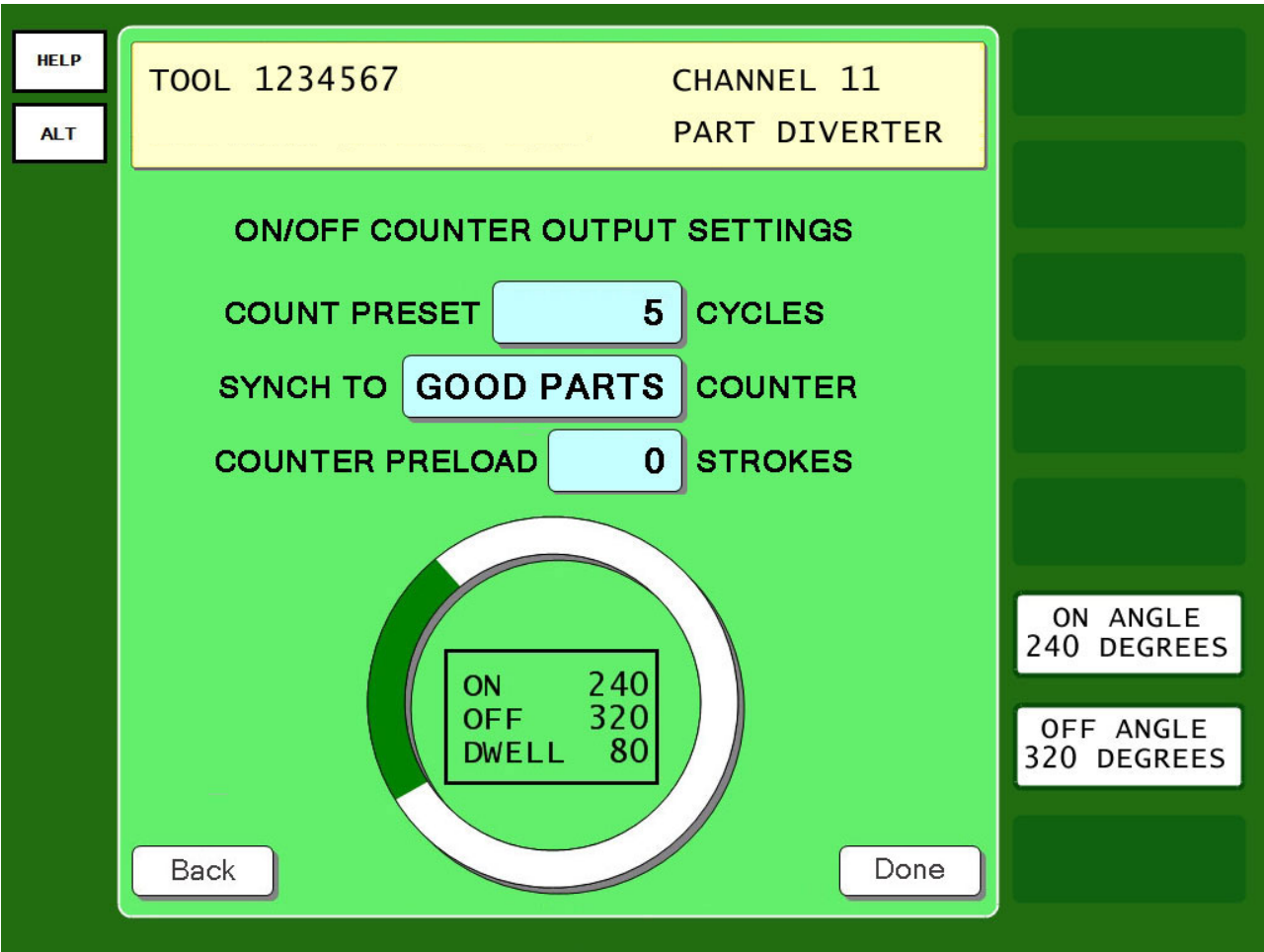


New Features for SmartPAC PRO

Wintriss Controls Group is excited to announce a sweeping new feature upgrade for the SmartPAC PRO ProCamPAC Programmable Limit Switch. These new capabilities transform the humble PLS into a powerhouse capable of providing precise timing signals for your most demanding automation requirements. This upgrade includes five new cam timing logic types, as well as extended capability for existing functions.

