CYBELEC
INFRANOR GROUP COMPANY

CybTouch Series

User Manual

for Shears

MARCH
2021
V5.1

Table of Contents

SAFETY

GENERAL SAFETY

The users must have **Read** and **Understood**, but most of all must Respect the directives described in this manual.

All people coming into contact with the machine on which the numerical control is installed, whatever their function or whatever state the machine is in (assembly, disassembly, start-up, production, maintenance, repairs) must have read and understood the requirements concerning the security and the entirety of the directives of operation described in the manuals delivered with the machine.

The operator must be properly trained to work with the machine on which the numerical control is installed. Improper use of the numerical control can cause heavy damage on equipment and/or injuries to people.

Modification of machine parameters can cause important material damage or lead to irregular product quality.

Do not expose the numerical control to excessive humidity to avoid any risk of electrocution and any deterioration of the equipment.

Make sure the numerical control is disconnected from the mains power before carrying out any cleaning. Do not use liquids based on alcohol or ammoniac.

In case of malfunction of the numerical control, call a technician.

Do not expose the numerical control to direct sun rays or any other heat source.

Do not place the numerical control in the neighbourhood of magnetic equipment such as transformers, motors or devices which generate interference (welding machines, etc.)

SIGNS AND ICONS APPEARING IN THIS MANUAL

While using this manual, you will come across the signs and icons represented here below: they are directly related to the safety and security of persons. Carefully follow this advice and inform others about it.

General warning

This warning sign appears in the manual whenever it is necessary to pay attention to rules, instructions or advice. The correct sequence of operations is to be followed in order to avoid damage to the machine.

Symbolizes a serious personnel danger.

Information

This warning sign appears in this manual whenever an important information needs to be taken into consideration. Pay attention to this sign and follow the instructions given.

Settings

This sign appears in this manual whenever SETTING INSTRUCTIONS are given. Pay attention to this sign and follow the sequence of instructions given.

Navigation

This icon appears in this manual to give navigation information, to give the path to the subject treated in the chapter.

GETTING STARTED WITH CYBTOUCH

Depending on software evolutions and the press brake controlled by the CybTouch (configuration/capabilities), the present manual may not fully correspond to the CybTouch that you currently have. However, differences are only minor.

This manual describes all features of

- CybTouch 8W, 8G and 12G

Touchscreens are pressure sensitive.

Do not press down hard on the screen.

Pressing hard on the screen will damage the display. Such damage is not covered by manufacturer warranty!

Do not use sharp and/or pointed objects (sheet metal, screwdriver, metal pen ball, etc.) to touch the screen; only use your fingers (with or without gloves on) or a plastic pen. Make sure that your gloves do not have metal particles encrusted in the fingertips as they may also damage the screen.

Take a few minutes to practice pressing gently on the screen, you will find that the screen is very reactive, and it is pleasant to use.

GENERAL NAVIGATION

Menu Button

The Menu button allows you to directly select (jump to) the desired screen. The content of the menu changes contextually.

Status Page Zone

The Status pages zone gives access to the Status page. This is really a zone that is active at any moment from any page.

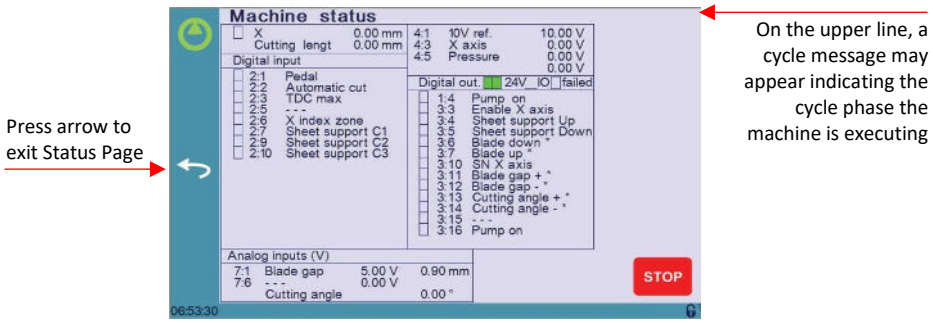
Screen Cleaning

To clean the screen while the CybTouch is on, touch the button.
Use only a damp and smooth cloth with soap or a neutral detergent.

NEVER use solvent, petrol, benzene, alcohols, etc.

STATUS PAGE

The Status page shows the status of all inputs and outputs and axes positions of the NC.
This feature is very useful during setup or during phone service with a machine installed in the field.
This page is accessed from anywhere by pressing the Status Pages Zone.
To exit the Status page, press on the arrow on the left.



Press arrow to exit Status Page

On the upper line, a cycle message may appear indicating the cycle phase the machine is executing

Axes have specific indicators. Their colour indicates the position of the axis relative to the tolerance.

Possible states are:

- : Device not active and in the tolerance.
- : Device moving.
- : Device not active and outside of the tolerance.

USER PREFERENCES

(Menu Button) → Other menus → User preference

To exit the User Preference page, touch the button.

Language

To browse through the available languages, simply touch Language on the screen.
Available languages are:

- EN English.
- CN 中文.
- CZ Český.
- DE Deutsch.
- ES Español.
- FR Français.
- IT Italiano.
- NL Nederlands.
- PL Polski.
- PT Português.
- RU Русский.
- TR Türkçe.
- TW 台灣.

The list of available languages is subject to change and may increase over time.

Length Units

This parameter allows choosing between mm, inch and none for the length unit to be used in the CybTouch.

When none is selected, the units used are millimetres.

Show axes position values

This function will display the axes positions on the Program Page.

- When set to no, the position of axes is displayed during the respective movements.
- When set to yes, the positions of the axes are constantly displayed under their respective set-point values.

AutoCut TDC Time

This parameter allows defining the waiting time (max 2 seconds) at top dead centre between 2 cuts in Automatic cut mode.

It is used to give the operator enough time to position the sheet against the back gauge before the blade comes down again.

