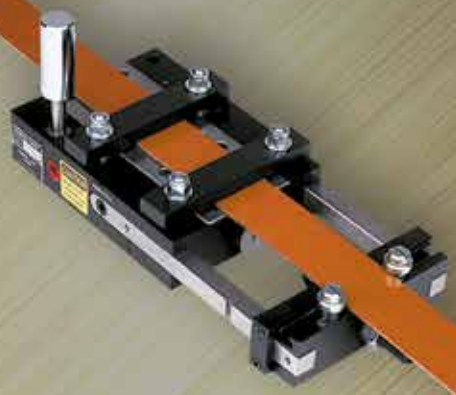
FEEDING & COIL HANDLING EQUIPMENT

RapidAir

PRODUCTION LINES

INDIVIDUAL PRODUCTS



CUSTOM SOLUTIONS

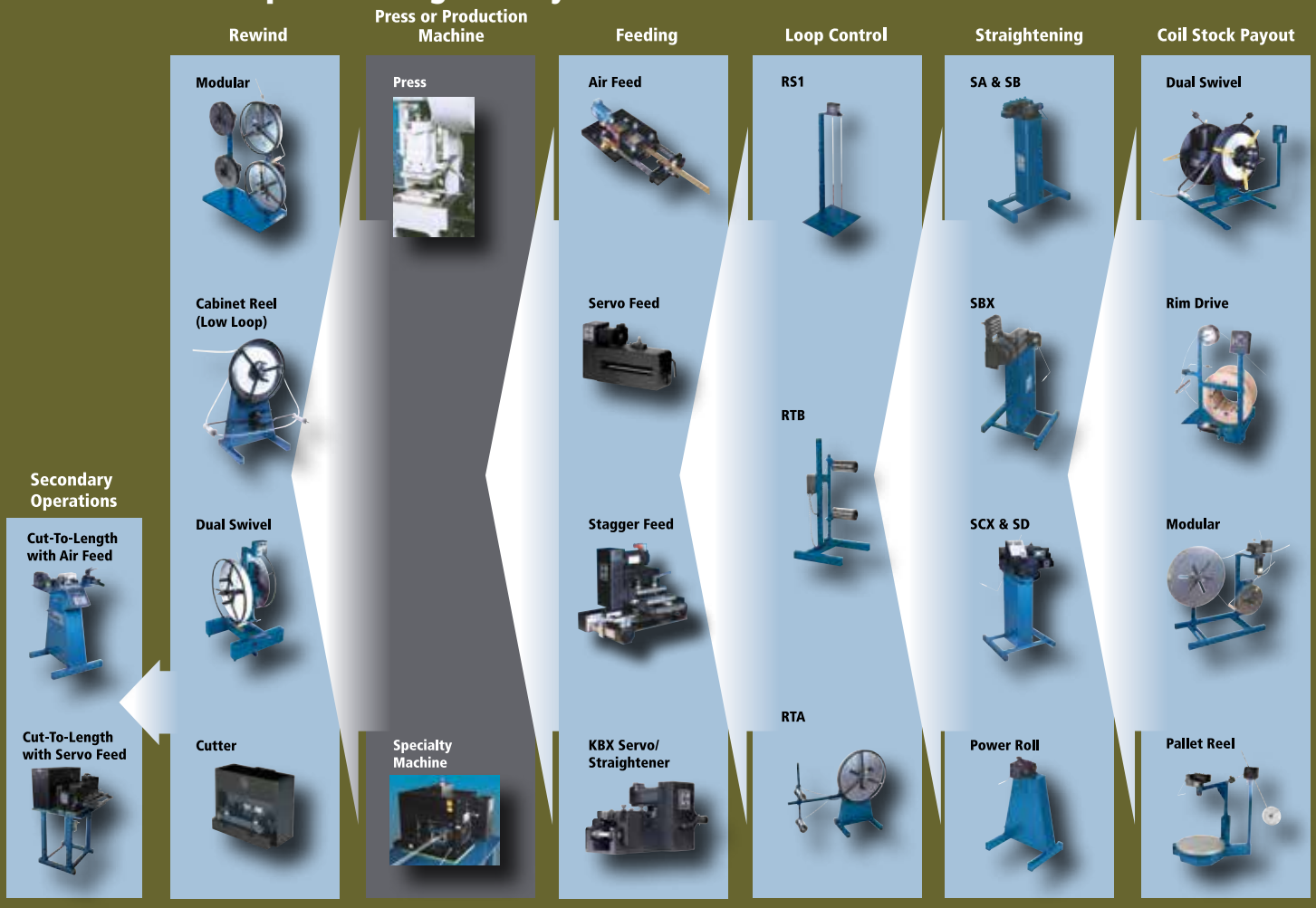
Feeding & Coil Handling Equipment

Contents

Complete Production Lines

Easy to set up. Perfectly matched. User-friendly controls.

Build Your Own Rapid-Air Integrated System



Feeding & Coil Handling Equipment

Individual Products

Easy to integrate into your existing stamping operation.

Innovation.

- Reliability, performance and innovation are engineered into every component we market.
- Rapid-Air began as a stamping operation over a half century ago. We felt the feeding and coil handling equipment the industry offered at that time was unsatisfactory, so we began to innovate our own line. In the same engineering spirit, we continue to design new, superior material handling solutions today. Equipment that can drastically increase your profitability.
- Compare and see why Rapid-Air products are the choice of leading stamping operations the world over.

Accuracy and dependability.

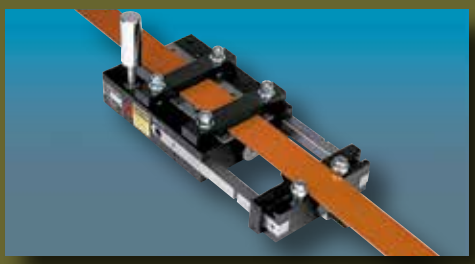
- Dependably built Rapid-Air products are designed for precision control at high productivity levels.
- When semi-finished or finished parts can't be subjected to buckling, distortion or scratching, depend on Rapid-Air.

Easy and versatile.

- Versatile Rapid-Air products are easy to integrate into your existing stamping operation.
- With our wide range of models, we have the right equipment for your specific application.
- Set-up and operation are easy and maintenance requirements are minimized.

Lasting performance and value.

- All Rapid-Air products are built with no-compromise materials and quality workmanship throughout.
- New manufacturing techniques have resulted in simplified designs and lower costs passed on to you.
- Unlike some manufacturers who supply equipment built from low bid off-shore components, we design and build all Rapid-Air products right here in our own U.S. factories. No inconsistent design, differing parts or sourcing problems. Just the same reliable quality, renowned support and lasting value you can always expect from Rapid-Air.



Air Feeds – Rapid-Air is the pioneer and still the leader. Widest selection, accessories and options anywhere.

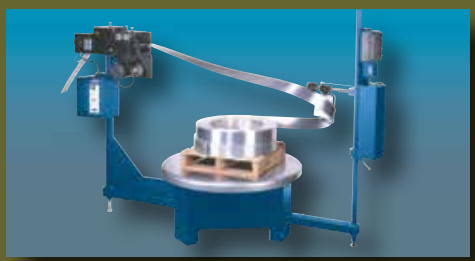
Mini-Servos – So economical you can mount it on the die and leave it on the die.

Servo Feeds – Redesigned. New manufacturing techniques bring you lowest cost, highest quality, lowest maintenance servo line ever.

Stagger Feeds – Produces the most parts from least amount of material.

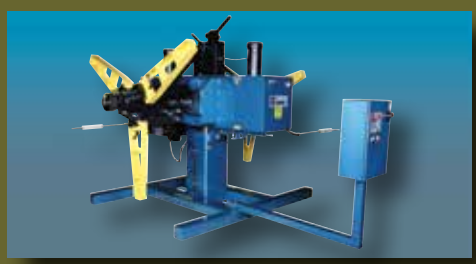
Stock Straighteners – Patented platen is unmatched at smoothing ripples, removing coil set, setting curvature.

Stock Reels – Flexibility, precise control, utmost reliability. Powered, non-powered. Hydraulic expansion and brakes.



Pallet Decoilers – Leave coils on pallets and reduce handling. Precise payout for high speed, high volume.

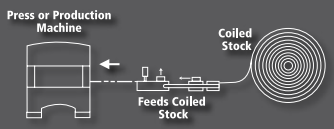
Cutters – Pivoting arm for round or flat stock. Reciprocating blade for flat stock.

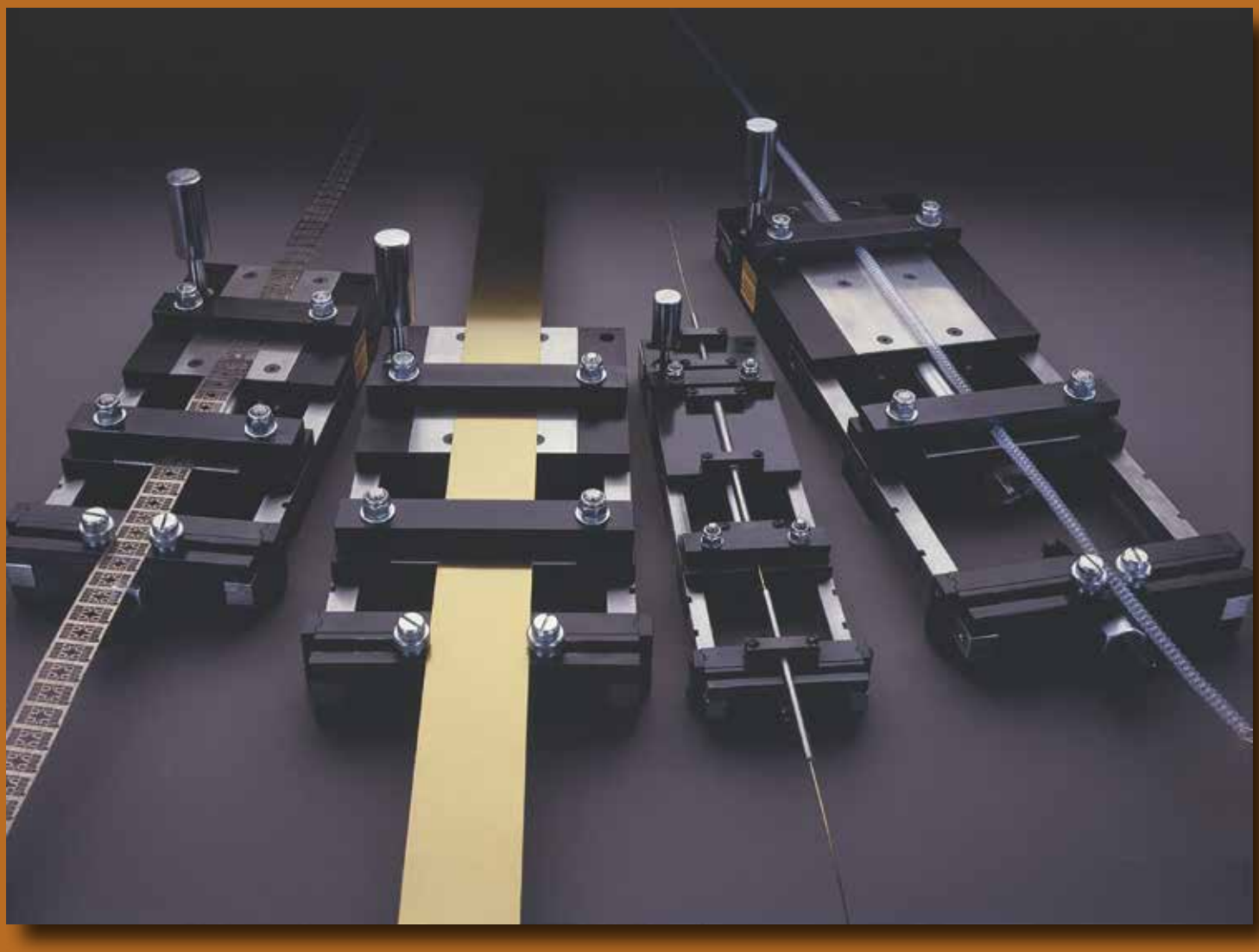


Dual Swivel Reels – For heavy-duty coil handling. Quick changeover minimizes downtime.

Transporters – Conveys scrap or parts quickly and economically. Compact, low under-die profile.

Air Feeds





Rapid-Air Feeds

Rapid-Air gives you more choices.

Improve production with faster material flow speeds and uniform accurate progressions.
Rapid-Air pioneered the first compact air feed with internal air circuitry, setting the technological and performance standards for the industry. The unique dual air valve system provides outstanding performance backed by reliability that has made Rapid-Air the recognized innovator and leader in air feed technology.

Superior versatility.
Rapid-Air feeds offer unmatched production flexibility. Their cost-effective operation often justifies permanent installation on die sets to minimize job setup time.

Easy installation and removal make Rapid-Air units the most versatile type of feeding equipment available. Two bolts are all it takes to install one. Stroke length and speed adjustments are positioned for easy access.

Feed a variety of material in any direction.
All kinds of coil stock plus paper, plastic, wire, fabrics, foil, tubing, extruded and preformed shapes can be fed at short and long progressions, and at different production speeds. Rapid-Air feeds are unequalled in handling both thin and delicate materials. Several actuation options allow our feeds to be used on standard production presses, electric presses, hydraulic presses, wire forming machines, multi-slide machines and special machines.

We offer a comprehensive range of standard models to feed flat stock up to 16″ (406mm) wide, .150″ (3.81mm) thick, and in lengths up to 20″ (508mm). Pulling capacities of up to 250 pounds (114kg) are available on heavy duty models. Our smallest feed is capable of 260 cycles per minute at a 2″ (50.8mm) progression and can cycle much faster at shorter progressions. Special models are available to meet unusual feeding requirements.

Air Feeds

Rapid-Air Feeds

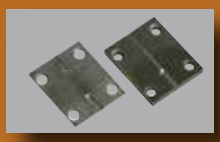
Rapid-Air gives you more choices.

Accessories and options.

Many accessories and options tailor Rapid-Air feeds to a variety of applications to feed metals, wire, plastic, fabric, you name it; and in most any shape including – flat, round, extrusions, etc.

Electric actuating valve.
An alternate to the standard actuating valve provided with each feed. Electric valve 2-way, normally open, 115 vac/60hz one size for series A & B feeds, one for Series C, D, F, H, J & W feeds, and another with quick exhaust for Series L, P, FX & LX.

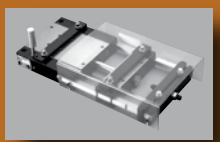
Custom stock & feed clamps.
To accommodate special material configurations, such as extrusions, delicate surfaces or soft, pliable materials. Rubber, leather, nylon and vinyl are among the clamp insert materials available.



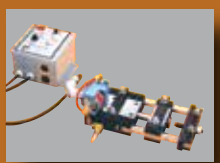
Special wear plates.
Replaceable wear plates can be grooved to accommodate special shapes and sizes.

Anti-buckling guides.
Specialty designed guides to prevent buckling of very thin flat or wire stock feeding at high speeds and/or long progressions.

Belt feed.
Enables feeds to accurately feed very limp delicate stock, including metals, teflon and other tapes, foil strips, fabrics, paper, photographic film and gasket materials. Material (even skeleton) is sandwiched between two endless belts to move it into or out of a press or other machines.



Safety guards.
See-through high-strength plastic safety guard shields the moving mechanism. For applications where safety requirements include machine guarding.



Multi-stroke control.
Provides longer stroke progressions between press strokes by cycling feed several times prior to a press stroke. Equipped with electric valve and fittings. Standard control variable up to 9 feed cycles - other control models available. All feed series can be used with the multi-stroke control.

Pilot release stock clamp.
The spring-loaded stock clamp, optional with all Rapid-Air feeds, is recommended for most applications. For unusual requirements, the pilot release stock clamp is available. An electric signal actuates the pilot release clamp so that it lifts completely to allow for free movement of stock to position material when pilots are used. Solenoid valve not included. Order separately from Rapid-Air.

Model Selection

Model	Max Material Width	Max Stroke Length*1	Stock Thickness*2	Speed Cycles/ Min. (recom.) *3	Pulling Capacity*4
A2	1-1/2" (38.1mm)	2" (50mm)	.002" - .040" (.051-1.02mm)	260	20 lbs (9.1kg)
A4	1-1/2" (38.1mm)	4" (101mm)	.002" - .040" (.051-1.02mm)	200	20 lbs (9.1kg)
A6	1-1/2" (38.1mm)	6" (152mm)	.002" - .040" (.051-1.02mm)	160	20 lbs (9.1kg)
B2	2-1/2" (63.5mm)	2" (50mm)	.002" - .040" (.051-1.02mm)	230	20 lbs (9.1kg)
B4	2-1/2" (63.5mm)	4" (101mm)	.002" - .035" (.051-0.89mm)	175	20 lbs (9.1kg)
C3	3" (76.2mm)	3" (76mm)	.003" - .075" (.076-1.91mm)	195	45 lbs (20.5kg)
C6	3" (76.2mm)	6" (152mm)	.003" - .062" (.076-1.57mm)	140	45 lbs (20.5kg)
C12	3" (76.2mm)	12" (305mm)	.003" - .062" (.076-1.57mm)	85	45 lbs (20.5kg)
D3	4" (101.6mm)	3" (76mm)	.003" - .075" (.076-1.91mm)	175	45 lbs (20.5kg)
D6	4" (101.6mm)	6" (152mm)	.003" - .062" (.076-1.57mm)	135	45 lbs (20.5kg)
W6	2" (50.8mm)	6" (152mm)	.003" - .090" (.076-2.29mm)	140	100 lbs (45.5kg)
W12	2" (50.8mm)	12" (305mm)	.003" - .062" (.076-1.57mm)	85	100 lbs (45.5kg)
W20	2" (50.8mm)	20" (508mm)	.003" - .050" (.076-1.27mm)	50	100 lbs (45.5kg)
F4	6" (152mm)	4" (101mm)	.004" - .075" (.1-1.91mm)	160	100 lbs (45.5kg)
F6	6" (152mm)	6" (152mm)	.004" - .075" (.1-1.91mm)	130	100 lbs (45.5kg)
F12	6" (152mm)	12" (305mm)	.004" - .050" (.1-1.27mm)	70	100 lbs (45.5kg)
F20	6" (152mm)	20" (508mm)	.004" - .035" (.1-0.89mm)	35	100 lbs (45.5kg)
H4	8" (203mm)	4" (101mm)	.004" - .075" (.1-1.91mm)	160	100 lbs (45.5kg)
H8	8" (203mm)	8" (203mm)	.004" - .062" (.1-1.57mm)	105	100 lbs (45.5kg)
FX6	6" (152mm)	6" (152mm)	.005" - .150" (.13-3.81mm)	105	145 lbs (66kg)
FX12	6" (152mm)	12" (305mm)	.005" - .150" (.13-3.81mm)	60	145 lbs (66kg)
L6	12" (305mm)	6" (152mm)	.005" - .090" (.13-2.29mm)	105	145 lbs (66kg)
L12	12" (305mm)	12" (305mm)	.005" - .090" (.13-2.29mm)	60	145 lbs (66kg)
P6	16" (406mm)	6" (152mm)	.005" - .075" (.13-1.91mm)	105	145 lbs (66kg)
P12	16" (406mm)	12" (305mm)	.005" - .062" (.13-1.57mm)	60	145 lbs (66kg)
LX12	12" (305mm)	12" (305mm)	.005" - .125" (.13-3.18mm)	50	250 lbs (114kg)

*1 Electric Actuating Valve is recommended for feeds that have stroke length over 8" (203mm). Add "E" to model number.
*2 Thinner materials and/or long strokes with thin materials possible by using anti-buckling guides. Maximum thickness capacity increases by same percentage as stock width decreases (up to max. of 150%).
*3 Approximate at maximum stroke length. Heavy stock requires slower speeds.
*4 At 100 psi (6.9 bar). (Includes allowance for normal friction of moving parts).

Add "W" to Model A or B for replaceable wear plates (standard on all other models).
Add "P" to model no. for feed with control port only. Add "S" to model no. for feed with end-of-stroke sensors.
Feeds should always draw material from a free loop, supplied by a powered reel or powered straightener.

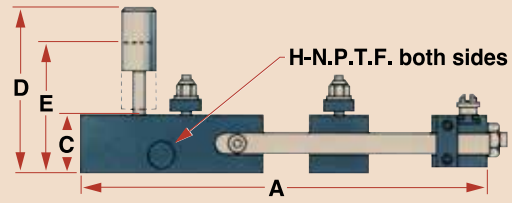
Air Feeds

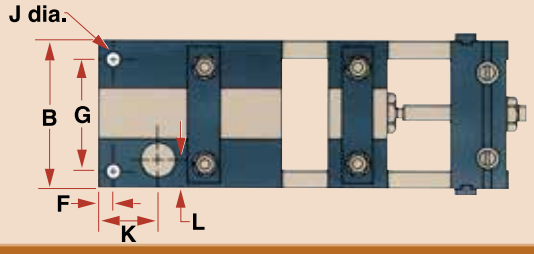
Specifications and Dimensions

Compact and versatile. Conveniently and easily mounted where you need them.

Specifications and Dimensions

Model	A	B	C	D	E	F	G	H	J	K	L
A2	8.69" (220mm)	3.22" (81mm)	1.24" (31mm)	3.50" (88mm)	2.69" (68mm)	0.38" (9mm)	2.62" (66mm)	1/8 (3mm)	.33 (8mm)	1.31 (33mm)	.50 (12mm)
A4	12.69" (322mm)	3.22" (81mm)	1.24" (31mm)	3.50" (88mm)	2.69" (68mm)	0.38" (9mm)	2.62" (66mm)	1/8 (3mm)	.33 (8mm)	1.31 (33mm)	.50 (12mm)
A6	16.69" (423mm)	3.22" (81mm)	1.24" (31mm)	3.50" (88mm)	2.69" (68mm)	0.38" (9mm)	2.62" (66mm)	1/8 (3mm)	.33 (8mm)	1.31 (33mm)	.50 (12mm)
B2	8.69" (220mm)	4.22" (107mm)	1.24" (31mm)	3.50" (88mm)	2.69" (68mm)	0.38" (9mm)	3.62" (91mm)	1/8 (3mm)	.33 (8mm)	1.31 (33mm)	.50 (12mm)
B4	12.69" (322mm)	4.22" (107mm)	1.24" (31mm)	3.50" (88mm)	2.69" (68mm)	0.38" (9mm)	3.62" (91mm)	1/8 (3mm)	.33 (8mm)	1.31 (33mm)	.50 (12mm)
C3	12.25" (311mm)	5.50" (139mm)	1.73" (43mm)	5.50" (139mm)	4.12" (104mm)	0.50" (12mm)	4.50" (114mm)	1/4 (6mm)	.39 (9mm)	1.53 (38mm)	.62 (15mm)
C6	18.25" (463mm)	5.50" (139mm)	1.73" (43mm)	5.50" (139mm)	4.12" (104mm)	0.50" (12mm)	4.50" (114mm)	1/4 (6mm)	.39 (9mm)	1.53 (38mm)	.62 (15mm)
C12	30.25" (768mm)	5.50" (139mm)	1.73" (43mm)	5.50" (139mm)	4.12" (104mm)	0.50" (12mm)	4.50" (114mm)	1/4 (6mm)	.39 (9mm)	1.53 (38mm)	.62 (15mm)
D3	12.25" (311mm)	6.50" (165mm)	1.73" (43mm)	5.50" (139mm)	4.12" (104mm)	0.50" (12mm)	5.50" (139mm)	1/4 (6mm)	.39 (9mm)	1.53 (38mm)	.62 (15mm)
D6	18.25" (463mm)	6.50" (165mm)	1.73" (43mm)	5.50" (139mm)	4.12" (104mm)	0.50" (12mm)	5.50" (139mm)	1/4 (6mm)	.39 (9mm)	1.53 (38mm)	.62 (15mm)
W6	19.94" (506mm)	5.00" (127mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.69" (17mm)	4.25" (107mm)	1/4 (6mm)	.53 (13mm)	2.62 (66mm)	.56 (14mm)
W12	31.94" (811mm)	5.00" (127mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.69" (17mm)	4.25" (107mm)	1/4 (6mm)	.53 (13mm)	2.62 (66mm)	.56 (14mm)
W20	47.94" (1217mm)	5.00" (127mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.69" (17mm)	4.25" (107mm)	1/4 (6mm)	.53 (13mm)	2.62 (66mm)	.56 (14mm)
F4	15.62" (396mm)	9.25" (234mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.62" (15mm)	7.50" (190mm)	1/4 (6mm)	.53 (13mm)	2.16 (54mm)	.56 (14mm)
F6	19.62" (498mm)	9.25" (234mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.62" (15mm)	7.50" (190mm)	1/4 (6mm)	.53 (13mm)	2.16 (54mm)	.56 (14mm)
F12	31.62" (803mm)	9.25" (234mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.62" (15mm)	7.50" (190mm)	1/4 (6mm)	.53 (13mm)	2.16 (54mm)	.56 (14mm)
F20	47.62" (1209mm)	9.25" (234mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.62" (15mm)	7.50" (190mm)	1/4 (6mm)	.53 (13mm)	2.16 (54mm)	.56 (14mm)
H4	15.62" (396mm)	11.25" (285mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.62" (15mm)	9.50" (241mm)	1/4 (6mm)	.53 (13mm)	2.16 (54mm)	.56 (14mm)
H8	23.62" (599mm)	11.25" (285mm)	1.98" (50mm)	5.75" (146mm)	4.31" (109mm)	0.62" (15mm)	9.50" (241mm)	1/4 (6mm)	.53 (13mm)	2.16 (54mm)	.56 (14mm)
FX6	23.38" (593mm)	10.00" (254mm)	2.48" (62mm)	7.38" (187mm)	5.38" (136mm)	0.62" (15mm)	8.00" (203mm)	1/2 (12mm)	.66 (16mm)	3.84 (97mm)	.88 (22mm)
FX12	35.38" (898mm)	10.00" (254mm)	2.48" (62mm)	7.38" (187mm)	5.38" (136mm)	0.62" (15mm)	8.00" (203mm)	1/2 (12mm)	.66 (16mm)	3.84 (97mm)	.88 (22mm)
L6	23.38" (593mm)	16.50" (419mm)	2.48" (62mm)	7.38" (187mm)	5.38" (136mm)	1.00" (25mm)	14.00" (355mm)	1/2 (12mm)	.66 (16mm)	3.84 (97mm)	1.53 (38mm)
L12	35.38" (898mm)	16.50" (419mm)	2.48" (62mm)	7.38" (187mm)	5.38" (136mm)	1.00" (25mm)	14.00" (355mm)	1/2 (12mm)	.66 (16mm)	3.84 (97mm)	1.53 (38mm)
P6	23.39" (594mm)	20.48" (520mm)	2.48" (62mm)	7.38" (187mm)	5.38" (136mm)	1.00" (25mm)	18.00" (457mm)	1/2 (12mm)	.66 (16mm)	3.84 (97mm)	1.53 (38mm)
P12	35.39" (898mm)	20.48" (520mm)	2.48" (62mm)	7.38" (187mm)	5.38" (136mm)	1.00" (25mm)	18.00" (457mm)	1/2 (12mm)	.66 (16mm)	3.84 (97mm)	1.53 (38mm)
LX12	35.39" (898mm)	18.00" (457mm)	2.98" (75mm)	7.88" (200mm)	6.00" (152mm)	1.00" (25mm)	14.00" (355mm)	1/2 (12mm)	.66 (16mm)	3.59 (91mm)	2.24 (56mm)

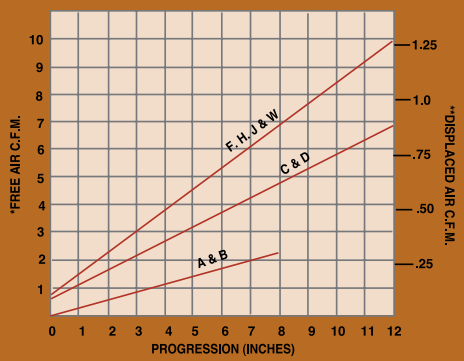




NOTE: CAD files available on request.

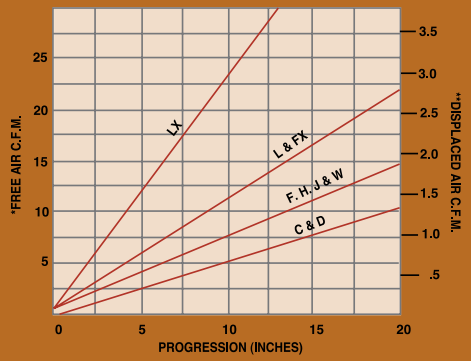
Air Consumption and Speed by Model Series

FEED AIR CONSUMPTION



* FREE AIR AT 100 PSI – 100 CYCLES/MIN.
** FEED DISPLACEMENT, C.F.M. – 100 CYCLES AT OPERATING PRESSURE

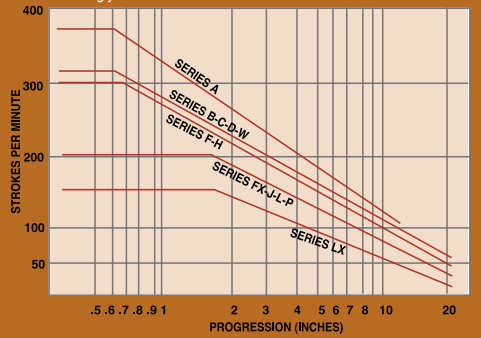
FEED AIR CONSUMPTION



* FREE AIR AT 100 PSI – 100 CYCLES/MIN.
** FEED DISPLACEMENT, C.F.M. – 100 CYCLES AT OPERATING PRESSURE

SPEED VS. PROGRESSION

The following graph indicates recommended maximum speeds anticipated for various progressions within each feed series (using an average stock thickness for each series). Feeding heavier stock would lower the maximum speed limit accordingly.



Air Feeds

The pioneer and still the leader.

Why Rapid-Air Feeds help make your precision stamping operation more profitable.

Eliminate marring, buckling and distortion.
An exclusive patented dual air valve system provides the correct clamping/feeding sequence essential in eliminating marring, buckling and distortion. One valve actuates the feed and stock clamp while the other actuates the slide block. As the valves operate in exact sequence, the material is always clamped before the slide block moves. This system allows Rapid-Air feeds to be controlled by an electric valve instead of a standard actuating valve, if desired.

Large Rapid-Air Models, Series C through LX, have dual cushion pistons that buffer shock from the back and forth travel of the slide block to smooth material flow.

There is no other air feed circuitry designed that can outperform the Rapid-Air dual valve system.

Our stock guide rollers keep stock moving the way it should.
No binding, side slipping or flopping up and down.

All adjustments for speed and stroke lengths are convenient and easy to make.
Maintain accurate settings using a screw for fine adjustments and stop block clamp for course adjustments.

Slide block forward speed control.
This adjustment opens and closes the air orifice and meters the air flow.

Innovative sealing system reduces friction and prevents debris from entering the feed body.
Specially designed by Rapid-Air engineers, the sealing assembly also prevents pressroom debris from entering the feed body.

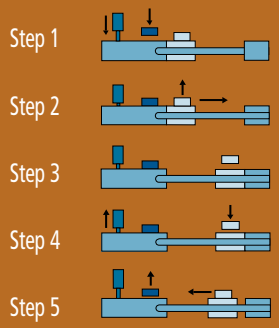
Mount Rapid-Air feeds conveniently and easily where you need them.
Rapid-Air feeds have few mounting limitations. They can be set up in a matter of minutes and very simply moved from machine to machine or die to die. Feed from right-to-left or left-to-right, from the back of a press, or in many other special applications. A single air line is all that is required. Alternate air inlets add to installation simplicity. Rapid-Air feeds are not position sensitive.

