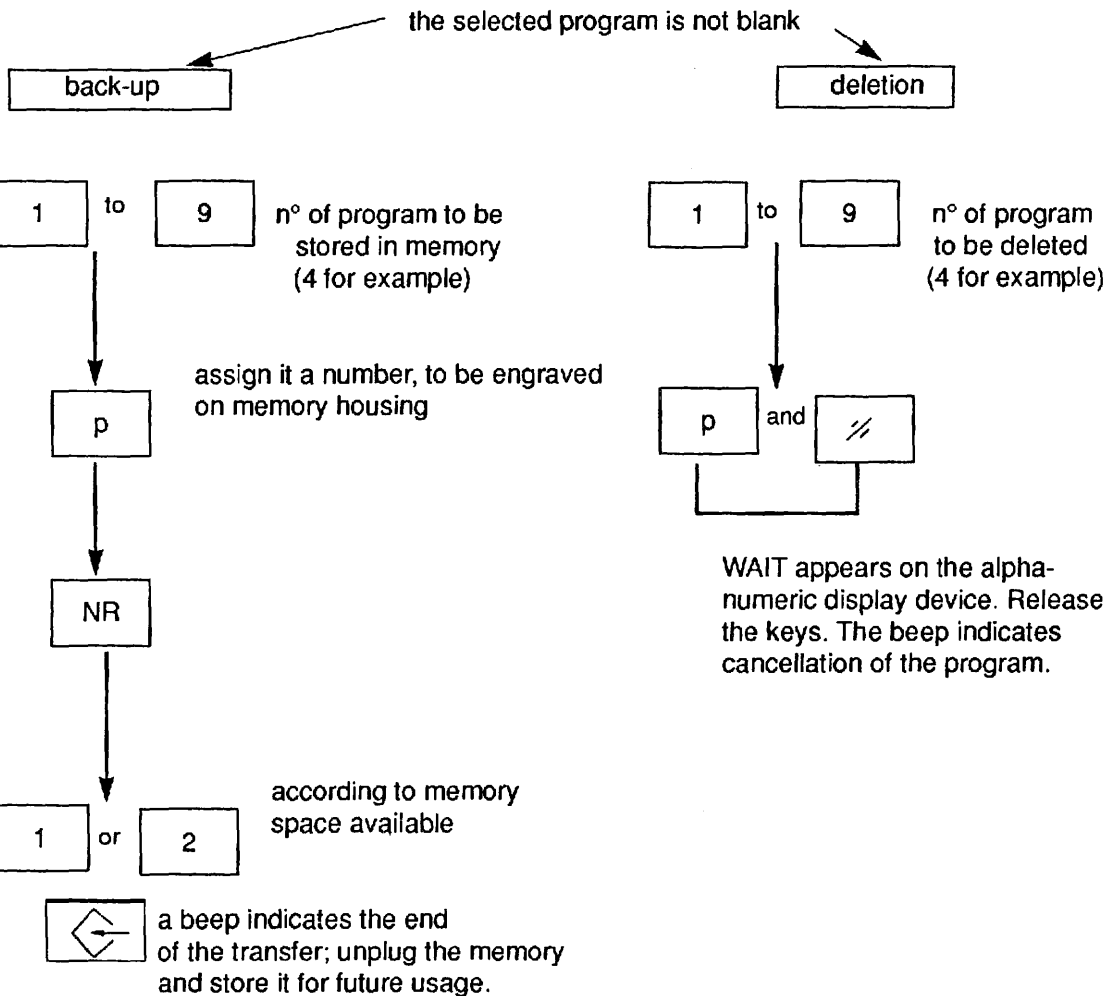
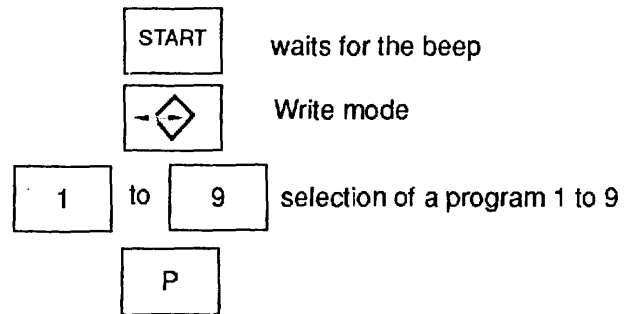


