

Miyano M-542



The Miyano M-542 is an Automatic Magazine style Bar Feeder designed for feeding round, square and hexagonal bar stock into Miyano lathes.

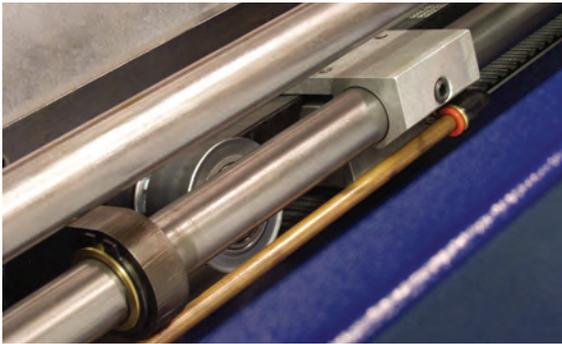
Marubeni Citizen-Cincom Inc.

M-542

The Miyano M-542 is designed for automatically feeding round, square and hexagonal bar stock in lengths up to 12', in a diameter range of 5-42 mm.

- **Double Pusher**

The two pusher system drastically reduces the overall length of the unit by as much as 4 feet. A short pusher pre-feeds the bar then retracts. A second full-length pusher lowers into position to continue the feeding process.



- **Self-Centering Gripper - Remnant Retract**

The gripper device holds and inserts the new bar into the bar collet and is also used to extract the remnant. Bar ends that are free of burrs require no additional chamfering. The gripper requires no adjustment for bar size changes as it "self-centers".

The bar remnant is withdrawn to the back end of the magazine. A gripper extracts it from the bar stock collet and deposits it in a remnant area.



- **Stock Size Adjustment**

Easy to use, bar diameter adjuster. This turn-knob allows for quick, on the fly switching of bar stock.



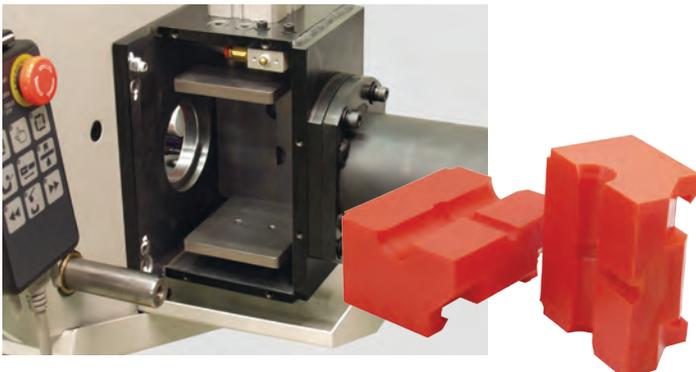
- **Rotating Tip & Collet**

The bar pusher is equipped with a standard rotating tip that ensures smooth running at high RPM. The bar stock collet is a common thread-on type.



- **Universal Bushing Blocks**

Durable Polyurethane bushing blocks eliminate bar vibration. Available in 2mm size increments, oil filled to achieve a hydrodynamic bearing effect.



- **Oil Reservoir**

Oil reservoir located beneath the remnant area, allows for full storage of collets and bushing blocks in the back stand.



● Control

A reliable, universal Mitsubishi controller and servo drive provide the M-542 with motion control and functionality. Electronics are mounted on an easy access fold out door.



● Remote Pendant

The M-542 features the convenience of an easy-to-use remote control pendant. Functions include:

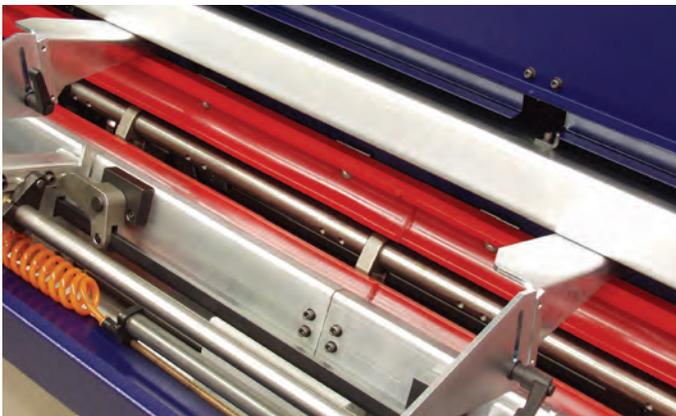


- manual and automatic operation
- manual load/unload of bar stock for set-up and/or changeover
- movement of bar pusher
- emergency stop

● Guide Channels

Universal polyurethane guide channels handle a wide range of stock sizes, yet change over quickly.

The channel is flooded with oil to create a hydrodynamic effect resulting in higher RPM with reduced noise and vibration.



● Touch Screen Control

The control is easy to program, yet flexible enough for all applications. Memory storage for jobs simplifies changeovers. Diagnostics and trouble shooting are all run from this advanced control screen.



