

MANUAL CNC BAR PULLERS

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Why Use A Bar Puller?

Bar pullers provide a simple, inexpensive method for automating any CNC lathe. Bar Pullers cost much less than a bar feed and do not use up valuable floor space. Providing a maintenance-free operation, bar pullers are very easy to set up and use- no electrical interface is required. A wide gripping range is obtained from a compact design and they can be easily moved from one machine to another.

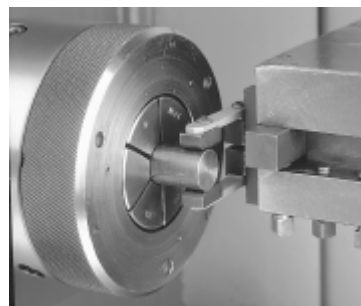
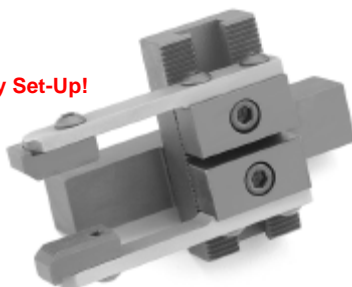
CNC COMPACT BAR PULLER

Extremely compact - Designed for small CNC machines where tool interference is a problem.

FEATURES:

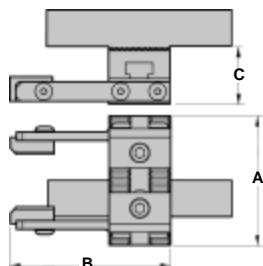
- Eliminates the need for expensive bar feeds.
- Gripping range from 1/8" - 4".
- Flexible heat-treated steel fingers provide strong gripping force.
- Also available in VDI shank styles.
- Standard jaws have a serrated gripping surface for increased holding power (smooth jaws available).
- Unit easily handles round, square, and hex stock.
- Finger holders and racks are serrated to provide positive location.
- All wear subjected parts are hardened for strength and long life.
- Comes with one set of standard jaws and one blank spindle bushing.

Easy Set-Up!



ROYAL PRODUCTS

Full Line Available!
Please call for more information.



Shank Size	Gripping Range	A	B	C	Part Number	Price Each
1/2" SQ	1/8" - 1 5/8"	2 1/8	3 3/4	1 3/16	ROY-43300	\$449.82
3/4" SQ	1/8" - 2 1/4"	2 5/8	3 3/4	1 3/16	ROY-43302	\$473.34
1" SQ	1/8" - 2 1/4"	2 5/8	3 3/4	1 3/16	ROY-43304	\$473.34
1" SQ	1/8" - 3"	3 5/8	3 3/4	1 3/16	ROY-43306	\$502.74
1" SQ	1/8" - 4"	3 5/8	3 3/4	1 3/16	ROY-43308	\$479.00

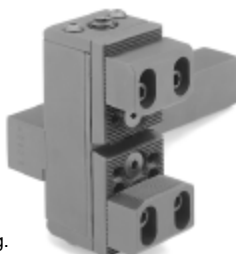
Compact Model Replacement Parts

Description	Part Number	Price Per Set
Spring Fingers	ROY-43505	\$58.80
Serrated Jaws	ROY-43500	\$84.28
Smooth Jaws	ROY-43502	\$106.00

CNC HEAVY DUTY BAR PULLER

- Gripping range from 1/8" to 6-1/2".
- Gripping force is easily adjusted by altering spring pressure.
- Available in square, round, and VDI shank styles.
- Jaws have two gripping surfaces:
 - Serrated for increased gripping power.
 - Smooth to help prevent marking.
- Unit easily handles round, square, and hex stock.
- Jaws and racks are serrated to provide positive location.
- All wear subjected parts are hardened for strength and long life.
- Eliminates the need for expensive bar feeds.
- Comes with one set of standard jaws and one blank spindle bushing.

