

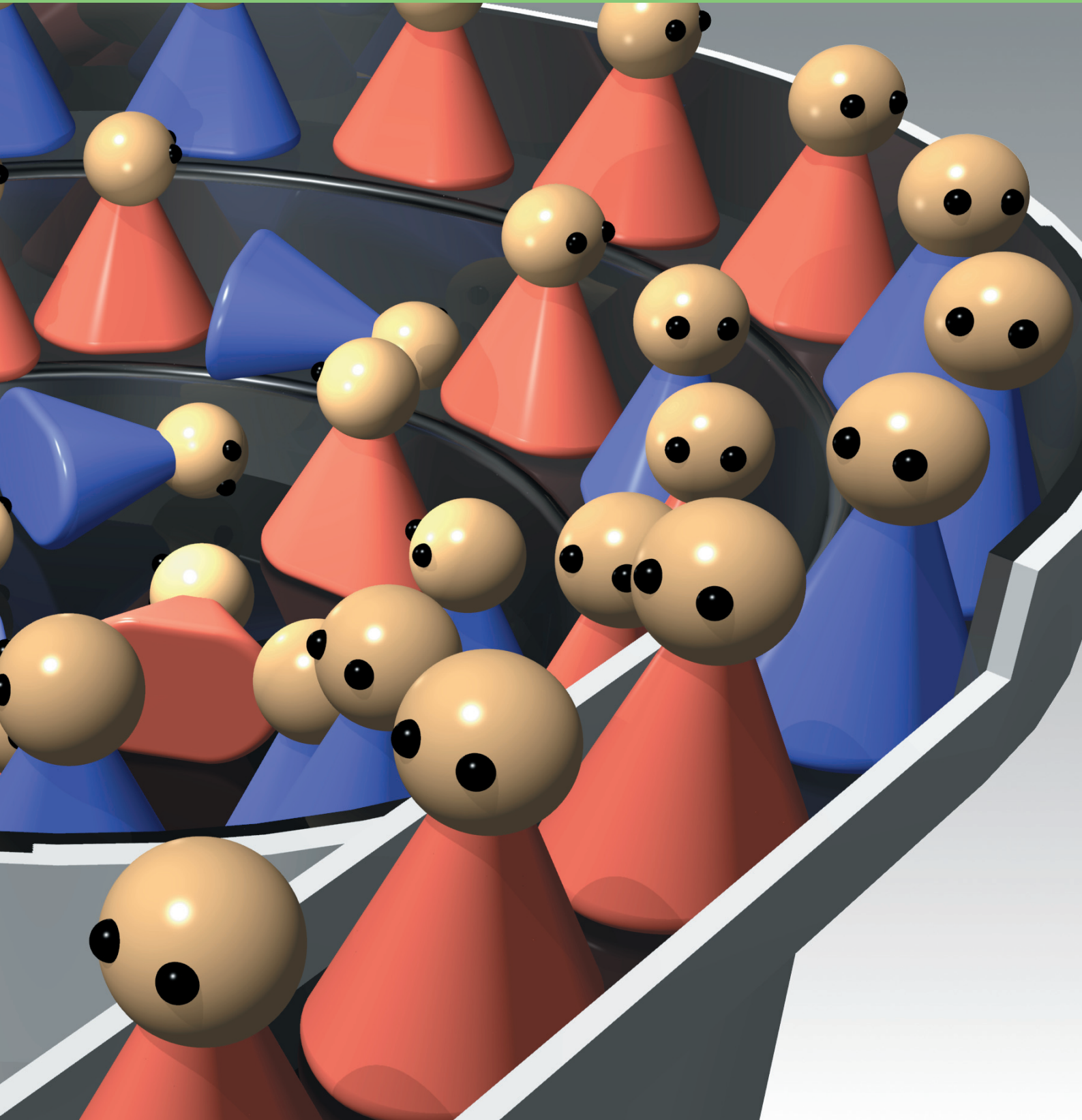
For New Technology Network

# NTN<sup>®</sup>

NTN corporation

# Parts Feeder Guide Book

CAT. No. 7019 / E



# Parts Feeders Support Factory Automation.

Parts feeders are important for automating the production line and assembly system, and are used by an overwhelming majority of manufacturers in automated industries.

NTN Parts Feeders are excellent at high speed feeding and, due to a unique horizontal vibration system and isolated bottom, are vibration resistant.

NTN has extensively developed a series of products, and not just Parts Feeders, but also the related peripheral equipment necessary to contribute to an energy-conserving, high-speed production line and assembly system.





# NTN Parts Feeder Guide Book

Operation of Parts Feeder

Introduction of Applications

Selection of Bowl and Unit

Introduction of Series

Assembly Layout

Escapement and Peripheral Equipment

Consultation inquiries:

# Operation of Parts Feeder

2

A parts feeder has three major functions: **storing**, **aligning** and **feeding**.

Aligning is the most important feature of the three. The parts are aligned using physical sensors in addition to the basic attachment aligning method.

This method aligns the parts within a series of shaped tracks and conveyances running inside or outside the bowl.

NTN's optimum aligning method ensures consistent production quality throughout automated lines, irregardless of the part's shape or size.

## ★ Born in the U.S. raised in Europe, matured in Japan

"Why would NTN, a bearing manufacturer, produce parts feeders?"

It's an interesting story. Here's a little background on how NTN became involved with parts feeders.

About 50 years ago, the parts feeder was invented in the United States by the Syntron Company. It was a simple device, composed of small magnets and a few plate springs, but it could convey parts one at a time by vibrating them on an upward slant.

Could the inventor have known how important parts feeders would be to manufacturing around the world? Syntron's parts feeders were popular first in the U.S. and the technology gradually spread, arriving in Japan around 1955. Sales of parts feeders expanded gradually.

Some years later, a European bearing manufacturer not satisfied with the feeding speed and stability of the Syntron parts feeder developed their own highly efficient parts feeder. This company had recently sold several production facilities to NTN and was also providing us with needle bearings. The parts feeders achieved satisfactory results at our own facilities, so NTN arranged



