

DIMAC

NC Roll Feeding Machine



www.compactfeeder.eu

VENDAR

Via E. Mattei, 58

35020 Sant' Angelo di Piove (PD)

P.iva NL005250406B66

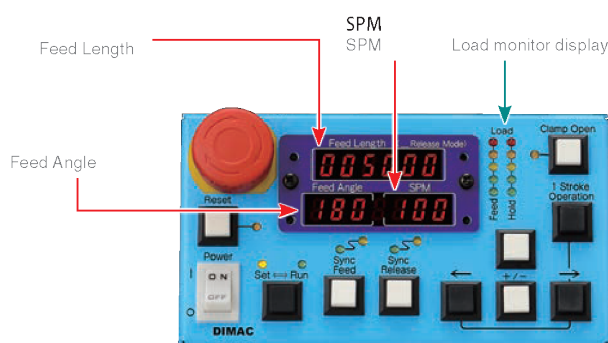
R·J Series NC Roll Feeding Machine

Serie J: Questa serie si distingue per l'integrazione di un *monitor di carico* che permette di verificare costantemente lo stato del servomotore durante l'alimentazione. Il sistema *calcola automaticamente la velocità di trasporto* del materiale basandosi semplicemente sull'inserimento dei parametri di lunghezza, angolo e colpi al minuto (SPM), semplificando notevolmente il setup operativo.

R·J Series NC Roll Feeding Machine

Control panel display function

410C Controller



Features

- *The load monitor can you check the state of the feeder when the servo motor is receiving load.
- *By setting the [Feed Length], [Feed Angle], [SPM], material transport speed is automatically calculated.

Product specifications



Model J06

Max. Material width	~ 70mm
Max. Material thickness	~ 1.2mm
Max. Feed length	~ 9999.99mm
Max. Stamp speed	~ 300spm
Required power supply	AC200V ±10% 50/60Hz 3-phase / Single-phase AC200V ±10% 50/60Hz
Weight	13kg
Pass line	70mm



Model J15

Max. Material width	~ 150mm
Max. Material thickness	~ 2.3mm
Max. Feed length	~ 9999.99mm
Max. Stamp speed	~ 250spm
Required power supply	AC200V ±10% 50/60Hz 3-phase / Single-phase AC200V ±10% 50/60Hz
Weight	25kg
Pass line	90mm



Model J25

Max. Material width	~ 250mm
Max. Material thickness	~ 2.3mm
Max. Feed length	~ 9999.99mm
Max. Stamp speed	~ 250spm
Required power supply	AC200V ±10% 50/60Hz 3-phase / Single-phase AC200V ±10% 50/60Hz
Weight	28kg
Pass line	90mm

*1 標準品 Standard Model

Serie R: Progettata per gestire materiali con dimensioni più importanti, la Serie R mantiene le funzioni intelligenti di monitoraggio della serie J ma estende la capacità operativa a larghezze di materiale fino a **500 mm** e spessori fino a **3.2 mm**. Rappresenta una soluzione robusta e versatile, capace di interfacciarsi con una vasta gamma di optional come i rulli in uretano o i sensori ottici di fine materiale.



Model R20

Max. Material width	~ 200mm
Max. Material thickness	~ 3.2mm
Max. Feed length	~ 9999.99mm
Max. Stamp speed	~ 200spm
Required power supply	AC200V ±10% 50/60Hz 3-phase / Single-phase AC200V ±10% 50/60Hz
Weight	42kg
Pass line	95mm



Model R30

Max. Material width	~ 300mm
Max. Material thickness	~ 3.2mm
Max. Feed length	~ 9999.99mm
Max. Stamp speed	~ 200spm
Required power supply	AC200V ±10% 50/60Hz 3-phase / Single-phase AC200V ±10% 50/60Hz
Weight	49kg
Pass line	95mm



Model R40

Max. Material width	~ 400mm
Max. Material thickness	~ 3.2mm
Max. Feed length	~ 9999.99mm
Max. Stamp speed	~ 200spm
Required power supply	AC200V ±10% 50/60Hz 3-phase / Single-phase AC200V ±10% 50/60Hz
Weight	55kg
Pass line	95mm



Model R50

Max. Material width	~ 500mm
Max. Material thickness	~ 3.2mm
Max. Feed length	~ 9999.99mm
Max. Stamp speed	~ 200spm
Required power supply	AC200V ±10% 50/60Hz 3-phase / Single-phase AC200V ±10% 50/60Hz
Weight	61kg
Pass line	95mm

*1 Standard Model

*2 The lower roll is a release roll, the pass line is lowered with the thickness of the material.

