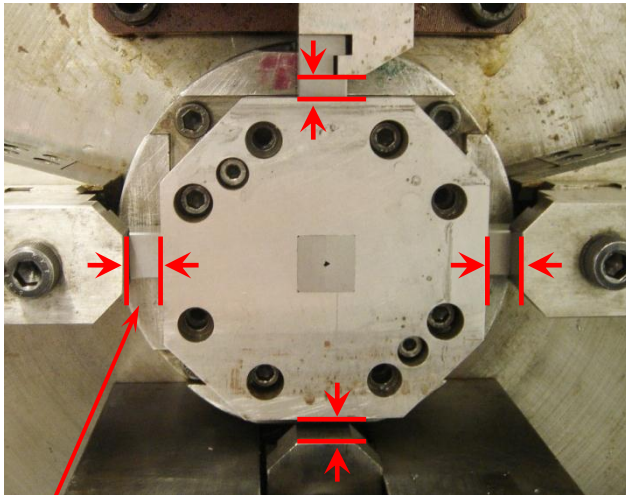


SETTING SHEET - FCM

MACHINE TYPE		PAGE	DATE	
INSERT SIZE		1 OF 3	SETTER	

OPERATION	P&C	WORKS ORDER	
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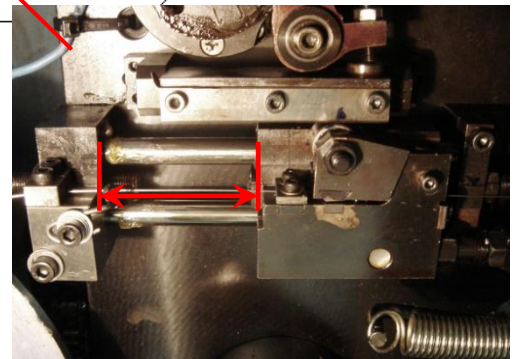
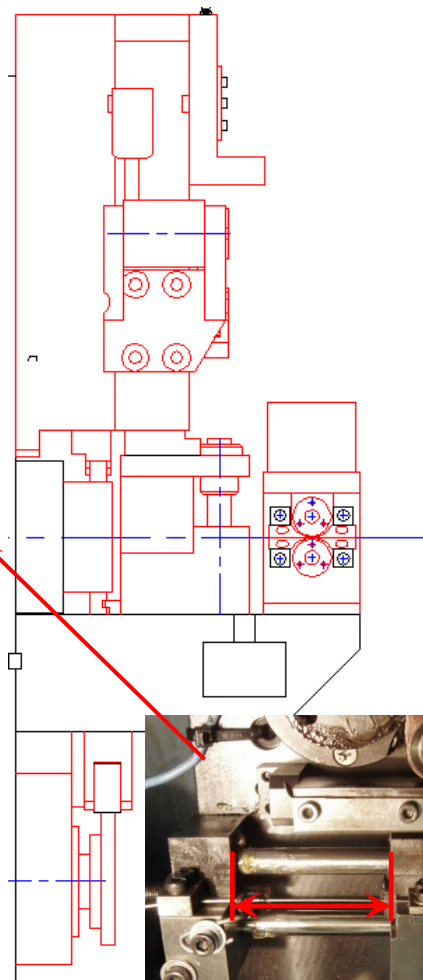
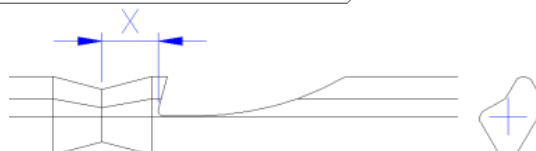
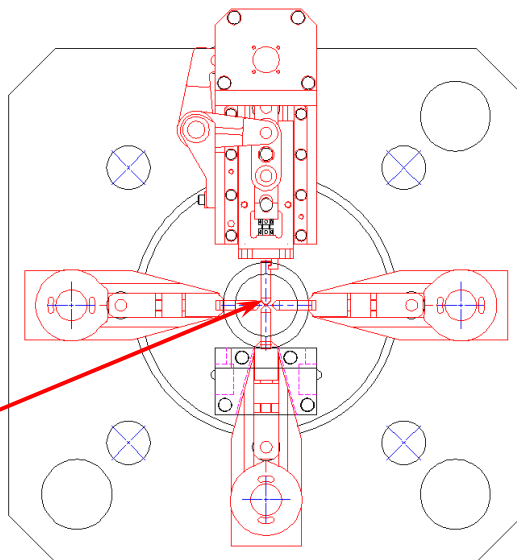
TOOLING		Bolster		Crush Tools	
Feed Rollers		Punch		Crush Plate	
Feed Roller		Die		Wire Guides	
Wire Guides				Mechanical	
		Stripper		Feed Wire	
				Guides	