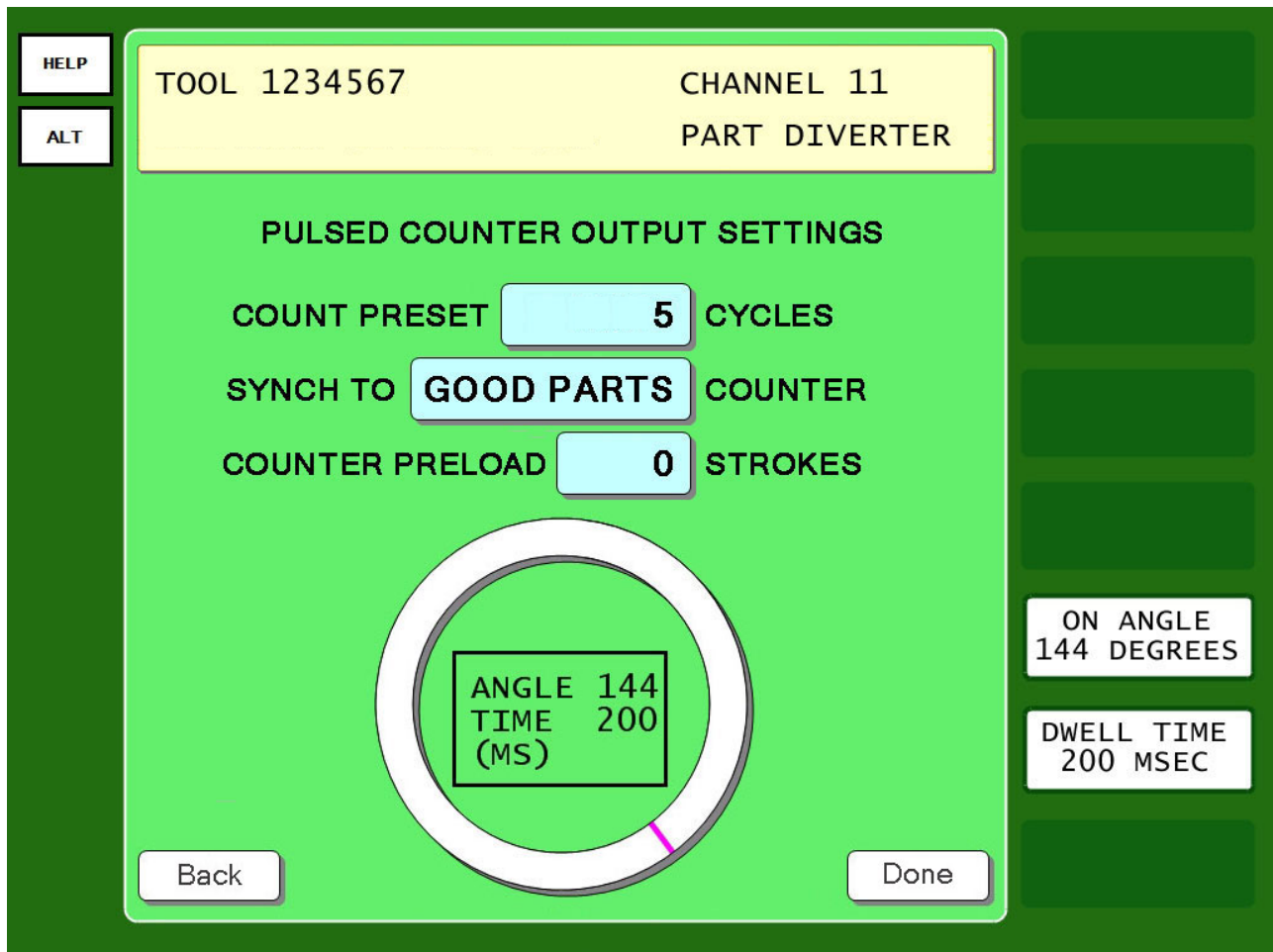
The ON/OFF Counter Cam Type



Settings For The ON/OFF Counter Cam Type

Instead of firing on every cycle, this new cam type will actuate every "X" number of cycles as determined by the preset. This type of output is useful for accurate timing of automation items (such as gagging cylinders) that need to engage only on specific cycles during a precise timing window.

