



# OPERATING INSTRUCTIONS FOR DIGIREAD S8002 PRESSBRAKE COUNTER

## Technical specifications:

Supply 220VAC 15VA  
Transducer input options  
RS 422 line driver  
Size: 305x190x120mm  
Selection of Pinch point  
or Tool option with a  
10 Tool memory for  
TOP Tool, Bottom Tool  
V size and depth.  
Sheet thickness.

CNT2\_9\_1.CDR



## MODES OF OPERATION:



Axis keys used to transfer values from the keyboard display to the counter or select special functions for the axis.



Numeric keys used to enter data into the keyboard display.



Press E to enter a value on the keyboard or execute a function.

Press C to clear the keyboard display or change a value.

The counter can be set to two different modes of operation. The mode is set with parameter P.15.

Pinch point mode with P.15 set to 0 and Tool mode with P.15 set to 1.

The X axis if enabled is always the backstop axis and the Y/Z axis is always the tool axis displaying the bending angle. The X axis is also used as an alphanumeric display for easier operation. Entered values are displayed on the keyboard display.

## PINCH POINT MODE



The Backstop position is set or reset with the X axis button. The value entered on the keyboard and displayed on the keyboard display is transferred to the backstop axis with the X axis button.



The Vee size is entered with the Y axis button. Press Y and the X axis display will read " U SIZE ". The keyboard display will show the current Vee size. To except the current size press E. To change the size press C and then enter the new size on the keyboard. Except the value with E key. The last selected Vee size is stored in memory and is available after switch off.



The pinch point is set with the Z axis button. Press the Z axis button and the angle display is set to 180.0 degrees.

## TOOL MODE

### Reference point:



For the Tool mode to be active the tool axis has to pass over a reference point to calculate the pinchpoint.

Press R on the keyboard and the LED above the R key will light up. If the backstop axis has been selected the left most decimal point on the X axis will light up. Move the backstop over the reference point and the left most decimal point will extinguish.

The left most decimal point on the Y/Z axis will light up. Move the tool over the reference point and the decimal point and the LED above the R key will extinguish.