



High Performance  
**Powered Straighteners**  
**Coil Handling Equipment**  
**& Air Feeds**



**FeedLease**






CORPORATION

**The Proven Choice**



The Proven Source

## Table of Contents

	<b>Pages 2 - 5</b> Powered Straighteners
	<b>Pages 6 - 11</b> Coil Reels
	<b>Pages 12 - 15</b> Coil Cradles
	<b>Page 17</b> Coil Upenders
	<b>Page 18 - 25</b> Air Feeds

Since 1969, Feed Lease has been the proven choice for top quality coil handling, straightening and feeding equipment. Our craftsmen build each machine to your specifications. Instead of relying on an impersonal "this is what you get" approach, Feed Lease sales and engineering staff listen to your concerns. We make it a point to quote and build each piece of equipment around the application's requirements. This "Engineered Solutions" approach allows us the versatility to make your equipment just right for your unique application. Our builders are quality craftsmen with years of experience manufacturing top quality equipment.

In this era of corporate takeovers and mergers, Feed Lease continues as a family owned and operated business. This means the same care and attention to detail comes through with each feed line or individual piece. Feed Lease is large enough to handle your heavy-duty applications (build equipment to 60,000 lbs and 96" wide), yet right sized to provide the personal attention and service that is often lacking today.

Please review our coil handling, straightening and air feed catalog and see for yourself why for over 30 years Feed Lease is the Proven Choice!

## Warranty

Feed Lease Corporation warrants its products against defects in material or workmanship for a period of one year from date of shipment. Parts claimed defective must be returned, freight pre-paid, to our plant in Rochester Hills, Michigan. Any part claimed defective and checked as such by our factory will be replaced or repaired (at our option) free of charge F.O.B. our plant. EXCEPT AS EXPRESSLY PROVIDED HEREIN, THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING A WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

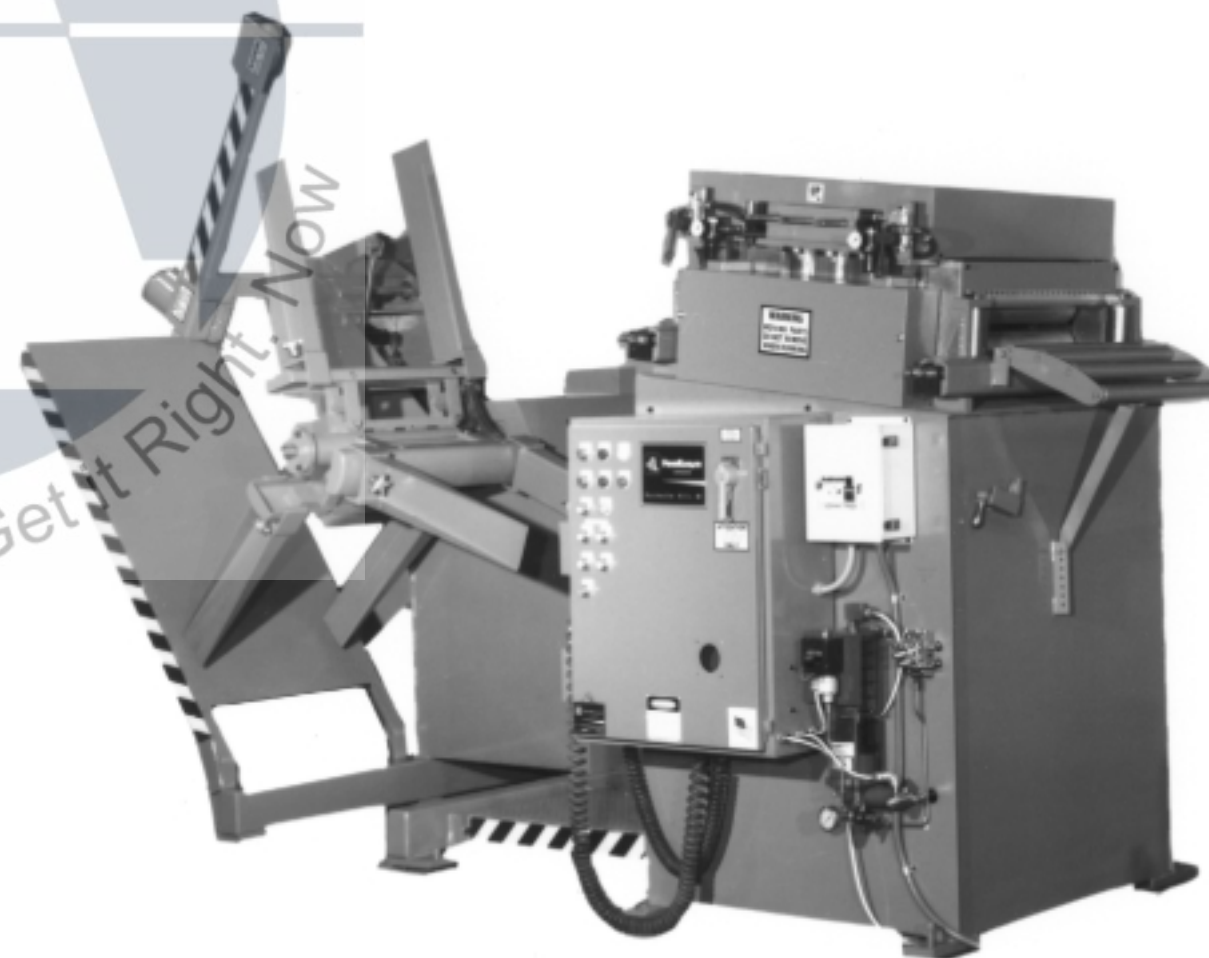
Our standard warranty is void if the unit has been tampered with, altered in any manner, or operated with parts other than supplied or recommended by Feed Lease Corporation. In no event shall Feed Lease Corporation be held liable for special, indirect, incidental or consequential damages, however arising.

Any change in the materials, design or performance intended to improve any product of Feed Lease Corporation shall not obligate Feed Lease Corporation to modify any previously manufactured equipment.

## Powered Straighteners

Feed Lease strives to build the most durable powered straightener available to ensure that you achieve the material straightness you require for years to come. To accomplish this lofty goal, precision craftsmanship, quality components and rugged design are essential. Notice these standard features of all Feed Lease powered straighteners:

- ▼ Precision ground side plates
- ▼ All machine bases are double welded for added structural integrity
- ▼ High strength, high carbon base materials
- ▼ Precision machined components
- ▼ Flame hardened rotating and striking surfaces (RC 58-62)
- ▼ Roller bearings sized to exceed specified loads
- ▼ Commercially available purchased parts (no proprietary gears, bearings, drives, etc)
- ▼ High Torque, AC variable frequency (flux vector) drives



# Powered Straighteners

PS-3 1/2-24-7 seven roll cabinet mounted owered straightener with optional central manifold lubrication, digital roll position readouts, screw-adjusted edge guides and air-operated pinch rolls.

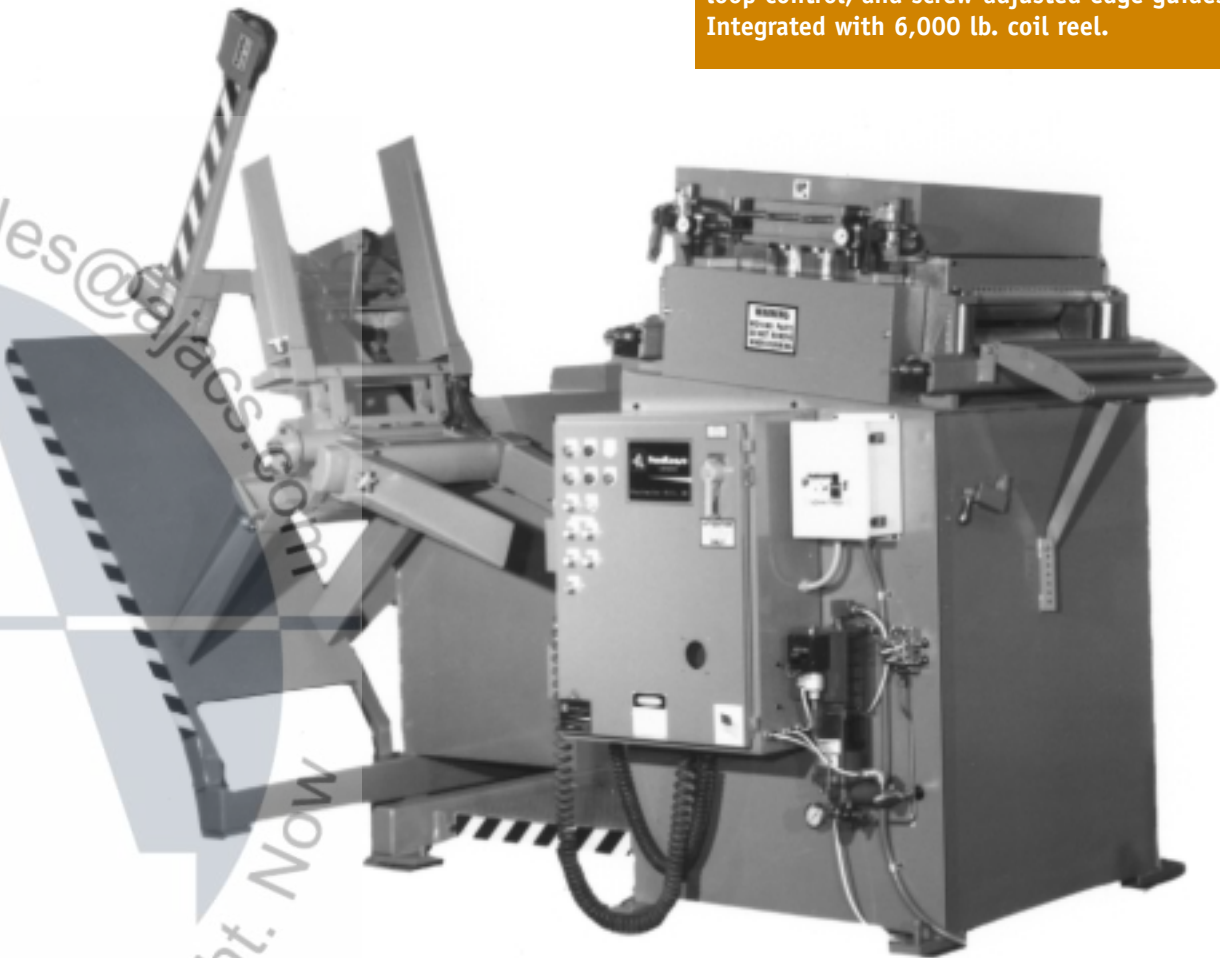


PS-5-60-7 seven roll cabinet mounted powered straightener, highlighting optional heavy-duty hydraulic hold-down arm/peeler/threader/debender with powered wheel, power-adjusted straightening rolls with LED readouts located in operator station and operator platform.