# 17 - PROGRAMMING

## 17 - 1 PROGRAMMING OF A PART



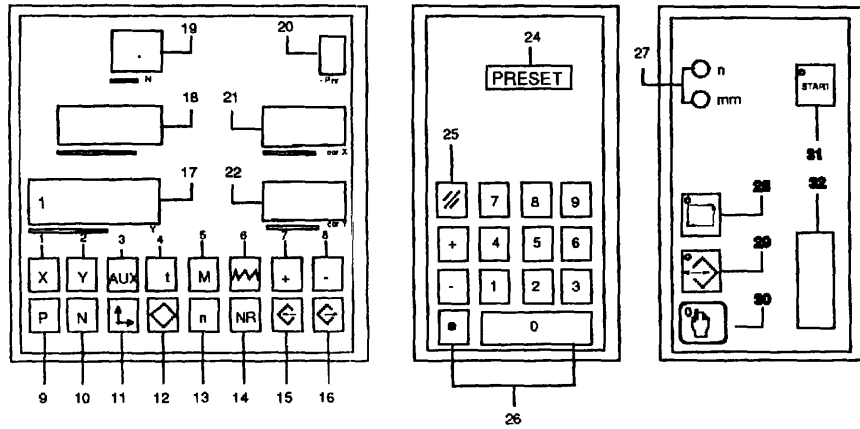


Fig. 1

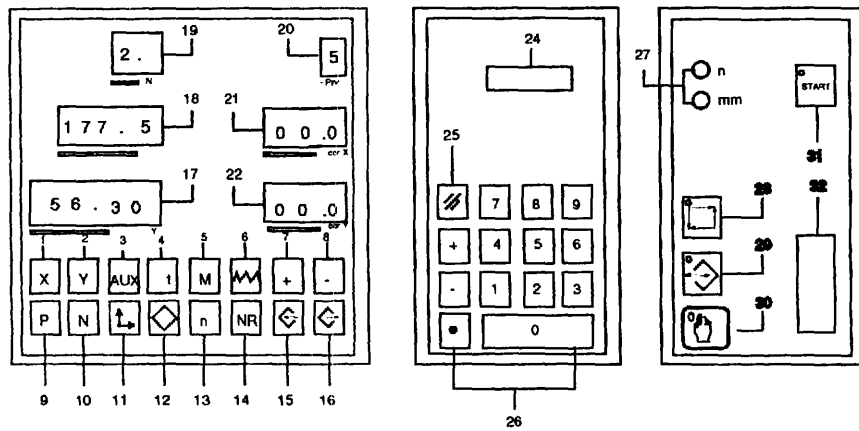


Fig. 2

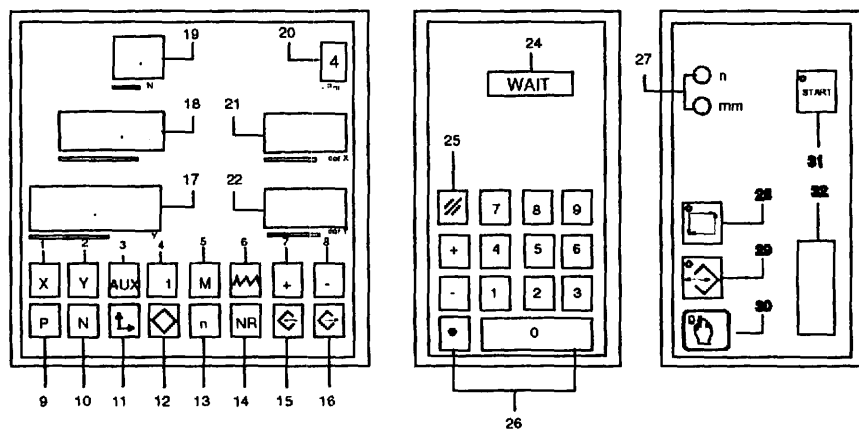
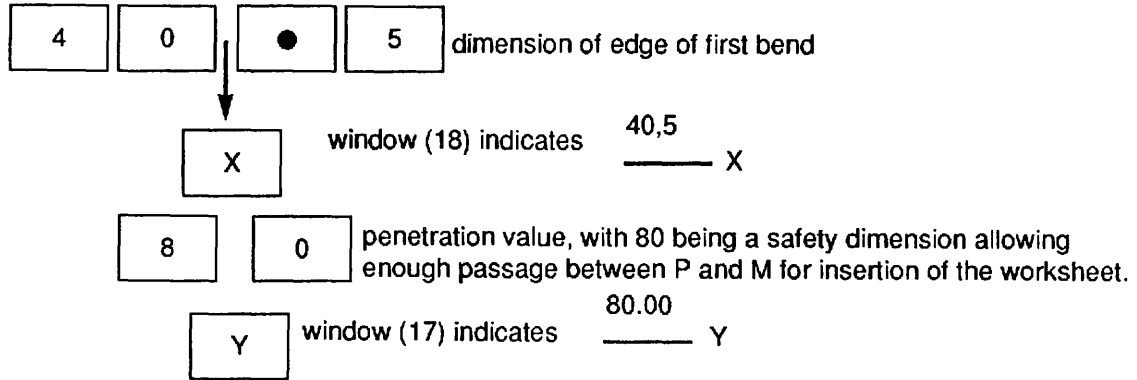
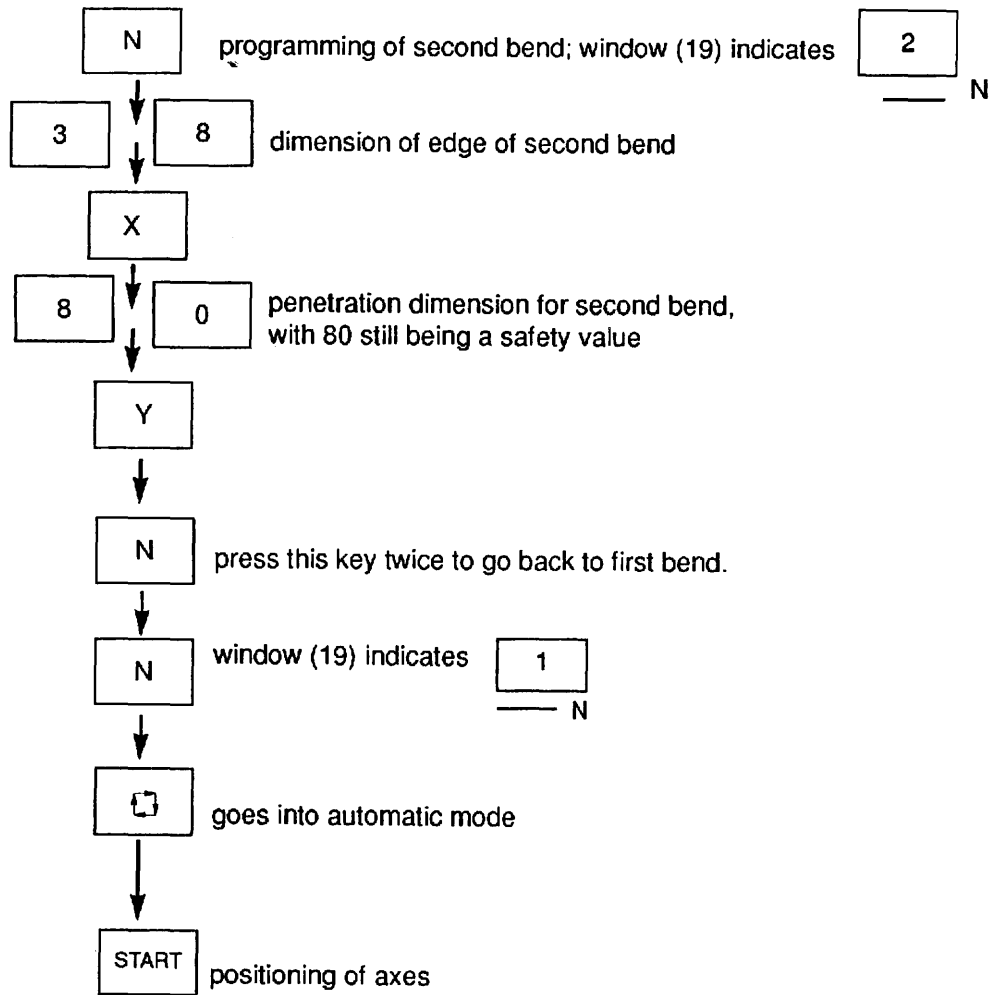


Fig. 3

## 17 - 2 PROGRAMMING OF BENDS



In the case of a 3-axis MB3 numerical control, program the dimension of the R axis or the Z axis, using the **AUX** key.



