

Master sheets: Description & uses

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Misati, expert in automating Transfer Presses, proposes using Master Sheets as a solution to reduce the transfer start-up time within just 30 minutes.

Traditional Adjustment: Press Downtime

Putting a transfer into operation has traditionally consisted of adjusting the spatial position of the pincers practically, i.e. manually, on the dies with the press stopped.

Such type of adjustment requires a great capacity for observation, apart from the experience and skill of the worker to know when the transferring process is a reliable one, as the adjustment may affect the 6 degrees of freedom.



Adjustment with Master Sheets: 30 Minutes

Thanks to the system of Master Sheets conceived by Misati, putting a lightweight transfer into operation becomes simpler and can get reduced to 30 minutes.

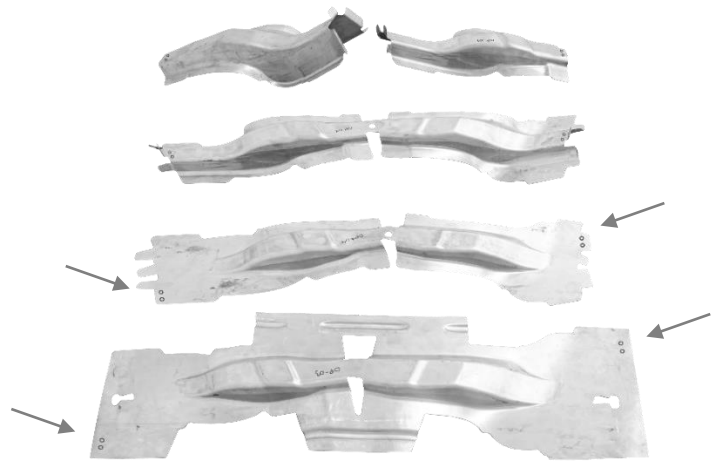


Description of Master Sheets

Master Sheets are a set of stamped sheets of all the operations of the transfer. They have been marked with the exact position where gripper fingers fasten the metal sheet.

What are they used for?

These marks that have been made on the sheet are taken as a **reference** to position the pincer.



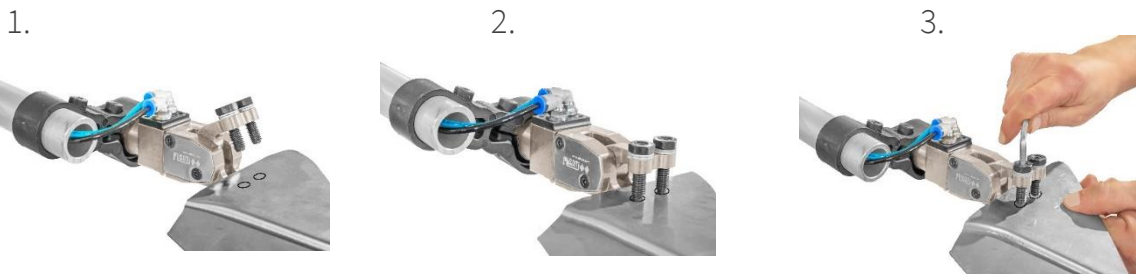
So, during the adjustment, Master Sheets enable us to adjust the pincer to the right position on the sheet in a few minutes and with no risk of making a mistake.

They are also useful in case of collision as the geometry of the pincers can be checked and readjusted quickly.

Putting a Transfer into Operation with Master Sheets

1. Master Sheets are placed on each die at the position of stamped & raised sheet (pickup point).
2. The transfer is moved towards the pickup position of the sheets according to the coordinates of the project.
3. The marks that have been made on the sheet are taken as a reference to position the pincer.

Manual adjustment



Adjustment with torque screwdriver

For maximum precision, we recommend the use of a torque-controlled screwdriver.



Video of pincer adjustment