

```

P      0      N      2      TK      _ _      0
K1:    2.00      6      Kg/mm2      45.0000
b/k    1/ 1      CR      _ _/r_i      _ _ _ _ _ _
      --HDF--      --KON--      --DUZ--
&      90.00°
Y1     122.009      127.33      - 0.09
Y2     122.009      120.00      - 0.27
X      143.0      76.2      _ _ _ _ _
MIK      _ _ _ _
PBoy 1400      Fb      27 TON
Rx      _ _ _      Hrc Start      _
Vy↓_ _ %↑_ _ %      ΔUZ      _ . . S
UON      _ _ _ _      HDN      _ _ _ _
F1: _ _ _ F2: _ _ _ F3: _ _ _ F4: _ _ F5: _ _ Bo: _ _ _

```





-The value is 222

-then, press the enter button

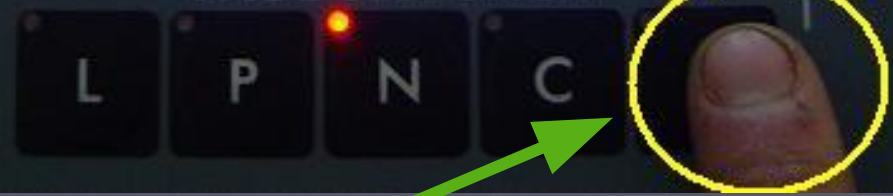


**Level must be 2**

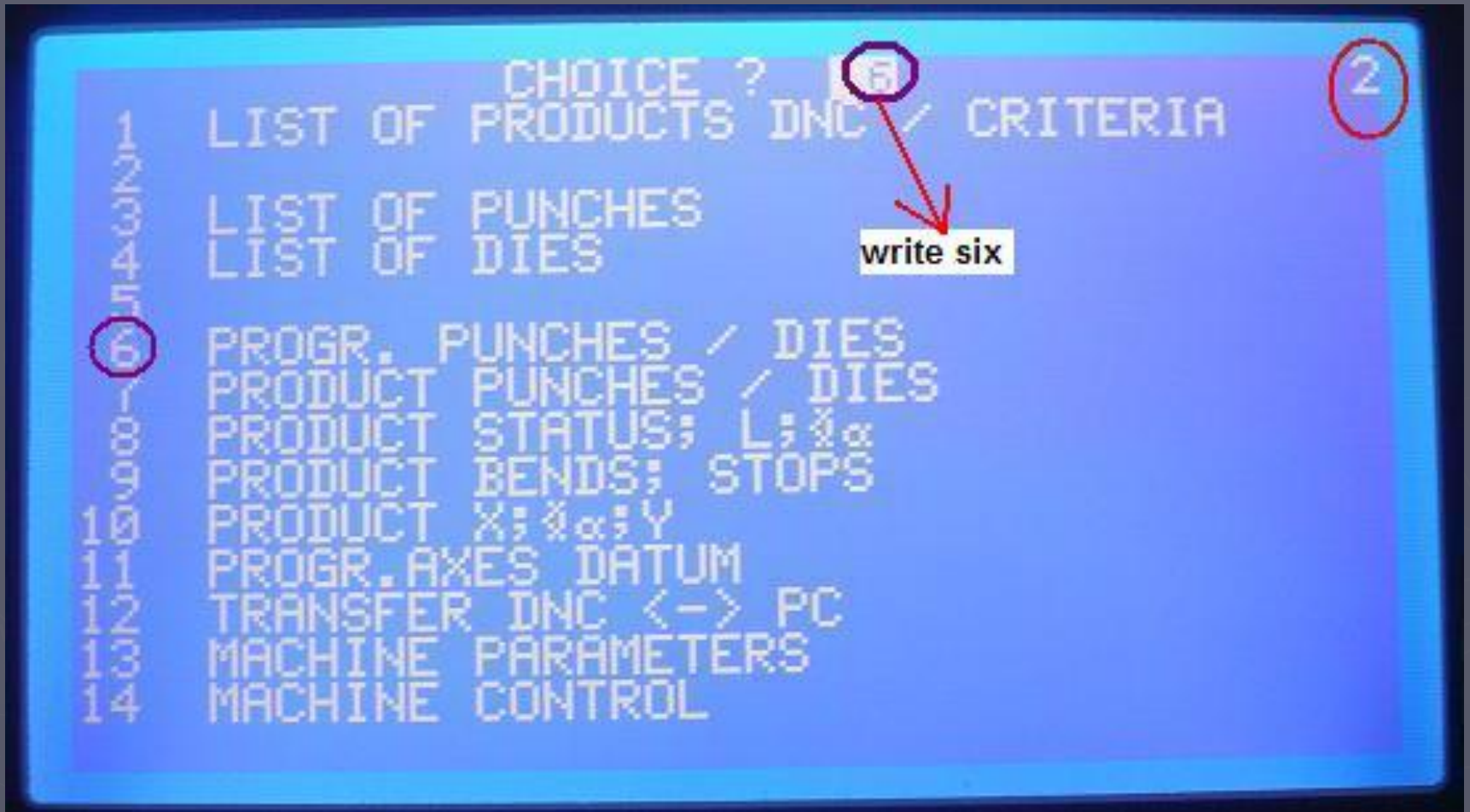
```
P 0 N 2 TK 6 K9/mm2 45.0002
K1: 2.00 CR 1/1 ---KON--- --DUZ--
b/k 1/1
---HDF---
3α 90.0°
V1 122.09 127.33
V2 122.09 120.00
X 143.0 76.2
MIK
PBoy 1400 Fb 21TON
Rx Hrc Start
U%↑%
UON HDN
F1: F2: F3: F4: F5: B0:
```

