

# Pressroom Electronics, Inc.

## Presscommander Touch Panel PC Remote Display

### Configuration and Operations



PN# 28-163R5

## Pressroom Electronics, Inc.

### Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

- The Touch Panel PC is 10.1" fully functional 4 core Windows Embedded computer that is powered by 12vdc (3A) to 24vdc (1.5A). It is switched via Terminal#3 (System OFF/ON keyswitch)
- Not necessary, but you can add a mouse or keyboard via the 2 USB ports.
- You can use the Presscommander Offline Job programmer (goto <http://pressroomelectronicupdates.com> user:level2 pass: 9742tri for videos) via either the USB or Serial port on the Touch Panel PC and the software already installed.
- Connection to the Presscommander and/or your network is via the Ethernet port, or wi-fi USB option. Wi-Fi module must be installed on the outside of your Metal enclosure. A Wired Ethernet is the preferred solution.
- When connected to your network, you can view other computers on your network and they can view you as "HMI000x-PC" on the network. Only the folder c:\pcslogs\ is available to anyone on the network using User Name: hmi719 and Password: hmi719
- Right Mouse Click: Touch and HOLD until a full circle appears around your finger, then release.

- 
- To use the Touch Panel PC as a Remote Display for the Presscommander, the Presscommander must have the Ethernet option installed.
  - The Presscommander Ethernet option must be enabled via the Blue PCS Display Keypad Unit menu. Use the Key to put the Display unit in PROG mode. Push the "OPTIONS" button 6 times. Cursor over to the right side of the word "TCP" and press "ENTER"
  - **Your Windows Touchscreen is preprogrammed with a fixed IP address of 192.168.0.140. So that the Touchscreen and Presscommander can talk to each other without need for connection to an external network. You will want to set this back to a DHCP "Obtain IP automatically" if you connect this system to your router network.**
  - **Your Presscommander Ethernet is preprogrammed with a fixed IP address of 192.168.0.141 and web port# 81, Data port# 231. This must remain fixed with this IP so the Windows PCS application can communicate with the PCS.**
  - **The Fixed IP can be changed using DeviceInstaller (found on desktop), but you will need to alter the C:\pcslogs\REASON\_CODES\_192.168.0.141.TXT file by editing and changing the IP address inside this file to match your new IP.**
  - **If your company network is not on the 192.168.0.xxx subnet, you must go into the Touchscreen Network Connections and change the TCP/IPv4 subnet mask to allow this subnet. (i.e. 255.255.0.0)**
  - The following pages will explain the operate of the Remote Display (see also YouTube video. Search Presscommander)

## Pressroom Electronics, Inc.

### Presscommander Ethernet/Wi-Fi Remote operator station and Down-Time Monitor

Fully functioning Windows 7 Industrial fanless multi-touch panel PC with 32GB Solid-State memory, USB, Ethernet, Optional Wi-Fi, Optional Wi-Fi bridge, Internet Explorer 10, Java, Open Office, Adobe Flash, and Adobe reader

You can connect to your company network, just like any other PC. You can see and be seen, just like any other PC (with proper setup)

Free OpenOffice version of Excel, called "Calc"

Saved Internet Link to Demo Presscommander (located at the factory) (see Page 2)

The Presscommander Offline Job Programmer (see Page 5)

Program to find the Internet Address of your Presscommander (see Page 6)



Terminal program if a Firmware update is ever needed

Folder that contains the LOG files. (The .CSV files will open in Excel) (see Page 3)

Tap 1 time to bring up a full keyboard (if it doesn't automatically pop up)

## Pressroom Electronics, Inc.

### Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Note: Key on Blue PCS keypad unit must be in RUN position while at this TouchPanel

Note: The LOCK ring and Fault Reset ring must be Blue or Green before changing most values

Touchscreen RUN/SETUP key: Turn to SETUP to change most values. Some critical value require a FULL UNLOCK password.

FULL UNLOCK: Enter in 5 digit code to unlock. First 3 digits are the password you may have assigned at the PCS Keypad Display Unit, followed by 63

If don't assign a password then enter 00063 to Full Unlock.

If you assigned a password of 435, then enter 43563 at the Touchscreen for Full Unlock

Red: Locked password protected. Touch Lock and enter 5 digit password  
Green: Unlocked. Touch Lock & ENTER to relock  
Black: Waiting for 5 digit code  
Blue: Keyswitch in SETUP

Red: Fault. Touch button & ENTER to Reset (must be unlocked first)  
Grn: No Fault

Touch a White Field & ENTER to change value

Touch a White Field & ENTER to Reset value

Touch this button 2 times to see the active FAULT screen

The screenshot shows the 'PCS Remote Display' window. The main area displays machine parameters: Operator #, Job #, Job Name, Strokes, Parts, Batches, Batch Size, Quality, Quantity Left, and Press Status. Below this are two monitors: 'Brake Monitor (mSec)' with Last Stop, Warn Set, and Fail Set values; and a central display showing Run Time, Down Time, Standby Time, Good PR, PPI, MPR, Avail, Perf, and OEE. At the bottom, there are three large digital displays for ANGLE, SPM, and Shut-Height, along with a POS indicator and a red 'Operator Downtime Reason Code' button. On the right side, there is a numeric keypad (0-9) with a 'Lock' button (red ring) and a 'Reset Fault' button (green ring). Below the keypad is a large 'ENTER' button and three 'PAGE' buttons: 'PLS/DIE', 'Tonn/Servo', and 'Other'. At the very bottom, it shows 'Logging started: 12/11/15 9:20:59 AM', 'Log Entry # 1', and 'IP address connected to: 192.168.0.141'.

Requires unlock 5 digit code for WARN and FAIL Brake monitor setpoints

Touch to Navigate to other screens (note: the button descriptions change depending on the page you are on)



## Pressroom Electronics, Inc.

### Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

#### Production & Downtime Monitor with Overall Equipment Effectiveness.

The User must calculate the PPT (Planned Production Time) for either the Shift, the Job, or the Operator (in Minutes). PPT is the best case scenario production time in MINUTES.

Example: PPT = Shift 480min – normal breaks 30min – normal lunch 60min – maintenance 40min = 350min

The User must calculate the MPR (Maximum Production Rate) for the current Job. This is based on SPM of the Job, wear of the die, material quality. MPR is best case scenario for PARTS / MINUTE

Example: MPR = 100 parts/minute (when press is running)

Run Time: Increments when the Press is cycling in SINGLE or CONT modes (in Hours:Min:Seconds)

Down Time: Increments when either a Down Time Reason Code is active or a Fault has occurred.

Standby Time: Increments when the Press is simply idle.

