

# OPERATING MANUAL

## 1. Description

The bar puller type SGF is intended to be used on CNC lathes with VDI tool turrets. It is designed to pull bar stocks and tubes into position for turning operations, if the lathes are not equipped with bar feeders. It is recommended to be used for small and medium size batch production.

- Clamping capacity with normal jaws: 6 – 56 mm
- Clamping capacity with reversed jaws: 56 – 110 mm
- Easy to setup and use
- Adjustable strong gripping force
- Rugged design and construction

## 2. Operation

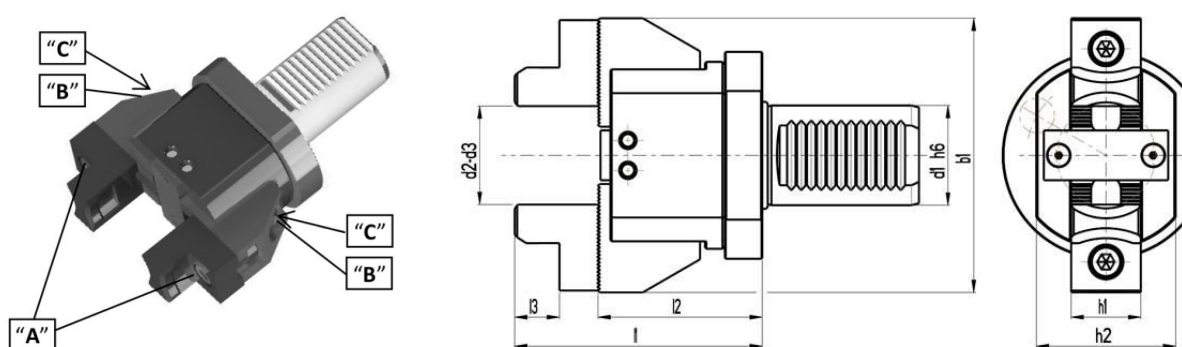
### 1. Setting the clamping distance of the jaws:

The clamping distance of the jaws should be 2-4 mm smaller than the workpiece diameter. To set the distance, move both jaws on serrated surfaces of the bar puller fingers and securely fix the jaws in a proper position with screws „A“.

### 2. Clamping force setting:

The clamping force depends on the material hardness, the surface state and the weight of the bar stock. The clamping force can be increased by turning the screws „B“ clockwise or decreased by turning them counterclockwise. Make sure to turn them with equal turns. When the screws are set, screw the nuts „C“ clockwise to secure them. The clamping force is set correctly, if the jaws are not slipping on the bar stock or the tube surface and there are no dents on the surface of the bar stock.

## 3. Dimensions



item	d1 mm	d2 mm	d3 mm	h1 mm	h2 mm	l1 mm	l2 mm	l3 mm	b1 mm	F kN
47-SGF32Z	cyl. 32	6-56	56-110	28	56	100	66	18	110	0,25-1,6
47-SGF20	20	6-56	56-110	28	56	100	66	18	110	0,25-1,6
47-SGF30	30	6-56	56-110	28	56	100	66	18	110	0,25-1,6
47-SGF40	40	6-56	56-110	28	56	100	66	18	110	0,25-1,6
47-SGF50	50	6-56	56-110	28	56	100	66	18	110	0,25-1,6