GT 552 BAR FEED

AUTOMATIC MAGAZINE BAR FEEDER FOR FIXED HEADSTOCK LATHES

Diameter range: 0.19" to 2.16" (5 mm to 55 mm)
Bar length: 36" - 12' 8" (915 mm - 3860 mm)

PERIPHERAL VISION
For CNC machine tool peripherals, it's *LNS*, then all the rest

LNS provides a full range of barfeeders, chip conveyors, coolant management systems, air filtration systems, and workholding systems that is second to none on the market. We are known in the industry for the solid experience we have gained over several decades in an exceptionally wide range of applications, our excellent customer service, and our technical support. This support is ensured by highly qualified technicians who are available throughout North America.

Accelerating Productivity at an Affordable Price

The GT 552 is LNS's highly affordable solution to automatically load long bars from 5 mm to 55 mm into fixed headstock machines. Its heavy duty design keeps production running at optimal RPMs.

Easy to Use Remote Control (HMI)

The user friendly touch screen HMI with prompting menu screens ensures the interaction between the bar feeder and the lathe, and therefore the production process can be run safely and efficiently.

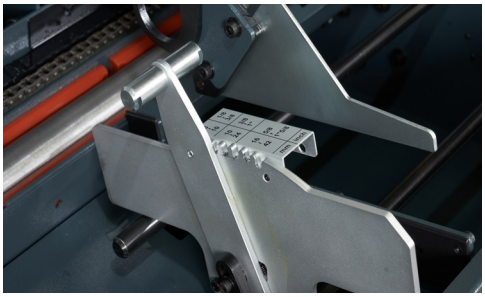
The remote control is ultra-light featuring easy set up and operation. It displays alarm description, alarm history of operation errors and position tracking (inch/metric programming).

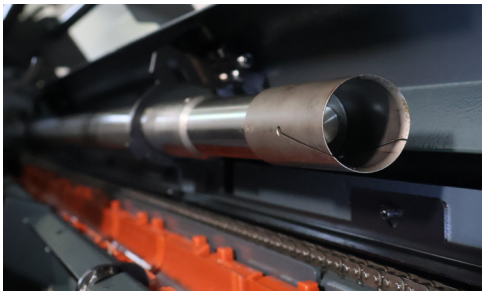
Easy setup in less than 1 minute. The operator simply inputs bar information into the remote control:

- Shape
- Bar Diameter
- Guiding Elements Diameter
- Feed Out Length

This automatically sets:

- Pushing Torque
- Forward Speed
- Feeding Length
- Front Stabilizer Adjustment





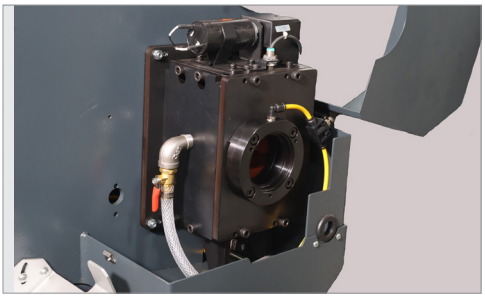
Changeover Simplicity

Changeover of bar diameter on magazine tray is performed by a simple manual adjustment via the changeover lever, no tool required.

- 2 minutes or less for partial changeover
- 11 minutes or less for complete diameter changeover

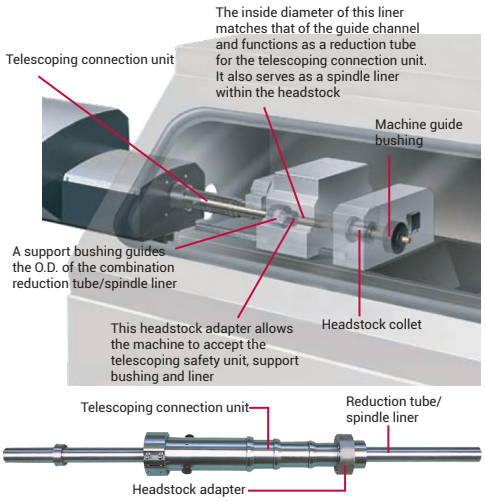
For complete diameter changeover, the lower guiding elements can easily and quickly be replaced. No tool required with this simple and reliable design. The patented upper section of channel guides cover the entire bar diameter range and do not need to be adjusted or replaced when changing out lower guide channels.

The minimal gap between guide channels maintains oil during bar rotation, and two available pusher lengths cover the entire range of fixed headstock machines with no pusher extension required.



Greater Bar Stock Stability and Less Oscillation Inside the Lathe

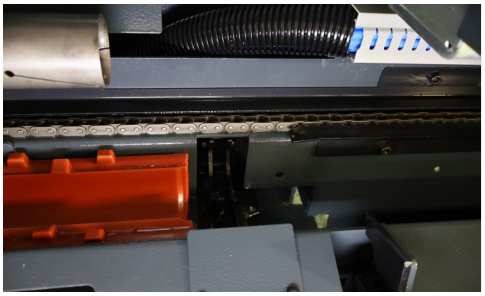
A robust automatic front stabilizer with v-shaped guiding elements dampens residual vibration between the front of the bar feeder and the back of the spindle. Automatic adjustment is managed via the bar diameter entered into the HMI. This provides a consistently accurate stabilizer setting, increasing stabilizer performance. Vee blocks can be easily changed out to round blocks for running profiled material. An air blast is included to eliminate residual oil transferring from the bar feeder to the machine.



