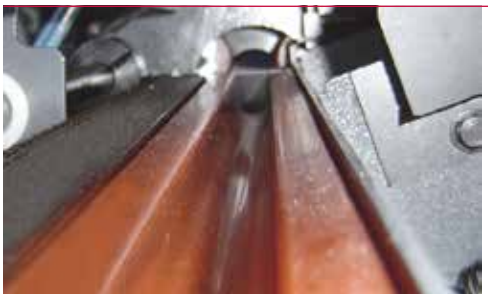
GT 326-E BARFEED

AUTOMATIC MAGAZINE BAR FEEDER FOR
SLIDING HEADSTOCK LATHES

Diameter range: .118" to .787" (3 mm - 20 mm)
1.02" (26 mm) max with
bar preparation

Bar length: 3.25' to 12'3"

YOUR "ONE-STOP-SHOP"
FOR MACHINE-TOOL PERIPHERALS



Guiding Your Productivity

The LNS economical solution to automatically load small diameter bar stock into sliding headstock lathes. The GT 326-E is designed to withstand production processes running at optimum RPMs. High guiding quality, low noise and effective vibration-dampening are guaranteed through molded polyurethane guiding channels. The GT 326-E is a highly productive and price-competitive automatic bar feeding system for bar stock diameters from 1/8" to 1.02" (3mm – 26mm). The GT 326-E will also accommodate fixed headstock lathes.

Easy to Use Remote Control (HMI)

The operator-friendly HMI ensures the interaction between the bar feeder and the lathe, and therefore the production process can be run safely and efficiently.

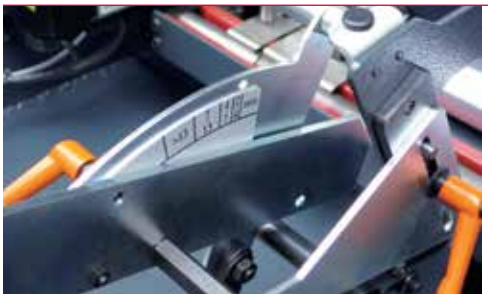
The HMI is ultra light featuring easy set up and operation. It displays alarm description, alarm history of operation errors and position tracking (inch/metric programming).

Easy setup in less than 1 minute. The operator simply inputs bar information into the remote control:

- Shape
- Diameter
- Feed out length

This automatically sets:

- Pushing torque
- Forward speed
- Feeding length



Quick Changeover Simplicity

Changeover of bar diameter on magazine tray is performed by a simple manual adjustment via the changeover gauge, no tool required. A four position scale allows you to visually see where your new adjustment is aligned for accuracy and quick selection.

- 2 minutes set up for partial changeover
- 8 minutes or less for complete changeover

Optimum Guiding

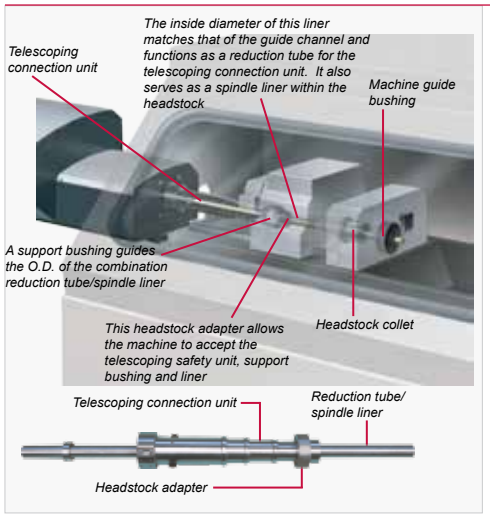
The guiding channels made of molded polyurethane are the essential elements for achieving optimum performance. They have to withstand the highest physical stresses.

The GT 326-E guide channel housing is a solid steel structure to dampen vibrations during production processes. Combined with the servo-controlled drive, the barstock is accurately and safely managed through the entire machining process.

The quick change guiding elements are secured by locating pins, enhancing stability. For complete diameter changeover, the elements can be replaced quickly and easily without tools. The pusher can be simply released by unlocking the quick turn hand levers.

Powerful Self-Centering Vise for Bar Extraction and Insertion

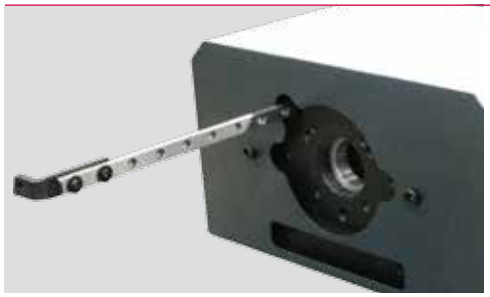
Strong design of the cylinder intensifies the vise to clamp bar stock, ensuring a high reliability of detection on insertion and extraction cycle. This averts new bar stock or remnant from failure inserted in or pulled out and ensures bar feeder running under control. The self-centering vise operates via an air regulator for optimum clamping for adjustment with small diameter bars, soft material or thin wall tubing.



Safer Operation and Optimum RPM

The LNS Swiss safety connection eliminates the unsupported area between the bar feed and machine tool to provide greater safety and better bar stock support. It consists of a telescoping tube that extends in sections to maintain a continuous connection between the GT 326-E and the machine sliding headstock. This feature allows the headstock to move forward to make parts without the danger of exposed bar stock.

For added flexibility, the GT 326-E includes an assortment of reduction tubes to use within the Swiss safety connection and the lathe headstock. The inside diameters of these reduction tubes match those of the bar feed's guide channels. They act as a combination spindle liner to reduce the gap inside the spindle and additionally the inside diameter of the Swiss safety connection. The result is reduced vibration and bar oscillation within a critical and traditionally under-supported area. This GT 326-E feature improves part diameter tolerances, increases RPM, enhances surface finish and extends tool life.



