

Vipros 255 Machine Programming Limits

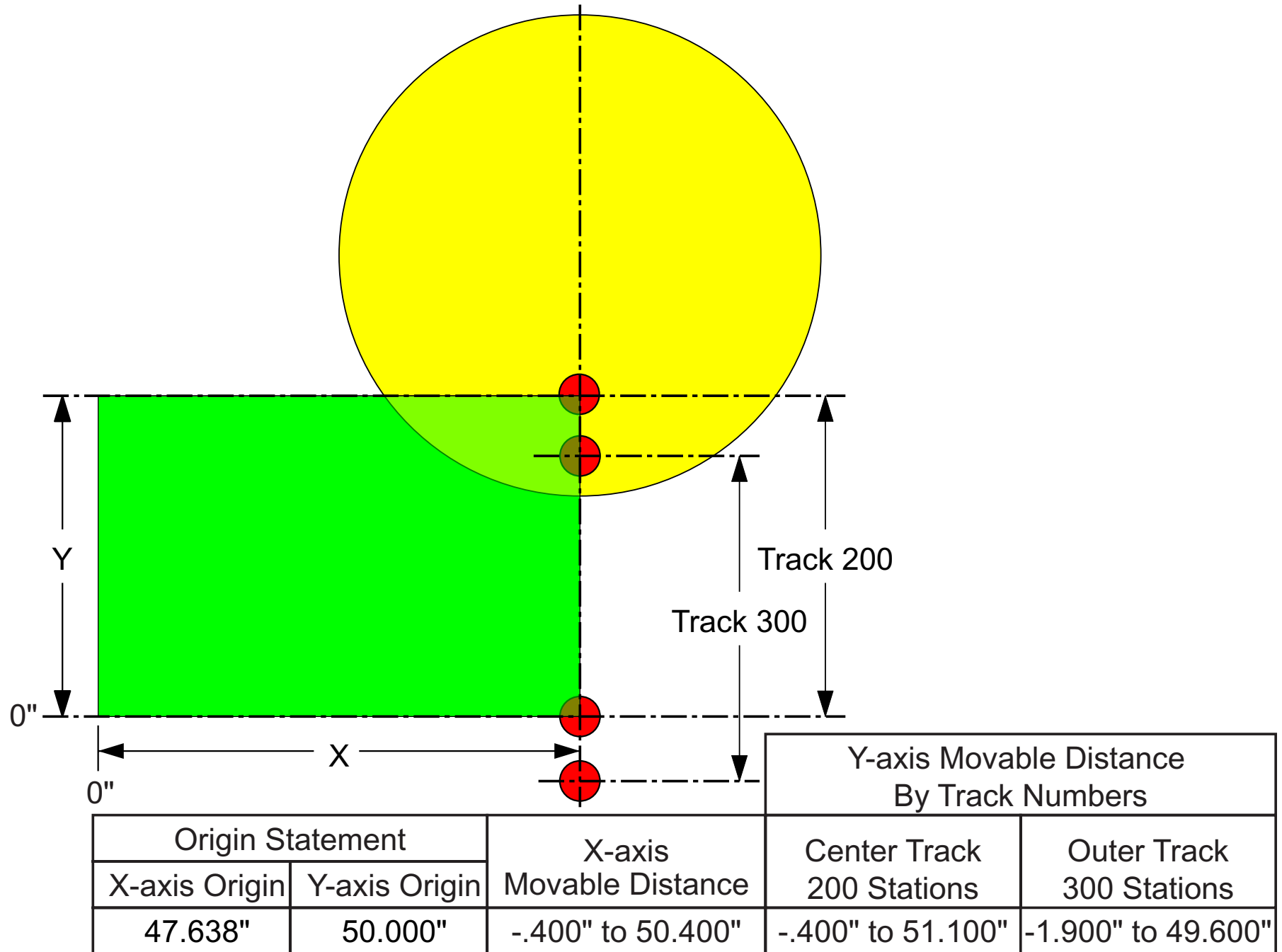


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Programmable Travel Limits



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

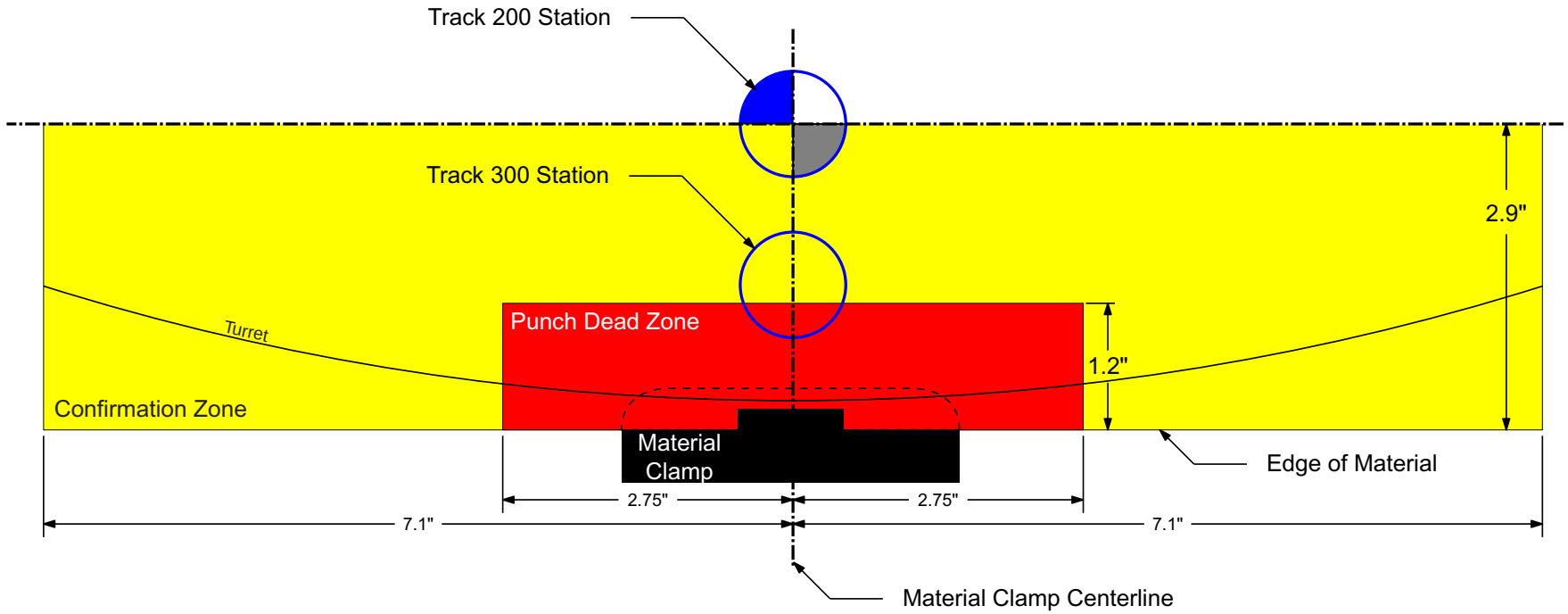
Punch Confirmation Area / Punching Dead Zone.

Definitions

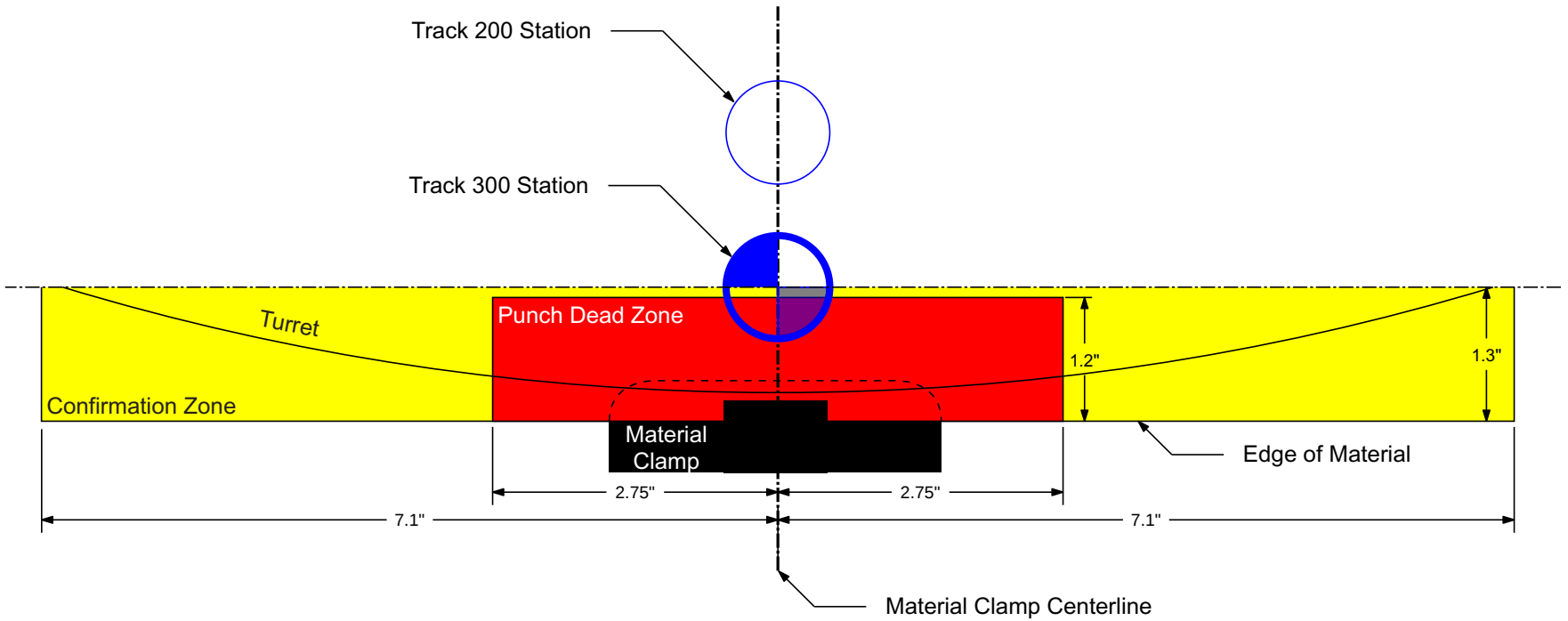
- | | | |
|-------------------|---|---|
| Confirmation Zone | = | An area that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton. |
| Punch Dead Zone | = | An area that the operator 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. |

A Size (½") Station

A Size Track 200 Stations

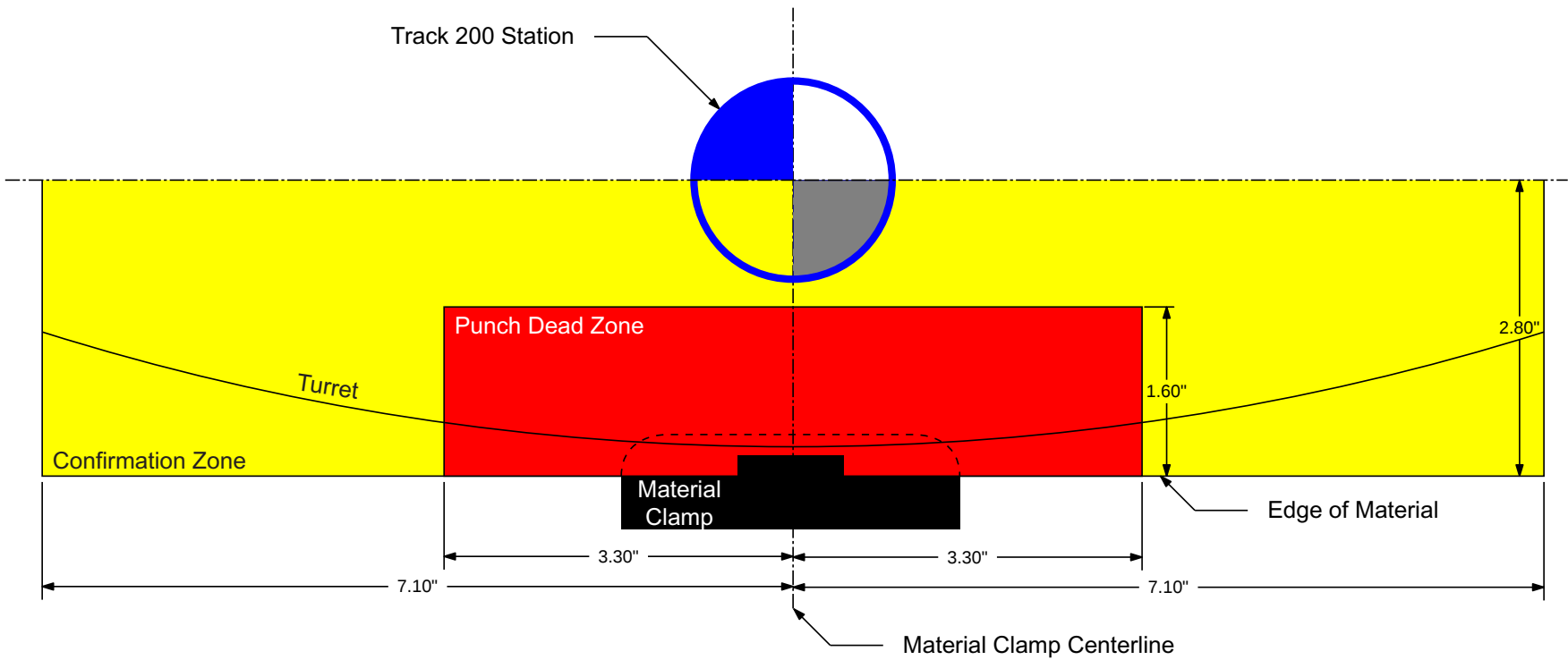


A Size Track 300 Stations

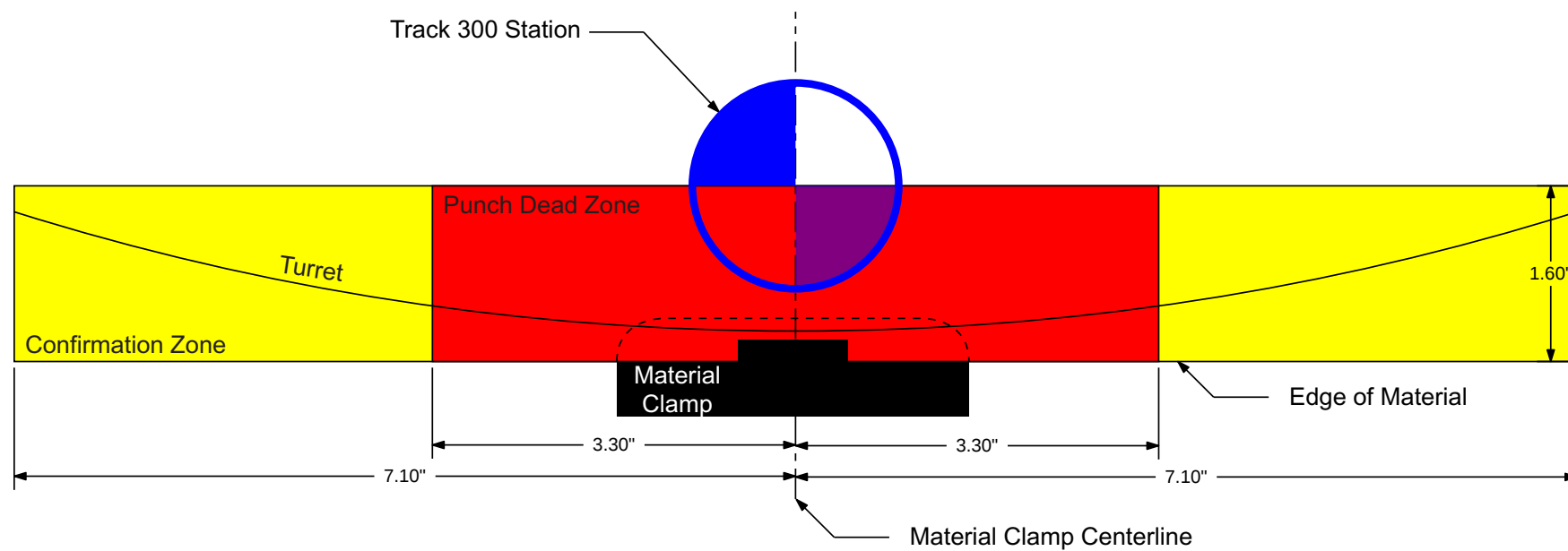


B Size (1¼") Station

B Size Track 200 Stations (Auto Index only)

