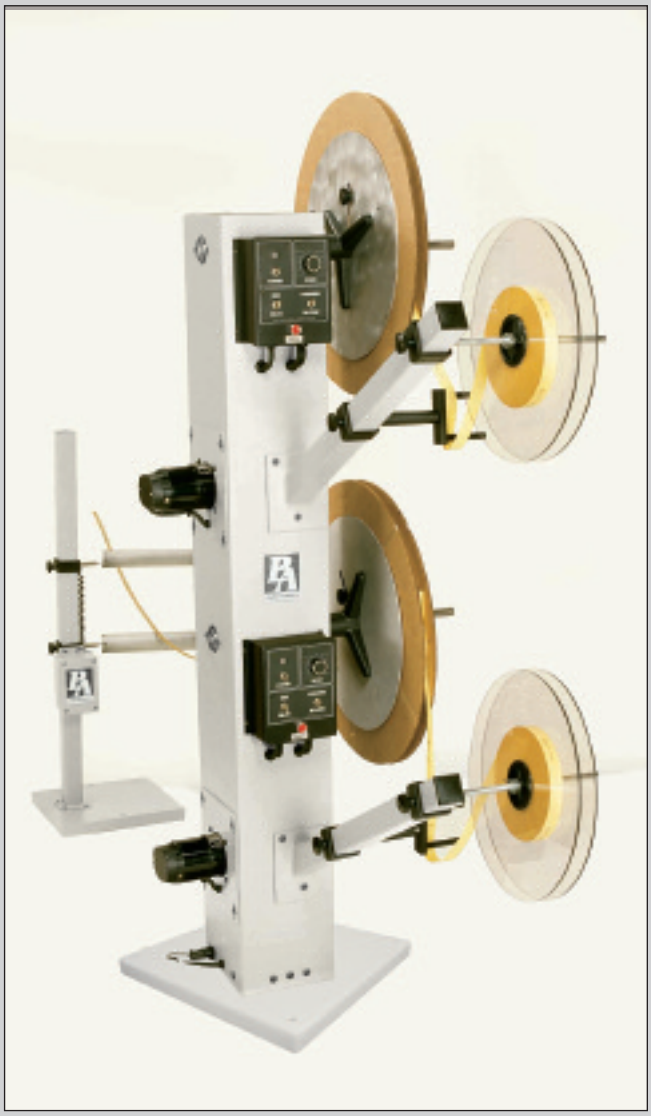


Payoff Drag Brake Assembly



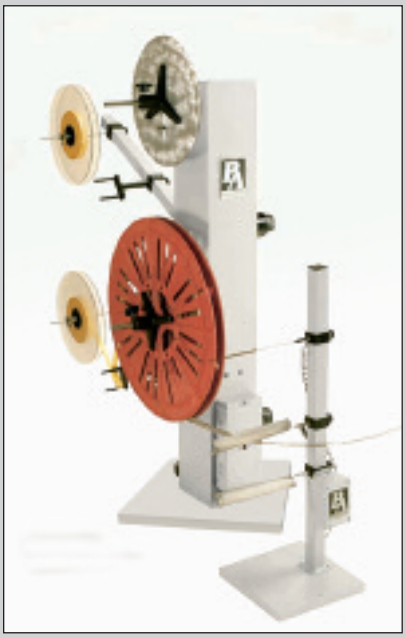
REWIND REELS

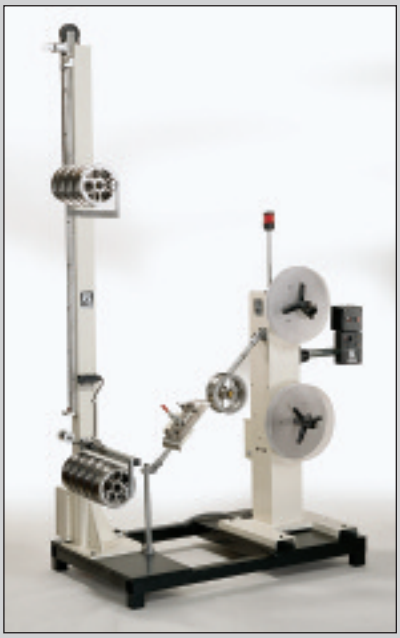


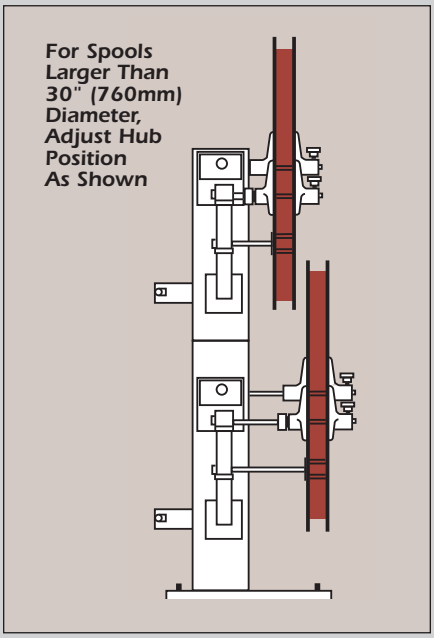


Custom designs are our specialty

- Designed for the electronics industry to handle delicate, prefinished or stamped materials without damaging the strip to be rewound
- Low voltage (less than 12 volts) antennas sense material position and signal the DC Drive to maintain a predetermined loop
- Solid state controller allows the operator to set the speed and spool rotation
- Drive plate is slotted to accommodate different size spool drive pins and a quick release outer hub supports the spool
- Pivoted tension/tuning fork and spring loaded paper interleaf holder provides the right amount of drag tension to ensure correct paper material wrap
- Compact modular construction reduces floor space and accommodates a variety of different configurations to suit your particular production needs
- Longer drive mandrels will accept multiple spools or provide offset staggered stock paths to keep material separated
- Options include spool spreaders to maintain cardboard spool openings, and emergency stock detectors to shut down the press in case of taut loop conditions
- Magnetic Brakes available for tension control of paper
- Dual unit is equipped with a Loop Control to handle single strip rewind operations with an empty spool always ready for material when the first spool fills up
- Two-Out Die applications are accommodated by dual control models with two LC-2 Loop Controls. Two spools are rewound simultaneously and individually controlled
- Proportional speed LC-3 Loop Control, UltraSonic Sonar Sensing System, and RF System can be supplied for other Loop System applications

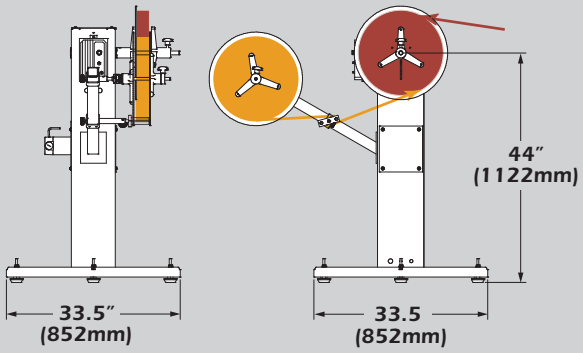




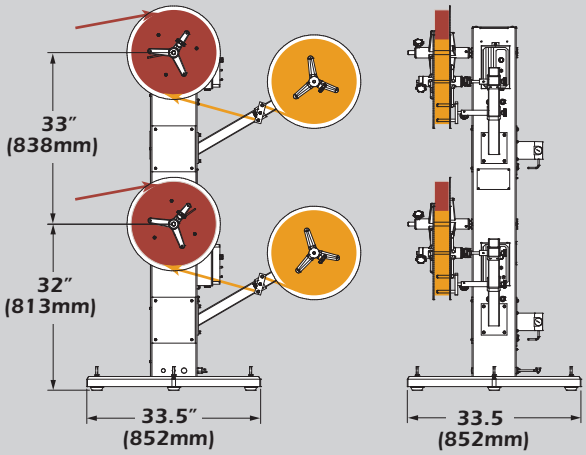


DIMENSIONS

Model SRWD1



Model SRWD2



SPECIFICATIONS – USA

Model	Max. Spool Weight (Lbs.)	Max. Strip Width (In.)	Shaft Dia. (In.)	Max. Spool OD (In.)	Speed Range (RPM)	DC Drive Motor (HP)	Input Power VAC/Ph/Hz	Number of Motors	Number of Controls	Spool Shafts	Stock Sensors
SRWD								1	1	1	1
SRWD2	75	3	.75	30	0 – 50	1/8	120 / 1 / 60	2	1	2	1
SRWD2/2LC								2	2	2	2

SPECIFICATIONS – METRIC

Model	Max. Spool Weight (Kg)	Max. Strip Width (mm)	Shaft Dia. (mm)	Max. Spool OD (mm)	Speed Range (RPM)	DC Drive Motor (kW)	Input Power VAC/Ph/Hz	Number of Motors	Number of Controls	Spool Shafts	Stock Sensors
SRWD							Specify	1	1	1	1
SRWD2	34	75	19	760	0 – 50	0,1	When	2	1	2	1
SRWD2/2LC							Ordering	2	2	2	2

Consult factory for higher speeds.

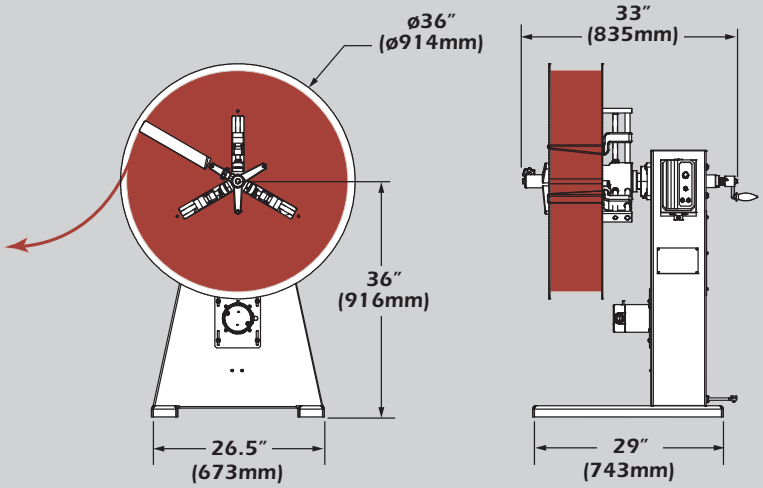
Custom Configurations available.

LIGHT DUTY STOCK REELS 200-600 Lbs. Fixed or Adjustable

- Recommended for a variety of applications that require a free loop of material at all times
- Efficient DC Drive package ensures that the reel will automatically compensate, without operator adjustments
- Two keeper discs prevent damage to the edges of the stock during rotation and eliminate side slippage tendencies of narrow coils
- Optional sensors are available.
- Non-motorized models are provided with caliper disc brakes.

DIMENSIONS

Models
SRA200D
SRA400D
SRA600D



SPECIFICATIONS – *USA*

Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	ID Range (In.)	Keeper Disc OD (In.)	Speed Range (RPM)	DC Drive Motor (HP)	Input Power VAC/Phase/Hz
Adjustable Shaft							
SRA200D	200		6 – 17				
SRA400D	400	10	6 – 17	24, 36, 42, 48	0 – 28	1/8	
SRA600D	600		8 – 18				120 / 1 / 60
Fixed Shaft							
SR200D	200		1				
SR400D	400	10	1.44	24, 36, 42, 48	0 – 28	1/8	
SR600D	600		1.94				

SPECIFICATIONS – *METRIC*

Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	ID Range (mm)	Keeper Disc OD (mm)	Speed Range (RPM)	DC Drive Motor (kW)	Input Power VAC/Phase/Hz
Adjustable Shaft							
SRA200D	90		150 – 430				
SRA400D	180	250	150 – 430	600, 915, 1070, 1220	0 – 28	0,1	
SRA600D	270		200 – 460				120 / 1 / 60
Fixed Shaft							
SR200D	90		25				
SR400D	180	250	37	600, 915, 1070, 1220	0 – 28	0,1	
SR600D	270		49				

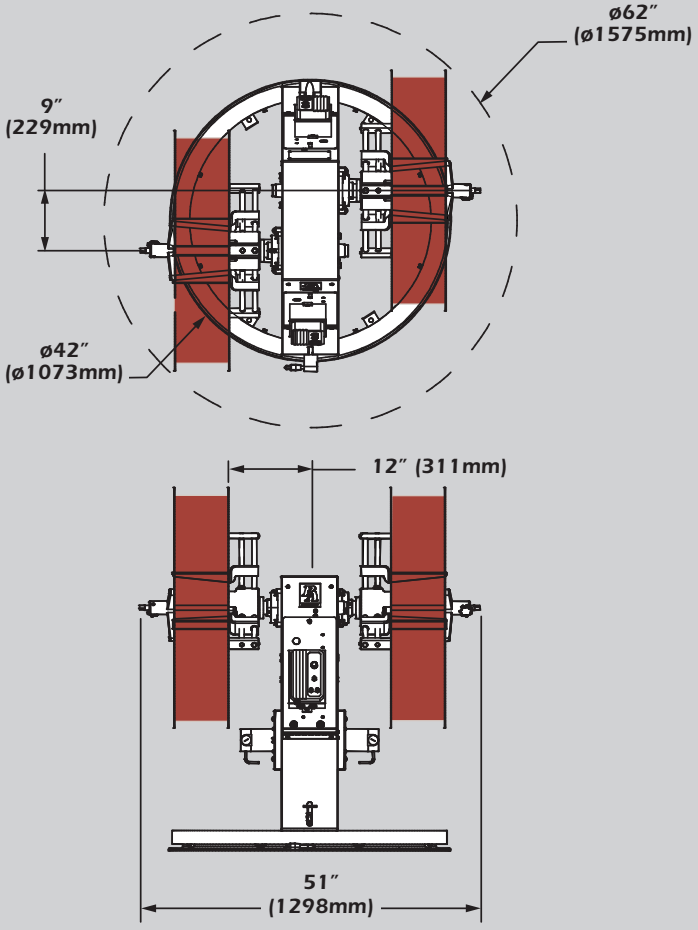
Consult factory for higher speeds and heavy duty drive applications.

LIGHT DUTY DUAL STOCK REELS 200-600 Lbs.

- Save production time by loading the next coil while the other side is paying off to the press increasing productivity
- Unique carousel design of the base reduces floor space by as much as 25%
- Position accuracy is guaranteed by a spring loaded locking pin
- Release of the locking pin is easy. Simply depress the foot pedal located on the cabinet base
- Twin DC Drive and solid state controls are enclosed inside the cabinet
- Optional sensors are available
- Non-motorized models are provided with caliper disc brakes

DIMENSIONS

Models
DSRA200D
DSRA400D
DSRA600D



SPECIFICATIONS – USA

Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	ID Range (In.)	Keeper Disc OD (In.)	Speed Range (RPM)	DC Drive Motor (HP)	Input Power VAC/Phase/Hz
Adjustable Shaft							
DSRA200D	200		6 – 17				
DSRA400D	400	10	6 – 17	24, 36, 42, 48	0 – 28	1/8	
DSRA600D	600		8 – 18				120 / 1 / 60
Fixed Shaft							
DSR200D	200		1				
SDR400D	400	10	1.44	24, 36, 42, 48	0 – 28	1/8	
DSR600D	600		1.94				

SPECIFICATIONS – METRIC

Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	ID Range (mm)	Keeper Disc OD (mm)	Speed Range (RPM)	DC Drive Motor (kW)	Input Power VAC/Phase/Hz
Adjustable Shaft							
DSRA200D	90		150 – 430				
DSRA400D	180	250	150 – 430	600, 915, 1070, 1220	0 – 28	0,1	
DSRA600D	270		200 – 460				120 / 1 / 60
Fixed Shaft							
DSR200D	90		25				
DSR400D	180	250	37	600, 915, 1070, 1220	0 – 28	0,1	
DSR600D	270		49				

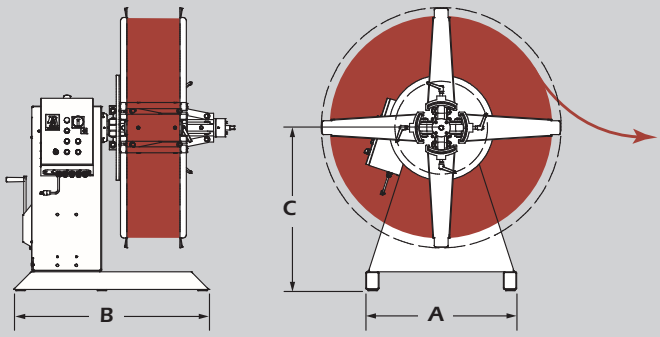
Consult factory for higher speeds and heavy duty drive applications.

MEDIUM DUTY STOCK REELS 1600-6500 Lbs.

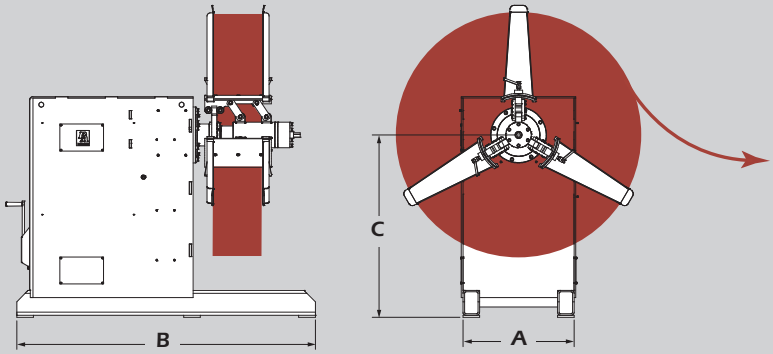
- Designed to handle loads from 1600–6500 lbs.
- Non-motorized reel is used with machines equipped with powered rolls that have sufficient power to unwind the necessary material
- Standard friction brake is adjustable to prevent material overrun when peripheral equipment is slowed or stopped
- Fully adjustable pneumatic safety brake
- Motorized versions smoothly deliver material to automatic feeding equipment
- Automatic centering of coil I.D.
- Reinforced steel coil keepers are individually adjustable
- Spindle is heat-treated alloy steel, precision ground and mounted in oversized tapered roller bearings

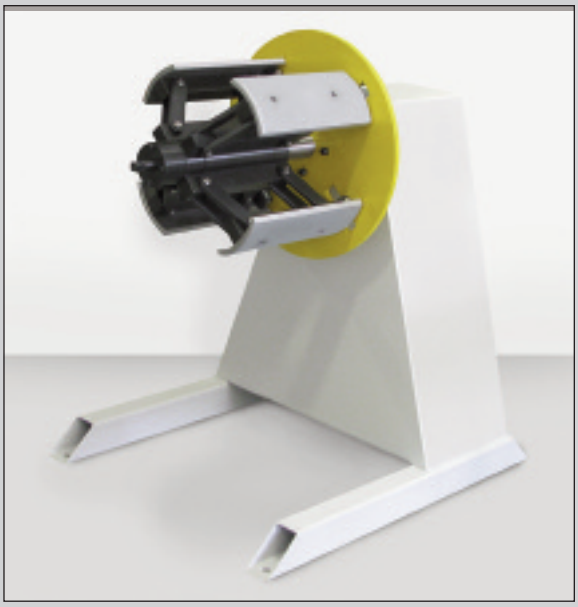
DIMENSIONS

Models SRA1612, 2516, 4524



Model SRA6512, 6524, 6536





DIMENSIONS – inches

Model	A	B	C
SRA1612	34	44	37
SRA2516	38	48	36
SRA4524	60	38	37
SRA6512	27	72	43.9
SRA6524	27.5	74	43.9
SRA6536	27.5	90	43.9

DIMENSIONS – mm

Model	A	B	C
SRA1612	864	1118	930
SRA2516	965	1213	910
SRA4524	1518	965	940
SRA6512	681	1829	1115
SRA6524	700	1878	1115
SRA6536	700	2278	1115

SPECIFICATIONS – USA

Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	ID Range (In.)	Max. OD Range (In.)	Speed Range (RPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
SRA1612D	1600	12	12.0 – 20.5	51 – 60	4 – 23	¾	120 / 1 / 60
SRA2516D	2500	16	15.7 – 20.5	55 – 60	3 – 15	¾	120 / 1 / 60
SRA4524D	4500	24	15.7 – 20.5	55 – 60	3 – 15	1	230 / 1 / 60
SRA6512D	6500	12	15.7 – 20.5	55 – 60	3 – 15	2	230 / 3 / 60
SRA6524D	6500	24	15.7 – 20.5	55 – 60	3 – 15	2	230 / 3 / 60
SRA6536D	6500	36	15.7 – 20.5	55 – 60	3 – 15	2	230 / 3 / 60

SPECIFICATIONS – METRIC

Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	ID Range (mm)	Max. OD Range (mm)	Speed Range (RPM)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
SRA1612D	727	305	300 – 520	1300 – 1500	4 – 23	0,56	
SRA2516D	1135	400	400 – 520	1400 – 1500	3 – 15	0,56	Specify
SRA4524D	2045	610	400 – 520	1400 – 1500	3 – 15	0,75	When
SRA6512D	3000	305	400 – 520	1400 – 1500	3 – 15	1,50	Ordering
SRA6524D	3000	610	400 – 520	1400 – 1500	3 – 15	1,50	
SRA6536D	3000	915	400 – 520	1400 – 1500	3 – 15	1,50	

Consult factory for higher speeds.
18"–21" (460mm–535mm) ID expansion range available.
Additional 4" (100mm) range of expansion obtainable with optional wedges.

All models available non-motorized with adjustable drag brake Longer keeper arms available for 60" to 72" (1525mm to 1825mm) OD.

MEDIUM DUTY DUAL STOCK REELS 1600-6500 Lbs.

- Same rugged construction as that of the Single Reels
- Motorized versions have two proportional speed AC motors
- Each drive motor uses a gear reducer with torque limiter for additional gearbox protection
- Oversized hand crank expands the mandrel which automatically centers the coil
- Coil keepers are easily adjustable and locked by quick release hand levers
- Optional pneumatic hold down arms help control coil clockspring during band-cutting.

SPECIFICATIONS – *USA*

Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	ID Range (In.)	Max. OD Range (In.)	Speed Range (RPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
DSRA1612D	1600	12	12.0 – 20.5	51 – 60	4 – 23	3/4	120 / 1 / 60
DSRA2516D	2500	16	15.7 – 20.5	55 – 60	3 – 15	3/4	120 / 1 / 60
DSRA4524D	4500	24	15.7 – 20.5	55 – 60	3 – 15	1	230 / 1 / 60
DSRA6512D	6500	12	15.7 – 20.5	55 – 60	3 – 15	2	230 / 3 / 60
DSRA6524D	6500	24	15.7 – 20.5	55 – 60	3 – 15	2	230 / 3 / 60
DSRA6536D	6500	36	15.7 – 20.5	55 – 60	3 – 15	2	230 / 3 / 60

SPECIFICATIONS – METRIC

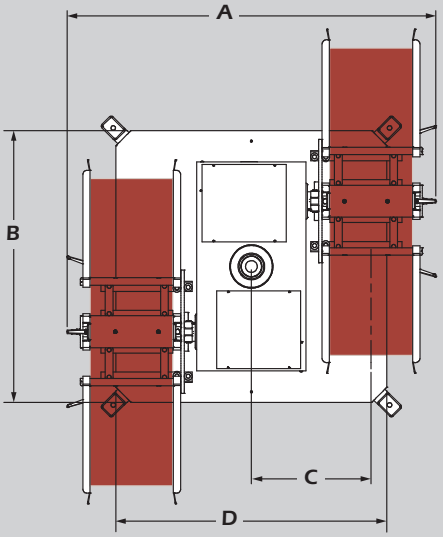
Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	ID Range (mm)	Max. OD Range (mm)	Speed Range (RPM)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
DSRA1612D	727	305	300 – 520	1300 – 1500	4 – 23	0,56	
DSRA2516D	1135	400	400 – 520	1400 – 1500	3 – 15	0,56	Specify
DSRA4524D	2045	610	400 – 520	1400 – 1500	3 – 15	0,75	When
DSRA6512D	3000	305	400 – 520	1400 – 1500	3 – 15	1,50	Ordering
DSRA6524D	3000	610	400 – 520	1400 – 1500	3 – 15	1,50	
DSRA6536D	3000	915	400 – 520	1400 – 1500	3 – 15	1,50	

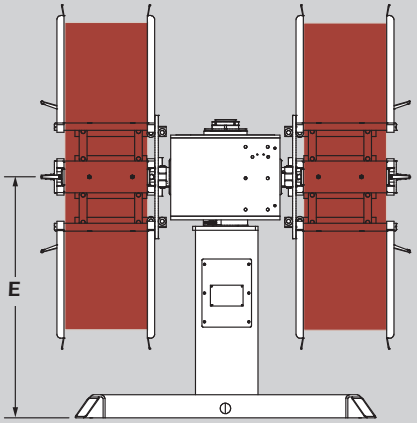
Consult factory for higher speeds.
18"–21" (460mm–535mm) ID expansion range available.
Additional 4" (100mm) range of expansion obtainable with optional wedges.

All models available non-motorized with adjustable drag brake. Longer keeper arms available for 60" to 72" (1525mm to 1825mm) OD.

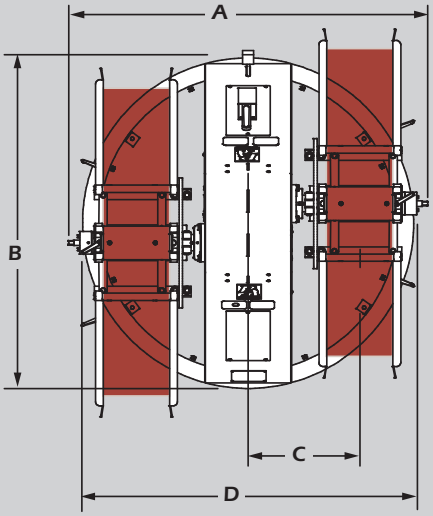
DIMENSIONS

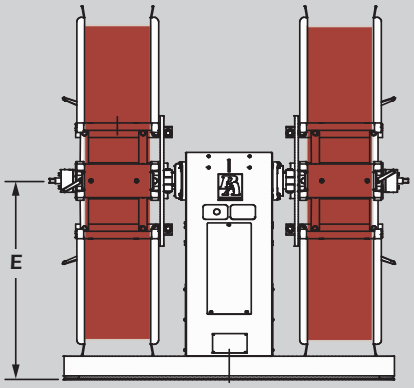
Model DSRA1612





Models DSRA 2516, 4524, 6512, 6524, 6536





DIMENSIONS – inches

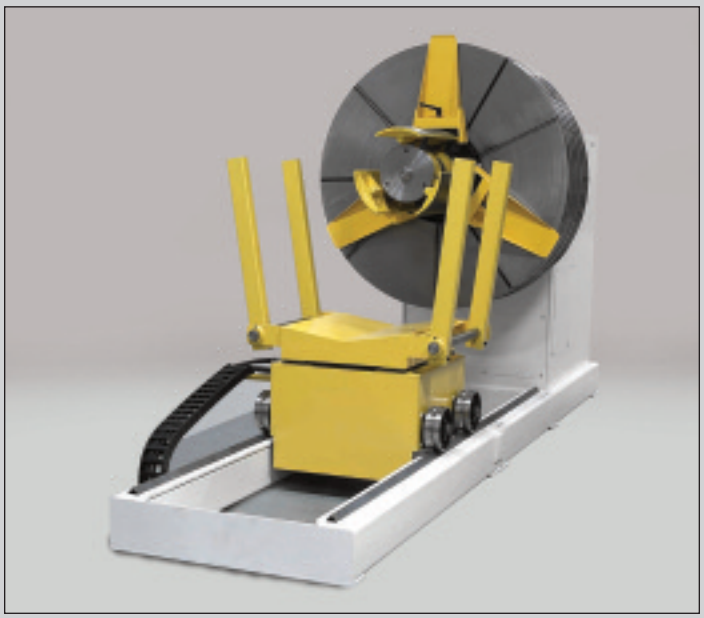
Model	A	B	C	D	E
DSRA1612	65.1	60	20.3	60	36
DSRA2516	71	52	23	52	46.1
DSRA4524	88.2	85.1	26.1	65.1	46
DSRA6512	75.7	74	23	74	46
DSRA6524	87	74	25	74	46
DSRA6536	118	74	35	98	46

DIMENSIONS – mm

Model	A	B	C	D	E
DSRA1612	1652	1524	515	1524	915
DSRA2516	1796	1321	583	1321	1171
DSRA4524	2241	1652	663	1652	1169
DSRA6512	1922	1880	581	1880	1177
DSRA6524	2206	1880	642	1880	1174
DSRA6536	3007	1880	886	2489	1174

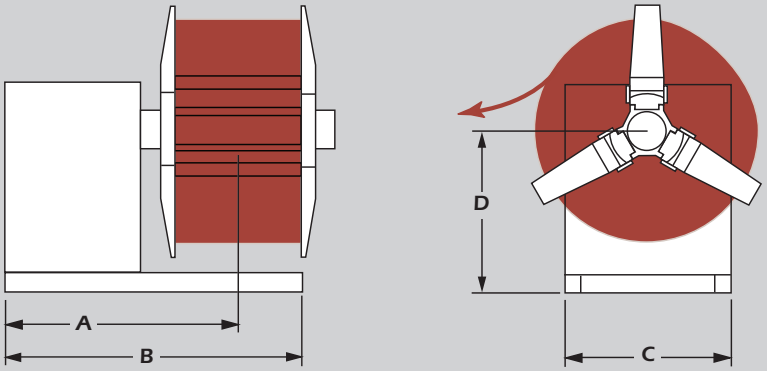
HEAVY DUTY STOCK REELS 10,000-20,000 Lbs.

- Mandrel assembly is made up of three cast, precision-machined jaws joined to the main shaft
- Steel shaft is supported by oversized, tapered roller bearings mounted in a rugged housing
- Coils are centered by hydraulic expansion of the jaws
- Motorized Reels use a variable speed drive
- Non-motorized models are equipped with an adjustable pneumatic safety brake
- Optional pneumatic pressure arm prevents material clockspring during band-cutting
- Coil cars are available



Single or Dual Mandrel Models

DIMENSIONS



SPECIFICATIONS – USA

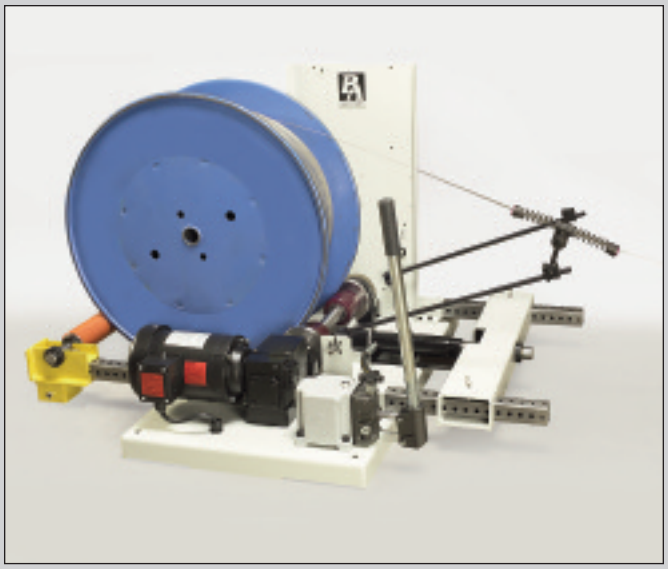
Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	ID Range* (In.)	Max. Coil OD (In.)	Dimensions (Inches) A	B	C	D
SRH10K-24	10,000	24	17 – 21	60	66	75	35	51
SRH10K-36		36			72	75	35	51
SRH10K-48		48			78	75	35	51
SRH12K-40	12,000	40	18.1 – 21	60	72	92	41	39.4
SRH12K-51		51			83	108	41	39.4
SRH13K-32	13,200	31.5	18.1 – 21	60	68	84	41	39.4
SRH15K-51	15,400	51			84	105	35	39.4
SRH18K-35	18,000	35	18.1 – 21	60	75	93	35	39.4
SRH18K-42		42			79	101	35	39.4

SPECIFICATIONS – METRIC

Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	ID Range* (mm)	Max. Coil OD (mm)	Dimensions (mm) A	B	C	D
SRH10K-24	4535	610	430 – 530	1525	1675	1905	890	1295
SRH10K-36		915			1830	1905	890	1295
SRH10K-48		1220			1980	1905	890	1295
SRH12K-40	5480	1000	460 – 530	1525	1830	2335	1040	1000
SRH12K-51		1300			2100	2750	1040	1000
SRH13K-32	5980	800	460 – 530	1525	1727	2130	1040	1000
SRH15K-51	6946	1298			2127	2677	890	1000
SRH18K-35	7973	890	460 – 530	1525	1917	2367	890	1000
SRH18K-42		1080			2017	2567	890	1000

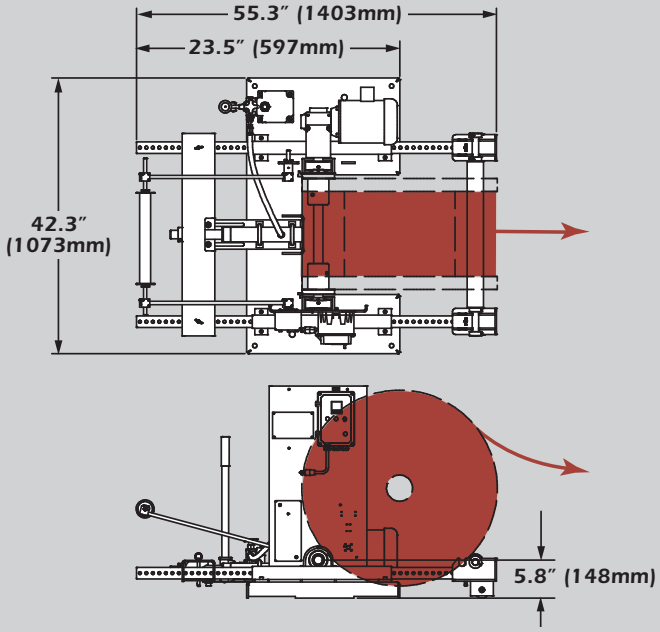
*22" to 25" (560mm to 650mm) available with additional wedges. Consult Factory for larger sizes. Optional 72" (1825mm) OD available.

TRAVERSE SPOOL REELS 3000 Lbs.



- Designed to handle payoff of oscillated wound materials delivered on spools
- TSR models are adjustable for a variety of spool sizes and use an efficient AC Drive to vary the spool rim speed to match press feed requirements
- Lightweight dancer arm automatically adjusts spool rim speed depending upon the loop position
- Controls include rotation selector switches along with an adjustable counterbalance for the loop-sensing arm
- TSR-LC uses a loop control to start and stop the drive motor. This system utilizes probe contact of conductive materials without scratching or marring the surface finish
- LC-2 uses a manually adjustable, speed control knob to allow the operator to set the payoff speed
- Optional LC-3 is a proportional sensor that automatically changes the rim speed
- Easy lift loading w/hydraulic lift to raise coils into place

DIMENSIONS



SPECIFICATIONS – *USA*

Model	Max. Spool Weight (Lbs.)	Spool Width Range (In.)	Spool Rim OD Range (In.)	Max. Rim Speed Range (IPM)	Max. Drive Roll (RPM)	Drive Motor (HP)	Input Power VAC/Phase/Hz
TSR-D TSR-LC TSR-LC3	3000	6 – 17	16 – 40	0 – 1760	173	3/4 AC	120 / 1 / 60
LW/TSR	200	4 – 12	8 – 20	0 – 1350	345	1/3 DC	120 / 1 / 60

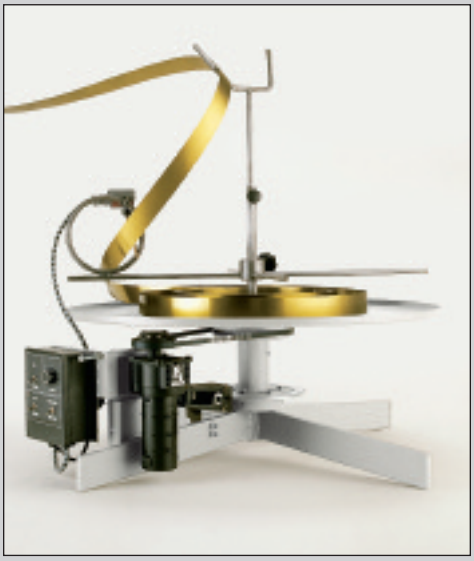
SPECIFICATIONS – *METRIC*

Model	Max. Spool Weight (Kg)	Spool Width Range (mm)	Spool Rim OD Range (mm)	Max. Rim Speed Range (M/Min.)	Max. Drive Roll (RPM)	Drive Motor (kW)	Input Power VAC/Phase/Hz
TSR-D TSR-LC TSR-LC3	1360	150 – 430	406 – 1000	0 – 44,5	173	0,60 AC	Specify When Ordering
LW/TSR	80	101 – 305	200 – 500	0 – 35	345	0,24 DC	

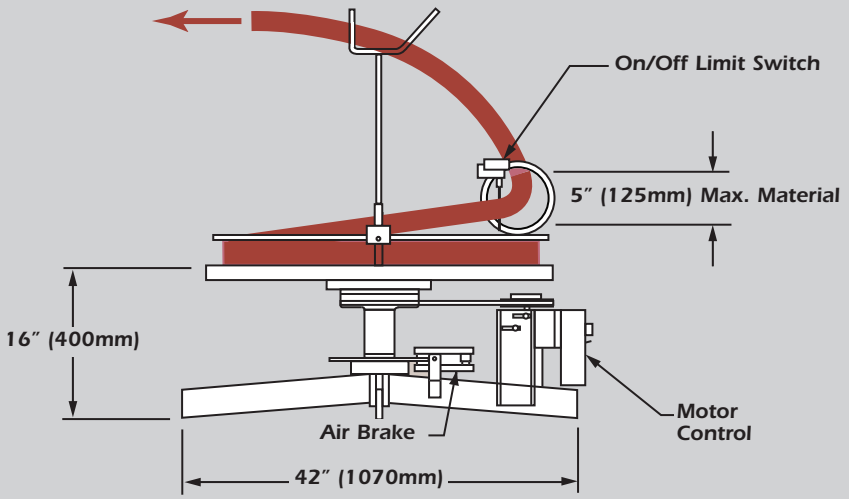
24" (665mm) or 36" (915mm) width models with larger diameter spools are available. Consult factory for special applications and low profile model.

HORIZONTAL REELS 800-1200 Lbs.

- An efficient and safe way to handle horizontal pay-off problems
- Reel is designed with a combination of a Timken tapered roller bearing and radial ball bearing housed in a rugged, cast iron hub
- Dual bearing design permits easy and safe coil loading
- These inexpensive reels use the natural tendency of material to unwind, causing the pan to rotate automatically. The circular stock guide and the rim of the pan retard this motion preventing slippage and over-travel
- Center hold-down assembly has stiff arms to retain the coil and is adjusted by a hand knob
- Material can be fed from either direction and taken from the inside or outside of the coil
- DC Drive package, equipped with dial-in speed adjustment, is controlled by a limit switch
- A caliper air disc brake is activated when the motor is off to control the material overtravel caused by rotational inertia
- Touch Probe Loop Controls are available.



DIMENSIONS



SPECIFICATIONS – *USA*

Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	Max. Coil Dia. (In.)	Speed Range (RPM)	DC Drive Motor (HP)	Input Power VAC/Phase/Hz
HR36	800		36			
HR42	1000	5	42	—	—	—
HR56	1200		56			
MHR36B	800		36			
MHR42B	1000	5	42	0 – 26	1/8	120 / 1 / 60
MHR56B	1200		56			

SPECIFICATIONS – *METRIC*

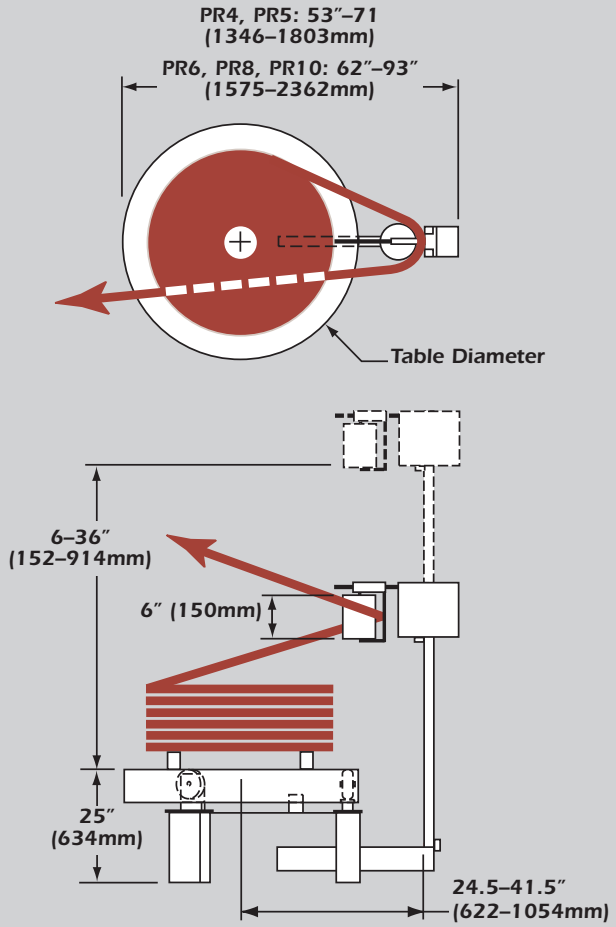
Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	Max. Coil Dia. (mm)	Speed Range (RPM)	DC Drive Motor (kW)	Input Power VAC/Phase/Hz
HR36	360		915			
HR42	450	125	1070	—	—	—
HR56	540		1425			
MHR36B	360		915			Specify
MHR42B	450	125	1070	0 – 26	0,09	When
MHR56B	540		1425			Ordering

Optional 1/4" (6.4mm) ribbed steel plate increases weight capacity to 1600 pounds (725 Kg).

PALLETIZER 4,000-10,000 Lbs.

- Designed to pay off pre-stacked coils of material
- Reduces the risk of injury to operators and damage to material by eliminating the handling of individual coils
- Set-up is straightforward. Simply load the pallet of coils onto the turntable with a forklift and set the guide for coil height
- Choose clockwise or counterclockwise rotation and feed the material into the press
- A variety of materials can be processed using our special guide roller-tensioning system
- AC Drive and proportional speed control combine to provide smooth and accurate material payout
- Unique rotary drive system allows the turntable to start instantly and to slow proportionately

DIMENSIONS



SPECIFICATIONS – USA

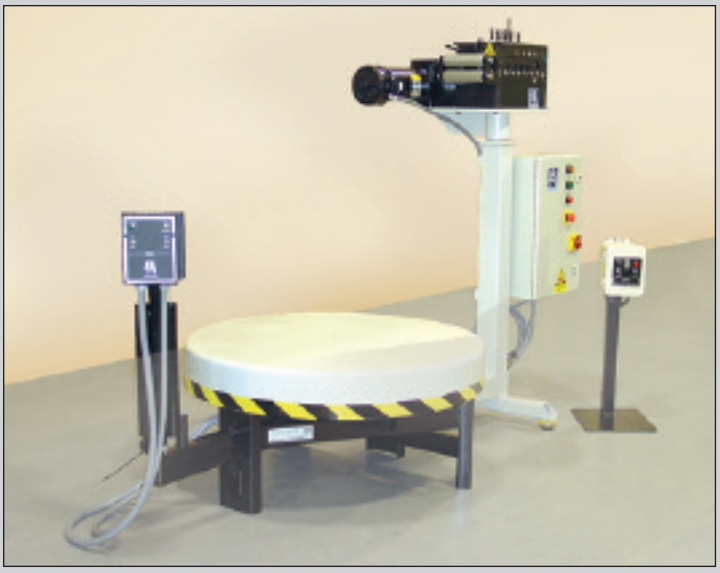
Model	Max. Pallet Weight (Lbs.)	Max. Stock Width (In.)	Stock Thickness Range (In.)	Max. Table Stacking Height (In.)	Table Speed Range (RPM)	Table Dia. (In.)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
PR4	4000				3 – 24	42	3/4	110 / 1 / 60
PR5	5500				3 – 24	42	1	220 / 1 / 60
PR6	6000	6	.004 – .065	36	3 – 11	52	1.5	220 / 1 / 60
PR8	8000				3 – 11	52	2	220 / 1 / 60
PR10	10,000				3 – 11	52	3	220 / 1 / 60

SPECIFICATIONS – METRIC

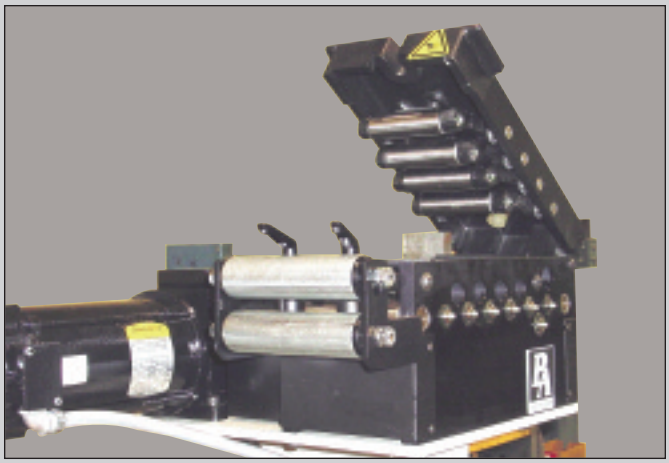
Model	Max. Pallet Weight (Kg)	Max. Stock Width (mm)	Stock Thickness Range (mm)	Max. Table Stacking Height (mm)	Table Speed Range (RPM)	Table Dia. (mm)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
PR4	1800				3 – 24	1067	0,56	
PR5	2500				3 – 24	1067	0,75	Specify
PR6	2700	150	0,1 – 1,8	915	3 – 11	1321	1,12	When
PR8	3600				3 – 11	1321	1,50	Ordering
PR10	4500				3 – 11	1321	2,24	

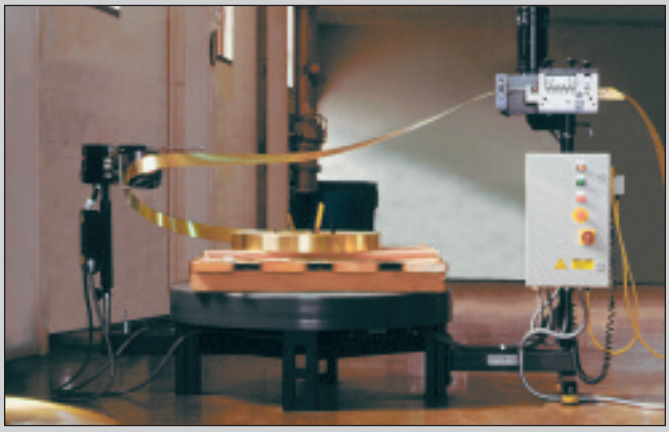
*Expanded speed range available.

PALLET REEL STRAIGHTENER



- Incorporates all the features of the Palletizer models with the efficiency of the Straightening Head





SPECIFICATIONS – USA

Model	Max. Pallet Weight (Lbs.)	Max. Stock Width (In.)	Stock Thickness Range (In.)	Max. Table Stacking Height (In.)	Table Speed Range (RPM)	Table Dia. (In.)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
PR4/SS49	4000	4	.015 – .065	36	3 - 24	42	3/4	220 / 1 / 60
PR4/SS89		6	.018 – .065					
PR4/SSP29		2	.005 – .040					
PR4/SSP49		4	.005 – .040					
PR4/SSP69		6	.005 – .030					
PR6/SS49	6000	4	.015 – .065	36	3 - 11	52	1.5	
PR6/SS89		8	.018 – .065					
PR6/SSP29		2	.005 – .040					
PR6/SSP49		4	.005 – .040					
PR6/SSP69		6	.003 – .030					

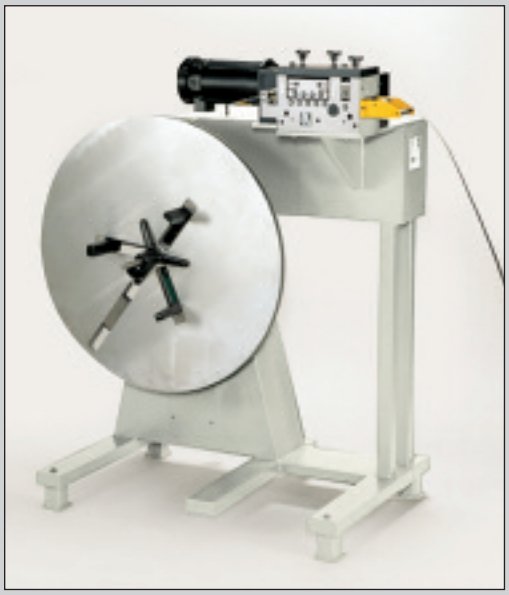
SPECIFICATIONS – METRIC

Model	Max. Pallet Weight (Kg)	Max. Stock Width (mm)	Stock Thickness Range (mm)	Max. Table Stacking Height (mm)	Table Speed Range (RPM)	Table Dia. (mm)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
PR4/SS49	1800	100	0,4 – 1,6	915	3 - 24	1070	0,56	Specify When Ordering
PR4/SS89		150	0,5 – 1,6					
PR4/SSP29		50	0,1 – 1,0					
PR4/SSP49		100	0,1 – 1,0					
PR4/SSP69		150	0,1 – 1,8					
PR6/SS49	2700	100	0,4 – 1,6	915	3 - 11	1325	1,12	
PR6/SS89		200	0,5 – 1,6					
PR6/SSP29		50	0,1 – 1,0					
PR6/SSP49		100	0,1 – 1,0					
PR6/SSP69		150	0,1 – 1,8					

Tension Guide Rollers up to 22" (560mm) are available.

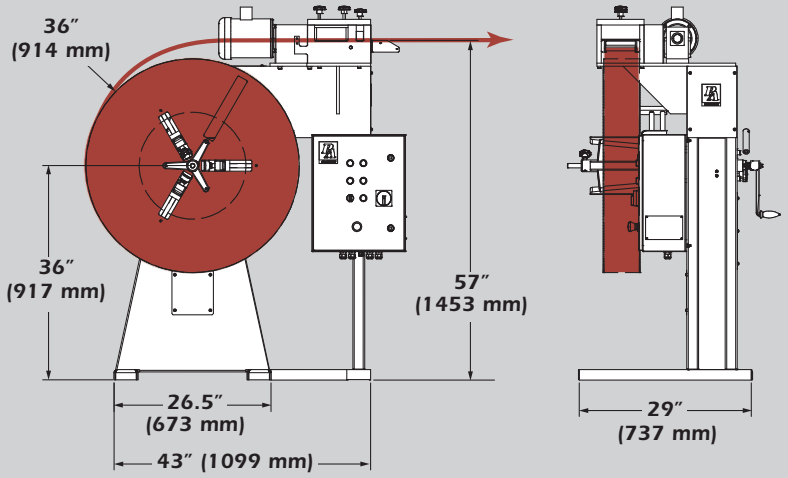
Coil weights up to 10,000 lbs. (4500Kg) are available.

PRECISION REEL STRAIGHTENERS 400-600 Lbs.



- Saves floor space and is also easy to load
- Nine different models are available with material widths up to 6 inch (150mm) and coil weights up to 600 lbs. (272 Kg)
- This unit should be of special interest to the electronic stamping industry for processing hard to straighten materials, such as beryllium copper, phosphorous bronze and brass
- Equipped with fully adjustable cast iron jaws with a generous expansion range
- An adjustable caliper disc brake provides the necessary tension to prevent material overrun. Two keeper discs are provided for proper material guiding
- Nine roll straightener utilizes exit pinch rolls for a total of eleven rolls
- The user friendly bank type adjustment
- Lower rolls are driven with a responsive DC drive and proportional loop control

DIMENSIONS



SPECIFICATIONS – USA

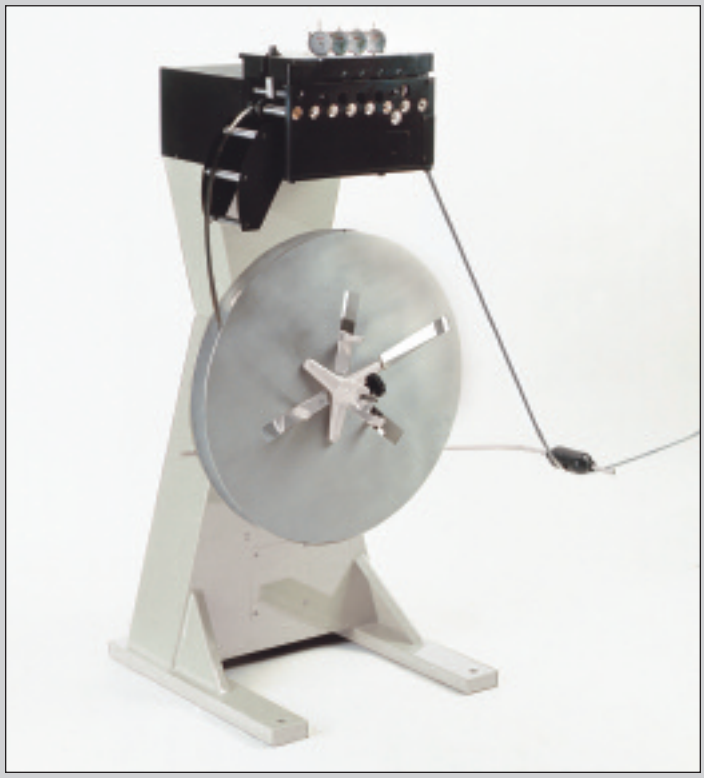
Model	Max. Stock Width (In.)	Max. Stock Thickness (In.)	Max. Coil Weight (Lb.)	Coil ID Range (In.)	Max. Coil OD (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
RS29P-4 RS29P-6	2	.040	400 600	6 – 17 8 – 18	24 / 30 / 36	0 – 1200	3/4	120 / 1 / 60
RS49P-4 RS49P-6	4	.040	400 600	6 – 17 8 – 18				
RS69P-4 RS69P-6	6	.030	400 600	6 – 17 8 – 18				

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Max. Stock Thickness (mm)	Max. Coil Weight (Kg)	Coil ID Range (mm)	Max. Coil OD (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
RS29P-4 RS29P-6	50	1.0	180 270	150 – 430 200 – 460	600 / 760 / 915	0 – 30	0,6	Specift When Ordering
RS49P-4 RS49P-6	100	1.0	180 270	150 – 430 200 – 460				
RS69P-4 RS69P-6	150	0.8	180 270	150 – 430 200 – 460				

Note: Other voltages available.

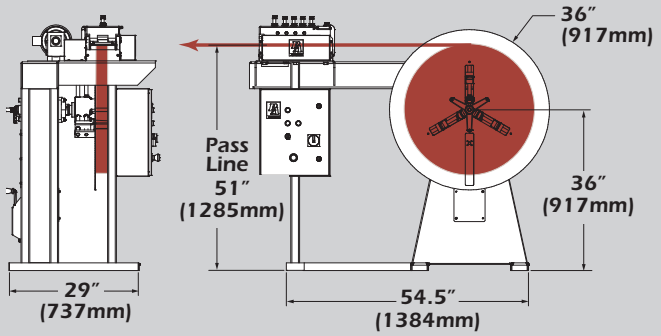
FLIP TOP REEL STRAIGHTENERS 400-2500 Lbs.



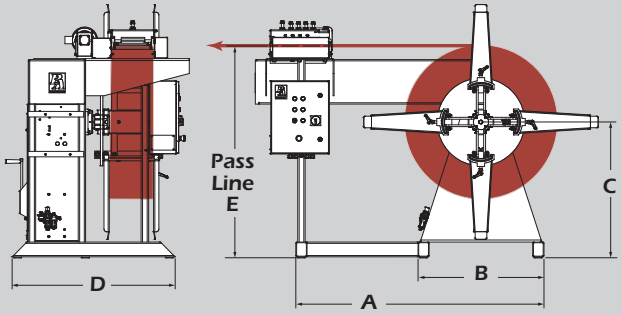
- A combination of the Flip Top Stock Straightener head and payoff reel
- Available in two configurations, these models will minimize the use of precious floor space
- Utilizes nine straightening rolls with two exit pinch rolls for optimum performance on a variety of applications
- AC drive provides sufficient torque for material payoff
- New and highly recommended is an optional Gas Operated Lift Spring for Flip Top Heads.

DIMENSIONS

Models RS49, RS89, RS129



Models RS89, RS129



DIMENSIONS – inches

Model	A	B	C	D	E
RS89-16	67	34	37	44	57
RS129-25	66	38	36	48	54
RS129-45	66	38	37	60	55

DIMENSIONS – mm

Model	A	B	C	D	E
RS89-16	1702	864	930	1118	1451
RS129-25	1683	965	914	1213	1380
RS129-45	1683	965	940	1518	1402

SPECIFICATIONS – USA

Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	Max. Stock Thickness (In.)	ID Range (In.)	Coil OD (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC / Phase
RS49-4 RS49-6	400 600	4	.080	6 – 17 8 – 18	24, 30, 36	0 – 800	1	120 / 1 / 60
RS89-6 RS89-16 RS89-25	600 1600 2500	8	.080	8 – 18 10 – 22 14.5 – 20.5	24, 30, 36 48 51 – 55	0 – 900		
RS129-16 RS129-25	1600 2500	12	.080	10 – 22 14.5 – 20.5	48 51 – 55	0 – 900		

SPECIFICATIONS – METRIC

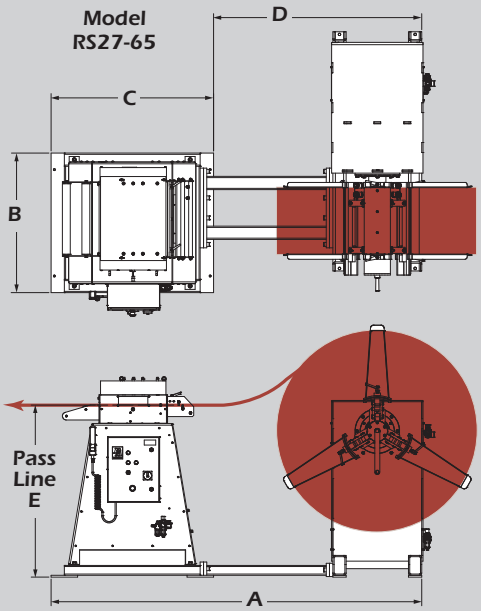
Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	Max. Stock Thickness (mm)	ID Range (mm)	Coil OD (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC / Phase
RS49-4 RS49-6	200 275	100	2,0	150 – 430 200 – 460	600, 760, 915	0 – 20	0,75	Specify When Ordering
RS89-6 RS89-16 RS89-25	270 725 1133	200	2,0	200 – 460 250 – 560 370 – 520	600, 760, 915 1220 1300 – 1400	0 – 23		
RS129-16 RS129-25	725 1133	300	2,0	250 – 560 370 – 520	1220 1300 – 1400	0 – 23		

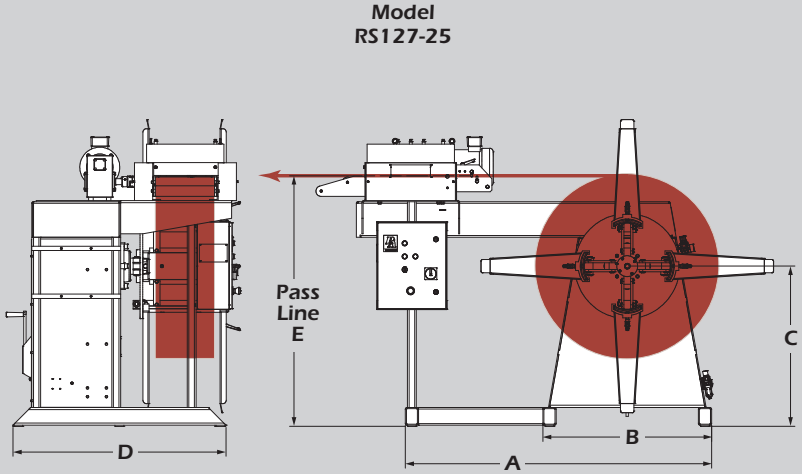
Consult factory for higher speeds.

SPACE SAVER REEL STRAIGHTENER 1600-6500 Lbs.

- Space Saver design for limited floor space
- Equipped with an adjustable safety brake
- AC drive Stock Straightener is offset for easy loading
- The loop-sensing arm automatically adjusts material payout speed to press requirements
- Equipped with entrance cascade and exit pinch rolls
- Specify left-to-right or right-to-left stock travel.

DIMENSIONS





DIMENSIONS – inches

Model	A	B	C	D	E
RS87-16	62	31	19	43	60
RS87-25	66	34	19	48	60
RS87-45	66	34	19	48	60
RS127-16	62	31	19	43	60
RS127-25	66	34	19	48	60
RS127-45	66	34	19	48	60
RS127-65	66	34	19	48	60
RS167-25	120	32	49	71	52
RS167-65	110	32	49	60.8	52
RS207-25	123	47.8	49	74	52
RS207-65	112	42	49	63	52
RS257-65	112	42	49	63	52

DIMENSIONS – mm

Model	A	B	C	D	E
RS87-16	1575	787	483	1092	1525
RS87-25	1676	864	483	1219	1525
RS87-45	1676	864	483	1219	1525
RS127-16	1575	787	483	1092	1525
RS127-25	1676	864	483	1219	1525
RS127-45	1676	864	483	1219	1525
RS127-65	1676	864	483	1219	1525
RS167-25	3048	813	1245	1803	1321
RS167-65	2789	813	1245	1545	1321
RS207-25	3124	1213	1245	1880	1314
RS207-65	2840	1067	1245	1595	1313
RS257-65	2840	1067	1245	1595	1313

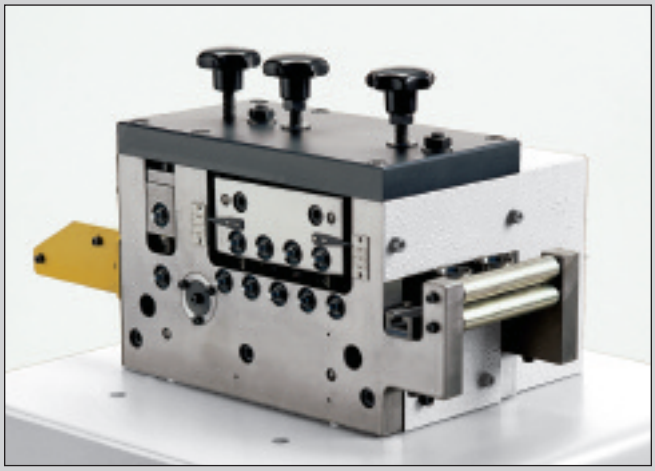
SPECIFICATIONS – USA

Model	Max. Coil Weight (Lbs.)	Max. Stock Width (In.)	Max. Stock Thickness (In.)	Coil ID Range (In.)	Max. Coil OD (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
RS87-16	1600	8	.135	12 – 20.5	51 - 60	0 – 900	3	230 / 3 / 60
RS87-25	2500			15.7 – 20.8	55 – 60			
RS87-45	4500			15.7 – 20.8	55 – 60			
RS127-16	1600	11.8	.125	12 – 20.5	51 – 60			
RS127-25	2500			15.7 – 20.8	55 – 60			
RS127-45	4500			15.7 – 20.8	55 – 60			
RS127-65	6500			15.5 – 20.5	55 – 60			
RS167-25	2500	15.7	.105	15.7 – 20.8	55 – 60			
RS167-65	6500			15.7 – 20.5	55 – 60			
RS207-25	2500	19.7	.095	15.7 – 20.8	55 – 60			
RS207-65	6500			15.7 – 20.5	55 – 60			
RS257-65	6500	25.5	.070	15.7 – 20.5	55 – 60			

SPECIFICATIONS – METRIC

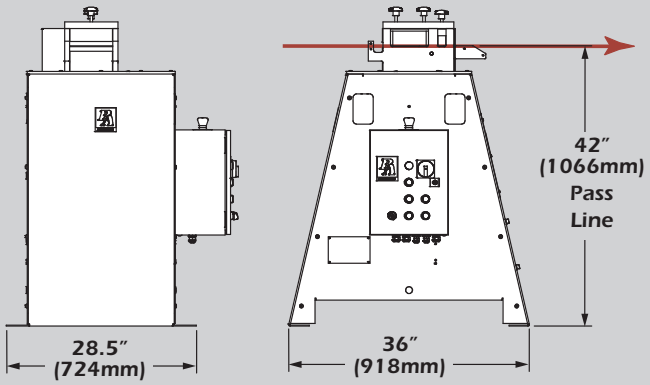
Model	Max. Coil Weight (Kg)	Max. Stock Width (mm)	Max. Stock Thickness (mm)	Coil ID Range (mm)	Max. Coil OD (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
RS87-16	727	200	3,4	300 – 520	1,30 - 1,52	0 – 23	2,24	230 / 3 / 60
RS87-25	1600			400 – 530	1,40 – 1,53			
RS87-45	2045			400 – 530	1,40 – 1,53			
RS127-16	727	300	3,2	300 – 520	1,30 – 1,52			
RS127-25	1600			400 – 530	1,40 – 1,53			
RS127-45	2045			400 – 530	1,40 – 1,53			
RS127-65	3000			400 – 520	1,40 – 1,52			
RS167-25	1600	400	2,7	400 – 530	1,40 – 1,53			
RS167-65	3000		1,8	400 – 520	1,40 – 1,52			
RS207-25	1600	500	2,4	400 – 530	1,40 – 1,53			
RS207-65	3000			400 – 520	1,40 – 1,52			
RS257-65	3000	650	2,7	400 – 520	1,40 – 1,50			

PRECISION STOCK STRAIGHTENERS



- Eleven roll straightener is very well suited for difficult to straighten material
- Recommended for applications in which the strip must be absolutely flat before stamping, such as with electrical switch elements and contacts
- Multiple hardened and ground, small diameter rolls on close centers straighten thin, resilient materials
- Special anti-friction, sealed bearings prevent foreign particle contamination
- Upper rolls are rigidly housed in a tiltable cradle
- Indicator and scale provide a "user friendly" adjustment
- Adjustable roller width guides and stock entry rollers guarantee smooth stock entry
- Exit pinch rolls, and all lower rolls, are power driven through a precision gear train
- Continuous free loop feeding is activated by the loop-sensing arm which controls the high torque, quick response DC Drive motor system

DIMENSIONS



SPECIFICATIONS – *USA*

Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Straightening Rolls Qty	Straightening Rolls Dia. (In.)	Pinch Rolls Qty	Pinch Rolls Dia. (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
SSP29	2	.005 – .040	9	1.00	2	1.6	0 – 1200	3/4	120 / 1 / 60
SSP49	4	.005 – .040							
SSP69	6	.005 – .030							
SSP89	8	.005 – .020							

SPECIFICATIONS – METRIC

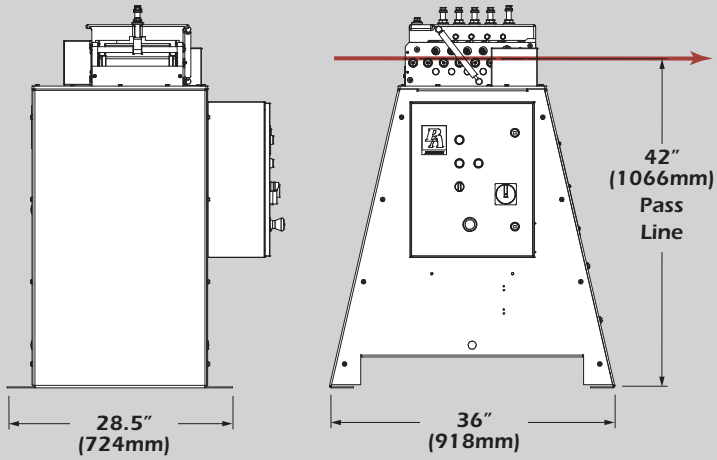
Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Straightening Rolls Qty	Straightening Rolls Dia. (mm)	Pinch Rolls Qty	Pinch Rolls Dia. (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
SSP29	50	0,1 – 1,0	9	25	2	40	0 – 30	0,6	Specify When Ordering
SSP49	100	0,1 – 1,0							
SSP69	150	0,1 – 0,8							
SSP89	200	0,1 – 0,5							

Consult factory for higher speeds.