Touching any timer will allow you to RESET them back to 0:0:0

Good PR: is the Production Rate of parts, based on values found in the Parts, Run, Down, and Standby timers. Normally the internal parts counter follows the stroke counter. To filter out bad parts, you would need to use Die#6 set to CNT. Input to Die#6 would then be used to determine a good part (pulse for every good part vs no pulse for bad parts).

Avail: Availability% is based on the Run, Down, and Standby timers vs PPT.

Perf: Performance% is based on the Good PR vs MPR

OEE: Overall Equipment Effectiveness is based on Avail and Perf together.

Operator Downtime Reason Code: Touch to Enter Downtime Reason for a list of Codes. Codes can be customized.

The screenshot displays the 'PCS Remote Display' window for 'Pressroom Electronics'. The interface is divided into several sections:

- Operator Information:** Operator #: 0, Job #: 1, Job Name: ----, Strokes: 50, Parts: 50 /1, Batches: 0, Batch Size: 1000, Quality: 50000, Quantity Left: 49950, Press Status: SINGLE.
- Brake Monitor (mSec):** Last Stop: 221, Warn Set: 270, Fail Set: 350.
- Timers and Performance:** Run Time: 0000:00:28, Down Time: 0000:00:00, Standby Time: 0000:00:21, Good PR: 06409 /hr, PPT: 0420, MPR: 060, Avail: 99%, Perf: 176%, OEE: 174%.
- Positioning:** POS. (circular indicator), ANGLE: 001°, SPM: 000, Shut-Height: +01.145.
- Operator Downtime Reason Code:** A red button labeled 'Operator Downtime Reason Code'.
- Navigation and Control:** A numeric keypad (1-9, 0, Lock, Reset Fault), an 'ENTER' button, and 'PAGE' buttons for 'PLS/ DIE', 'Tonn/ Servo', and 'Other'.
- Footer:** service@pressroomelectronics.com • www.pressroomelectronics.com, Logging started: 12/11/15 9:20:59 AM, Log Entry #: 1, IP address connected to: 192.168.0.141.

Arrows from the text blocks point to specific elements in the interface: PPT points to the PPT value (0420), MPR points to the MPR value (060), Avail points to the Avail percentage (99%), Perf points to the Perf percentage (176%), OEE points to the OEE percentage (174%), and the Operator Downtime Reason Code text points to the corresponding red button.

## Pressroom Electronics, Inc.

### Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

#### Production & Downtime Monitor with Overall Equipment Effectiveness.

The Operator can Touch any Red Button to select the current Down Time Reason.

Once a Reason Code is touched, you will go back to the MAIN screen and the STATUS line will reflect the Code.

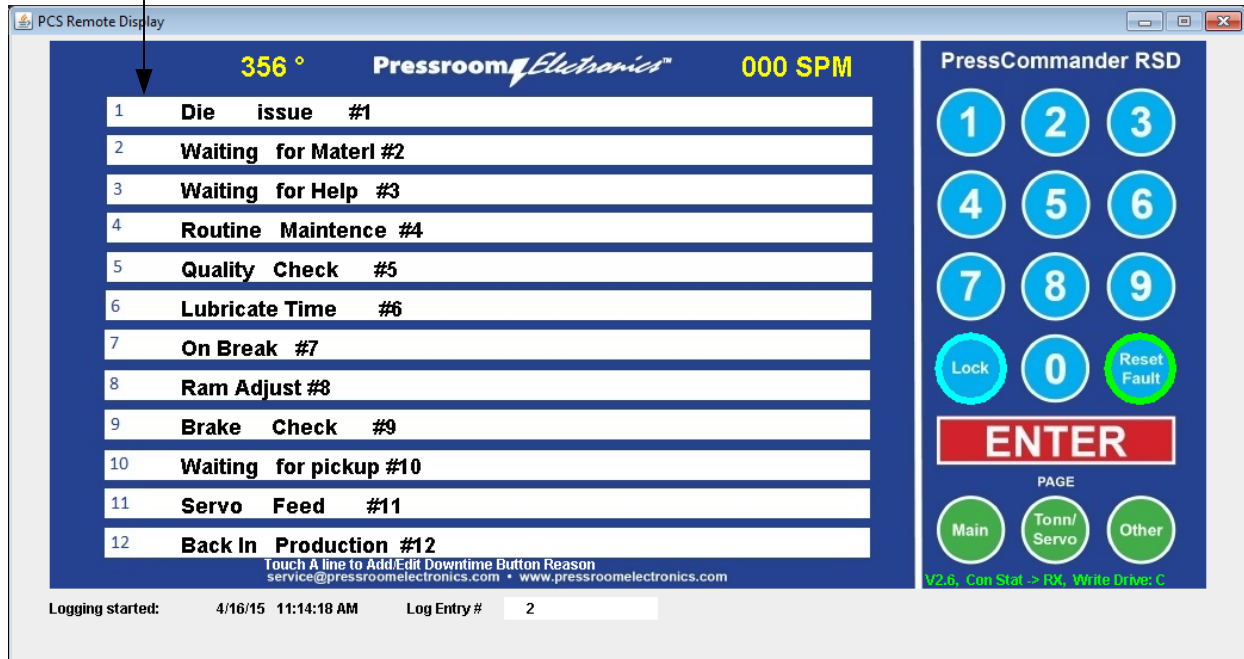
The Last Red Button will release the Press back into Production, or Cycling the Press with the KEY in RUN mode.

Cycling the Press with the KEY in PROG mode will not remove the Reason Code.



This list can be customized by Touching the Square Green button, while the Remote is UNLOCKED.

A virtual keyboard will appear and you can alter 1 – 11 (12 cannot be altered)



**Pressroom Electronics, Inc.**  
**Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor**

**Programmable (Dry contact Relay) outputs and Die Inputs**

**LS1-LS6 (expander adds LS7-12)  
Die1-Die6 (expander adds Die7-12)**

The screenshot displays the 'PressCommander RSD' software interface. At the top, it shows '356 °' and '000 SPM'. On the left, a 'KEY' section explains abbreviations: PLS \* = RLY ON, Spd \* = Speed Comp ON, CLS-OPN = In DEG., DLY-HLD = Cycles, and TIM = Time in 100thSec. Below this is a green circle labeled '7-12'. The main area contains two tables. The top table lists outputs (LS1-LS6) with columns for NAME, Spd, CLS-OPN, CLS-OPN, DLY-HLD, CLS-TIM, and PLS. The bottom table lists inputs (SEN1-SEN6) with columns for NAME, TYPE, STP, BGN-END, WND, FLT, and DIE. On the right, a numeric keypad (1-9, 0, Lock, Reset Fault) and an 'ENTER' button are shown, along with 'PAGE' buttons for Main, Tonni/Servo, and Other. At the bottom, status information includes 'Logging started: 11/17/21 9:25:51 AM', 'Log Entry # 1', and 'IP address connected to: 192.168.0.141'.

