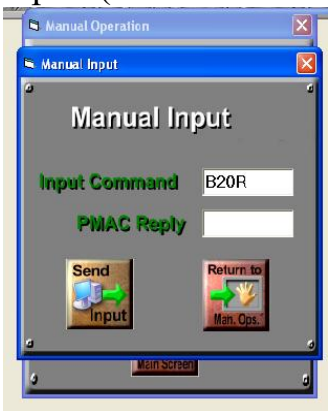# Adjusting the Bend Arm Home Position and Arcs for Accubend Lite
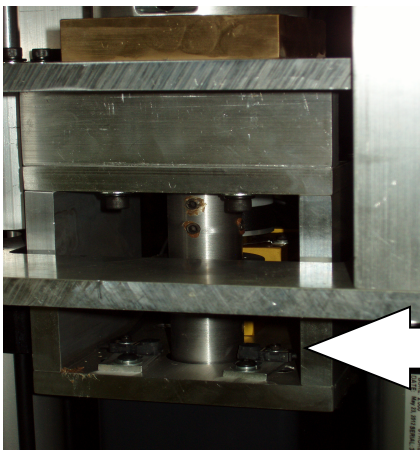
1. Go to Manual Operations

   Manual Input and type ***a*** then click send input and ***b20r*** then click send input. (This is the homing program which runs between every letter.)
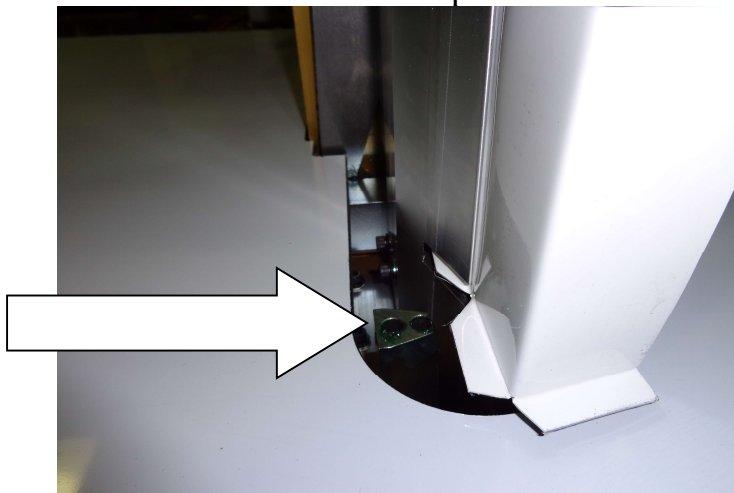

2. Watch the bend arm to make sure it is not hitting the clamp when the arm homes. If the arm <u>does not</u> hit the clamp, go to step 6.
3. If the arm <u>does</u> hit the clamp, remove the end cover under the offload table. This will give you access to the limit switches.

Bend arm limit switch

4. Loosen the button head screw on the right limit switch mount and move the switch back toward the machine about 1/8 of an inch on the slotted hole and retighten. With the power on, there is a red light on the limit switches.
5. Go to step 1 and repeat until the arm is about 1/8 of an inch from the clamp.
6. Open the file called **arctest.dxf** on the **C:\samples** file folder
7. Run the "fat L" with the start and end points shown below.
8. After the first bend, (a reverse or negative bend) watch as the arm switches sides. Before the arm drops down, it should rotate until the back side of the arm is parallel with the material as shown below.

9. A. If the arm <u>is</u> in the correct position, skip to step 22.
9. B. If the arm <u>is not</u> in the correct position, go to manual operations, manual input, send input and type *i226* and hit enter.