"3-S" High Speed Headstock Synchronization System (Patent)

The headstock is directly connected to the servo drive eliminating transmission delay and guarantees perfect synchronization between the pusher and the headstock.

Innovative Front Stabilizer (Patent)

Troublesome bar vibrations transferring to the machine cutting area can create poor machining performance and wear on tool life drastically.

The two-position automatic hydrostatic front stabilizer with v-shaped guiding elements dampens residual vibration between the front of the bar feeder and the back of the spindle. Quickly and accurately change to the bar diameter by simply making a manual adjustment. Air blast is included to eliminate residual oil from the bar feeder to the machine.

Exceptional Productivity

- Optional Z-axis barfeed retraction system with a safety switch provides full access to the machine for easy maintenance.
- An adjustable 2-position retraction with dual safety switches to accommodate non-guide bushing applications is also available.

Specifications subject to change without notice

GT 326-E BARFEED
TECHNICAL SPECIFICATIONS

Capacity		
Diameter	mm	3 - 20 (26 max. with bar prep.)
Bar Length (3.25' to 12'3")	mm	990 min. to 3749 max.
Loading Capacity	mm	270
Loading Side		Right or Left
Shipping Weight	lbs	1,300
Applications		
Type of Headstock		Sliding
Headstock Synchronization		Electronic "3S", High Speed
Changeovers		
Partial changeover	min	2 within the range of guide channel
Complete changeover	min	8 or Less
Driving Systems and Bar Support		
Motor		Servo
Options		

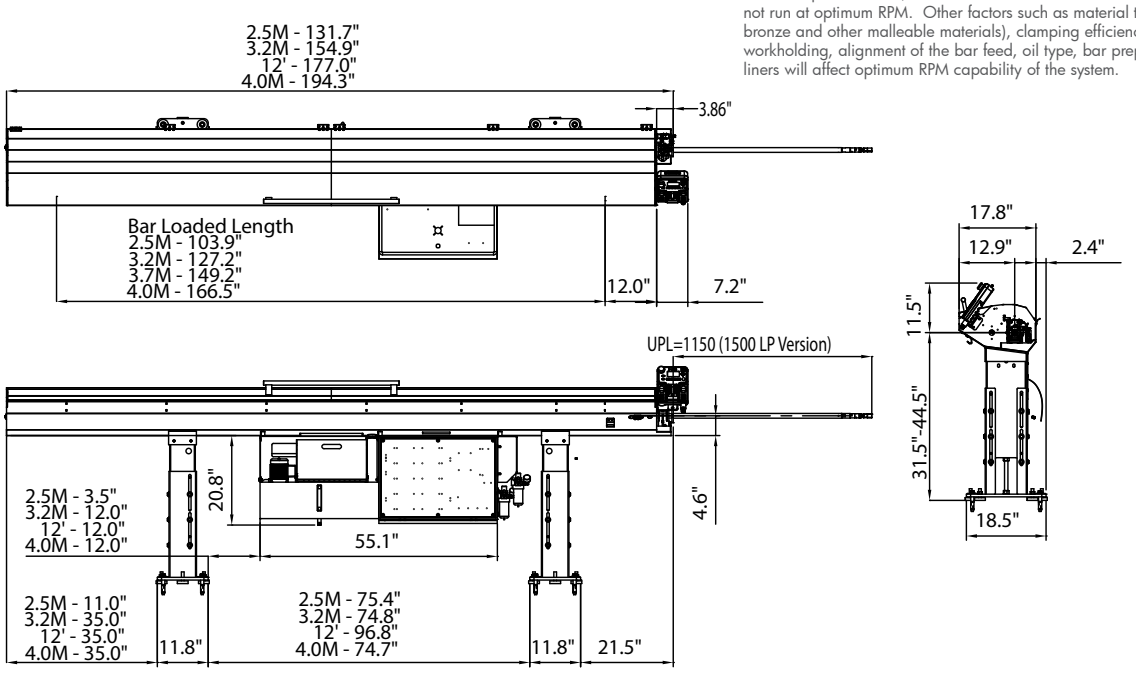
Z-axis retraction and adjustable 2-position for non-guide bushing set-up

Guiding Channel Selection Chart				
Guiding Channel Diameter	27	23	21	19
Bar Stock Diameter Range without Bar Preparation	17-23	13-20	11-18	8-16
Bar Stock Diameter Range with Bar Preparation	17-25	13-22	11-20	8-18

Guiding Channel Diameter	17	14	11	8
Bar Stock Diameter Range without Bar Preparation	7-14	4-10	3-8	3-5
Bar Stock Diameter Range with Bar Preparation	7-16	4-12	3-10	3-7

Barstock Straightness Specifications and Performance

For optimum rotational performance speeds, bar stock straightness needs to be .020" per 3.25 feet, non accumulative. Bar stock out of this tolerance will not run at optimum RPM. Other factors such as material type (brass, copper, bronze and other malleable materials), clamping efficiency of the machine workholding, alignment of the bar feed, oil type, bar preparation and spindle liners will affect optimum RPM capability of the system.



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LNS provides a full range of barfeeders, chip conveyors, coolant management systems, air filtration systems, and workholding systems that is second to none on the market. We are known in the industry for the solid experience we have gained over several decades in an exceptionally wide range of applications, our excellent customer service, and our technical support. This support is ensured by highly qualified technicians who are available throughout North America.

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