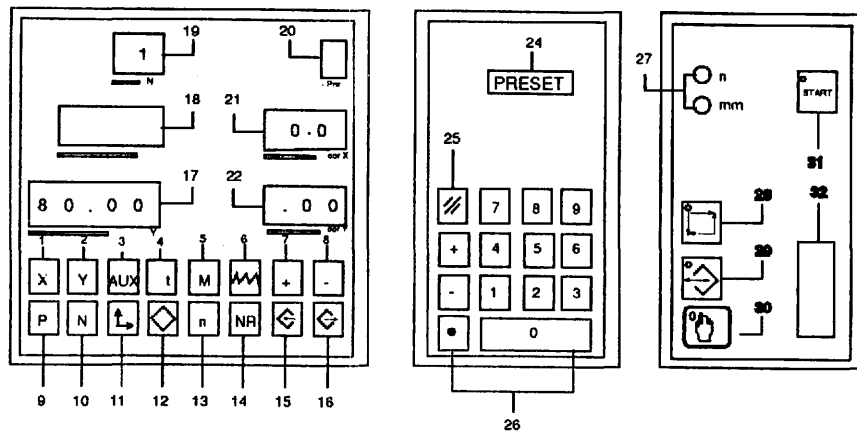


Fig. 4

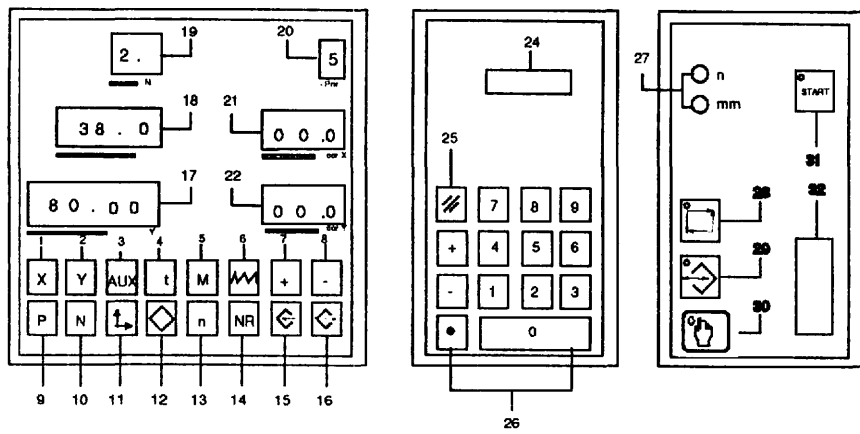


Fig. 5

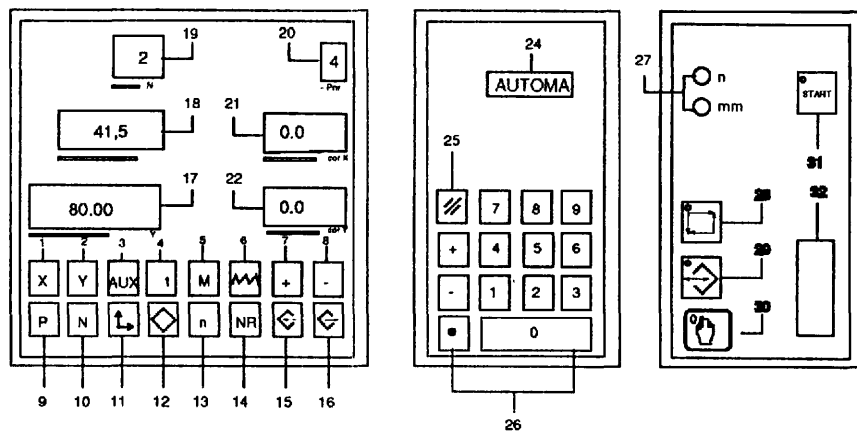
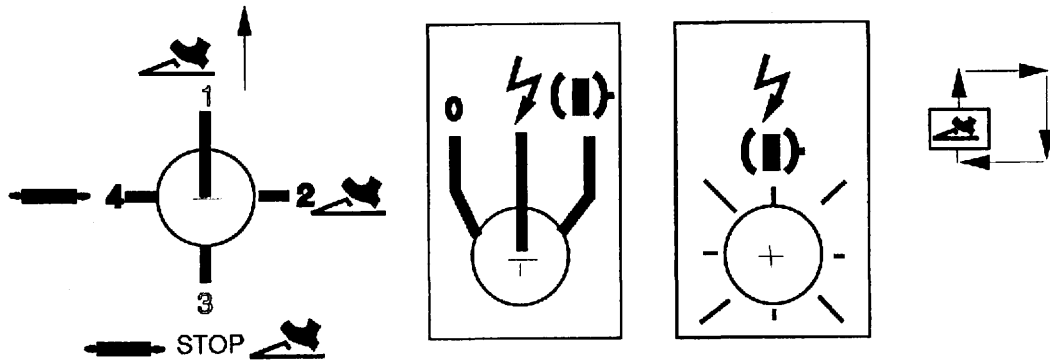


Fig. 6

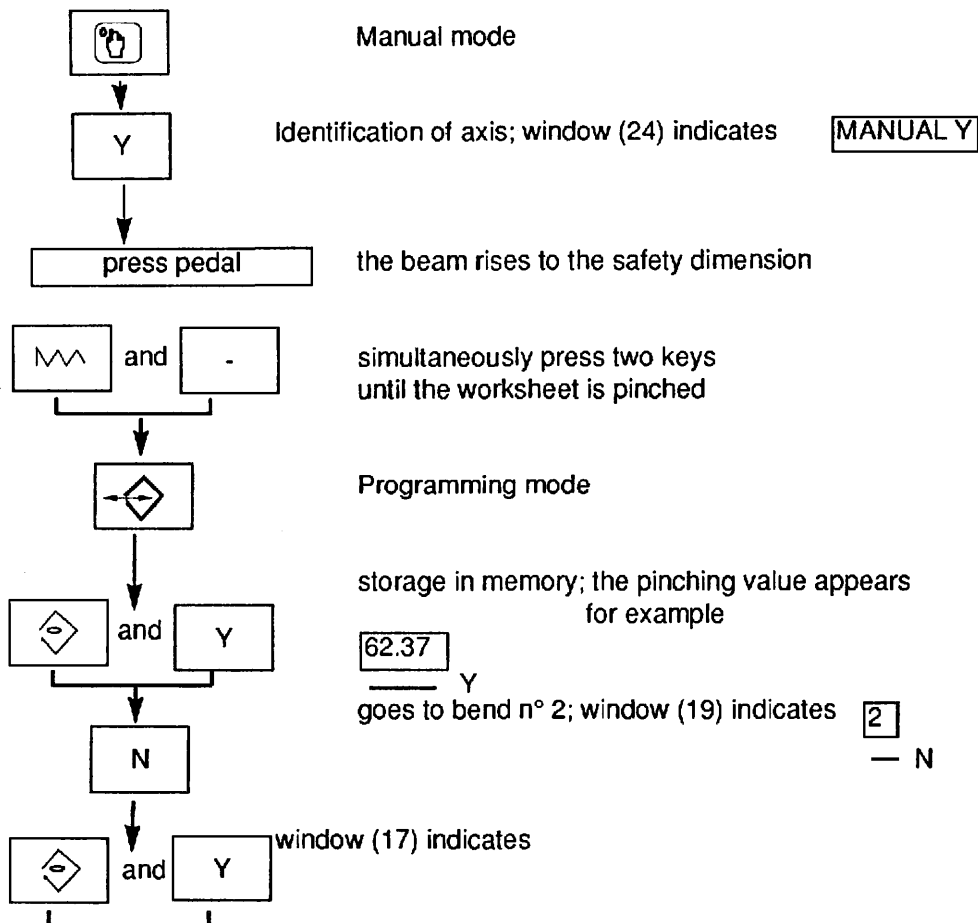
### 17 - 3 FINDING PINCH DIMENSION

#### 17 - 3 - 1 IN MANUAL MODE

Position of switches on electrical control compartment



resetting, green indicator light is on



proceed in the same manner if the program has other bends.