DNC  
60

PAGE SELECTION



Press empty button

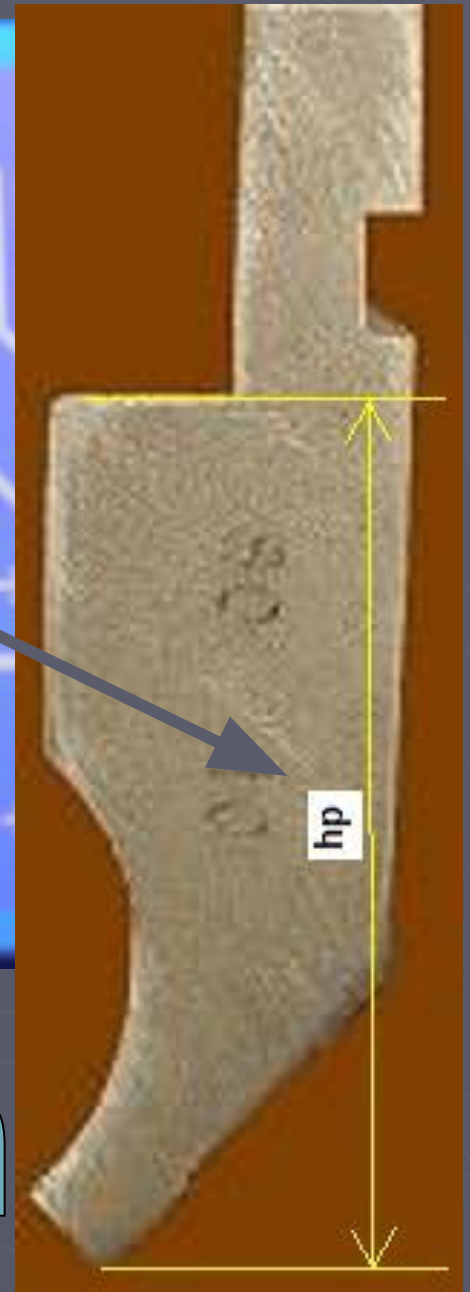


**1-Write six**

**2-And write six, step to that button** →

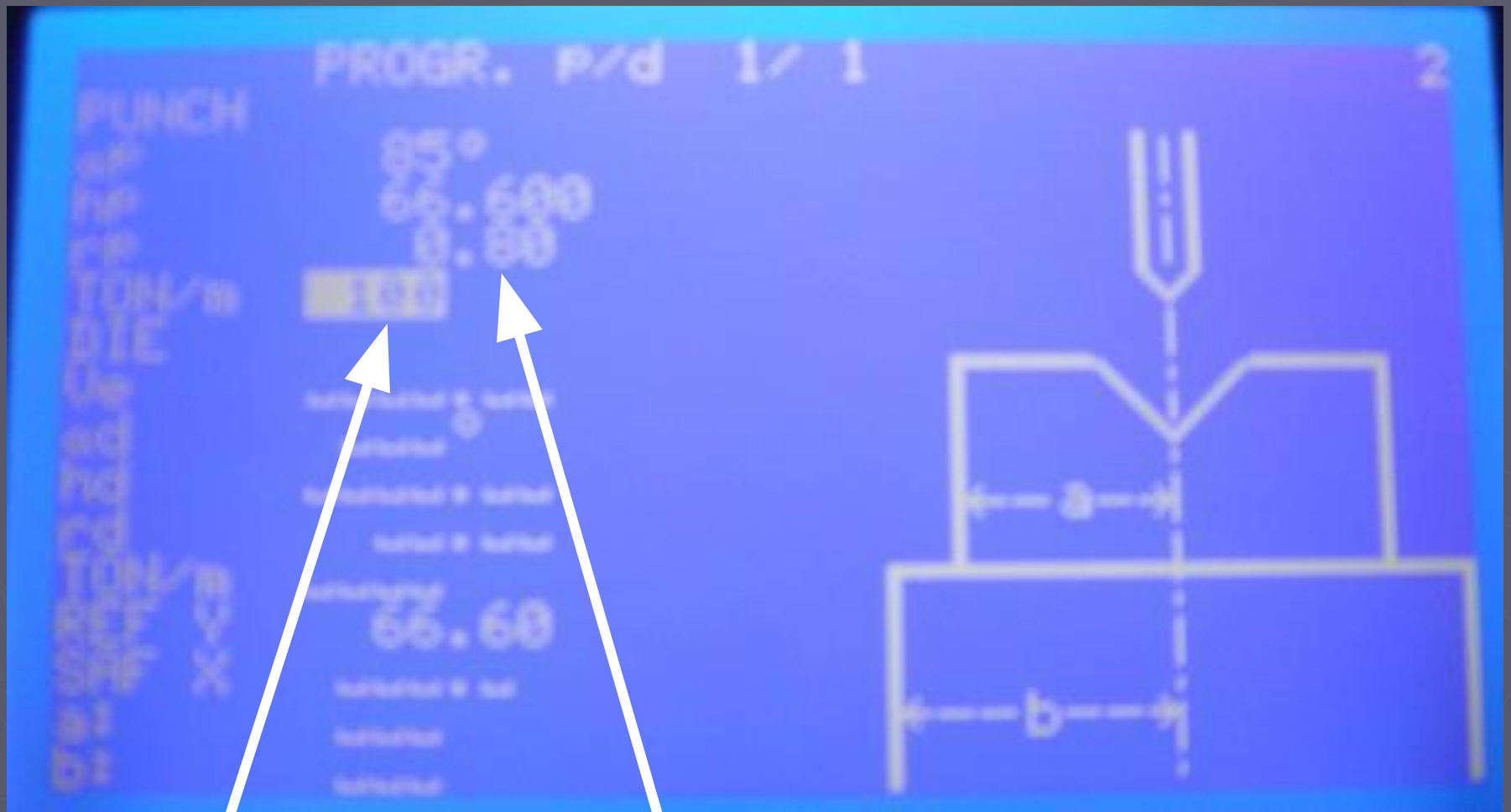