Sheet support

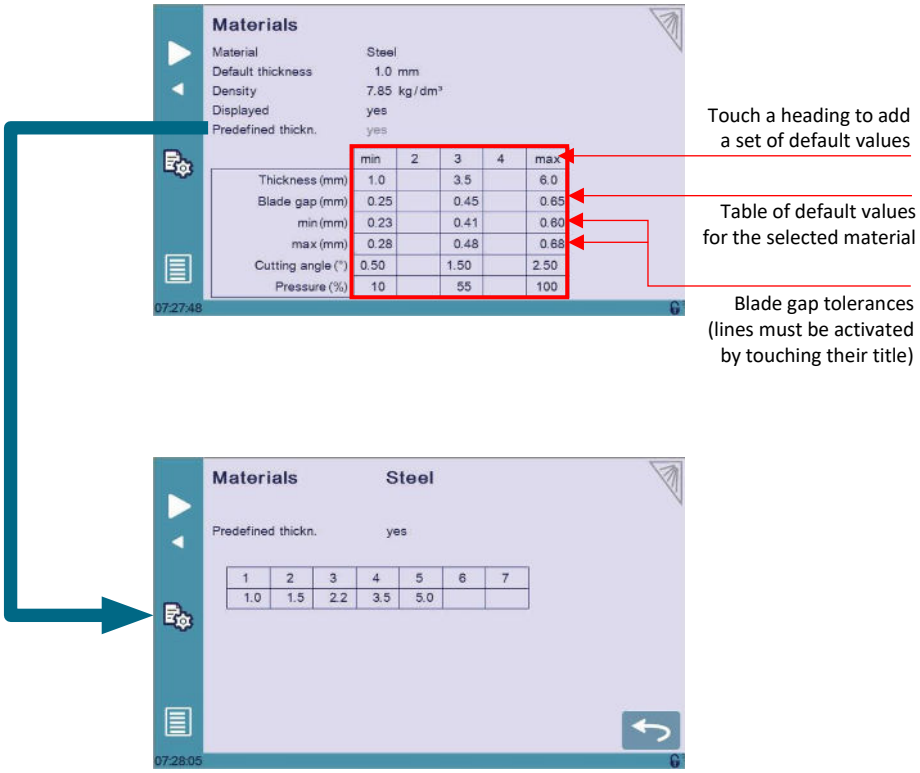
This parameter allows choosing if the sheet support returns into position automatically or manually at the end of a cycle. When Manual return is selected, the operator must press the START button or the pedal at the end of a cut for the sheet support to return to its original position.

This preference is of course only available on machines equipped with a sheet support, and under certain conditions.

Materials

Touching Materials opens the Materials page, where the default characteristics for each material can be changed, or a new material can be configured.

This page may not be available, depending on the machine parameters' configuration. To be allowed to access the Materials page, a level 2 password is required



The Materials page displays:

- Material: Selected material (here Steel).
- Default thickness for the material.
- Density: Default density for the material (here 7.85 kg/dm³).
- Displayed: If the material will be available to be selected for use (here yes).
- Predefined thickn.: Allows defining up to 7 different predefined thicknesses for the selected material.

In the table at the bottom of the screen, the min and max columns must be filled for each material. Whether or not extra sets of values are added, the software simply extrapolates values between two completed columns.

Three predefined default materials are available (steel, stainless steel, aluminium), but others can be added.

To add a material:

1. Touch **Material** and select a non-configured material (Mater X) from the list.
2. Enter the new material's characteristics.
3. Touch the name (Mater X) to display the keyboard and enter the name of the new material.

RFLink

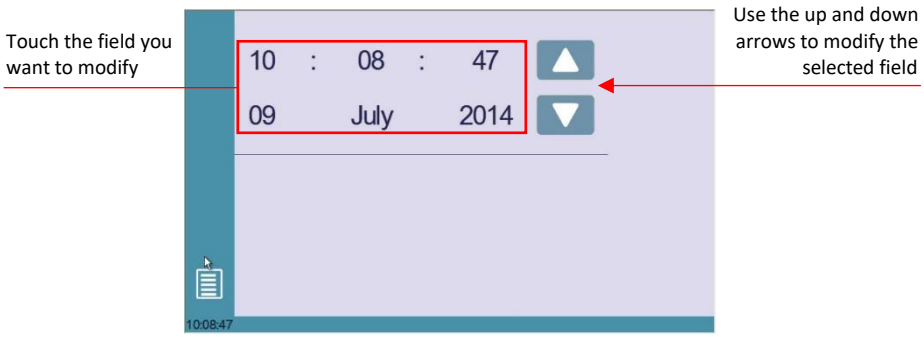
When activated, this function allows communication between the CybTouch and a laptop computer, onto which Cybelec's RFLink dongle is plugged in. This function's default status is **off**, and it is automatically reset to **off** every time the NC is turned on.

Clear indexation

When activated, this function clears the index and the machine will search for them, as it does when turning the power on, allowing the operator to re-index its machine without turning it off.

Set Clock

Allows the user to set the time and date on the CybTouch.



Touchscreen Calibration

As a tall operator will tend to touch higher than a smaller one on the screen, this function allows the calibration of the touch screen, and also makes sure that it is operating correctly.

SETTING INSTRUCTIONS:

Simply follow the instructions on the page to calibrate the touchscreen.

Use your finger or the plastic tip of a pen to calibrate the Touchscreen. Never use sharp objects as this will damage the screen.

Brightness xx% Eco xx%

Here the brightness of the screen for normal mode and Eco mode can be defined:

1. Touch the mode for which you want to modify the brightness.
2. Use the − + buttons to set the brightness.

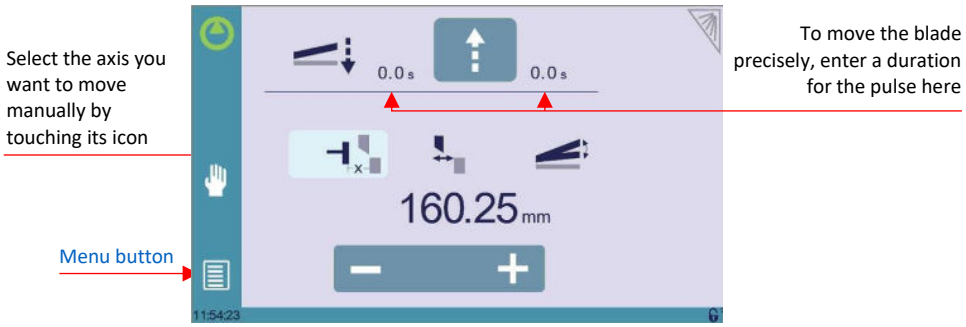
Program counter mode

Select here if the part counter must count up (from 0 to the desired quantity or down (from the desired quantity to 0).

MANUAL AXES MOVEMENT

In the course of setting up a machine, it is sometimes necessary to be able to move the axes manually, for example when changing the tooling. This can be done on this page.

