

P	0	N	2	TK	uu		0
K1:	2.00				6	K9/mm ²	45.000 ⁰
b/k	1/1			CR	uu/ri	uuuuuu	
		--HDF--			--KON--		--DUZ--
α		90.0°					
Y1		122.09			127.33	-	0.09
Y2		122.09			120.00	-	0.27
X		143.0			76.2		uuuuuu
MIK		uuuu			uuuu		
PBoy	1400			Fb	27TON		
Rx		uuu		Hrc	Start		
Uy↓uu%↑uu%				Δ UZ	uuuS		
UON		uuuu		HDN	uuuu		
F1:uuu	F2:uuu	F3:uuu	F4:uu	F5:uu	Bo:uuu		





-The value is 222

-then, press the enter button



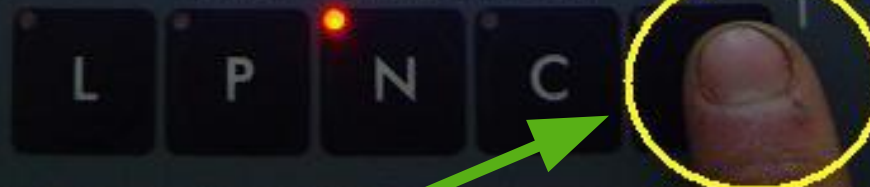
Level must be 2

CYBELEC

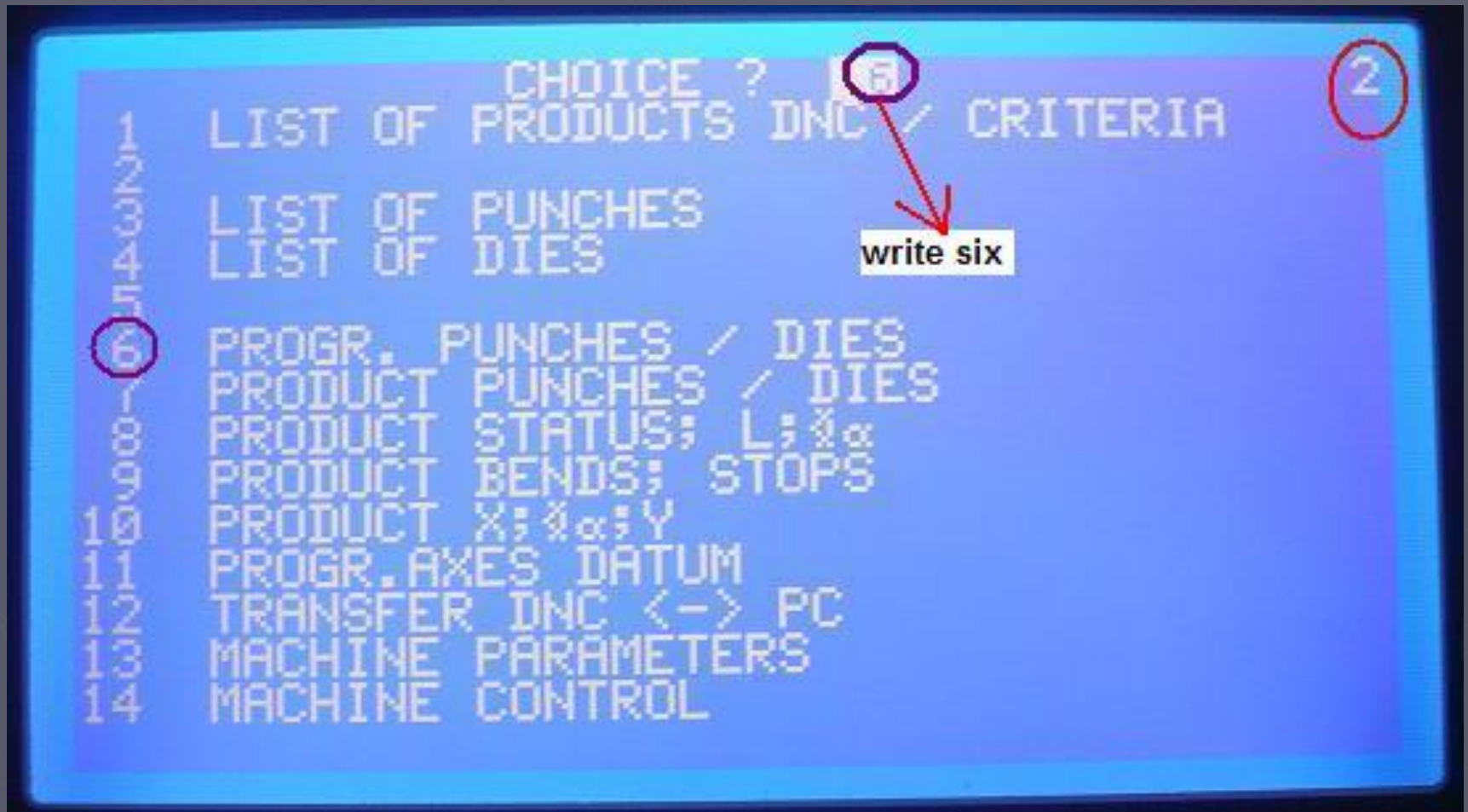
P 0 N 2 TK 6 K9/mm² 45.000²
K1: 2.00 CR 1/1 --KON-- --DUZ--
b/k 1/1 --HDF--
3α 90.0°
V1 122.09 127.33
V2 122.09 120.00
X 143.0 76.2
MIK
PBoy 1400 Fb 27TON
Rx Hrc Start
Uy%↑% ΔUZ
UDN HDN
F1: F2: F3: F4: F5: B0:

DNC
60

PAGE SELECTION



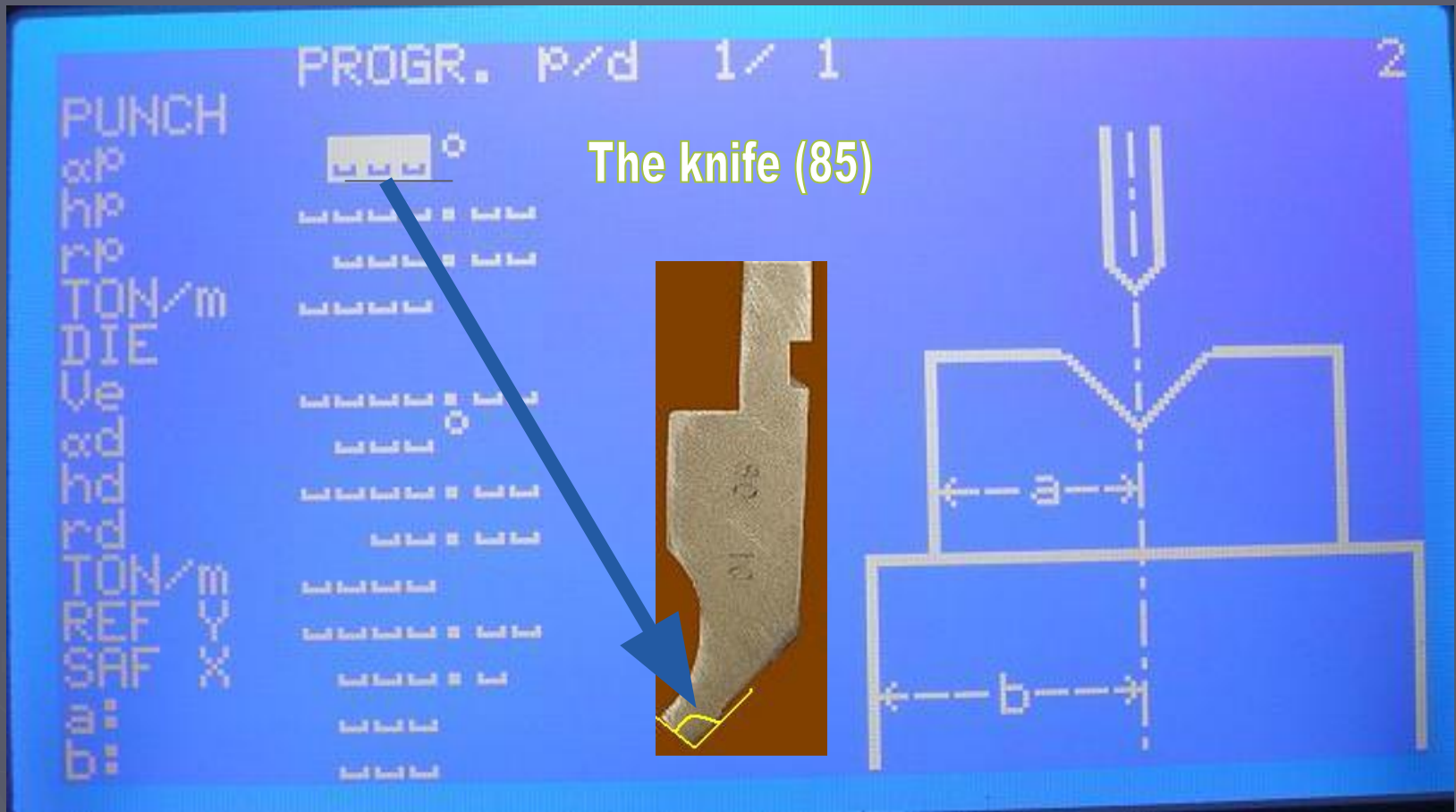
Press empty button



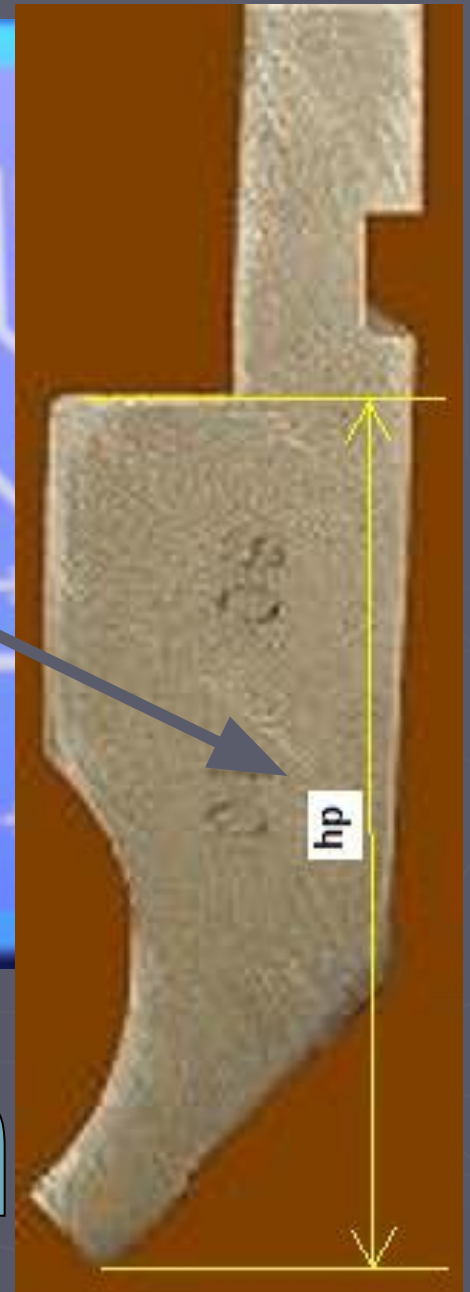
1-Write six

2-And write six, step to that button →

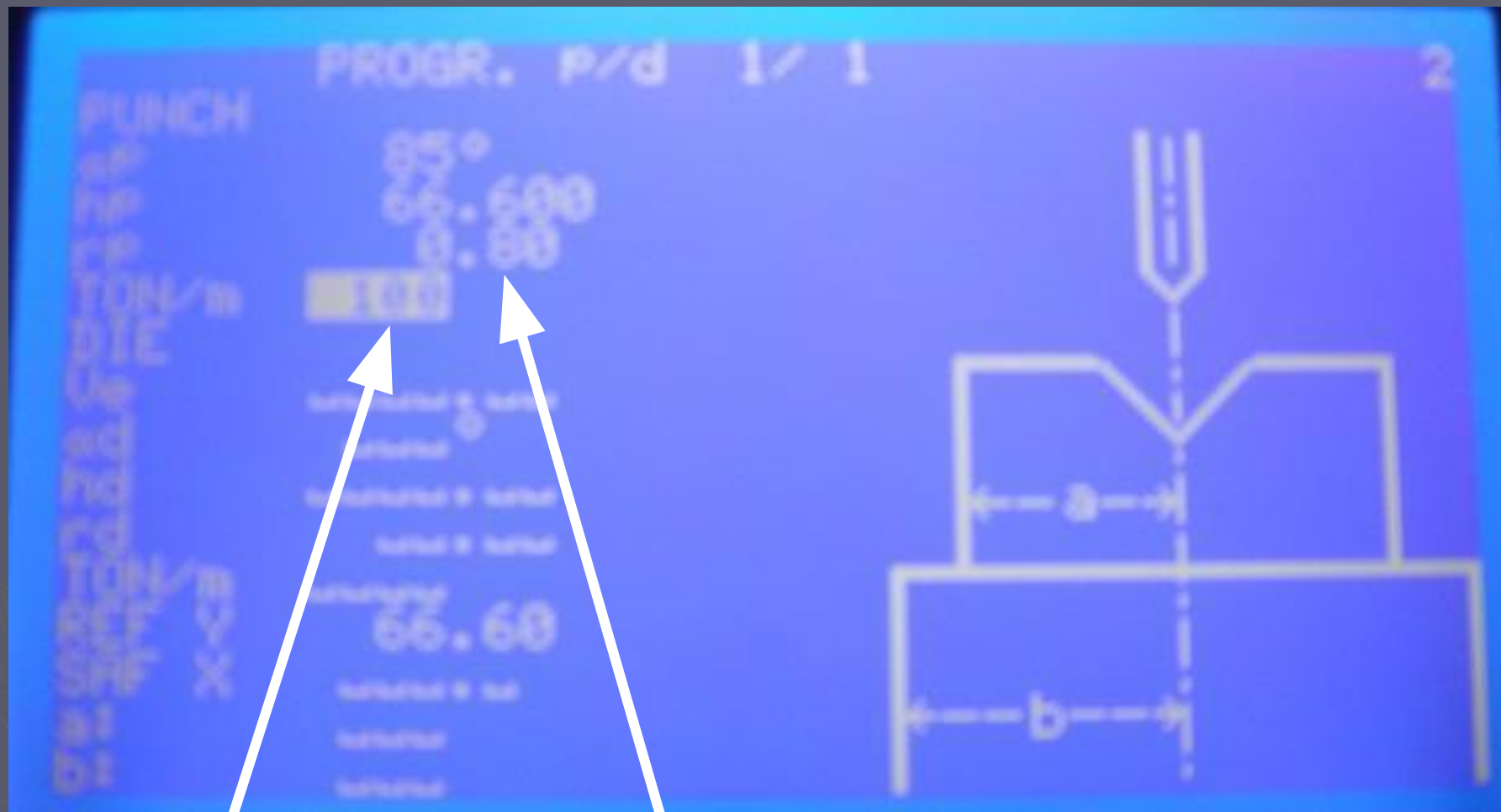




