

Pega 244N With 04PC Machine Programming Limits

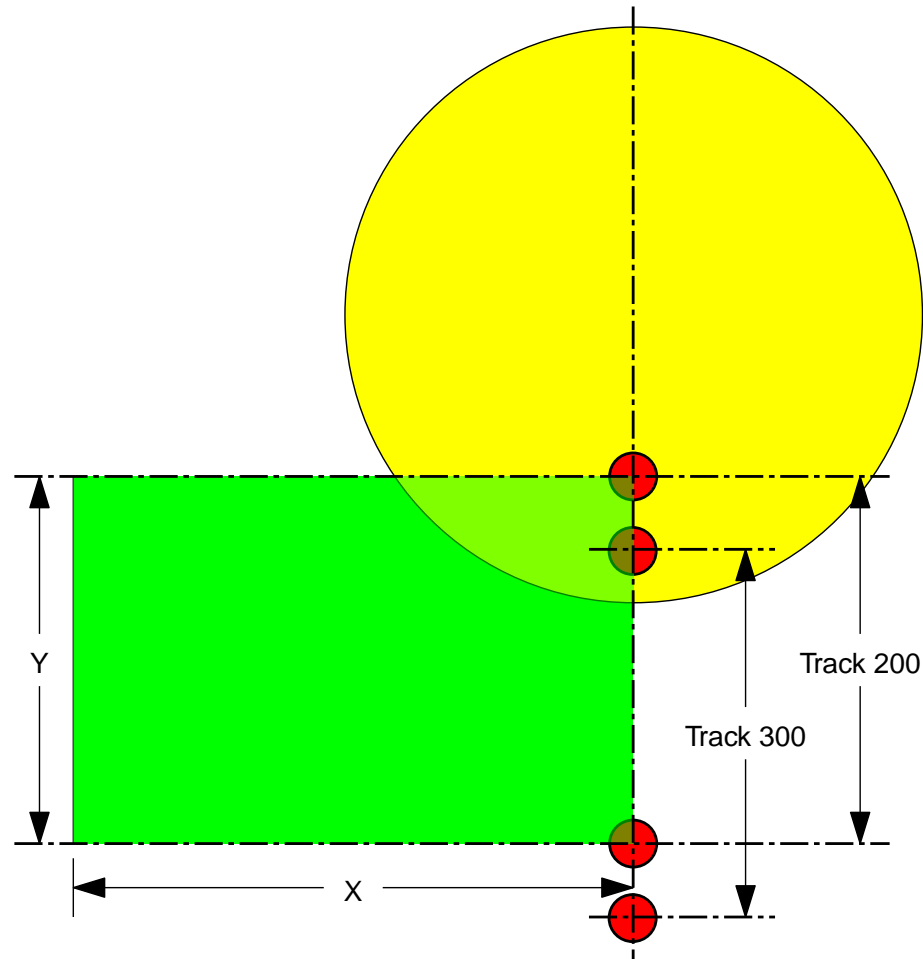


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Programmable Travel Limits



Origin Statement		X-axis Movable Distance	Y-axis Movable Distance By Track Numbers	
X-axis Origin	Y-axis Origin		Center Track 200 Stations	Outer Track 300 Stations
40.000"	40.945"	-.394" to 40.394"	-.394" to 41.399"	-1.969" to 39.764"

