

DIMAC

RF-A Series

RF06A / RF15A / RF25A

RF20A / RF30A / RF50A

NC Roll Feeder

Instruction Manual

Description of display

Setting input procedure

Mechanical adjustment
Roll opening adjustment

Material charging and guide roller adjustment
Speed adjustment and material pressurization adjustment

<Performance curve diagram>
RF06A

<Performance curve diagram>
RF15A, 25A

<Performance curve diagram>
RF20A, 30A, 50A

Cam signal setting

Use of hazardous chemical substance

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<http://www.dimac.co.jp>

* This is the Instruction manual to be read before use.

* Be sure to read the separate "Safety standard manual in operation" together with "Instruction manual" before use for proper operation.

■ Contact of the manufacturer ■

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Display when power is turned on

Warning

Display: 444444
 Cancel the emergency stop switch(Display: 555555).
 Turn off power switch (supply).
 Turn on the power switch.

Run status

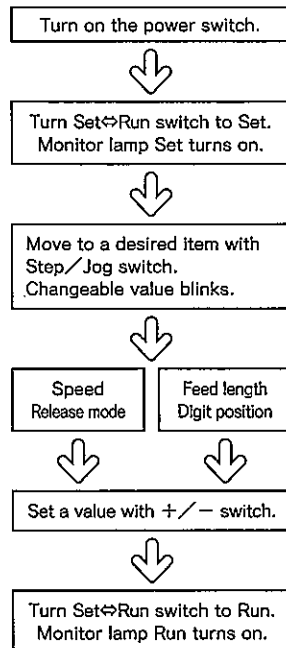
Display position	Display condition	Description
Feed length		
444444	Blinking	RF emergency stop switch is on.
555555	Blinking	Emergency stop switch cancelled Resetting: RF power off/on
888888	Blinking	Roll opened. Resetting: Turn the clamp switch to CL.
Feed length setting display	One digit blinking	Set⇔Run switch is set.
	All blinking	Automatic feed is off.
	Left end blinking	Continuous input of feed signal Or, release signal is missing.
	Right end blinking	Continuous input of release signal Or feed signal is missing.
666666	Blinking	Feed interference error displayed. Resetting: Resetting switch
777777	Blinking	Stop because material is out. Resetting: Resetting switch
111111	Blinking	Stop signal output from outside (such as a press) Or short-circuit error
Release mode	Off Blinking	Automatic release is off. Set⇔Run switch is set.
Speed %	Blinking	Set⇔Run switch is set.

*When display is duplicated, display blinks on and off in turn.

Monitor lamp

Error	Blinking	Error is displayed in feed length position.
Set	On.	Numeric setting can be changed.
Run	Blinking On.	Standard operation incomplete. Standard operation active.
Feed	On.	Feed signal input.
Release	On.	Release signal input.

Value setting procedure



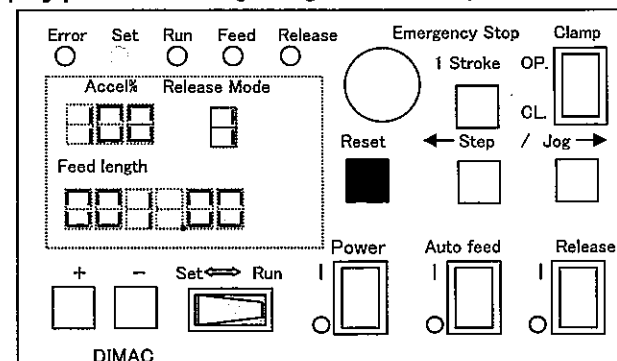
Warning

When error is displayed, it is not allowed to change setting.

Caution

If a value is continue to be changed, move item with Step/Jog switch.

Display panel When setting is changed: Set monitor lamp turns on and changeable value blinks.



Mechanical adjustment

Adjust roll opening.



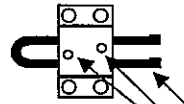
Request

Roll opening must be made small depending on the thickness of material.

RF06A, 15A, 25A

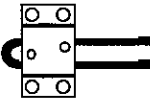
Roll opening adjusting position

Top view

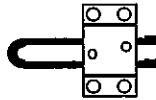


Loosen the lock bolt at two positions and move the adjusting plate.

