

```

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

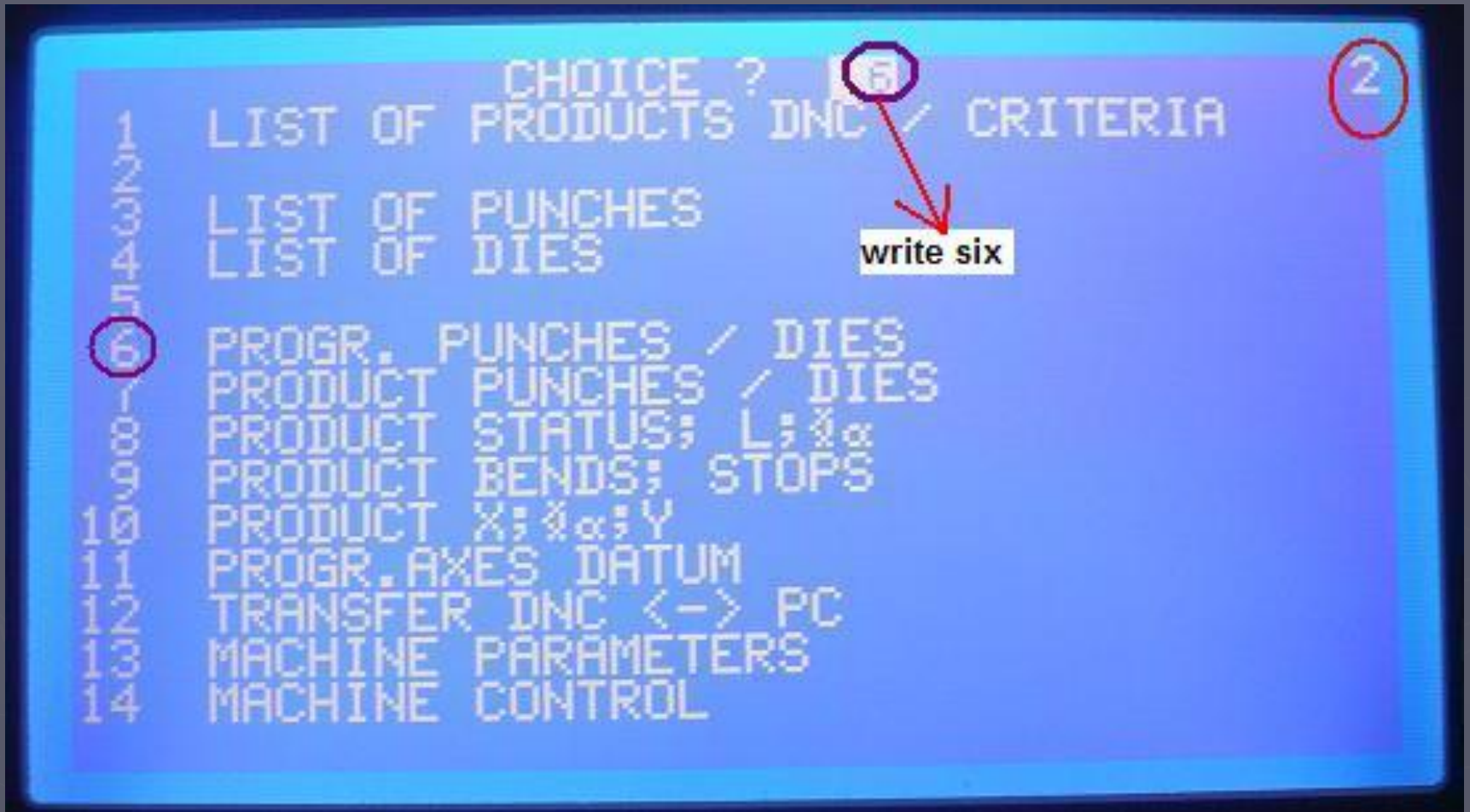
```
P 0 N 2 TK 6 K9/mm2 45.0002
K1: 2.00 CR 1/1 ---KON--- --DUZ--
b/k 1/1
---HDF---
3α 90.0°
V1 122.09 127.33
V2 122.09 120.00
X 143.0 76.2
MIK
PBoy 1400 Fb 21TON
Rx Hrc Start
U%↑%↑% ΔUZ
UON HDN
F1: F2: F3: F4: F5: B0:
```

DNC
60

PAGE SELECTION



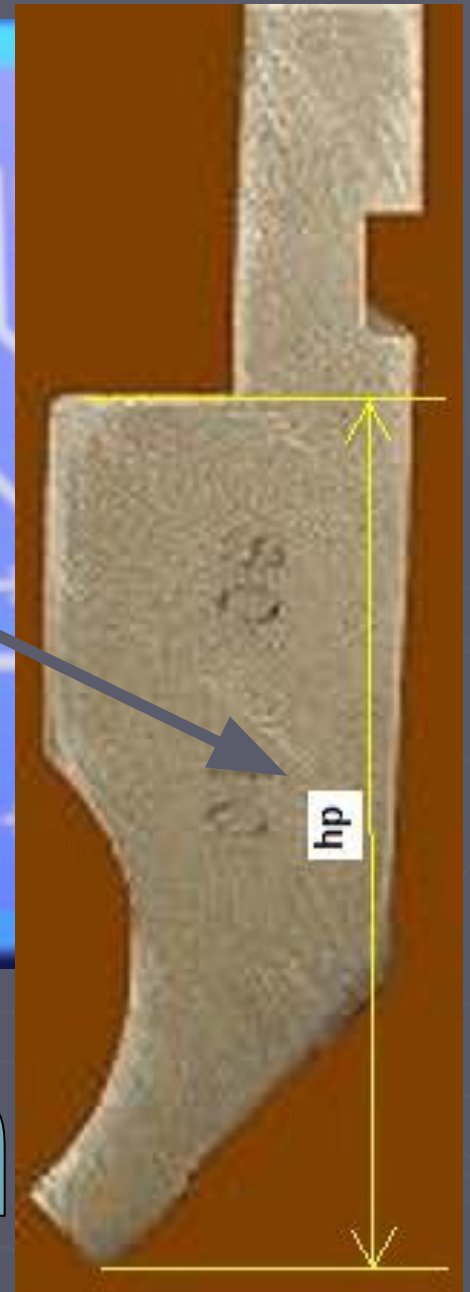