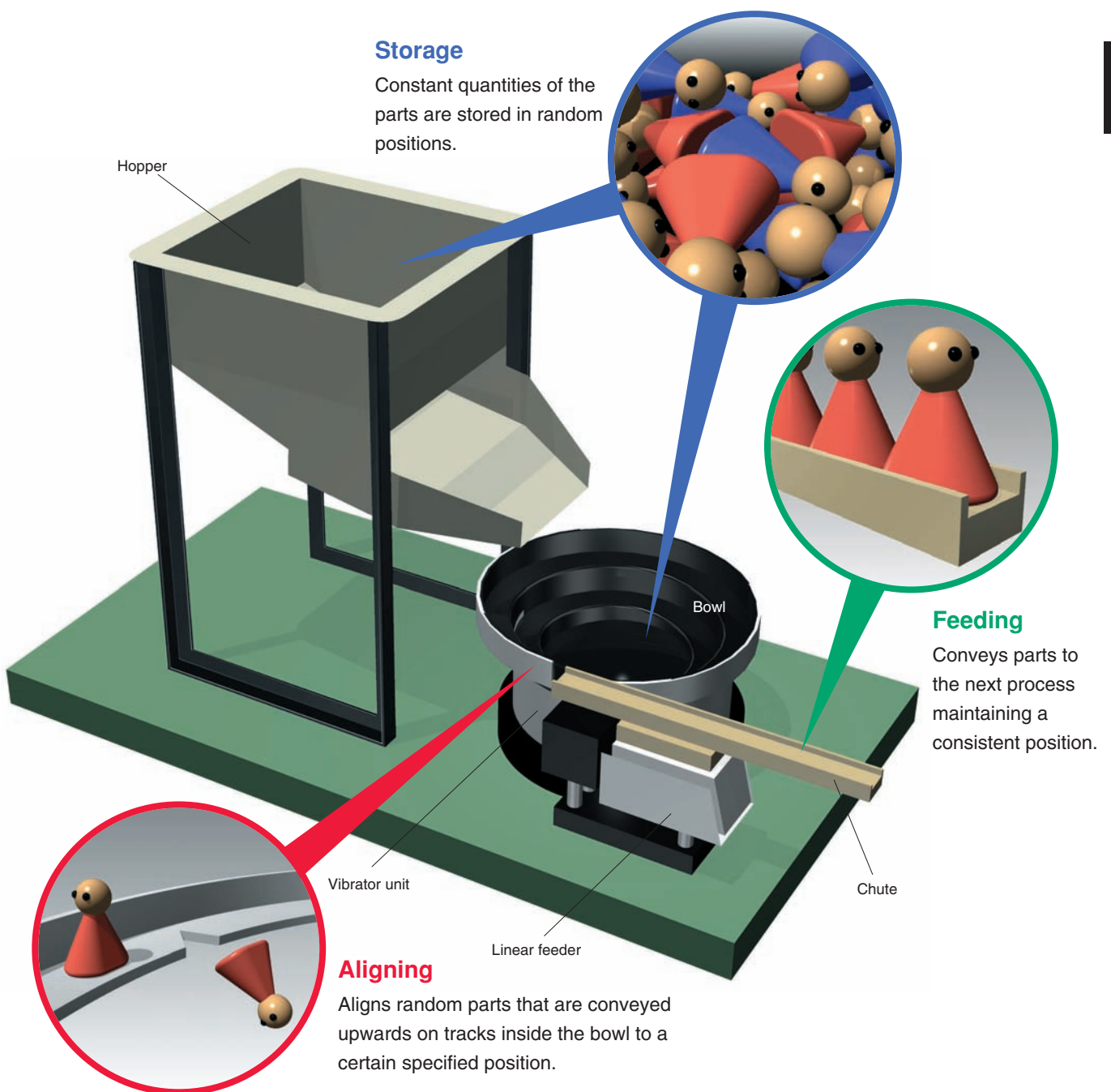
to begin production of this improved parts feeder—not only for use inside our own facilities, but also for general use in the Japanese market.

Since then, NTN Parts Feeders have become widely used in the Japanese market and we have introduced subsequent technological improvements, expanded the series' lines and expanded into servicing the peripheral equipment. NTN is now the leading manufacturer of parts feeders in Japan.

The Syntron method: born in the U.S., modified in Europe and brought to maturity in Japan by NTN.



*A parts feeder can align scattered parts in order and convey them in a consistent posture.  
The device seems to be just a magic box, but as a matter of fact, it incorporates precision mechanisms.*



**Standard composition of the parts feeder system**

# Introduction of Applications

- Metallic parts**

NTN parts feeders can align and feed anything from general nuts and bolts to specific industrial metal parts. For feeding springs which are easily tangled, the parts feeder is provided with a special unraveling mechanism.



- Rubber parts**

Rubber parts are soft and thought to be difficult to feed due to rubber's large coefficient of friction, but NTN parts feeders can align and feed rubber parts using technologies we have developed such as matching the vibration characteristics with the rubber's characteristics and a special-processing of the bowl.



*While NTN part feeders are used in applications handing a wide range of uniform parts it also handles parts that may surprise you.*

● **Plastics**

As the engineering of various molded plastic parts improves, their shapes tend to become more complicated.

NTN parts feeders' optimum aligning and feeding systems can accommodate complicated shapes.



● **Electronic equipment parts**

A variety of feeder systems are available from NTN for electronic parts, from transistors to condenser or microchip components. Special units for high speed, high frequency operation can be prepared.



● **Foodstuffs**

NTN parts feeders can convey various foodstuffs, such as candies and crackers, products in cartons such as ice cream or dry soups, or other packaged goods. The parts feeders can accommodate the wide ranges of size, shape and weight.

● **Medical equipment**

NTN parts feeders are important contributors to the clean environments required in the manufacture of medications in pill or tablet form, as well as for medical equipment, such as syringes.



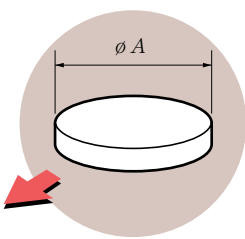
# Selection of Bowl and Unit

When selecting a parts feeder, first determine the bowl size and type and then the feeder unit. The graphs below and on the following pages will identify the three basic shapes of most parts and the bowl dimensions (for either a cylindrical or stepped bowl) and feeder unit to accommodate them.

As a practical matter, consider all of the variables, such as the shape, material, weight, feeding capacity, feeding position and feed-in quantity. The graphs serve as a standard guideline.

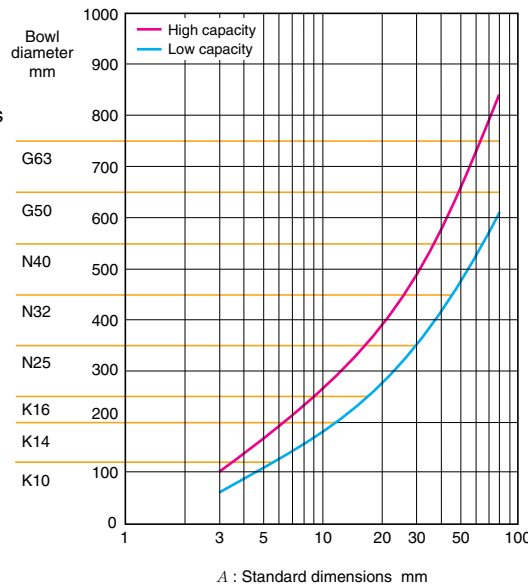
Literature cited: For the Application of Parts Feeder/Japan Parts Feeder Industrial Committee.(Oct.1994)

## Standard graphs to select the bowl size and feeder unit.

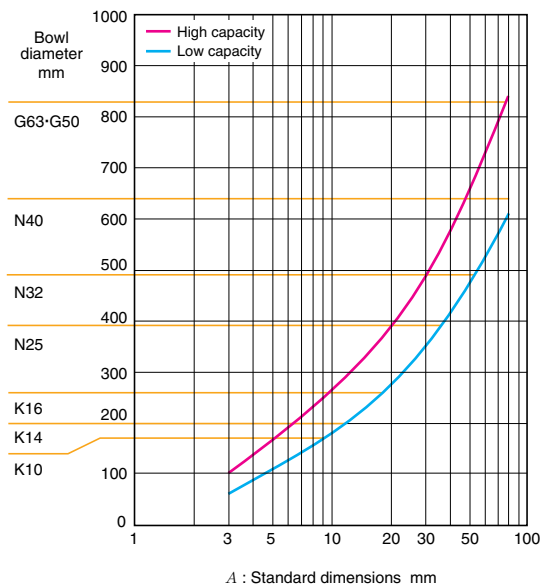


A : Standard dimensions

### ■ Cylindrical bowl



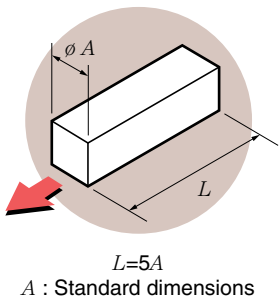
### ■ Stepped bowl



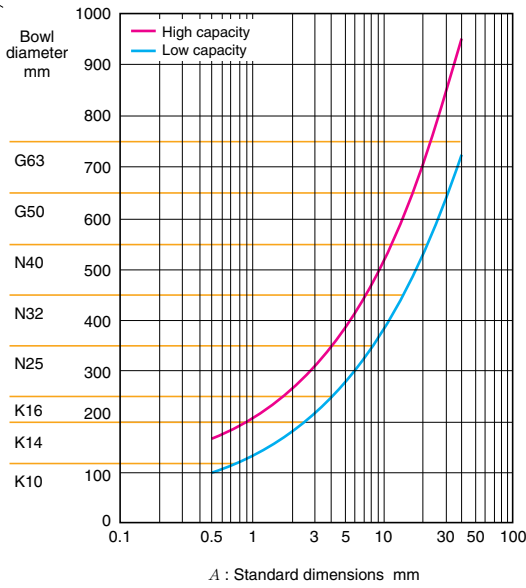




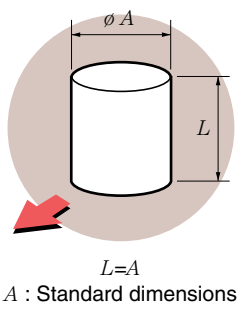
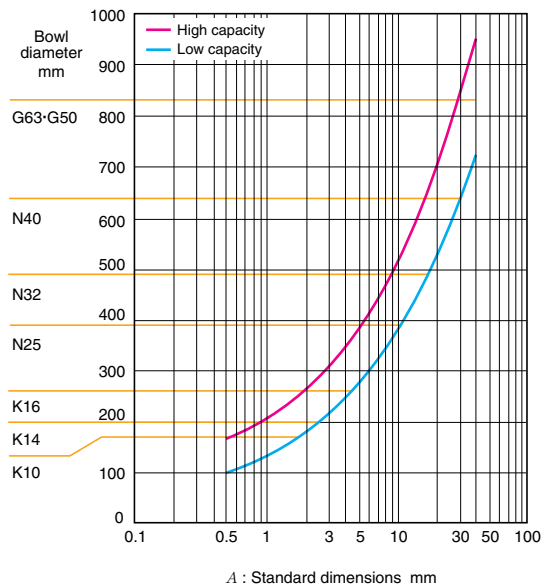
An NTN parts feeder enables you to choose the optimum system among a range of feeders.



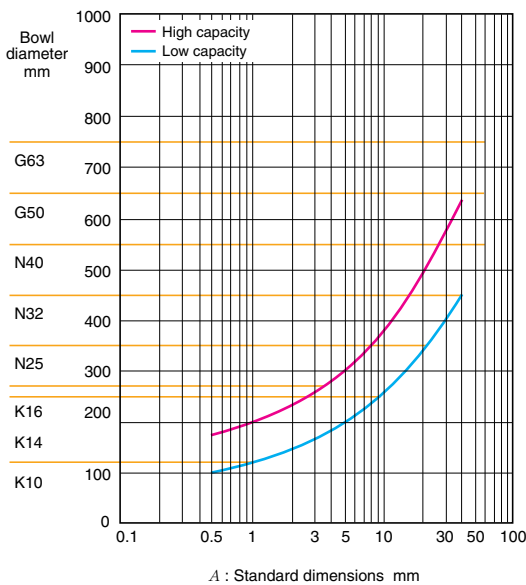
**■ Cylindrical bowl**



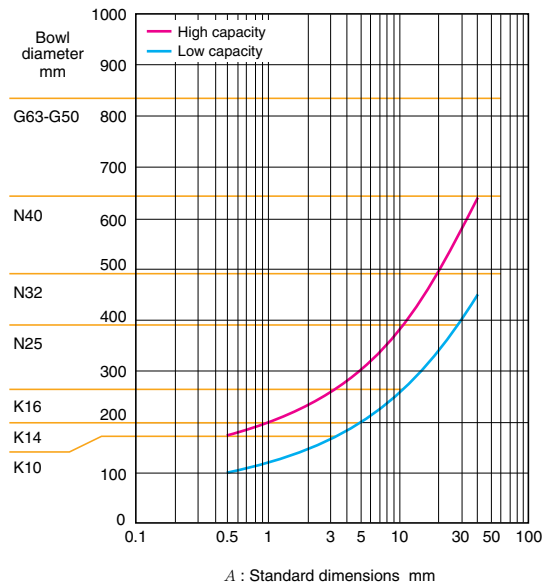
**■ Stepped bowl**



**■ Cylindrical bowl**



**■ Stepped bowl**



# Introduction of Series

## ● Bowl feeder series



### **K-series**

Aligns and conveys minute parts such as electronic parts and others.

- Maintains a stable and suitable full-wave vibration for aligning microparts.
- Easy spring adjustment due to a convenient cover-less construction.



### **F-series**

Conveys minute parts at high speed.

- Smoother feeding of parts at a higher speed than K series is possible by adopting a unique horizontal driver as small models and a suitable attachment angle of plate spring.



### **HF-series**

Precision conveyance of microparts such as electronic parts for chips.

- Using the combination of a horizontal driving system and a high frequency driver, the precision feeding of parts at high speed is possible.



### **N-series**

Conveys middle size parts.

- Adopting the traditional isolated bottom and a horizontal driving system, this best-selling series is a typical NTN parts feeder that provides stable operation and high durability.
- An auxiliary hopper can be attached to the bowl to easily increase the storage capacity of parts.



### **G-series**

Aligns and conveys large and heavy parts.

- Adopting the powerful double spring unit, it can also readily handle large amplitude operation using a large size bowl.
- As with the N-series models, the isolated bottom can be provided. Even though heavy parts are thrown in, it maintains a stable feeding speed.

## ● Bowl series



### **Precision cut-out bowl**

Suitable for aligning and feeding minute parts.

- Various high precision track shapes can be formed because of precision machining.



### **Stepped bowl**

For general purposes (universal type)

- Clogging of parts does not occur in the bowl.
- Two materials are prepared: cast aluminum alloy which is very light and stainless steel which enables an easy assembly of attachment.



### **Cylinder bowl**

For general purpose and special applications.

- Installation of long attachments with complicated shapes are possible.
- Setting of the attachment is easy since the external form is even.



### **Cone bowl**

For general purpose.

- Clogging of parts does not occur in the bowl.
- Setting of the attachment is easy since the external form is even.



### **Dish bowl**

For high speed feeding of thin parts.

- Flat parts can be easily supplied at a high speed by providing slim tracks.

Various types of parts feeder can treat a wide variety of parts.

● Controller series



**Standard controller**

General purpose amplitude control and ON/OFF control sensors.

- General purpose controller provided with many operational features and lots of variations.



**Constant voltage controller**

Applicable where the power source voltage fluctuation is intense or facilities requiring 24-hour continuous operation.

- Prevents troubles due to power source voltage fluctuation and provides a stable continuous power supply.



**Constant amplitude controller**

Applicable to conveyance facilities for heavy items such as auto parts.

- Compensates automatically the change in the feeding speed due to the weight of parts to ensure a stable feeding.



**Variable frequency controller**

Feeders can be operated regardless of the power source frequency.

- The conventional troublesome plate spring adjustment according to the weight of bowl and chute is unnecessary.
- Adjustment is unnecessary even though the equipment receives the different power frequencies.
- There are analog type controllers, variable frequency controllers (for the high frequency wave) and the newly developed digital control system variable frequency controllers. This controller has a highly stable frequency and more micro-computerized functions.



**Constant voltage twin controller**

Suitable when using the combination of parts feeder and linear feeder.

