### **CALIBRATION OF RAM Y1 & Y2**

- 1 Clean all surfaces of punch and die.
- 2 Go to manual operation mode.
- 3 Bring top punch close to bottom die.
- 4 Move bottom die to any flat surface aligned with top punch.
- 5 Set punch down on bottom die.
- 6 Check for light gaps between punch and die.
- 7 If there are gaps, loosen 2 top bolts and 1 middle bolt on punch holder.
- 8 Tap wedges with brass punch and hammer and retighten all bolts.
- 9 Add the Effective height of punch and die together.For example 4.331 + 3.94 = 8.271



Write this number down.

10 Check current on Y1 & Y2 if not same as your Effective height (8.271), take 8.271 and subtract current reading of Y1 and Y2 separately. Write down the answers.







Enter the new values into the reference positions

Now reboot the machine:



