



Machine Features

- HIGH PRODUCTION MACHINE –5160 TO 7740 PINS PER HOUR
- PIN LENGTHS FROM 50mm to 229mm (2" to 9")
- PIN DIAMETERS FROM 1.57mm to 3.18mm IN DIAMETER (.062" to .125")
- 20 to 40 MINUTE LENGTH CHANGE
- 1-2 HOUR DIE CHANGE FOR DIFFERENT DIMENSIONS ON ENDS OF PINS
- PIN DIAMETER CHANGE IN 2-3 HOURS
- HOLDS CLOSE TOLERANCE ON REDUCED DIAMETERS OF +/-0.025mm (+/-0.001")



Wire Cutoff and Straightener

The **Oakley Terminal Pin Production System** consists of two machines: a Wire Cutoff and Straightener and a Cold Heading machine. These machines can accommodate wire diameters from 1.57mm (.062") to 3.18mm (.125") and pin lengths from 50mm (2.0") to 229mm (9.0").

The wire is taken from spools or stems and then fed through a rotary straightener and cut to the desired length. This straightener will cut pin blanks from 50mm (2.0") to 140mm (5.5") at a rate of 10,000 per hour and pin blanks from 140mm (5.5") to 229mm (9.0") at a reduced rate of 5,000 per hour. The wire is also cleaned as it is fed into the machine.

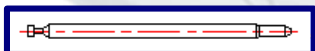
The pin blanks are then placed in the hopper located at the rear of the Cold Heading Machine. The pin blanks are then fed through a series of progressive dies that gradually form the ends of the terminal pins. The production rate on the cold heading machine is 7,740 pieces per hour for pins with wire diameters from 1.57mm (.062") to 2.0mm (.079") and 5,160 pieces per our for pins with wire diameters from 2.1mm (.083") to 3.18mm (.125").

The Cold Heading Machine can be changed for different length pins in 20 to 40 minutes. The machine can be changed for different dimensions on the ends of the pins in 1-2 hours by removing and replacing the forming dies. The machine can also be changed for different wire diameters in 2-3 hours.

The Cold-Heading machine is capable of holding a tolerance of +/- 0.25mm (.010") on the length of the pins and +/- 0.025mm (.001") on the reduced diameters.

Because the machine must form the pins, the wire must have a tensile strength between 60,000psi and 75,000psi (4218 kg/cc² and 5273 kg/cc².) Stainless steel wire is **definitely not** suitable for these machines.

The following are the types of pins that can be made on these machines.



Typical upper terminal pin



Typical lower terminal pin with optional washer groove

Cold-Heading Machine Specifications

Length:	915mm (36")
Width:	915mm (36")
Height:	1651mm (65")
Weight:	680 kgs.(1500 lbs.)
Electric Supply:	380v/3ph/50hz or 220/440v/3ph/60hz
Power Consumption:	3.8Kw@220v;4.6Kw@380v; 4.15Kw@480v
Production Speed:	5,160 to 7,740 pieces per hour depending upon diameter
Min. Pin Diameter:	1.57mm (0.062")
Max. Pin Diameter:	3.18mm (0.125")
Minimum Pin Length:	50mm (2.0")
Maximum Pin Length:	229mm (9.0)
Pin Material:	Must have a tensile strength between 65,000 to 75,000psi or 4218 to 5273 kg/cc ²

Wire Cutoff and Straightener Specifications

Length:	2438mm (96")
Width:	915mm (36")
Height:	1220mm (48")
Weight:	365 kgs.(800 lbs.)
Electric Supply:	380v/3ph/50hz or 220/440v/3ph/60hz
Power Consumption:	3.8Kw@220v;4.6Kw@380v; 4.15Kw@480v
Production Speed:	5,000 to 10,000 pieces per hour depending upon length
Min. Pin Diameter:	1.57mm (0.062")
Max. Pin Diameter:	3.18mm (0.125")
Minimum Pin Length:	50mm (2.0")
Maximum Pin Length:	229mm (9.0)
Pin Material:	Must have a tensile strength between 65,000 to 75,000psi or 4218 to 5273 kg/cc ²