Internal or external actuation.
Rapid-Air feeds do not require any mechanical linkage to the crankshaft. The feed cycle can be internally actuated with the mechanical valve built into the feed, or externally actuated with optional electric or air-operated control valves. An adjustable bracket and actuator to mount on the punch holder or ram of a press are furnished with each unit.

Air Feed Operating Sequence

Step	Actuating Valve Status	Stock Clamp Status	Feed Clamp Status	Slide Block Status
1	Starts Down	Closes	Closed*	Forward
2	Down	Closed	Open	Starts Retracting
3	Down	Closed	Open	Retracted
4	Starts Up	Closed*	Closes	Retracted
5	Up	Open	Closed	Feeding

*Temporarily



Add-on flat stock and wire straighteners for air feeds.
Models SO and WO can be attached to our air feeds for special light duty applications.

Rapid-Air units are simple to service. All internal parts are readily accessible. Service videos may be downloaded from the Rapid-Air web site. AutoCAD assembly files may be e-mailed to you for design assist.

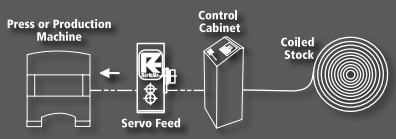
Model TC3 & TW6 Transporters

- Conveys scrap or parts quickly and economically.
- Crisp, sharp tray action shuffles parts off faster.
- Eliminates costly conveyors and belt replacement.
- Compact low profile for better clearance.
- Easily mounted. Perfect for tight areas.
- Low cost, long life wear parts.
- Low maintenance.
- Precision designed and built with the same rugged reliability as our Rapid-Air feeds.
- Air pressure operating range 20 to 80 psi (1.4 to 5.5 bar). Easy access speed adjustment screw for fine tuning.
- Easily moves 10 lbs. (4.5kg) at 40 psi (2.8 bar) air pressure.
- Accepts higher pressures for heavier loads.
- Special shuttle trays, tray surfaces and accessories available.
- Convey high temperature parts.

Model Selection

Model	Load Capacity	Recom. Speed SPM (adj)	Feed Rate (per min)	Air Pressure Range
TC3	10 lbs (4.5kg)	175	300" (7.6m)	20-80 psi (1.4 - 5.5 bar)
TW6	20 lbs (9.0kg)	175	350" (8.9m)	20-80 psi (1.4 - 5.5 bar)

Servo Feeds



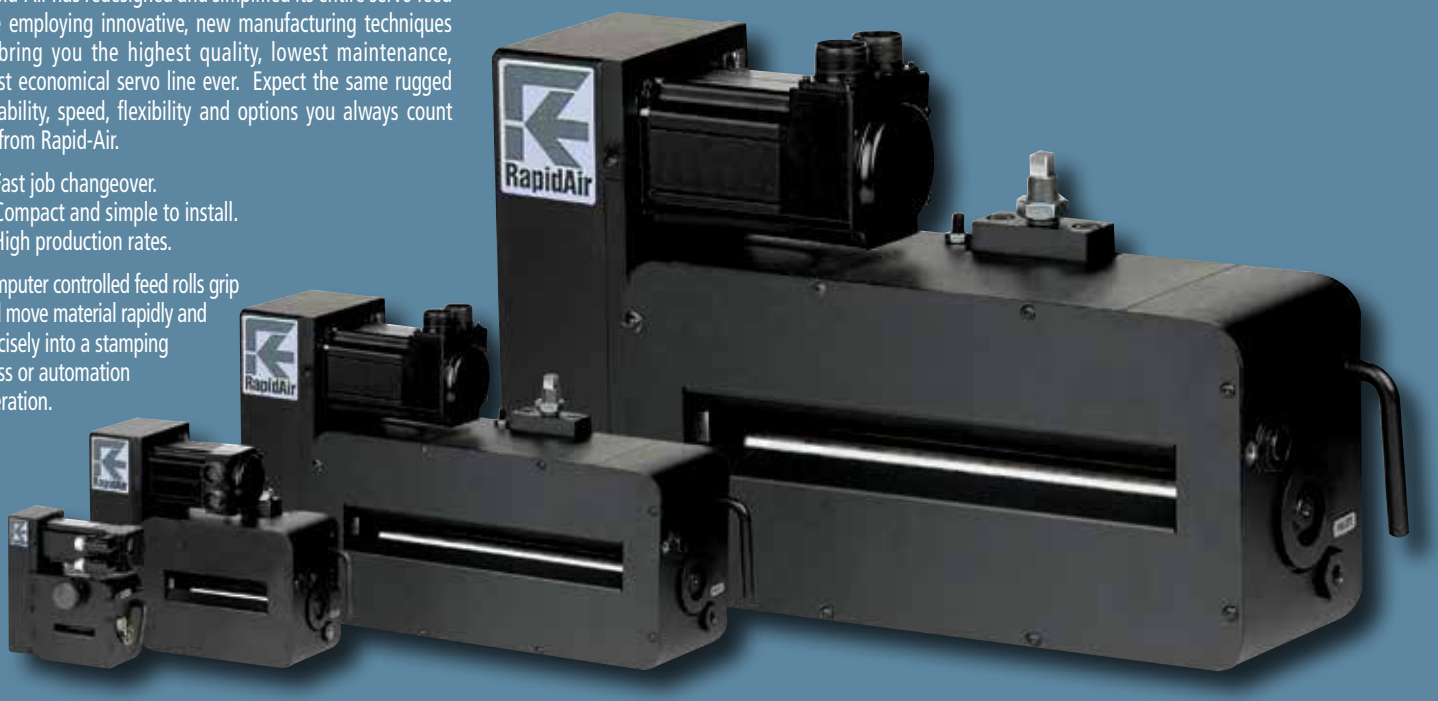
Mini, 100D, 100T, 200T, 200TX

For hard driving, fast, accurate production.

Rapid-Air has redesigned and simplified its entire servo feed line employing innovative, new manufacturing techniques to bring you the highest quality, lowest maintenance, most economical servo line ever. Expect the same rugged reliability, speed, flexibility and options you always count on from Rapid-Air.

- Fast job changeover.
- Compact and simple to install.
- High production rates.

Computer controlled feed rolls grip and move material rapidly and precisely into a stamping press or automation operation.



MiniServo and Control

Model Selection

How to select the Rapid-Air Servo Feed model that is right for you.

Primary considerations in selecting a servo feed should be material thickness, width and press speed. Once the model series has been selected, review the description in the Model Selection Guide below for features associated with that model. If questions remain, call a Rapid-Air sales engineer for guidance.

Model Selection

Model	Max Material Width	Max Thickness Capacity at Full Width	Max Feed Roll Roll Opening	Standard Roll Type	AC Input Power
MiniServo				Hardened & Ground Standard	115V, 1ph, 60hz
MS2	2" (51mm)	.040" (1.02mm)	.060" (1.52mm)		
MS4	4" (102mm)	.040" (1.02mm)	.060" (1.52mm)		
MS8	8" (203mm)	.031" (.79mm)	.060" (1.52mm)		
100D Series					
106D	6" (152mm)	.085" (2.15mm)	.150" (3.81mm)		
112D	12" (305mm)	.060" (1.52mm)	.150" (3.81mm)		
118D	18" (457mm)	.045" (1.14mm)	.150" (3.81mm)		
Standard 100T Series					230V, 3ph, 60hz
106T	6" (152mm)	.105" (2.66mm)	.150" (3.81mm)		
112T	12" (305mm)	.080" (2.03mm)	.150" (3.81mm)		
118T	18" (457mm)	.065" (1.65mm)	.150" (3.81mm)		
Standard 200T Series					
208T	8" (203mm)	.105" (2.66mm)	.180" (4.57mm)		
212T	12" (305mm)	.095" (2.41mm)	.180" (4.57mm)		
218T	18" (457mm)	.085" (2.15mm)	.180" (4.57mm)		
224T	24" (610mm)	.075" (1.91mm)	.180" (4.57mm)		
Heavy Duty 200TX Series					
208TX	8" (203mm)	.125" (3.18mm)	.180" (4.57mm)		
212TX	12" (305mm)	.125" (3.18mm)	.180" (4.57mm)		
218TX	18" (457mm)	.100" (2.54mm)	.180" (4.57mm)		
224TX	24" (610mm)	.100" (2.54mm)	.180" (4.57mm)		

Model Selection Guide

MODEL	DESCRIPTION
MiniServo – 115 VAC MS2, MS4 & MS8 (.040 max. material thickness, 8" wide maximum, 250 S.P.M.)*	Economical programmable roll feed, 99 job storage, feed advisor, wide range of accessories. Ideal for shops making transition from air feeds. MiniServo feeds are economical enough to mount and leave on the die, saves set-up time. Compact size makes the Mini ideal for automation equipment.
100D Series – 115 VAC (.085 max. material thickness, 18" wide maximum, 400 S.P.M.)*	Programmable roll feed, 99 job storage, feed advisor, feed complete signal, Data Instruments and Link Press control compatible, batch count, adjustable speed, acceleration/deceleration. Wide range of accessories, higher speed than MS Series with the convenience of 115 VAC.
100T Series – 230 VAC (.105 max. material thickness, 18" wide maximum, 450 S.P.M.)*	Similar to 100D Series but with more capacity, speed and torque. See table.
200T Series – 230 VAC (.105 max. material thickness, 24" wide maximum, 500 S.P.M.)*	This Servo feed group has everything the 100T Series has plus larger feed roll diameter. Higher capacity and speed. Air regulated feed roll pressure and standard air pilot release.
200TX Series – 230 VAC (.125 max. material thickness, 24" wide maximum, 500 S.P.M.)*	Similar to 200T Series but with more capacity. See table.
KBX104S, 108S and 112S – 230 VAC (.080 max. material thickness, 12" wide maximum, 450 S.P.M.)*	Programmable roll feed and flat stock straightener combined in one unit. All the features of a 100T Series plus the extra power to straighten .080 thick C.R.S. (.060 thick at 12" max. width, commercial low carbon steel). The KBX may be used as a Servo Feed alone by merely raising the straightening rolls. Patent.
KBXP104S and 108S – 230 VAC	Similar to KBX100S Series but with air pilot release. Patent.

Note: KBX Series provide floor space saving by eliminating the material loop between feed and straightener. * Speeds (S.P.M.) are based on 1.0" progression and 180° feed angle.

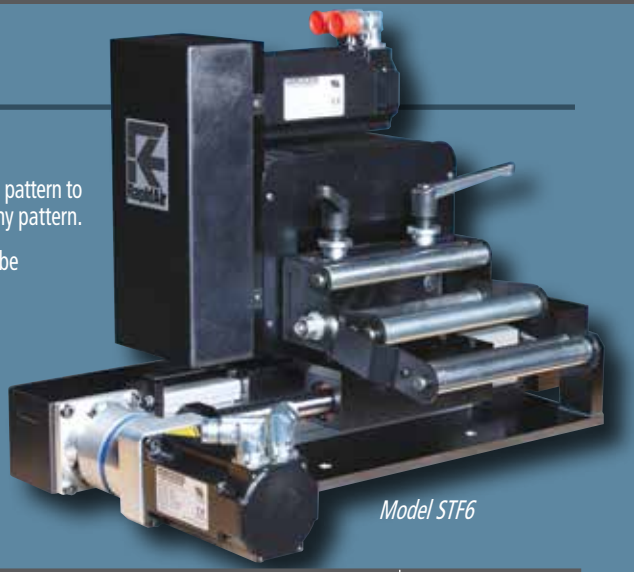
Servo Feeds

Servo Drive Stagger Feed STF4, STF6, STF8

Produces the most parts from the least amount of material.

Rapid-Air's STF Series Servo Drive Stagger Feed maximizes material usage by pre-programming the optimum pattern to reduce coil material waste. Enhances even the most simple die by feeding it diagonally, side-to-side, or in any pattern.

- The programmability allows use of common or uncommon stock widths. Uncommon stock widths may be purchased at a lower cost and maximized by using our servo drive stagger feed.
- Any pattern, staggered or column, can be created for round or non-round parts to maximize material usage, staggered or column.
- The STF Series is a dual servo drive working in harmony with the die to provide fast, accurate moves.
- Feeds coil material up to 8" (203mm) wide x .085" (2.15mm) thick. Shuttle travel 8.5" (216mm). 8.0 usable travel.
- Incorporates our reliable, high performance Rapid-Air servo which offers quick changeover and speed, unlike time-consuming mechanical models.
- User-friendly Rapid-Air controls.
- In-house programming capabilities no one else can offer.
- Pilot release is included. Just add valve.
- 250 strokes per minute, with or without pilot release.
- Low maintenance.



Model STF6

Model Selection

Model	Max Material Width	Max. Thickness Capacity At Full Width	Shuttle Move	A.C. Input Power Required	Speed Strokes Per Minute (With or Without Pilot Release)
STF4*	4" (101mm)	.040" (1.01mm)	0 to 4" (0 to 101mm)	115vac, 1ph, 60/50hz	2 5 0
STF6*	6" (152mm)	.085" (2.15mm)	0 to 6" (0 to 152mm)	230vac, 1ph, 60/50hz	2 5 0
STF8*	8" (203mm)	.105" (2.66mm)	0 to 8" (0 to 203mm)	230vac, 1ph, 60/50hz	2 5 0

* Contact factory for special feed requirements. Capacity and thickness can be dependent on application.

Tandem Servo Feeds

Ideal for feeding thin or very flexible materials.

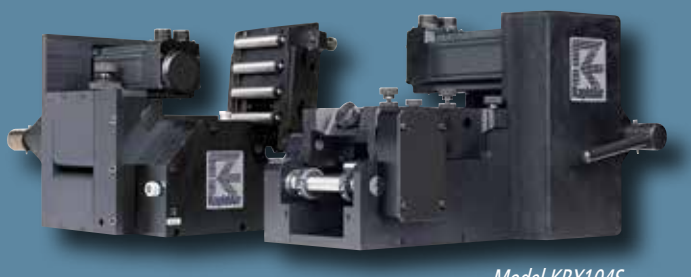
A Rapid-Air Tandem Servo Feed is recommended when feeding thin or very flexible material into a die. Two synchronized feeds prevent buckling by maintaining tension on the stock using a special program. A Primary Servo Feed is placed at the entrance to the die and a Secondary Servo Feed is placed at the exit. You can later convert to two standard feeds, if desired, by a simple addition of a keypad and a standard program for the slave unit.

Model Selection

Series	Model	Max Material Width	Max Thickness Capacity at Full Width	Max Feed Roll Opening	Standard Roll Type	AC Input Power Required
TSMS Series	**TSMS2**	2" (51mm)	.040" (1.02mm)	.060" (1.52mm)	Hardened & Ground Standard	115V, 1ph, 60hz
	TSMS4	4" (102mm)	.040" (1.02mm)	.060" (1.52mm)		
	TSMS8	8" (203mm)	.031" (.79mm)	.060" (1.52mm)		
T100D Series	**T106D**	6" (152mm)	.085" (2.15mm)	.150" (3.81mm)		
	T112D	12" (305mm)	.060" (1.52mm)	.150" (3.81mm)		
	T118D	18" (457mm)	.045" (1.14mm)	.150" (3.81mm)		
T100T Series	**T106T**	6" (152mm)	.105" (2.66mm)	.150" (3.81mm)		230V, 3ph, 60hz
	T112T	12" (305mm)	.080" (2.03mm)	.150" (3.81mm)		
	T118T	18" (457mm)	.065" (1.65mm)	.150" (3.81mm)		
T200T Series	**T208T**	8" (203mm)	.105" (2.66mm)	.180" (4.57mm)		
	T212T	12" (305mm)	.095" (2.41mm)	.180" (4.57mm)		
	T218T	18" (457mm)	.085" (2.15mm)	.180" (4.57mm)		
	T224T	24" (610mm)	.075" (1.91mm)	.180" (4.57mm)		

Servo Feed/Straightener Combos

Save floor space and economize.



