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MANUAL button on the main control panel. If the workclamp position is changed in the NC mode other than MANUAL, the workclamp position may not be read in the next automatic operation, causing the workclamp to be

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punched. Position the workclamps as far apart as possible and check the "dead zone". 3. Checking tools and station numbers Example:

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Manual Data Input (MDI is also referred to as “Depth Mode” and can best be described as the manual operation of the press brake with only a minimum of computer control. Only basic and direct program data is submitted to the controller. All that is necessary is the depth of penetration and backgauge[ location.

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accuracy of a press brake is affected by, among other factors, the deflection of the upper and lower beams.

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