

# Vipros 255 Machine Programming Limits



LAPIS SERVICES, INC.  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

Amada America Inc.  
7025 Firestone Blvd.  
Buena Park, CA 90621  
Phone: 714-739-2111  
Fax: 714-739-4099  
Email [info@amada.com](mailto:info@amada.com)

# Table of Contents

Programmable Travel Limits .....3

Programmable Feed Rates .....4

    Punching Mode .....4

    Contouring Mode .....4

Punch Confirmation Area / Punching Dead Zone .....5

    Definitions .....5

    A Size (1/2") Station .....6

        A Size Track 200 Stations .....6

        A Size Track 300 Stations .....7

    B Size (1 1/4") Station .....8

        B Size Track 200 Stations (Auto Index only) .....8

        B Size Track 300 Stations .....9

    C Size (2") Station .....10

        C Size Track 200 Stations .....10

        C Size Track 200 Stations Auto Index .....11

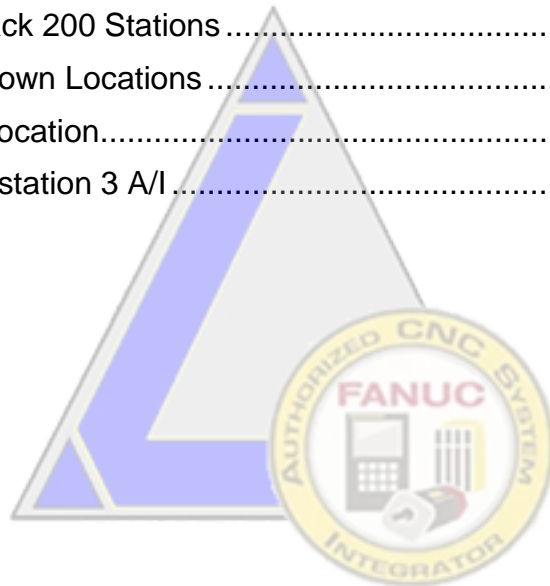
    D Size (3 1/2") Station .....12

        D Size Track 200 Stations .....12

Reposition Holddown Locations .....13

Material Clamp Location .....14

