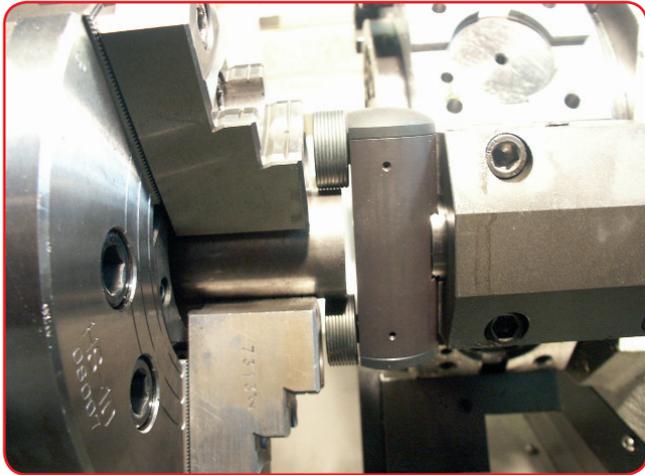
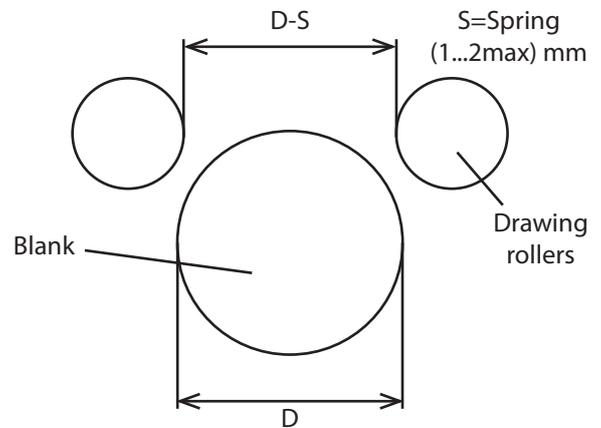


Rod Drawing Machine and a System for Moving the Blank in the NC-Machine Tool



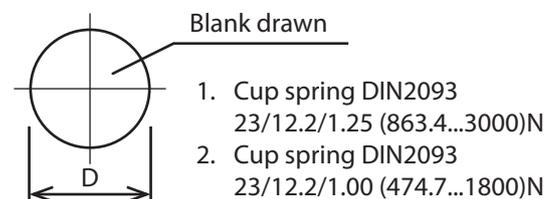
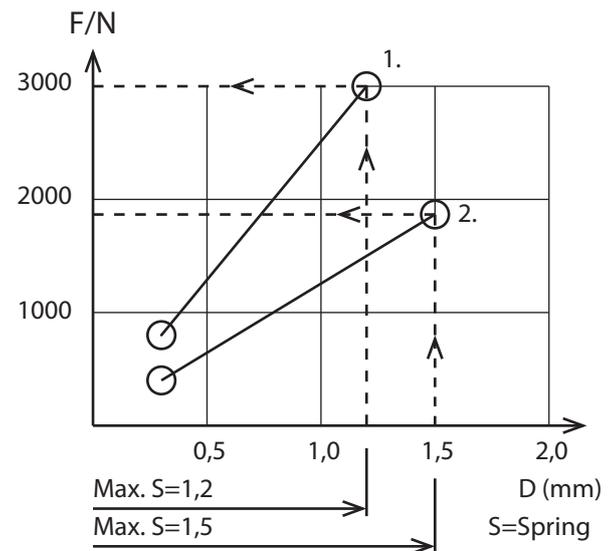
Advantages of the Masi Number One Tool:

1. The structure has a particular impact protection which improves safety and minimises damage costs. This structure in the tool prevents the device or machine from breaking even if the blank head were to collide with the tool body.
2. This tool has no actual wearing points due to its structure and method of use. The moving contact between the tool and the blank occurs in the parallel direction of the brushes drawing the blank and not in the cross-direction.
3. All parts susceptible to even the smallest wear are nitrated. Thus, a surface as resistant to wear and as hard as possible has been obtained. Costs due to use after the purchase are almost non-existent, since by loosening the mounting screw of the drawing rollers, the worn point can be moved aside, and a new point of the rollers can be used in working.
4. The diameter of the tool grip is easy and quick to adjust according to the blank diameter. An extensive range of use:
 1. BG50 10/65 pressing force $F \sim 450\text{N}$
 2. BG75 35/110 pressing force $F \sim 3000\text{N}$
 3. BG100 35/150 pressing force $F \sim 3000\text{N}$
5. Thanks to the tool and the method, moving the blank as required by the new piece is fairly quick, and for its part, maximises the number of products manufactured.
6. When the production is of the nature that rod magazines and feeding devices cannot be employed or are not absolutely necessary, this drawing machine is an excellent solution on the basis of the above mentioned grounds. Expensive working space is also saved!



1. Masi 10/65 adjustment as per dimension D

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



Masina-tuote Oy

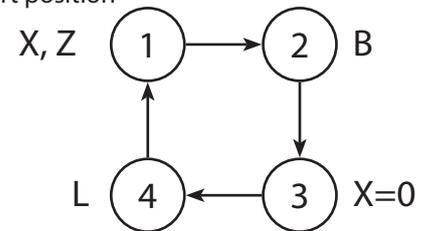
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Work Phases:

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 BG50 contains the following roller pairs:
(For the diameters of 10 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.



d=140mm, weight 175kg (above)

Guarantee 3 years

The hold on the blank ist fast

User Experiences:

During a year and a half, a single Masin Number One Tool 20/65 has been used to draw more than a hundred thousand draws of steel blanks of 45... 50 mm. No problems or operating costs what so ever. The one and same roller pair of the tool is still used in drawing. We have especially positive experience on the gripping force of the Masi 2 and 3. The hold on the blank is fast!

Sami Anttila, a satisfied Managing Director and Masi "Number One Tool" and a model of the pipe blank drawn - now on the table of the MD!
"The best and most efficient thing brought to the tool market in this sector for a long time!"



Sami Anttila
Managing Director

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