

T Series

NC Twin Roll Feeding Machine

Model T20 / T30**Model TJ06 / TJ15****Specifications Note****Cautions for Installation**

1. The supply voltage for NC feeding machines are 3 phase / single phase 200V ($\pm 10\%$)•50/60Hz, and no adjustment is made to adapt to conditions of electricity at each installation site. Note that a transformer to be installed independently is needed to adapt to the supplied voltage at the site where the feeder is going to be installed.
2. English characters and symbols are used to indicate operation panels on the controller.
3. The harmonic content included in the power circuit, which provides servo function, may cause radio hazards to AM radio, etc.
4. Installing a breaker may be required to work with the inverter which is placed at the site where the Feeder is installed.
5. Conformity of the specifications depends on machining system, type of the mold, and conditions of equipment.
6. DIMAC NC Feeder is manufactured on the basis of specifications for domestic (in Japan) use. If the feeder is relocated to overseas or exported, be sure to start operation after safety requirement to observe in the country concerned is confirmed and necessary measures are taken.

* This specification is subject to changes without notice.

The feeder is under warranty in accordance with DIMAC Quality Assurance Provisions as described below.

【1】Warranty

(1) Scope

- 1) If DIMAC genuine parts are found to be faulty under normal conditions of operation described in the Manual due to defects in the material or in the manufacturing process, the parts are supplied free of charge.

(2) Term

- 1) 12 months from the date of shipment.
- 2) 12 months from the date within thirty (30) days of shipment and described in the export declaration, if used overseas.

(3) Method

- 1) Persons are not dispatched to an installed site for repair and service but maintenance products and / or repair parts are provided.

【2】Warranty exclusions

- (1) Cases listed below are excluded from the scope of warranty while in the terms of warranty.
 - 1) Natural disasters such as earthquake, typhoon, flood, and thunder fall, or accidents, fire, etc.
 - 2) Failure or malfunction due to repair, restoration, remodeling, etc. irrelevant to DIMAC.
 - 3) Usage out of the scope described in the specifications and ill or incorrect maintenance.
 - 4) Malfunction and failure due to other equipment connected to the feeder.
 - 5) Defects, corrosion, etc. due to external factor.
 - 6) Malfunction due to aging, wear from usage.
 - 7) Changes to human sense irrelevant to function (operational noises from controller, motor, etc.).
 - 8) Consequential damages to material, product, personal body, etc. due to installing this machine.
- (2) Services below are provided at user's charge.
 - 1) Inspection, maintenance, and cleaning.
 - 2) Replacement of supply parts described in the Manual.

【3】Repair after the term of warranty is expired.

- 1) Repair to the product whose warranty term is expired is provided at user's charge.
- 2) For the case where 13 years have passed since the date of shipment of this product, there might be cases where repair service can't be provided due to stock and procurement conditions of the parts.
- 3) When quality and performance assurance after repair is deemed to be impossible, there might be cases where repair service can't be provided.

▪ Specification

Specification	Unit	T20	T30	TJ06	TJ15
Max. Material width	mm	~200	~300	~70	~150
Max. Material thickness	mm		~3.2	~1.2	~2.3
Max. press follow-up speed	spm			~200	
Feeding system			Roll system by servo motor		
Acceleration adjustment			Automatic calculation (by press speed and feeding angles)		
Max. press shoot count	mm		~999		
Max. feed length	mm		~999.99		
Feed length setting unit	mm		0.01		
Discharge length setting unit	mm			~999 (Setting in 1 mm increments)	
Roll pressure system			Spring pressure		
Roll pressure range	*1 N	~1716		~784	~1470
Release system		Air cylinder		Air diaphragm cylinder	
Steel coil material wid.* thick.	mm	50×3.2 200×1.6	50×3.2 300×1.6	70×1.2	60×2.3 150×1.6
Approximate material dimensions					
Steel sheet material wid.* thick.*2	mm	200×3.2	300×3.2	70×1.2	120×2.3 150×1.6
Max. Feeding material weight	kg	15		3	10
Slid adjustment length	*3 mm	160		130	
Min. passline height	*3 mm	118		83	103
Press frame gap length	*3 mm	210	260	115	170
Power supply voltage			3-phase / single phase 200V (±10%)·50/60Hz		
Weight feeder side (With controller)	kg	48	56	15	25
Weight pull side	kg	46	54	11	23
Protection circuit	Standard	1. 2circuit emergency stop output			
		2. Abnormal stop output			
		3. Continuous operation stop output			
		4. Self-diagnosis / Abnormal stop			
		5. Overload prevention stop			
		6. Emergency stop input circuit			
Controller model	Option	1. Work shortage sensor *4			
			450C		