Options

	R Series			J Series		
	R20	R30/R40/R50	J06	J15	J25	
Optical work shortage sensor	●	●	●	●	●	
Pulling function	●	●	●	●	●	
Controller off-set	●	●	*	●	●	
Swing cover	●	●	●	●	●	
Urethane roll	●	●	●	●	●	
Silicone roll	●	●	●	●	●	
BBC(Blast+Blueing) roll	●	●	●	●	●	
Sepalate roll	●	●	—	▲	▲	
Extention aplon roll	●	●	●	●	●	
Slide plate for mounting machine	●	—	●	●	●	

● Standard ▲ Not available bottom roll.

Feed Performance Table

R20/R30/R40/R50				J06				J15/J25			
Feed angle Setting Value	150°	180°	210°	Feed angle Setting Value	150°	180°	210°	Feed angle Setting Value	150°	180°	210°
spm	Feed length (mm)			spm	Feed length (mm)			spm	Feed length (mm)		
200	28	42	60	300	12	19	27	250	18	29	41
190	31	47	67	280	14	22	32	240	20	32	45
180	35	54	76	260	17	26	38	230	23	35	50
170	40	61	86	240	21	32	46	220	25	39	55
160	46	70	98	220	25	39	56	210	28	43	61
150	54	80	113	200	32	49	69	200	32	48	68
140	63	94	131	180	41	62	87	180	40	61	86
130	74	110	153	160	53	80	112	160	53	79	111
120	88	131	181	150	62	92	129	150	61	91	128
110	106	157	215	140	72	108	150	140	71	106	149
100	131	192	255	130	85	126	176	130	84	125	174
90	164	234	303	120	101	150	208	120	100	149	206
80	207	286	364	110	122	181	247	110	121	179	244
70	263	353	443	100	150	220	292	100	149	218	289
60	338	443	548	90	188	268	349	90	186	265	345

It may not be possible to finish workpiece feed at angle as specified on the feed performance table if the feeding machine is under a load resulting from material stress, etc.

H Series NC Roll Feeding Machine

DIMAC

for high speed stamping presses

MODEL **H07 / H13 / H25**

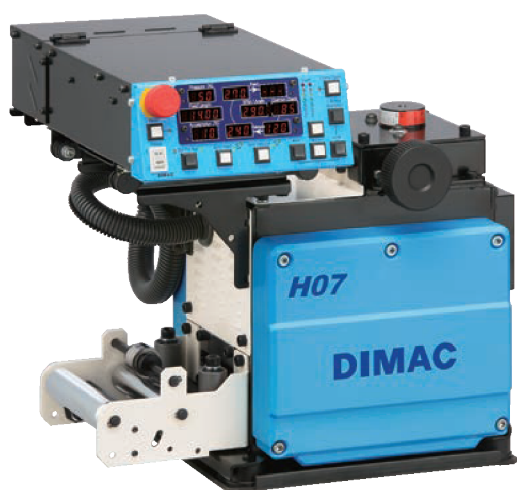


Serie H: Focalizzata sulle applicazioni ad *alta velocità*, questa serie può raggiungere prestazioni fino a **1000 colpi al minuto**. Include innovazioni specifiche per la qualità del prodotto, come l'opzione **RV (Ring-Rolls)** che protegge le superfici delicate da segni di pressione e il sistema a camma per lo sgancio rapido del supporto del rullo (apron bracket), che facilita le operazioni di pulizia e ispezione.

