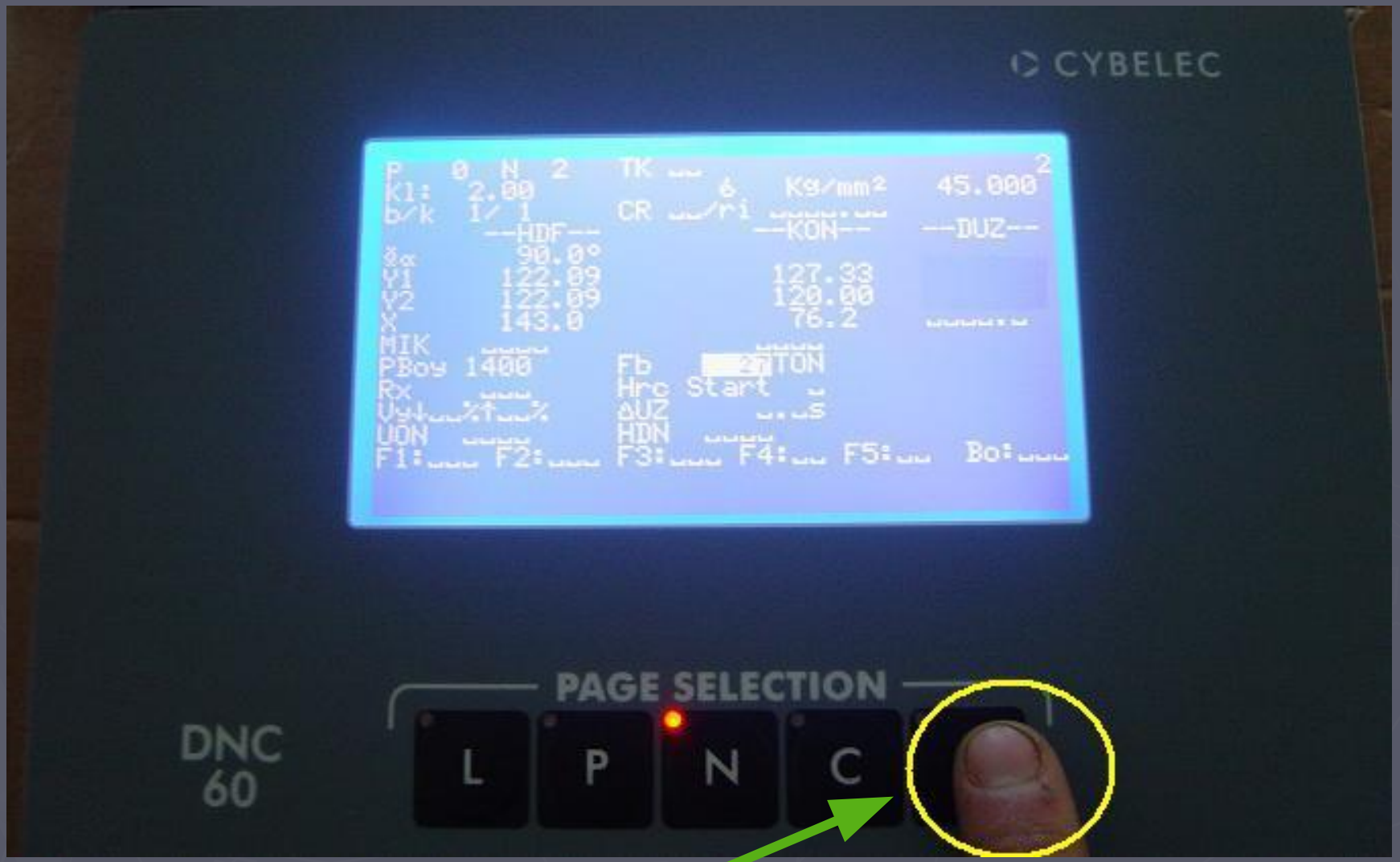

P 0 N 2
TK
0
K1: 2.00
6 Kg/mm²
45.000
b/k 1/ 1
CR /ri
--HDF--
--KON--
--DUZ--
90.0°
Y1 122.09
127.33
- 0.09
Y2 122.09
120.00
- 0.27
X 143.0
76.2
MIK
PBoy 1400
Fb 27TON
Rx
Hrc Start
Vy↓ %↑ %
ΔUZ s
UON
HDN
F1: F2: F3: F4: F5: Bo:


PAGE SELECTION
DNC
60
L
P
N
C
7
VWX
8
YZI
9
\]^
4
MNO
5
PQR
6
STU
1
DEF
3
JKL
START
STOP

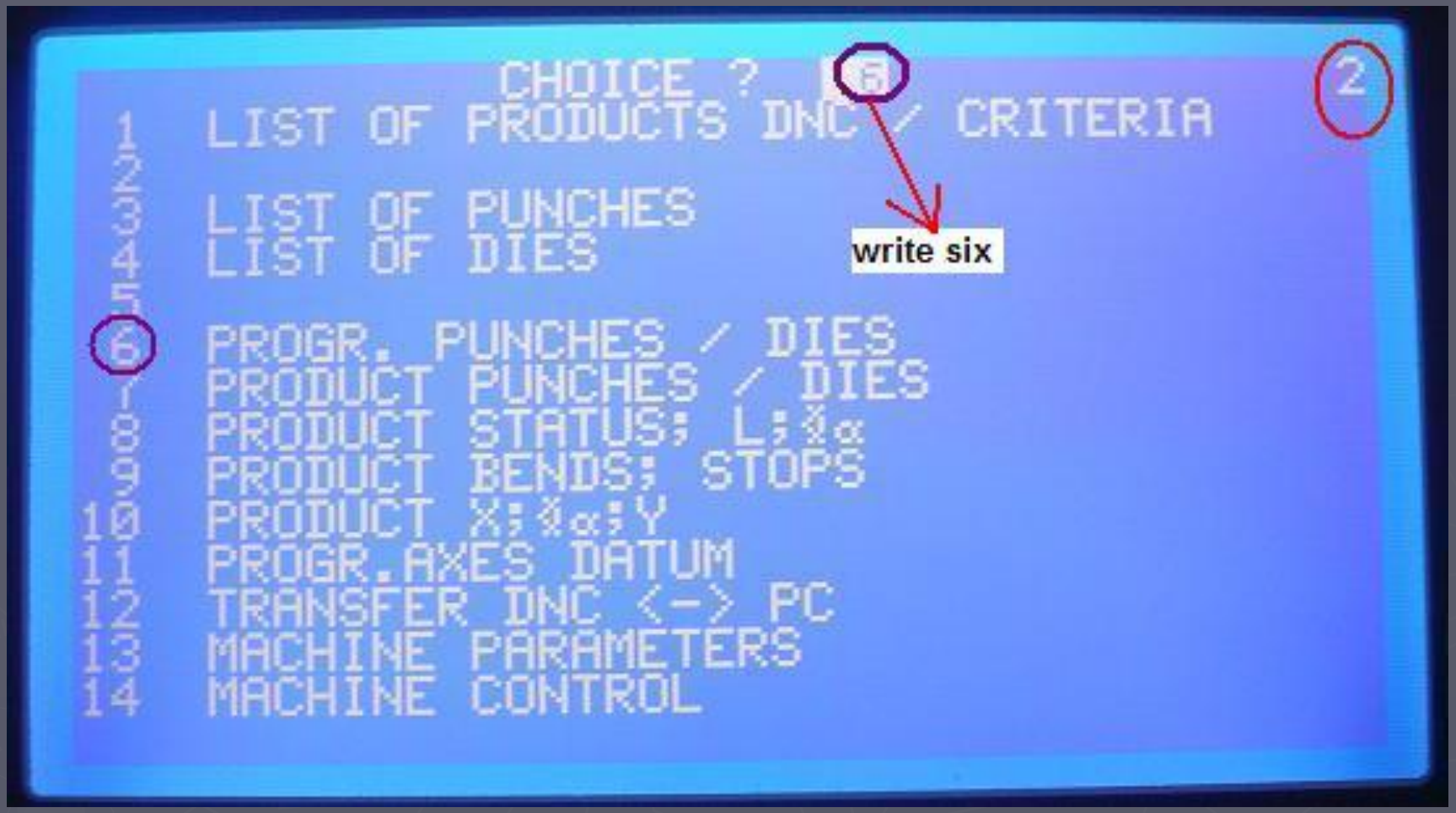
-The value is 222

-then, press the enter button

Level must be 2

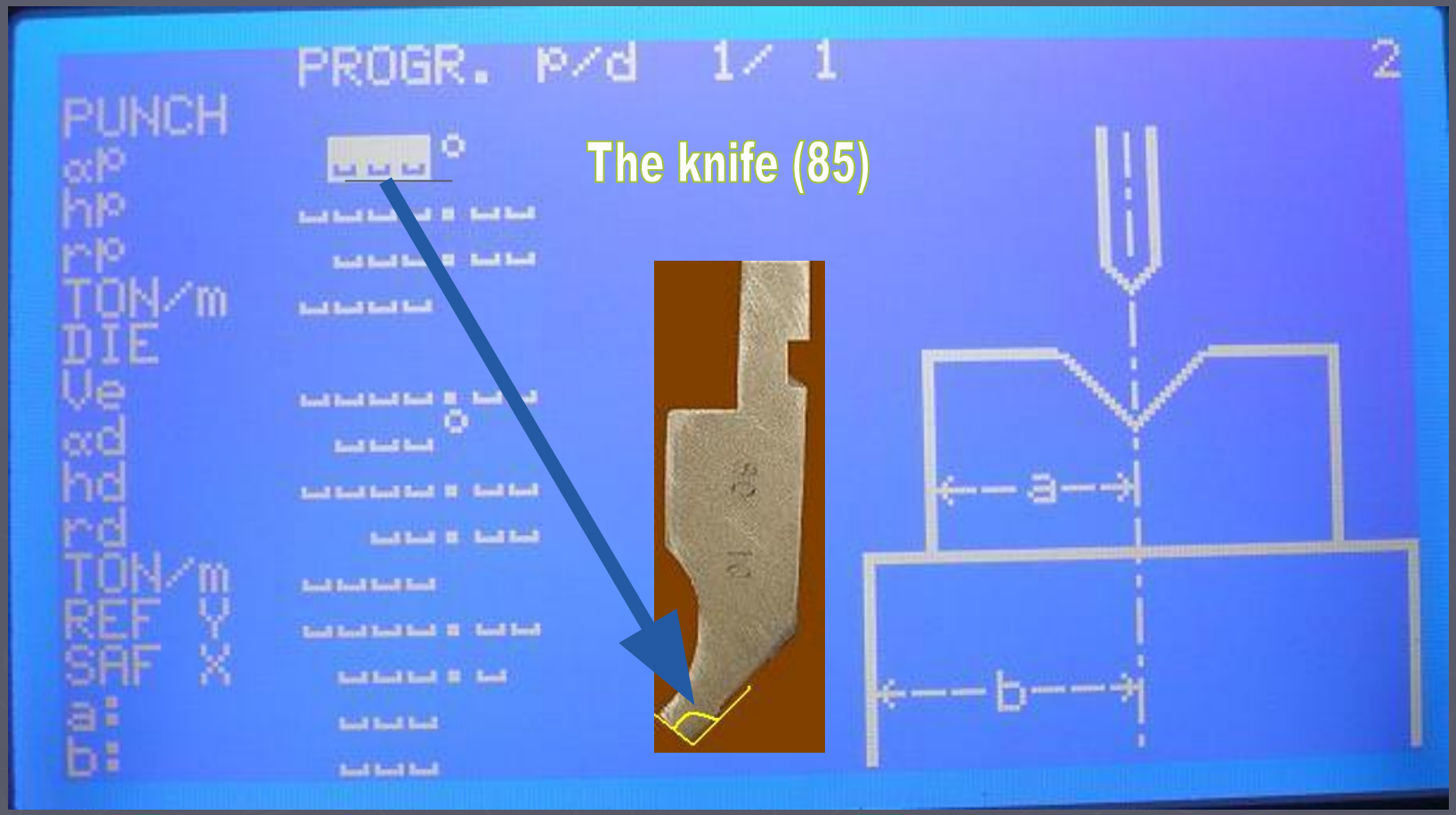


Press empty button

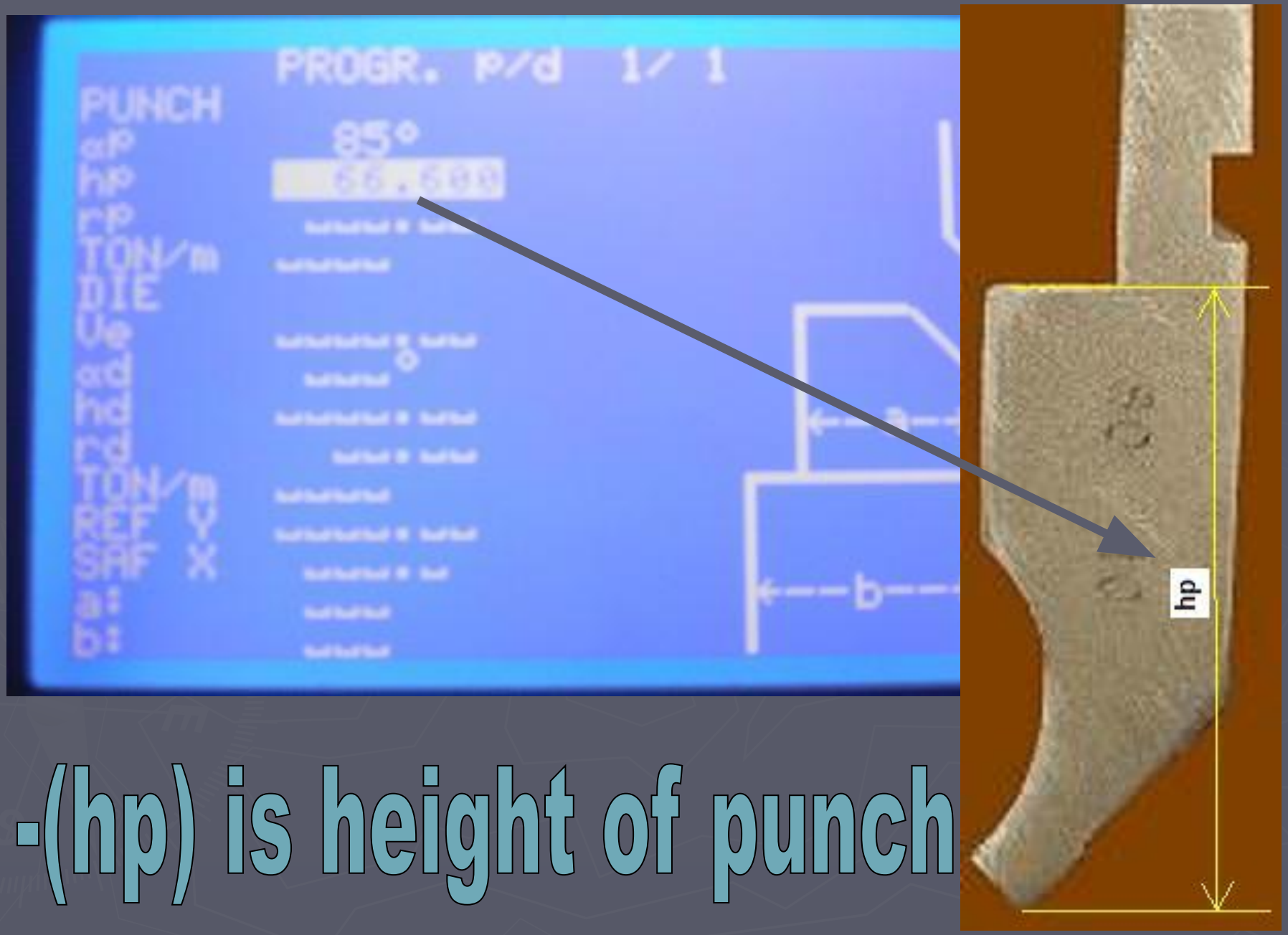


1-Write six

2-And write six, step to that button