	NAME	Spd	CLS-OPN	CLS-OPN	DLY-HLD	CLS-TIM	PLS
1	LS1		000 - 050	000 - 000	000 - 000	000 - 000	
2	LS2		050 - 100	000 - 000	000 - 000	000 - 000	
3	LS3		100 - 150	000 - 000	000 - 000	000 - 000	
4	LS4		150 - 200	000 - 000	000 - 000	000 - 000	
5	LS5		200 - 250	000 - 000	000 - 000	000 - 000	
6	LS6		320 - 020	000 - 000	000 - 000	000 - 000	*

	NAME	TYPE	STP	BGN-END	WND	FLT	DIE
1	SEN1	MOM	E	000 -000			
2	SEN2	MOM	E	000 -000			
3	SEN3	MOM	E	000 -000			
4	SEN4	MOM	E	000 -000			
5	SEN5	MOM	E	000 -000			
6	SEN6	MOM	E	000 -000			

You can change the name of both Output and Input sensors

ON/OFF Status of each Die input and PLS output

Fault Status

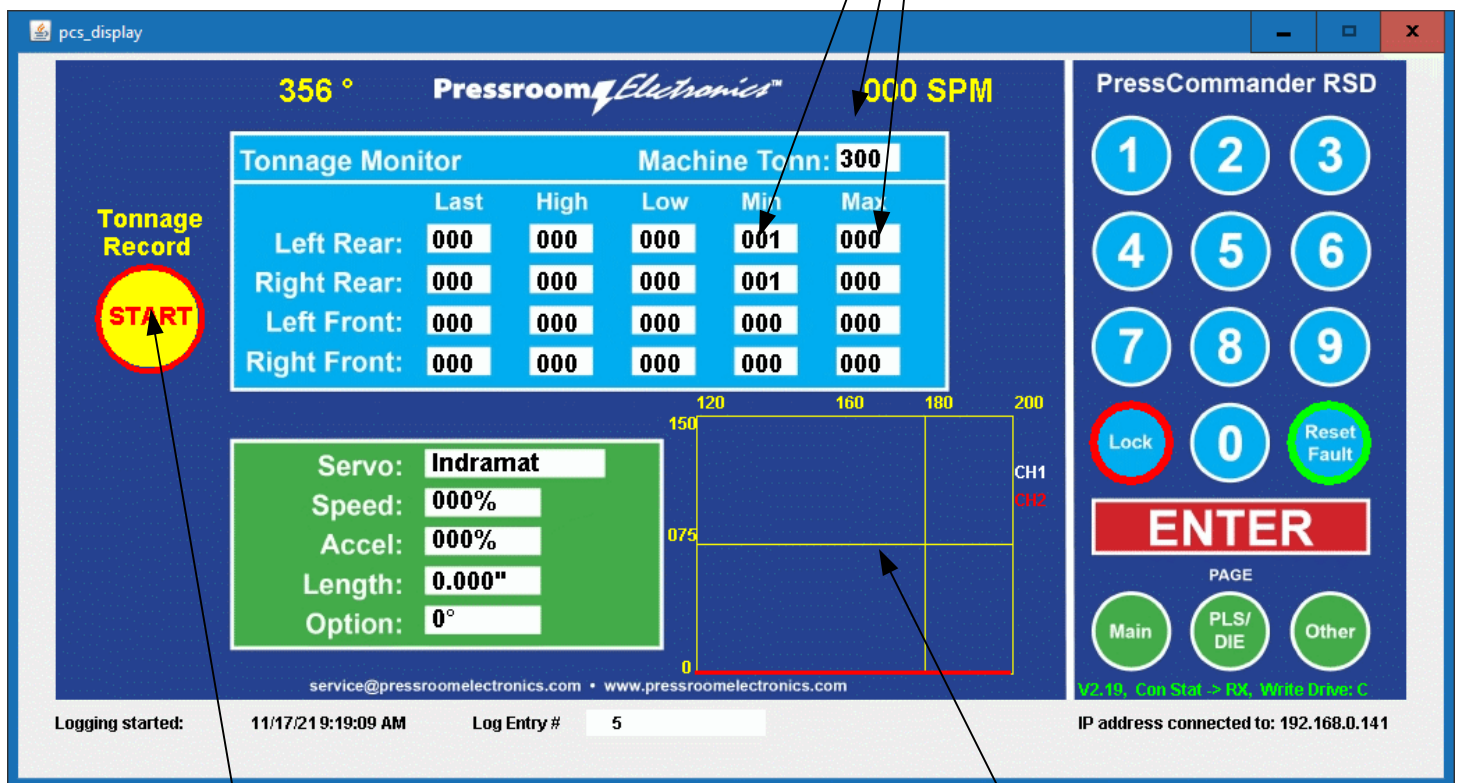


**Pressroom Electronics, Inc.**  
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**Tonnage and Servo screen**

Enter Values for Job.

Note: A MIN > 0 is required to activate channel



Touch to Start/Stop recording tonnage profiles to a CVS spreadsheet. 100 cycle max

Signature of Tonnage sensors for the last cycle. Displaying Tonn vs angle



**Pressroom Electronics, Inc.**  
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**Setup and input status Screen**

Job Min/Max Press speed

Angle to Command a STOP

Angle for Mute and auto return

Optional CONT mode STOP angle for very fast machines

The screenshot shows the 'PressCommander RSD' interface. At the top, it displays '356 °' and '000 SPM'. Below this is a 'Press Control (deg)' section with fields for Min Speed (005), Max Speed (140), Motion Det (0.5), Spd Comp (000°), pclick, Job Rst, Stop (290°), By-Pass (180°), Limit (010°), and Die-Tstp (000°). There are checkboxes for pclick, Job Rst, and Spd On. Below the control section is an 'OPTO INPUTS' section with four binary strings: 01100001, 00000110, 11111000, and 00000000. At the bottom left is a 'Set TDC:' field. The bottom status bar shows 'Logging started: 11/17/219:19:09 AM', 'Log Entry # 5', and 'IP address connected to: 192.168.0.141'. On the right is a numeric keypad with buttons 1-9, 0, Lock, Reset Fault, and an ENTER button. Below the keypad are three circular buttons labeled 'Main', 'PLS/ DIE', and 'Tonn/ Servo'. The text 'V2.19, Con Stat -> RX, Write Drive: C' is visible at the bottom right of the keypad area.