-Enter the punch angle

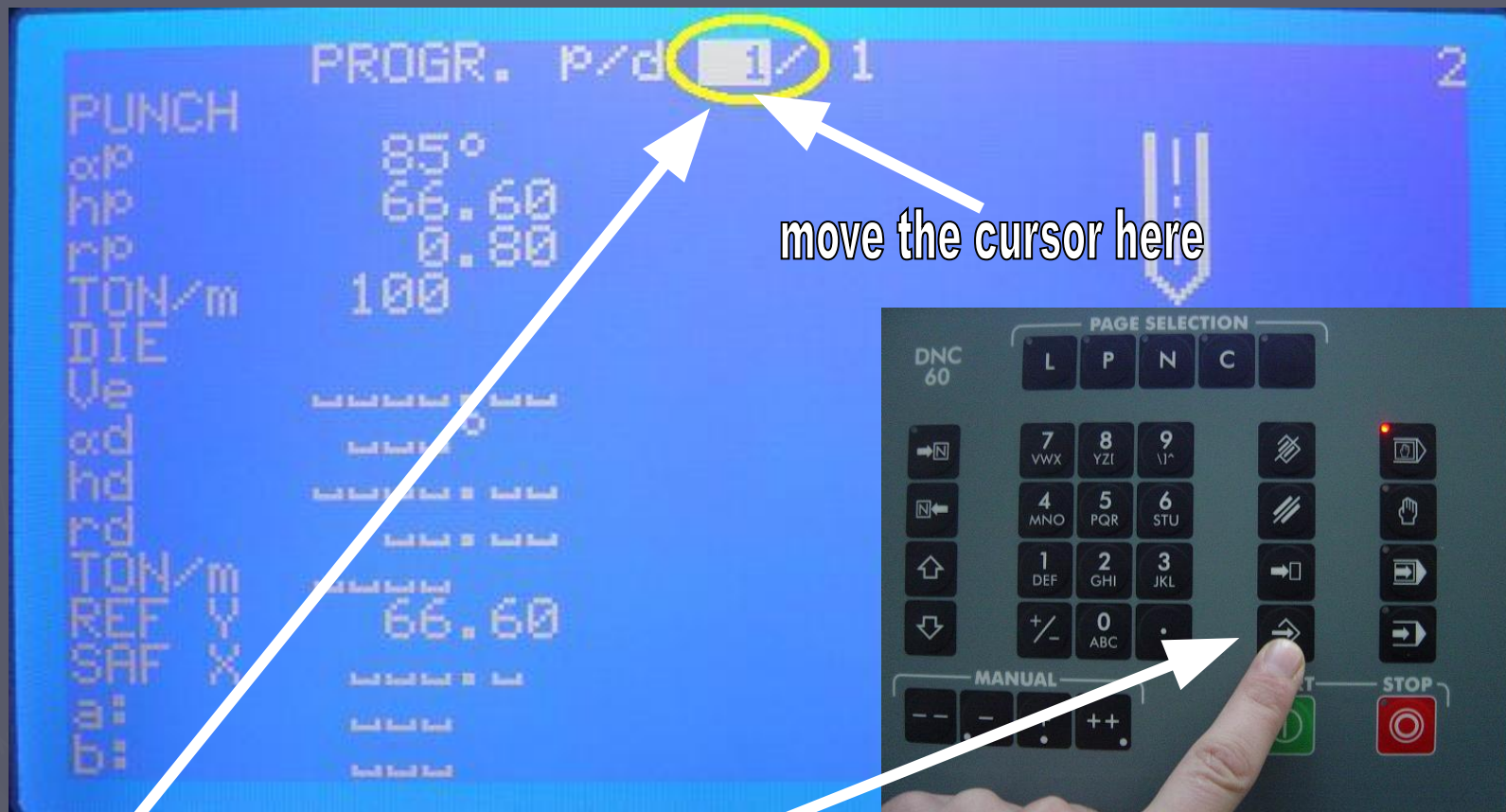


-(hp) is height of punch



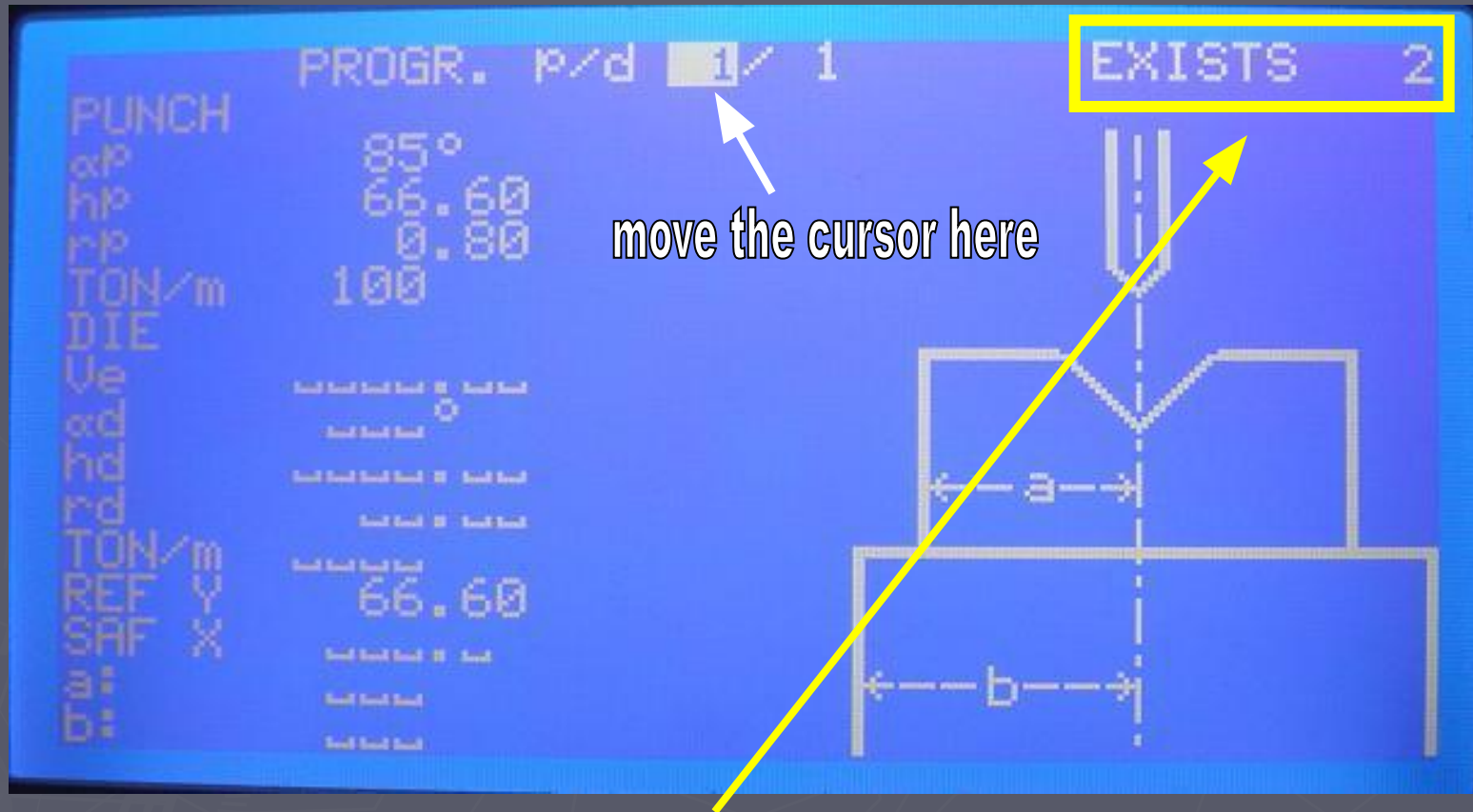
- $r_p=(0.8)$ Radius is always same

-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 !



