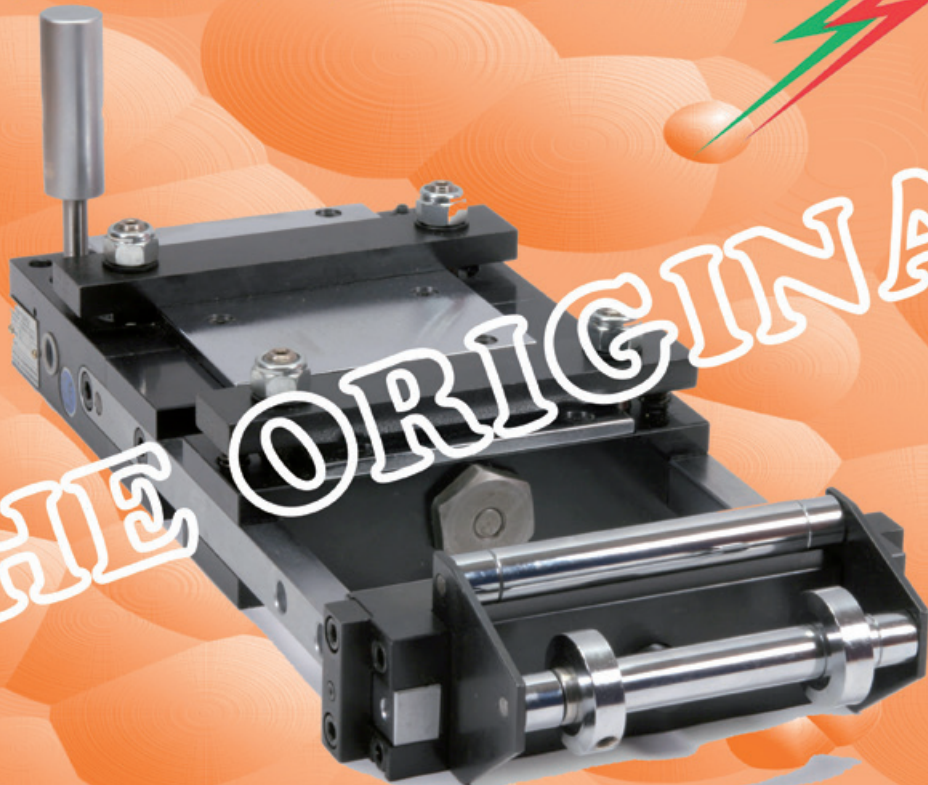




Pneumatic feeders

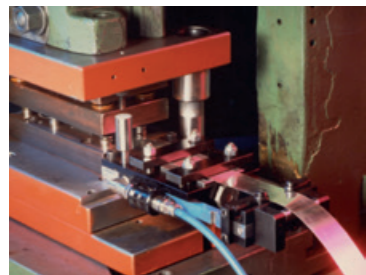
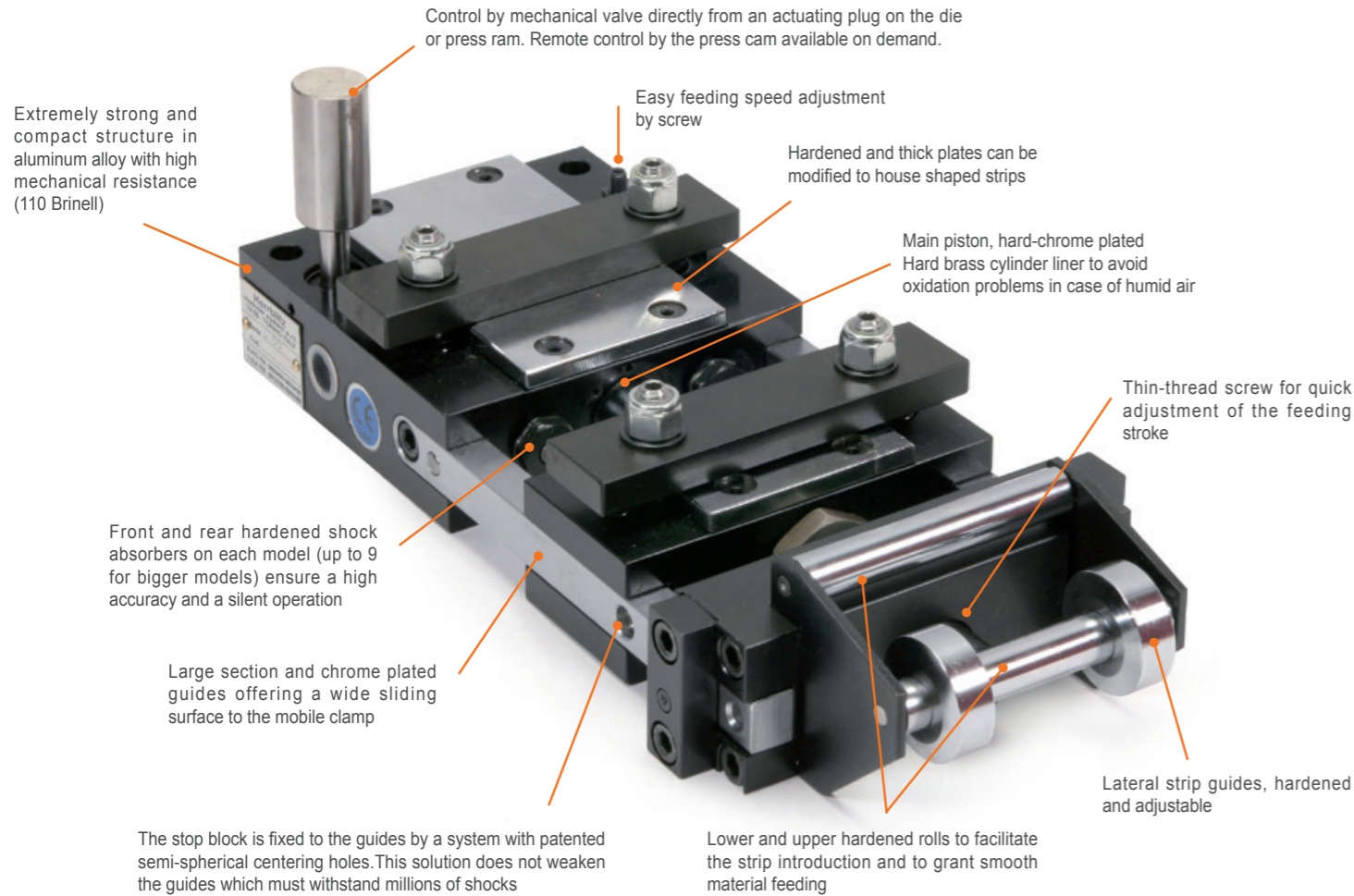
herrblitz[®]

THE ORIGINAL



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Automatization of stamping process

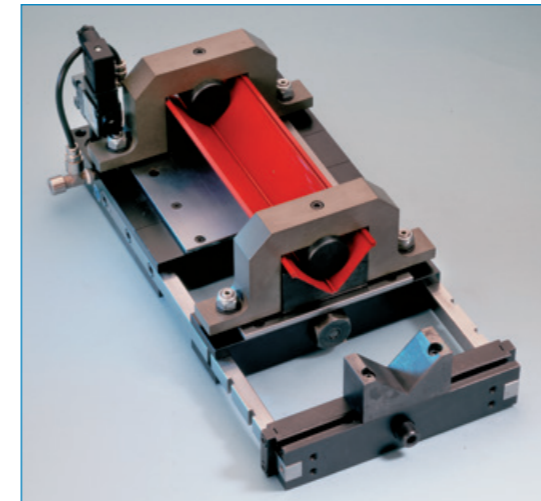


When a company begins to assemble a stamping line, usually the feeder is the last item that they will think about. Their attention is focused on the choice of the press, on the manufacturing of the die set and its perfecting in order to aim to a high quality production. But when it comes the moment to consider how to feed the material, it is very important not to make mistakes and to choose the suitable feeder. Given the complex manufacturing of a die set, it is wrong to try to save money when choosing the feeder. In fact, the productivity rates, the quality of your products and the amount of wasted material will depend on the feeder.

