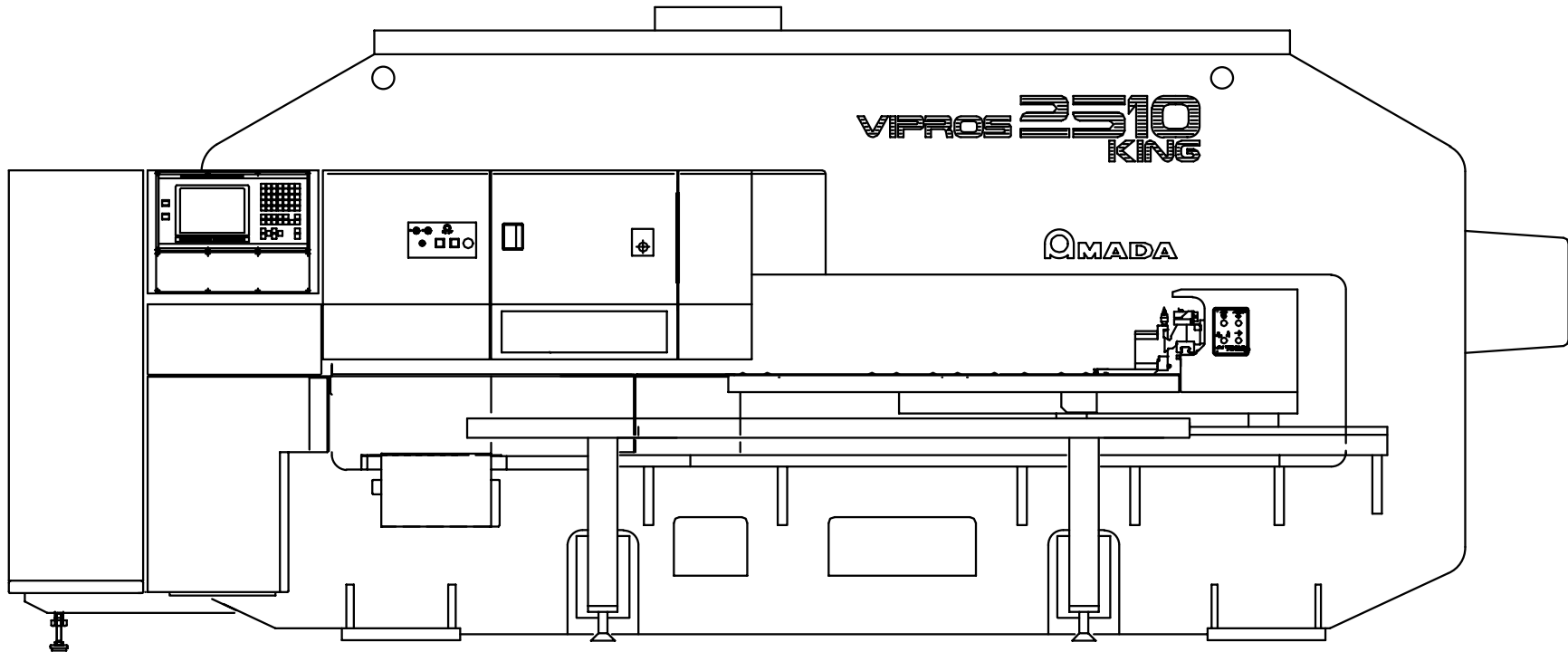


# Vipros 2510 Machine Programming Limits



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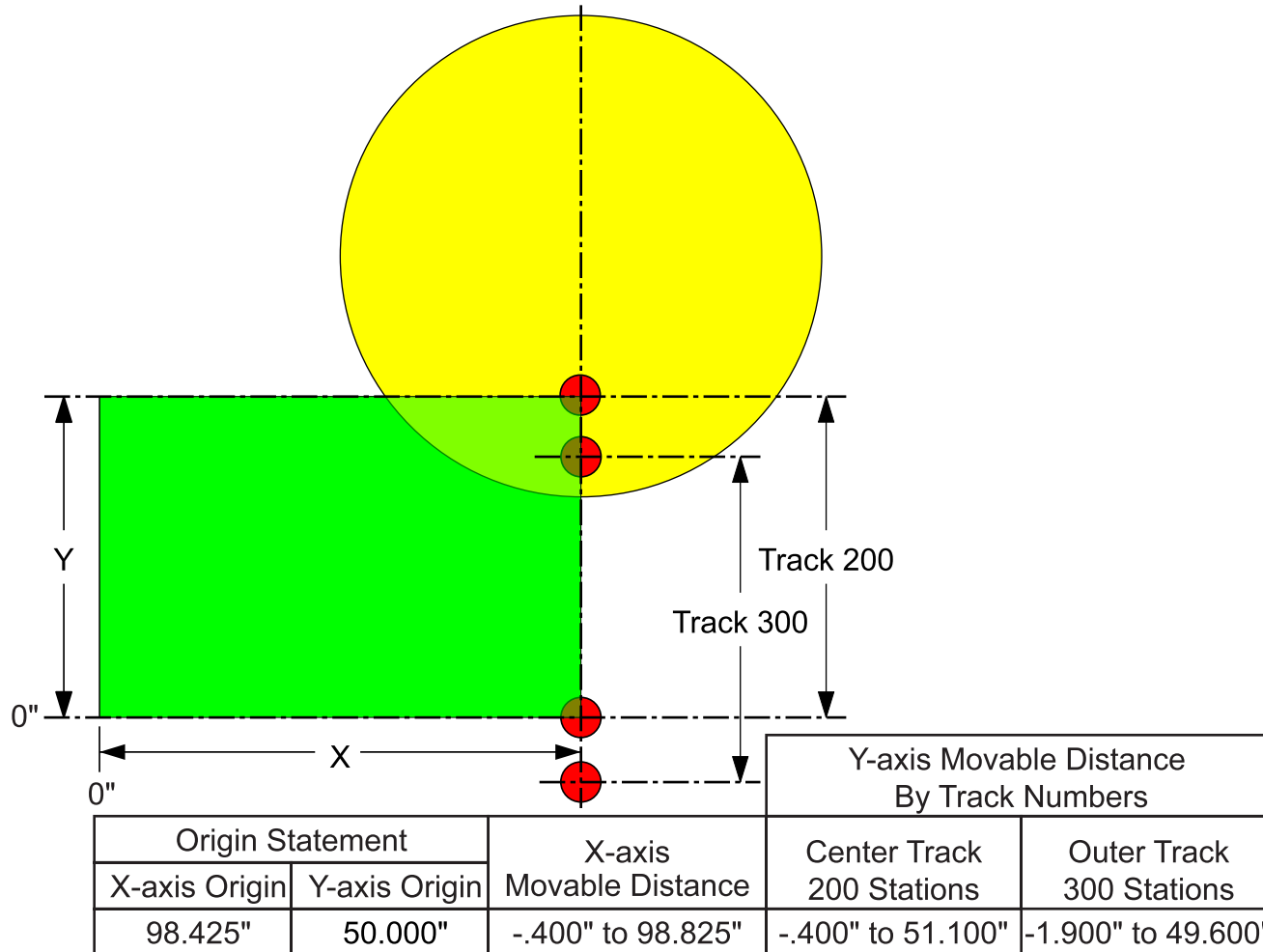
Amada America Inc.  
7025 Firestone Blvd.  
Buena Park, CA 90621  
Phone: 714-739-2111  
Fax: 714-739-4099  
Email [info@amada.com](mailto:info@amada.com)

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# Programmable Travel Limits



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## Programmable Feed Rates

### Punching Mode

F1	=	X3937 IPM Y3149 IPM
F2	=	X2952 IPM Y2362 IPM
F3	=	X1968 IPM Y1574 IPM
F4	=	X984. IPM Y787 IPM

### Contouring Mode

G00	max.	3149 IPM
G01	max.	300 IPM
G02	max.	300 IPM optional
G03	max.	300 IPM optional

