4.2 DEFINITION OF THE BENDING ORDER

The EURO III allows to define the bending order:

Press the ⌷P⌷ key, to display the PRODUCT BEND; LEGS page.

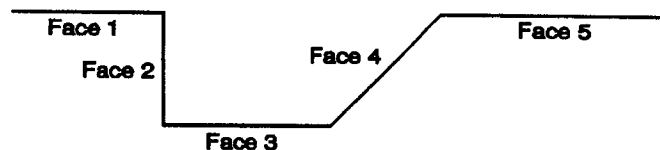## 4.2.1 PRODUCT BEND page; LEGS: Explication of the top screen fields

P

Number of the product
- currently in the work memory or
- to be searched for.

N

Number of the sequence being bent displayed on the SEQUENCE page.

p/d

Punch / die pair associated with the product.

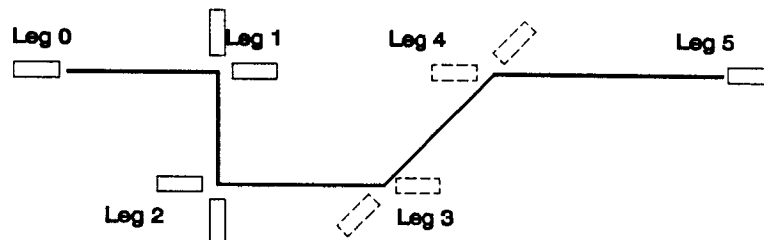## 4.2.2 PRODUCT BEND page; LEGS: Explication of the table columns

Each line (except the last) in the table on the **PRODUCT BEND; LEGS** page represents data concerning a sequence.

N

Automatic numbering of sequences
A "sequence" is defined as being a movement of the machine axes for a given action.
The maximum number of sequences which can be programmed for a product is **14**.

FACE

Face number.

LEG

Number of the face which will press against the stop.

The orientation of the legs is made as a function of the bending order.

CR

Number of bends requested when working with ideal curve.

p/d

Definition of a tooling pair for a particular bend (if different from the pair specified in the p/d field at the top of the page).

4.2.3   PRODUCT BEND page; LEGS: Example of simulation of a simple product

For this example we will use the product created as an exercise on the **PRODUCT STATUS** page.
It was stored under the number 1. (If you cannot find it, create it by following the instructions in chapter 4.1.1.3, page 43).
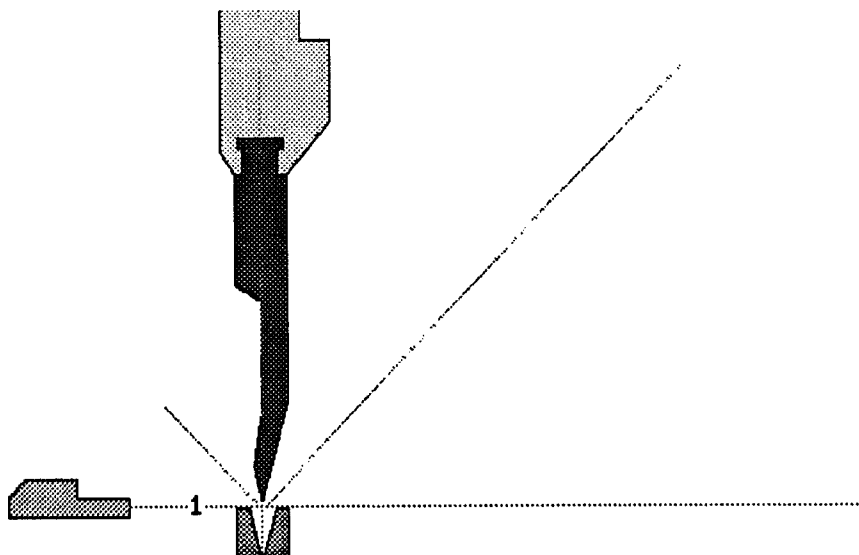Call this product to the screen by entering its number in the P
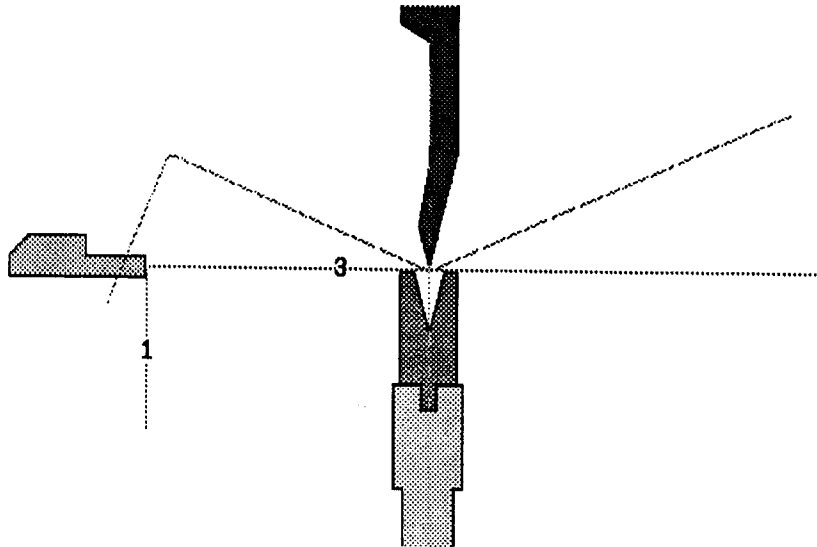
field, and then pressing the ⏎ key.

