

M Series**NC Roll Feeding Machine****Model M07 / M14****Specifications Note****Cautions for Installation**

1. The supply voltage for NC feeding machines are 3 phase / single phase 200V ($\pm 10\%$) \cdot 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 to 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 specifications 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	M07	M14
Max. Material width		mm	~70	~140
Max. Material thickness		mm	~1.0	
Max. press follow-up speed		spm	~700	
Feeding system			Roll system by servo motor	
Acceleration adjustment			Automatic calculation (by press speed and feeding angles)	
Max. feed length		mm	~9999.99	
Feed length setting unit		mm	0.01	
Roll pressure system			Spring	
Roll pressure range *1		N	~1470	
		kgf	~150	
Release system			Mechanical with release camshaft	
Roll opening / closing at material int at material introduction			Air cylinder	
Repeatability		mm	±0.05	
			Condition : Feed length 50 mm • not release	
Approximate material dimensions *2		mm	70 × 1.0	140 × 1.0
Power supply voltage		V • Hz	3 phase / Single phase 200V (±10%) • 50 / 60Hz	
Total weight		kg	22	26
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	
	Option		1. Work shortage sensor	
Controller model			410C	

*1 Maximum material thickness

*2 It may vary depending on material stress and surface roughness.

▪ Performance table

M07 / M14

Press Speed	Feed Angle		
	150°	180°	210°
SPM/Cons.	Unit(mm)		
700	4.2	8.1	13.2
650	5.6	10.3	16.5
600	7.4	13.2	20.8
550	9.8	17.1	26.4
500	13.2	22.5	34.2
480	14.9	25.2	38.0
460	16.9	28.3	42.5
440	19.3	31.8	47.6
420	22.0	36.0	53.5
400	25.2	40.9	60.5
380	28.9	46.7	68.6
360	33.4	53.5	78.3
340	38.9	61.7	89.5
320	45.4	71.7	102.0
300	53.5	83.7	116.2
280	63.6	97.6	132.4
260	76.2	113.7	151.2
240	91.8	132.4	173.0
220	110.3	154.6	198.9
200	132.4	181.2	229.9

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.

▪ Standard product and accessories

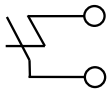
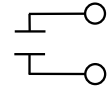
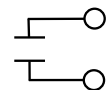
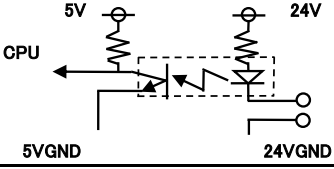
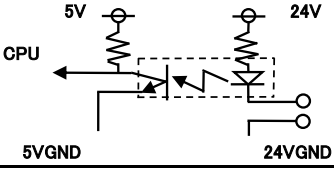
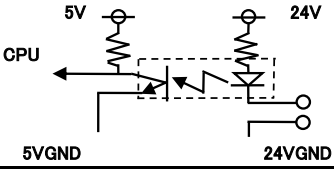
• Electrical cable	1set-8m × 1
• Air regulator	
• Terminal, Mark tube	
• Fixing bolt washer	
• Instruction manual	

▪ Option

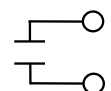
• Mounting bracket for machining unit (With slide plate)
• Work shortage sensor
• DS6 / Feed direction change
• BS6 / Feed-during output
• FF6 / Feed completion output
• MP6 / Date bank
• RC6A / Remote box
• TC6 / Feed conditions measurement

* There are other options as well.

