

Pega 357 With 04PC Machine Programming Limits

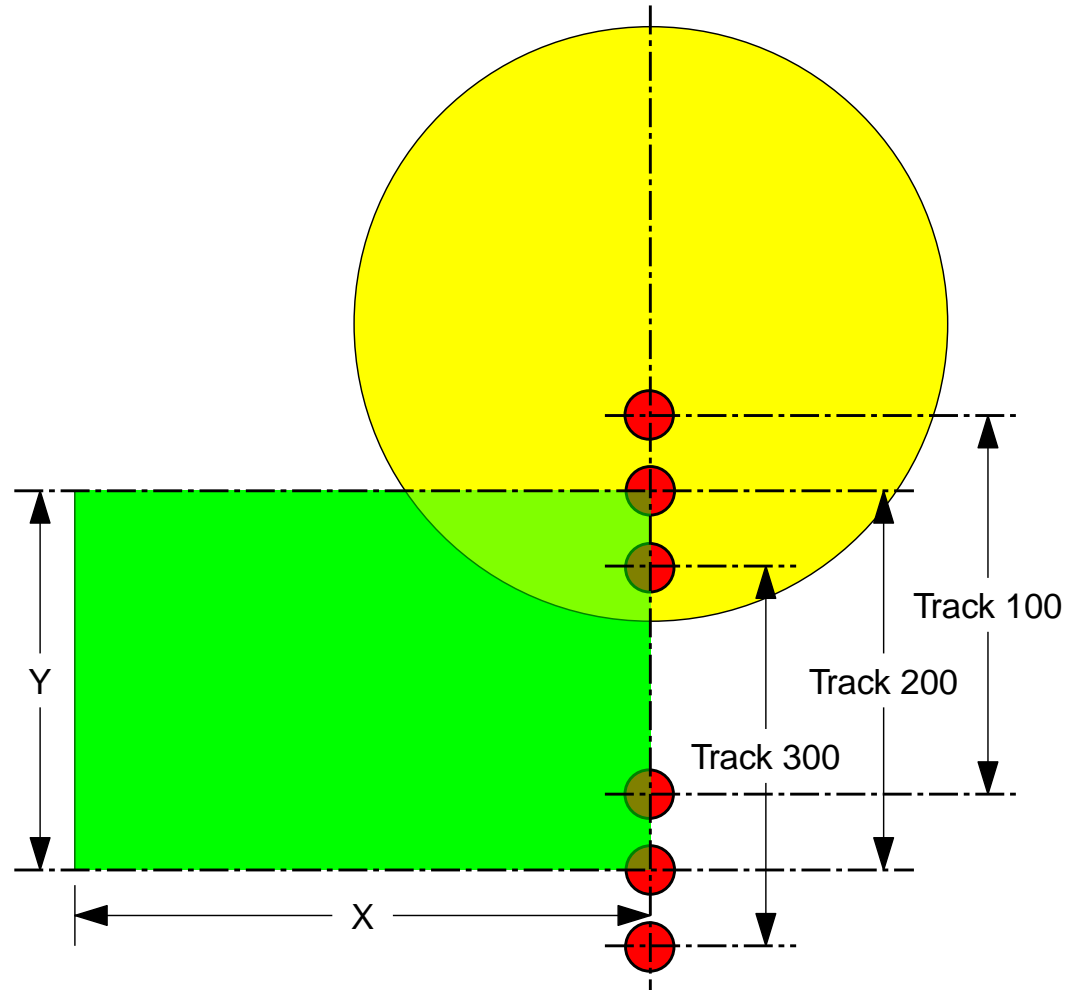


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Programmable Travel Limits



Origin Statement		X-axis Movable Distance	Y-axis Movable Distance By Track Numbers		
			Inner Track 100 Stations	Center Track 200 Stations	Outer Track 300 Stations
X-axis Origin	Y-axis Origin				
72.000"	50.000"	-.400" to 72.400"	1.175" to 51.575"	-.400" to 50.000"	-1.975" to 48.425"