Model KBX104S

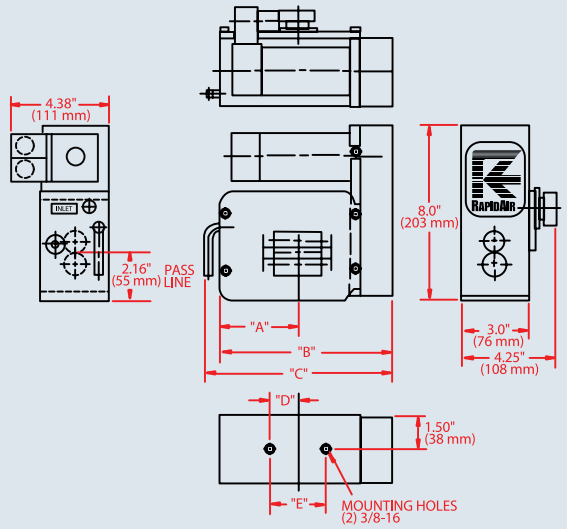
Model Selection

Model	Max Material Width	Max Thickness Capacity at Full Width	Max Feed Roll Opening	AC Input Power
Heavy Duty KBX100S Series				230V, 3ph, 60hz
KBX104S	4" (102mm)	.080" (2.03mm)	.150" (3.81mm)	
KBX108S	8" (203mm)	.070" (1.78mm)	.150" (3.81mm)	
KBX112S	12" (305mm)	.060" (1.52mm)	.150" (3.81mm)	
Piloted Heavy Duty KBXP100S Series				
KBXP104S	4" (102mm)	.080" (2.03mm)	.150" (3.81mm)	
KBXP108S	8" (203mm)	.070" (1.78mm)	.150" (3.81mm)	

Servo Feeds

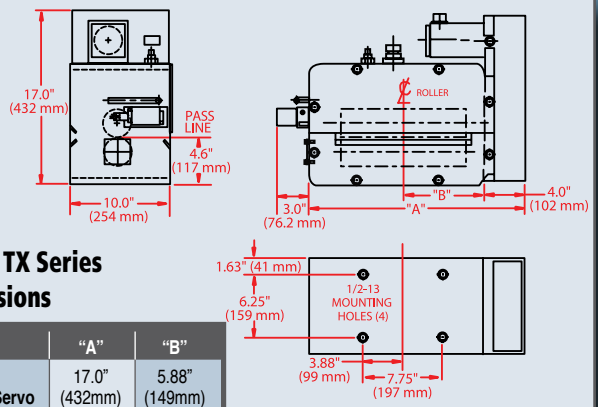
Dimensions

Envelope drawings.



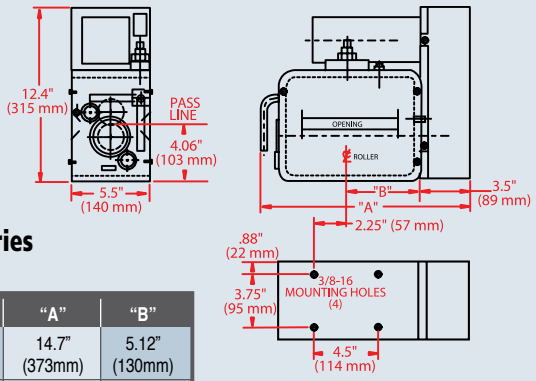
MiniServo Dimensions

Model	"A"	"B"	"C"	"D"	"E"
MS2	3.50" (89mm)	7.80" (198mm)	8.50" (216mm)	1.50" (38mm)	3.00" (76mm)
MS4	4.50" (114mm)	9.80" (249mm)	10.50" (267mm)	1.50" (38mm)	3.00" (76mm)
MS8	6.50" (165mm)	13.80" (351mm)	14.50" (368mm)	1.50" (38mm)	3.00" (76mm)



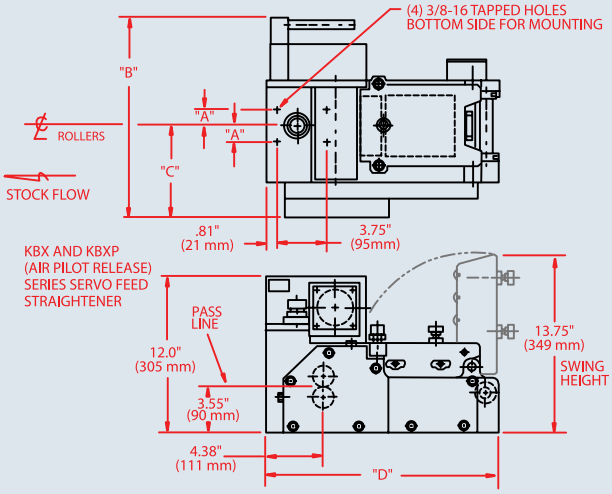
200T & TX Series Dimensions

Model	"A"	"B"
208T & TX Servo	17.0" (432mm)	5.88" (149mm)
212T & TX Servo	21.0" (533mm)	7.88" (200mm)
218T & TX Servo	27.0" (686mm)	10.88" (276mm)
224T & TX Servo	33.0" (838mm)	13.88" (352mm)



100D & T Series Dimensions

Model	"A"	"B"
106D & T Servo	14.7" (373mm)	5.12" (130mm)
112D & T Servo	20.7" (526mm)	8.12" (206mm)
118D & T Servo	26.7" (678mm)	11.12" (282mm)



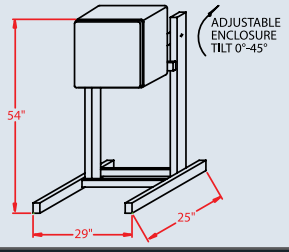
KBX Series Servo Feed / Straightener Dimensions

Model	"A"	"B"	"C"	"D"
KBX104S	1.25" (32.0mm)	15.25" (387.4mm)	7.0" (178mm)	18.0" (457mm)
KBX108S	2.25" (57.2mm)	19.25" (489.0mm)	9.0" (229mm)	18.0" (457mm)
KBX112S	2.25" (57.2mm)	23.25" (590.6mm)	11.0" (279mm)	18.0" (457mm)
KBXP104S	1.25" (32.0mm)	17.0" (432.0mm)	7.0" (178mm)	20.0" (508mm)
KBXP108S	2.25" (57.2mm)	21.0" (533.4mm)	9.0" (229mm)	20.0" (508mm)

Servo Feed Control

Control mounting stand

Height: 54" (1,371mm) Width: 29" (737mm) Depth: 25" (635mm)

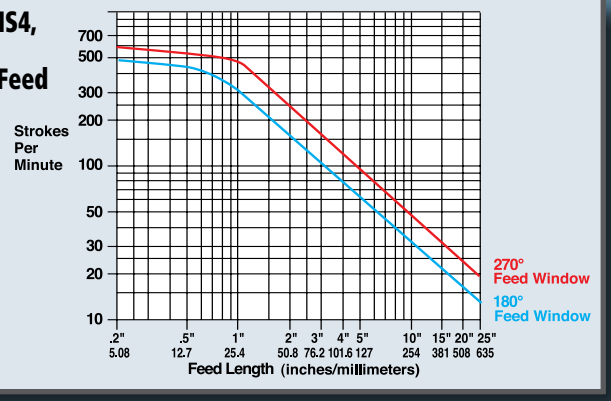


Servo Feeds

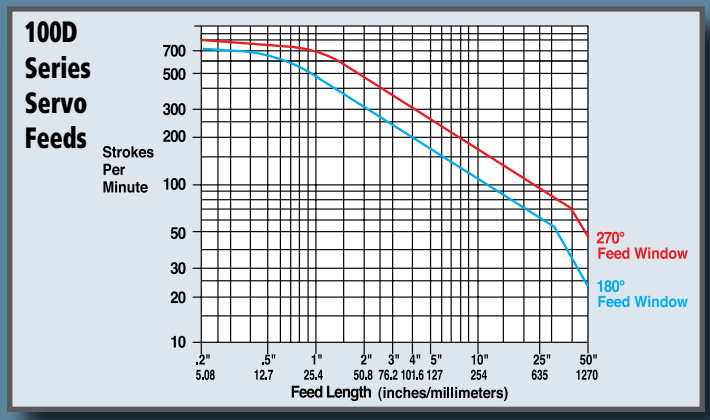
Performance Data

The relationship between strokes per minute and feed length for each model.

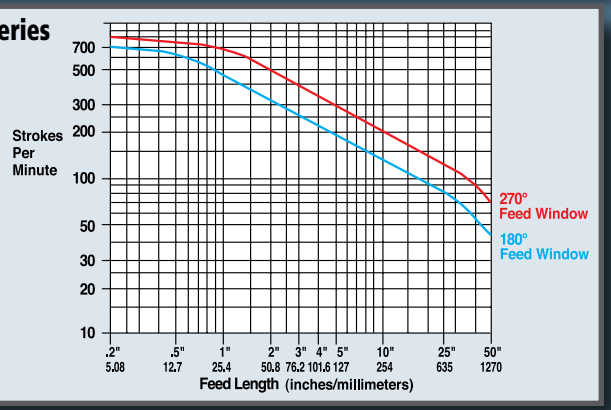
MS2, MS4, & MS8 Servo Feed



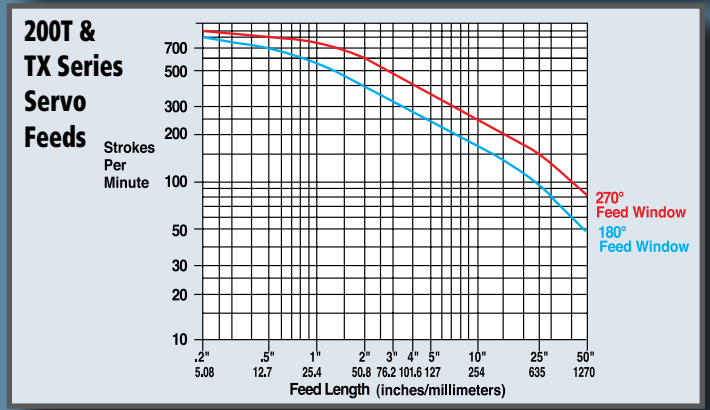
100D Series Servo Feeds



100T Series Servo Feeds



200T & TX Series Servo Feeds

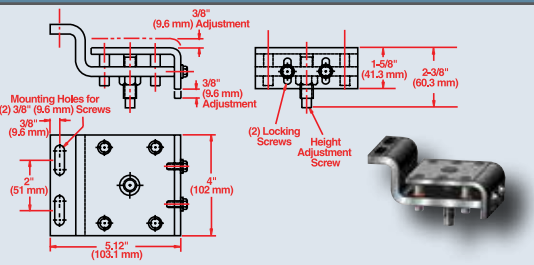


Speed charts are only intended to be a guide for potential production rates.
Charts represent max. S.P.M. with mechanical pilot release or no pilot release. Using air pilot release limits speed to 300 S.P.M. with adequate air supply.

Options and Accessories

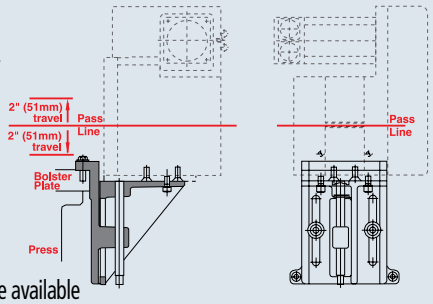
Easily adapt to a wide range of applications.

Adjustable Mounting Bracket For MiniServo MS2



Adjustable Mounting Bracket For MiniServo, MS4 & MS8, 100 & 200 KBX Series

NOTE: May also be used with MS2. Adaptor plate required.



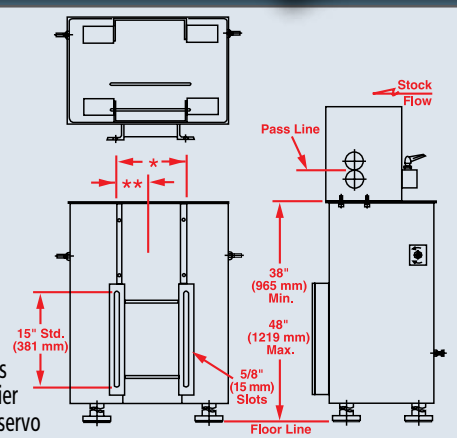
Adjustable mounting bracket are available for all servo feed models. Consider adjustable stand for wider, heavier models.

Entrance Cascade Rolls

Fully adjustable entrance cascade rolls are available for all models.

Adjustable Servo Cabinet Dimensions

* Contact Rapid-Air with your requirements.
** Contact Rapid-Air with your requirements.



Adjustable servo cabinets available for wider, heavier feeds. Fabricated, fixed servo feed stands also available. Contact Rapid-Air with requirements.

Straighteners

SA, SB, SBX, SCX, SD

Powered stock straighteners for superior coil set removal.

Simple to operate.
Rapid-Air high-performance straighteners are simple to operate and capable of processing an exceptionally wide range of stock widths and thicknesses. They combine precision coil set removal with smooth payout of material. Easy to load and run, they're built with traditional Rapid-Air ruggedness for demanding, continuous use.

Model SCX6 *Model SCX12 (cover open)* *Model SBX4*

Model SCX12

Model SCX12

Straighteners

Model Selection and Dimensions

Model Selection

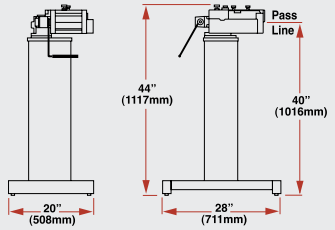
Model	Max Material Width	Effective Straightening Range	Max Speed per min	AC Input Power Required
SA3	3" (76mm)	.002" - .030" (.051-.76mm)	700" (1778cm)	1/4hp, 115vac, 1ph
SA3M	3" (76mm)	.002" - .030" (.051-.76mm)	1,400" (3556cm)	1/2hp, 115vac, 1ph
SB4	4" (102mm)	.003" - .050" (.076-1.27mm)	700" (1778cm)	1/2hp, 115vac, 1ph
SB4M	4" (102mm)	.003" - .050" (.076-1.27mm)	1,400" (3556cm)	1/2hp, 115vac, 1ph
SBX4	4" (102mm)	.004" - .080" (.10-2.03mm)	825" (2100cm)	3/4hp, 115vac, 1ph
SBX8	8" (203mm)	.004" - .070" (.10-1.78mm)	825" (2100cm)	3/4hp, 115vac, 1ph
SBX12	12" (305mm)	.004" - .060" (.10-1.52mm)	825" (2100cm)	3/4hp, 115vac, 1ph
SBX4M	4" (102mm)	.004" - .080" (.10-2.03mm)	1,650" (4200cm)	1hp, 115vac, 1ph
SBX8M	8" (203mm)	.004" - .070" (.10-1.78mm)	1,650" (4200cm)	1hp, 115vac, 1ph
SBX12M	12" (305mm)	.004" - .060" (.10-1.52mm)	1,650" (4200cm)	1hp, 115vac, 1ph
SCX6	6" (152mm)	.006" - .100" (.15-2.54mm)	825" (2100cm)	1hp, 115vac, 1ph
SCX12	12" (305mm)	.006" - .090" (.15-2.29mm)	825" (2100cm)	1hp, 115vac, 1ph
SCX18	18" (457mm)	.006" - .080" (.15-2.03mm)	825" (2100cm)	1hp, 115vac, 1ph
SCX24	24" (610mm)	.006" - .065" (.15-1.65mm)	825" (2100cm)	1hp, 115vac, 1ph
SCX6M	6" (152mm)	.006" - .100" (.15-2.54mm)	1,650" (4200cm)	2hp, 230vac, 1ph
SCX12M	12" (305mm)	.006" - .090" (.15-2.29mm)	1,650" (4200cm)	2hp, 230vac, 1ph
SCX18M	18" (457mm)	.006" - .080" (.15-2.03mm)	1,650" (4200cm)	2hp, 230vac, 1ph
SCX24M	24" (610mm)	.006" - .065" (.15-1.65mm)	1,650" (4200cm)	2hp, 230vac, 1ph
SCX6H	6" (152mm)	.006" - .080" (.15-2.03mm)	4,100" (10400cm)	3hp, 230vac, 1ph
SCX12H	12" (305mm)	.006" - .070" (.15-1.78mm)	4,100" (10400cm)	3hp, 230vac, 1ph
SCX18H	18" (457mm)	.006" - .060" (.15-1.52mm)	4,100" (10400cm)	3hp, 230vac, 1ph
SCX24H	24" (610mm)	.006" - .055" (.15-1.40mm)	4,100" (10400cm)	3hp, 230vac, 1ph
SD6	6" (152mm)	.006" - .125" (.15-3.18mm)	825" (2100cm)	2hp, 230vac, 1ph
SD12	12" (305mm)	.006" - .125" (.15-3.18mm)	825" (2100cm)	2hp, 230vac, 1ph
SD18	18" (457mm)	.006" - .100" (.15-2.54mm)	825" (2100cm)	2hp, 230vac, 1ph
SD24	24" (610mm)	.006" - .090" (.15-2.29mm)	825" (2100cm)	2hp, 230vac, 1ph

Straightening range based on low carbon steel, commercial grade.

