

Metal Stamping Machine

July, 1996

Application Note #20

Application:

The Model 1000 Controls a Compumotor SX drive and two punch presses to cut-to-length a piece of sheet metal used in the ventilation industry. The sheet metal will then be formed into a box.

Type:

Motion Control

Objectives:

- Operator entry
- Recipe storage
- Position display

Product Used:

Model 1000

Solution:

The operator needs to specify the length of the piece by entering two lengths of the metal sheet which will be the length and width of a box when finished. The Operator also specifies the number of pieces to be cut. Certain parameters which include speed of the feeder roll, dwell time, notch and shear dwell times, and "k" value which is the width of the notch are stored in the Eason and changed by the operator depending on the part.

To verify the punches are in position are two proximity sensors. An I024 interrupt is used if the punches are out of position and software will not allow the program to continue until the punches are repositioned.

Eason Technology, Inc

241 B Center St., Healdsburg, CA 95448

Tel. (707) 433-2854 Fax (707) 433-3706 BBS: (707) 433-4947

<http://www.eason.com>, e-mail: info@eason.com

