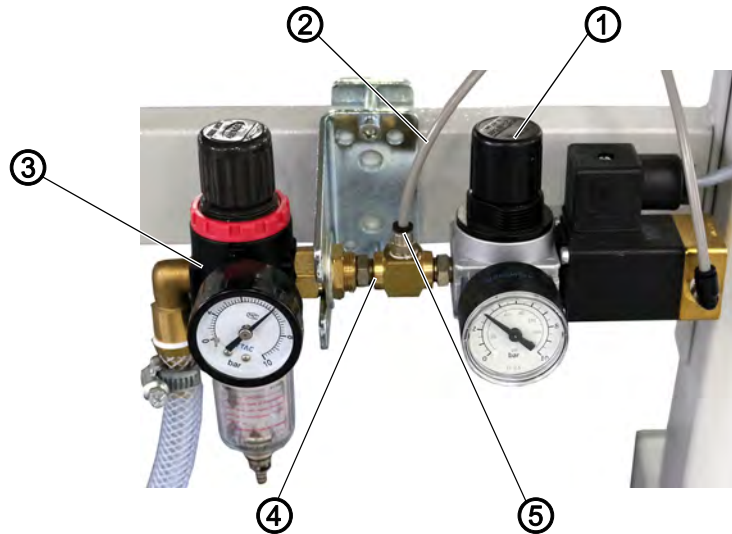


Assembling and setting the pneumatic edge stop



1. Assemble the pneumatic edge stop on the throat plate slide.

Fig. 1: Completing the compressed air maintenance unit

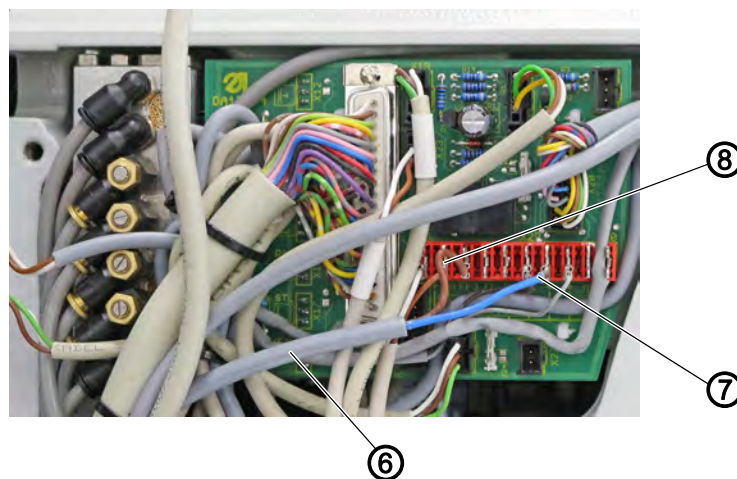


- | | |
|---------------------------------------|------------------|
| (1) - Pressure controller | (4) - Connection |
| (2) - Pneumatic hose | (5) - Connection |
| (3) - Compressed air maintenance unit | |



2. **Class 867-M PREMIUM:** Assemble the compressed air maintenance unit (3).
Class 867: Compressed air maintenance unit (3) is already available.
3. Connect additional compressed air maintenance unit with connection (4) to the compressed air maintenance unit (3).
4. Connect the pneumatic hose (2) to the connection (5).
5. Set the pressure controller (1) to a maximum of 3 bar.

Fig. 2: Connecting the pneumatic edge stop



- | | |
|--|-----------------------|
| (6) - (17) - Cable (from the magnet valve) | (8) - Phase (FF3 OUT) |
| (7) - Neutral conductor (+ 24 V) | |



6. Connect both connections from the magnet valve (6) to the connector strip 7, X22, PIN3 (FF3 OUT) and PIN 1, 7 or 8 (+24 V) of the circuit board.

Control DAC basic



To assign the *pneumatic edge stop* function to a button on the machine arm:

1. Call up the Technician level and press the button which is to be assigned the *pneumatic edge stop* function.
2. Set parameter *t 51 20* to the value *10* and press **OK** to confirm.
↳ The display switches to parameter *t 11 60*.
3. Set parameter *t 11 60* to the value *06* and press **OK** to confirm.

Control DAC comfort



To assign the *pneumatic edge stop* function to a button on the machine arm:

1. Press the **P** and **S** buttons at the same time to call up the Technician level and enter the password (25483).
2. Open the menu *User config. > Output Config* to select the desired output (FF3 (OUT) (X22) = output X90.15 and assign mode *41* (pneumatic edge stop).
3. Open the menu *User config. > Input Config* to select the input for the desired button and to assign mode *26* (pneumatic edge stop).
4. Open the menu *Machine config. > EdgeGuide* to activate the edge stop (parameter *t 32 00*).
5. Open the menu *Machine config. > EdgeGuide > Motor* to assign the mode *0* (pneumatic version, parameter *t 32 03*).
6. Restart the machine.