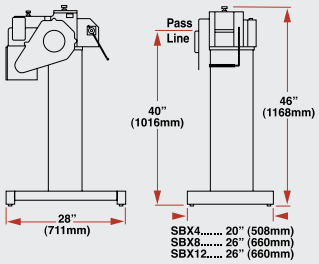
High-torque, quick response drive in a compact package.

Straightener Dimensions

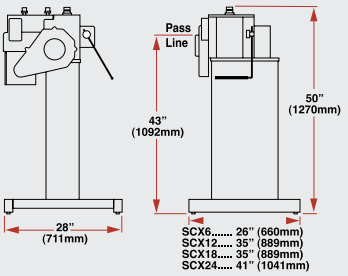
Power Roll, SA & SB Series



SBX Series



SCX & SD Series



Equipment To Expand Your Straightening Capabilities

Standard material flow direction.
(Facing straightener control)
SA and SB straighteners flow left to right. SBX, SCX and SD straighteners flow right to left. All models are available with opposite flow direction. Please specify when ordering. Factory convertible.

Entrance/exit cascade rolls.
Fully adjustable entrance and/or exit cascade rolls are available for all models.

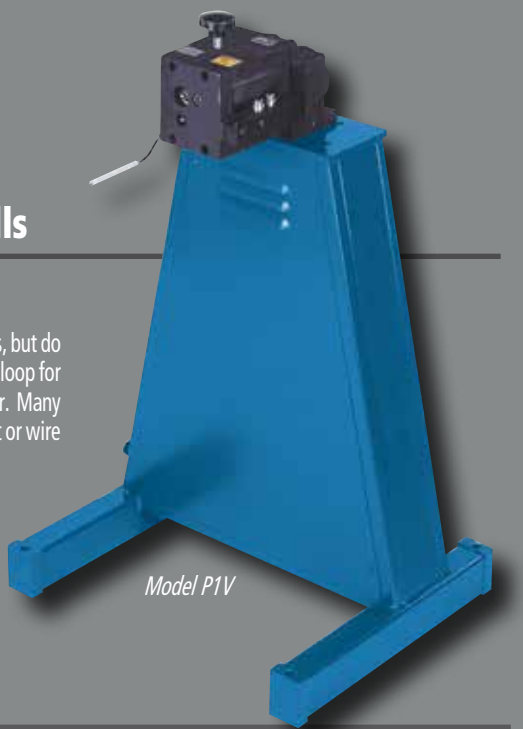
Optional heavy-duty dancer arm.
Dancer arm with adjustable counterweight available for SCX and SD models.

Optional loop controls.
All straightener models are equipped with an external plug connector which allows simple connection of the Rapid-Air loop control systems.

Rapid-Roll Power Rolls

An ideal pulling source.

If you don't need straightening capabilities, but do require a pulling source to maintain a free loop for consistent feeding, Rapid-Roll is the answer. Many different models are available to meet flat or wire stock requirements.



Model P1V

Model Selection

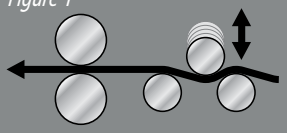
Model	Max Material Width	Recommended Operating Range	Speed	Max Speed per min	AC Input Power Required
P1V	1-1/2" (38mm)	.0005" - .075" (.0127-1.91mm)	Standard	700" (1778cm)	1/4hp, 115vac, 1ph
P1M	1-1/2" (38mm)	.0005" - .075" (.0127-1.91mm)	Medium	1,400" (3556cm)	1/2hp, 115vac, 1ph
P4V	4" (102mm)	.0005" - .060" (.0127-1.52mm)	Standard	700" (1778cm)	1/4hp, 115vac, 1ph
P4M	4" (102mm)	.0005" - .060" (.0127-1.52mm)	Medium	1,400" (3556cm)	1/2hp, 115vac, 1ph
P1W	wire	.005" - .150" (.127-3.81mm)	Standard	700" (1778cm)	1/4hp, 115vac, 1ph
P1WM	wire	.005" - .150" (.127-3.81mm)	Medium	1,400" (3556cm)	1/2hp, 115vac, 1ph

Patented Platen Straightener Feature

Rapid-Air straighteners are unmatched at smoothing ripples, removing coil set, and setting the amount and direction of curvature.

The traditional straightener operates by vertically adjusting a straightening roll between two opposing rolls as illustrated in Figure 1 below. Notice that the rolls are effective at smoothing ripples in material and not very effective at removing coil set.

Figure 1



Now see what happens when the rollers can be adjusted forward and backward and up and down as in the patented Rapid-Air straighteners. Figure 2 illustrates a forward position of the straightening roll with the resulting upward curve of material. Figure 3 illustrates a rear position of the straightening roll with the resulting downward curve to the material. Notice that the sharpest bend occurs where two rolls are close together. The degree of bend can be adjusted by a combination of vertical and horizontal adjustments.

Figure 2

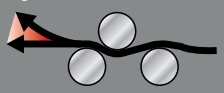
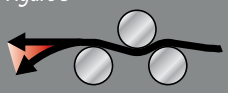


Figure 3



Additional rolls are added to better smooth ripples in material as illustrated in Figures 4 & 5 below.

Figure 4 --- Rolls forward - curve up

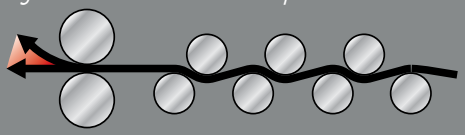
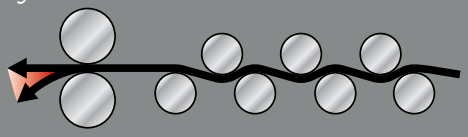
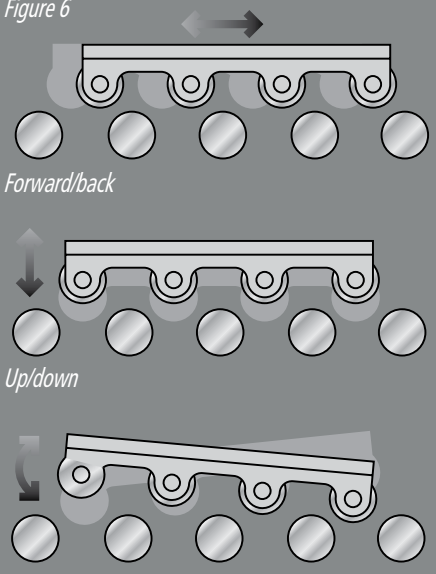


Figure 5 --- Rolls back - curve down



Six-way upper roll adjustment:
After manufacturing straighteners with vertically adjustable rolls for many years, Rapid-Air developed and patented the adjustable platen type straightener as illustrated in Figure 6.

Figure 6



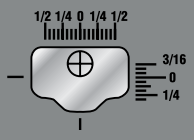
Advantages:
The high degree of flexibility afforded by the adjustable platen design provides a predictable straightening method for a wide variety of materials and takes a lot of the "Black Magic" out of pressroom straightener setup. The reduction in the flexing and distortion of the strip of material and the reduction of the straightening power required allows this design to be effective with heavy materials. Additionally, the ability to place rolls in a proper close proximity allows effective straightening with very thin materials.

Roll diameter:
The smaller the roll diameter in a straightener, the better it is able to remove distortions in the strip of material. But this factor is compromised by the requirement of larger rolls in wider models of straighteners in order to prevent deflection of the rolls themselves. Rapid-Air straighteners are designed to optimize all factors (including number of rolls, diameter and position) within the published material capacities and specifications for each model.

Counter-balanced, swing-open top:
Rapid-Air pioneered the swing-open top in order to facilitate cleaning of rolls and threading of a new strip of material. For convenience and safety, each top is counter-balanced and held in the open position until it is clamped for operation. Roll adjustment settings are maintained when the top is closed and locked.

Outperforms competitive makes.
Within rated thickness capacities Rapid-Air straighteners will outperform competitive makes that rely on traditional vertically adjustable rolls or those with simple two-point bank adjustment - including many of the expensive 17 or 21 roll varieties.

Roll position indicators are built into the side of the adjustable platen - eliminates the need for dial-type indicators.



Non-Powered Pull Through Straighteners

Extend the versatility of a Rapid-Roll Power Roll.

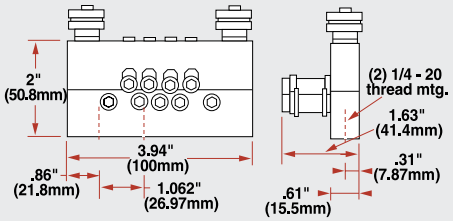
Two flat stock straightener and three wire straightener models extend the versatility of Rapid Roll power units. Stock can be pulled through each of these straighteners using a Rapid Roll unit as a pulling source.

Model Selection

Model	Roll Diameter	Max Material Width	Recommended Operating Range
S0 S1	.375" (9.53mm) .718" (18.24mm)	.5" (12.7mm) - flat stock 1.5" (38mm) - flat stock	.003" - .020" (.076-.51mm) .005" - .035" (.127-.89mm)
W0 W1 W2	.375" (9.53mm) .900" (22.86mm) 1.000" (25.40mm)	wire wire wire	.003" - .030" dia (.076-.76mm dia) .015" - .060" dia (.38-1.52mm dia) .050" - .150" dia (1.27-3.81mm dia)

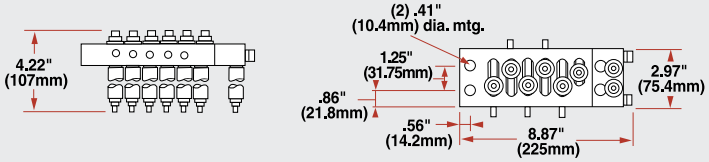
Model S0

- Flat stock.
- 1 entrance guide roll.
- (7) .375" (9.5mm) diameter straightening rolls.
- Unit separates in middle for easy loading.



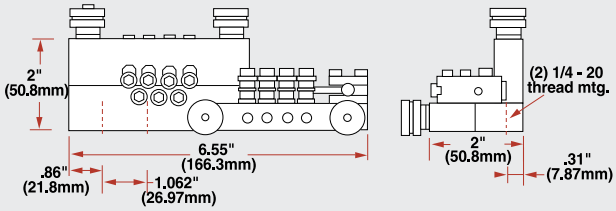
Model S1

- Flat stock.
- 2 entrance guide rolls.
- (6) .718" (18.2mm) diameter straightening rolls.



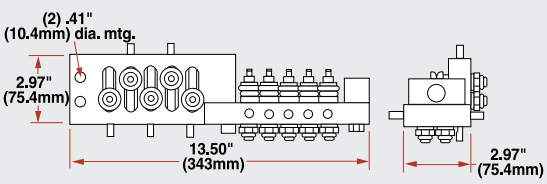
Model W0

- Wire.
- 14 grooved wire rolls for two plane straightening.
- Units separate easily for loading.

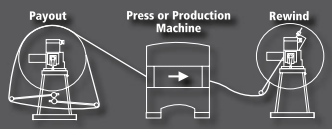


Model W1 and W2

- Wire.
- 10 grooved wire rolls for two plane straightening.



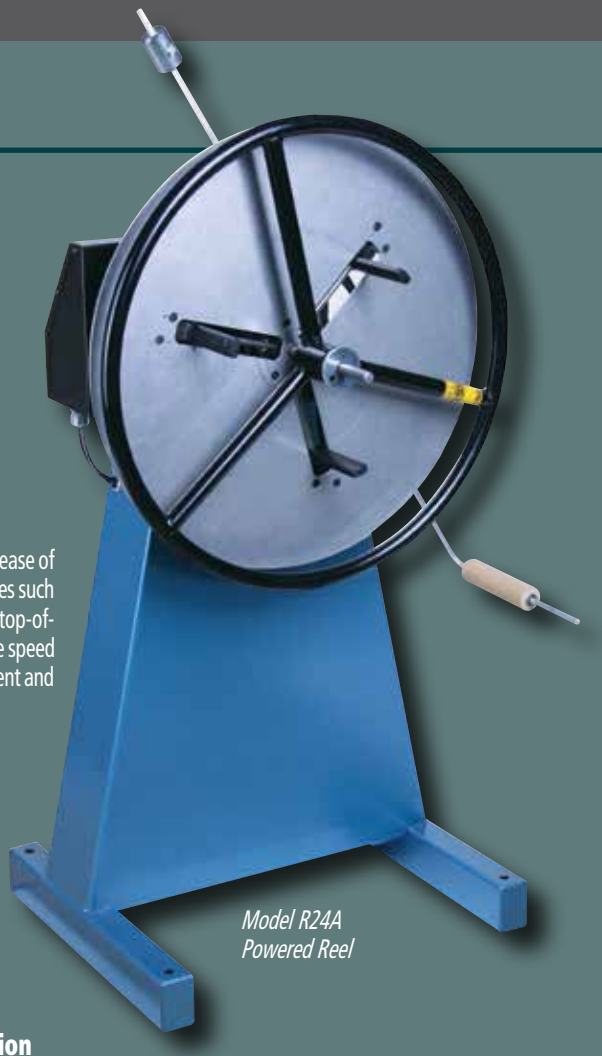
Stock Reels



100 Series Stock Reels

The most complete selection available from any source. Powered and non-powered. Adjustable and fixed centers.
Max. capacities 50-500 lbs. (22-227kg).

We build our stock reels for lasting durability featuring heavy duty shafts with full bearing support to handle heavy coil loads day in and day out, rugged coil centering arms, and sturdy all steel cabinets and support bases. The options and accessories for each of our models enables you to configure a reel practically any way you want for dependable payoff of coil stock.


Model R24A Powered Reel

Powered reels.
Electric drive-powered reels are made for ease of operation with innovative standard features such as our proportional control system. This top-of-the-line patented system features variable speed capability, electronic loop height adjustment and loop sensing arm range control.


Model R24NF Non-Powered Reel

***Non-powered.**
Non-powered reels are available in all sizes, 50 lbs. (22kg) capacity to 500 lbs. (227kg) capacity. All have adjustable mechanical drag brakes. Add NF for non-powered fixed center or NA for non-powered adjustable center.

