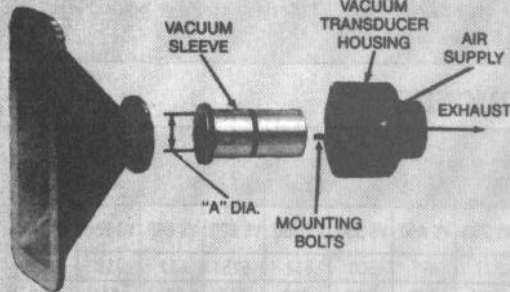




RT SERIES VACUUM TRANSDUCERS

Each unit consists of a Vacuum Transducer with replacement Vacuum Sleeve combined with one of three funnels.
When ordering, list the Vacuum Transducer part number first and the funnel size added as a suffix. E.G.: RT1500-F5.



VACUUM TRANSDUCER Part Number	RT 1250	RT 1500	RT 1750	RT 2000
Use Vacuum Sleeve Part Number	VS 1250	VS 1500	VS 1750	VS 2000
"A" DIA. of Vacuum Sleeve	1.250	1.500	1.750	2.000
Area of "A" DIA.	1.22 in. ²	1.76 in. ²	2.41 in. ²	3.41 in. ²

See Vacuum Sleeve Chart on Page 442 for vacuum performance at various pressures.

VACUUM FUNNEL PART NUMBER	F5	F6	F7
Width	4%	2%	2%
Length	8%	6	9%
Height	4½	2%	5

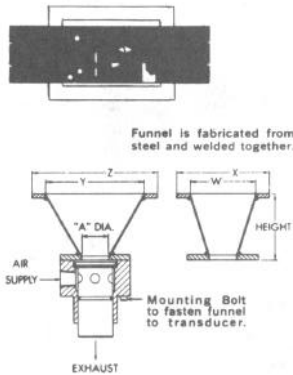
FUNNELS F5-F6 WILL FIT RT 1250-RT 2000
FUNNEL F7 WILL FIT RT 1250-RT 1500
Indicate "A" DIAMETER when ordering funnel only.
Example: F6-1250.

SELECTING VACUUM TRANSDUCER AND FUNNEL SIZE

HOW TO SIZE RECTANGULAR FUNNEL UNITS:

The "A" DIAMETER of the unit is selected according to the following factors:

1. The "A" DIAMETER must be approximately 1/8" larger than the longest dimension on pieces of scrap. In this example, the dimension is 1 1/16".
2. The "A" DIAMETER must equal in area the total area of die openings into funnel. In this example, this area equals .39 in.² — which is approximately equivalent to a 1 1/16" diameter.

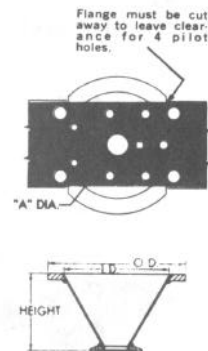


Therefore, the LENGTH OF SCRAP FACTOR was greater than the TOTAL AREA FACTOR, and determined the size of unit. When 1/8" was added to scrap length for clearance, a unit with "A" DIA. METER of 1.250" was selected.

HOW TO SIZE ROUND FUNNEL UNITS:

The "A" DIAMETER of the unit is selected according to the following factors:

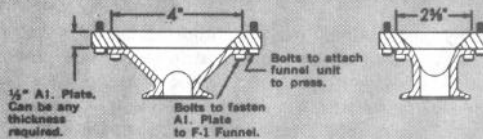
1. The "A" DIAMETER must be approximately 1/8" larger than the longest dimension on pieces of scrap. In this example, the dimension is 1/16".
2. The "A" DIAMETER must equal in area the total area of die openings into funnel. In this example, the combined area of the 8 slugs was .609 in.² which is approximately equivalent to a 1 1/16" diameter.



Therefore, the TOTAL AREA FACTOR was greater than the LENGTH OF SCRAP FACTOR and a VT-940 unit was required. However if the funnel had been designed to also include the four pilot holes, the total area allowing atmospheric air into the funnel would have been 1.35 in.² and a VT 1250 unit would be required.

HOW TO EXTEND USE OF A STANDARD FUNNEL TO FIT A SPECIAL APPLICATION

Standard Funnel opening can be changed to meet your requirements. For example, by mounting an aluminum plate to the flange of a standard F1 Funnel, the 1 1/16" x 3 1/8" opening can be increased up to 2 1/8" x 4".



HOW TO UTILIZE AN AIR-VAC FUNNEL FOR HORIZONTAL SCRAP REMOVAL

In application below, a solid press bed made it necessary to remove loose scrap horizontally. A standard VT 750 C1 Vacuum Transducer with Cap Unit and Funnel was mounted under the bottom die.

