

## A-11 DESCRIPTION

The standard 3 axis controller which comes with our PLE-1212, PLE-1325 and PLE-2030 (2M3M). This controller has preset functions - ideal for new users or those with limited knowledge of speeds and feedrates.

The feedrate is preset before you start the job. You select a certain milling speed for the job - for example 600 mm/min. The machine will attempt to maintain 600 mm/min - except around corners, where it will slow down automatically to avoid drag on the workpiece.

The Spindle speed is preset to one of 8 speeds in 3000 rpm steps which can be manually adjusted at any point during the job by the user - if required.

## A-18 DESCRIPTION

The standard 4 axis controller which is an **option** for our PLE-1325 and PLE-2030 (2M3M). This controller has the same functionality regarding speedrates and feedrates as the A-11

The feedrate is preset before you start the job. You select a certain milling speed for the job - for example 600 mm/min. The machine will attempt to maintain 600 mm/min - except around corners, where it will slow down automatically to avoid drag on the workpiece.

The Spindle speed is preset to one of 8 speeds which can be manually adjusted at any point during the job by the user - if required.

## A-11 SPECIFICATIONS

- 3 axis motion control
- 8 I/O interface board, 9 workpiece origins, and 8 breakpoint /resume storage positions
- Configurable position and speed of tool setting
- HIGH / LOW manual speed switching, fine stepping adjustment and distance setting
- Spindle speed and feedrate are user adjustable during machining
- Supports mobile & fixed calibration
- System alarms for drivers, inverter, E-stop and limits
- Supports array work, mill plane, scale work
- Supports "tool broken" continue, breakpoint resume, and intelligent power failure recovery
- Stop position and status can be set by user

## A-18 SPECIFICATIONS

- 4 axis motion control
- 4th axis can be set as standard axis or rotary axis
- 8 I/O interface board, 9 workpiece origins, and 8 breakpoint/resume storage positions
- Configurable position and speed of tool setting
- HIGH / LOW manual speed switching, fine stepping adjustment and distance setting
- Spindle speed and feedrate are user adjustable during machining
- Supports mobile & fixed calibration
- System alarms for drivers, inverter, E-stop and limits
- Supports array work, mill plane, scale work
- Supports "tool broken" continue, breakpoint resume, and intelligent power failure recovery
- Stop position and status can be set by user

A-11 3-Axis



A-18



## B-51 DESCRIPTION

Advanced 3 axis controller for our PLE-1212, PLE-1325 and PLE-2M3M for experienced technicians. Parameters can be changed, allowing the controller to follow ALL instructions in G-Code, including speedrates and feedrates.

A colour screen displays a visual image of the artwork that shows where the spindle is working during the process. It also allows for smaller adjustments during the work process compared to the A-11. Instead of adjusting spindle speed by 3000 rpm, it allows for increases on a ratio from 0.1 to 1.0 depending on the speed set in the G-Code.

If you set the output spindle speed to 24000 rpm in G-code, the spindle will start with a 1 to 1 ratio (24000 rpm), but if you reduce the ratio to 0.7, the spindle speed will go down to 16800 rpm.

This controller has advanced corner compensation which provides improved performance when doing detailed and intricate work.

## B-58 DESCRIPTION

Advanced 4 axis controller which is an **option** for our PLE-1325 and PLE-2030 (2M3M). This controller has the same functionality regarding speedrates and feedrates as the B-51

A colour screen displays a visual image of the artwork that shows where the spindle is working during the process. It also allows for smaller adjustments during the work process compared to the A-11. Instead of adjusting spindle speed by 3000 rpm, it allows for increases on a ratio from 0.1 to 1.0 depending on the speed set in the G-Code.

## B-51 SPECIFICATIONS

- 3 axis motion control
- 16 I/O interface board, 9 workpiece origins, and 8 breakpoint /resume storage positions
- Configurable position and speed of tool setting
- HIGH / LOW manual speed switching, fine stepping adjustment and distance setting
- Spindle speed and feedrate are user adjustable during machining
- Supports mobile & fixed calibration
- System alarms for drivers, inverter, E-stop and limits
- Supports array work, mill plane, scale work
- Supports "tool broken" continue, breakpoint resume, and intelligent power failure recovery
- Stop position and status can be set by user

## B-58 SPECIFICATIONS

- 4 axis motion control
- 4th axis can be set as standard axis or rotary axis
- 8 I/O interface board, 9 workpiece coordinates, and 8 breakpoint storage/resume positions
- Configurable position and speed of tool setting
- HIGH / LOW manual speed switching, fine stepping adjustment and distance setting
- Spindle speed and feedrate are user adjustable during machining
- Supports mobile & fixed calibration
- System alarms for drivers, inverter, E-stop and limits
- Supports array work, mill plane, scale work
- Supports "tool broken" continue, breakpoint resume, and intelligent power failure recovery
- Stop position and status can be set by user

B-51 3-Axis



B-58