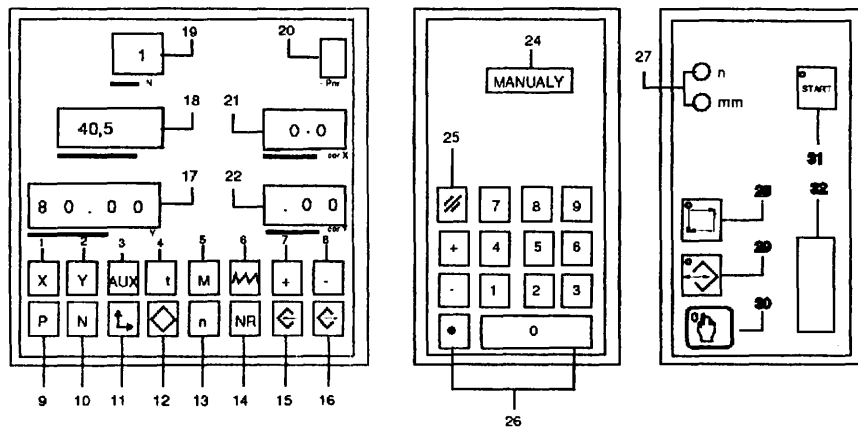


Fig. 7

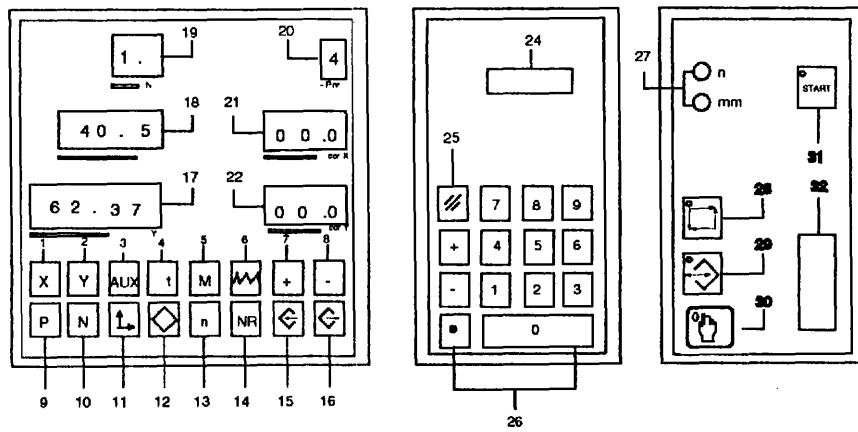


Fig. 8

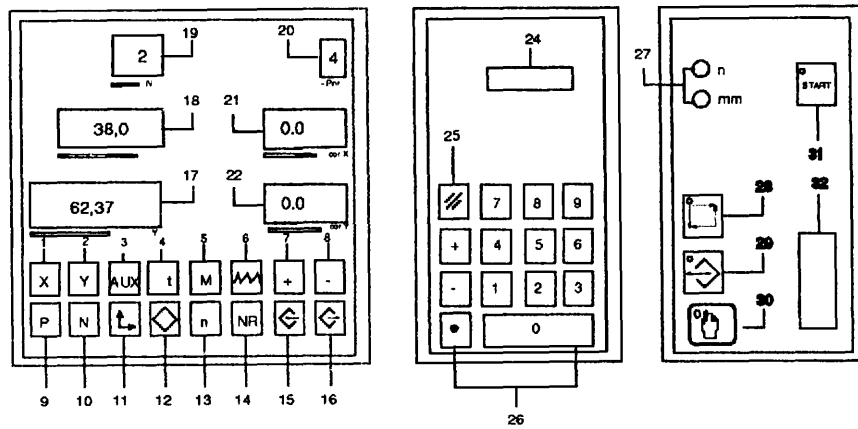


Fig. 9

17 - 3 - 2 IN PROGRAMMING MODE

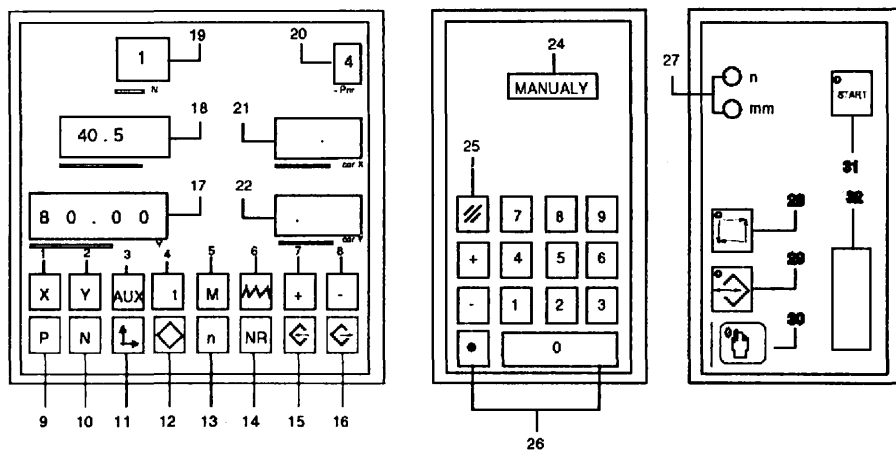
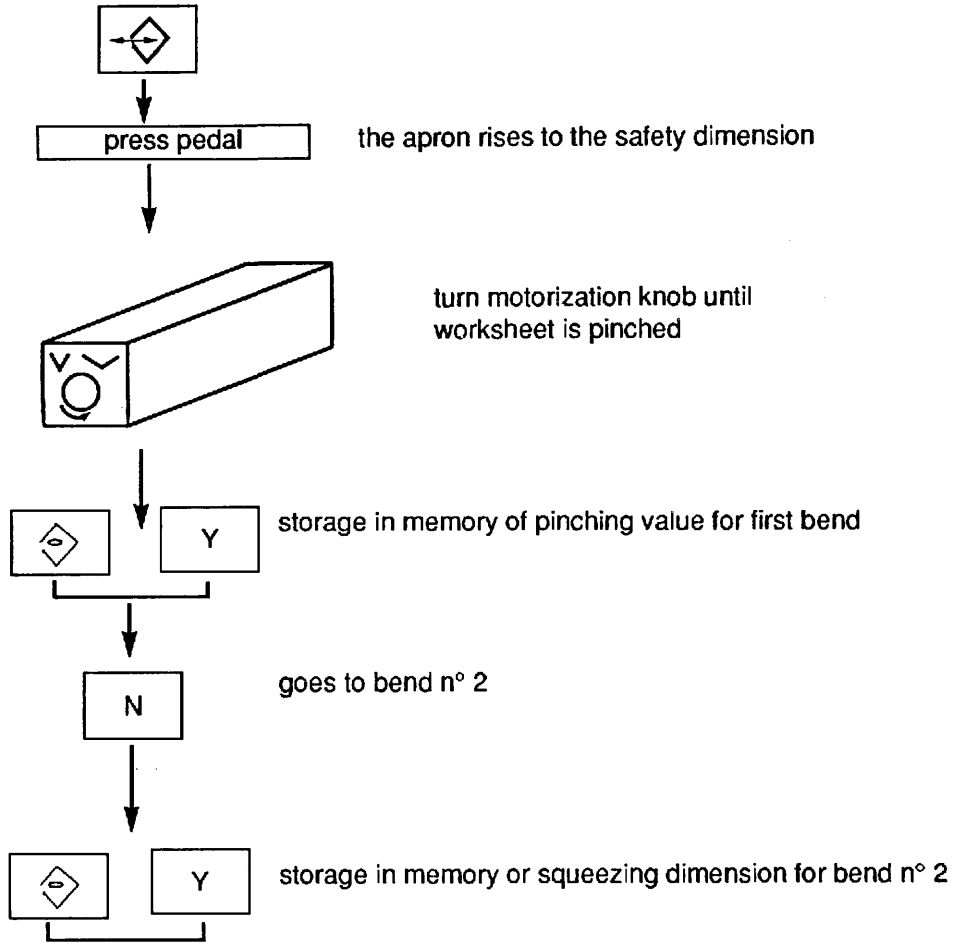