● Robust Construction

Heavy gauge structural steel ensures rigidity and long term durability.

● Large Storage Capacity

The bar stock magazine is an incline rack with a loading capacity of 12 linear inches.

● Stock Alignment Guides

The bar stock alignment guides are quickly and easily adjusted for different bar diameters, effectively reducing set up time.



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Technical Data

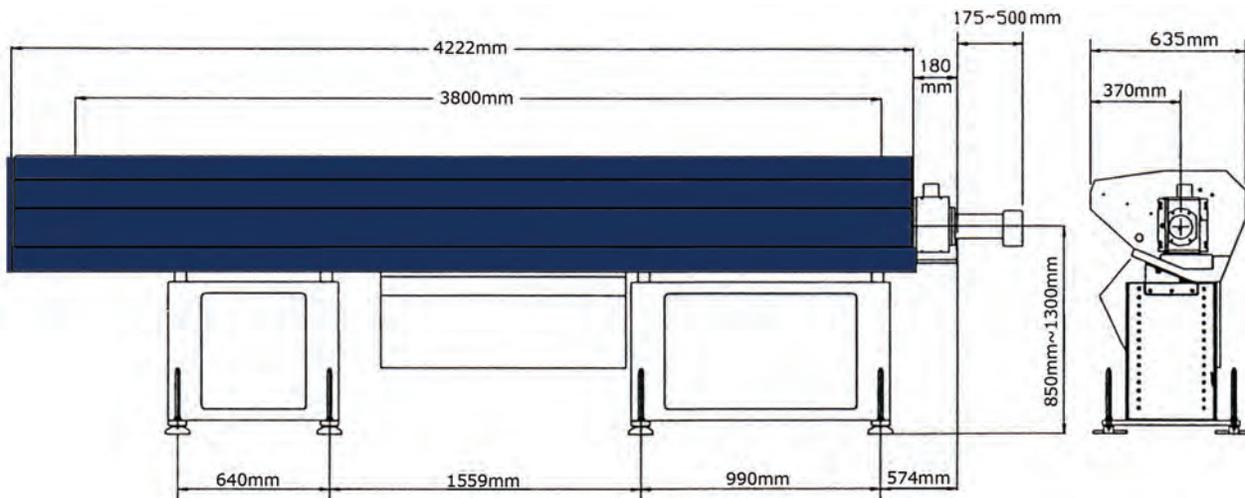
- **Power consumption**
2 KW
- **Feed force**
adjustable, max. 450 N (101 lbf)
- **Forward feed rate**
adjustable 750 mm/sec max. (2.46 ft/sec)
- **Return feed rate**
1000 mm/sec (3.3 ft/sec)
- **Loading time**
30 sec (for 12' bars)
- **Oil capacity**
55 liters (15 gallons)
- **Oil viscosity**
ISO 100-150 hydraulic oil
- **Operating voltage**
200-230 V/60 Hz
- **Compressed air supply**
6 bar = (90 psi)
- **Compressed air consumption**
approx. 8 liters per loading action
- **Weight without oil**
950 kg (2100 lbs)
- **Remnant length**
406 mm max (16 inches)



- **Maximum Bar Length**
3810 mm (12'6")
- **Bar Diameter Range**
5-42 mm (.196"-1.653")
- **Magazine Capacity**
12 linear inches

Channel Size	Bar Size Capacity (mm)		
	Minimum Bar Size	Maximum Bar Size	Max. Bar Size w/Front Remnant Expulsion*
13mm	5mm(.196")	10mm(.393")	12mm(.472")
17mm	5mm(.196")	15mm(.591")	16mm(.629")
21mm	8mm(.315")	16mm(.630")	20mm(.787")
26mm	8mm(.315")	21mm(.827")	25mm(.984")
28mm	10mm(.393")	25.4mm(1.00")	27mm(1.062")
33mm	10mm(.393")	28.5mm(1.125")	32mm(1.260")
36mm	12.7mm(.500")	32mm(1.260")	35mm(1.377")
38mm	15.8mm(.625")	33.3mm(1.312")	37mm(1.456")
43mm	19mm(.750")	38mm(1.500")	42mm(1.653")

*This max. diameter is attainable only if remnant is ejected through the lathe spindle or if one end of the bar stock is turned down to a smaller O.D. to accept a smaller O.D. collet.



Technical data subject to change without notice

Marubeni Citizen-Cincom Inc.

www.marucit.com

40 Boroline Road
Allendale, NJ 07401
201-818-0100

2316 Touhy Avenue
Elk Grove Village, IL 60007
847-364-9060

17815 Newhope Street, Suite P
Fountain Valley, CA 92708
714-434-6224

68 Moylan Lane
Agawam, MA 01001
413-786-6655

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