Programmable Feed Rates

Punching Mode

F1 = X1968. IPM Y1968. IPM

F2 = X1476. IPM Y1476. IPM

F3 = X984. IPM Y984. IPM

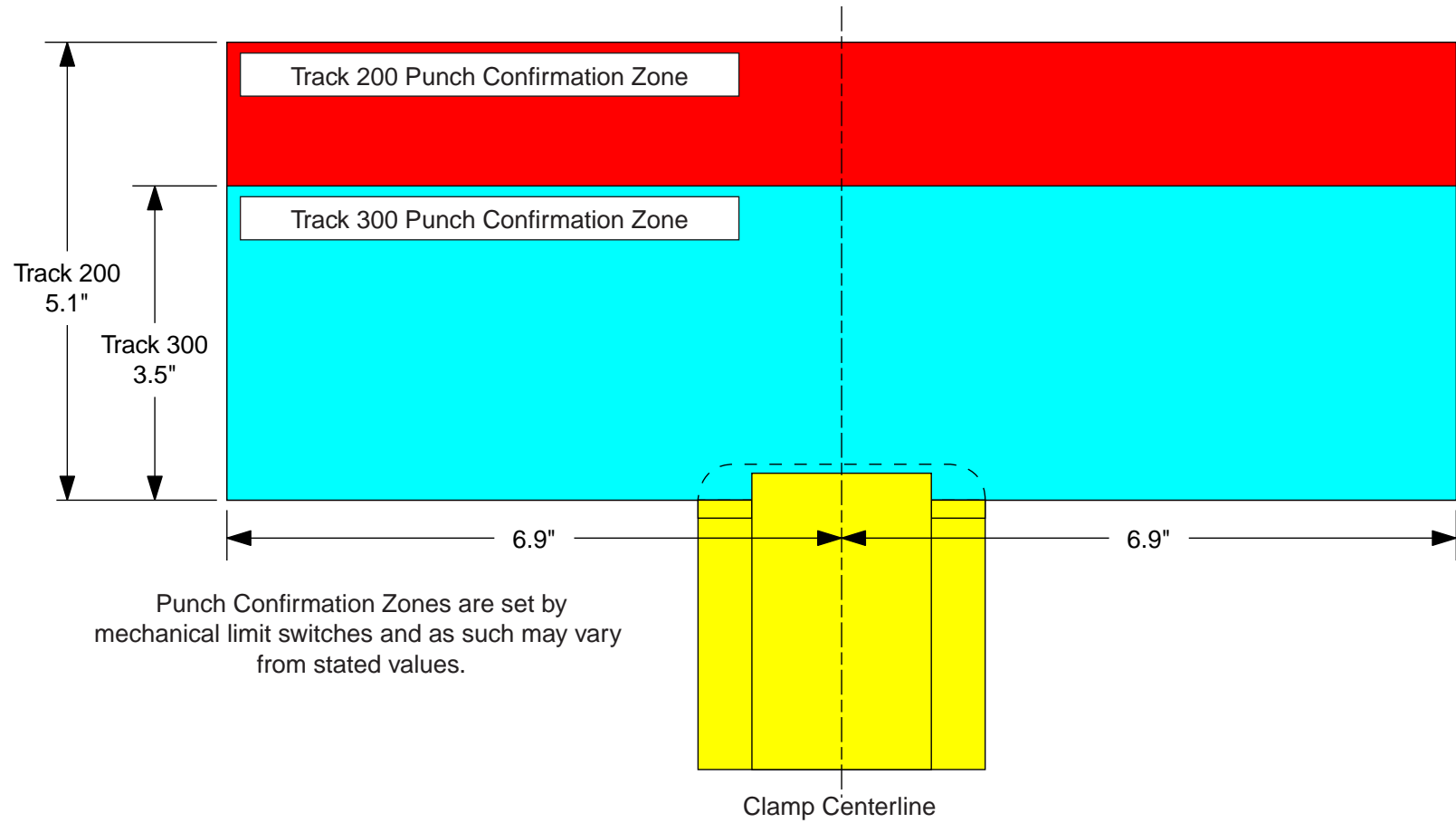
F4 = X492. IPM Y492. IPM

Punch Confirmation Area / Punching Dead Zone.

