

**A60080-A60099 OSCILLATING DIE  
REBUILD**

**Before**

**After**



***automatic***  
**FEED COMPANY**

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## Scope of Project

**Scope of Project:**

- **Build new controls**
- **Modify the die conveyor**
- **Integrate the control with the coil line PLC**

Controls include a new Unico drive for the oscillating die. This will be synchronized with the feeder control and stacker. This will allow use of the press mounted resolver to minimize the velocity of the drive to swing the die while maximizing the rate of production. This mode is often referred to as the *Profile Mode*. The controller uses the available angle and automatically calculates the longest acceleration and deceleration with the lowest velocity while using the entire available angle. This translates to higher production rates with less wear on the machine.

**Coil Specifications:**

Coil Weight:	33,750 kg (75,000 lbs) maximum
Coil Width:	406.4 mm (16") minimum 1,828.8 mm (72") maximum
Coil OD:	914.4 mm (36") minimum 1,930.4 mm (76") maximum
Coil ID:	508 mm (20") minimum 609.6 mm (24") maximum

**Material Specifications:**

Thickness:	.51 mm (.020") minimum 2.79 mm (.110") maximum
Yield Strength:	50,000 psi maximum
Average Line Speed:	300 fpm

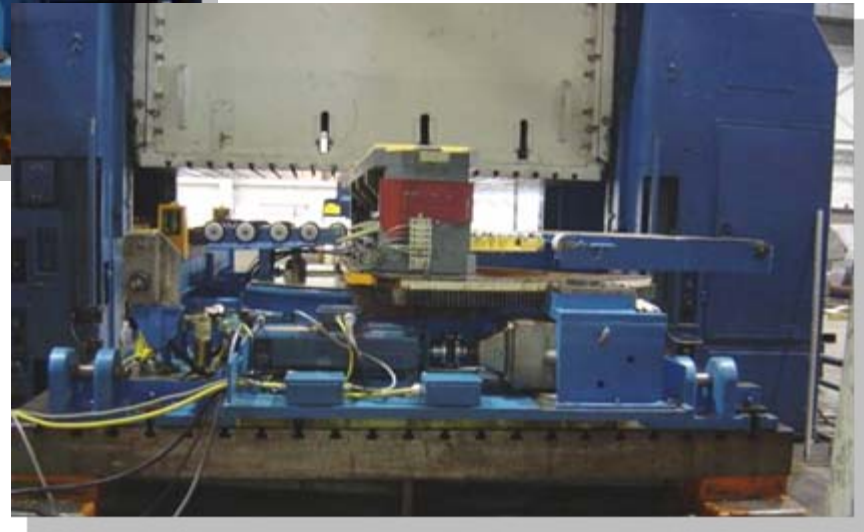
# A60080-A60099 Oscillating Die Rebuild

Before



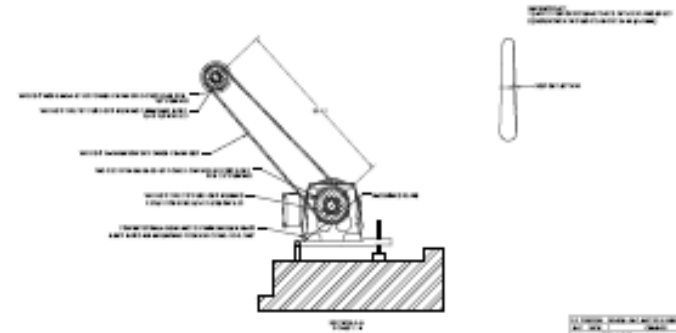
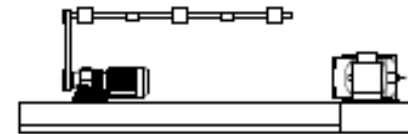
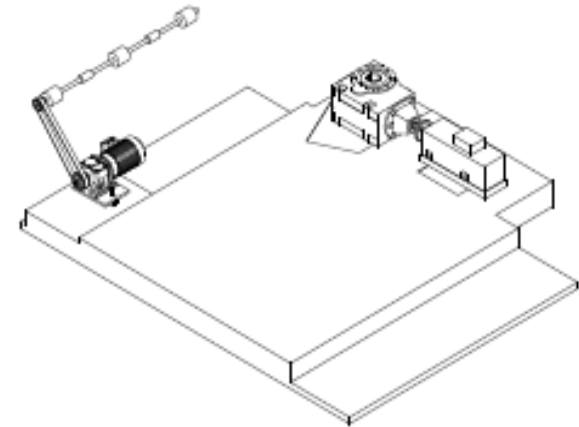
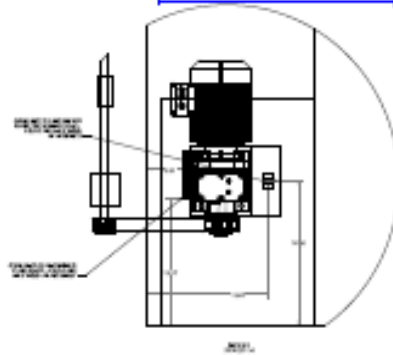
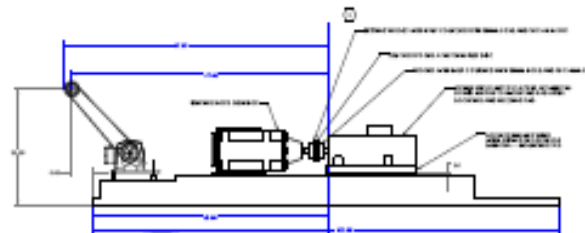
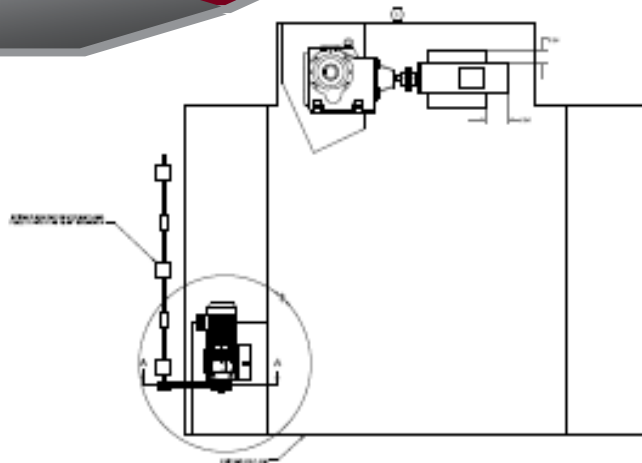
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After



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## Drawing



1. LISTED DRAWING NUMBER	
2. DATE	
3. DRAWN BY	
4. CHECKED BY	
5. APPROVED BY	
6. PART NUMBER	A60080
7. REV. NO.	1.0