NC Roll Feeding Machine H Series



Product specifications



Model **H07**

Max. Material width	~ 75mm
Max. Material thickness	~ 1.2mm
Max. Feed length	~ 999.99mm
Max. Stamp speed	~ 1000spm
Required power supply	AC200V ±10% 50/60Hz 3-phase AC200V ±10% 50/60Hz
Weight	34kg
Pass line	78mm



Model **H13**

Max. Material width	~ 130mm
Max. Material thickness	~ 1.6mm
Max. Feed length	~ 999.99mm
Max. Stamp speed	~ 1000spm
Required power supply	AC200V ±10% 50/60Hz 3-phase AC200V ±10% 50/60Hz
Weight	52kg
Pass line	98mm



Product specifications



Model **H25**

Max. Material width	~ 250mm
Max. Material thickness	~ 1.6mm
Max. Feed length	~ 999.99mm
Max. Stamp speed	~ 700spm
Required power supply	AC200V ±10% 50/60Hz 3-phase AC200V ±10% 50/60Hz
Weight	66kg
Pass line	98mm

*1

Standard Model

*2

The lower roll is a release roll, the pass line is lowered with the thickness of the material.

NC Roll Feeding Machine H Series



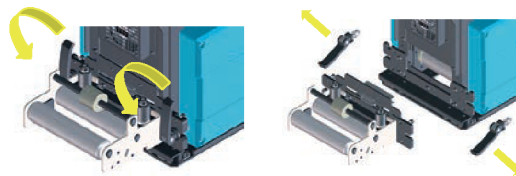
H Series Options

H-RV Series NC Roll Feeding Machine

H Series with RV

It is an option that removes apron bracket by cam lever.
The feed roll can be easily inspected and cleaned.

Apron Bracket Detachable method



NC Separate-Roll Feeding Machine

It is possible for two ring-rolls to clamp the positions that you selected, which is useful to feed a secondary processed products and suitable to escape a release mark.

H Series Separate roll with RV





Controller options

■ DS6

Feed direction change



■ FF6

Feed completion output



■ TC6

Feed conditions measurement



■ MP6

Data bank



■ BS6

Feed-during output



■ RC6A

Remote box

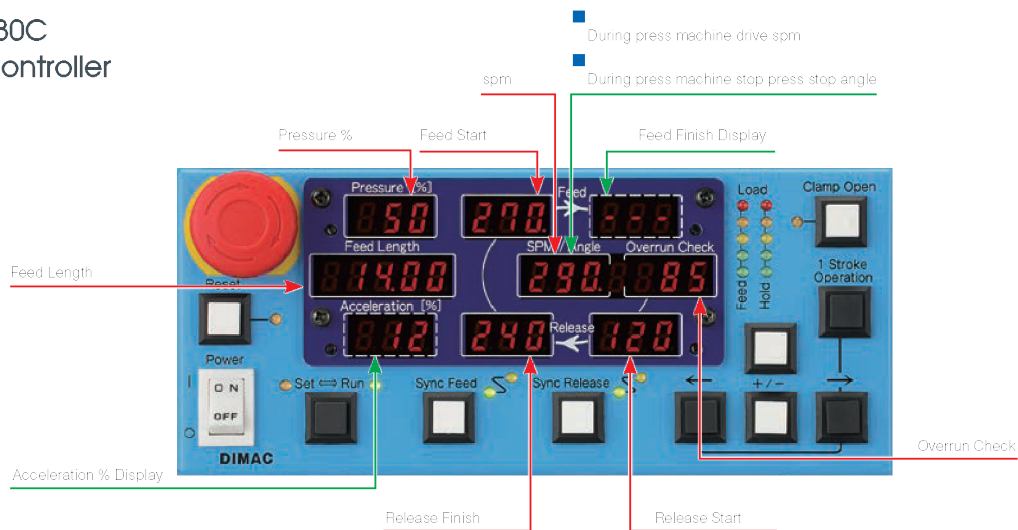


NC Roll Feeding Machine H Series



Control panel display function

430C
Controller



Feed Performance Table

H07		
Feed angle Setting value	180°	210°
spm	Feed length (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		
Feed angle Setting value	180°	210°
spm	Feed length (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		
Feed angle Setting value	180°	210°
spm	Feed length (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

Depending on the starting angle and acceleration of the press machine, the release operation may not be able to follow up.

