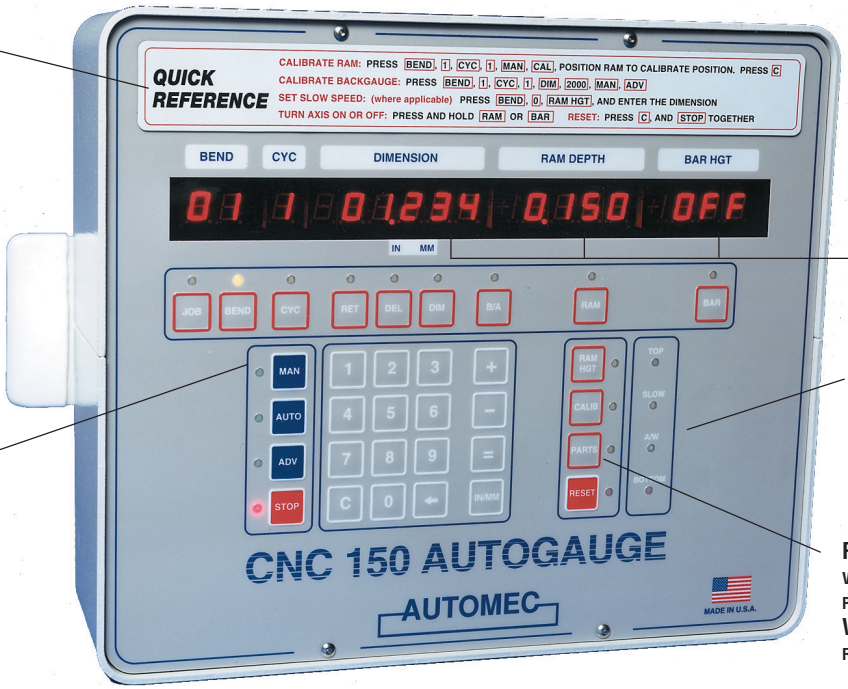
CNC 150 AUTOGAUGE CONTROL

THE SIMPLE ALTERNATIVE

CALIBRATION INSTRUCTIONS ARE PRINTED RIGHT ON THE DISPLAY FOR EASY RECALL.



3 SEPARATE DISPLAY WINDOWS MEANS UP TO 3 AXES CAN BE DISPLAYED AT THE SAME TIME.

LED INDICATORS MONITOR SYSTEM FUNCTION.

VELVET-LEXAN FRONT PANEL FEATURES HIGH-FEEDBACK TACTILE FEEL PUSH KEYS.

PARTS COUNTER CAN BE VIEWED BY MOMENTARILY PRESSING ONE BUTTON. WHEN RELEASED YOU RETURN TO THE PROGRAM.

FEATURES

- **Incremental Corrections**–dimensions can be corrected by adding or subtracting incrementally from the existing dimension.
- **Bend Allowance**–All backgauge dimensions can be offset with one data entry up to ± .393″
- **Ram Depth Mode**–Programmable in inches or millimeters from the flat metal calibration point. On most hydraulic pressbrakes, the top of stroke can be varied from bend to bend and a ram slow down point can be programmed for each job.
- **Ram Offset**–all of the Ram depths can be offset with one data entry up to ± .393″
- **Backgauge Retract/Delay**–Backgauge can be programmed to retract away from the die a specified time and distance to allow the operator time to reposition the workpiece.
- **Backgauge Retract on Pinch Point**–On 2-axis hydraulic brakes this feature allows you to program the backgauge to retract once the workpiece is pinched in order to clear reverse bends. Both time and distance of retract can be programmed separately for each bend.
- **Self Diagnostics**–error codes appear for programming mistakes or system malfunction.

TECHNICAL SPECIFICATIONS

Up to 11 digit part numbers can be assigned

150 jobs (00 to 150)

20 bends per job

Cycles – up to 9 per bend

Programmable delay/retract between bends (0-9 sec.)

1, 2 or 3 axis

.001″ resolution

Red L.E.D. display

In/mm conversion

Tactile feel pushbuttons

30 day battery back-up

Input power – 115 VAC ±10% 50/60 HZ, 7A MAX

Width 15″ x Height 11″ x Depth 4″

Weight 10 lbs.

