

ATS 565

Low-cost
CNC-control for
synchronized press brakes



ATS 565:
Fast and reliable machine control for synchronized press brakes

Y1	-4.38	(50.41)	X:	500.0	(609.3)
Y2	-4.38	(50.41)	R:	120.0	(120.0)
TDC	:	72.00	Thickness	:	2.00
Fa SI	:	5.0	Pressure	:	5
AutoUp	:	Yes	Retract	:	No
			Workspeed	:	10.00

Main screen layout

AUXILIARY					
Antideflct	:	100	Type Count	:	No
Fingers	:	up	Pieces	:	--
ToolHeight	:	210.0	Dwelltime	:	0.80
V-opening	:	12.00			

Additional settings

Simple and easy

The **ATS 565** is an easy-to-use press brake control that allows the user to create multiple bending programs by entering a number of steps with a target depth and the desired position of the back gauge.

Optional settings for the depth axis can be assigned per step, e.g. TDC, plate thickness, auto-up function, system pressure and fast/slow point.

The system automatically controls the depth and pressure of the hydraulic axis.

Some features

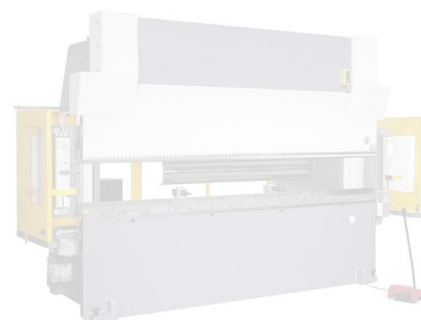
- Graphic LCD display (240 x 64 dots)
- Automatic or manual program execution
- Up to 200 programs / 400 steps
- Absolute or incremental back gauge programming
- Programmable retraction
- Mm or Inch
- Language support
- All logic for machine control on-board (no additional logic or relays required)
- Proportional valve amplifiers on-board
- Digital outputs for direct valve on/off control
- Digital outputs for special functions
- CAN-bus extension (optional)

Low-cost solution

This control is one of the most suitable units when it comes to simple and fast programming of the press brake.

Simple as well as complex work pieces are no problem for this type of control.

An **ATS 565** combined with a low-cost machine results in a highly desirable system with lots of possibilities.



Detailed specifications

Hardware

- Graphic LCD display (240 x 64 dots)
- High-resistant flat front cover with mechanical keyboard
- Outputs for direct hydraulic valve control
- Incorporated proportional valve drive
- All logic for machine control on-board (no additional logic or relays required)
- Proportional valve amplifiers on-board

General control functions

- Automatic or manual bending
- 200 programs and 400 program steps
- Absolute or incremental programming of the back gauge
- Program target depth or pressure
- Programmable speed changeover point
- Programmable Top Dead Centre
- Auto-Up function for automatic beam return
- Programmable beam tilting
- Programmable CNC-controlled anti-deflection
- Programmable retraction
- Backlash compensation
- Jogging
- Mm or Inch units in beam and back gauge positioning
- Programmable limits
- Tool height calibration mode
- Programmable finger height adjustment

Other features

- Workpiece counter (up/down)
- Extra outputs for auxiliary functions
- 20 to 2000 ton machine adaptation via parameters
- Diagnostics and service routines
- Lifelong servicing
- No specific training required

Electrical specifications

(specs may vary in case of extended axes)

- **Power supply:** 24V DC $\pm 25\%$
- **25 digital inputs** (24V DC $\pm 25\%$)
(some are pre-set by PLC function)
 - down-command
 - back gauge limits
 - reference back gauge
 - feedback hydraulic valves
 - etc.
- **25 digital outputs** (24V DC / 1A)
(some are pre-set by PLC function)
 - enable DC back gauge
 - hydraulic valves
 - pneumatic finger control
 - anti-deflection control
 - etc.
- **2 analog inputs** (0 \rightarrow 5 V DC)
(pre-set by PLC function)
 - hydraulic pressure sensor
 - anti-deflection position
- **7 analog outputs**
 - 4 proportional hydraulic valves for position control (current for direct valve control)
 - speed control DC back gauge (0V \rightarrow ± 10 V)
 - 2 proportional hydraulic valve current for pressure control (bending/crowning)
 - analog out for back gauge speed control
- **3 incremental encoder inputs**
(5 \rightarrow 24V DC / 25 kHz)
- **Encoder specifications**
 - open collector / depth axis / +5V power supply
 - push / pull (back gauge) / 5V or 12V power supply
 - no symmetric channels required (A-B-Ref)
 - 1 repulse per revolution/length
- **Electrical connections**
 - easy plug connection
 - according to attached connector layout
 - no special tools or connectors required
- **Optional CAN-extension**
- **Pre-configured for HOERBIGER Easy Control open loop system**



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