A-A Series Long Sprint NC Roll Feeding Machine

for high speed stamping presses

Serie A (Long Sprint): Questa serie è dedicata a produzioni che richiedono elevate prestazioni su materiali di grande larghezza, fino a **600 mm**. È dotata di sistemi avanzati per la **regolazione automatica dell'accelerazione e dello spessore**, operando con tecnologia **Air-Free** a pressione elettromagnetica per garantire precisione e costanza senza l'uso di aria compressa.

MODEL **A40A / A60A**



A40A



A60A



491C Controller





Features

- Automatic Acceleration Setting System
- Automatic Thickness Adjustment System
- Air Free
- Electromagnetic Roll Pressure System



Input Items

- Feed Length (mm/Inch)
- Roll Pressure (%)
- Press Shot Speed (SPM)
- Feed Start Angles · Overrun Check Angles
- Release Start Angles · Release Finish Angles



Product Specifications

Specifications	A40A	A60A
Material Width	120mm* ~ 400mm	150mm* ~ 600mm
Max. Material Thickness	~ 1.6mm	
Max. Material Weight	~ 10kg	
Max. Stamp Speed	~ 600spm	
Max. Feed Length	999.99mm (0.01mm)	999.99mm (Adjusted by 0.01mm unit)
Required Power Supply	(±10%) · 50/60Hz	3-phase 200V(±10%) · 50/60Hz

Optional feed rolls are available for minimum material widths of 120/150 or less.



Feed Performance Table

Feed Angle 150°		Max. Feed Length [mm]		
Press Speed	spm	Material Weight		
		3kg	5kg	7kg
600		17.4	10.9	5.7
550		23.5	14.6	7.7
500		31.9	19.9	10.5
450		44.0	27.4	14.5
400		61.8	38.5	20.4
350		89.1	55.6	29.4
300		133.2	83.1	44.0
250		209.8	131.0	69.3
200		334.7	223.1	118.0
150		542.9	422.5	227.9
100		959.3	838.9	555.0

Feed Angle 180°		Max. Feed Length [mm]		
Press Speed	spm	Material Weight		
		3kg	5kg	7kg
600		31.9	19.9	10.5
550		41.7	26.0	13.7
500		55.0	34.3	18.1
450		73.9	46.1	24.4
400		101.4	63.3	33.5
350		143.1	89.3	47.2
300		209.8	131.0	69.3
250		309.7	202.7	107.2
200		459.6	339.2	179.6
150		709.5	589.1	341.5
100		999.9**	999.9**	803.8

Feed Angle 210°		Max. Feed Length [mm]		
Press Speed	spm	Material Weight		
		3kg	5kg	7kg
600		50.8*	31.7*	16.7*
550		64.7*	40.5*	21.4*
500		82.6	52.6	27.8
450		107.3	69.6	36.8
400		142.7	94.1	49.8
350		195.6	131.0	69.3
300		278.8	189.7	100.3
250		409.7	290.0	153.4
200		584.5	464.2	254.1
150		876.0	755.6	478.1
100		999.9**	999.9**	999.9**

It may not be possible to finish workpiece feed at angle as specified on the feed performance table if the feeding machine is under a load resulting from material stress, etc.

G Series NC Grip Feeding Machine

for high speed stamping presses

Serie Grip (G): Utilizza un meccanismo di alimentazione e rilascio a pinze completamente indipendente dalla rotazione della pressa, eliminando le deviazioni causate dalle variazioni di velocità. Grazie al sistema elettromagnetico *Air-Free*, il modello TG4 può raggiungere i **1000 colpi al minuto**, offrendo un controllo numerico totale su parametri critici come la pressione di presa e gli angoli di interferenza.

