



Microguide Computerized Numeric Control MK5

Hardware

- Panel PC based on PCI-bus with multicolor LCD screen
- Panel design and functionality identical to MK 1-4 but foil exchangeable
- Commercial CPU with software release update capability
- Commercial SERCOS Interface for main drive, servos, press load monitor
- Commercial double ASI interface
- CONFIX: external memory plug for parameter transfer in case of control exchange
- Free PCI-slot

Software

- Operator guidance language adapted (Latin, Chinese and Japanese characters)
- Simple language for sheet layout and die setup programming (99 files memory)

- Restroke safe discharge monitor (die safety) incl. signal/crankshaft position indicator
- Press load monitor
- Piece and sheet counters
- Power on and production hour counters
- DNC factory automation interface for: Program data interchange, overhead line control and productivity analysis
- Automatic algorithmic adjustment for dynamic synchronization between feed system and press
- Automatic optimization for servo parameters on each start up
- Diagnosis system for all external devices incl. servos with help text window
- Oscilloscope functionality for servo speed over time
- Commercial 32 bit real time basic operating system



METAL UTILIZATION

Maximum metal utilization is reached by elimination of the otherwise necessary trim operation of the sheets. With the high positioning accuracy, a minimum scrap of 0,6 mm / 0.024 inches (E, EF, AF, DF) resp. 0,8 mm / 0.032 inches (OF) between blanks is achieved. With the usage of prescrolled material, the highest material utilization is reached. On the other hand, even those sheets can be processed, which are sizewise not layouted to the blank diameter of the tool.

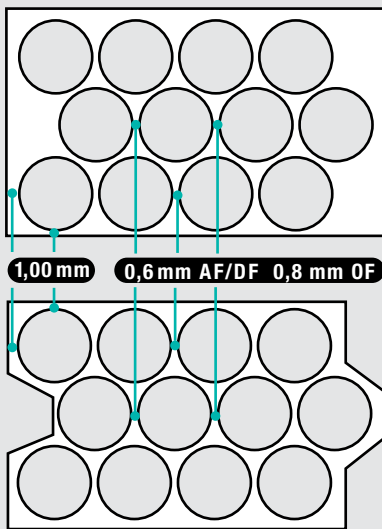
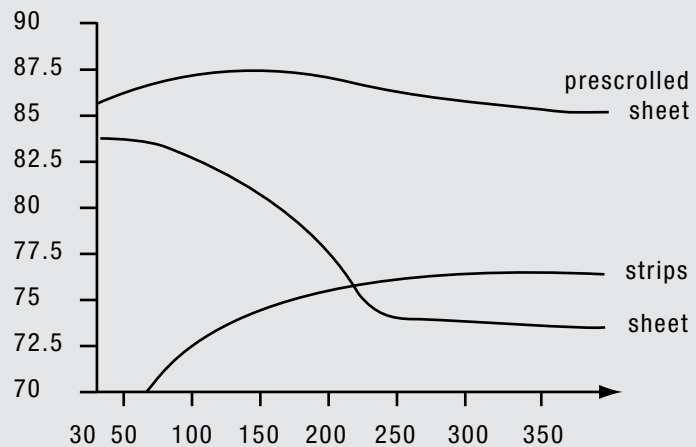


DIAGRAM OF METAL UTILIZATION

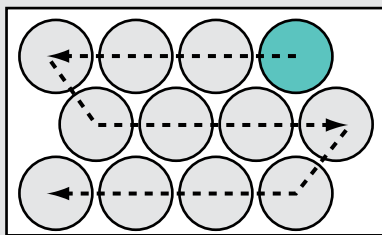
Metal utilization in %



SINGLE & MULTI DIE ARRANGEMENT

Single die

- Direction of advance System in X and Y

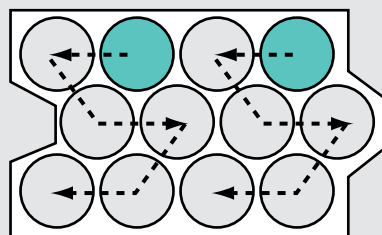


Multi die

- Direction of advance System in X and Y

Conditions for zig-zag multi die:

- equal number of blanks per row in X-direction
- number of blanks per row \geq double no. of dies
- number of blanks per row dividable integerly by no. of dies.



Double row (gang) die

- Movement of advance System in Y-direction only

Conditions of gang dies:

- total no. of dies must be odd