Round Shank

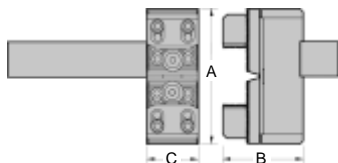


Square Shank



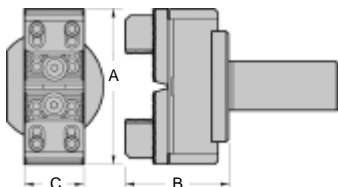
ROYAL PRODUCTS

Square Shank



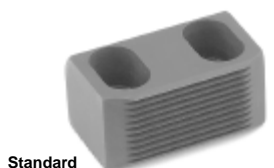
Square Shank Size	Gripping Range		A	B	C	Right Hand Part Number	Price Each
	Standard Jaws	Extra Cap. Jaws					
3/4"	1/8-2 1/4	1 7/8-3 3/4	3 7/8	2 9/16	1 1/2	ROY-43360	\$526.26
1"	1/8-2 1/4	1 7/8-3 3/4	3 7/8	2 9/16	1 1/2	ROY-43366	\$555.66
1"	1/8-3 1/2	1 7/8-5 3/8	4 3/4	2 9/16	1 1/2	ROY-43370	\$580.16
1"	1/8-3 5/8	1 7/8-5 1/2	5"	2 3/4	1 3/4	ROY-43372	\$598.78
1"	1/8-4 7/8	1 7/8-6 1/2	6 3/4	2 3/4	1 3/4	ROY-43376	\$671.30

Round Shank

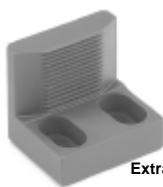


Round Shank Size	Gripping Range		A	B	C	Part Number	Price Each
	Standard Jaws	Extra Cap. Jaws					
1" dia.	1/8-2 1/4	1 7/8-3 3/4	3 7/8	2 15/16	1 1/2	ROY-43400	\$663.46
1 1/4 dia.	1/8-2 1/4	1 7/8-3 3/4	3 7/8	2 15/16	1 1/2	ROY-43402	\$663.46
1 1/4 dia.	1/8-3 1/2	1 7/8-5 3/8	5 3/8	2 15/16	1 1/2	ROY-43404	\$694.82
1 1/4 dia.	1/8-3 5/8	1 7/8-5 1/2	5"	3 1/8	1 3/4	ROY-43406	\$680.00
1 1/4 dia.	1/8-4 7/8	1 7/8-6 1/2	6 3/4	3 1/8	1 3/4	ROY-43408	\$749.70

REPLACEMENT JAWS



Standard



Extra-Capacity

Description	Part Number	Price Per Set
Standard	ROY-43510	\$116.62
Extra-Capacity	ROY-43512	\$134.26

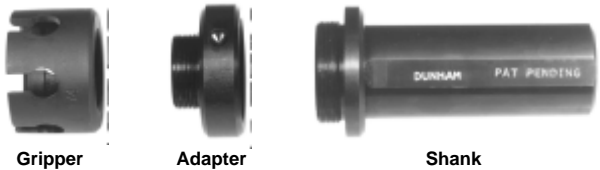
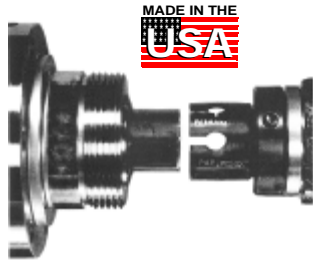
ROYAL PRODUCTS

Call Us Or Visit Our Website For Our Complete Selection!

MANUAL CNC BAR PULLERS

BAR STOCK PULLER FOR CNC LATHES

The Dunham Bar-Pull, designed for CNC lathes, is lightweight and self-activating with no moving parts. It does not interfere with other tools or cause turret imbalance, and installs easily in 60 seconds. It uses a shank (available in 7 diameters from 1/2" to 1 1/2") that is clamped in the turret lathe like a boring bar. The grippers are hand turned onto the shank thread or onto adapters that attach to the shank to accept smaller diameter grippers. The grippers are slotted like standard collets and, as they advance over the bar, are forced open to firmly grasp the bar for pulling out of the spindle to the programmed length. The gripping and release of the bar is automatic, and the Bar-Pull needs only 1/4" of the bar to engage.



How it works:

- Mount shank in turret, screw on adapter (if required) and gripper.
- Insert bar through back of spindle and clamp with collet or chuck.
- Face off minimum 1/4" projection using parting-off command in CNC program.
- Index turret to Bar-Pull and traverse turret toward spindle for programmed distance, sliding gripper over stock.
- Release clamping pressure on bar.
- Retract turret programmed distance.
- Reclamp bar.
- Retract turret to clear gripper from bar.
- Begin programmed machining cycle.
- Repeat until all bar is used.