Machine Speeds

Axis Speed in Punching Mode

F1 = X1,968. IPM Y1,968. IPM

F2 = X1,476. IPM Y1,476. IPM

F3 = X984. IPM Y984. IPM

F4 = X492. IPM Y492. IPM

Hit Rate

200 Hits Per Minute on 1" centers

350 Hits Per Minute in Nibble mode

Turret Rotation Speed

30 RPM

Auto Index Speed

Rotation Speed 60 RPM

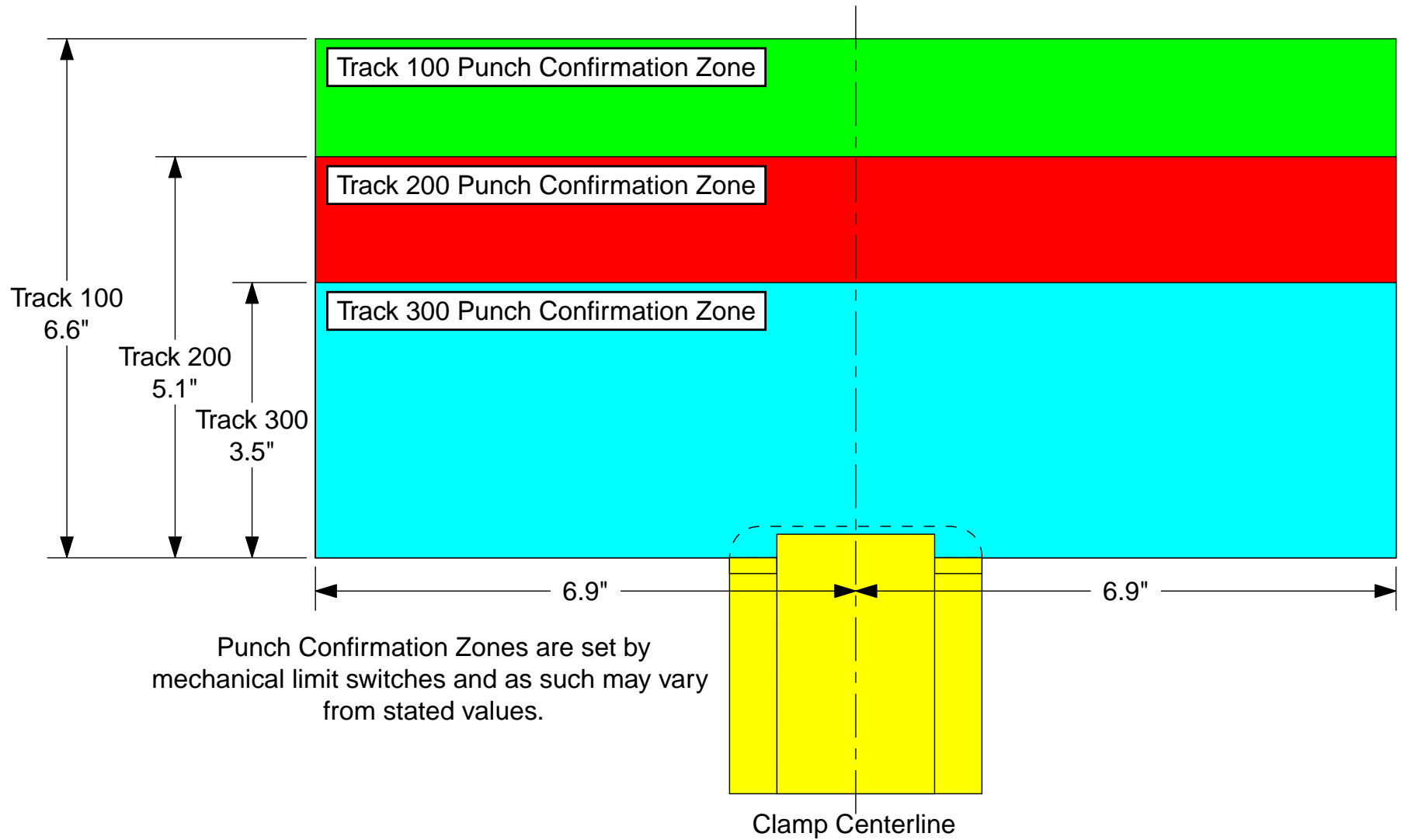
5° maximum rotation in nibble mode

Punch Confirmation Area / Punching Dead Zone.