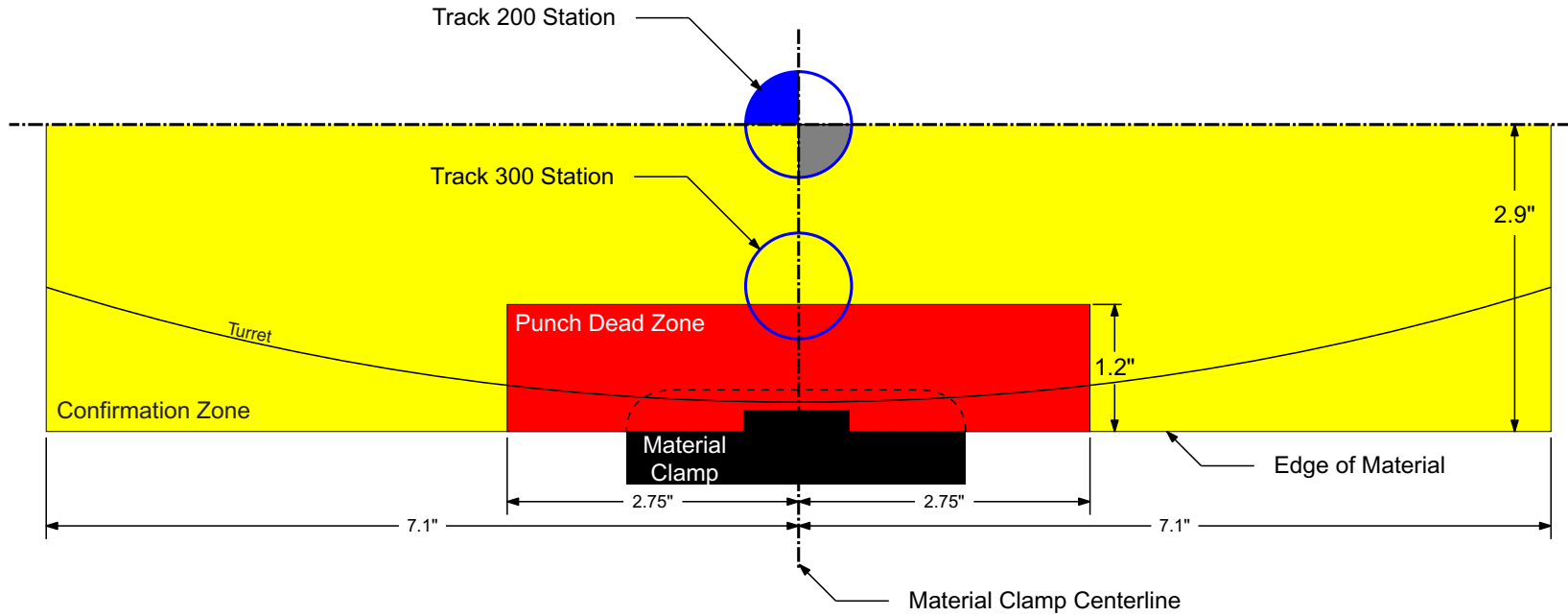
## Punch Confirmation Area / Punching Dead Zone.

### Definitions

- Confirmation Zone = An area that when the confirmation switch is in the on position or it is the first run of the part program the operator must confirm the punch by pressing the confirmation pushbutton.
- Punch Dead Zone = Punching in this area with standard tools may damage the material, material clamp, tool, other machine components, and may cause operator injury. The operator must confirm the punch by pressing the punch and confirmation buttons.
- Y-Overtravel Zone = An area that exceeds the travel limits of the machine.

