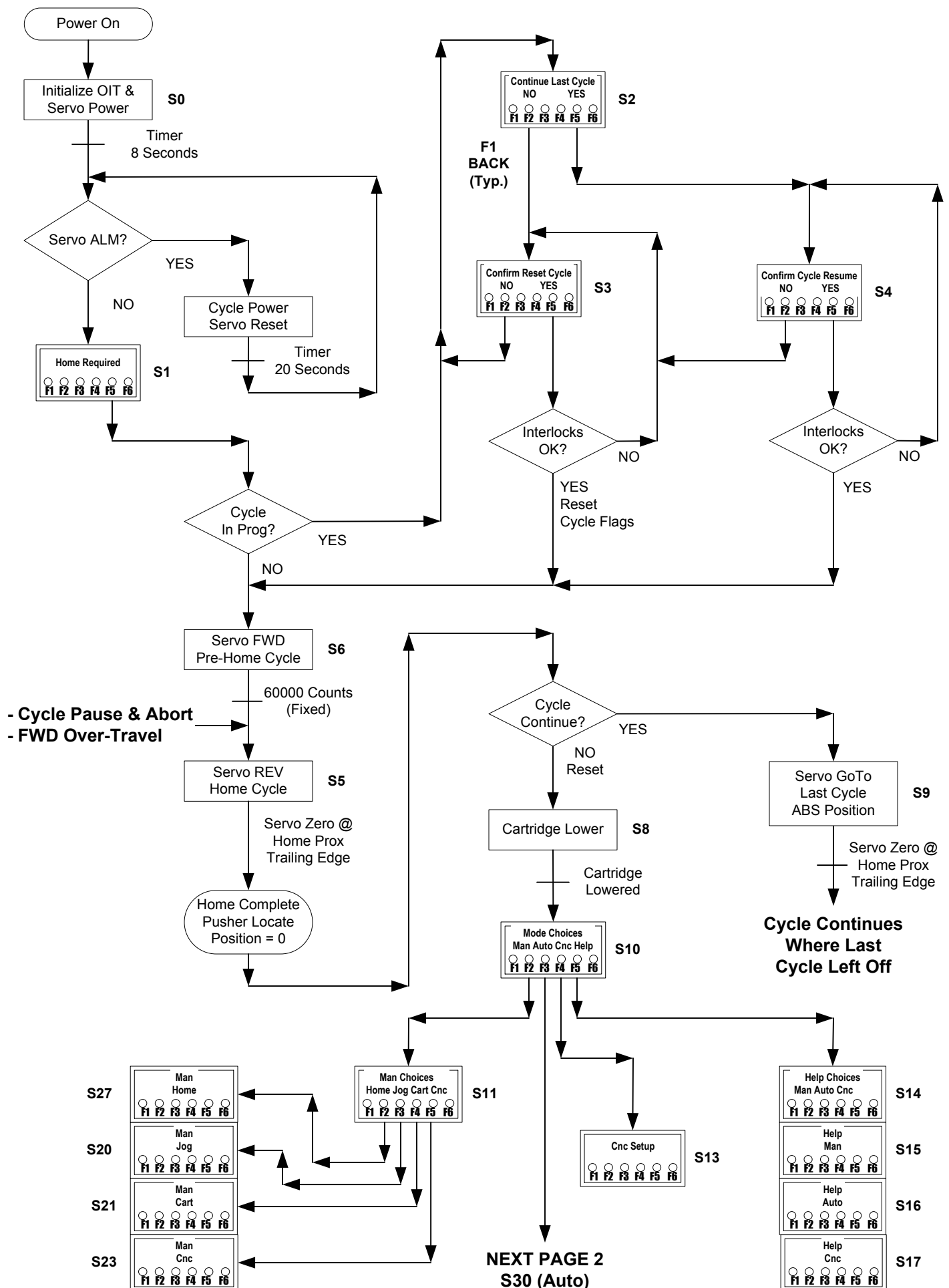
