

CybTouch 6 W-G

Swing Shears & Adjustable Rake Angle Shears

User Manual V2.4c

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GETTING STARTED

GENERAL INTRODUCTION

This user manual is for the CybTouch 6 W (swing shear) – G adjustable rake angle (shear) numerical control (Dec. 2011).

Due to software evolutions and the shear controlled by the CybTouch (configuration/capabilities), the present manual may not fully correspond to the CybTouch that you currently have. However, differences are only minor.

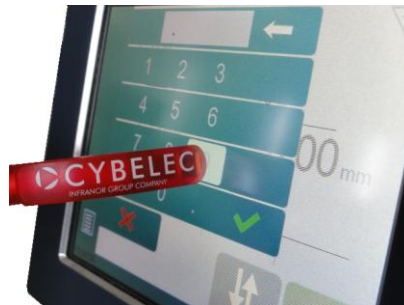
Touchscreens are pressure sensitive.

Do not press down hard on the screen.

Pressing on the screen hard will damage the display. Such damage is not covered by manufacturer warranty!




Do not use sharp and/or pointed objects (sheet metal, screwdriver, metal pen ball, etc) to touch the screen; only use your fingers (with or without gloves on) or a plastic pen. Make sure that your gloves do not have metal particles incrustrated in the finger tips as they may also damage the screen.



Take a few minutes to practice pressing gently on the screen, you will find that the screen is very reactive and it is pleasant to use.


Screen Cleaning

To clean the screen while the CybTouch is on, touch the  button. Use only a damp and soft cloth with soap or a neutral detergent.

NEVER use solvent, petrol, benzene, alcohols, etc!!

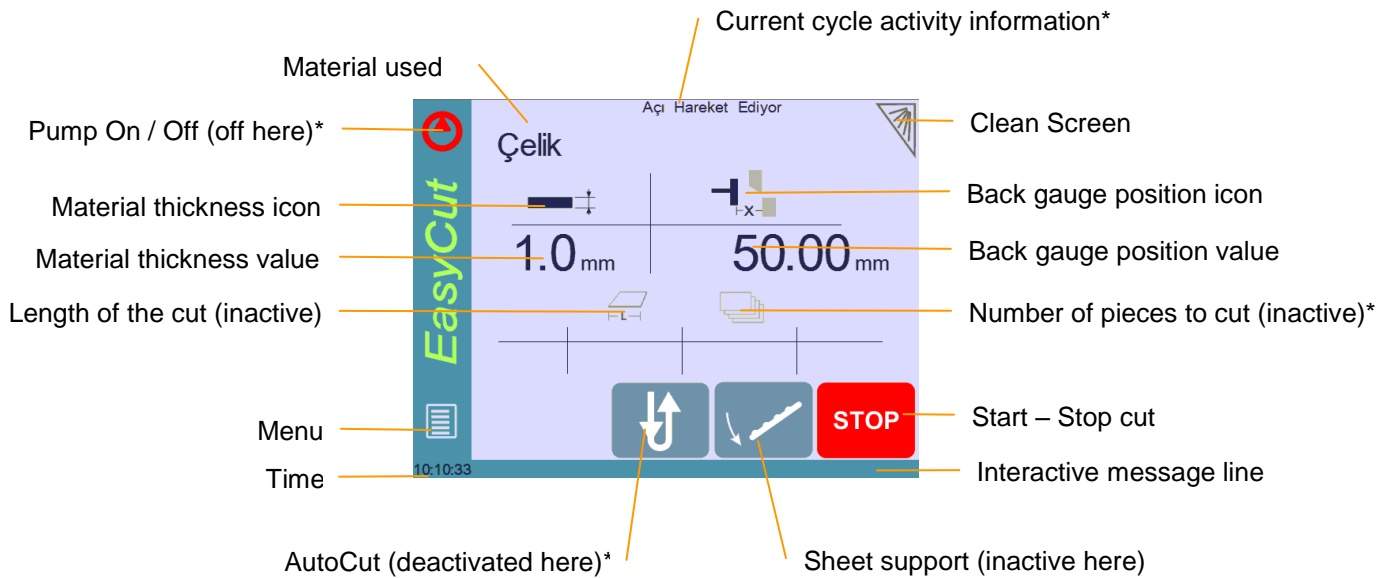
SELECTING YOUR LANGUAGE

To choose your language, please follow the below steps:

1. Touch the **Menu** button .
2. Touch **Other menus**.
3. Touch **User preference**.
4. Touch **Language** and select your language in the list.

USING EASYCUT PAGE


BASIC SCREEN DESCRIPTION



*Only available if the machine is equipped with this option, or if the option was configured upon machine setup.


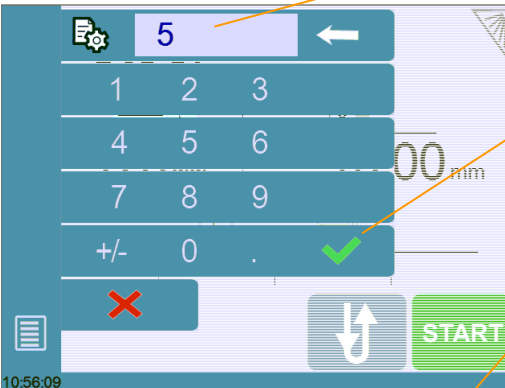


STARTING THE PUMP MOTOR

Touch the **Pump motor** button  for 2 seconds if it is available on screen.

Once the motor is running the button becomes red .

If the **Pump motor** button is not available on the screen, start the main pump motor using the adequate button on the machine.

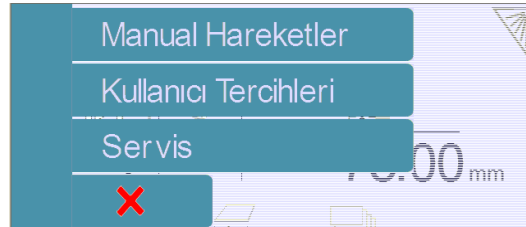
MAKING A BASIC CUT WITH EASYCUT PAGE

- 
1. Touch the **Material** field to chose the material type used.
 2. Touch the **Material thickness** value.
 3. Enter the material thickness.
- 
4. Validate.
 5. Touch the **Back gauge position** value and enter the value using the keyboard.
- 
6. Touch **START** or briefly press the foot-pedal to position the back gauge.
When the machine is ready, the **START** button displays **OK**. The machine will not cut until **OK** is displayed:
- 
7. Press the foot-pedal to make the cut.

PROGRAMS

PROGRAM MENU

In EasyCut page, touching the **Menu**  button opens the below program menu:



What is a program?

- A program is a set of different sequences (cuts) that should be executed one after the other in order to obtain a complete part.
- A program can be stored in memory and can be recalled again later for a same job order.
- A program can be deleted once it becomes obsolete.
- A program can be executed without the need to store it if this program will be executed only once.
- A program can contain up to 24 sequences.
- The material setting page of a program (the initial page of the program) is commonly called "Sequence 0".

New program choice clears the previous program currently in the working memory, and jumps directly to the sequence 0, ready for the operator to enter data for the new program.

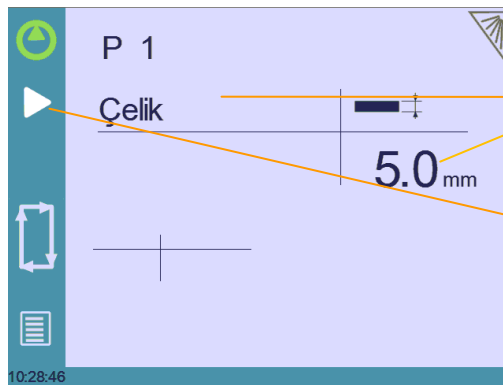
Current program choice jumps to sequence 1 of the last executed/programmed program.

Call program choice displays the table of contents for stored programs.

