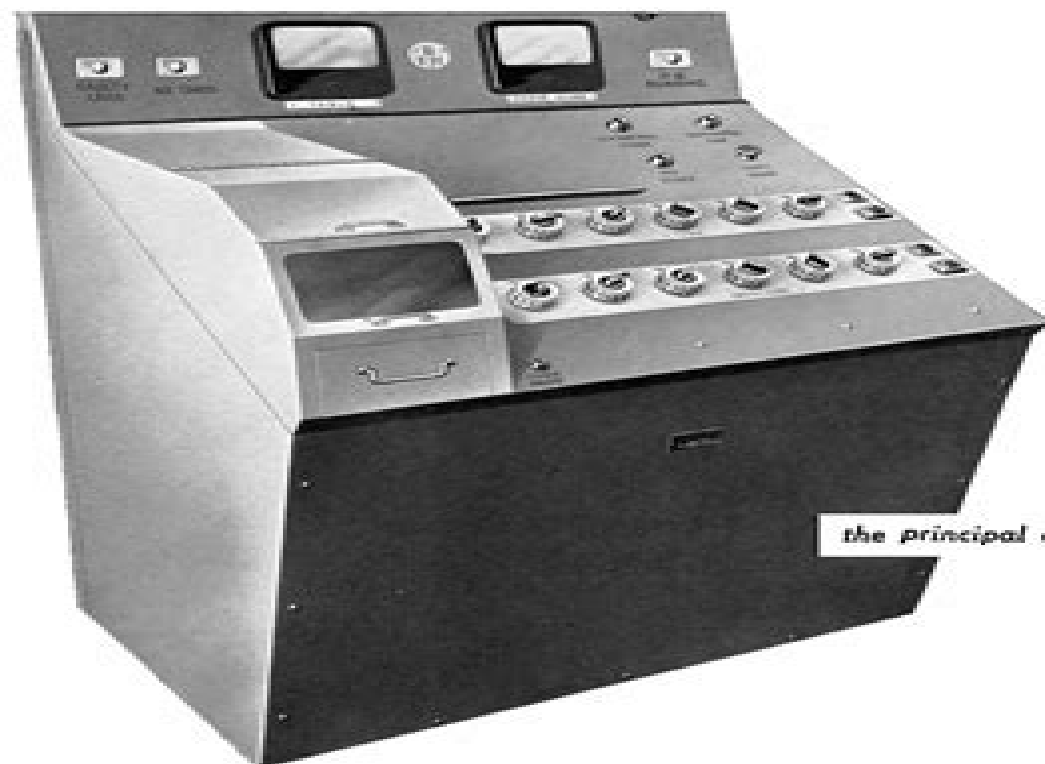


B.T.H. desk with controls for co-ordinate setting and punched card operation.



the principal advantages of these automatic features are:

- (i) Lessening of operator fatigue.
- (ii) Time saving by positioning of two co-ordinates at once instead of singly, and by tool changing or making reference to drawings during this period.
- (iii) Avoidance, especially when punched cards or tape are used, of necessity for the operator to check his settings.
- (iv) By employing punched cards or tape, calculations of co-ordinates need not be left to the operator. These may be prepared together with production schedules in the planning department, so that chances of errors are minimised and maximum machine utilisation is ensured.
- (v) Once a set of punched cards or a tape has been proved on the first component, this will be known to be correct for any number of similar components in the future, however infrequently they are manufactured.

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The final setting movement, amounting to approximately 0.02", always takes place in the same direction. With the exception of this small movement, the slide always moves directly from one position to another, irrespective of direction, without having to return to zero.

An important feature of the control system is that, in the final stages of the approach to position, the speed of the positioning drive motor is controlled by a suitably amplified error signal generated by the detector head, the signal being gradually reduced as the head approaches zero position. In consequence, the positioning motor is automatically under close control right down to zero speed, and positioning is, therefore, entirely independent of limit switches, timers, automatic brakes, or similar apparatus. By reason of this "closed loop" system, the automatic cycle will not be completed unless the table has been positioned within the stated limits.

The total setting time is the sum of the times due to distance to be moved and the final positioning cycle of about 5 seconds. A 1 inch movement is accomplished in 7 seconds; 6 inches in 10 seconds and 24 inches in 21 seconds approximately. During these periods the operator may be engaged in tool changing so that in fact no time is wasted. As an alternative to dimension selection by manual rotation of the setting dials, these may be controlled by punched cards, one card being used for each pair of co-ordinates. Cards may be inserted into the machine in packs of up to 500 and are automatically fed into the reader on pressing a push button, which is duplicated on the control desk and machine console. Dials may also be operated through the medium of punched paper tape if this facility is specially ordered; in this case it is usual to retain the card reader so that either medium of automatic input information may be used as well as the provision for manual setting. Dimensions selected by punched cards or tape can be preset to save time and automatically appear on the dials used for manual selection. Interlocks are provided so that indication will be given and automatic setting prevented if normal faults, such as the insertion of an improperly punched card or tape or of two cards together, occur.

Newall Digipac 1 Manual

RD Boyd



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