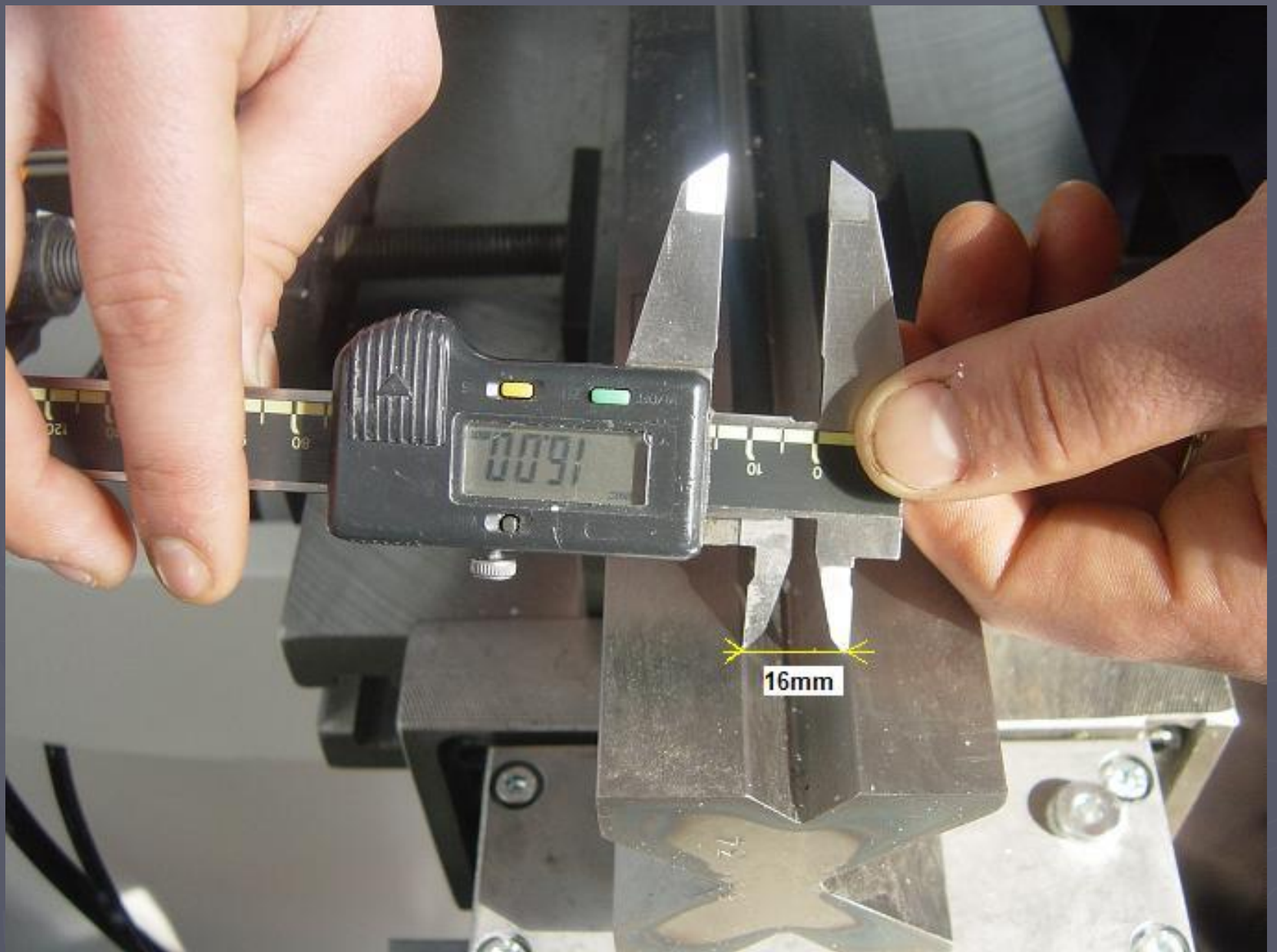
-if you see 'exists' message

-First, press to this button



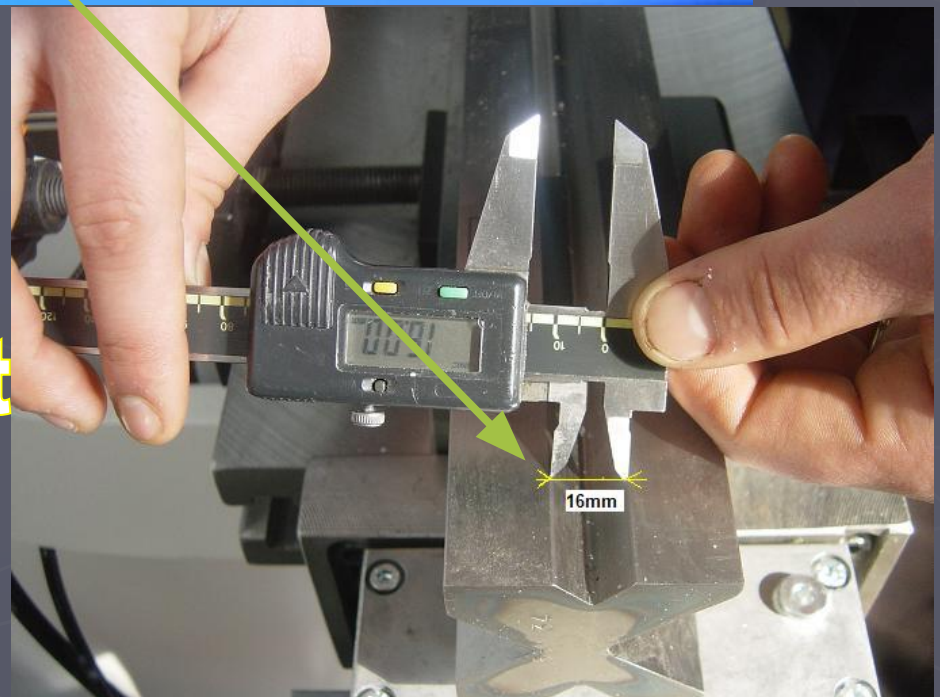
-Second, press to this button





