



## ME-660 Control Description

MEI660-SB052715

The ME-660 CNC controls is a state of the art, roll form control system that provides programmable rolling functions with easy to use programming and operation functions for most Farnham Rolls. Using the ME-660 not only do general roll arc but parts as complex as leading edges as well.

The 660 system uses industrial style PAC and part recipes format to roll parts repetitively and accurately. It utilizes the existing AC motors that are generally used on existing machine as well as the roller motor. Position feedback devices and a pneumatic back gage system are added to the machine and controlled by a dedicated PAC control system

Programming is performed by entering in the sheet position and the desired amount for depth for each point up to 32 total points.

Below are the features the ME-660 provides.

### Hardware:

- New CPAC PLC system for axis and machine control
- New operator console and motion PB interface
- 3 AC inverters installed to control the position and feed of the rollers and press.
- New Analog in/out and head transducers
- Enhanced machine diagnostics screens and PLC Monitoring
- Weidmann industrial control console
- Encoder Feedback system for roller speed and position.
- New back gage brackets to locate parts during roll operations.



Specification MEI660-SB052715



## Software:

- Customized HMI operator interface
- 32 programmable points for roll operation per program
- 200 Total part program storage.
- Graphic machine setup page
- 3 modes of operation. Manual, MDI, and Automatic
- Alarm Screen
- Calibration screen for easy machine setup and calibration
- Diagnostics Screens for PAC
- Settings screen for machine parameters

## Operator Console Controls:

- Machine On
- Machine Off
- Reset
- Mode Select
- Cycle Start
- Cycle Stop
- Load
- Unload
- Roll jog forward/reverse
- Left head jog up and down
- Right head jog up and down
- Both heads jog up and down
- Emergency Stop
- Alarm Indicator



*Figure 1 Pushbutton Layout*

## CNC Control Screens:

- Program/Save Load Screen
- Automatic Operation Screen
- MDI Operation Screen
- Manual Operation Screen
- Machine Control Parameters Screen
- Part Program Edit Screen
- Diagnostic Maintenance Screens
- Machine Setup Screen

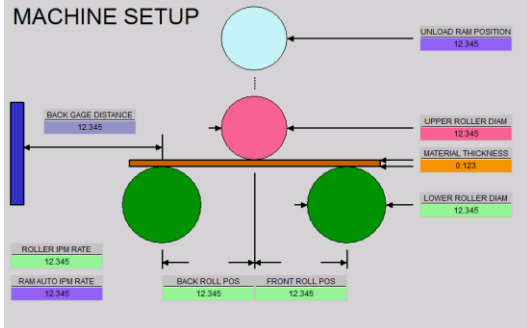


Figure 2 Machine Setup Screen



Figure 3 Program Load/Save Screen

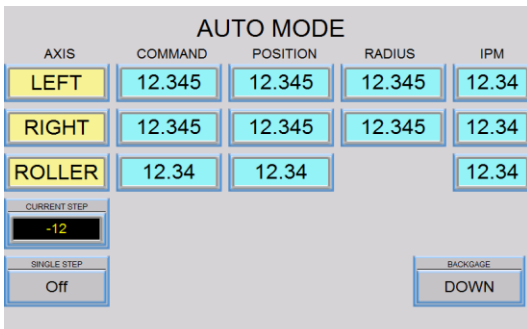


Figure 5 Auto Mode Screen



Figure 4 MDI Screen

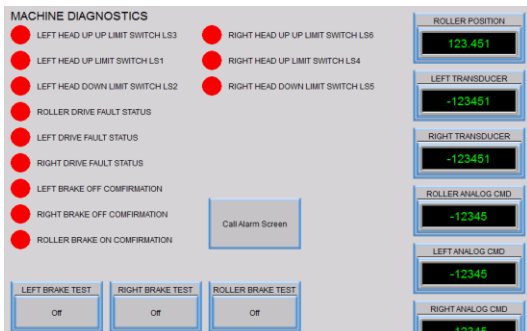


Figure 7 Machine Diagnostics Screen

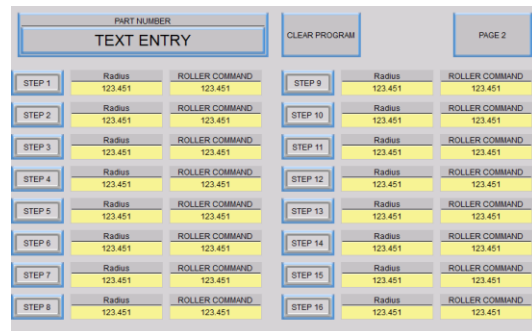


Figure 6 Part Program Entry Screen