Press empty button



1-Write six

2-And write six, step to that button →



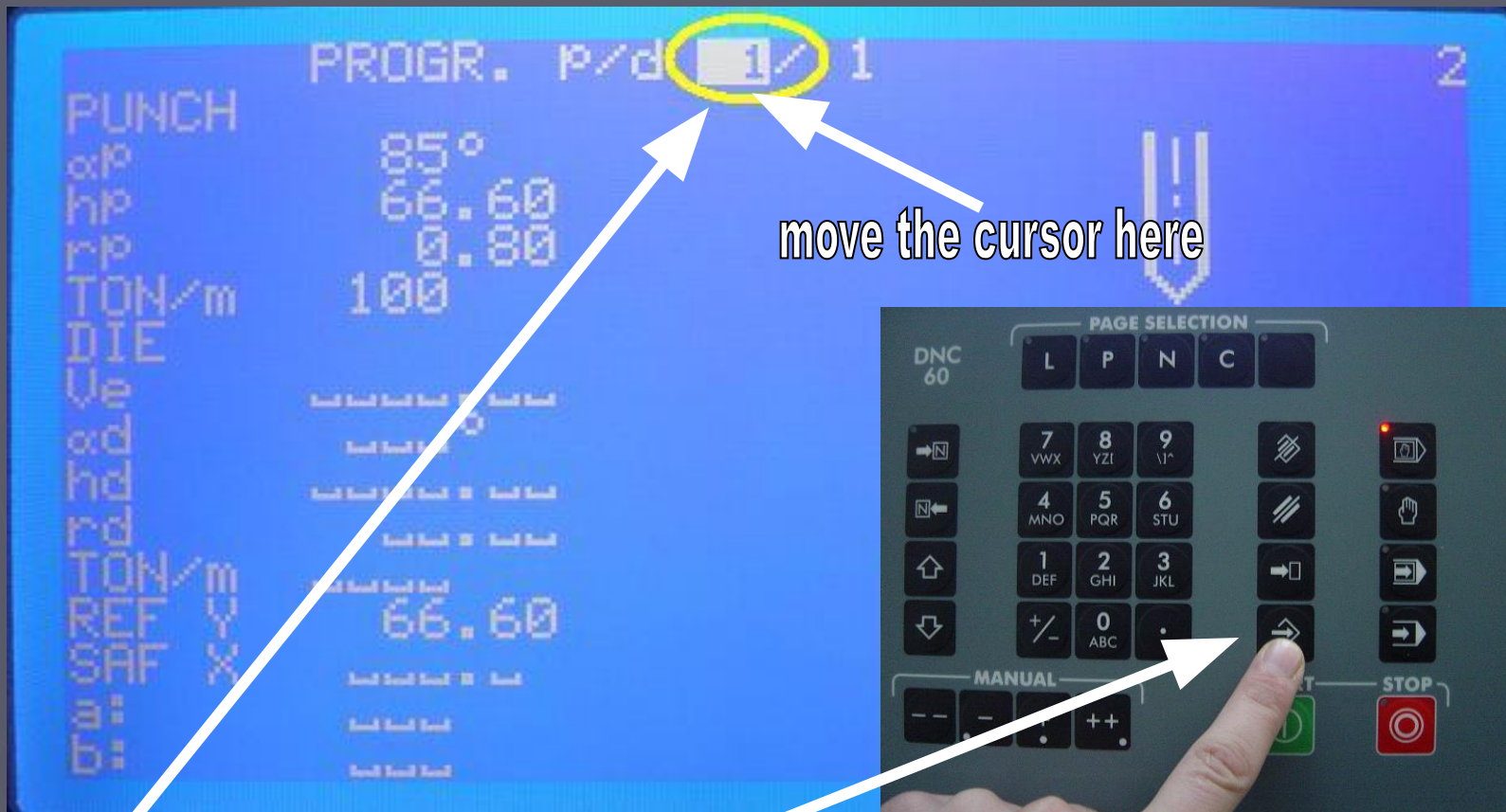


-(hp) is height of punch



- $r_p=(0.8)$ Radius is always same

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

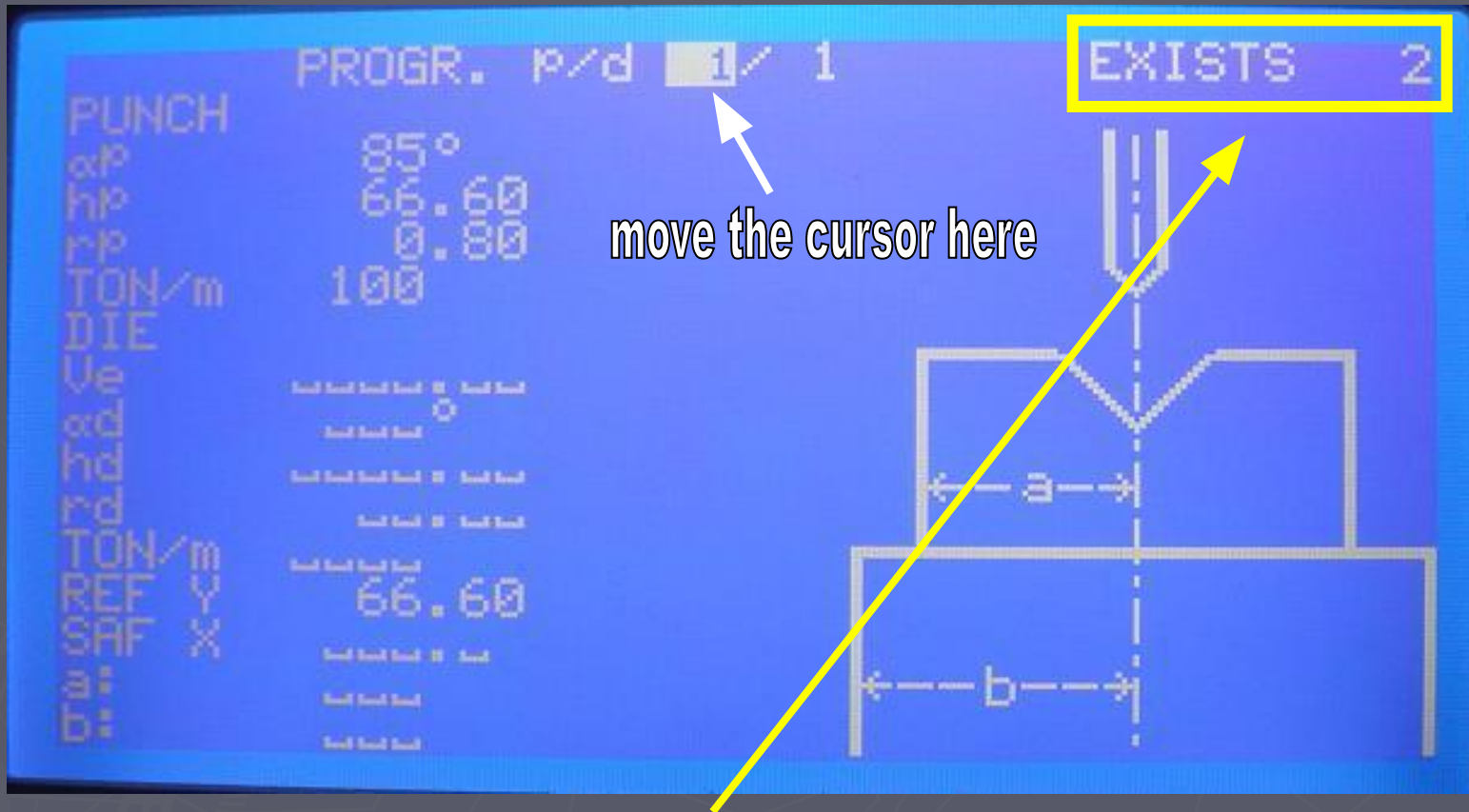


move the cursor here

1-Give the number for the punch

2-Press enter button to save

ATTENTION !



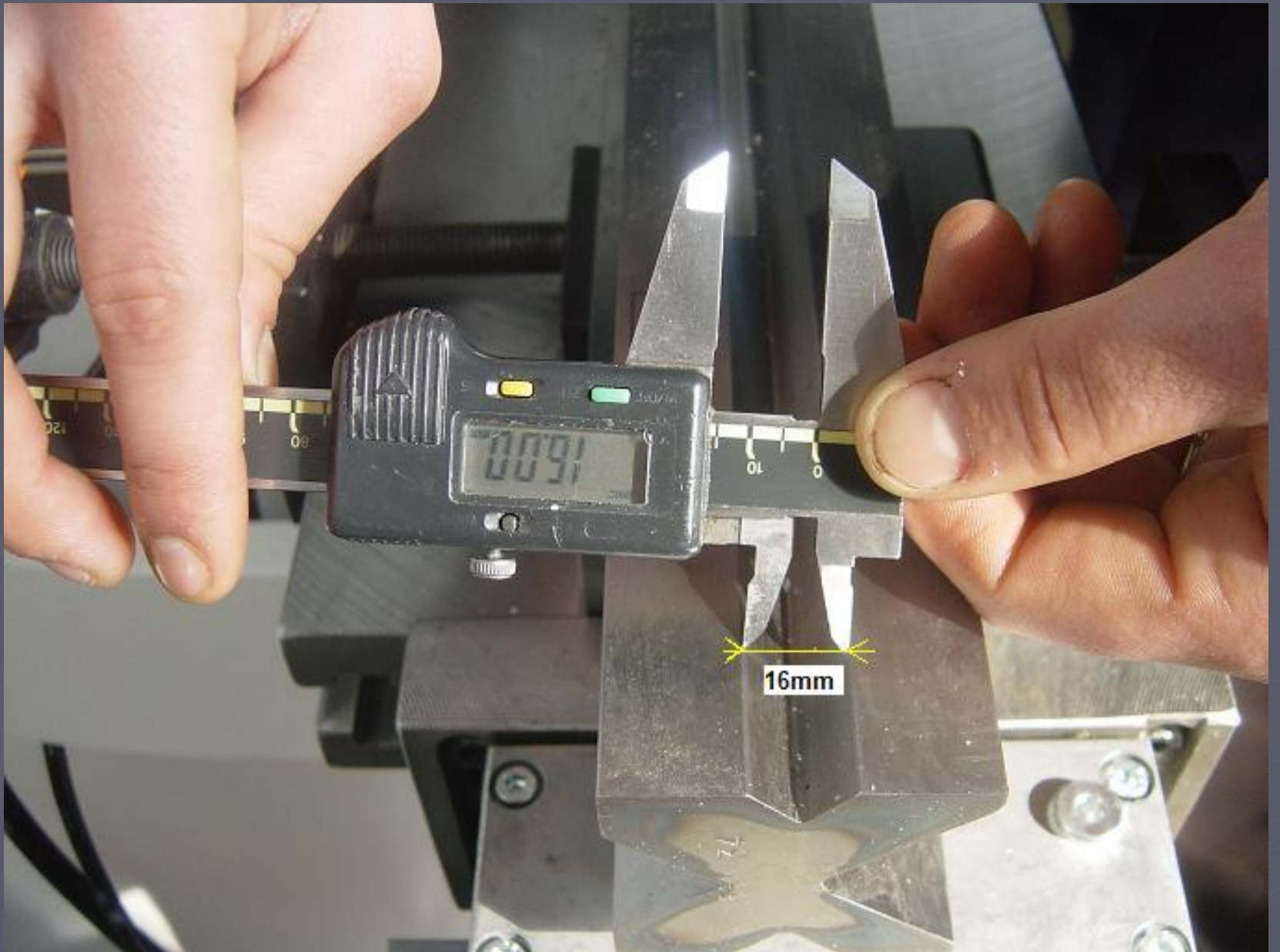
-if you see 'exists' message

-First, press to this button



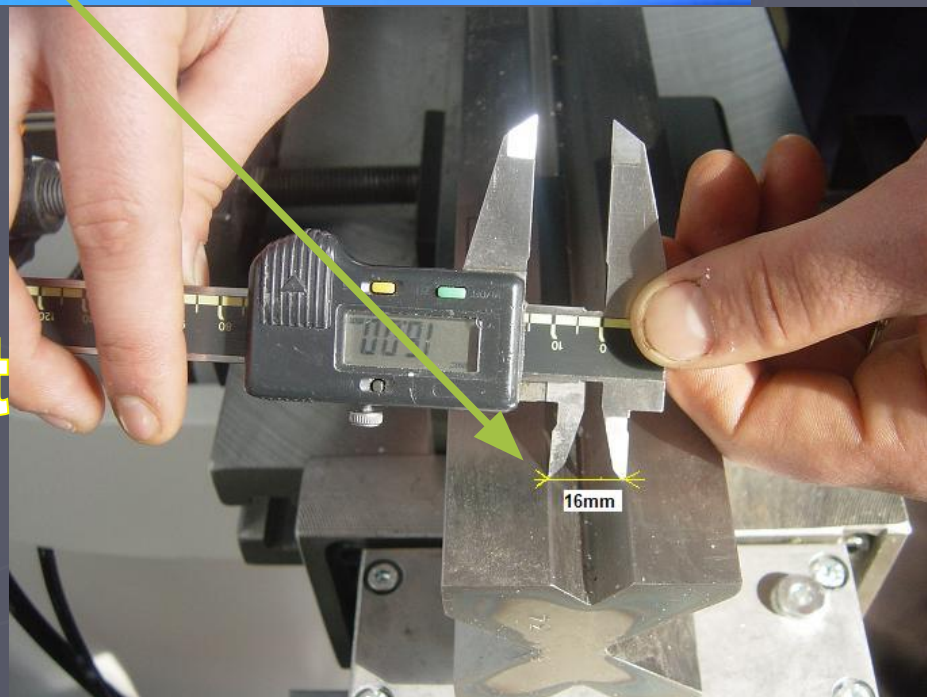
-Second, press to this button