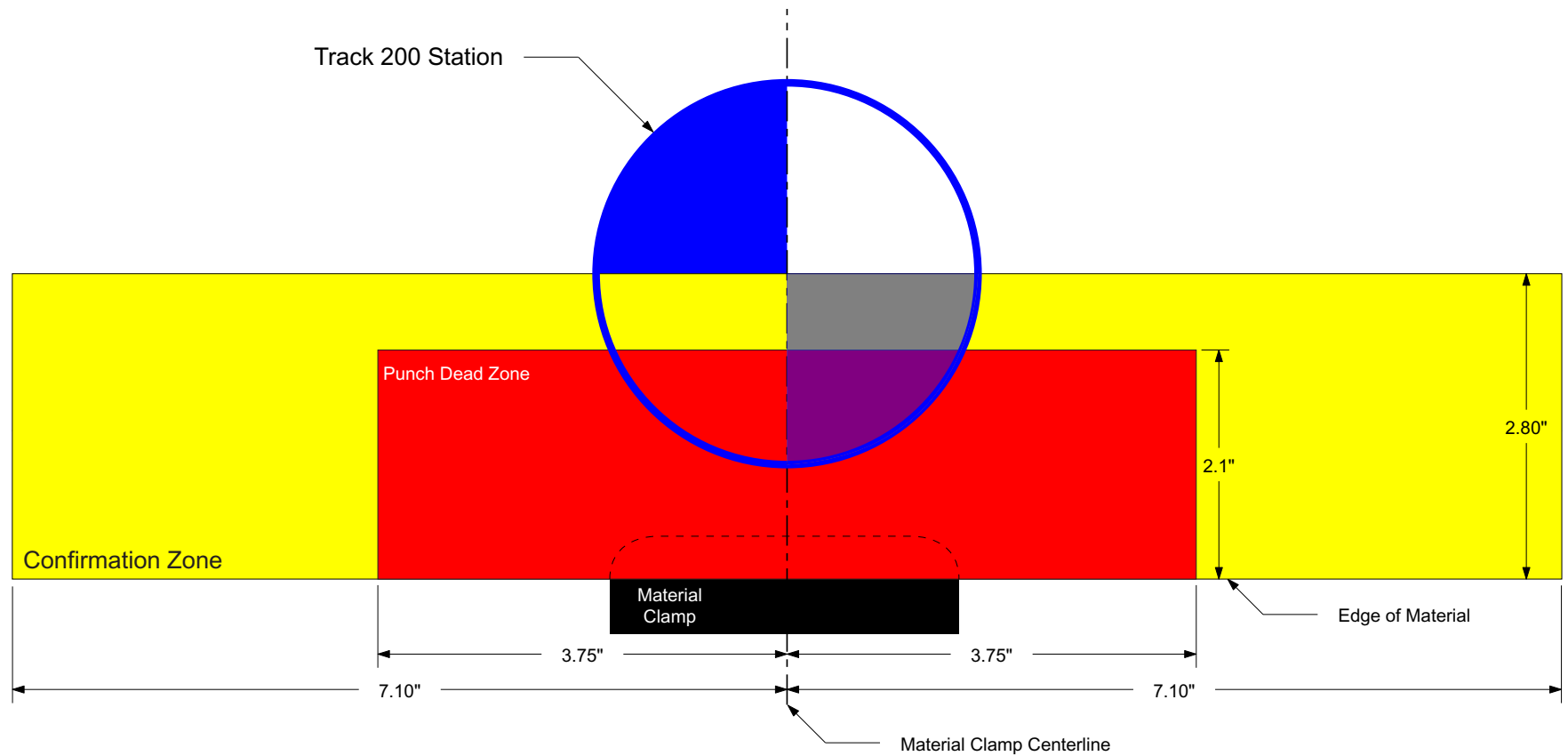


B Size Track 300 Stations

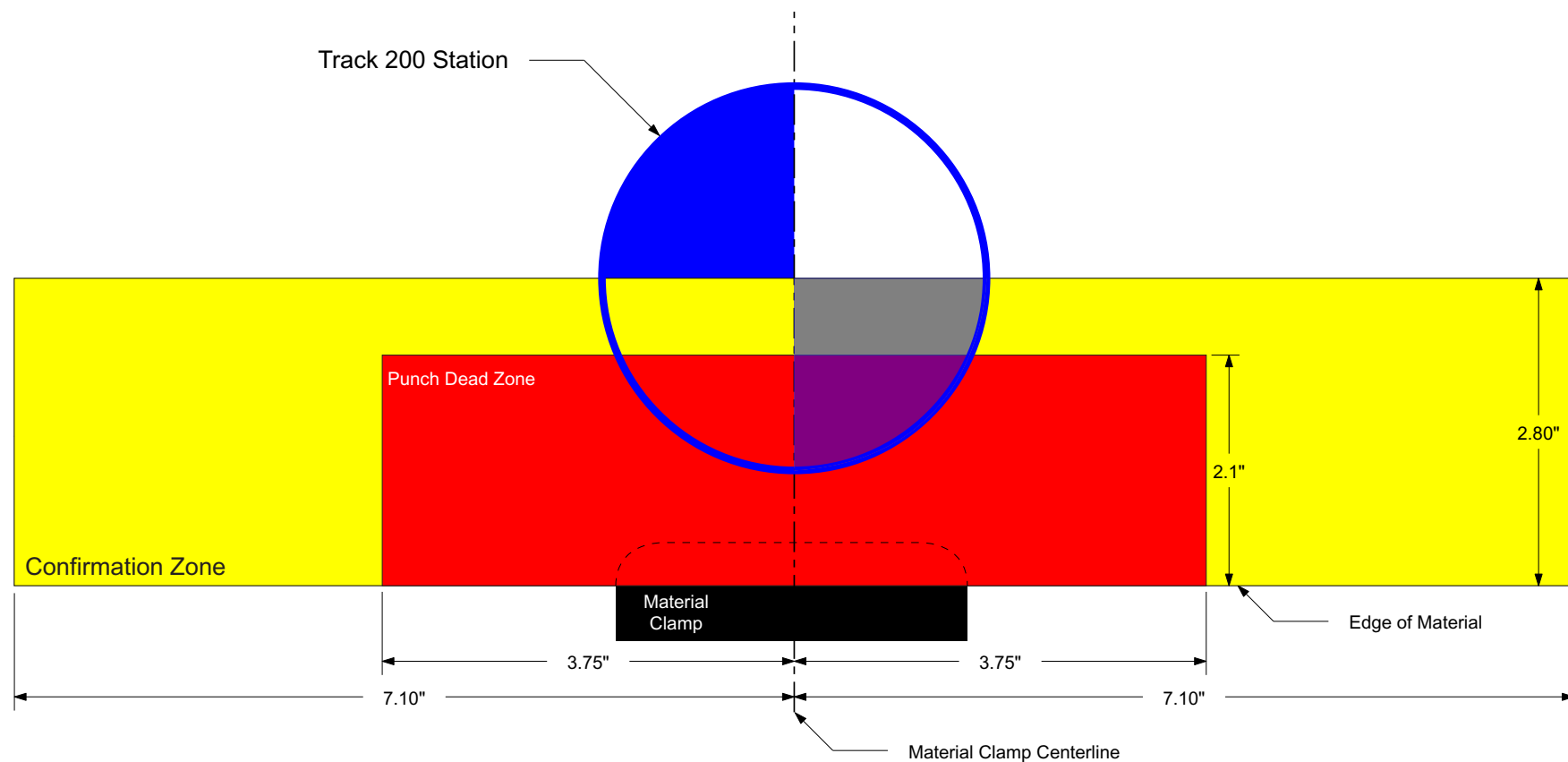


