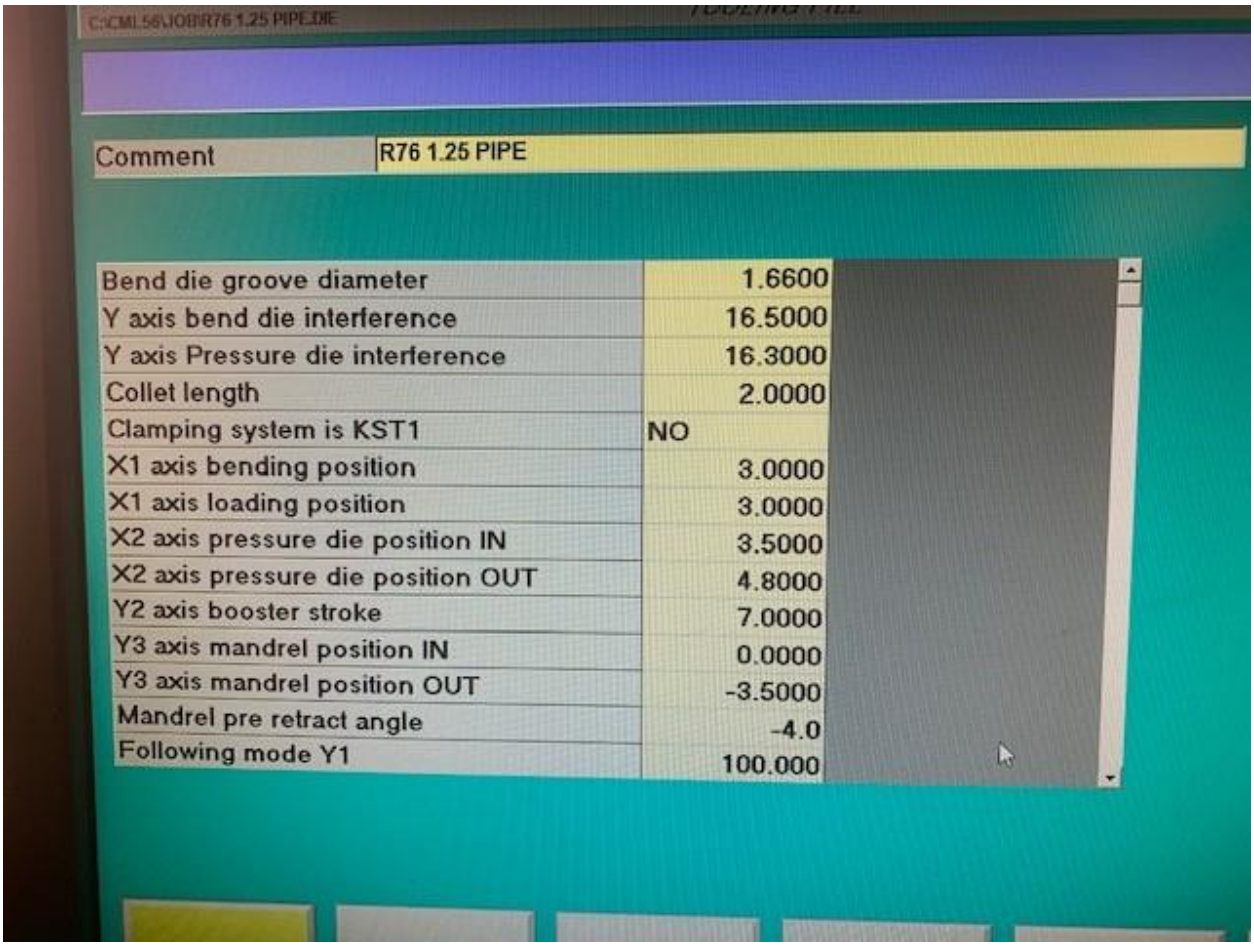
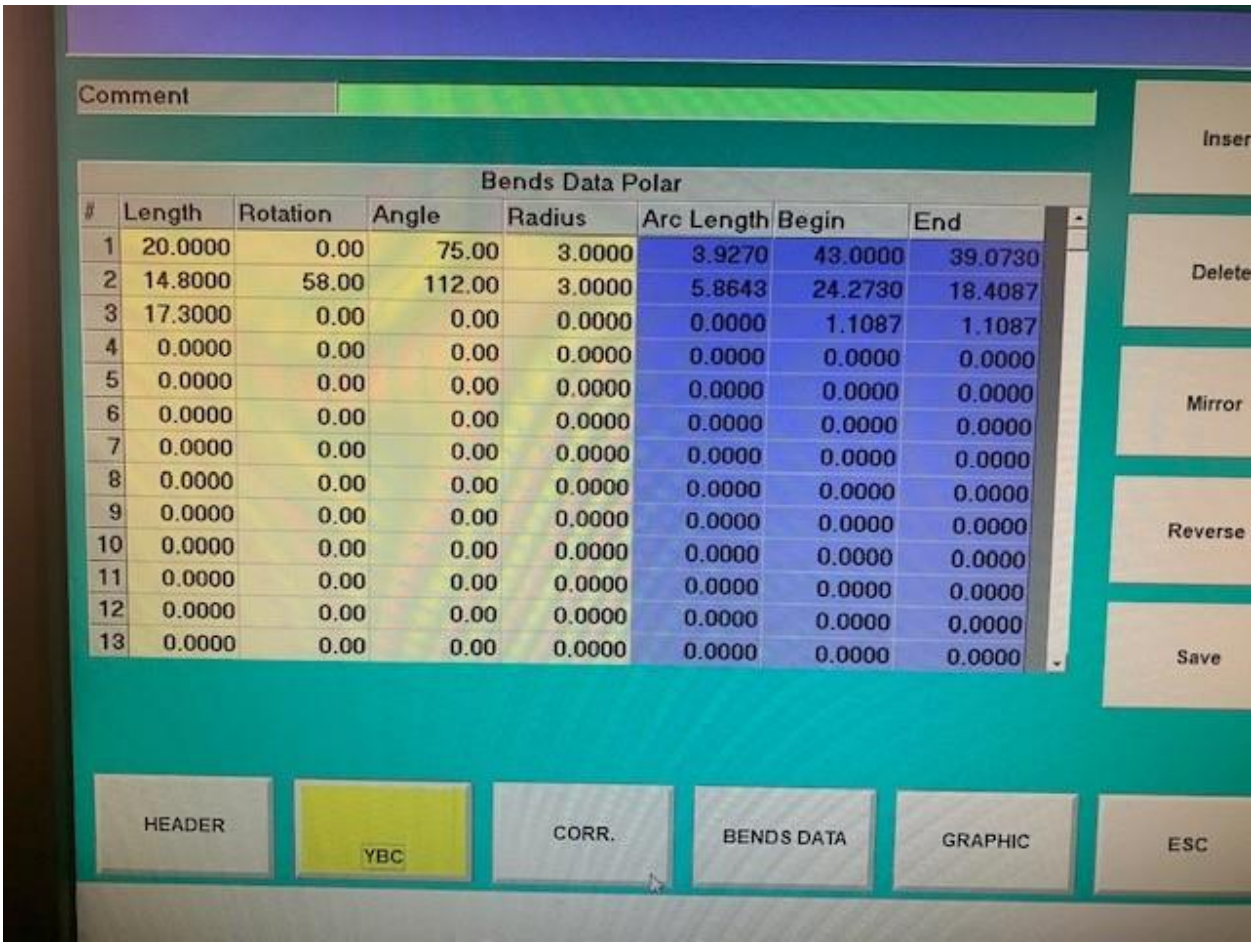
If the machine is not executing the last bend in a series, it is usually due to the last bend falls in a position that is beneath the programmed limit switch settings according to the toolset.