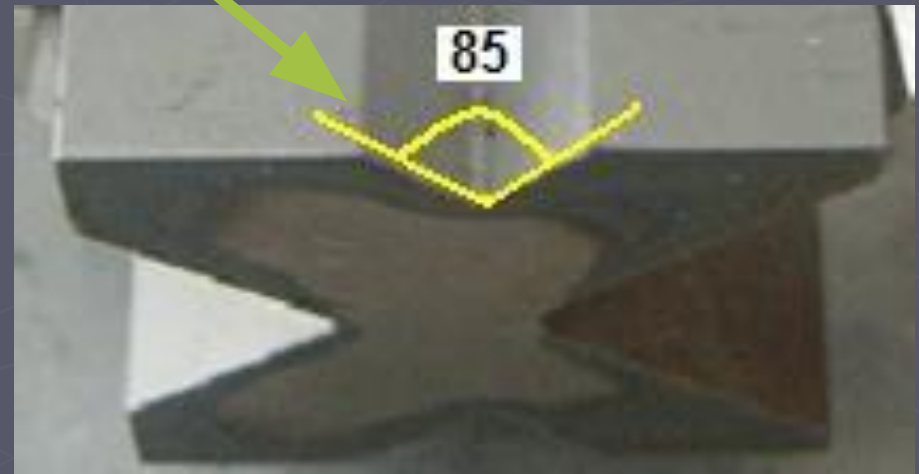


-Enter this
value to that segment

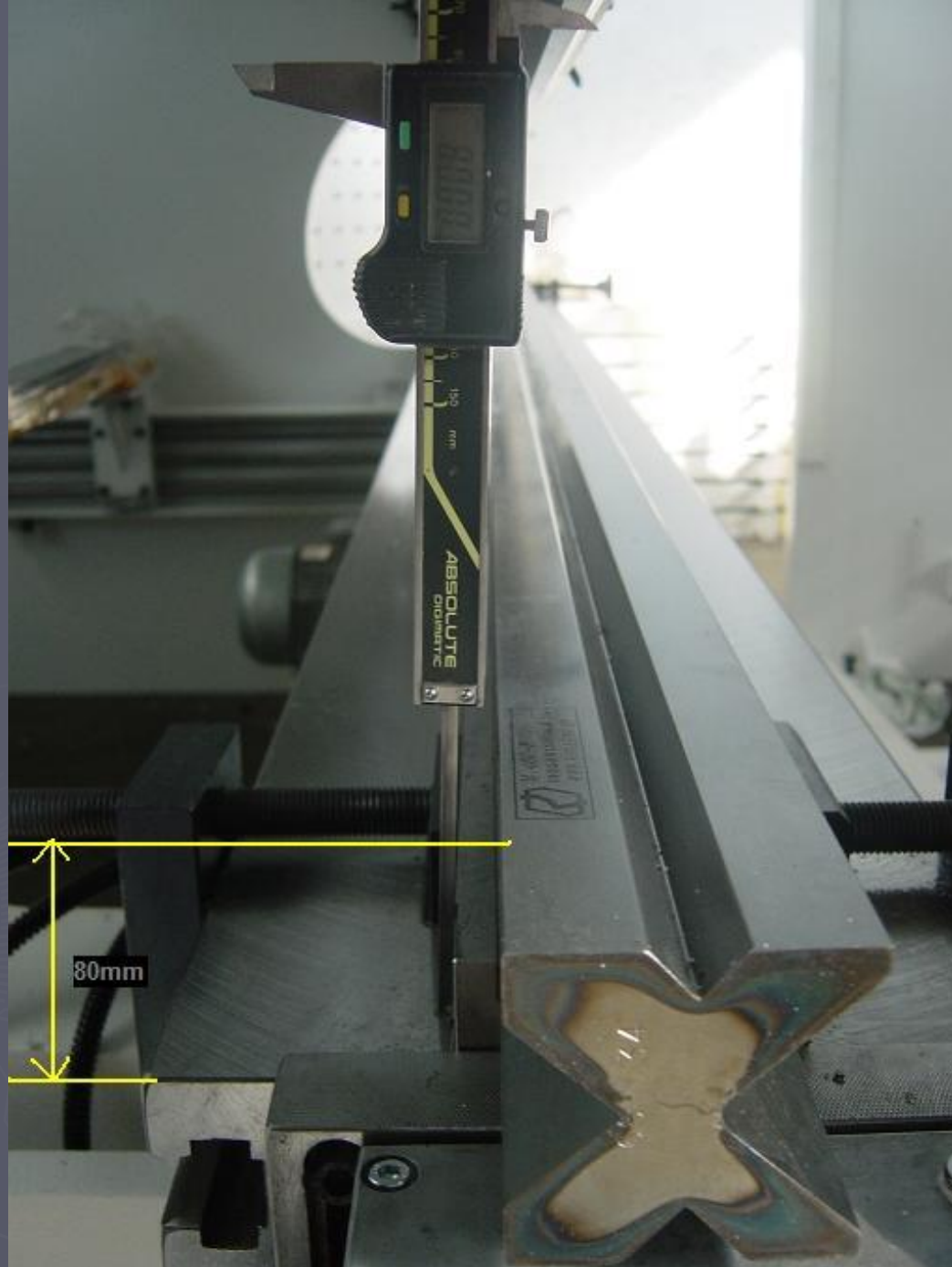


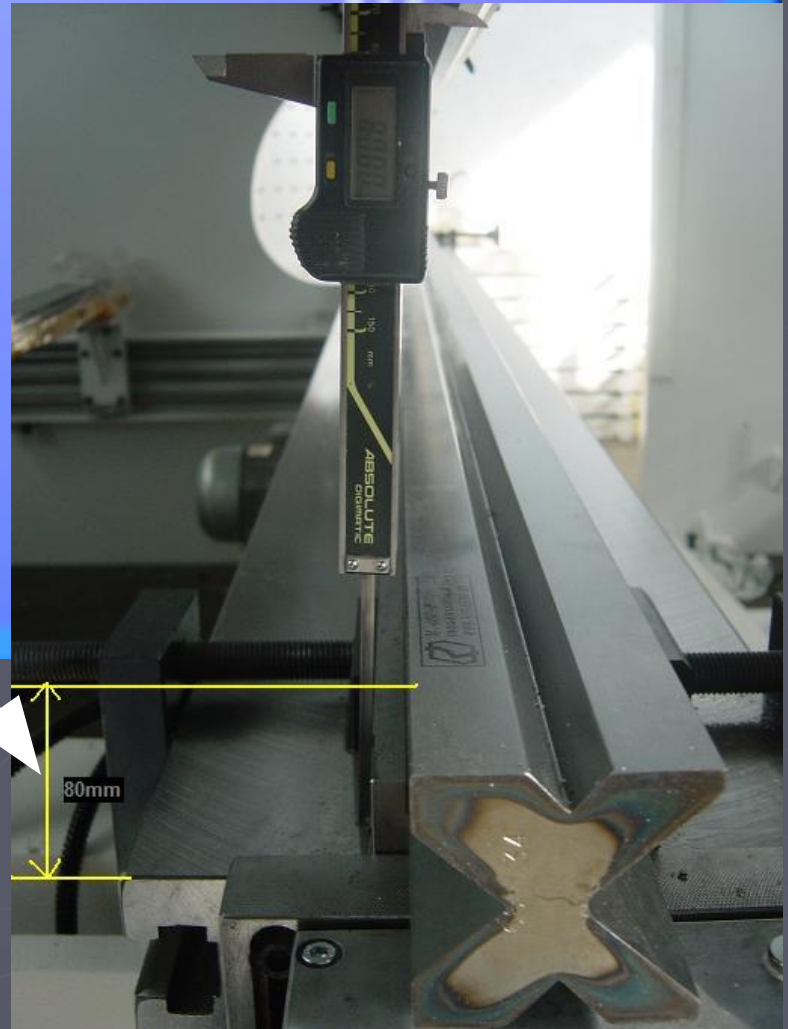
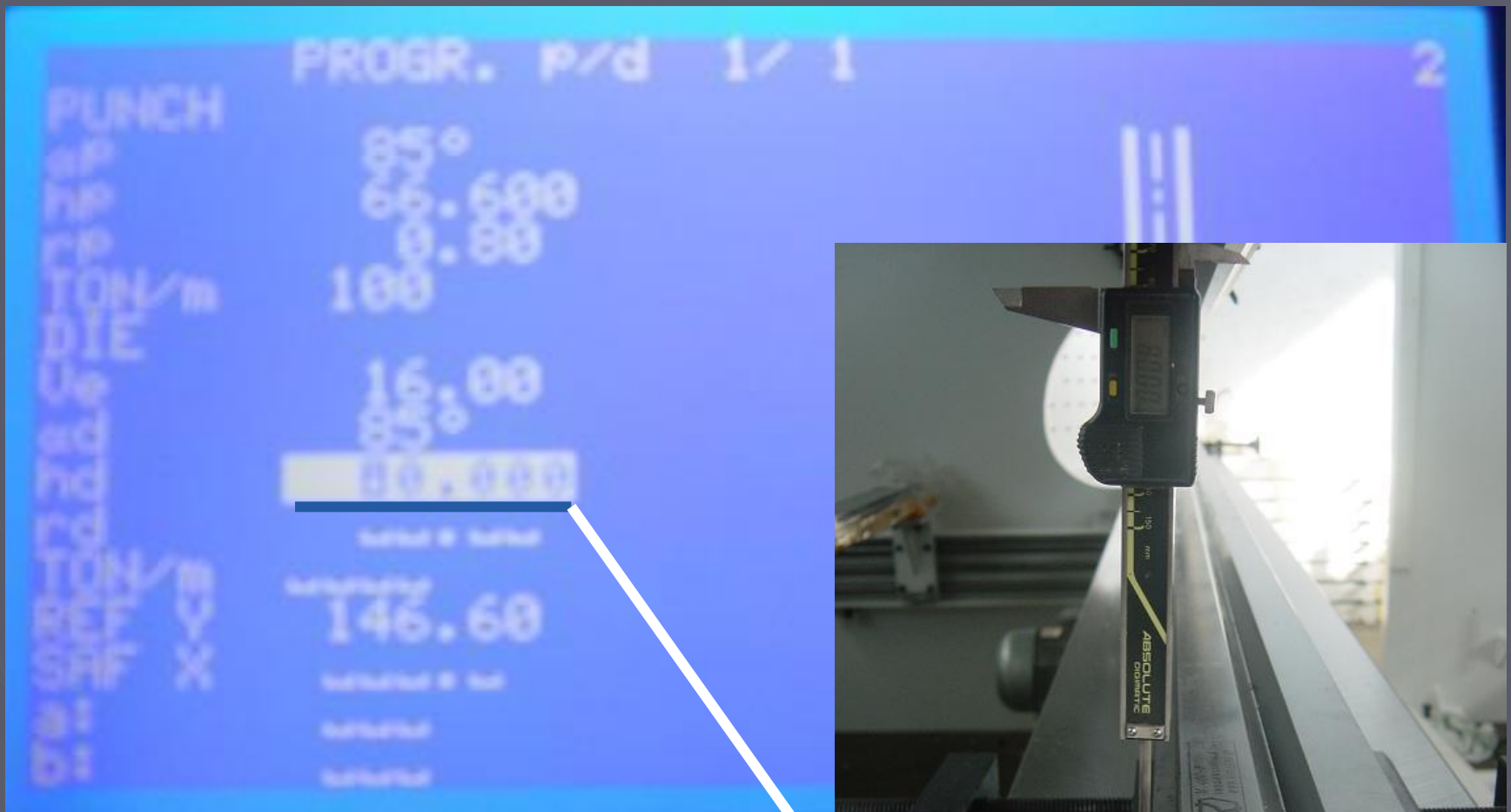