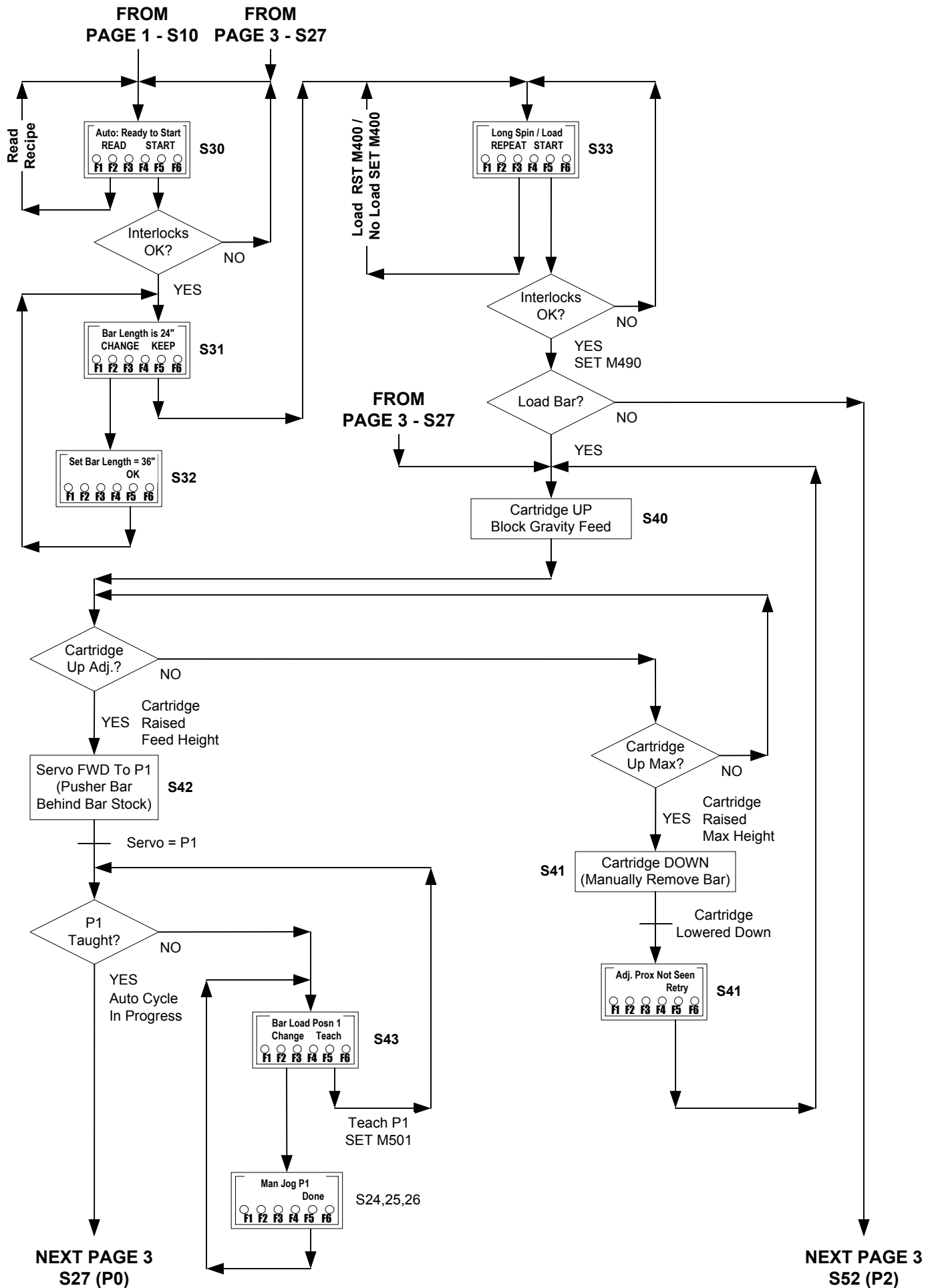
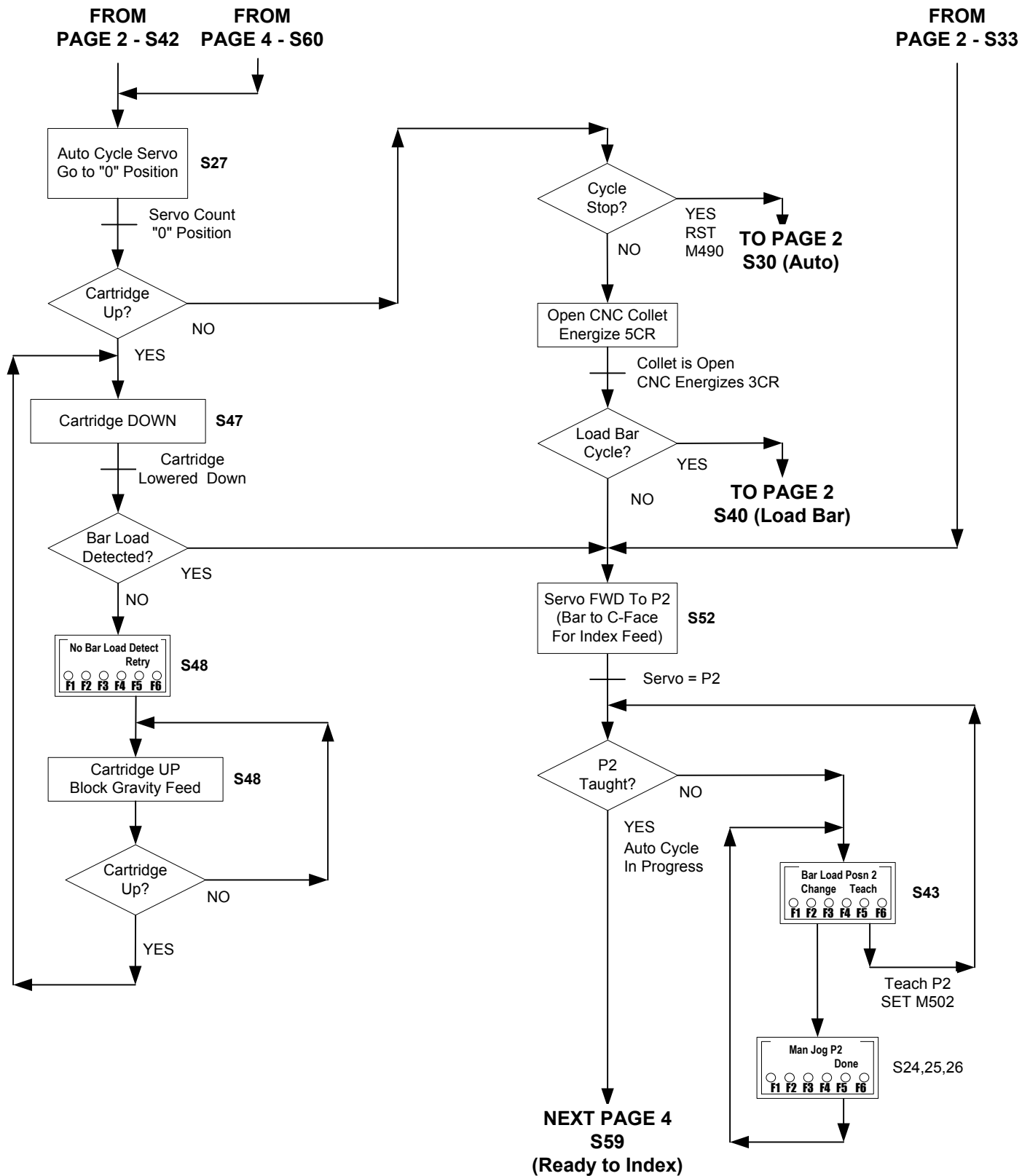