The Pulsed Counter Cam Type



Settings For The Pulsed Counter Cam Type

There is a problem when a conventional ON/OFF output is used to control the delivery of air or lubricant. If the press happens to stop during the timing window, the output will continue to run until the press crankshaft is moved outside of the timing window. The "Pulsed" output prevents this.

The pulsed output type is similar to the ON/OFF type described above, but instead of a timing window that turns ON and OFF at specific angles, the pulsed output turns ON at a specific angle, and turns OFF after a preset amount of time (up to 9999 milliseconds). This output should be used when controlling the delivery of air or oil, or any time you need an output to turn OFF even if the press stops.

The Toggle Output

HELP
ALT

TOOL 1234567 CHANNEL 11
PART DIVERTER

TOGGLE OUTPUT SETTINGS:

ACTIVATION ANGLE DEGREES

SYNCH TO COUNTER

COUNTER PRELOAD STROKES

STAY OFF FOR STROKES

STAY ON FOR STROKES

STAY OFF FOR STROKES

STAY ON FOR STROKES

Cancel More ▾ Exit

ADD A NEW SEQUENCE

Settings For The Toggle Cam Type

The Toggle Cam type turns an output ON for a specified number of strokes, and OFF for a specified number of strokes. The most common use for this output type is to control a parts diverter gate. For example, if 1000 parts will fit in a bin, two bins can be placed side-by-side with a moveable parts chute that can be diverted from one to the other.