10. A number should appear in the PMAC reply window. (about -16000)
11. If the arm is too close to the <u>front</u> side of the clamp, make the number more negative by 300 counts. (If i226=-15900,
    make it i226=-16200.) If the arm is too close to the <u>center</u> of the clamp, make the number less negative. To do so, in the manual input window, type *i226=-16200* or whatever the new value needs to be and click send input.
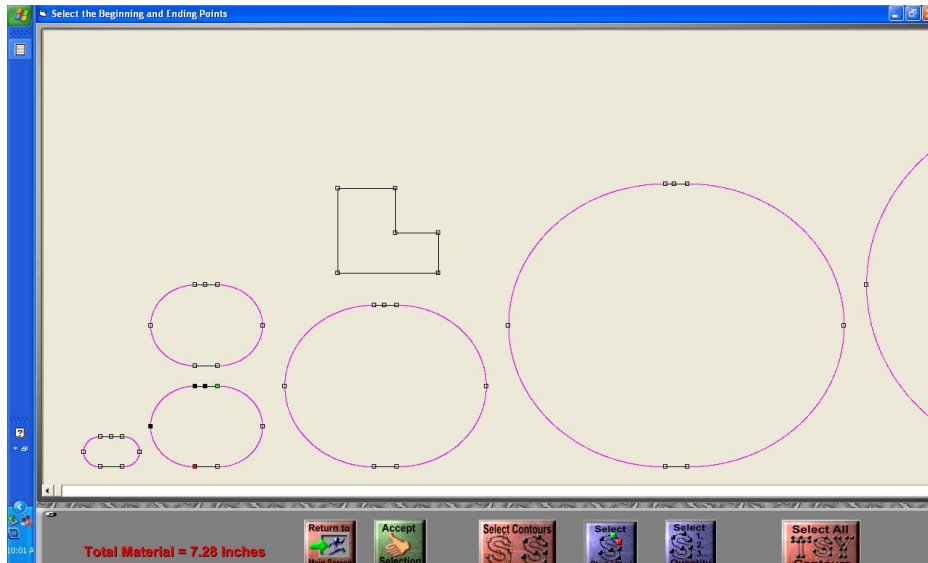   *NOTE: I226 <u>MUST</u> be a negative number to avoid the arm hitting the clamp.*

12. Type *save* in the window.

13. Go to step 6.
14. Run the 2nd arc from the left putting the start and end points as shown below.

15. The result should be very close to what is displayed on the screen.
16. If the bend is good, go to step 22.
17. If the bend is too open, go to manual operations, manual input, type
    p964 and hit enter to find out what the value is (PMAC Reply is usually
    0)

18. Increase p964 by 2 by typing *p964=2* or whatever the new value is in the
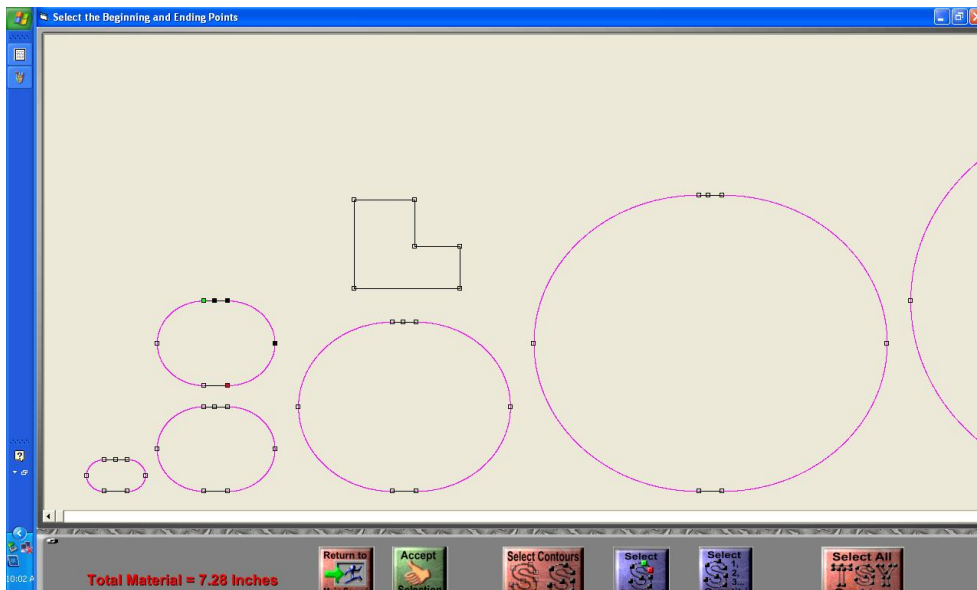   input command window and click send input.

19. Type *save* in the input command window.

20. Go to step 14.
21. Run the top arc the 2nd from the left with the start points selected as shown below.

Total Material = 7.28 Inches

22. The result should look like the picture. If it does, you are done. If not, proceed to step 23.
23. Go to manual operations, manual input, send input and type *p974* and hit enter. A number (usually 0) should now appear in the PMAC Reply window.

24. If the bend is <u>too much</u>, decrease the value of P974 by 2. (If P974=0, type *P974=-2* then send input).
    If the bend is <u>not enough,</u> increase the value of P974 by 2. (If P974=0, Type *P974=2* then send input.

25. Type *save* in the Manual Input window and click send input.

26. Repeat step 21. You may end up with P964=2.2 and P974=-1.6. Using + or – 2 for a change in radius bend is enough to notice a difference without an extreme change. The key is getting the bend arm to home close to the factory setting. Once you are there, there should be little change on P964 and P974. The numbers are in degrees per bend.
27. You are now ready to start bending.