- It is possible to control both the parts feeder and the linear feeder at the same time using one controller.
- Stable power voltage supply even if a power source voltage fluctuation occurs since the constant voltage circuit is installed.



**Timer unit**

Applicable to expand functions of each controller

- It is possible to add functions of the ON/OFF control sensors and valve-drivers while in operation by adding this unit and connecting it with a controller.

● Linear feeder series



**S-series**

General model (for conveyance to automated machines by combining with NTN Bowl Feeders series).

- The high-sturdy vibrator unit and the design of strong springs provide a uniform feeding speed and stable operation over a long period of time.
- Easy installation and adjustment location using the fitted base.



**HS-series**

For the precision conveyance of microparts such as electronic chips.

- Used in combination with the NTN bowl feeder HF-series, the precision feeding of parts at high speed is possible.



**L-series**

For high speed conveyance of thin parts.

- Introducing the horizontal driving system based on an entirely new principle of operation, smooth feeding with few jumps at high speed is possible.
- Chute can be easily designed....The feeder can be driven with a good balance by placing the center of gravity of the chute at the center of the upper vibrator.

● Hopper series



**Detached hopper**

Contains a high volume at storage and supplies a wide range of parts from small parts to large billets matching the bowl feeder series.

- Stable feeding of light works and heavy works is possible.



**Space-saving type hopper**

Most suitable for saving installation space.

- The work storage tank is mounted above the parts feeder to make the installation space compact.
- The tank can be easily moved up and down, also turned to the rotation direction. It enables the easy maintenance of attachments and parts feeder.



**Automatic auxiliary hopper**

For the storage and supply of parts which are light and have complicated shapes that conventional auxiliary hoppers cannot handle.

- A completely air-driven control moves the hopper up and down, eliminating the necessity of the electrical installation for a control panel.
- Similar to the conventional auxiliary hopper in the bowl, it saves space and is easy to detach.



**Rotary hopper**

This separate type storage hopper can feed object such as fine powder to minute parts.

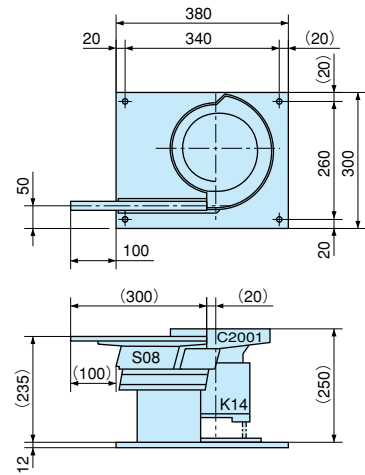
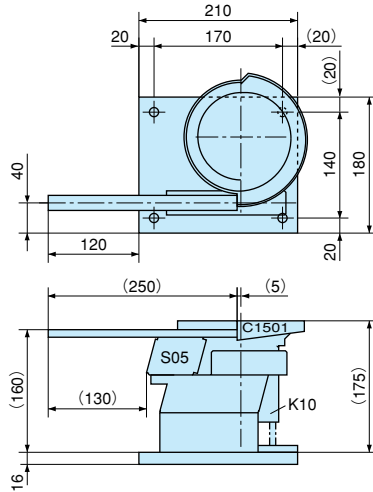
- Capable of discharging minute parts with minimal discharge rate hardly fluctuation.
- Works are discharged by the rotation of the drum which eliminates the generation of excess noise and vibration which is inherent to vibration type hoppers.

# Assembly Layout

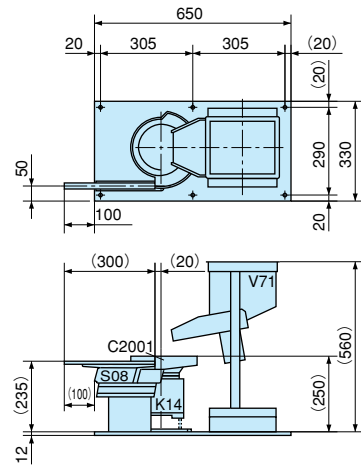
<Typical combinations of products and boundary dimensions of combination> .....

Model	K10	K14
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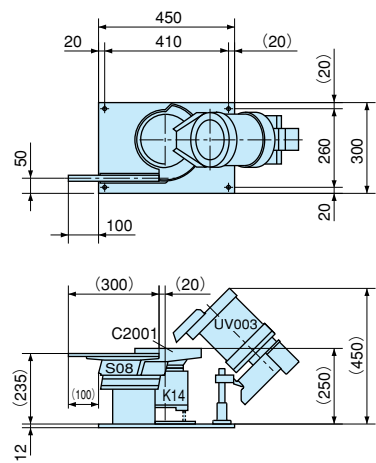
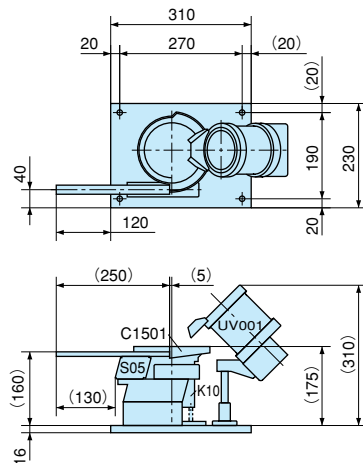
Parts Feeder  
+  
Linear Feeder



Parts Feeder  
+  
Linear Feeder  
+  
Detached Hopper



Parts Feeder  
+  
Linear Feeder  
+  
Space-saving  
Type Hopper  
(Rotary hopper)

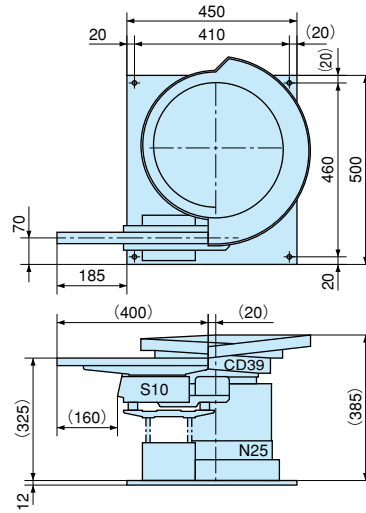
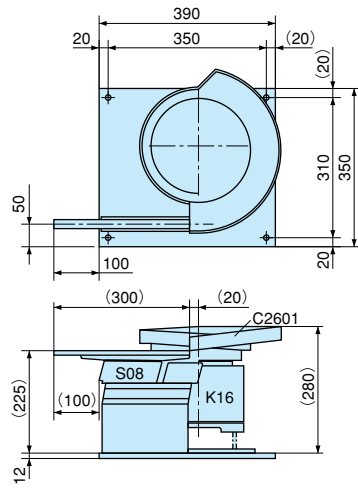


Note \* Parts feeders shall use the stepped bowl specifications.  
 \* N25, 40 and G50 shall be in the free set base specifications.

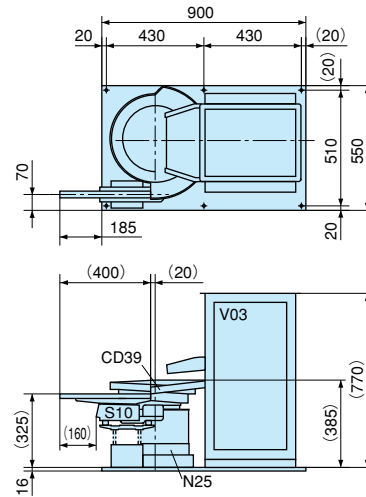
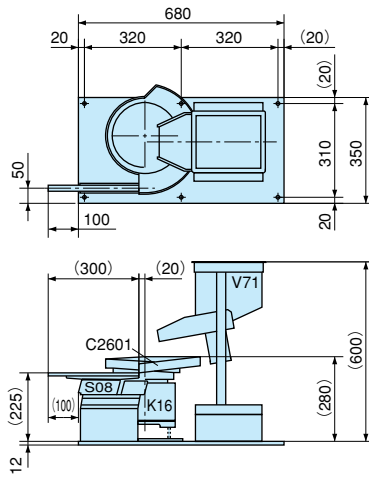
For the customer who has difficulty in providing enough space, a space-saving model is available.