Model Selection

Powered Model*	Max Coil Weight	Max Coil OD	Max Material Width	Center Diameter	Powered Max Speed
Adjustable Center					
R23A	75 lbs (34kg)	18" (457mm)	4" (102mm)	3" - 10" (76-254mm)	80rpm
R24A	75 lbs (34kg)	24" (610mm)	4" (102mm)	3" - 12" (76-305mm)	80rpm
R25A	75 lbs (34kg)	30" (762mm)	4" (102mm)	3" - 12" (76-305mm)	80rpm
R34A	150 lbs (68kg)	24" (610mm)	4" (102mm)	5" - 16" (127-406mm)	50rpm
R35A	150 lbs (68kg)	30" (762mm)	4" (102mm)	5" - 16" (127-406mm)	50rpm
R36A	150 lbs (68kg)	36" (915mm)	4" (102mm)	5" - 16" (127-406mm)	50rpm
R45A	250 lbs (114kg)	30" (762mm)	6" (152mm)	9" - 20" (229-508mm)	50rpm
R46A	250 lbs (114kg)	36" (915mm)	6" (152mm)	9" - 20" (229-508mm)	50rpm
R56A	500 lbs (227kg)	36" (915mm)	6" (152mm)	9" - 20" (229-508mm)	33rpm
R58A	500 lbs (227kg)	48" (1220mm)	6" (152mm)	9" - 20" (229-508mm)	33rpm
Fixed Center					
***R13NF**	50 lbs (22kg)	18" (457mm)	4" (102mm)	3/4" (19mm)	----
R23F	75 lbs (34kg)	18" (457mm)	4" (102mm)	3/4" (19mm)	80rpm
R24F	75 lbs (34kg)	24" (610mm)	4" (102mm)	3/4" (19mm)	80rpm
R25F	75 lbs (34kg)	30" (762mm)	4" (102mm)	3/4" (19mm)	80rpm
R34F	150 lbs (68kg)	24" (610mm)	4" (102mm)	1-1/2" (38mm)	50rpm
R35F	150 lbs (68kg)	30" (762mm)	4" (102mm)	1-1/2" (38mm)	50rpm
R36F	150 lbs (68kg)	36" (915mm)	4" (102mm)	1-1/2" (38mm)	50rpm
R45F	250 lbs (114kg)	30" (762mm)	6" (152mm)	1-1/2" (38mm)	50rpm
R46F	250 lbs (114kg)	36" (915mm)	6" (152mm)	1-1/2" (38mm)	50rpm
R56F	500 lbs (227kg)	36" (915mm)	6" (152mm)	1-3/4" (44.5mm)	33rpm
R58F	500 lbs (227kg)	48" (1220mm)	6" (152mm)	1-3/4" (44.5mm)	33rpm

* Example of non-powered modular reel generally used for paper interleaf.

Stock Reels

100 Series Single Hydraulic Stock Reels


Model RH34F

The smooth running capability of our hydraulic reel means superior performance when handling delicate materials. The light tensioning capability offers an outstanding alternative for difficult rewind applications.

Hydraulic Model Selection

Powered Model	Max Coil Weight	Max Coil OD	Max Material Width	Center Diameter	Powered Max Speed
Hydraulic Reel Adjustable Center					
RH34A	150 lbs (68kg)	24" (610mm)	4" (102mm)	5" - 16" (127-406mm)	80rpm
RH35A	150 lbs (68kg)	30" (762mm)	4" (102mm)	5" - 16" (127-406mm)	80rpm
RH36A	150 lbs (68kg)	36" (915mm)	4" (102mm)	5" - 16" (127-406mm)	80rpm
RH45A	250 lbs (114kg)	30" (762mm)	6" (152mm)	9" - 20" (229-508mm)	80rpm
RH46A	250 lbs (114kg)	36" (915mm)	6" (152mm)	9" - 20" (229-508mm)	80rpm
RH56A	400 lbs (182kg)	36" (915mm)	6" (152mm)	9" - 20" (229-508mm)	70rpm
RH58A	400 lbs (182kg)	48" (1220mm)	6" (152mm)	9" - 20" (229-508mm)	70rpm
RH2012	2,000 lbs (907kg)	60" (1524mm)	12" (305mm)	16" - 24" (406-610mm)	23rpm
Hydraulic Reel Fixed Center					
RH34F	150 lbs (68kg)	24" (610mm)	4" (102mm)	1-1/2" (38.1mm)	80rpm
RH35F	150 lbs (68kg)	30" (762mm)	4" (102mm)	1-1/2" (38.1mm)	80rpm
RH36F	150 lbs (68kg)	36" (915mm)	4" (102mm)	1-1/2" (38.1mm)	80rpm
RH45F	250 lbs (114kg)	30" (762mm)	6" (152mm)	1-1/2" (38.1mm)	80rpm
RH46F	250 lbs (114kg)	36" (915mm)	6" (152mm)	1-1/2" (38.1mm)	80rpm
RH56F	400 lbs (182kg)	36" (915mm)	6" (152mm)	1-3/4" (44.5mm)	70rpm
RH58F	400 lbs (182kg)	48" (1220mm)	6" (152mm)	1-3/4" (44.5mm)	70rpm

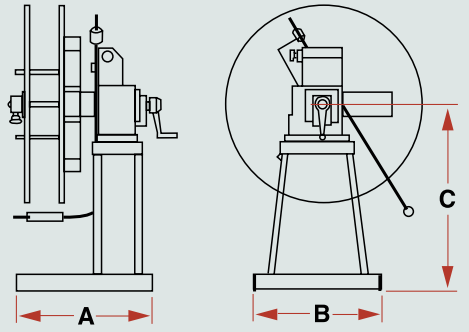
100 Series Powered, Non-Powered and Hydraulic Reel Selection Guide

MODEL	DESCRIPTION
Drives	D.C. powered, hydraulic powered and non-powered with adjustable drag brake.
Styles	Cabinet, swivel, modular multi-head, custom arrangement, fixed and adjustable center. Loop arm, low loop and external loop control.
Application	Determine max. coil wt. and select appropriate model. Example: 125 lbs. (56kg) coil wt. = R30 reel, 150 lbs. (68kg) max. cap. coil O.D., I.D. and width = 24" (610mm) O.D. x 12" (305mm) I.D. X 1.3" (33mm) wide chose R34A = 24" (610mm) O.D. X 5" (127mm) to 16" (406mm) I.D. X 4" (102mm) wide max. speed (at minimum O.D.) 12" (305mm) I.D. X π X 50rpm max. = 1,884 inches (4785cm) per min. for powered reel.

100 Series Powered, Non-Powered and Hydraulic Reel Dimensions

Reel Series Number	Base Depth A	Base Width B	Center Height C
Powered Reel Dimensions			
R20	20" (508mm)	24" (610mm)	34" (863mm)
R30	20" (508mm)	24" (610mm)	34" (863mm)
R40	20" (508mm)	24" (610mm)	34" (863mm)
R50	25" (635mm)	24" (610mm)	34" (863mm)
Non-Powered Reel Dimensions			
R20N	20" (508mm)	24" (610mm)	34" (863mm)
R30N	20" (508mm)	24" (610mm)	34" (863mm)
R40N	20" (508mm)	24" (610mm)	34" (863mm)
R50N	25" (635mm)	24" (610mm)	34" (863mm)
Hydraulic Drive Dimensions			
RH30	20" (508mm)	24" (610mm)	34" (863mm)
RH40	20" (508mm)	24" (610mm)	34" (863mm)
RH50	25" (635mm)	24" (610mm)	34" (863mm)
RH2012	45" (1,143mm)	61" (1,549mm)	40" (1,016mm)

100 Series Powered, Non-Powered and Hydraulic Dimensions



AutoCAD files are available on Rapid-Air products to assist in layout on integration.

Stock Reels

1000 Series Single Stock Reels

Powered and non-powered. Adjustable and fixed. With or without brakes.

Max. capacities 1,500-6,000 lbs. (682-2727kg).

Model RAH6018 with Pneumatic Hold Down

The Rapid-Air 1000 Series of single stock reels represents a line of heavy-duty reels starting at 1,500 lbs. (682kg) capacity. Built rock solid in the Rapid-Air tradition, with heavy-duty shafts and full bearing support to handle heavy coil loads, 1000 Series single stock reels are available in both powered and non-powered models.

Powered reels are designed to accept all Rapid-Air loop controls. All Rapid-Air powered stock reels are equipped with variable speed drive motors and feature as standard, our proportional electronic control system. This system allows loop curve to be tailored to individual material characteristics. Operating speed is automatically adjusted to match line speed. Dancer arm loop sensing is standard.

Inner coil plates or keeper arms are options on both variable speed powered and non-powered models.

Hydraulic Expansion Reels

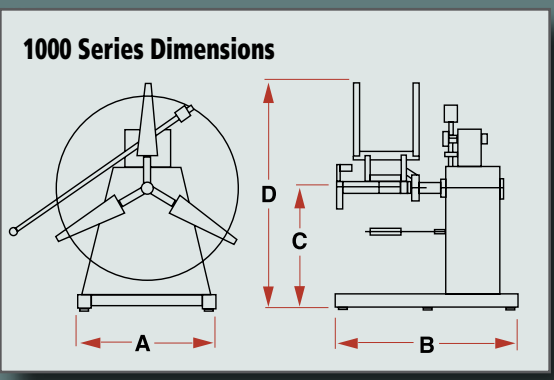
Rapid-Air offers manual centering arms or hydraulic expansion to grip the inside diameter of the coil. We also offer optional hold down arms and safety cages for "clockspring" concerns.

Consult Rapid-Air for your unique requirements. We are happy to manufacture special diameter shafts, stepped shafts, shafts for air chuck style inside diameter grip and other engineered solutions to meet your specific needs.

1000 Series Model Selection

Mechanical Centering Arms Model	Max Coil Weight	Max Coil OD	Max Material Width	Center Diameter	Max Speed in/min	Powered AC Input Power Required
Powered						
RA1512	1,500 lbs (682kg)	48" (122cm)	12" (31cm)	14" - 22" (36cm-56cm)	23rpm	1/2hp, 115vac, 1ph
RA2506	2,500 lbs (1136kg)	60" (152cm)	6" (15cm)	16" - 24" (41cm-61cm)	23rpm	1hp, 115vac, 1ph
RA2512	2,500 lbs (1136kg)	60" (152cm)	12" (31cm)	16" - 24" (41cm-61cm)	23rpm	1hp, 115vac, 1ph
RA2518	2,500 lbs (1136kg)	60" (152cm)	18" (46cm)	16" - 24" (41cm-61cm)	23rpm	1hp, 115vac, 1ph
RA4012	4,000 lbs (1818kg)	60" (152cm)	12" (31cm)	16" - 24" (41cm-61cm)	23rpm	1-1/2hp, 230vac, 1ph
RA4018	4,000 lbs (1818kg)	60" (152cm)	18" (46cm)	16" - 24" (41cm-61cm)	23rpm	1-1/2hp, 230vac, 1ph
RA4024	4,000 lbs (1818kg)	60" (152cm)	24" (61cm)	16" - 24" (41cm-61cm)	23rpm	1-1/2hp, 230vac, 1ph
RA6012	6,000 lbs (2727kg)	72" (183cm)	12" (31cm)	17" - 24" (46cm-64cm)	17rpm	2hp, 230vac, 1ph
RA6018	6,000 lbs (2727kg)	72" (183cm)	18" (46cm)	17" - 24" (46cm-64cm)	17rpm	2hp, 230vac, 1ph
RA6024	6,000 lbs (2727kg)	72" (183cm)	24" (61cm)	17" - 24" (46cm-64cm)	17rpm	2hp, 230vac, 1ph
Non-Powered Air Drag Brake						
RPA1512	1,500 lbs (682kg)	48" (122cm)	12" (31cm)	14" - 22" (36cm-56cm)		
RPA2506	2,500 lbs (1136kg)	60" (152cm)	6" (15cm)	16" - 24" (41cm-61cm)		
RPA2512	2,500 lbs (1136kg)	60" (152cm)	12" (31cm)	16" - 24" (41cm-61cm)		115vac, 60hz, 1ph for hydraulic expansion
RPA2518	2,500 lbs (1136kg)	60" (152cm)	18" (46cm)	16" - 24" (41cm-61cm)		
RPA4012	4,000 lbs (1818kg)	60" (152cm)	12" (31cm)	16" - 24" (41cm-61cm)		
RPA4018	4,000 lbs (1818kg)	60" (152cm)	18" (46cm)	16" - 24" (41cm-61cm)		
RPA4024	4,000 lbs (1818kg)	60" (152cm)	24" (61cm)	16" - 24" (41cm-61cm)		
RPA6012	6,000 lbs (2727kg)	72" (183cm)	12" (31cm)	17" - 24" (46cm-64cm)		
RPA6018	6,000 lbs (2727kg)	72" (183cm)	18" (46cm)	17" - 24" (46cm-64cm)		
RPA6024	6,000 lbs (2727kg)	72" (183cm)	24" (61cm)	17" - 24" (46cm-64cm		

1000 Series Dimensions



1000 Series Dimensions

Model	A	B	C	D
Series 15 Powered & non-powered 1,500 lbs (682kg) Capacity				
RA1512	35" (89cm)	48" (122cm)	38" (97cm)	62" (158cm)
Series 25 Powered & non-powered 2,500 lbs (1136kg) Capacity				
RA2506	45" (114cm)	61" (155cm)	40" (102cm)	74" (188cm)
RA2512	45" (114cm)	61" (155cm)	40" (102cm)	74" (188cm)
RA2518	45" (114cm)	61" (155cm)	40" (102cm)	74" (188cm)
Series 40 Powered & non-powered 4,000 lbs (1818kg) Capacity				
RA4012	45" (114cm)	61" (155cm)	40" (102cm)	74" (188cm)
RA4018	45" (114cm)	61" (155cm)	40" (102cm)	74" (188cm)
RA4024	45" (114cm)	61" (155cm)	40" (102cm)	74" (188cm)
Series 60 Powered & non-powered 6,000 lbs (2727kg) Capacity				
RA6012	58" (147cm)	67" (170cm)	43" (109cm)	84" (213cm)
RA6018	58" (147cm)	67" (170cm)	43" (109cm)	84" (213cm)
RA6024	58" (147cm)	67" (170cm)	43" (109cm)	84" (213cm)

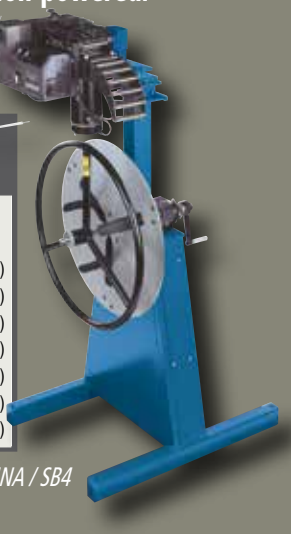
Specialty Stock Reels

100 Series Non-Powered Single Reel With Straightener

Save floor space and maximize production with a Rapid-Air Reel/Straightener Combo. Non-powered.
Max. capacities 150-500 lbs. (68-227kg).

Model Selection

Adjustable Center Model	Max Coil Weight	Max Coil OD	Max Material Width
Reel/Straightener with SB4			
R34NA/SB4	150 lbs (68kg)	24" (61cm)	4" (102mm)
R35NA/SB4	150 lbs (68kg)	30" (76cm)	4" (102mm)
R36NA/SB4	150 lbs (68kg)	36" (91cm)	4" (102mm)
R45NA/SB4	250 lbs (114kg)	30" (76cm)	4" (102mm)
R46NA/SB4	250 lbs (114kg)	36" (91cm)	4" (102mm)
R56NA/SB4	500 lbs (227kg)	36" (91cm)	4" (102mm)
R58NA/SB4	500 lbs (227kg)	48" (122cm)	4" (102mm)



Model R34NA / SB4

1000 Series Non-Powered Single Reel With Straightener – Low

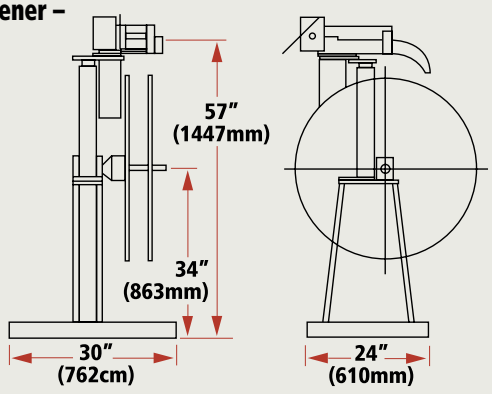
Low height non-powered reel and powered straightener. Right or left payout.
Max. capacity 1,500 (682kg).