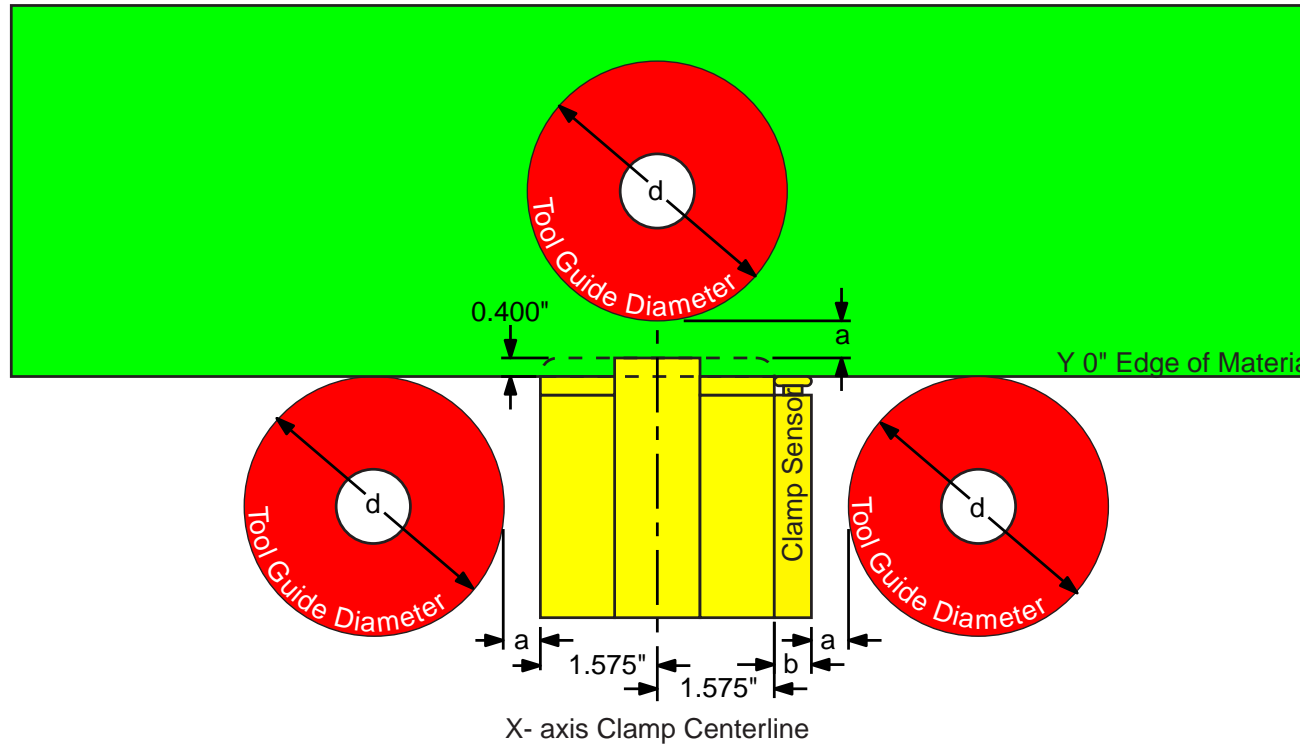
Definitions

- Confirmation Zone = An area that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton.
- Punch Dead Zone = An area that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton. Punching in this area with standard tools may damage the material, material clamp, tool, other machine components and may cause operator injury.