Turret Layout 31 station 3 A/I .....15

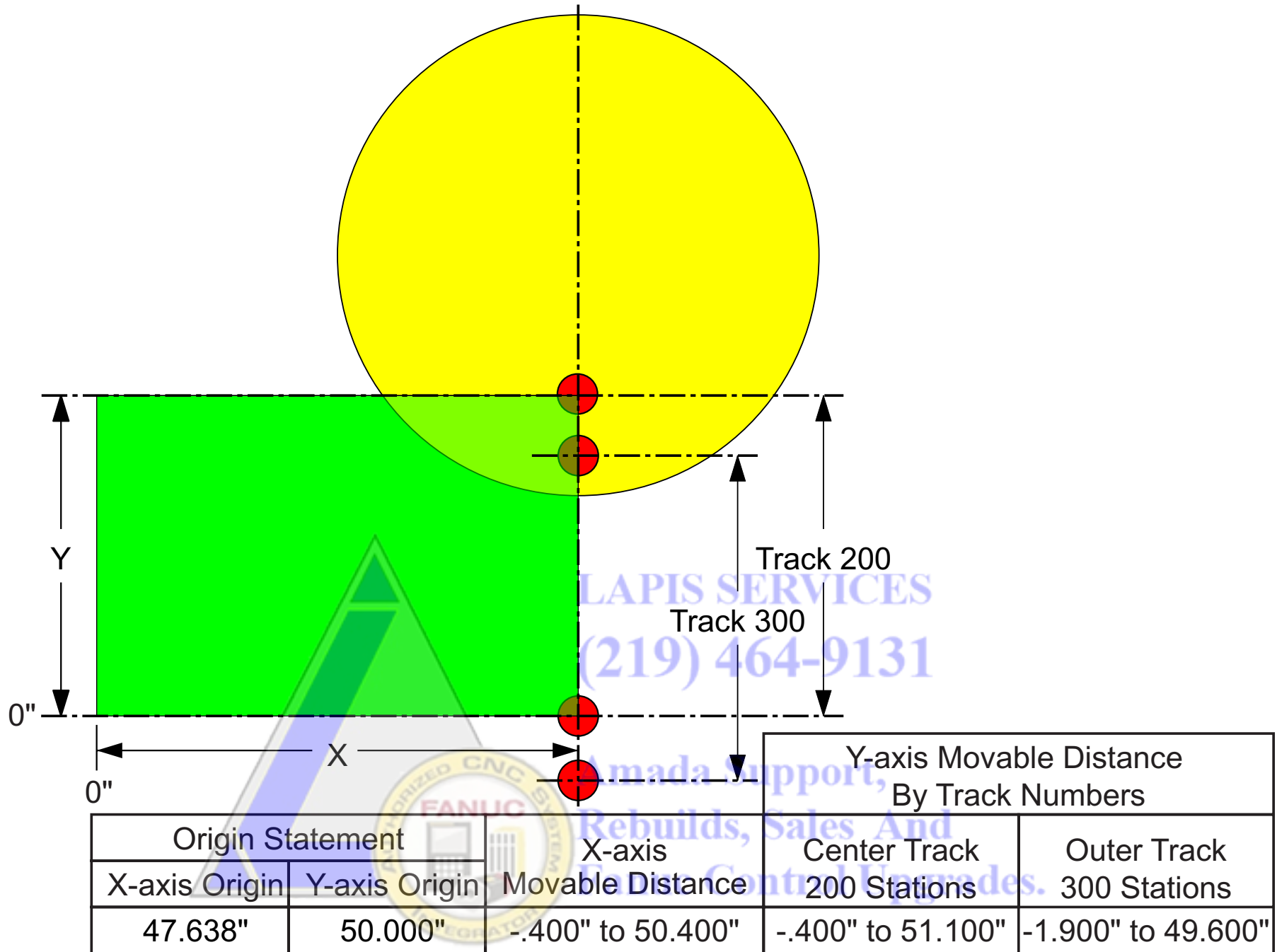


**LAPIS SERVICES**  
**(219) 464-9131**

**Amada Support,  
 Rebuilds, Sales And  
 Fanuc Control Upgrades.**

**LAPISINC.COM**

# Programmable Travel Limits



# Programmable Feed Rates

## Punching Mode

F1	=	3,229. IPM
F2	=	2,421. IPM
F3	=	1,614. IPM
F4	=	807. IPM

## Contouring Mode

G00	max.	3,149. IPM
G01	max.	300. IPM
G02	max.	300. IPM optional
G03	max.	300. IPM optional



**LAPIS SERVICES**  
**(219) 464-9131**

**Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.**

**LAPISINC.COM**

## 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 the operator must confirm the punch by pressing the punch and confirmation buttons. Punching in this area with standard tools may damage the material, material clamp, tool, other machine components and may cause operator injury.
- Y-Overtravel Zone = An area that exceeds the travel limits of the machine.



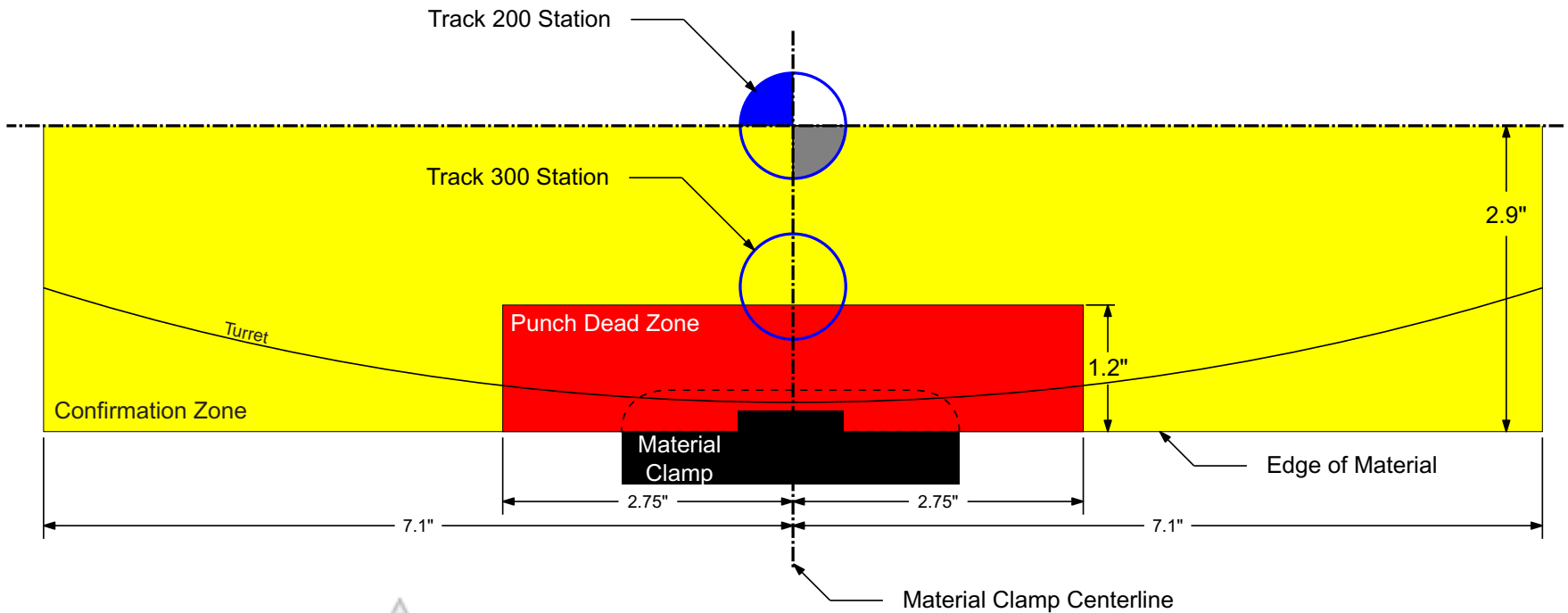
LAPIS SERVICES  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

