

BURNY 1250 Plus

BURNY 1250 Plus is an economical fully-integrated shape-cutting control and drive system designed for single-torch plasma cutting machines



Performance Benefits

The BURNY 1250 Plus Operator Control System provides companies with an economical fully-integrated shape-cutting control system in one enclosure. It is available from the Burny Division of Cleveland Motion Controls, internationally recognized as leaders in the development of controllers for the shape-cutting industry, improving productivity and reducing costs.

The BURNY 1250 Plus Operator Control System offers users single-source control system responsibility and single-source reliability. It is easy to operate and offers a variety of design features to increase shape-cutting quality and accuracy, increasing productivity and reducing production costs.

Design Features

The BURNY 1250 Plus Operator Control System includes a fully-integrated new BURNY 2.5 Plus Shape-Cutting Controller, plasma process controls and a ServoPak® 120 watt pulse-width-modulated drive system.

The BURNY 1250 Plus Operator Control System incorporates a BURNY 2.5 Plus Controller, with a processor that is more than 300% faster than its predecessor. It has 512K of part program storage. In addition, the BURNY 2.5 Plus Controller uses FLASH memory instead of EPROMS, enabling users to easily connect a laptop computer and download new software or new part programs.

The BURNY 1250 Plus Operator Control System is recommended for shape-cutting machinery with single-torch plasma process capabilities. It is available for use with new machinery or to retrofit older flame-cutting machines.

- Reduces costs and increases shape cutting productivity
- Provides single-source control system responsibility
- Integrates a full-featured BURNY® Plus Control that is over 300% faster; including faster processing, faster downloading and faster kerf calculation
- Integrates a built-in drive amplifier system
- Integrates complete plasma and plate marker controls
- User-friendly

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Full Function CNC Plus Shape-Cutting Control

The BURNY 1250 Plus Operator Control System includes a fully-integrated BURNY 2.5 Plus Controller, one of the easiest and most cost-efficient shape-cutting controls available today. Numerous standard features include RS 232/422 communications and up to 512K of non-volatile memory, chain cutting, automatic plate alignment, a built-in library of 53 pre-programmed shapes, and an independent Jog Keypad. With the BURNY 2.5 Plus, users can create and modify their own programs and send and receive part programs from an off-line programming center.

In addition, the BURNY 2.5 Plus Controller is also one of the faster shape-cutting controls available. It provides users with processing speeds that are more than 300% faster than its predecessor, kerf calculation that is over four times faster, and downloading times (for software and part programs) that are over four times faster as well.

Complete Plasma Process Controls

All BURNY 1250 Plus process control switches and control relays are fully integrated with the shape-cutting control

to utilize available microprocessor-generated timing and automatic control sequences.

Plasma start and stop controls are also fully-integrated, enabling the shape-cutting control to generate automatic cutting sequences for automatically controlled plasma cutting or for manual control for maximum operator flexibility.

Fully-Integrated Drive Controls

The BURNY 1250 Plus Operator Control System includes a fully-integrated ServoPak 120 watt pulse-width-modulated drive system. With fast response, low power consumption, and a wide dynamic speed range, this servo drive provides reliable performance and improves cut quality.

STANDARD DESIGN, CONSTRUCTION AND FUNCTIONAL SPECIFICATIONS

- Includes a BURNY 2.5 Plus Shape-Cutting Control with Jog Keypad. (See the BURNY 2.5 Plus Control data sheet for a complete listing of specifications.)
- Membrane front panel with ISO 7287 international standard symbols.
- Uses 24 volt relay logic to isolate cutting function voltages.
- Plasma relay outputs are:
 - Plasma Start
 - Plasma Stop
 - Height Sensor Disable
- Includes plate marker relay output.
- A two-pole potential free Clutch Switch is wired to the motor connectors.
- BURNY 1250 Plus includes a 120 watt Pulse-Width-Modulated (PWM) DC drive.
- Speed reference card provides High and Low speed reference adjustments.
- Includes standard RS232/422 adapter.
- Speed Range Select is a three-position toggle switch.

• Up	Maintained High	Speed Reference is in High Range
• Middle	Maintained Low	Speed Reference is in Low Range
• Down	Maintained Off	Speed Reference is Zero
- Lifter switch is a three-position toggle switch.

• Up	Momentary On
• Middle	Maintained Off
• Down	Momentary On
- Speed adjustment potentiometer.

• Range	0 - max. speed	Controls machine speed during cutting and jogging
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- Incoming power can be 115 or 230 volts AC 50/60 Hz (internally selectable).
- Internal cooling fan is used to provide air circulation.
- Large Emergency Stop push-button on the side of the control stops machine motion and turns off cutting process.
- Enclosure is dust tight and the connectors, transformers, fuses, door and hinge are gasketed.
- Enclosure is 16-gauge cold rolled steel and plated and painted to provide a high level of corrosion protection.
- Panel base plate is 0.125" aluminum and the graphics layer is 10 mil polycarbonate. The panel is textured and highly scratch and chemical resistant.
- Special precautions have been taken to guard against high frequency plasma noise.
- Grounding screws are provided to attach the 360 degree cable clamps to the back of the enclosure.
- Four holes are provided on the bottom of the enclosure for ease of mounting.
- BURNY 1250 Plus can also support a single oxyfuel torch instead of a plasma torch.

Cleveland Motion Controls, Inc.
7550 Hub Parkway
Cleveland, OH 44125
tel: 216.524.8800 or 800.321.8072
burnysales@itt.com

KALIBURN, Inc.
455 Fleming Road
Charleston, SC 29412
tel: 843.795.4286 or
800.252.2850
kaliburn.sales@itt.com
www.burny.com

ITT Control Technologies GmbH
Werkstrasse 5
D-64732 Bad Koenig, Germany
tel: +49 6063 9314 0
burny.de@itt.com