NC Grip Feeding Machine G Series

G series features

Air Free

This machine has the structure where feed and release do not receive the deviation of press rotation speed, because no link of the drive mechanism by the press machine.

Electromagnetic Grip Pressure / Release Systems.

Numerical setting items : feed length, feed start angle, feed interfere angle, release start / end angles, Grip pressure.

Product specifications



Model **G11**

Material width	8mm ~ 120mm
Max. Material thickness	~ 0.8mm
Max. Feed length	~ 110.00mm
Max. Stamp speed	~ 600spm
Required power supply	±10% 50/60Hz 3-phase AC200V ±10% 50/60Hz
Weight	42kg
Pass line	169mm



Model TG4

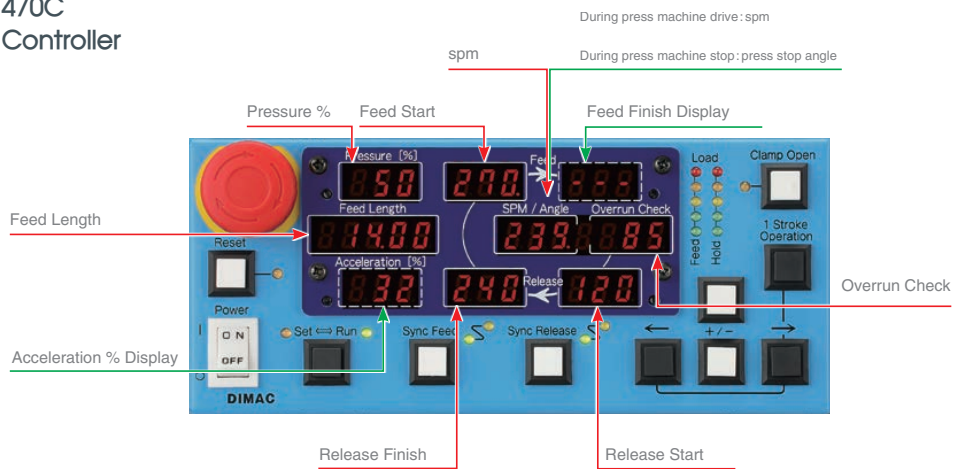
Material width	8mm ~ 120mm
Max. Material thickness	~ 0.8mm
Max. Feed length	~ 40.00mm
Max. Stamp speed	~ 1000spm
Required power supply	±10% 50/60Hz 3-phase AC200V ±10% 50/60Hz
Weight	42kg
Pass line	169mm

- *1 Standard Model
- *2 Release will be moving the lower gripper.

NC Grip Feeding Machine G Series

Control panel display function

470C
Controller



Numerical setting items

	G11	TG4
Feed length	0.01 ~ 110.00mm (Unit 0.01mm)	0.01 ~ 40.00mm (Unit 0.01mm)
Grip pressure	10% ~ 100%	
Feed start	210° ~ 150°	
Feed interfere	210° ~ 150°	
Release start	60° ~ 180°	
Release finish	120° ~ 300°	
SPM / Angle	1 ~ 700spm	1 ~ 1200spm*

* In case of over 1000, To display the last 3 digit and dot.