Model LCRMA1512 / SBX8

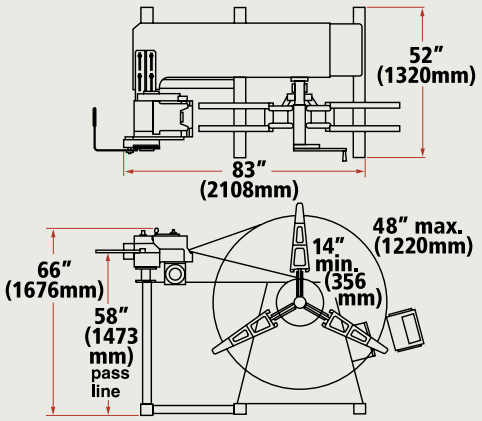
Model Selection

Adjustable Center Model	Drag Brake	Max Coil Weight	Max Coil OD	Max Material Width
Single Non-Powered Reel With Straightener LCRPA1512/SBX8	Air	1,500 lbs (682kg)	48" (122cm)	8" (15cm)
LCRPA1512/SBX12	Air	1,500 lbs (682kg)	48" (122cm)	12" (31cm)
LCRPA2506/SCX6	Air	2,500 lbs (1136kg)	60" (152cm)	6" (15cm)

With Straightener – Dimensions



Low Height With Straightener – Dimensions



100 Series Dual Swivel Reels

Save valuable production time with dual swivel reels. Powered and non-powered.
Max. capacities 150-500 lbs. (68-227kg).

Easy and safe head rotation.
There is no better way to increase coil stock payout or rewind productivity. These reels save valuable production time. Rapid-Air dual swivel reels can be equipped with the same operating controls as any of our single reels. The swivel head is mounted on heavy-duty bearings for easy 180 degrees rotation. The swivel head locks into place with a secure latch. A safety switch automatically shuts off power any time the latch is not completely engaged. Swivel head rotation is easily and safely accomplished by depressing a foot-operated release lever which cuts power to both reel heads. The reel rotates with a light hand motion and the active reel can be started when the latch is engaged. The run switch easily reestablishes the operation of the reel. Only one of the reels can receive power to run at any time. A limit switch automatically selects which reel is in the operating position. A foot-operated release disengages the swivel latch to allow a 180 degree rotation on the non-powered models.

Model RS56A

Specialty Stock Reels

1000 Series Dual Swivel Reels

For heavy-duty coil handling. Variable speed powered and non-powered. Hydraulic expansion and brakes.

Max. capacities 1,500-6,000 lbs. (682-2727kg).

Rapid-Air 1000 Series dual swivel reels offer all the features of the 100 Series dual swivel reels in a larger, heavy-duty unit designed to save valuable production time when handling heavy coils. Benefit from quick changeover and minimize downtime between loading coils or stock. The swivel reel is designed so the operator can load or unload the inactive reel head while the job is still running.

Model RSA6000

Rim Drive Payout Reels

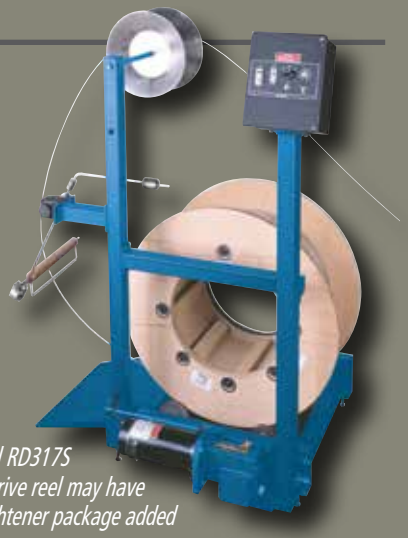
Allows payout from either press side or backside of reel.

Our rim drive reel can be ordered with a Rapid Roll or straightener package. Choose the control that best fits your needs. Our three controls include standard loop control as well as auxiliary touch control or sonic control. See the control section of this catalog for details.

Model Selection

Reel Model	Payout Max Coil Weight	Max OD	Min OD	Material Max Width	Speed per min	Size HP
Rim Drive Only						
RD317S	3,000 lbs (1360kg)	40" (1016mm)	18" (457mm)	17" (431mm)	2,400" (60m)	1/2
RD417M	4,000 lbs (1814kg)	40" (1016mm)	18" (457mm)	17" (431mm)	3,600" (91m)	1

Straighteners or power rolls may be added for space saving.



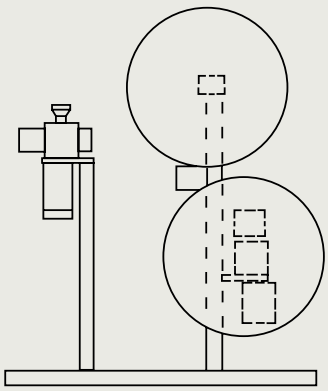
Model RD317S
Rim drive reel may have straightener package added

Modular Multi-Head Reel Combinations

Multi-head reel combinations provide payout and rewinding capabilities and interleaf protection.

Any number of multi-head setups can be put in place to accommodate your manufacturing needs. One reel setup can be in full operation while the other setup is standing by, ready to make a smooth and quick changeover. Less downtime means added production efficiently. Inserting interleaf material to protect delicate, plated or intricately shaped materials that could snag or tangle during manufacturing is a simple procedure. The use of multi-head reel combinations allows you to put tension on the stock for a tighter, more compact wrap. Consult factory for special arrangements.

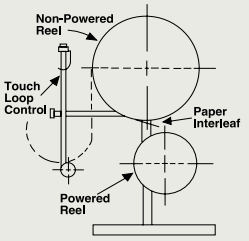
*Model ML2B*R13NF*R13NF*R24A*R24A*



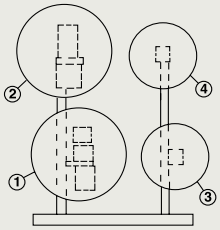
Example: ML2A2B *PIV
R23A *R23NF

A three head modular system unit for left-hand active loop. *PIV is on left post, R23A on lower right-hand post, and *R23NF on upper right-hand post.

Optional equipment for this system could include: Model LC-DSE Dual Switch to select upper or lower head, non-powered straightener, loop control system, optional post heights.



Typical dual reel setup when paper interleaf is required.



Both left-hand and right-hand modular system units are assembled in the sequence illustrated.

Pallet Reels

Pallet Master Decoilers

Leave stock coils on shipping pallets and reduce material handling.

Pallet Master offers precision payout for high-speed, high-volume operations. Handle loads up to 10,000 pounds (4545kg). A variety of options extend versatility.

With Pallet Master decoilers, less material handling is required and delicate materials are less apt to be damaged. Also improves safety.

Pallet Master decoilers can be linked to Rapid-Air stock straighteners or Rapid-Roll Power units. Payout, pulling, straightening and loop control on stock widths up to 6" (152mm) can be performed with these space-saving, affordable combinations. Direct drive assures smooth, dependable operation.

Options and accessories expand versatility:

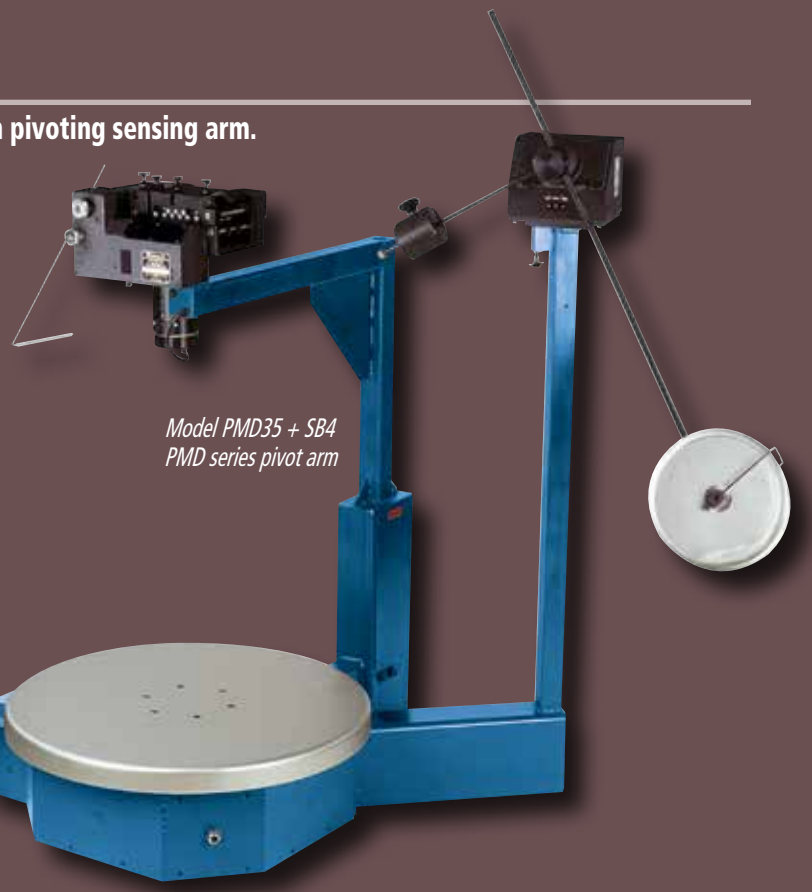
- Taut stock detection capability can be added.
- Electronic, high-speed braking package.
- Remote jog provides set-up convenience.
- Outside diameter keeper minimizes clockspring.

Pivot Arm

With or without straightener. Center turntable support with pivoting sensing arm.

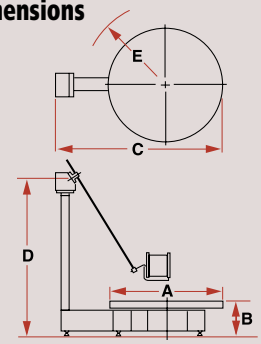
Max. capacities 3,500-10,000 lbs. (1591-4545kg).

Rapid-Air Pallet Master decoilers with pivot arm provide a versatile material payout positioning loop sensoring arm coupled with a control that allows further "fine tuning" capability. These units are available with a space saving modular Rapid-Air straightener as well. Optional guide rollers available.



Model PMD35 + SB4
PMD series pivot arm

PMD Dimensions



Dimensions

	A	B	C	D	E
PMD35	37" (939mm)	14.5" (368mm)	63.5" (1612mm)	66" (1676mm)	44" (1117mm)
PMD50	51" (1295mm)	17.5" (444mm)	71" (1803mm)	66" (1676mm)	44" (1117mm)
PMD100	51" (1295mm)	19.5" (495mm)	71" (1803mm)	66" (1676mm)	58" (1473mm)

Model Selection

Standard Pallet Reel Pivot Arm Model	Max Coil Weight	Max Coil OD	Max Material Width	Max Material Thickness	Max Coil Height	Powered Reel Max Speed	AC Input Power Required
PMD35	3,500 lbs (1591kg)	36" (914mm)	4" (101mm)	.050" (1.27mm)	30" (762mm)	20rpm	3/4hp, 115vac, 1ph
PMD50	5,000 lbs (2272kg)	50" (1270mm)	6" (152mm)	.050" (1.27mm)	30" (762mm)	20rpm	1hp, 115vac, 1ph
PMD100	10,000 lbs (4545kg)	50" (1270mm)	6" (152mm)	.050" (1.27mm)	30" (762mm)	20rpm	2hp, 230vac, 1ph

NOTE: Consult factory on material width and thickness outside table specifications.

Pallet Reels

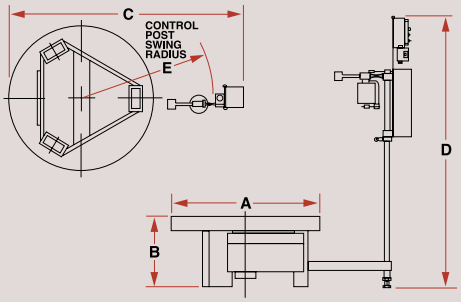
Horizontal Arm

With or without straightener. Low cost solution with turntable edge support and horizontal sensing arm.
Max. capacities 3,500-5,000 lbs. (1591-2272kg).

The ideal low cost pallet decoiler. Features easy set up and thread up. The free motion material guide roll automatically seeks the best position for material transition and guiding. Available with a modular Rapid-Air straightener to provide increased production in a compact, space saving unit. Optional guide rollers available.

Model PMDH35 + SBX4
PMDH series
horizontal arm
with straightener

PMDH Dimensions



Dimensions

	A	B	C		D		E	
			Min.	Max.	Min.	Max.	Min.	Max.
PMDH35	42" (1066mm)	20" (508mm)	61" (1549mm)	68" (1727mm)	52" (1320mm)	77" (1955mm)	31" (787mm)	38" (965mm)
PMDH50	51" (1295mm)	20" (508mm)	71" (1803mm)	78" (1981mm)	52" (1320mm)	77" (1955mm)	37" (939mm)	44" (1117mm)

Model Selection

Standard Pallet Reel Horizontal Arm Model	Max Coil Weight	Max Coil OD	Max Material Width	Max Material Thickness	Max Coil Height	Powered Reel Max Speed	AC Input Power Required
PMDH35	3,500 lbs (1591kg)	36" (914mm)	4" (101mm)	.050" (1.27mm)	30" (762mm)	20rpm	3/4hp, 115vac, 1ph
PMDH50	5,000 lbs (2272kg)	50" (1270mm)	6" (152mm)	.050" (1.27mm)	30" (762mm)	20rpm	1hp, 115vac, 1ph

Pivoting Arm Cutters and Reciprocating Blade Cutters

For a variety of applications. Accurate, automated for precise, high-speed high volume repetitive jobs.

Rapid-Air offers a full range of pneumatic stock cutters that provide outstanding application flexibility and efficiency in handling your routine or specialty shearing and cut-to-length jobs. Choose from a small pivoting arm model for light gauge material up to a cutter that exerts 8,000 lbs (3636kg) of force for 24" (610mm) wide flat stock. It can be a stand-alone press or base-mounted unit, or part of a fully synchronized cut-to-length system.

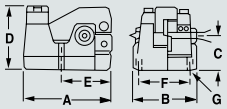
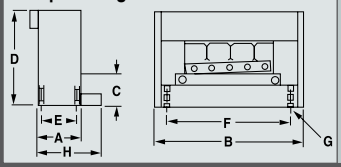
Model Selection

	Cutter Only Model	CTL Cutter Model	Max Stock Width	Max Thickness Capacity at Full Width	Cutter Blade Opening	Max. Force @ 100 psi (6.9 bar)
Pivoting Arm Flat Stock Cutters	**SCR125**	**SCR125S**	1-1/4" (32mm)	.040" (1.02mm)	.135" (3.43mm)	1,400 lbs (636kg)
	SCL125	**SCL125S**	1-1/4" (32mm)	.040" (1.02mm)	.135" (3.43mm)	1,400 lbs (636kg)
Pivoting Arm Round Stock Cutters	**RSC14**	**RSC14S**	.170" dia (4.32mm dia)	.170" dia (4.32mm dia)	.200" (5.08mm)	1,400 lbs (636kg)
	RSC25	**RSC25S**	.250" dia (6.35mm dia)	.250" dia (6.35mm dia)	.312" (7.92mm)	2,500 lbs (1136kg)
Reciprocating Flat Stock Cutters	**FSC4**	**FSC4S**	4" (102mm)	.040" (1.02mm)	.150" (3.81mm)	1,200 lbs (545kg)
	FSC6	**FSC6S**	6" (152mm)	.046" (1.17mm)	.180" (4.57mm)	2,000 lbs (909kg)
	FSC12	**FSC12S**	12" (302mm)	.068" (1.73mm)	.100" (2.54mm)	4,000 lbs (1818kg)
	FSC18	**FSC18S**	18" (457mm)	.080" (2.03mm)	.180" (4.57mm)	3,000/6,000 lbs (1365/2727kg)
	FSC24	**FSC24S**	24" (610mm)	.090" (2.29mm)	.090" (2.29mm)	4,000/8,000 lbs (1818/3636kg)

Cut range based on low carbon steel, commercial grade.

