



RESET X AND Y AXES
For numerical control FANUC OP

SHEET LOADING FOR RESET AXIS

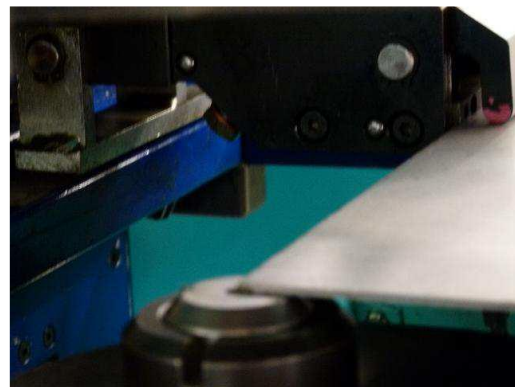
1. Switch the punch machine on
2. Rotate MODE selector on MDI (foto 1)
3. Load a tool on machine (use a round tool, like nibbler, diameter 10 mm)
4. Load a rectangular sheet
5. Rotate MODE selector on JOG (foto 1)
6. With X+, X-, Y+, Y- pushbuttons, slowly put load top left of sheet near die's center (foto 2)

N.B.: during this movements, if you read a "S LMT" alarm on screen, press EMERGENCY and release it (pressing and rotating the EMERGENCY red button) to continue the sheet movement

7. Rotate MODE selector on (foto 1)
8. On "NUMERO UTENSILE" (tool number) display (foto 3), set tool number 2 with "+" e "-" buttons
9. Switch the punch machine off



1



2



3

PREPARING PARAMETERS TO RESET AXIS

10. Disconnect and connect ENCODER cables on BOTH red heads of X and Y (foto 4)
11. Switch the punch machine on
N.B.: after restart, on screen “Reset Axis X and Y” alarms will appear
12. Press “RESET” to delete alarms from screen
13. Press “SET” on pushbuttons
14. Press “PAGE ↓” several times, to scroll all pages on screen, until you read “PARAMETER ENBL=0”
15. Write “P 1” and press INPUT on pushbuttons
N.B.: after this operation, an alarm number 100 will appear; it advises that “parameters write mode” is active
16. Press “RESET” to delete alarms from screen
17. Press “PARAM” on pushbuttons
18. Write “N 23” and press INPUT on pushbuttons to read parameter number 23
19. Write “P 00001111” and press INPUT on pushbuttons; check if parameter number 23 “00001111” indeed
N.B.: after this operation, an alarm number 100 will appear; it advises that “parameters write mode” is active
20. Switch the punch machine off and then on again



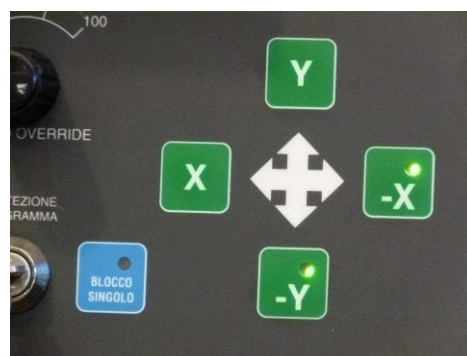
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RESET PARAMETERS

21. Press “POS” on pushbuttons
22. Press “PAGE ↓” several times, to scroll all pages on screen, until you read “ACTUAL POSITION (RELATIVE)”
23. Write “X”
24. Press “CAN” on pushbuttons (to reset relative position of X axis)
25. Write “Y”
26. Press “CAN” on pushbuttons (to reset relative position of Y axis)
27. Rotate MODE selector on STEP 10 (foto 1)
28. With X+ e X- on pushbuttons, move X axis to X=20 position
29. With X+ e X- on pushbuttons, move X axis to X=-10 position
30. With X+ e X- on pushbuttons, move X axis to X=0 position
31. With Y+ e Y- on pushbuttons, move Y axis to Y=20 position
32. With Y+ e Y- on pushbuttons, move Y axis to Y=-10 position
33. With Y+ e Y- on pushbuttons, move Y axis to Y=0 position
34. Rotate MODE selector on MDI (foto 1)
35. Press “PARAM” on pushbuttons
36. Write “N 82” and press INPUT on pushbuttons to read parameter number 82 value
37. Memorize parameter 82 value (example “12500”)
38. Write “P” and then parameter 82 value (in our example “P 12500”)
39. Press INPUT on pushbuttons to overwrite parameter 82 value (with the same value it had before)
40. Press “RESET” to delete “000” alarm appeared
41. Press “PARAM” on pushbuttons
42. Write “N 83” and press INPUT on pushbuttons to read parameter number 83 value
43. Memorize parameter 83 value (example “11800”)
44. Write “P” and then parameter 83 value (in our example “P 11800”)
45. Press INPUT on pushbuttons to overwrite parameter 83 value (with the same value it had before)
46. Switch the punch machine off and then on again