CREATING A BASIC NEW PROGRAM

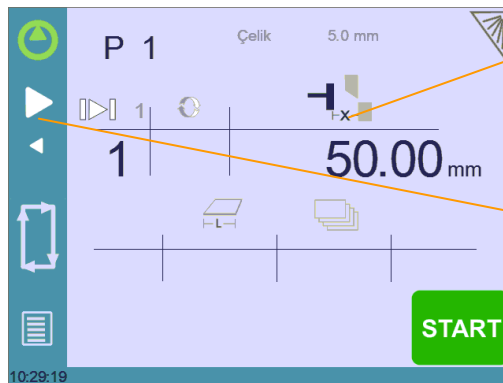
Touch **New Program** in the program menu to begin creating a new program. Here we will create a program with two sequences:

PAGE 1 OF PROGRAM - SEQUENCE 0, BASIC PROPERTIES FOR THE PROGRAM:



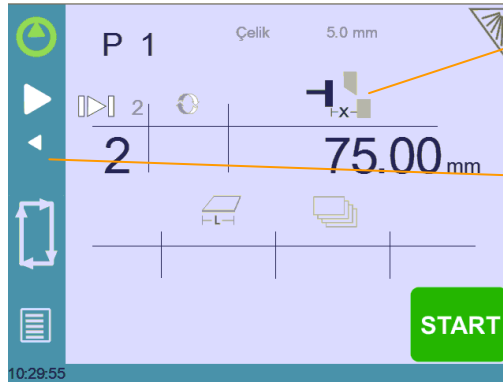
1. Choose the material and its thickness like in the EasyCut page.
2. Touch the **Next page** button, and validate to create a new step.

PAGE 2 OF PROGRAM - SEQUENCE 1, PROPERTIES FOR FIRST CUT OF THE PROGRAM:



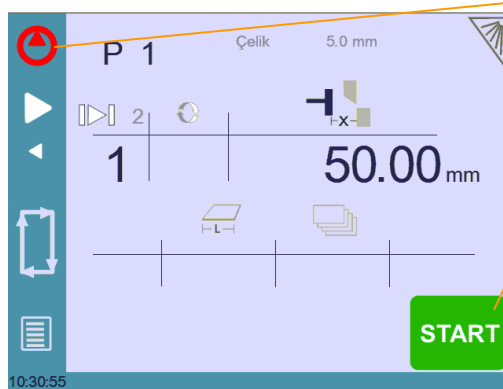
3. Touch the **Back gauge** position value and enter the value using the keyboard.
4. Touch the **Next page** button.

PAGE 3 OF PROGRAM: SEQUENCE 2, PROPERTIES FOR SECOND CUT OF PROGRAM:



5. Touch the **Back gauge position** value and enter the value using the keyboard.

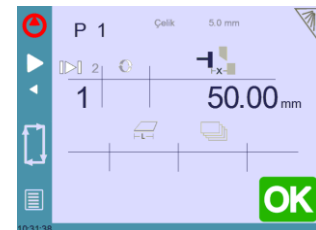
6. Go back to the first sequence created by touching the **Previous page** button.



7. Turn on the pump, by touching the **Pump On – Off** button for 2 seconds (or using the button directly on the machine).

8. Touch the **START** button or briefly press the foot-pedal to position the back gauge.

When the machine is ready, the **START** button displays **OK**. The machine will not cut until **OK** is displayed:



9. Press the foot-pedal to execute the program.

Note: Up to 24 sequences can be added to a program.

After completing the cuts, you can save the program by touching the **P0** field (program number) and giving the program a number so that you can use it again later.










EXTRA CUTTING FEATURES














There are various other features to help the operator to perform tasks.







These features can be used in both in EasyCut mode or for programs.

The below table regroups and describes all buttons and features available on the CybTouch 6:

**Functions with an asterisk (*) are not available on all machines, depending on the CybTouch version and the machine type.*

Icon / Button	Description
 Pump Off*	The pump is off, to turn it on touch this button for 2 seconds, it will become red.
 Pump On*	The pump is on, to turn it off touch this button for 2 seconds, it will become green.
 Clean Screen	Touching the Clean Screen button deactivates the screen for 8 seconds, giving the operator time to clean the screen with a damp cloth with neutral soap or detergent.
 Menu	Touching the Menu button in EasyCut page opens the program menu. Touching the Menu button in the program page allows the operator to access the EasyCut page and the other menu pages.
 Material thickness	Touching the Material thickness button or icon allows the user to enter the thickness of the material.
 Next page	The operator can use this button to go to the next page in a program or menu.
 Previous page	The operator can use this button to go to the previous page in a program or menu.
 Sequence	Only available in program mode. By touching this button, the operator can insert a sequence after the selected sequence in a program (or delete the selected sequence). The small number next to this button displays the total number of sequences in the program.
 Back gauge	The Back gauge icon is active; pressing the back gauge value below the icon allows the operator to change the back gauge position. Touching this icon will hide the back gauge value and park the back gauge at the end of the machine, for cuts which do not require a back gauge.

 <p>Back gauge foldaway</p>	<p>The back gauge is parked and is not used. This function is used for cuts which do not require a back gauge.</p>
 <p>Cutting length</p>	<p>The cutting length can be activated or deactivated by touching this button. The operator can enter a cut length value by touching the value below this button. The value is expressed in sec for a fixed angle shear and in mm for a variable angle shear.</p>
 <p>Piece counter</p>	<p>The operator can enter a number of parts to be cut by touching this icon and entering a value.</p>
 <p>AutoCut* Off</p>	<p>The AutoCut function is off, to switch it on the operator can touch this button. This feature is only available in EasyCut mode.</p>
 <p>AutoCut* On</p>	<p>The AutoCut function is on. This function allows the operator to continuously cut simply by keeping the foot pedal pressed down. If the pedal is released, the AutoCut function is set to Off.</p>
 <p>Repeat sequence (CY)</p>	<p>Only available in program mode. Touching this button allows the operator to define a number of times the selected sequence shall be repeated in the cycle.</p>
 <p>Blade gap*</p>	<p>This icon and the value below represent the blade gap. In general it cannot be changed and is calculated automatically according to the material and material thickness. On some machines however the value can be modified by the operator within a limited tolerance.</p>
 <p>Cut offset*</p>	<p>Touching the Cut offset icon or the value below it allows the operator to enter an offset for the cut. This function is only available on adjustable angle shears. When activated the blade stops when it reaches the offset position.</p>
 <p>Sheet support* Off</p>	<p>Sheet support is deactivated; touching this button will activate the sheet support.</p>
 <p>Sheet support* On, 2 positions</p>	<p>Sheet support 2 positions is activated; touching this button will deactivate the sheet support.</p>
 <p>Sheet support* On, 3 positions</p>	<p>Sheet support 3 positions is activated; touching this button will deactivate the sheet support.</p>
 <p>Return to sender* Off</p>	<p>The Return to sender function allows the operator to retrieve the piece after the cut without walking around the press, by making the back gauge move towards him, thus pushing the piece towards him. The Return to sender function can only be activated if the sheet support is activated.</p>
 <p>Return to sender* On</p>	<p>The Return to sender function is activated; it will become red as soon as the cut is finished and the Return to sender function is ready to be used.</p>

 <p>Return to sender* ready</p>	<p>The Return to sender function is ready; the operator can press and hold this button as long as needed to make the back gauge move the cut piece towards him in order to retrieve it. A specific button can be added to the machine to use the return function.</p>
 <p>Blade retraction* off</p>	<p>Blade retraction is off. The back gauge will not pull back up after a cut. Touching this icon activates the back gauge retraction.</p>
 <p>Blade retraction* on</p>	<p>Blade retraction is on. The back gauge will pull back up after the cut. Touching this icon deactivates the back gauge retraction.</p>
 <p>Move beam down</p>	<p>This icon is inactive; to move the beam the operator must press on the pedal in manual mode. Depending on the machine, the beam may rise up automatically or not when the pedal is released.</p>
 <p>Move beam up</p>	<p>The operator can move the beam up in manual mode by touching this button.</p> <p>By entering a value in the field next to this icon, the operator can move the beam up in short steps.</p>
 <p>Cut angle*</p>	<p>The cut angle can be defined by the operator on adjustable angle shears.</p>

USING CURRENT PROGRAM

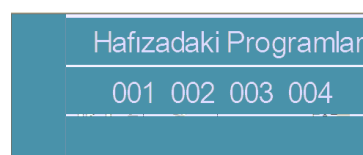
Touching **Current program** opens the last program in the working memory. This is especially useful when an operator is cutting series of sheets with a program and another colleague needs to quickly cut one or two sheets.

