

### PEHU

Positioning systems

## PEHU LMS Measuring Systems

The Pehu LMS10 and LMS15 is a manually operated measuring system with a digital read out indicating the current stop position.

The Pehu LMS30 to Pehu LMS80 are powered models which can be configured as either auto-measuring or auto-feeding systems\*.

The operator enters the required stop positions into the NC control and the system automatically runs through the program until it is completed. Specific systems can be configured to work with saws, drills and steelworkers or punching machines.

\*The LMS30 & LMS45 requires the PEHU 112 Control to become a fully automatic solution.



**PEHU LMS 15**

### Machine Features

- LMS10/15 - Manual positioning of stop
- LMS30/45/60/80 - Powered programmable positioning of stop unit
- LMS30/45/60/80 - Servo motor with rotary encoder to ensure positioning accuracy
- LMS60/80 - Fully Automatic Stop / Push-Up System
- Precision linear rail guidance system
- Digital read out of stop position
- Increased cutting accuracy by eliminating measuring errors
- Increased productivity - one set up for multiple cuts at same length
- Stop runs on precision linear guidance rail
- Rotary encoder ensures positioning accuracy
- +/- 0.1mm Repeatability
- Ideal for use with saws, drills and steelworkers
- Roller track available separately

### Optional Equipment

- NC servo control and can serve as both a stop and push control for length measuring systems (LMS30 & LMS45)
- Manual or powered flip up stop to allow cutting of longer material
- Pneumatic or hydraulic gripper or material clamp on the feeder unit
- Material Stop Warning Lamp
- Control Display in Arm
- Interconnection Kit
- Extension Kits for PEHU Rail
- Gravity or powered roller track to suit
- Light Guard Safety System



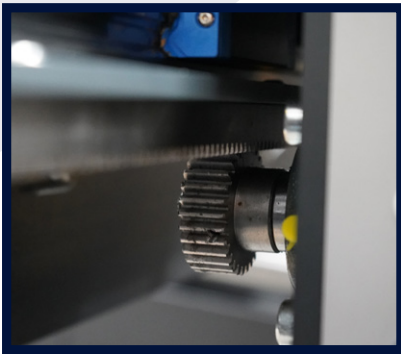
**FLIP-UP STOP FOR MATERIAL FEED-THROUGH**



**NC CONTROLLER**



**MATERIAL STOP**



**LINEAR RAILS**



**DIGITAL READ OUT OF STOP POSITION**

**WATCH THE MACHINE IN ACTION**



## TECHNICAL SPECIFICATIONS

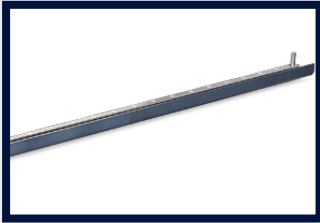
MODEL	Servo Control	Measuring Operation	Flip-Up Stop Operation	Set-Up	Width	Base Length	Additional Lengths	Positioning Accuracy	Positioning Speed
					mm	mm	m	mm	m/min
PEHU LMS10-02	N/A - Manual	Manual + DRO	Manual	Attaches to existing roller track system	250	2,000 (2m working length)	+2m per length	+/-0.2 mm	Manual
PEHU LMS15-04	N/A - Manual	Manual + DRO	Manual	Attaches to existing roller track system	350	4,000 (3.6m working length)	+1m per length	+/- 0.2 mm	Manual
PEHU LMS15-04 + 112S (3.3)	112S 3.3Nm Servo Control	Semi-Automatic (Stroke Control)	Manual	Attaches to existing roller track system	350	4,000 (3.6m working length)	+1m per length	+/- 0.2mm	Manual
PEHU LMS30-04	112S 3.3Nm Servo Control	Semi-Automatic (Stroke Control)*	Manual	Attaches to existing roller track system	350	4,000 (3.6m working length)	+1m per length	+/- 0.1 mm	+/- 40
PEHU LMS30-04 + 112 (3.3)	112 3.3Nm Servo Control	Fully Automatic	Manual	Attaches to existing roller track system	350	4,000 (3.6m working length)	+1m per length	+/- 0.1 mm	+/- 40
PEHU LMS45-04	112S 3.3Nm Servo Control	Semi-Automatic (Stroke Control)*	Manual	Attaches to existing roller track system	630	4,000 (3.6m working length)	+1m per length	+/- 0.1 mm	+/- 40
PEHU LMS45-04 + 112 (3.3)	112 3.3Nm Servo Control	Fully Automatic	Manual	Attaches to existing roller track system	630	4,000 (3.6m working length)	+1m per length	+/- 0.1 mm	+/- 40
PEHU LMS45-04 + 112 (5.0)	112 5.0Nm Servo Control	Fully Automatic	Manual	Attaches to existing roller track system	630	4,000 (3.6m working length)	+1m per length	+/- 0.1 mm	+/- 40
PEHU LMS60-06	112 5.0Nm Servo Control	Fully Automatic	Hydraulic-Electric	Integrated into a separate dedicated frame	830	6,000 (4.5m working length)	+1m per length	+/- 0.1 mm	+/- 40
PEHU LMS80-06	112 5.0Nm Servo Control	Fully Automatic	Hydraulic-Electric	Integrated into a separate dedicated frame	1100	6,000 (4.5m working length)	+1m per length	+/- 0.1 mm	+/- 40

\*The LMS30 & LMS45 requires a PEHU 112 Control to become a fully automatic solution

# OPTIONAL EXTRAS FOR THE PEHU MEASURING SYSTEMS

You can expand the PEHU Measuring Systems with additional options, as detailed below;

## PEHU EXTENSION



PEHU length measuring systems are extendable per meter. Extension consists of:

- Special angle line
- Linear rail
- Rack
- Cable duct + support + cover
- Cable carrier

## PEHU MATERIAL STOP LIGHT

The PEHU stops can be equipped with a stop lamp, which lights up when material is against the stop. This is a handy aid for longer lengths.

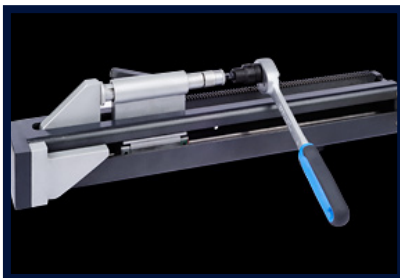


## PEHU AUTOMATIC FOLDING STOP



PEHU length measuring systems LMS15/30/45 are supplied as standard with a manually foldable stop. With the LMS15/30/45 you can opt for an extra support that lowers the stop in a controlled manner by means of a gas spring.

With the LMS 45 you can also opt for an electrically foldable stop. The stop is provided with a drive that you can operate from the control unit (pehu 112 cabinet). In some situations it is also possible to automatically fold up the stop during the retract movement. The PEHU LMS 60/80 are equipped with a foldable stop as standard.



## PEHU MATERIAL CLAMP

In order to prevent the material from rolling during pushing, PEHU has developed its own material clamp, which can clamp to any desired width by means of a fast sliding system. The pusher runs over a linear guide and is secured by means of a pin, after which it is tightened by hand. As an option, one can choose a pneumatic or hydraulic clamping.



## PEHU CONTROL DISPLAY IN ARM

Control display is hung on the machine. Control cabinet with driver(s) is placed elsewhere. Maximum cable length between display and control cabinet is 8 meters. Control display hangs on a hinged part so that the reading angle is adjustable and will be easy to read for everyone.



## PEHU INTERCONNECTION KIT

The kit is necessary if you are going to use a coupling between the push system and the processing machine. This ensures the communication between both systems. With this kit you can make a semi-automatic machine into a fully automatic machine. Or you can still feed a manually operated machine automatically without operating the control.