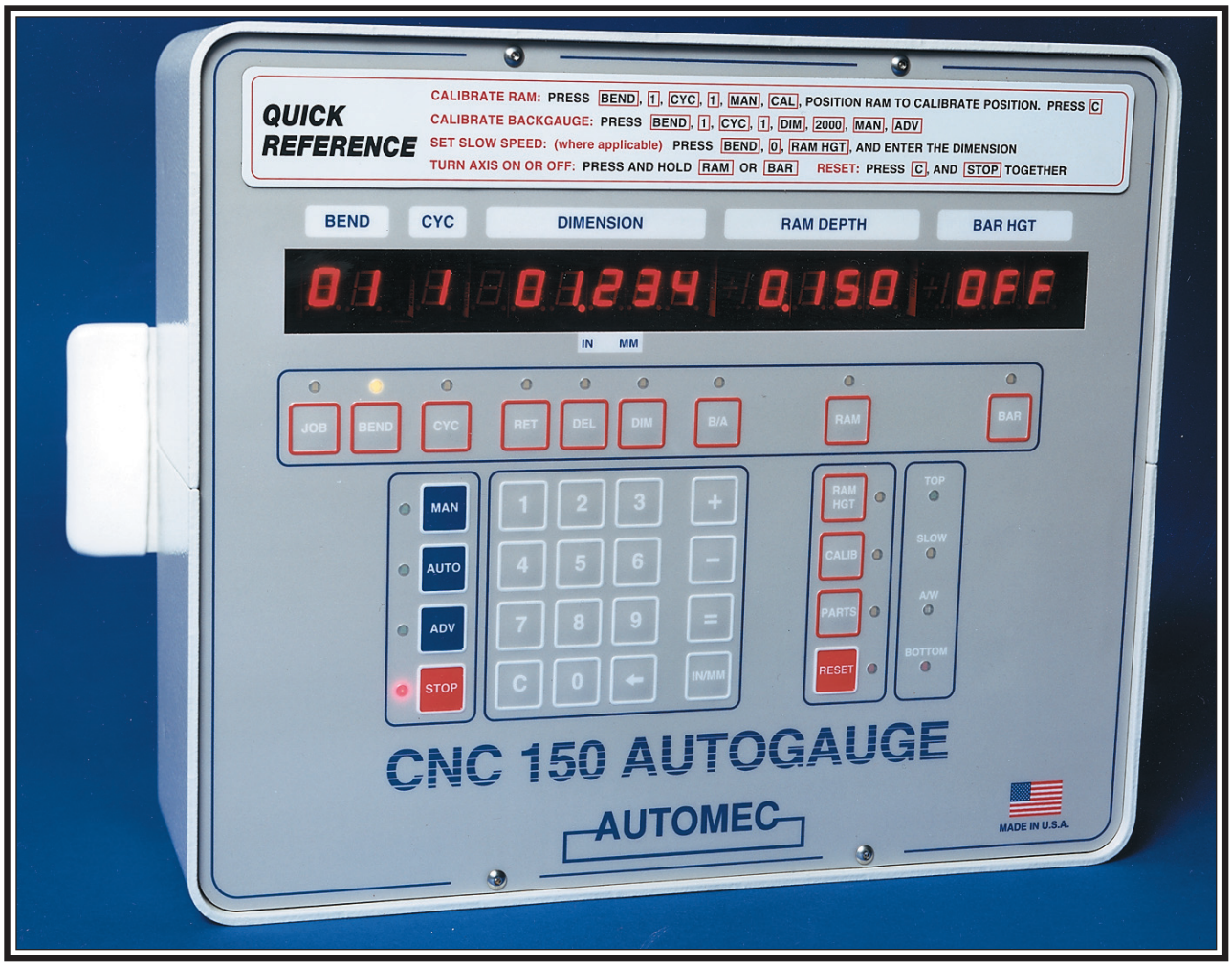
AUTOMEC

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CNC150 AUTOGAUGE



CNC150 is an economical, simple-to-use control that incorporates the most popular features used in our 30-plus years experience in the pressbrake backgauging business.

CNC150 will control any of the Automec backgauge configurations as either a 1-axis (backgauge), 2-axis (Ram Control) or 3-axis (programmable gauge bar height).