C Size (2") Station

C Size Track 200 Stations

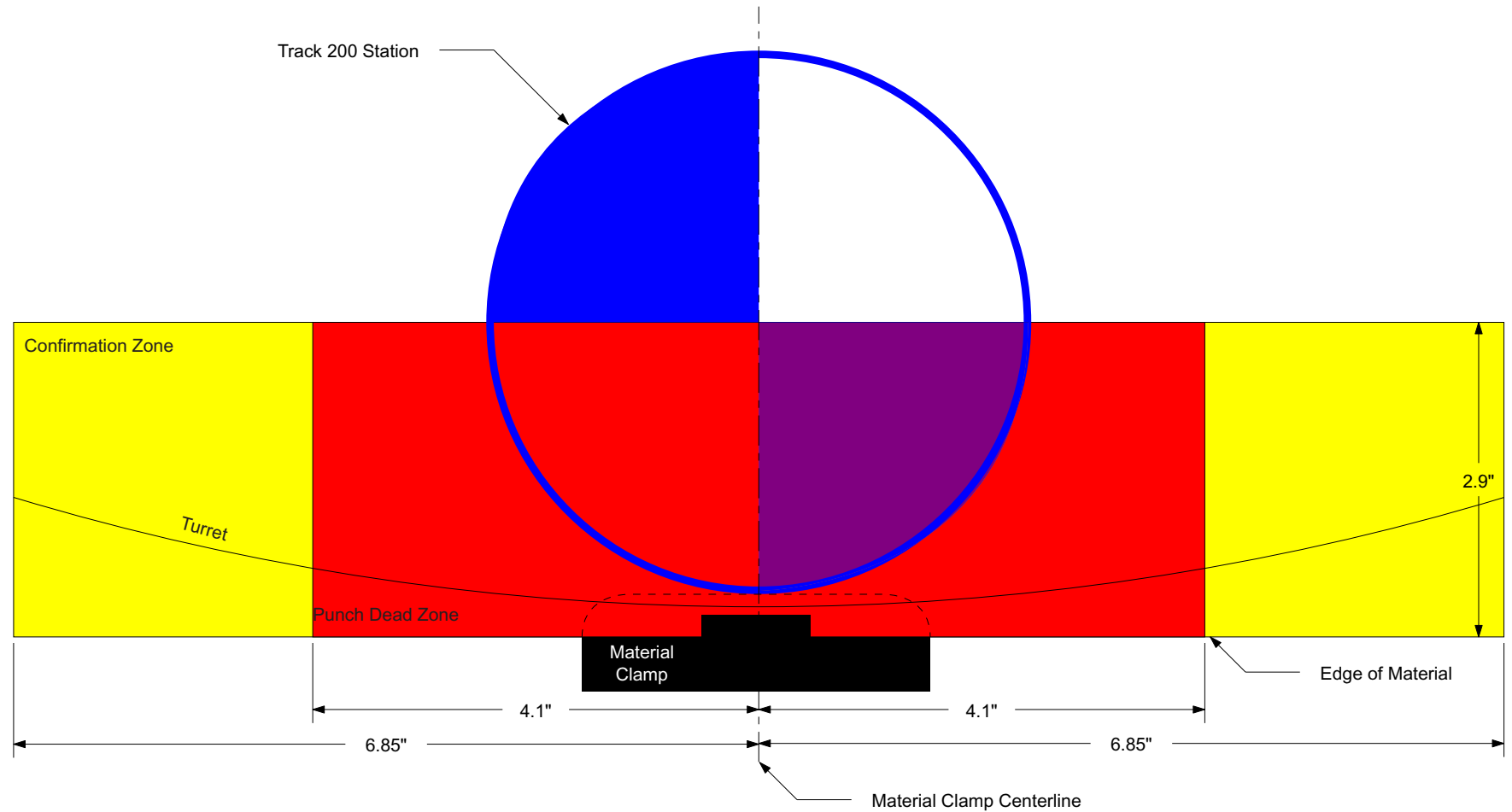