FLIP TOP STRAIGHTENERS

- Makes strip loading easy. Simply swing open the head, feed in the strip, close and tighten
- Single-point adjustment for each roll ensures a precise setting and eliminates the cambering caused by nonparallel rolls
- Reloading is even easier because these straighteners maintain their roller adjustment – exactly.
- Allows easy cleaning of the rolls to prevent scratching of coated or polished strip
- All models are equipped with eleven hardened and ground rolls (nine straightening, two exit pinch rolls)
- All lower rolls and exit pinch rolls are driven by precision spur gears that are hardened for long life
- AC Drive system has full torque capability, even at a low speed, allowing the use of non-motorized payoff reels
- Optional gas operated lift spring for Flip Top Heads

DIMENSIONS



SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Straightening Rolls Qty	Straightening Rolls Dia. (In.)	Pinch Rolls Qty	Pinch Rolls Dia. (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
SS49	4	.015 – .080	9	1.50	2	1.5	0 – 900	3/4	120 / 1 / 60
SS89	8	.018 – .083							
SS129	12	.020 – .075							

SPECIFICATIONS – METRIC

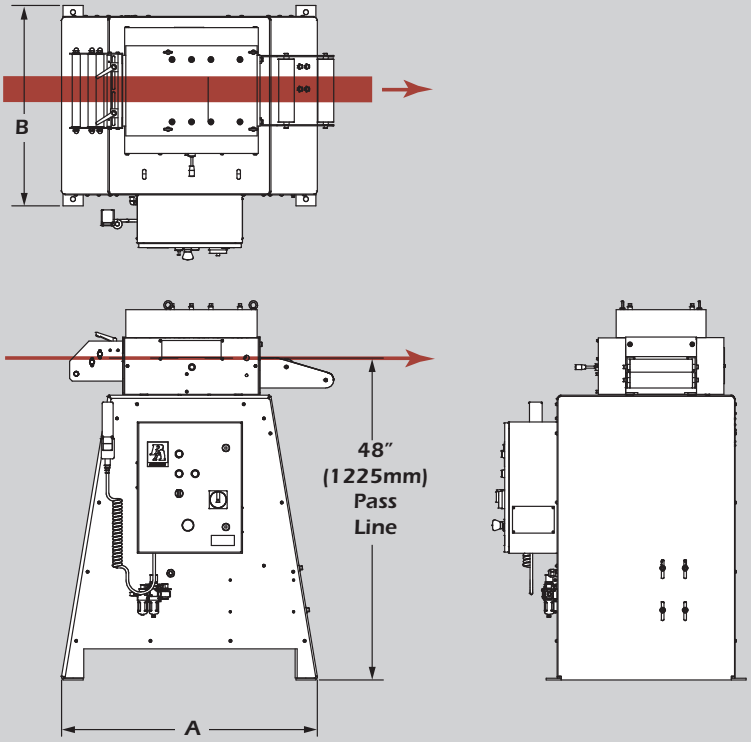
Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Straightening Rolls Qty	Straightening Rolls Dia. (mm)	Pinch Rolls Qty	Pinch Rolls Dia. (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
SS49	100	0,4 – 2	9	38	2	38	0 – 23	0,75	Specify When Ordering
SS89	200	0,5 – 2							
SS129	300	0,5 – 2							

Consult factory for higher speeds.

MEDIUM DUTY STRAIGHTENERS 7 Roll

- Used for medium stock thickness ranges
- Precise gear arrangement drives lower entrance/exit pinch rolls, as well as all lower straightening rolls
- Top rolls have individual depth adjustments with reference indicators on the side of the frame
- Straightening rolls may be adjusted from either side
- Roller chain connects the two roll adjustment screws to ensure absolute roll parallelism
- Pneumatic Pinch Rolls allow easy strip loading
- All rolls are alloy steel, case hardened to Rockwell C-60, and ground to a fine finish
- Anti-friction needle bearings are fitted in a rugged cast iron frame
- Entrance support rolls and adjustable width guide rolls with twist lock hand levers are standard features
- Exit rollers support straightened stock and prevent deformation
- Models with eleven straightening rolls are available for thinner or harder material, such as stainless steel
- Pneumatic inlet pinch roll release assists in material threading and adjustable cascade exit rolls allow for just the right stock curve support
- Various sensor options are available
- 15 Degree Incline Head is available to reduce floor space

DIMENSIONS



DIM. (in.)	A	B
SS87	38	30
SS127	38	30
SS167	38	30
SS207	38	40
SS257	38	40
SS327	38	46
SS407	38	54
SS1211	44	26
SS2011	44	40
SS2511	44	40
SS3211	45	46
SS4011	45	54

DIM. (mm)	A	B
SS87	975	762
SS127	975	762
SS167	975	762
SS207	975	1016
SS257	975	1016
SS327	975	1168
SS407	975	1372
SS1211	1124	660
SS2011	1124	1016
SS2511	1124	1016
SS3211	1132	1168
SS4011	1132	1372

SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Straightening Rolls Qty	Straightening Rolls Dia. (In.)	Pinch Rolls Qty	Pinch Rolls Dia. (In.)	Speed Range (IPM)	AC Drive Motor* (HP)	Input Power** VAC/Phase/Hz
SS87	8	.020 – .135							
SS127	12	.020 – .125							
SS167	15.8	.020 – .105							
SS207	19.7	.020 – .095	7						
SS257	25.6	.020 – .070							
SS327	31.6	.020 – .040							
SS407	39.4	.020 – .032		2.4	4	2.4	0 – 900	3 AC	230 / 3 / 6
SS1211	12	.016 – .118							
SS2011	19.7	.016 – .071							
SS2511	25.6	.016 – .063	11						
SS3211	31.6	.016 – .043							
SS4011	39.4	.016 – .035							

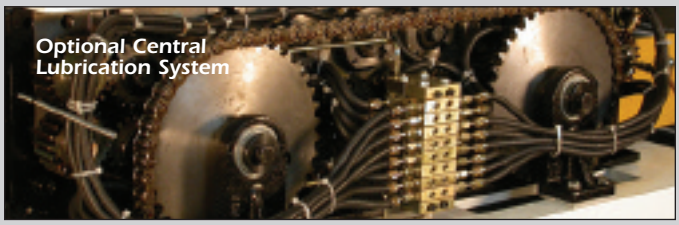
SPECIFICATIONS – METRIC

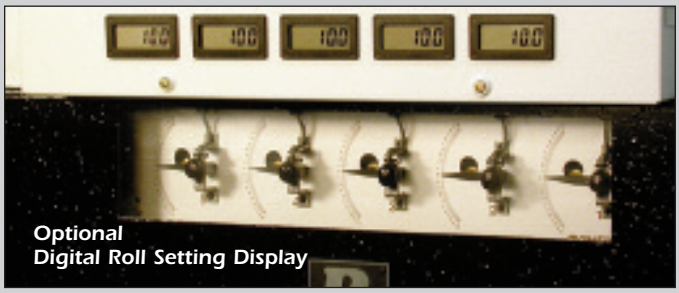
Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Straightening Rolls Qty	Straightening Rolls Dia. (mm)	Pinch Rolls Qty	Pinch Rolls Dia. (mm)	Speed Range (M/Min.)	AC Drive Motor* (kW)	Input Power** VAC/Phase/Hz
SS87	200	0,5 – 3,4							
SS127	300	0,5 – 3,2							
SS167	400	0,5 – 2,7							
SS207	500	0,5 – 2,4	7						
SS257	650	0,5 – 1,8							
SS327	800	0,5 – 1,0							
SS407	1000	0,5 – 0,8		60	4	60	0 – 23	2,25 AC	Specify When Ordering
SS1211	300	0,4 – 3,0							
SS2011	500	0,4 – 1,8							
SS2511	650	0,4 – 1,6	11						
SS3211	800	0,4 – 1,1							
SS4011	1000	0,4 – 0,9							

*Optional 5 HP Drive (3.75 kW) for increased capacity and/or speed.

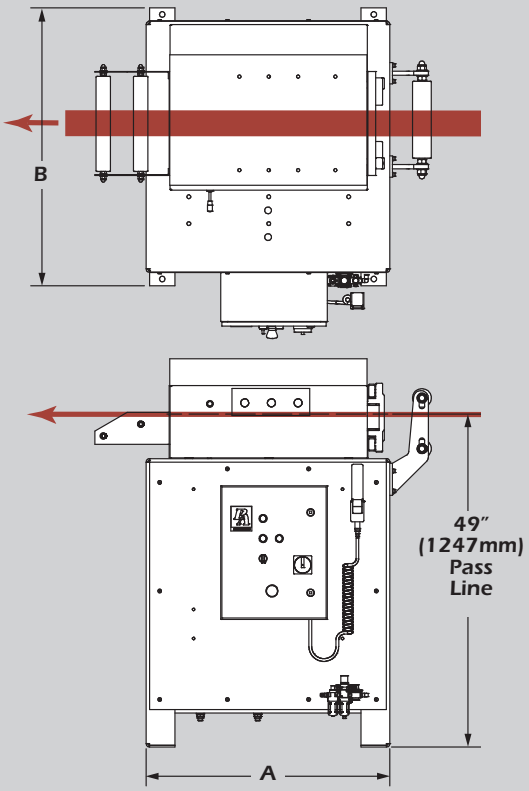
**Optional 460/3/60 Supply

HEAVY DUTY STRAIGHTENERS





DIMENSIONS



DIMENSIONS – inches

Model	A	B
SS87HD	36	41
SS127HD	36	41
SS407HD	36	57
SS507HD	36	69
SS1211HD	44	41
SS257HD	36	57

DIMENSIONS – mm

Model	A	B
SS87HD	914	1041
SS127HD	914	1041
SS407HD	914	1448
SS507HD	914	1753
SS1211HD	1127	1041
SS257HD	914	1448

SPECIFICATIONS – USA

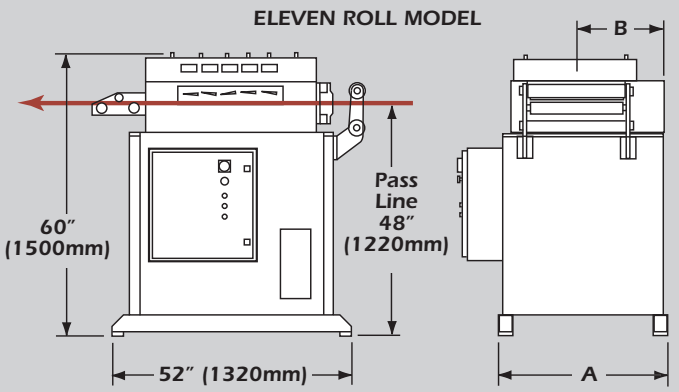
Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Straightening Rolls Qty	Straightening Rolls Dia. (In.)	Pinch Rolls Qty	Pinch Rolls Dia. (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
SS87HD	8	.030 – .200	7	3.15	4	3.15	0 – 900	5	230 / 3 / 60
SS127HD	12	.030 – .189							
SS167HD	16	.030 – .178							
SS207HD	20	.030 – .165							
SS257HD	25	.030 – .140							
SS327HD	32	.030 – .091							
SS407HD	40	.030 – .083							
SS507HD	50	.030 – .068							

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Straightening Rolls Qty	Straightening Rolls Dia. (mm)	Pinch Rolls Qty	Pinch Rolls Dia. (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
SS87HD	200	0,8 – 5,1	7	80	4	80	0 – 23	3,8	Specify When Ordering
SS127HD	300	0,8 – 4,8							
SS167HD	400	0,8 – 4,5							
SS207HD	500	0,8 – 4,2							
SS257HD	650	0,8 – 3,6							
SS327HD	800	0,8 – 2,3							
SS407HD	1015	0,8 – 2,1							
SS507HD	1270	0,8 – 1,7							

HEAVY DUTY STRAIGHTENERS with Larger Drive System

DIMENSIONS



DIMENSIONS – inches

Model	A	B
SS87HDX	35	11
SS127HDX	35	13
SS167HDX	35	15
SS207HDX	35	17
SS257HDX	41	20
SS327HDX	45	23
SS407HDX	65	32
SS507HDX	77	35
SS1211HDX	35	15
SS2011HDX	35	17
SS2511HDX	41	20
SS3211HDX	45	23
SS4011HDX	65	32
SS5011HDX	77	35

DIMENSIONS – mm

Model	A	B
SS87HDX	940	320
SS127HDX	940	370
SS167HDX	940	420
SS207HDX	940	470
SS257HDX	1041	545
SS337HDX	1143	620
SS407HDX	1346	720
SS507HDX	1651	869
SS1211HDX	940	420
SS2011HDX	940	470
SS2511HDX	1041	545
SS3311HDX	1143	620
SS4011HDX	1346	720
SS5011HDX	1651	869

SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Straightening Rolls Qty	Straightening Rolls Dia. (In.)	Pinch Rolls Qty	Pinch Rolls Dia. (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
SS87HDX	8	.030 – .256	7	3.15	4	3.15	0 – 900	7.5	230 / 3 / 60
SS127HDX	12	.030 – .236							
SS167HDX	16	.030 – .215							
SS207HDX	20	.030 – .205							
SS257HDX	25	.030 – .175							
SS327HDX	32	.030 – .125							
SS407HDX	40	.030 – .115							
SS507HDX	50	.030 – .090							
SS1211HDX	12	.023 – .189	11						
SS2011HDX	20	.023 – .165							
SS2511HDX	25	.023 – .140							
SS3211HDX	32	.023 – .090							
SS4011HDX	40	.023 – .083							
SS5011HDX	50	.023 – .068							

