

MOUNTING INSTRUCTIONS FOR DIGIREAD SEP 80208 CONTROL

Customer: _____
 Machine: _____
 Date : _____ Remarks: _____



To view or change the machine parameters press the P key and the LED above the P key will light up. The alpha display will read "ENTER CODE". Enter the code number 805. All LED's will light up. The alpha display will change to "EDIT PARAM.". The axis display will read P.01 for parameter 1. Press E to accept the value. C to clear the old value then enter a new value and store the value with the E key. After all values have been entered the LED above the P key goes off and all displays are cleared.

Machine Parameters software ver. SEP2_505.2 axis Press Brake control.

X axis counter closed loop ,Z axis counter closed loop. NOTE: All sizes are in 0.1mm resolution.

| | | | | |
|------|---------------------------|--------------|-------|-------|
| P.01 | Deceleration point 1 | X axis | _____ | _____ |
| P.02 | Deceleration point 2 | X axis | _____ | _____ |
| P.03 | Overshoot | X axis | _____ | _____ |
| P.04 | Backlash | X axis | _____ | _____ |
| P.05 | Scaling factor * 1000 | X axis | _____ | _____ |
| P.06 | Reference offset | X axis | _____ | _____ |
| P.07 | Position Window | X axis | _____ | _____ |
| P.08 | Password | | _____ | _____ |
| P.09 | Max. Velocity | | _____ | _____ |
| P.10 | Reference speed fast | | _____ | _____ |
| P.11 | Reference on -off | | _____ | _____ |
| P.12 | Tool open LMT | 1 =n/o 0=n/c | _____ | _____ |
| P.13 | Reference speed slow | | _____ | _____ |
| P.14 | Software limit X+ | | _____ | _____ |
| P.15 | Software limit X- | | _____ | _____ |
| P.16 | Z axis mm | 1=on 0=off | _____ | _____ |
| P.17 | Pulse in msec for Z relay | | _____ | _____ |
| P.18 | Z pulse | 1=on 0=off | _____ | _____ |
| P.19 | Retract on off | | _____ | _____ |
| P.20 | Deceleration point 1 | Z axis | _____ | _____ |
| P.21 | Deceleration point 2 | Z axis | _____ | _____ |
| P.22 | Overshoot | Z axis | _____ | _____ |
| P.23 | Backlash | Z axis | _____ | _____ |
| P.24 | Scaling factor*1000 | Z axis | _____ | _____ |
| P.25 | Reference offset | Z axis | _____ | _____ |
| P.26 | Positioning window | Z axis | _____ | _____ |
| P.27 | Software limit Z+ | Z axis | _____ | _____ |
| P.28 | Software limit Z- | Z axis | _____ | _____ |
| P.29 | Bending comp. Obtuse in % | | _____ | _____ |
| P.30 | Bending comp. Acute in % | | _____ | _____ |

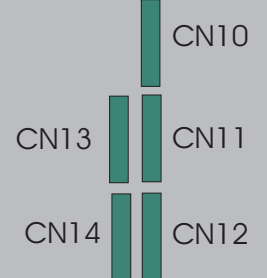
SEP505PA.CDR

9 pin sub D RS 422 transducer input.

- 1 >----- channel A
- 2 >----- channel A
- 3 >----- +5 V DC
- 4 >----- 0 V DC
- 5 >----- channel B
- 6 >----- channel B
- 7 >----- channel R
- 8 >----- channel R
- 9 >----- screen

- P.19=0 NO RETRACT
- P.19=1 RETRACT LMT NC
- P.19=2 RETRACT LMT NO
- P.19=4 FAST RETRACT ON
- P.19=8 ANALOG FEEDBACK
- P.19=16
- P.19=32
- P.19=64
- P.19=128

- P.11=1 X REF OFF
- P.11=2 Y REF OFF
- P.11=4 Z REF OFF
- P.11=8
- P.11=16
- P.11=32 Z AXIS OFF
- P.11=64 SER TEST ON
- P.11=128 PLC DISPLAY ON



CN 10

- 1>---
- 2>---
- 3>---
- 4>---
- 5>---
- 6>---
- 7>---
- 8>---
- 9>---

CN 11 output

- 1>--- IN POSITION X
- 2>--- +24VDC in
- 3>--- DIR X- OUT
- 4>--- +24VDC in
- 5>--- DIR X+ OUT
- 6>--- +24VDC in
- 7>--- +24VDC in
- 8>---
- 9>--- S2 IND X/Z

CN 12 input

- 1>--- AUTO
- 2>--- START
- 3>--- STOP
- 4>---
- 5>---
- 6>--- TOOL OPEN LMT
- 7>--- RETRACT LMT
- 8>---
- 9>--- 0V DC

CN 13 output

- 1>--- IN POSITION Z
- 2>--- +24VDC IN
- 3>--- DIR Z- OUT
- 4>--- +24VDC IN
- 5>--- DIR Z+ OUT
- 6>--- +24VDC IN
- 7>--- +24VDC IN
- 8>--- S1 IND X/Z
- 9>---

CN 14 input

- 1>--- X+ JOG
- 2>--- X- JOG
- 3>--- 24V on
- 4>---
- 5>--- REF. X
- 6>--- Z+ JOG
- 7>--- Z- JOG
- 8>--- REF. Z
- 9>--- 0V DC