The Rebel V-65 Servo and Rebel Ecofeed are compact bar loading systems for CNC lathes. With a large magazine capacity allowing for long unattended operation, the Rebel 65mm Series combines the advantages of auto bar loading with a small footprint and an economical price.
The Rebel V-65 Servo and Rebel Ecofeed are automatic Bar Loading Magazines for processing bars in the diameter range of 5 to 65mm and in lengths up to 1520mm on CNC lathes.

Rebel V-65 Servo Features

- **Quick and Easy Programming**
  User friendly software delivers fast set-up on easier jobs and powerful advanced features for more sophisticated demands.

- **Axial Shift**
  The axial shift allows for maintenance access to the back of the lathe spindle. The axial track is standard in X-axis.

- **Pusher Storage**
  Special rack holds 2 pushers, while the 3rd is in use. 6,12 and 19mm pushers included.

- **Free Of Noise And Vibration**
  The rotating stock does not come in contact with the loading magazine allowing high speed machining, especially in hex, square, or profiled stock.

- **Extra Large Magazine**
  Magazine storage capacity is 650mm (25”)

- **Soft Load**
  The magazine incline is adjustable enabling the “soft load” for large diameter bars. Material is lowered onto urethane cushions in the V Tray to the proper center height.

- **Bar Diameter Setup**
  Material is lifted up to centerline height. Manual diameter adjustment is indicated in metric and English increments.

Rebel Ecofeed Features

- **Control**
  Easy Access Panel - Mitsubishi PLC

- **Feed Force**
  Feed force set by air pressure gauge for fine tuning.

- **Encoder**
  Used in conjunction with pusher location for “end of bar” command, outputs position in control.

- **Pusher Storage**
  Special rack holds 2 pushers, while the 3rd is in use. 6,12 and 19mm pushers included.

- **Feed Force**
  Parameters setting allows for feed force adjustment and bar diameter.

- **Sub-spindle mode**
  allowing you to “feed-on-the-fly” using your lathe’s sub-spindle.

- **Fixed piece feedout**
  eliminates the need for a stock stop by allowing you to program a feedout value.

- **Slug Load**
  Optional. Consult Edge Technologies Engineering for custom slug load applications.

- **Adjustable Magazine**
  Angle adjustment for impact control depending on stock diameter/weight. Assists in ease of loading hex and shaped bars.

- **Linear Feed & Servo Drive**
  The bar stock is loaded into the main spindle of the lathe by a linear feed mechanism with a toothed belt and servo motor. This allows for the feeding of the bar stock into position with or without the use of a fixed bar stop.

- **Encoder**
  Used in conjunction with pusher location for “end of bar” command, outputs position in control.

- **Feed Force**
  Parameters setting allows for feed force adjustment and bar diameter.

Using the control pendant, the operator can choose either forward or reverse pusher travel while the Rebel 65mm series is in manual mode. Other manual movements include: forward and reverse of material, V Tray height, pre-feed material, semi-auto load.

The bar stock is loaded into the main spindle of the lathe by a linear feed mechanism with a toothed belt and servo motor. This allows for the feeding of the bar stock into position with or without the use of a fixed bar stop.
Rebel Ecofeed Technical Data

- Center Line Height: 920mm (36.2") - 1300mm (51.1")
- Bar Diameter: 5mm (.196") - 65mm (2.56")
- Rapid Return Rate: 1300mm/sec.
- Bar Change Time: Approx 20 sec.
- Operating Voltage: 230V-60Hz single phase
- Air Supply: 70-100 psi
- (3) Bar Pushers: 6,12,19mm
- Weight: 650 lbs.
- Positioning Accuracy: Turret Stop Required

Options:
- Lathe Spindle Liners - Spindle liners sized to bar stock diameter support the rotating bar allowing maximum RPM.
- V-Tray Extension (required on some lathes)
- 1.2M & 1.5M versions available
- Pneumatically feeds to a turret stop

Rebel V-65 Servo Technical Data

- Center Line Height: 920mm (36.2") - 1300mm (51.1")
- Bar Diameter: 5mm (.196") - 65mm (2.56")
- Rapid Return Rate: 1300mm/sec.
- Bar Change Time: Approx 20 sec.
- Operating Voltage: 230V-60Hz single phase
- Air Supply: 70-100 psi
- (3) Bar Pushers: 6,12,19mm
- Weight: 550 lbs.
- Positioning Accuracy: First Infeed +/- .020” +/- .100” in cycle

Options:
- Lathe Spindle Liners - Spindle liners sized to bar stock diameter support the rotating bar allowing maximum RPM.
- Special Applications Loading
- V-Tray Extension (required on some lathes)
- 1.2M & 1.5M versions available

Specifications

2 Size Barfeeders Available

1.2 Meter (Bar Length)

<table>
<thead>
<tr>
<th>Bar Size</th>
<th>5mm - 65mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rack Capacity</td>
<td>650mm</td>
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<tr>
<td>Bar Length</td>
<td>48&quot; Max</td>
</tr>
<tr>
<td>X-Axial Track Travel</td>
<td>X-Axis = 335mm</td>
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</tbody>
</table>

1.5 Meter (Bar Length)

<table>
<thead>
<tr>
<th>Bar Size</th>
<th>5mm - 65mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rack Capacity</td>
<td>650mm</td>
</tr>
<tr>
<td>Bar Length</td>
<td>60&quot; Max</td>
</tr>
<tr>
<td>X-Axial Track Travel</td>
<td>X-Axis = 335mm</td>
</tr>
</tbody>
</table>

Options:

- Lathe Spindle Liners - Spindle liners sized to bar stock diameter support the rotating bar allowing maximum RPM.
- Special Applications Loading
- V-Tray Extension (required on some lathes)
- 1.2M & 1.5M versions available

Technical data subject to change without notice

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