FEATURES:

- Pulls bar to last usable part length
- Pull/positions bar $\pm 0.001"$
- Eliminates expensive bar feeds
- Works close to chuck or collet nose
- Does not interfere with adjacent tools or turret movement

Adaptors

Adaptor Size	Part Number	Price Each
5/8	DTC-APB0625	45.00
1	DTC-APB1000	45.00

Shanks

Shank Size	Part Number	Price Each
1/2	DTC-PB0500	58.00
5/8	DTC-PB0625	58.00
3/4	DTC-PB0750	58.00
7/8	DTC-PB0875	58.00
1	DTC-PB1000	58.00
1 1/4	DTC-PB1250	58.00
1 1/2	DTC-PB1500	58.00

Grippers

Grip Size	Part Number	Price Each
Using 5/8 Bar Pull Adapter		
3/16	DTC-PBG0187	45.00
1/4	DTC-PBG0250	45.00
5/16	DTC-PBG0312	45.00
3/8	DTC-PBG0375	45.00
7/16	DTC-PBG0437	45.00
Using 1" Bar Pull Adapter		
1/2	DTC-PBG0500	45.00
9/16	DTC-PBG0562	45.00
5/8	DTC-PBG0625	45.00
11/16	DTC-PBG0687	45.00
3/4	DTC-PBG0750	45.00
Direct Mount Grippers		
1 3/8	DTC-PBG1375	45.00
1 1/2	DTC-PBG1500	45.00
1 5/8	DTC-PBG1625	75.00
1 3/4	DTC-PBG1750	75.00
1 7/8	DTC-PBG1875	75.00
2	DTC-PBG2000	75.00

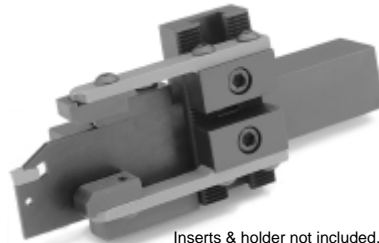
Kits Also Available! Please Call For More Information!

COMBINATION CNC BAR PULLER WITH CUT-OFF TOOL

Eliminates the need to index between cut-off and pulling operations because both tools occupy the same turret location.

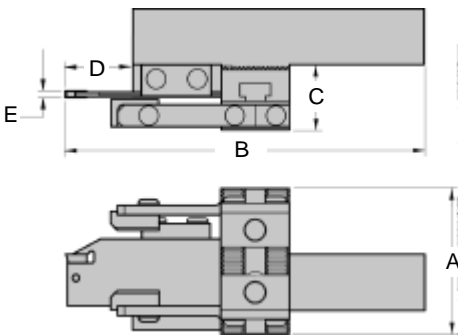
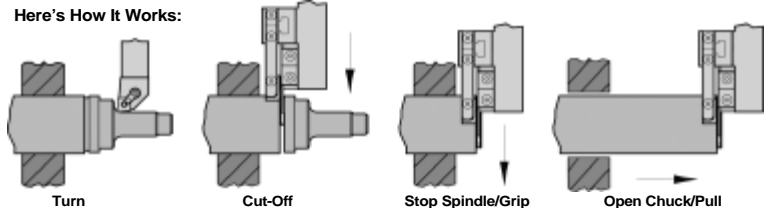
FEATURES:

- Reduced Indexing Time, Set-up Time and Cycle Time
- Compact design - good for small CNC machines where tool interference is a problem.
- Gripping range from 1/8" - 4", and handles round, square and hex stock.
- Flexible heat-treated steel fingers provide strong gripping force.
- Standard jaws have a serrated gripping surface for increased holding power (smooth jaws available).



Inserts & holder not included.

Here's How It Works:



Compatibility Chart

Brand	1/2" or 3/4" Shank	1" Shank
Carboly	150.10-20-3	150.10-25-3
Iscar	SGFH26-3	SGFH32-3
Kennametal	DSB4-340-105	DSB5-340-110
Manchester	340-105	340-110
Sandvik	151.2-21-30	151.2-25-30
Valenite	VH101 26 3	VH101 32 3

Combo CNC Bar Pullers

Shank Size	Gripping Range	A	B	C	D1	E	Right Hand Part Number	Price
1/2" SQ	1/8-1 5/8	2 1/8	4 11/16	1-3/16	7/8	0.125	ROY-43452	\$596.82
3/4" SQ	1/8-2 1/4	2 5/8	4 3/4	1-3/16	7/8	0.125	ROY-43456	\$613.48
1" SQ	1/8-2 1/4	2 5/8	6 3/8	1-3/16	1-1/4	0.125	ROY-43460	\$620.34
1" SQ	1/8-3	3 5/8	6 3/8	1-3/16	1-1/4	0.125	ROY-43464	\$642.88
1" SQ	1/8-4	3 5/8	6 3/8	1-3/16	1-1/4	0.125	ROY-43468	\$731.08

Replacement Parts

Description	Part Number	Price Per Set
Spring Finger Set	ROY-43505	\$58.80
Serrated Jaw Set	ROY-43500	\$84.28
Smooth Jaw Set	ROY-43502	\$103.88

Call Us Today For All Of Your Machine Tool Needs!