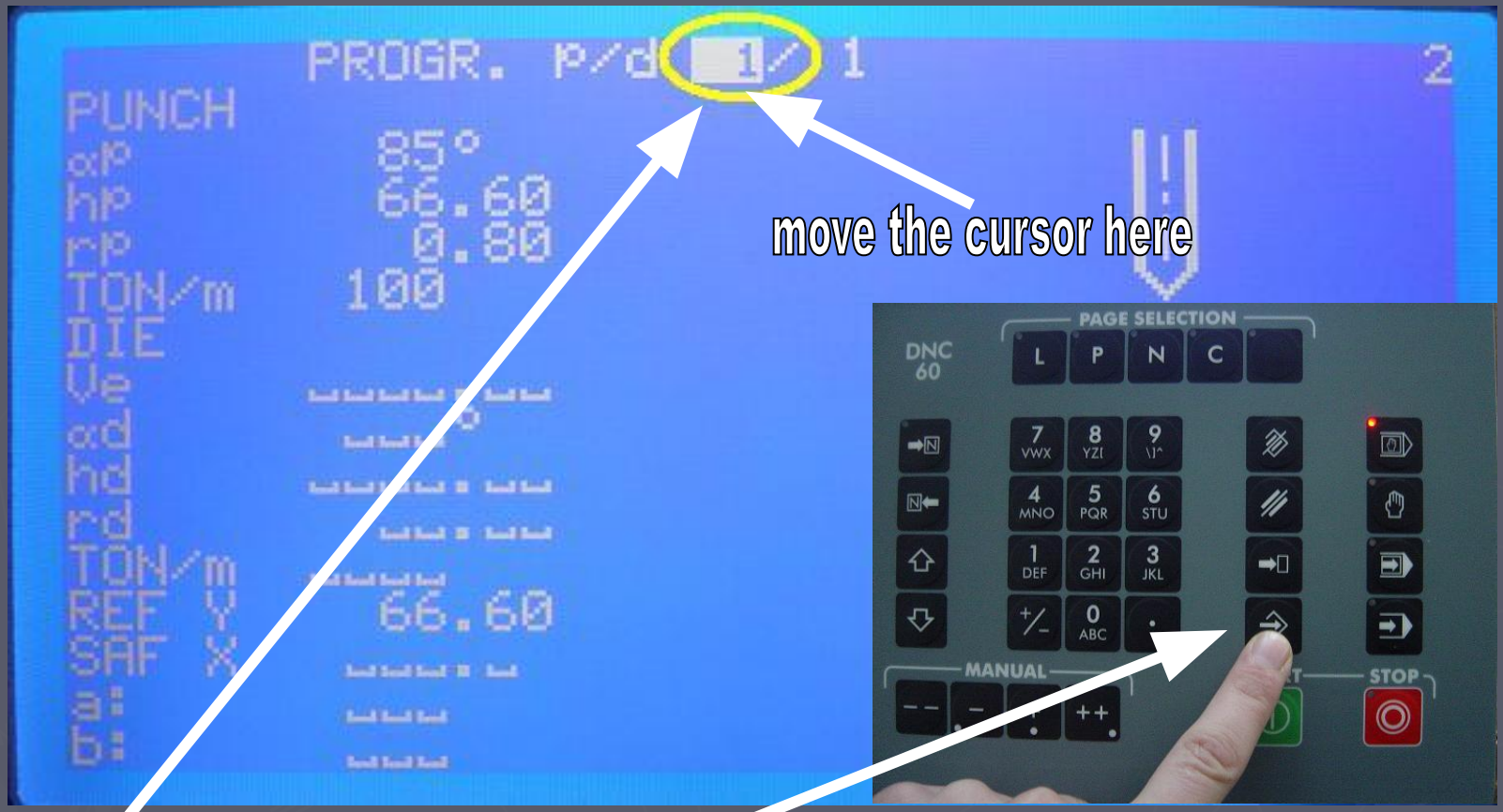
-Enter the punch angle



-(hp) is height of punch

-rp=(0.8) Radyus is always same

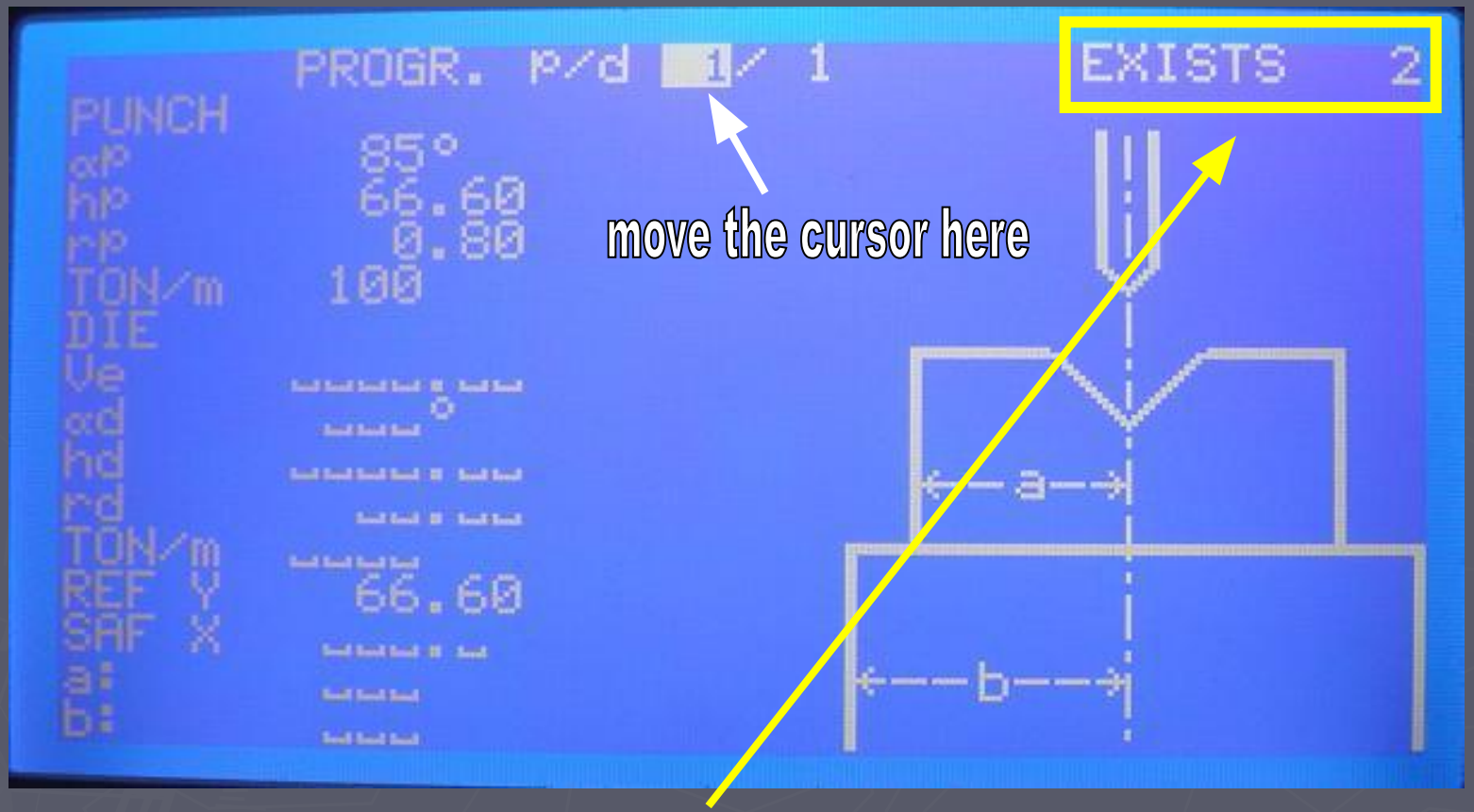
-Ton/m This is always 100 Ton/m for our machine



1-Give the number for the punch

2-Press enter button to save

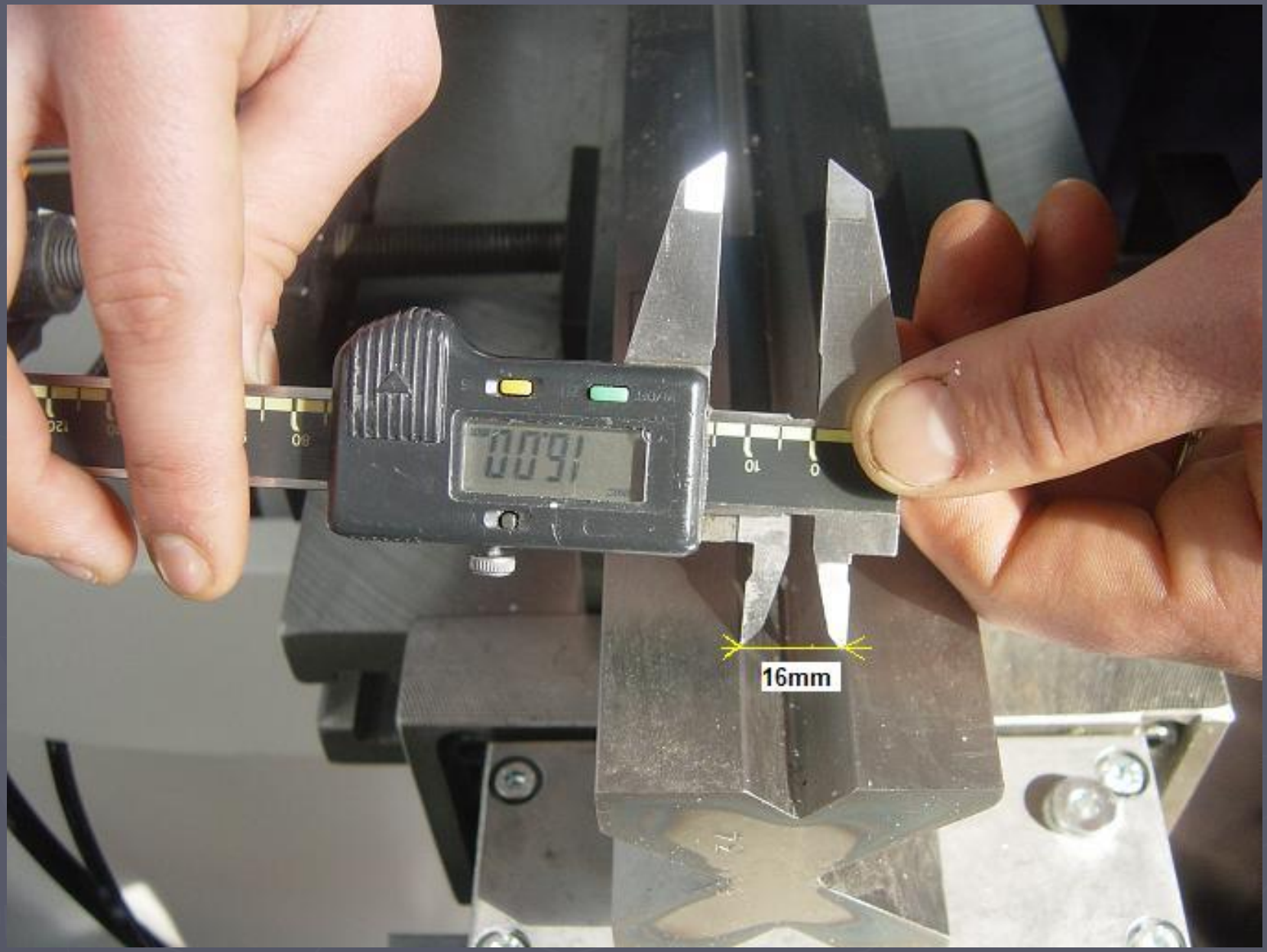
ATTENTION !