(Menu Button) → Other menus → Manual movement



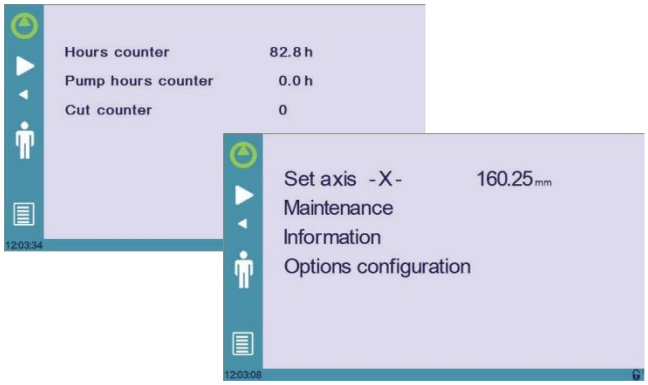
SETTING INSTRUCTIONS:

1. Select the axis that you want to move:
   - for the back-gauge X axis.
   - for the blade gap.
   - for the cutting angle.
2. Touch the buttons to move the selected axis.
3. Use the foot switch (Low Speed Down movement) and this button (High Speed Up) to move the blade.

If no specific duration is entered, the axis will move as long as the command (pedal or button) is activated.

SERVICE PAGE

(Menu Button) → Other menus → Service → Service



Set Axis

Allows the operator to manually adjust the position of the back gauge (axis X).

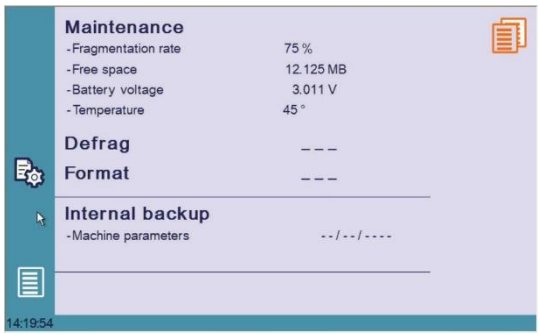
This function must be used with utter care and only by experienced personnel. Wrong settings may mechanically damage the machine.

Settings are lost after indexing the machine.

Maintenance

The Maintenance page displays the hardware status of the CybTouch and lets the operator perform different maintenance actions.

(Menu Button) → Other menus → Service → Service → Maintenance



All the following actions require codes and should only be performed by technicians or upon request of a technician.

Defrag

The defragmentation function is made automatically and rearranges the memory space of the CybTouch. Upon request from a technician, it is however possible to do it manually from here. Simply follow the instructions given in the yellow pop-up window.

Format

This function will erase all data in the CybTouch. Only use this with the help of a technician.

Internal backup

This function is specially designed for OEM and support.

Usually a machine parameters' backup is made by the machine manufacturer or the company who services the machine. This backup allows a maintenance technician to restore original working parameters if necessary.

Should there be a need to restore parameters, call on a maintenance technician and follow his instructions.

Do not try to use this function unless you are in dire need.

Information

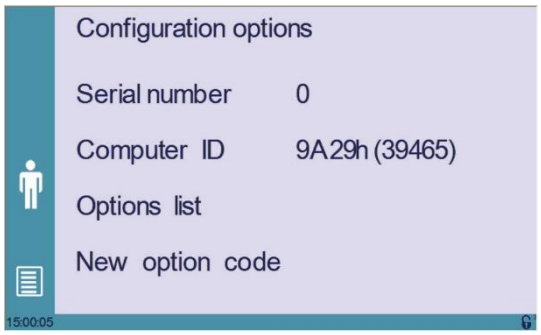
The Information page displays the names and versions of the software installed on the CybTouch. Pressing the Advanced button shows more detailed information.

(Menu Button) → Other menus → Service → Service → Information

Configuration options

Touching this menu opens the following page, where one can find the computer's identification and manage the machine's options.

(Menu Button) → Other menus → Service → Service → Configuration options



Serial number
This is the serial number of the CybTouch. It is entered at the factory at the end of the machine's initial setup and is related to the machine's option list.

Changing the serial number means that all the options installed on the machine can be lost.

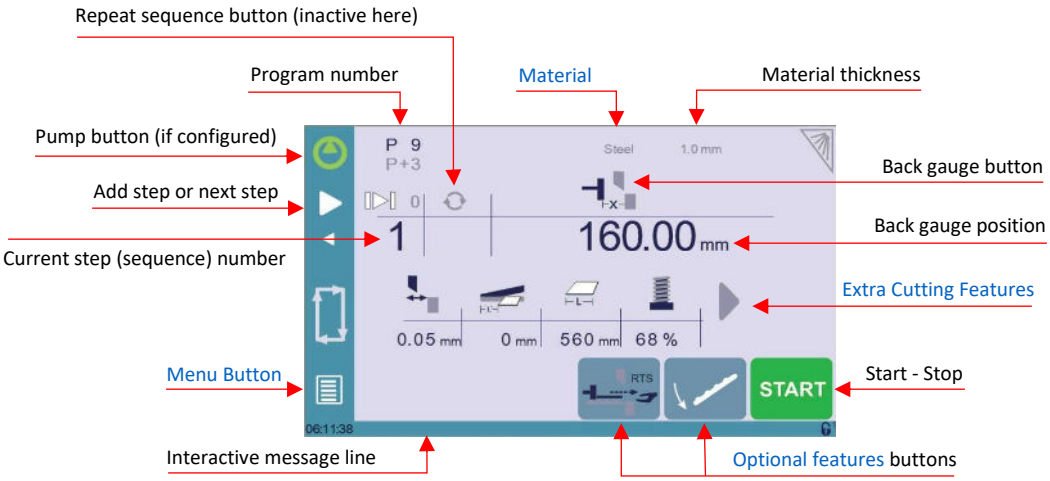
Computer ID
This line displays an identification code that is unique to each CybTouch and guarantees, together with the serial number, a correct identification of the machine.

Option list
This function opens a yellow pop-up window where all the options installed on the CybTouch are displayed.

New option code
The function opens an alphanumerical pad where the code of the new option must be entered. The format of an option code is ABC-DEF-GHI-JKLM

BASIC PAGE DESCRIPTION

PROGRAM PAGE



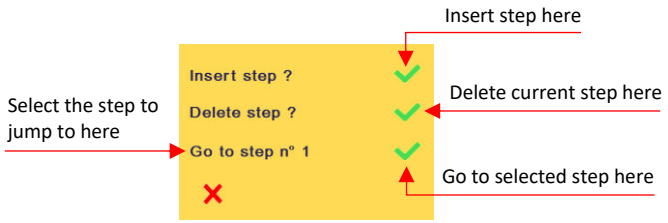
Available functions on the Program page

The Program Page is normally the working page, from which the cuts are executed, and most of the navigation originates from and leads to.