Fig. 13

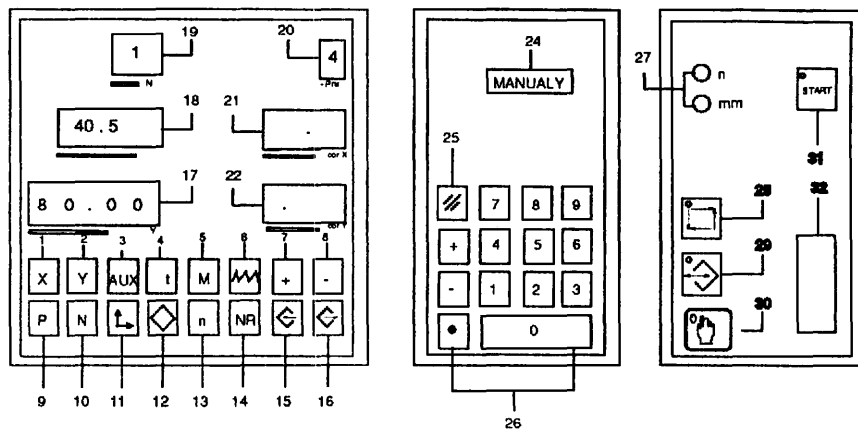


Fig. 10

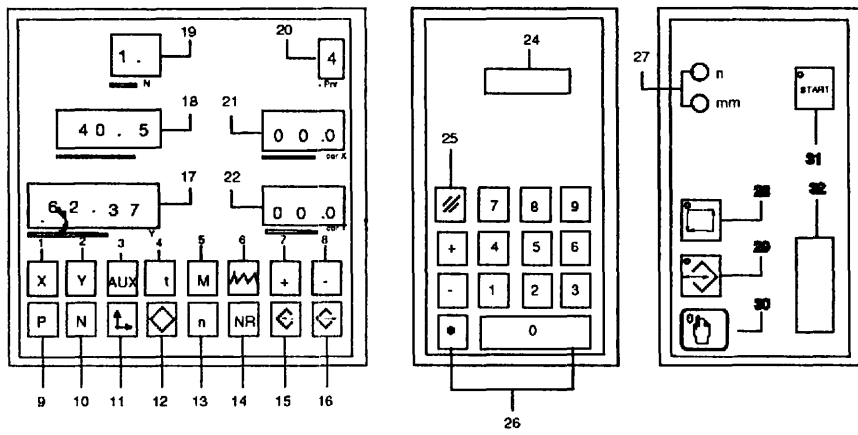


Fig. 11

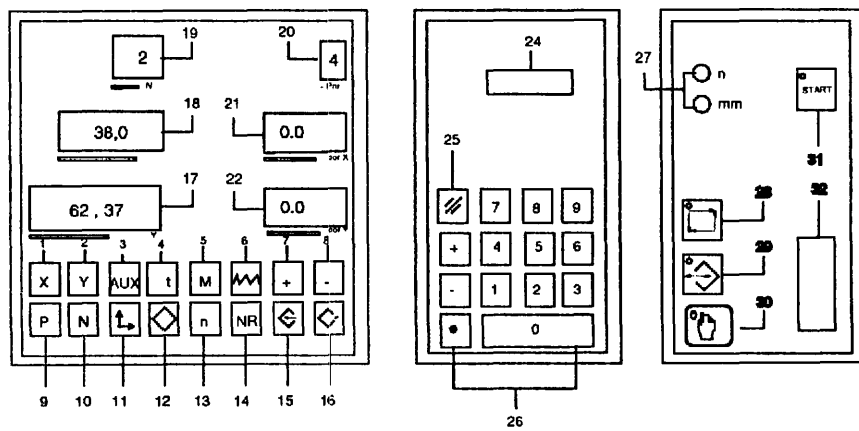
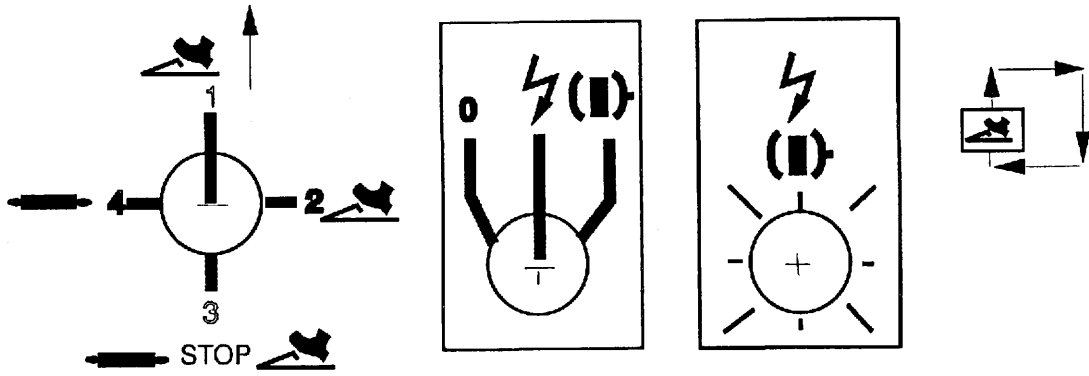


Fig. 12

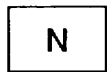



17 - 4 FINDING BENDING DEPTH VALUE



Position of switches on electrical control compartment

resetting, green indicator light is on



Return to bend n° 1 



Automatic mode



The axes are positioned on bend n° 1  
(wait for beep)