• Required for installing a press

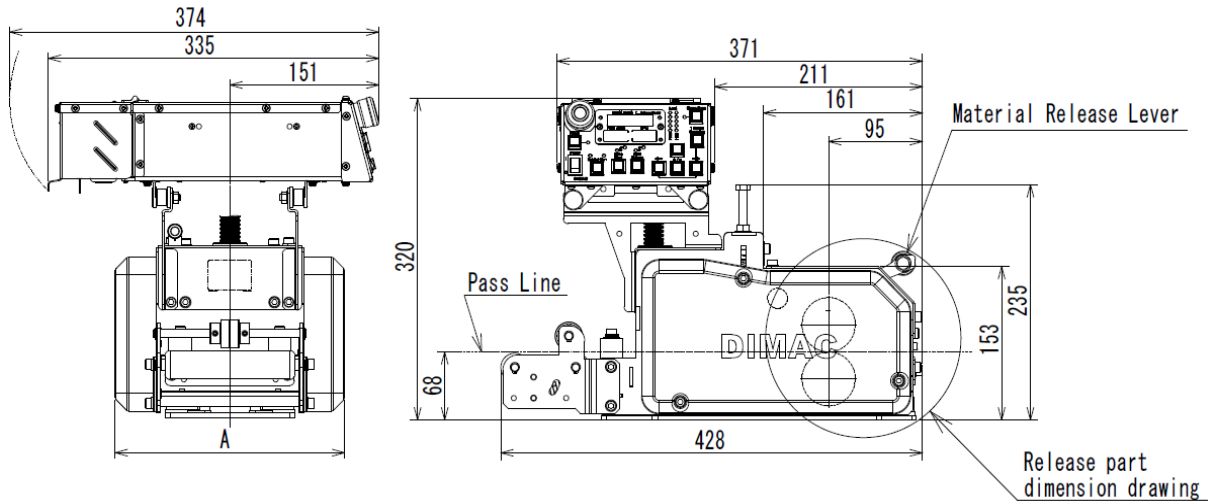
Press	M07 / M14	
Power supply voltage	3 phase / Single phase 200V (± 10%)·50 / 60Hz	
Rated power consumption	800W	
Emergency stop switch input 2-systems support	Emergency stop signal output This signal outputs directly from the emergency stop switch 1 A at 250 VAC or less 1 A at 30 VDC or less	
Abnormal 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 corrector output or Contact output	Emergency stop input circuit 0.01 A at 24 VDC	
Press continuous operation output Open corrector 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 0.3~0.5MPa	Use when opening and closing the roll clamp	

<Option>

Press	M07 / M14	
Work shortage sensor input circuit	Work shortage sensor output circuit 1 A at 250 VAC or less 1 A at 30 VDC or less Output at open	

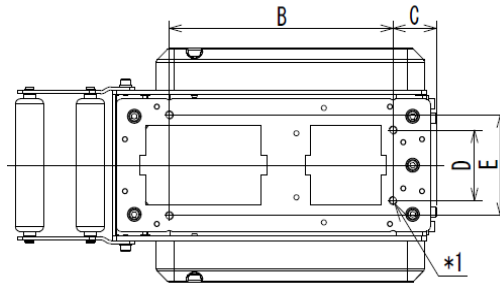
▪Figure of dimension

M07 / M14



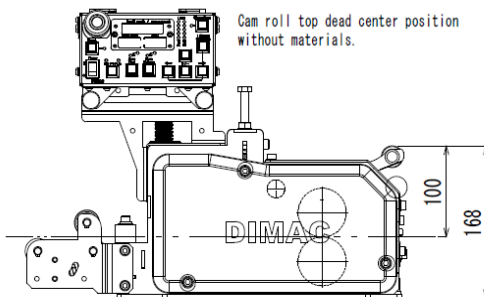
MODEL	A	B	C	D	E
M07	233	228	44	70	100
M14	303	250	39	130	130

* 1 Screw Positions for Mounting product (4 × M8)

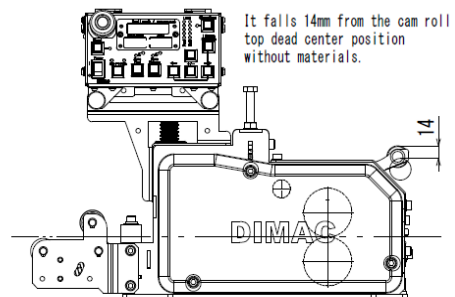


Release part dimension drawing

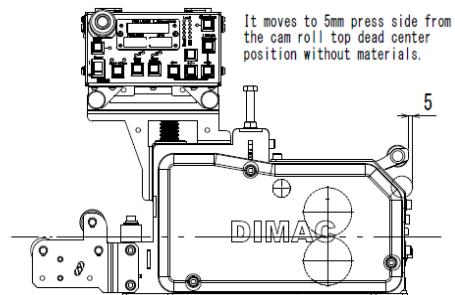
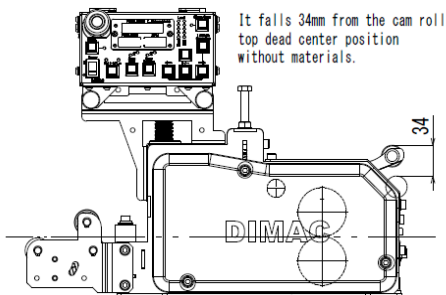
[Roll clamp state without material]



[Material insertion with 1mm thickness]



[Release cam roll lower limit position]



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