



A Metal Stamping Press Control System from **Reflex Integration**

Command Stamp allows
you to control your metal
stamping press with easy
installation and operation

With **Command Stamp**
you will have your press
operating quickly and
increase the **safety** and
productivity of your metal
stamping operations

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CSA Z142-02 Compliant



SCREEN SELECT

RESET MINOR



SPECIFICATIONS

CLUTCH / BRAKE MODULE

Supports up to 4 run stations (T-Stands). No more than 500 milliseconds between operator buttons and an overall timer of 5 seconds between stations.

Dual inputs for: Ram Block, Emergency Stop, Safety Lights and Safety Guard Interlocks. No need for safety relay(s).

Programmable press parameters with password protection for TDC Cam, variable speed compensation, brake monitor, and Encoder zero offset.

Inputs for press diagnostics such as low air pressure, lube fault, main motor off, tripped overload, etc.

Self-adjusting TDC compensation for speed changes and brake wear.

CAM MODULE

2 latched cam output relays per module (maintains contact position when power is lost) N.O. (normally open) and N.C. (normally closed) output contacts. (1 included)

Maximum of 5 relay modules for a total of 10 programmable cams.

Programmable CAM with degree to degree or degree to time programming.

CAM response up to 500 SPM.

Settings stored in die memory for each customer die.

Contact Rating: 120V AC, 5A

DIE PROTECTION MODULE

8 inputs per module, each input will have a programmable CAM or window operation. Maximum of 2 modules for a total of 16 die protection inputs.(1 included)

Each input will have 9 modes of operation:

- (1) Static N.O.
- (2) Static N.O. in CAM Window
- (3) Cyclic N.O. in CAM Window
- (4) Cyclic N.O. in CAM Window, static N.C. outside the CAM Window
- (5) Static N.C.
- (6) Static N.C. in CAM Window
- (7) Cyclic N.C. in CAM Window
- (8) Cyclic N.C. in CAM Window, static N.O. outside the CAM Window
- (9) Transfer Operation
- (0) Bypassed

The Command Stamp is designed with 3rd party certification to conform to the requirements of CSA Z142-02.



MAIN DISPLAY MODULE

128 x 64 bit graphic display and rotary encoder mouse for diagnostics and data entry.

Die library will hold 200 customer dies. Memory settings, stored cam settings, die number and palm station setup.

Cam settings, die protection settings, optional feeder settings (for servo feeds only).

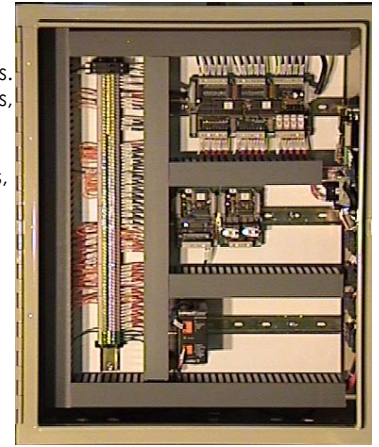
The display will communicate with system modules for die memory recall of settings and module diagnostic information.

Displays alphanumeric part number and 5-digit batch number. Errors displayed in plain English.

Input Diagnostic Screen for quick troubleshooting.

Will hold all counter functions (total count, batch, etc.) and system fault recording.

Power: 120V AC



BRAKE MONITOR / ENCODER

Monitors brake system performance every time brake is applied.

Prevents initiation of a successive stroke if there is an increase in the stopping time beyond preset limits.

Incorporated directly into press control and password protected. RLS/Encoder Assembly: 0.75" keyed shaft; 6 station/cam rotary limit switch, drive check. Pre-wired. Monitors crankshaft position.

ADDITIONAL INPUTS

Motor: Forward and reverse contacts.

Customized Status Codes: 1 for E-Stop, 2 for Top Stop

OUTPUTS

DSV: 4 monitored relays. Rating 5A @ 120 VAC. For emergency and top stopping.

Error/Status Signal: Allows to stop auxiliary equipment.

ENCLOSURE

Controller: 24" x 30" x 10", NEMA 12, includes displays and key lock switch(es). Warranty 1 year parts and labour (drilling holes in top of unit will void warranty)

OPTIONS

• **Operator Station:** NEMA 12, includes 2 Palm Buttons, top stop, continuous and e-stop buttons, palm time and mute indicators. Pre-wired.

• **Dual Safety Valve:** (DSV) 0.75" herion model XSz, [1" or Ross models optional]. Controls airflow to the clutch keyed shaft; 6 station.

• Main Air Pressure Switch

• Counterbalance Air Pressure Switch

• Light Curtain

• Motor Starter Integration

• Pilot Devices

• Complete Installation

FOR INFORMATION CONTACT:

