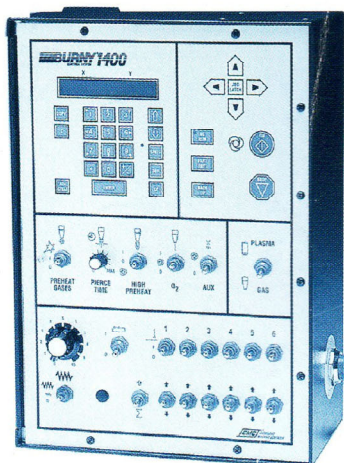


Full Function CNC Shape Cutting Control

The BURNY 1400 Control System includes a fully-integrated BURNY 2.5 CNC, one of the easiest and most cost-efficient shape-cutting controls available today. Numerous standard features include RS 232/422 communications and up to 512K of non-volatile memory, chain cutting, automatic plate alignment, a built-in library of 53 pre-programmed shapes, and an independent Jog Keypad. With BURNY 2.5, you can also create and modify your own programs and send and receive part programs from an off-line programming center.



relays are fully integrated with the CNC to utilize available microprocessor-generated timing and automatic control sequences. Heavy duty switches and relay outputs control the functions of preheat, ignite, high preheat and cutting oxygen. An adjustable pierce time potentiometer is included for control of machines equipped with two-stage piercing cycle capabilities. Plasma start and stop controls are also fully-integrated, enabling the CNC to generate automatic cutting sequences for automatically controlled plasma cutting or for manual control for maximum operator flexibility.

integrates a CNC generated enable command, allowing external torch height controls to be automatically controlled during the cutting process—maximizing quality and productivity.

Fully-Integrated Drive Controls

BURNY 1400 includes a fully-integrated SERVOPAK 120 watt pulse-width-modulated drive system. With fast response, low power consumption, and a wide dynamic speed range, this servo drive provides reliable performance and improves cut quality. If a larger drive is required, the BURNY 1400 is also available with external servo outputs to performance-match a larger SERVOPAK drive system to the exact size and weight of your shape cutting machine.

Plus Numerous Other Features & Benefits

With the BURNY 1400 Control System, you benefit from a dedicated shape cutting control system for oxy-fuel or plasma processes—and much more. You benefit from single-source reliability and single-source responsibility from the international Burny Group, the industry leader in CNC shape cutting technology. The BURNY 1400 Control System incorporates numerous other built-in design features and performance benefits.

Complete Oxy-fuel & Plasma Process Controls

All BURNY 1400 process control switches and control

Fully-Integrated Torch Controls

The BURNY 1400 Control System integrates heavy duty switches and relay outputs to select and control individual torch stations and a lifter up/down switch for up to six torch stations. In addition, an Auto mode position on the station select switch

STANDARD DESIGN, CONSTRUCTION AND FUNCTIONAL SPECIFICATIONS

- Includes a BURNY 2.5 CNC shape cutting control with Jog Keypad. (See the BURNY 2.5 CNC brochure and specification sheet for a complete listing of specifications.)
- Membrane front panel with ISO 7287 international standard symbols.
- Gas functions with six Station Selects.
- Six Torch capacity with DPDT Relay Outputs for AC or DC Lifters.
- Auto Height capability with relay outputs to control auto height enables.
- Adjustable timers to command All Up of the Lifters after High Preheat and Cut Off.
- To maximize safety, no high voltage wiring is on the front panel, 24 volt logic is used instead.
- Arc squelching Resistor / Capacitor snubbers on outputs.
- Larger Control Transformer to handle additional relays' power requirements.
- Relay Card utilizing the Motorola MC68HC05P9 high-density complementary metal-oxide semiconductor (HCMOS) micro controller unit (MCU). Wire jumpers connect input AC Lines as source for Solenoids and Lifters or voltage can be customer supplied.
- Solenoid relay outputs are:
 - Auxiliary
 - High Cut O₂ (2nd stage)
 - High Preheat
 - Ignitor
 - Low Cut O₂ (1st stage)
 - Low Preheat
 - Marker
 - Oxy-Vent
- Plasma relay outputs are:
 - Plasma Start
 - Plasma Stop
 - Height Sensor Disable
- There are twelve lifter relay outputs, consisting of an up and down relay for each motorized torch station. The MCU commands the torches All Up after the High Preheat and after the Cutting Oxygen solenoids turn off. The time duration that the All Up relay remains on is adjustable via two potentiometers within

the control.