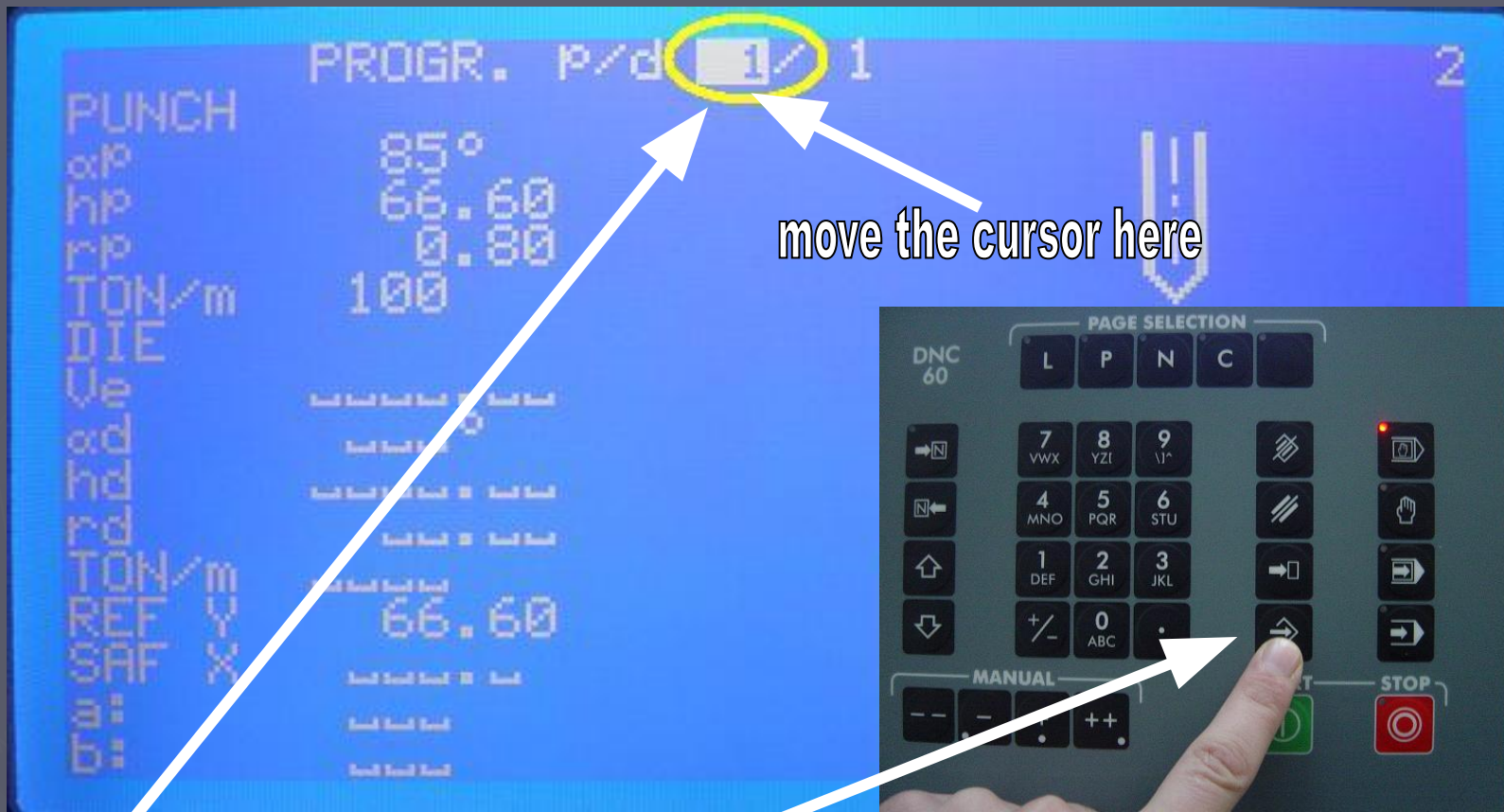
-(hp) is height of punch





- $rp=(0.8)$  Radyus is always same

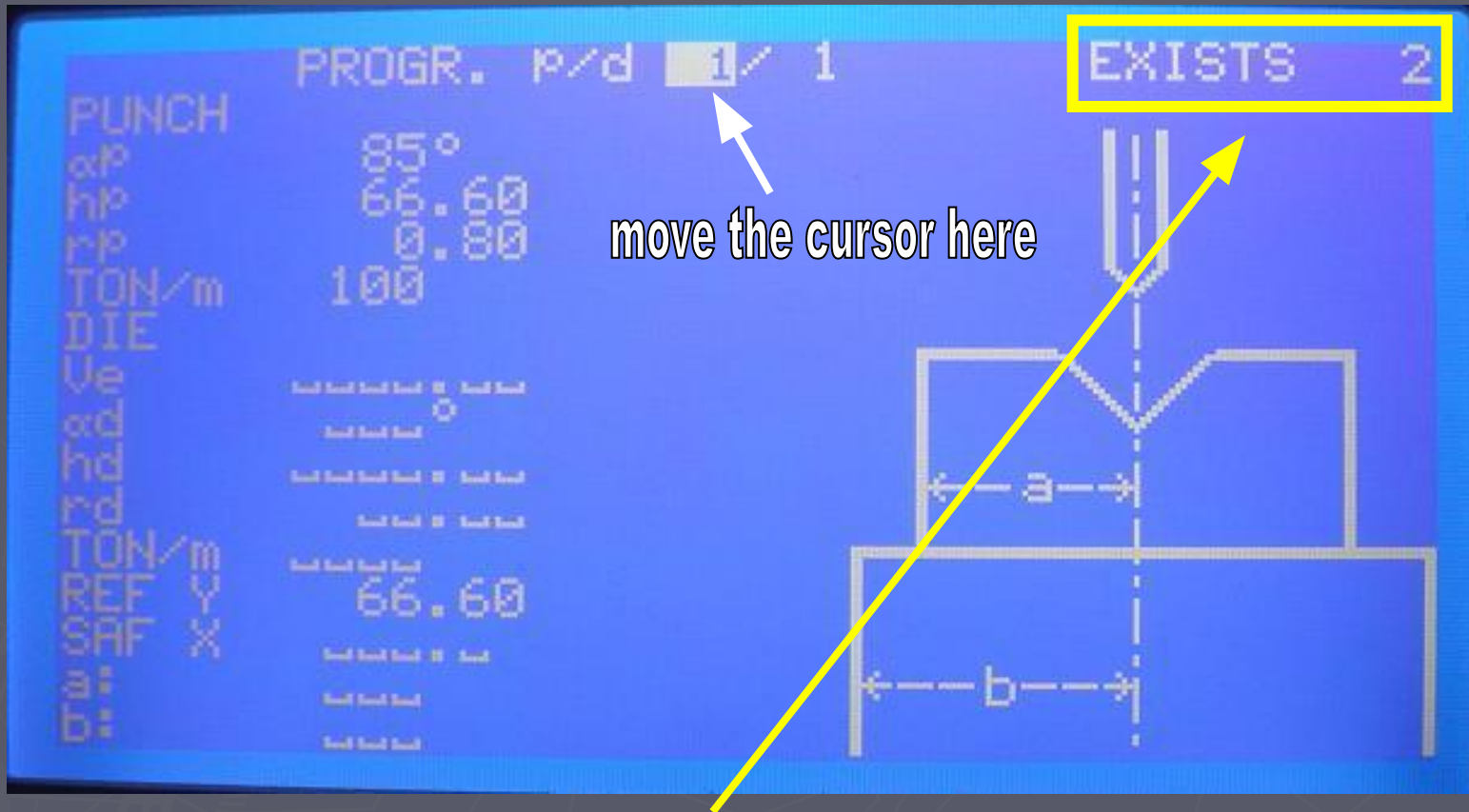
-Ton/m This is always 100 Ton/m for our machine



move the cursor here

- 1-Give the number for the punch
- 2-Press enter button to save

# ATTENTION !



move the cursor here

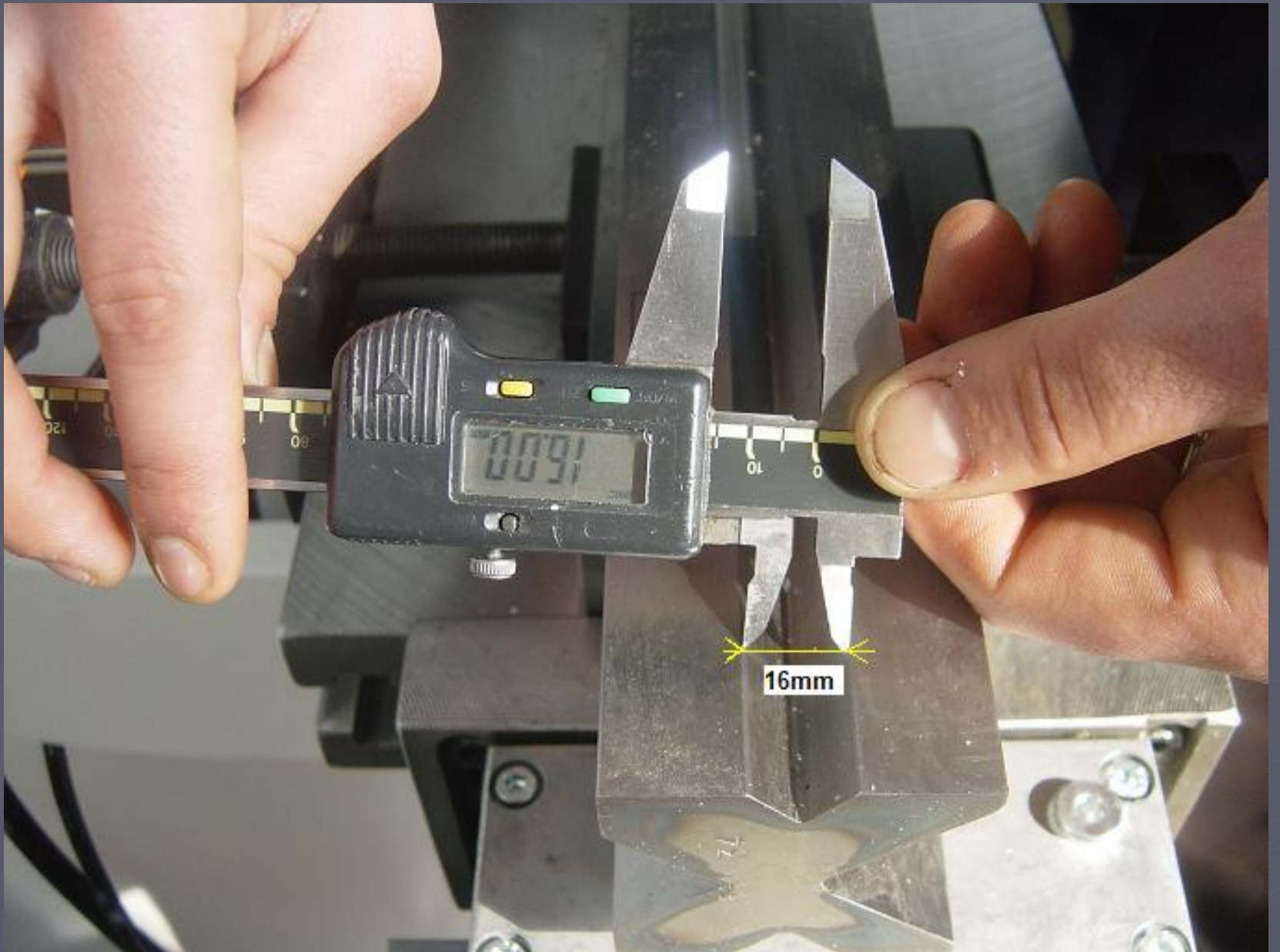
**-if you see 'exists' message**

**-First, press to this button**



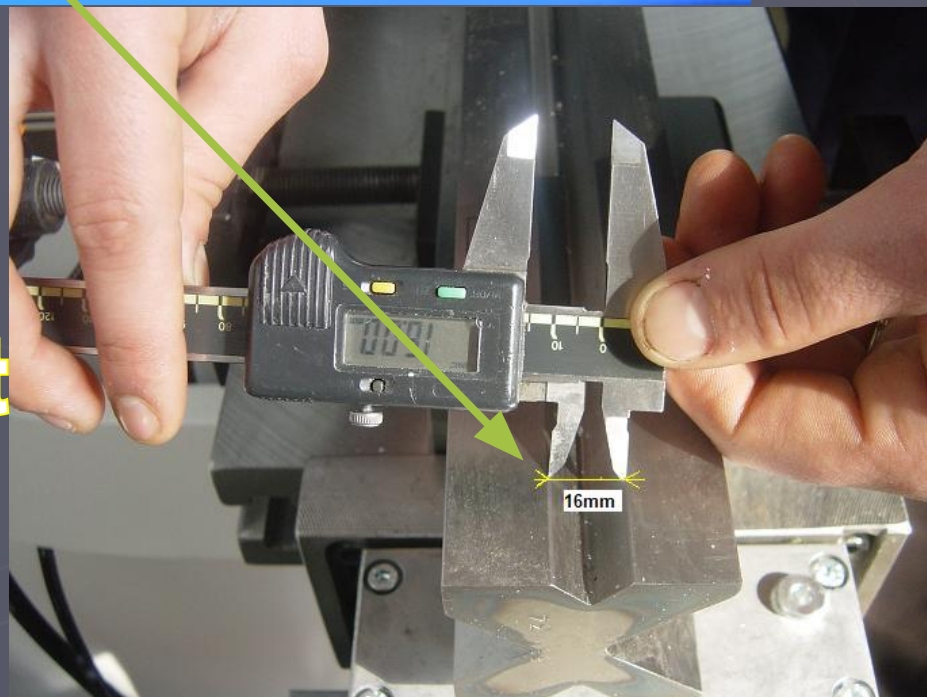