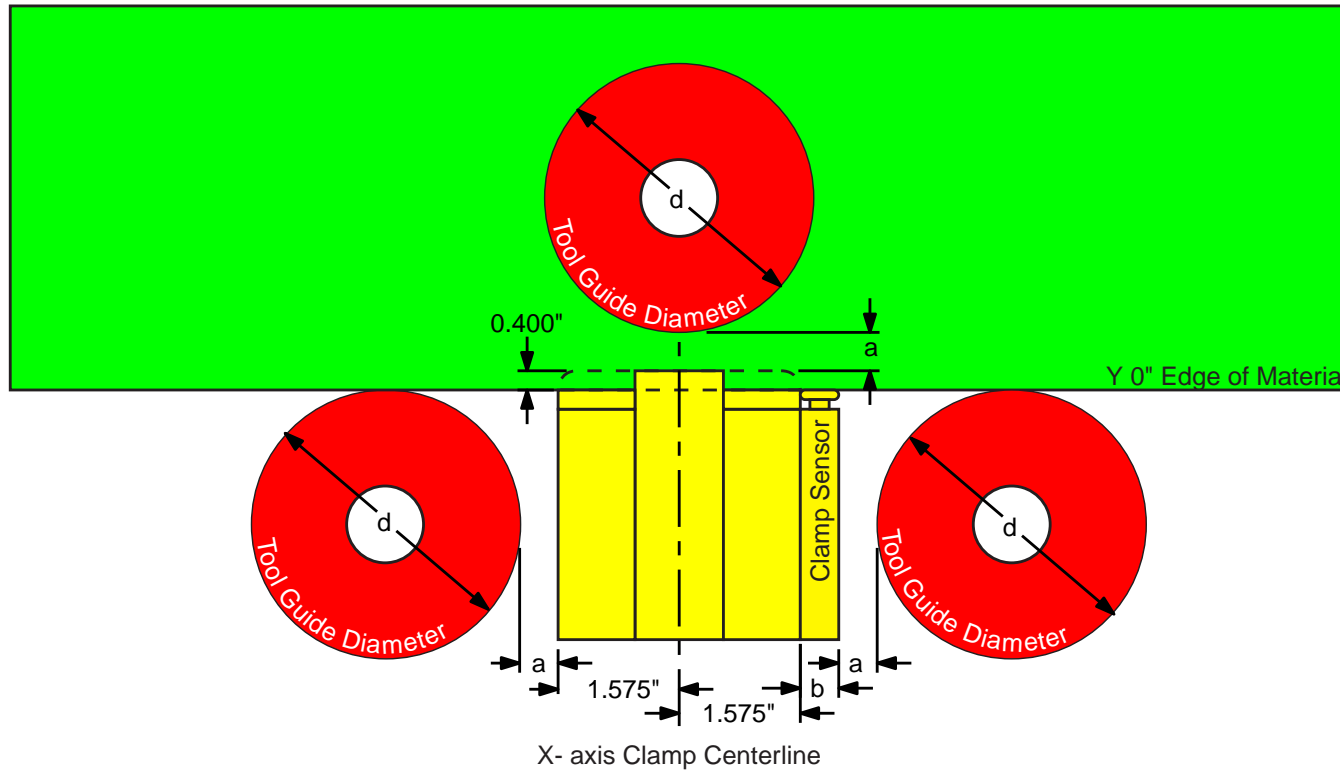
Definitions

- Confirmation Zone = An area that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton.
- Punch Dead Zone = An area within the Confirmation Zone that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton. Punching in this area with standard tools may damage the material, material clamp, tool, other machine components, and may cause operator injury.