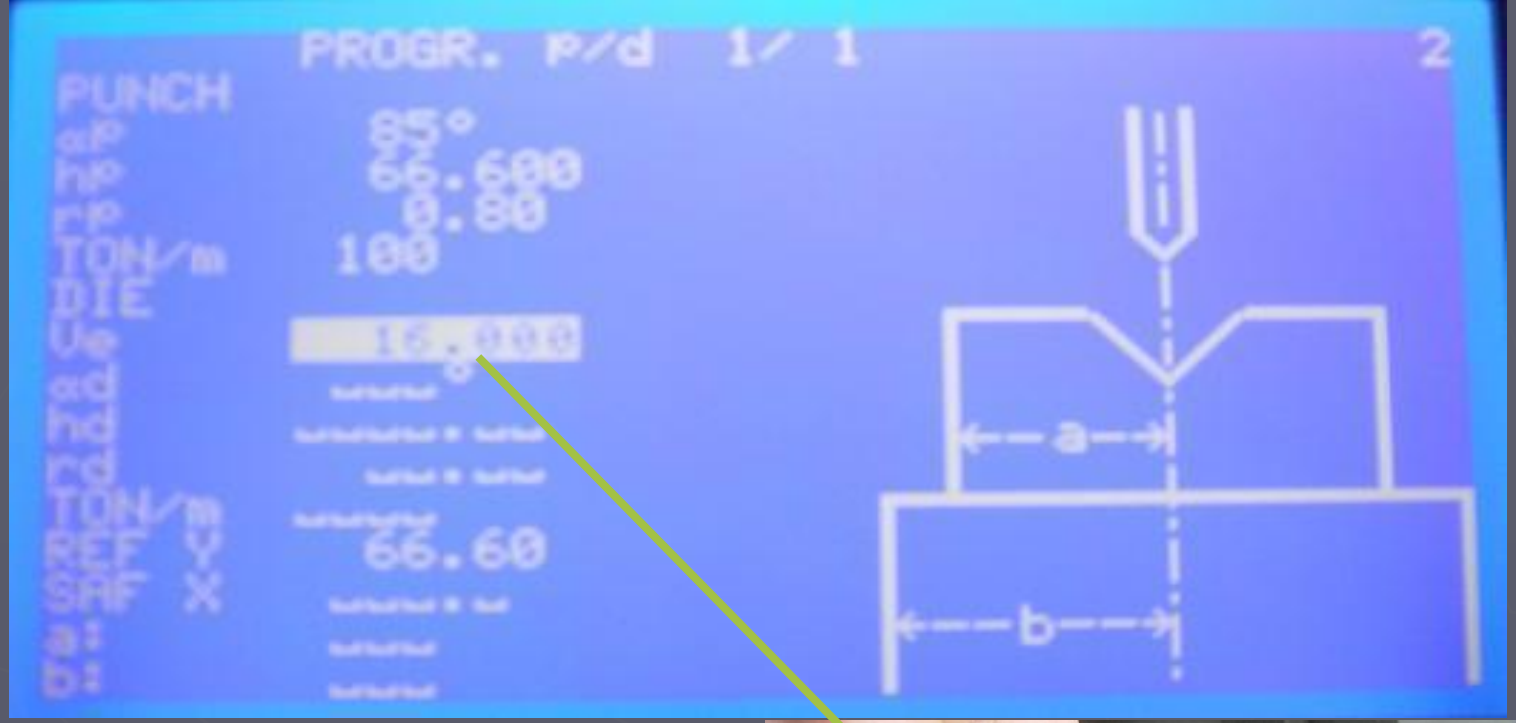


-if you see 'exists' message

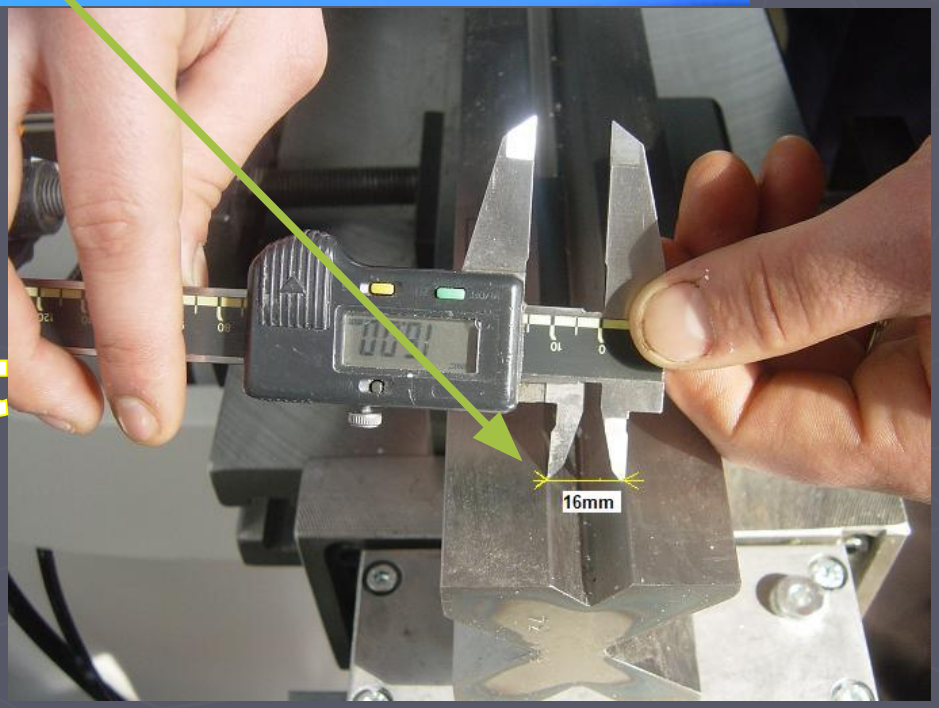
-First, press to this button

-Second, press to this button