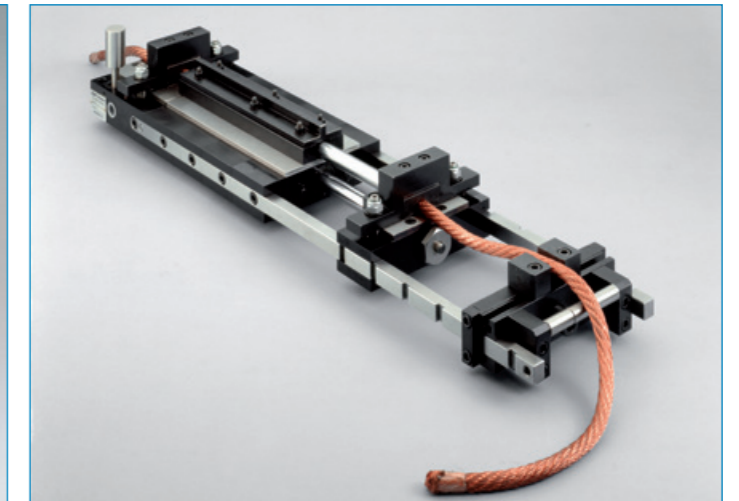
...this is the reason to buy a feeder with the following features:

- **Strong and rigid structure**, but also compact, so that it can be installed as close as possible to the die set. This is a very important feature, especially in case of thin strips and progressive dies. It also helps to save space in the working area.
- **Accurate**, since high quality of the final products demands accuracy, and also to increase the die set durability. Accuracy is granted by the presence of shock absorbers at the end of strokes and also by the great care which is put in the manufacturing of the mechanical parts.
- **Low cost**: low price for the purchase and low expenses during production. Thanks to the simple effect concept, Herrblitz feeders have a 50% reduced air consumption rates than other feeders.
- **Simple** to use and to install: two screws are all that's needed to fix it to the die set or to the press support. You will only need to have a compressed air line for working. Feeders with mechanical actuation don't even need cams on the press: the movement of the die itself actuates the feeder!
- Manufactured to have the **longest durability** and lowest rates of wear, even in presence of humidity in the compressed air. All sliding components are hardened or hard-chrome-plated. Pistons are in stainless steel with high mechanical resistance. The cylinder liners are in hard brass to avoid oxidation problems in presence of humidity in the air. There is no part working in direct contact with the main aluminum body, but rather each part is positioned in suitable housings for easy and quick replacement.
- **Easy maintenance**: Herrblitz feeders are conceived for rapid maintenance. A feeder can be removed from the die, have all gasket replaced and be installed back in line in less than an hour.
- **Customized accessories** for every production need: available for purchase a vast choice of guiding accessories for thin and delicate strips, of accessories for feeding profiles and stamped strips, wires, pipes, and material of every kind.

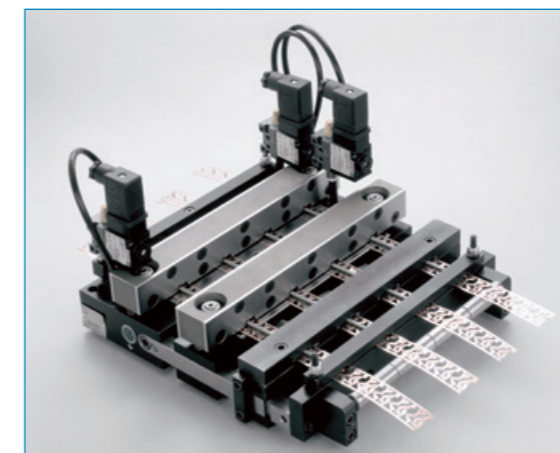
Herrblitz can customize the feeders for every production need!
Do not hesitate to contact us!



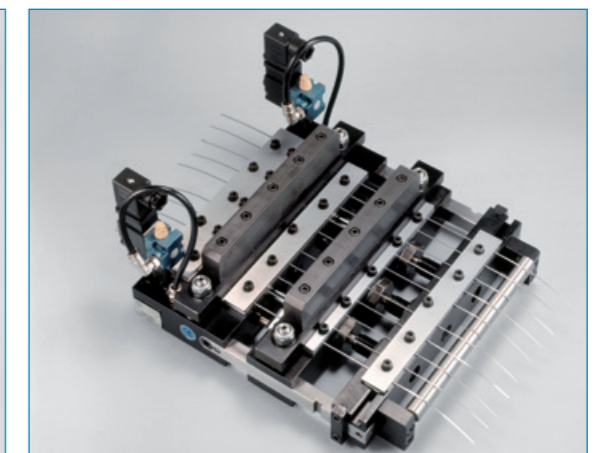
Feeder with shaped clamps for "V-shaped" profiles



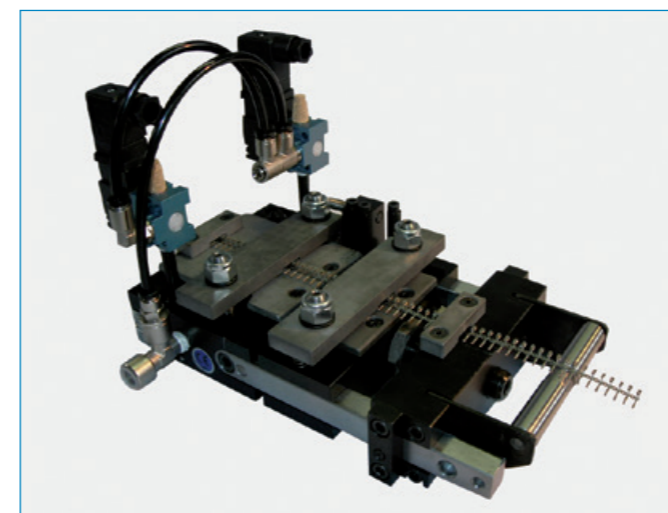
Feeding system for flexible cables



Multi feeding with separate clamping pressure for each strip or wire



Feeding of bicycle chain



Special clamps for shaped strips

When using other feeders, fitted on the press table, the die-to-feeder distance will often cause bending of the workstrip, resulting in feeding inaccuracy, processing problems, or even the damaging of the dies.

In case thin and delicate workstrips are to be processed, the feeders fitted to the press cannot always ensure proper operation.

HERRBLITZ feeders eliminate all such troubles, as they are fitted directly onto the die set.

