

AHS MACHINERY
SERVICE & SALES, INC.
TYLERSPORT, PA (215) 257-0571

PUNCH RETROFIT PACKAGES

FOR MECHANICAL AND HYDRAULIC PUNCHES



Our CNC Control packages can be designed to retrofit virtually any brand or size punch models currently equipped with NC or CNC controls. The packages are completely pre-engineered and designed to be installed in under 40 hours on-site.

INCLUDED IN THE PACKAGE:

- DynaPath 1000P or 2000P control with all these features:
 - 3.5" Floppy Disk Drive
 - 2Gb (Minimum) Hard Disk
 - Interactive Programming Help Screens
 - 12" Color LCD Display
- Custom Operator Panel, Pre-wired
- NEMA 12 Operator Control Cabinet
- Pre-Assembled cables for interfacing panels
- Pre-Assembled and Pre-Wired panel mount for CPU; with simple terminal strip connections for existing machine I/O wiring.
- Field-tested Operational Software. Parameters are preset for your machine.
- All required wire/cable; including new shielded cable for axis feedback, and cable connection hardware.
- **Complete Documentation:**
 - Installation Instructions
 - Operator Manual
 - Programming Manual
 - Maintenance Manuals:
 - Hardware Descriptions
 - Schematics
 - Software ladder listing

FEATURES & BENEFITS

Improved Productivity:

Faster set-ups with automatic tool compensation entry, "Plain-English" menu selection screens, and On-Screen "Dry-Run" plotting.

Uses DynaPath's menu-driven conversational programming.

View your tool path; (before you move any axis or during actual machining).

Multi-Part Nesting Software Option available.

Powerful Conversational Program Events simplify programming: BOLT-CIRCLE, LINEAR, ARC , FRAME, CIRCLE, GRID and ROTATE.

Clamp Relocate Event, with Separate Clamp Move option.

Subroutine and repeat block programming.

Clear and easy to understand Status and Error messages.

Improved Reliability:

Industrial PC Motherboard with 586 CPU.

One Year Warranty on all electrical components.

Fewer parts and standardized electrical hardware; means low maintenance costs and better support - now and in the future.

Flash memory for Exec. Program means software upgrades can be easily installed in the field.

Battery back-up is measured in years, not hours.

Complete & thorough Documentation, Flow charts and Ladder diagrams aid in Troubleshooting.

BUDGETARY PRICING: †

BASIC LOW-COST PACKAGE (complete):

This is a 2-Axis "Bolt-On"⁽¹⁾ package designed to mount on a small Operator-fed Punch which has already been equipped with ball screw feed for a programmable backstop. The package consists of a standard DynaPath 1000P control with (2) 20-in/lb. servo motors with solid-state Drives. The Operator Panel is mounted in a Pendant Control Box. The PLC logic will be custom programmed for your machine, and will support Axis Home and Overtravel Switches, a footswitch Punch Activator, and RAM stroke safety switches. It will work on either Hydraulic or Mechanical Punches. Note: this package is provided with 8 programmable outputs and 16 programmable inputs and is not expandable.

BASE PRICE* \$ 19,800.00

STANDARD PACKAGE (control only):

This is a 2-Axis control package designed to mount on a CNC Punch with part grippers. The package consists of a standard DynaPath 2000P control with (2) axis interface for existing analog controlled drives. The PLC logic will be custom programmed for your machine, and will support Axis Home and Overtravel Switches, a footswitch Punch Activator, Work Clamp and Holder controls, Clamp Interference and RAM stroke safety switches. It will work on either Hydraulic or Mechanical Punches, but does not support a Tool Turret as standard.

BASE PRICE* \$ 22,400.00

OPTIONS TO STANDARD PACKAGE:

Multi-Part (Nesting software)	add	\$ 950.00
Tool Turret Control	add	\$ 1,680.00

AXIS/TURRET DRIVES

20-in/lb. servo motors with solid-state Drive (each axis) <i>(included in low-cost basic package)</i>	add	\$ 2,575.00
Upgrade Axis Motors to 30 in-lb. (each axis)	add	\$ 110.00
Upgrade Axis Motors to greater than 30 in-lb.	call	
Axis/Turret Feedback Encoder (each)	add	\$ 650.00

(1) Motor mounting does not include pullys or couplings. Some modification to machine equipment may be required.

*Prices above do not include installation. Installation can be quoted "Flat-Rate" or Hourly, (at standard AHS Service Rates). If required, Installation includes removal of old control from machine, routing of new wiring, installation of new control and axis encoders, modification of PLC ladder for any special machine features (if required), complete de-bug & testing, operator & maintenance training.

Additional charges for travel and living expenses will be applied for installations over 75 miles from Tylersport, PA.

† Exact Price will be determined only after review of machine, and customer documentation. A formal Thirty-Day Quote will be generated for approval.

FREIGHT:	F.O.B. factory
WARRANTY:	1-Year warranty on all hardware & software, with Service Labor provided by AHS machinery.
TRAINING:	Operator & Programming Training will be quoted upon request.
DELIVERY:	Estimated delivery: 4 to 6 weeks after order, machine down time less than 4 days.
TERMS OF PAYMENT:	25% With Order 60% At Delivery 15% Net 30 Days from delivery

ALL PRICES QUOTED ARE VALID FOR THIRTY (30) DAYS