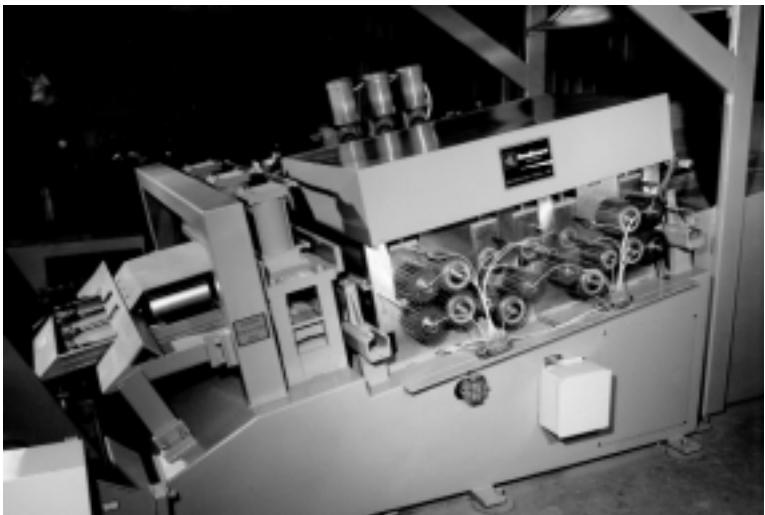


# Powered Straighteners

PS-3-24-7 seven roll cabinet mounted powered straightener with optional automatic lubrication, four roll curve section, air-operated pinch rolls, ultrasonic loop control, and screw-adjusted edge guides. Integrated with 6,000 lb. coil reel.



PS-5-60-5 five-roll powered straightener with overshot roll mounted in base of a coil cradle. Includes optional coil end bender, power-adjusted straightener rolls, screw-adjusted entry & exit vertical guides and automatic lubrication.



# Powered Straighteners - Optional Equipment



Standard-Duty Peeler/Threader Assembly



Ultrasonic Loop Control



Heavy-Duty Hold-Down Arm/Peeler/Threader (shown with optional powered wheel & hydraulic cylinder)



Digital Roll Position Readout



Exit Thread Table



Power-Adjusted Straightener Rolls

## Specifications

MODEL No.	Straightener Roll Dia.	Pinch Roll Dia.	Center Distance	Width Range	Thickness Range
PS-1 3/4	1 3/4	2 5/8	2 5/8	6 - 18	.010 - .125
PS-2 1/4	2 1/4	3 1/2	3 1/2	6 - 30	.020 - .165
PS-3	3	4 1/4	5	6 - 54	.060 - .265
PS-3 1/2	3 1/2	5 1/4	6 1/2	6 - 60	.080 - .300
PS-4 1/4	4 1/4	5 1/2	6 15/16	6 - 78	.080 - .470
PS-5	5	6 1/2	8 3/16	6 - 90	.080 - .500

Note: All straighteners can be quoted 5,7,9, or 11 roll (PS 1 7/8 starts with 7 rolls). More rolls available upon request.  
\* Widths are in 6 inch increments.

- ▼ Entrance and exit vertical edge guides

▼ Screw adjusted vertical edge guides

▼ Four roll curve section (cascade rolls)

▼ Central manifold lubrication (no removal of guards required)

▼ Automatic lubrication system
- ▼ Coil end bender (flatten tail edge of thick coil)

▼ Slant top operator console

▼ Tie structure for integrating coil reel

▼ Quick open "alligator" head for roll cleaning

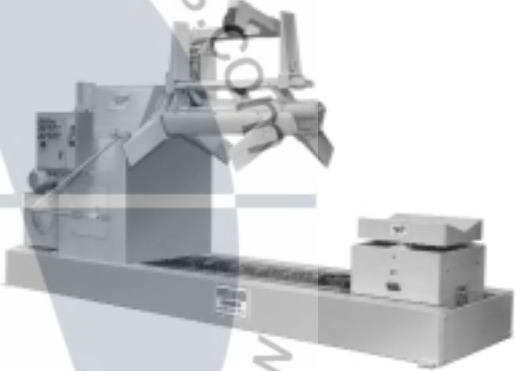
▼ Synchronization to servo feed for tight space applications

# Coil Handling Equipment - Introduction

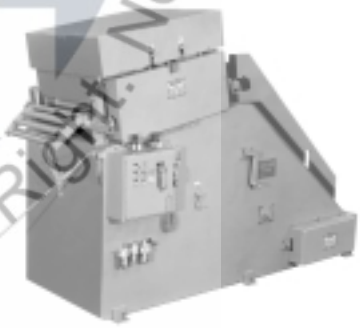
Coil handling equipment is the backbone of every coil line. Feed Lease believes that variety is critical to the building of coil handling equipment. Does your application call for a coil reel? No problem! Need to add a load car, or an integrated upender? We do that. Do you still love the simplicity of coil cradles? We are happy to oblige. Since this equipment call for such versatility, Feed Lease is dedicated to making you the priority. We build reels from 1,500 lbs. to 50,000 lbs. Cradles from 4,000 lbs. to 60,000 lbs. Whatever the width, thickness, material type or application concern, chances are Feed Lease already has a proven solution for your coil handling challenge.

Since operator safety is a top priority with you, Feed Lease makes it a priority as well. We have numerous hold down arms, coil keepers arms and rolls, and safety interlocks to ensure the safest equipment possible. Whether you need a 1,500 lbs reel or a 60,000 lbs cradle, Feed Lease builds safety and durability into every piece of equipment!

## Reels & Load Cars



## Coil Cradles



## Coil Upenders



# Coil Reels - 1,500-12,000 lb.

## Specifications

MODEL NUMBER	Weight Capacity(lb.)	Widths Available	Coil O.D. *	Standard Expansion	Brake Style or Drive Size	Standard Spindle R.P.M. ***
R-15C	1,500	18	54	14 - 20	mech. drag **	N/A
PR-15C	1,500	18	54	14 - 20	1/2 HP AC Fixed ****	12
R-25C	2,500	12-18-24-30-36	60	16 - 21	mech. drag **	N/A
PR-25C	2,500	12-18-24-30-36	60	16 - 21	1 HP Ac Fixed ****	12
R-46M	4,000-6,000	12-18-24-30-36	60	17 - 21	Air	N/A
PR-46M	4,000-6,000	12-18-24-30-36	60	17 - 21	2 HP AC Variable Freq.	2-15 Variable
R-8M	8,000	12-18-24-30-36	60	17 - 21	Air	N/A
PR-8M	8,000	12-18-24-30-36	60	17 - 21	3 HP AC Variable Freq.	2-15 Variable
R-10M	10,000	12-18-24-30-36-42-48	60	20 - 24	Failsafe Air	N/A
PR-10M	10,000	12-18-24-30-36-42-48	60	20 - 24	5 HP AC Variable Freq.	2-12 Variable
R-12M	12,000	12-18-24-30-36-42-48	60	20 - 24	Failsafe Air	N/A
PR-12M	12,000	12-18-24-30-36-42-48	60	20 - 24	5 HP AC Variable Freq.	2-12 Variable

\* 72" ODs optional on 46M and larger  
\*\* Optional air brakes available  
\*\*\* Higher speeds are available. Consult factory.  
\*\*\*\* Variable speed DC drives available

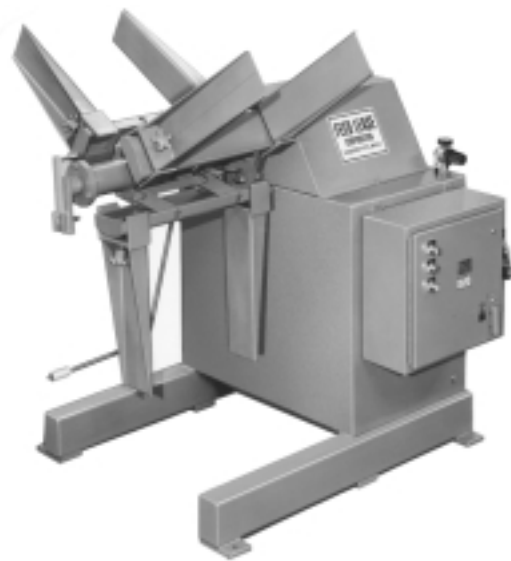
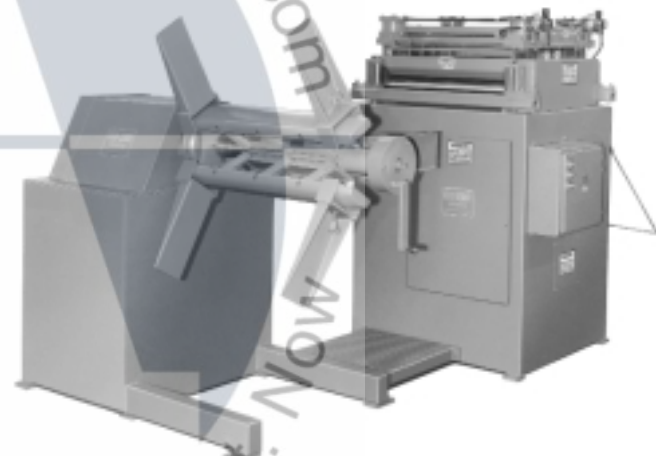


1500 lb. powered reel (AC drive) and standard loop control arm.