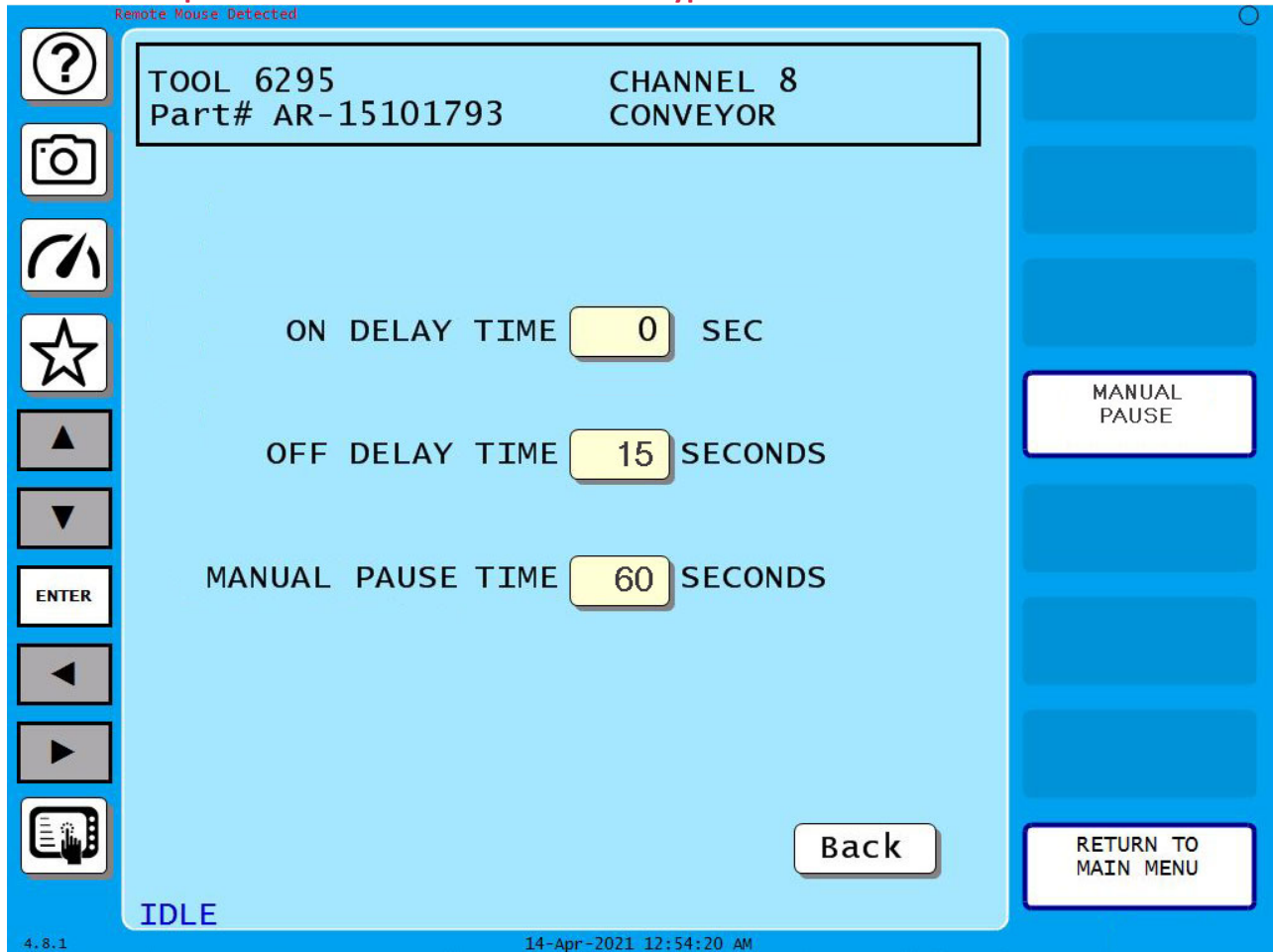
The toggle output would control the diverter, and it would be set to turn ON for 1000 strokes, and turn OFF for 1000 strokes. When one bin fills, the diverter will switch to the second bin, and give the operator time to replace the first (full) bin with an empty one. Since the number of ON and OFF strokes is the same, this is called a symmetrical toggle.

The new cam type is also capable of controlling asymmetrical toggles (with a different number of ON and OFF strokes). You can also program additional sequences to control complex automation such as the gaging operations required on continuous hinge dies and similar parts.

Always ON Cam Type

The "Always ON" cam type is used in applications where an output needs to be present throughout an entire job. This is typically used as an "enable" signal is required for a piece of ancillary equipment, or to control the position of tooling in an automatically configurable die. When the tool setup is loaded, the output will turn on and stay on until a different tool is loaded.

