

Patriot 338 & 551

Automatic Magazine Bar Feeder for Fixed and Sliding Headstock CNC Lathes

EDGE ○○○
TECHNOLOGIES



Diameter range: 3mm to 38mm (0.118" to 1.500")
42mm (1.653") max with bar prep

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

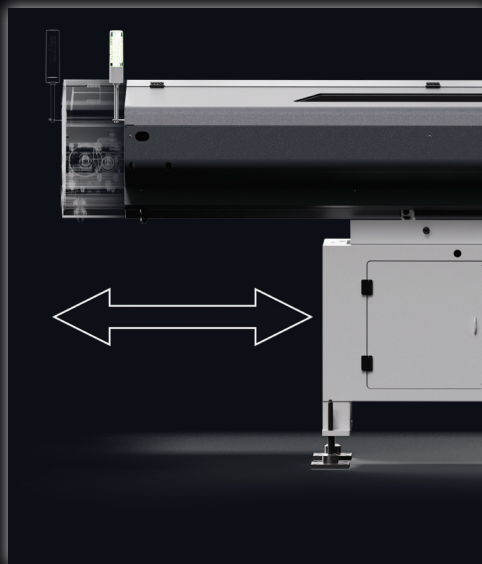
Diameter range: 5mm to 50.8mm (0.196" to 2")
54.5mm (2.145") max with bar prep

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



Improved user experience.

Larger windows and an internal LED light in the gripper area make setups easier and safer.



Z-axis shifting device.

Now standard on all models. Shift and lock down the chassis of the bar feeder to optimize Swiss, non-guide-bushing mode, and provide easy access for spindle liner changeover and maintenance.



Toolless guide channel set removal.

Next generation quick change guide channel sets minimize changeover times.

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Automatic Magazine Bar Feeder for Fixed and Sliding Headstock CNC Lathes



Technical Data

Bar diameter

Patriot 338: 3mm - 42mm
(0.118" - 1.653")

Patriot 551: 5mm - 54.5mm
(0.196" to 2.145")

Bar length

Patriot 338: 1000mm - 3800mm
(39.4" - 12'5")

Patriot 551: 1000mm - 3800mm
(39.4" - 12'5")

Magazine capacity

304mm (12")

Remnant length

406mm max. (16")

Bar loading cycle time

Approx. 30 sec (for 12' bars)

Feed force (Pusher torque)

Max 450 N, adjustable

Forward feed rate

593mm/sec (1400in/min) max,
adjustable

Return feed rate

1000mm/sec (2360in/min) max,
adjustable

Power consumption

1.5 kW/2 kVA

zOperating voltage

230 V/60Hz - 3 phase

Control voltage

24V DC

Oil capacity

57 liters (15 gallons)

Oil viscosity

ISO 100 cST - Machine oil

ISO BG32 - Air oil

Compressed air supply

6 bar (90 psi)

Compressed air consumption

Approx. 8 liters per loading cycle

Weight without oil

Patriot 338: 1130kg (2500lbs)

Patriot 551: 1225kg (2700lbs)

Material Straightness

Specifications
0.007" TIR/foot of material (V blocks,
6" equidistant)

300 Part Program Storage

PLC motion control is Ethernet
ready.

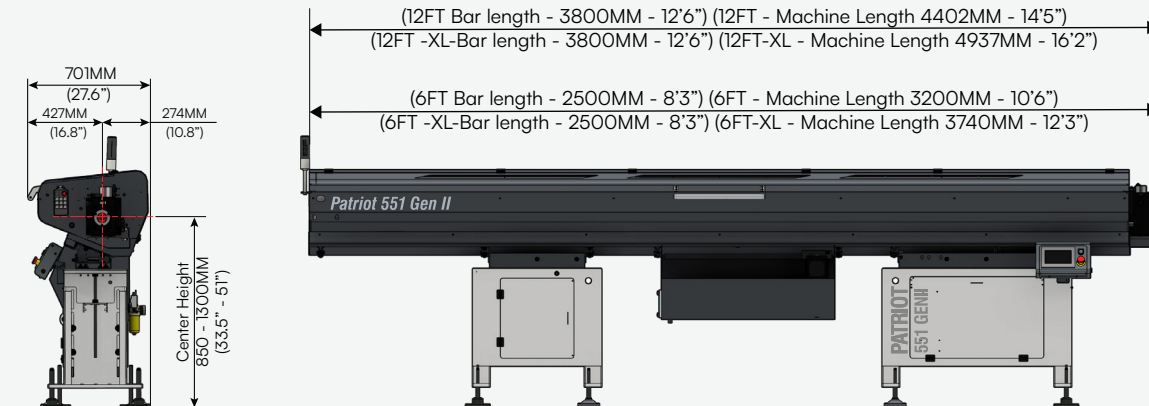
Guide Channel Sizes

Guide Channel Sets	Pusher Diameter	Minimum Bar Size	Maximum Bar Size	Maximum Bar Size with Front Remnant Expulsion*
Ø 13mm	12.5mm	3mm (0.118")	10mm (0.393")	12mm (0.472")
Ø 17mm	16.5mm	5mm (0.196")	15mm (0.591")	16mm (0.629")
Ø 21mm	20.5mm	8mm (0.315")	19mm (0.750")	20mm (0.787")
Ø 26mm	25.0mm	8mm (0.315")	22.2mm (0.875")	25mm (0.984")
Ø 28mm	27.5mm	10mm (0.393")	25.4mm (1.000")	27mm (1.062")
Ø 33mm	32.5mm	10mm (0.393")	28.5mm (1.125")	32mm (1.259")
Ø 36mm	34 or 35.5 mm	12.7mm (0.500")	32mm (1.260")	35mm (1.377")
Ø 39mm	38.0mm	15.8mm (0.625")	35.0mm (1.377")	38mm (1.500")
Ø 43mm	42.5mm	19mm (0.750")	38mm (1.500")	42mm (1.653")
Ø 46mm	45.5mm	22.2mm (0.875")	42.07mm (1.656")	44.5mm (1.750")
Ø 52mm	51.0mm	25.4mm (1.000")	47.75mm (1.880")	50.5mm (2.000")
Ø 56mm	55.0mm	25.4mm (1.000")	50.8mm (2.000")	54.5mm (2.145")

Patriot 338

Patriot 551

* 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 Patriot Gen II



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