Because of their very competitive price, it is economical to fit one feeder on each die. In fact you just need to mount the feeder on the die set and adjust the feeding stroke. You only need a few minutes for set up and then you will have automatic units ready for use at all times.

Few minutes for fixing the die set on the press table and no waste of time for feeding stroke adjustments!

SIMPLE INSTALLATION!

Two mounting screws are all that's necessary. The movement of the die actuates the feeder.

Upon request, it is possible to have a remote control from the press cam.

ACCURATE!

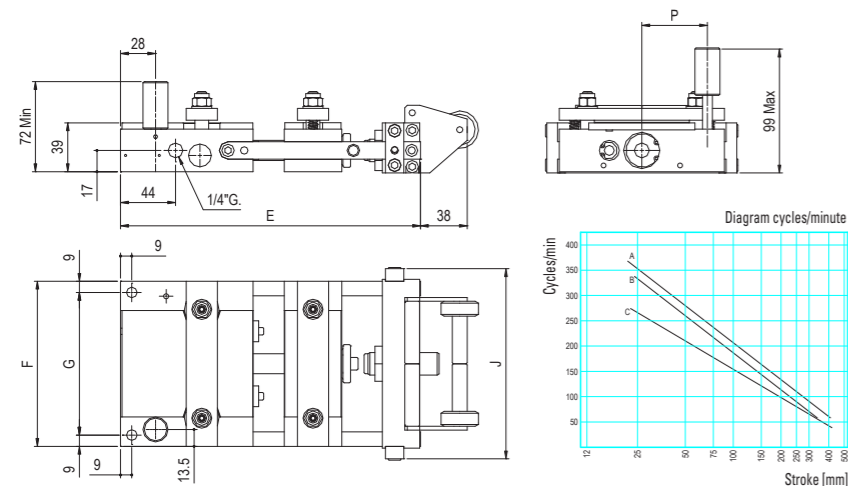
All HERRBLITZ feeders are fitted with pneumatic shock absorbers for maximum feed accuracy, also at high feeding speeds. Functioning with simple effect cylinders reduces the air consumption: consumption rates are 50% less than other feeders.

COMPACT!

No connection outside the feeder is required except for the compressed air line.

HERRBLITZ feeders offer customers four outstanding advantages: **TIME SAVING, SAFETY AND QUALITY IN PRODUCTION, VERY LOW COSTS OF PRODUCTION AND LOW PRICE!**

Normal series, type A-B-C



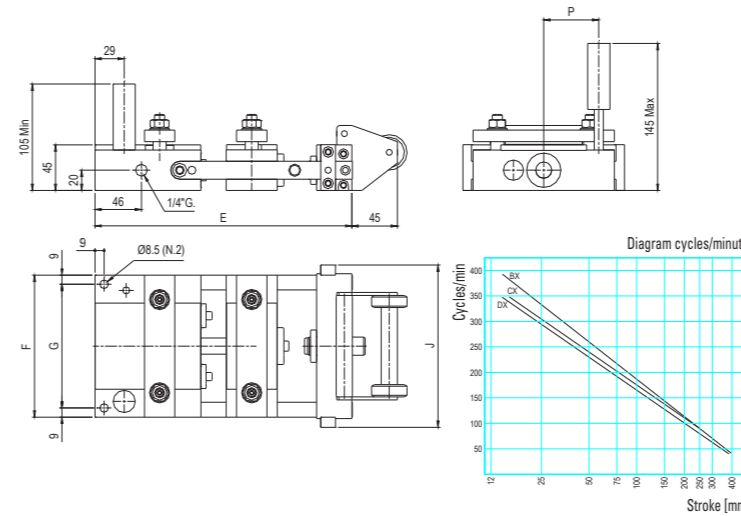
Dimensional characteristics

TYPE	E	F	G	J	P
A 50T	240	107	89	127	40
A 100T	340	107	89	127	40
A 150T	440	107	89	127	40
A 200T	540	107	89	127	40
A 250T	640	107	89	127	40
B 50T	240	132	114	152	52.5
B 100T	340	132	114	152	52.5
B 150T	440	132	114	152	52.5
B 200T	540	132	114	152	52.5
B 250T	640	132	114	152	52.5
C 50T	240	157	139	177	65
C 100T	340	157	139	177	65
C 150T	440	157	139	177	65
C 200T	540	157	139	177	65
C 250T	640	157	139	177	65

Technical features

TYPE	Max. strip width [mm]	Stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamp [kg]	Traction force [kg]	Air consumption [liters/min.]	Weight [kg]
A 50T	50	50	1.30	280	64	120	24	50	3.9
A 100T	50	100	1.30	200	64	120	24	71	4.8
A 150T	50	150	1.20	160	64	120	24	80	5.7
A 200T	50	200	1.10	130	64	120	24	85	6.1
A 250T	50	250	1.00	110	64	120	24	90	7.3
B 50T	75	50	1.30	260	64	120	24	46	4.8
B 100T	75	100	1.30	190	64	120	24	67	5.8
B 150T	75	150	1.20	150	64	120	24	78	6.8
B 200T	75	200	1.10	110	64	120	24	77	7.8
B 250T	75	250	1.00	90	64	120	24	78	8.8
C 50T	100	50	1.30	210	64	120	24	37	5.6
C 100T	100	100	1.30	160	64	120	24	56	6.6
C 150T	100	150	1.20	120	64	120	24	68	7.8
C 200T	100	200	1.10	90	64	120	24	63	9.0
C 250T	100	250	1.00	80	64	120	24	70	10.1

Middle series, type BX-CX-DX



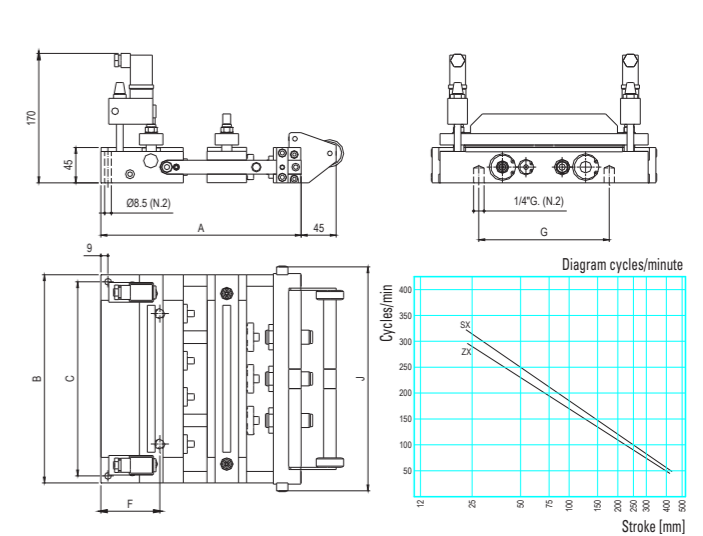
Dimensional characteristics

TYPE	E	F	G	J	P
BX 50	255	140	122	160	54.5
BX 100	355	140	122	160	54.5
BX 150	455	140	122	160	54.5
BX 200	555	140	122	160	54.5
BX 250	655	140	122	160	54.5
CX 50	255	165	147	185	67
CX 100	355	165	147	185	67
CX 150	455	165	147	185	67
CX 200	555	165	147	185	67
CX 250	655	165	147	185	67
DX 50	255	215	197	235	92
DX 100	355	215	197	235	92
DX 150	455	215	197	235	92
DX 200	555	215	197	235	92
DX 250	655	215	197	235	92