Roll opening small

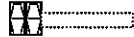


Roll opening large

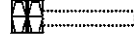


RF20A, 30A, 50A

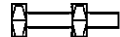
Roll opening adjusting bolt



Roll opening large



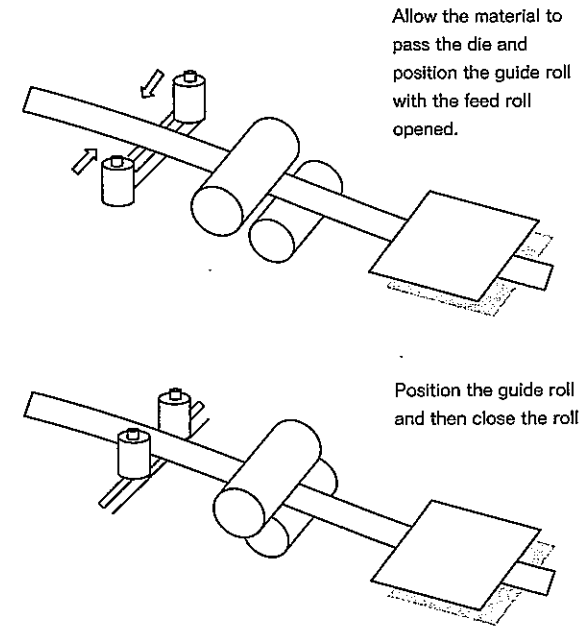
Roll opening small



Lock nut

Mechanical adjustment

Material charging and guide roller adjusting



Allow the material to pass the die and position the guide roll with the feed roll opened.

Position the guide roll and then close the roll.

Speed adjustment and material pressure application adjustment

Speed and material pressure application must be adjusted in conformance with press rotating speed.

Set the speed with reference to the feed length curve diagram.

Adjust the roll pressure application spring of the machine body for pressure applied to material.



Caution

Apply equal pressure on the right and left in principle.

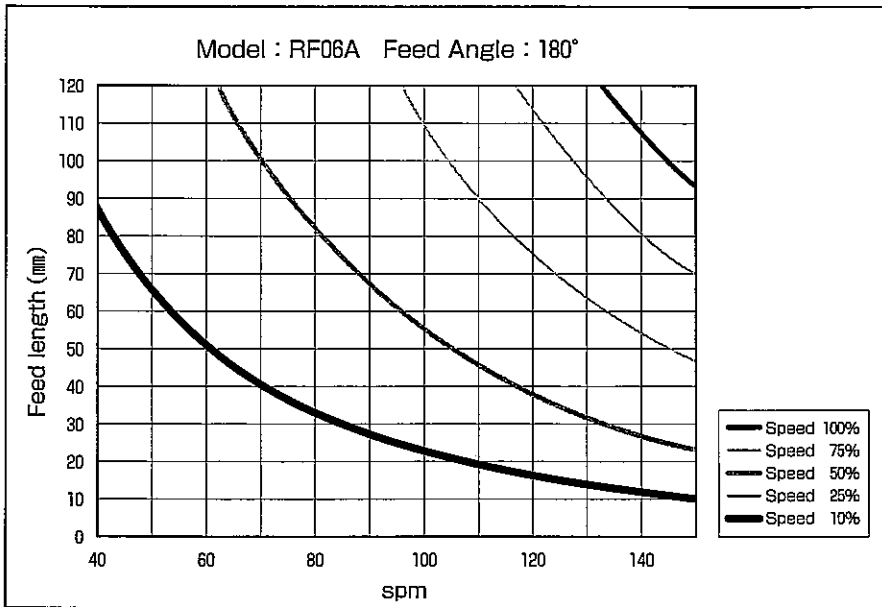


Warning

Be sure to fix the loosened bolt, nut, etc after completion of adjustment for mechanical adjustment.

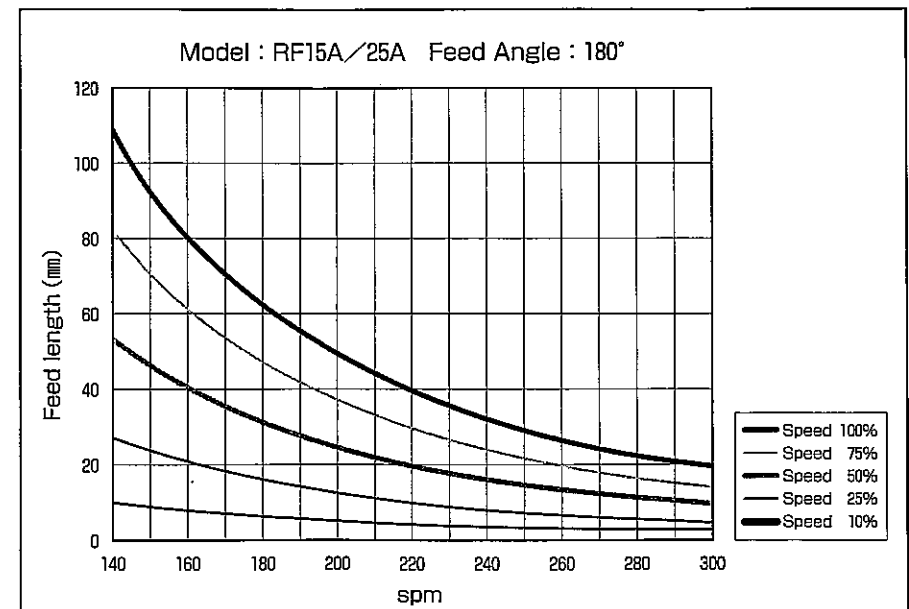
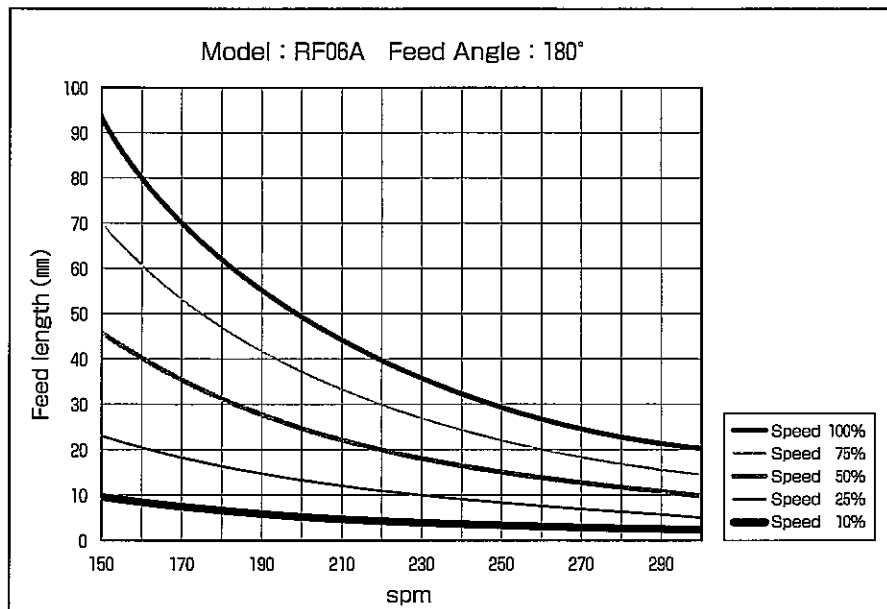
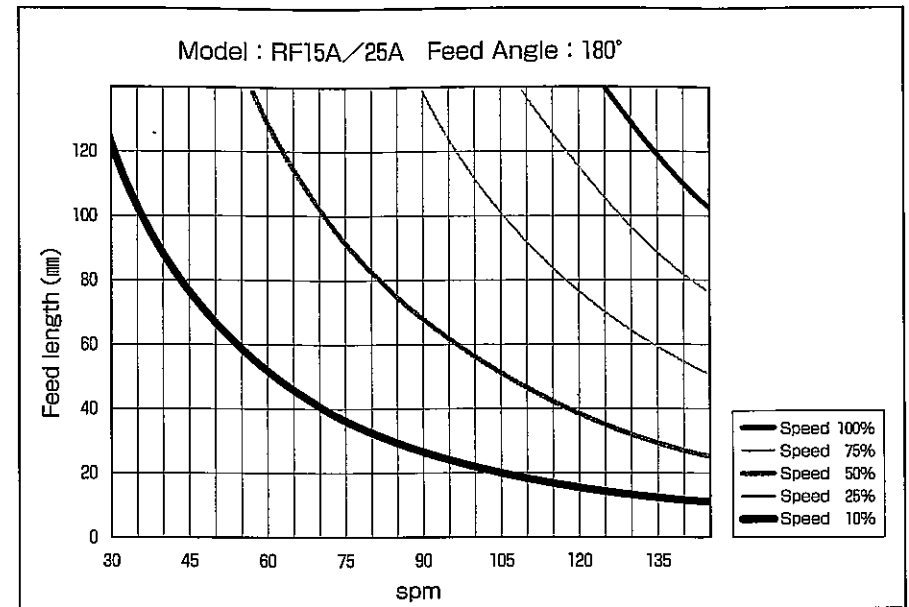
Speed and feed length curve diagram