# Coil Reels - 1,500-12,000 lb.

- ▼ Double welded cabinet bases
- ▼ Heavily gusseted bases for maximum rigidity
- ▼ Heavy-duty link expansion
- ▼ Bearings sized to exceed machine capacity
- ▼ 4,000-12,000 lb. powered reels use Reliance AC variable frequency drives)
- ▼ Hold-down arms, safety guards, coil load cars, hydraulic expansion available

All coil reels can be combined with powered straighteners to conserve floor space.



6000 lb. powered reel, 60" O.D.

10,000 lb. x 48" powered reel with manual loop arm, solenoid valve, air-operated coil hold-down arm, hydraulic mandrel expansion and hydraulic traveling coil load car

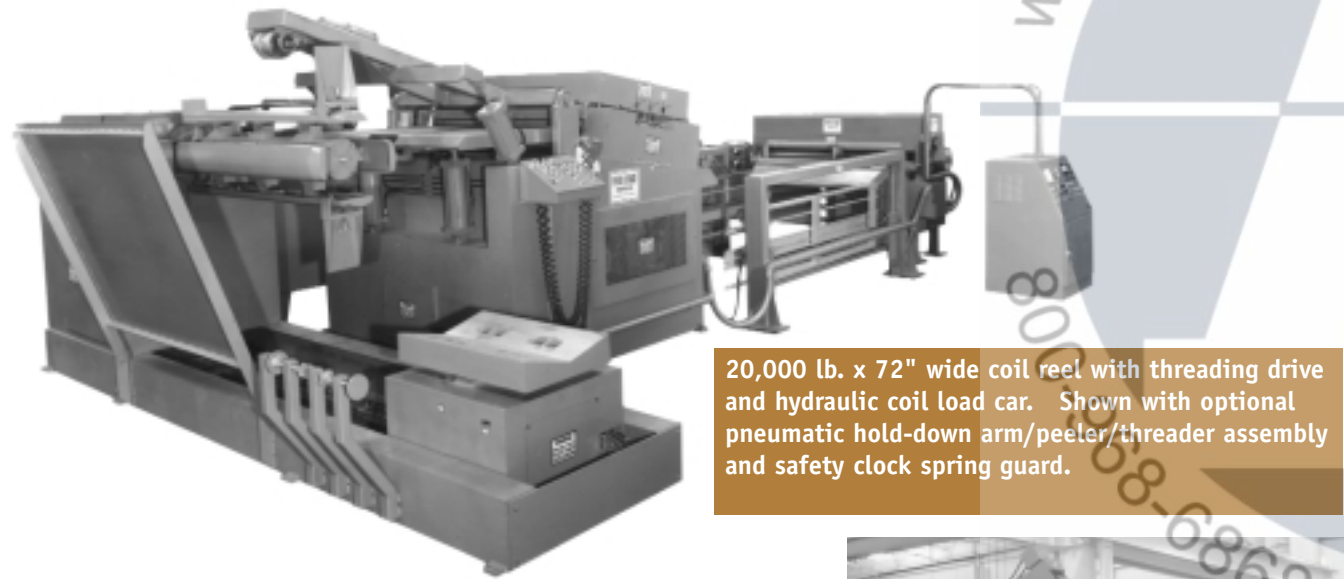


# Coil Reels - 15,000 - 50,000 lb.

## Specifications

MODEL NUMBER	Weight Capacity(lb.)	Widths Available	Coil O.D.	Standard Expansion	Brake Style or Drive Size	Standard Spindle R.P.M. **
R-15M	15,000	36-42-48-54-60	60*	20 - 24	Failsafe Air	N/A
PR-15M	15,000	36-42-48-54-60	60*	20 - 24	5 HP AC Variable Freq.	2-12 Variable
R-20M	20,000	36-42-48-54-60-66-72	60/72	20 - 24	Failsafe Air	N/A
PR-20M	20,000	36-42-48-54-60-66-72	60/72	20 - 24	7 HP AC Variable Freq.	2-12 Variable
R-30M	30,000	36-42-48-54-60-66-72	72	22 - 26	Failsafe Air	N/A
PR-30M	30,000	36-42-48-54-60-66-72	72	22 - 26	10 HP AC Variable Freq.	2-12 Variable
R-40M	40,000	36-42-48-54-60-66-72	72	22 - 26	Failsafe Air	N/A
PR-40M	40,000	36-42-48-54-60-66-72	72	22 - 26	15 HP AC Variable Freq.	2-12 Variable
R-50M	50,000	36-42-48-54-60-66-72-78	72	22 - 26	Failsafe Air	N/A
PR-50M	50,000	36-42-48-54-60-66-72-78	72	22 - 26	20 HP AC Variable Freq.	2-12 Variable

\* 72" ODs optional  
\*\* Higher speeds are available. Consult factory.



20,000 lb. x 72" wide coil reel with threading drive and hydraulic coil load car. Shown with optional pneumatic hold-down arm/peeler/threader assembly and safety clock spring guard.



40,000 lb x 60" wide x 72" O.D. coil reel with hydraulic threading drive, hydraulic load car, hydraulic hold-down arm/peeler/threader and safety clock spring guard

# Coil Reels - Double Arm Reels

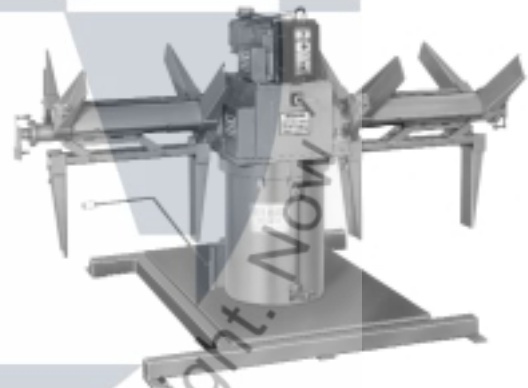
## Specifications

MODEL NUMBER	Weight Capac. Per Arbor (lb.)	Stock Widths Available	Coil O.D.	Mandrel Expansion	Drive Unit
DAPR-15C	1,500	18	54	14 thru 20	1/2 HP DC Variable
PR-20M	20,000	36-42-48-54-60-66-72	72	HYD 20-24	1 HP DC Variable
PR-30M	30,000	36-42-48-54-60-66-72	72	HYD 22-26	2 HP AC Variable
PR-40M	40,000	36-42-48-54-60-66-72	72	HYD 22-26	5 HP AC Variable

Double arm reels are ideal for continuous line operation, such as feeding material into a roll former. The material can be loaded and readied on one side of the reel while the opposite side is paying out stock. By depressing a shot pin in the base, the new coil of material can be rotated 180° into position for threading. Optional hydraulic threading (for non-powered reels), hydraulic expansion, and hydraulic rotation are available.

