

MANUAL/AUTO SELECTOR IN POSITION AUTO SEMI AUTOMATIC MODE

Switch the selector to the position AUTO. The cycle light lights up. The keyboard display will show P--. The alpha display will read "ENTER Prog.No". Enter the required program number i.e. 1 and the keyboard display will show P01.(Program 1 line 0). If an incorrect number has been entered the keyboard display will read "PROG. No ERROR". Clear the message with the C key and enter the correct number.

The alpha numeric display will read "R +10.0 M " (if a Retract Size of 10.0 mm was programmed).

Press the 1/2 key and the LED above 1/2 key will light up.

Press START and the keyboard display will show P01.02.(Program 1 line 2). Line 1 is not shown as it contained the programmed angle and the program continued to line 2 which contained the backstop position. The centre axis display will display A and the programmed angle, the alpha numeric display will contain the programmed backstop position and the M function.

Select the required program block with the NO key. Press E when the required block is displayed.

The tool adjustment will move to the programmed angle. Then the backstop will travel to the first programmed size. Press the footswitch and the first bend is executed. If M16 has been programmed (and a switch to detect the pinchpoint is fitted) the backstop will retract as soon as the pinchpoint is reached. The tool will close until the programmed angle has been reached. The tool will go up after the bend has been executed. If M08 has been programmed two bends have to be executed for the same backstop position.

The program display will change to the next program line and show the size for the second position.

Select the block by pressing E or page forward with the NO key and then press E to accept the displayed block.

After the tool adjustment and the backstop have reached their programmed position press the footswitch again and the second bend is executed. Continue until all the program blocks have been executed. The program will jump back to program block P01.01.

Select the next block as described previously.

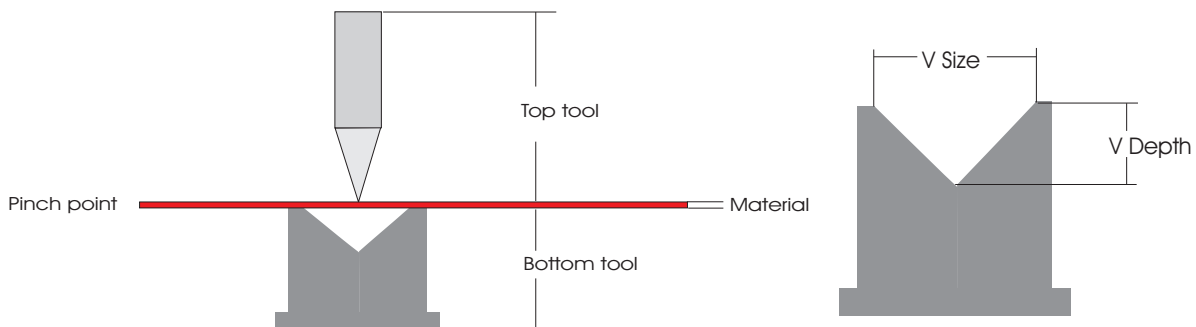
The cycle can be stopped anytime by pressing the STOP button on the operator control panel. The alpha numeric display will read "CYCLE STOP". The bending tool will move to the open position. Switch the selector to MANUAL and the program is terminated.

If the error message "X HOME POSITION " is displayed switch to MANUAL and clear the message with the C key. Move the backstop to the home position.

If the error message "FEEDHOLD" is displayed the bending tool is not in the open position. Switch to MANUAL and clear the message with the C key.

If the error message "PROGRAM ERROR" is displayed no data has been programmed for the selected program. Select MANUAL and press C to clear the error message.

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|-----------------|---------------------|
| 0 NO COMMENT | 4 ROTATE R 90 |
| 1 TURN OVER L-R | 5 NARROW SIDE FIRST |
| 2 TURN OVER F-B | 6 WIDE SIDE FIRST |
| 3 ROTATE L 90 | 7 NO COMMENT |



	Double Bend	Retract	End of program	Retract to home
■ M08	X			
■ M16		X		
■ M24	X	X		
■ M32			X	
■ M33			X	X
■ M40	X		X	
■ M48		X	X	
■ M56	X	X	X	
■ M57	X	X	X	X

■ Basic M functions. All other M functions are derived from adding M functions together.