Current step (sequence) number

Touching the step number will open a yellow pop-up window as shown here, with 3 different actions to choose from:

- Insert step: this function will insert a step after the current one.
- Delete step: this function will erase the current step.
- Go to step: this function allows jumping directly to the desired step.



The small number next to this button displays the total number of sequences in the program.

Back-gauge button

The back gauge can be activated/deactivates suing this icon. When activated, the Back-gauge position is displayed, allowing the operator to program it according to his needs.

Pressing two seconds will enable the relative positioning. A first absolute sequence must be programmed before.

The back gauge can be deactivated for cuts which do not require a back gauge. It is thus sent to its parking position. The back-gauge position is no longer displayed.

Back gauge position

This value determines the physical position of the X axis, or back gauge. It is a sequence parameter. Its display depends of the setting of User Preference Length Units.

This parameter is only available if the back gauge is activated (see Back gauge button)

Extra Cutting Features

Depending on the configuration of the machine, there can be various other optional features to help the operator to perform tasks. They are located in the lower half of the screen, whether it be the Program Page or the EasyCut Page.

Blade gap

This function may not be available on your machine and depends on its type and configuration.
This icon and the value below represent the blade gap. In general, it cannot be changed and is calculated automatically according to the Material and Material thickness. On some machines however the value can be modified by the operator within a limited tolerance.

For more information about the blade gap's default values and tolerances, refer to chapter Materials.

Cutting offset

This parameter allows the operator to enter an offset for the cut. When activated, it is used in conjunction with the cutting length to determine the BDC

This function is only available on adjustable angle shears.

Cutting length

This parameter defines the width of the sheet metal part that will be cut. It is used to calculate the end of the cut, i.e. the point where the beam stops moving down and goes back up. The value is expressed in sec for a fixed angle shear and in mm for a variable angle shear.

If this parameter is not activated (gray), the CybTouch will not calculate the end of the cut, and the beam will go all the way down to the BDC.

Hold-downs pressure

This parameter allows defining the hydraulic pressure with which the hold-downs will press on the sheet metal plate. The value entered is a percentage of the maximum pressure allowed.

Number of parts

The operator can enter here the total amount of parts to be produced. Every time all the sequences of the program are executed, hence a part is completed, this counter is updated of one unit. When the amount of parts is reached, a yellow pop-up window signals it to the operator.

The parts counter can count up or down. This can be defined in the User Preferences (see Program Counter Mode).

Optional features

The bottom of the Program Page can be populated by a number of different icons, depending on the configuration and type of the machine. Hereafter is a list of the available optional features.

Automatic cut

The AutoCut function allows the operator to continuously cut simply by keeping the foot pedal pressed down. The button turns to green when the function is activated.
If the pedal is released, the AutoCut function is reset to Off.

Sheet support

This button controls the sheet support. It can have different functions according to whether the sheet support is configured to work manually or automatically in sync with the machine cycle.

- When control is manual, touching this button will activate or deactivate the sheet support.
- When control is automatic, touching this button will synchronize the sheet support's state with the actual state of the machine.

In both cases, the button turns to green (like this when sheet support has 2 positions, or like this when it has 3) when the function is activated.

Return to sender

The RTS function (for **R**eturn **T**o **S**ender function) allows the operator to retrieve the piece after the cut without walking around the machine, by making the back gauge move towards him, pushing the piece out the front of the machine.

The RTS function can only be activated if the sheet support is activated. Activating the RTS function will make its button turn green and automatically activate the Sheet support if it wasn't already so.

To retrieve his part, the operator must wait for the button to turn red , which happens at the end of the cut. He can press and hold the button as long as needed to make the back gauge moves the cut piece towards him.

Anti-twist

The anti-twist function can be activated/deactivated using this button. This is a sequence function that can be individually used or adjusted for each step of the program.
When activating the function, the button turns to green and a numerical pad is display, where the operator must enter the required anti-twist pressure (as a percentage of the maximum pressure allowed).

Thin sheet support

The thin sheet support function is activated/deactivated with this button.
The button turns to green  when the function is activated.
This is a sequence function that can be individually used for each step of the program.

Ejector

The ejector function is activated/deactivated with this button. It pushes the remaining piece of sheet metal towards the inside of the machine.
The button turns to green  when the function is activated.

Scrap hatch

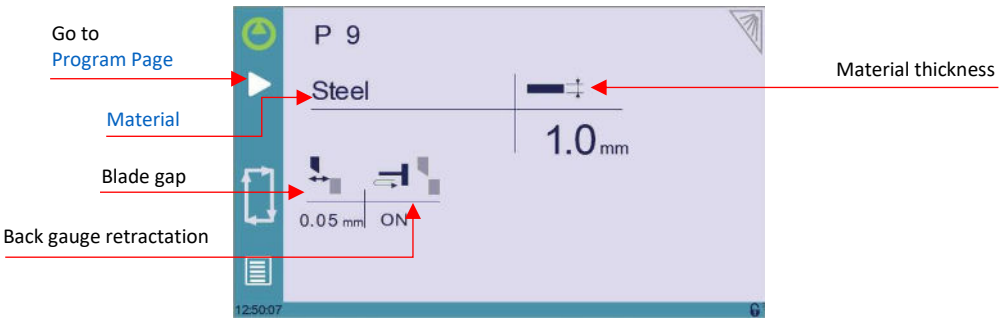
The scrap hatch function is activated/deactivated with this button. It opens a special compartment inside the machine to retrieve scrap cuts.
The button turns to green  when the hatch is open.

Auxiliary functions

The type of auxiliary function controlled by this button depends of the configuration of the machine.
Touching the button activates one, the other or both functions at the same time. The activated function's half of the button turns green when activated.

BASIC PARAMETERS PAGE

Program Page → 



The Basic Parameters page is the first page displayed when creating a new program (see Creating a Part Program), but can also be reached at any time from the Program Page.

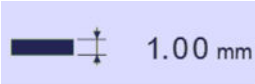
Available parameters on the Basic page

The Basic Parameters page displays parameters related to the part. Depending on the CybTouch configuration and the type of machine, some may or may not be available.