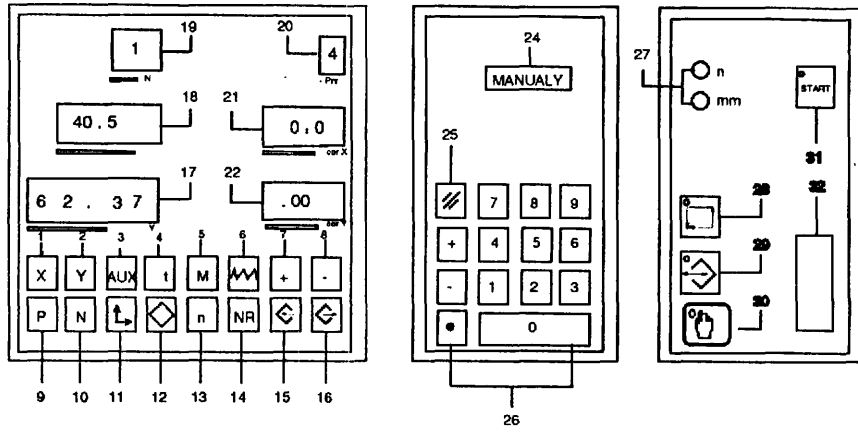


Fig. 14

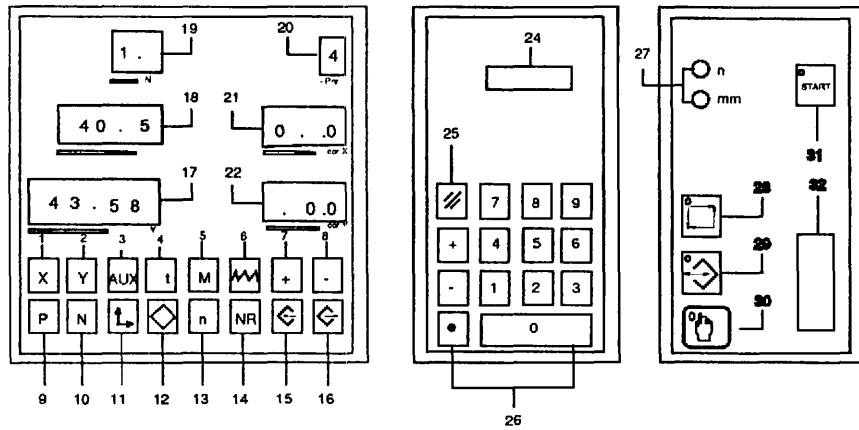


Fig. 15

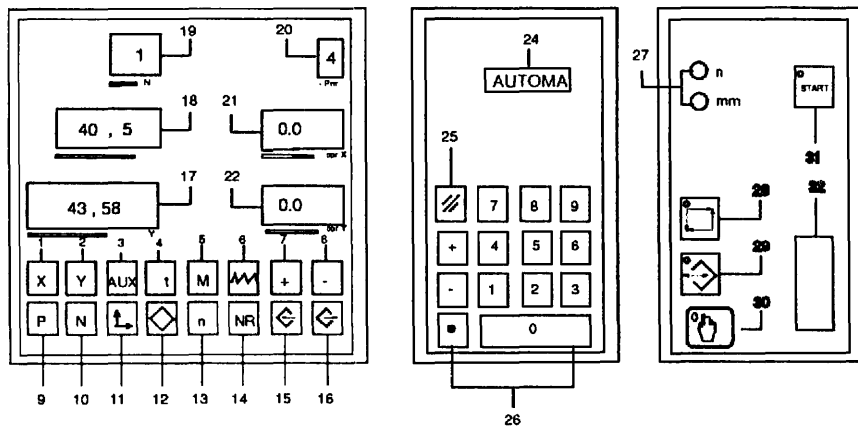
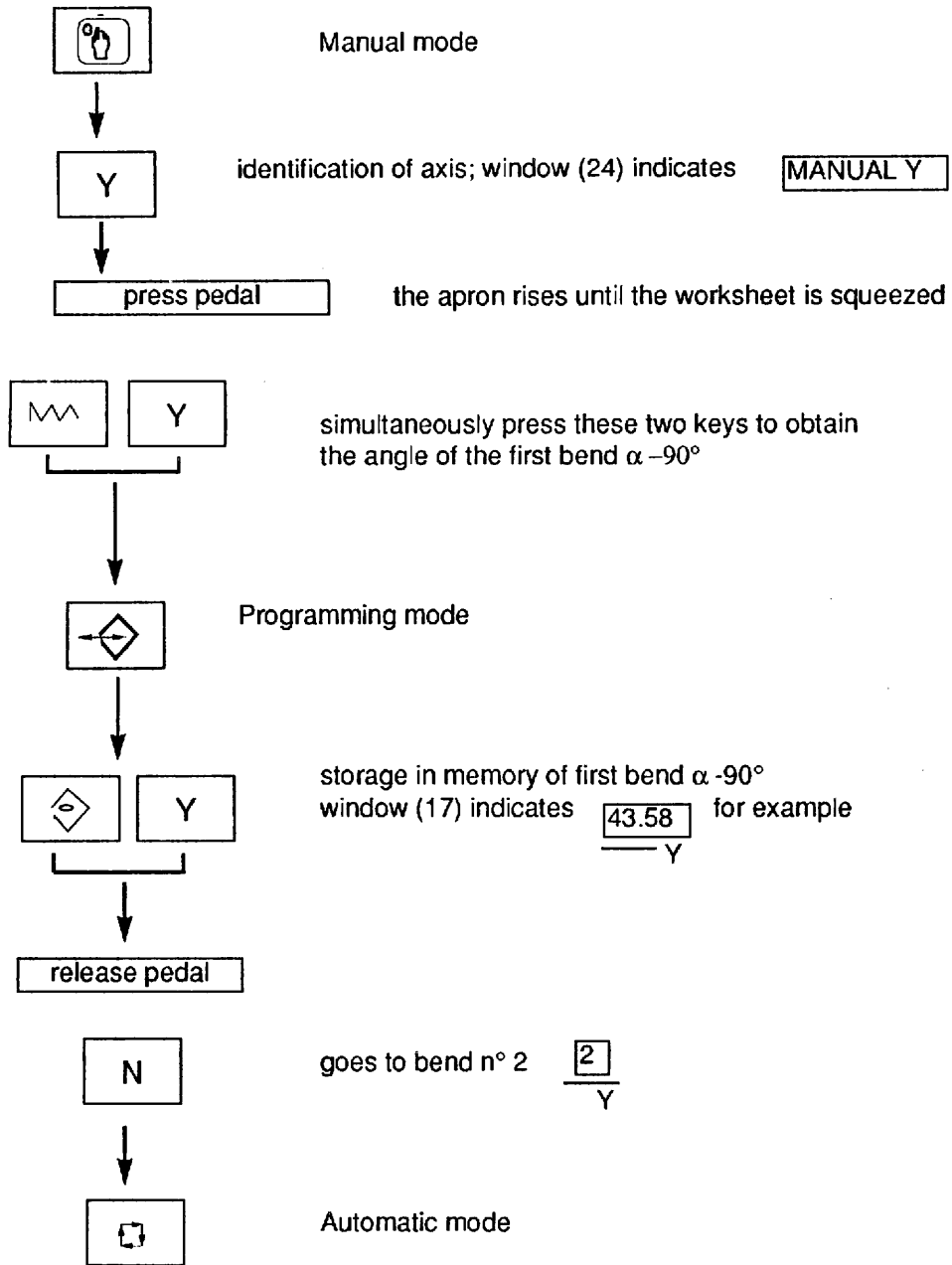


