

3. CENTRING SHOVELS

POSITIONING OF BLANKS

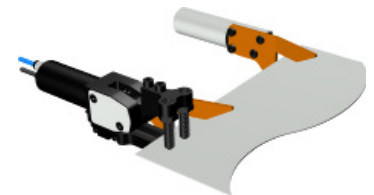
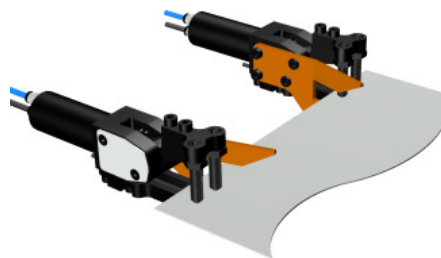
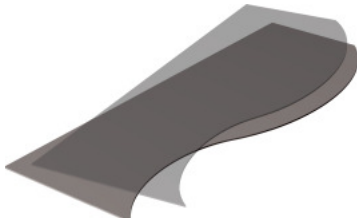


When the feeder places the blank on the previous station to the transfer, it can be positioned wrongly, either transverse or longitudinally. It will be then necessary to center the blank before it is moved to the first die. This operation can be made with **centring shovels**, which are used along with pincers.

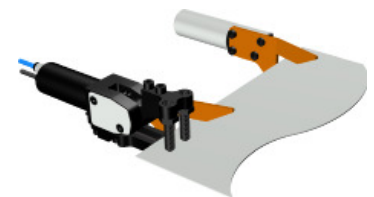
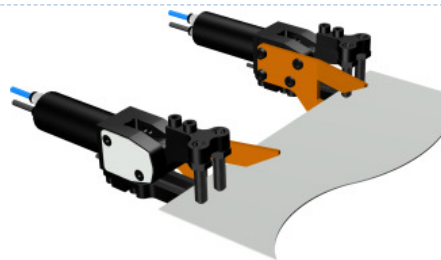
Position of the Blank

Possible Solutions

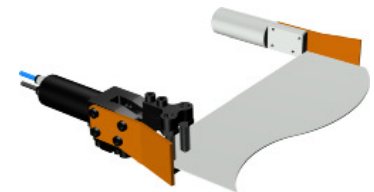
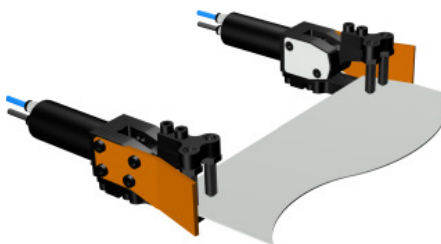
Off-center Blank



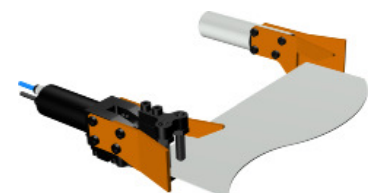
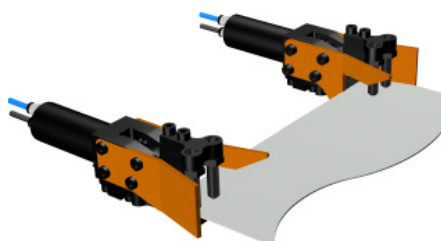
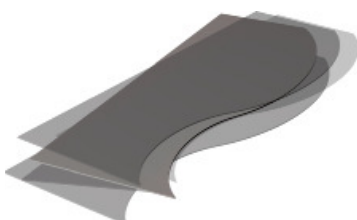
Slightly Off-center Blank



Advanced Blank



Sum of the Previous Examples



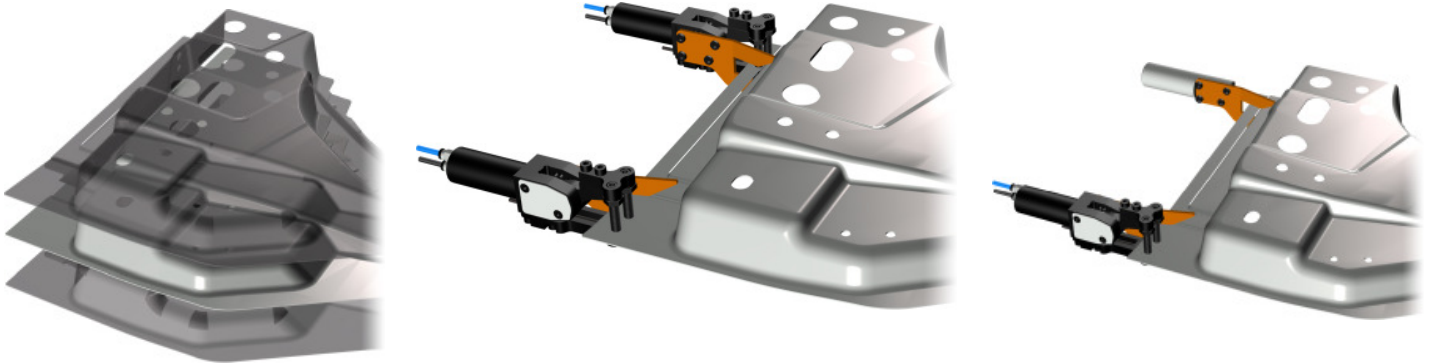
VERTICAL CENTRING OF STAMPED SHEETS

Once the sheet has been stamped, we cannot be sure that it has been positioned at the same height as the die. When the transfer goes in the die, pincers could collide with the sheet, and so the screws, the arm or the internal mechanism of the pincer would be damaged.

In these cases, it is recommended to **lead the sheet** into the pincer with **centring shovels**.

Position of the Sheet

Possible Solutions



Examples of Use of Vertical Centring Shovels

Apart from preventing pincers from being damaged, the advantages of using centring shovels are:

- The pincer's opening angle is reduced, so its cycle is shortened and **production is higher**.
- Smaller pincers may be used: they **take up less space**, they **consume** less compressed air, they are **lighter** and they have a **lower cost**.

For more information, check our "Transfer Press" catalogue on www.misati.com