Material

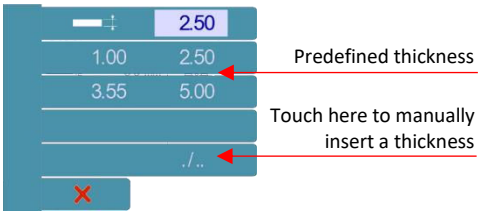
This is not a sequence parameter, but of course a part parameter. Each touch on the material's name selects the next available from the list of Materials.

Material thickness



The default thickness, defined in Materials, is automatically displayed when changing material. It is however possible to change it simply by touching this icon.

If on the other hand, the parameter **Predefined thickn.** is set to **yes, a touch on this icon will open a** numerical pad as show to the right, where the operator will be able to select directly one of the predefined thicknesses.



This is a part parameter.

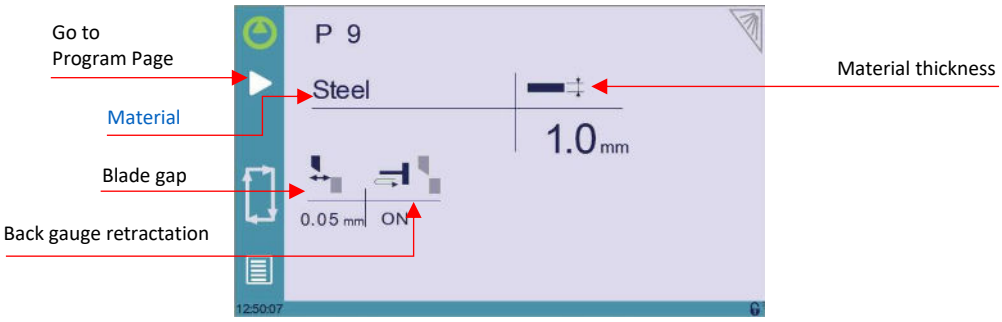
Material

The back gauge retractation can be activated/deactivated here. The retractation distance cannot be changed and is determined in the machine parameters. This is a part parameter, meaning it is applied or not to all sequences of a program.

CREATING A PART PROGRAM

A program is a succession sequences (cuts) that should be executed one after the other in order to obtain a complete part. A program can contain up to 24 sequences and can be stored in the memory for later use.

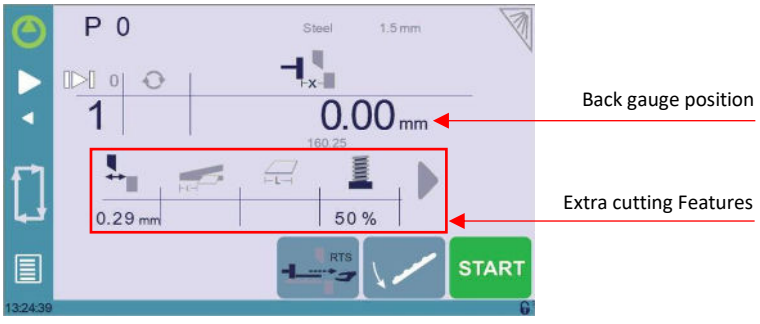
BASIC PARAMETERS



This page is the first page displayed when creating a new program. It contains parameters common to all sequences of the part.

SETTING INSTRUCTIONS:

1. Touch the program number, select New program in the list, and touch Graphical.
2. Touch the Material's name (here Steel) until the desired one is displayed.
3. Touch the Material thickness and choose one of the predefined thickness if available, or simply enter the actual thickness
4. If needed (and available), activate the Back gauge retractation.
5. Touch the ▶ button to go to the Program Page



6. Touch the Back-gauge position value and enter the desired value using the keyboard.

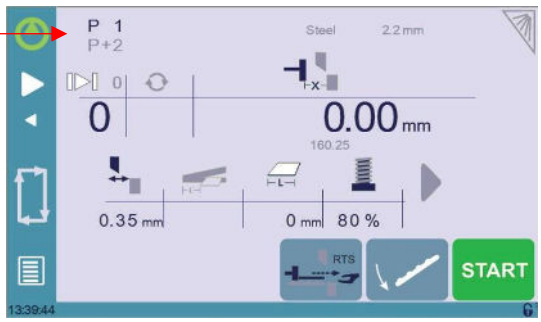
7. If necessary, program any of the desired Extra Cutting Features available.
8. Add the next cut to the program by touching  .
9. Proceed in the same manner to create the other sequence of the program.
10. Go to the desired step touching the Current step (sequence) number or using this  or this  button.
11. Start the hydraulic pump motor (by pressing this button  if available. It turns red when the motor is running).
12. Press the  button to position the machine according to the data that were just entered.
13. When the machine is ready to cut, a  button is displayed.
14. Press the foot switch to execute the cut.

NEXT-PART FUNCTION

This function allows the operator to run two, or several, part-programs one after another. This is very handy when one wants to make a three-dimensional part, like a box for example, or make a final product composed of several parts.

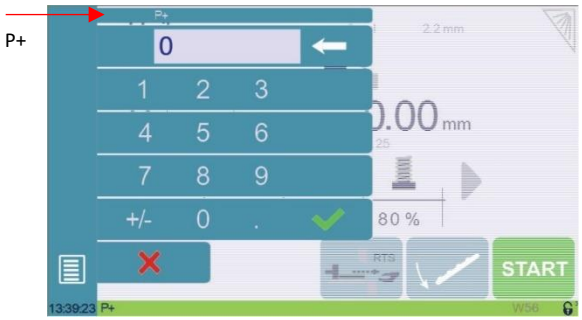
The CybTouch will execute the current program. At the end of the last sequence, instead of returning to the first sequence of the current program, the CybTouch switches to the program selected as P+nn (i.e. the next one). It goes on like this, as long as a part is programmed with a next one.

P2 will be executed after P1



SETTING INSTRUCTIONS:

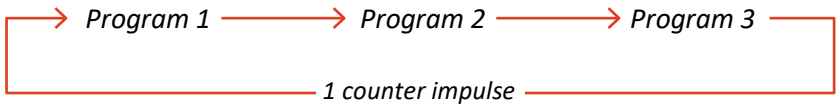
1. To activate the Next-Part function, touch the Program number (e.g. P1) and keep it pressed until the following numerical pad is displayed.



2. Enter the number of the program that must be executed at the end of the current one.
3. Save the program (see Saving a Program).

Cycles and quantities

It is naturally possible to cycle the programs, meaning that the program following the last one is the first one. There are however some specificities to take into consideration when one wants to produce certain number of cycled programs.