# A Size (1/2") Station

## A Size Track 200 Stations

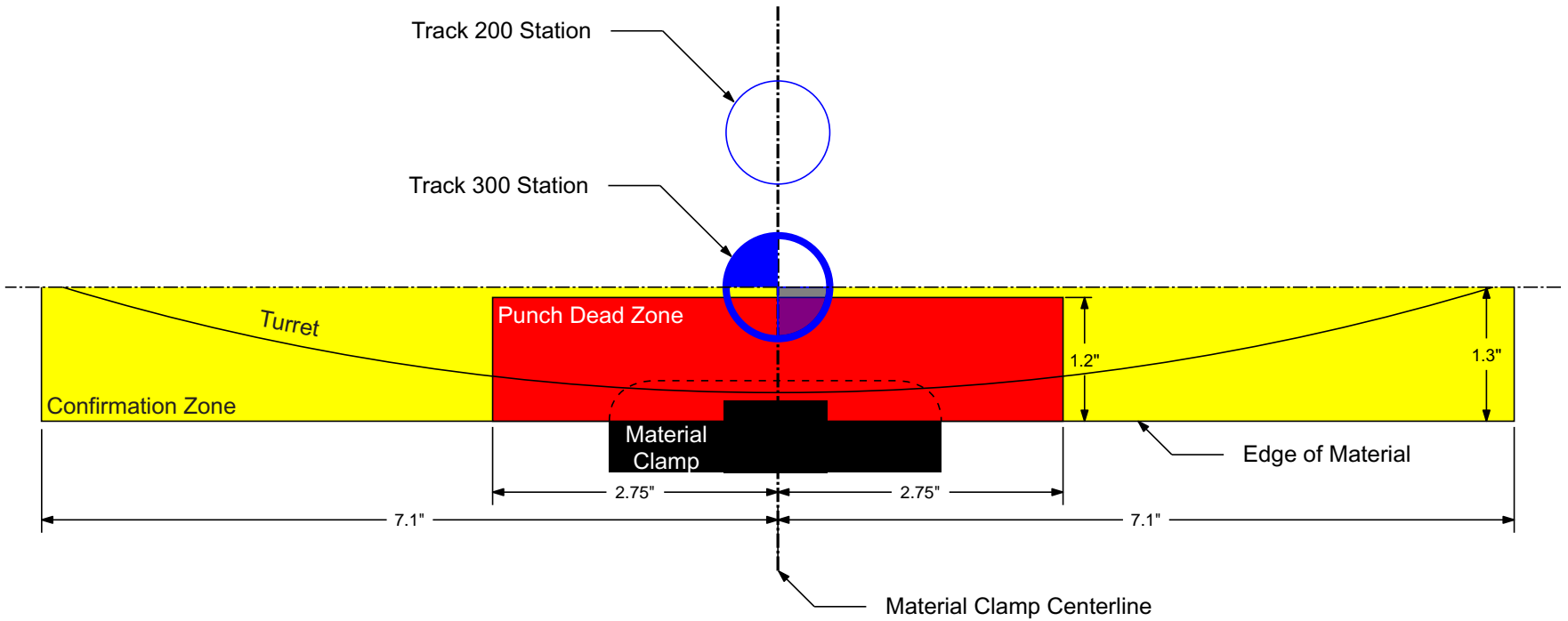


LAPIS SERVICES  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

# A Size Track 300 Stations



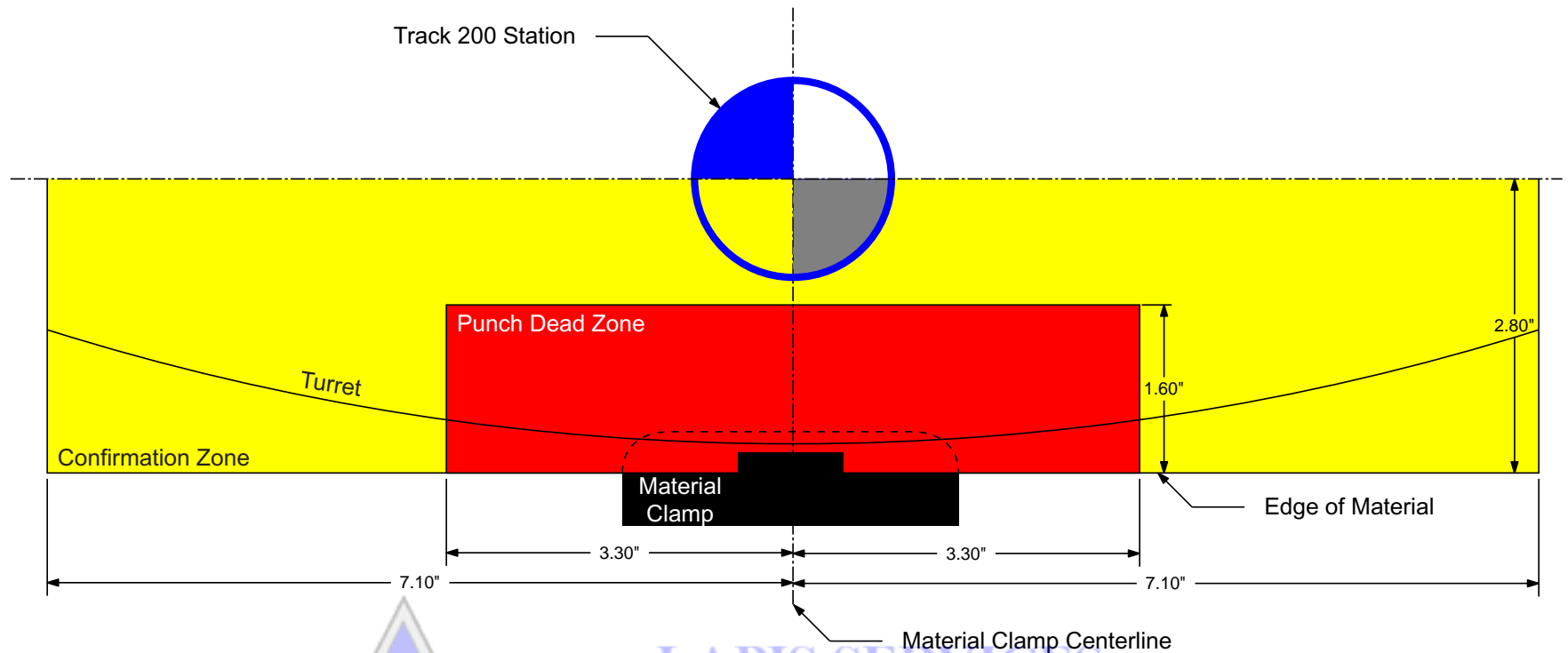
LAPIS SERVICES  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