Additional Capabilities for the ON With DSV Cam Type

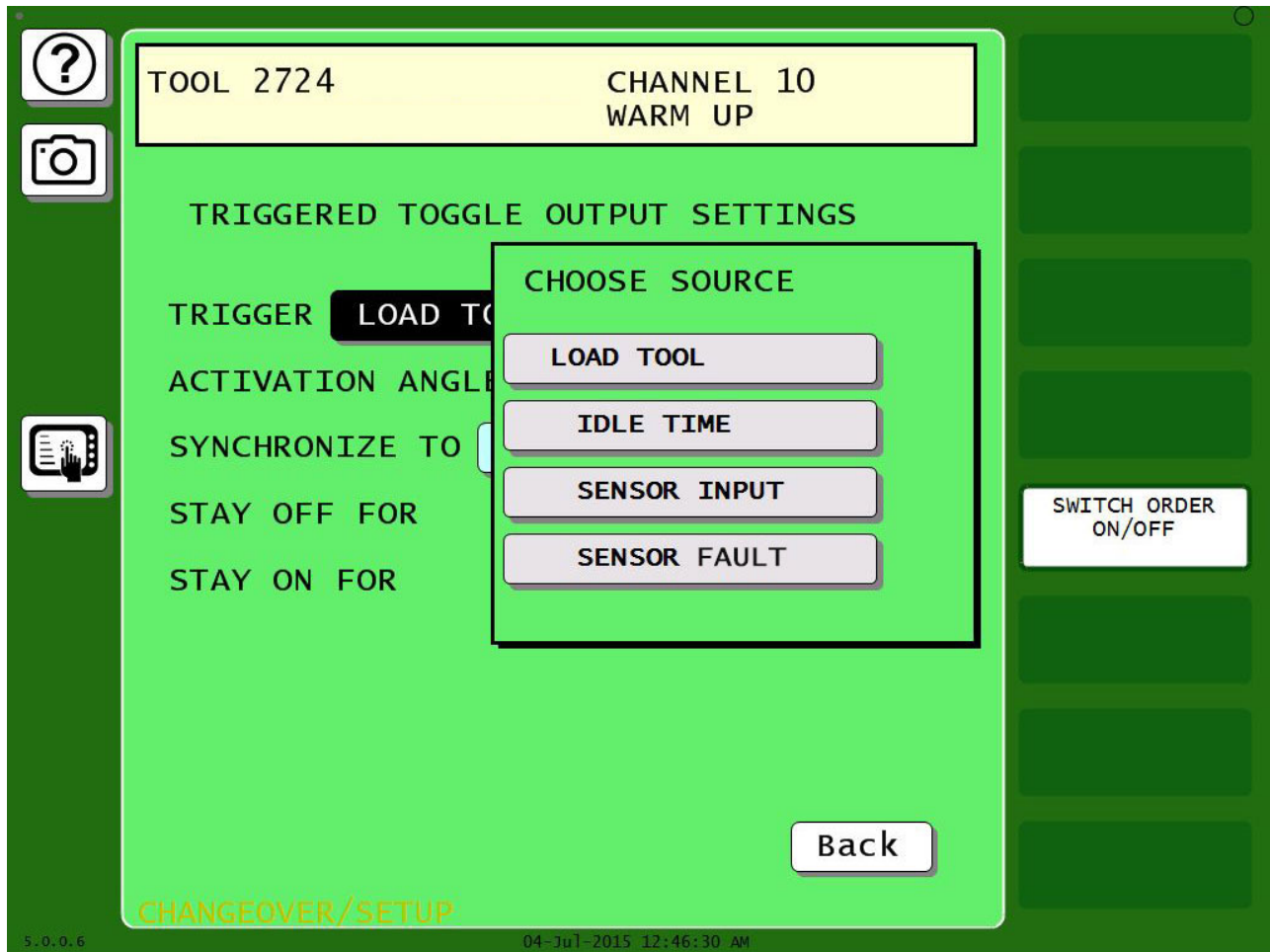


Settings For The ON With DSV Cam Type

The ON with DSV cam type was originally designed for controlling conveyors. The conveyor turns ON when the press starts, and turns OFF when it stops, with an optional timer to delay the OFF for up to 4 minutes. We've added several new capabilities to this cam type. We've included an ON delay timer which works similarly to the OFF Delay, except it delays the actuation of the output for a preset amount of time after the press starts.

We've also added a unique "Pause" function that will temporarily turn the output OFF for a preset amount of time (up to 4 minutes). The purpose of the pause is to briefly stop a conveyor to allow an operator time to switch parts or scrap bins without having to stop the press or deal with parts cascading onto the floor. The pause is initiated manually by the operator, and can either be allowed to time out automatically or the operator can end the pause manually.

Triggered Cam Type



The Triggered Cam Type

This unique output type actuates a precision one-time cam timing signal based on a preset trigger such as an external input from a piece of ancillary equipment, an extended period of machine idle time, a job change, or a sensor fault. The most common uses for this output type will be to divert parts during a warm-up period, diverting parts for QC checks, or diverting bad parts as determined by an outside measuring system.

A triggered channel can be programmed as an ON/OFF, Pulsed, or Toggle cam type. It will actuate one-time (as programmed) whenever it receives the appropriate trigger.

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