Punch Confirmation Area



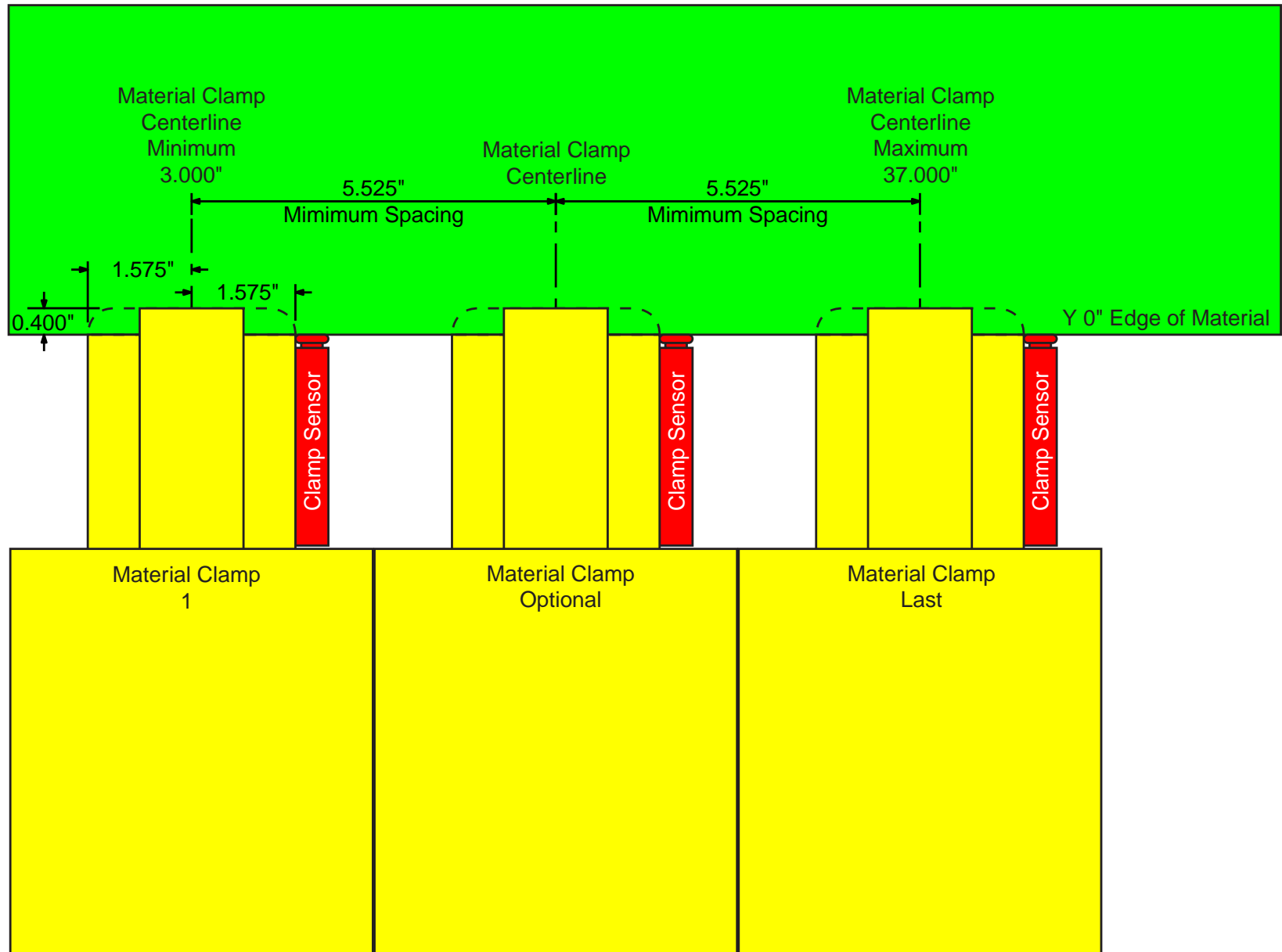
Punching Dead Zone.



