



# LIST of OPTIONS

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Option Section      Dynamic Option Name

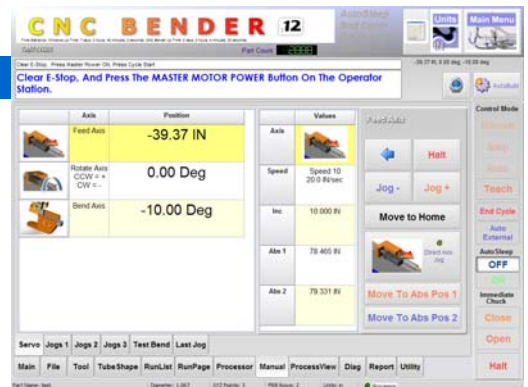
## Tool

- 1                      Radius Shifting
- 2                      PDB Inhibit Zone From Start
- 3                      Horizontal Head Position After Home
- 4                      Mandrel Rod Protection
- 5                      Mandrel Rod Protection Zone Start
- 6                      Inside Wiper Installed
- 7                      Inside Wiper Zone Start
- 8                      Swing Away Inside Wiper Enable



## Manual

- 1                      Clamp Die Advance Timer
- 2                      Clamp Die Return Timer
- 3                      Pressure Die Advance Timer
- 4                      Pressure Die Return Timer
- 5                      PD Boost Advance Timer
- 6                      PD Boost Return Timer
- 7                      Inside Wiper Swing-In Timer
- 8                      Inside Wiper Swing-Out Timer
- 9                      Programmable Clamp Pressure
- 10                     Programmable PD Pressure
- 11                     Programmable PD Boost Velocity
- 12                     Programmable PD Boost Pressure
- 13                     Manual Feed Torque
- 14                     Manual Feed-Bend Torque
- 15                     Manual Rotate Torque



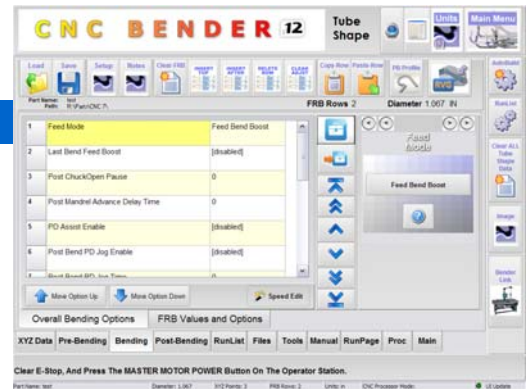
## PreBend

- 1 Mandrel Early Advance in PreBend
- 2 Mandrel Early Advance Safety OFF
- 3 Teach Mode Enable
- 4 SKIP Chuck Close/Open
- 5 AUTOMATIC Part-in-Collet Sensor
- 6 AUTOMATIC Chuck Close Mode
- 7 SKIP - Run Buttons
- 8 Seam Detect Mode
- 9 AutoLoader Arm Enable
- 10 AutoLoader Hopper Enable
- 11 Mandrel Check Enable
- 12 Preload – Radius Shift Away
- 13 Load – Radius Shift Away
- 14 Start – Radius Shift Away
- 15 Absolute Pre-Rotate Enable
- 16 Absolute Pre-Rotate Angle
- 17 PD Load Capture Enable
- 18 PD Load Capture Timer
- 19 Use Preload Position
- 20 Use Start Position For Load Position
- 21 Mist Lube
- 22 Mist Lube Duration
- 23 Mist Lube 2
- 24 Mist Lube 2 Duration
- 25 Safety Scanner Field Pair
- 26 Rotate to Start Angle
- 27 Rotate To Start Angle Speed
- 28 Use Clamp Plug
- 29 COMDEF to Run With Part
- 30 PreCommand Load Position
- 31 PreCommand Chuck Close Event
- 32 PreCommand Start Position



## Overall

- |    |  |
|----|--|
| 1  | Post Mandrel Advance Delay Time        |
| 2  | Feed Mode                              |
| 3  | Last Bend Feed Boost                   |
| 4  | Post Chuck Open Pause                  |
| 5  | PD Assist Enable                       |
| 6  | Post Bend PD Jog Enable                |
| 7  | Post Bend PD Jog Time                  |
| 8  | Cycle Hold - After All Mandrel Extends |
| 9  | Clamp Move Pressure                    |
| 10 | Programmable PD Move Pressure          |
| 11 | Programmable PD Boost Move Velocity    |
| 12 | Programmable PD Boost Move Pressure    |
| 13 | Dies Low Speed                         |
| 14 | Split Die Enable                       |
| 15 | Extra Horizontal Clamp Enable          |
| 16 | Dies Close Delay Enable                |
| 17 | Dies Close Delay Time                  |



## Feed

- |    |   |
|----|---|
| 1  | Feed Speed                                    |
| 2  | Avoidance Mode                                |
| 3  | Overfeed Distance                             |
| 4  | Feed / Rotate Mode                            |
| 5  | Recapture Mode                                |
| 6  | Recapture Arc Length Distance                 |
| 7  | Recapture Springback                          |
| 8  | Last Row Absolute Feed Clear - Enable         |
| 9  | Last Row Absolute Feed Clear - Position       |
| 10 | Last Row Absolute Feed Clear - Speed          |
| 11 | Last Row Absolute Feed Clear - Immediate Move |
| 12 | Last Row Absolute Feed Clear - Delay After    |
| 13 | Mist Lube                                     |
| 14 | Mist Lube Duration                            |
| 15 | Mist Lube 2                                   |
| 16 | Mist Lube 2 Duration                          |



## Rotate

- 1 Rotate Speed
- 2 Avoidance Mode (Pre Feed/Rotate)
- 3 Avoidance Mode Move (Degrees)
- 4 Avoidance Mode Speed
- 5 Avoidance Mode Finish Direction

## Bend

- 1 Bend Speed
- 2 Custom Bend Arm Return Speed Enable
- 3 Custom Bend Arm Return Speed
- 4 Bend Return Step Point (Degrees)
- 5 Mandrel Cycle Enable
- 6 Teach Mode Enabled
- 7 Feed Speed % Adjustment During Bend
- 8 Push Bending Profile Name
- 9 Push Bending – Post Bend Action
- 10 PDA-Realtime Variable Gearing Options
- 11 Bend Die Align Mode
- 12 Bend Die Align At Angle
- 13 Post Bend Jog Enable
- 14 Post Bend Jog Distance
- 15 Feed-Bend Feed Push Torque
- 16 Bend Stop Return Mode
- 17 Bend Stop Return Angle
- 18 Early Mandrel Forward At Return Angle
- 19 PD Retract Timer Enable
- 20 PD Retract Timer Milliseconds
- 21 PD/PD Boost Retract Method
- 22 PD/Clamp Close Method
- 23 PD/Clamp Open Method
- 24 Split Die Close Mode
- 25 Split Die Open Mode
- 26 Multiple Bend Mode
- 27 Multiple Bends - Manual Bend Count
- 28 Hitch Feed Enable
- 29 Hitch Feed Distance
- 30 Hitch Feed Speed
- 31 Hitch Feed Clamp Enable
- 32 Tool Action For Zero Deg Bend



- 33 Hold Mandrel Forward
- 34 Early Mandrel Extraction Enable
- 35 Early Mandrel Extract Zone
- 36 Mandrel Lube Enable
- 37 Mandrel Lube Start Angle Within
- 38 Mandrel Lube Stop Angle Within
- 39 Mist Lube Enable
- 40 Mist Lube Duration
- 41 Mist Lube 2 Enable
- 42 Mist Lube 2 Duration
- 43 High Speed Dies Open
- 44 Safety Scanner Field Pair
- 45 Cycle Hold Before- Before Dies Close
- 46 Cycle Hold Before- After Dies Close
- 47 Cycle Hold After- After Bend Completes
- 48 Cycle Hold After - After Dies Open
- 49 Cycle Hold After - After Clamp Die Opens
- 50 Cycle Hold After - After Pressure Die Opens
- 51 Cycle Hold After – After Post Bend Jog
- 52 Cycle Hold After - Before Bend Arm Return
- 53 Clamp Pressure
- 54 Programmable PD Pressure
- 55 Programmable PD Boost Velocity
- 56 Programmable PD Boost Pressure

## Radius Shift

- 1 Radius Shift Mode
- 2 Simultaneous Vertical / Horizontal Shift
- 3 Horizontal Radius Shift Offset
- 4 Radius Shift Delay
- 5 Radius Shift Away
- 6 Early Radius Level Change
- 7 Stair-Step Radius Change



## PostBend

- 1 Release Mode
- 2 Safety Scanner Field Pair
- 3 Unloader Conveyor Mode
- 4 Unloader Conveyor Duration
- 5 Wait At Unloader Full
- 6 Unloader Type
- 7 Unloader Pause After Grip Duration
- 8 PD Unload Capture
- 9 PD Unload Capture Timer
- 10 Bend Arm Motion After PD Release
- 11 Kicker Mode