Must use 5 digit password to unlock first. Touch here, then hit ENTER to ZERO "0" resolver

Status of all 32 Opto inputs 1-32

Angle at which a STOP Die fault will change to TSTOP to prevent jams

Position based Brake monitor fault limit

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## Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Double Tapping the pcslogs folder icon on the desktop brings you here.

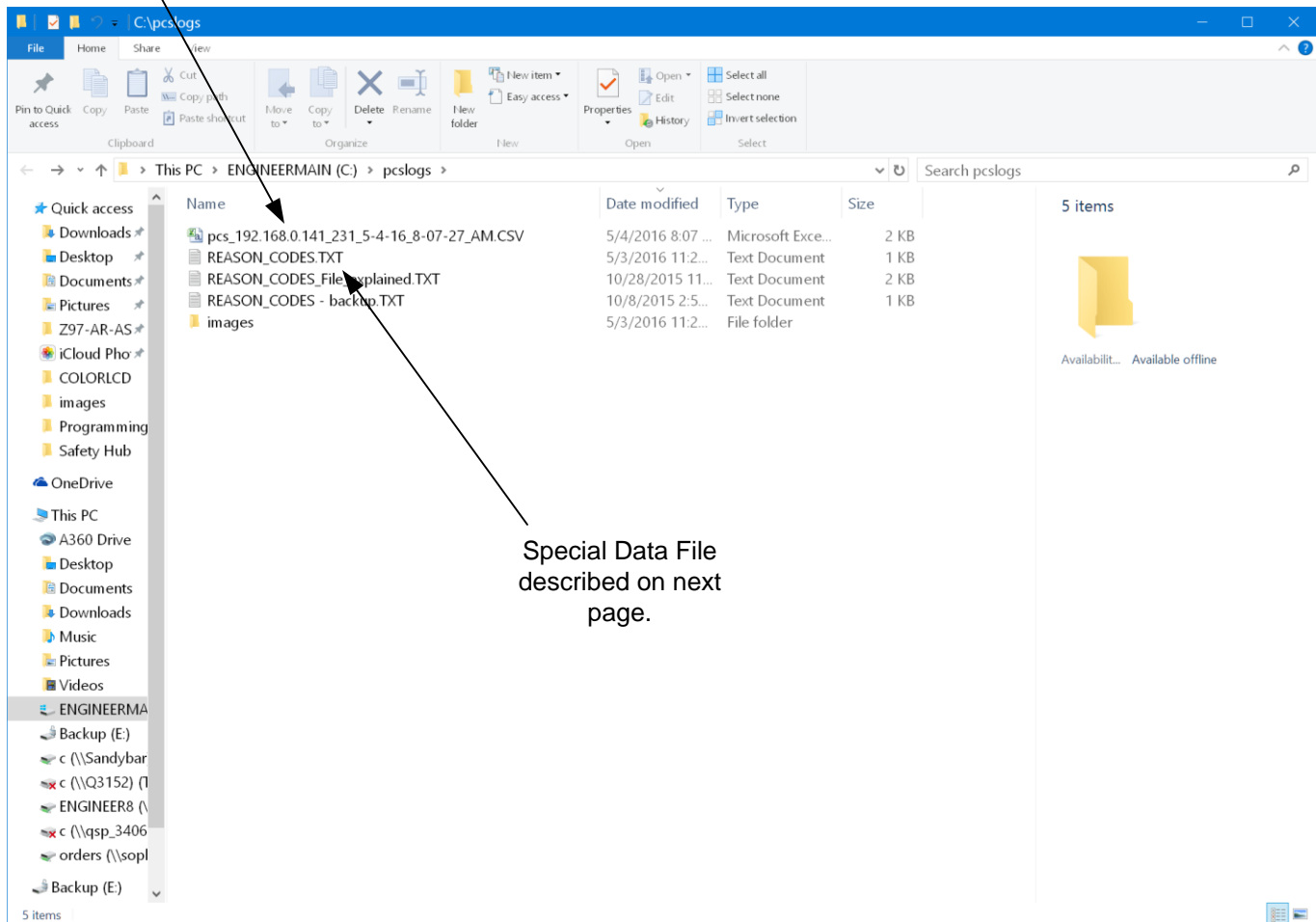
Do not attempt to open any of these files while the Internet Connection to the Presscommander is open and running.

The best way to view the file with an OPEN connection, is to make a copy of the file

### COPY/PASTE on a Touch Screen:

Double Tap the .CSV file to open the file in OpenOffice Calc or Excel

HOLD your finger on the File (until a full circle appears around your finger) and the pop up menu appears.  
Select either COPY or PASTE



Like any Windows PC, you can setup Windows to allow Outside access to this folder. See your IT person to help set this up for you.

OR

You can Map a Network Hard Drive (NAS) and have the Logs directly written to your Mapped Drive instead of locally on the Touch Screen Drive. The next page describes this.

## Pressroom Electronics, Inc.

### Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

“REASON\_CODES\_192.168.0.141.TXT” file contains all your downtime reason codes and various other information described below:

Line 1: Downtime reason code #1

.  
.

Line 24: Last reason Code #24

Line 25: The Drive Letter to locate the LOG files:

C indicates the files will be written to C:\pcslogs

Z indicates the log files will be written to Z:\pcslogs

Line 26: PPT value for production monitoring

Line 27: MPR value for production monitoring

Line 28: IP address of your PressCommander

Line 29: IP Data Port# of your PressCommander

```
REASON_CODES_File_explained.TXT - Notepad
File Edit Format View Help
You can alter Reason codes, LOG file Driver letter, Shift Operating Time, and Max Part Rate directly on the REASON_CODES.TXT file (NOT THIS FILE)

1st reason code      (first 10 characters are first line, next 20 characters are second line)
2nd reason code
3rd reason code
4th reason code
5th reason code
6th reason code
7th reason code
8th reason code
9th reason code
10th reason code
11th reason code
12th reason code     (this line should always say: "Back In  Production  #12")
13th reason code
14th reason code
15th reason code
16th reason code
17th reason code
18th reason code
19th reason code
20th reason code
21th reason code
22th reason code
23th reason code
24th reason code     (this line should always say: "Back In  Production  #24")
C                    (this is the DRIVE letter of where to store LOG files)
123                  (this is PPT, which is the best case amount of time available to operate the press - breaks and lunch and maintenance )
50                   (this is the MPR (Max Parts / Minute) that you would expect)
192.168.0.10         (this is the IP address of the Presscommander you want to connect to)
230                  (this is the Data Port of the Presscommander you want to connect to)
line30              (Reserved)
```

Only Lines 25, 28,29 need to be directly modified by text editor. The other lines are modified from within the Remote Touch Screen program

NOTE: The IP address is in the REASON\_CODES file name so you can run multiple Touchscreen units on the same network.