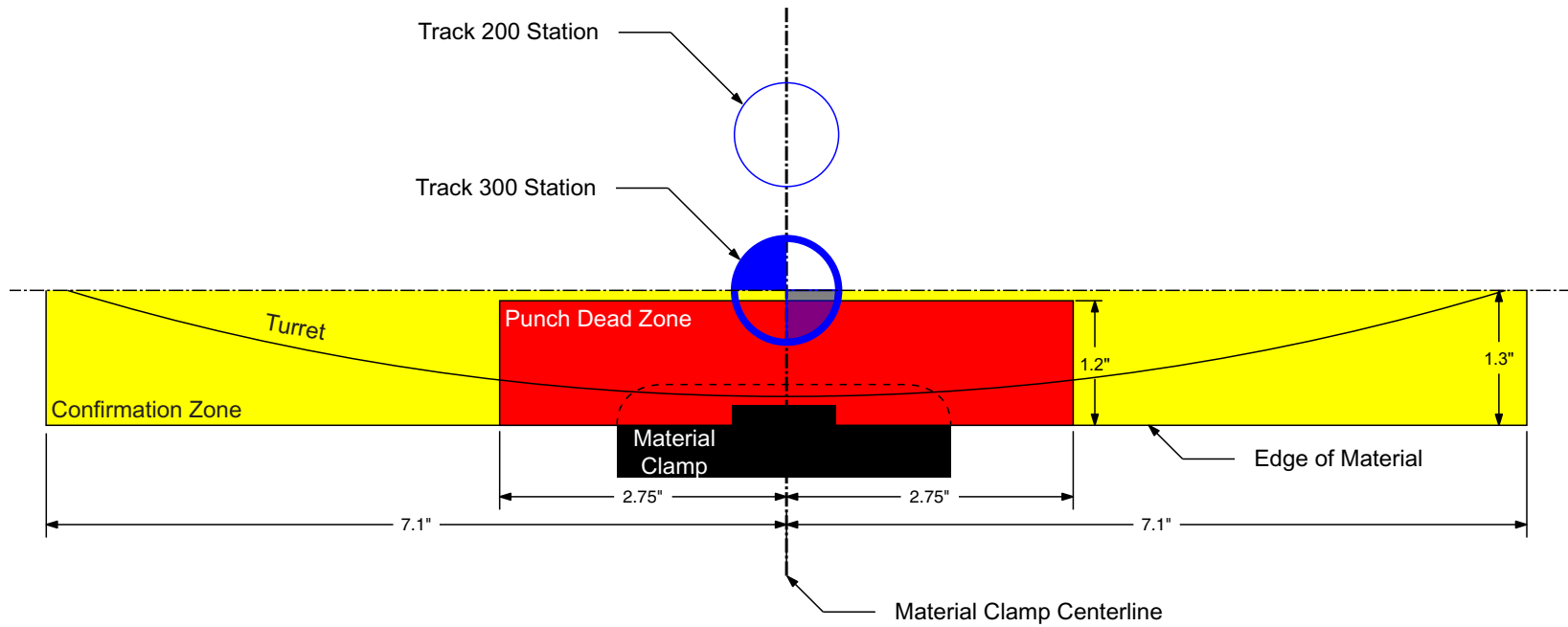
# A Size (1/2") Station

## A Size Track 200 Stations



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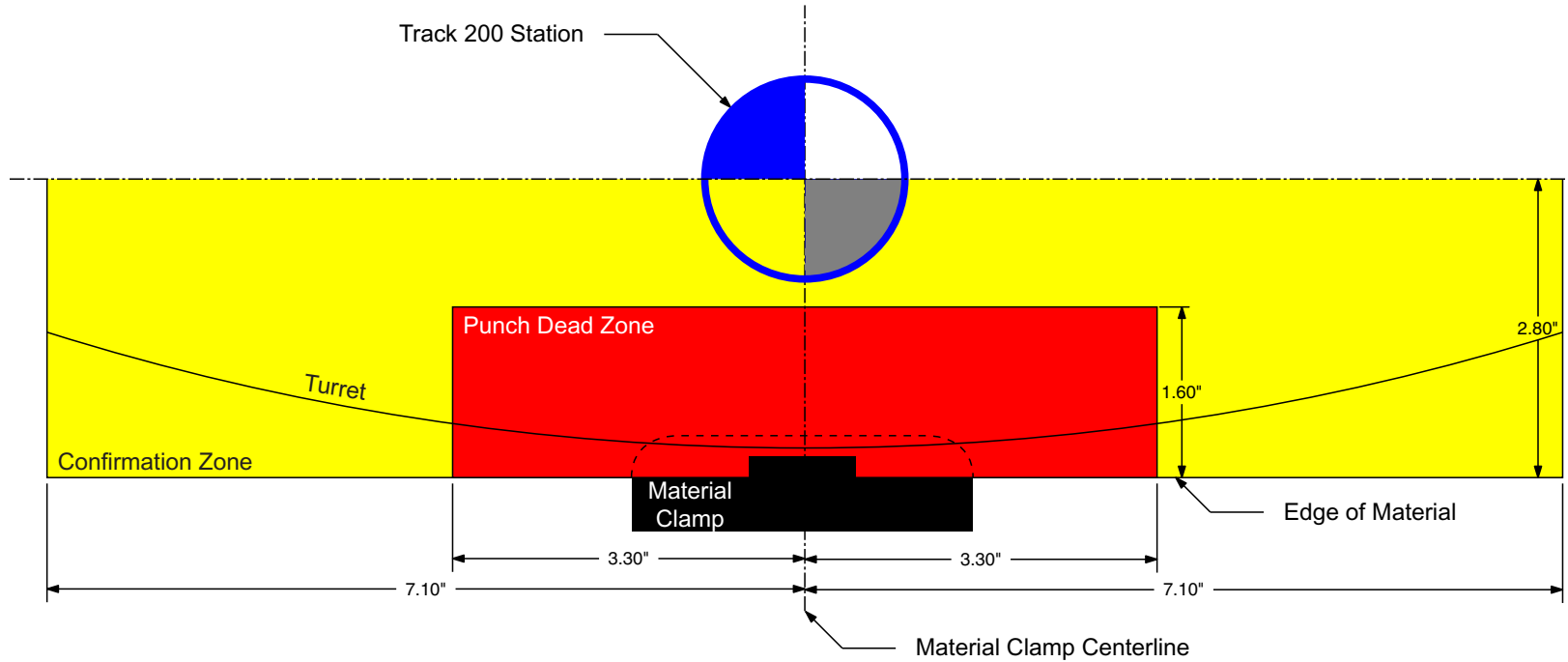
## A Size Track 300 Stations