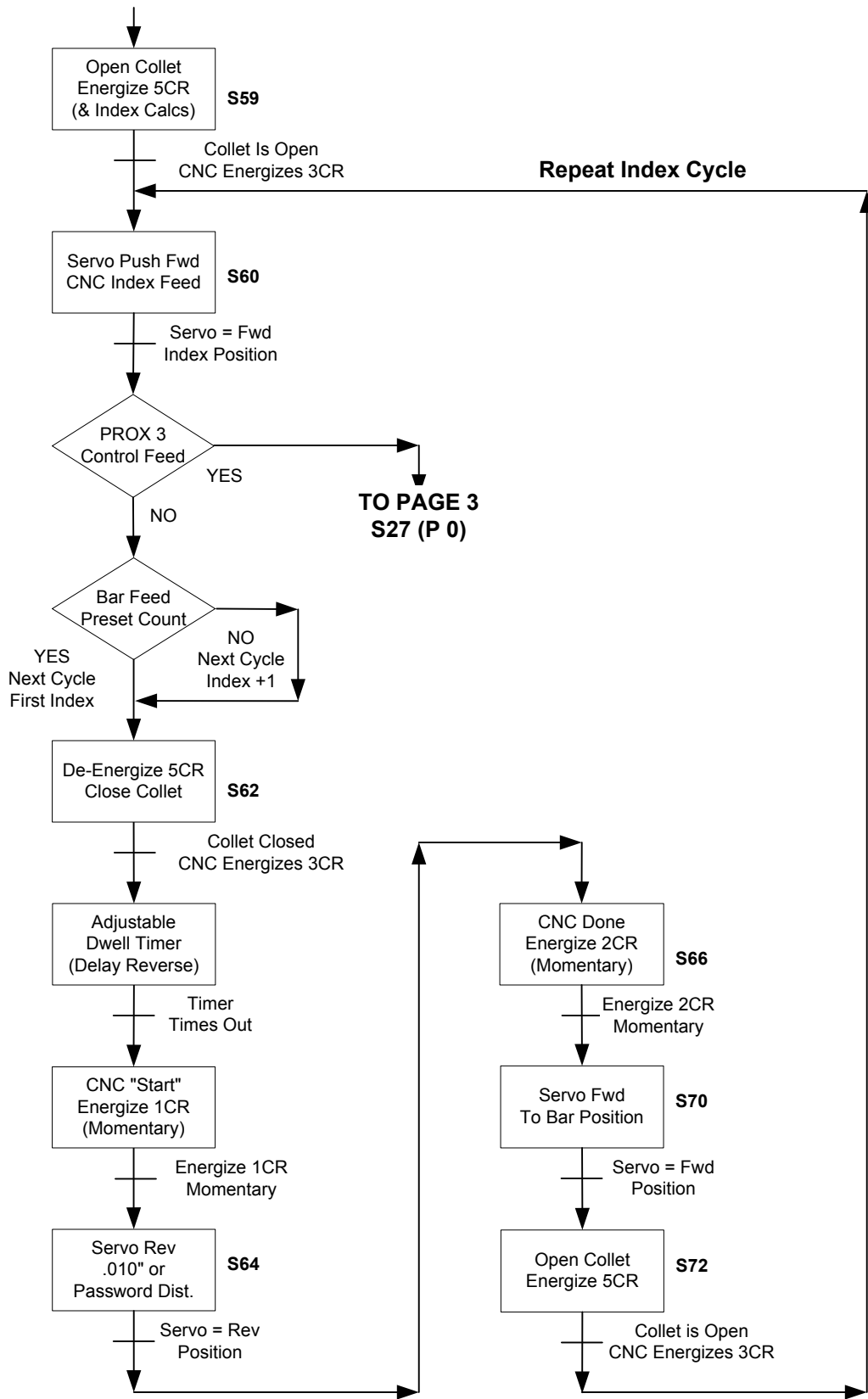