Fig. 16

17 - 4 - 1 IN MANUAL MODE



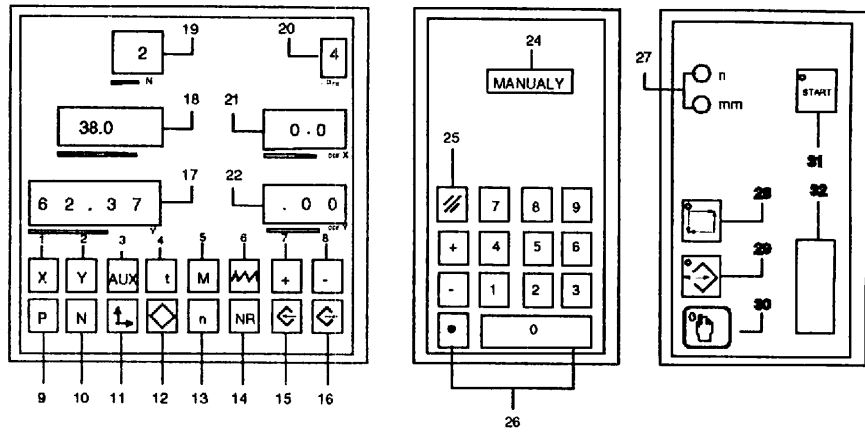


Fig. 17

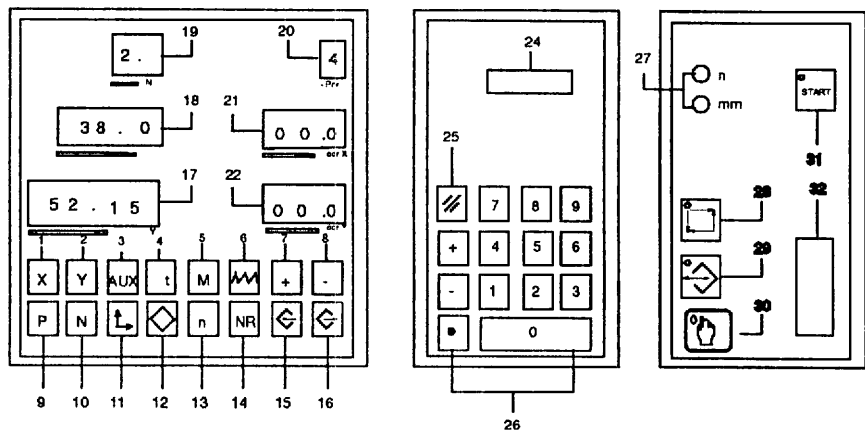
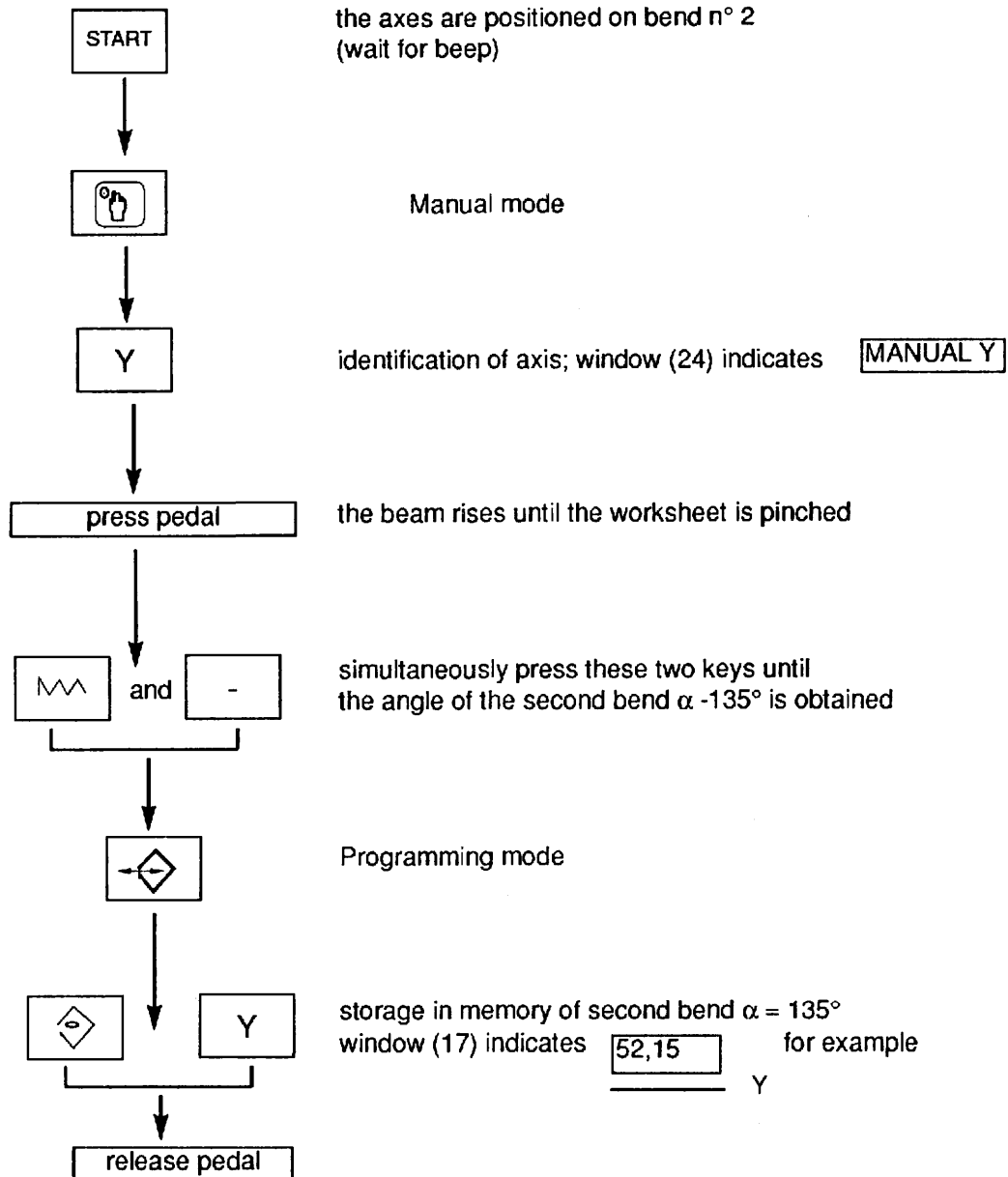


