



Tips for Better Bar Pulling

- 1) Always employ a spindle tube liner sized for the material you are running. We recommend "Trusty-Cook" spindle liners, they are the best.
- 2) Always have good clearance between the chuck/collet and the raw material.
- 3) When setting up your bar puller, run the tool a few inches in front of the bar to prove out the program. When you are satisfied that you will not have a crash, set the proper "Z" reference for pulling.
- 4) Use a minimum of 2 serrations (.125") to engage the material. This is ideal for running parts close to the chuck/collet for more rigidity. However, the more serrations that are engaged on the material, the shallower the marks from the grippers will be.
- 5) When using a sub-program to loop bar pull, your "L" count is extremely important. An improper "L" count can cause a crash by leaving a slug in the grippers. A subsequent pull will drive the slug into the body of the bar puller, which will damage your tool.
- 6) For longer production runs (when running more than one bar) raw material bars should be cut to the same length. This is where part yield calculation becomes critical.
- 7) Mount your bar puller in a position that is away from tools that make a lot of small chips.
- 8) When engaging, pulling, and disengaging, faster is usually better than slower. Do not leave the grippers engaged on material for extended periods of time.

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