(See reverse side for specifications)

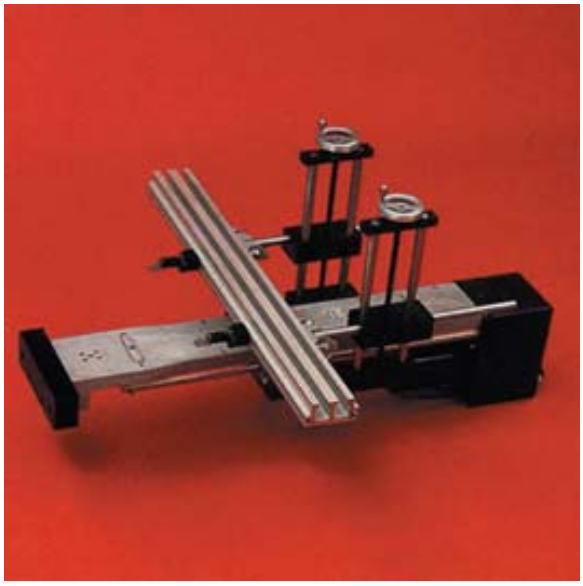
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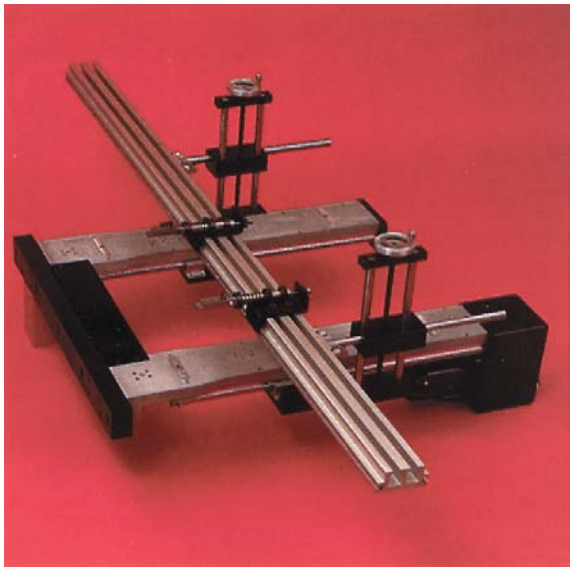
G24 SERIES
24 ″ TRAVEL AUTOGAUGES

The G24 series is designed for applications where 24″ of front to rear travel is desired. Each system features Automec's DC motor drive which is backed up by an electro-mechanical disc brake once the backgauge reaches position. This drive system is known for its high reliability and holding force.



MODEL	A
Holding Force	200 lbs.
# of Drives	1
Weight	200 lbs.
Overall Heigh	26″
Overall Dept	42″
Overall Width	16″
Gauge Bar Length	3′
Positioning Speed	600 IPM
Gauge Travel	24″
Repeatability	±.002″
Vertical Height Adjustment	10″
Recommended Width	Up to 4′

The A compact gauge for press brakes with 12″ to 42″ between sideframes. This unit is available with a 3′ gauge bar for light applications.



MODEL	BP	HD/P
Holding Force	400lbs.	
# of Drives	2	
Weight	300 lbs.	
Overall Height	26″	
Overall Depth	42″	
Overall Width	40″	
Gauge Bar Length	7′	
Positioning Speed	600 IPM	
Gauge Travel	24″	
Repeatability	±.002″	
Vertical Height Adjustment	10″	
Recommended Pressbrake Side frame Width	5′ to 8′6″	

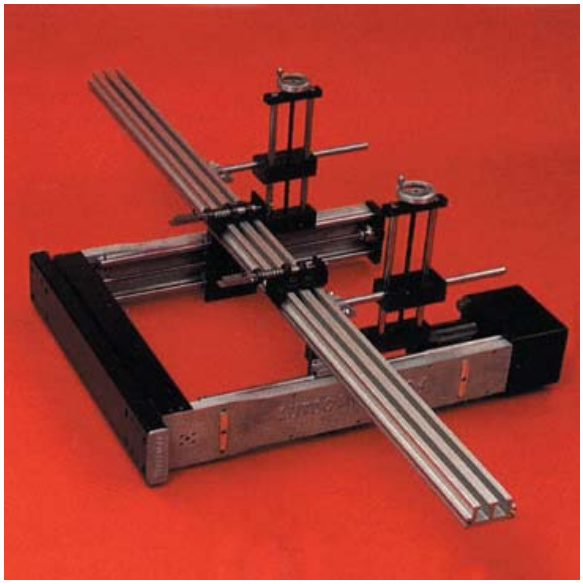
The P models are required for Amada, Promecam, and other brakes in which the rear bed clearance is less than 7″. This low-profile backgauge bolts right to the die rail.

