Pressure Foot System

Stacked Sheet Processing using the Pressure Foot System allows machining operations to be carried out on a stack of material.

The initial machining cycle cuts the parts, leaving small tabs between the parts and the remaining material. After this initial cycle, the pressure foot moves into place to hold the parts while the tabs are machined away.

The assembly is designed to hold the pressure foot stationary on the part while the spindle is allowed to move slightly in the X and Y axes, removing the tabs. The parts are released and the cycle is restarted.

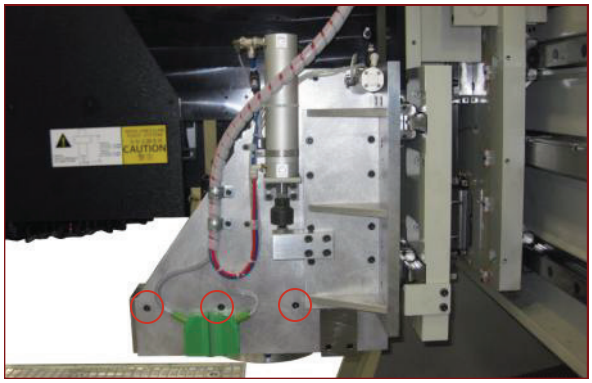
1) Load a stack of same size sheet material onto a plywood board. The stack can be up to 0.6" (15mm) thick, depending on type of material, tooling and machining process. Normally, four screws in the corners of the stack are used to secure the sheets of material to the plywood.
2) Manually position the plywood and stack of material onto the worktable. The vacuum will hold the stack in place.
3) Start machining cycle. The cycle will drill and route all work pieces. Tabs will hold the individual parts in the stack until the end of the initial machining cycle. The pressure foot will slide across the top of the material in low pressure mode, with just enough pressure to hold the material in place. The integrated air blast keeps chips from scratching the top sheet of material.
4) After initial machining cycle is complete, the pressure foot goes into high pressure mode, holding the stack in place while the machine spindle cuts the tabs from the individual parts.
5) At the end of the cycle, the operator removes the stack, loads a new stack, then collects the parts and discards remaining scrap material while the new stack is cutting.

The assembly can be split apart and moved out of the way by removing three screws. This allows you to use the spindle alone, without the pressure foot.

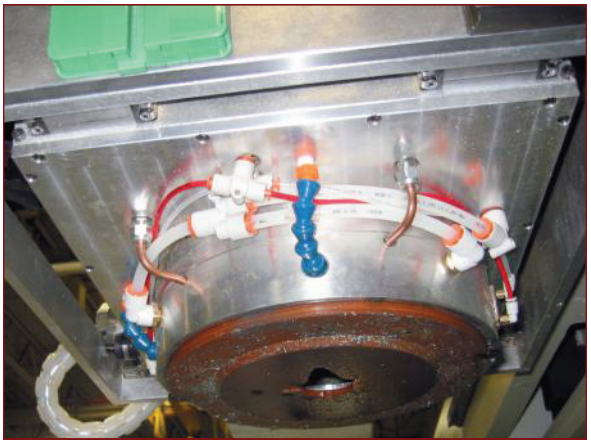
The wear pad (which slides across the material as the tabs are being removed) is easy to access and replace.

The pressure foot assembly includes its own chute for connection to chip collection, as well as provisions for air blast and mist.

Assembly Splits Apart for Spindle Alone



Remove Three Screws then Slide Assembly Apart



Wear Pad is Easy to Replace

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