

Transfer System Specifications

The type of transfer system used has a great impact on the design of a die. Transfer systems may be tri-axis, crossbar, rail, beam, or overhead feeders.

A designer must configure the die timing giving careful consideration to the transfer system and the use of transfer curves. These curves are generated by transfer system manufacturers and must be supplied to the designer in order to validate relative movements within a die.

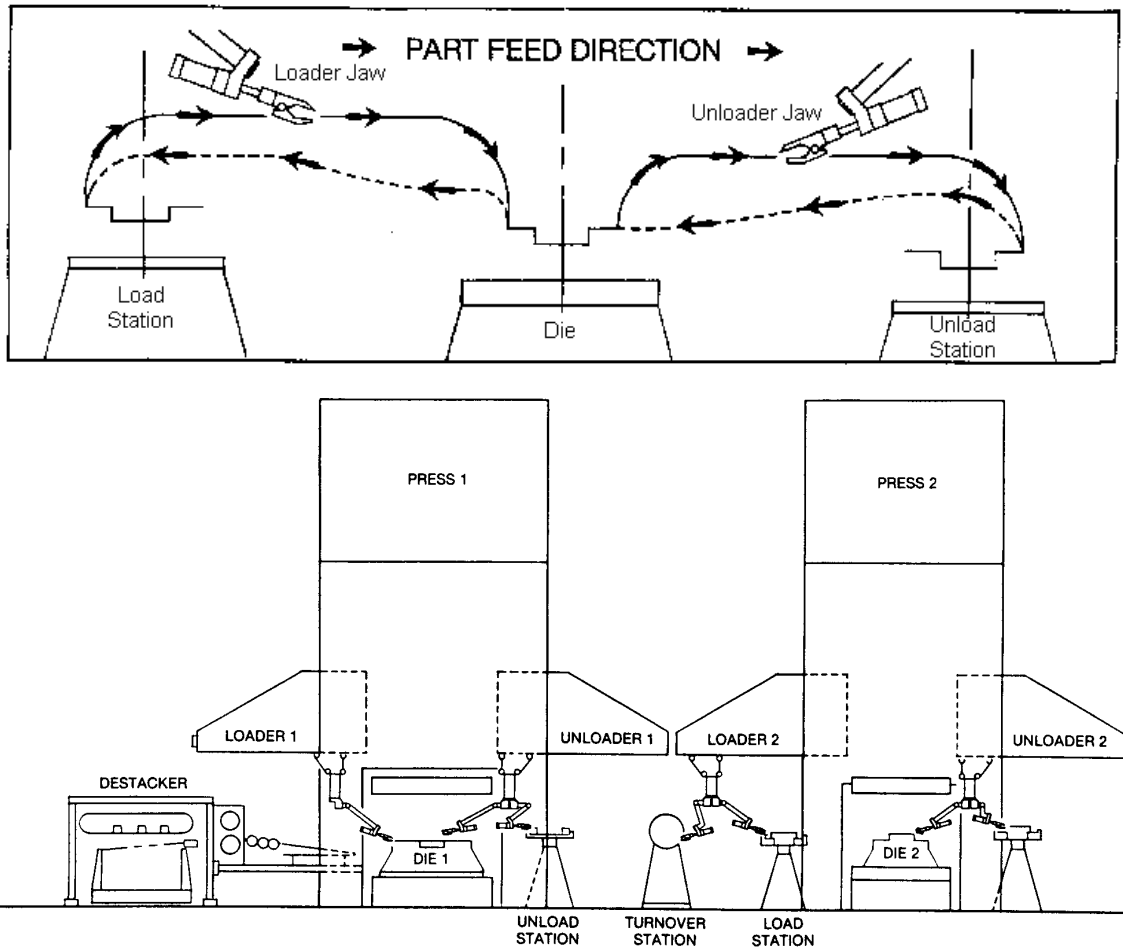


Figure 4-12. Transfer Considerations

The following is an example of an automation standard that a die designer has to consider.

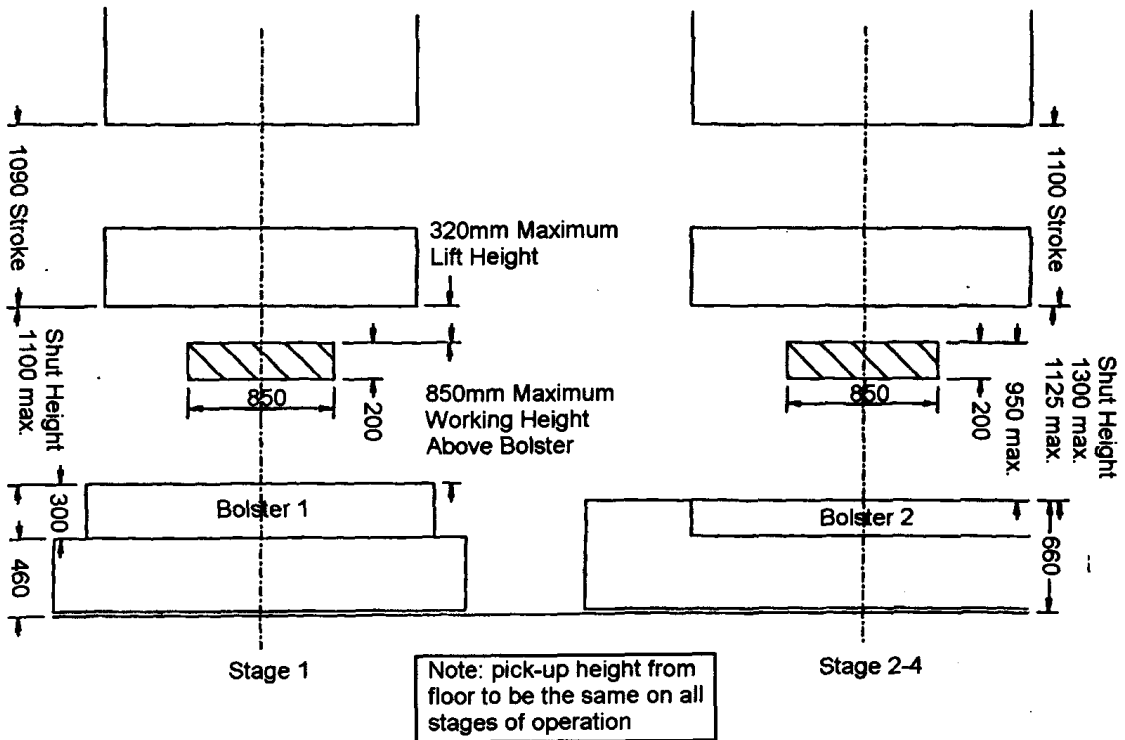


Figure 4-13. Transfer Limitations of a 4800 Ton Transfer Press

As shown in the above press specification, the maximum lift height to move a panel between operations in this press is 320 mm.