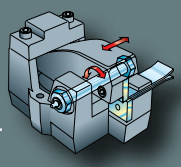
Pivoting Arm Cutters and Reciprocating Blade Cutters Dimensions and Features

Dimensions

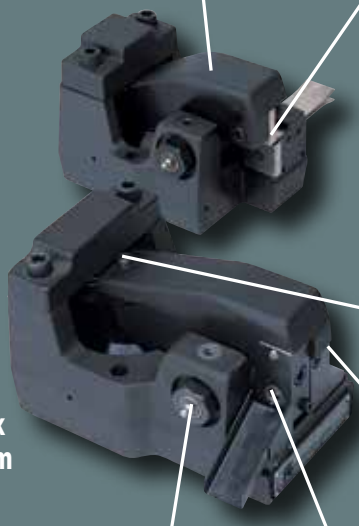
	Model	A	B	C	D	E	F	G	H
Pivoting Arm Cutters 	Wire or Round Stock								
	RSC14	7.94" (201mm)	5.75" (146mm)	3.00" (76mm)	5.50" (139mm)	4.50" (114mm)	4.69" (119mm)	.41" (10mm)	--
	RSC25	9.44" (239mm)	6.28" (159mm)	3.00" (76mm)	5.75" (146mm)	5.26" (133mm)	5.00" (127mm)	.53" (13mm)	--
	Flat Stock								
	SCR125	7.94" (201mm)	5.75" (146mm)	3.00" (76mm)	5.50" (139mm)	4.50" (114mm)	4.69" (119mm)	.41" (10mm)	--
	SCL125	7.94" (201mm)	5.75" (146mm)	3.00" (76mm)	5.50" (139mm)	4.50" (114mm)	4.69" (119mm)	.41" (10mm)	--
Reciprocating Blade Cutters 	Flat Stock								
	FSC4	6.00" (152mm)	10.50" (261mm)	3.22" (81mm)	10.70" (271mm)	5.00" (127mm)	8.00" (203mm)	.53" (13mm)	9.00" (228mm)
	FSC6	7.25" (184mm)	13.00" (330mm)	3.22" (81mm)	9.80" (248mm)	6.00" (152mm)	10.42" (264mm)	.53" (13mm)	10.00" (254mm)
	FSC12	8.72" (221mm)	22.00" (558mm)	4.50" (114mm)	13.25" (336mm)	7.24" (183mm)	18.00" (457mm)	.66" (16mm)	12.50" (317mm)
	FSC18	10.75" (273mm)	29.00" (736mm)	6.95" (176mm)	20.50" (520mm)	9.25" (234mm)	25.00" (639mm)	.66" (16mm)	--
	FSC24	10.75" (273mm)	35.00" (889mm)	6.95" (176mm)	20.50" (520mm)	9.25" (234mm)	31.00" (787mm)	.66" (16mm)	--

Flat stock pivoting arm cutters

Models
SCR 125 & SCL125
Flat stock up to
1-1/4" (32mm) wide



- Pivot arm adjusts laterally for cutting blade clearance.
- Eight cutting edges per blade can be used before resharpening.

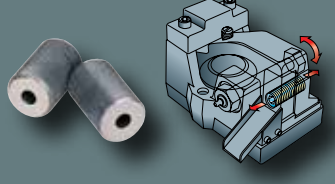


- Stock guides included on flat stock models.
- Custom guides available.
- Pivot arm position is adjustable to align cutting inserts.
- Special stock guiding systems can be added.

Round stock pivoting arm cutters

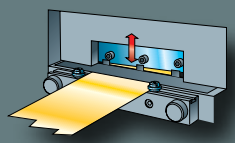
Models
RSC14 & RSC25
Wire or round stock
up to .312" (7.92mm)

- Lube fitting for pivot shaft bearings.
- Threaded cutting inserts for clearance adjustment.

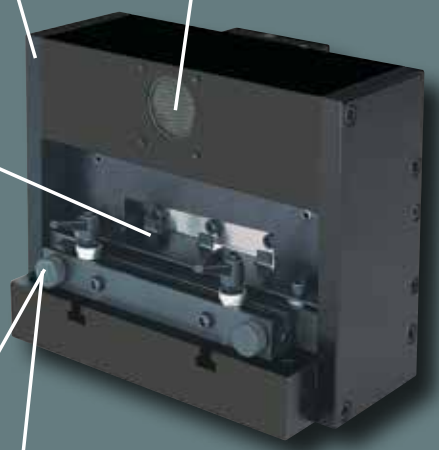


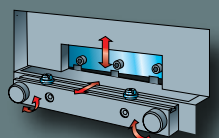
Reciprocating blade cutters

- Solid structural parts hold long-term alignment and cutting accuracy.
- Precision machined operating components are all housed inside the cutter.
- No external cylinders, valves or hoses.
- Internal pneumatic piston system includes integrated quick exhaust and muffler.
- 18" (457mm) and 24" (610mm) cutters include selectable tonnage control.



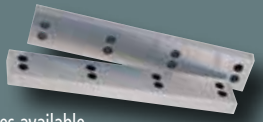
- Adjustable stock guide rollers.
- Safety guard - stock must pass underneath the guard before reaching recessed cutting area.





- Quick, simple blade adjustment.
- Upper blade lowers on a cam assembly.
- Thumbscrews position lower blade front-to-back.

Models FSC4,
6, 12, 18, 24
Flat stock up to
24" (610mm) wide



- Easy blade removal.
- Four blade edges can be used before resharpening.
- Tool steel blades are standard.
- Carbide insert, titanium nitride coated and other type blades available.

Cut-To-Length

C-T-L Machines

Accurate, automated stock cutting for precise, high-speed high volume repetitive jobs.

Model Selection with Air Feed

Cut-To-Length Model Number	Cutter Width	Max Stock Width	Max Cutter Thickness
FSC4SEB+CB16C+D3S	4" (102mm)	4" (102mm)	.040" (1.02mm)
FSC6EB+CB16C+F4S FSC6EB+CB16C+F6S FSC6EB+CB16C+F12S	6" (152mm) 6" (152mm) 6" (152mm)	6" (152mm) 6" (152mm) 6" (152mm)	.046" (1.17mm) .046" (1.17mm) .046" (1.17mm)
FSC12SEB+MB24C+L12S	12" (305mm)	12" (305mm)	.068" (1.73mm)
SCL125S+CB16A+A2S SCL125S+CB16A+A4S	1-1/4" (32mm) 1-1/4" (32mm)	1-1/4" (32mm) 1-1/4" (32mm)	.040" (1.02mm) .040" (1.02mm)
* RSC14S+CB16A+A2S * RSC14S+CB16A+A4S * RSC14S+CB16A+W6S * RSC14S+CB16A+W12S	.170" dia (4.32mm dia) .170" dia (4.32mm dia) .170" dia (4.32mm dia) .170" dia (4.32mm dia)	.170" dia (4.32mm dia) .170" dia (4.32mm dia) .170" dia (4.32mm dia) .170" dia (4.32mm dia)	.170" dia (4.32mm dia) .170" dia (4.32mm dia) .170" dia (4.32mm dia) .170" dia (4.32mm dia)
* RSC25S+CB16A+W6S * RSC25S+CB16A+W12S	.250" dia (6.35mm dia) .250" dia (6.35mm dia)	.250" dia (6.35mm dia) .250" dia (6.35mm dia)	.250" dia (6.35mm dia) .250" dia (6.35mm dia)

* Consult factory with actual specifications prior to ordering.

A Rapid-Air cut-to-length machine combines an air operated stock cutter and a Rapid-Air feed or a programmable Rapid-Roll feed with a control system. All of this is mounted in one convenient, easy-to-use, low cost package for use on simple cut-off operations.

Model CTL SCL125S + CB16A + A2S

A Rapid-Air cut-to-length machine with servo feed, or servo feed straightener (KBX100), is a real production booster for both long or short length stamping operations. These integrated units may provide a maximum feed stroke of up to 999" (2537cm) or more, and handle maximum stock widths up to 24" (610mm).

Consult our application engineers regarding special control programs and feed-cutter combinations available to meet your specific needs.

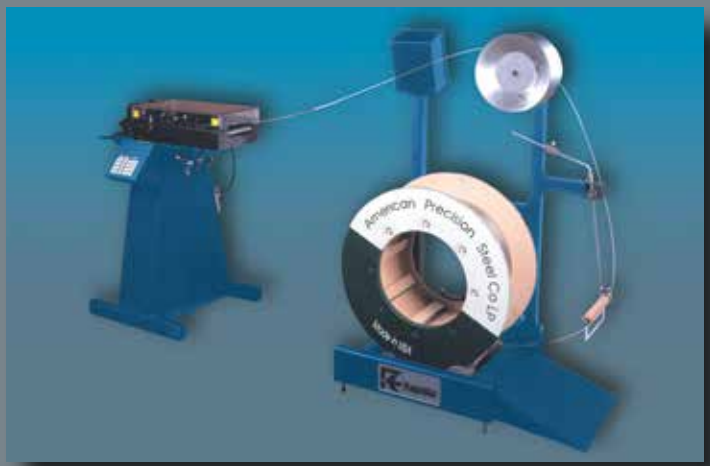
Model CTL FSC24S + MB30 + 224T

Model Selection with Servo Feed

CTL Model Number	Cutter Width	Max Stock Width	Max Cutter Thickness
FSC6S+CB16+106D FSC6S+CB16+KBX104S FSC6S+CB16+KBX108S	6" (152mm) 6" (152mm) 6" (152mm)	6" (152mm) 4" (102mm) 6" (152mm)	.046" (1.17mm) .046" (1.17mm) .046" (1.17mm)
FSC12S+MB24+112D FSC12S+MB24+112T	12" (305mm) 12" (305mm)	12" (305mm) 12" (305mm)	.068" (1.73mm) .068" (1.73mm)
FSC18S+MB30+118D FSC18S+MB30+118T FSC18S+MB30+218T	18" (457mm) 18" (457mm) 18" (457mm)	18" (457mm) 18" (457mm) 18" (457mm)	.080" (2.03mm) .080" (2.03mm) .080" (2.03mm)
FSC24S+MB330+224T	24" (610mm)	24" (610mm)	.090" (2.29mm)
SCL125S+CB16+SMS2	1.25" (32mm)	1.25" (32mm)	.040" (1.02mm)
* RSC14S+CB16+106D	.170"dia (4.32mm dia)	grooved rolls	.170"dia (4.32mm dia)
* RSC25S+CB16+106D	.250"dia (6.35mm dia)	grooved rolls	.250"dia (6.35mm dia)

* Consult factory with actual specifications prior to ordering.

Cut-to-length special order.



Complete cut-to-length line: SCL125S + CB16A + W6S air feed CTL machine and RD317S rim drive payout reel (loop is developed behind and above reel to save space).

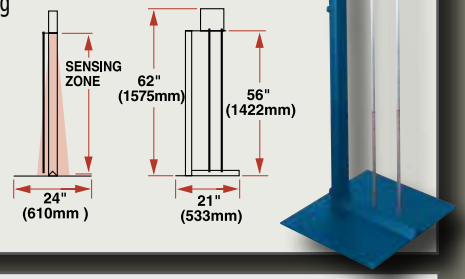
Loop Controls

Loop Controls

Proportional electronic loop control system is standard for powered models.

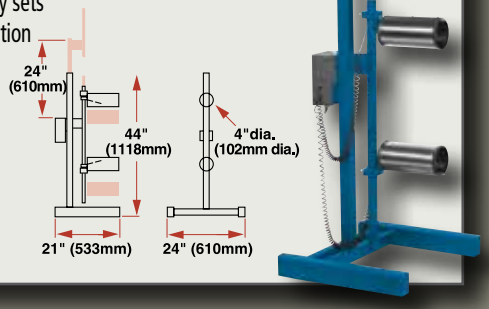
Model RS1 – Optional ultrasonic non-contact loop control.

Automatically adjusts the operating speed of a powered reel to maintain a free material loop and to match material flow to a required line speed. No moving parts, no stock contact, no loop sensing arm, mechanical linkage or other hardware. Works with equal precision for both conductive and non-conductive materials. Ultrasonic pulses locate the material position anywhere in the sensing range. Signals are transmitted to an integral microprocessor which programs the speed of the coil reel. A free loop, even at high speeds, can be kept under precise control without erratic stop and start. Special stock types and configurations can be processed without damage - regardless of coil coating finishes, density or capacity.



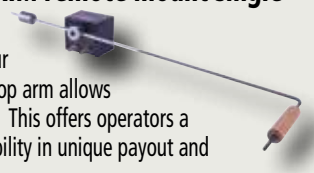
Model RTB – Optional electronic hi-lo touch system loop control.

The Rapid-Touch system works without use of a material sensing arm by sensing the upper and lower position of conductive material. For use with non-conductive material, an adjustable probe is furnished on the inside of the large diameter, flexible sensors. As the material ranges between the sensors, a solid state controller automatically sets the most uniform line speed for continuous operation and changes this speed to match variable requirements. Power requirements and interfacing are satisfied when the plug connection is made with the Rapid-Air reel. Sensor height is adjustable three ways to accommodate varying material loop positions.



Optional LLRIC/LLRIM remote mount single actuating arms.

The modular design of our Rapid-Air proportional loop arm allows it to be remote mounted. This offers operators a high degree of loop flexibility in unique payout and rewind applications.

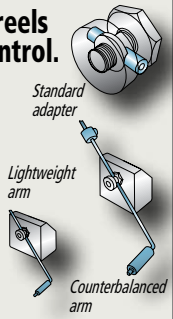


External loop control port included with all powered reels and straighteners

Our standard loop control for Rapid-Air power products is a pushbutton unit with digital display. This very flexible proportional control allows fine setting or speed, loop angle and loop height. A remote or external loop sensor may be plugged directly into this control as an alternate loop control.

Standard features on DC drive reels and stock straightener loop control.

Both a lightweight low inertia loop sensing arm and a heavier, counterbalance arm can be used on all powered reel models. The counterbalanced arm fits directly through the loop sensing arm shaft. A counterweight can be shifted to apply more or less tension to material being payed out or rewound. When the lightweight arm is used, it fits into a sleeve that is inserted in the shaft hole and locked into place.



Model Selection

Model	Description	Used With
RS1	Rapid-Sense Ultrasonic Loop Control	Reels, Straighteners & Power Rolls
RTB	Rapid-Touch Loop Control with Base Mounting	Reels, Straighteners & Power Rolls
RTA	Rapid-Touch Loop Control with Arm Mounting	Reels, Straighteners & Power Rolls

Special Requirements

Custom Solutions

Line or Unit Modifications

- We can modify a line or an individual unit to suit your special requirements.

Custom Programming

- Experienced engineers on staff can provide special programming soutions and displays, gag, metric, cut-to-length, multiple languages, special job storage requirements, and many other capabilities.

Mechanical Modifications

- Rapid-Air can make both control and many mechanical system modifications to our standard equipment models to suit your individual production process.

Product Specifications:
All product specifications are subject to change without prior notice. Rapid-Air Corp. will provide up-dated technical data and specifications on any product upon written request.

The Most Reliable Feeding & Coil Handling Equipment Made

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