-This is die angle

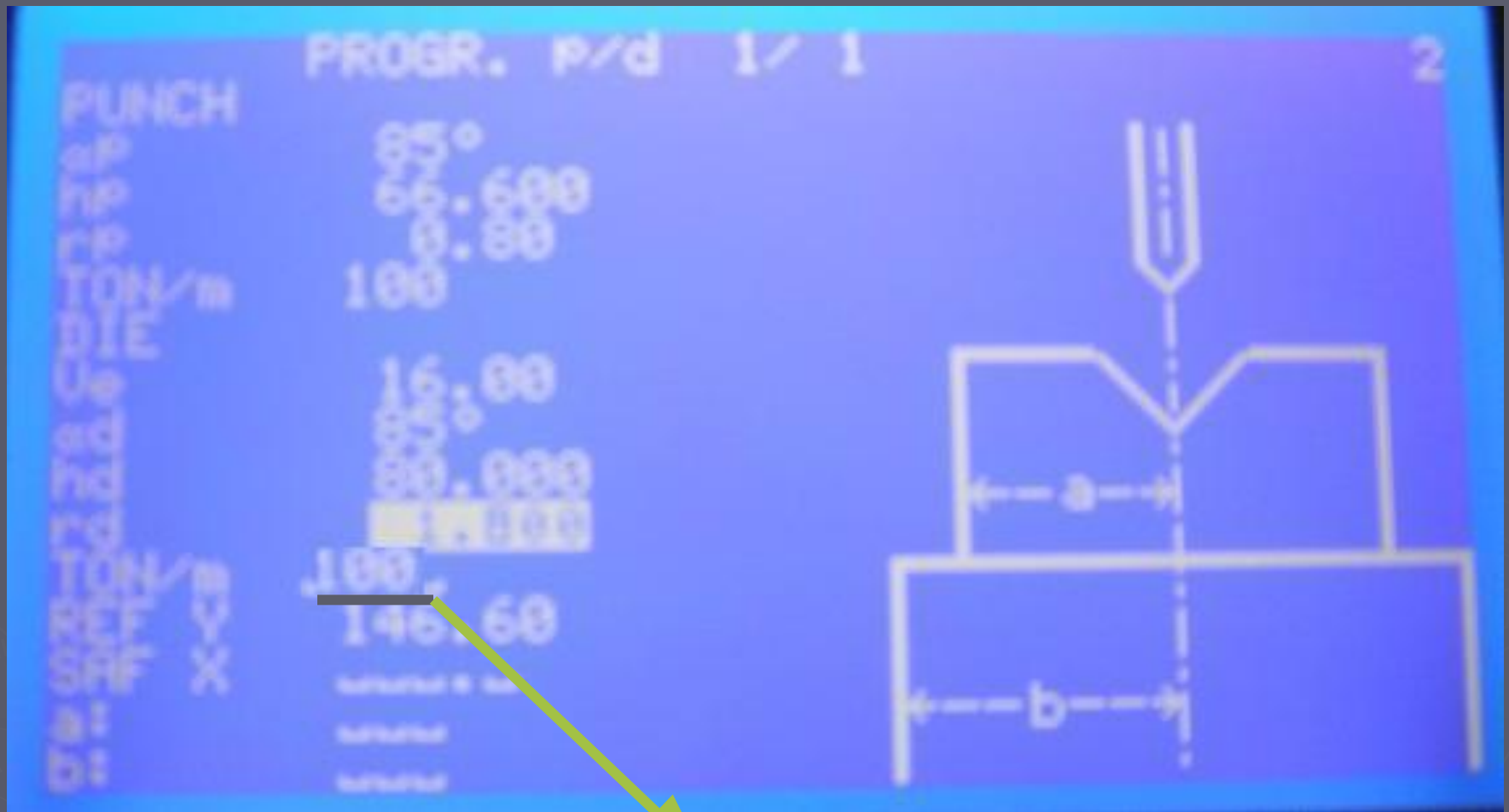


hd

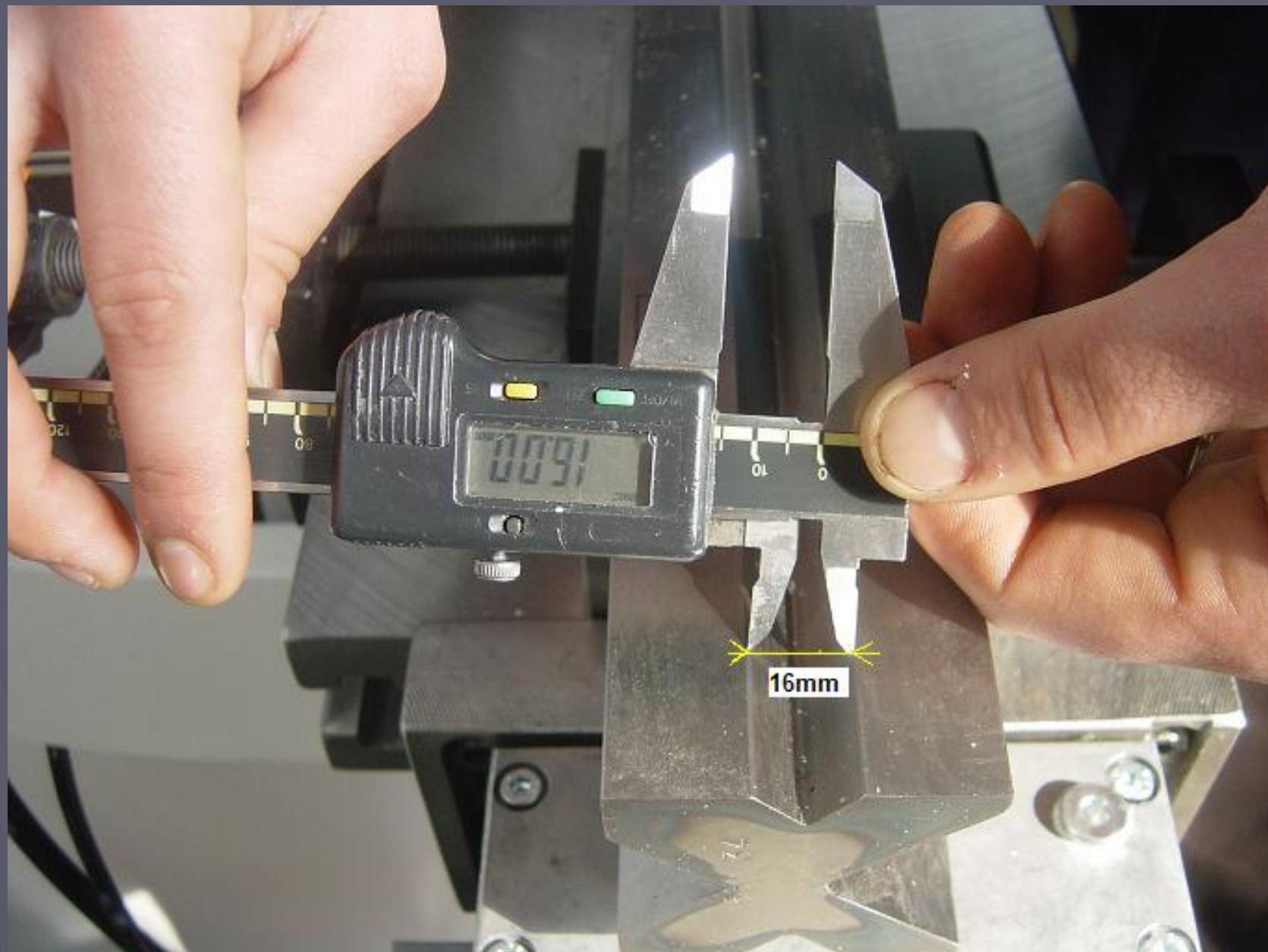


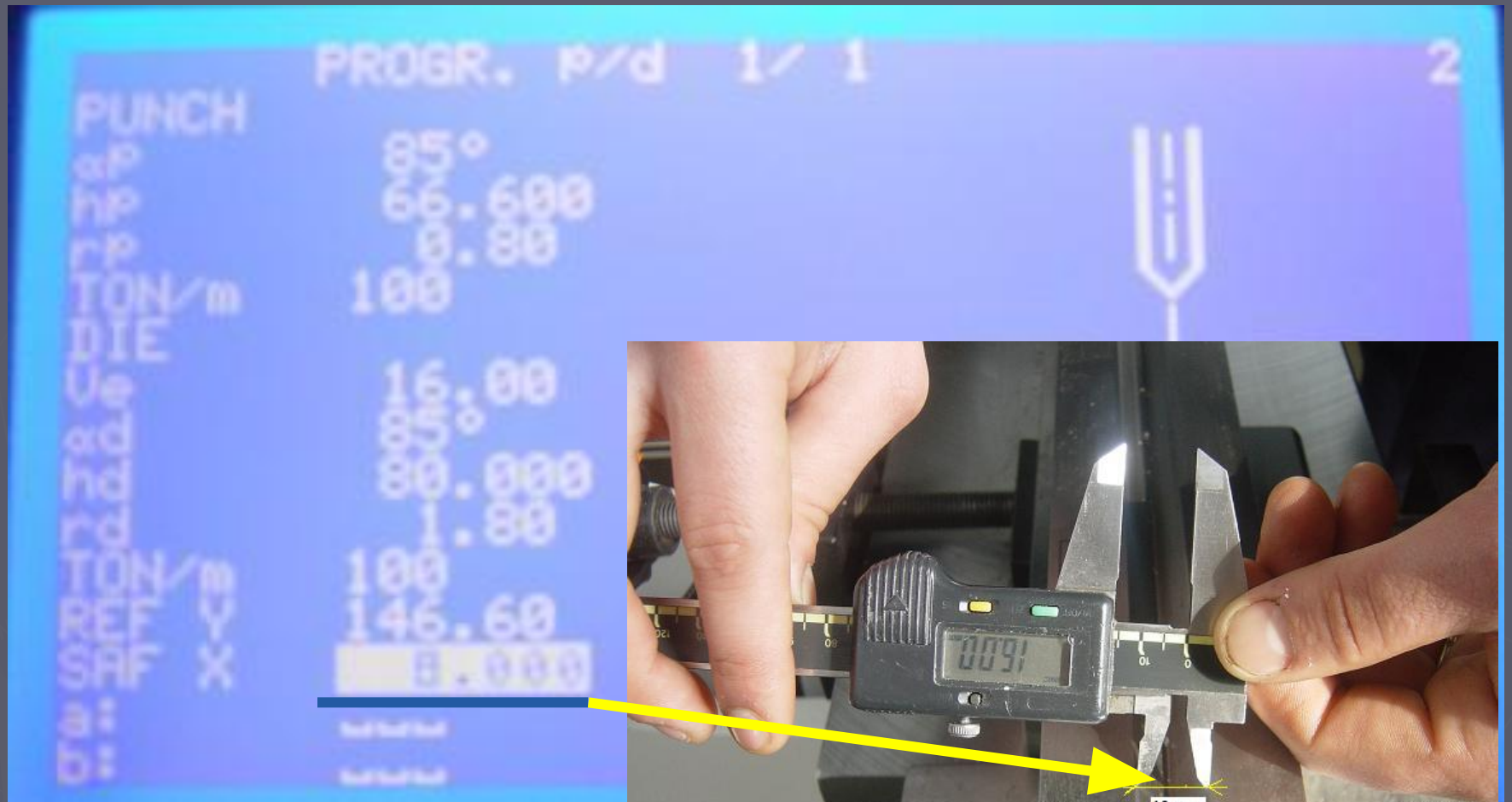


-This is die height