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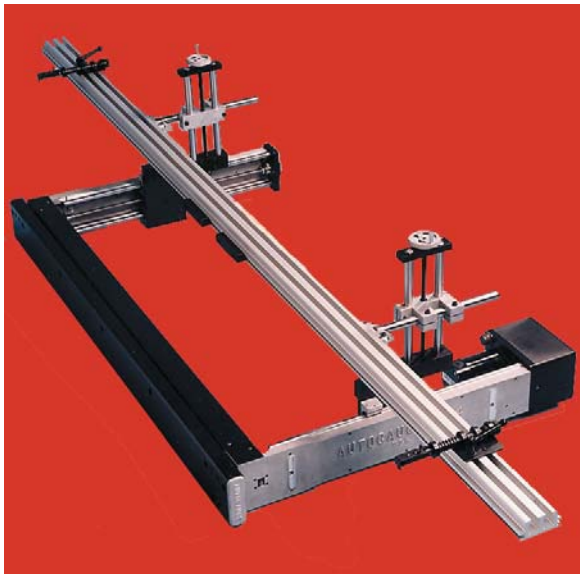
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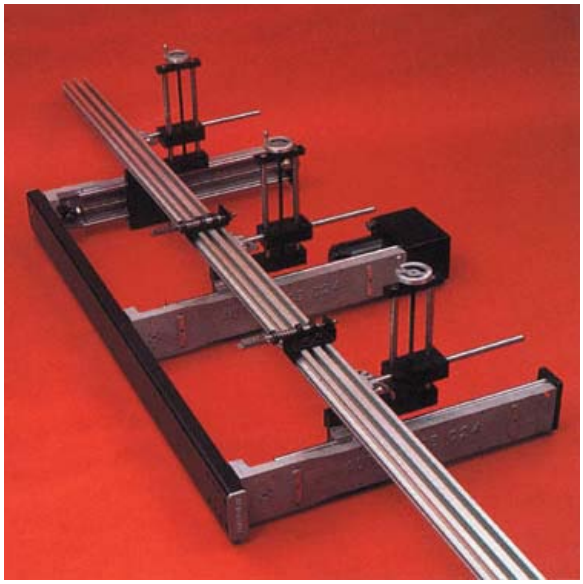
MODEL	B
Holding Force	400lbs.
# of Drives	2
Weight	300 lbs.
Overall Height	26″
Overall Depth	42″
Overall Width	40″
Gauge Bar Length	7′
Positioning Speed	600 IPM
Gauge Travel	24″
Repeatability	±.002″
Vertical Height Adjustment	10″
Recommended Pressbrake Sideframe Width	5′ to 8′6″

The B is Automec's most popular model. Ideal for pressbrakes with up to 8′6″ between the sideframes.



MODEL	HD
Holding Force	400lbs.
# of Drives	2
Weight	300 lbs.
Overall Height	26″
Overall Depth	42″
Overall Width	77″
Gauge Bar Length	11′
Positioning Speed	600 IPM
Gauge Travel	24″
Repeatability	±.002″
Vertical Height Adjustment	10″
Recommended Pressbrake Sideframe Width	9′ to 14′

The HD heavy-duty offers more rigidity for larger pressbrakes or when progressive die set-ups are used.



MODEL	TD
Holding Force	600lbs.
# of Drives	3
Weight	450 lbs.
Overall Height	26″
Overall Depth	42″
Overall Width	148″
Gauge Bar Length	18′
Positioning Speed	600 IPM
Gauge Travel	24″
Repeatability	±.002″
Vertical Height Adjustment	10″
Recommended Pressbrake Sideframe Width	over 14′

The TD has 3 drive screws with the center drive flanked by 2 drives 6′ away on each side. Designed for large bed pressbrakes.