In the diagram above, an assembly needs 3 programs to be completed: program 1 is followed by program 2, which in turn is followed by program 3. To complete the cycle, program 3 is programmed to be followed by program 1. In such a case, the value of the part counter will be updated (see Number of parts) of 1 unit when it goes from program 3 to program 1.
The CybTouch is designed like this: every time the program following the current one has a smaller number, the counter value is changed.

When a series of programs corresponds to one single part, make sure that their intrinsic numbers increase chronologically.

MANAGING PROGRAMS

SAVING A PROGRAM

After creating a program, an operator can save the program in order to use it again:

1. Touch the Program number (e.g. **P0**).
2. Touch **Save program**.
3. Enter the number you wish to give to the program (e.g. **1** for **P1**), followed by  .
4. The program is now called P1 and is saved in the CybTouch.

LOADING A PROGRAM

To call (load) a program:

1. Touch the Program number (e.g. **P1**).
2. Touch **Call program**.
3. Select the program to be loaded from the list (e.g. **002** for **P2**).
4. The selected program (**P2**) is then loaded into the work memory and is ready to be used.

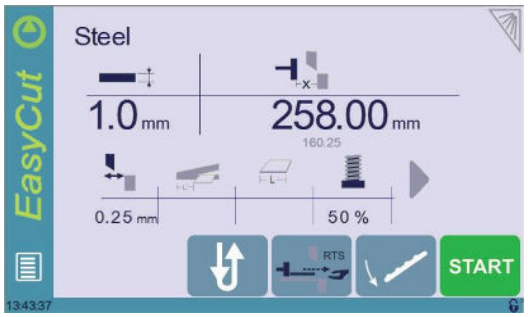
DELETING A PROGRAM

To delete a program:

1. Touch the Program number (e.g. **P1**).
2. Touch **Delete program**.
3. Select from the list the program to be deleted.
4. Touch  to confirm.

EASYCUT PAGE

(Menu Button) → EasyCut



The EasyCut page is used for individual cuts, for example when an external worker needs to interrupt production just to make a single cut.

The program currently being used for production is only temporarily interrupted (no need to save it) when switching to the EasyCut page, and then resumed again when returning to the program page (Menu Button → Current program).

MAKING A CUT ON THE EASYCUT PAGE

See Basic Page Description for more information on the different controls on the EasyCut page.

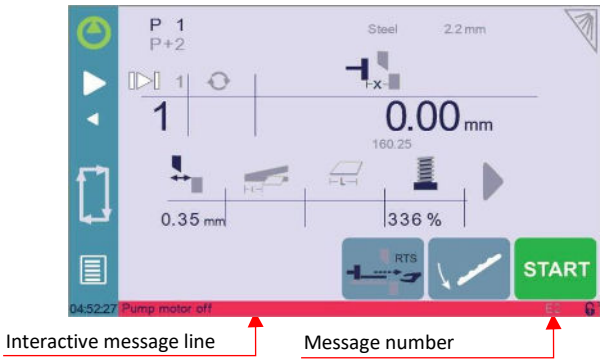
SETTING INSTRUCTIONS:

1. Touch the material's name (here Steel) until the desired one is displayed.
2. Touch the material thickness and choose one of the predefined thicknesses if available, or simply enter the actual thickness.
3. If the back gauge is not needed, deactivate it by touching the Back-gauge button.
4. If the back gauge is needed, enter the desired value in the Back-gauge position field.
5. Start the hydraulic pump motor (by pressing this button if available. It turns red when the motor is running).
6. Press the START button to position the machine according to the data that were just entered.
7. When the machine is ready to cut, a OK button is displayed.
8. Press the foot switch to execute the cut.

ERROR AND WARNING MESSAGES

Following is a list of warning and error messages which may be displayed on the interactive message line of the CybTouch. There are two types of messages:

• Warning Messages, which are displayed on a green background. They are information or instructions that will disappear automatically.



• Error Messages (machine or NC errors), which are displayed on a red background. They inform the user of an error occurring on the machine or NC, and sometimes require intervention by the end user or a technician.

When reporting error messages, please ALWAYS indicate the complete message, including eventual numbers between brackets [ ], and of course the error number at the end of the line. This number also refers to the first column in the section below.

WARNING MESSAGES

MSG NR.	MESSAGE	DESCRIPTION
W01	Value Min/Max (Blade gap)	
W02	Value Min/Max (Cutting angle)	
W03	Code accepted	This message is displayed when the correct password has been entered.
W04	Please press 3 seconds	This message reminds the operator to keep the start pump button pressed for 3 seconds.
W05	The pump is on	This message appears after the pump starting cycle has been correctly executed.
W06	The pump is off	This message indicates that the pump has been stopped.
W07	Index OK	
W08	Touch OK to continue	Indicates that a validation is required to continue.
W09	Parking	This message is displayed when pressing this icon to send the back gauge to its parking position.
W10	Cycle in progress	While this message is displayed, the machine cycle is in progress and the screen is locked, except for the Stop button.
W11	Machine is indexed	Indicates the indexation cycle was successful.
W12	Identification OK	In the Axis Wizard, indicates the identification cycle was successful.
W13	Ignore	This message appears when the desired action makes no sense, like for example clearing the indexation when the indexation was not made.
W14	Enter anti twist % pressure	
W15	“automatic cut” input is not active	The Automatic cut input is configured but not active. It must be active to enable the AutoCut function in the EasyCut page. Usually a switch or key switch is used to enable this function.