When this situation occurs, the operator simply touches the **Menu** button and then **EasyCut**. He can then leave the machine for the colleague to work with the EasyCut page.

Once the colleague has finished his short job, the operator simply touches the **Menu** button and **Current program** in order to return to his program and continue his work (even if the program has not been saved in memory).

CALLING A SAVED PROGRAM

In the program page, touch the program name, and then touch **Call program**. A list of programs saved in the memory is displayed. Touch the one that you need, it will immediately be loaded in the working memory, ready to be used.



OTHER MENUS

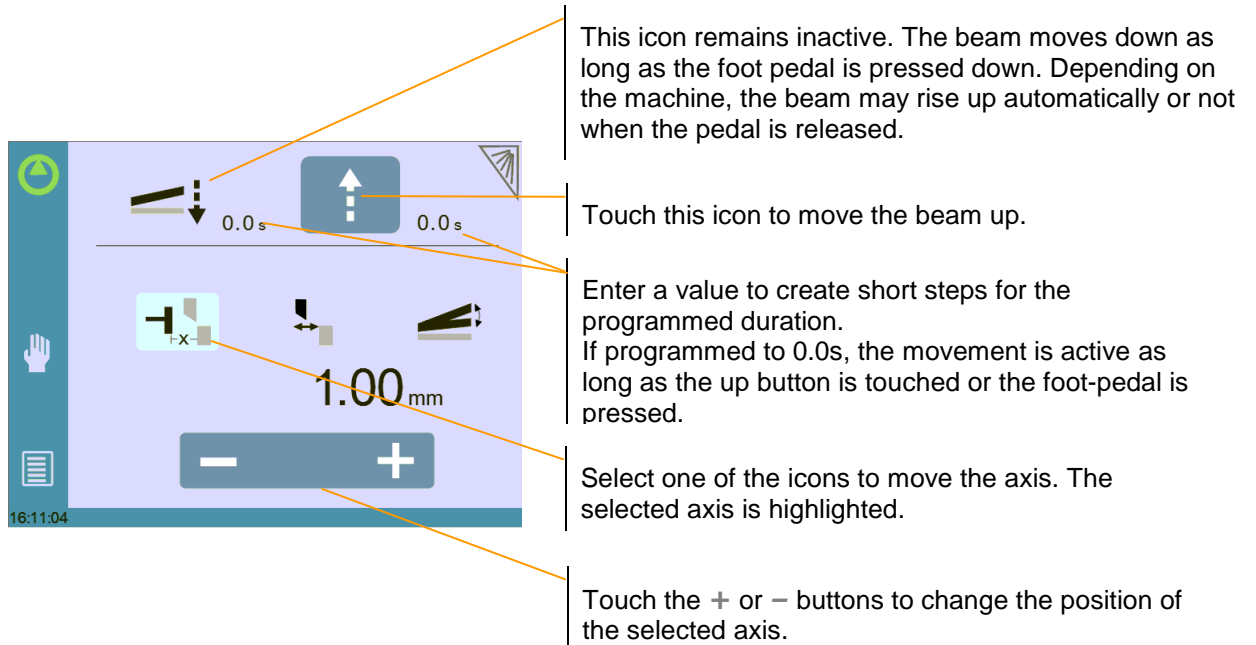
Touching **Other** displays the menu below:



MANUAL MOVEMENT

Touching **Manual movements** in the **Other** menu displays the below page.

This page allows the operator to manually move the axes and functions.



USER PREFERENCE

Touching **User Preference** displays the following menu:



Language

Touch **Language** and select your language in the list.

Event Viewer

Allows the operator to view a log file to trace problems. Usually requested and used by a technician to solve any possible problems.

Touchscreen Calibration

Allows the touchscreen to be calibrated. To be more precise, it is recommended to use a plastic pen tip and gently touch the center of each cross when asked.

Set Clock

Allows the user to set the time and date on the CybTouch.