Technical features

TYPE	Max. strip width [mm]	Stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamp [kg]	Traction force [kg]	Air consump. [liters/min.]	Weight [kg]
BX 50	75	50	2.00	260	70	158	41	64	6.2
BX 100	75	100	2.00	180	70	158	41	92	7.7
BX 150	75	150	1.80	150	70	158	41	115	9.2
BX 200	75	200	1.60	120	70	158	41	122	10.7
BX 250	75	250	1.50	90	70	158	41	115	12.2
CX 50	100	50	2.00	240	70	158	41	61	7.3
CX 100	100	100	1.80	170	70	158	41	87	8.8
CX 150	100	150	1.70	140	70	158	41	107	10.2
CX 200	100	200	1.60	110	70	158	41	112	11.7
CX 250	100	250	1.50	90	70	158	41	115	13.1
DX 50	150	50	1.60	230	70	158	41	59	9.6
DX 100	150	100	1.40	160	70	158	41	82	11.2
DX 150	150	150	1.20	130	70	158	41	100	12.7
DX 200	150	200	1.00	100	70	158	41	102	14.2
DX 250	150	250	1.00	80	70	158	41	103	15.7

Middle series, two pulling cylinders, type SX-ZX

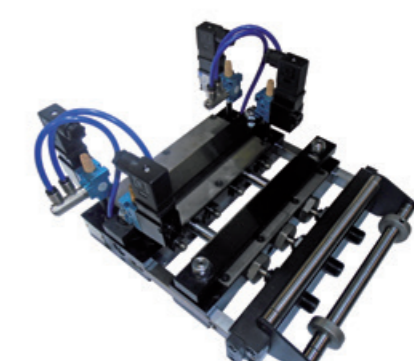


Dimensional characteristics

TYPE	A	B	C	F	G	J
SX 50	255	265	247	75	166	285
SX 100	355	265	247	125	166	285
SX 150	455	265	247	175	166	285
SX 200	555	265	247	225	166	285
SX 250	655	265	247	275	166	285
ZX 50	255	365	347	75	146	385
ZX 100	355	365	347	125	146	385
ZX 150	455	365	347	175	146	385
ZX 200	555	365	347	225	146	385
ZX 250	655	365	347	275	146	385

Technical features

TYPE	Max. strip width [mm]	Stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamp [kg]	Traction force [kg]	Air consump. [liters/min.]	Weight [kg]
SX 50	204	50	1.50	250	70	158	82	127	12.7
SX 100	204	100	1.30	180	70	158	82	180	14.9
SX 150	204	150	1.10	150	70	158	82	215	16.8
SX 200	204	200	1.00	140	70	158	82	250	18.9
SX 250	204	250	1.00	100	70	158	82	255	20.9
ZX 50	304	50	1.10	230	70	158	82	117	18.2
ZX 100	304	100	0.90	160	70	158	82	165	21.2
ZX 150	304	150	0.70	130	70	158	82	198	24.1
ZX 200	304	200	0.50	110	70	158	82	214	27.0
ZX 250	304	250	0.50	90	70	158	82	229	29.8



Heavy-duty series

Extremely strong and compact structure.
High power performances with small space requirement.

Advisable: remote control from the press cam by electric valve or pneumatic valve.
This is a much faster and more versatile control method, very useful in case of long vertical strokes of the press.

PSZ series is predisposed for pilot release. On the V-K series, this function must be required at the moment of the order.

FEEDING ACCURACY

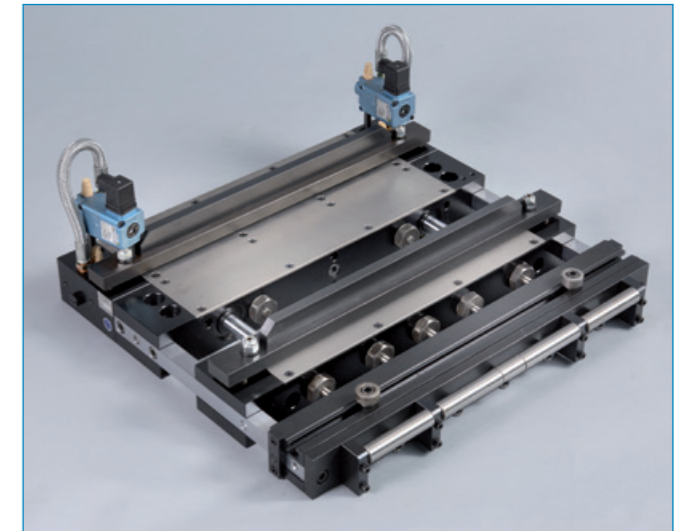
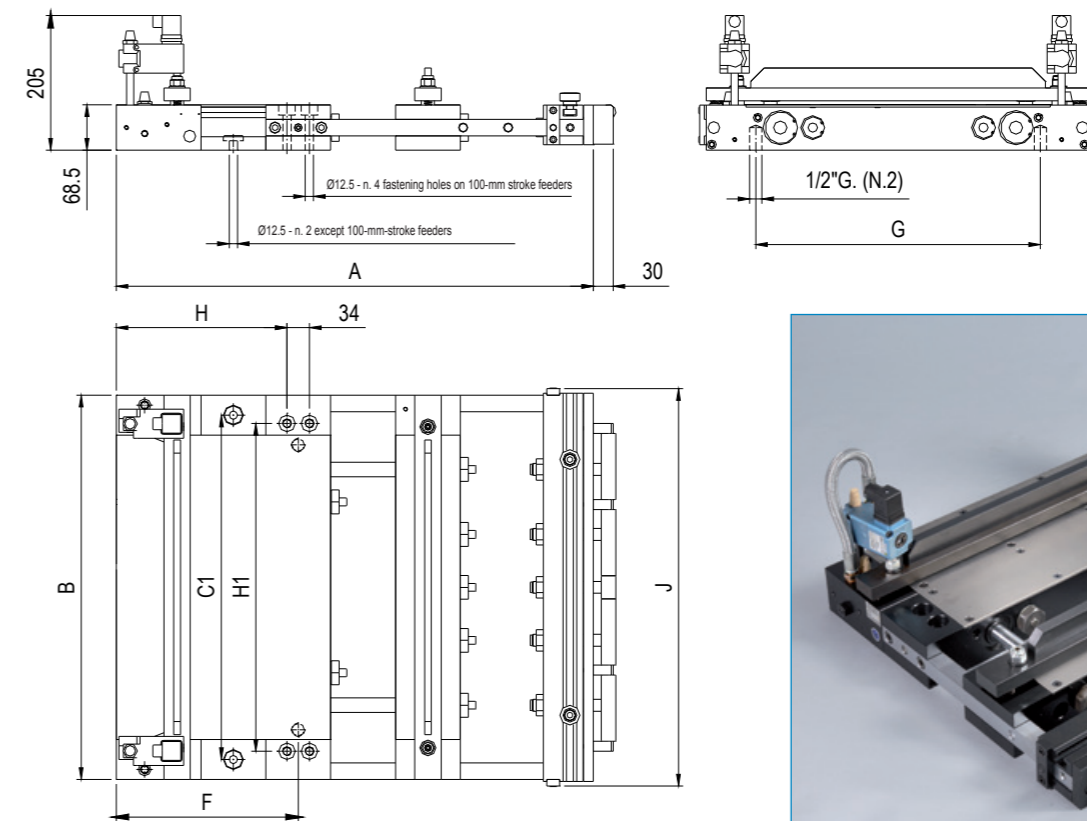
All HERRBLITZ feeders are fitted with pneumatic shock absorbers for maximum feed accuracy, also at high feeding speeds. Functioning with simple effect cylinders reduces the air consumption: consumption rates are 50% less than other feeders.

