



403 SERIES 4 ROLL CONTROL OPTIONS

GENERAL DESCRIPTION: This control has a circuit board in the machine by the hydraulic valve bank. This allows us to use much smaller wires to the operator panel which results in a smaller cord. These cords are prewired with the proper plugs, so they can be conveniently changed, if they were accidentally cut. The circuit board has the required hardware, so it is easier to add options. The roll trim is operated from the main panel instead of the side of the machine. The pinch roll has a digital readout to show position in addition to the pinch roll pressure adjustment (except the Beta W4.2). This control also utilizes a variable frequency drive for the main motor. We use this for speed control instead of a hydraulic flow control. The footswitch option is made to be added to any machine without needing to do any wiring and it comes with a selector to select between rotation forward/reverse, or pinch roll up/down. With this control it can be upgraded to a better control any time.

BETA 4.2

This is a manual control and comes with the base machine at **NO CHARGE.**
(shown with optional rotation readout)



FEATURES:

Push buttons to control:

- Control
- Emergency stop
- Near roll
- Pinch roll
- Far roll
- Roll rotation
- Drop end

Selector switch to control:

- Roll trim
- Rotation reroll

Dial to control:

- System speed

Digital readout to show position of:

- Near roll
- Pinch roll
- Far roll

- Free standing rolling console
 - NEMA 12 Fiberglass enclosure
 - Stainless steel hand rail
 - Receptical for control cord
- Recommended use, Job Shops and part batches up to 10 pieces.

Option:

Beta 4.2R Rotation readout to show length in inches of the roll rotation.

Recommended use, jobs with multi radius or flats.

\$2,800.00

BETA W 4.2

This is a wireless manual control and can be upgraded from the Beta 4.2 control for **\$10,150.**



FEATURES:

Wireless "Belly Pack" with shoulder strap and tether cord. Toggle switch to control TX power. Dial to control System speed. Emergency stop push button.

Joy sticks to control:

- Near roll
- Pinch roll
- Far roll
- Roll rotation

LCD display to show position of:

- Near roll
- Far roll

Control mounted on machine features push button to control:

- Control
- Emergency stop
- Drop end

Selector Switch to control:

- Roll trim
- Rotation reroll

Digital readout to show position:

- Near roll
 - Far Roll
 - NEMA 12 enclosure
 - Receptical for control cord
 - Receptical for tether cord
- Recommended for jobs where increased mobility is required.

PRE 4.2

This is a preset control and can be upgraded from the Beta 4.2 control for **\$12,650.**



FEATURES:

Push buttons to control:

- Control
- Emergency stop
- Drop end
- Far roll gauge position

Variable speed joysticks to control:

- Near roll
- Pinch roll
- Far roll
- Roll rotation

Selector switches to control:

- Roll trim
- Rotation reroll
- Set point 1 mode
- Set point 2 mode
- Normal mode

Digital readout to show position and control:

- Near roll (2 set points)
- Pinch roll (2 set points)
- Far roll (3 set points)
- Roll rotation (3 set points)

- Free standing rolling console
 - NEMA 12 enclosure
 - Stainless steel hand rail
 - Receptical for control cord
- Recommended use, this popular control provides just enough automation to greatly speed through put performance, and accuracy. It is easily programmed and can be used as manual or preset type control. In many cases this control increases roll performance 500% or more and is usually all the automation that is required. This control is recommended for part batch sizes from 3 to 100 pieces or more.

AUTO 4.2

This is an automatic control and can be upgraded from the Beta 4.2 control for \$29,100.



DESCRIPTION:

This NC control is used for high volume production. The material is hand-fed and it completes all forming functions automatically, and has 4 modes; warm-up to get the machine to operating temperature, Drop end open for full circles, Drop end close for segments and tack for positioning part to tack weld on the machine. This control can be used in manual, presets or auto modes and has a 6-part memory storage. It is recommended for part batch size of 50 plus pieces.

FEATURES:

Push buttons to control:

- Control
- Drop end
- Emergency stop
- Mode
- Pause/SP over ride

Joysticks to control:

- Near roll
- Pinch roll
- Far roll
- Roll rotation

Selector Switches to control:

- Roll trim
- Rotation reroll
- Cycle - warmup, dropend open/close or tack.
- Part selector - Part # 1,2,3,4,5, or 6

Dial to control:

- System speed

Digital readout to show position and control:

- Near roll
- Pinch roll
- Far roll
- Roll rotation

Indicator lights to show:

- Manual mode
- Preset mode
- Auto mode
- Auto ready

Footswitch to control:

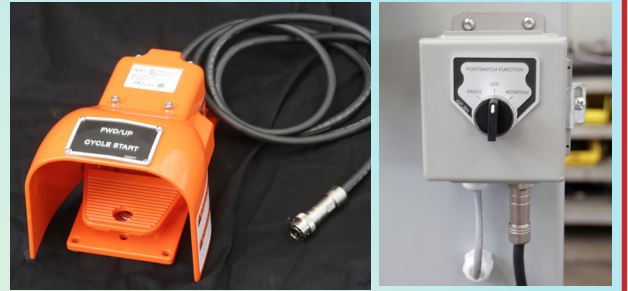
- Cycle start, rotation forward, pinch rollup

- Free standing rolling console
- NEMA 12 enclosure
- Stainless steel hand rail
- Receptical for control cord

Other features and variations available to suit your individual needs . . . P.O.A.

We reserve the right to make changes in design and specifications without obligation or notification.

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FS 1.2

This is a single footswitch option. \$800.

FEATURES:

Selector to control function:

- Pinch roll up
- Rotation Forward
- Off
- Compatible with all controls (included with Auto 4.2 Control n/c)



FS 2.2

This is a double footswitch option. \$1,000.

FEATURES:

Selector to control function:

- Pinch roll up/down
- Rotation Forward/Reverse
- Off
- Compatible with all controls

COMING SOON

WR 2.2

This is a double wireless remote. P.O.R.

FEATURES:

Selector to control function:

- Pinch roll up/down
- Rotation Forward/Reverse
- Off
- Compatible with all controls



OPTION: Wooden hand rail with template shelf, clipboard and cup holder. \$300