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Shaft Press Video Transcript

0:05 I'm Paul Johnson with Dexter Precision.

0:08 I'm going to demonstrate pressing a shaft into a pulley using our DS50 servo press.

0:13 This machine has a 5 kilonewton capacity in a 200 millimeter stroke.

0:18 I'm going to show the shaft, pulley, press tools, and examples of the press operation.

0:23 Then I'll review data that the servo press can acquire during operation.

0:27 The Dexter Precision servo press can acquire and evaluate in process data to help ensure that the Press operation is done right

0:36 This is the shaft. It's a simple shaft with a couple of ground diameters.

0:40 This is the pulley. It's a piece of timing pulley stock with the whole bored and reamed through it.

0:46 This is a shaft press tool. It's a piece of hardened steel with a bore in it. There's also a magnet that holds the shaft in place. The tool fits in the servo press ram.

1:00 This is a shaft press fixture. It's a piece of hardened steel with a bore in it that locates the pulley. It mounts to the servo press base.

1:12 I'll load the program. You can learn about programming by watching our servo press programming video.

1:23 I'll insert the part and run the program. As the program runs, the machine

can acquire force and position data.

1:36 Here’s a closeup.

1:42 You can see the force and position data being plotted.

1:45 There are also live meters showing force, position, speed, and time.

1:49 The data is saved in a comma separated value file.

1:54 That can be downloaded through USB or Ethernet.

2:02 I’m using a spreadsheet to open the file. You can use any spreadsheet that can import a .csv file.

2:08 The servo press appears as a removable disk.

2:11 Navigate to the export data folder.

2:15 Data files are stored in sequential folders that are automatically created by the machine.

2:20 The data files are also created sequentially. Open the file. And import the data.

2:25 The data is in three columns; time in seconds, position in millimeters and force in newtons.

2:32 I’ll select the position and force columns and insert a chart, XY, lines only.

2:39 Here we can see the force versus position data from the press operation.

2:44 Thanks for watching. For more information check out our website at dexterprecision.com

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