RF06A



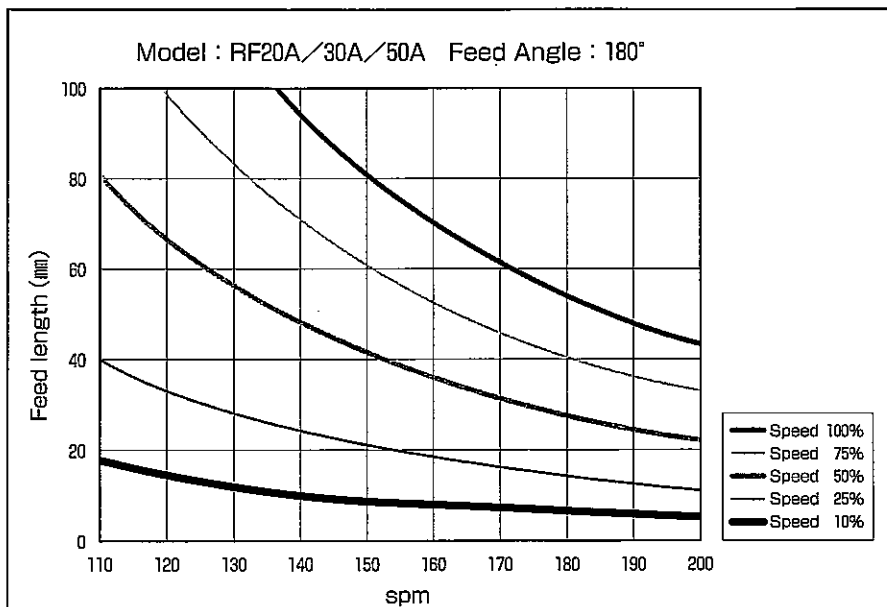
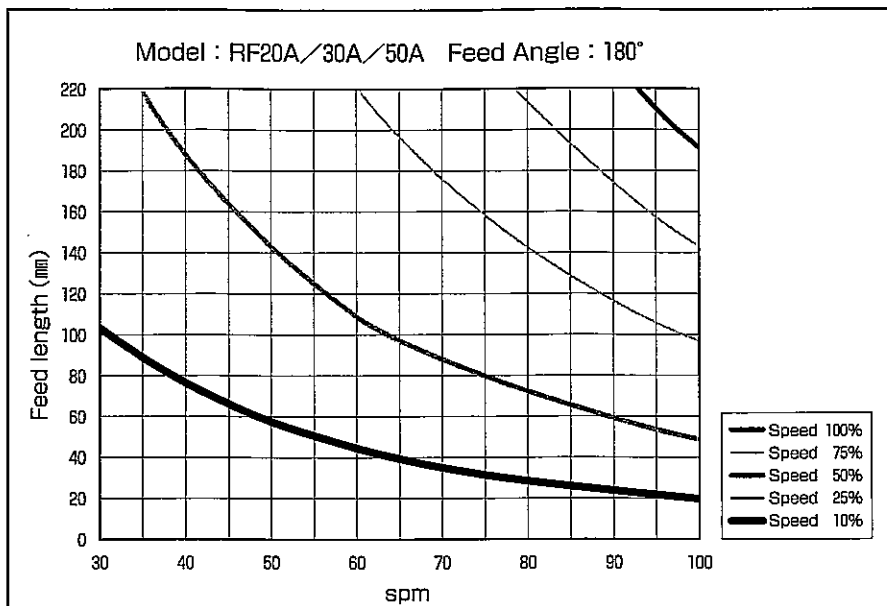
Speed and feed length curve diagram

RF15A/25A



Speed and feed length curve diagram

RF20A/30A/50A



Press cam signal setting

1. Feed setting Ex: When you want to start feed at 270 degrees.

Press angle	Press cam SW	Panel display	Roll feeder
240°	 ON Signal input	Feed <input type="radio"/> Release <input type="radio"/> ON	Setup
270°	 OFF	Feed <input type="radio"/> Release <input type="radio"/> OFF	Feed is started.

Caution
When feed cam signal is input, interlock is activated.

Request
Turn off the angle where feeding is to be started. Approx 30 degrees is required for ON angle.

2. Release setting

Release mode setting: Release system can be chosen by release mode setting value.

Release mode

0	Release OFF	Release is disabled irrespective of signal
1	Matching with cam	Opens when press cam signal is on, and
2~9	Setting count Release time	2 ~ 3, 4, 5, 6, 7, 8, ~ 9 0.015 Proportional in unit 0.005

Example

Release mode	Press angle	Press cam SW	Panel display	Roll feeder
0	120°	 ON	Feed <input type="radio"/> Release <input type="radio"/> on	Release is disabled irrespective of
1	120°	 ON	Feed <input type="radio"/> Release <input type="radio"/> on	Release is started.
	200°	 OFF	Feed <input type="radio"/> Release <input type="radio"/> Off	Release is ended.
2~9 Select Example:6	120°	 ON	Feed <input type="radio"/> Release <input type="radio"/> on	Terminated in 0.035 sec irrespective of OFF signal.

Caution
Timer termination irrespective of OFF signal.

Caution
Air is used for releasing, and release operation is delayed by the time for actuation of air.

Performance curve diagram) RF20A / 30A / 50A

Cam signal setting