



## New Features for the SmartPAC 2 Servo

The SmartPAC 2 Servo uses a linear position sensor to monitor the slide position and saves unique bottom and top return positions for each tool.

The SmartPAC 2 Servo can store information for up to 200 jobs, and features optional programmable limit switches, die protection sensor inputs, and tonnage monitoring.

The SmartPAC 2 Servo can monitor up to ten stages of slide motion. The SmartPAC 2 Servo considers a 'stage' a direction change of the slide, so velocity changes and dwell periods do not consume any of the SmartPAC Servo's available stages.



### **Self Learning**

The SmartPAC 2 Servo has the ability to 'learn' the upper and lower limits for up to ten stages of slide movement per cycle. The operator simply places the SmartPAC 2 Servo into the "learn mode", then runs the machine through a complete cycle. The SmartPAC 2 will automatically store the upper and lower limits for each stage, for each tool. In addition, the SmartPAC 2 Servo will increment the parts counter only after the completion of all stages in a cycle.

### **Ability to "Mask" Cam Outputs and Die Protection Sensor Inputs**

In many applications, it is necessary to activate outputs and/or monitor sensor inputs only during specific stages of a cycle. For example, if it takes several hits in separate stages to produce a part, it doesn't make sense to trigger a part blow-off or try to monitor part ejection until the last stage. The new SmartPAC 2 Servo allows you to operate limit switch outputs and monitor sensor inputs only during the stages where they are required.

### **Selectable Motion Curves**

The SmartPAC 2 Servo features three selectable built-in motion curves for programming programmable limit switch and sensor timing:

- Sinusoidal – This curve most closely approximates the operation of a standard part revolution mechanical power press.
- Proportional – This motion curve most closely approximates the motion of a hydraulic press, with each timing adjustment increment equal throughout the upstroke and downstroke.
- Asymmetrical – There are three variable resolution curves built in to the SmartPAC 2 Servo. These curves are proportional through the top of the stroke, and feature high resolution areas near the bottom. By selecting these curves, you will be able to time limit switches and sensor monitoring widows to resolutions as small 0.001" of slide motion (on a 2-1/2" stroke).