

RMG Pointing Equipment

Rockford Manufacturing Group provides the best solutions for all of your off-line push pointing or pull pointing needs. Our wire pointers, electric and hydraulic powered, cover a wire range of .020" (0.5 mm) to 1.750" (45.0 mm) diameter and are proven to increase production up-time.

Pointing Equipment

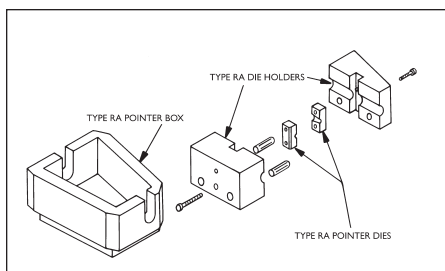
It is always necessary to provide a pointed end when setting up a wire drawing machine. Although butt-welding a slightly smaller wire to the head end of the wire to be drawn represents one common method of providing the pointed end, under some circumstances it is more practical to use a pointer. This technique "necks down" a section of the parent wire and permits it to be inserted through the drawing die for initial set

up. For small wire sizes, .060" (1.5 mm) to .250" (6.4 mm), two common methods are *pull pointing and roll pointing*. Pull pointers can be mounted on each wire drawer but, because the capstan is used to power the pointer, pull pointers interfere with production. Roll pointers stand alone allowing the wire to be pointed ahead of string-up and, one unit can service several wire drawers. For medium wire sizes, .250" (6.4 mm) to .500" (12.7 mm), the pull pointer is

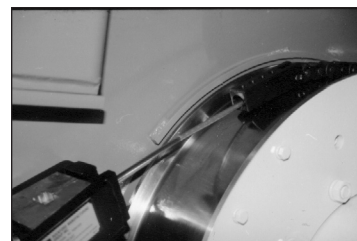
a good inexpensive method because it uses the capstan to provide the substantial pull required. However, as mentioned before, the pull pointer interrupts production. For large wire sizes, .500" (12.7 mm) to 1.00" (25.4 mm), the self-contained hydraulic push pointer will provide the power necessary, and pointing can be accomplished "off-line" as with a roll pointer.

RMG Pull Pointing Operation

Type RA Pull Pointer



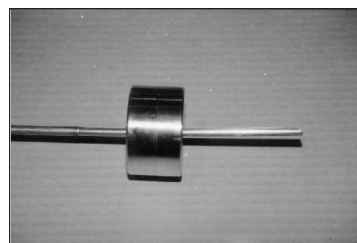
1. The head end of the wire is inserted through the Type RA pointer assembly. The gripper is attached to the wire.



2. The machine is jogged and about 6" (150 mm) of wire is reduced to a diameter about .006" (.15 mm) to .010" (.25 mm) smaller than the finished wire diameter.



3. The reduced portion is cut with bolt cutters before removing the gripper chain and before removing the wire from the pointer assembly. Any residual fins are removed by filing.



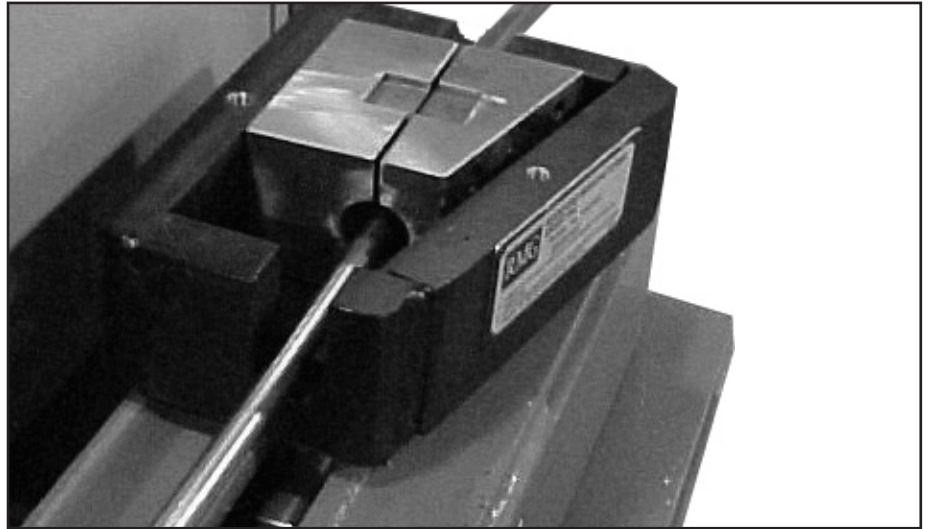
4. This operation results in a reduced diameter on the head-end of the wire, which can be inserted through the drawing die.

Description	.250" (6.4 mm) Max. Part #	.450" (11.4 mm) Max. Part #	.550" (14.0 mm) Max. Part #	.650" (16.5 mm) Max. Part #
Box only (no tools)	D1392.03	D1592.02	D1592.12	D3582
Die Holder	D1393	D1593	D4804	D4804
Stock Dies	D1341	D1541	D3575	D3575
Die Dimensions (in.)	.37x.50x1.25	.62x.75x1.62	.75x1.0x2.25	.75x1.0x2.25

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Advantages of pointing off-line

- Set-up reduction
- Reduced pointer tooling inventory
- Safety
- Ease of use
- Portability



The RMG Off-Line Pull Pointer (OLPP-10) uses the same pointing tooling as our in-line Wire Drawers and can be mounted to a bench or a service cart for use in multiple work centers.

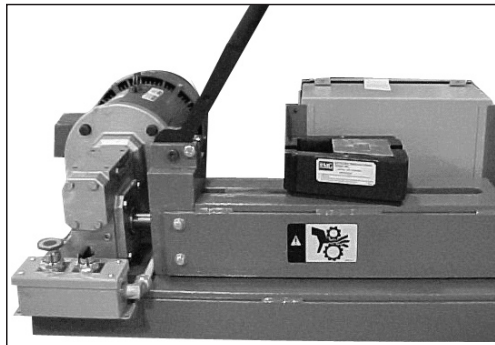
OLPP-100 Specifications

Maximum Pull Force	10,000 lbs. (4,533 kg)
Maximum Wire Diameter	0.625" (16.0 mm)
Minimum Wire Diameter	0.02" (0.5 mm)
Cycle Time	Less than 1 minute
Overall Dimensions	27 x 37 in. (686 x 940 mm)

Pull Pointer OLPP-10

Features and Benefits

- Bench top design which can also be mounted on a wheeled cart to service several units.
- Uses existing RA pull point tooling.
- Available in single and three-phase construction.
- Can be used without interrupting production.
- Auto polarity correction.



ROCKFORD MANUFACTURING GROUP INC. • FASTENER ENGINEERS & LEWIS MACHINE

14343 INDUSTRIAL PARKWAY SOUTH BELOIT, ILLINOIS 61080

Phone 815.624.2500 Fax 815.624.7254

Email rmgfelem@rmgfelem.com Website www.rmgfelem.com