Fill in the **FACE** and **LEG** fields as follows:

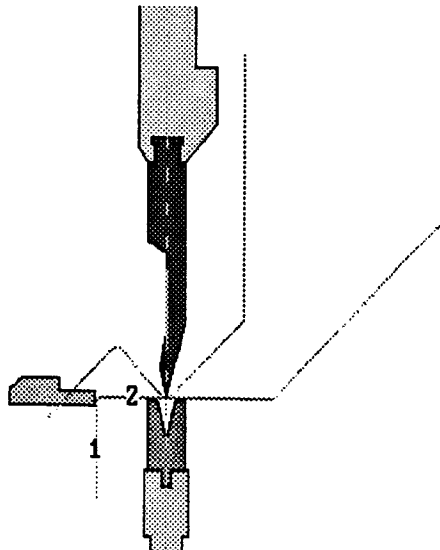| N	FACE	LEG	CR	p/m
1	1	0	—	1/ 1
2	3	1	—	1/ 1
3	2	1	—	1/ 1
4	4	5	—	1/ 1

The following illustrations show you the sheet metal before and after bending for each sequence.
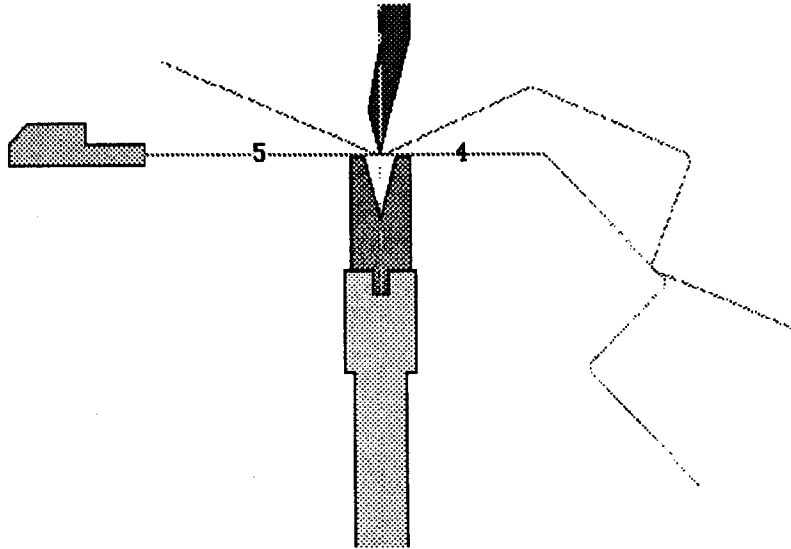

Bend 1 on Face 1 and Leg 0

Bend 2 on Face 3 and Leg 1
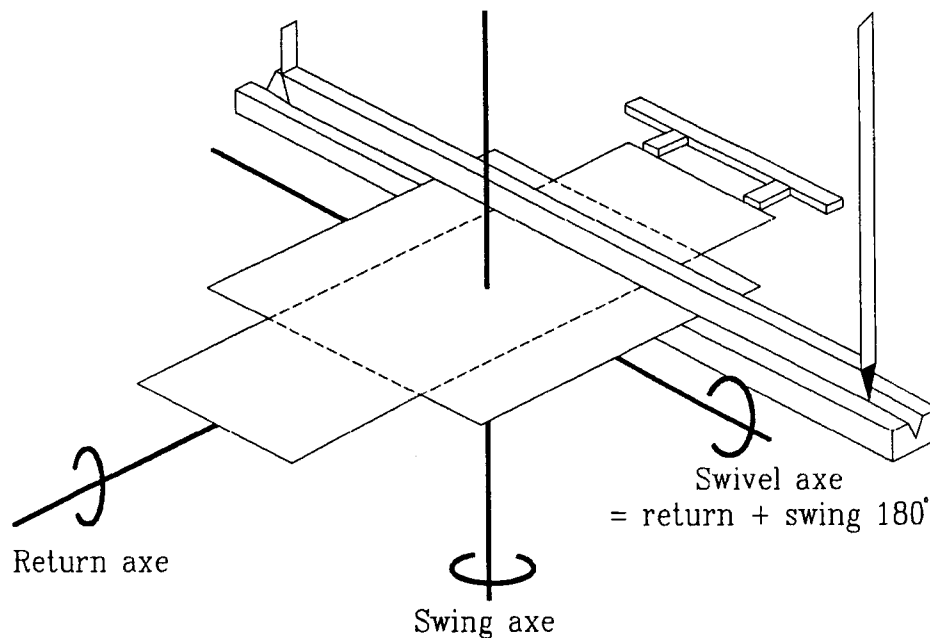

Bend 3 on Face 2 and Leg 1

Bend 4 on Face 4 and Leg 5

Press the ⊣ key.
The system calculates the entire machine program (axes, functions, etc.) and displays the sheet metal manipulations to be made before each sequence. (See the sheet metal manipulation diagram below).