# B Size (1 1/4") Station

## B Size Track 200 Stations (Auto Index only)

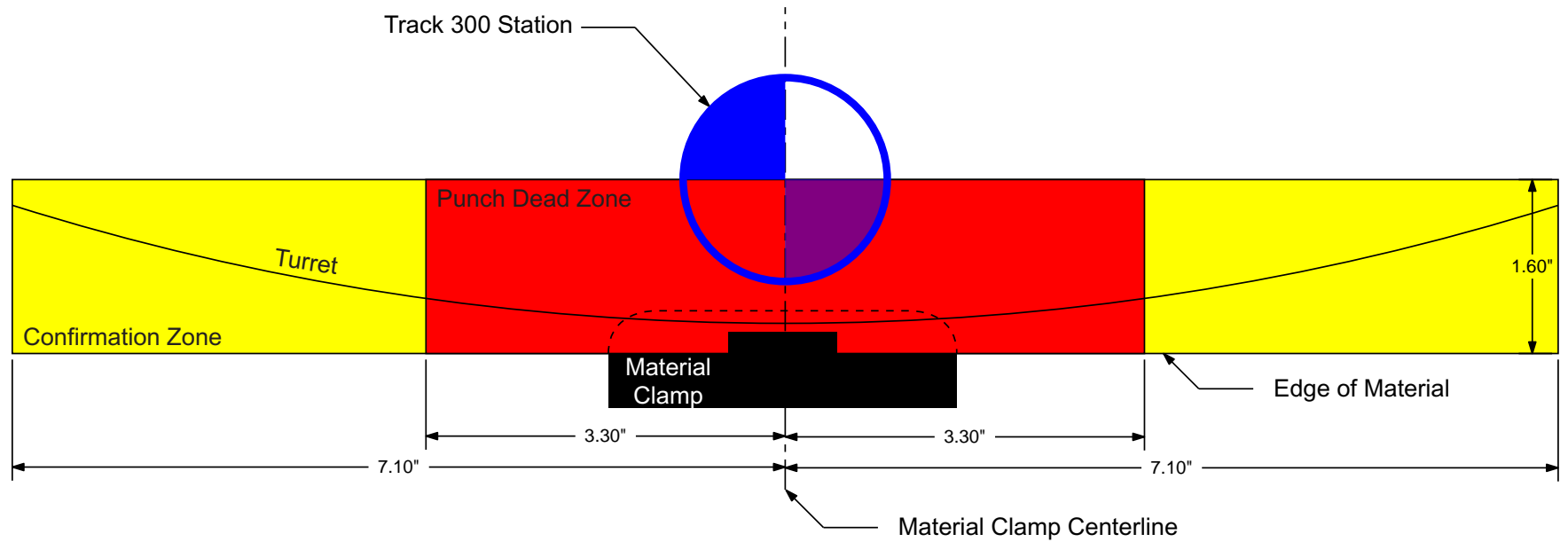


LAPIS SERVICES  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

## B Size Track 300 Stations



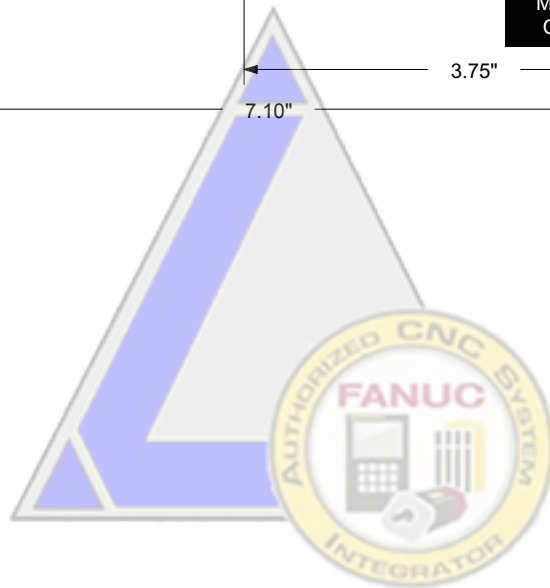
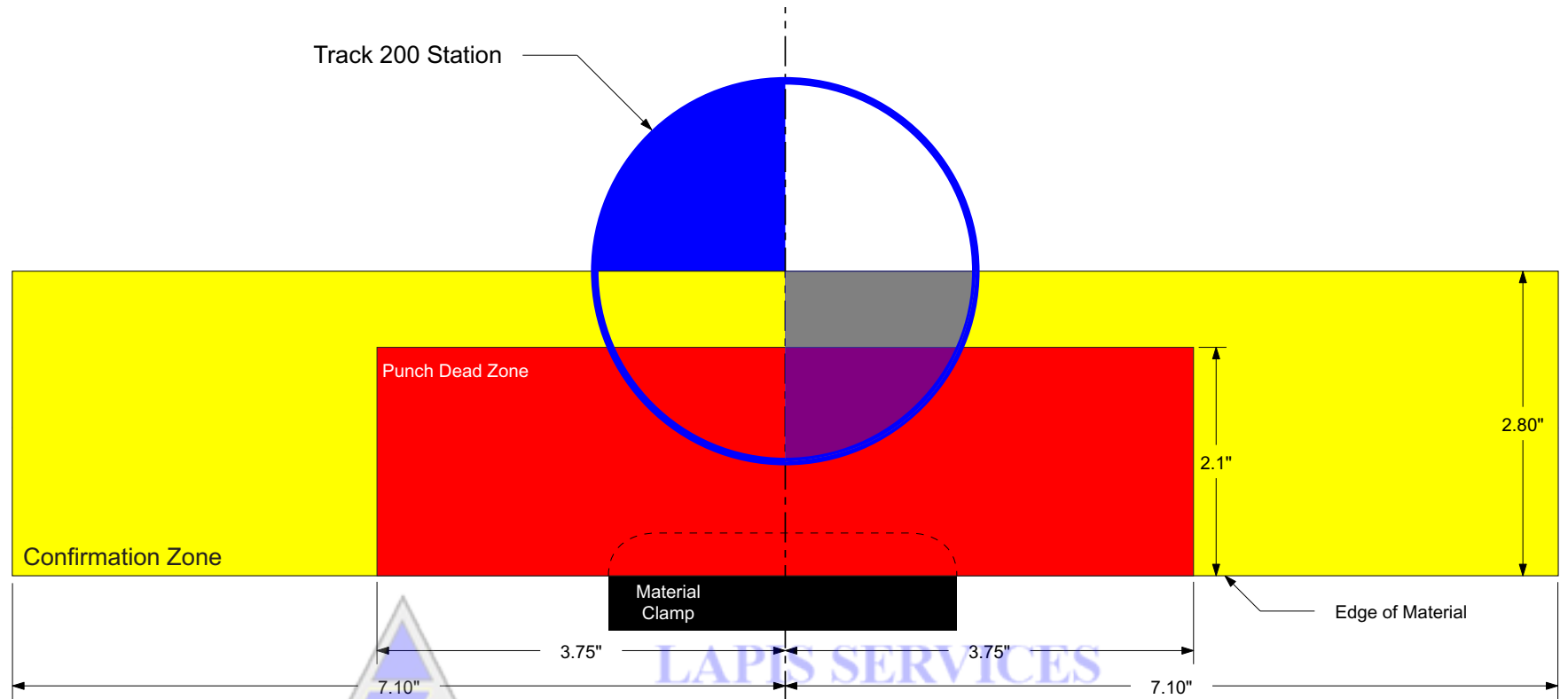
LAPIS SERVICES  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

