

NC Controller

Control unit which manages machine axis motion and tool expansion

- The perfect addition to ensuring honing quality
- Gehring Digital Honing Control unit manages every parameter of the honing data set including machine axis motion, tool expansion and post process gauging
- Pre-programmed controller for the honing, so easy to use. You have to inform cutting parameters you want, not to program
- Up to 100 programme parameter and tool data set
- Display and correction options for all required machine parameters
- Possibility to short stroke for blind bores
- Quick changeover procedure from one component to another
- Data protection via Gehring NCBACKUP program
- Universal application
- Optional In or Post process pneumatic measuring device which automatically update the feed control depending on the final size checked
- Optional Post process pneumatic measuring device which automatically update the feed control and stroke reversing points depending on the final size and shape checked



Control operation functions:

- Quick loading of parameter sets in the memory to reduce changeover time
- Up to 100 setting parameter data sets: honing programmes and operating sequence mode
- Up to 100 tool data sets: honing tool information and wear level. This avoid the work with a worn tool
- One tool is attached to one parameter set, as well, possibility to use the same tool for several parameter sets
- Copy/Paste function for duplicate parameters and save setting time
- Alternative axe for stroking movement with the possibility to short stroke for blind bores
- Fully programmable stroke on speed, acceleration/deceleration at each end of stroke, reversing points with different combination type, unloading position, etc
- Sequence and rotation with optimal surveillance of the speed
- Settable start and end cycle position in order to manage rotation movement in relation to the stroking axe
- Settable loading/unloading position as well the loading/unloading speed
- Global stone feeding management. Speed and size control for approach and retraction speed and values as well for all working feeding curves (up to four different types on expansion speed as expansion step)
- Possibility to switch cutting parameters during the honing cycle as stroke speed, stroke reversing points and speed rotation
- Override special function for improving honing parameters during the process and automatic saving of updated parameters
- Teach special function for quick setting of stroking points and with automatic values saving
- Data protection via password entry for protection from unauthorized and accidental modification of the machine parameters
- Post process pneumatic measuring device (optional) which automatically updates the stone wear depending on final size checked
- In process pneumatic measuring device (optional) which automatically updates the feed control during the process depending on existing size checked in the bore in progress
- Post process pneumatic measuring device (optional) which automatically updates the stone wear depending on final size checked as well manage the stroke reversing points depending the shape checked (compensate automatically taper, bellmouth and barrel default)
- Data protection saving: can be carried out with customer PC and with the optional Gehring NCBACKUP program
- Diagnostic status to and from LCD panel for input/output verification status, encoder position and automatic self diagnostic procedure
- Program errors are automatically detected by the controller and explained in clear messages
- Multiple language available
- Display panel: Gehring BED membrane panel with LCD readout display highly resistant
- Connection for Tele-service as option