Clamp Dead Zones "areas where the punch will contact the material clamp" are calculated in the following manner.		
X-axis	To the left of the clamp	Clamp position -1.575" - a - d/2
	To the Right of the clamp	Clamp position +1.575" + a + b + d/2
Y-axis	.400" + a + d/2	

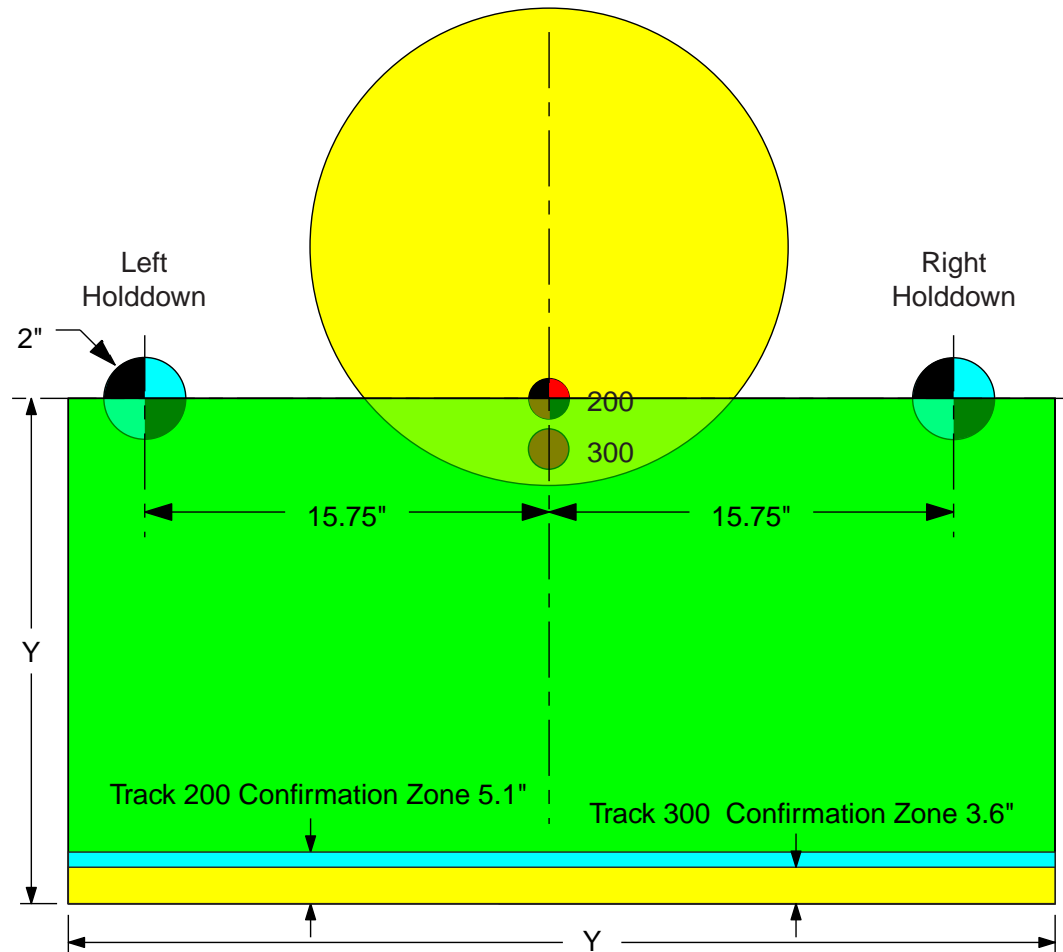
b=	.500"		
a=	.500"		
d=	Station Size	A	1.020"
		B	1.883"
		C	3.500"
		D	4.938"
		E	6.250"

