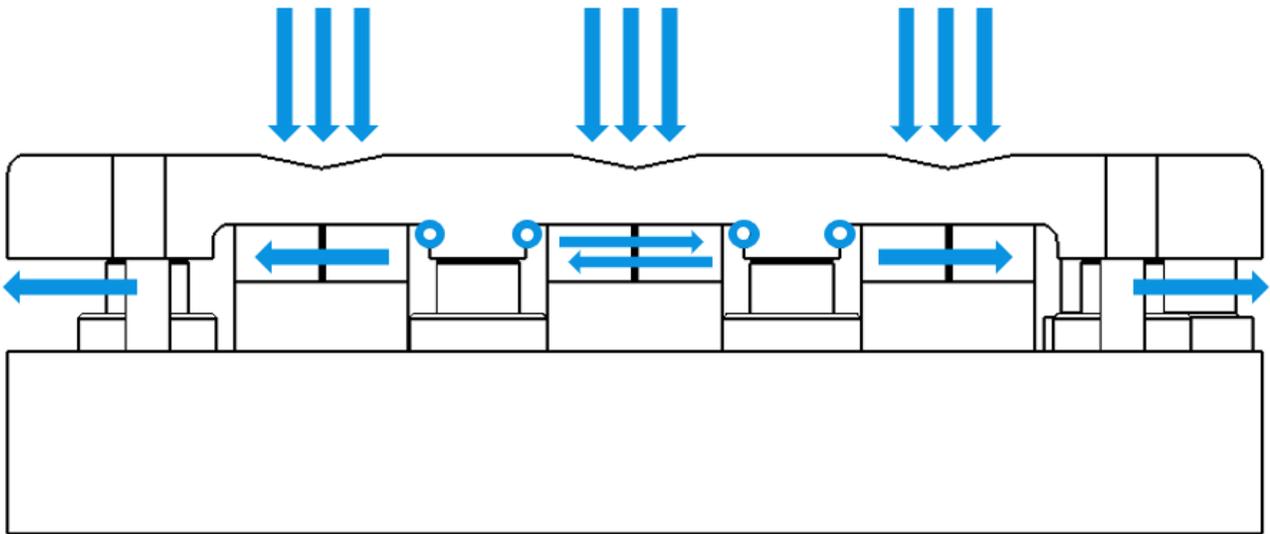


AIR BLOW-OFF FEATURE



PURPOSE:

An Air Blow-Off feature can be added to help clean between the die punches using air streams. It will assist in preventing a build-up of burrs and small shavings in the die.

Having air flow during the entire stitching process is important because as the punches are pulled out of the stitch, small fines and burrs that fall off the cut edges are carried away from the stitch in the air stream. This will blow debris outside the punch area where the burrs will not be able to damage the material.

HOW IT WORKS:

Air wands are integrated into the stripper plates. These air wands have small holes that are spaced to blow an air stream between each die punch. When the Joiner is turned on to stitch, the air blow-off feature will turn on and blow any burrs or small shavings out of the die, while the stitch is being made.

A venturi effect is created when air flows through the wands, magnifying the amount of air moved through the stripper. Air is drawn through the punch openings in the stripper and exhausted under the sides of the stripper. This venturi effect is high enough that you may notice the strip being pulled slightly against the stripper.

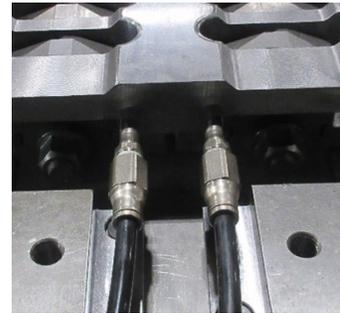
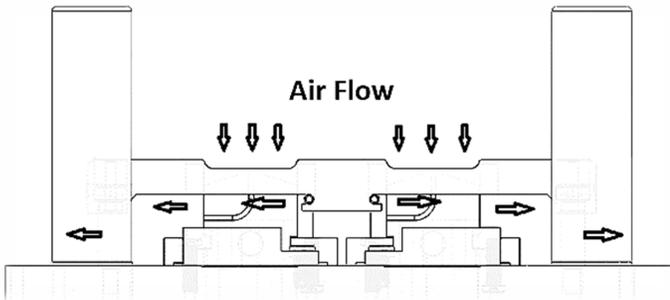
SINGLE ROW FEATURE

- One air wand is added to each stripper plate along-side the die punches
- Two air wands total
- Upper and lower wands are connected with a tee
- The small holes in each wand are spaced between every die punch



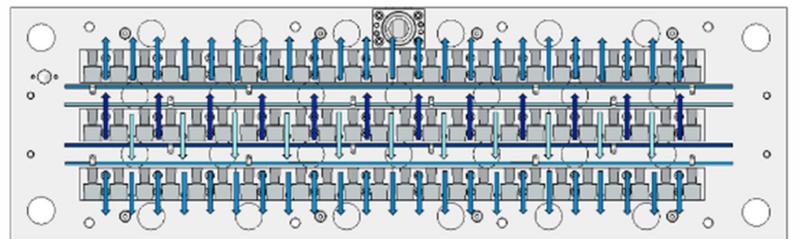
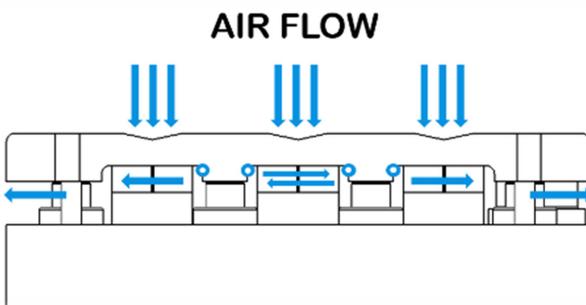
DOUBLE ROW FEATURE

- Two air wands are added to the middle rib under the stripper plate
- Four air wands total
- Upper and lower wands are connected with a four-tube manifold
- The small holes are spaced between every die punch
- The wands are in the middle to blow the burrs to the outside



TRIPLE ROW FEATURE

- Four air wands are added to the bottom of the lower stripper plate only
- The air wands are connected on each side with a four-tube manifold
- The two outer wands face outwards and are spaced between every die punch
- The two inner wands face the inside and have holes spaced every other die punch so that the air streams are offset and do not cancel each other out



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