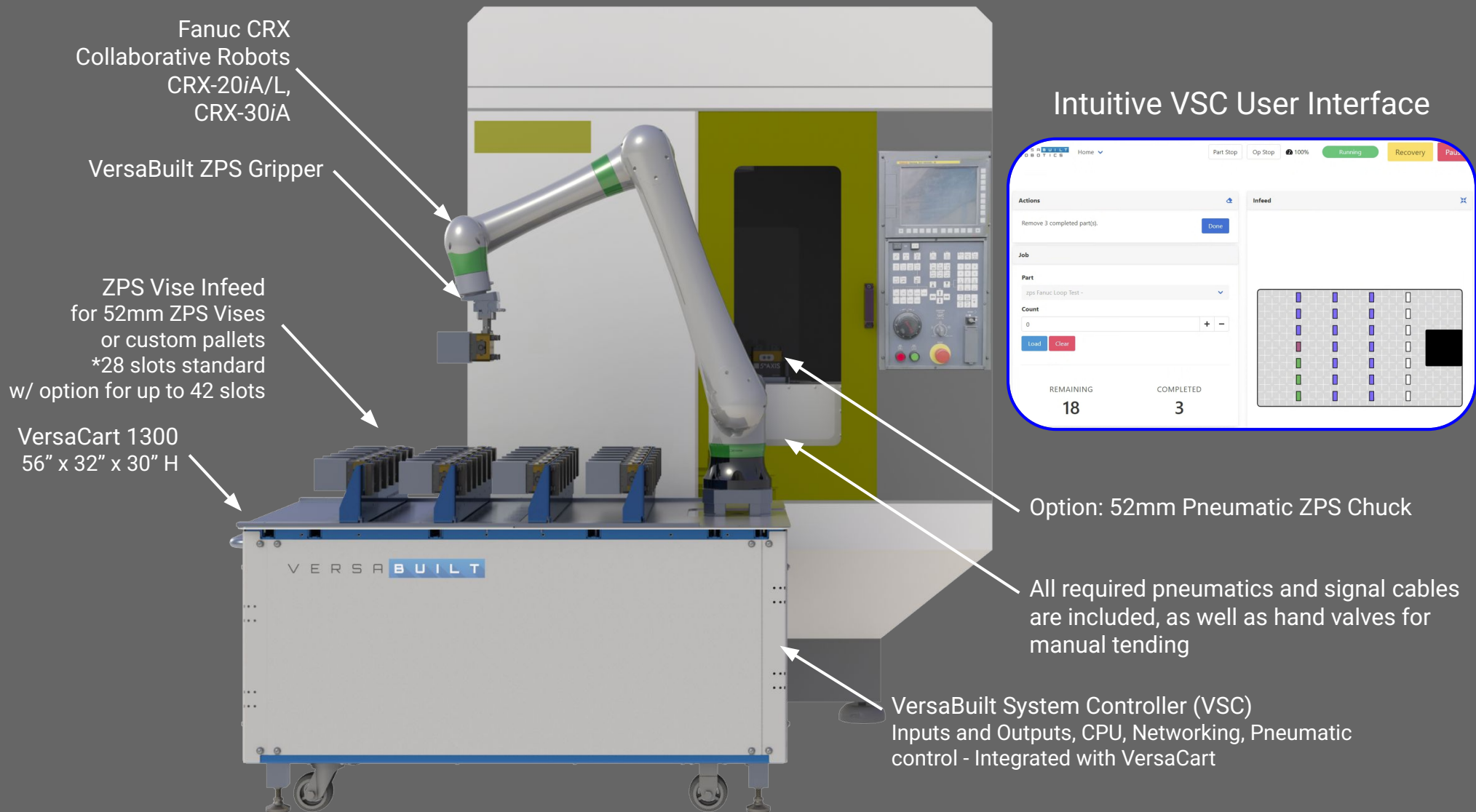


VERSA BUILT

Zero Point System (ZPS) Automation System



No Robot Programming

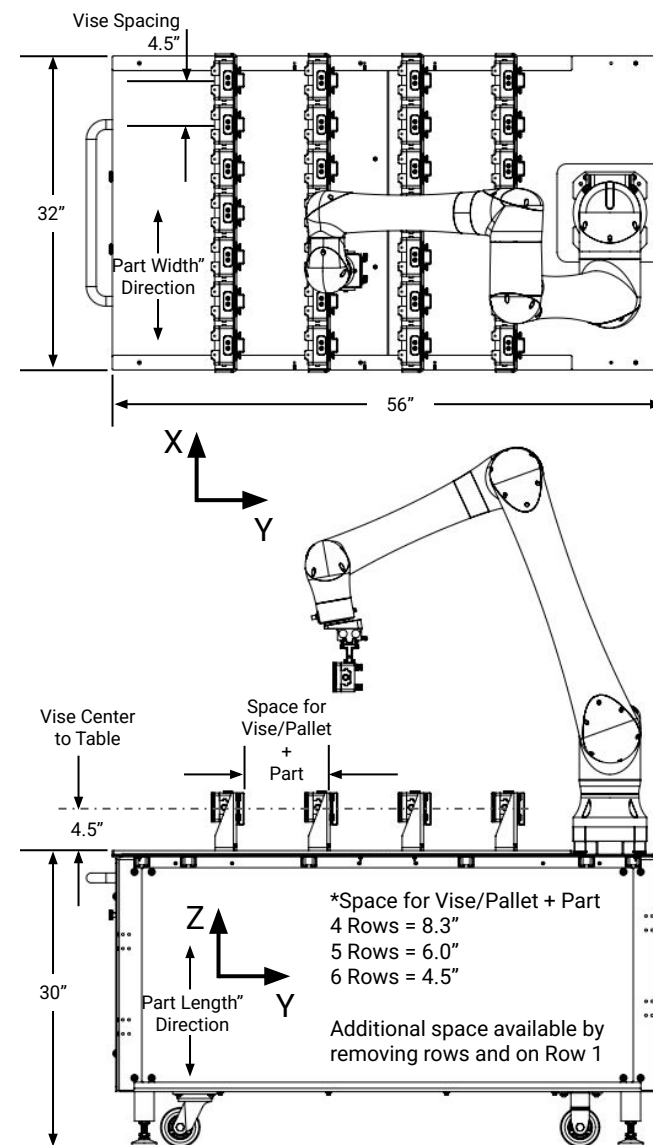
Install in 1 day

Plug and Play with any CNC

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Hardware & Software included	VersaCart 1300 with ZPS-Ready Infeed (4-Rows)	VersaBuilt ZPS Gripper	VersaBuilt ZPS Cleats for Vise to Gripper Adapter
	VSC 2.0 Standard** **Advanced VSC available option	VSC User Interface Software	All Required Electrical cables & Pneumatic valves and tubing
	*Base System 4 Row Infeed (28 Vise Slots)	Robot Tubing Kit	Hand valves for Manual Tending
System Options	Robot Types: Fanuc CRX-10iA/L Fanuc CRX-20iA/L Fanuc CRX-25iA Fanuc CRX-30iA	52mm ZPS Vises 52mm ZPS Dovetail Fixtures 52mm Custom Pallets	Infeed Option: 4, 5, or 6 Rows
	5th Axis ZPS Chuck	5th Axis ZPS Chuck Mount Plate	
Maximum Part Sizes *Height value is space for Vise/Pallet plus Part Height	4 Row Infeed	7 parts/row: 4.5" Wide x 9.0" Long x 8.3" Height* 4 parts/row: 9.0" Wide x 9.0" Long x 8.3" Part Height*	
	5 Rack Infeed	7 parts/row: 4.5" Wide x 9.0" Long x 6.0" Height* 4 parts/row: 9.0" Wide x 9.0" Long x 6.0" Height*	
	6 Rack Infeed	7 parts/row: 4.5" Wide x 9.0" Long x max 4.5" Height* 4 parts/row: 9.0" Wide x 9.0" Long x max 4.5" Height*	
Maximum Payload Gripper = 1.1 kg	Fanuc CRX-10iA/L	Vise/Pallet + Part, max payload = 7.5 kg / 16.5 lbs.	
	CRX-20iA/L	Vise/Pallet + Part, max payload = 15.5 kg / 34.0 lbs.	
	Fanuc CRX-30iA	Vise/Pallet + Part, max payload = 25.5 kg / 56.0 lbs.	
Software	VSC Software enables users to setup, calibrate and run system, recover from errors, add/configure new parts, configure settings, test I/O, and enable remote support.		
Programming	No Robot Programming required. VSC software enables new part introduction with configuration forms. Pre-Integrated and Pre-configured for ZPS Vise load and unload to and from VersaCart infeed Racks		
User Interface	User Interface Connection Options <i>*customer provided</i> - Web based application, connected via Wi-Fi or LAN, Phone, Tablet, Laptop or Computer - Monitor, keyboard, mouse connection to VersaBuilt System Controller		
Support	Remote connectivity available for software updates and remote support *availability of network connection for remote support is customer responsibility		
CNC compatibility	Vertical Machining Centers *Horizontal Milling Centers, depending on layout Robot2CNC dynamic communication for Haas NGC/Legacy and Fanuc Focus 2.0 controls. Handshake communication with all other CNCs		
Air Requirements	90-120 psi, 15-20 scfm *air should be conditioned to meet ISO 8573-1:2010 [7:4:4] standard		
Electrical Requirements	120VAC 1 Phase, 50/60Hz, Full Load 30A (Robot, Controls, VersaWash Pump)		
Optional Accessories	VersaDoor CNC AutoDoor	Area Safety Scanners	VSC 2.0 Standard or VSC 2.0 Advanced Hardware
	Dual CNC Setup	VersaCart Anchor Kit	

7 Vise Slots per Row
4 Rows Standard
Option for 5 or 6 Rows



Robot2CNC Communication

1. Macro-Driver Communication with CNC

Available for Haas Legacy, Haas NGC, and Fanuc Focus 2.0 controls (see list in VSC/CNC Manual)

With CNC Dispatcher in memory, CNC programs are communicated via macro-variables from the VSC to the CNC to select programs from the CNC program list, then run as sub-routines in the Dispatcher.

CNC Cycle Start is initiated with a 2-wire relay connection to the CNC Cycle Start Button

Cycle End is commanded at the end of the program through the dispatcher and M-code command.

G-Code Commands are available for control of Vise Open, Close, and Pressure Exhaust

2. Standard-Driver Communication with CNC

Generalized handshake between VSC and CNC, for CNC Controls without Macro-Driver option

CNC Cycle Start is initiated with a 2-wire relay connection to the CNC Cycle Start Button

Cycle End is commanded at the end of the program through an M-code command triggering a 24VDC signal to the VSC.

*Alternative options for Cycle Start/Cycle End are available, such as push-button actuator for cycle start, and stack-light trigger for Cycle End, etc.

Infeed Options available with System

52mm ZPS Slots

7 Slots per Row

4, 5, or 6 Rows

Devices/Hardware:

VersaBuilt ZPS Gripper - Centering Pneumatic Gripper with interface for picking the VersaBuilt ZPS Cleat assembled to ZPS Vises or Pallets.

VersaCart - Steel construction on casters, with adjustable foot pads to lock position, robot pedestal and infeed options optimized for 1300mm reach robots

VSC 2.0 - Computer, Pneumatics, and Electrical Signal devices for System

VSC Enable Button - Physical button, local to system, allowing for user access to VSC software

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VSC M8 Cable Digital Inputs and Outputs:	VSC 2.0 Pneumatics:	VSC Accessories:
1. 24VDC Outputs	1. Standard VSC 2.0 Connections	1. Pneumatics
Cycle Start	Gripper 1 Open & Close	Supply, Shut-off and Lockout Valve
VersaWash	ZPS Chuck Release & Release Exhaust	Supply Air Pressure Gauge
Robot Lock (for Dual CNC tending applications)	ZPS Chuck Blow-off & Blow-off Exhaust	Vise Air Pressure Gauge
Pallet Ready (for CNC's with Pallet Ready button)	VersaDoor Open & Close	Exhaust through bottom ports with push-to-connect fittings for customer routing, if desired
Door Interlock Release (for CNC's with Door Interlock Release button)	2. VSC 2.0 Advanced adds the following:	2. Electrical/User Interface:
Chuck 1 Toggle (for lathe foot pedal)	Gripper 2 Open & Close	110 VAC to 24VDC Power Supply with connector
Chuck 2 Toggle (for lathe foot pedal)	Vise 2 Open & Close	HDMI for monitor connection to user-interface computer
2. 24VDC Inputs	Vise 3 Open & Close	2x USB for software backup and connection to user-interface computer
Vise 1 and Vise 2 Sensors	Vise 4 Open & Close	3. Networking:
VersaDoor 1 Open/Close Sensor	Vise Pressure Control	5-Port Ethernet Switch
VersaDoor 2 Open/Close Sensor	3. Hand Valves	Ethernet Cables for CNC, Robot Controller, Router, and VSC
VSC Enable	Diverter Valve to switch between "Auto" / VSC valves or "Manual" Vise valves	WiFi or Networking Options available for U/I and Remote Support
CNC Cycle End (for non-macro-driver CNC controls)	1x Vise Hand Valves	
Robot Lock (for Dual CNC tending applications)		
Pallet Safe (for CNC's with Pallet Ready button)		

Processes included with Mill Automation System w/ DuoGrip

10p w/ 1 Vise

Infeed Options:
4 Row
5 Row
6 Row

*custom processes available for quotation

General Part Configuration Data Entry

Part Number

Part Description

Process (10p ZPS)

CNC Programs*

- Op1
- Wash Program

CNC Programs for System Operation

Dispatcher Files (9000's)
*if 9000 programs are in use, file numbers can be changed

Example Table Load Program (8000)
*position the CNC table at the vise calibration location for robot load/unload operations
*For Mill Automation Systems

Example Table Wash Program (8001)
*chip mitigation between operations

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Standard Systems:

VersaBuilt Automation Systems are Pre-programmed, Standardized CNC Machine Tending solutions with the robot moving between “Home” locations above the Table (Table Home), in front of the CNC (CNC Home), inside the CNC (InCNC Home), and performing operations with the Gripper, Chucks, and VersaDoor, based on the selected Part Configuration Selections/Options and setup on the VSC User-Interface Settings page. These Standard Systems are pre-programmed in a generalized manner for an easy-to-use interface, incorporating known CNC process requirements.

General DuoGrip Lathe Process Overview:

- CNC Dispatcher or Non-Macro Driver program is in memory
- User selects Part, Enters Quantity on VSC User Interface (multiple parts can be added at once)
- Operator loads vises/pallets on VersaCart, matching display on User Interface
- User selects Cycle Start on VSC user interface
- Robot Picks Vise/Pallet from first slot
- Robot Loads Vise/Pallet into Chuck
- CNC Cycle Start / Op1
- While the CNC is running, the Robot waits at CNC Home
- After CNC Operation is complete, Robot Unloads the Vise/Pallet
- The Chuck can be washed with a CNC wash.
- CNC Programs are run sequentially one-operation at a time.
- Parts can be added to the system while it is running a job, either by adding parts to empty slots shown on the User Interface, or Operator unloading of finished parts and adding on the User Interface.

Definitions:

- **FreeDrive** - Robot state where an operator can freely move the robot by gently pushing on the robot joints
- **Bin Drop** - Option for placing or dropping a part at a calibrated location (in location behind robot base, near the VersaWash tank), rather than placing the finished part back on the VersaCart Infeed.
- **Dump coolant** - after unload from the CNC, flipping the Gripper to drip coolant in the CNC

General System Notes:

- The user interfacing device is provided by the customer (not included in the quoted price). The user interface options are:
 - Wi-Fi connected device with Web-Browser (e.g., laptop, tablet) connected to the VSC interface via a Wi-Fi signal from the VSC router
 - Ethernet connectivity from device with Web-Browser connected to the VSC interface via VSC Ethernet Switch
 - Monitor/Keyboard/Mouse connected directly to the VSC via HDMI and USB ports
- The system operates on software local to the system (i.e., an internet connection is not required for the system to run).
- Pneumatic Tubing is color coded for applications. In general, Red or Black = Close, Blue or White/Clear = Open.
- Compressed air supply shall be 80 to 115 psi and conditioned to meet ISO 8573-1:2010 [7:4:4] standard. Maximum system air consumption is 15-20 SCFM.
- Remote Support is critical for success for installation, troubleshooting and software updates.
- Terms and conditions of sale can be found on the VersaBuilt website: www.versabuilt.com