**-Second, press to this button**







**-Enter this value to that segment**

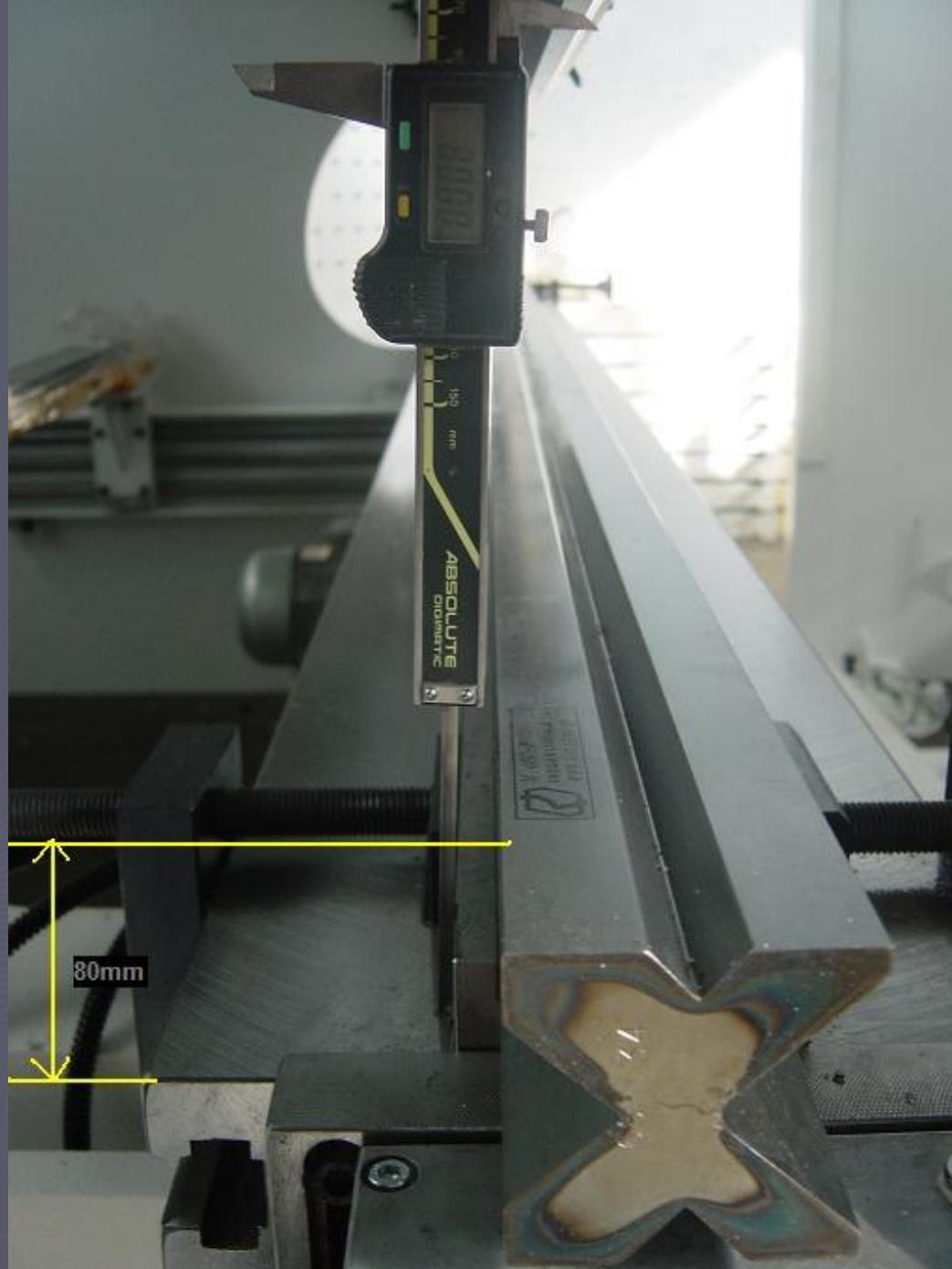


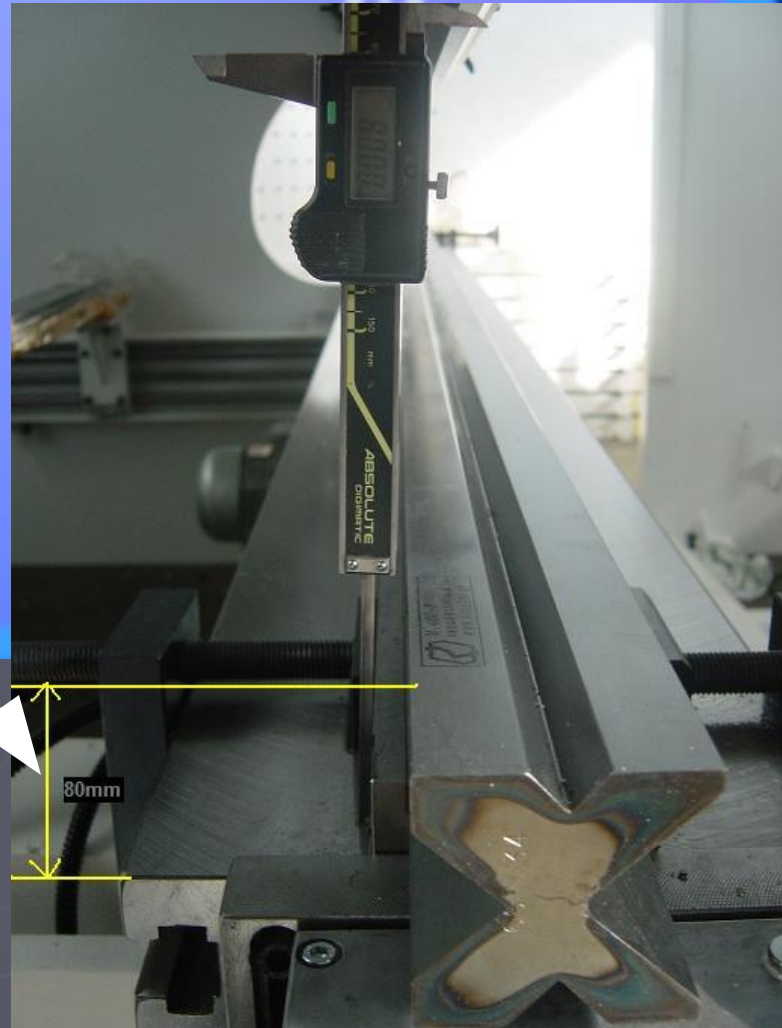
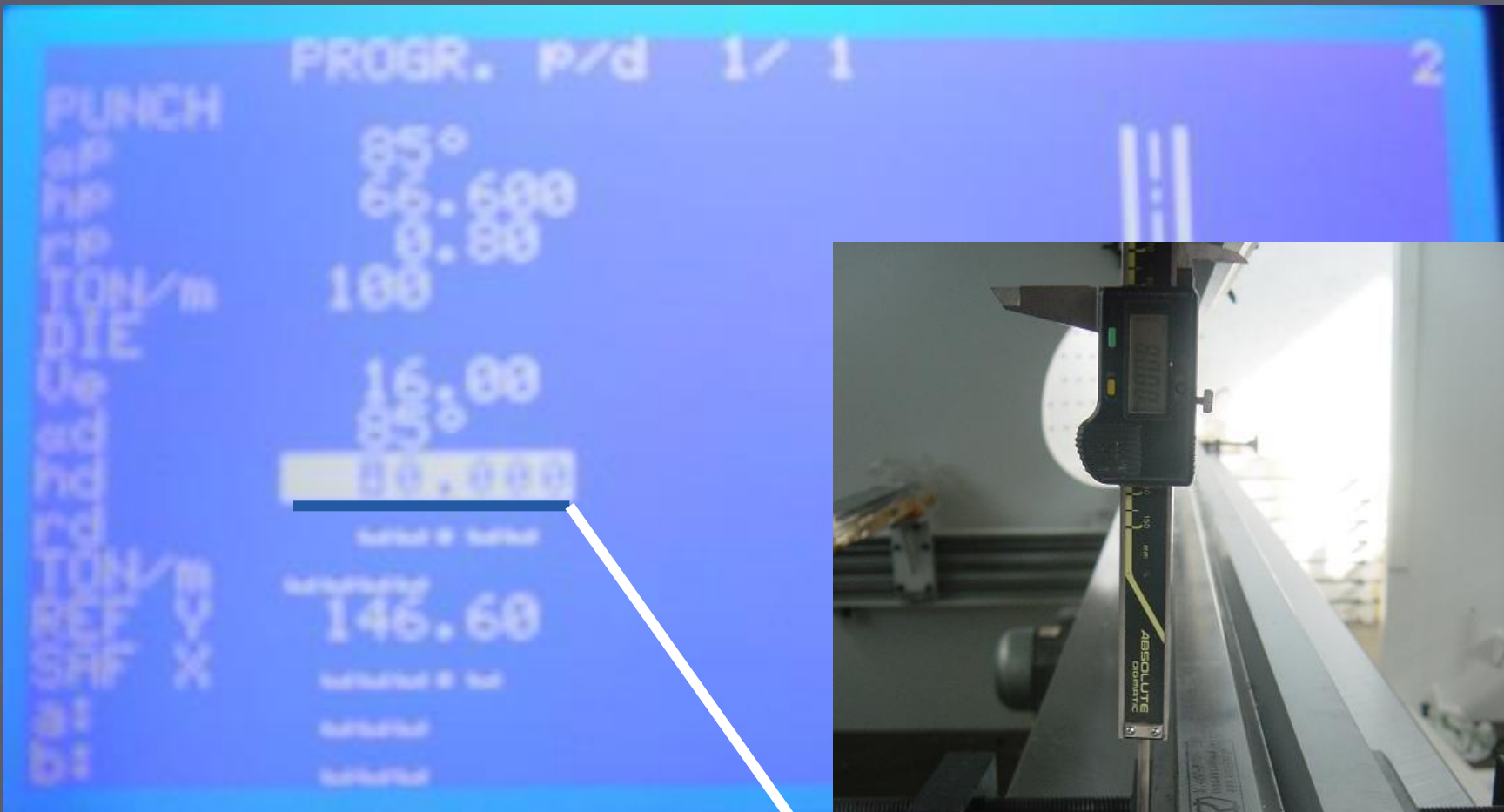


