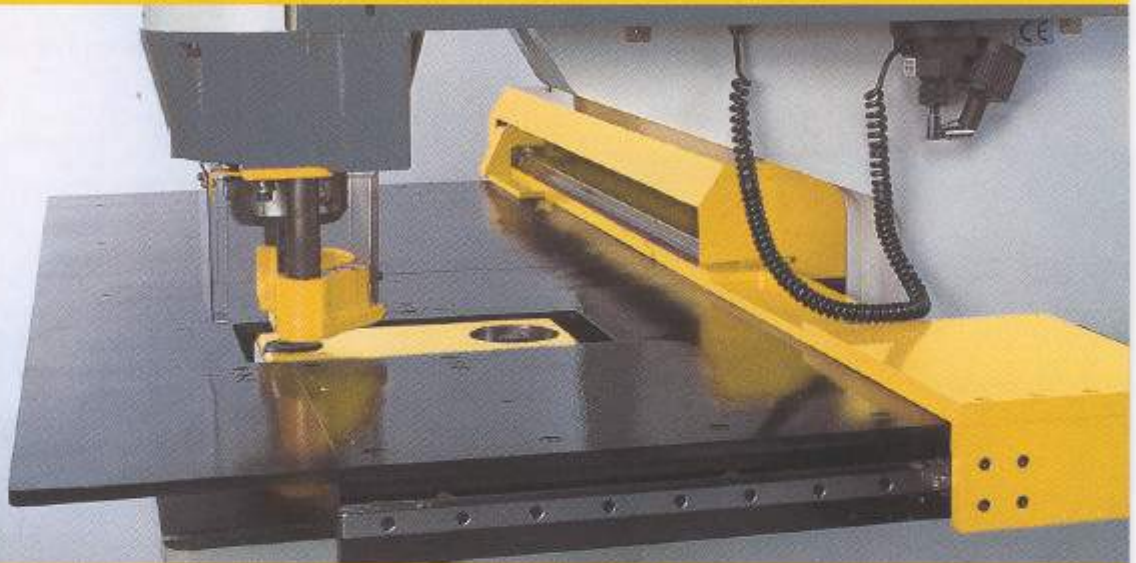


2 AXIS CNC CONTROLLED POSITIONING TABLE

Punching of plates, flat steel, in the web of channel and on the flange of channel and 'I' beams. The punching of the web in channel is effected with the flanges up and by using extended length punches. The table is delivered complete with servo-motor and 2 axis measuring system, and is equipped with an easy to operate Robosoft M200 (or optional M600) control.

Especially advantageous is the repeatability accuracy when manufacturing repeat batches. The use of labour intensive manual layout is no longer required and possible operator error is eliminated. The workpiece is pushed to the CNC controlled stop, after punching the stop goes to the next position etc.



The CNC Controlled Positioning Table can be fitted to all Kingsland "XS" and Ultima Steelworkers and all Punching machines (with 625 mm deep throat) working area:

- Lateral Stop (X-axis) 1,005 mm
- Bit Stop (Y-axis) 510 mm
- Positioning accuracy: ± 0.1 mm



The **M200 Controller** has been developed to execute punching jobs in a fast and repeatable way with high accuracy. With the M200 Controller it is possible to make 8 different punching programs, each with a maximum of 100 steps (holes). The holes need to be programmed with their respective X and Y axis co-ordinates. Furthermore, the co-ordinates can be programmed using either absolute or relative positions. Repetition of incremental steps is also possible. The controller can be used in both automatic or manual mode.



The **M600 Controller** with a 9" LCD screen, using standard ISO codes, it is possible to carry out linear, square, rectangular, circular and circle arts of any size of opening requested in the punching process. The workpiece with its programmed hole pattern is graphically simulated on the screen. The CNC control ensures the required accuracy within a hole pattern using several gauge lines. Each program with its graphic simulation can be stored on disk (disk memory 720 kB, 3.5" disk drive).

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