

Machine Control Options

Shown below are some typical upgrades for machine control options



Automatic machine control panel with programmable operator terminal

Hard wired button descriptions:

1. Reset – black momentary push button
Function: resets the machine to “Home Position”
2. Manual / Automatic Mode selector switch
Manual Mode Operation: Machine cycle will single step through the bending cycle each time the palm button is pressed.
Automatic Mode Operation: Machine cycle will automatically restart once the previous cycle is complete
3. Cycle Start – Green momentary push button
Function: starts the machine cycle
4. Cycle Stop - Red momentary push button
Function: stops the machine at the end of cycle
5. Control Power On – Green illuminated push button
Function: Push to turn on control power
6. Emergency Stop – Red illuminated, maintained push button
Function: Push to stop the machine cycle in position
Note: once the emergency stop circuit has been deactivated, machines are typically programmed to allow the machine to be restarted by selecting the cycle start push button or reset to home position by selecting the reset push button
7. Programmable operator terminal
Function: custom programmed to provide a multitude of functions such as: part number selection, part count, status indicators of inputs and outputs, diagnostic functions



Automatic machine control panel

Hard wired button descriptions:

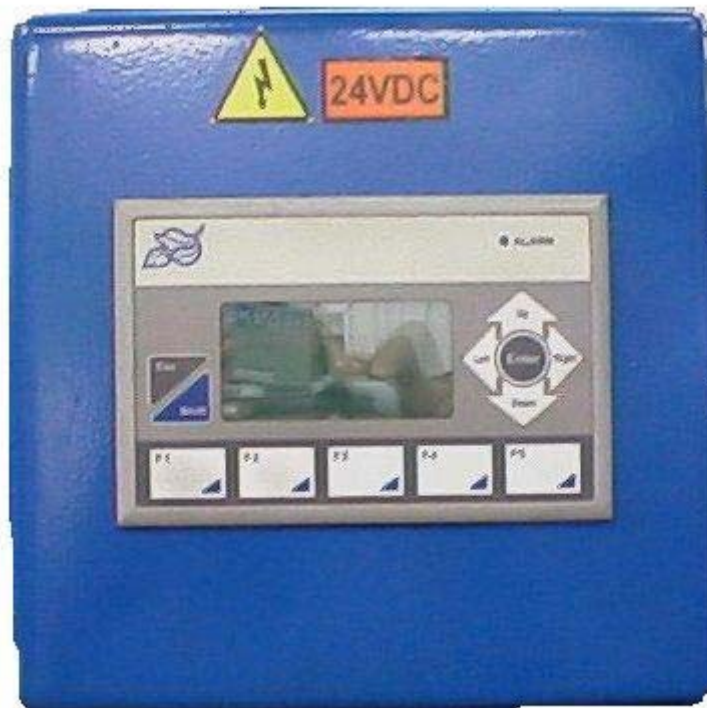
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5. Cycle Start – Green momentary push button
Function: starts the machine cycle
6. Cycle Stop - Red momentary push button
Function: stops the machine at the end of cycle
7. 1st Fault Light – Red illuminated Light
Function: indicates machine fault
8. 2nd Fault Light – Red illuminated Light
Function: indicates machine fault
9. Cycle Count – 7 digit resettable counter
Function: displays total number of parts produced



Semi-Automatic machine control panel

Hard wired button descriptions:

1. Control Power On – Green push button
Function: Push to turn on control power
2. Reset – black momentary push button
Function: resets the machine to “Home Position”
3. Manual / Automatic Mode selector switch
Manual Mode Operation: Machine cycle will single step through the bending cycle each time the palm button is pressed.
Automatic Mode Operation: Machine cycle will automatically restart once the previous cycle is complete
4. Emergency Stop – Red illuminated, maintained push button
Function: Push to stop the machine cycle in position
Note: once the emergency stop circuit has been deactivated, machines are typically programmed to allow the machine to be restarted by selecting the cycle start push button or reset to home position by selecting the reset push button
5. Cycle Count – 7 digit resettable counter
Function: displays total number of parts produced
6. Key Switch – Green momentary push button
Function: used to reset counter
7. Small programmable terminal
Function: custom programmed to provide a multitude of functions such as: part number selection, part count, status indicators of inputs and outputs, diagnostic functions



Small programmable terminal

Function: custom programmed to provide a multitude of functions such as: part number selection, part count, status indicators of inputs and outputs, diagnostic functions



Hard wired indicator lights

Function: Provides information to the operator, can be used to display items such as part number selection, machine faults, parts detected, ect.