Punch Confirmation Area



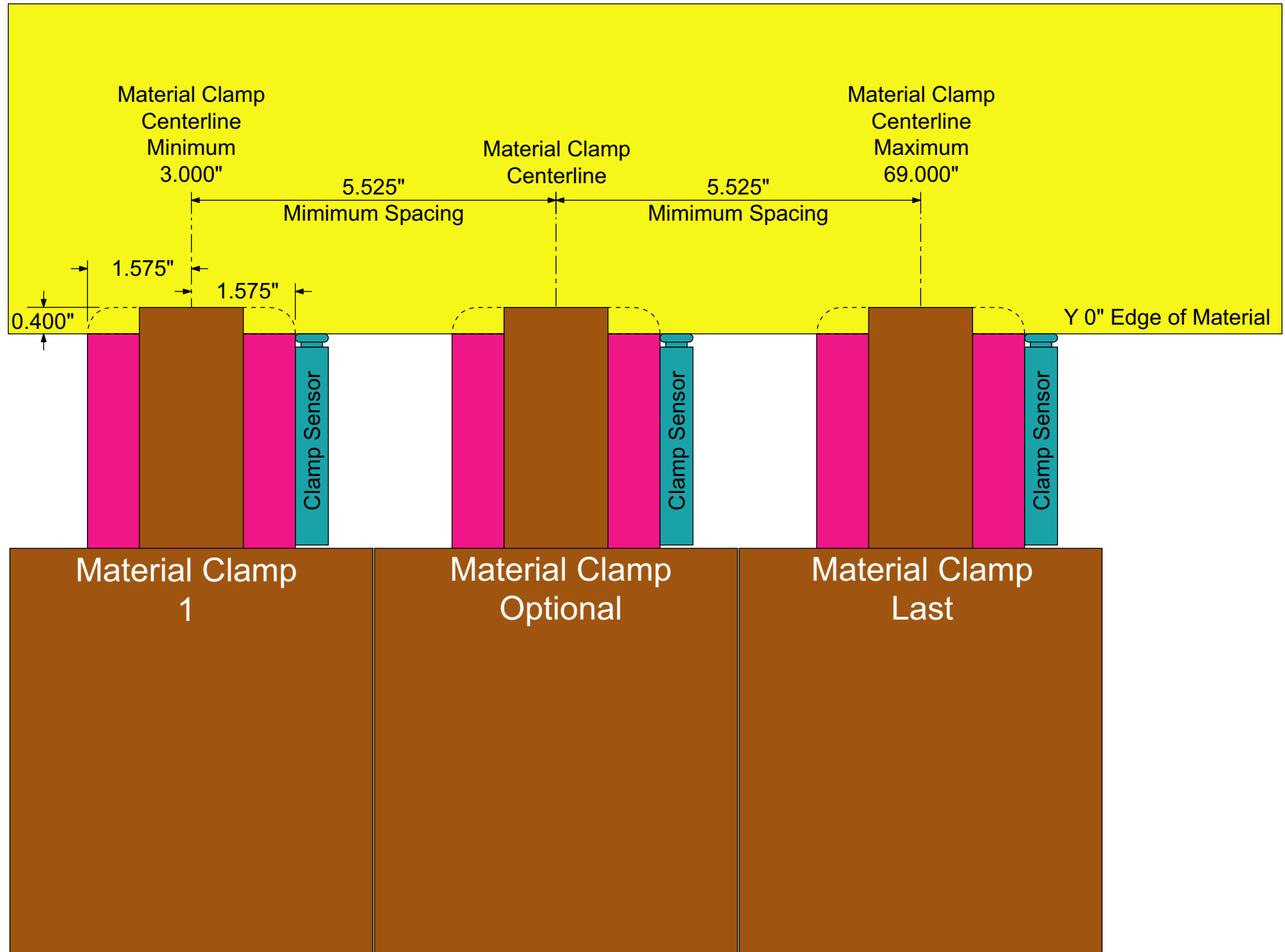
Punching Dead Zone.



Clamp Dead Zones		
"areas where the punch will contact the material clamp" are calculated in the following manner.		
X-axis	To the left of the clamp	Clamp position $-1.575" - a - d/2$
	To the Right of the clamp	Clamp position $+1.575" + a + b + d/2$
Y-axis	$.400" + a + d/2$	

