

THE FACTORY AUTOMATION COMPANY

FANUC

FANUC pressure and position control function

**Advanced control software for
outstanding die cushion performance.**

Available for the following CNCs:

- FANUC Power Motion *i*-A Control
- FANUC Series 30*i*/31*i*-B Control
- FANUC Digital Servo Adapter DSA-B

Advantages of FANUC servo-press solutions

Enhanced control and repeatability

- high accuracy pressure sensor for accurate force control of die cushion
- position and pressure controlled in the DSP in 1ms cycles
- copy working set points from one machine to another and maintain same high degree of accuracy

Less energy compared to hydraulic

- no pump is needed and energy is only consumed when force is applied
- FANUC servo drives regenerate energy and return it to the power source. This is not possible with hydraulic systems.

Sustainable and environmentally friendly

- 100% clean electrical systems without the risk of hydraulic oil leaks

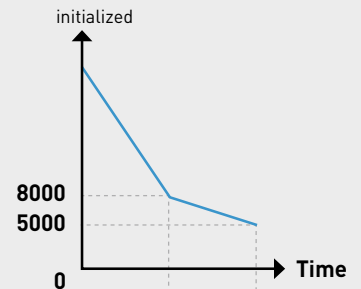
PARALLEL PRESSURE AND POSITION CONTROL

NC PROGRAMM EXAMPLE

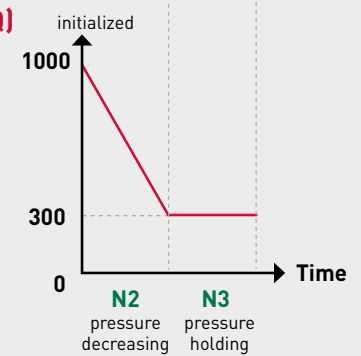
```

N1 G135.4 X0 P1 Q1000 ;      Pressure command initialized
N2 G135.5 X8000 Q300 F400 ;  Move with pressure decreasing
N3 G135.5 X5000 Q300 F100 ;  Move with pressure holding
    
```

Position command (X)



Pressure command (Q)



FUNCTIONS OF THE FANUC SERVO PRESS SOFTWARE FOR DIE CUSHION

