

Bar Pullers**Bar Pull Threaded Adapter 5/8"****\$52**Item Number: **844-20625**

This photo is of a bar pull system without an adapter. Explanation is for the bar pull system generally not just the adapter.

Bar Pull Threaded Adapter 5/8"

HOW IT WORKS

1. Mount shank in tool holder; screw on adapter (if required) and gripper.
2. Insert bar through back of spindle and clamp with collet or chuck.
3. Face off minimum 1/4" projection using parting-off command in CNC program.
4. Position gang slide and bar pull in front of spindle. Move slide forward to programmed distance sliding gripper over stock.
5. Release clamping pressure on bar.
6. Retract turret programmed distance.
7. Reclamp bar

Bar Pullers**Bar Pull Threaded Adapter 1.0"****\$52**Item Number: **844-20750**

Bar Pull Threaded Adapter 1.0"

MACHINING INSTRUCTIONS:

Bar-pull grippers can be machined to pull a bar up to 1/16" larger than its original size. An understanding of the gripper is important to machine properly.

The gripping diameter is at a 3.2" (3-12') with the centerline of the part. therefore, the gripper in its expanded position (over bar) has a complete gripping diameter making contact. This is what generates the holding power. Machining instructions continued on details of next item.

Bar Pullers**Bar Pull threaded Adapter****\$59**Item Number: **844-20751**

Bar Pull threaded Adapter APB1000GT for use with shank PB0625GT (5/8") and gripper PBG1000 (1.0")

Bar Pullers**Bar Pull Shank 5/8"-Gang Tool****\$66**Item Number: **844-30625**

Gang Tool Machine Only

No Adapter needed-Grippers up to 3/4"

The Bar-Pull line of low cost bar stock pullers for CNC lathes has been expanded to incorporate grippers in 1/16" increments from 3/16" to 1" and 1/8" increments from 1-1/8" to 2". When a Bar-Pull is used, the gang lathe no longer acts as a stock stop, reducing turret degradation and eliminating expensive, space-consuming, high maintenance bar feeds. These self-activated grippers are slotted like standard collets and, as they advance over the bar to be pulled, are forced open to firmly grasp the bar for pulling out of the spindle to a programmed length. Only 1/4" bar engagement is needed. Gripping and release of the bar are automatic when the tool bar is advanced and retracted. Bar-Pull components are available in kits. Bar-Pull shanks should be specified to the size of the tool holders.

USE Bar Pull threaded Adapter APB1000GT for use with this shank PB0625GT (5/8") and gripper PBG1000 (1.0")

Bar Pullers**Bar Puller 3/4" Shank****\$66**Item Number: **844-30875**

Bar Puller 3/4" Shank:

Machining Instructions:

1. Hold gripper in chuck of engine lathe. Chuck only 3/8" of gripper body.
2. Gripper body must not flex during machining operation. This can be prevented by securing a hose clamp (automotive screw type) around gripper fingers. Do not compress fingers, just secure.
3. Set machine compound rest to cut at a 3.2 deg or 3deg-12' with centerline of part.
4. Cut bore .015" smaller than bar to be gripped. Do not enlarge gripping diameter more than .047".
Example: a 1" diameter gripper body will be opened up to grasp a 1-1/16" diameter bar. Measured diameter= baar to be gripped- .015" 1.047" = 1.062" - .015"
- Many small cuts are better than several large cuts.
5. Turn a radius on the leading edge on gripper finger. Radius size is

Bar Pullers**Bar-Pull Kit #7****\$515**Item Number: **844-50020**

Special kit for gang tool lathes: 10 grippers 3/16" to 3/4" at 1/16" increments. All grippers mount directly to bar pull shank, no adapter required (this kit only), includes bar pull shank 5/8"GT with this kit only.

Features And Benefits....

- Pulls bar to last usable part length
- Pull-positions bar +/- 0.001"
- Eliminates expensive bar feeds
- Works close to the chuck or collet nose
- Does not interfere with adjacent tools