**-This is die angle**



hd



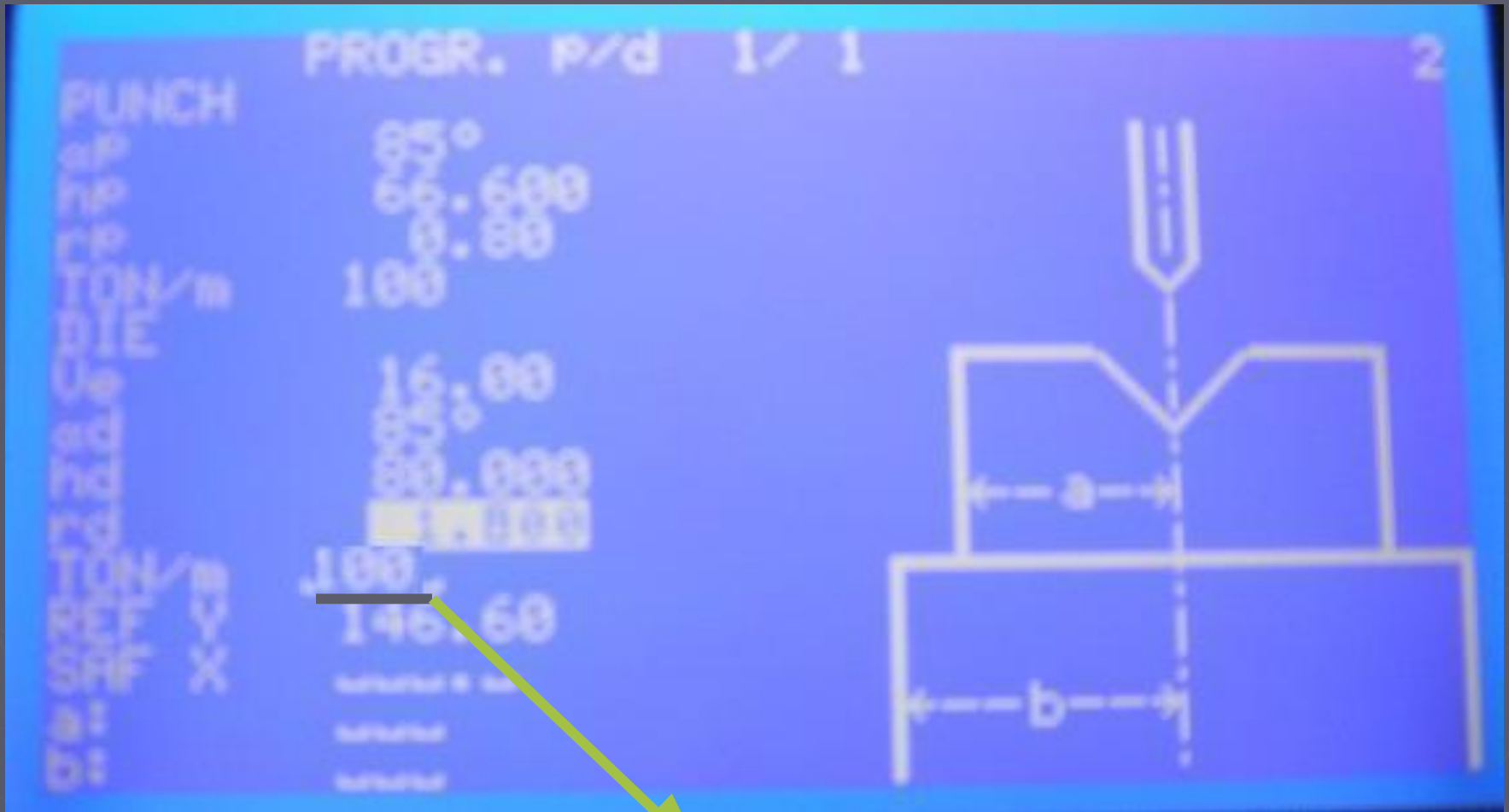


**-This is die height**