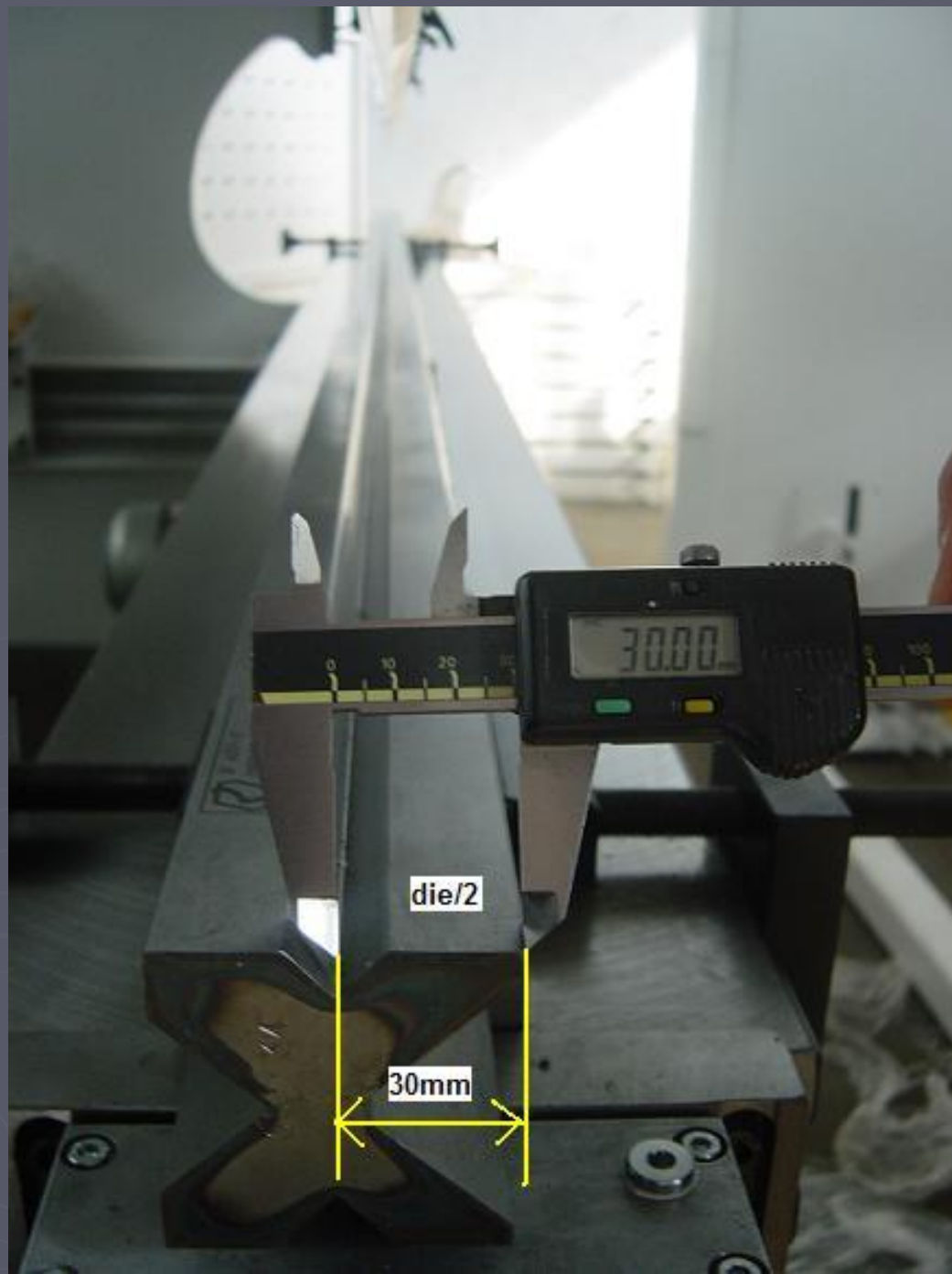


**-This is always 100
Ton/m for our machine**





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





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



