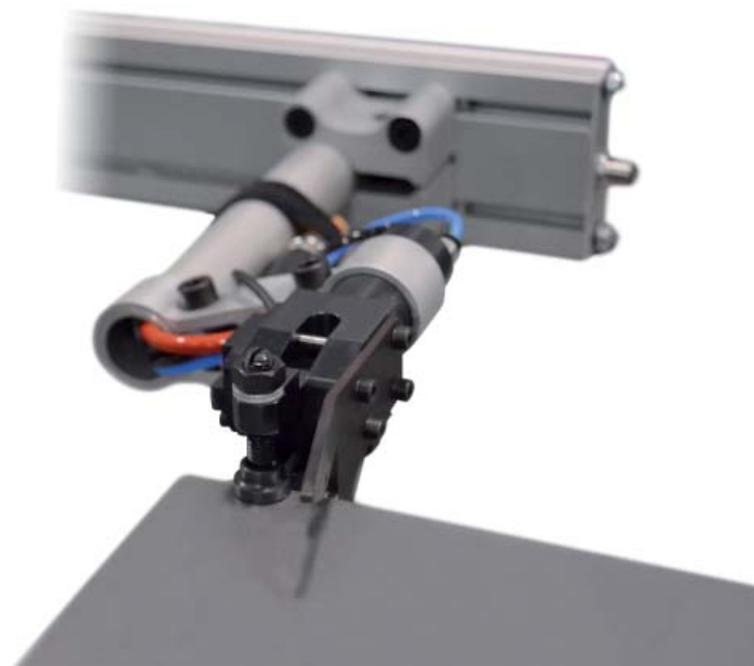## DOUBLE-THICKNESS SHEET-DETECTION CONTROL

During the stamping process, blanks may be soaked or lubricated in oil to avoid oxidation and to facilitate the cold sheet metal forming.

But, despite regular controls, this oil can make blanks stick together due to a capillary action, and so two blanks can be lifted at a time at the first die of the press.

If these two sheets have some kind of shape, dies can get damaged. Therefore, an unplanned production stoppage can last for several days while the damaged die is being repaired.

- Misati recommends to use a minipincer equipped with a **sheet thickness control device** (one minipincer per transfer is just enough). This minipincer will fasten and transfer the blank from the stacker or feeder to the first die and, in order to act accordingly, it will identify the presence of a single blank, no blank or a double blank in the die.

MINIPINCERS WITH A SHEET THICKNESS CONTROL DEVICE

TI-20-30-CE
TIP-20-30-CE

Minipincers ref.
TIP-20-30-CE or TI-20-30-CE
detect **sheet thickness equal or higher than 0.5 mm.**

DOUBLE-THICKNESS SHEET DETECTION

It is also possible to check the double sheet thickness in a **static** position of the blank. In this case, minipincer **TLR-20-15-CE** can be used in the previous position to transferring the blank into the first die.

The sensor of the minipincer prevents two blanks entering the transfer without stopping the production process.

TLR-20-15-CE

Minipincer ref. **TLR-20-15-CE** is recommended to be used with **thinner sheets,** as it is capable of detecting thicknesses of **0,25 mm.**

SHEET DETECTOR

After ensuring that a single sheet has entered the press, it is still necessary to control that the stamped sheet is correctly transferred during all the process. Therefore, all Misati minipincers are provided with a **sheet detector** which reports about the presence or absence of the sheet. Damages and production stoppages are then prevented, proving the maximum reliability of the process.

SHEET DETECTOR

TYPE: ST-01