**-Enter this
value to that segment**

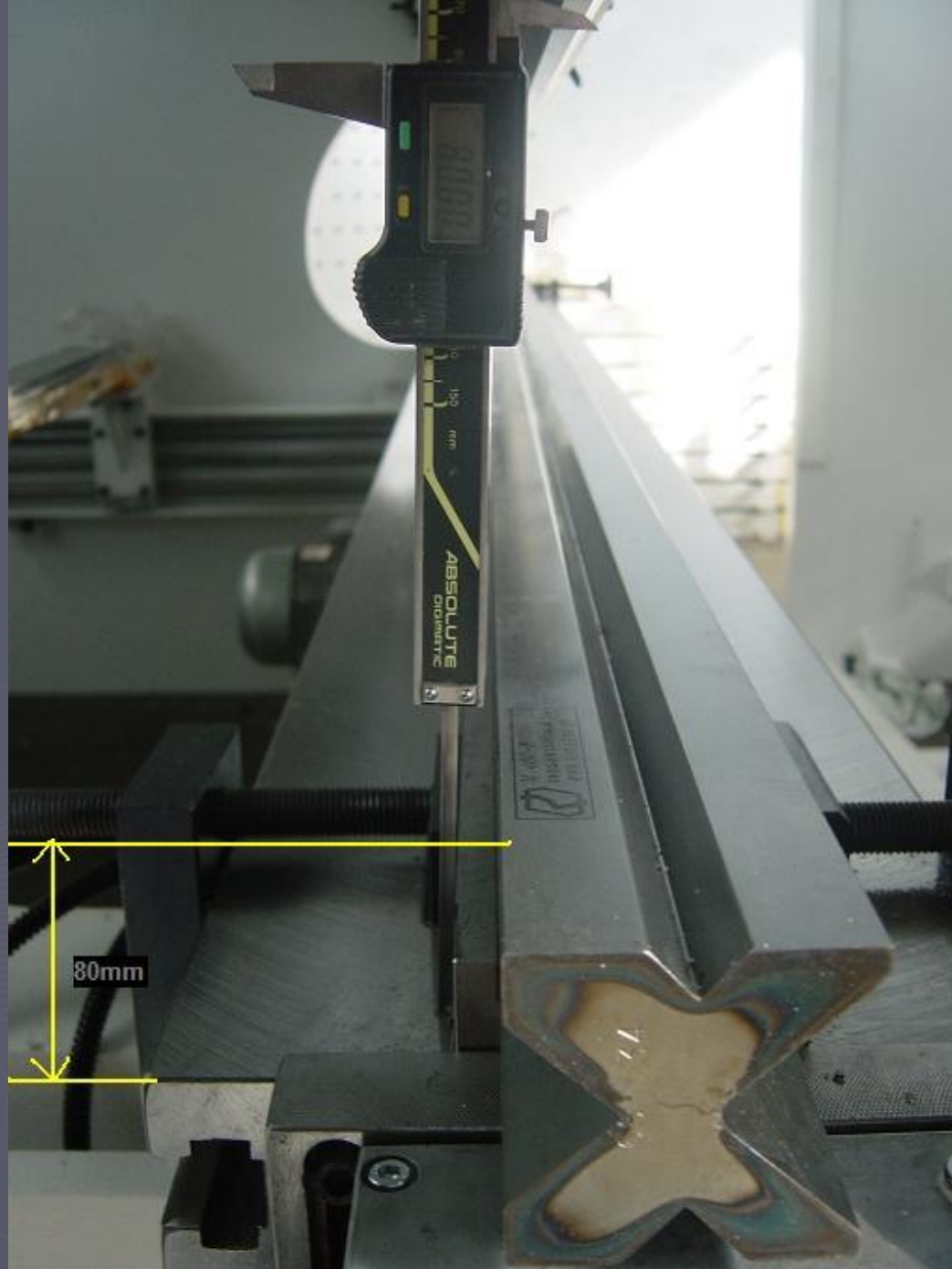


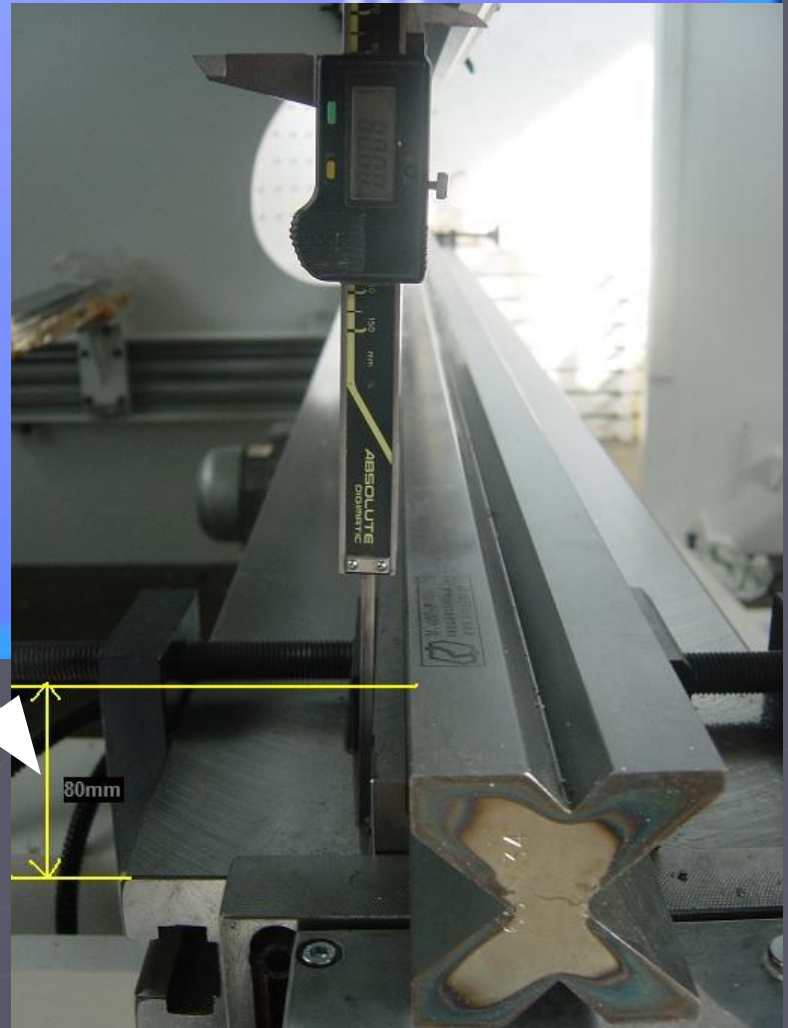
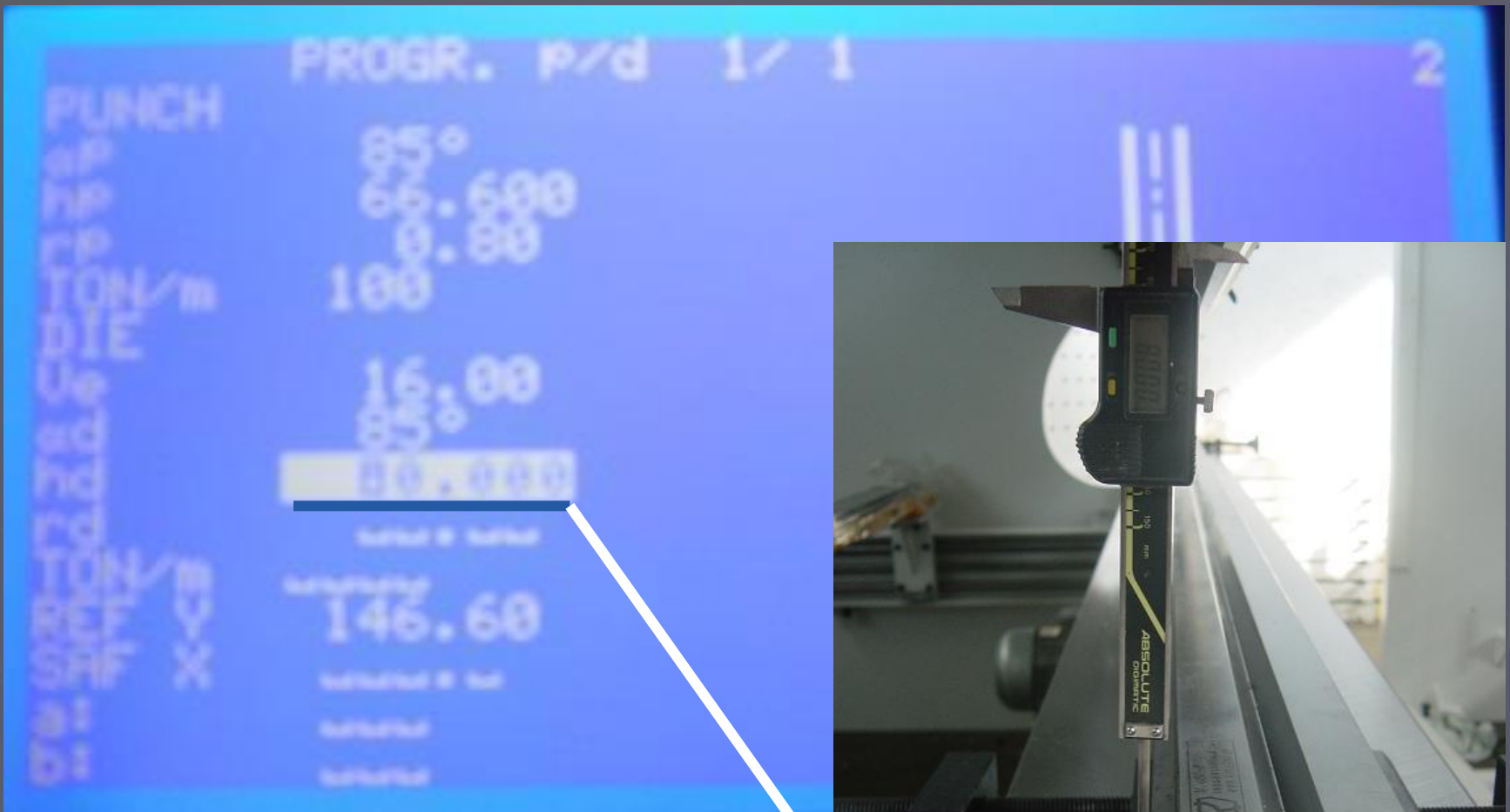