AZZERAMENTO ASSI X E Y

47. After restart, on screen “Reset Axis X and Y” alarms will appear
48. Press “POS” on pushbuttons
49. Press “PAGE ↓” several times, to scroll all pages on screen, until you read “ACTUAL POSITION (RELATIVE)”
50. Write “X”
51. Press “CAN” on pushbuttons (to reset relative position of X axis)
52. Write “Y”
53. Press “CAN” on pushbuttons (to reset relative position of Y axis)
54. Rotate MODE selector on STEP 10 (foto 1)
55. With X- button, move X axis to X=-20 position
56. With X+ button, move X axis to X=-10 position
57. Rotate MODE selector on ZRN (foto 1)
58. Keep pressed X- button, until “X- led” lights (foto 5)
59. Rotate MODE selector on STEP 10 (foto 1)
60. With Y- button, move Y axis to Y=-20 position
61. With Y+ button, move Y axis to Y=-10 position
62. Rotate MODE selector on ZRN (foto 1)
63. Keep pressed Y- button, until “Y- led” lights (foto 5)



FINAL TEST

64. After restart, punch machine asks to reset T axis
65. Rotate MODE selector on ZRN (foto 1)
66. Press “ZERO ASSE T” button on pushbuttons
67. Load a tool on machine (use a round tool, like nibbler, diameter 10 mm)
68. Load a rectangular sheet
69. Press “POS” on pushbuttons
70. Press “PAGE ↓” several times, to scroll all pages on screen, until you read “ACTUAL POSITION (ABSOLUTE)”
71. Rotate MODE selector on JOG (foto 1)
72. With X+, X-, Y+, Y- buttons, move axis to X=50 position and Y=50 position (for example)
73. Press PUNCH pedal (with foot) to punch a hole in these positions
74. With a caliber, measure distance from left side of hole to left border of sheet; and distance from top side of hole and top side of sheet
75. In our example (round tool 10 mm and X=50 and Y=50 as positions), left distance must be 45 mm; top distance must be 45 mm too
76. If measurements are ok, reset procedure is well done; you can go to next paragraph of this guide
77. Instead, if measurements are not good, it is necessary to modify parameters
78. Example: distance on X axis is 45,50 mm (instead of 45). Parameter number 82 was 12500; we have to modify: $12500 - 500 = 12000$ (1 mm = 1000)
79. Rotate MODE selector on MDI (foto 1)
80. Press “PARAM” on pushbuttons
81. Write “N 82” and press INPUT on pushbuttons to read parameter number 82 value
82. Write “P 12000” and press INPUT on pushbuttons to overwrite parameter number 82 value
83. Example: distance on Y axis is 44,70 mm (instead of 45). Parameter number 83 was 11800; we have to modify: $11800 + 300 = 12100$ (1 mm = 1000)
84. Rotate MODE selector on MDI (foto 1)
85. Press “PARAM” on pushbuttons
86. Write “N 83” and press INPUT on pushbuttons to read parameter number 83 value
87. Write “P 12100” and press INPUT on pushbuttons to overwrite parameter number 83 value
88. Switch the punch machine off and then on again

89. Do this final test again, to check your parameters; repeat this procedure until your hole is in precise position.

FINAL OPERATIONS

90. After restart, an alarm will advise that parameter “write mode” is enable

91. Press “RESET” to delete alarm from screen

92. Press “SET” on pushbuttons

93. Press “PAGE ↓” several times, to scroll all pages on screen, until you read
“PARAMETER ENBL=1”

94. Write “P 0” and press INPUT on pushbuttons