

# COIL FEED

**MODELS: PLCF6014•PLCF6016•PCLF7214•PCLF7216**

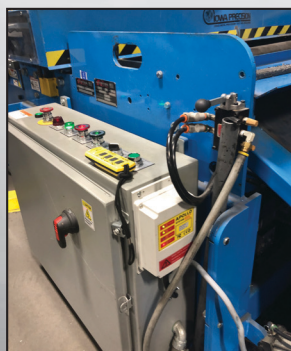
Available for both laser and plasma cutting systems



Maximize cutting productivity and meet the demands of growing trends in the HVAC duct construction industry with Iowa Precision's Coil Feed. Iowa Precision has created a highly integrated Coil Feed system with wireless capabilities to eliminate the need to load material by hand. The Coil Feed was designed for upload and reloading of coil production for either a plasma or laser-cutting tables.

The Coil Feed system is comprised of a drive motor and a series of rolls to feed and remove coil set from the material. The material is advanced by the operator using an on/off switch. This allows the operator to follow the material to proper location along the cutting table. Drive is by way of entry pinch rolls and exit pinch rolls. Straightening is accomplished with rolls located between the entry and exit rolls, which are controlled by way of a hand wheel for depth penetration. Length of feed is at the operator's discretion, as the machine does not measure the material. Plasma or laser cut-off of the sheet length is standard, optional sheet cut-off system is available.

- E-Z Load system for ease of use when loading coils
- Complete hands-off technology once coils are loaded
- Productivity and savings can be increased with the addition of beading
- Down-bead or up-bead patterns are available
- One-man operation system that reduces material handling
- Instead of storing material on racks, coil stations are ready to feed cutting tables
- Small footprint saving valuable shop floor space
- Reduction in scrap material
- Reduced material costs with coil versus sheet stock production
- Labor savings when uploading coil stock vs handling sheet stock
- Material utilization completely optimized when cutting from coil especially when operating a 20' table



# COIL FEED



Model Shown with coil overfeed system.  
Underfeed system available



## SPECIFICATIONS:

### MAXIMUM WIDTH CAPACITY

- 72" (1829 mm)

### MAXIMUM GAUGE CAPACITY

- 16 ga. with option for 14 ga.

### PASS LINE HEIGHT

- 32.5" (826 mm)

### ROLL DIAMETER

- 4.167" (105,7 mm)

### MATERIAL JOG SPEED

- 35 FPM (10,7 MPM)

### ELECTRIC MOTOR SIZE

- 3 HP (2,3 kw)

## AVAILABLE BEADING OPTION

Down-Bead or Up-Bead pattern is rolled into the coil as it is being fed onto the cutting table. The bead pattern is produced by bead rings that ride in grooves machined into a pair of pinch rolls with the bottom roll powered and the top roll adjustable up and down by means of a hand wheel. The bead pattern is not intended to be a half radius, but more of a rounded shallow vee to form a cross-break in the material for stiffening.

## BEAD SPECIFICATIONS:

### BEAD PATTERN SPACING

- 12" (304,8 mm) centers 6" (152,4 mm) from edge

### BEAD PATTERN HEIGHT

- 0.060" (1,5 mm) – 0.120" (2,5 mm) adjustable

### MINIMUM GAUGE

- 28 ga. (0,5 mm)

### MAXIMUM GAUGE

- 16 ga. with option for 14 ga.