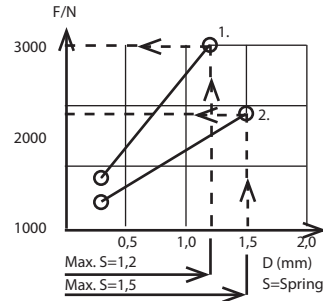
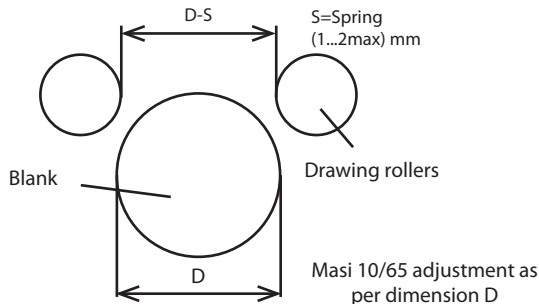
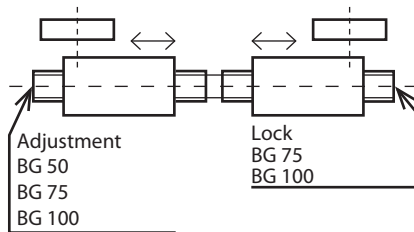
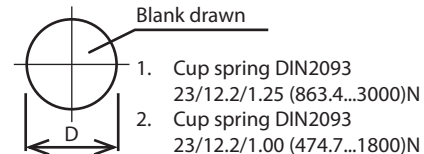


Rod Drawing Machine and a System for Moving the Blank in the NC-Machine Tool

Tool number



Masi 35/110 and
35/150
adjustment as per
dimension D:



Masina-Tuote Oy

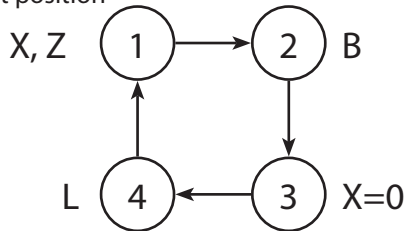
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www.masina-tuote.com

Work Phases:

1. Position of tool X, Z when new length L of the blank is searched for.
2. Tool driven to position 2 with quick movement so that the desired place of the drawing roller width B is above the drawn blank. At this point, the drawing rollers must not be in contact with the blank.
3. With a quick movement, the tool is driven to position X=0. Then the tooth-grooved outer surface of the drawing rollers presses the outer surface of the blank with spring force. The chuck is open.
4. With a quick feeding movement, move the tool in the direction Z for distance L. The chuck is closed.
5. Drive tool to the starting position with quick movement in direction X.
6. Machining process.

Start position



The program part required for the manufacturing of the machined piece concerned with the use of Masi "Number One Tool" with control of Fanuc 0T.

Program Part:

T00 00

G0 X (d + 25 mm) Z - 14

G1 G98 X0 F (3000... 5000)

M17

G1 Z (length of piece)

M18

G0 X (d + 25 mm)

Drawing tool Masi 1 contains the following roller pairs:

(For the diameters of 19 mm ... 68 mm of the blank drawn)

1 pc roller pair blank diameters 10 ... 26 mm.

1 pc " 18 ... 36 mm.

1 pc " 34 ... 51 mm.

1 pc " 49 ... 68 mm.

Drawing tool BG75 (Blank drawn D=(35...110)mm

Drawing tool BG100 (Blank drawn D=(35...150)mm

In production, this tool will soon pay for the purchase costs as the production by piece increases and operating costs decrease.