OPTIONAL Swiss Safety Connection

The LNS Swiss safety connection eliminates the unsupported area between the bar feed and machine tool to provide greater safety and better bar stock support. It consists of a telescoping tube that extends in sections to maintain a continuous connection between the GT 552 and the machine sliding headstock. This feature allows the headstock to move forward to make parts without the danger of exposed bar stock.

For added flexibility, this connection system has an available assortment of reduction tubes. The inside diameters of these reduction tubes match those of the bar feed's guide channels. They act as a combination spindle liner to reduce the gap inside the spindle and additionally the inside diameter of the Swiss safety connection. The result is reduced vibration and bar oscillation within a critical and traditionally under-supported area. This GT 552 feature improves part diameter tolerances, increases RPM, enhances surface finish and extends tool life.



Powerful Self-Cleaning Vise for Bar Extraction and Insertion

A strong cylinder design intensifies the bar stock clamping, ensuring high reliability of detection on insertion and extraction cycle. This helps prevent new bar stock or remnant from insertion failure or pulling out, thus improving operational reliability.

More Robust for Exceptional Productivity

The GT 552 is built around an extra heavy, rigid frame filled with mineral cast to further improve long-term stability and vibration dampening.

A Z-axis retract system on the GT 552 allows the bar feed to be moved back 19 inches (490 mm) from the machine spindle.

With its simplified design, this feature improves serviceability by providing easy access to all components, reducing production downtime.

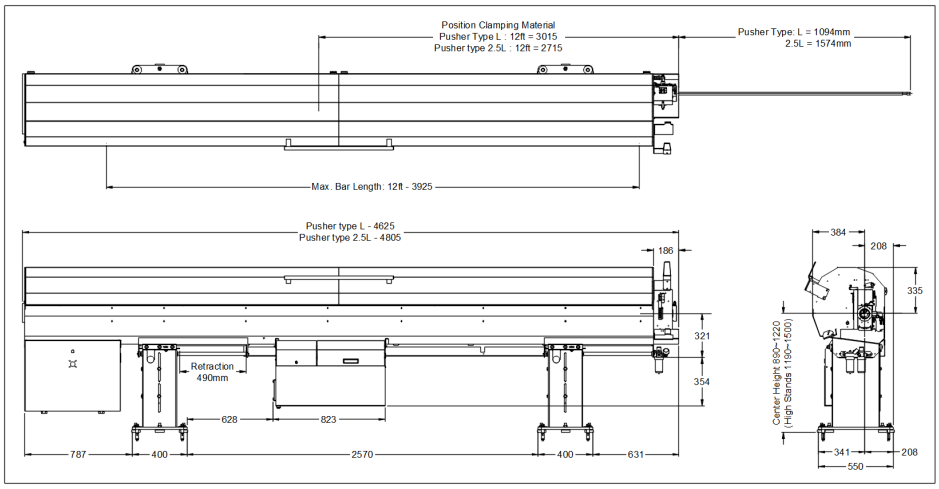
GT 552 BARFEED
TECHNICAL SPECIFICATIONS

Capacity	
Diameter	0.19" - 2.16" (5 mm - 55 mm)
Bar Length (12')	36" - 12' 8" (915 mm - 3860 mm)
Loading System	Lateral
Loading Capacity	11"(280 mm)
Loading Side	Front or Rear
Shipping Weight	3,250 lbs
Applications	
Type of Headstock	Fixed (Optional: Sliding)
Retraction Z	19.3" (490 mm)
Remnant Length	Min: 100 mm, Max: 450 mm
Front Rest	Automatic Adjusting Vee Block
Bar Selection	Simple Lever
Controls	Hand Held, Touch Screen

Changeovers	
Partial changeover	2 minutes (within the same guiding elements)
Complete changeover	11 minutes (for all guiding elements)
Driving Systems and Bar Support	
Motor	Servo
Drive	Chain
Guiding Channel	Sealed, Semi-Round
ISO 100 oil	15 gallons
Options	
Tall stand option - For expanded CL height range of 1210 mm to 1540 mm	
Sliding headstock package - Includes telescopic tube assembly and adaptation	

Barstock Straightness Specifications and Performance
For optimum rotational performance speeds, bar stock straightness needs to be .020" per 3.25 feet, non accumulative. Bar stock out of this tolerance will not run at optimum RPM. Other factors such as material type (brass, copper, bronze and other malleable materials), clamping efficiency of the machine workholding, alignment of the bar feed, oil type, bar preparation and spindle liners will affect optimum RPM capability of the system.

Guiding Channel Selection Chart										
Guiding Channel Diameter	14	17	23	29	33	39	43	46	53	56
Bar Stock Diameter Range Using Standard Collets	5-11	6.3-15	11-20.8	17-26.5	21-30.3	27-36.5	31-40.5	34-43	41-50	44-52
Bar Stock Diameter Range with Bar Preparation	5-13	6.3-16	11-22	17-28	21-32	27-38	31-42	34-45	41-52	44-55



PERIPHERAL VISION

Peripherals, by definition, are an outer boundary. But at LNS, that boundary is where we put our focus. Because here's the secret—with LNS peripherals on your side, you can turn your attention to what you do best—making chips and making money.

That's why we do what we do. Five product categories and industry-best expertise means no company on earth can match the passion and vision we have for machine tool peripherals.

LNS North America, Inc.
4621 East Tech Drive
Cincinnati, OH 45245

513-528-5674
allproducts-sales@LNS-northamerica.com
www.LNS-northamerica.com