*1 When maximum thickness. *2 It may vary depending on material stress and surface roughness. *3 In case of installing in the bolster inner side.

*4 Applicable only in coil mode, single mode. In the sheet mode, it is used as a standard as a cycle stop output.

▪ Performance table

T20 / T30

Press Speed	Feed Angle		
	150°	180°	210°
SPM/Cons.		Unit(mm)	
200	14	22	31
180	18	28	39
160	24	36	51
140	32	48	68
120	45	68	94
100	68	100	138
80	109	160	221
60	200	283	367
40	409	534	659

Max. feed length by the feed angle and rotation speed (mm)

Note: It may be impossible to finish workpiece feeding at the angle as specified on the feed performance table if the feeder is under a load resulting from material stress, etc.

TJ06

Press Speed	Feed Angle		
	150°	180°	210°
SPM/Cons.		Unit(mm)	
200	21	31	45
180	26	40	56
160	34	52	73
140	47	70	97
120	66	97	136
100	97	144	200
80	157	231	318
60	288	408	528
40	588	769	949

TJ15

Press Speed	Feed Angle		
	150°	180°	210°
SPM/Cons.		Unit(mm)	
200	20	31	44
180	26	39	56
160	34	51	72
140	46	69	96
120	65	96	134
100	96	142	197
80	155	228	314
60	285	403	522
40	582	760	939

▪ Standard product and accessories

• Electrical cable 1set-8m×1
• Mounting bracket for machining unit *1
• Slide plate *1
• Foot switch *2
• Air regulator
• Terminal, Mark tube
• Instruction manual

*1 Left and right common

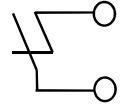
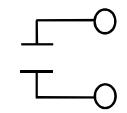
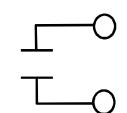
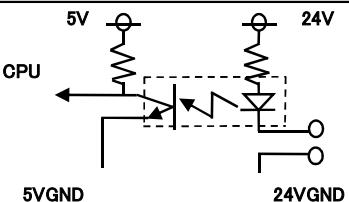
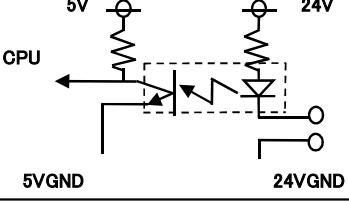
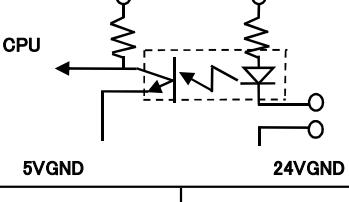
*2 For material grabbing after the second time in sheet mode.

▪ Option

• Work shortage sensor
• DS6 / Feed direction change
• BS6 / Feed-during output
• FF6 / Feed complete output
• MP6 / Data bank
• TC6 / Feed conditions measurement
• RC6A / Remote box

*There are other options as well.

▪ Requirements for installing press

Press	T20	T30	TJ06	TJ15
Power supply voltage		3-phase / single phase 200V ($\pm 10\%$) \cdot 50/60Hz		
Rated power consumption	1600W		600W	1600W
Emergency stop switch input 2-systems support	Emergency stop signal output This signal output directly from the emergency stop switch 1 A at 250 VAC or less 1 A at 30 VDC or less			
Abnormal stop input	Abnormal stop output 1 A at 250 VAC or less 1 A at 30 VDC or less	Output at open		
Continuous operation stop input	Continuous operation stop output 1 A at 250 VAC or less 1 A at 30 VDC or less	Output at open		
Emergency stop output Open collector output or Contact output	Emergency stop input circuit 0.01 A at 24 VDC			
Press continuous operation output Open collector output or Contact output	Press process input circuit 0.01 A at 24 VDC			
Synchronizing signal output 2-Open corrector output or 2-Contact output	Feeder synchronization signal input circuit Feed signal input circuit Release signal input circuits			
Air source spm200 ℥/min.	0.4~0.5MPa (0.5MPa)	5.0	1.27	2.60