-This is die angle



hd

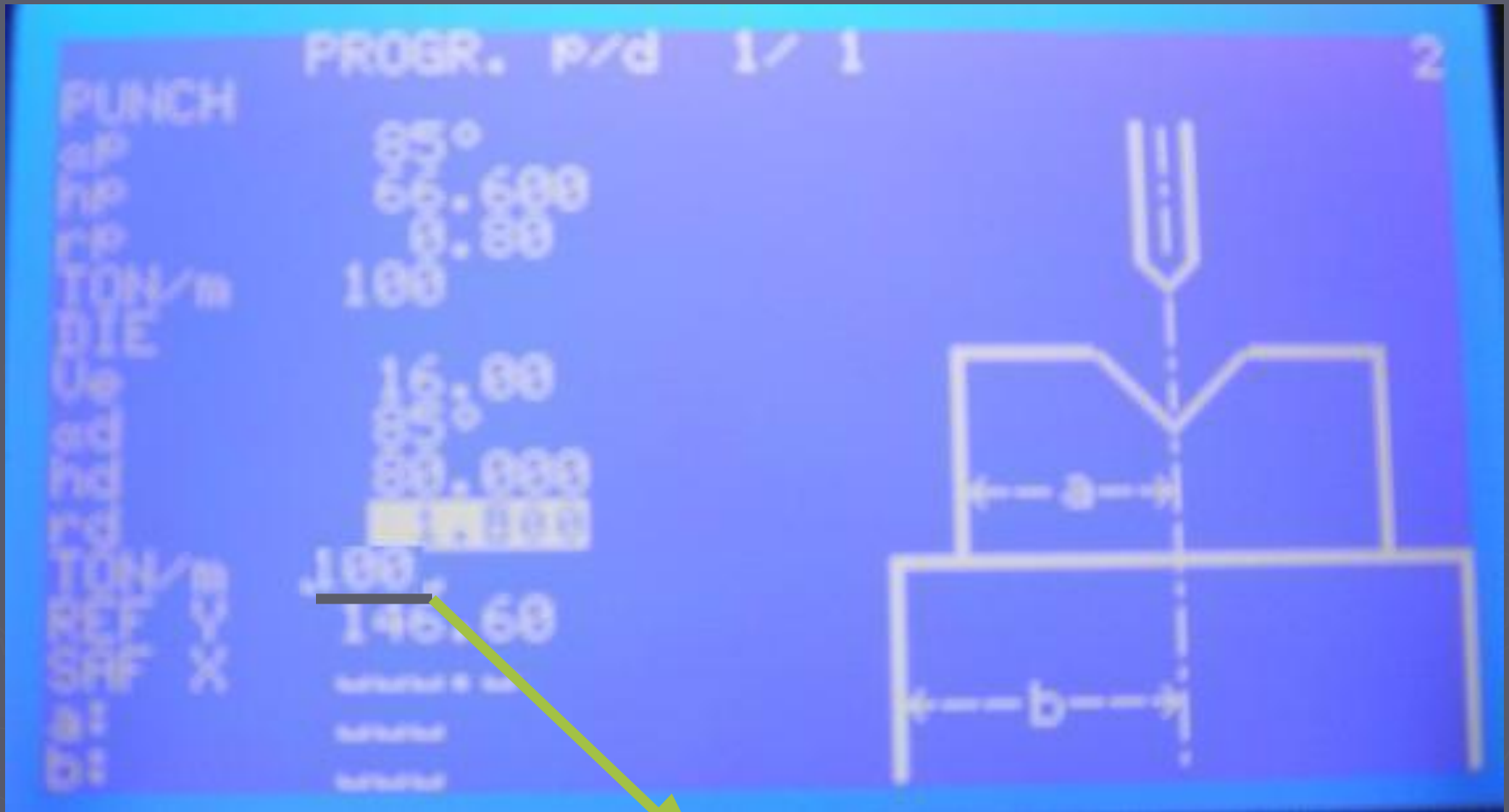




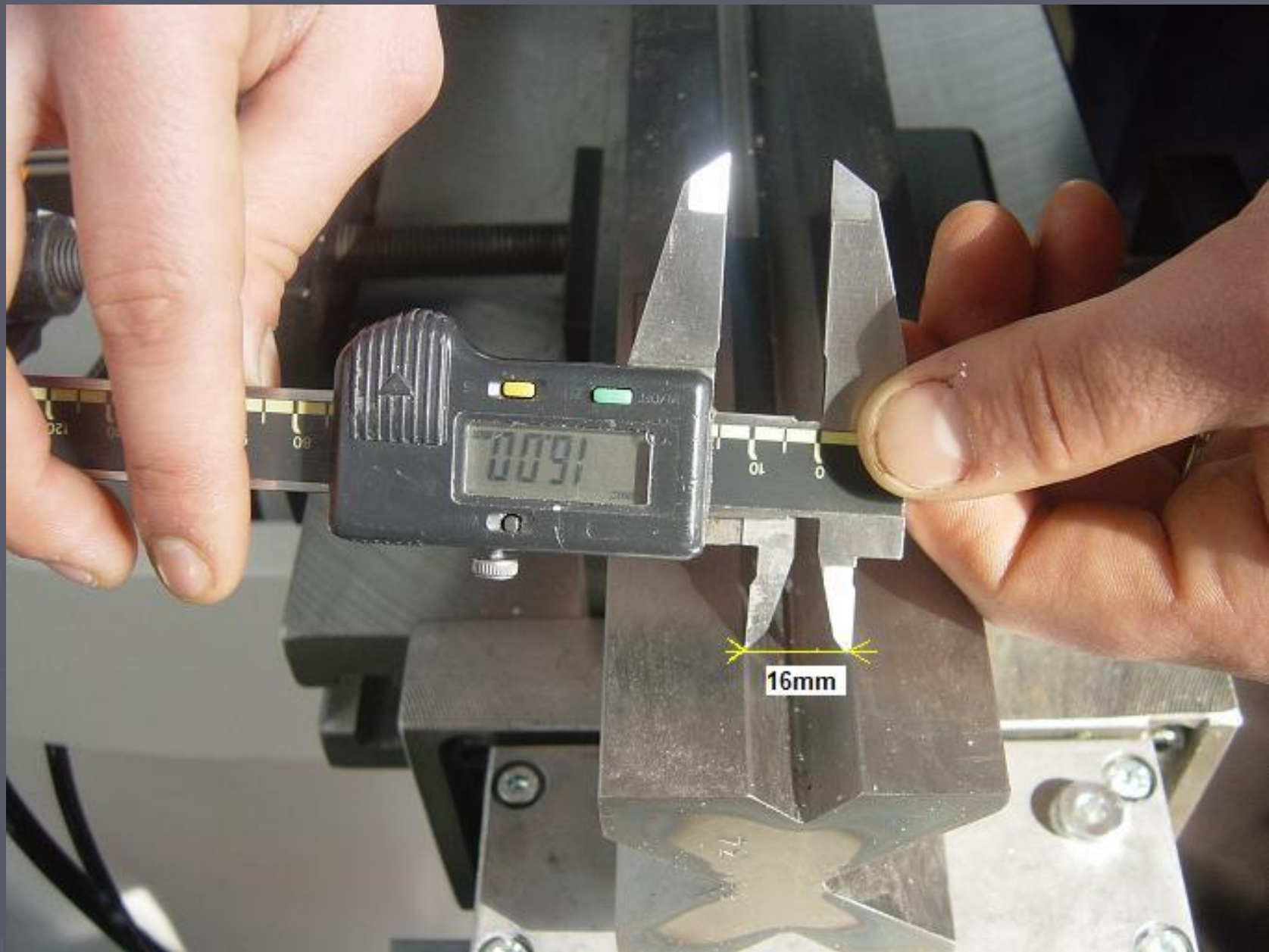
-This is die height

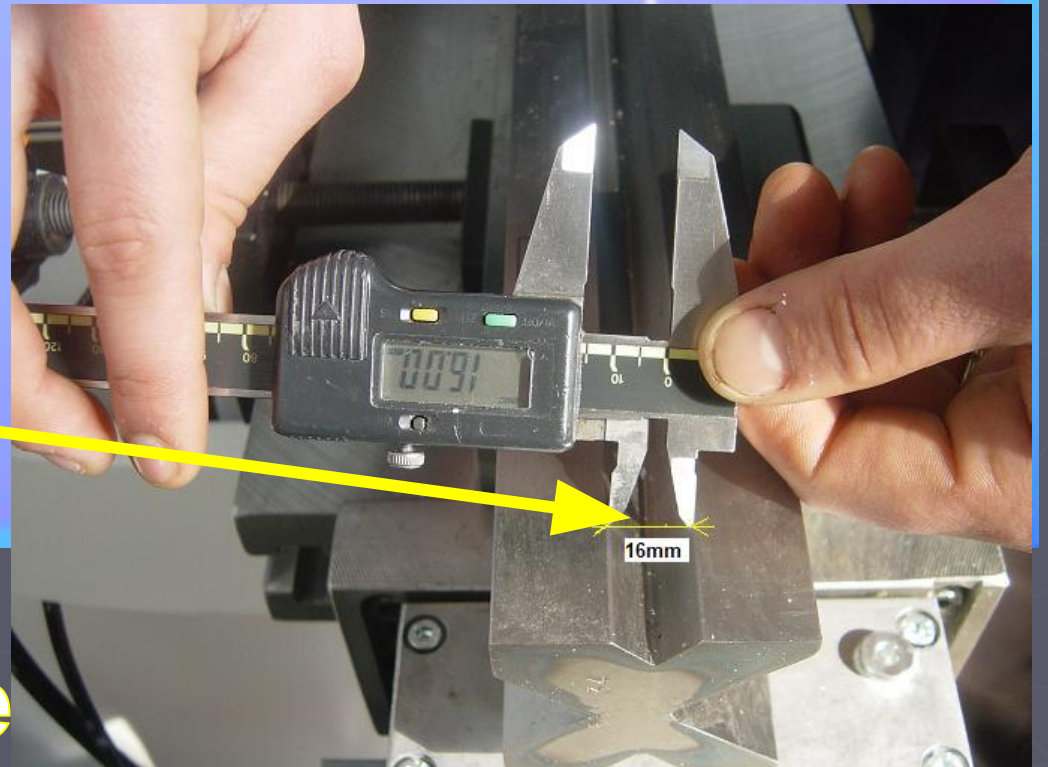