# C Size (2") Station

## C Size Track 200 Stations

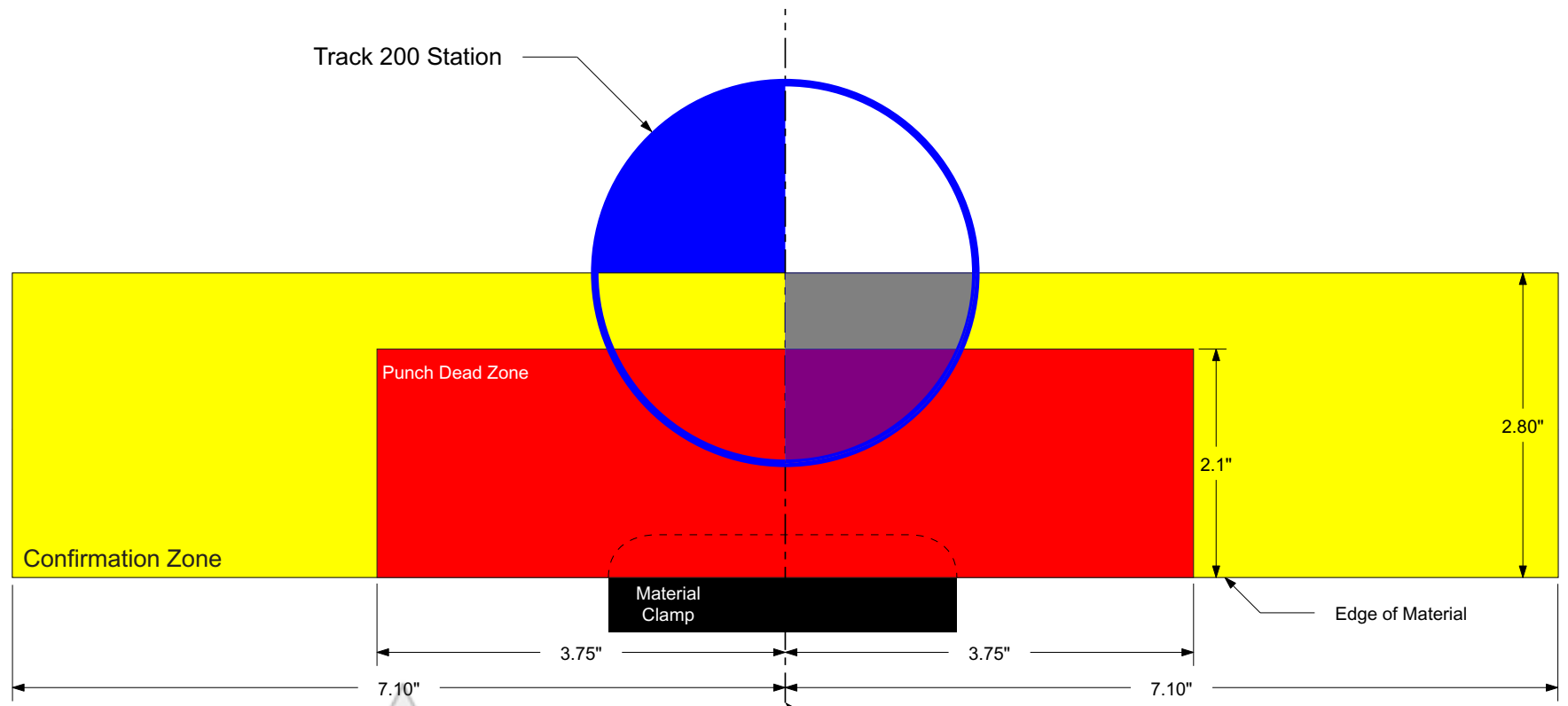


LAPIS SERVICES  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

