Adjusting Edge Detection On Siemens Controls

1. Place material in work clamps

2. Press **MDA** hardkey

3. Press **MACHINE** hardkey

4. Execute "**EDGEFIND**". This command will detect material edge and do a reposition to place the front edge at X0.0

5. Place "**;**" back in front of EDGEFIND (or delete command)

6. After reposition, execute "**G00X0.0**"

7. Place "**;**" back in front of G00X0.0 (or delete command)

8. Verify that the edge of the material is centered on the die

9. If the material is centered, process is complete. If not, continue to step 10

10. Measure the distance from the edge of the material to the center of the die in millimeters

11. Press **Menu Select** hardkey

12. Press **Parameter** softkey

13. Press **Userdata** softkey

14. Press (**GUD +**) until you are on the GUD page 2 or MGUD, not SGUD or UGUD (dependent on control version)

15. Scroll down to the bottom of the listing to "Edge_Adjustment"

16. Add or subtract the difference found in step 10 to the current value. Adding will move the hole **further away** from the edge and subtracting will move the hole **closer** to the edge.

17. Press "**ENTER**"

18. Return to step 2 and repeat until material is centered on die

End of Procedure

OP-300-3400AII-840AII-A-Adjusting Edge Detect