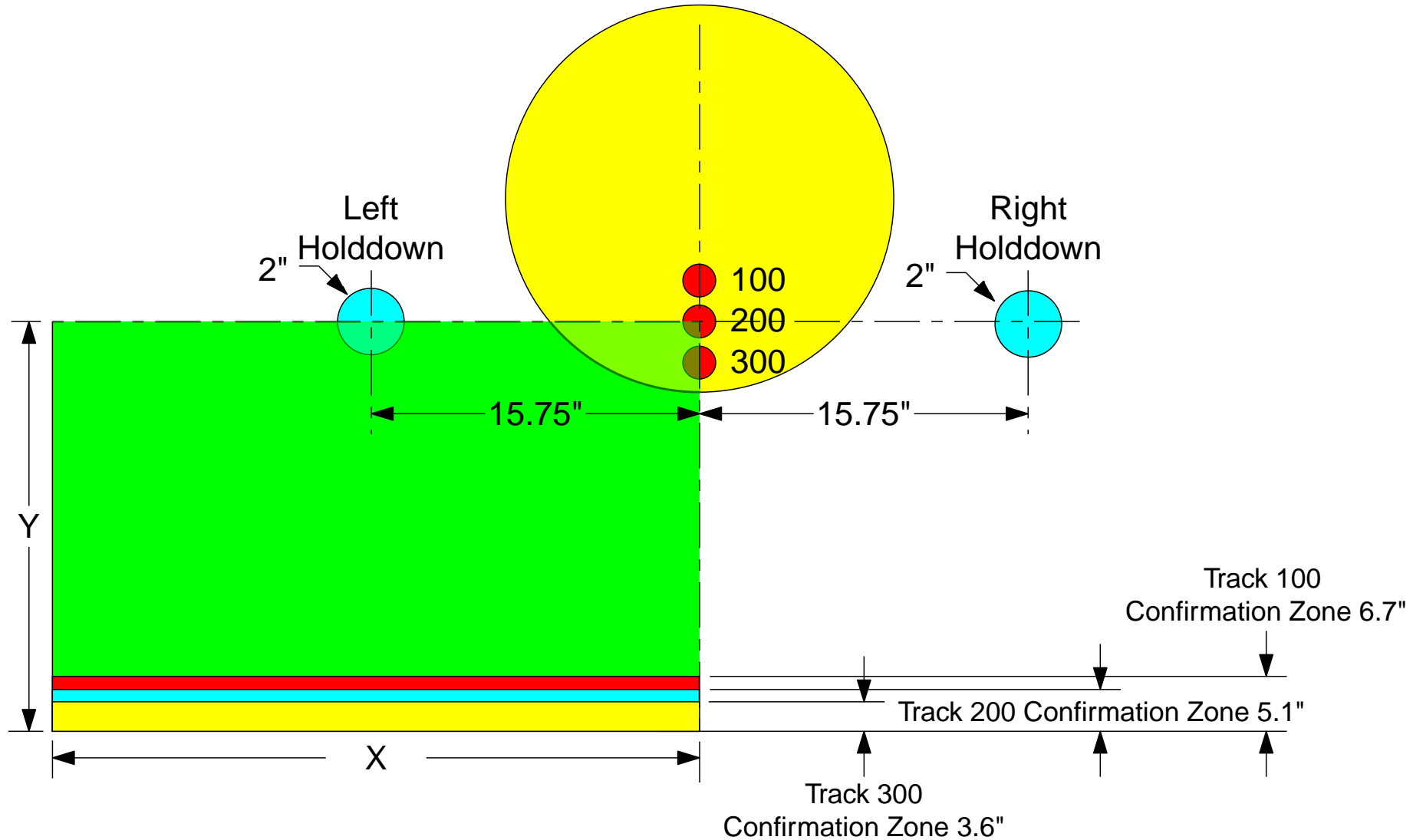
b=	.500"	
a=	.500"	
d=	Station Size A	1.020"
	Station Size B	1.883"
	Station Size C	3.500"
	Station Size D	4.938"
	Station Size E	6.250"