Model	K16	N25
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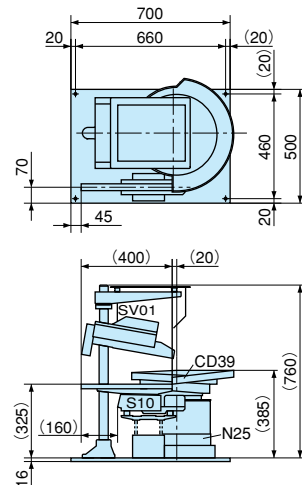
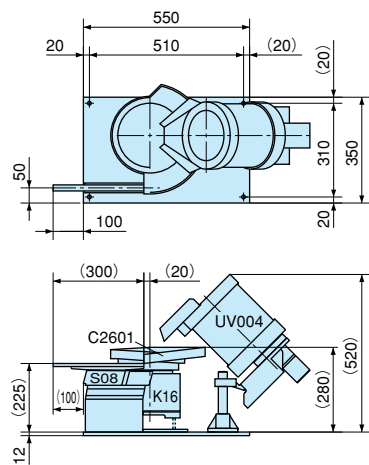
Parts Feeder  
+  
Linear Feeder



Parts Feeder  
+  
Linear Feeder  
+  
Detached Hopper



Parts Feeder  
+  
Linear Feeder  
+  
Space-saving Type Hopper (Rotary hopper)

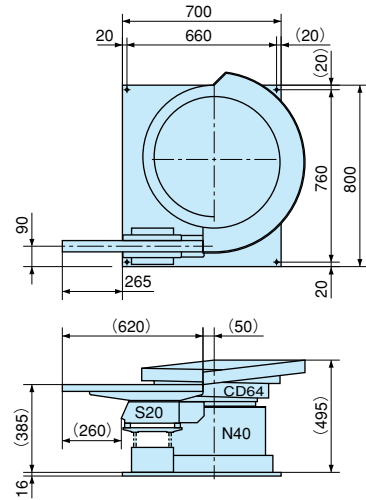
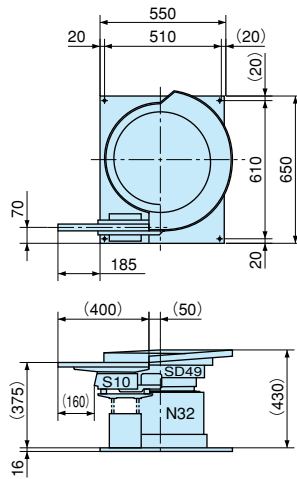


Model  
Combination

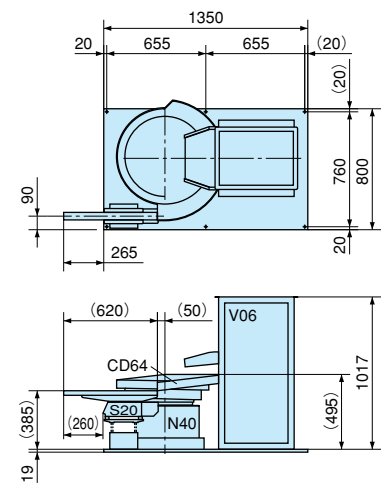
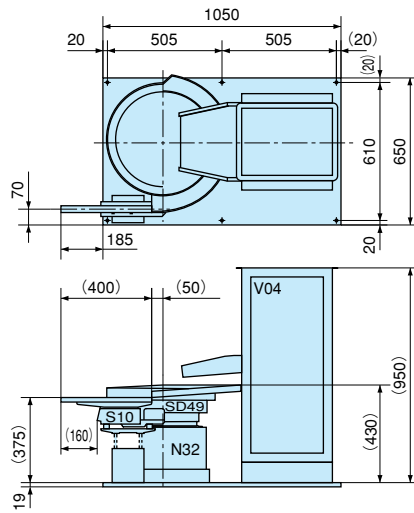
N32

N40

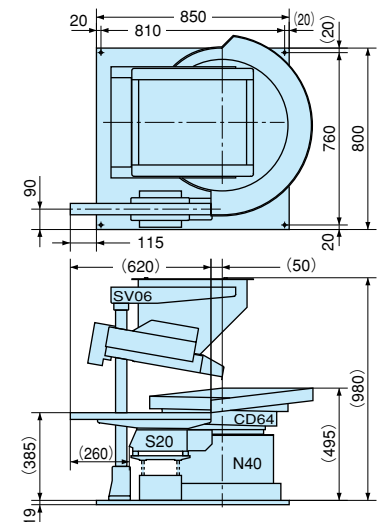
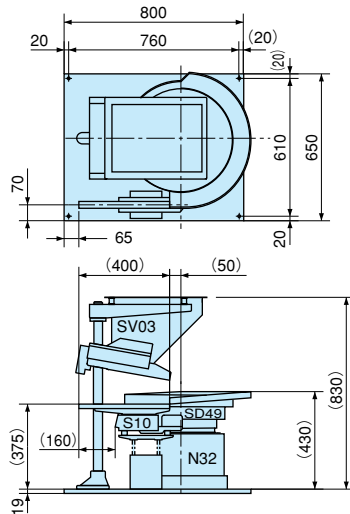
Parts Feeder  
+  
Linear Feeder



Parts Feeder  
+  
Linear Feeder  
+  
Detached  
Hopper



Parts Feeder  
+  
Linear Feeder  
+  
Space-saving  
Type Hopper

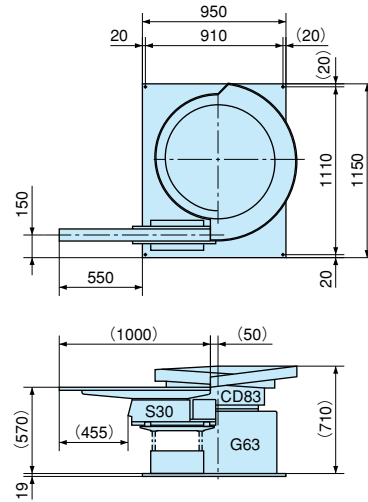
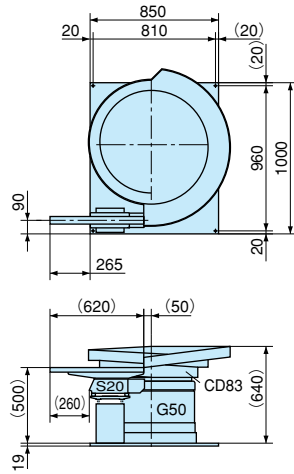


Note \* Parts feeders shall use the stepped bowl specifications.  
 \* N25, 40 and G50 shall be in the free set base specifications.