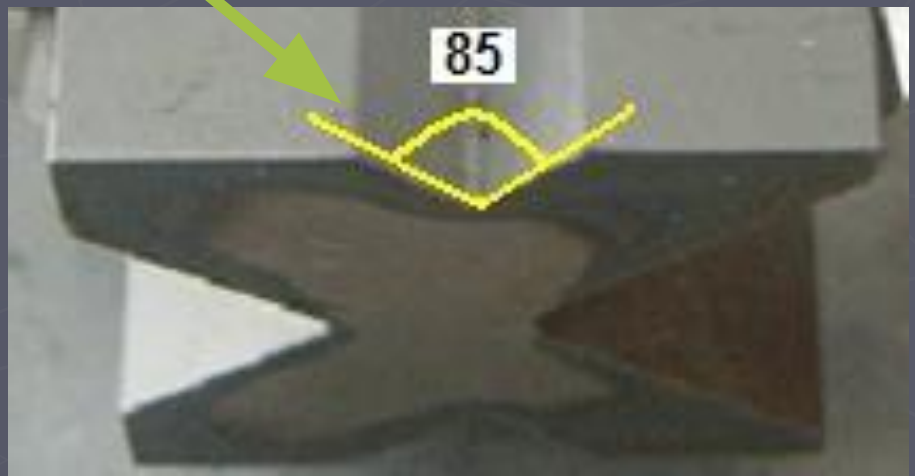

0.091
16mm



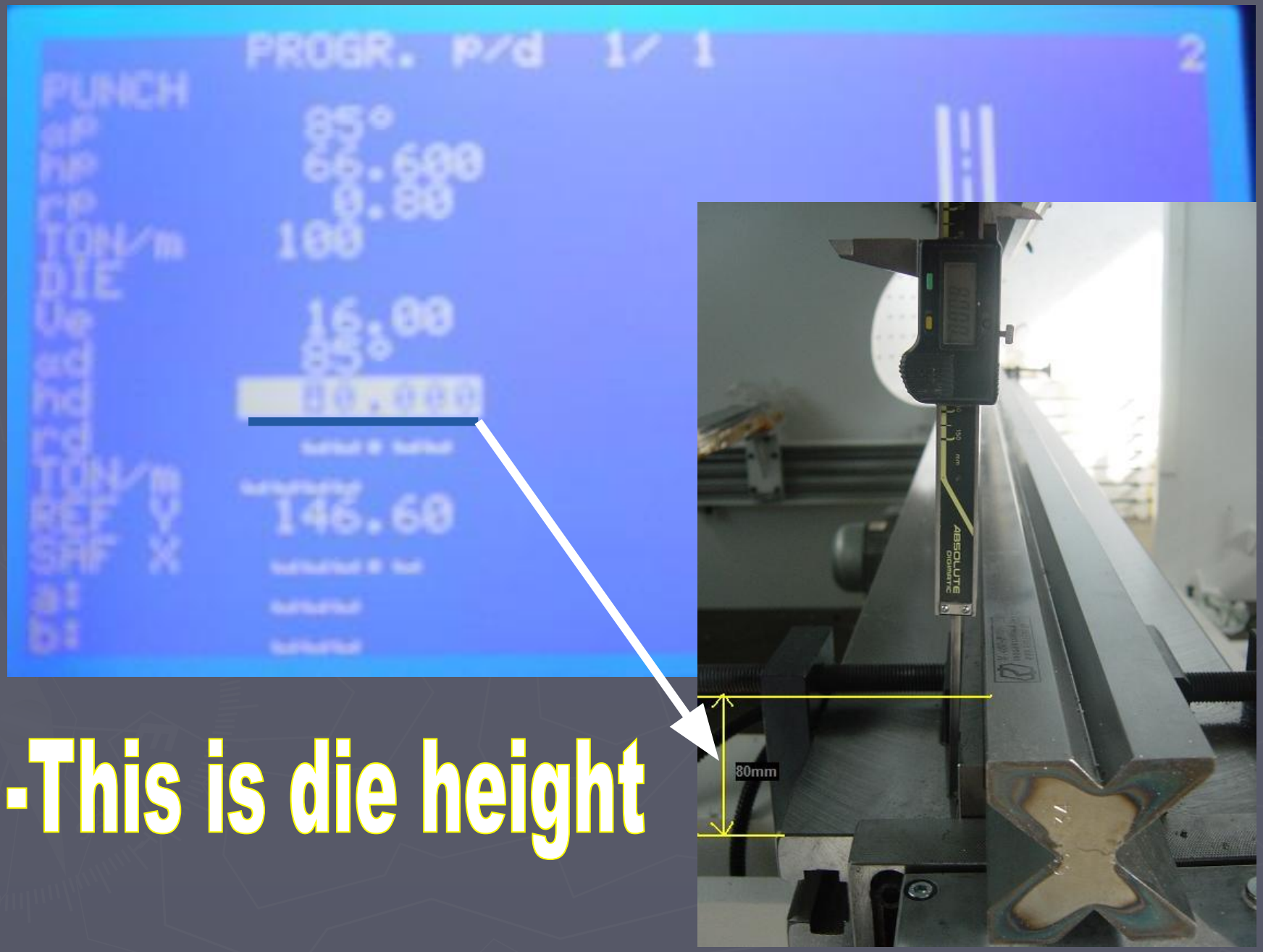
-Enter this
value to that secment



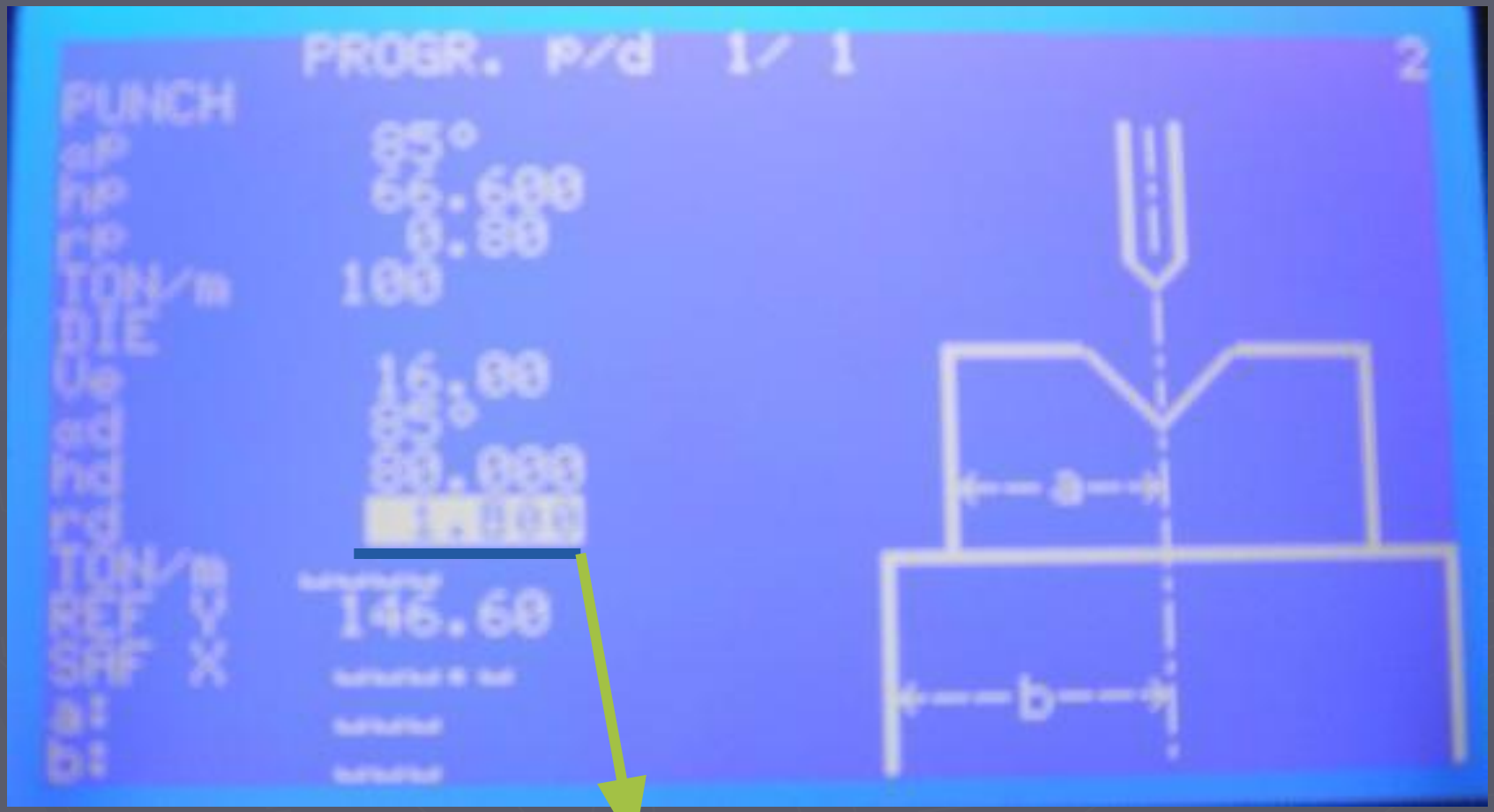
-This is die angle



hd



