




OPERATING INSTRUCTIONS FOR DIGIREAD SEP 80208 CONTROLLER Page 2

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MANUAL OPERATION: If no operation is selected on the keyboard the backstop can be moved forward and backward with the Jog buttons. The actual backstop position is shown on the top axis display. If the forward or backward software limit is reached a error message " X LIMIT " is displayed. Move the backstop off the limit with the opposite Jog button. The bending angle is displayed on the center axis display in degrees. The maximum stroke is defined by entering the tool sizes and the Vee depth. A error message " Z LIMIT " or " V LIMIT " is displayed if this size is exceeded.

EDIT MATERIAL
 Press MODE on the keyboard to enter or edit the tool setup. The alphanumeric display will read " EDIT MAT.SIZE ". Press YES to edit the material size or ESC to exit. To enter the material size press C to clear the old value. Enter the new value and press E to accept. The value is stored in the memory of the control and is common to all programs until changed.

SELECT TOOL 0-9
 Press MODE on the keyboard to enter or edit the tool setup. The alphanumeric display will read " EDIT MAT.SIZE ". Press NO and the alphanumeric display will read " SELECT TOOL ". To enter the tool press C to clear the old value. Enter the new value and press E to accept. The value is stored in the memory of the control and is common to all programs until changed.

TOOL SETUP V SIZE
 Press MODE on the keyboard. The alphanumeric display will read "EDIT MAT.SIZE ". Press NO twice and the alphanumeric display will read " EDIT TOOL ". Press YES to edit the tool sizes or ESC to exit. The display will read "TOP TOOL". Press E to enter or C to clear the old value. Enter the new value. Press E to accept. The display will change to " ENTER BOT.TOOL ". Enter the size for the bottom tool. The display will change to "ENTER V SIZE". Enter the width of the Vee. The display will change to "ENTER V DEPTH". Enter the depth of the Vee. This size is used to calculate the minimum angle for the tool. The display will change to "V OFFSET". Enter zero. These values are stored in the memory of the control and are common to all programs until changed.

HOME POSITION
 Select R on the keyboard. The LED above the R key will light up. The alpha display will read "X HOME POSITION". Press the START button on the operator control panel and the backstop will travel to its home position. The alpha numeric display will change to "Z HOME POSITION". Press the footswitch and the tool will move up. Once the tool has stopped release the footswitch.

MDI MODE
 Select M on the keyboard. The LED above the M key will light up. The alpha numeric display will read "ENTER ANGLE ". If an angle smaller than defined by the Vee depth is entered an error message "Z LIMIT" is displayed. Enter the bending angle. The alpha display will read "ENTER POSITION". Enter the size for the backstop. If a size outside the software limits is entered a error message "X LIMIT" is displayed. Press the START button on the operator control panel and the backstop will travel to the programmed position. Press the footswitch to execute the bend. To execute another bend with the same angle press the footswitch again. To exit the MDI mode press the STOP button and then the C key on the keyboard. The LED above the M key goes off.

MANUAL/AUTO SELECTOR IN POSITION AUTO 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 START and the keyboard display will show P.01.02.(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. The backstop will travel to the first programmed size.

Press the footswitch and the first bend is executed. If M16 has been programmed 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 P01.03.(Program 1 line 3) and show the size for the second position. The tool adjustment will move to the programmed angle. After the backstop has reached it's 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 and position the backstop to the programmed position.

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.