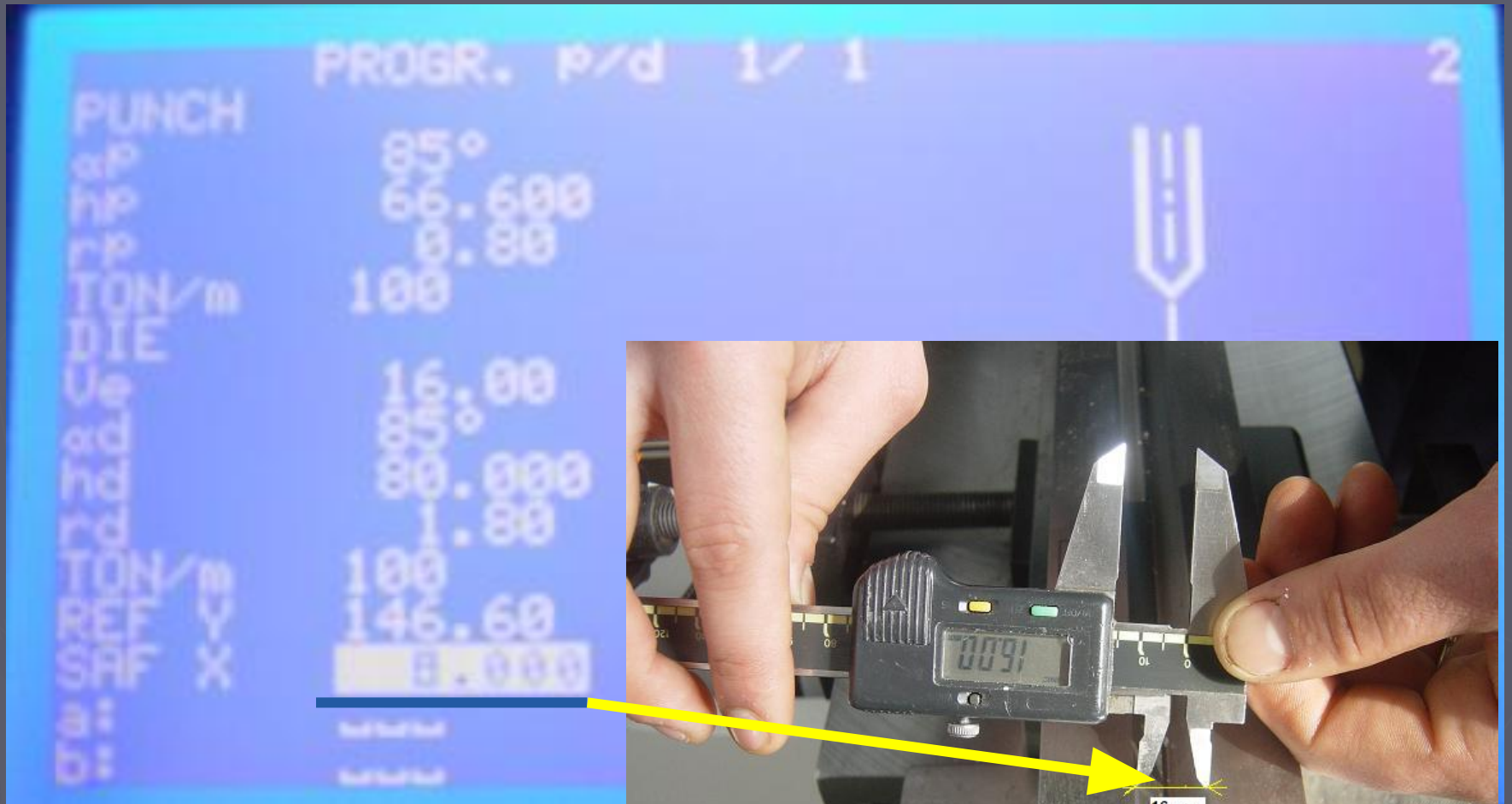


**-This radius depends on (ve) value
ve=? (8-16) enter rd=1.8
(16-25) enter rd=2
(25-45) enter rd=3**

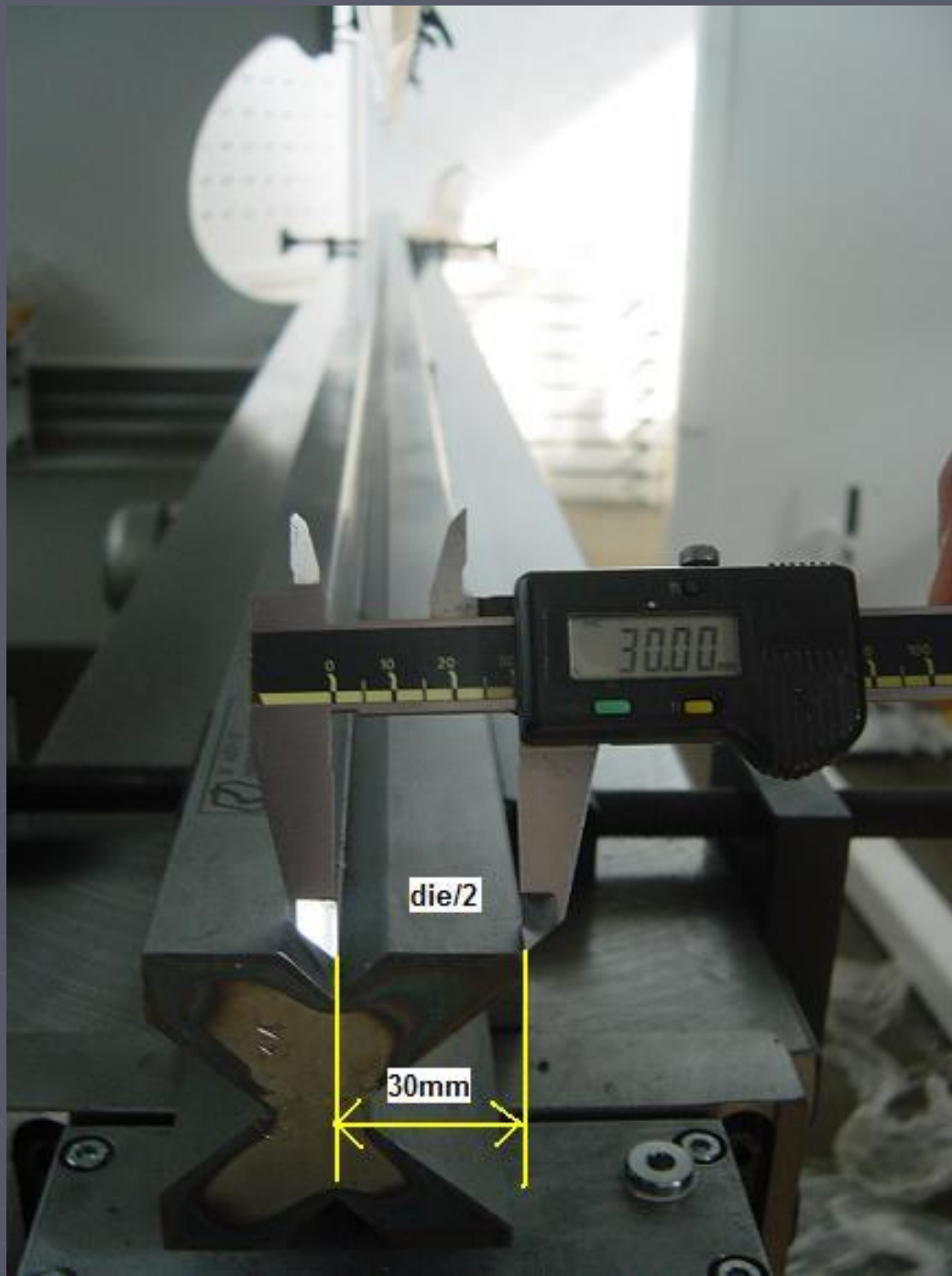