MSG NR.	MESSAGE	DESCRIPTION
W16	Eco mode	This message appears when the Eco mode starts, after the timer defined in the machine parameters is over.
W17	Press footswitch to move down	
W18	Empty field	Operator did not enter a value.
W19	24V I/O power on	24V to the inputs/outputs is now available.
W20	Please select a field	This message is displayed when trying to set the time (see Set Clock) and no field (minute, seconds, etc.) has been selected.
W21	Set seconds	In the Set Clock page, when the corresponding field is selected, indicates that it can be set using the up and down arrows.
W22	Set minutes	
W23	Set hour	
W24	Set day	
W25	Set month	
W26	Set year	
W27	Wizard start	
W28	Wizard end	
W29	End of list	This message is displayed when reaching the end of the list in one of the different menus .
W32	Data entry in progress	Operation impossible: data entry in progress. Please finish entering data and try again.
W33	Indexation in progress	Operation impossible: indexation in progress. Wait until the indexation is finished to try again.
W34	RFlink disconnected	When the RFLink connection to a laptop has been shut down from the latter.
W35	Access not allowed	Operator needs another level password.
W37	Moving direction has been inverted	Wizard message: Rotary direction of the motor has been changed.
W38	Counting direction has been inverted	Wizard message: Counting direction of the axis has been changed.
W39	Moving and counting directions have inverted	Wizard message: Both the rotary direction of the motor and the counting have been changed.
W40	OK	Indicates a cycle or operation has properly ended.
W42	No movement executed	Axis Wizard message: Operator pressed but no movement was made.
W43	Waiting input “RTS ready”	A switch makes sure the sheet support is in the correct position for the operator to move the back gauge to retrieve the cut part. Check the RTS switch on the sheet support.
W44	Min BDC limit reached	Minimum BDC limit has been reached, down stroke has been stopped. This may occur in manual mode. If this message appears often in normal cutting operation, the machine parameters need to be readjusted.
W45	Enter unlock interface password	This message is displayed when parameter P04.04 Level 0 Lock HMI is set to yes and the screen is touched.
W46	Enter password level 1 or greater	This message is displayed when a password of level 1 or higher is needed to execute a specific operation.
W47	Enter password level 3	This message is displayed when a password of level 1 or higher is needed to execute a specific operation.

MSG NR.	MESSAGE	DESCRIPTION
W48	Enter new password	These messages are displayed when changing passwords.
W49	Confirm new password	
W50	Enter password for backup	This message is displayed when trying to create a backup.
W51	Enter password for restore	This message is displayed when trying to restore a backup.
W52	Enter password for init	This message appears on the page displayed after the system crashed (soft or hardware problem), when the operator tries to format the machine.
W53	Enter password for deleting all backups	This message is displayed when trying to delete all backups.
W54	Serial number from 100’000 thru 199’999	This message appears only when entering the serial number. It indicates the range of the number to be entered. Attention, this operation is normally done at the factory, with a serial number is related to the options installed on the machine. Do not change it!
W55	New option code	When installing a new option in the Service Page (see page 11).

ERROR MESSAGES

MSG NR.	MESSAGE	DESCRIPTION
E01	Thickness greater than max	The thickness entered for the material is above the maximum value defined in the User Preferences (see Materials, page 7).
E02	Pump motor off	The pump motor needs to be on for the sequence to start.
E03	Buffer Full	The part-program memory is full, you cannot add another sequence.
E04	Code refused	The level code to access the selected page is not correct. Try again or ask for it if you do not have it.
E05	File not compatible	The loaded part-program is incompatible with the NC. This part should be deleted.
E06	Machine parameter file problem	This file is corrupt and cannot be saved. Try to restart the NC. If the problem persists, format the memory.
E07	Machine parameters not compatible, please format data	This message appears when a software update has been made over a much older version and the parameters are no longer compatible. It can also appear if the uploaded parameters (with RFlink) are much older or newer than the current software version and they are not be compatible. A new start-up of the machine must be made. Contact your dealer.
E08	Lismisc File not compatible	Information message, which will disappear when restarting the
E09	Save program problem	NC.
E10	File not found [ ]	This file is corrupt and cannot be saved. Try to restart the NC. If the problem persists, format the memory.
E11	Write to file problem	A file is missing, and the code indicates which one. Call Cybelec with this code to know which file is missing.
E12	X smaller than minimum limit	This file is corrupt and cannot be saved. Try to restart the NC. If the problem persists, format the memory.
E13	X over maximum limit	Operator entered a value under the limit, or a memorized value in the program is under the limit. The wrong value flashes and must be corrected.
E14	Fw SetVar Error [ ]	Operator entered a value over the limit, or a memorized value in the program is over the limit. The wrong value flashes and must be corrected.
E15	“BDC min” input is active	May occur when a feature is configured, but the dedicated input/
E16	Fw Axes Error [ ] ...	output is not configured. Call a technician or your retailer.
E17	Programming error	Min BDC has been reached; the blade cannot descend any more.
E18	Off limit	Axis manager error. The number gives more information. Most common errors are described in messages E55 to E68.
E19	Sheet support X safety	If other error numbers are listed, please send conditions of problem, traces and parameters to the Cybelec Technical support for assistance.

MSG NR.	MESSAGE	DESCRIPTION
E20	Cycle repeat = 0	Cannot start cycle because repeat cycle function is set to “0”.
E21	No material defined (define one or more in MP)	No materials programmed in the Material pages (in User preferences). A material must be selected to perform calculations.
E24	Identification Error [ ]	During the Axis Wizard, there was an error identifying one of the axes. The error number (typically E55, E56 or E57) gives more information. See also message E16.
E25	No FAST task running [ ]	Switch OFF the machine for 1 min and restart it again.
E26	NULL pointer to axis struct.	This message indicates a software bug. Write it all down and contact Cybelec.
E27	MUTEX Error [ ]	This message indicates a software bug. Write it all down and contact Cybelec.
E28	I/O no 24V or overload (output in safety off)	The 24V power supply for the inputs/outputs is no longer present or an output is overloaded. Reset any safety device on the machine, check protection grids and rear guards are closed, etc.
E29	Radio link error, code [ ]	If the problem persists, switch machine OFF for 3 min and restart it again. If the problem still persists, check the machine manual and/or ask a service technician to check your machine.
E30	Touchscreen error, code [ ]	The RFlink chip has detected an error. Check the environment for disturbances (cell phone, wi-fi) and that the material works properly. If the problem persists, write the error number down and send it Cybelec.
E31	Retraction mandatory for the selected thickness	Please contact your machine dealer with this specific code and details.
E33	Pedal released before end of cycle	Cannot disable retraction because the selected material is too thick.
E34	Syntax error in XML file	Cutting length is programmed and operator released the foot pedal before the cutting length was reached. In such case, the cut is considered as not finished. In the program, CybTouch doesn’t jump to next step. Keep pedal pressed until the beam automatically returns.
E35	Memory allocation problem	This file is corrupt and cannot be used. Try to restart the NC. If the file is a part-program, try to delete it.
E36	(xml)	There was a problem while trying to read a file in the memory. The file is probably corrupted. The number gives more information, write it down.
E37	Endless loop on process task	Process error. Please restart the NC and inform your dealer.
E38	Thickness smaller than min	The thickness entered for the material is below the minimum value defined in the User Preferences (see Materials, page 7).
E39	WARNING: Overloop intern	This error should normally never happen on the machine. It means there are too many elements in a coded list.
E40	Unknown key	There is a list of known screen zones, and the pressed zone is not in it. This error can normally not happen in the field.
E41	“Pedal” input refused	Pressing the pedal is not accepted in this page/situation.
E42	Error calculating resolution	This message appears if entering improper values during the Cutting Length Wizard. Start the wizard again, measure and enter values with care.

