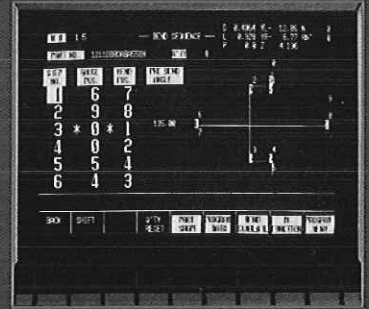
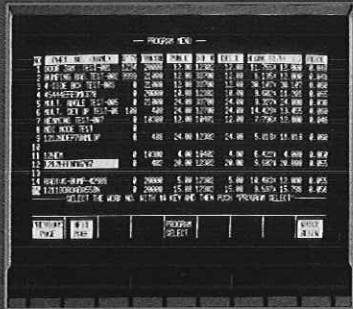


A[®] U.S. AMADA, LTD.

NC9-F

CNC PRESS BRAKE GAUGING SYSTEM



NC9-F

— AXIS POSITION —

D 0.4064 YR 0.928

L 0.928 VL 12.86

YL -12.86 VR 6.77

Z 4.196 ZL 4.196

P₁₀₀₀ 0.0 INSERD TENSE 80.0

OPERATION MODE

ORIGIN C MANUAL AUTO PAUSE FEED STOP

NO READY 2ND X READY POS READY ALARM

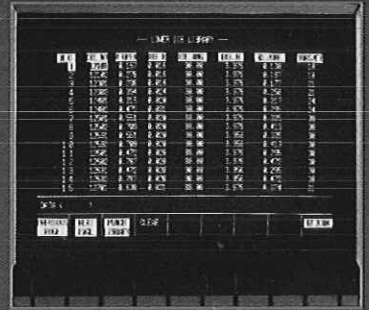
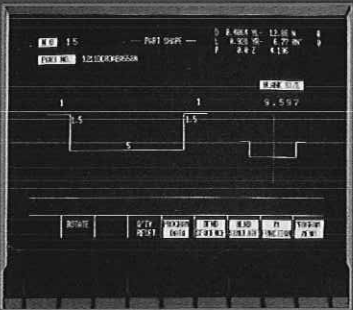
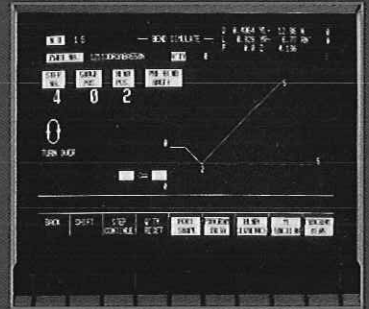
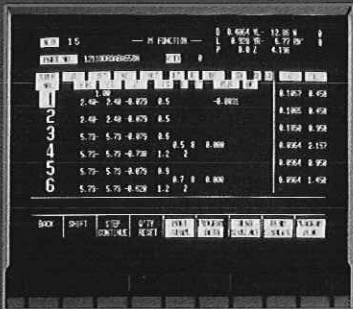
START STOP CHG START CHG STOP

CONFIRM RAM DOWN

7 8 9 4 5 6 1 2 3 0 . -

ALARM CANCEL COPY INPUT

POWER MODE HAND WHEEL EMERGENCY STOP



- Simplified Programming
- Increased Productivity
- DNC Capability



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NC9F

CNC PRESS BRAKE GAUGING SYSTEM

U.S. Amada's NC9F CNC Press Brake Gauging System is the state-of-the-art control which combines Amada's experience and know-how with customer requirements.

The NC9F control is designed to simplify program input and confirmation, reduce set-up time and scrap.

The NC9F control is available on the Amada Fine Alpha Bender series Press Brakes.

FEATURES

- 12" CRT with graphic display allows operator to see product shape and bending sequence.
- Seven (7) Programmable Axis:
 - L-1 and L-2 Axis — Backgauge Positioning
 - D Axis (Depth) — Ram Positioning
 - Y-1 and Y-2 Axis — Horizontal Gauge Finger Positioning
 - Z-1 and Z-2 Axis — Vertical Gauge Finger Positioning
- Automatic entry of the following functions eliminates the need for operator input:
 - Horizontal gauge finger positioning (Y Axis)
 - Vertical gauge finger positioning (Z Axis)
 - Gauge retract
 - Bending speeds
 - Stroke length
 - Backgauge delay timers
- Tool library with 60 punch and 60 dies simplifies tool data entry and allows entry of tooling tonnage limitations for safer operation.
- AC Servo motors on backgauge and ram axis for reduced maintenance.
- Memory capacity of 30 programs, 20 bends per program with a maximum of 300 bends.
- DNC capability with RS-232-C port.
- Help screens to assist operator in machine operation.
- Soft keys simplify programming and reduce key strokes.
- Alpha/numeric part number entry (20 characters).

SPECIFICATIONS

Feed Speeds

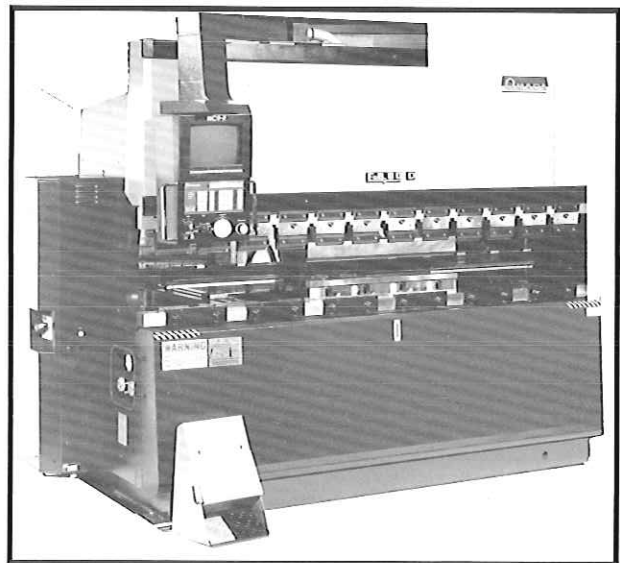
L-AXIS	1181 in./min.
D-AXIS	39 in./min.
Y-AXIS	590 in./min.
Z-AXIS	23 in./min.

Positioning Accuracy

L-AXIS	± .001"
D-AXIS	± .0004"

Movement Range

L-AXIS	0 to 19.685"
D-AXIS	0 to 3.936"
Y-AXIS	Full Length of Gauge Bar
Z-AXIS	5.9"



FBD-8020 Equipped with NC9F Control