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# B Size (1 1/4") Station

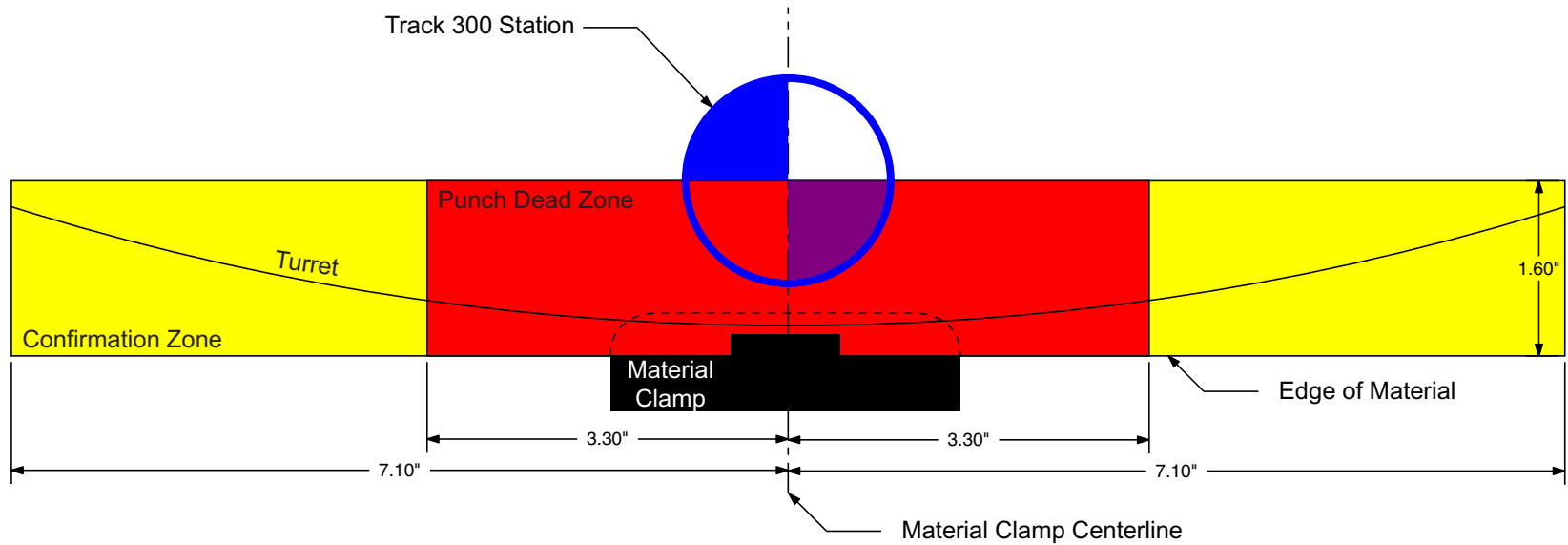
## B Size Track 200 Stations (Auto Index only)