CRUSH TOOL SETTING	
TOP	
BOTTOM	
LEFT	
RIGHT	

CRUSH TOOL LENGTHS	
TOP	
BOTTOM	
LEFT	
RIGHT	

NOTCH POSITION
(Measured cut off to tip of notch)



MECHANICAL FEED START POSITION

SETTING SHEET - FCM

MACHINE TYPE		PAGE	DATE	
INSERT SIZE		2 OF 3	SETTER	

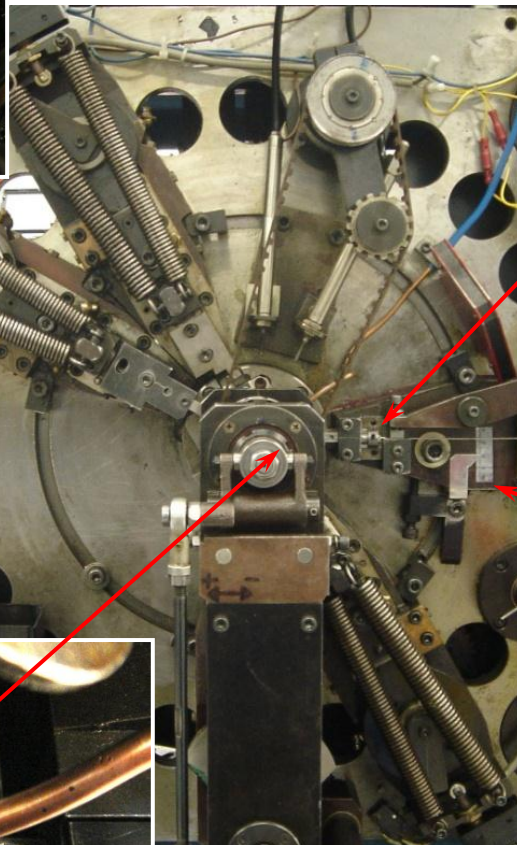
OPERATION	Coiling	WORKS ORDER	
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TOOLING					
Coiling Wire Guides		Arbor		Collet Shaft	
Sensor Wire Guides		Forming Tool		Spacer	
Wire Guide Holder				Sleeve	

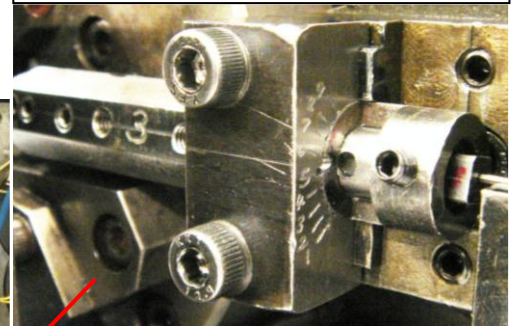
FORMING TOOL CAM POSITION



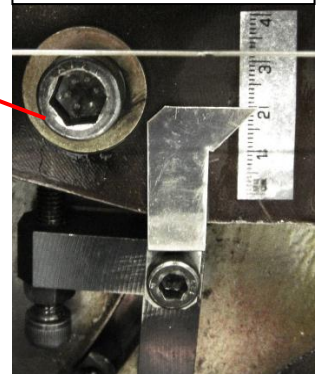
MACHINE FACE



WIRE GUIDE ANGLE

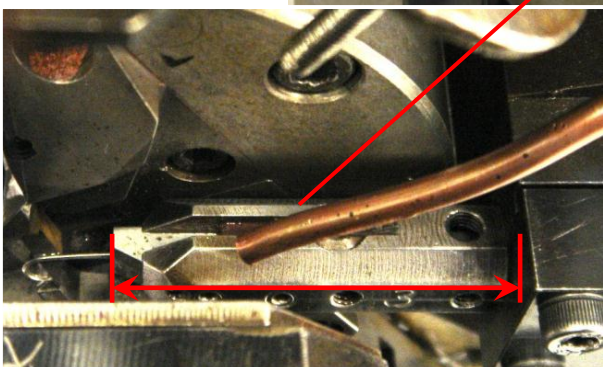


WIRE GUIDE HEIGHT



WIRE GUIDE POSITION

(Measured shoulder of holder to tip of wire guide)