# C Size Track 200 Stations Auto Index



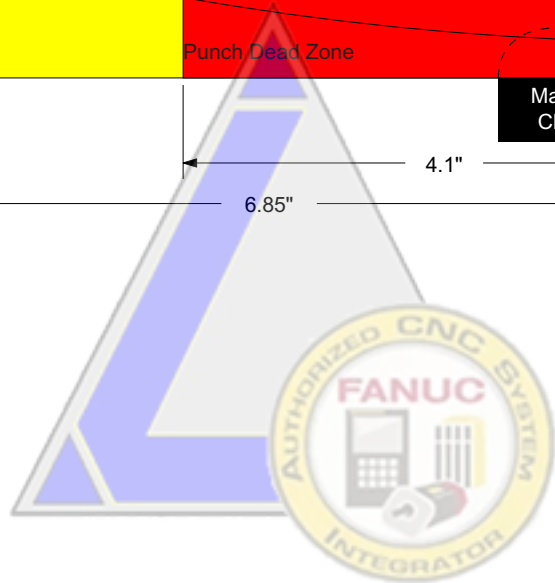
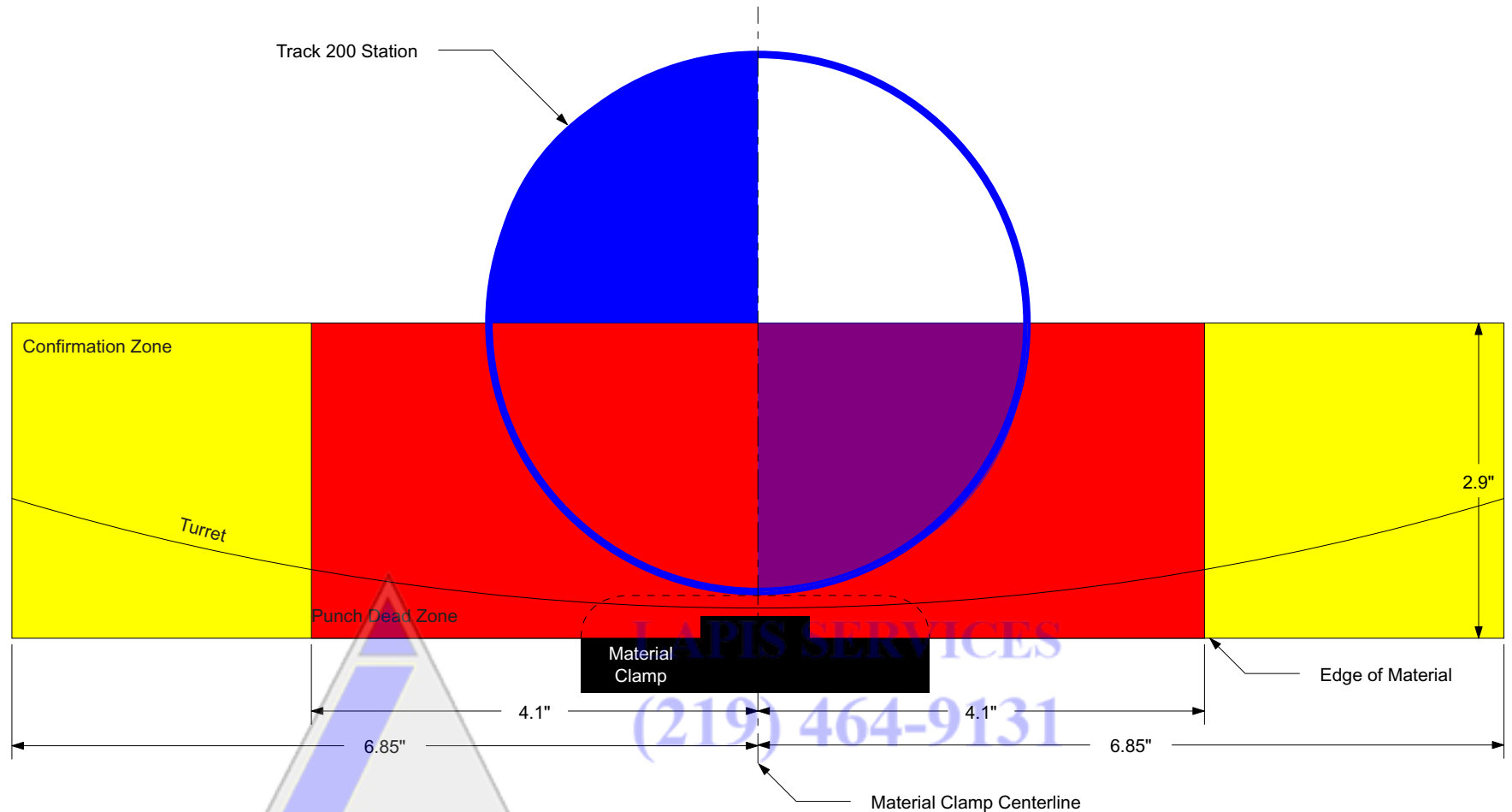
LAPIS SERVICES  
(219) 464-9131

Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

# D Size (3½") Station

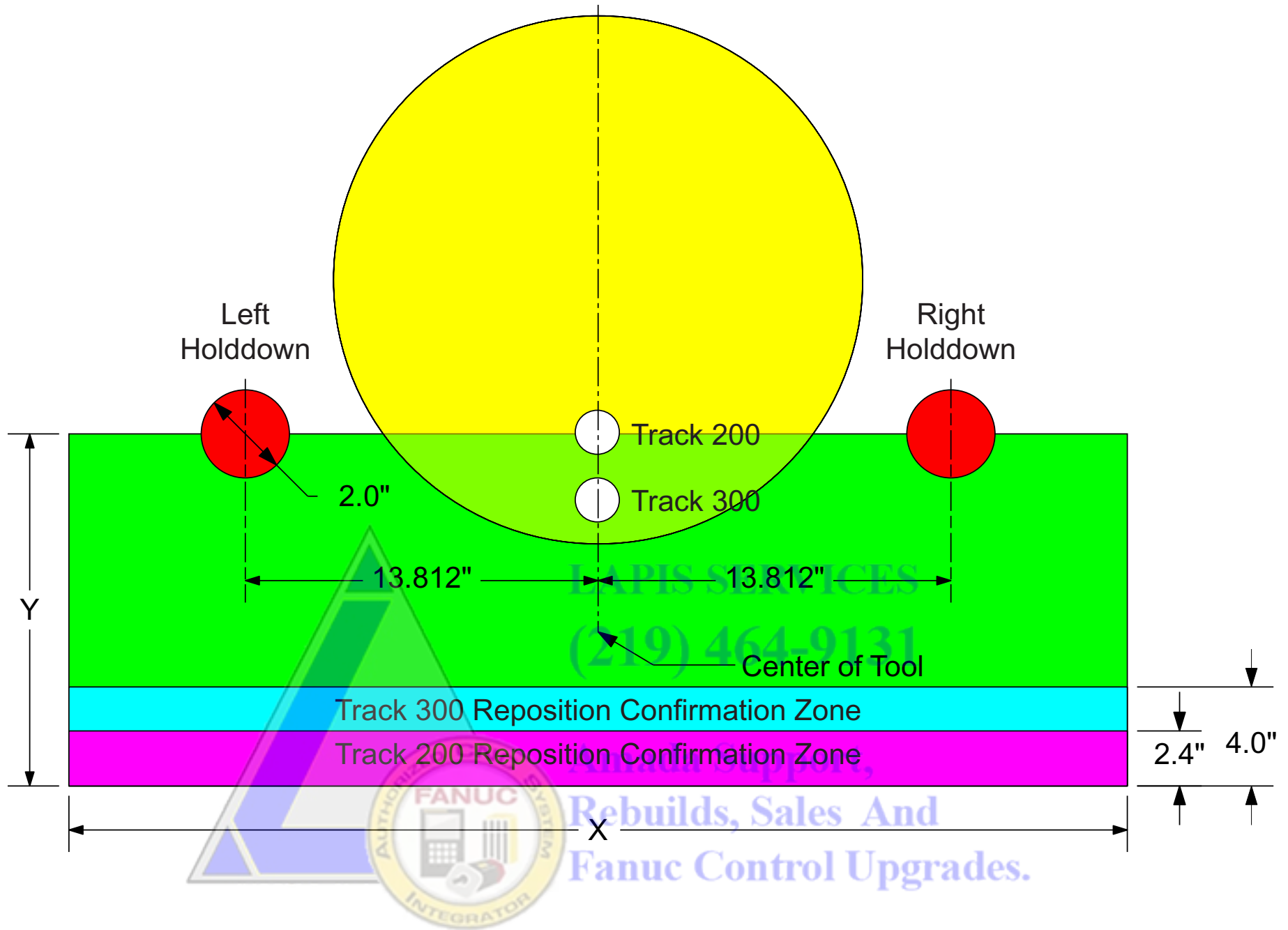
## D Size Track 200 Stations



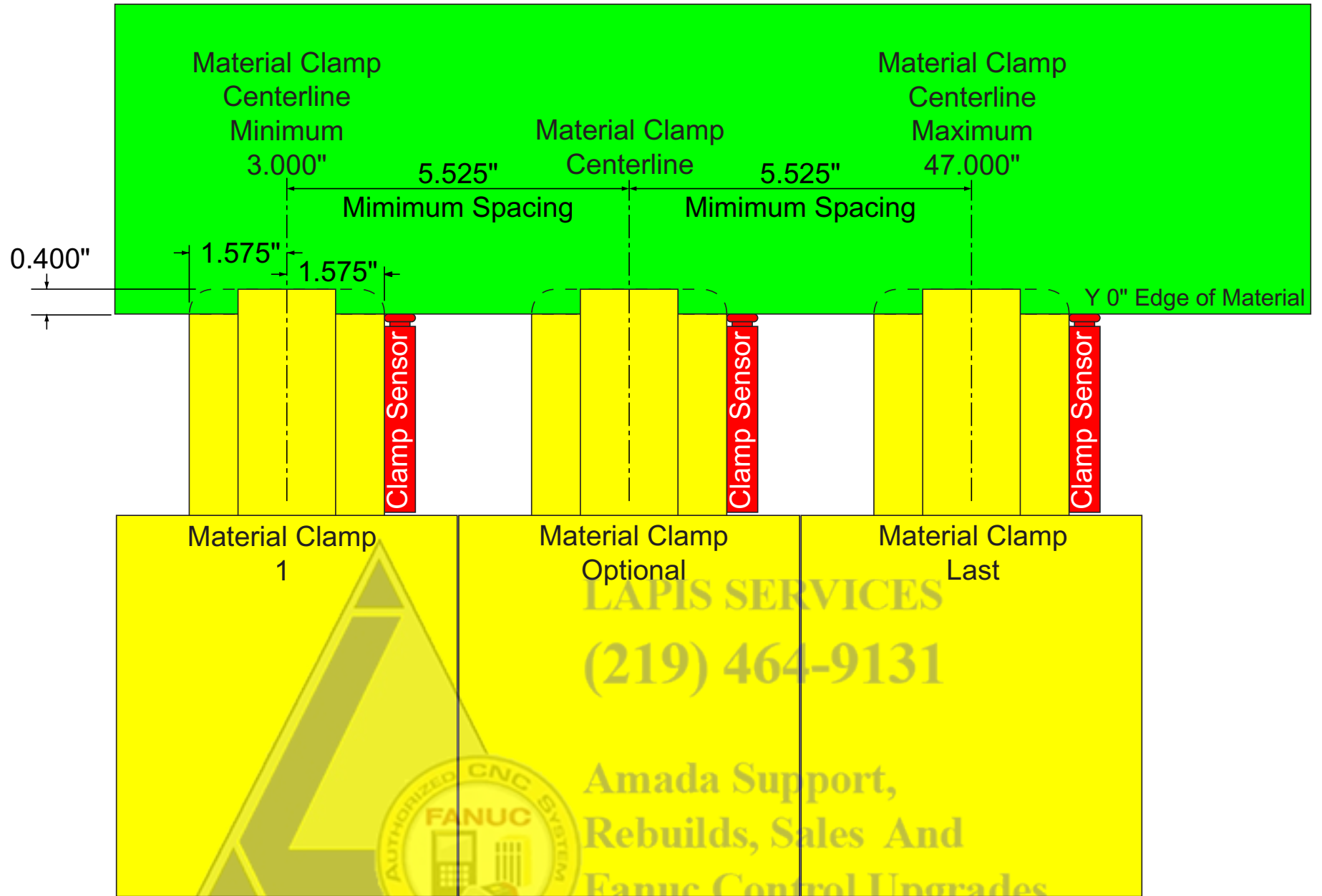
Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.

