



XL200 Series Controls for Roll Forming Machines

The XL200 is specifically designed to be the ultimate in roll forming machine controllers. Through software selection and configuration parameters, it can easily be adapted to any machine type and offers accuracy, efficiency and ease of use. AMS Controls has over 30 years of experience developing, building, installing and servicing the roll forming market and has sold over 10,000 control systems. With this wealth of knowledge and experience, we can create a control system for any roll forming line.

OPERATING MODES

Stop to Cut	Flying Cut / Flying Punch	Servo Roll Feed	Servo Flying Press
Single or two-speed	Boost cylinder control	Single or two encoders	Dynamic home position based on line speed
Adaptive stopping compensation	Speed compensation	Single stroke or continuous press operation	Support for multiple flying axis, multiple hits per cycle

SYSTEM DETAILS

Main Features

Hardware

- Rugged industrial controller
- Full optical isolation for outstanding noise immunity
- High speed DSP coprocessor for motion control algorithms

Productivity

- Data entry while in automatic mode
- Automatic punch calculations
- Staggered part production
- Automatic partial cuts for short parts
- Automatic machine configuration based on profile or material

Production Tracking

- Continuous improvement tools
- Production control
- Multi-user Eclipse

Scrap Reduction

- Scrapless transition of part length and punching patterns
- Crash detection

Accuracy

- Tight tolerances: +/- 0.002" possible on roll feeds
- Stopping reaction compensation
- Speed compensation
- Servo positioning for material and tooling

Flexibility

- Adapts to any machine type
- Cutoff and punches can be synchronized to hole/edge sensor
- X-Y coordinates punching
- Support for continuous press operation
- PLC integration (MODBUS)

Performance

- 500+ fpm machine speed
- Best possible length control accuracy
- Automatic stopping reaction time measurement and adjustment for non-servo start-stop operations
- Automatic press reaction time compensation for non-servo flying operations
- Linear, rotary and crank servo motion control mode

Integrated Manufacturing



with Eclipse Production Management Software

- Download orders and manufacturing data
- Upload real-time status and production data
- Coordinated part marking and bundle label printing
- Bar code scanning of coil identification labels
- Tracking of coil usage and scrap generation
- Coil verification for order matching
- Tracking of machine down-time
- Quality audits
- Preventive maintenance schedules and wear reporting
- Continuous improvement tools such as OEE reporting
- Multiple terminal access

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