-This is die height

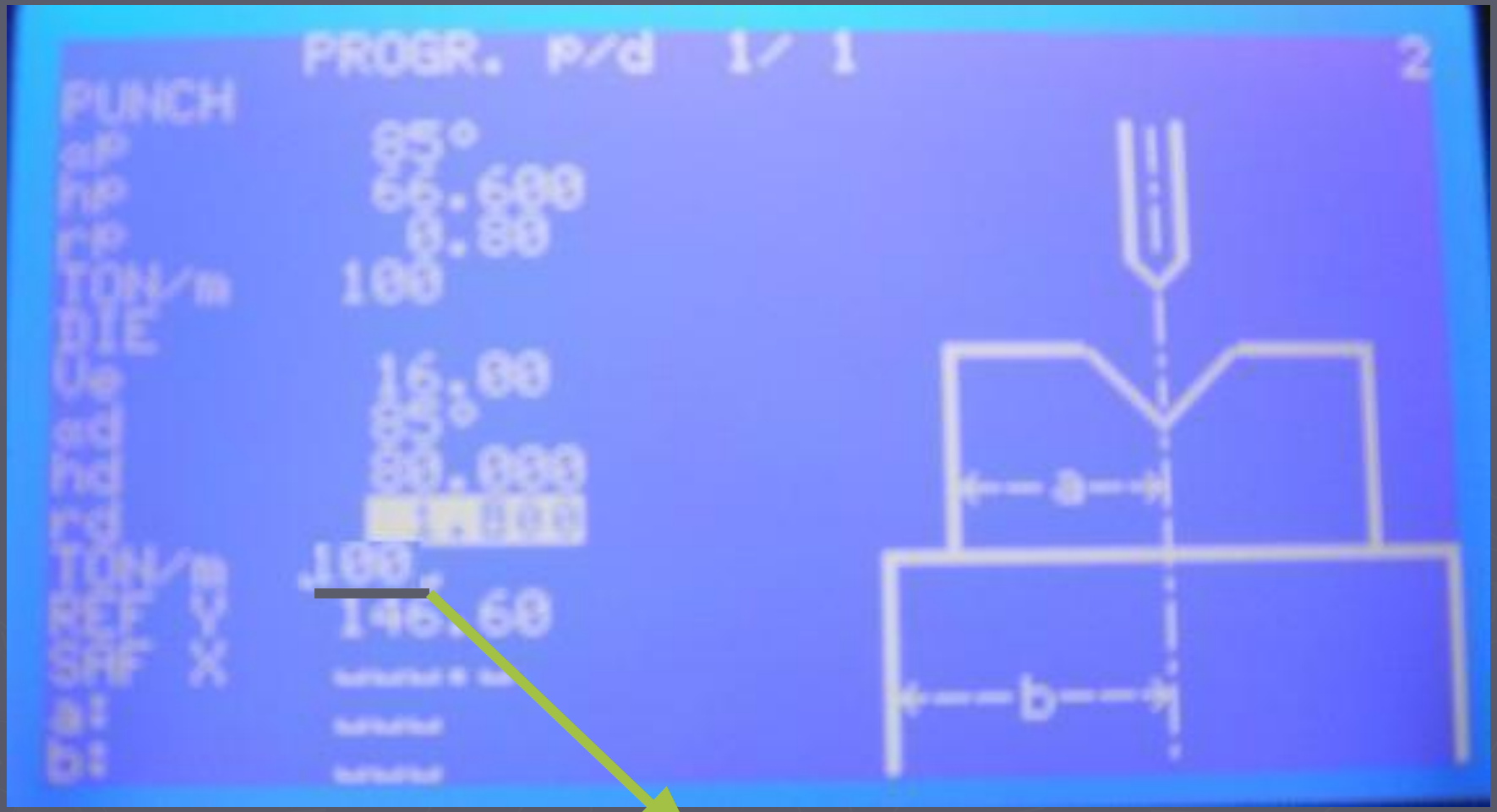


-This radius depends on (ve) value

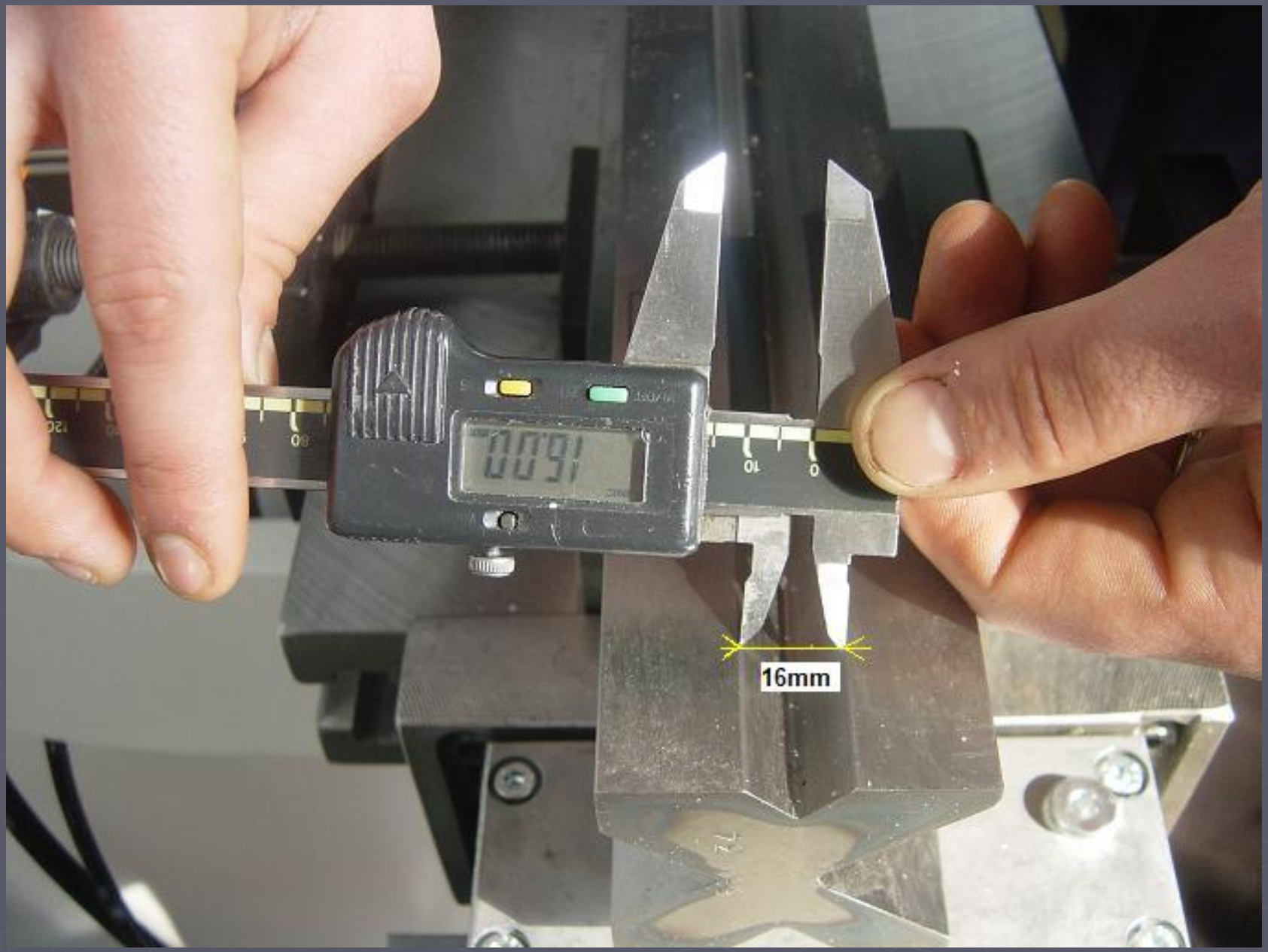
ve=? (8-16) enter rd=1.8