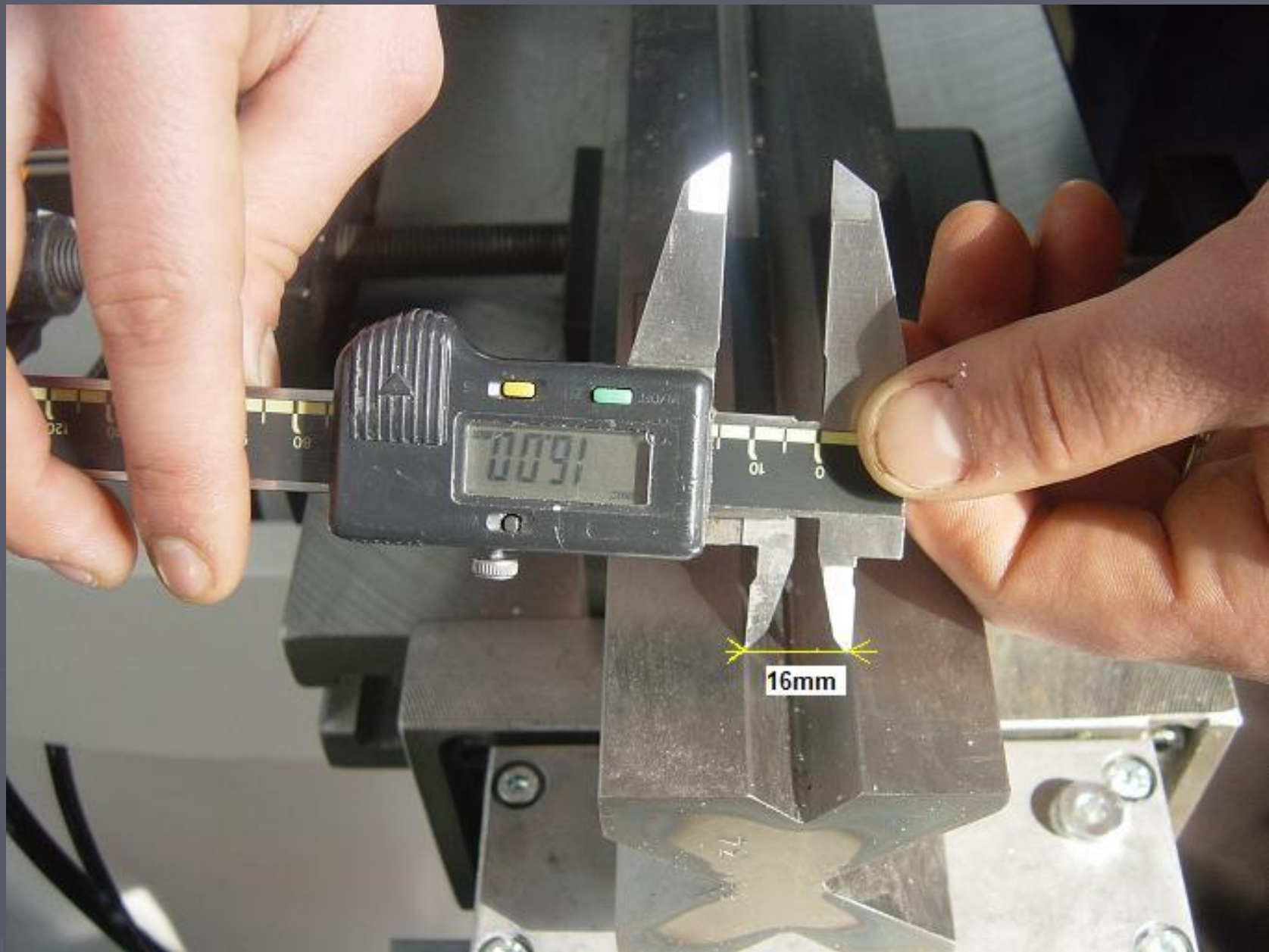


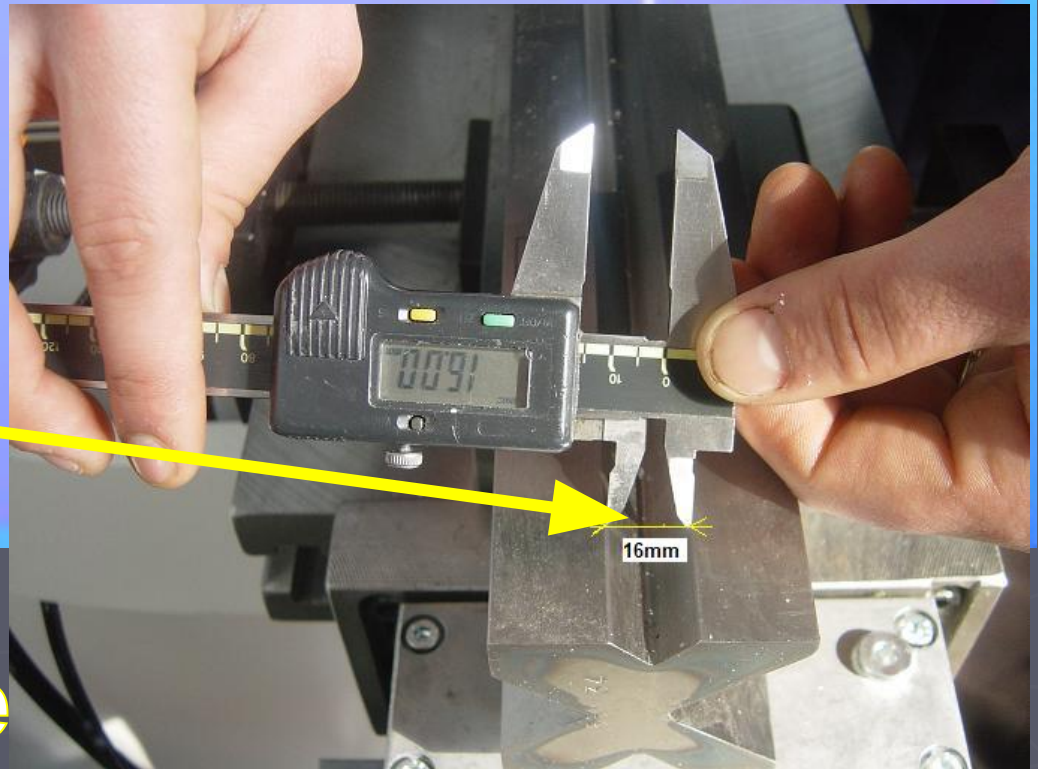
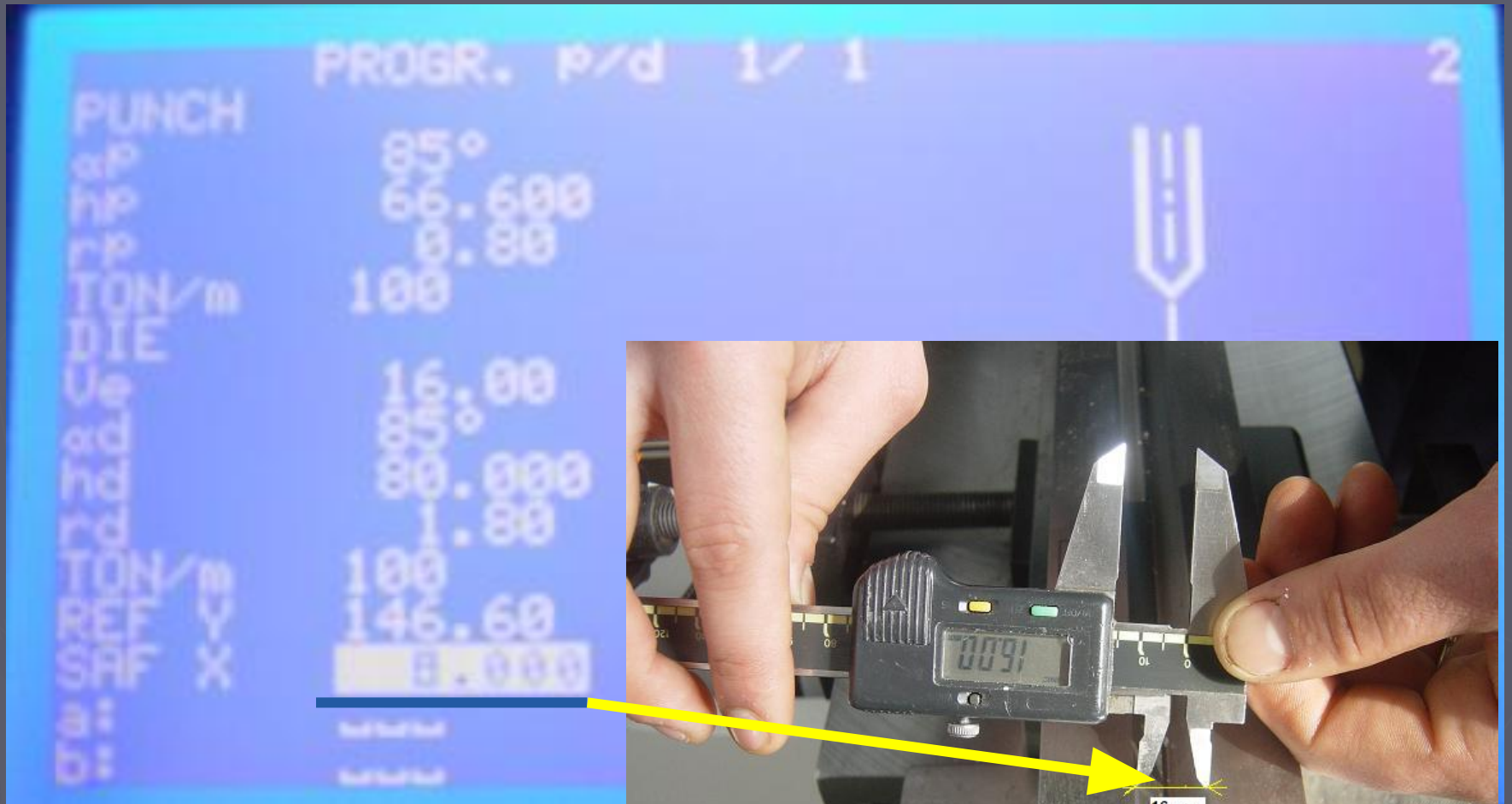