LAPISINC.COM

# Reposition Holddown Locations



# Material Clamp Location

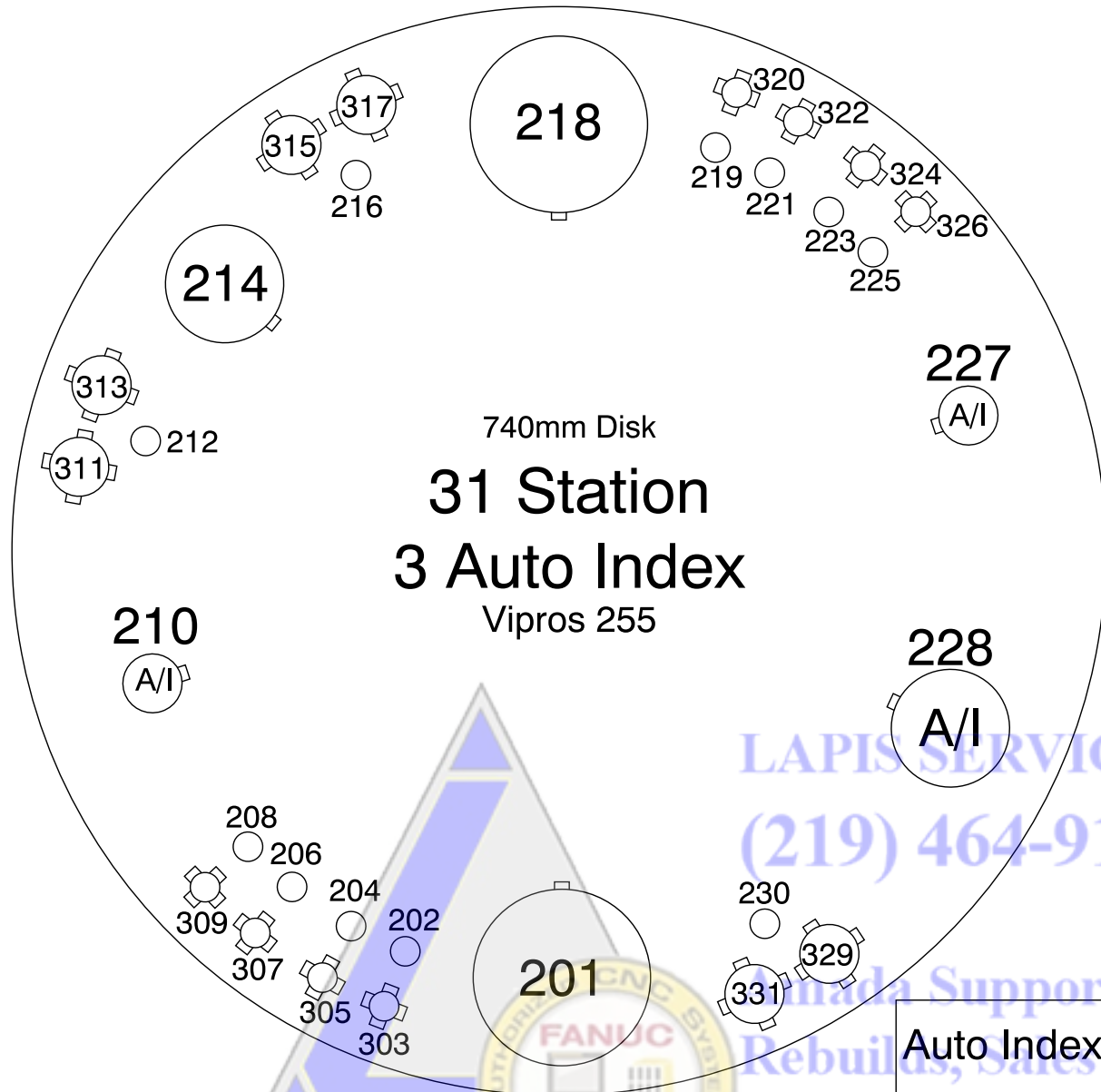


LAPIS SERVICES  
(219) 464-9131  
Amada Support,  
Rebuilds, Sales And  
Fanuc Control Upgrades.



LAPISINC.COM

# Turret Layout 31 station 3 A/I



	Maximum Size Round	Number of Stations (keyed)	
A	1/2" (12.7mm)	19 (8)	
B	1 1/4" (31.7mm)	6 (6)	
C	2" (50.8mm)	1 (1)	
D	3 1/2" (88.9mm)	2 (2)	
Auto Index	B	1 1/4" (31.7mm)	2 (2)
	C	2" (50.8mm)	1 (1)