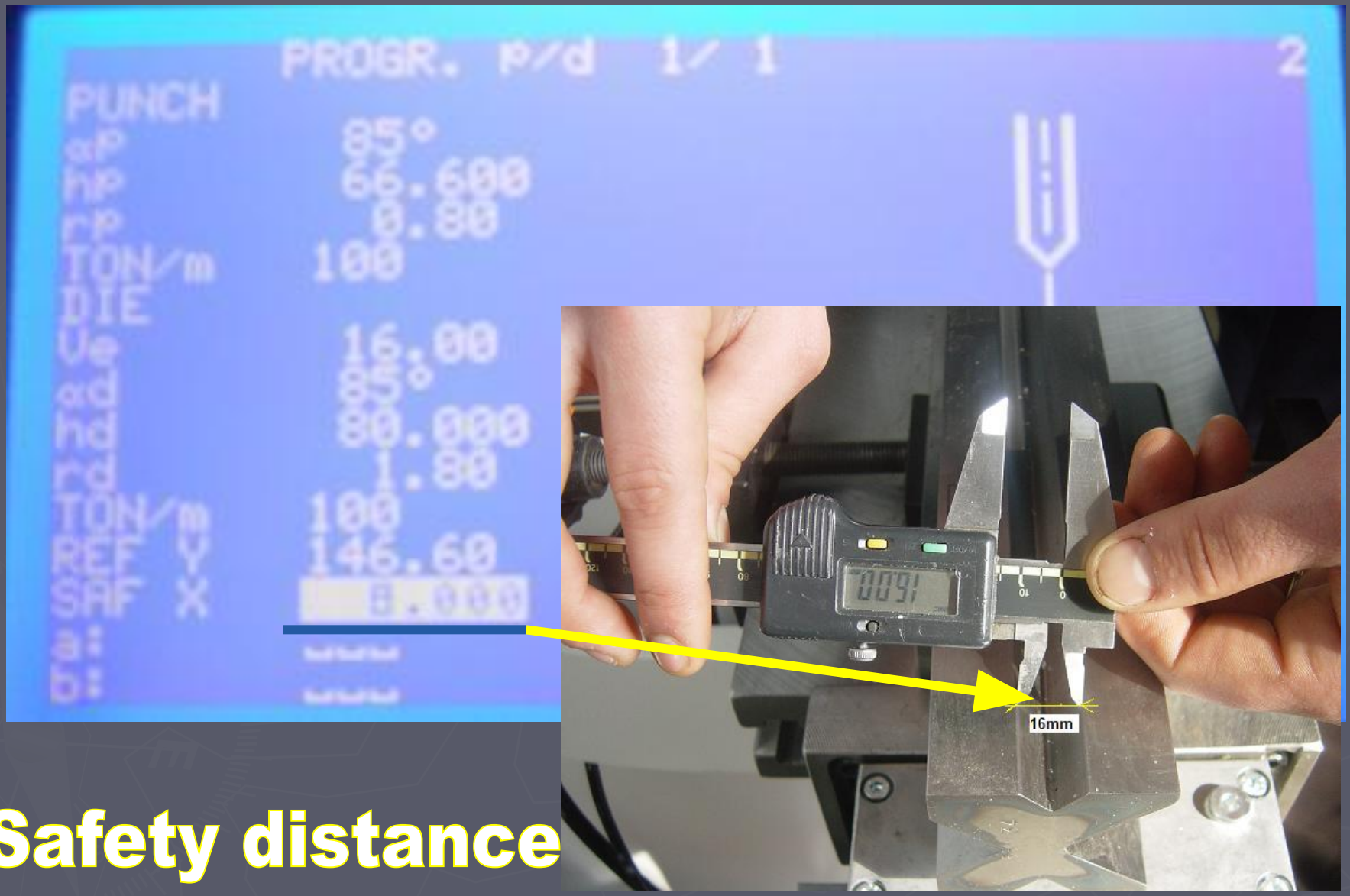
(16-25) enter rd=2

(25-45) enter rd=3

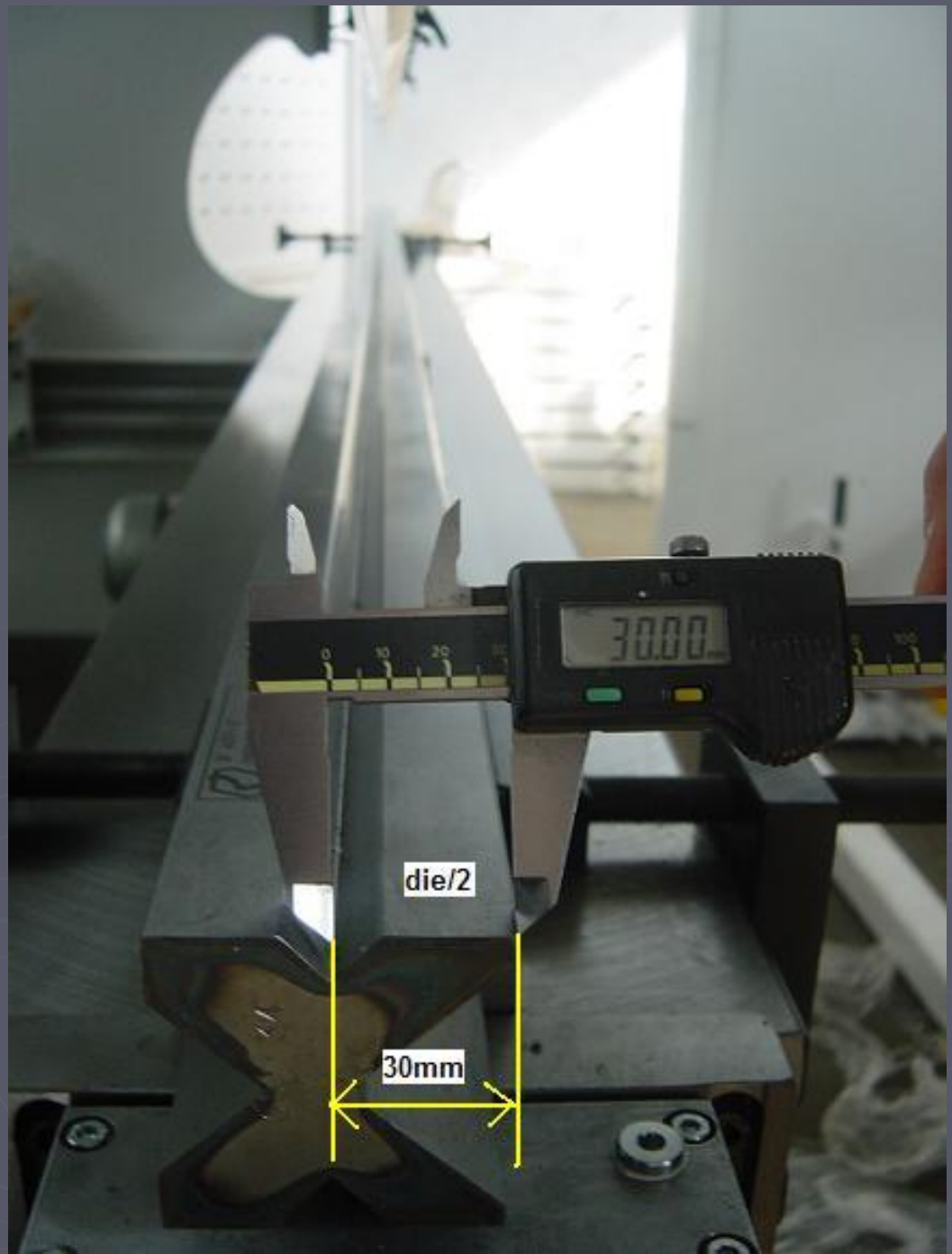


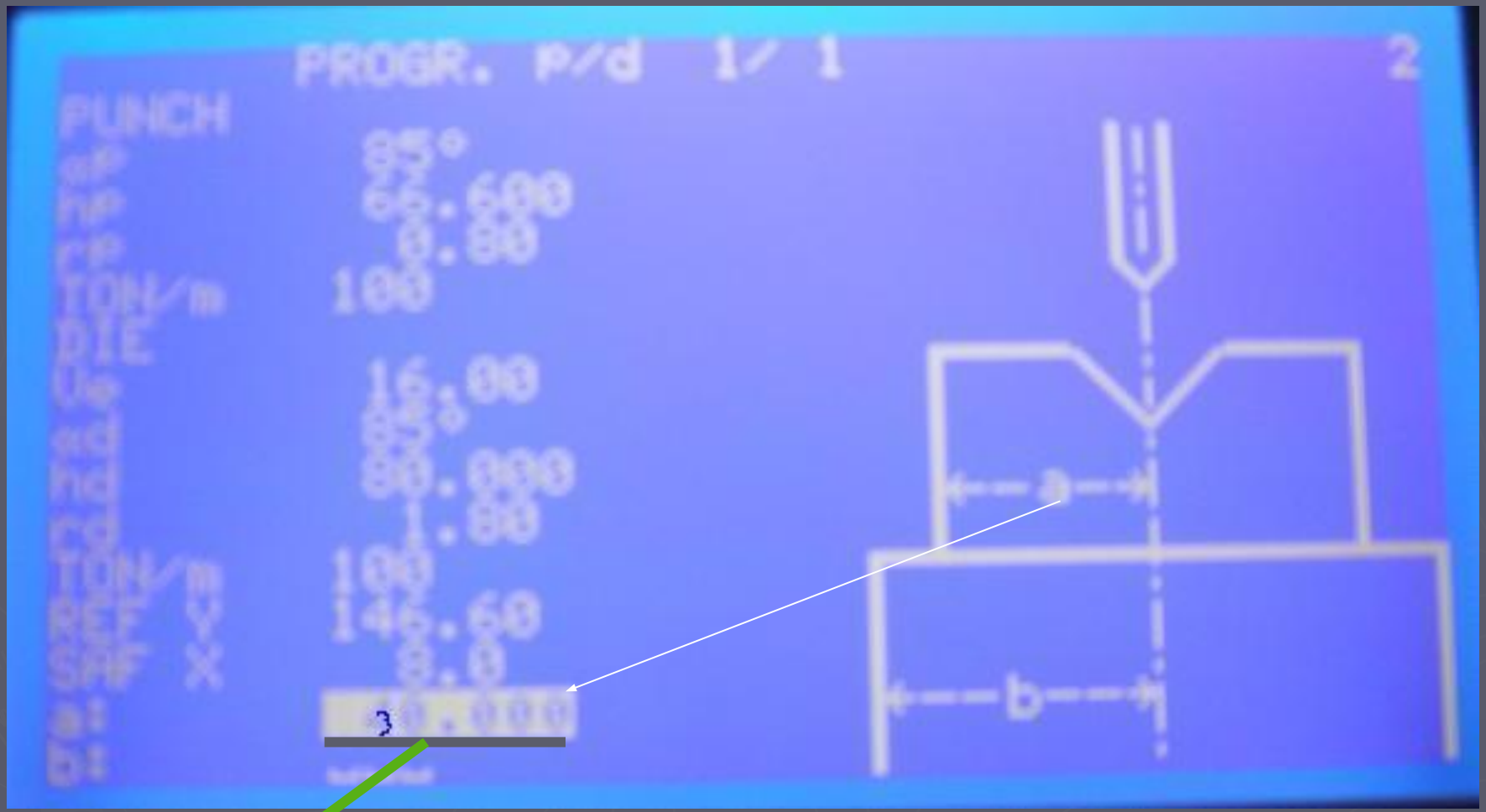
-This is always 100 Ton/m for our machine


