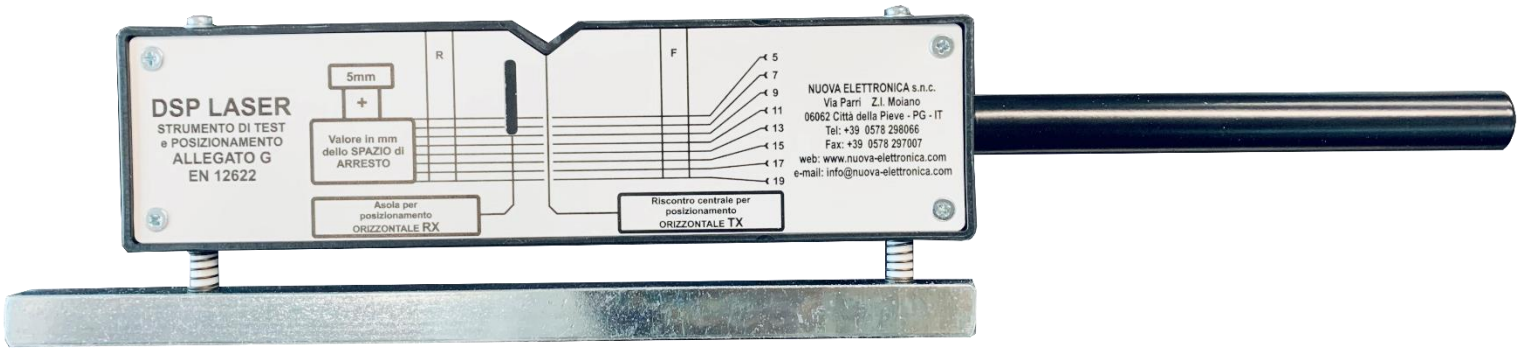
Test Hand for DSP Standard

COD. 001 P

Test Hand for DSP Laser Standard



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ADJUSTING THE PHOTOCELLS AFTER INSTALLATION

For the first installation of the DSP Laser Standard photocells it will be necessary to adjust the aforementioned safety device, therefore the special test hand must be used to carry out this adjustment and test.

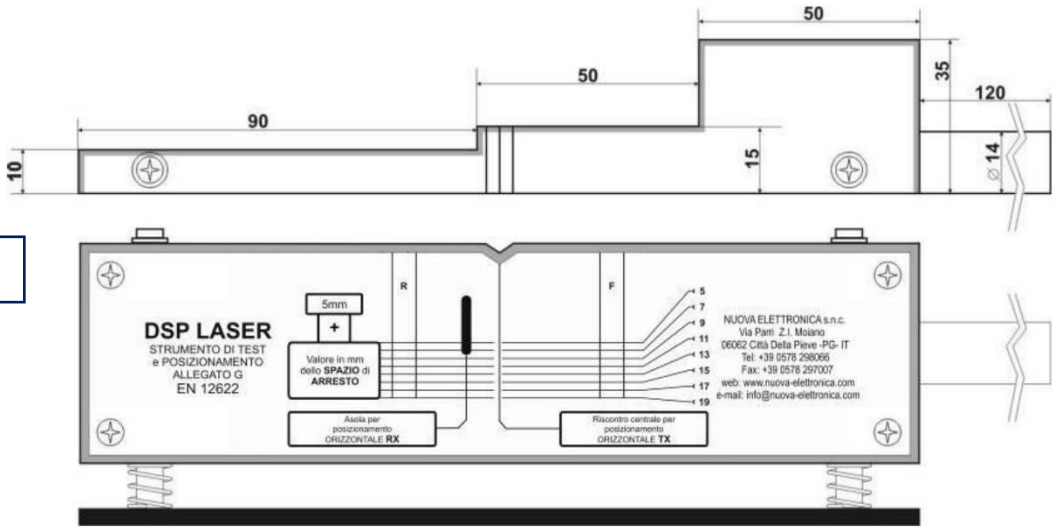

Fig. 14.1

PROCEDURE:

Set a reduced closing speed, less than or equal to 10 mm / sec.
Place the test and positioning tool on the lower tool at point A (near the TX) of Fig. 14.3. Lower the upper tool until its tip touches the notch in the vertex of the recess of the upper part of the tool resting on the die, as in Fig. 14.4.
Adjust the height of the TX, moving the support vertically, so that the LOWER EDGE OF THE LASER EMISSION coincides with the line indicating the STOP SPACE of the machine, as in Fig. 14.4.

ATTENCION:

In this example, the lower edge of the laser emission is positioned on the line indicating a stop space whose value is 13mm. **For each machine tool it is necessary to know its stopping distance**. If this data is not known, initially position the lower edge of the laser emission coinciding with the line that indicates the highest value (19mm) of the stopping space.

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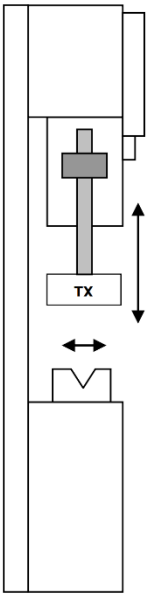
Fig. 14.2



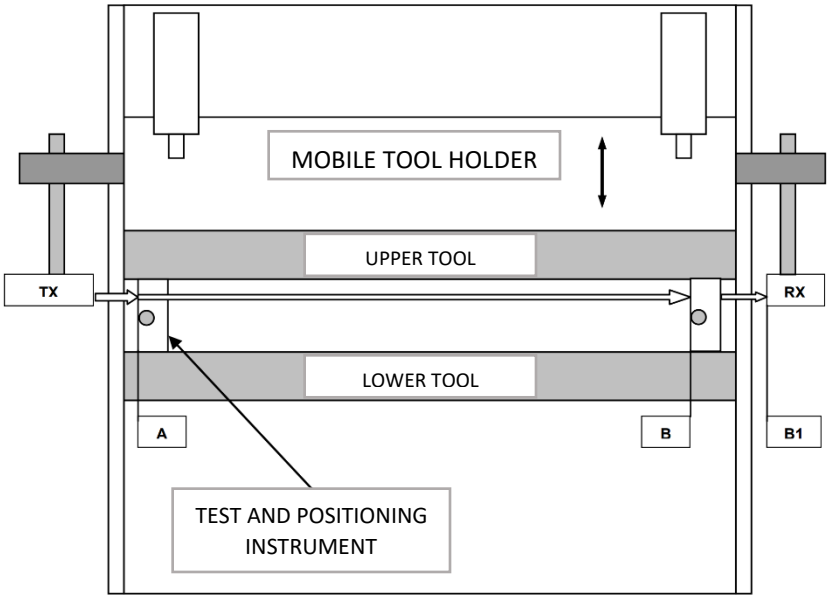
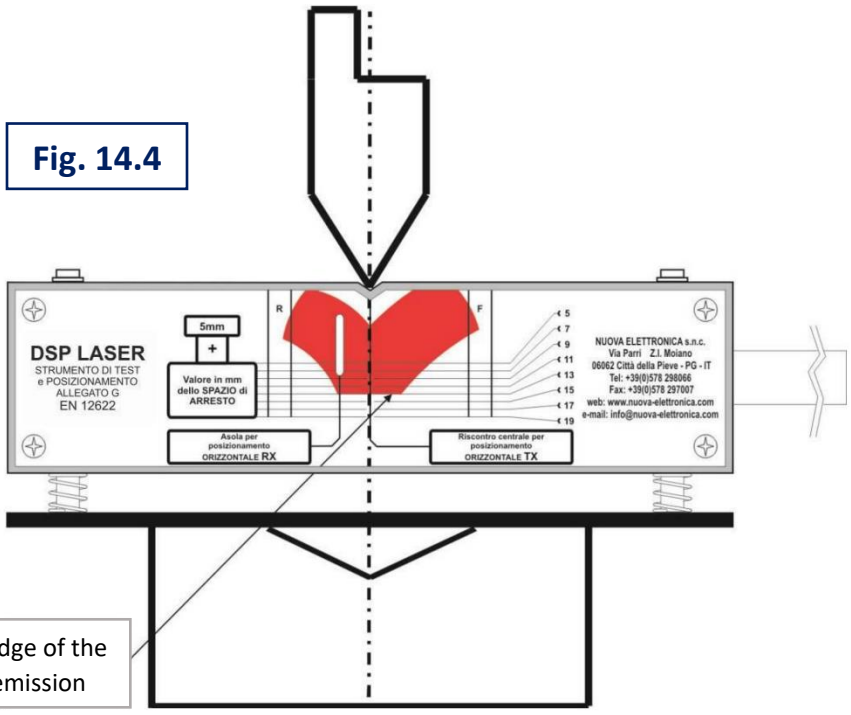


Fig. 14.3

Then adjust the TX along the transversal plane (to the bending plane) by acting on the fixing screws of the TX to the support so that the central vertical plane of the detection zone coincides with the STRIKER FOR HORIZONTAL POSITIONING and the ends of the detection zone are contained within the two surfaces delimited by the two vertical lines and marked one with R and one with F, as in Fig. 14.4.
Then block TX in this position.