- Six Station Select outputs can be directed by either the Gas On relay or the Cutting Oxygen On relay.
- Auto Height Outputs are manipulated by the MCU. The LEVITATOR Auto Mode is enabled during High Preheat and when the Cutting Oxygen is on.
- A two-pole potential free Clutch Relay is wired to a six-point terminal block inside the control for customer use.
- Drive included with the BURNY 1400 is a 120 watt Pulse-Width-Modulated (PWM) DC drive.
- Should a larger drive be required, external Servo outputs are provided to control optional external SERVOPAK Drive systems.
- A speed reference card has been added to provide the High and Low speed reference adjustments.
- RS232/422 adapter is a standard feature in the BURNY 1400.
- Preheat Gases switch is a three-position toggle switch.
 - Up Momentary On Torches Ignite
 - Middle Maintained On Low Preheat is On
 - Down Maintained Off Gas Relay is Off
- High Preheat switch is a three-position toggle switch.
 - Up Maintained On High Preheat is On
 - Middle Maintained Off High Preheat is Off
 - Down Maintained Auto CNC controls High Preheat
- O₂ switch is a three-position toggle switch.
 - Up Momentary On Low and High Cut O₂ are On
 - Middle Maintained Auto CNC controls Cut O₂
 - Down Maintained Off Low and High Cut O₂ are Off
- Aux switch is a two-position toggle switch
 - Up Maintained Auto Aux is controlled by High cut O₂
 - Down Maintained Off Aux Output is off
- Plasma / Gas select is a two-position toggle switch.
 - Up Maintained On Plasma Cutting Mode is selected
 - Down Maintained On Oxygen Cutting Mode is selected
- Clutch switch is a two-position toggle switch.
 - Up Maintained On The Clutch Relay is on
 - Down Maintained Off The Clutch Relay is off
- Station selects are three-position toggle switches.
 - Up Maintained On Station on and Auto Height Auto
 - Middle Maintained On Station on and Auto Height Manual
 - Down Maintained Off Station off and Auto Height Manual
- Speed Range Select is a three-position toggle switch.
 - Up Maintained High Speed Reference is in High Range

- Middle Maintained Low Speed Reference is in Low Range
- Down Maintained Off Speed Reference is Zero
- All Up switch is a two-position toggle switch.
 - Up Momentary On Lifter Up relays are energized
 - Down Maintained Off Lifter relays operate normally
- Lifter switches are three-position toggle switches.
 - Up Momentary On Lifter Up Relay is energized
 - Middle Maintained Off Lifter relays are not energized
 - Down Momentary On Lifter Down Relay is energized
- Pierce Time adjustment potentiometer.
 - Range 0-20 seconds Controls time duration between first and second Cut O₂
- Speed adjustment potentiometer.
 - Range 0 - max. speed Controls machine speed during cutting and jogging
- Incoming power can be 115 or 230 volts AC 50/60 Hz.
- Internal 115 volt AC cooling fan is used to provide air circulation.
- Large Emergency Stop push-button on the side of the control breaks the power line for safe operation.
- Enclosure is dust tight and the connectors, transformers, fuses, door and hinge are gasketed.
- Enclosure is 16-gauge cold rolled steel and plated and painted to provide a high level of corrosion protection.
- Panel base plate is 0.125" aluminum and the graphics layer is 10 mil polycarbonate. The panel is textured and highly scratch and chemical resistant.
- Special precautions have been taken to guard against high frequency plasma noise from disturbing the sensitive electronics.
- Eight Grounding screws have been provided to attach the 360 degree cable clamps to the back of the enclosure.
- Four holes have been provided on the bottom of the enclosure for ease of mounting.
- Five fuses are standard in the BURNY 1400 Operator System:
 - An incoming power fuse
 - A Station power fuse
 - Two Lifter power fuses
 - A Solenoid power fuse

BURNY GROUP

Burny Division
Cleveland Machine Controls, Inc.
 7550 Hub Parkway/ Cleveland, OH 44125 U.S.A.
 Tel: (216) 524-8800 Fax: (216) 642-2119
 Service: (216) 642-2198

Burny/Etek GmbH Industrie-Elektronik
 Werkstrasse 5
 D-64732 Bad König, Germany
 Fax: 49 (0) 6063-5492 Tel: 49 (0) 6063-9314

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