Available accessories:

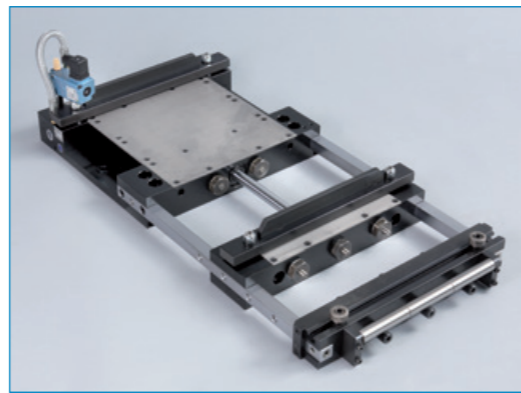
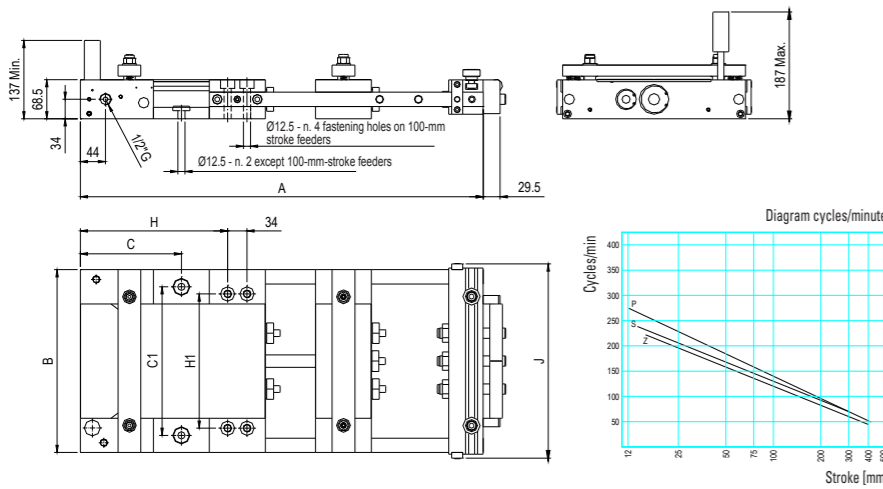
- Complete support body with connection bracket to the press and working height adjustment by handle.
- Upon request: horizontal adjustment to place the feeder as close as possible to the die set.
- On smaller models: connection bracket with working height adjustment by screw.
- Roller conveyor at the strip entrance composed of 5 hardened and adjustable rollers to facilitate the strip introduction.
- Filter-lubricator group with three-way valve for quick air release.
- Quick stroke-adjustment device by handle.



Type V-K, two pulling cylinders

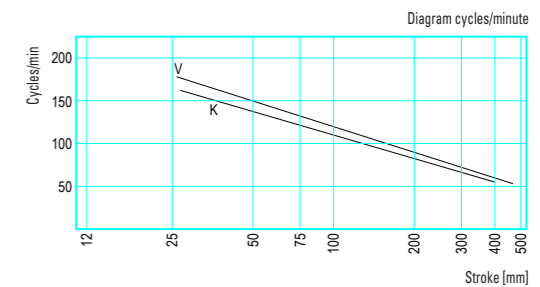


Type P-S-Z



Dimensional characteristics

TYPE	A	B	C	C1	H	H1	F	G	J
V1	523	580	-	-	160	495	177	430	600
V2	721	580	177	520	258	495	275	430	600
V3	919	580	226	520	356	495	373	430	600
V4	1117	580	275	520	454	495	471	430	600
K1	523	730	-	-	160	645	177	580	750
K2	721	730	177	670	258	645	275	580	750
K3	919	730	226	670	356	645	373	580	750
K4	1117	730	275	670	454	645	471	580	750



Dimensional characteristics

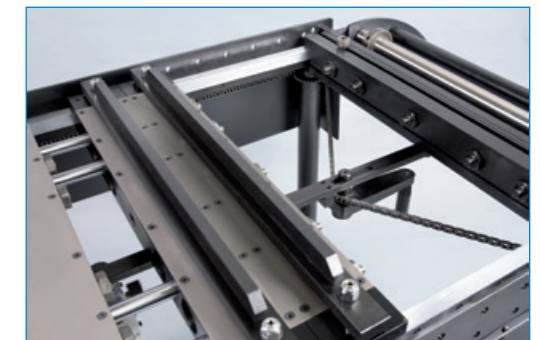
TYPE	A	B	C	C1	H	H1	J
P1	508	270	-	-	160	185	290
P2	706	270	177	210	258	185	290
P3	904	270	226	210	356	185	290
S1	508	320	-	-	160	235	340
S2	706	320	177	260	258	235	340
S3	904	320	226	260	356	235	340
Z1	508	420	-	-	160	335	440
Z2	706	420	177	360	258	335	440
Z3	904	420	226	360	356	335	440

Technical features

TYPE	Max. strip width [mm]	Stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamp [kg]	Traction force [kg]	Air consumption [liters/min.]	Weight [kg]
P1	155	100	3.8	140	280	604	108	184	32
P2	155	200	3.5	120	280	604	108	314	39
P3	155	300	3.0	70	280	604	108	275	46
S1	205	100	3.0	130	280	604	108	170	38
S2	205	200	3.0	110	280	604	108	288	45
S3	205	300	3.0	70	280	604	108	275	54
Z1	305	100	3.0	120	280	604	108	158	48
Z2	305	200	3.0	95	280	604	108	249	58
Z3	305	300	2.5	60	280	604	108	235	69

Technical features

TYPE	Max. strip width [mm]	Stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamp [kg]	Traction force [kg]	Air consumption [liters/min.]	Weight [kg]
V1	460	100	3.0	120	280	604	216	314	101
V2	460	200	2.5	100	280	604	216	500	112
V3	460	300	2.0	80	280	604	216	620	123
V4	460	400	1.8	60	280	604	216	620	134
K1	610	100	2.5	110	280	604	216	288	116
K2	610	200	2.0	95	280	604	216	490	126
K3	610	300	1.8	75	280	604	216	580	139
K4	610	400	1.5	55	280	604	216	586	154



Series Maxi

Extremely strong and compact structure.
High power performances with small space requirement.

Advisable: remote control from the press cam by electric valve or pneumatic valve.
This is a much faster and more versatile control method, very useful in case of long vertical strokes of the press.

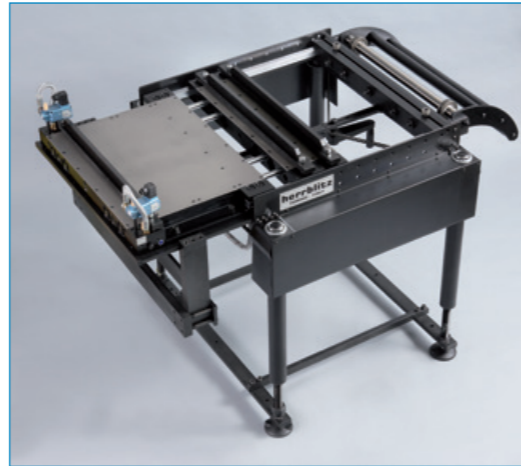
On the Maxi series, the function of pilot release by an additional electric valve must be required at the moment of the order.