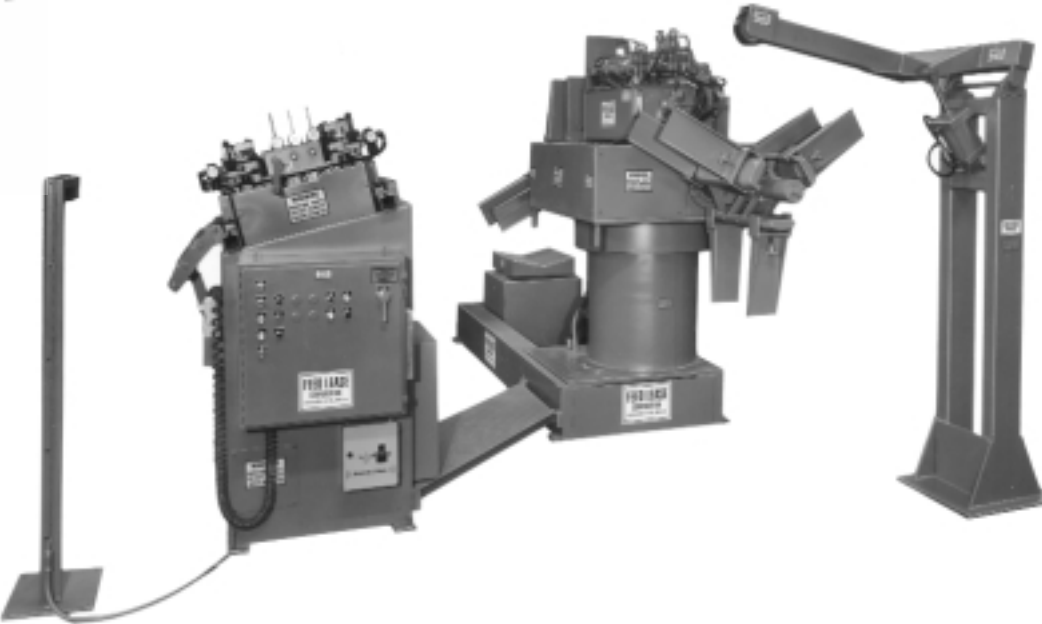


DAR-25C, 60" O.D. non-powered double reel

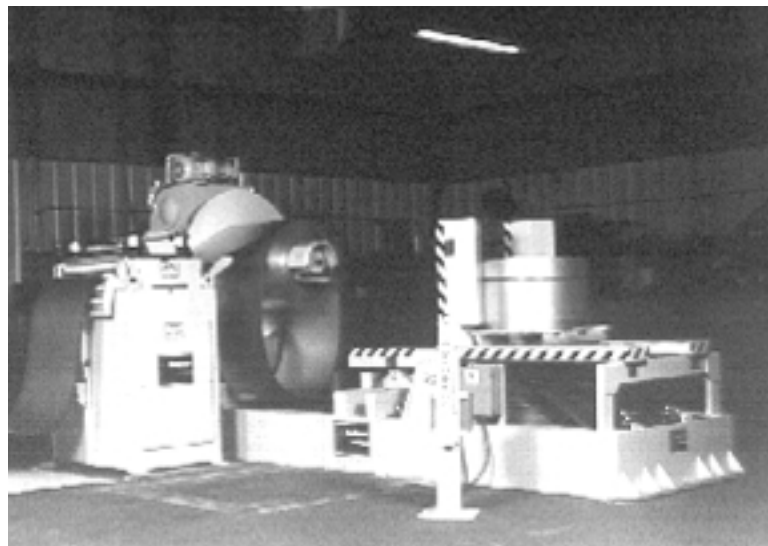


DAPR-46M-30, 60" O.D. powered double reel

Double arm pull-off reel with hydraulic mandrel expansion and hydraulic load car, floor mounted air-operated coil hold-down arm and variable speed powered straightener with ultra-sonic loop control.



## Coil Reels - Unique Concepts



15,000 lb x 36" wide powered coil reel with paddle loop control via lights (loop developed under spindle to conserve space). Reel travels to stationary hydraulic coil load elevator with integrated hydraulic coil upender. This system allows a pallet to be placed on coil line, turned 90 degrees and loaded onto the elevator. Reel with fixed back plate then travels to elevator and coil is lifted onto spindle. Once loaded, reel is traveled back to running position.

20,000 lb. x 42" wide coil reel with coil load car within overhead deflector with base mounted powered straightener. This system allows heavy gauge coils to be used on a reel with a load car for quick coil change without requiring a looping pit. The system is modular and plant space can be used and adjusted more effectively.



## Coil Cradles - 4,000 lb.

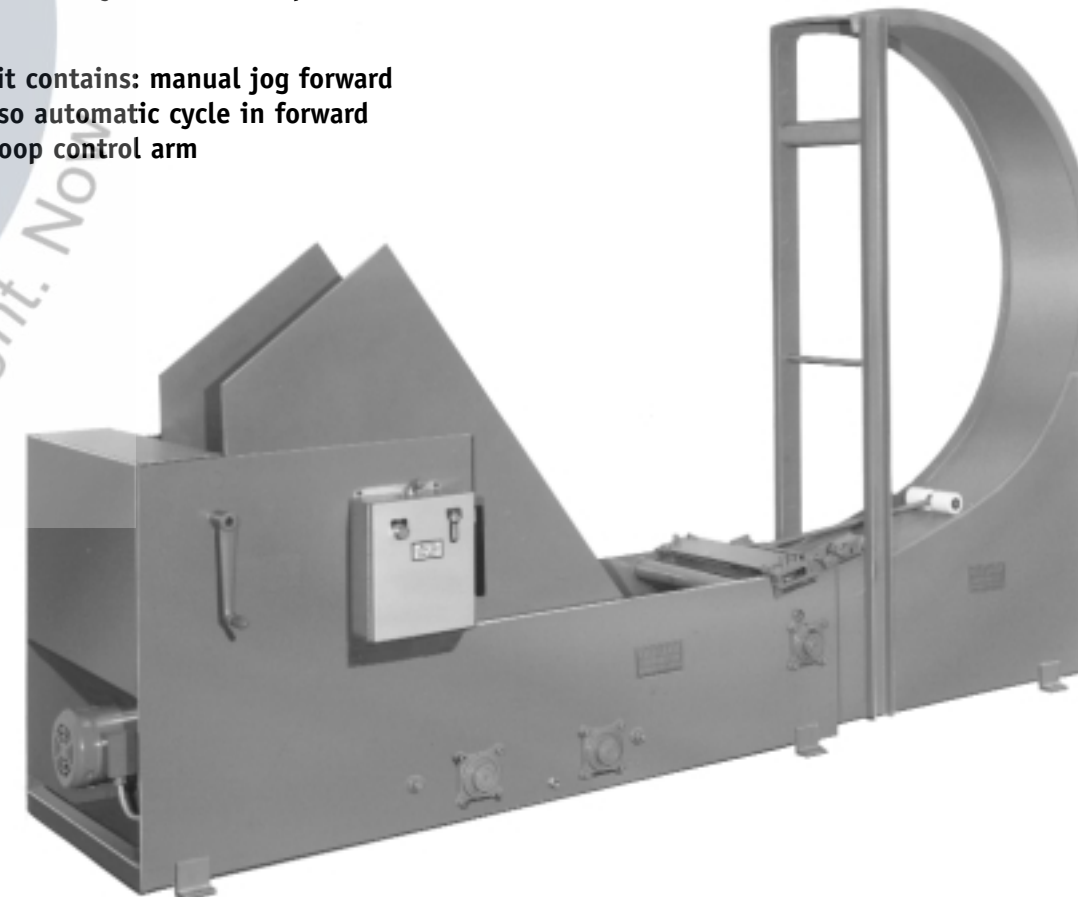
### Standard Features

- ▼ 60" diameter coil capacity
- ▼ Hardened 3 1/2" diameter nest rolls
- ▼ Hardened 3" diameter pinch rolls (both rolls powered)
- ▼ Flame hardened pinch roll gears
- ▼ 230, 460 or 575 volt electric, 3 phase (100V at controls optional)
- ▼ Payout rate fixed at 60 FPM controlled by loop control arm and adjustable timer
- ▼ Motor and gear reducer driven
- ▼ Electrical disconnect enclosure standard
- ▼ Heavy steel plate welded construction
- ▼ Adjustment of pressure on the two hardened driving pinch rolls is by a chain and sprocket arrangement.
- ▼ Electrical circuit contains: manual jog forward and reverse, also automatic cycle in forward controlled by loop control arm

- ▼ Drive unit 2 HP 3-phase standard. Other drives available
- ▼ Adjustable side plates hold the coil firmly in position for continuous payout
- ▼ .250" thick material max. capacity at full width
- ▼ Manually adjustable stock peeler

### Optional Extras

- ▼ 60" diameter return stock deflector
- ▼ 110 volt electrics at controls
- ▼ Air cylinder pinch roll, hand valve actuated, in lieu of chain and sprocket
- ▼ 72" diameter coil capacity
- ▼ Crodon surfaced pinch rolls
- ▼ Overhead tip-up chute



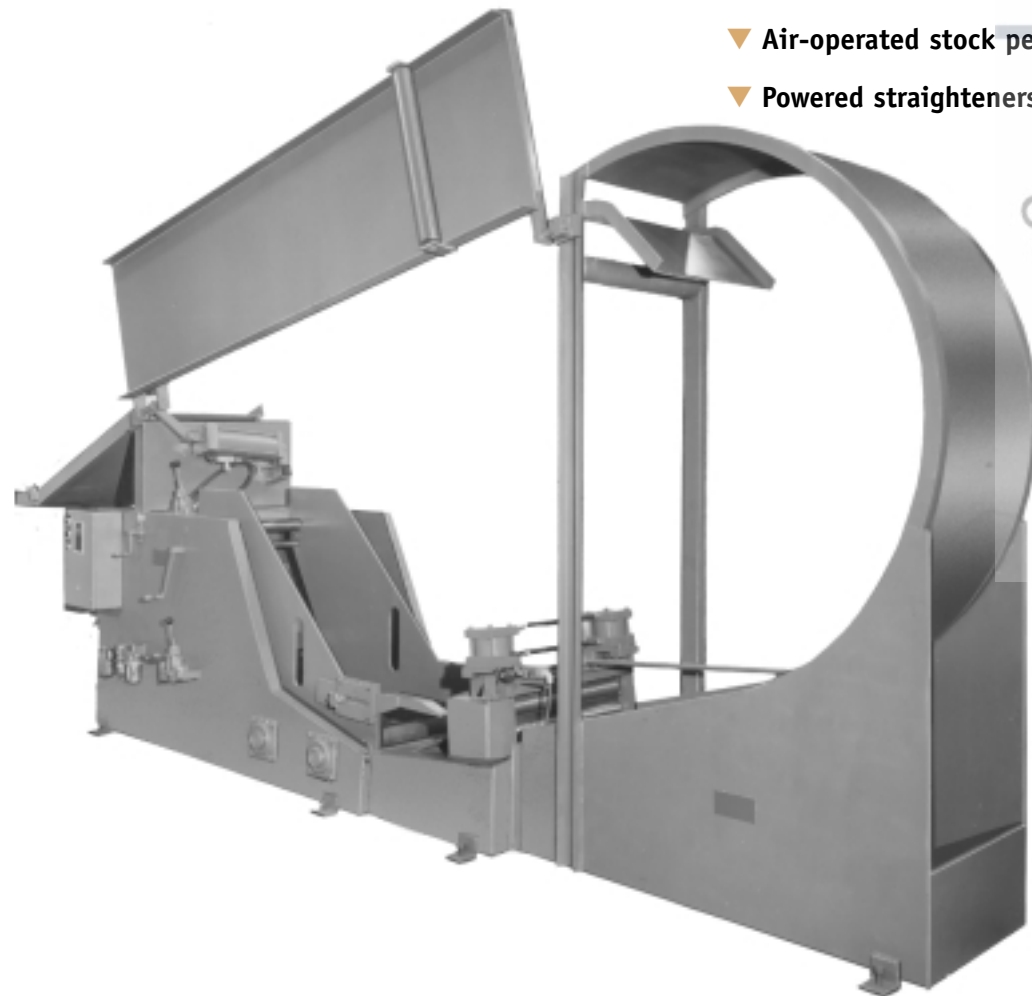
## Coil Cradles - 6,000 - 12,000 lb.