C Size Track 200 Stations Auto Index

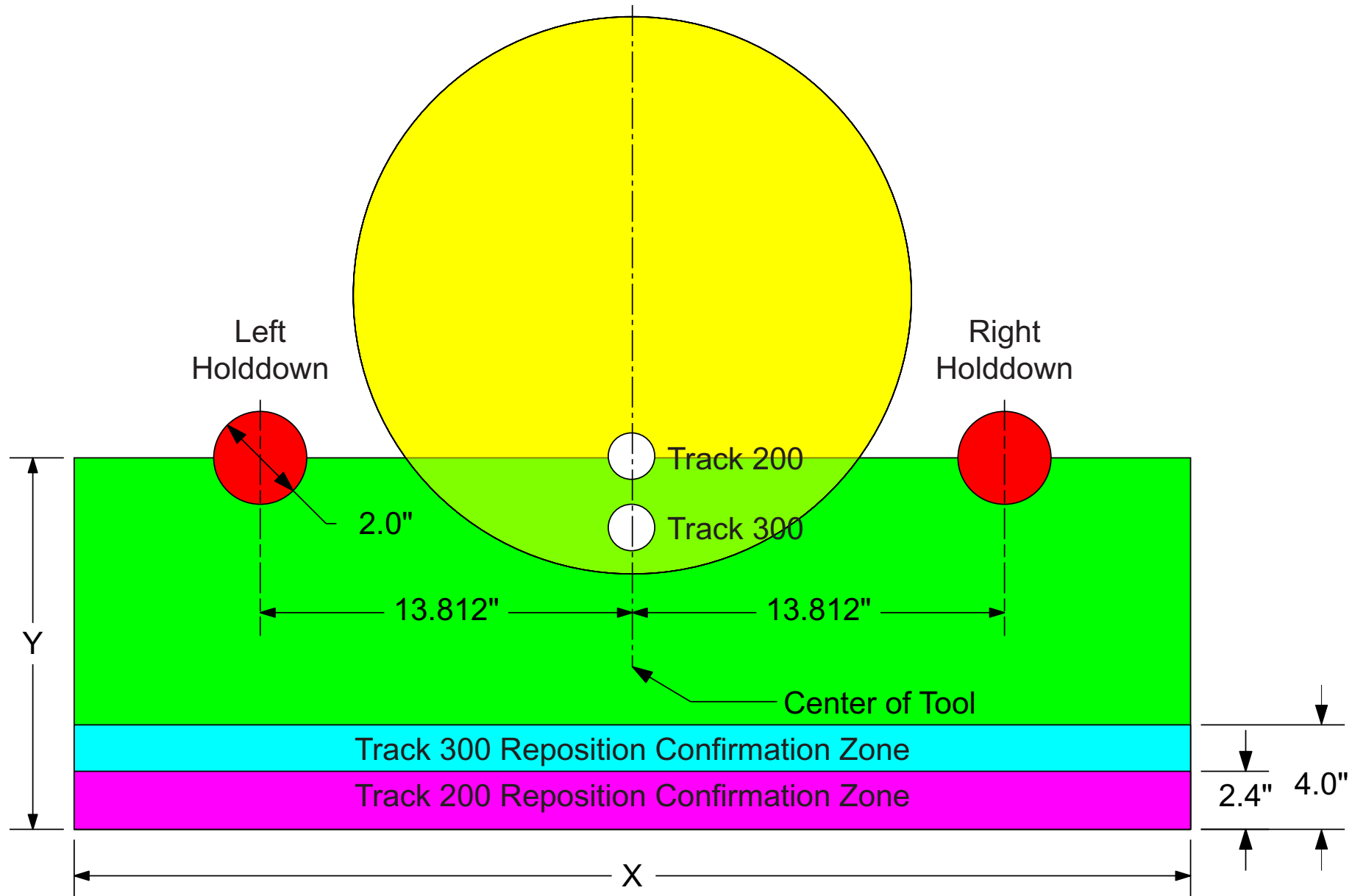


D Size (3½") Station