FROM
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P0 = Home Position (Ball Screw Pusher Bar can Accept Max Bar Stock of 36")

P1 LOAD Cycle (Up) = (BarLen - ScrewMax) + (C-FaceDist - 1")

P1 NO LOAD (Down) = P1 Up (calculated) - PBarLen

Note: C-Face is the P1 Target, and default is less one inch. Operator may JOG FWD & Teach (No way to JOG Bar Stock Reverse)

SHORT SPINDLE Cycle: If PBarLen >= P1 - BarLen (Program Calculated)

In other words, when the Pusher Bar (Fixed Length) is equal or greater than the Teach P1 position, minus the Bar Stock Length
Note: CNC Setup should be equal to the distance

LOAD Cycle: If BarLen >= PBarDiff (ScrewMax - PBarLen), (Program Calculated), AND BarLen is greater than 8"

In other words, If the Bar Stock length is greater or equal to the Maximum Feed Distance, AND 8" or greater,

Then it CAN NOT Feed far enough to clear the cartridge mechanism when raised & lowered for Next gravity feed of New Bar Stock.

Note: A LOAD Cycle refers to preparing the new bar stock Up & Into C-Face for CNC Index Feeding

A NO LOAD Cycle refers to allowing a CNC Index Feed immediately following gravity feed of New Bar Stock

Note: Bar Stock Length is calculated from exit side of Baby Bar Feeder

Note: PBarDiff = (ScrewMax - PBarLen)

{ScrewMax & PBarLen Should be Equal, the ScrewMax is Fixed, but a shorter PBarLen May be used}

EX: If PBarLen = 20", Then (33" ScrewMax) - 20" = 13". Thus If BarLen >= 13", Then it would need to be a LOAD Cycle }