Even if you need to change the IP address of the PCS unit, do not change the file name, just the IP address inside this file.

After making a copy of the .CSV file and then Double Tapping on the file copy, you will open up “Calc” automatically and this is something like what you will see

The screenshot shows the Microsoft Excel interface with the following details:

- Title Bar:** pcs\_192.168.0.132\_230\_4-25-14\_2-38-38\_PM - Copy.CSV - Microsoft Excel
- Ribbon Tabs:** Home, Insert, Page Layout, Formulas, Data, Review, View, Add-Ins, QuickBooks.
- Formulas Tab:** Includes options for Width, Height, Scale, Gridlines, Headings, Bring to Front, Send to Back, Selection Pane, Align, Group, Rotate, and Arrange.
- Name Box:** A1, Logging Started: 4/25/14 2:38:38 PM
- Worksheet Content:**
  - Row 1: Logging Started: 4/25/14 2:38:38 PM
  - Row 2: MESSAGES AND FAULTS:
  - Row 3: Operator Change
  - Row 4: 4/25/2014 14:38 4/25/14 2:36 4/25/14 2:3 4/25/14 2:3
  - Row 5: Initial Log
  - Row 6: Unlocked some Fields
  - Row 7: Op# Change
  - Row 8: job# Change Req
  - Row 9: New job#
  - Row 10: Current



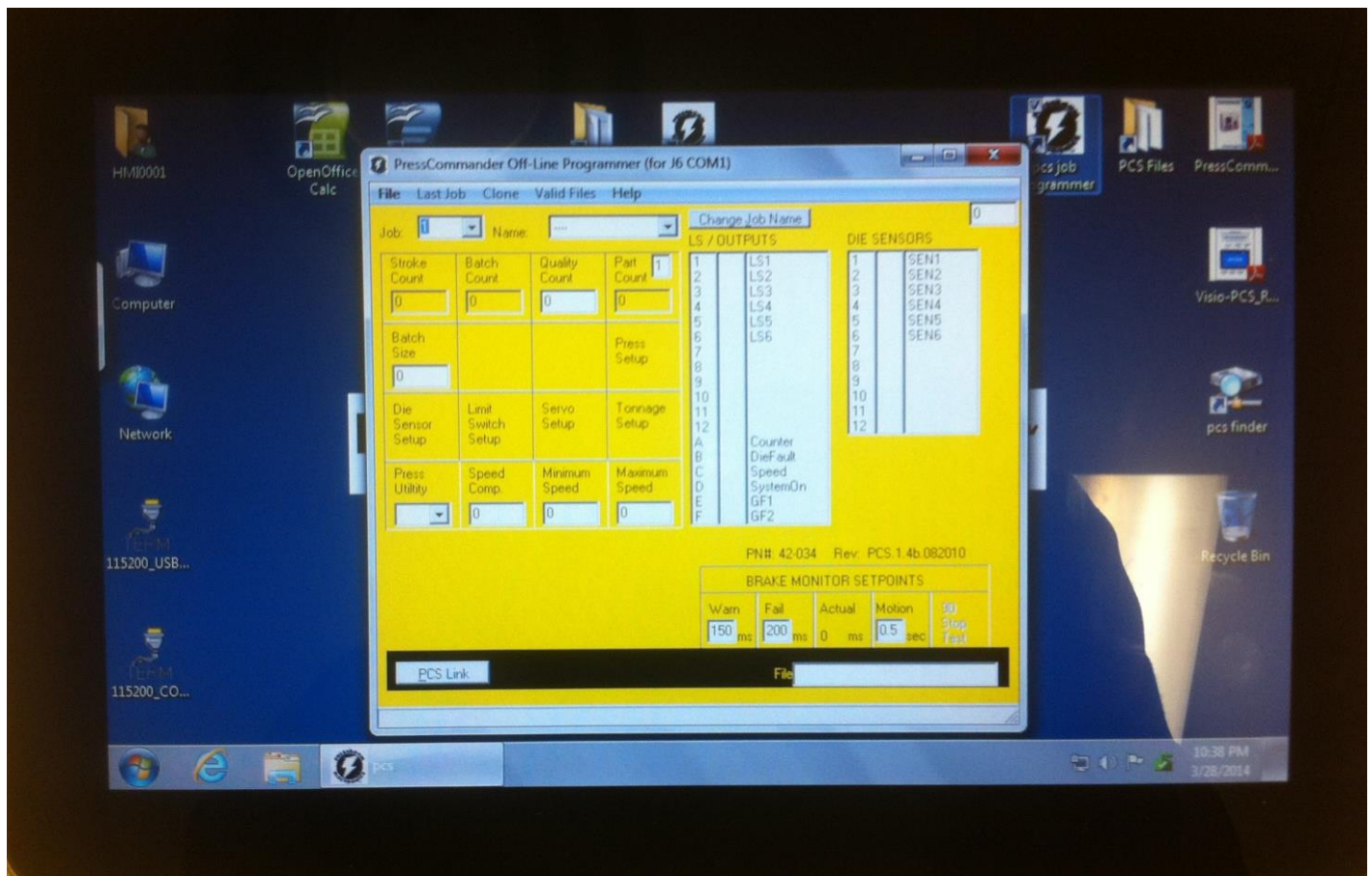
## Pressroom Electronics, Inc.

### Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

The Presscommander OFFLINE Job(s) Programmer connects to the Presscommander via either USB or Serial COM port.

Go into the PCS FILES folder for documentation

This Job Programmer allows for backup storage of the Jobs that are contained in the Presscommander (PCS) DISPLAY UNIT.