**-This is always 100
Ton/m for our machine**





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



$\text{die}/2$

30mm



This is bottom table

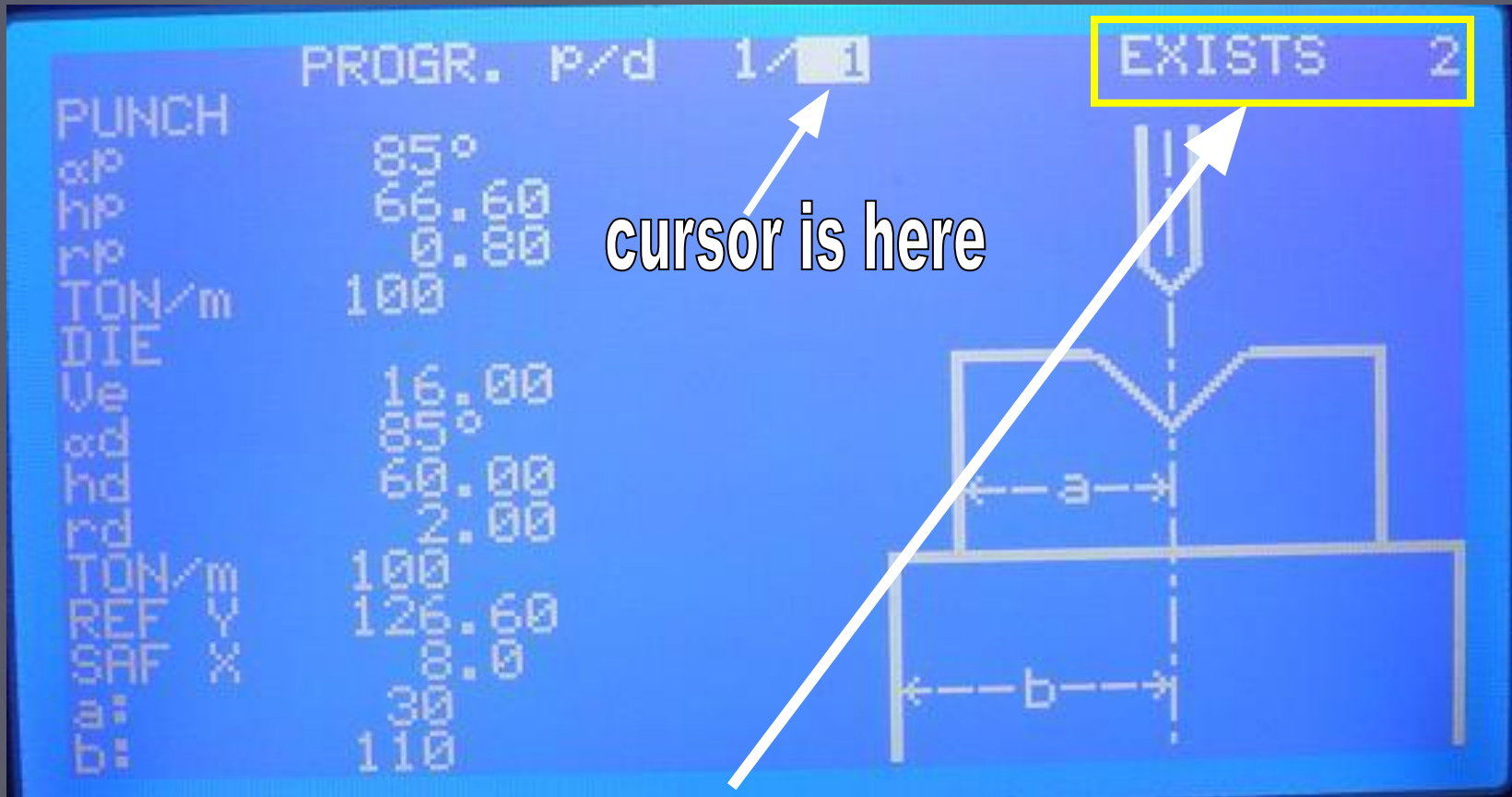


-(b) Value should be half measurement of bottom table width (bottom table/2)



- 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