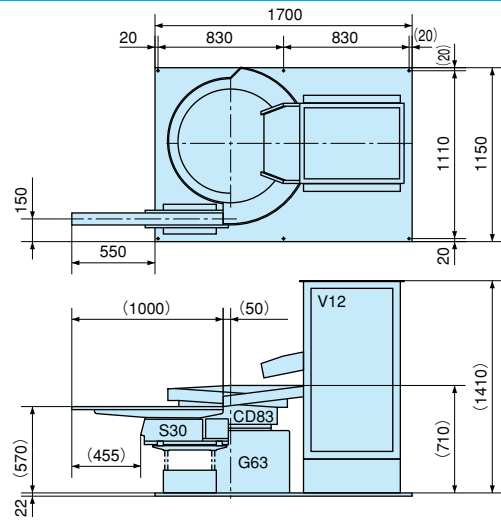
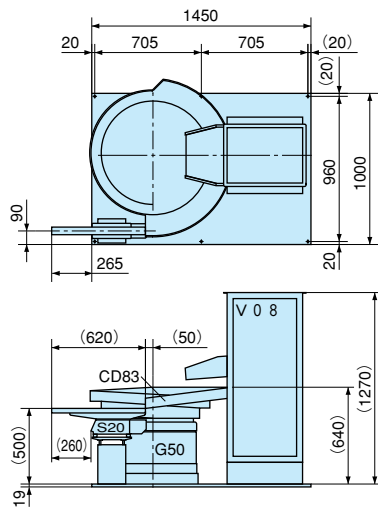
Model	G50	G63
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Combination

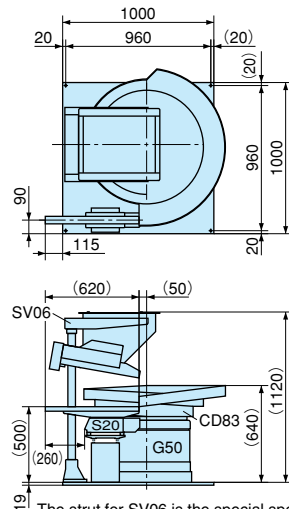
Parts Feeder  
+  
Linear Feeder



Parts Feeder  
+  
Linear Feeder  
+  
Detached Hopper



Parts Feeder  
+  
Linear Feeder  
+  
Space-saving Type Hopper



The strut for SV06 is the special specification.

# Escapement and Peripheral Equipment

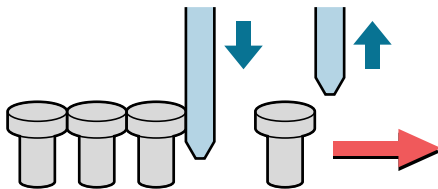
## Escapement

The word, "escapement" means to detach and separate parts one at a time or in several pieces which are conveyed forward continuously after aligning by the parts feeder.

NTN can suggest the most suitable escapement to match the customer's requirements using our many years of experience.

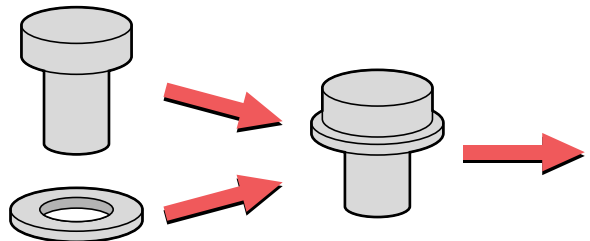
- **Separating one part.**

Using a cylinder, it separates a part.



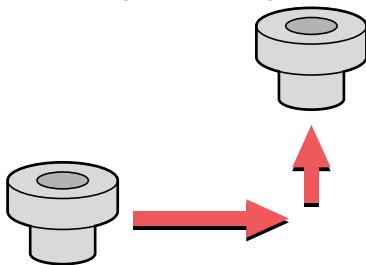
- **Combining.**

Combines parts fed separately and sets them mechanically.



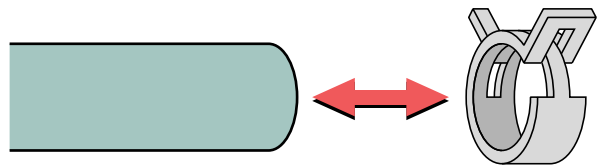
- **Lift-up.**

A part is elevated using the hole as a guide.



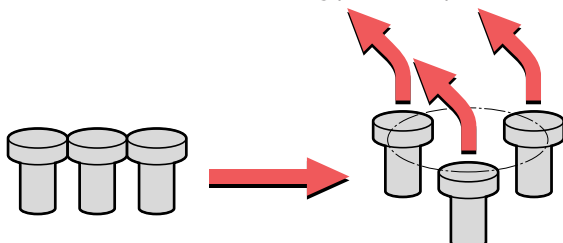
- **Assembly of the hose clamp.**

Loosens the hose clamp metal fitting and loads it onto a hose.



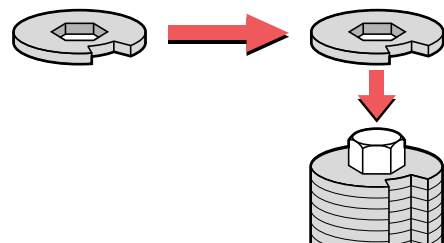
- **3-row feeding by pneumatic pressure.**

This process distributes parts in single row alignment into three rows and feeds them using pneumatic pressure.



- **Stacking.**

Aligns notched parts in the same direction, and skewers them onto a rod.

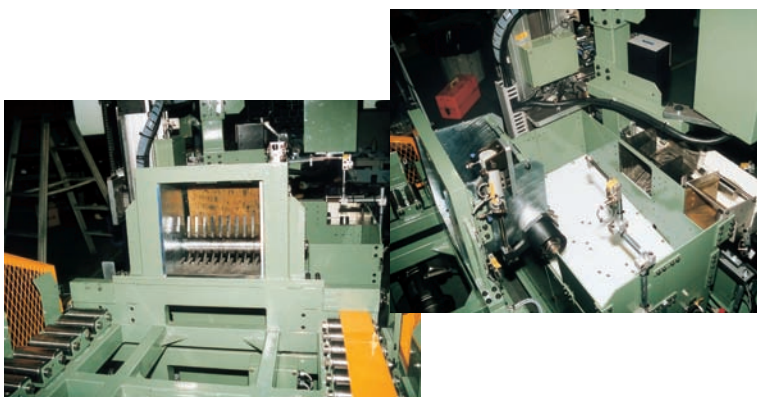
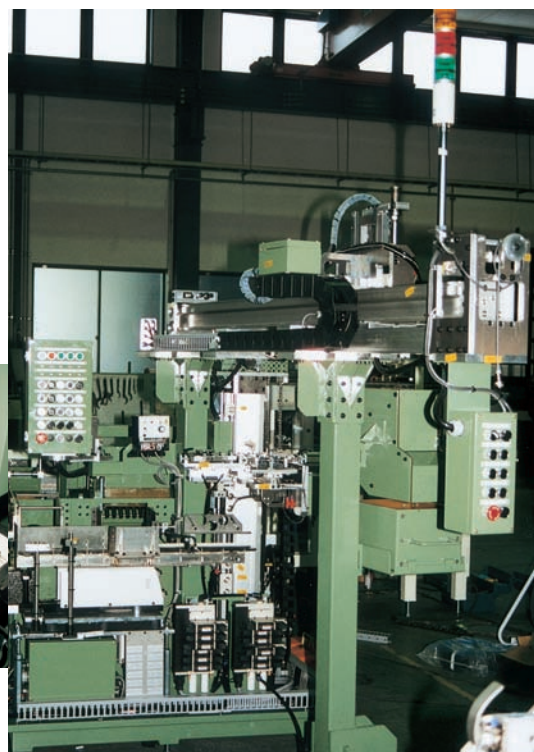
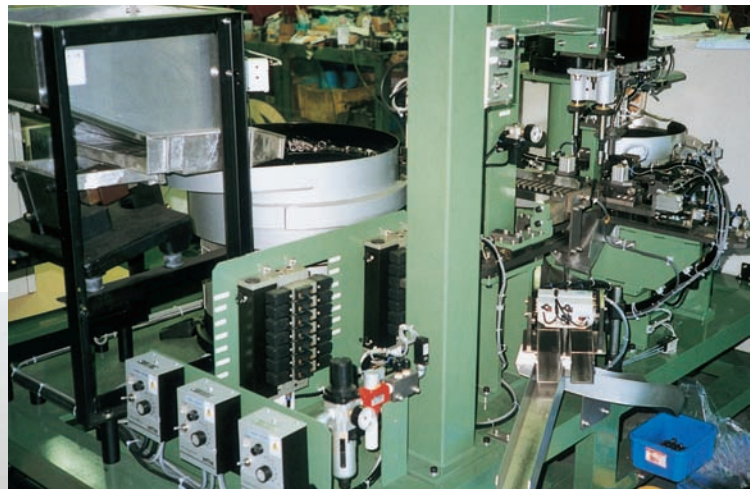




