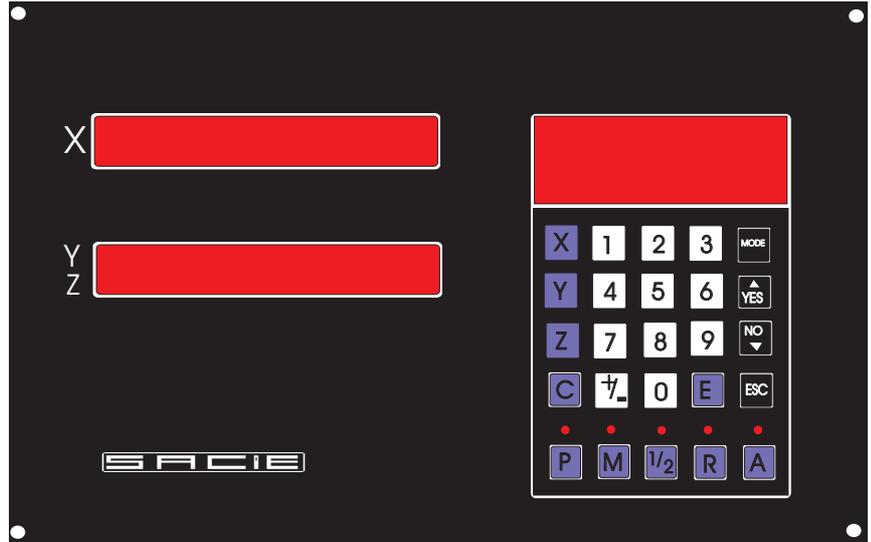


# OPERATING INSTRUCTIONS FOR DIGIREAD SEP 80208 CONTROLLER

## 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 281x205x90 WxHxD  
Cutout Size 258.5 x 198.5  
Hole Sizes 269x193 holedia 5mm  
X axis PID closed loop  
Z axis angle display and control  
Memory for 99 programs with 12 bends  
(angle and backstop positions).  
MDI function  
Tool memory for 10 tools

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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 99. If a number > then 99 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 in mm. To accept the size press E or C to clear the size and then enter a new size. Press E to enter. The alphanumeric display will read "ENTER JOB". A number from 0-32000 can be entered. Enter a number and press E to proceed.

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 ^. 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 24. If block 24 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 12 bends can be programmed per program.