AutoCut TDC Time

Waiting time (max 2 seconds) at top dead center between 2 cuts in AutoCut mode. Used to give enough time to the operator to position the sheet against the back gauge before the blade comes down again.

Brightness xx% Eco xx


Screen brightness adjustments for normal and Eco mode.

Length units

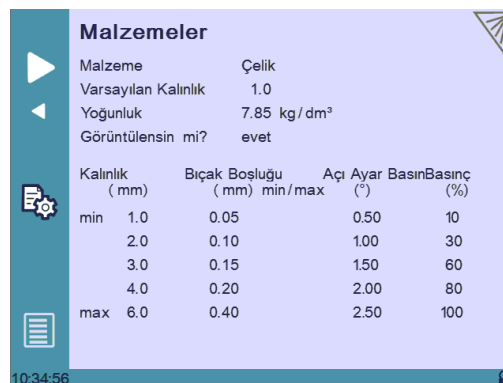
Chose between mm and inches.

Materials

To access the Materials page, from the EasyCut page touch the **Menu** button, touch **Current Program**, touch the **Menu** button again, and touch **User Preferences**. Now scroll to the next page by touching the  button, then touch **Materials**.

Enter the required access code using the numerical pad, followed by .

The Materials page is displayed:




Malzemeler				
Malzeme	Çelik			
Varsayılan Kalınlık	1.0			
Yoğunluk	7.85 kg/dm³			
Görüntülensin mi?	evet			
Kalınlık (mm)	Bıçak Boşluğu (mm)	Açı (°)	Ayar Basın (%)	Basınç (%)
min	1.0	0.05	0.50	10
	2.0	0.10	1.00	30
	3.0	0.15	1.50	60
	4.0	0.20	2.00	80
max	6.0	0.40	2.50	100

Here the default characteristics for each material can be changed, or a new material and its corresponding characteristics can be configured in the CybTouch:

- **Material:** Selected material name (here **Steel**).
- **Default thickness:** Default thickness for the material (here **1.0** mm) when you call the material.
- **Displayed:** determines whether the material shall be available to be selected or not for use (here **yes**).
- **Thickness/Blade gap/Cutting angle/min – max:** Determines the default blade gap and cutting angle used according to the thickness of the material.

Three predefined default materials are available (steel, stainless steel, aluminum).

Other materials can be added. To add a material, simply touch  until an empty page is displayed (**called Material_X**), and then enter the values for the material to be created, as mentioned above.

If an operator wishes to be able to modify the blade gap in order to improve the quality of the cut, a range of tolerated values must be entered (using the **min/max** column).

After the **Blade gap** column, there is a **min/max** header. Touching this header displays two columns (min and max). For each blade gap defined by the manufacturer, a range of tolerated values can be defined for the operator.

The values entered here must prevent any programming errors and be in accordance with the machine. By activating this feature, the blade gap is automatically displayed in the working pages.

Kalınlık (mm)	Bıçak Bosluğu (mm)	min/max		Basınç (%)
		min	max	
min 1.0	0.10	0.05	0.12	10
2.0	0.10	0.05	0.15	30
3.0	0.15	0.15	0.20	60
4.0	0.20	0.15	0.30	80
max 6.0	0.40	0.25	0.40	100

SERVICE

Touching **Service** in the **Other** menu displays the **Service** menu below. A key code will be requested. Enter the service code and press **Enter**.

Eksen Ayarları -X-	50.00mm
Bakım	
Bilgi	
Makine Durumu	evet

AXIS SETTING --X--

Allows the position of the back gauge to be set. This operation is not necessary if the back gauge is configured to search for the index at machine start up.

MAINTENANCE

The **Maintenance** screen displays the free memory space in the CybTouch and the fragmentation rate. The Maintenance screen is also used for the following actions:

- **Formatting memory:** Only use this with a technician's help.
- **Creating internal data backups** Machine parameters and axis parameters. Usually only performed by a service technician when the machine is finished being setup and is ready to operate.
- **Restoring** machine parameters and axis parameters.
In case of accidental machine parameters modification, this operation allows the machine owner to retrieve the original machine set up.