MSG NR.	MESSAGE	DESCRIPTION
E43	Configuration error	Input/output incorrectly configured in machine parameters; the error input/output page is displayed. Check for unauthorized doubled output or inputs. This message can also be displayed if the chosen configuration requires more icons on the first page than their room available.
E44	“External stop” input is active	External stop may be caused by safety devices, emergency buttons, rear protection guards, etc. See machine instructions.
E45	“Blade gap” analog input not configured	While configuring (setting up) the CybTouch, dedicated input or output were not configured but are requested to run properly.
E46	“Pressure” analog output not configured	Same message as E45, but for the pressure.
E47	Error calculating cutting angle	These messages appear if entering improper values during the Cutting Length Wizard. Start the wizard again, measure and enter values with care.
E48	Error calculating cutting length	The back-gauge cycle (see Back Gauges) cannot start because the beam is locked.
E49	Max pressure moving to TDC	While the beam was returning to TDC, the CybTouch provided maximum pressure output, perhaps due to a friction point or a setting point. This case should not occur.
E50	Value out of limit	This message is displayed when the value the operator is trying to be program is bigger than the maximum authorized value.
E51	Error[ ][ ][ ][ ]...	Internal management error. Write the error’s codes down and the software’s number (see Information, page 12) and call Cybelec.
E52	“Blade gap2” analog input not configured	Same message as E45, but for the second blade gap.
E53	“TDC Max” digital input not configured	Same message as E45, but for TDC max.
E54	“BDC Min” digital input not configured	Same message as E45, but for BDC min.
E55	Identification Error 1 (No motion detected)	No motion detected. Should not happen if you started the Wizard from the beginning. If the error remains, check limit switches, drive, wiring, etc.
E56	Identification Error 2 (Not enough oscillations)	Not enough oscillations Increase the identification time. See machine parameters manual.
E57	Identification Error 3 (Amplitude of the oscillation)	Oscillation amplitude. Increase the identification voltage. See machine parameters manual.
E58	Fw Axes Error 32 [Trajectory tracking error]	This is a regulator error. The axis could not follow its trajectory. Reset the error. If problem persists, call a technician.
E59	Fw Axes Error 311 [MaxSpeed too high !]	Max speed or encoder resolution too high.
E60	Fw Axes Error 312 [MaxSpeed too small !]	Max speed or encoder resolution too low.
E61	Fw Axes Error 313 [Acceleration too small or MaxSpeed too high !]	Acceleration too low (mm/s2) or max speed too high. This needs to be corrected. Please note that acceleration is not a ramp distance.
E62	Fw Axes Error 314 [Acceleration too high or MaxSpeed too small !]	Acceleration too high (mm/s2) or max speed too low. This needs to be corrected.
E63	“Cutting length” analog input not configured	Same message as E45, but for the cutting length.
E64	“Cutting length” encoder not configured	Same message as E45, but for the cutting length encoder.

MSG NR.	MESSAGE	DESCRIPTION
E65	X axis is not configured	RTS is configured in machine parameters, while X axis is not configured. X axis must be configured for the RTS function to be available.
E66	Fw Axes Error 33 [Maximum voltage time exceeded (10V)]	Same message as E58.
E67	Fw Axes Error 39 [Speed tracking error]	Same message as E58.
E68	Fw Axes Error 316 [MinPosition or MaxPosition outside limit !]	The axis management detects a set-point outside the limits. Check all the axis parameters. If the error occurs frequently, make a trace and send it to Cybelec.
E69	Parking not allowed with RTS	Parking and RTS functions cannot be used at the same time. Deactivate one or the other.
E70	Blade gap out of limit	When a movement is attempted, the blade gap is out is out of machine limits. Check the Material page.
E71	File access error	There was an error when trying to access a file while programming an option. Make sure that the code was entered properly. If it is not working, try and restart the NC. If the problem persists, contact Cybelec.
E72	Unknown error	An unknown error occurred while trying to program an option. Contact Cybelec.
E73	Thin sheet support X safety	A safety zone is defined while using the thin sheet support. The thin sheet support cannot be used while X is programmed in that zone.
E74	(max x mm)	The code entered for the new option you try to install is not correct.
E75	Bad serial number	The timer defined in the machine parameters is expired. Check the back-gauge's parking movements.
E76	Parking on time out	Same message as E75.
E77	Parking off time out	Thickness of the sheet is bigger than the limit defined in the machine parameters.
E78	Thin sheet support thickness too high (max x mm)	When trying to make a cut, the CybTouch detected that the beam's calibration was not OK. If the problem persists, call a technician to check the machine parameters and check the values.
E79	Beam Calibration probably not	During the Cutting Length Wizard, the beam has not reached TDC max.
E80	OK	This message is displayed when the machine is equipped with 2 blade gaps and the operator tries to select one of them in the machine parameters without unlocking the padlock first.
E81	"TDC max" input is not active	Thickness of the sheet is bigger than the limit defined in the machine parameters.
E82	Movement locked	This message is displayed when trying to use the anti-twist function with a back-gauge position (X axis) inferior to the minimum allowed defined in the machine parameters.
E83	Sheet support thickness too high (max x mm)	Thickness of the sheet is bigger than the limit defined in the machine parameters.
E84	Anti-twist X safety (min x mm)	This message appears when an up or down order is given to the sheet support and the corresponding input has not changed state before the timer defined in the machine parameters ran out.

MSG NR.	MESSAGE	DESCRIPTION
E85	Sheet support digital inputs (C1,C2,C3)	This message appears when the corresponding inputs for the sheet support have not been configured.
E86	Sheet support digital outputs (Up, Down)	This message appears when the corresponding outputs for the sheet support have not been configured.

RESOURCES

TUTORIALS - VIDEOS

Please subscribe to our YouTube channel to have our latest videos and tutorials.

https://www.youtube.com/channel/UCLBu-RxCGGf_epuHtMwoAcQ

Don’t forget to click on the ring bell button to stay in touch!

Your feedback is very important for us in order to improve our equipment.

Please, let us know if you have any suggestion

Mail us to our support: support@cybelec.ch