

# Minuteman 320<sup>V3</sup>

Automatic Magazine Bar Feeder for Fixed and Sliding Headstock CNC Lathes

**EDGE** TECHNOLOGIES



*Diameter range: 3mm to 25.4mm (0.118" to 1.00")  
27mm (1.062") max with bar prep*

*Bar length: 1000mm to 3800mm (39.4" to 12'5")*



**Rack Configuration.** True "Left to Right" or "Right to Left" rack configuration for easier loading.



**Dual Anti-Vibration Devices.** One is internal to the feeder and one attaches to the lathe headstock. These stabilize bar stock for max RPM and minimize guide channel set changeovers.



**Touchscreen HMI Control.** The HMI is user friendly with 300-part program storage. Schneider PLC motion control is Ethernet ready.

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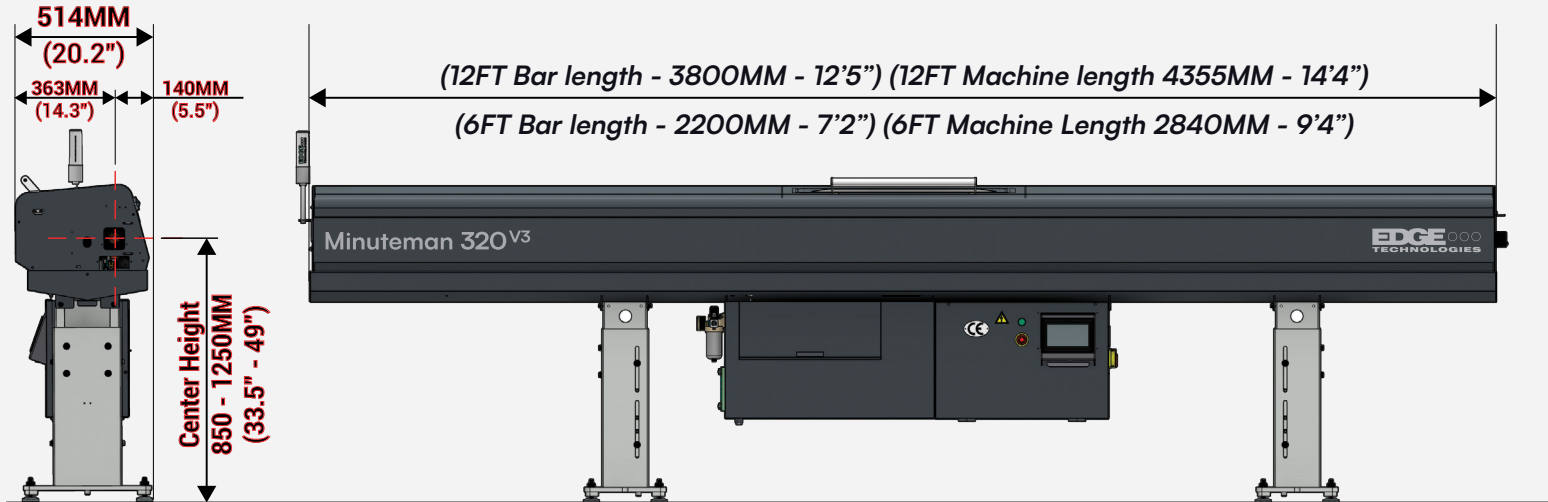
## Technical Data

<b>Bar Diameter</b> 3mm - 27mm (0.118" - 1.062")	<b>Operating voltage</b> 230 V/60Hz - 3 phase
<b>Bar Length</b> 1000mm (39.4") - 3800mm (12'5")	<b>Control voltage</b> 24V DC
<b>Magazine capacity</b> 254mm (10")	<b>Oil capacity</b> 46 liters (12 gallons)
<b>Remnant length</b> 355mm max. (14")	<b>Oil viscosity</b> ISO 100 cST - Machine oil ISO BG32 - Air oil
<b>Bar Loading Cycle Time</b> Approx. 35 seconds for 12' bars	<b>Compressed air supply</b> 6 bar (90 psi)
<b>Feed force (Pusher Torque)</b> Max 450 N, adjustable	<b>Compressed air consumption</b> Approx. 8 liters per loading cycle
<b>Forward feed rate</b> 593mm/sec (1400in/min) max, adjustable	<b>Machine Weight (without oil)</b> 600 kgs (1320 lbs)
<b>Return feed rate</b> 1000mm/sec (2360in/min) max, adjustable	<b>Material Straightness Spec.</b> 0.007" TIR/1ft of material (V blocks, 6" equidistant)
<b>Power consumption</b> 1.5 kW/2 kVA	<b>300 Part Program Storage</b> <b>PLC motion control is Ethernet ready.</b>

## Guide Channel Sizes

Guide Channel Sets	Pusher Diameter	Minimum Bar Size	Maximum Bar Size	*Maximum Bar Size with Front Remnant Expulsion
Ø 8mm	7.5mm	3mm (.118")	6.4mm (.250")	7mm (.275")
Ø 11mm	10mm	3mm (.118")	9mm (.354")	10mm (.393")
Ø 14mm	12mm	3.2mm (.125")	11mm (.437")	13mm (.512")
Ø 16mm	15mm	5mm (.196")	12.7mm (.500")	15mm (.594")
Ø 18mm	16mm	5mm (.196")	14.2mm (.562")	17mm (.669")
Ø 20mm	18mm	8mm (.315")	16.2mm (.640")	19mm (.750")
Ø 22mm	20 mm	8mm (.315")	19mm (.750")	21mm (.826")
Ø 24mm	22mm	8mm (.315")	20mm (.787")	23mm (.905")
Ø 28mm	25/27mm	10mm (.395")	25.4mm (1.000")	27mm (1.062")

\* This max diameter is attainable only if remnant is ejected through the lathe spindle or if one end of the bar stock is turned down to a smaller O.D. to accept a small O.D. collet.



## Edge Technologies

Bar feeding has remained the focus at Edge Technologies for 40+ years. Experience and breadth of model offerings drive our customer-centric approach to solving your bar feeding needs. Service, parts, and technical support have always been the backbone of the company, because we understand that performance and up-time of a bar feeder is a difference maker to your bottom line.

Scan here for more information about the Rebel 80 Servo V3



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