

## Siemens User Cycles

User cycles are used in part programming to define machine motion and perform special machine functions. Refer to Programming Guide for more details.

Command	Description
CLAMPCONTROL-----	Opens clamps without activating load pin or material stop
CLAMPLOCATION-----	Scans clamps and updates clamp position status
CLAMPVERIFY (X,Y)----	Verifies clamp locations (X= Clamp 1, Y = Clamp 2)
CLEAROFFSET-----	Clears <b>all</b> offsets (both presets and reposition offsets)
FORMINGMODEOFF----	Forming pressure OFF ( <i>modal</i> )
FORMINGMODEON-----	Forming pressure ON ( <i>modal</i> )
INCHMODE-----	Inch mode active ( <i>modal</i> )
MARKINGMODEON-----	Marking pressure on ( <i>modal</i> ) (3400 Heavy only)
MARKINGMODEOFF----	Marking pressure off ( <i>modal</i> ) (3400 Heavy only)
METRICMODE-----	Metric mode active ( <i>modal</i> )
PARTDOOR-----	Activates part door cycle
PRESET(X,Y)-----	Preset command. Used to alter coordinates of X & Y axis
PUNCHOFF-----	Punch OFF
PUNCHON-----	Punch ON
RAMREPO(X)-----	Reposition command utilizing the ram as a hold-down <b>Note:</b> The ram will punch a hole using this command
REPOSITION(X)-----	Reposition command using only hold down cylinders
RESTOREOFFSET-----	Restores reposition offsets after power interruption
SETCUTMODE-----	Prepares torch to cut material ( <i>modal</i> )
SETMARKMODE-----	Prepares torch to mark (etch) material ( <i>modal</i> )
TAPMODE-----	Tap/Drill ON ( <i>modal</i> )
TAPCANCEL-----	Tap/Drill OFF ( <i>modal</i> )
TAPCHANGE-----	Move Y to -60" (-1500 MM) and lowers fixture
TOOLCHANGE("Name")-	Tool change command using descriptors. <i>Used in conjunction with Tool Caddy (optional)</i>
TOOLDEPOSIT-----	Places active tool back onto rail ( <i>MDA ONLY</i> ) <i>Setup command to allow access to all tools and clamps</i>
TOOLPICKUP(X)-----	Picks up a tool from pocket X ( <i>MDA ONLY</i> ) <i>Must be used after a TOOLDEPOSIT command</i>
TOOLPOCKET(X)-----	Tool change command off of back gauge rail
TORCHOFF-----	Turns torch off
TORCHON-----	Ignites torch
TORCHSETTING(X,Y)---	Sets Amperage (X) and Dwell (Y) settings <b>Note:</b> Amperage must also be set on HPR torch screen
YVUNSYNC-----	Parks the V-axis (must be at Y-6.0 (-152.4 mm) or less) <b>Note:</b> V-axis must be parked to torch, drill, or tap)
YVSYNC-----	Re-synchronizes the Y and V axes <b>Note:</b> Y and V must be synchronized to punch)

**Part Handler II™ Specific User Cycles**

EDGEFIND-----	Aligns the leading edge of material in X axis
MATLTHK-----	Used to verify proper material setup ( <i>optional</i> )
RAWLOAD-----	Performs auto load of material from stock to machine <b>Note:</b> X axis must be in correct position before executing
STOCK_TABLE-----	Moves platen to stock table