Signify

VISUAL WORK INSTRUCTION

Amada 002 Model 357S

Operator

Definitions:
1: ☐ Ops Description   2: 🟦 Quality Check / Verification   3. 🟨 Safety Awareness

Proper Powering On Visual Work Instruction

Step 1

Turn on Circuit Breaker on East side
of machine.

Step 2

Push green ON button to the left of the screen.

Step 3

On machine start up, turn key to reset and then back to run to reset the light curtain.

Step 4

Safety check, Refer to bottom left side of control panel. Red lights indicate a problem. (Oil Leaks, Air Pressure, etc.)

Step 5

Verify that the light curtain is free of any obstructions and is in working condition.

Step 6

If the light curtain presents a lockout situation, make sure the light curtain is free of any obstructions. Then turn the key to reset and then back to run.
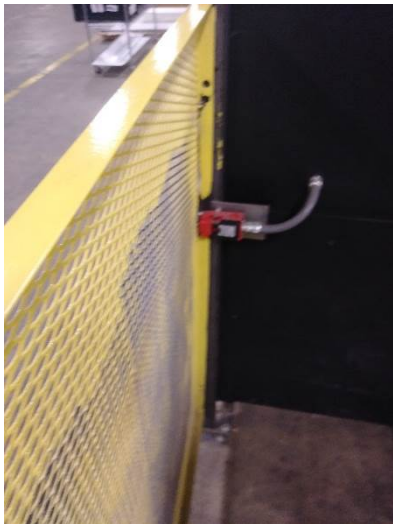
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Proper Powering On Visual Work Instruction

Step 7

Verify that the gate is closed before starting machine. If the gate is opened while the machine is running, restart the machine.
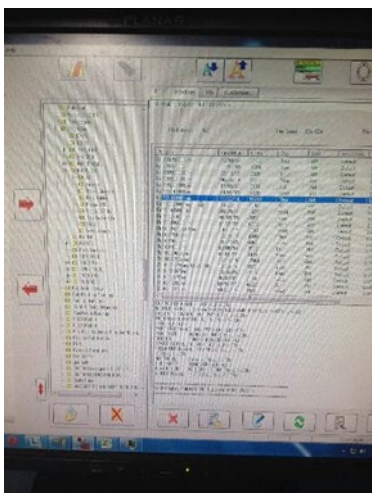

Step 8

Turn selector switch to edit.

Step 9

Delete old order that has been completed (ex. O#####). Put in new order (ex. O####) Press Read button, (will be blinking)

Step 10

Refer to computer for this machine, highlight Amada 002 as the Machine, scroll down to job number and click send.

Step 11

Go back to control panel, turn selector switch to manual.

Step 12

Open doors to turret and change to needed tooling.

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Step 13

Jog turret to desired tool by pressing and holding right or left green turret jog button.

Step 14

For assistance with tooling use tool holder to lift and place tooling where needed. Inspect tool holder for possible problems before using.

Step 15

To use tool holder, turn the selector switch ($4^1/_2$) to OFF. This will allow you to pull down the end of the holder to fasten the tooling.

Step 16

Place threaded end of holder in desired tooling, and tighten. Be sure not to cross-thread. Before the next step make sure end of holder is tight in the tooling.

Step 17

To lift the tool out of Turret, turn the (4 ½) switch to ON and it will lift the tool automatically. Keep hands clear of tool and cylinder while performing this step. Before rotating turret be sure that tooling is not obstructing in any way.

Step 18

When finished with tool holder and tool changing be sure to fold back into closed position and close all doors.

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Step 19

Set clamps to dimensions given on setup sheet.

Step 20

Refer back to control panel to reference bed and clamps. Turn selector switch to manual then hold down X+ and Y+ until ORIGIN lights for both of these turn green.

Step 21

Press and hold turret button until ORIGIN light comes on the reference turret.

Step 22

Turn selector switch back to memory, machine is ready to run.

Step 23

Press foot pedal to open clamps.

Step 24

Once metal is loaded and clamps in place, make sure the override confirmation switch is OFF

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Step 25

Press the Cycle Start button to start machine cycle.

Step 26

When the clamps reach the Clamp Protection Zone, press the Override Confirmation button. (This only has to be done on the first cycle to store it in memory)

Revision

Revision Number	Date	Changes	Revised By
1	05/30/15	Initial issue.	J.Warren/B.Carter/T.Jones
2	10/06/17	Edited Steps 3,5,6,26	Chris Holder/Alan Blansett

Review

Date	Reviewed By
05/30/15	Ken Riley/Les Griffin
10/06/17	Ken Riley