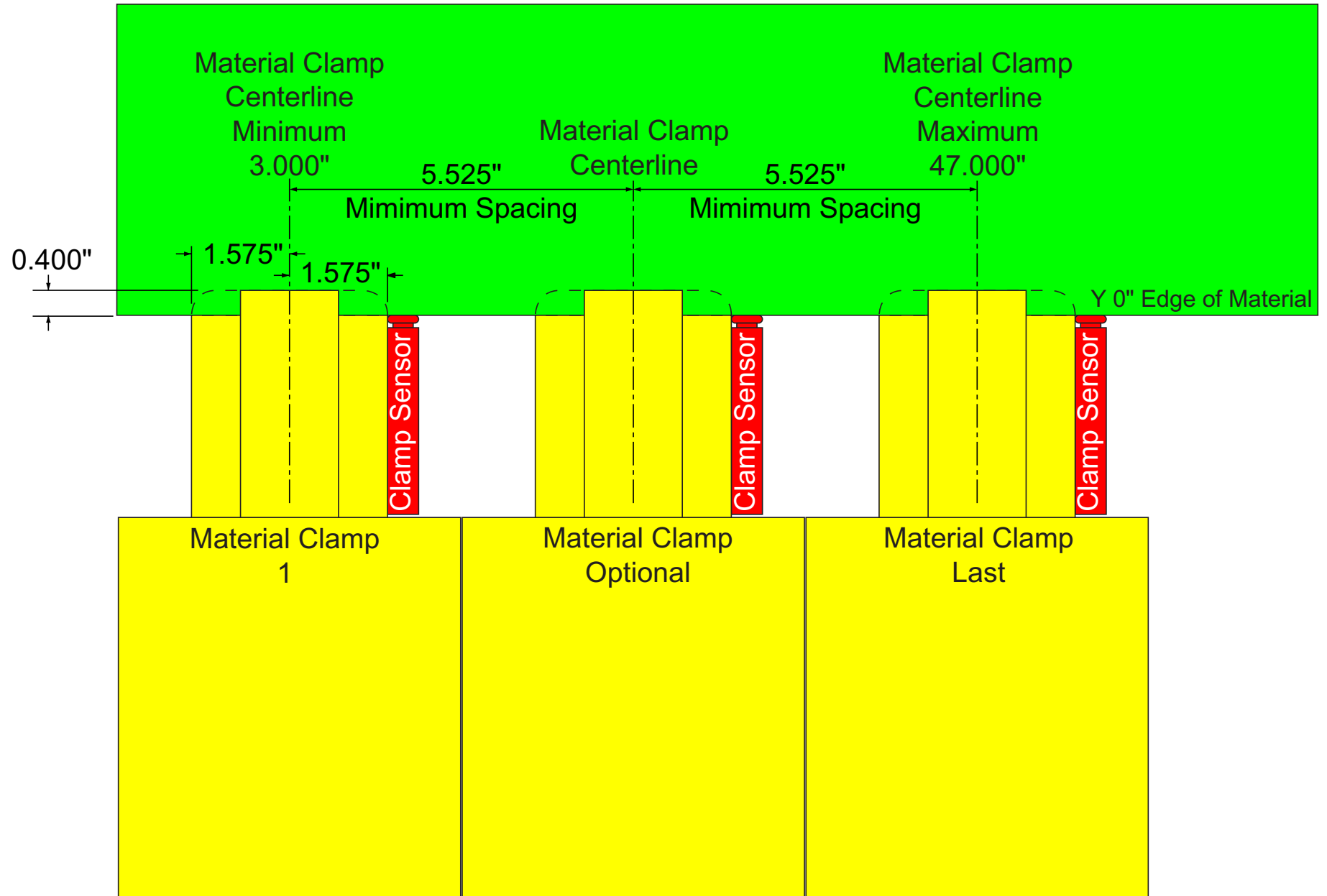
D Size Track 200 Stations



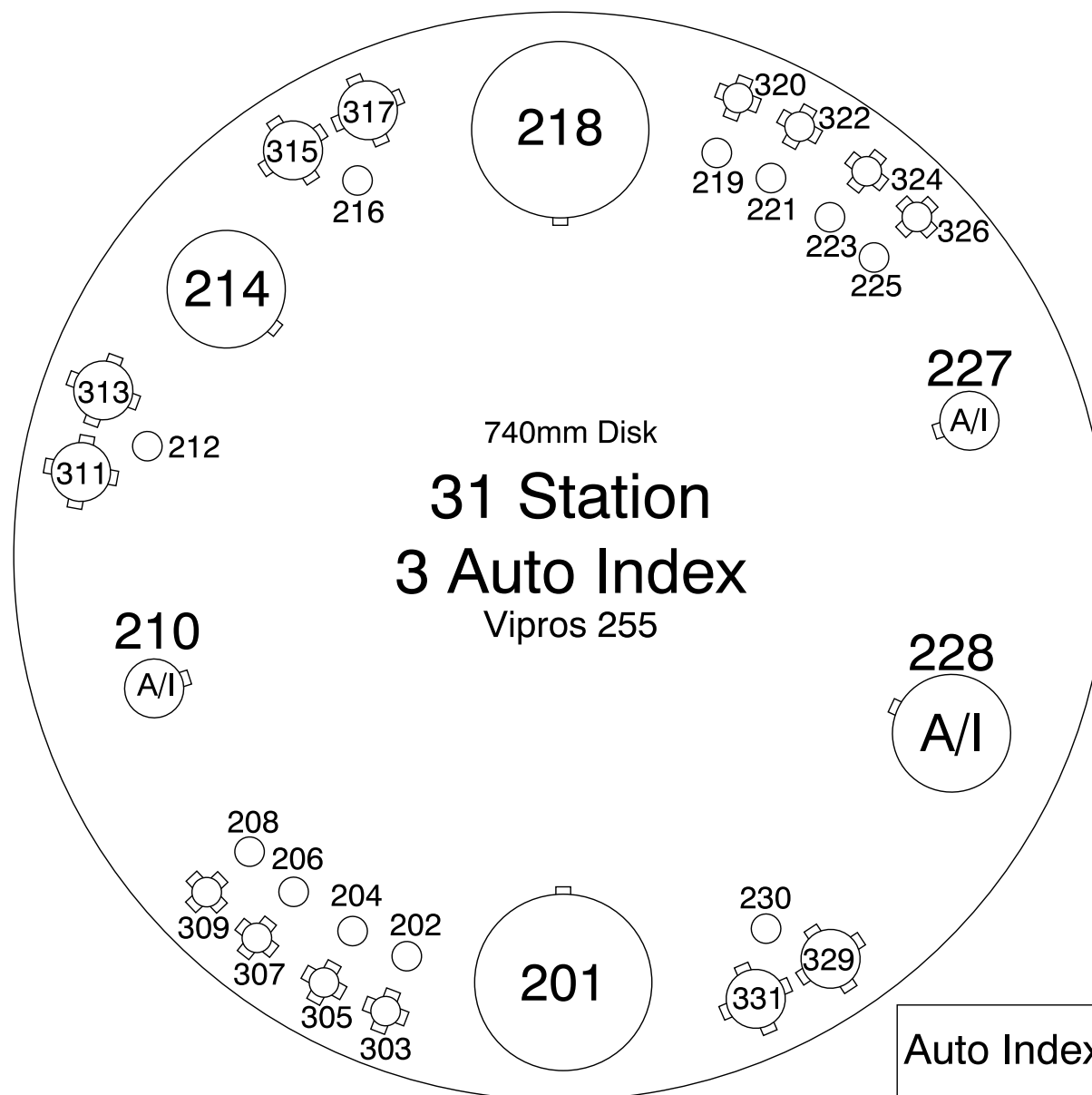
Reposition Holddown Locations



Material Clamp Location



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)