N	FACE	LEG	CR	p/m	
1	1	0	—	1/1	
2	3	1	—	1/1	RETURN
3	2	1	—	1/1	
4	4	5	—	1/1	SWIVEL

Return axe

Swing axe

Swivel axe
= return + swing 180°

Sheet metal manipulation

By pressing the ⊡ key, you can consult the **PRODUCT**; X; ⟨α; Y
page which displays for each sequence the X and Y axes' values.

```
P    1  N  1
  N     -X-      -(α-      -Y-      CY
  1    78.06     90.0    229.90    ___
  2   145.51    135.0    233.58    ___ RETURN
  3    58.06     90.0    229.90    ___
  4   119.39    135.0    233.58    ___ SWIVEL
  5   ____.__   ___._    ____.__    0
  6   ____.__   ___._    ____.__   ___
  7   ____.__   ___._    ____.__   ___
  8   ____.__   ___._    ____.__   ___
  9   ____.__   ___._    ____.__   ___
 10   ____.__   ___._    ____.__   ___
 11   ____.__   ___._    ____.__   ___
 12   ____.__   ___._    ____.__   ___
 13   ____.__   ___._    ____.__   ___
 14   ____.__   ___._    ____.__   ___
```

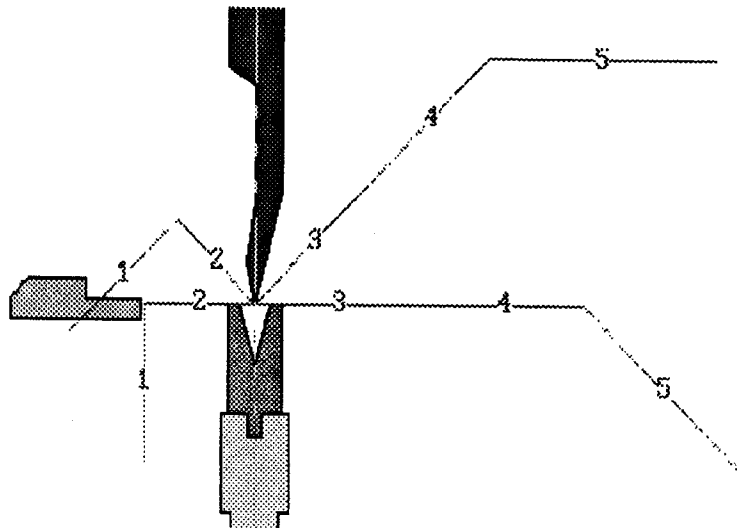We are now going to see another bending order.

To do this recall the product to the screen by pressing the ⊡ key
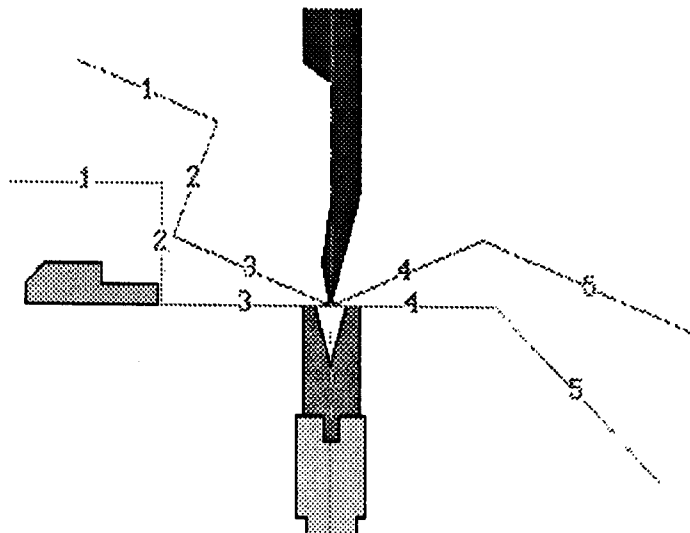twice.

Fill in the **FACE** and **LEG** fields as follows:

```
  N    FACE    LEG    CR    p/m
  1     4       0     ___   1/1
  2     1       0     ___   1/1
  3     2       1     ___   1/1
  4     3       2     ___   1/1
```

The following illustrations will show you the sheet before and
after bending for each sequence.

Bend 1 on Face 4 and Leg 0

Bend 2 on Face 1 and Leg 0

Bend 3 on Face 2 and Leg 1

Bend 4 on Face 3 and Leg 2

Press the ⊣ key.
The system calculates the entire machine program (axes, functions, etc.) and displays the sheet metal manipulations to be made before each sequence.

N	FACE	LEG	CR	p/m	
1	4	0	—	1/1	
2	1	0	—	1/1	
3	2	1	—	1/1	RETURN
4	3	2	—	1/1	