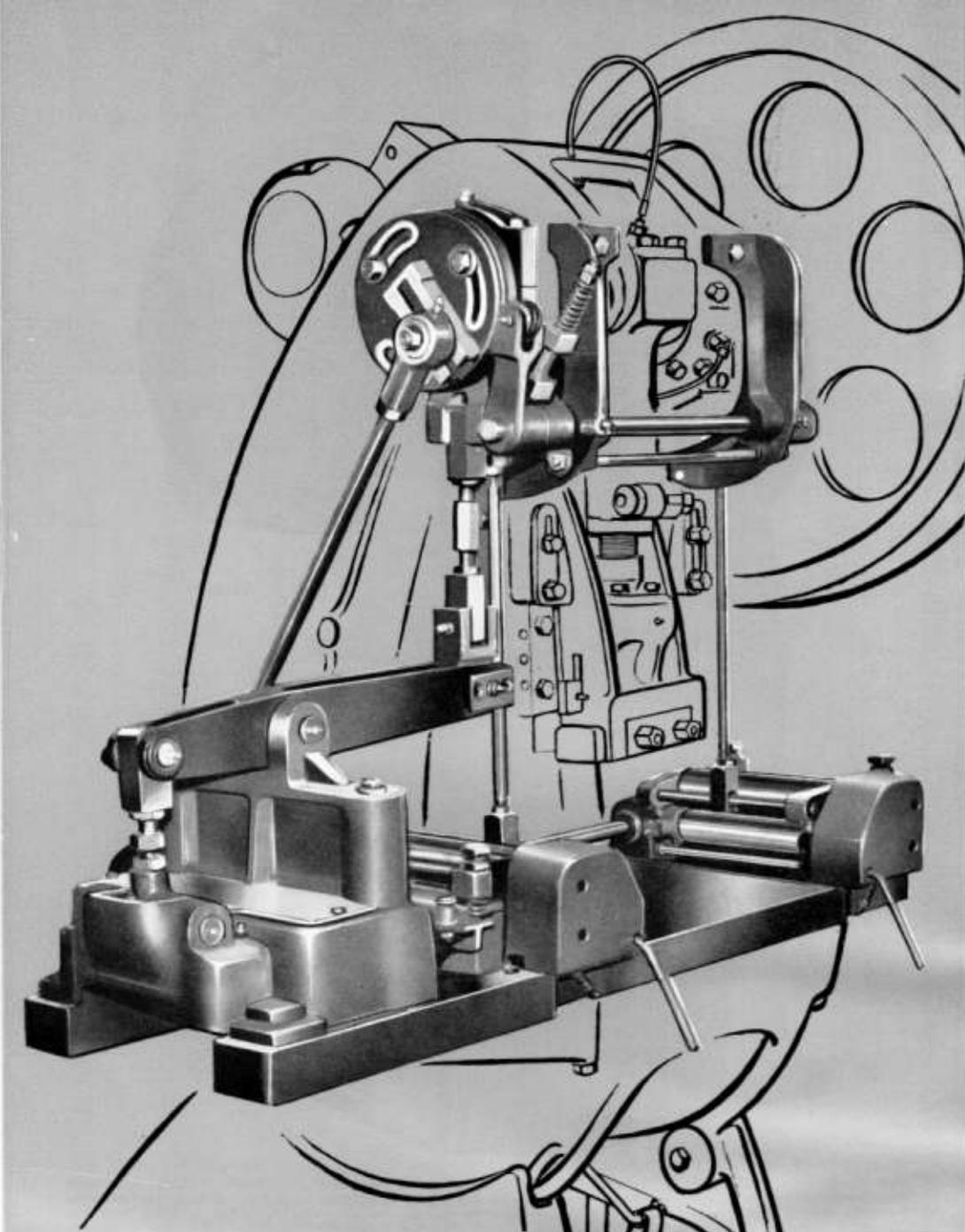# Automatic
ROLL
FEED
ATTACH-
MENTS

This is the most universal type of feed and is ideal for complex multi-stage tooling and simple single stage dies because of the adjustable roll lift device which allows pilots in the die to accurately position the strip after each feed stroke.

Most economical results are obtained with the use of coiled material, but guillotined strips can be satisfactorily handled.

The Roll Feed is a complete unit which bolts to the press bed in place of the standard bedplate. On all except 2001A and 2202A Models, the bedplate has been extended to take a Scrap Cutter, which is offered as an OPTIONAL EXTRA.

Single Roll Feeds are available upon request.

DOUBLE ROLL FEED SPECIFICATIONS

For Press Model No.	201A Series 2	202A Series 3	202½A Series 3	203A Series 3 203AG Series 3	205A Series 3 only	206A Series 3 only	207A Series 4 207AG Series 4
Double Roll Feed No.	2001A Series 2	2202A Series 1	2202½A Series 1	2203A Series 1	2205A Series 2	2206A Series 2	2207A Series 1
Maximum Width of Strip	4½	6½	7	10	10	10	14
Maximum Length of Feed— Standard Gears	0 – 4½	0 – 4½	0 – 4½	0 – 4½	0 – 4½	0 – 10	0 – 10
*Special Gears	0 – 8¼	0 – 8¼	0 – 8¼	0 – 8¼	0 – 8¼	0 – 5	0 – 5
Maximum Die Space (Slide to Bedplate—Std. Stroke down Adj. up)	5¾	6½	7¼	8⅛	9½	10½	12½
Distance between Feed Roll Centres	20½	23	27	28	35½	36½	37½
Avail. Roll Lift Mech. Clearance	14½	14½	18¾	19¾	27	26¾	30
Diam. of Feed Rollers	2⅜	2⅜	2⅜	2⅜	2⅜	3⅜	3⅜
Height of Bottom Feed Roller above Bedplate (Bottom Die Height)	2½	3	3	3	3	5	5
Distance from centre of Slide to edge of Roll Feed Cross Shaft	4¾	6½	6½	8¾	8¾	8¾	10½
Opening in Bedplate: R to L x F to B	—	—	6 × 3	6 × 3	7 × 4	8 × 4	8 × 4
Thickness of Bedplate	1½	2½	2½ Steel	2½ Steel	2½ Steel	2½ Steel	3½ Steel
Bottom Die Clamping	Tapped Holes on R to L centre line						
Approx. Weight of Unit: Kilograms	177	254	343	432	457	508	966
Direction of Feed: L to R or R to L	L to R	Optional	Optional	Optional	Optional	Optional	Optional

*Special gear ratios are available for more accurate feeding of short pitches.