WIRE CAST

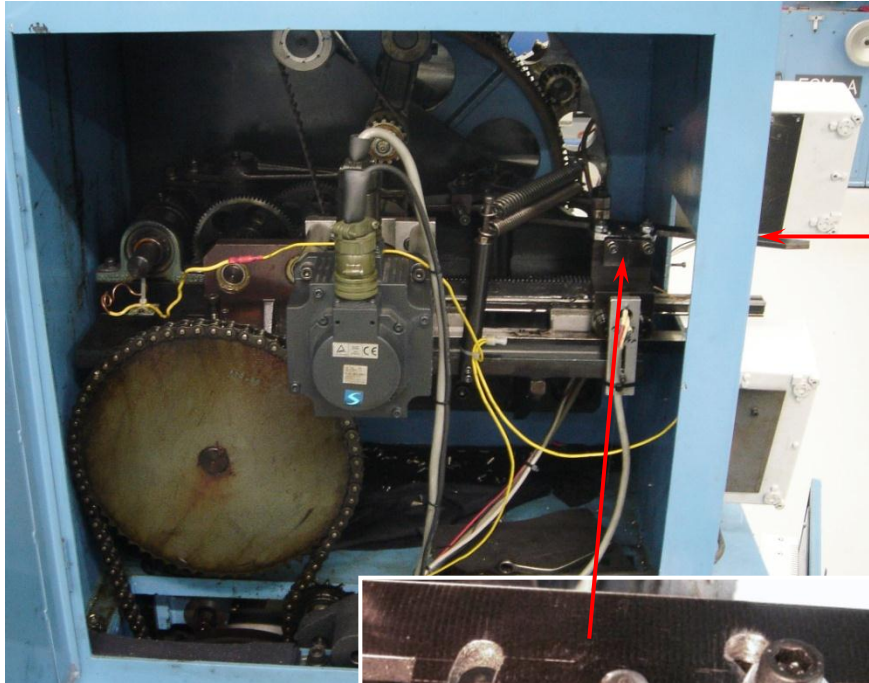
(2 feed lengths measured cut off to cut off)



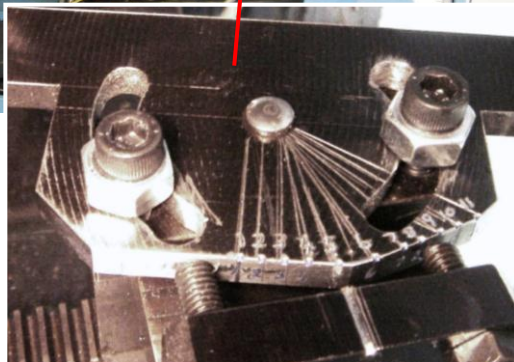
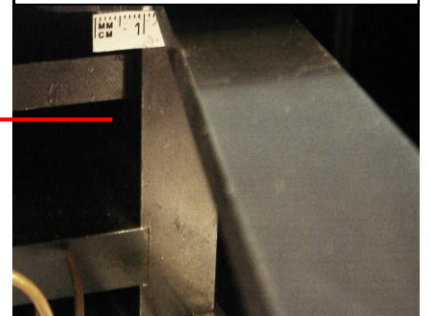
SETTING SHEET - FCM

MACHINE TYPE		PAGE	DATE	
INSERT SIZE		3 OF 3	SETTER	

BACK OF MACHINE



PITCH BAR SETTING



PITCH BAR ANGLE

AXIS 1

COILING STEPS	PATTERN	CONTROL METHOD	ACCEL TIMES	DECEL TIMES	ADDRESS ABS	COMMAND SPEED
1						
2						
3						
4						
5						

AXIS 2

FEED STEPS	PATTERN	CONTROL METHOD	ACCEL TIMES	DECEL TIMES	ADDRESS INC	COMMAND SPEED
1						
2						