### Standard Features

- ▼ 60" diameter coil capacity (widths 12 - 48")
- ▼ 3/4" thick independently adjustable side plates
- ▼ Hardened and ground 3 1/2" diameter pinch rolls On models 12" - 30" wide (4 1/2" on models 36" - 48" wide)
- ▼ Fused electrical disconnect enclosure
- ▼ 230, 460 or 575 volt electric, 3 phase (100V at controls optional)
- ▼ Heavy duty flame hardened cluster gears on pinch rolls
- ▼ Manually adjusted stock peelers

### Optional Extras

- ▼ 72" return stock deflector
- ▼ Air-operated tip-up chutes on models up to 36" wide
- ▼ Roll-down chutes in models 42" wide & wider
- ▼ Crodon surfaced pinch rolls
- ▼ Air cylinder operated pinch rolls in lieu of bevel gear
- ▼ 72" diameter coil capacity
- ▼ 3" diameter hardened separator guide rolls in adjustable side plates
- ▼ Heavy-duty 4 1/2" diameter pinch rolls on 12' - 30" wide units
- ▼ Coil end bender
- ▼ Air-operated stock peeler
- ▼ Powered straighteners mounted in base



## Coil Cradles - 15,000 - 60,000 lb.

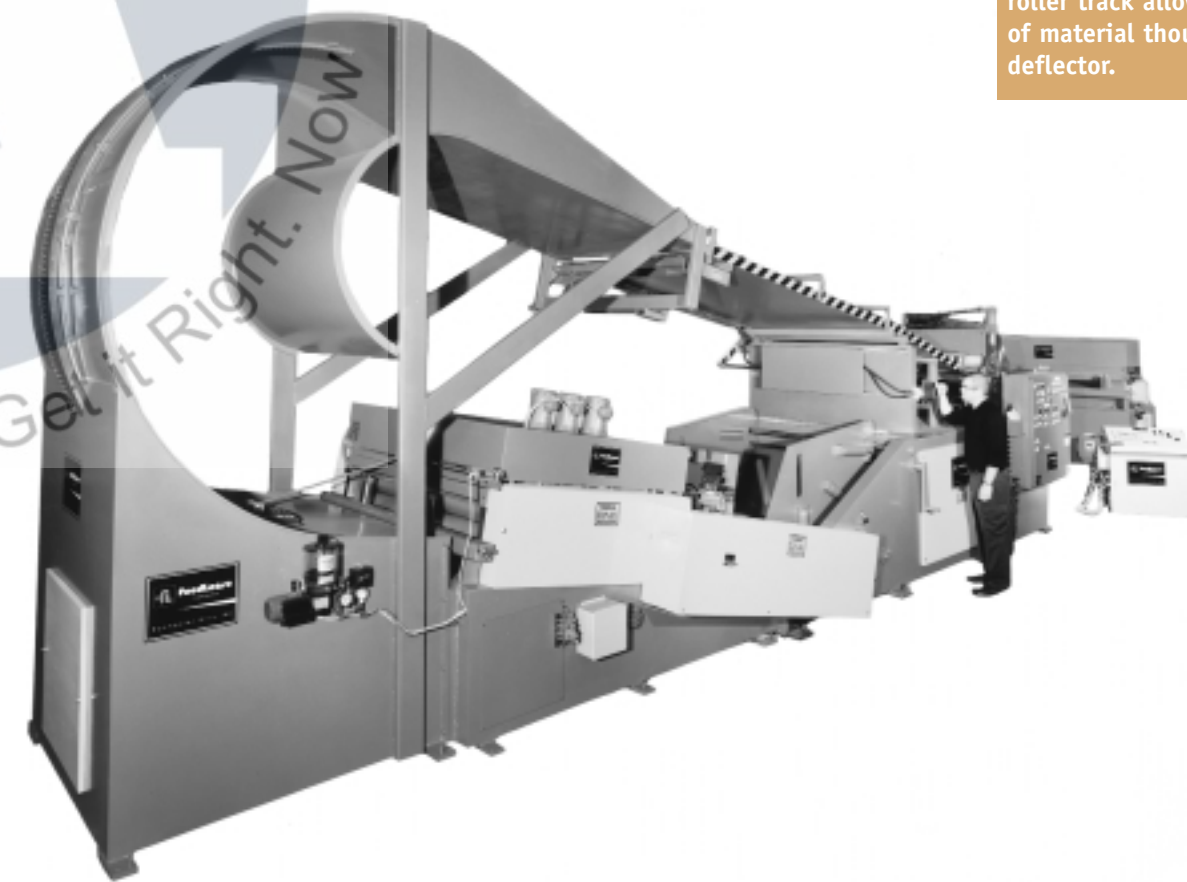
### Available Features

- ▼ Widths available from 12" to 96" wide
- ▼ Powered pinch rolls standard. Powered straighteners optional.
- ▼ Powered straighteners sized to job specifications
- ▼ Air-operated tip-up chutes in models up to 36" wide
- ▼ Roll-down chutes in models 42" wide and wider
- ▼ Coil end bender
- ▼ Coil hold-down arm
- ▼ Air-operated stock peeler

Optional hydraulic tilting pinch rolls assembly enhances operator safety by enabling the operator to direct heavy-gauge material to the feed system hands free.



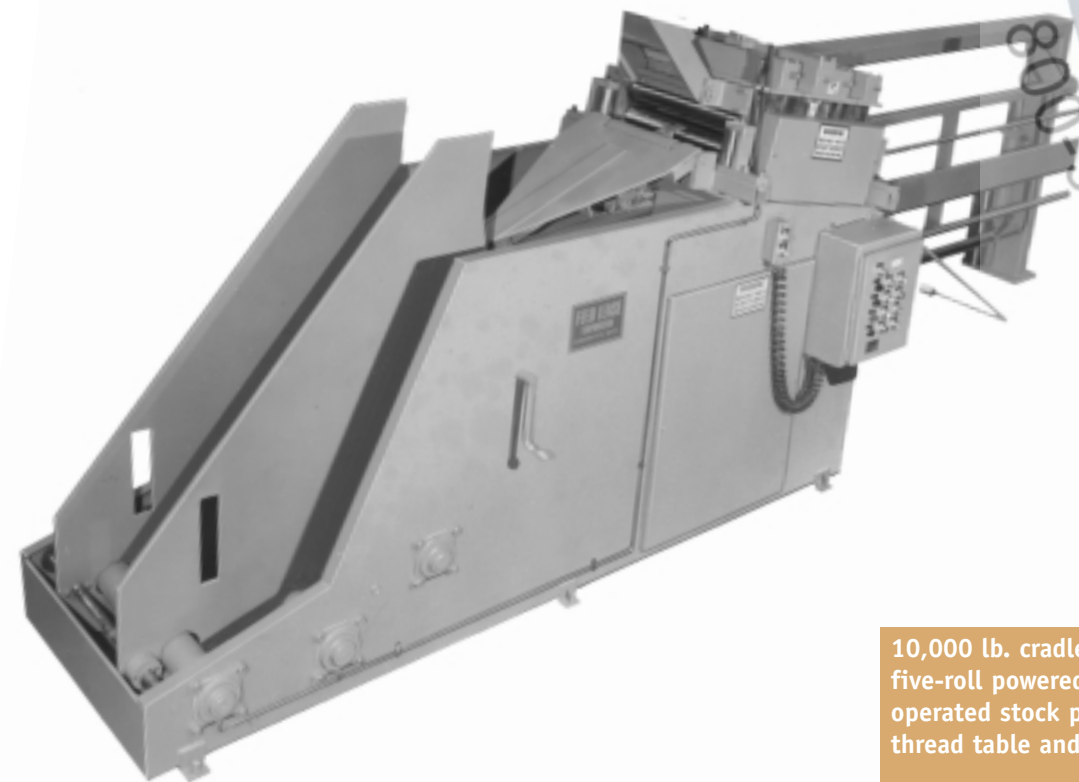
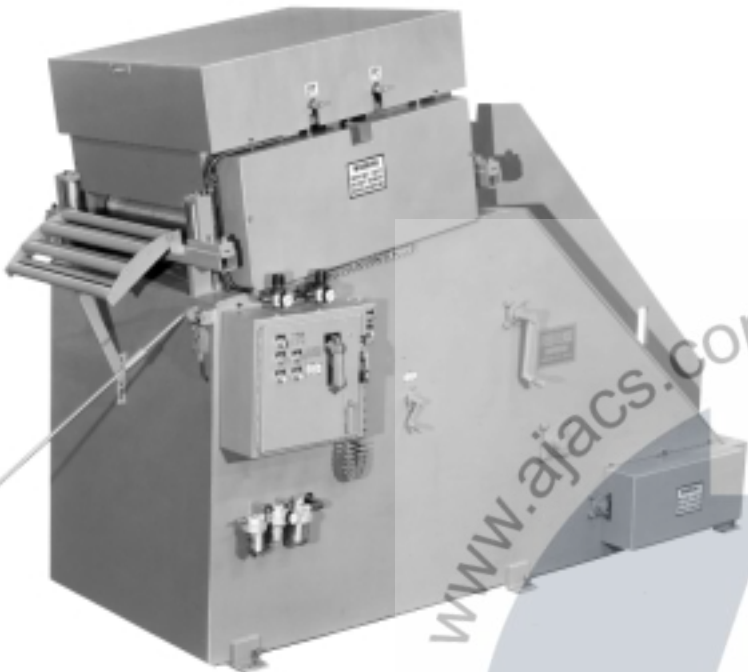
Optional precision machined roller track allows smooth flow of material through overhead deflector.



