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## BURNY 1250 Plus

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

### 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.

## BURNY 1250 Plus is an economical fully-integrated shape-cutting control & drive system



### 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.

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