FEEDING ACCURACY

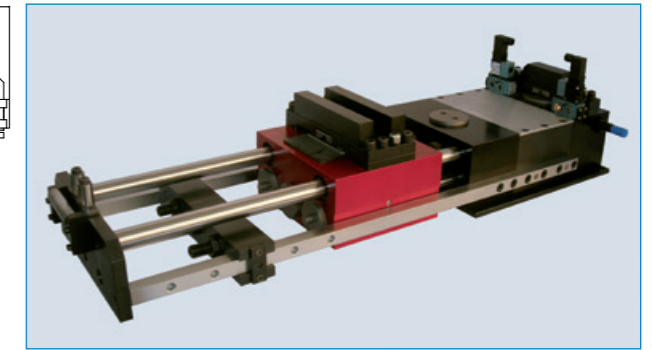
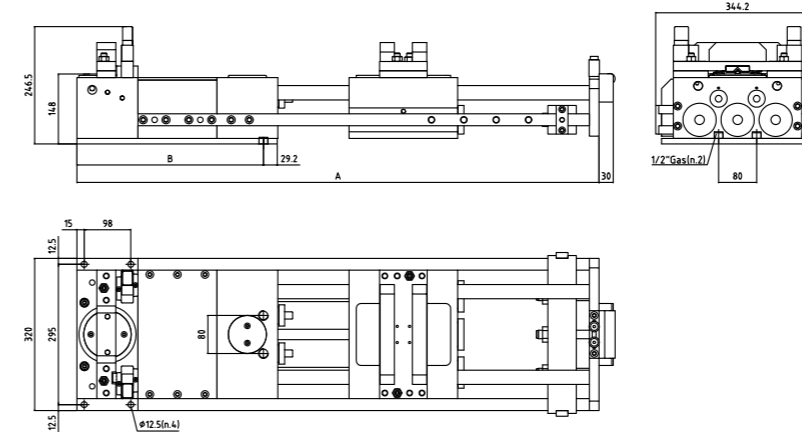
All HERRBLITZ feeders are fitted with pneumatic shock absorbers for maximum feed accuracy, also at high feeding speeds. Functioning with simple effect cylinders reduces the air consumption: consumption rates are 50% less than other feeders.

Available accessories:

- Complete support body with connection bracket to the press and working height adjustment by handle.
- Upon request: horizontal adjustment to place the feeder as close as possible to the die set.
- Roller conveyor at the strip entrance composed of 5 hardened and adjustable rollers to better guide the strip.
- Filter-lubricator group with three-way valve for quick air release.
- Quick stroke-adjustment device by handle.



Type TZF - for narrow strips or wires



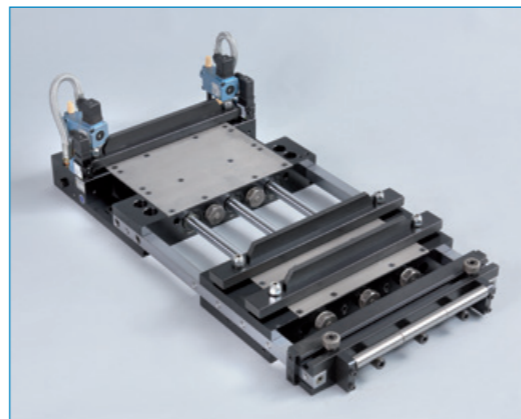
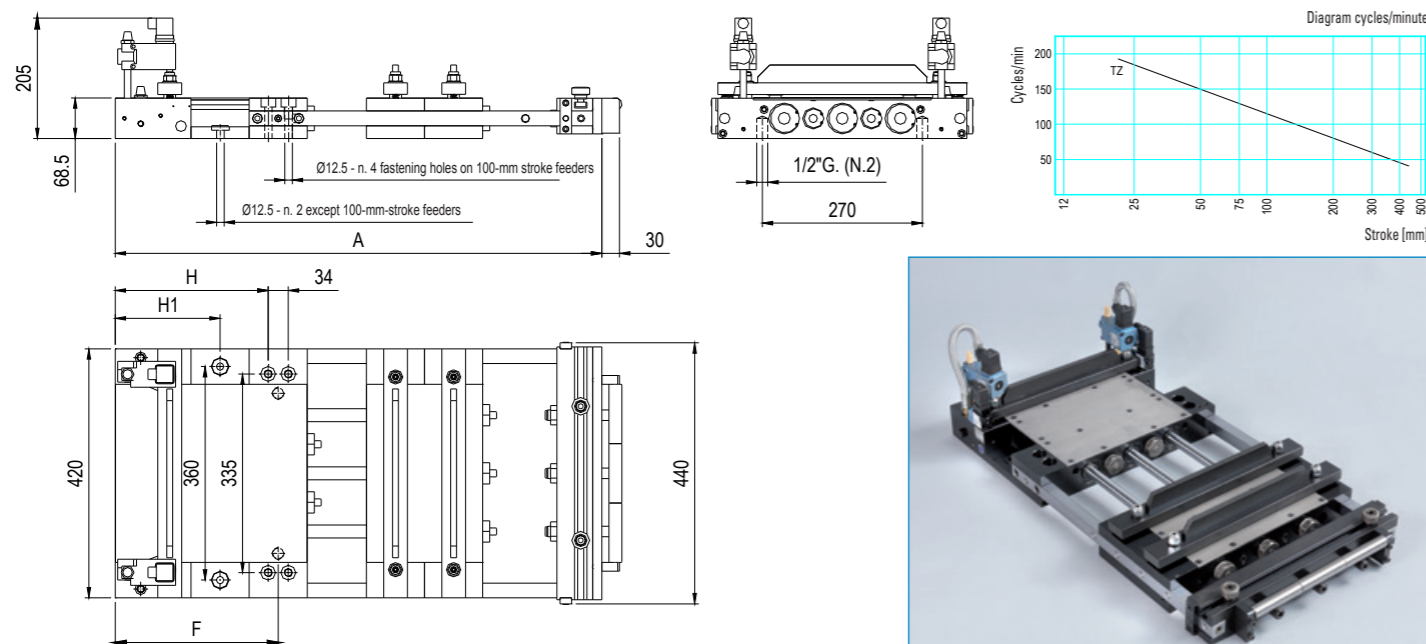
Dimensional characteristics

TYPE	A	B
TZF1	897	391,8
TZF2	897	391,8
TZF3	1097	291,8

Technical features

TYPE	Max. strip width [mm]	Stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamps [kg]	Traction force [kg]	Air consumption [liters/min.]	Weight [kg]
TZF1	50	100	8	110	570	1500	546	700	107
TZF2	50	200	7,5	70	570	1500	546	891	107
TZF3	50	300	7	50	570	1500	546	957	119