Controller options

DS6

Feed direction change



FF6

Feed completion output



TC6

Feed conditions measurement



MP6

Data bank



BS6

Feed-during output



RC6A

Remote box



NC Grip Feeding Machine G Series

Feed Performance Table

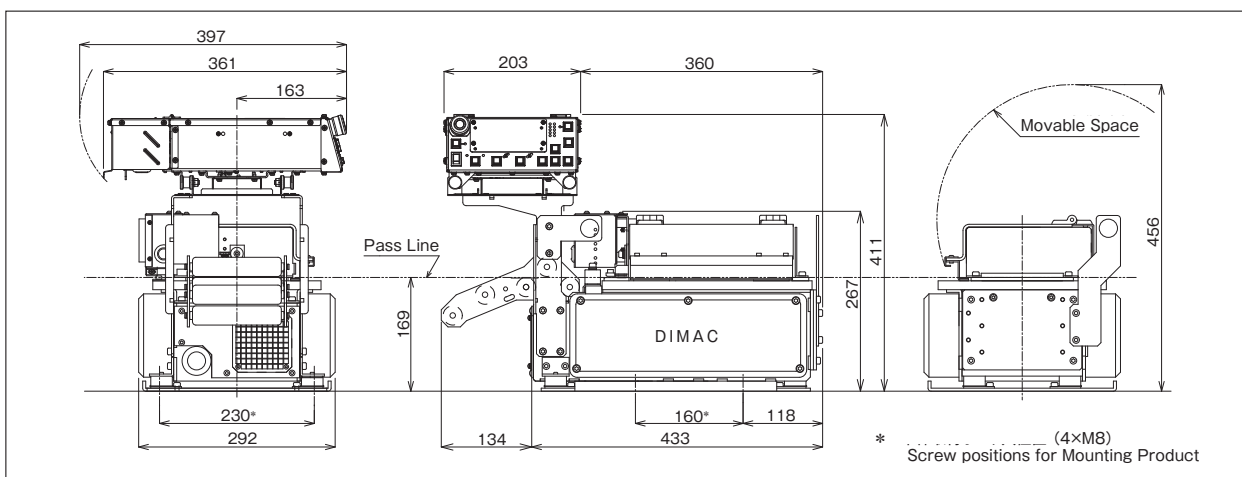
G11		
Feed angle Setting value	150°	180°
spm	Feed length (mm)	
600	1.9	4.5
550	2.9	6.4
500	4.5	9.1
450	6.8	13.0
400	10.4	18.9
350	16.2	28.0
300	25.8	43.1
280	31.5	51.8
260	38.7	62.9
240	48.1	77.1
220	60.4	95.0
200	77.1	*110.0
180	99.0	*110.0
160	*110.0	*110.0

* Maximum value of setting

TG4		
Feed angle Setting value	150°	180°
spm	Feed length (mm)	
1000	1.7	3.1
950	2.0	3.6
900	2.4	4.2
850	2.9	5.0
800	3.5	5.9
750	4.2	7.0
700	5.2	8.5
650	6.3	10.2
600	7.8	12.6
550	9.8	15.6
500	12.6	19.6
450	16.3	25.2
400	21.7	33.2
350	29.7	*40.0

* Maximum value of setting

Figure dimension



T Series NC Twin Roll Feeding Machine

Serie Push Pull (Serie T): Caratterizzata dalla configurazione a doppio rullo, questa serie permette un utilizzo flessibile sia in *modalità foglio (sheet mode)* che in *modalità bobina (coil mode)*. Il design compatto integra l'elettronica nel corpo macchina per risparmiare spazio, mentre la struttura con *telaio a C* dei modelli T20 e T30 agevola l'inserimento frontale del materiale, rendendola ideale per banchi pressa con spazi ridotti.

NC Twin Roll Feeding Machine T Series

T series features

- By setting the feeder on the left and right, it is possible to use it in seat mode and coil mode.
(Steel sheet material, Steel coil material)
- Space saving design which integrates machine body and control equipment.
- Adjustment to inside and outside of bolster is possible by standard equipment of slide type plate.
(Manual operation)
- The T20 / T30 adopts a C type frame, and material input can be taken from the front of the main body.
(TJ06 / TJ15 is impossible)
- The controller will calculate the feeding rate according to "Feed Angle" and "SPM".

Product specifications



Model T20

Max. Material width	~ 200mm
Max. Material thickness	~ 3.2mm
Max. Stamp speed	~ 200spm
Required power supply	200V ±10% 50/60Hz 3-phase / Single phase 200V ± 10% 50/60Hz
Max. material transport weight	15kg
Min. Pass line height	118mm
Depth length from roll center	210mm

Product specifications



Model T30

Max. Material width	~ 300mm
Max. Material thickness	~ 3.2mm
Max. Stamp speed	~ 200spm
Required power supply	200V ±10% 50/60Hz 3-phase / Single phase 200V ± 10% 50/60Hz
Max. material transport weight	15kg
Min. Pass line height	118mm
Depth length from roll center	260mm