Material Clamp Locations



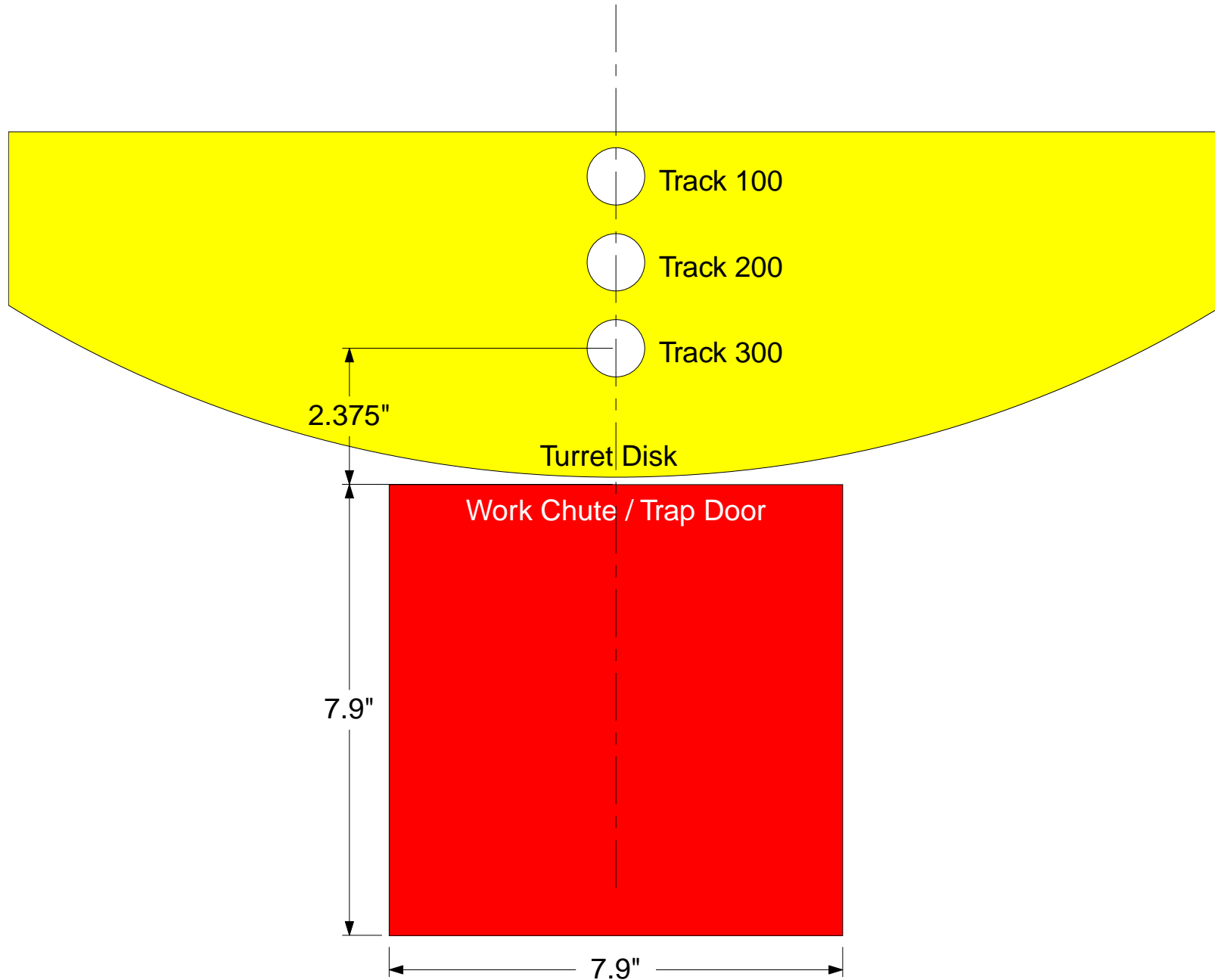
Reposition Limitations

When repositioning within a Confirmation zone the Confirmation Button must be pressed to initiate the reposition cycle, as the material clamps could collide with the repositioning cylinders.



