

# PressPro Control System for Stamping Presses

**Reduce operating costs and downtime with reliable and flexible programmable press controls.**

## Overview

The Rockwell Automation PressPro System is an advanced programmable controller-based system used for the control and monitoring of mechanical and hydraulic stamping presses. The PressPro control system is for customers who want to reduce cost and risk by purchasing a complete pre-engineered system, ready for installation.

The PressPro System uses the Allen-Bradley Logix™ family of processors. PressPro allows the user to add their own software into the same processor where the safety kernel resides, while maintaining safety integrity.

## Legacy Systems

Many systems in the field today are based on relays or proprietary "black box" controls. These systems are often inflexible, difficult to troubleshoot, limited in features, and expensive to maintain. Many legacy systems also reach their limitations when integrating with a plant-wide Information System.

## System Description

The PressPro System is a flexible, pre-engineered press control system based on standard Rockwell Automation components available locally and supported worldwide. PressPro Systems provide press control, operator interface, and magnetics in a single integrated package including a complete set of documentation. The use of field-proven hardware and software helps users minimize cost, risk, and comply with the necessary ANSI, OSHA and CSA standards.

## Results

A PressPro System will help provide the following:

- Reduced downtime through comprehensive operator diagnostic messages and on-line control system troubleshooting.
- Increased flexibility through open integration of press control functions and industry-standard connectivity to other equipment including coil feeds, computers, drives, robots and servo transfer feeds.
- Improved quality through recipe-based control of process parameters such as shut height, counterbalance air pressure, motor speed, die protection and programmable limit switch.
- Reduced costs through the use of standard Rockwell Automation industrial control hardware, field-proven application software, and a comprehensive documentation package.



## PressPro Functions

The PressPro System is modular, which allows each system to be configured to the requirements of each specific application.

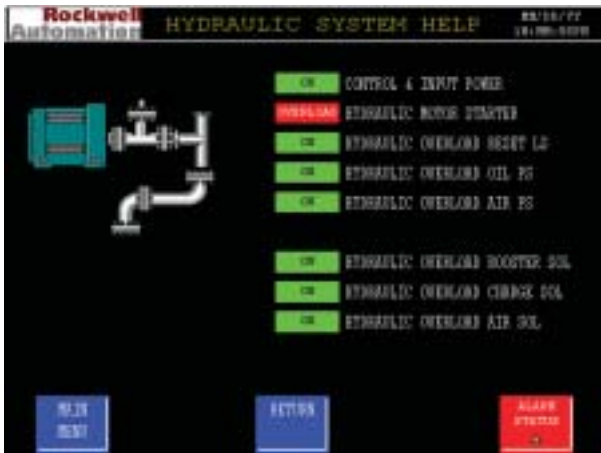
### Standard functions include:

- Safety Interlocks and Light Curtain interface
- Main Motor/Pump Control, including a reversing motor starter
- Lubrication control, including a motor starter and lube verification
- Manual Slide Adjust/ Ram Profile Control
- Alarm Status/History and Fault/Prompt operator screens on a 10" color PanelView™ display
- Clutch/Brake Safety Control with Inch, Single Stroke, Continuous, Micro Inch, Remote and Die Setup Modes of Operation, including a mode select key switch on mechanical presses
- Interface for four run stations with anti-tiedown protection
- Fully assembled and mounted in a NEMA 12 rated industrial enclosure

### Optional functions include:

- Automatic Slide Adjust
- Die Protection
- Programmable Limit Switch
- Tonnage Monitoring
- Automatic Counterbalance Air Pressure Control
- Die Clamp Control
- Bolster Control
- Light Curtain with muting
- Hydraulic Overload Control
- Recipe Management
- Automatic Die Change

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## PressPro System Architecture

The PressPro System uses the Allen-Bradley Logix family of processors, the benchmark for PLCs. The safety kernel, executed in dual Logix processors, is based on standard Bulletin 6556 clutch/brake or ram control software, designed by Rockwell Automation to comply with ANSI B11.1/B11.2, OSHA 1910.217, CSAZ142-M90, and EN 954. This safety kernel is coupled with additional software that provides all other press automation control, monitoring, information and network requirements. The power and flexibility of the RSLogix5000™ programming environment allows the user to add their own additional custom software into the same processors where the safety kernel resides.

The standard operator interface is a color PanelView 1000 (keypad or touchscreen). The system is available in several physical packages including a freestanding console or an upright enclosure with a press mounted operator station. The processors are networked using the open NetLinx™ networks to allow programs to be edited, uploaded, and downloaded from a single connection point.

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[www.rockwellautomation.com](http://www.rockwellautomation.com)

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## Other Press Control Systems

Rockwell Automation offers a complete line of standard and custom press and automation control solutions for the pressroom. Solutions are available for mechanical and hydraulic stamping press (gap, straight side, transfer), tandem line, forging, die casting, and motion control applications. **AxisPro™** inter-press automation motion control systems, **STFPro™** servo-transfer feed control systems and **TandemPro™** supervisory systems designed to provide line control and pressroom production data acquisition are also available.

## For More Information

Contact the local Rockwell Automation sales representative or authorized Rockwell Automation distributor for a **PressPro** System Quotation Worksheet. Complete the worksheet and return it to the Rockwell Automation press control team using the telefax number or e-mail address listed on the worksheet. The worksheet will be used as the basis for a proposal for the configuration selected. Further information is also available on the Internet at

[www.rockwellautomation.com/metalfforming](http://www.rockwellautomation.com/metalfforming)