16mm



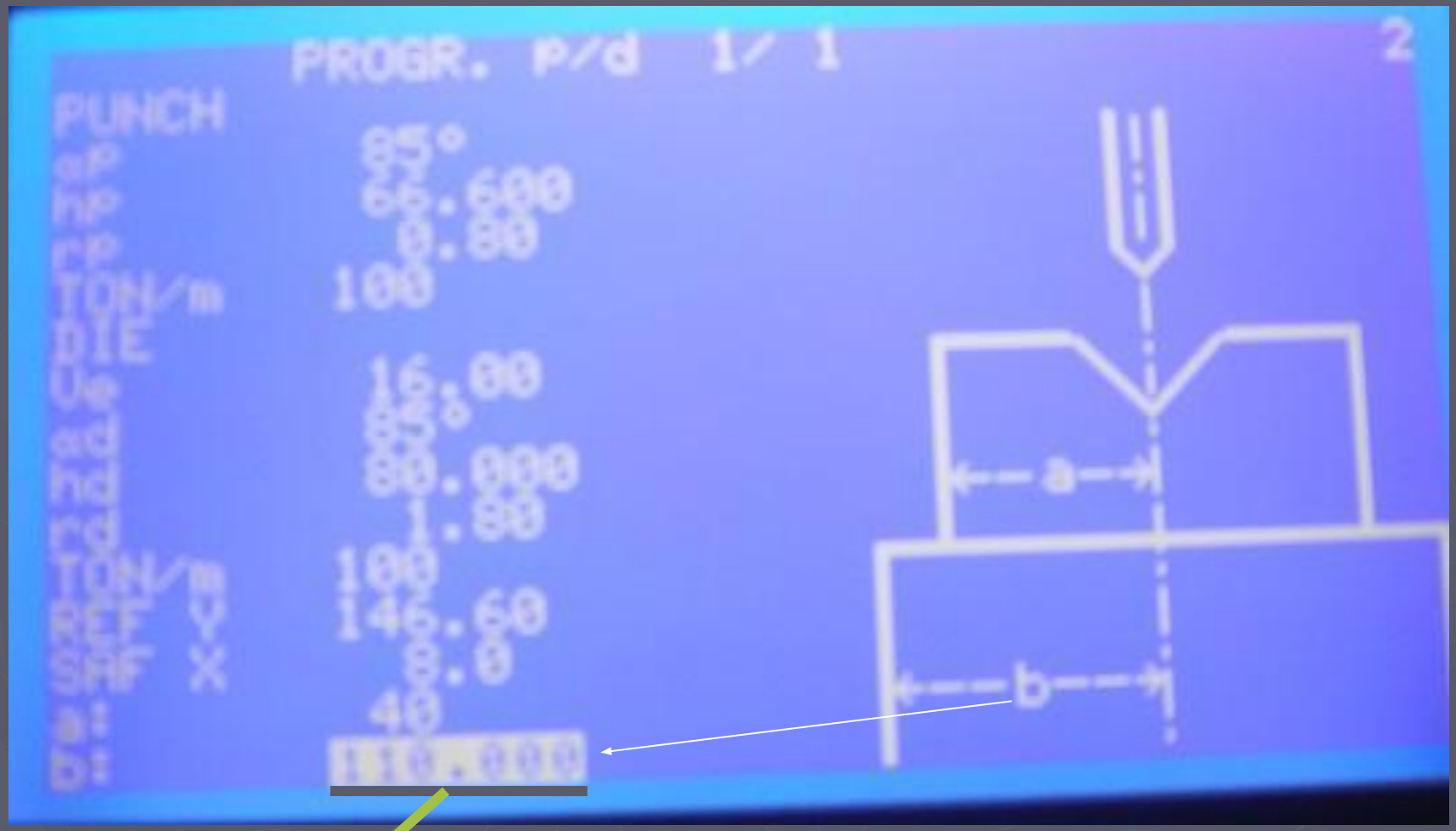
-Safety distance should be (Ve/2)


30.00
die/2
30mm



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

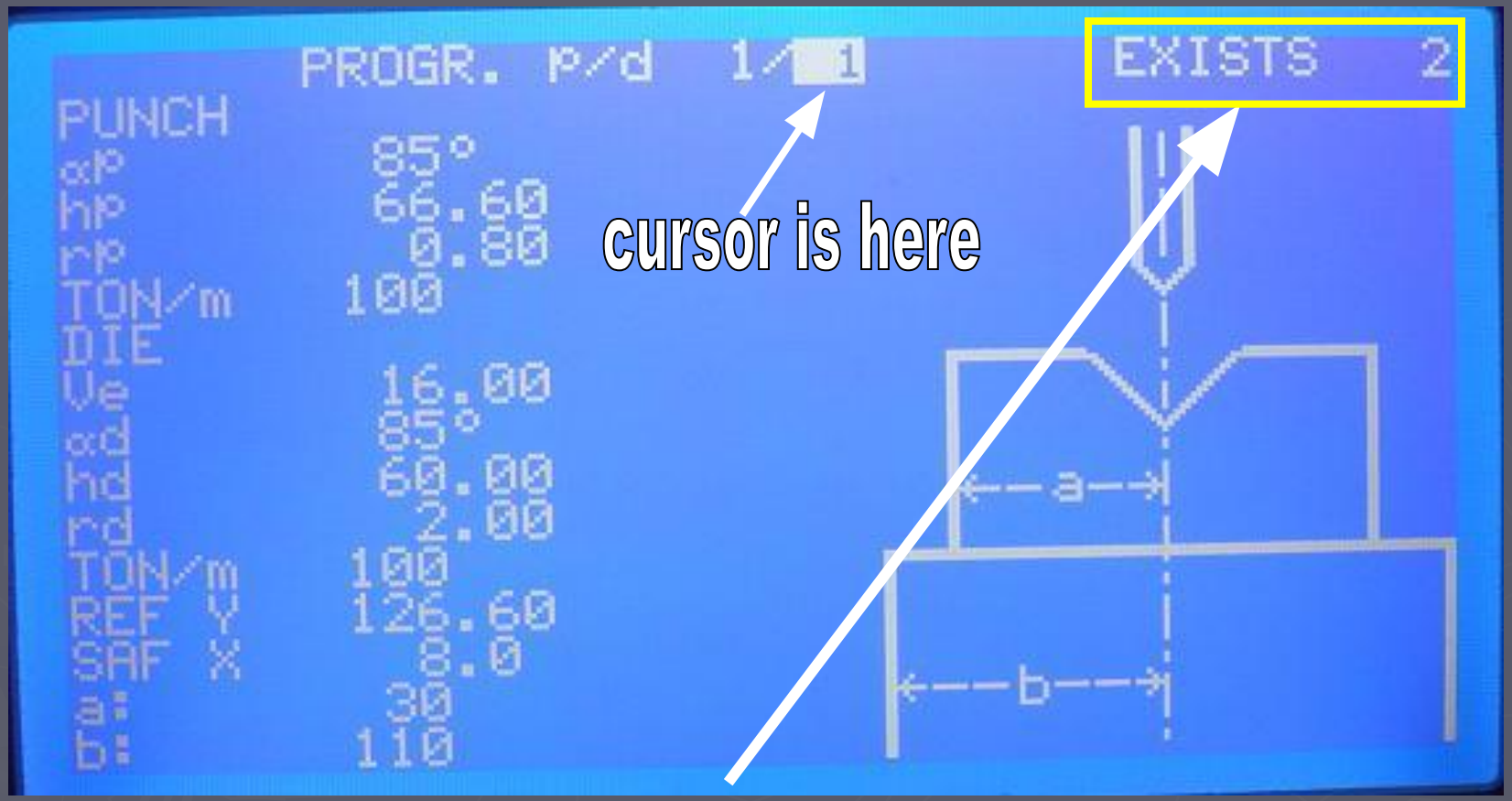

This is bottom table



-(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