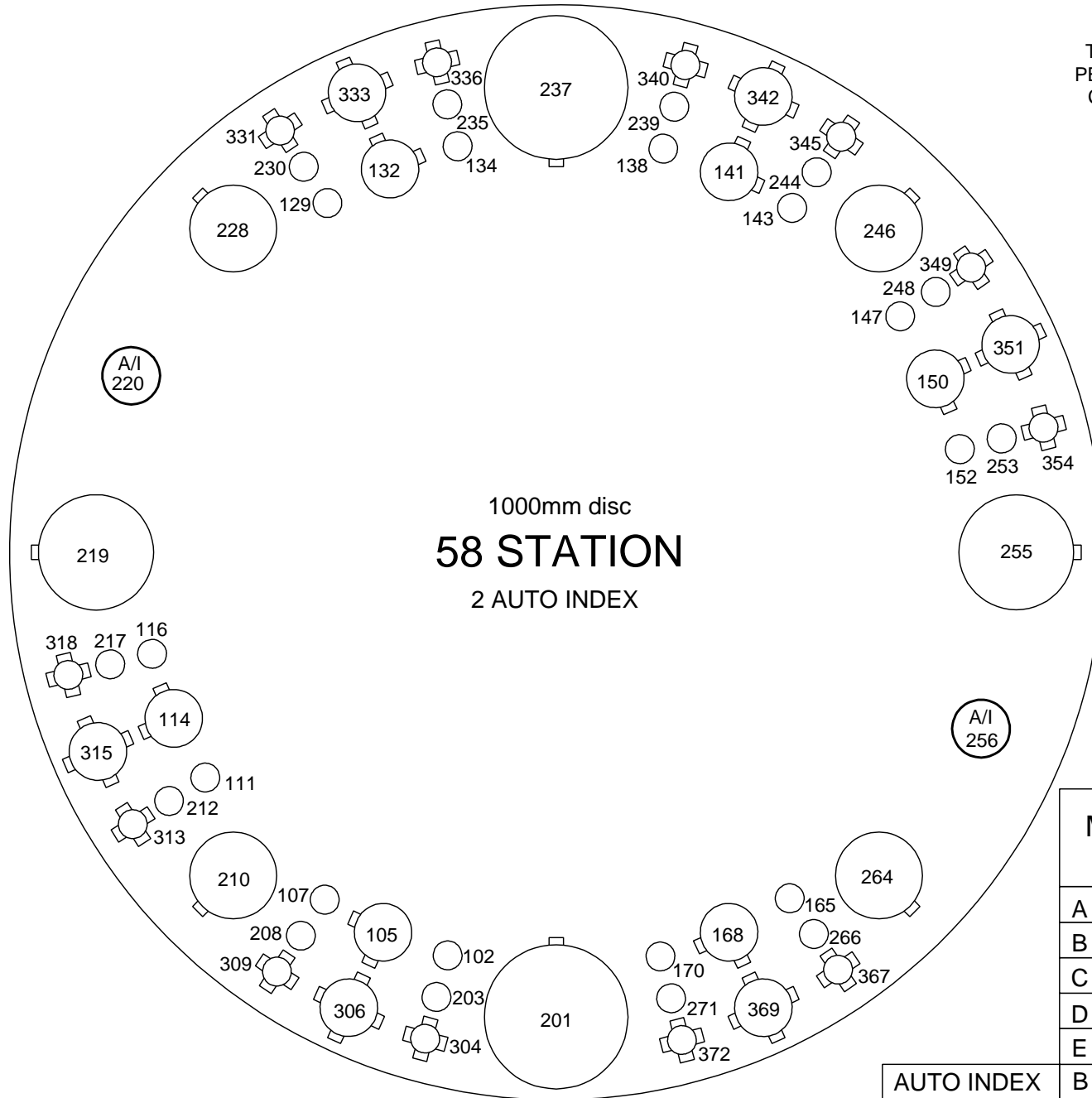
Work Chute / Trap Door

Work Chute / Trap door only available on ball transfer table equipped machines.



58 Station 2 Auto Index Thick Turret

This turret used on the following machine models
 PEGA 345, PEGA 345 King, PEGA 357, PEGA 367
 COMA 555, COMA 557, COMA 567, COMA 588
 VIPROS 345, VIPROS 357, VIPROS 367
 VIPROS 357 Queen, VIPROS 367 Queen



	MAXIMUM SIZE ROUND	NUMBER OF STATIONS (KEYED)
A	1/2" (12.7mm)	36 (12)
B	1 1/4" (31.7mm)	12 (12)
C	2" (50.8mm)	4 (4)
D	3 1/2" (88.9mm)	2 (2)
E	4 1/2" (114.3mm)	2 (2)
AUTO INDEX	B 1 1/4" (31.7mm)	2 (2)