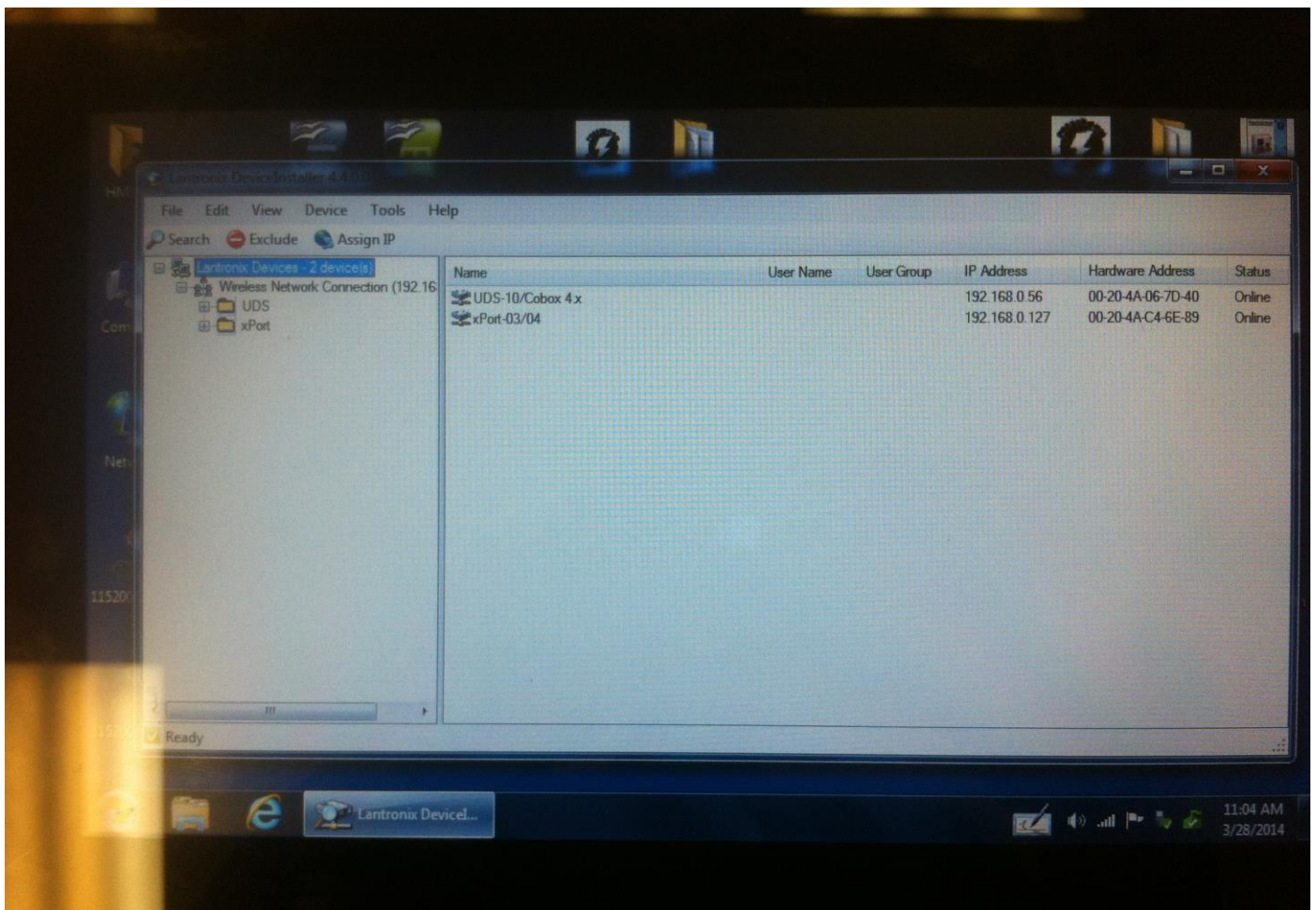


## Pressroom Electronics, Inc.

### Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

The Presscommander (PCS) finder searches your network to find the Internet address (IP) of all your Presscommanders that are connected to the same network.

It is possible to SET an IP address permanently if you don't have a DHCP server on the network

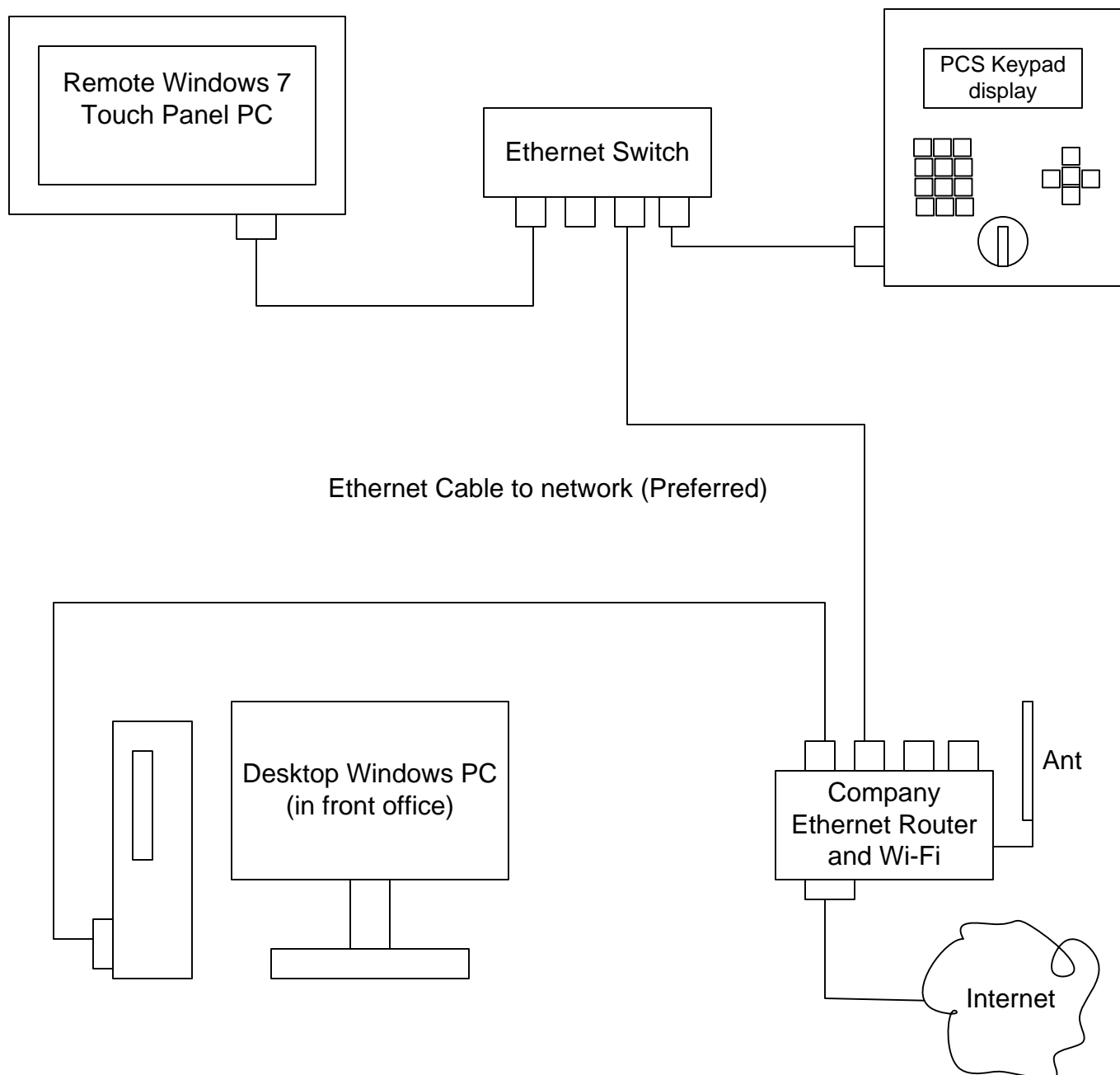


**Pressroom Electronics, Inc.**  
**Presscommander Ethernet/Wi-Fi Remote operator station and Down-Time Monitor**

Please note that some knowledge of Ethernet and Router configuration is required.