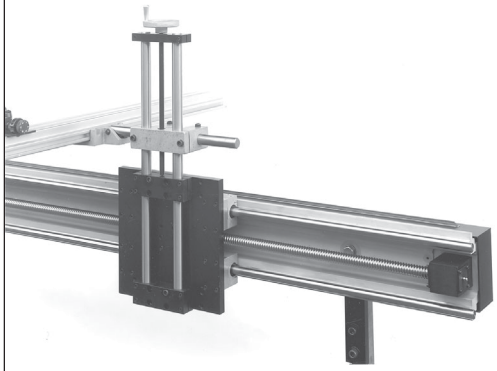
AUTOGAUGE G48 PLATE GAUGE FOR HEAVY FORMING

EXTRA SAVINGS BECAUSE HANDLING PLATE IS MORE LABOR INTENSIVE THAN SHEET METAL

The G48 offers significant productivity improvement because handling larger, heavier workpieces often involves 2 or more operators and material handling equipment. Although these handling methods may still be employed, once the workpiece is maneuvered to the bending die it can be sequenced through the bends as the backgauge repositions on each ram cycle.

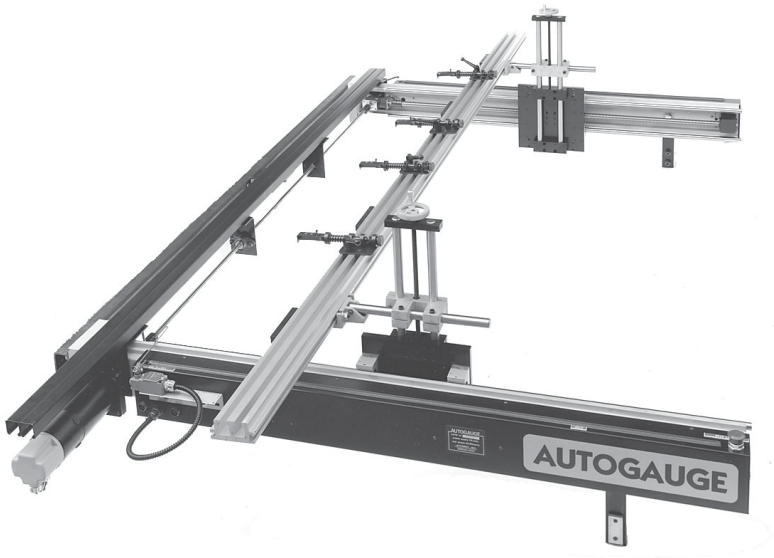
TIME SAVINGS EVEN ON SINGLE-BEND WORKPIECES

Considerable time is involved setting a manual backstop for a solitary bend on plate. The stop must be very rigid and making changes on such a bulky apparatus is time consuming. Some operators resort to layout and scribing which is equally time consuming. The G48 lets the operator punch in the dimension and bend in seconds.



49″ TRAVEL FILLS A VOID ON LARGE FLANGE SHEET METAL APPLICATIONS

Traditional 24″ travel backgauges prohibit deep flanges on some workpieces. The G48 opens that range up to 49″.



TECHNICAL SPECIFICATIONS

DUAL DRIVE		TRIPLE DRIVE	
Recommended press brake width (Between side frames)	96″ to 144″	Recommended press brake width (Between side frames)	144″ to 288″
Tilting gauge bar	std.	Tilting gauge bar	std.
No. of drive screws	2	No. of drive screws	3
Gauge height adj.	12″	Gauge height adj.	12″
Gauge travel	49″	Gauge travel	49″
Gauge speed	600″/minute	Gauge speed	600″/minute
Resolution	.001″	Resolution	.001″
Repeatability	±.002″	Repeatability	±.002″
Workblocks supplied	4	Workblocks supplied	4
GF-8 flip fingers supplied	4	GF-8 flip fingers supplied	4
Horizontal calibration adjustment	16″	Horizontal calibration adjustment	16″
Holding force	400 lbs.	Holding force	600 lbs.
Std. gaugebar length	11’	Std. gaugebar length	18’
O.A. Width	84″	O.A. Width	168″
O.A. Height	32″	O.A. Height	32″
O.A. Depth (front to rear)	75″	O.A. Depth (front to rear)	75″
Gauge bar shock mounts	std.	Gauge bar shock mounts	std.
Rear support legs	std.	Rear support legs	std.
Shipping weight	590 lbs.	Shipping weight	750 lbs.

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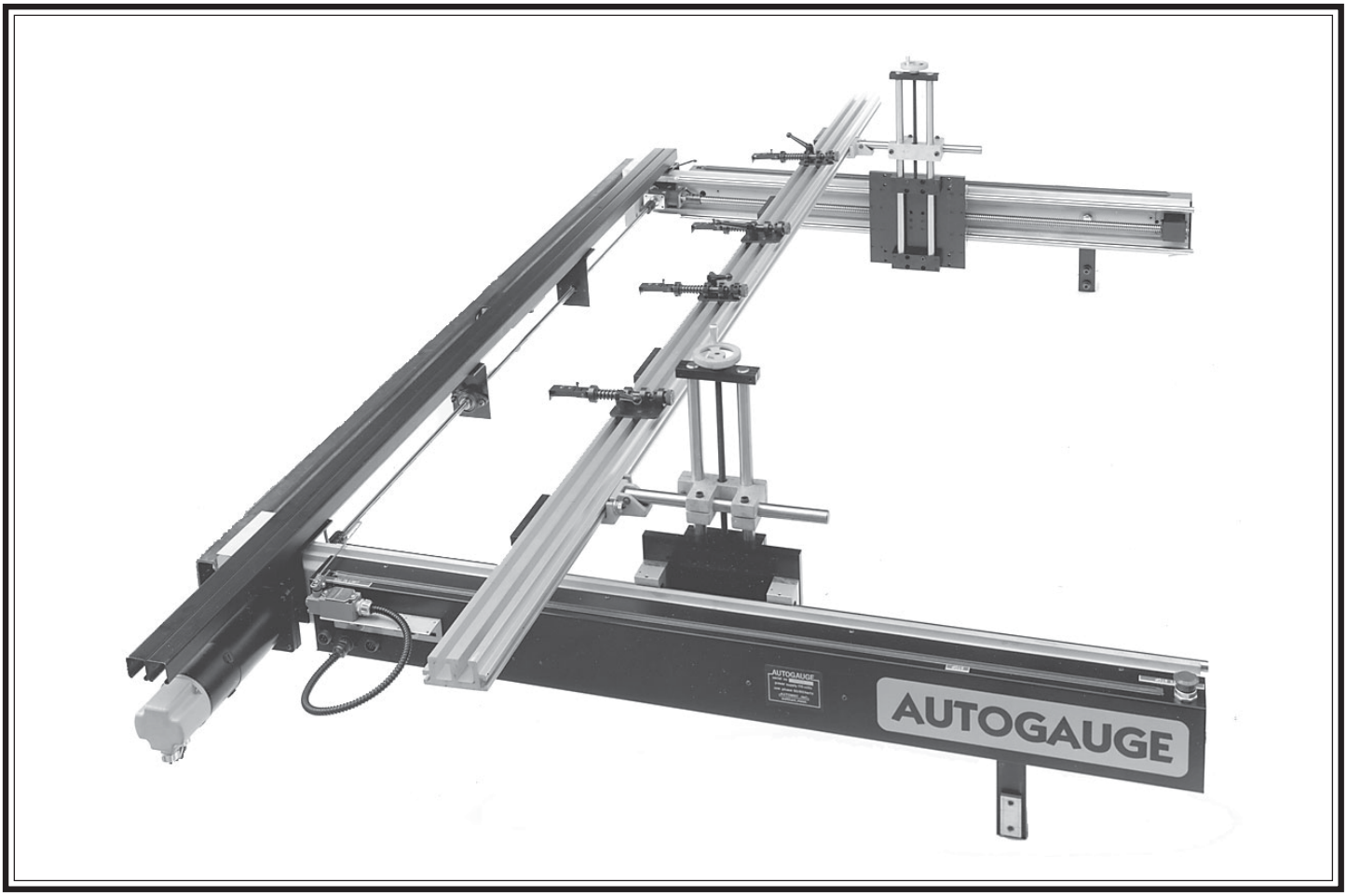
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AUTOGAUGE G48

PLATE GAUGE FOR HEAVY FORMING



Programmable backgauging for pressbrakes has always offered impressive productivity savings for medium and short runs on light sheet metal. Now, the G48 for Pressbrakes brings those same savings when forming heavier materials.

