

CNC BENDER ProControl

now with **TEACH MODE**

FEATURES

PDA Motion
Real-time Variable Gearing

ISSUES

Pressure Die Assist setup can be challenging when performed with manual flow-control valves.

With a non-servo directional valve controlling the PDA, there is lack of perfect synchronization with the bend arm motion.

GOALS

Provide a control system that perfectly gears the PDA motion with the bend arm every time.

Allow the operator to adjust the ratio of motion at any point during bender in real-time in order to better control the flow of material over the dies.

Perfect Pressure Die Assist Motion Control Through Electronic Gearing

PERFECT SYNCHRONIZATION FOR PRESSURE DIE ASSIST

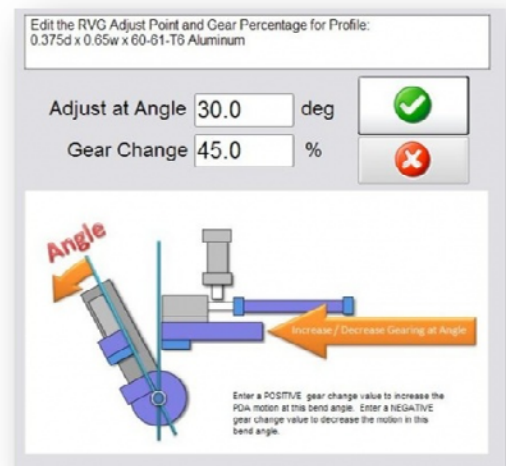
With this feature, unlike non-servo controlled motion, there is virtually zero percent chance for collision between the PDA axis and the bend arm axis during bending. When the bend arm moves - the PDA follows.

It enables real-time perfect following-synchronization between the bend arm and the PDA axis.

When the bend arm accelerates or decelerates, the PDA actuator *also accelerates or decelerates in perfect synchronization*. The PDA axis responds to every small change in the bend axis.

● Powerful RVG = Real-time Variable Gearing

Use the PDA RVG feature to command PDA-to-Bender Arm gear ratio changes in real-time relative to the position of the bend arm.



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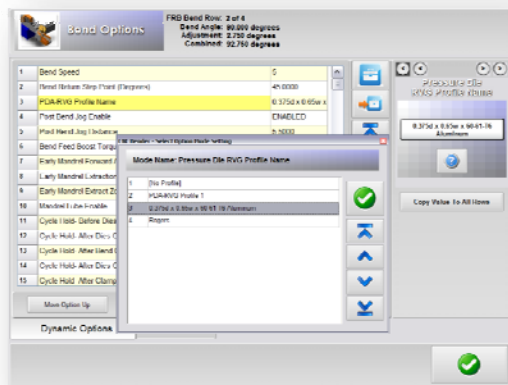


RVG Profile Setup Editor

The RVG profile setup editor screen allows you to enter hundreds of custom RVG setups.

The editor uses a grid interface that can expand to any number of rows of setup data. Each row is an "RVG Profile" that can be assigned to any bend in any row in any bend program.

Profile Name	Adjust Point 1	Adjust Point 2	Adjust Point 3
1 PDA RVG Profile 1	0.0%, 0.0d	100.0%, 45.0d	-50.0%, 90.0d
2 0.375d x 0.65w x 60 61 TB	12.0%, 0.0d	15.0%, 10.0d	25.0%, 20.0d



Unlimited RVG Setup Database

CNC Bender allows you to add any number of RVG Profile setup rows that control how the PDA changes gearing in real-time. There is no pre-set limit.

Up to 20 Adjust Points per Bend

Program up to 20 bend-arm positions per bend to set where the gearing changes. For example, you may want to move the PDA slightly faster at 20 degrees for thin-walled aluminum tubing over mandrel. You could set the PDA gearing at +2% at 20 degrees. This would press more material into the outer section of the bend after 20 degrees of bend.

Easy to Use

It couldn't be any easier to apply an RVG profile to a bend. Select the PDA-RVG option inside any bend options cell, and then choose the RVG profile you want to use from a list of profiles (that you setup in the RVG Setup Editor). It's that simple!

TECHNICAL SUPPORT

We offer our LogMeIn Rescue service to remotely access your CNC Bender computer for tech-support.

KNOWLEDGEBASE

We have an unparalleled web-based knowledgebase that is available to all our customers for details about our products – including revision details and technical documents.

BENDERLINK SOLUTIONS

We can help you integrate CNC Bender to measuring centers of nearly any type. We're known as the Benderlink specialists.

For more information please visit us on the Web at:

www.advancedtubular.com



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