

“Air grind” @ 20 IPM Feed Rate @ 10 IPM Feed Rate @ 4 IPM

Feedrate automatically adjusted according to load

Adaptive Control minimizes cycle time

WALTER's new *Adaptive Control* cuts cycle times up to 20% (particularly for larger tools) without sacrificing quality, finish, or wheel life. You simply set the optimum load limit for the wheel. The grinding program automatically adjusts the feed rate to maintain maximum—but not excessive—load. The result is:

- The shortest possible cycle times without operator input
- Maximum wheel life, because the wheel experiences constant load and never exceeds the limit you set
- Extended unmanned operation, since the wheel lasts longer and the feedrate automatically adjusts to the changing wheel condition

Without *Adaptive Control*, you must program feed rates based on the heaviest material removal and watch the wheel grind air at the flute or gash entrance at the worst case feedrate. Adaptive Control eliminates this problem. It's automatic.

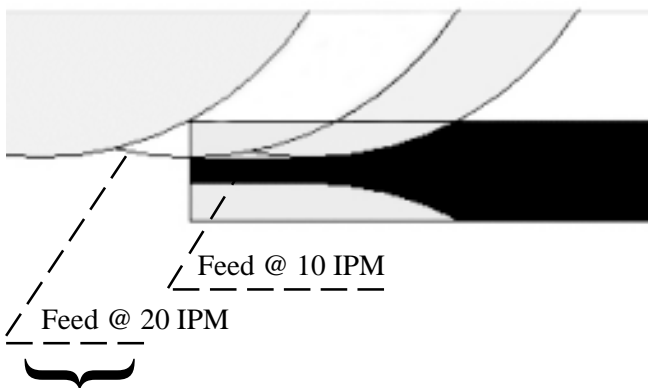
Tools exhibit no transition marks when changing feedrates, even in previously challenging areas like where the stock removal changes quickly or when the grinding wheel exits the flute after heavy material removal. That's because:

- The Power machine's rigidity eliminates effects of changing speed
- *Adaptive Control* changes feed rate quickly but gradually

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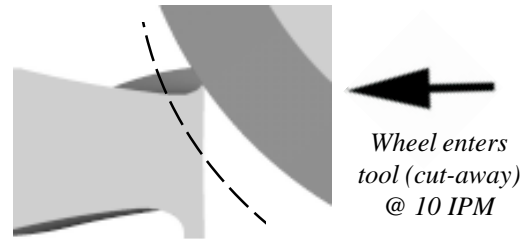
Cuts cycle times for endmills and drills too

Adaptive Control has the greatest impact on tools in which the optimal feed rate changes significantly in different parts of the tool. This is evident in step tools with big diameter changes, but it's also true for drills and endmills because the optimum feed rate changes significantly as the wheel approaches the tool and enters a flute. The optimum feedrate also changes significantly when gashing an endmill. So *Adaptive Control* cuts cycle times significantly in these tools too. In one case, *Adaptive Control* cut the time to manufacture a 1" square endmill from 11 minutes to 9½ minutes.



“Air grind” time eliminated

When fluting an endmill, Adaptive Control starts with a fast feed and slows only as the wheel engages the blank, eliminating the “air grind” that occurs when the feed rate is set for heaviest stock removal



Adaptive Control also optimizes the feedrate during gashing

Getting Adaptive Control

Adaptive Control is standard on all Power machines shipped from now on. It can be retrofitted on all HMC 500 control Powers running NT at low cost.

Call us to learn more!

Most versatile tool grinders
Best software
Best support...worldwide

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