This is bottom table



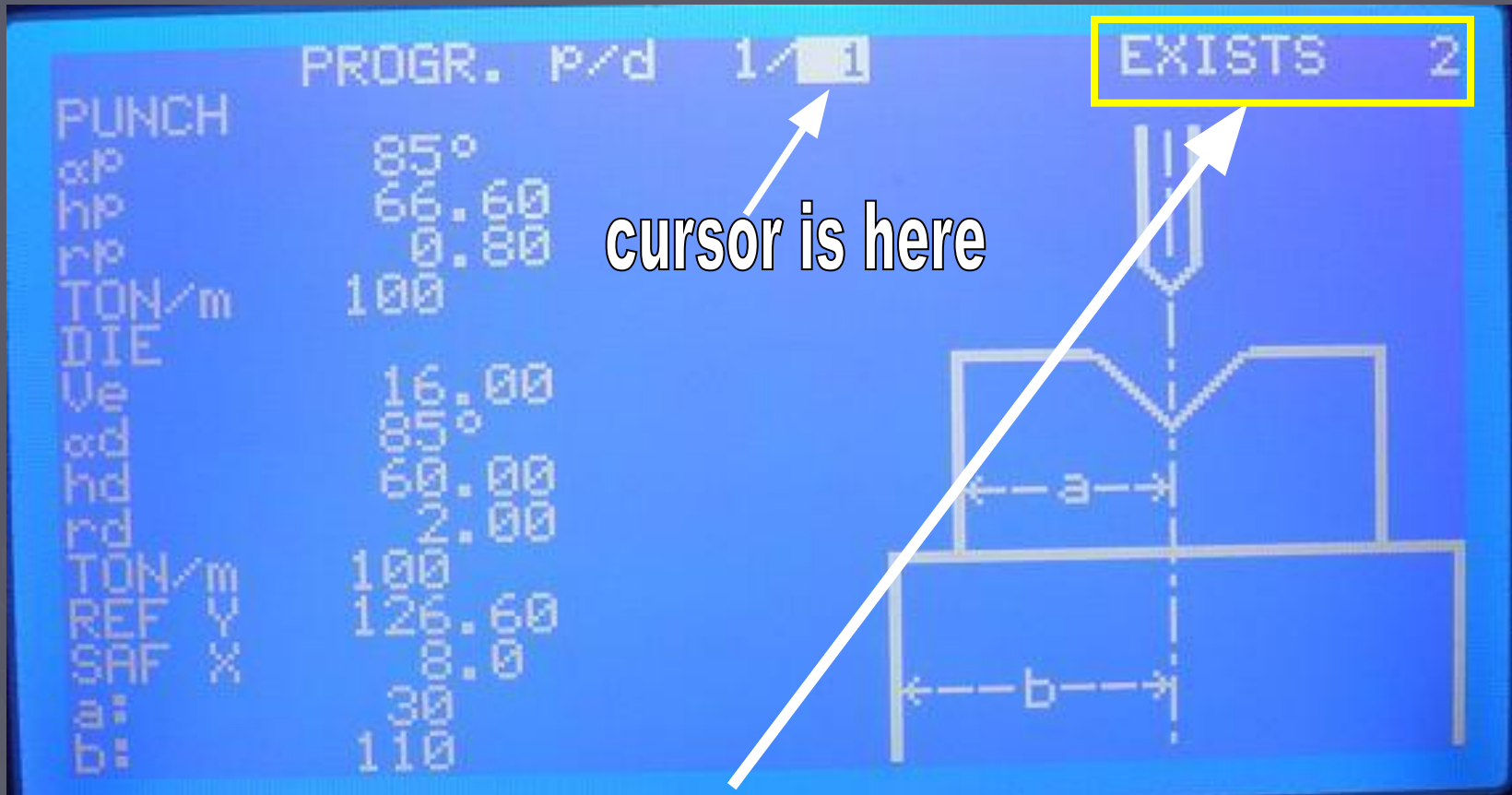
-(b) Value should be half measurement of bottom table width (bottom table/2)



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