Type TZ - three pulling cylinders



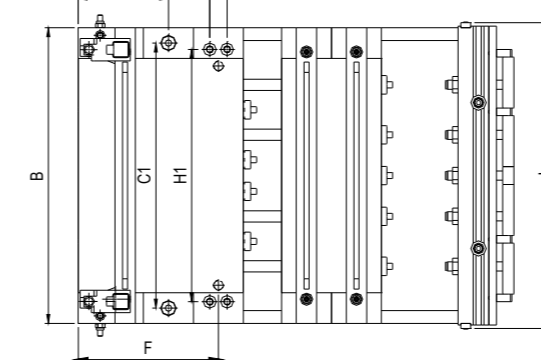
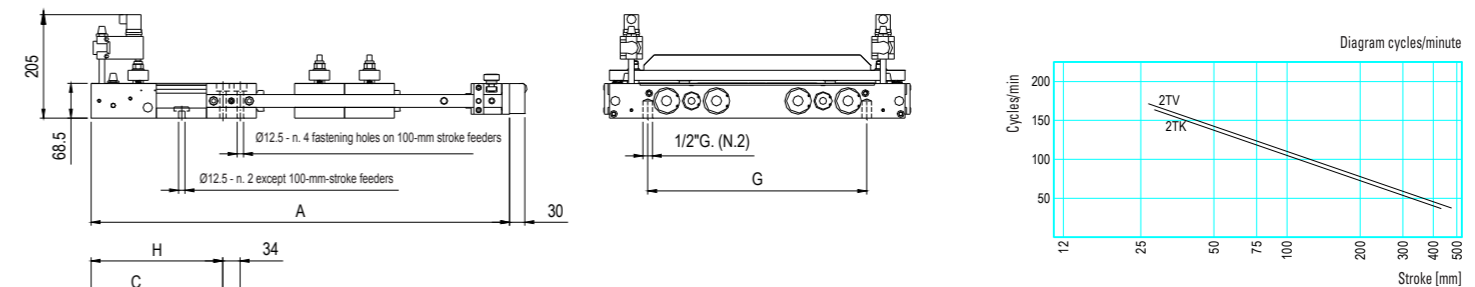
Dimensional characteristics

TYPE	A	H1	H	F
TZ1	623	-	160	177
TZ2	821	177	258	275
TZ3	1019	226	356	373

Technical features

TYPE	Max. strip width [mm]	stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamps [kg]	Traction force [kg]	Air consumption [liters/min.]	Weight [kg]
TZ1	305	100	4.5	115	280	1208	324	450	65
TZ2	305	200	4.0	80	280	1208	324	620	78
TZ3	305	300	3.5	60	280	1208	324	707	91

Type 2TV-2TK - four pulling cylinders

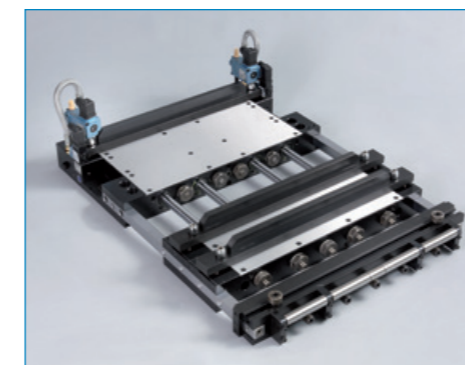


Dimensional characteristics

TYPE	A	B	C	C1	H	H1	F	G	J
2TV1	623	580	-	-	160	495	177	430	600
2TV2	821	580	177	520	258	495	275	430	600
2TV3	1019	580	226	520	356	495	373	430	600
2TV4	1217	580	275	520	454	495	471	430	600
2TK1	623	730	-	-	160	645	177	580	750
2TK2	821	730	177	670	258	645	275	580	750
2TK3	1019	730	226	670	356	645	373	580	750
2TK4	1217	730	275	670	454	645	471	580	750

Technical features

TYPE	Max. strip width [mm]	Stroke [mm]	Strip thickness [mm]	Cycles min.	Pressure of fixed clamp [kg]	Pressure of mobile clamps [kg]	Traction force [kg]	Air consumption [liters/min.]	Weight [kg]
2TV1	460	100	3.5	110	280	1208	430	576	101
2TV2	460	200	3.0	85	280	1208	430	890	112
2TV3	460	300	2.5	65	280	1208	430	1020	123
2TV4	460	400	2.0	40	280	1208	430	838	134
2TK1	610	100	3.0	105	280	1208	430	550	116
2TK2	610	200	2.5	80	280	1208	430	838	126
2TK3	610	300	2.0	60	280	1208	430	943	139
2TK4	610	400	1.5	35	280	1208	430	734	154



A vast choice of accessories available for every feeder model!

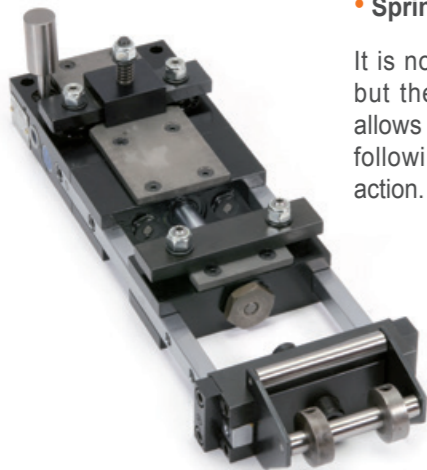
Pilot releasing in case of progressive dies

Pilot release can be done by installing an additional electric valve or pneumatic valve on the feeder body. The feeder must be equipped with remote control from the press cam or from PLC (and this modification must be required at the order).

It is also possible to obtain the strip releasing by:

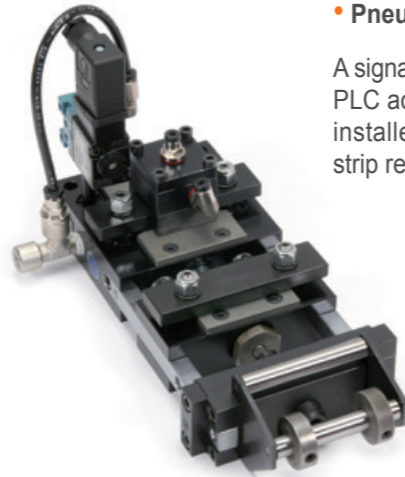
• Spring clamp

It is not a complete opening, but the spring on the clamp allows small slides of the strip following the centering pilots action.



• Pneumoelectric clamp

A signal coming from the press cam or PLC actuates a double effect cylinder installed on this clamp, allowing the strip release.



Feeding of delicate, flexible and/or very narrow strips

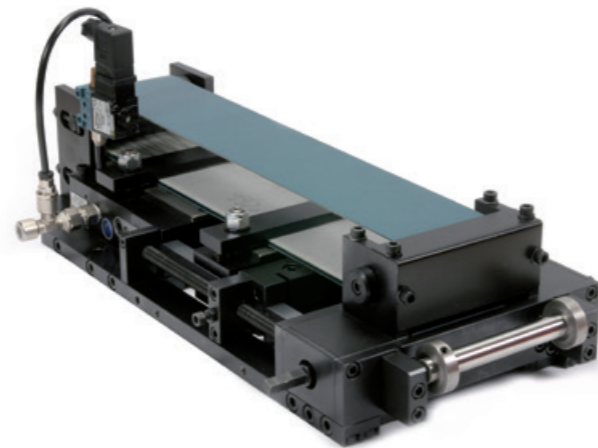
Herrblitz offers many solutions for these needs:

• Thin strips guiding device by two endless belts type 2GNR

To be used not only in case of thin strips, but also to feed delicate material which may be damaged by the clamping operation (for example, lacquered strips, shiny surfaces or stainless steel).