Material Clamp Locations

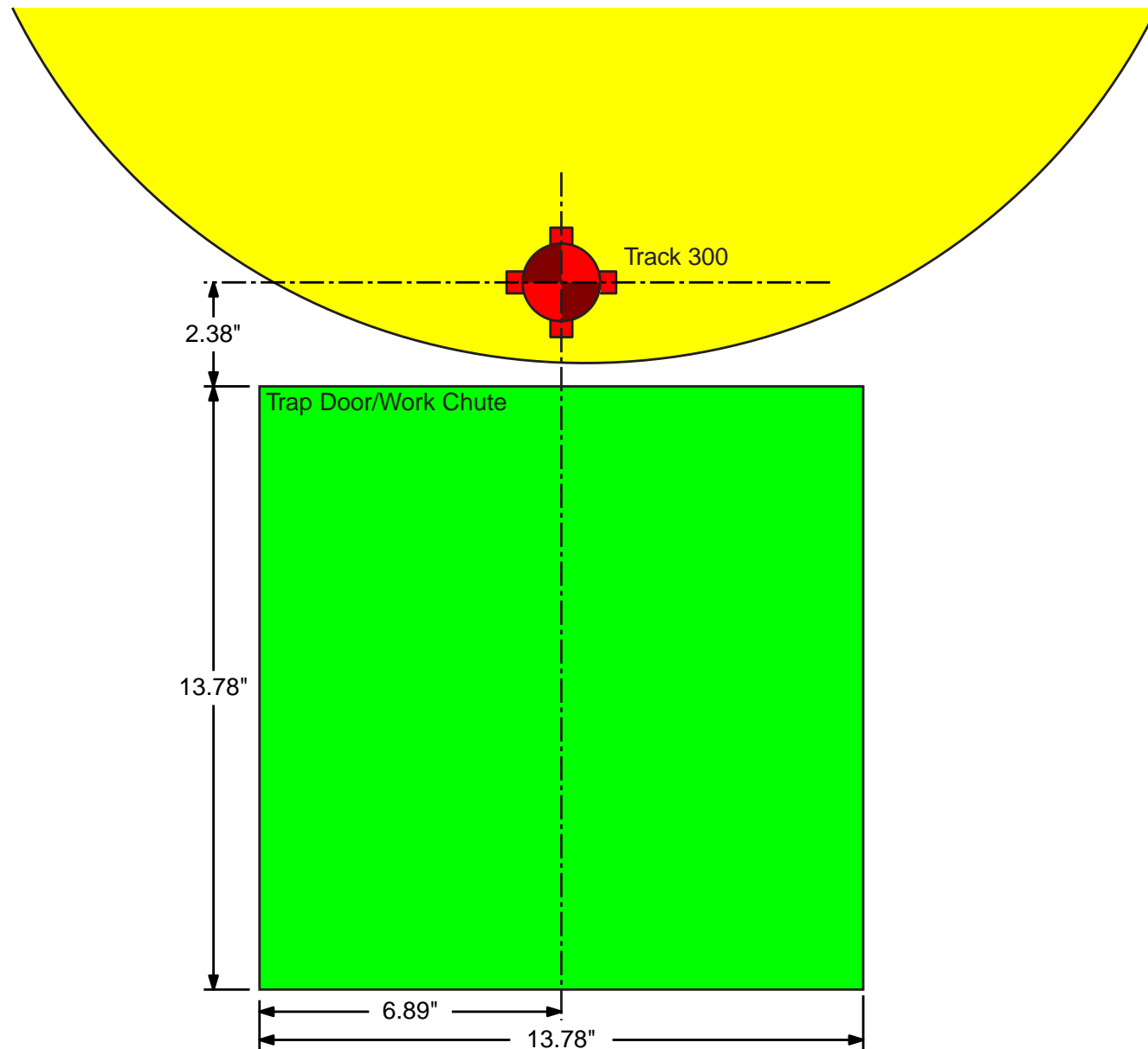


Reposition Limitations

When repositioning within a Confirmation zone the Confirmation Button must be pressed to initiate the reposition cycle, as the material clamps could collide with the repositioning cylinders.

