

PS 50 AUTOFEED



PS 50 AUTOFEED CAN DYNAMICALLY INCREASE THE PRODUCTIVITY OF YOUR SHEARING, PUNCHING OR STAMPING OPERATION.

The operator simply loads a blank onto PS 50, locks it in place with pneumatic grippers, and sets the feed in motion which automatically triggers a shear, punch or stamping machine.

PS 50 utilizes the CNC300 Automec control.



It features 300 job storage, shop-rugged LED display, and an RS232 computer interface



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SIMPLE TO PROGRAM

No programming or tape prep experience is required. The operator simply enters a load position, and desired punch or shear dimensions. Once the advance key is depressed the blank is moved into position for the first operation and the shear or punch is activated. When the ram reaches top of stroke the PS 50 advances the material to the next step until the piece is complete. It then returns the grippers to the load position for unloading and loading of the next piece.

SAFER

The operator's hands are kept free of the punch or shear and reduced handling of material reduces chance of injury.

ACCURATE

Gauging from the front of the device using one reference point on the work-piece eliminates cumulative tolerance buildup experienced with backgauging. All dimensions will tolerance within +/- .002" of the original reference.

SHAKER PARTS

The key to a reshearing operation lies in (2) 1/8" punched holes that you program into the cnc punch program a specified distance from your punched pattern. When loading to the PS 50, these (2) holes provide an accurate reference to the punched pattern so that shear cuts are precisely registered and operator error is eliminated. This method is more efficient than shaker parts for the following reasons.

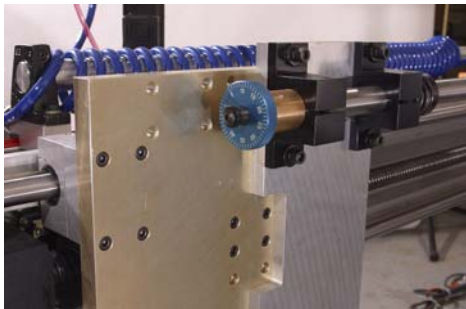
- 1) Straight line cuts are better done on a shear than a punch as nibble marks are eliminated.
- 2) Deburring of edges is significantly reduced.
- 3) Premature shaking apart is eliminated.
- 4) CNC punch time is transferred to the less costly to operate shear. Usually, a single operator can be assigned to a cell so that the shear is parting out the multiple parts while the CNC punch is creating the next punched blank.
- 5) Parts can be grouped closer on the blank so that the leading edge of one row can be the trailing edge of the next. This means extra row of parts can often be added to blanks to reduce scrap.

STRIP CUTTING

Another application for PS 50 is fast, accurate blanking of multiple pieces from a large sheet. The operator handles the piece only once and need not worry about hitting a backgauge accurately on each cut. In this case, reference holes are not required.

COMPUTER INTERFACE

An RS232 I/O with software is included. Jobs can be uploaded, downloaded, programmed and stored at your P.C.



Rugged 1 1/8" dual ball screws and (4) 3/4" shafts handle the sheet movement. A 1000 watt closed loop D.C. servo motor/amplifier drives the system with speed and precision. Travel is 50"



Side-to-side adjustable pneumatic fingers grip the workpiece for feeding. Grippers can be placed up to 8 ft. apart and travel up to 50" front to rear. Grippers can move to within 1" of the punch or shear blade. 1/8" dia. Pins on each gripper fit into a corresponding hole on the blank for accurate referencing.



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