

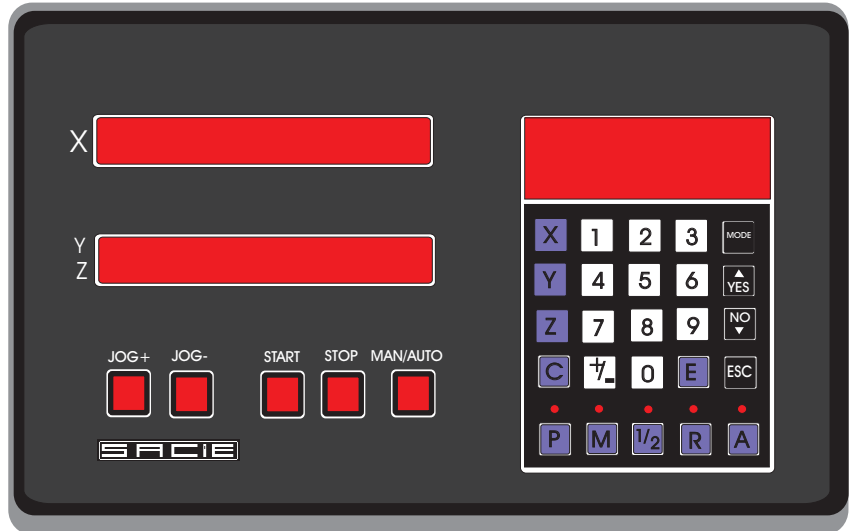
OPERATING INSTRUCTIONS FOR DIGIREAD SEP 80818 CONTROLLER

Technical specifications:

Supply 220VAC 15VA
Transducer input RS 422 Line Receiver
Outputs 8 x 24 VDC 0.2A
Inputs 16 x 24 VDC 0.01A
Size 305x186x110 WxHxD

X axis PID closed loop
Z axis angle display and control
Memory for 50 programs with 9 bends
(angle and backstop positions).
MDI function
Tool memory

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MODES OF OPERATION:

MANUAL/AUTO SELECTOR IN POSITION MANUAL

PROGRAMMING MODE:



Press P on the keyboard and the light next to the P key will light up. The alphanumeric display will read "Enter CODE ". Enter the Code (Password) and press E. If the password is correct the alphanumeric display will read "Enter Prog.No ". Enter a number between 1 and 50. If a number > then 50 is entered an error message "Prog.No ERROR " is displayed. If a correct program number f.ex 8 is entered the axis display will read P.08. The alpha numeric display will show the previously programmed block. If a M function has been programmed it is displayed on the keyboard display.

Press E to advance to the next block or C to edit the block. If C is pressed the alpha numeric display will read "ENTER RETRACT". The keyboard display will display the Retract size. To accept the size press E or C to clear the size and then enter a new size. Press E to enter. The alpha numeric display will show the programmed block. Press E to advance to the next block or C to edit the block again.

The axis display will change to P.08.01. The next block is displayed on the alpha numeric display. Press E to advance or C to edit. To go back a block press YES \wedge . If C has been pressed the alpha numeric display will read "ENTER ANGLE" and the keyboard display will display the angle in absolute degrees f.ex. 90.0 degrees. Press the E key to accept the size or C to clear and then enter a new size. Press E to enter. The alpha numeric display will read "ENTER ANG. ADJ" and the keyboard display will contain the value. The adjustment value is relative with a maximum value of +/- 12.7 degrees. This value can be used to compensate for springback and differences in material without changing the programmed bending angle. To edit the value press C otherwise press E to accept the present value. The complete block is displayed.

Press E to advance to the next block. The axis display will change to P.08.02. The block is displayed on the alpha numeric display. To edit press C. The alpha numeric display will read "ENTER POSITION". The keyboard display will contain the position in absolute. Press E to accept the displayed size or press C to clear and then enter a new size. Press E to enter. The alpha numeric display will read "ENTER BEND ADJ". The keyboard display will contain the value. The value is relative with a maximum value of +/- 12.7 mm. This value can be used to compensate for the difference in the programmed size and the bending size due to the bending process. To edit the size press C or E to accept the size.

The alpha numeric display will read "ENTER M FUNC.". The keyboard display will display the M function. Enter 16 if the backstop has to retract at pinch point. Enter 8 for a double bend. Enter 32 for the end of program or 33 for end of program and a retract after the last bend to the home position. Press E to accept or C to clear and then enter a new M function. The values for the M functions have been chosen so they can be added together to give a wide choice of functions.

The axis display will change to P.08.03. The alpha numeric display will show the next angle. To edit press C or E to advance to the next program block. Continue until all sizes, angles and M functions have been entered. The M function of the last block has to be 32 or 33 to detect the end of the program. If 33 is entered the backstop will retract to the reference position after the last bend.

The maximum number of blocks per program is 18. If block 18 does not end with M32 or M33 (or M40, M48, M56, M57) the error message "MEMORY ERROR " is displayed. Press C to clear and enter 32 or 33 (or M40, M48, M56, M57) for the M function. The program is complete and the light next to P key goes off.

To edit the program press P and enter the program number. Press E until the correct block is displayed and do the changes by clearing the old value with the C key. Enter a new value and press E. Advance to the end with the E key. The program alternates between bending angle and backstop position. A maximum of 9 bends can be programmed per program.