Fig. 18



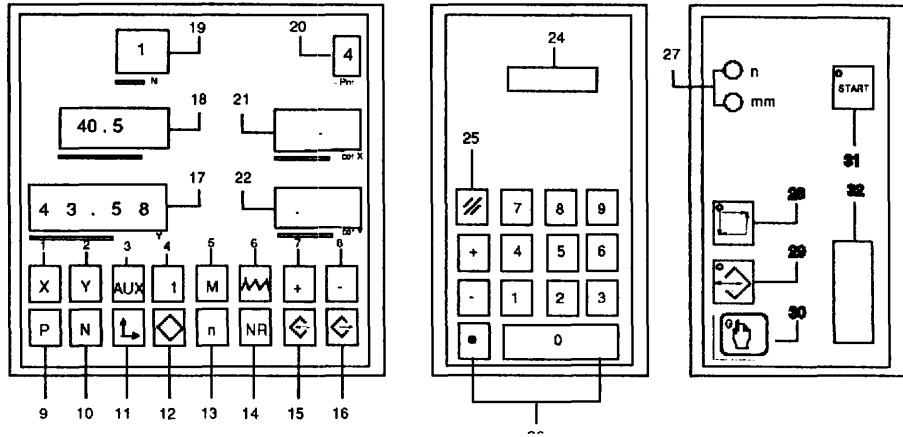


Fig. 19

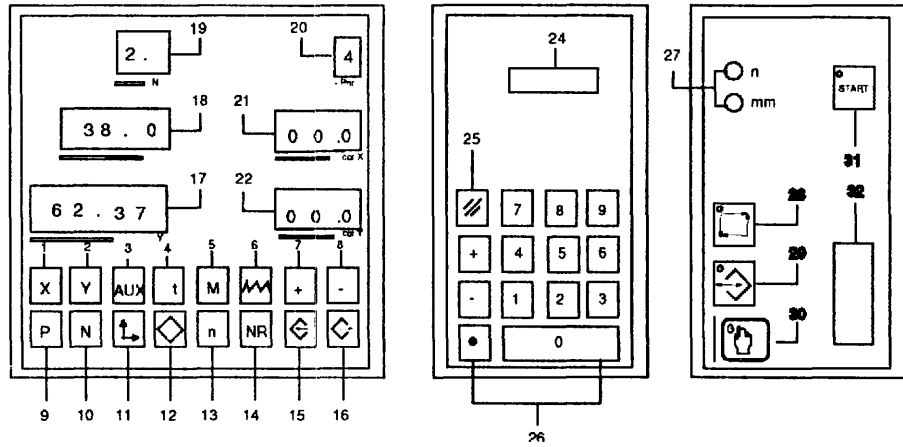


Fig. 20

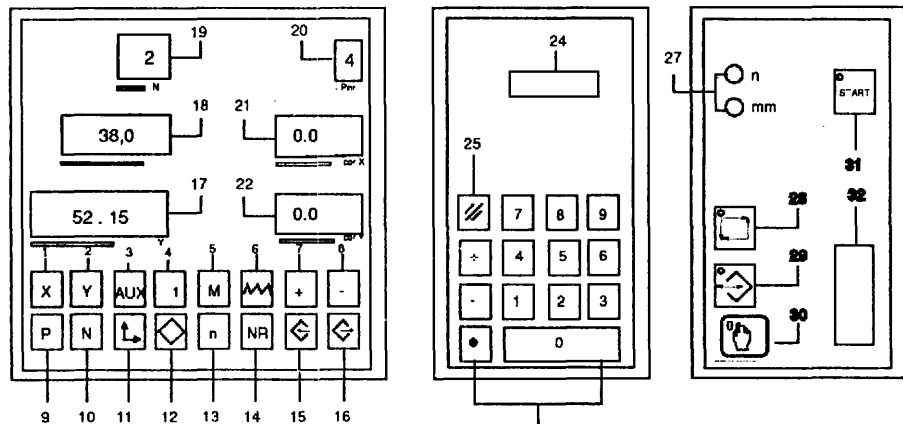
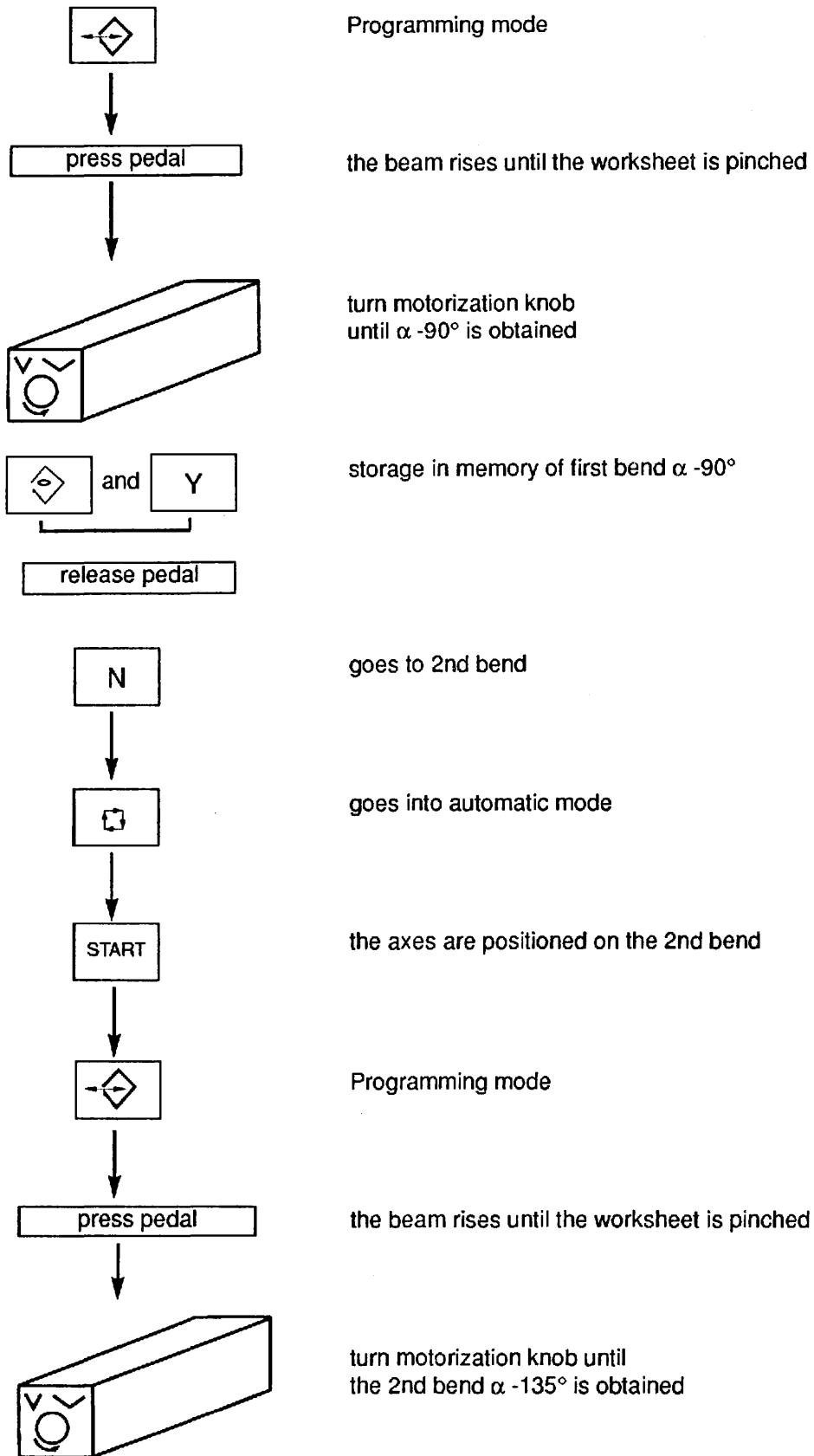


Fig. 21

17 - 4 - 2 IN PROGRAMMING MODE



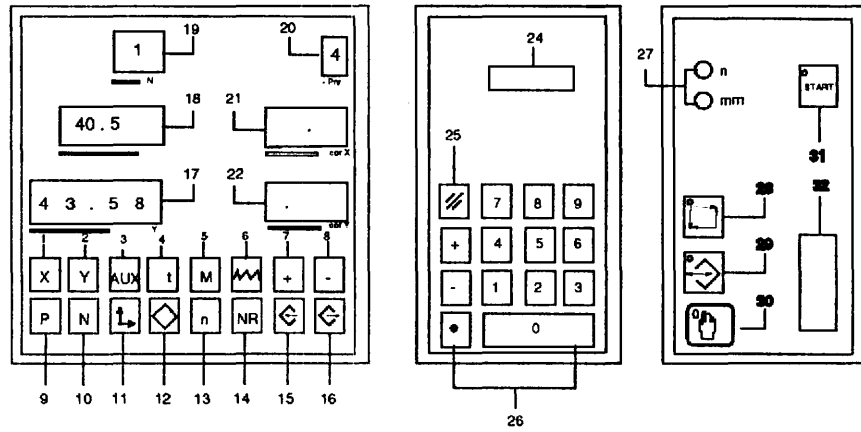


Fig. 22

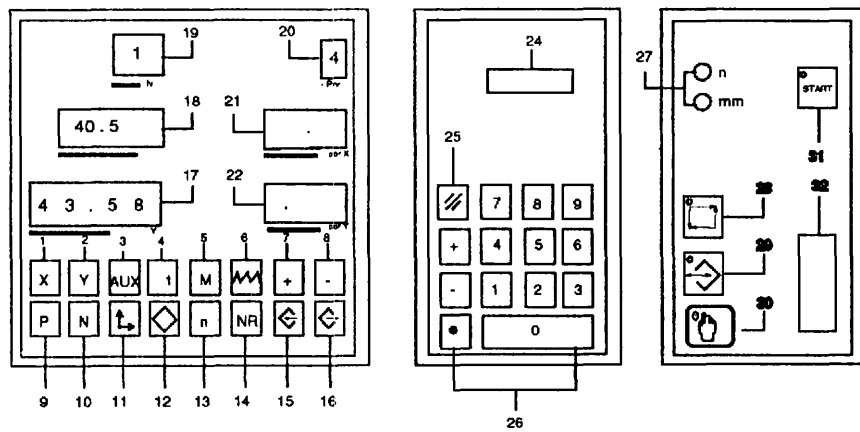
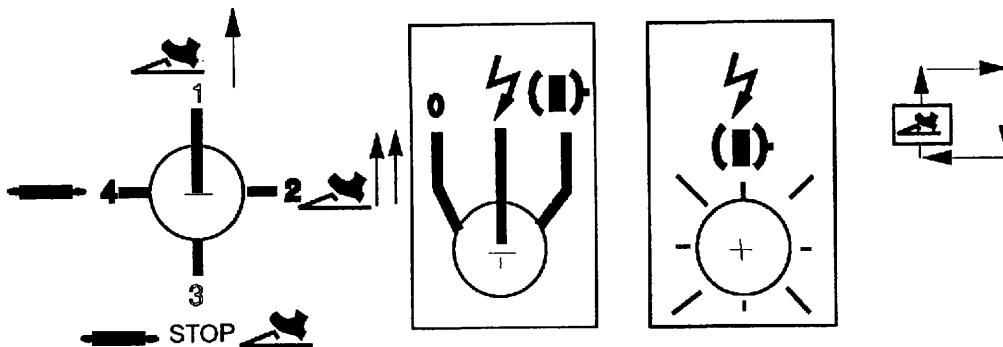


Fig. 23

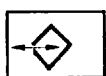


## 17 - 5 PRODUCTION

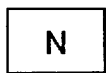
Position of switches on electrical control cabinet



resetting, green indicator light is on



Programming mode



return to bend n° 1 1  
 N



goes into automatic mode



the axes are positioned on bend n° 1  
 wait for end of positioning (beep)

You can now make the first bend.

After making the first bend, the numerical control is automatically placed on next bend.  
 Always wait for the end-of-positioning beep before pressing the pedal again.