Fig. 14.4



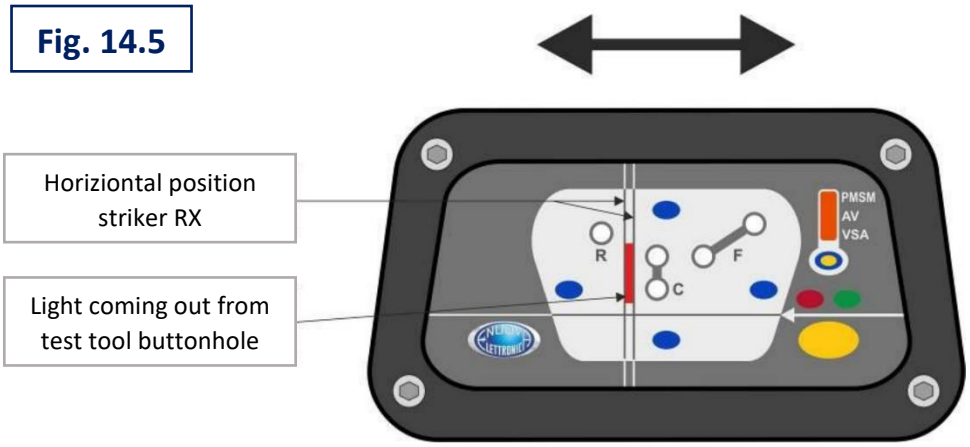
Then move the test and positioning tool to the lower tool at point B in Fig. 14.3 or in any case close to the RX. Verify that the beam is still in its previous position relative to the positioning tool. If this is not the case, act on the adjustment screws for the parallelism of the TX beam with respect to the bending line identified by the lower edge of the punch, in order to obtain in point B the position conditions of the beam as in point A of Fig. 14.3, without change the vertical and horizontal position previously adjusted to position A.

ATTENTION:

If an adjustment is necessary to collimate the beam with the specimen in position B, **REPEAT THE VERIFICATION OPERATION FOR POSITION A.**

Only when the beam hits the specimen correctly in both positions can the positioning and adjustment of TX be considered complete.

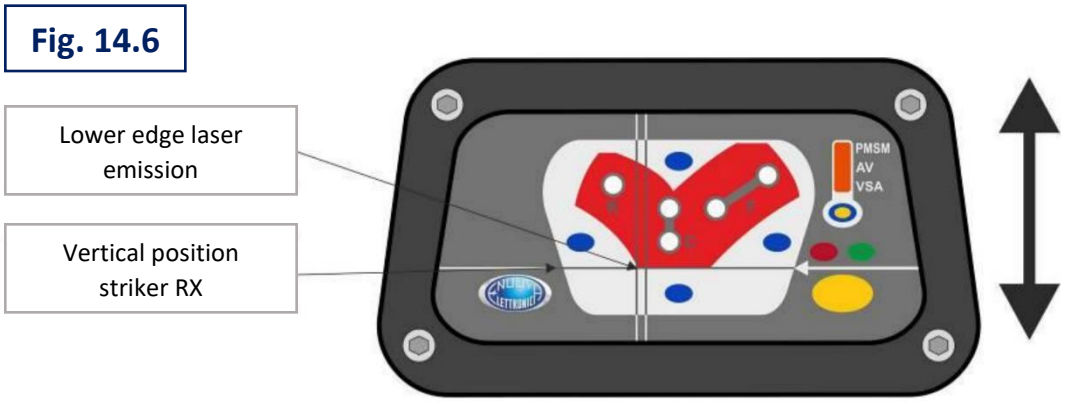
Fig. 14.5



In point B1 of Fig. 14.3 the front of the RX will be observed which is illuminated by a portion of the beam coming out of the RX HORIZONTAL POSITIONING SLOT.

Move RX horizontally so that the light is between the REFERENCES FOR RX HORIZONTAL POSITIONING, as in Fig. 14.5.

Fig. 14.6



Remove the tool from the lower tool.

Move the RX vertically in such a way that the LOWER EDGE OF THE LASER EMISSION coincides with the FACE FOR VERTICAL RX POSITIONING as in Fig. 14.6.

Check that the YELLOW / BLUE LED lights up, confirming the alignment.
If this is not the case, act on the RX parallelism adjustment screws with respect to the bending line identified by the lower edge of the punch, in order to obtain the lighting condition of the YELLOW / BLUE LED, without changing the vertical and horizontal position adjusted. previously.

THE CORRECT INSTALLATION OF THE SUPPORTS AND MECHANICAL ADJUSTMENT OF THE STANDARD DSP LASER SAFETY DEVICES REQUIRES THAT AT EACH TOOL CHANGE THE HEIGHT OF THE SAME IS SIMPLY ADJUSTED ACCORDING TO THE HEIGHT OF THE PUNCH WITHOUT ANY INTERVENTION BY THE USER.

Then check the correct alignment by first installing the upper tool of minimum height and then the one of maximum height.
In the event that the conditions for correct adjustment are missing, it is necessary to check and possibly intervene on the parallelism of the supports with respect to the bending plane.