There are many possible configurations of the Presscommander with the Remote Touch Panel PC Display.

Below is the **preferred configuration**: Hard wired Ethernet cable between all devices with inexpensive Ethernet Switches and routers. Access to the PCS can be obtained from the Touch Panel, Office PC, and over the Internet

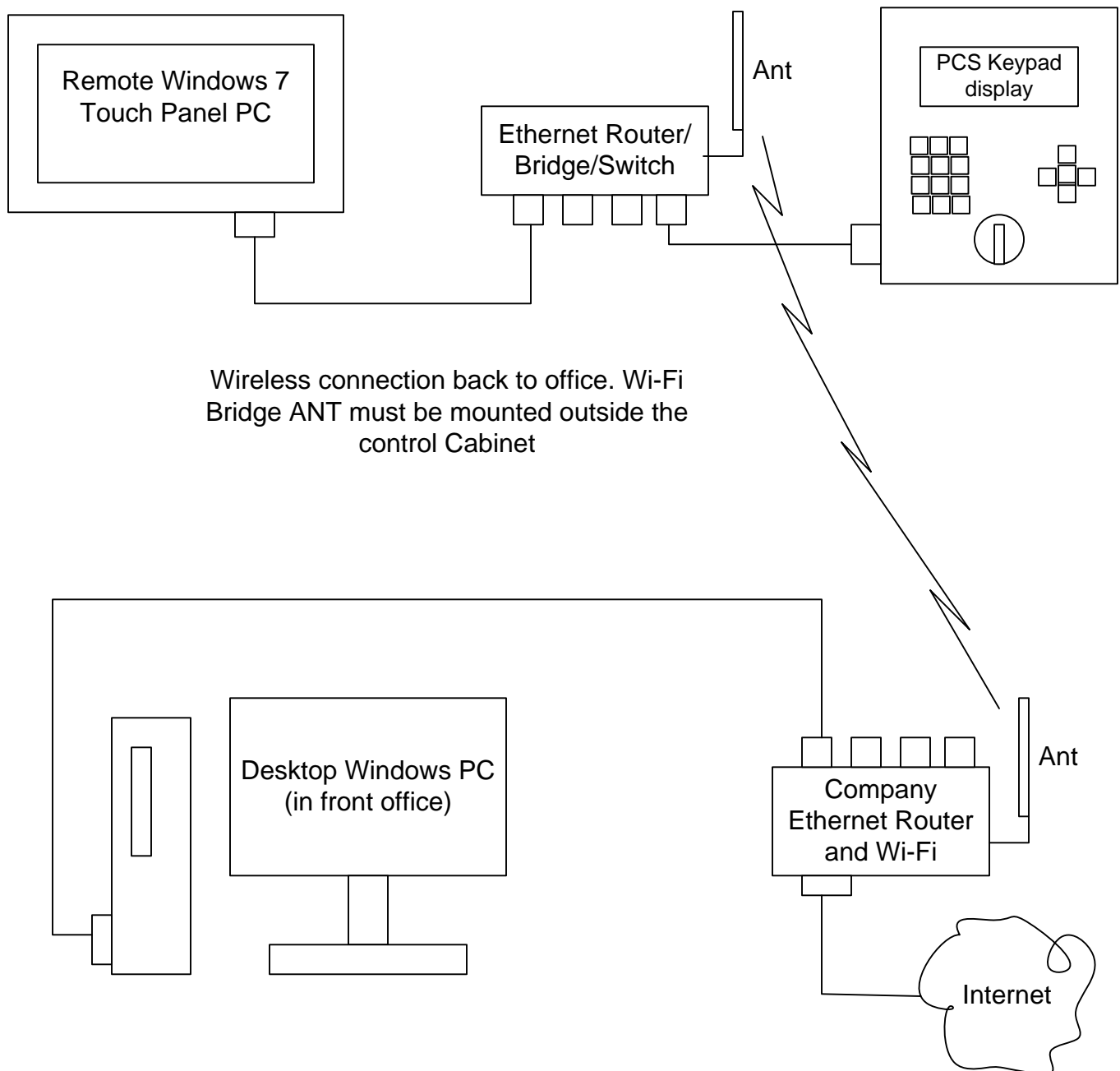


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There are many possible configurations of the Presscommander with the Remote Touch Panel PC Display.

Below is much less preferred configuration: Hard wired Ethernet cable between the Touch PC and PCS, but Wi-Fi back to the front office. Wi-Fi performance and connection issues.