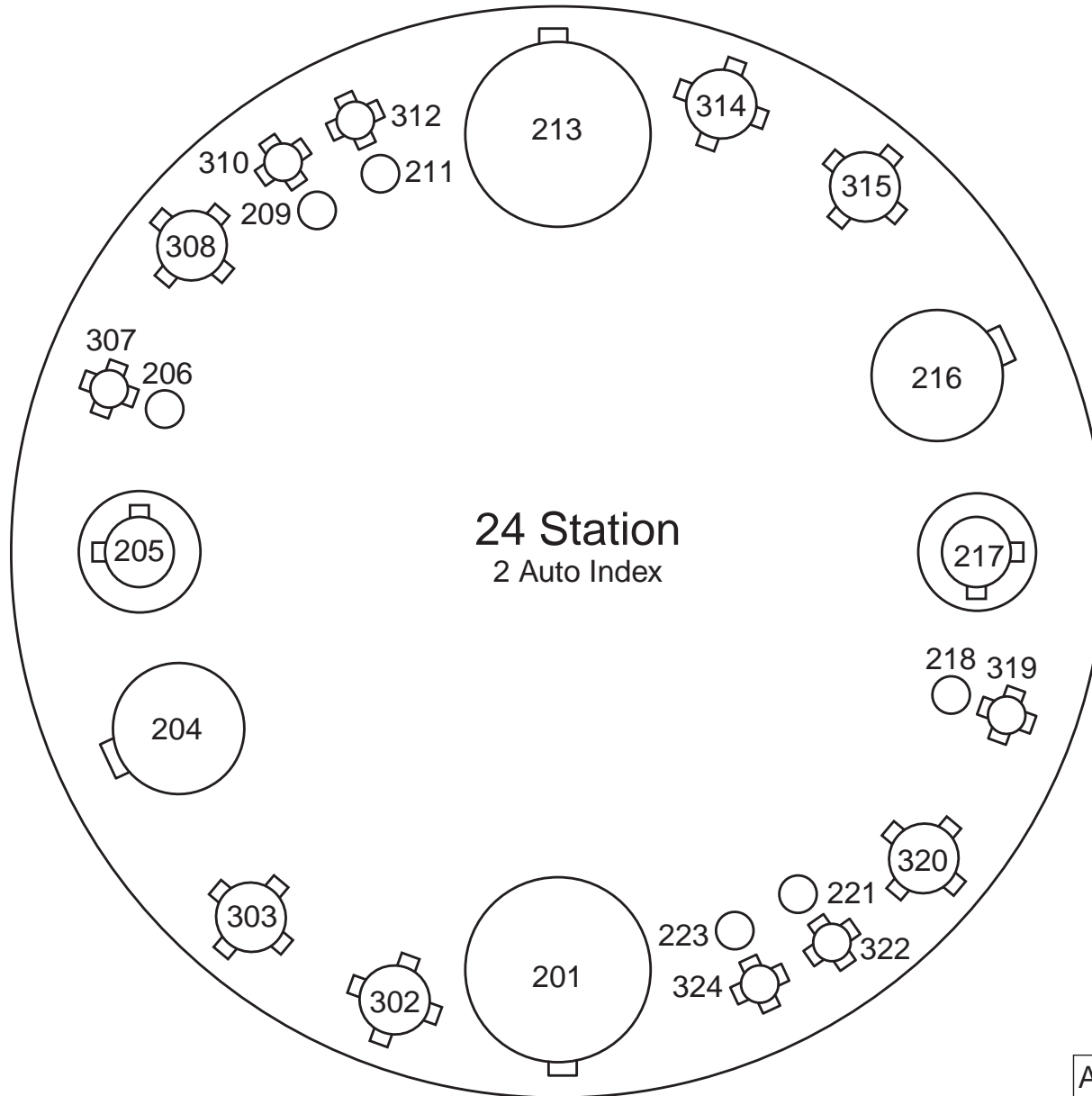


Work Chute / Trap Door



Turret 740mm Disk Thick 24 Station 2 Auto Index

This turret configuration used on the following machine models
Pega 244



	Maximum Size Round		Number Of Stations (Keyed)
A	½"	12.7mm	12 (6)
B	1¼"	31.7mm	6 (6)
C	2"	50.8mm	2 (2)
D	3½"	88.9mm	2 (2)
Auto Index	B	1¼"	2 (2)