



## Remanufactured Minster MEF5-32 Single Roll Electric Feed

New 1999 – Remanufactured 2019

Nidec Press & Automation Stock #100299A



Photo of actual machine

### Specifications:

- 32.00 in. Maximum Material Width (813 mm)
- 0.250 in. Maximum Stock Thickness @ 16.00 in. Width
  - (6.3mm @ 406 mm Wide)
- 0.125 in. Maximum Stock Thickness @ 32.00 in. Width
  - (3.18 mm @813 mm)
- 0.020 in. Minimum Thickness (0.5 mm)
- 0.470 in. Maximum Roll Opening (11.9 mm)
- 5.40 in. Feed Roll Diameter (2137 mm)
- 64.50 in. Material Pass Line  $\pm$  4.50 in. Over Floor
  - (1638  $\pm$  114 mm)
- 99.99 in. Maximum Programed Feed Length (2540 mm)

### Features:

- Motorized Pass Line Adjustment
- Pass Line Mounting Clamps
- End of Stock Sensor
- Grease Lubrication System

Price, FCA Shipping Point: ..... Price On Request

### Contact:

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### Nidec Press & Automation

240 West Fifth Street  
Minster, OH 45865  
419-628-2331 • [www.nidecpa.com](http://www.nidecpa.com)



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### Main Feed Head Rebuild

- Disassemble entire feed head and drive train
- Inspect all machine components for integrity, wear and damage
  - Components to include:
    - Feed rolls and journals
    - Side plates and gear housing
    - Upper roll lift assembly
    - Drive train components (gears, belts, pulleys, sheaves)
    - Lubrication points and manifold
- Clean, sand, prime and paint appropriate components
- Grind and apply matte chrome finish to upper / lower feed rolls
- Rebuild pneumatic cylinders (Roll lift, pilot and anti-backup)
- Install new bearings, races and bushings
- Re-assemble entire feed head
- Install drive train and verify alignment
- Time upper feed roll adjustment for parallelism
- Install new solenoid control valve(s)
- Install new pneumatic components (fittings, quick exhausts, flow controls)
- Install new lubrication fittings, hosing and accessories
- Rebuild cabinet pass line elevation system
- Rebuild motorized pass line adjustment as required
- Clean, sand and paint entire machine to color of choice
- New OEM safety warning labels

### Complete new servo drive and control package\*



- 425 in./lbs. motor (48 Nm)
- 480 VAC Primary Voltage
- 999.999 in. Maximum Feed Length (25,400 mm)
- Within 0.003 in. Material Feed Accuracy (0.076 mm)
- Allen Bradley KINETIX AC Servo Drive
- Allen Bradley CompactLogix PLC
- Allen Bradley AC Servo motor
- **Integrated holding brake on motor**
- Touchscreen HMI operator interface
- Servo feed software optimized for press feeding applications
- Motor Power / Encoder cable(s) 10M
- Ethernet IP communication
- SD Card Drive data storage and recovery
- USB HMI data storage and recovery
- Emergency stop button with integrated safety relay
- Free standing sloped front electrical enclosure
- Fused safety disconnect

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### STANDARD FEATURES

- Safe Torque Off (Hard Wired)
- 24 Volt VDC based control system
- 100 Part recipe storage
- Automatic, manual and setup modes
- Programmable per part recipe
  - Feed to length
  - Feed velocity
  - Feed acceleration
  - Batch count
- Feed length micro adjustment
- Manual mode:
  - Jog continuous
- Setup Mode:
  - Jog to part length
  - Single feed to part length
- Remote jog pendant with 10' curly cord and mounting holster
- Pilot pin release
- Feed complete output
- Fault history
- (2) 24-volt DC capable dry contacts from the press rotary cam switch will be required. One for automatic feed initiate, and one for pilot pin release.
- Full digital operator's manuals and electrical schematics



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