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(71) Applicant(s):

KOMATSU LTD. [JP/JP]; 2-3-6, Akasaka, Minato-ku, Tokyo 1078414 (JP) *(for all designated states except US)*

KOMATSU INDUSTRIES CORP. [JP/JP]; 5 Jigata, Yokaichi-machi, Komatsu-shi, Ishikawa 9230868 (JP) *(for all designated states except US)*

SUZUKI, Yuichi [JP/JP]; c/o Komatsu Plant of KOMATSU INDUSTRIES CORP., 5 Jigata, Yokaichi-machi, Komatsu-shi, Ishikawa 9230868 (JP) *(for US only)*

(72) Inventor(s):

SUZUKI, Yuichi; c/o Komatsu Plant of KOMATSU INDUSTRIES CORP., 5 Jigata, Yokaichi-machi, Komatsu-shi, Ishikawa 9230868 (JP)

(74) Agent(s):

KINOSHITA & ASSOCIATES; 3rd. floor, Ogikubo TM building 26-13, Ogikubo 5-chome Suginami-ku, Tokyo 1670051 (JP)

(54) Title (EN): DIE CUSHION CONTROL DEVICE

(54) Title (FR): DISPOSITIF DE COMMANDE D'AMORTISSEMENT DE FILIÈRE

(54) Title (JA): ダイクッション制御装置

(57) Abstract:

(EN): A die cushion control device (40) for controlling the moving up/down speed of a die cushion pad(15) based on specified pressure pattern (56) and positional pattern (54), wherein a position/pressure control switching unit (51) always monitors and compares a pressure-use speed command signal #pc according to a pressure deviation signal ep and a position-use speed command signal vhc according to a position deviation signal eh, and selects whichever speed command signal is smaller for sending to a speed control unit (53). Since a pressure-use speed command signal #pc and a position-use speed command signal #hc are always monitored and either one of them is selected, a pressure change and a position change can be recognized accurately to allow switching between a pressure control and a position control quickly, constantly and positively.

(FR): L'invention concerne un dispositif de commande d'amortissement de filière (40) permettant de réguler la vitesse de montée/descente d'un patin amortisseur de filière (15) sur la base d'un schéma de pression spécifié (56) et d'un schéma positionnel (54), où une unité de commutation de commande position/pression (51) va toujours surveiller et comparer un signal de commande de vitesse utilisant la pression #pc selon un signal d'écart de pression ep et un signal de commande de vitesse utilisant la position #hc selon un signal d'écart de position eh, et sélectionner le signal de commande de vitesse le plus petit pour l'envoyer à une unité de commande de vitesse (53). Dans la mesure où un signal de commande de vitesse utilisant la pression #pc et un signal de commande de vitesse utilisant la position #hc sont toujours surveillés et que l'un d'entre eux est sélectionné, on peut reconnaître un changement de pression et un changement de position de manière précise pour permettre une commutation entre une commande de pression et une commande de position et ce, rapidement, de manière constante et positive.

(JA): 所定の圧力パターン56および位置パターン54に基づいてダイクッションパッド15の昇降速度を制御するダイクッション制御装置40において、位置・圧力制御切換部51は、圧力偏差信号epに応じた圧力用速度指令信号

upcと、位置偏差信号 e hに応じた位置用速度指令信号uhcとを常に監視、比較し、両者のうち小さい方の速度指令信号を選択して速度制御部 5 3 に流す。圧力用速度指令信号upcと位置用速度指令信号uhcとを常に監視しいずれか一方を選択するので、圧力の変化および位置の変化を的確に把握でき、位置制御と圧力制御とを迅速かつ安定して確実に切換できる。

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