



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.

ACCUDYNE PRODUCTS, LLC.
2835 S. RARITAN ST.
ENGLEWOOD, CO 80110-1103
www.accudyneproducts.com
(O): 303.991.1500
(F): 303.991.1921