The material never comes in contact with clamps and plates: it is fed thanks to the belts' movement, actuated by the feeder.

On demand, the stroke length adjustment can be made easier and faster thanks to a handle device.

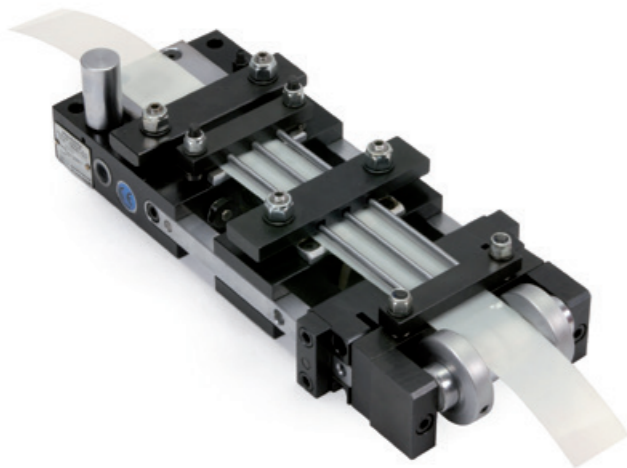


Thin strips guiding device by top and bottom sticks type DGN

Clamps and plates of the feeder will be shaped in order to house guiding sticks.

The strip is fed between two series of sticks which prevent it from waving.

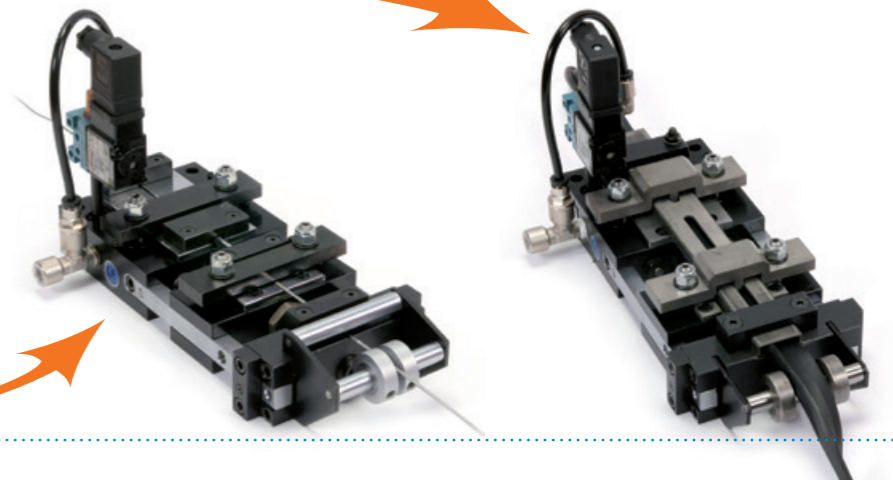
Advantages: with the DGN guiding device you can use the total feeder width.



Guiding device with simple or double "C" guide

The strip is laterally guided during all feeding operation.

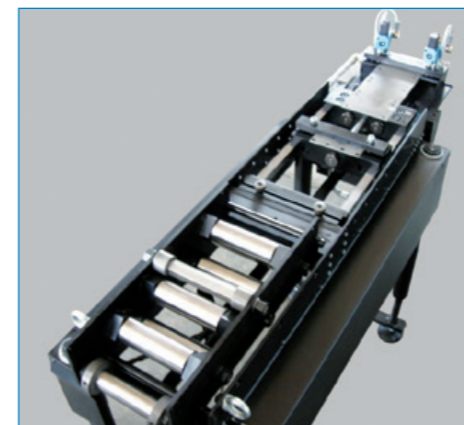
It is possible to transform the sliding plates in a guiding tunnel. For this purpose Herrblitz plates are 10 mm wider than the stated maximum strip width.



Guiding device for narrow and flexible strips or wire by a telescopic tube

The material can not wave because it is housed inside a telescopic tube while it is fed. In case of very narrow strips, the tube will have an elliptical shape.

This accessory is advisable in case of strips not wider than 6 mm.



Non-motorized straightening devices

Some feeder series can be equipped with non-motorized straightening groups composed of 6 rollers in hardened and ground steel (hardness: 61 HRC), fitted in pairs on balancing supports.

The adjustment can be made by handle or by a hexagonal wrench, according to models.

The middle series (BC-CX-DX) mounts a straightening group with rollers diameter 40 mm.

On the heavy-duty series (P-S-Z), we install the straightening group with rollers diameter 54 mm and on the maxi series the straightening group has rollers with diameter 72 mm.

Usually, feeder and straightener are installed on a support base or a support body with working height adjustment by handle.



The solution of feeder with incorporated straightening group saves money and space.

Feeding solutions for bars and sheet metal (not coil)

This system is used when you must perform profiles punching operations, and especially, in case of small stamping productions. In these situations, the customer will prefer to purchase the material in bars and not in coils in order to save money.

In this case it is required to install 2 feeders: one before the press, pushing the material into the tool, and another one at the press exit, to pull out the last part of the material.

The feeding synchronization is always granted since both feeders are equipped with remote control by electric valves, actuated by the same cam on the press.

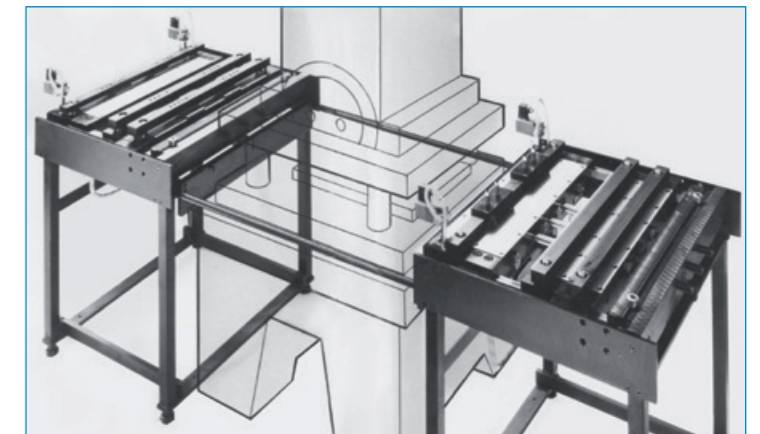
Multistroke counter box

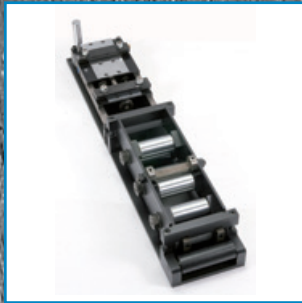
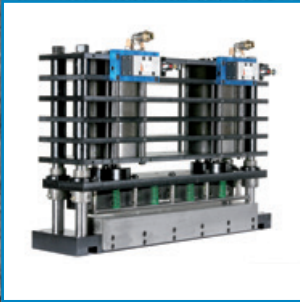


This little and compact electronic box can be installed on all models and allows to repeat the feeding stroke several times for every press cycle. The feeder will control the press descent only after it has made the programmed number of feeding strokes.

Other available functions:

- a programmable piece counter
- an automatic stop of the line when there is no more material





YOUR NEAREST CONTACT

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