(See reverse side for specifications)

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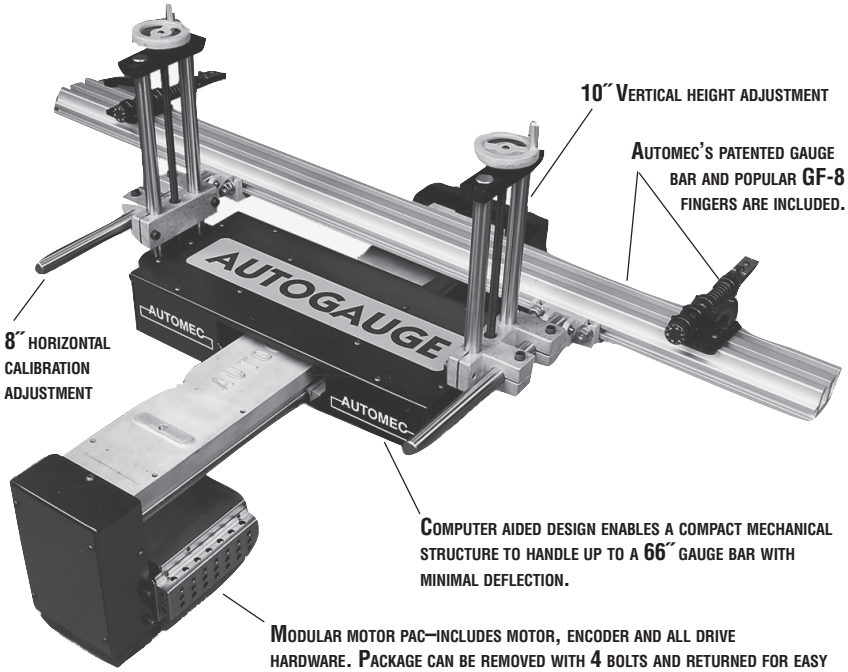
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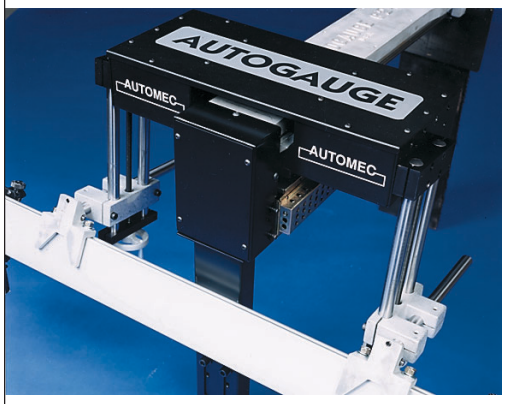
AUTOGAUGE MB for SMALL to MEDIUM APPLICATIONS

MINIBRUTE

Offers quick set-up and sequential backgauge positioning for brakes with 3´ to 8´6˝ between the side frames, utilizing up to a 66˝ gauge bar. It is designed for workpieces where 20˝ of front to rear positioning is satisfactory and one operator handles the workpiece. MINIBRUTE is available as a single axis backgauge or a 2-axis with ram control. Consult price sheet for compatible control options.

Video and mounting templates are provided for simple self-installation of single axis systems.





Unique fold-down feature allows the uprights and gauge bar to be swung out of the way for forming flanges exceeding 20˝. A rear support leg is also provided for increased rigidity.

TECHNICAL SPECIFICATIONS

Recommended press brake width (Between side frames)	3´ to 8´6˝	Workblocks supplied	2
Tilting gauge bar	std.	GF-8 flip fingers supplied	2
Fold-down gauge bar	std.	Horizontal calibration adjustment	8˝
No. of drive screws	1	Holding force	200 lbs.
Gauge height adj.	10˝	Std. gaugebar length	66˝
Gauge travel	20˝	O.A. Width (less gaugebar)	31˝
Gauge speed	600˝/minute	O.A. Height	21˝
Resolution	.001˝	O.A. Depth (front to rear)	41˝
Repeatability	±.002˝	Rear support leg	std.
		Shipping weight	260 lbs.