The Y Axis Bend die Interference and Y axis Pressure die interference define the zone for the Y axis to position.

If the programmed bend position lies underneath (smaller value) then machine will not execute that bend and will show a fault or alarm noting the position is under the limit switch value.

A quick way to see if any bends are programmed under the limit switch is to look at the YBC page of the program and compare these values to the setting on the respective toolset.

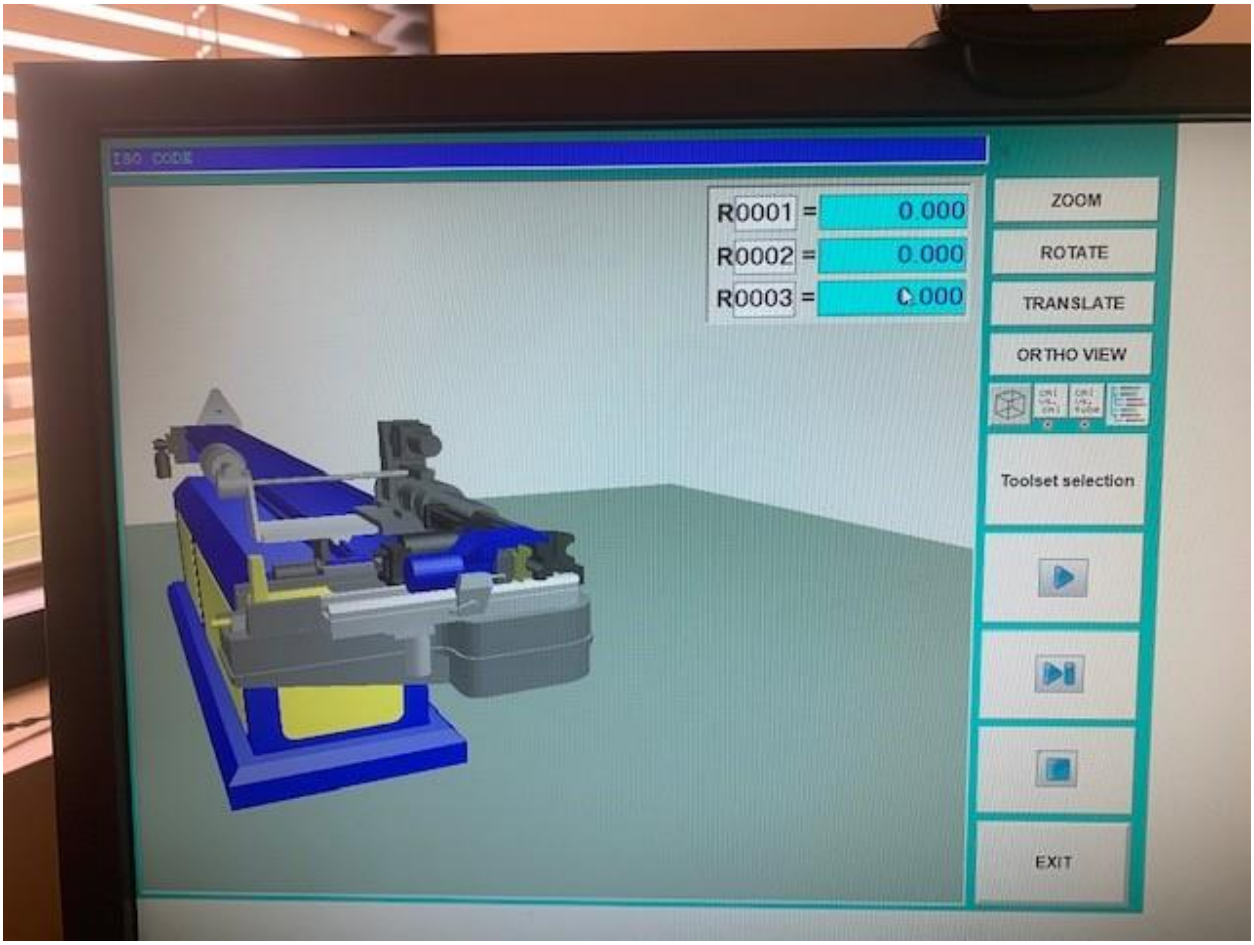


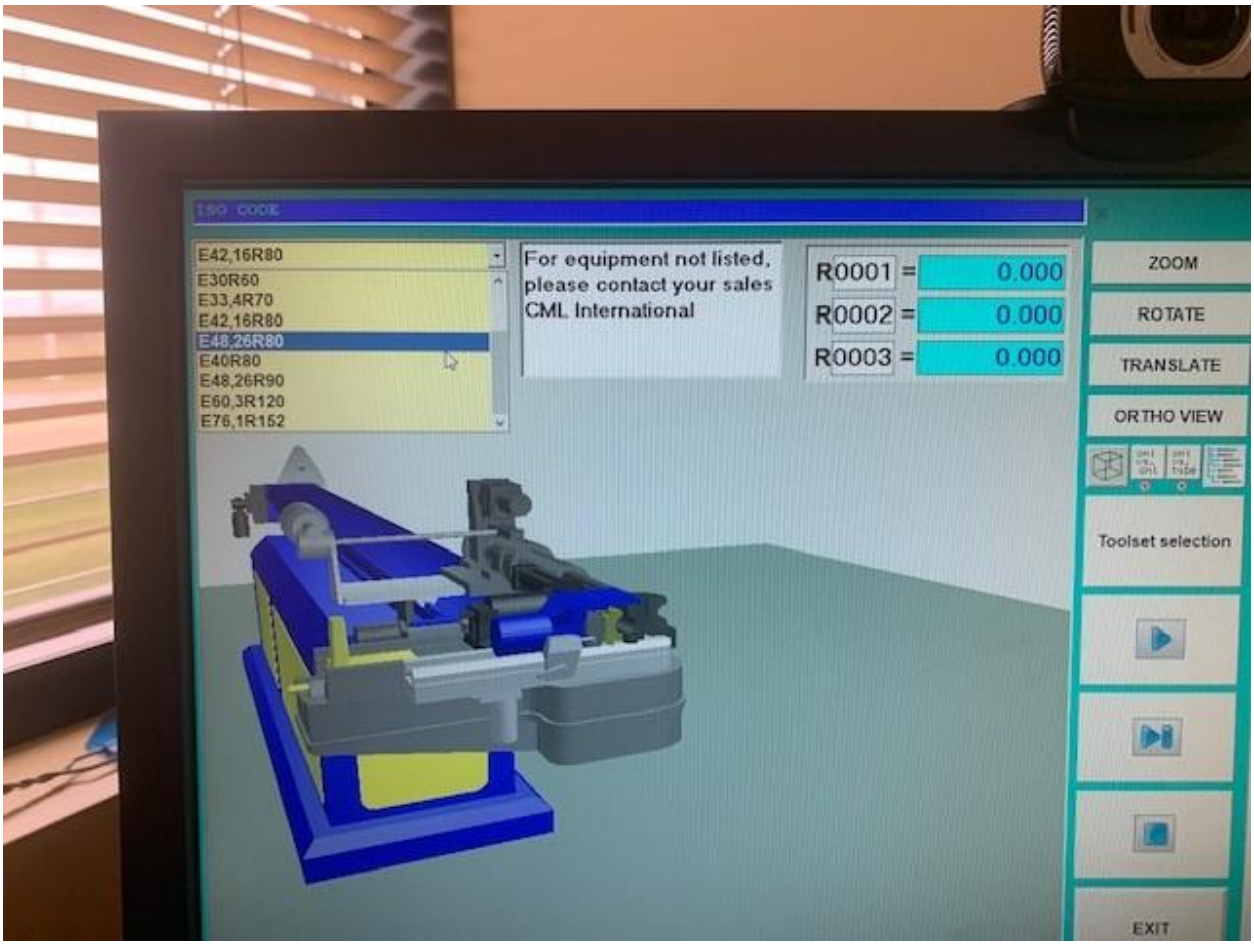
#	Length	Rotation	Angle	Radius	Arc Length	Begin	End
1	20.0000	0.00	75.00	3.0000	3.9270	43.0000	39.0730
2	14.8000	58.00	112.00	3.0000	5.8643	24.2730	18.4087
3	17.3000	0.00	0.00	0.0000	0.0000	1.1087	1.1087
4	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
5	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
6	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
7	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
8	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
9	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
10	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
11	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
12	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000
13	0.0000	0.00	0.00	0.0000	0.0000	0.0000	0.0000

The columns labeled BEGIN and END show where each respective bend lies along the overall developed length.

The solution in this case is to add material to the overall length if possible and move the bend location out of the interference zone or to change the settings on the toolset file IF there is NO mechanical interference with the wiper die bracket or the pressure die bracket.

If the machine is showing alarms or collision during the simulation, check to see if the correct simulation toolset is selected for the animation. The simulation graphics are NOT automatically set according to the current polar file. You must select the toolset on the simulation page. Choose a toolset that closely matches the radius of your actual tooling .





If you are seeing, collision with clamp also be sure that the programmed distance between your bends is NOT shorter than the clamping distance on the former and clamp die.