44 Station 2 Auto Index Thick Turret

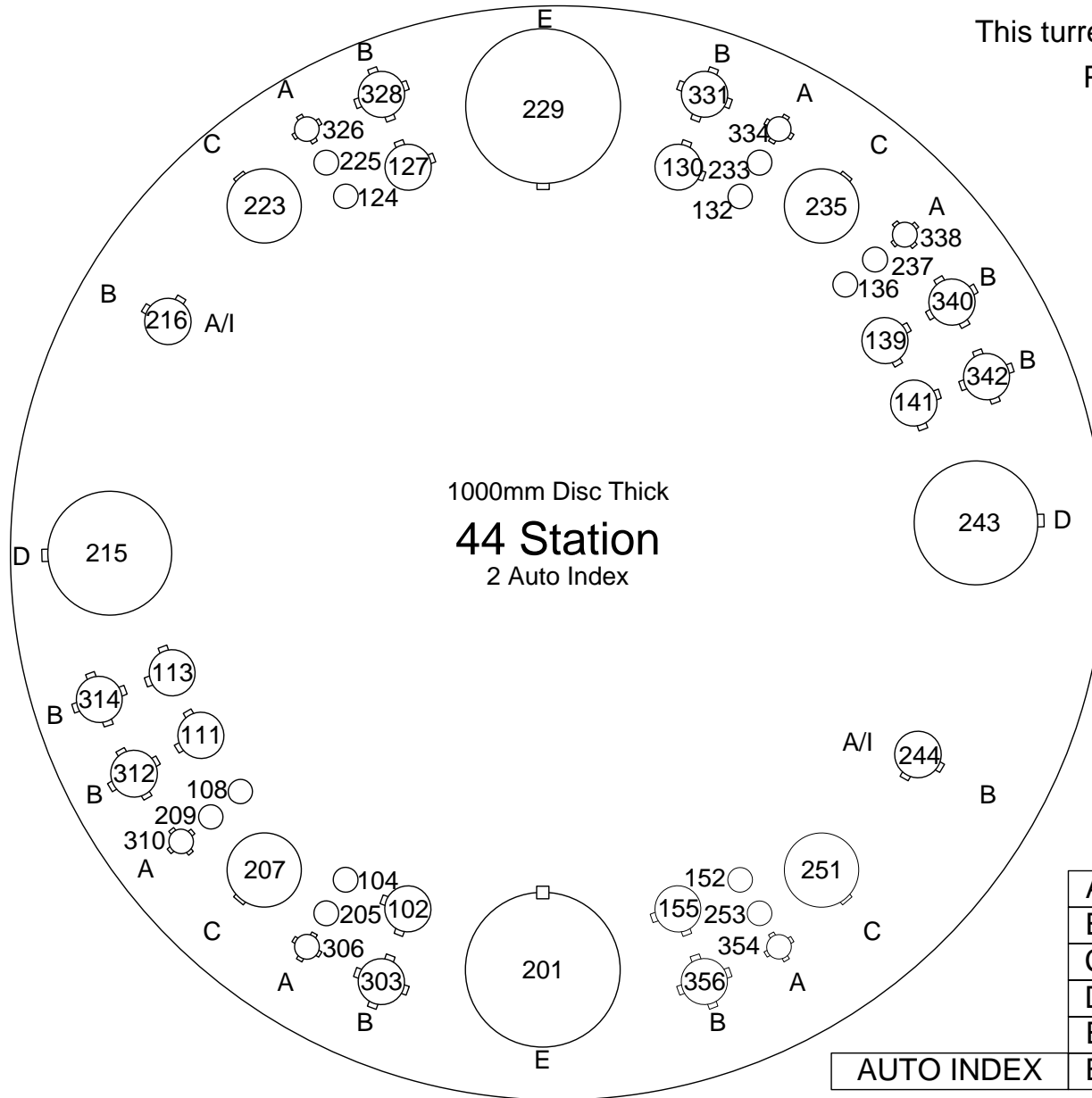
This turret used on the following machine models

Pega 344, 345Q, 345K, 357, 367

Coma 555, 557, 567, 588

Vipros 345, 357, 367

Vela II 355



	MAXIMUM SIZE ROUND		NUMBER OF STATIONS (KEYED)	
A	1/2"	12.7mm	18 (6)	
B	1 1/4"	31.7mm	16 (16)	
C	2"	50.8mm	4 (4)	
D	3 1/2"	88.9mm	2 (2)	
E	4 1/2"	114.3mm	2 (2)	
AUTO INDEX	B	1 1/4"	31.7mm	2 (2)