# BB02-D2 CALIBRATION

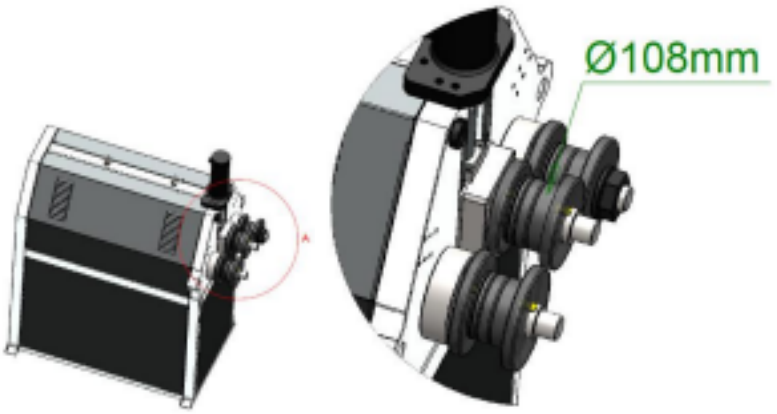
To measure the length (X-Axis) of the bent part on profile bending machines, calibrate the machine based on the tool diameter. Calculate the tool circumference to determine the value for calibration entry.

Tool circumference = Tool diameter x $\pi$ ($\pi$ = 3,14)

Ex : Calculation for the tool given below ;

Tool circumference = 108 x 3,14

= 339,12 mm ⍰ ***Integer value = 339***




## Calibration Steps:

***Note: Prior to calibration, remember to mark with pencil/paint to clearly indicate one rotation of the roll.***

1. Begin by pressing the PROG Key.
2. Once you spot the PASS text, adjust the value to 20 using the arrow keys and then hit the PROG button.
3. Use the Up Arrow key to access the CAL 1 parameter.
4. Press the PROG button twice to display the CAL 2 parameter.
5. Press the right foot pedal and rotate the roll a full turn.
6. Upon aligning the marked area, press the PROG button once more.
7. Input the calculated value using the OK keys (e.g., for the tool in the example, enter 339).
8. Conclude by pressing the PROG button.