*Satisfactory presentation of the escapement and peripheral equipment enables customers to receive efficient and flexible service from us.*

### Peripheral equipment.

We can suggest the automated and energy-saving unit to match the customer's requirements such as the parts assembly unit, aligning and feeding units, testing and selection units by utilizing our feeding technology experience in developing parts feeders.



**HEADQUARTERS**

**NTN Corporation URL <http://www.ntn.co.jp>**

1-3-17, Kyomachibori, Nishi-ku, Osaka-shi, Osaka 550-0003 Japan  
Phone: +81-6-6443-5001

**NTN USA Corporation URL <http://www.ntnamerica.com>**

1600 E. Bishop Court, P.O. Box 7604, Mount Prospect, IL 60056-7604, U.S.A.  
Phone: +1-847-298-7500 Fax: +1-847-294-1209

**SALES NETWORK**

**NTN Bearing Corp. of America**

Head Office / 1600 E. Bishop Court, P.O. Box 7604, Mount Prospect, IL 60056-7604, U.S.A.  
Phone: +1-847-298-7500 Fax: +1-847-699-9744

Central Sales Office / 2413 North Main Street, East Peoria, Illinois 61611  
Phone: +1-309-699-8600 Fax: +1-309-699-8670

NTN Automotive Center / 39255 W. 12 Mile Road, Farmington Hills, MI 48331-2975, U.S.A.  
Phone: +1-248-324-4700 Fax: +1-248-324-1103

**NTN Bearing Corp. of Canada Ltd. URL <http://www.ntn.ca>**

Head Office / 305 Courtneypark Drive West, Mississauga, Ontario, L5W 1Y2, Canada  
Phone: +1-905-564-2700 Fax: +1-905-564-7749

Vancouver Branch / 106B - 3680 Bonneville Place Burnaby, B.C. V3N 4T6, Canada  
Phone: +1-604-444-2007 Fax: +1-604-444-2665

Edmonton Branch / 4608-97th Street, Edmonton, Alberta T6E 5N9, Canada  
Phone: +1-780-435-6200 Fax: +1-780-435-3600

Toronto Branch / 305 Courtneypark Drive West, Mississauga, Ontario L5W 1Y4, Canada  
Phone: +1-905-564-9600 Fax: +1-905-564-9609

Montreal Branch / 4973 Levy Street, Ville, St-Laurent, Quebec, H4R 2N9, Canada  
Phone: +1-514-333-8054 Fax: +1-514-333-1078

**NTN Wälzlager (Europa) GmbH. URL <http://www.ntn-snr.com>**

Head Office / Max-Planck-Str. 23, 40699 Erkrath, F.R.Germany  
Phone: +49-211-2508-0 Fax: +49-211-2508-400

Stuttgart Branch / Plieninger Str. 63B, 70794 Filderstadt F.R.Germany  
Phone: +49-711-123901-0 Fax: +49-711-123901-660

**NTN Bearings (UK) Ltd. URL <http://www.ntn-snr.com>**

Wellington Crescent, Fradley Park, Lichfield, Staffordshire, WS13 8RZ, U.K.  
Phone: +44-1543-445000 Fax: +44-1543-445035

**NTN-SNR ROULEMENTS. URL <http://www.ntn-snr.com>**

Head Office / 1, rue des Usines B.P. 2017 74010 Annecy Cedex, France  
Phone: +33-4-50-65-30-00 Fax: +33-4-50-65-32-91

Lyon Branch / Le Florentin, 71, Chemin du Moulin Carron, BP8-69570 DARDILLY, France  
Phone: +33-4-78-66-68-00 Fax: +33-4-78-66-68-20

Paris Branch / 6, rue Auguste Comte, BP49, 92174 Vanves Cedex, France  
Phone: +33-1-40-93-66-00 Fax: +33-1-40-93-66-10

Cran Gevrier Branch / 6 route de la Salle, 74960, Cran Gevrier, France  
Phone: +33-4-50-65-93-00 Fax: +33-4-50-65-93-46

**SNR Wälzlager GmbH.**

Duesseldorf Branch / Max-Planck-Str. 23, 40699 Erkrath, F.R.Germany  
Phone: +49-211-2508-0 Fax: +49-211-2508-400

Bielefeld Branch / Friedrich-Hagemann-Straße 66, 33719 Bielefeld, F.R.Germany  
Phone: +49-521-9-24-00-00 Fax: +49-521-9-24-00-90

Stuttgart Branch / Plieninger Str. 63B, 70794 Filderstadt F.R.Germany  
Phone: +49-711-123901-0 Fax: +49-711-123901-660

NTN-SNR ITALIA S.P.A. / Via Riccardo Lombardi, 19/4, 20153 Milan, Italy  
Phone: +39-02-47-99-86-00 Fax: +39-02-33-50-06-56

NTN-SNR IBERICA SA / Calle Barberán n 6, 28035 Madrid, Spain  
Phone: +34-916-71-89-13 Fax: +34-916-73-65-48

NTN-SNR RULMENTI S.R.L. / Zona Industriala-Vest, 6 Strada Salzburg, 24 00 SIBIU, Romania  
Phone: +40-269-20-35-00 Fax: +40-269-20-35-25

NTN-SNR Marocco / 73, boulevard Moulay Slimane, Ain Sebaâ Casablanca,  
BP 15873 Casa-Principal, Marocco  
Phone: +212-522-66-76-80 Fax: +212-522-66-5166

**NTN Bearing-Singapore (Pte) Ltd. URL <http://www.ntn.com.sg>**

Head Office / No.9 Clementi Loop Singapore 129812  
Phone: + 65-64698066 Fax: +65-64695400

Philippine Representative Office / Unit 1002 Philippine Axa Life Centre Condominium  
Corporation Sen. Gil Puyat Ave Corner Tindalo Street Makati City, Philippines  
Phone: +63-2-759-4407 Fax: +63-2-759-4409

Vietnam Representative Office / 303, 3rd of Thanh Dong Building 132 - 138  
Kim Ma Str., Ba Dinh Dist., Ha Noi, Viet Nam  
Phone: +84-4-37347661 Fax: +84-4-37347662

**NTN Bearing India PVT. Ltd.**

Head Office / SPIC Annexe Building, 2nd Floor No.86, Mount Road, Guindy  
Chennai 600032, India  
Phone: +91-0-44-33707700 Fax: +91-0-44-33707701

Delhi Branch / 715-716, International Trade Tower, Nehru Place, New Delhi -  
1100019, India  
Phone: +91-0-11-40520406 Fax: +91-0-11-40520407