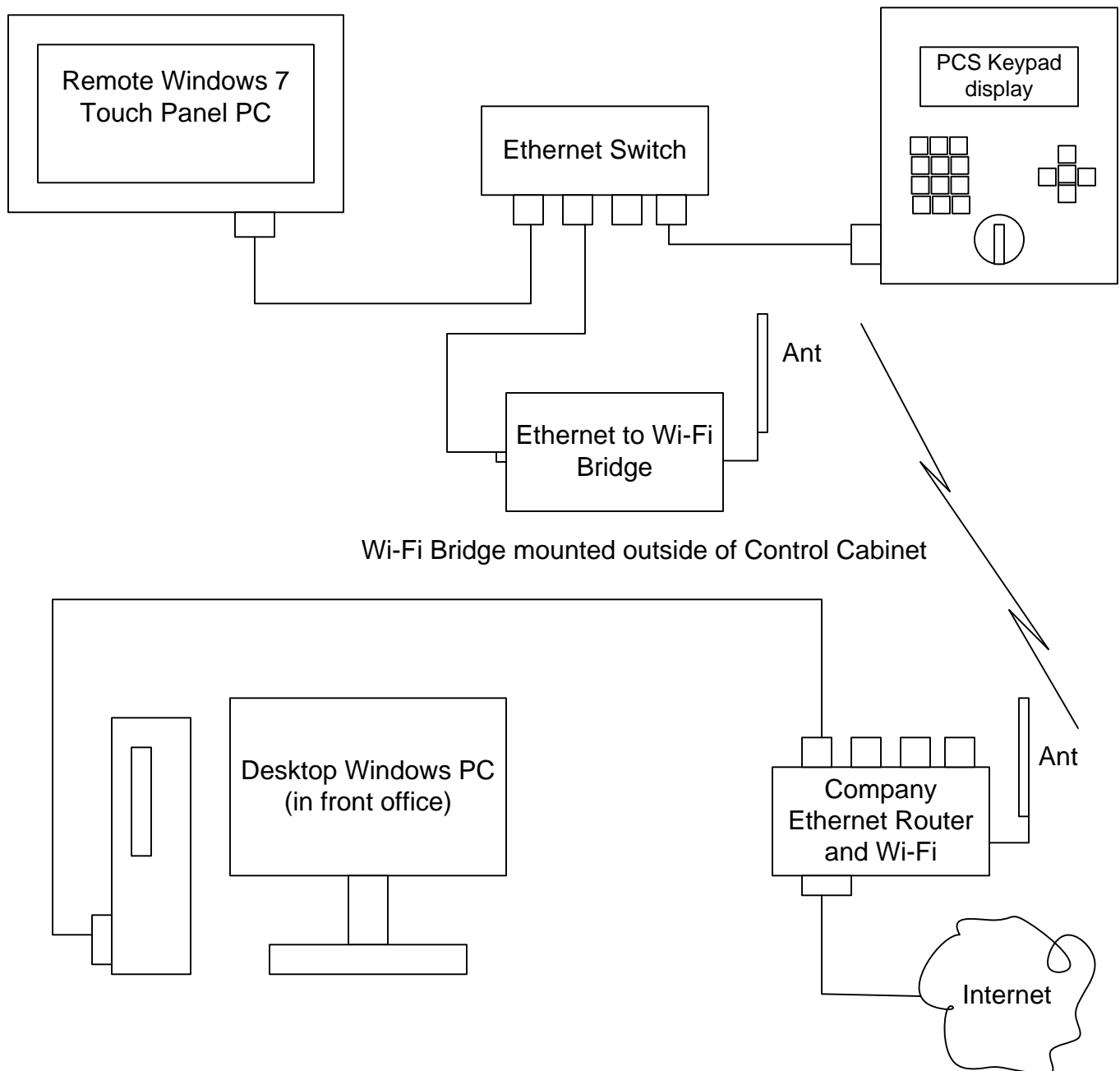


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## **Presscommander Ethernet/Wi-Fi Remote operator station and Down-Time Monitor**

### Connecting the Presscommander to your Network

- A) Touch Panel PC Remote Display and Ethernet Enabled Presscommander**
- B) Ethernet Enabled Presscommander ONLY**

#### Wired Setup (standard hardware):

Simply connect your networks CAT 5e Ethernet Cable to: an open port on the Ethernet Switch provided with option A) or the Ethernet Jack on the side of the Presscommander Display Unit with option B)

#### Wi-Fi Bridge Setup (this is OPTIONAL hardware):

Follow the instructions that come with the Bridge before plugging it into anything.

You will need to plug the Bridge into your laptop to set it up to automatically connect to your networks Wi-Fi. This requires you to know the SSID of the Wi-Fi network and its password.

You will then need to pick a location to install the Bridge device. Avoid high power or high voltage devices (i.e. motors, starters, drives, high voltage lines).

Connect the Wi-Fi Bridge Ethernet jack to any open port on the Ethernet Switch with option A) with Cat5e cable, or the Ethernet Jack on the side of the Presscommander Display Unit with option B)

#### Presscommander Ethernet IP Address:

**NO NETWORK:** If you have option A) Touch Panel PC with the Presscommander, but do not connect it to your network, your Presscommander will be assigned an IP automatically (i.e. 169.xxx.xxx.xxx). You will not be able to connect to the Internet itself, but the Touch Panel PC will be able to Remote Display the Presscommander.

**NETWORK:** Whether you have Option A) or B), once connected to your Network, your Networks Router will supply an Internet IP address to your Presscommander.

#### Finding the Presscommander Ethernet IP Address:

On the Touch Panel PC Click to Run “tcp ip finder” app from the Desktop

On a laptop PC you must download and install DeviceInstaller.exe from Lantronix

Either program will allow you to find the IP address of the Presscommander based on the MAC ID. The MAC ID is written on a label on the backside of the Presscommander Display unit and on the Ethernet Jack of the Presscommander itself (with aluminum cover removed).

You can keep the IP address from changing by going to your network router and assigning the IP address as STATIC

[www.pressroomelectronics.com](http://www.pressroomelectronics.com)

# Pressroom *Electronics*™

## WARRANTY

Manufacturer warrants that this product will be free from defects in material and workmanship for a period of one year from the date of shipment thereof. Within the warranty period, manufacturer will repair or replace such products which are returned to it with shipping charges prepaid and which will be disclosed as defective upon examination by the manufacturer. This warranty will not apply to any product which will have been subject to misuse, negligence, accident, restriction, and use not in accordance with manufacturer's instructions or which will have been altered or repaired by persons other than the authorized agent or employees of the manufacturer.

## DISCLAIMER

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**WARNING:** The entire machine safety system must be tested at the start of every shift. Machine testing should include: (1) proper machine operation and stopping capability; and (2) verification of proper installation and settings of all point of operation guards and devices before the operation is released for production.

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## Additional products to achieve your **Total Safety Solution!!!**

- Safety Light Curtains (All Types and Styles)
- Universal Safety Controller HUB / Safety PLC
- Safety Mat Systems and Controls
  - Area Guarding Systems
  - NSD Safety Mat Systems
  - STTS Safety Mat Systems
  - Direction of Travel Mats
  - High-Temp Welding Mats
- Ergonomic Palm Buttons
  - UltraTouch Palm Buttons
- Safety Interlock Switches (including explosion proof)
- Customized "control reliable" controls for dual solenoid activated pneumatic and hydraulic valve applications
- Fencing with Interlocks
- E-Stop Buttons
- Stack Lights

- Energy Isolation and Single Point Lockout Systems
- Plant Surveys, Risk Assessment & Installation Services
- Customized Control Panels; Stainless Steel enclosures available for all products

### Punch Press / Metal Stamping Industry

- Resolver or Rotary Cam Based Clutch / Brake Controls - OSHA/ANSI Compliant
- Punch Press Automation Controllers
- Time-Based Brake Monitors
- Programmable Limit Switches
- Die Protection & Tonnage Monitoring Systems
- Servo Feed Interfaces

### Press Brake Guarding and Controls

- Press Brake Guarding for Mechanical, Air Clutch and Hydraulic Press Brakes
- Press Brake Control Systems



# Pressroom Electronics™

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