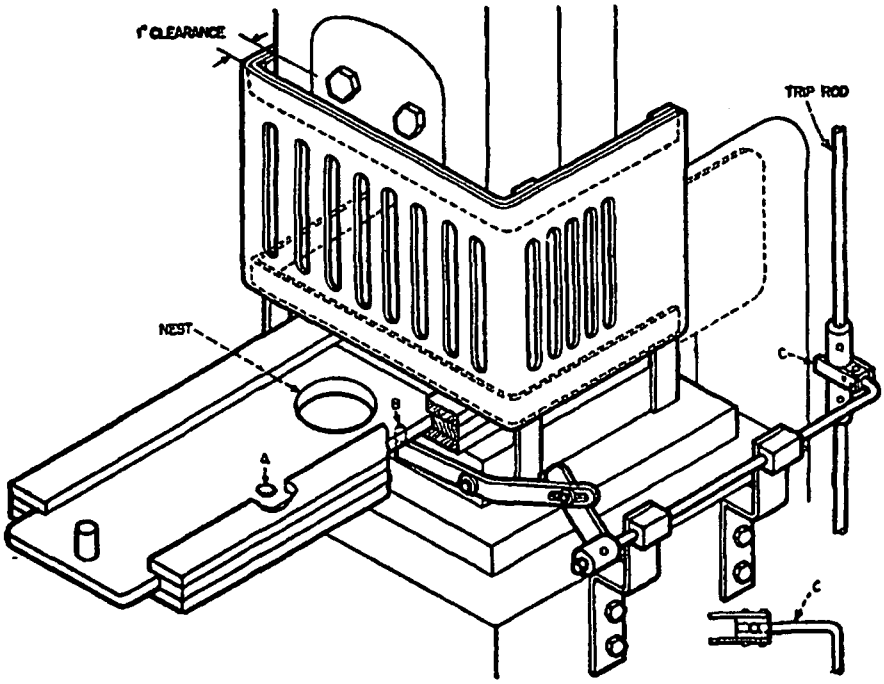


Fig 23-26. A manually operated plunger feed. Note that the press cannot be tripped until the part is pushed to the next location. At this point, hole "A" is directly over tapered pin "B," it can rise and release yoke "C" so that the press can be tripped.

tion of the operator at each stroke of the press Such feeds have a distinct advantage in that the operator is not required to reach into the point-of-operation area to feed the press, and the feeding method permits complete enclosure of the die. This type of feeding is not adaptable for certain blanking operations nor for nesting of odd-shaped pieces.

The six principal types of semiautomatic feeds are chute (both gravity and follow), plunger, slide or push, sliding dies, dial, and revolving dies

Of the six semiautomatic methods, the *chute feed* is probably the most widely used It is a horizontal or inclined chute into which each piece is placed by hand The pieces then slide or are pushed one at a time into position in the lower die. The entire die may be enclosed, since it is unnecessary for the operator to place his hands in the point-of-operation area if nonmanual ejection is also provided (Fig. 23-25)

It is customary to use a soft metal pick or rod or a wood stick to remove pieces that jam in the die *A steel rod should never be used If caught in the die, it could shatter, with the result that the die might be ruined and the operator injured*

Many hand-fed dies can be changed to chute feed by reversing the dies and inclining the press A chute feed on an inclined press not only helps center the piece as it slides into the die but also simplifies the problem of ejection.

Plunger feeds are a variation of the push feed and may be semiautomatic or manual in operation. The semiautomatic plunger feed is a magazine or chute in which blanks or partly formed pieces are placed The