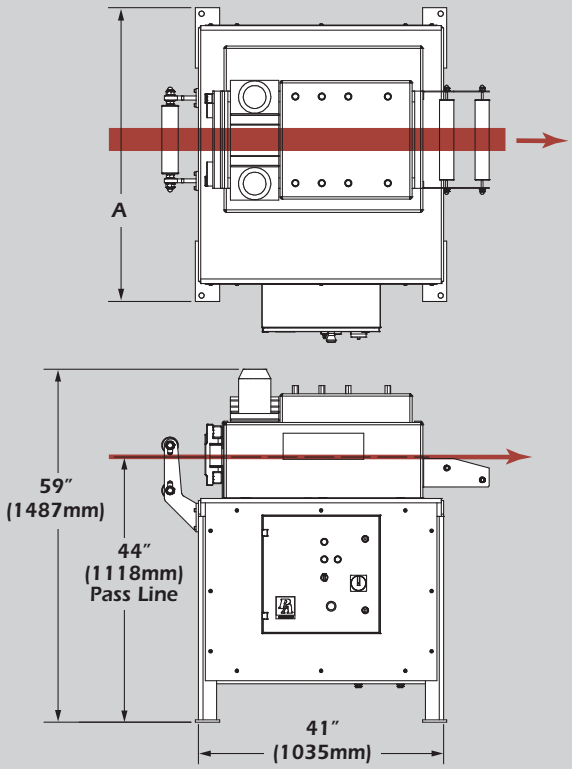
SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Straightening Rolls Qty	Straightening Rolls Dia. (mm)	Pinch Rolls Qty	Pinch Rolls Dia. (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
SS87HDX	200	0,8 – 6,5	7	80	4	80	0 – 23	5,6	Specify When Ordering
SS127HDX	300	0,8 – 6,0							
SS167HDX	400	0,8 – 5,5							
SS207HDX	500	0,8 – 5,2							
SS257HDX	650	0,8 – 4,4							
SS327HDX	800	0,8 – 3,2							
SS407HDX	1000	0,8 – 2,9							
SS507HDX	1300	0,8 – 2,3							
SS1211HDX	300	0,6 – 4,8	11						
SS2011HDX	500	0,6 – 4,2							
SS2511HDX	650	0,6 – 3,5							
SS3211HDX	800	0,6 – 2,3							
SS4011HDX	1000	0,6 – 2,1							
SS5011HDX	1300	0,6 – 1,7							

MAGNUM STRAIGHTENERS

- Removes coil set from thicker, wider material
- Compliments the P/A Magnum Servo Roll Feeds
- Solid cast frame construction insures precise roll parallelism
- Seven oversized straightening rolls
- Three upper rolls have independent height settings, with built-in dial display
- Entrance and exit pinch rolls are standard with all the lower straightening and pinch rolls being driven
- Pneumatic opening of the entrance pinch rolls
- Entrance and exit support rolls are standard with fully adjustable exit cascade rolls available as an option
- Vertical entrance guide rolls are provided with tee slots for ease of adjustment
- An Ultrasonic Loop Control is included to regulate material loop and speed.

DIMENSIONS



DIMENSIONS – in.

Model	A
SS300-7	49
SS500-7	49
SS650-7	55
SS800-7	61
SS1000-7	69
SS1300-7	81

DIMENSIONS – mm

Model	A
SS300-7	1245
SS500-7	1245
SS650-7	1397
SS800-7	1549
SS1000-7	1752
SS1300-7	2057

SPECIFICATIONS – *USA*

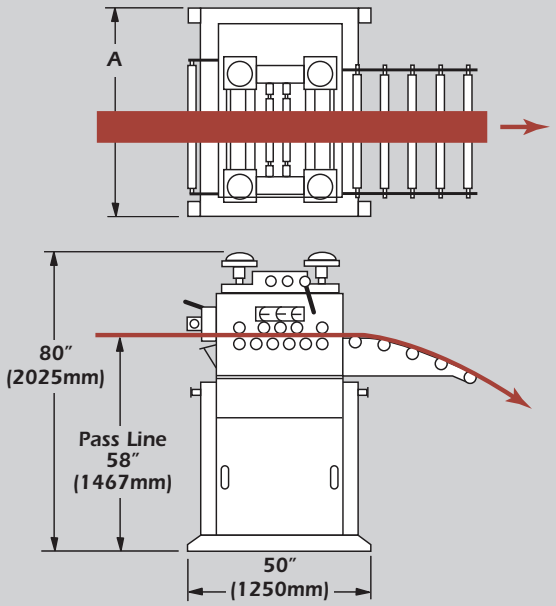
Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Straightening Rolls Qty	Straightening Rolls Dia. (In.)	Pinch Rolls Qty	Pinch Rolls Dia. (In.)	Speed Range (IPM)	AC Drive Motor (HP)	Input Power VAC/Phase/Hz
SS300-7	12	.040 – .236	7	3.75	4	3.75	0 – 900	10	460 / 3 / 60
SS500-7	20	.040 – .197							
SS650-7	25	.040 – .177							
SS800-7	30	.040 – .157							
SS1000-7	40	.040 – .118							
SS1300-7	50	.040 – .098							

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Straightening Rolls Qty	Straightening Rolls Dia. (mm)	Pinch Rolls Qty	Pinch Rolls Dia. (mm)	Speed Range (M/Min.)	AC Drive Motor (kW)	Input Power VAC/Phase/Hz
SS300-7	300	1,0 – 6,0	7	95	4	95	0 – 23	7,5	Specify When Ordering
SS500-7	500	1,0 – 5,0							
SS650-7	650	1,0 – 4,5							
SS800-7	800	1,0 – 4,0							
SS1000-7	1050	1,0 – 3,0							
SS1300-7	1300	1,0 – 2,8							

EXTRA HEAVY DUTY STRAIGHTENERS

DIMENSIONS



DIMENSIONS – in.

Model	A
SS425-7X	45
SS675-7X	55
SS1025-7X	69
SS1325-7X	81
SS1525-7X	90

DIMENSIONS – mm

Model	A
SS425-7X	1150
SS675-7X	1400
SS1025-7X	1750
SS1325-7X	2050
SS1525-7X	2290

- Our most robust model built for removing coil set from thicker, wider material
- Compliments the Magnum X-Model Servo Roll Feeds
- Majority of features and options are the same as Magnum Straighteners
- Large 4 inch (100mm) diameter pinch & straightening rolls are backed up to provide the capacity for heavier applications
- Upper three straightening rolls are adjusted with ratchet handles
- Roll settings are displayed on indicator dials provided or with optional digital display
- Ultrasonic loop control is included

Backed-Up Straightening Rolls

SPECIFICATIONS – USA

Model	Max. Stock Width (In.)	Stock Thickness Range (In.)	Straightening Rolls Qty	Straightening Rolls Dia. (In.)	Number of Back Up Rolls for each Roll	Pinch Rolls Qty	Pinch Rolls Dia. (In.)	Speed Range (IPM)	AC Drive Motor* (HP)	Input Power VAC/Phase/Hz
SS425-7X	16	.050 – .295	7	4	1 Optional	4	4	0 – 900	20	460 / 3 / 60
SS675-7X	26	.050 – .255			1 Optional					
SS1025-7X	40	.050 – .196			3 Sets					
SS1325-7X	52	.050 – .157			3 Sets					
SS1525-7X	60	.050 – .149			5 Sets					

SPECIFICATIONS – METRIC

Model	Max. Stock Width (mm)	Stock Thickness Range (mm)	Straightening Rolls Qty	Straightening Rolls Dia. (mm)	Number of Back Up Rolls for each Roll	Pinch Rolls Qty	Pinch Rolls Dia. (mm)	Speed Range (M/Min.)	AC Drive Motor* (kW)	Input Power VAC/Phase/Hz
SS425-7X	425	1,2 – 7,5	7	100	1 Optional	4	100	0 – 23	15	Specify When Ordering
SS675-7X	675	1,2 – 6,5			1 Optional					
SS1025-7X	1025	1,2 – 5,0			3 Sets					
SS1325-7X	1325	1,2 – 4,0			3 Sets					
SS1525-7X	1525	1,2 – 3,8			5 Sets					

Note: Maximum material capacity for narrower widths 3/8″ (9.5mm).

*Larger HP Drives are available.

LOOP CONTROL

The ON/OFF dancer arms normally furnished on your older constant speed cradles, reels, or straighteners may not provide the necessary loop required for long feed or higher speed applications. The bouncing dancer arms often dent, scratch, and crease delicate, prepainted, or highly polished stock. This causes press downtime and rejected parts. To address this problem, P/A offers two inexpensive solutions: the LC-2 and LC-3. Retrofit your existing equipment with either model.

The LC-2 is an ON/OFF electronic limit switch that senses vertical movement in a slack loop of conductive material. Spring probes maintain smooth stock delivery between the adjustable upper and lower limits.

The LC-3 is a proportional loop control designed to interface with a variable speed AC or DC Drive. The Drive changes speed automatically in response to signals from the touch probes for smoother payoff and take-up. No operator intervention is required after the initial set-up. The LC-3 can also be converted to a no-touch sensor system with the use of proximity sensors, which are available upon request.

STOCK DETECTOR

The P/A Stock Detector reduces die breakage and machine downtime by using a resistance-sensing controller to monitor material position as it enters the press or moves through the die. Stock buckling, run-out, and misfeeds are detected before a serious problem develops.

The low voltage controller allows the Detector to be used in areas where limit switches, operating at line voltage, are dangerous to personnel.

The Stock Detector operates through customer-supplied contact sensors or probes to signal either an Emergency Stop or Top Stop of the press. P/A will help you select the probes and sensors best suited to your application. Prevent the smash-up of **one** die and this sensor pays for itself.

NO TOUCH SENSORS

Any one of the P/A motorized Stock Reels or Straighteners can be equipped with an electronic sensing system that detects material position without physically touching it. These non-contact control systems permit smooth acceleration, deceleration, and braking throughout the reel's speed range, as well as maintaining constant torque/ tension characteristics. These sensors are ideal for the rewinding of lead frame, connectors, or payoff of delicate, thin, and highly polished material applications.

RF SYSTEM

The RF System uses a shielded antenna and a radio frequency field to sense conductive material. As the loop changes height, the radio signal changes in response. This causes the solid state circuitry to instantly adjust the variable DC] Drive of the Reel or] Straightener to maintain] a constant loop. The RF is not susceptible to ultrasonic interference which makes it an attractive alternative to sonar sensing systems.

ULTRASONIC

The UltraSonic Loop Control utilizes sonar, or "echo location", to determine and maintain a constant loop height. The adjustable sensor head bounces controlled, coded bursts of high frequency sound off the lowest point in the strip. It then measures the echo distance and adjusts the operating speed of the Reel or Straightener.

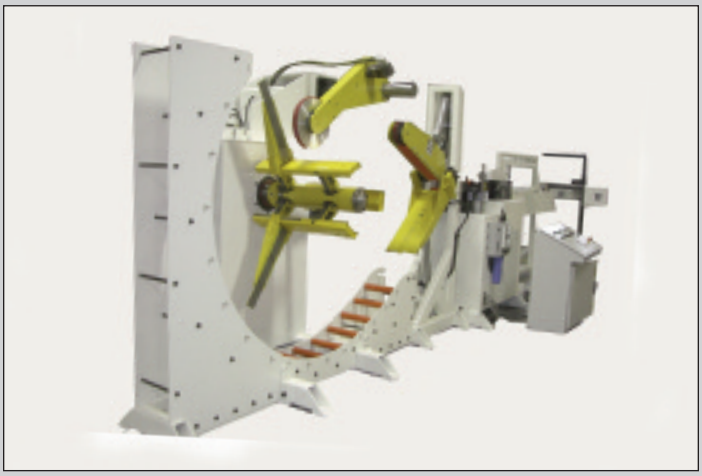
The microprocessor-based control eliminates signal drift, while the coded sound bursts reject interfering sound waves.

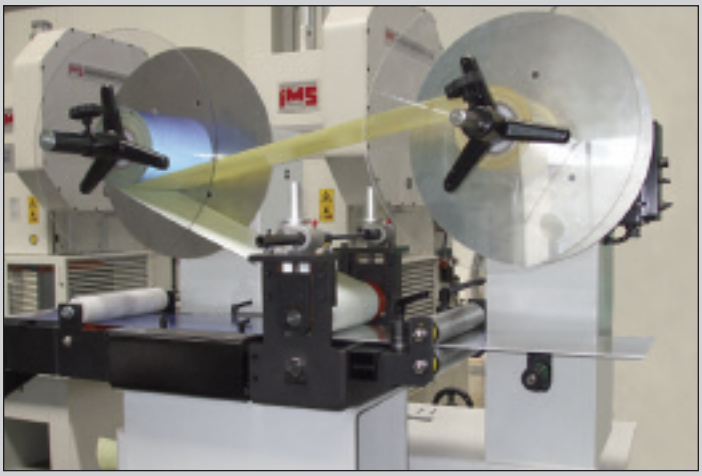
The UltraSonic gives the operator the flexibility of using the longer loops required when stamping long progressions. It is a highly accurate and sophisticated way to monitor both conductive and non-conductive material.