# Cradle/Straightener Combinations - 4,000 - 40,000 lb.

This unit uses standard cradle construction with a powered straightener. All of our powered straighteners have a hardened gear train, and all feature cluster gears on both the entrance and exit pinch rolls. All bottom straightening rolls are powered.

12,000 lb. cradle with 3 1/2" diameter five-roll powered straightener.



10,000 lb. cradle with 3" diameter five-roll powered straightener, air-operated stock peeler, entrance thread table and exit thread table.

# Coil Weight and Loop Information

## Coil Weight

O.D.	I.D.					
	16"	18"	20"	22"	24"	26"
38"	262	247	230	212	192	170
42"	332	317	300	282	262	240
48"	451	436	419	401	381	359
54"	595	580	563	545	525	503
60"	746	731	714	696	676	654
66"	902	887	870	852	832	810
72"	1084	1069	1092	1034	1014	992
Above equals pounds per inch of width for steel coils.						
To determine weights for other materials, multiply the figures for steel by the following constraints:						
Brass	1.082					
Copper	1.135					
Aluminum	0.340					
Magnesium	0.222					

## Gage/Decimal Conversion

Mfrs. Gage No.	Decimal Equiv.	Mfrs. Gage No.	Decimal Equiv.
9	.1495	20	.0359
10	.1345	21	.0329
11	.1196	22	.0299
12	.1046	23	.0269
13	.0897	24	.0239
14	.0747	25	.0209
15	.0673	26	.0179
16	.0598	27	.0164
17	.0538	28	.0149
18	.0478	29	.0135
19	.0418	30	.0120

## Calculating Loop Length & Adequate Slack

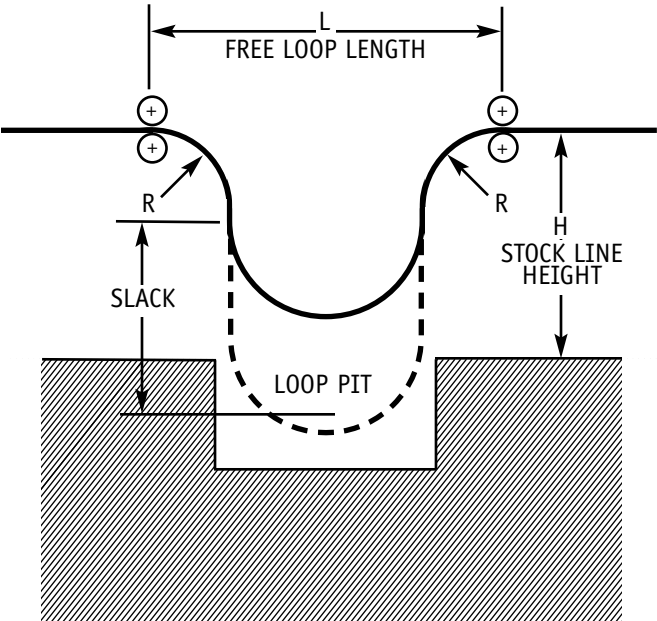
To calculate desirable loop length and establish adequate material storage (SLACK) the following applies:

- R = Minimum radius to avoid distortion of material. (360 x material thickness)
- L = Free loop length. (4 x R)

When H (stock line height) is greater than 2 x R, some storage (SLACK) is available. At least two feed lengths of slack material should be made available.

Decision: Adjust stock line height or install pit.

Materials over .125" thick are not recommended for a free loop condition without required threading and safety devices. Materials over .125" thick can also be handled effectively in an overhead controlled loop condition.



# Coil Up Enders

## Available Features

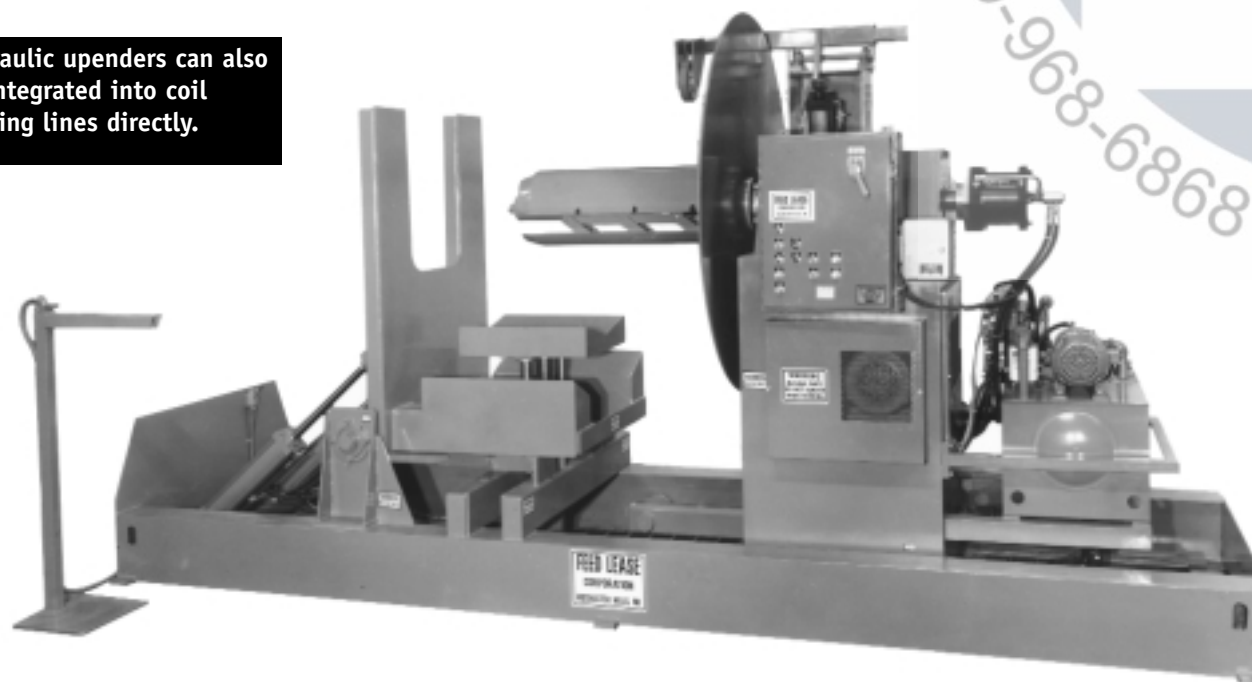
- ▼ Up ends coils by indexing 90°
- ▼ Three phase motor and gearbox driven
- ▼ Standard 48" wide x 60" O.D. coils. Wider coils available, 72" O.D. available.
- ▼ Standard 10,000 lb. capacity. Larger capacities available.
- ▼ Pedestal-mounted operator control station.
- ▼ Electrical disconnect enclosure
- ▼ "V" block for nesting coils. Optional nylon facing for "V" block to prevent possible scratching of outer coil surface.
- ▼ Optional 180° powered horizontal rotation allows loading and unloading of coils in the same direction.
- ▼ Optional narrow coil keepers.

Stationary unit (non-rotating)  
90° indexing, 10,000 lb.  
capacity, coil "V" nest with  
narrow coil keepers



90° indexing, 180° rotating  
unit, 10,000 lb. capacity.

Hydraulic upenders can also  
be integrated into coil  
feeding lines directly.



# Air Feeds - Features

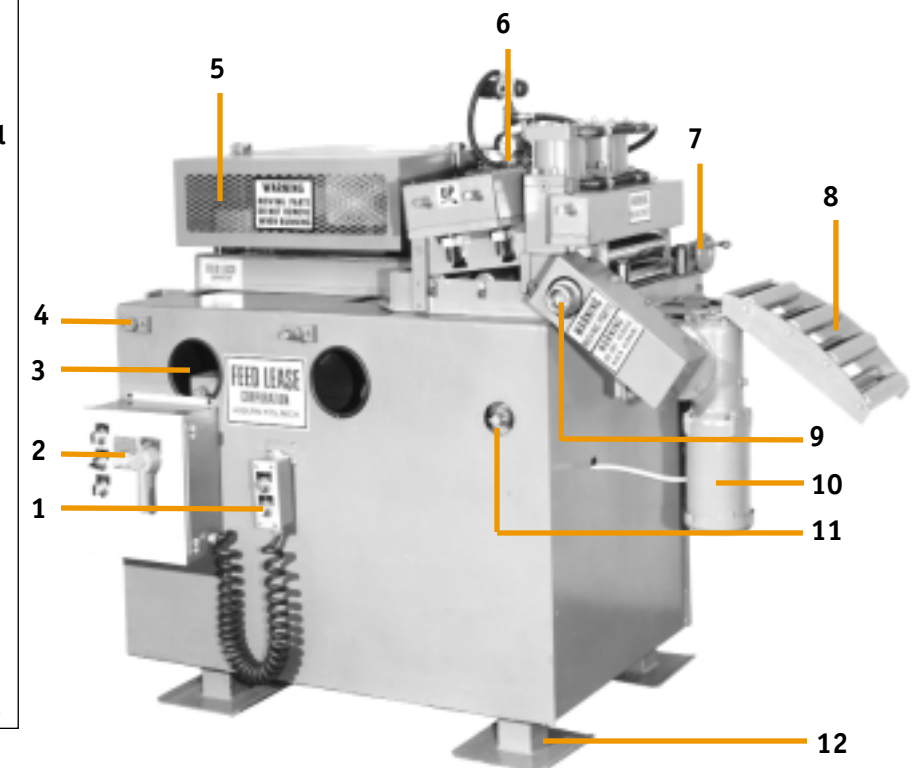
- ▼ Accurate to  $\pm .001"$
- ▼ Precision fabricated steel feed base
- ▼ High strength cast alloy gripped carriage
- ▼ Pilot pin release electrical circuit
- ▼ Outboard-mounted electrical controls (no reaching over material)
- ▼ Adjustable double-acting air cushion
- ▼ Numatics Inc. control valves  
1/2" style on FL-1 1/2 through FL-2 1/2  
3/4" style on FL-3 1/4 through FL-5  
1" style on FL-6 and Dual Grip feeds
- ▼ Rapid stroke length adjustment by means of handwheel
- ▼ Two-roll rear entrance stock guide with entrance vertical guide
- ▼ Side shield barrier safety guides
- ▼ Noise control mufflers
- ▼ Guide bar keeper plates
- ▼ Industry-standard interchangeable precision parts
- ▼ Pre-drilled mounting bracket holes
- ▼ Rear leg support
- ▼ Stock support rollers on models FL-2 thru FL-6, having stock width of 18" or wider