*1

Steel sheet material

*2

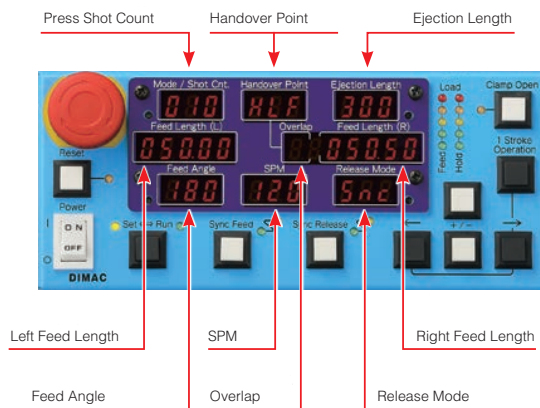
In case of installing in the bolster inner side.

NC Twin Roll Feeding Machine T Series

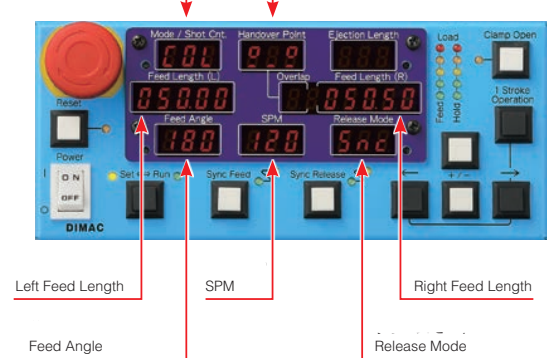
Control panel display function

450C Controller

Sheet mode



Coil Mode



Product specifications



Model TJ06

Max. Material width	~ 70mm
Max. Material thickness	~ 1.2mm
Max. Stamp speed	~ 200spm
Required power supply	200V ±10% 50/60Hz 3-phase / Single phase 200V ± 10% 50/60Hz
Max. material transport weight	5kg
Min. Pass line height	83mm
Depth length from roll center	115mm

Product specifications



Model **TJ15**

Max. Material width	~ 150mm
Max. Material thickness	~ 2.3mm
Max. Stamp speed	~ 200spm
Required power supply	200V ±10% 50/60Hz 3-phase / Single phase 200V ± 10% 50/60Hz
Max. material transport weight	15kg
Min. Pass line height	103mm
Depth length from roll center	170mm

- *1 Steel sheet material
- *2 In case of installing in the bolster inner side.

NC Twin Roll Feeding Machine T Series

Controller options

DS6

Feed direction



- To change the feed direction of the feeder.

FF6

Feed completion output



- To output a signal when the feeder finishes feeding material.

RC6

Remote box



- To remotely controls of 1 Stroke feed, Inching feed, Clamp Open / Close.

MP6

Date bank



- To memorize the feed setting value.
(Up to 20 layers)
Multiple feed is possible by combining memorized layers.

BF6

Feed-during output



- To output a signal when the feed-during.

Feed Performance Table

TJ06				TJ15				T20 / T30			
Feed angle Setting value	150°	180°	210°	Feed angle Setting value	150°	180°	210°	Feed angle Setting value	150°	180°	210°
SPM	Feed length (mm)			SPM	Feed length (mm)			SPM	Feed length (mm)		
200	21	31	45	200	20	31	44	200	14	22	31
180	26	40	56	180	26	39	56	180	18	28	39
160	34	52	73	160	34	51	72	160	24	36	51
140	47	70	97	140	46	69	96	140	32	48	68
120	66	97	136	120	65	96	134	120	45	68	94
100	97	144	200	100	96	142	197	100	68	100	138
80	157	231	318	80	155	228	314	80	109	160	221
60	288	408	528	60	285	403	522	60	200	283	367
40	588	769	949	40	582	760	939	40	409	534	659
20	*999	*999	*999	20	*999	*999	*999	20	*999	*999	*999

* Maximum value of setting



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