Simply touch **internal backup** and select the action you need to **perform**; you will need an access code.

All the above actions require codes and should only be performed by technicians or upon request of a technician.

INFORMATION

Touching **Information** displays all information regarding:

- Hardware
- Boot version
- RF link (Radio Frequency link)
- HMI (Human –Machine Interface)
- Real Time

Touching the **Advanced** button  displays more detailed information.

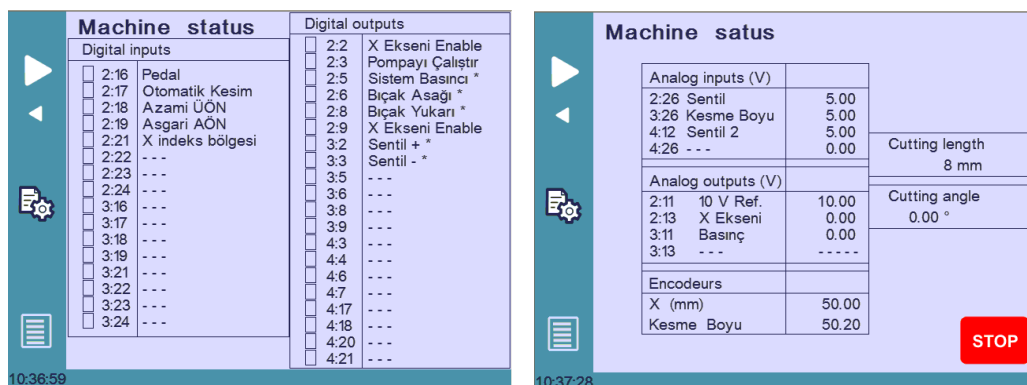
MACHINE STATUS

Choose **Yes** or **No** to make the machine status screen accessible or not while working. This allows the operator to display the inputs and outputs while the machine is working. This can be requested by a technician to help determine a problem in the working process.

Once the machine status is set to **Yes**. The operator can access the Machine status page by touching the area in red showed below in the screen, from any page in the CybTouch.



The two machine status pages are now available and can be viewed by touching :



INFORMATION AND ERROR MESSAGES

Below is a list of warning and error messages which may be displayed in the interactive message line:

- Information messages are on a **green background**, they will disappear automatically.
- Error messages (machine or NC errors) are on a **red background**. They inform the user of an error occurring on the machine or NC, and sometimes require intervention by the end user or a technician.

INFORMATION MESSAGES	
10 //Döngü işlemede	The operator touched the screen while a cycle is running (the screen is inactive except the STOP button).
15 //Otomatik Kesim girişi yok	The automatic cut input is configured but not active. It must be active to enable the AutoCut function in the EasyCut page. Usually a switch or key switch is used to enable this function.
18 //Boş Alan	Operator did not enter a value.
19 //G/Ç İçin 24V Besleme Gerilimi Aktif	24V to the inputs/outputs is now available.
29 //Liste Sonu	End of list reached. Scroll backwards.
32 //Veri girişi devam ediyor...	Operation impossible: data entry in progress. Please finish entering data and try again.
35 //Erişime izin yok	Operator needs to enter a different password.
43 //"OGG hazır" girişi bekleniyor	A switch makes sure the sheet support is in the correct position for the operator to move the backgauge to retrieve the cut part. Check the sheet support position, it must be fully up. Otherwise check the RTS switch.
44 //AsgAÖN sınıra ulaşıldı	Minimum BDC limit has been reached, down stroke has been stopped. This may occur in manual mode. If this message appears often In normal cutting operation, the machine parameters need to be readjusted.
ERROR MESSAGES	
03 //Buffer Full	The part-program memory is full, cannot add another sequence.
04 //Kod Kabul Edilmedi	The password to access the selected page is not correct. Enter the correct password.
05 //Dosya Uyumlu Değil	The loaded part-program is incompatible with the NC. This part should be deleted.
06 //Makine parametresi dosya hatası	This file is corrupt. Try to restart the NC. If the problem persists, format the memory. Before formatting memory, make sure with your dealer that original parameters backup is available.
07 //Makine parametresi uyumsuz, lütfen diskini biçimlendirin.	A software update has been made over a much older version, the original parameters are no longer compatible. Or uploaded parameters (with RFlink) are much older or newer than the current software version, and are not compatible. A new start up of the machine must be made. Contact your dealer.
11 //Dosyaya Yazma Sorunu	This file is corrupt and cannot be saved. Try to restart the NC. If the problem persists, format the memory. Before formatting memory, make sure with your dealer that original parameters backup is available.
12 //X asgari sınırın altında	The operator entered a value under the limit or a memorized value in the program is under the limit. Change value.
13 //X azami sınırın üzerinde	The operator entered a value over the limit or a memorized value in the program is over the limit. Change value.
15 //"AÖN asg" girişi aktif	Min BDC has been reached, cannot descend more.