Input power – 115 VAC ±10% 50/60 HZ, 7A MAX

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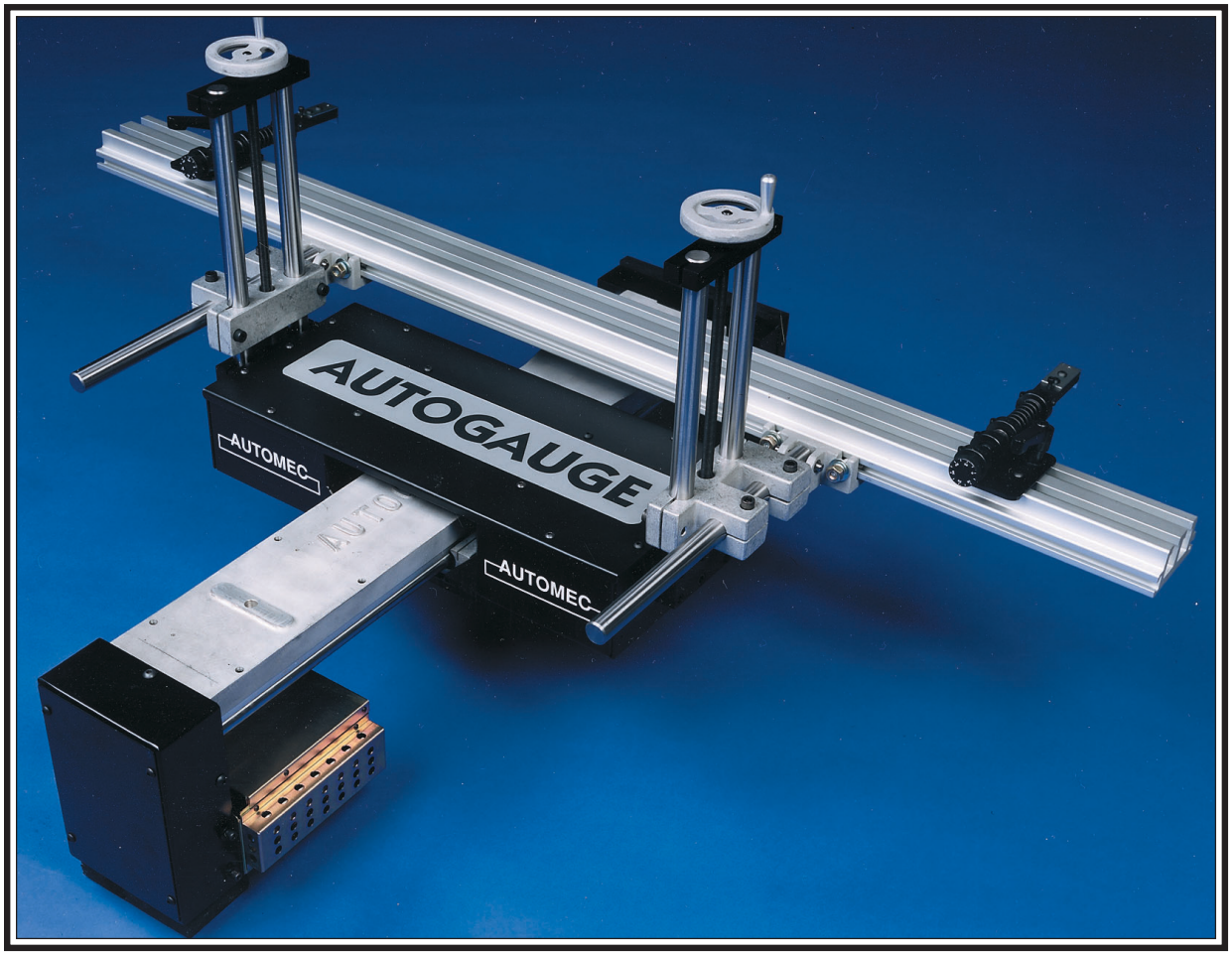
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AUTOGAUGE MB

MINI BRUTE – SMALL BUT TOUGH



Designed to fit on pressbrakes with up to 8′ 6″ between the side frames, the MINI BRUTE offers a compact, rugged solution to pressbrake gauging, where a single operator handles the workpiece. The DC motor driven gauge has 20″ of travel and comes with a 66″ gauge bar.

(See reverse side for specifications)

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