

5.2.2.2 **Operating Mode Key**



The ETS 250 has three operating modes:

- JOG
- AUTO
- MANUAL

Each time the Operating Mode key is depressed, the next mode is selected and indicated in the dialog box directly above the key.

In all three modes, the press ram step begins when either the palm pushbuttons or footswitch is pressed.

5.2.2.2.1 **Jog Mode**



In JOG, the press ram will stop in place:

- At any point in the step, if the palm pushbuttons or footswitch are released.
- Once it reaches the program bend point or the preset tonnage limit.

To raise the press ram:

- To the program up-limit, switch to AUTO or MANUAL, then push and release the palm pushbuttons or footswitch.
- To an un-programmed position, push RAM UP and release when the press ram is at the desired position.

NOTE: The press brake should be used in Jog mode for setup proposes only.

5.2.2.2.2 **Auto Mode**



In AUTO, the press ram returns to the program up-limit:

- At any point in the step, if the palm pushbuttons or footswitch are released.
- After reaching the program bend point
- After it reaches the preset tonnage limit.

To begin each step, release and push the palm pushbuttons or footswitch.

5.2.2.2.3 **Manual Mode**



In MANUAL, the press ram returns to the program up-limit:

- At any point in the step if the palm pushbuttons or footswitch are released.
- After it reaches the preset tonnage limit.