

COLD FORMING OF METALS

guard is a solid metal plate covering the nip point for the full length of the rolls. This plate, equipped with a stud welded to each end, is attached to slotted vertical brackets by means of nuts and washers, so that it is adjustable vertically. The bracket can be either welded or bolted to the feed table. If desirable, the horizontal member of this bracket also can be slotted to give further adjustability.

The feed table may be made adjustable vertically by making the legs of pipe of different diameters to achieve a telescopic effect. The larger, or base section, should be equipped with a setscrew of sufficient size to ensure stability when adjustment has

been made. Further stability is given this feed table by welding foot plates to the base section of the leg.

Another method of protection, although less desirable, consists of emergency tripping bars connected to electric cutoff switches or, preferably, reverse electric switches. Such emergency bars may be installed at knee level in front of the operator or directly in front of the bottom feed roll, far enough below the feed point to avoid accidental tripping.

Special-purpose feeding devices for narrow stock may be easily installed, as shown in Fig 23-46.

References

- American Standards Association, 10 East 40th St., New York City *Safety Code for Power Presses* B11-1.
- Joint Industries Conference *JIC Hydraulic Standards for Industrial Equipment* Published by General Motors Corp., Detroit, Mich.
- National Safety Council, 425 North Michigan Ave., Chicago, Ill.
- Industrial Data Sheets
- Alligator Shears Data Sheet 213
 - Cutting Oils, Emulsions and Drawing Compounds Data Sheet 501
 - Handling Finished Pieces at Power Presses Data Sheet 534
 - Individual Die Guards and Adjustable Press Barriers Data Sheet 365
 - Kick (Foot) Presses Data Sheet 363
 - Metal Squaring Shears Data Sheet 328
 - Method of Locking Out Electric Switches Data Sheet 237
 - Power Press Maintenance Data Sheet 224
 - Press Brakes Data Sheet 416
 - Scrap Handling—Punch Presses Data Sheet 395
 - Setting Up and Removing Power Press Dies Data Sheet 211
 - Veneer Clippers Data Sheet 542
- Power Press Safety Manual
- Wilson, Frank W., ed
- Die Design Handbook* New York City, McGraw-Hill Book Company, 1955
 - Handbook of Fixture Design* New York City, McGraw-Hill Book Company, 1962