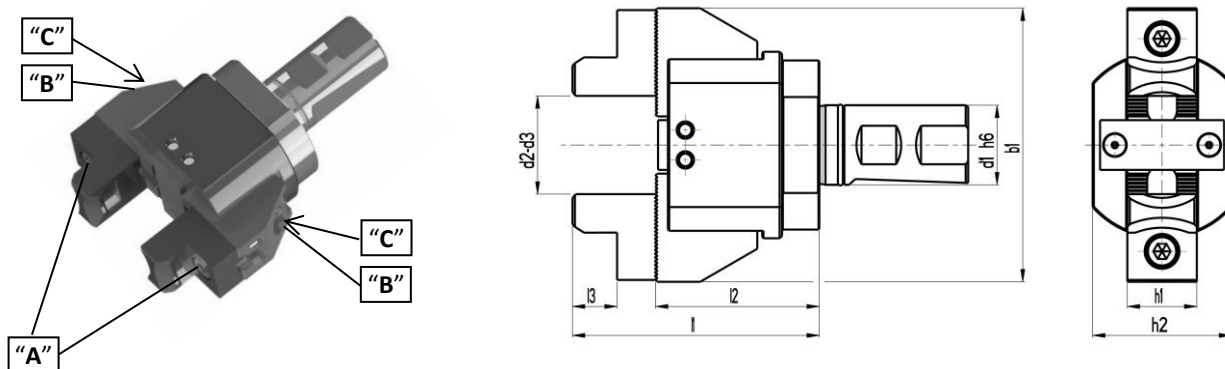


# BAR PULLER

- ✓ **Bar/tube clamping capacity**
  - 6 - 56 mm (normal jaws)
  - 56 - 110 mm (reversed jaws)
- ✓ **Easy to setup and use**
- ✓ **Adjustable strong gripping force**
- ✓ **Rugged design and construction**
- ✓ **One pair of reversible jaws**
- ✓ **WELDON shank**

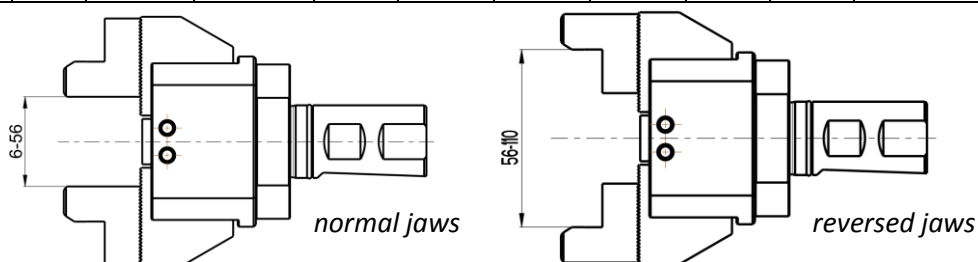
## DESTINATION:

- Bar Puller are intended to use on CNC Lathe. It is designed to pull bar stock and tubes into position for turning operations, for that lathes not equipped with bar feeders.
- Bar Puller is recommended to be used for small and medium size batch production.



Dimensions in [mm]

Code	d1	d2	d3	h1	h2	l1	l2	l3	b1	F ( clamping force)
NGT BP-WLD25	25	6-56	56-110	28	56	100	66	18	110	0,25 -1,6 kN
NGT BP-WLD32	30	6-56	56-110	28	56	100	66	18	110	0,25 -1,6 kN
NGT BP-WLD40	40	6-56	56-110	28	56	100	66	18	110	0,25 -1,6 kN



## OPERATING:

- a) Bar stock or tube is fed manually through the machine's hollow spindle to a fixed stop.
- b) **Setting of the clamping distance of the jaws:** with 2-4 mm smaller than the workpiece diameter, by moving both jaws on serrated surfaces of the Bar Puller fingers and securely fixed jaws in place, with screws "A" in a proper position.
- c) **Clamping force setting**, takes into account: material hardness, surface state, weight of the bar stock.
  - Clamping force can be increased (by turning clockwise the screws "B") or decreased (by turning anticlockwise the screws "B") with an Allen Key (hex 3 mm).
    - When you make fitting of screws "B", please turn them with equal turns.
    - Finally, lock the two "B" screws by screwing clockwise the nuts "C" with an Outer Hex Spanner of 10 mm.
  - Clamping force is correct set, when:
    - gripping jaws are not slipping on the bar stock or tube surface, and
    - there are not appearing dents on the surface of bar stock
- d) The spindle chuck is then clamping the bar stock.
- e) Bar Puller mounted in the turret is bringing towards the lathe headstock and the jaws of the Bar Puller are forced over the bar/tube clamped in the spindle chuck.
- f) The spindle chuck is then unclamped and the spring gripping jaws of the Bar Puller grip the bar/tube, dragging out to a pre-set stop position set by program.
- g) Bar/tube is then clamped by the spindle hydraulic/pneumatic chuck or collet.
- h) Turret is withdrawn further to release the jaws.
- i) Machining program starts and cutting process is completed till the end (last operation is cutting-off the bar/tube).
- j) The bar is then ready for the machining process to be repeated in a new cycle.
- k) Go to operation e).