## Standard Features on FL-4 through FL-6

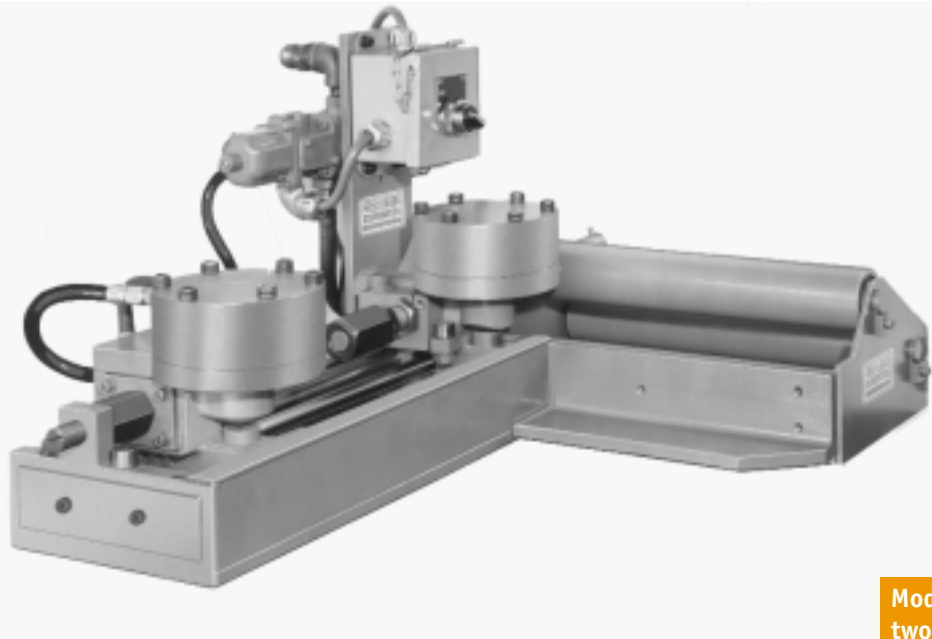
- ▼ Mechanical numeric stroke length indicator
- ▼ Adjustable air saver cylinder
- ▼ Right angle stroke adjustment by means of hand wheel

## STANDARD & AVAILABLE OPTIONS

1. Hand-held remote for power pinch rolls.
2. Electrical enclosure with disconnect. (Std. for voltage over 110V.)
3. Maintenance porthole for removing gripper and retainer lower anvils.
4. Dual lead screws for horizontal positioning of feed.
5. Hinged safety guard.
6. Special air lift to raise break rolls in order to release material for proper pilot location.
7. Hand wheel for stroke adjust.
8. Curve section for smooth flow of material in the loop.
9. Manual clutch to engage and disengage power pinch rolls.
10. Electric motor and gear box for power pinch rolls.
11. Cabinet jack screw. Raise or lower the entire cabinet from one location.
12. 5-ton jack. Four jacks move cabinet  $\pm 6"$  from set passline.

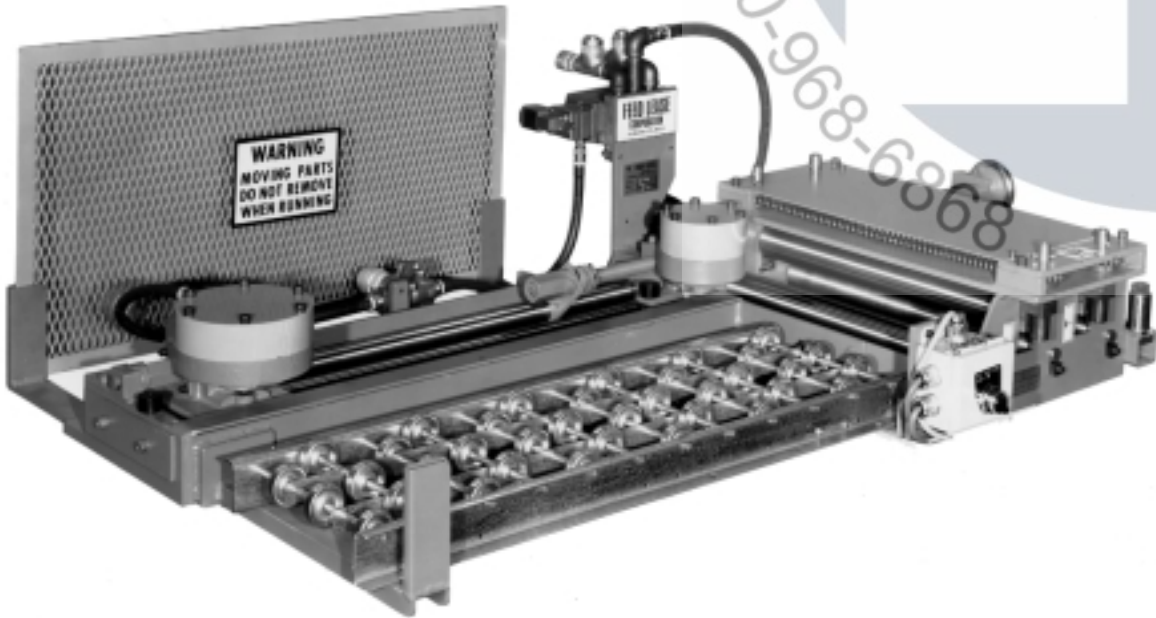


# Air Feeds - Models FL 1½, 2, 2½ & 3¼



Model FL-1½ 12 x 6 with standard two-roll entrance stock guide (shown without standard side-shield safety guards and outboard-mounted electrical controls).

Model FL-2 18 x 24 with five-roll pull-through straightener (shown with one of the two side shield safety guards).



# Specifications - Strokes per Minute

STROKE LENGTH	Max. Strokes Per Minute			
	Model FL 1½	Model FL 2	Model FL 2½	Model FL 3¼
6	120	110	90	80
12	90	90	70	60
18	75	70	50	50
24	60	50	40	40
30	40	35	30	30
36	30	25	25	25

Note: Feed stroke is 5/8" longer than chart indicates.

# Specifications - Stock Thickness

STOCK WIDTH	Max. Stock Thickness (Without Straightener/With Straightener)			
	Model FL 1½	Model FL 2	Model FL 2½	Model FL 3¼
6	.093 / .060	.156 / .125	.187 / .156	.218 / .187
12	.060 / .030	.125 / .090	.156 / .125	.187 / .156
18	-	.090 / .060	.125 / .090	.156 / .125
24	-	.060 / .040	.090 / .060	.125 / .090
30	-	.040 / .025	.060 / .030	.090 / .060
36	-	-	.045 / .025	.060 / .030

Note: Material is 1" wider than chart indicates.

Model FL-3¼ 18 x 12 with five-roll pull-through straightener (shown with one of the two side shield safety guards).



# Air Feeds - Models FL 4, 5 & 6

## Specifications

### Strokes per Minute

STROKE LENGTH	Max. Strokes Per Minute		
	Model FL 4	Model FL 5	Model FL 6
6	120	110	40
12	90	90	30
18	75	70	29
24	60	50	18
30	40	35	15
36	30	25	12

Note: Feed stroke is 5/8" longer than chart indicates.

### Stock Thickness

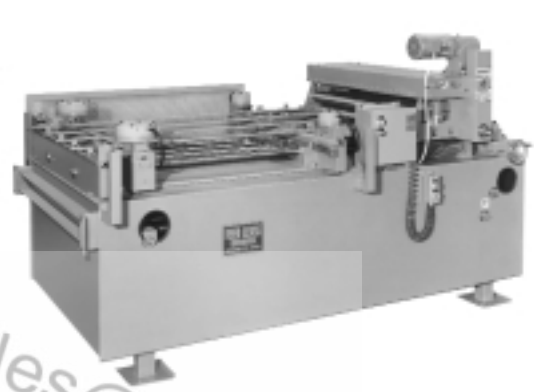
STOCK WIDTH	Max. Stock Thickness (With Strtnr./Without Strtnr.)		
	Model FL 4	Model FL 5	Model FL 6
6	.340 / .312	.375 / .340	.375
12	.312 / .250	.340 / .312	.375
18	.250 / .180	.312 / .250	.375
24	.200 / .150	.250 / .180	.312
30	.170 / .120	.180 / .150	.250
36	.120 / .070	.150 / .120	.187

Note: Material is 1" wider than chart indicates.  
FL 6 information shown with straightener only.

Model FL-5 18 x 24 with stock support rollers and five-roll and manual pinch roll pull-through straightener (shown with one of the two side-shield safety guards).



# Air Feeds - Zig-Zag, Double & Dual Grip Models



## Dual Grip Model

Dual Grip feeds are the most effective method for handling wide, thin material.