**-This radius depends on (ve) value  
 ve=? (8-16) enter rd=1.8  
 (16-25) enter rd=2  
 (25-45) enter rd=3**

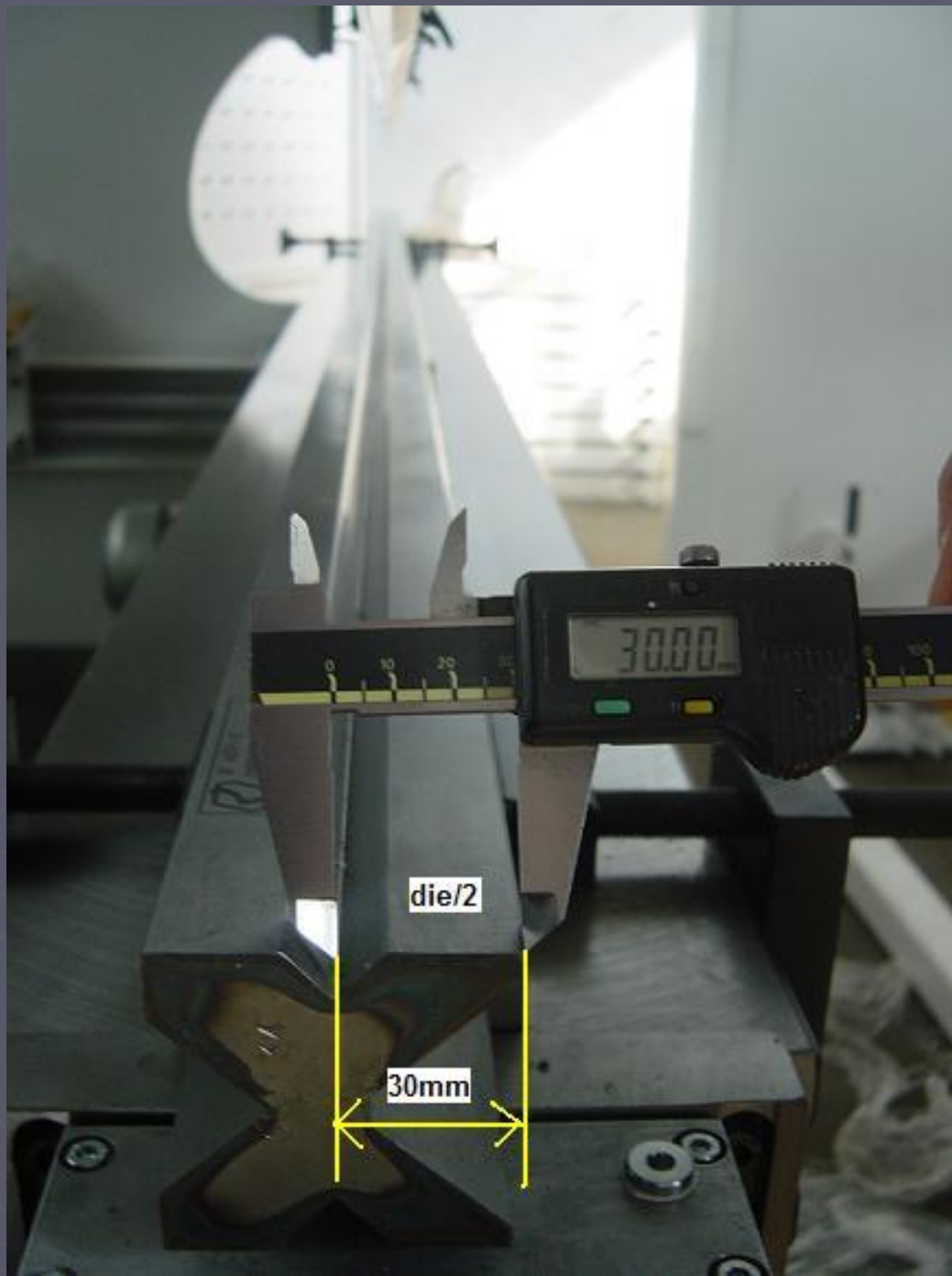


**-This is always 100  
Ton/m for our machine**



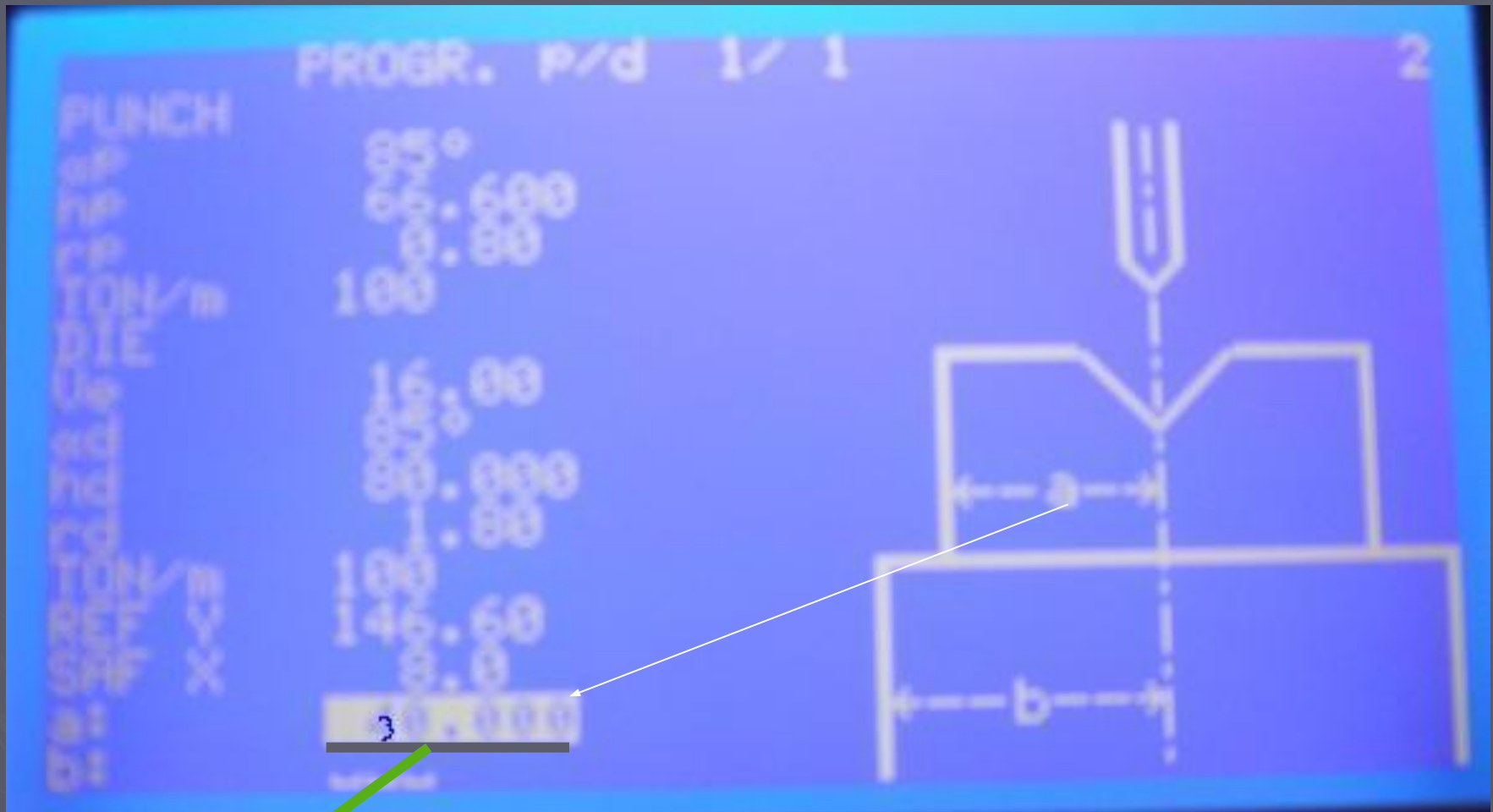


**-Safety distance  
should be  $(V_e/2)$**



$\frac{die}{2}$

30mm



**-(a) value should be half measurement of die width (die/2)**



**This is bottom table**



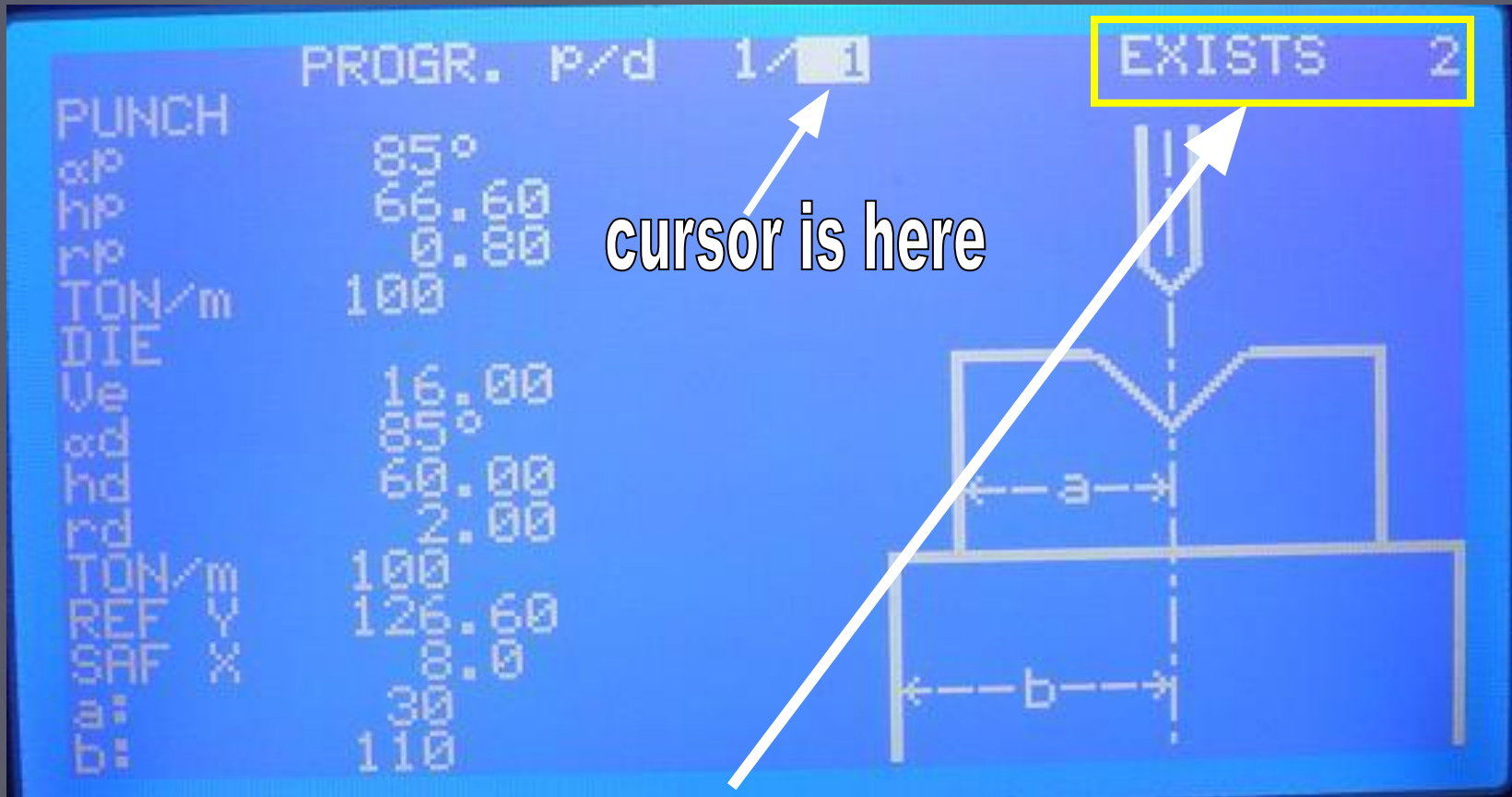
**-(b) Value should be half measurement of bottom table width (bottom table/2)**





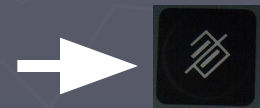
- 1-Enter a number for the die
- 2-Press enter button to save

# ATTENTION!



**if you see 'exists' message**

**-First, pres to this button**



**-Second, pres to this button**

