

# Siena & ST Machines

## Procedure to Calibrate Work Holder Detection System (Metric)

### 1. Set end gage

Adjust the end gage pin so the programmed X dimension of a hole matches the actual location of the hole on the sheet.

### 2. Set X-axis reference position

Using the scale on the axis, locate the work holders at 400 millimeters and 700 millimeters. If \*optional third work holder is used, locate it at 1200 millimeters.

Adjust the X-axis reference position so that the center of the work clamp closest to the operator is 400 millimeters from the end gage.

### 3. Adjust work holder recognition switch

Command the X-axis to 400 millimeters. Then align the work clamp recognition switch so that it is centered over the vane on the work holder.

### 4. Turn on control maintenance parameter

Set parameter K10.0 to one.

If not already set, set CLAMP SWITCH OFFSET - PCODE #507 to 0

### 5. Calibrate work holder detection system

Put in "MAN" mode.

Press "CUSTOM" key on MDI panel.

Press left most softkey to display the "<1>" softkey label.

Press "CLAMP" softkey.

Enter 400.00 in "CALIBRATE POSITION" box for clamp 1.

Enter 700.00 in "CALIBRATE POSITION" box for clamp 2.

Enter 1000.00 in "CALIBRATE POSITION" box for clamp 3 (if optional clamp is used).

Press "START CALIB" softkey.

Press "CYCLE START" push button (clamps are scanned and calibrated).

### 6. Turn off control maintenance parameter

Set parameter K10.0 to zero.

\* Refer to page three for optional third work holder setup procedure

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## Procedure to Calibrate Work Holder Detection System (English)

### 1. Set end gage

Adjust the end gage pin so the programmed X dimension of a hole matches the actual location of the hole on the sheet.

### 2. Set X-axis reference position

Using the scale on the axis, locate the work holders at 13 inches and 28 inches. If

\*optional third work holder is used, locate it at 47 inches.

Adjust the X-axis reference position so that the center of the work clamp closest to the operator is 13 inches from the end gage.

### 3. Adjust work holder recognition switch

Command the X-axis to 13 inches. Then align the work clamp recognition switch so that it is centered over the vane on the work holder.

### 4. Turn on control maintenance parameter

Set parameter K10.0 to one.

If not already set, set CLAMP SWITCH OFFSET - PCODE #507 to 0

### 5. Calibrate work holder detection system

Put in "MAN" mode.

Press "CUSTOM" key on MDI panel.

Press left most softkey to display the "<1>" softkey label.

Press "CLAMP" softkey.

Enter 13.000 in "CALIBRATE POSITION" box for clamp 1.

Enter 26.000 in "CALIBRATE POSITION" box for clamp 2.

Enter 39.000 in "CALIBRATE POSITION" box for clamp 3 (if optional clamp is used).

Press "START CALIB" softkey.

Press "CYCLE START" push button (clamps are scanned and calibrated).

### 6. Turn off control maintenance parameter

Set parameter K10.0 to zero.

\* Refer to page three for optional third work holder setup procedure

## **Siena & ST Machines**

### **Optional third work holder setup procedure**

Press "CUSTOM" key on MDI panel.

Press left most softkey to display the "<1>" softkey label.

Press "CLAMP" softkey.

Press right most softkey to display the "<2>" softkey label.

Press "USE 3 CLAMP" softkey,