19 //Sac destek X güvenliği	A safety zone is defined while using the sheet support. The sheet support can't be used while X is programmed in that zone.
20 //Döngü Tekrarı = 0	Cannot start cycle because repeat cycle function is set to "0".
21 //Malzeme tanımlı değil (en az bir malzeme tanımlamalısınız)	No materials programmed in the Material pages (in User preferences). A material must be programmed and selected to perform calculations.
25 //No FAST task running []	Switch OFF the machine for 1 min and restart it.
28 //G/Ç 24V yok veya Aşırı Akım (çıkışlar korumada)	Inputs/outputs 24V power supply is no longer present or an output is overloaded. Reset any safety device on the machine, and check that protection grids and rear guards are closed, etc. If problem persists, switch machine OFF for 3 min and restart again. If problem still persists check the machine manual and/or ask a service technician to check your machine.
30 //Touch Screen error, code []	Contact your machine dealer with this specific code and details.
31 //Bu kalınlık için geri çekilme zorludur	Cannot disable retraction because the selected material is too thick.
32 //Çevrim tamamlanmadan önce pedal bırakıldı	Cutting length is programmed and operator released the foot pedal before the cutting length was reached. In such case, the cut is considered as not finished. In a program, when cutting length is programmed, keep pedal pressed until the beam automatically returns.
33 //XML dosyasında yazı hatası	This file is corrupt and cannot be used. Try to restart the NC. If the file is a part-program, try to delete it.
34 //Memory allocation problem (xml)	May be displayed when loading an element (part-program, parameter, etc.) and memory is almost full.
35 //Endless loop on process task	Process Error. Please restart the NC and inform your dealer.
39 //"Pedal" girişi reddedildi	Pressing the pedal is not accepted in this page/situation.
41 //Açı < asg.açı	The calculated cutting angle is smaller than the maximum machine limits. Check the Material page, none of the angle values must be under/over the machine parameter limits.
42 //Açı > azm açı	The calculated cutting angle is larger than the minimum machine limits. Check the Material page, none of the angle values must be under/over the machine parameter limits.
44 //"Harici Stop" girişi aktif	An external stop may be caused by safety devices, emergency buttons, rear protection guards, etc. Check machine instructions.
58 //Fw Axes Error 32 [Trajectory tracking error]	Regulator error. The axis could not follow its trajectory. May be due to higher friction, resistance or an obstacle on the axis movement. May also be a drive problem. Contact a technician.
66 //Fw Axes Error 33 [Maximum voltage time exceeded (10V)]	Regulator error. The axis could not follow its trajectory. May be due to higher friction, resistance or an obstacle on the axis movement. May also be a drive problem. Contact a technician.
67 //Fw Axes Error 39 [Speed tracking error]	Regulator error. The axis could not follow its trajectory. May be due to higher friction, resistance or an obstacle on the axis movement. May also be a drive problem. Contact a technician.
69 //Dikkat! Makine indeksli değil. Limitler Doğru Çalışmaz!	Before the machine is indexed, the NC doesn't know where the axes are. In manual page, movements are authorized but the electronic stroke limits are not activated. Operator is responsible for stopping axis movement before mechanical limit is reached.
70 //Sentil sinir disisi	When a movement is attempted, the blade gap is out of machine limits. Check the Material page. Check the Material page, none of the angle values must be under/over the machine parameter limits.