⟨Option⟩

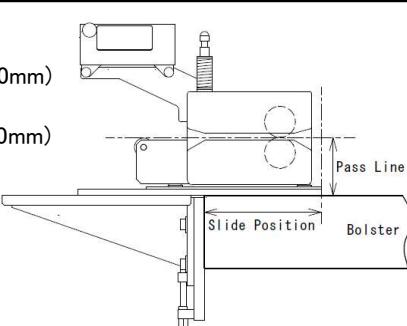
Press	T20	T30	TJ06	TJ15
Work shortage sensor input circuit	Work shortage sensor output circuit *			

* Applicable only in coil mode, single mode. In the sheet mode, it is used as a standard as a cycle stop output.

▪ Setting position : In case of installing in the bolster inner side.

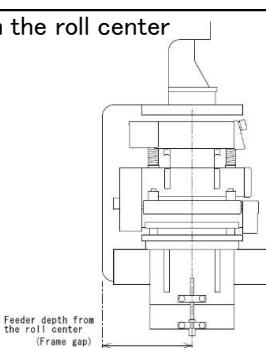
▪ Max. slide position length

T20 / T30 : 240mm
(Slide adjustment amount : 160mm)
TJ06 / TJ15 : 120mm
(Slide adjustment amount : 130mm)



▪ Feeder depth from the roll center

(Frame gap)
T20 : 210mm
T30 : 260mm
TJ06 : 115mm
TJ15 : 170mm

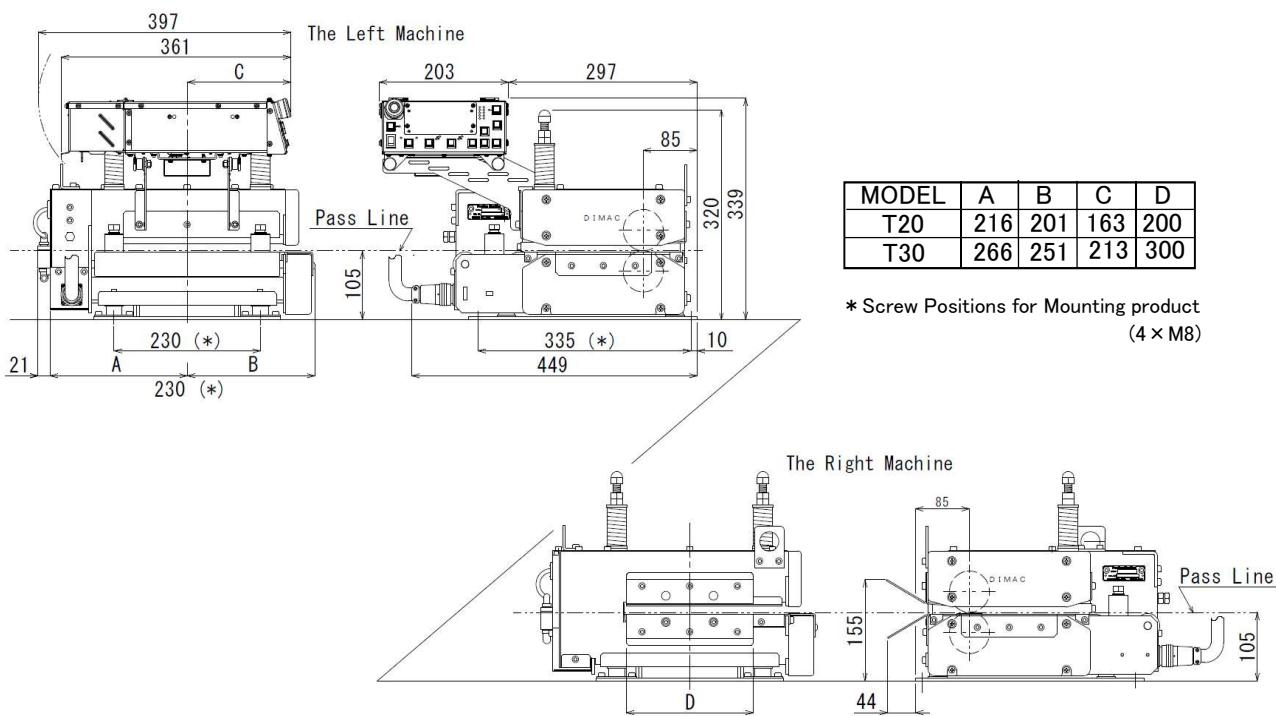


▪ Min. pass line height

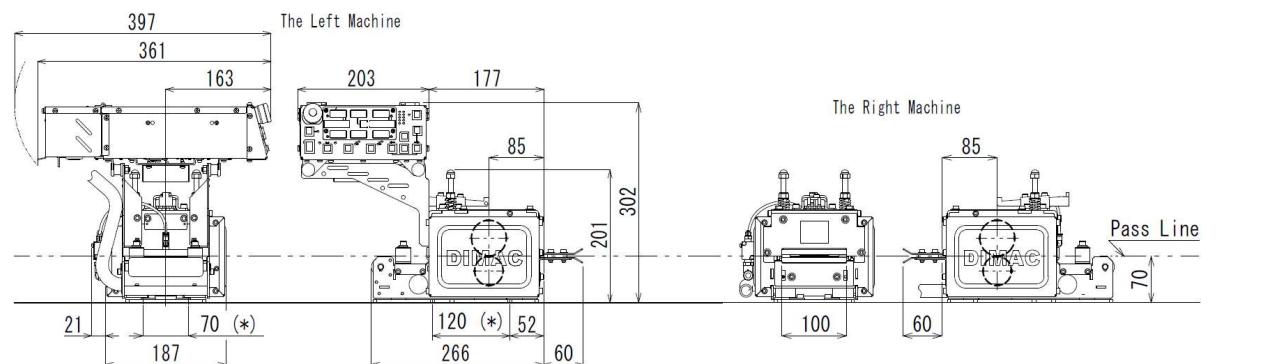
T20 / T30 : 118mm
TJ06 : 83mm
TJ15 : 103mm

•Figure of dimension

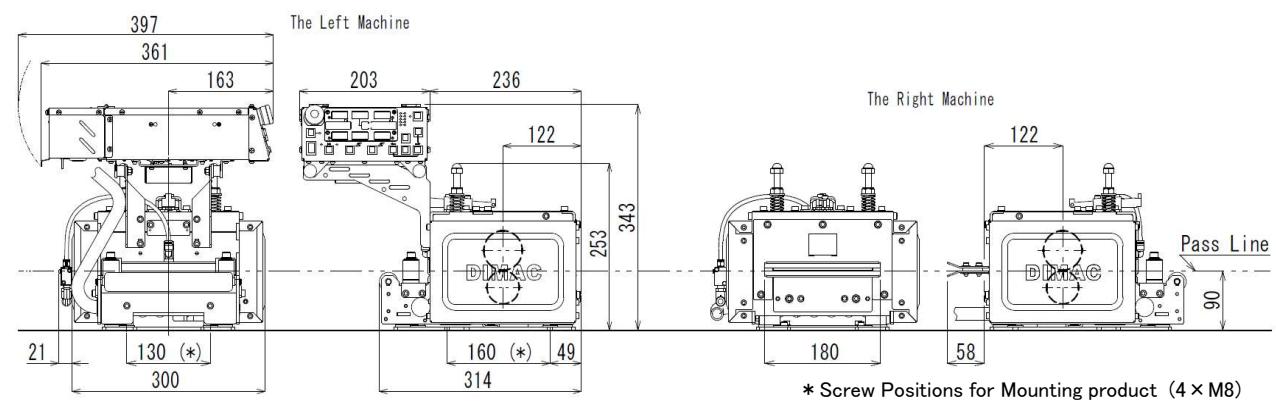
T20 / T30



TJ06



TJ15



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