**NTN (China) Investment Corp. URL <http://www.ntn.com.cn>**

Shanghai Head Office / No.6 building No.1666 Nanle Road, Songjiang Industrial  
Zone, Songjiang, Shanghai 201611, China  
Phone: +86-21-5774-5500 Fax: +86-21-5778-2898

Beijing Branch / Unit 3018, South Tower, Beijing Kerry Centre, 1 Guanghua Road,  
Chaoyang District, Beijing 100020, China  
Phone: +86-10-6568-3069 Fax: +86-10-6568-2278

Guangzhou Branch / Room 3606, Onelink Center, No.230-232 Tianhe Road,  
Tianhe District, Guangzhou 510620, China  
Phone: +86-20-3877-2943 Fax: +86-20-3877-2942

Nanjing Branch / Room 18A, Nanjing IFC, No.1 Hanzhong Rd, Baixia District,  
Nanjing 210029, China  
Phone: +86-25-8477-5355 Fax: +86-25-8477-5360

Chongqing Branch / Room 15-6, Carnival mansion, No.9 Guanyingqiao Street,  
Jiangbei District, Chongqing 400020, China  
Phone: +86-23-6796-0812 Fax: +86-23-6796-0878

Shenyang Branch / Room 2606, China Resources Building, No.286 Qingnian Street,  
Heping District, Shenyang 110004, China  
Phone: +86-24-3137-9186 Fax: +86-24-3137-9185

**NTN China Ltd. URL <http://www.ntnchina.com>**

Hong Kong Office / Room 1914-15, Park-In Commercial Centre, 56 Dundas Street,  
Mongkok, Kowloon, Hong Kong  
Phone: +852-2385-5097 (4 lines) Fax: +852-2385-2138

**NTN Bearing-Thailand Co., Ltd.**

Head Office / 12th Floor, Panjathani Tower, 127/15 Nonsee Road, Chongnonsee  
Yannawa, Bangkok 10120, Thailand  
Phone: +66-2-681-0401 Fax: +66-2-681-0408

Khon Kaen Branch / 189-191 Ruen Rom Road Tambon Nai-Muang, Amphur  
Muang, Kohn Kaen, 40000, Thailand  
Phone: +66-43-223679 Fax: +66-43-223601

Haad Yai Branch / 198-198/1 Nipat U-Thid 2 Road, Amphur Haad Yai, Songkhla,  
90110, Thailand  
Phone: +66-74-236568 Fax: +66-74-231520

Bangna Branch / 35/35 Bangna-Trad Road, KM11 Bangplee, Samutprakarn,  
10540, Thailand  
Phone: +66-2-7501732 Fax: +66-2-7501731

Chiangmai Branch / 46/8-10 Thy wang Rd. Changmoi sub.district, Munag district,  
Chiangmai province, 50300 Thailand  
Phone: +66-53-874328 Fax: +66-53-874330

**NTN Bearing-Malaysia Sdn. Bhd.**

Head Office / No.2, Jalan Arkitek U 1/22, Hicom Glenmarie Industrial  
Park, 40150 Shah Alam, Selangor, Malaysia  
Phone: +60-3-55696088 Fax: +60-3-55690200

Butterworth Branch / 4700, Jalan Permatang Pauh, 13400 Butterworth, Malaysia  
Phone: +60-4-3328312 Fax: +60-4-3324407

Iphoh Branch Office / 65, Medan Kidd, Kinta Mansion, 30200 Ipoh, Malaysia  
Phone: +60-5-2547743 Fax: +60-5-2538077

Kuantan Branch / B-72, Ground Floor, Jalan Berserah 25300 Kuantan, Malaysia  
Phone: +60-9-5141132 Fax: +60-9-5141164

Johor Bahru Branch / 51 Jalan, Sri Bahagia 5, Taman Sri Bahagia, Tampoi, 81200  
Johor Bahru, Malaysia  
Phone: +60-7-2364929 Fax: +60-7-2370897

**PT. NTN Bearing Indonesia**

C-21, 22 MM2100 Industrial Town, Cikarang Barat, BEKASI 17520 West Java Indonesia  
Phone: +62-21-252-2081 Fax: +62-21-252-2082

**NTN-CBC (Australia) Pty. Ltd.**

3, The Crescent, Kingsgrove, NSW 2008, Australia  
Phone: +61-2-99479200 Fax: +61-2-95543311

**NTN de Mexico, S.A. URL <http://www.ntnmexico.com.mx>**

Mexico Head Office / Emilio Cárdenas No.158 Apdo.124, C.P.54030, Tlalhepantla,  
Edo.deMexico, Mexico  
Phone: +52-55-5390-1133 Fax: +52-55-5565-8545

Guadalajara Branch / Calle 22 No.2465, Zona Industrial, C.P.44940, Guadalajara,  
Jalisco, Mexico  
Phone: +52-33-3145-1448 Fax: +52-33-3145-1594

Monterrey Branch / Av. Ruiz Cortines No.1336 Ote, Col. La Purisima, C.P.67120,  
Cd. Guadalupe, Nuevo Leon, Mexico  
Phone: +52-818-334-9931 Fax: +52-818-334-9932

Mexicali Branch / Blvd. Benito Juárez No.3293 Esq. Ayuntamiento, C.P.21360,  
Mexicali, BCN, Mexico  
Phone: +52-686-563-3632 Fax: +52-686-582-2057

Veracruz Branch / María Auxiliadora No.687 Esq. J.F.Molina, C.P.91870, Col.  
Los Pinos, Veracruz, Mexico  
Phone: 52-229-934-4757 Fax: +52-229-938-0457

**NTN Sudamericana, S.A. URL <http://www.ntnsudamericana.com>**

World Trade Center Panama  
Calle 53 Este, Urbanización Marbella Piso NO.16, Oficina 1601  
Apartado Postal 832-0487, Panamá, Rep.de Panamá  
Phone: +507-269-4777 Fax: +507-264-5592

**NTN do Brasil Ltda. URL <http://www.ntn.com.br>**

Av. Moema, 94-9' Andar-conj, 92a94 CEP 04077-020-Indianópolis-São Paulo-SP, -Brasil  
Phone: +55-11-5051-0600 Fax: +55-11-5051-2807

**NTN Korea Co., Ltd.**

Head Office / 10th Floor, Press Center, 25, Taepyong-Ro 1-GA, Jung-Gu, Seoul  
100-745, Korea  
Phone: +82-2-720-3665 Fax: +82-2-720-3669

Busan Branch / Rm.707, 7th Floor, Daerim Bldg., 341-5 Bujeon 1-Dong, Busanjin-  
Gu, Busan, Korea, 614-843  
Phone: +82-51-811-1351 Fax: +82-51-811-1353

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# NTN Parts Feeder Estimation Request

● Fill in the necessary information in the blanks and send it to NTN by FAX.

Please paste your business card.  
(Or fill in the following items.)

Company : \_\_\_\_\_

Department : \_\_\_\_\_

Person in charge : \_\_\_\_\_

Phone : \_\_\_\_\_ Fax : \_\_\_\_\_

Date : \_\_\_\_\_

Quotation expiration date : \_\_\_\_\_

Work name/work material/condition		/	/	dry · rinse · oil · others
Feeding rate	Feeding rows	( ) pieces / minutes / rows		( ) rows
		Cycle time ( ) sec./ ( ) pieces ( ) rows		( ) rows
Combined machine		Assembling machine · Forming machine · Inspection machine Others ( )		
Work posture at the parts feeder's exit. (Customer shall present the work drawing to us.)		Side view at the exit		Front view at the exit.
		Mark the forward direction with an arrow.		
Remarks and Requests				

For your inquiries, refer to