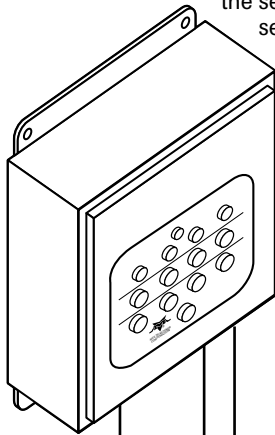




PierceForm® Stud

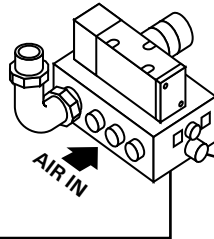
SYSTEM CONTROLLER

This unit controls all functions of the system. The timing of all solenoid valves, the release of a Stud to the Installation Head, and the sensing of a Stud within the Head are all sequenced through this Controller. All functions are timed to take place within single or continuous cycles. Note: If the speed of the press is to be altered, the controller may need to be reprogrammed.



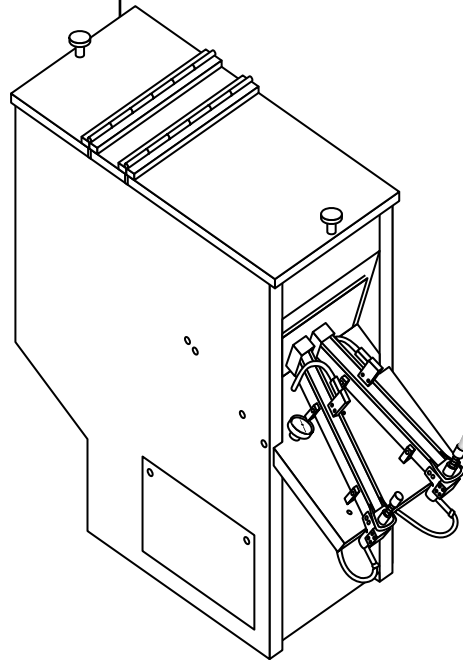
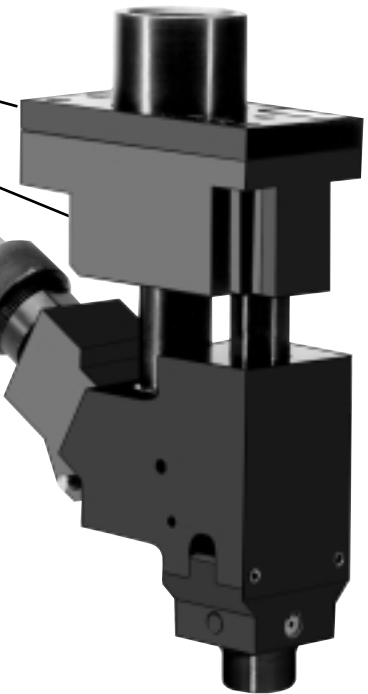
PNEUMATIC CONTROL VALVE

This system consists of a Solenoid, which controls the movement of the Installation Head. The Solenoid is initiated through the system controller. This timing shall be pre-set and adjusted to the stroke and speed of your press.



INSTALLATION HEAD

The PierceForm Stud Installation Head is mounted in the upper die shoe of the press. It is air-controlled and designed to accurately install PierceForm Studs using the mechanical force of the press.



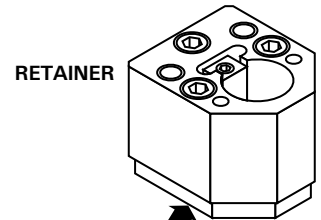
STUD GUIDE

STUD GUIDE

The plastic Stud Guide is connected between the Feeder and the Installation Head. When setting up the system, careful attention must be taken not to kink this component. Generally a three foot radius is used to ensure efficient operation. The length of the Stud Guide effects cycle time.

DIE BUTTON & RETAINER

The Die Button is secured in a Retainer, which is mounted in the lower die shoe. When the press closes, the Installation Head punches the PierceForm Stud through the metal panel supported by the Die Button. The Die Button forms the barrel of the Stud around its circumference to securely lock it in place and coins the slug into the barrel, thereby eliminating scrap disposal.



HARDENED BACKUP PLATE

FEEDER

Because PierceForm Studs are blown by air pressure from the feeder to the Installation Head in the Feed System, the Feeder can be mounted at any level you choose. The Feeder has internal solenoids integrated with the System Controller for blowing of Studs to the Head Assembly.