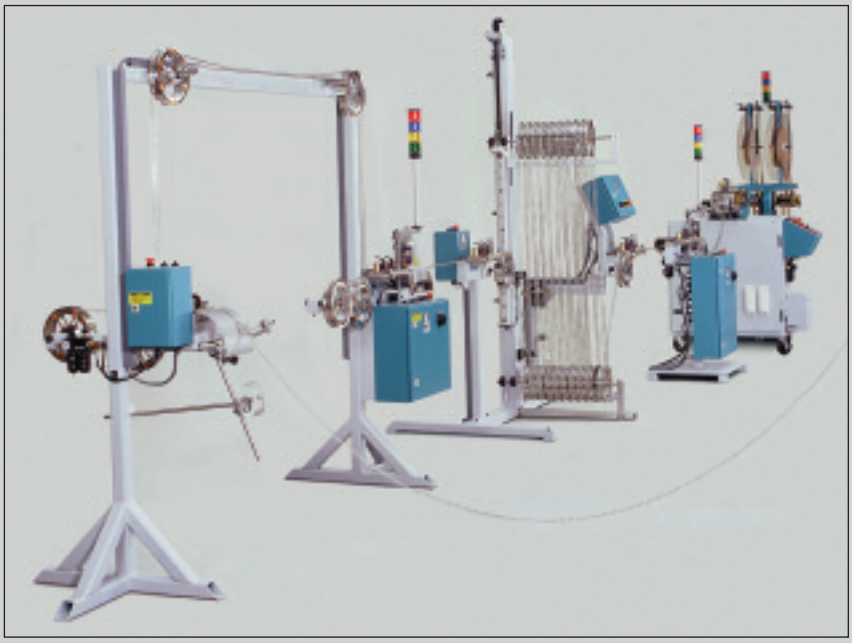
LASER LOOP CONTROL

This No-Touch Laser has a longer, more precise range than the Ultrasonic. It is ideal for loop pits. The Laser has a 40mm dia. "spot" that enables the sensor to detect non-continuous/stamped product. Standard features include built-in Tight Loop Output, Digital Parameter Settings and 6 foot tall mounting stand.

CUSTOM & SPECIAL APPLICATIONS







REFERENCE DATA

PRODUCTION – PARTS PER HOUR (Figures Based Upon One Part Per Press Stroke)

Press Speed (Strokes Per Minute)		40	60	70	80	100	120	150	200	250	300
Efficiency Rate	100%	2400	3600	4200	4800	6000	7200	9000	12000	15000	18000
	90%	2160	3240	3780	4320	5400	6480	8100	10800	13500	16200
	80%	1920	2800	3360	3840	4800	5760	7200	9600	12000	14400
	75%	1800	2700	3150	3600	4500	5400	6750	9000	11250	13500
	70%	1680	2520	2940	3360	4200	5040	6300	8400	10500	12600
	60%	1440	2160	2520	2880	3600	4320	5400	7200	9000	10800
	50%	1200	1800	2100	2400	3000	3600	4500	6000	7500	9000

STRIP CONSUMPTION – FEET PER MINUTE

Feed Length (Inches)		0.5	1	1.5	2	3	4	5	6	8	10	12	16
Press Speed (Strokes Per Minute)	40	1.7	3.3	5.2	6.5	10	13	16	20	26	33	40	52
	60	2.5	5	7.5	10	15	20	25	30	40	50	60	80
	70	2.9	5.8	8.8	11	17	23	29	35	46	57	70	92
	80	3.3	6.6	10	13	20	26	33	40	52	66	80	105
	100	4.2	8.2	13	16	25	33	41	50	66	82	100	131
	120	5.0	10	15	20	30	40	50	60	80	100	120	160
	150	6.3	12	18	25	37	50	62	75	100	125	150	200
	200	8.3	16	25	34	50	66	82	100	131	164	200	266
	250	10.4	21	31	41	62	83	103	125	164	205	250	328
	300	12.5	25	40	50	75	100	125	150	200	250	300	400

COIL ROTATIONAL SPEEDS – REVOLUTIONS PER MINUTE

Strip Consumption (Feet Per Minute)		5	15	30	45	60	75	90	120	150	180	210	240	270	300	330	360
Coil Diameter (Inches)	60	0.3	1.0	1.9	2.9	3.8	4.8	5.7	7.6	9.5	11.5	13.4	15.3	17.2	19.1	21.0	22.9
	48	0.4	1.2	2.4	3.6	4.8	6.0	7.2	9.5	11.9	14.3	16.7	19.1	21.5	23.9	26.3	28.6
	36	0.5	1.6	3.2	4.8	6.4	8.0	9.5	12.7	15.9	19.1	22.3	25.5	28.6	31.8	35	38.2
	24	0.8	2.4	4.8	7.2	9.5	11.9	14.3	19.1	23.9	28.6	33.4	38.2	43.0	47.7	52.5	57.3
	18	1.1	3.2	6.4	9.5	12.7	15.9	19.1	25.5	31.8	38.2	44.6	50.9	57.3	63.7	70.0	76.4
	12	1.6	4.8	9.5	14.3	19.1	23.9	28.6	38.2	47.7	57.3	66.8	76.4	85.9	95.9	105.0	114.6

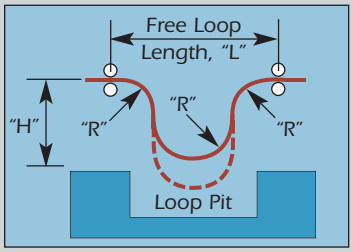
COIL WEIGHT REFERENCE CHART

Based on 1 Inch Strip Width – Steel.
Factor From Chart x Width of Coil = Total Coil Weight.

To Obtain Weight of:
Aluminum. . . . . Multiply Total Wt. x .344
Brass . . . . . Multiply Total Wt. x 1.08
Copper. . . . . Multiply Total Wt. x 1.14
Stainless Steel . . . . . Multiply Total Wt. x 1.02

Inside Diameter		6	8	10	12	14	16	18	20	22	24
Outside Diameter	10	15	–	–	–	–	–	–	–	–	–
	12	25	15	–	–	–	–	–	–	–	–
	14	35	20	20	–	–	–	–	–	–	–
	16	50	40	35	25	–	–	–	–	–	–
	18	65	60	50	40	30	–	–	–	–	–
	20	80	75	65	55	45	35	–	–	–	–
	24	120	110	105	95	85	70	55	40	–	–
	28	170	160	150	140	130	120	105	85	65	45
	32	220	210	205	195	185	170	155	140	120	100
	36	280	270	265	255	245	230	215	200	180	160
	40	350	340	330	325	310	300	285	265	250	230
	44	420	410	405	400	385	375	360	340	325	305
	48	500	490	485	480	470	455	440	425	405	385
	52	590	580	575	570	560	545	530	510	495	470
	56	690	680	670	665	655	640	625	610	590	570
	60	800	790	780	770	760	745	730	710	695	675

FREE LOOP AREA & SLACK MATERIAL AVAILABILITY FOR MILD STEEL COIL STOCK

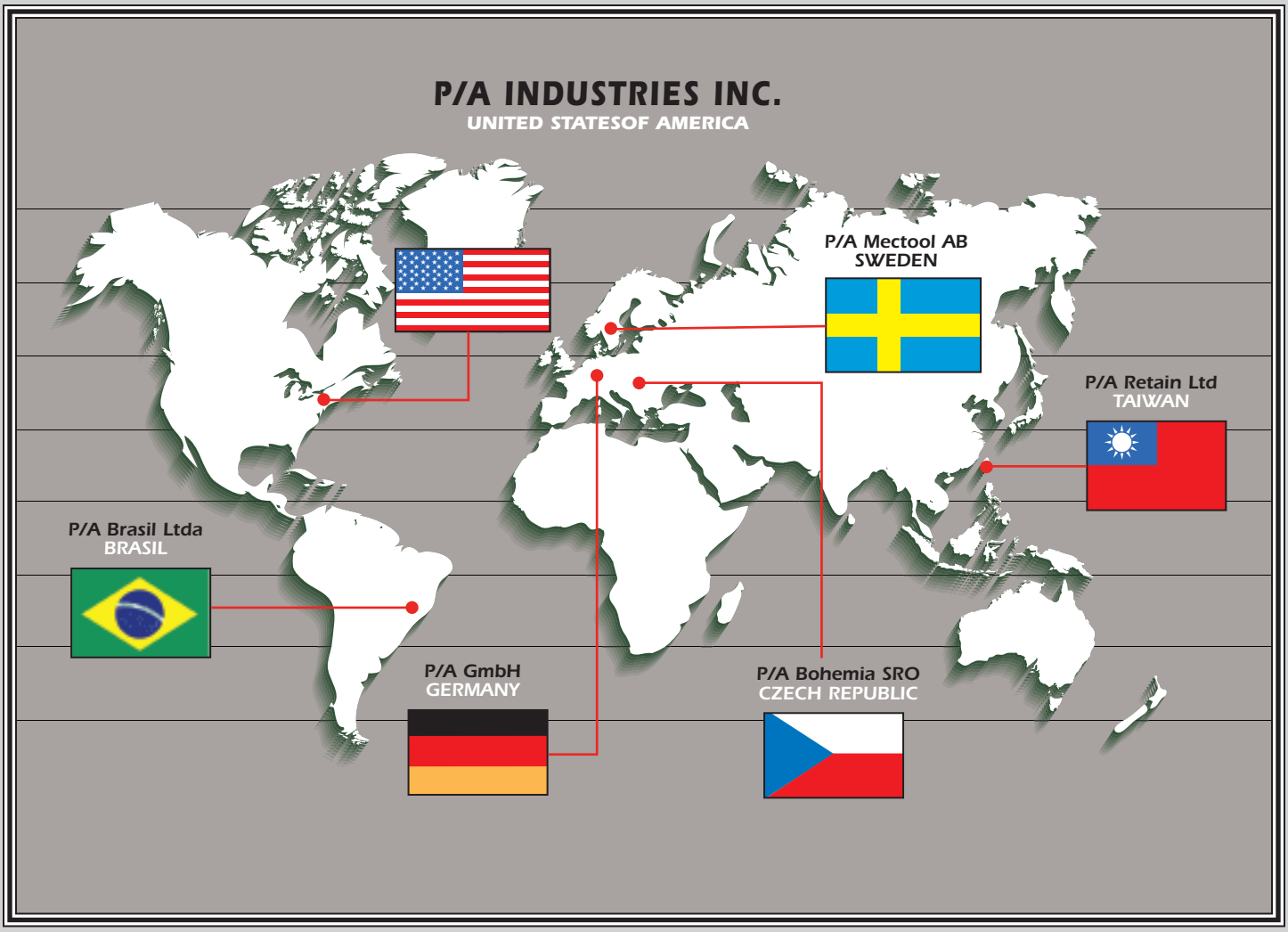


"R" = Radius desirable to avoid distortion of material in free loop calculated at approximately 360 times metal thickness.

Loop Pit can provide 2 inches of additional slack material for each inch of depth once "H" is equal to at least two times "R".

Chart below shows inches of loop required for a given thickness & inches of slack material in a full loop.

Material Thickness T, (Ins.)	Free Loop Length L, (Ins.)	Pass Line Height H, (Ins.) Accumulated Slack 36	42	48	54	60	66	72
0.015	48	48	56	68	81	99	107	121
0.031	72	37	45	56	67	78	90	106
0.062	96	30	38	47	57	67	78	88
0.093	144	21	29	36	44	52	61	71
0.125	180	18	24	31	38	45	53	61
0.187	276	–	19	22	27	33	39	45
0.250	360	–	–	18	22	27	32	37



WARRANTY

We warrant our mechanical parts against defects under normal use and service for a period of 2 years after date of shipment. We warrant all components installed, but not manufactured by P/A, for 1 year after date of shipment. Our obligation under this warranty is limited to replacing or repairing (at our option) the defective part without charge, F.O.B. our plant in Bloomfield, Connecticut. The defective part must be forwarded to our plant, freight-prepaid, for our inspection prior to replacement or repair. EXCEPT AS EXPRESSLY PROVIDED HEREIN, THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING A WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

WARNING !

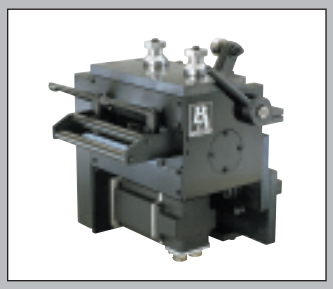
This equipment offers various means of operating metal forming machines, delivers material or parts to the machine, or removes material, parts, or scrap from the machine. The operator's hands must NOT be in or near the point-of-operation of the machine, or the operating parts of any equipment installed on the machine, or bodily injury could result. The EMPLOYER must post adequate warning signs on the press with proper warnings for his machine and the specific application to which the machine and equipment are being applied. If the EMPLOYER requires help in preparing wording for his application after he has determined the details of that application, he is invited to contact P/A Industries for such help.

The EMPLOYER must meet all OSHA regulations including, but not limited to, 1910.211, 1910.147, 1910.212, 1910.217 and all applicable state laws. All equipment manufactured by P/A Industries is designed to meet the construction standards of OSHA in effect at the time of sale, but the EMPLOYER installs the equipment, and therefore the EMPLOYER is responsible for installation, use, application, training, and maintenance, as well as adequate signs on the press or other machine onto which this equipment will be installed.

All P/A products are sold for use only in accordance with our installation and operating instructions which accompany the products. P/A accepts no responsibility for any use or application not in accordance with our instructions, or for any modification or alteration of the product.

Accident-free press operation will result from a well developed, management-sponsored and enforced press safety program. P/A Industries is not responsible for notifying the user of this equipment of further changes in State or Federal laws, construction standards, or changes in P/A designed and built products.

Servo Feeds



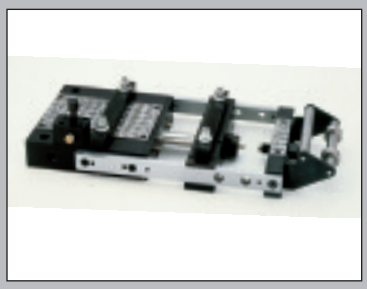
Cut-To-Length

Wire Handling

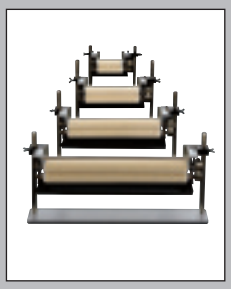
Transporters

Shears

Air Feeds



Oilers



Sensors

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