- ▼ 30-gallon air supply tank
- ▼ Air pressure safety release valve
- ▼ Digital readout stroke adjustment
- ▼ 1" N.P.T. Numatics control valve
- ▼ i" N.P.T. filter, regulator and lubricator
- ▼ Side-shield barrier safety guards



## Double Model

Double feeds are used primarily for feeding wide, heavy gauge material.

- ▼ All double feeds include fabricated steel cabinet base
- ▼ Operator has option of running one feed or both
- ▼ 30-gallon air supply tank standard
- ▼ Dual lead screw horizontal width positioning is standard
- ▼ Flow track support between feeds
- ▼ Mounted and plumbed filter, regulator and lubricator standard

## Zig Zag Model

Zig-Zag feeds are used primarily to cut down on steel scrap when running round blanks

- ▼ Available in all feed sizes
- ▼ Two-out and three-out systems available

ZFL-21/2 12x12 with two stock guides and four-roll curve section. Shown with one of the two side-shield safety guards.



## Air Feeds - Options: Pull-Through Straighteners

**F**eed Lease Corporation pull-through stock straighteners are available for all models of feeds and are designed to attach directly behind the feeding unit. In operation, the stock is pulled through the straightener to effectively remove coil curvature and increase die life.

All pull-through straighteners are available with five, seven or nine rolls.

- ▼ Pinch rolls: either manual or power operation
- ▼ Hand-held remote control to aid operator in threading of material
- ▼ Optional crodon surfaced pinch roll (maximum grip on material)
- ▼ Air-operated pinch rolls
- ▼ Air-operated clutch on powered pinch rolls

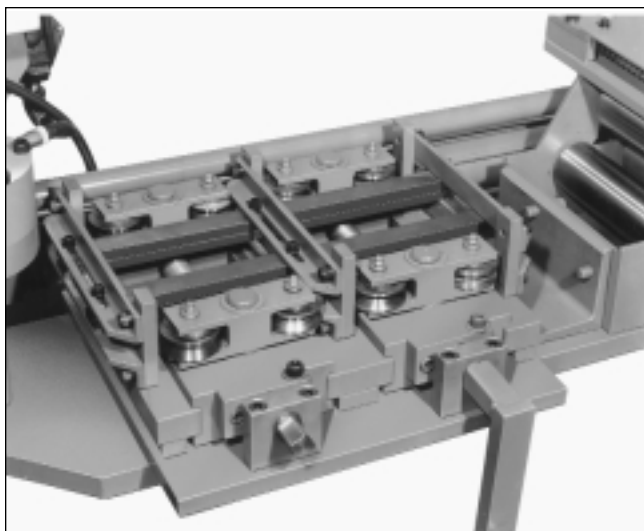
Optional five-roll pull-through straightener



Optional five-roll pull-through straightener with powered pinch rolls. Available on all Feed Lease Corporation pull-through straighteners. Power units include electrical disconnect enclosure.



Optional pull-through edge conditioner features eight rollers with graduated angles to roll over the burred edge of slit steel. Can be mounted at entry or exit end of pull-through straightener.



## Air Feeds - Optional Features

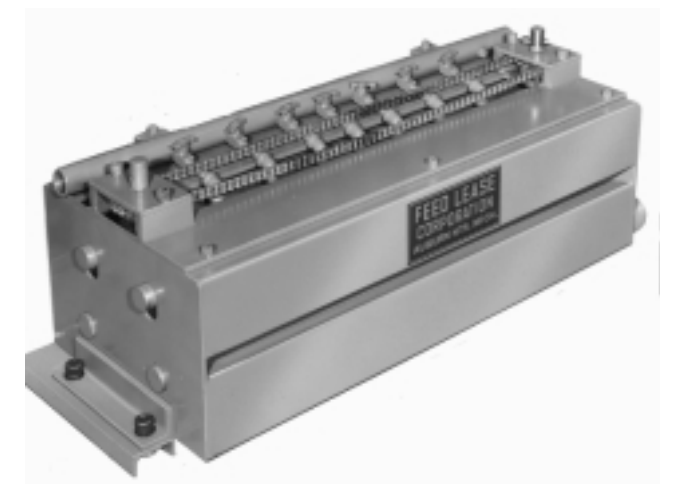
### Cabinet-Mounted Air Feeds

- ▼ Standard option for all single feed models
- ▼ Fabricated steel construction to withstand extreme usage
- ▼ Vertical adjustment of  $\pm 6"$  from a given passline
- ▼ Quick and accurate vertical and lateral adjustment to minimize feed setup time
- ▼ Lateral adjustment is by dual lead screws, which assures squareness in all positions
- ▼ Ideal for those who change dies frequently
- ▼ Easy to move from press to press with simple setup
- ▼ Highly recommended for our extra heavy duty feeds (FL-4, FL-5 and FL-6)



Adjustable "Air Saver" cylinder increases feed response as stroke length setting is decreased. Air consumption decreases at shorter stroke lengths with this feature. Standard on all model FL-4, FL-5 and FL-6 air feeds

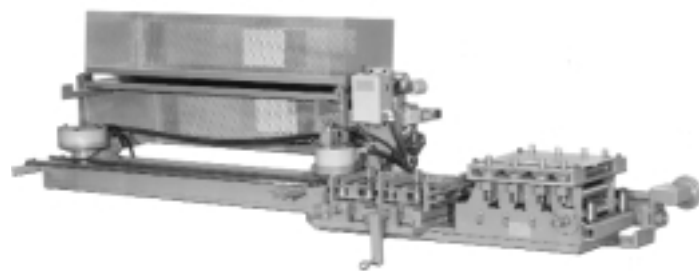
Four-roll stock lubricators are generally mounted between feed and press, applying lubrication just before material enters the die. The optional air pump or gear pump recirculates the desired amount of lubrication.



## Air Feeds - Bar & Wire Feeds

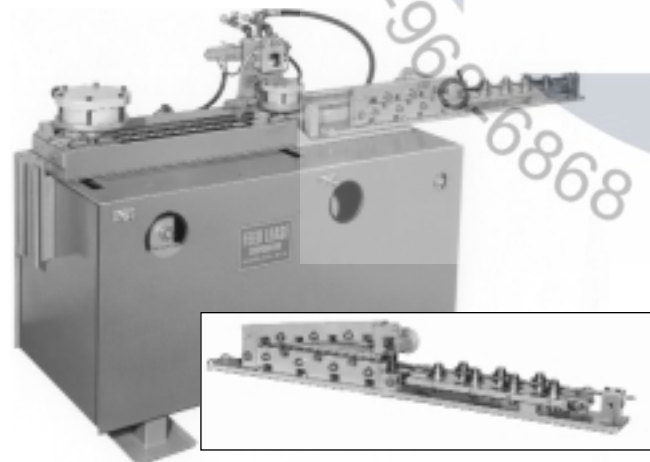
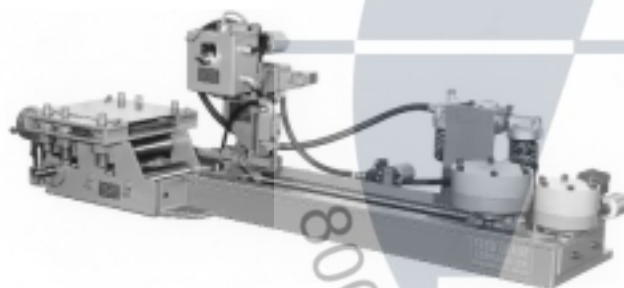
### Bar Feeds

- ▼ Special bar feeds
- ▼ Push-pull feeds for removing skeleton from press or for removing strip material from die.
- ▼ Feeds to handle round, rectangular, I-beam channel and other special shaped bars
- ▼ Multiple strip feeds feed two or more strips or material simultaneously from coil or bar stock



FL-2 6x24 front-end retainer feed, five-roll and manual pinch roll pull-through straightener. Shown without standard side shield safety guards and outboard mounted electrical controls. Clamping retainer is located at exit end of feed, allowing longer control of material (increases automatic running time).

FL-26x36 with seven-roll and manual pinch roll pull-through straightener and 7"-wide edge conditioner mounter between feed and straightener (shown with optional overhead hinged safety guard).

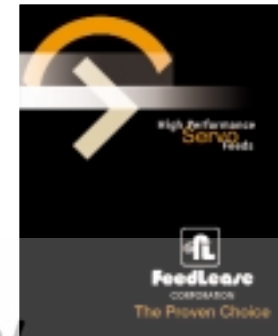


FLW-5 with two-plane wire straightener designed to feed and straighten round, half round or flat wire. Inset shows optional seven-roll, two-planed straightener with optional flip-open feature.

### Wire Feeds

- ▼ Minimum wire diameter .062"
- ▼ Maximum wire diameter .625". (Larger upon request.)
- ▼ Available with or without wire straighteners
- ▼ All wire straighteners are two plane style
- ▼ Five-roll and seven-roll straighteners available
- ▼ Feeds can be bracket or cabinet mounted
- ▼ Most standard feed options available, including special electrical
- ▼ Stroke lengths the same as standard single feed

## Feed Lease Servo Feeds



Feed Lease offers a broad line of electronic servo feeds, with models to fit a wide range of stamping applications. The latest in servo technology is combined with the rugged durability that makes Feed Lease equipment a leader in the industry. Request a copy of Servo Feed catalog for complete information on features, specifications, optional equipment and complete coil lines.



### Precision Series

Precise, powerful feeds for small-to-medium stamping. Built for light materials but not light on power and durability.

### Performance Series

Rugged, performance-based feeds for medium-to-heavy stamping. Massive side plates, huge drives and oversized bearings to provide an extremely durable feed system.

### POWER-CORE Series

Extremely powerful and reliable feeds for heavy stamping requirements (up to .780" thick).



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