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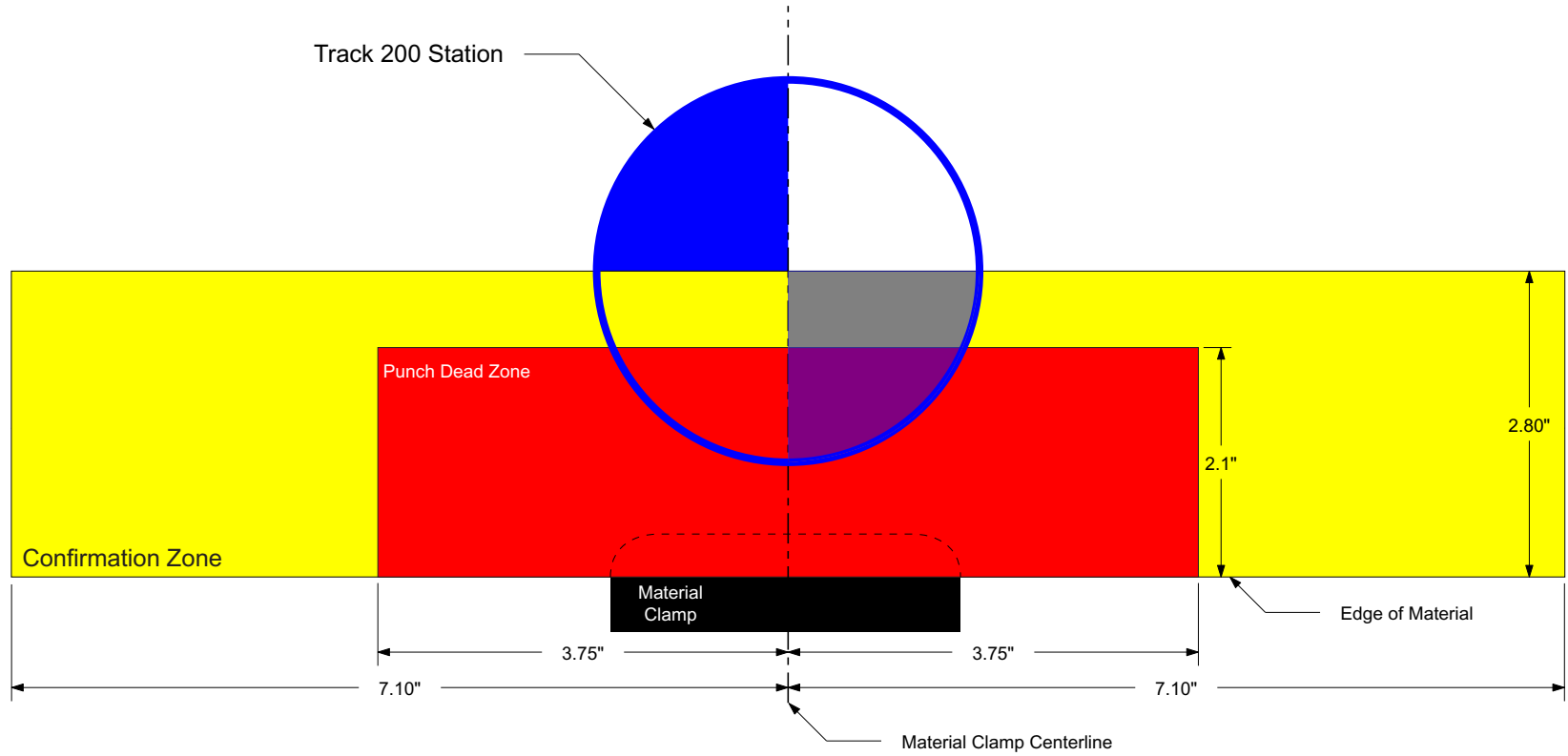
### B Size Track 300 Stations



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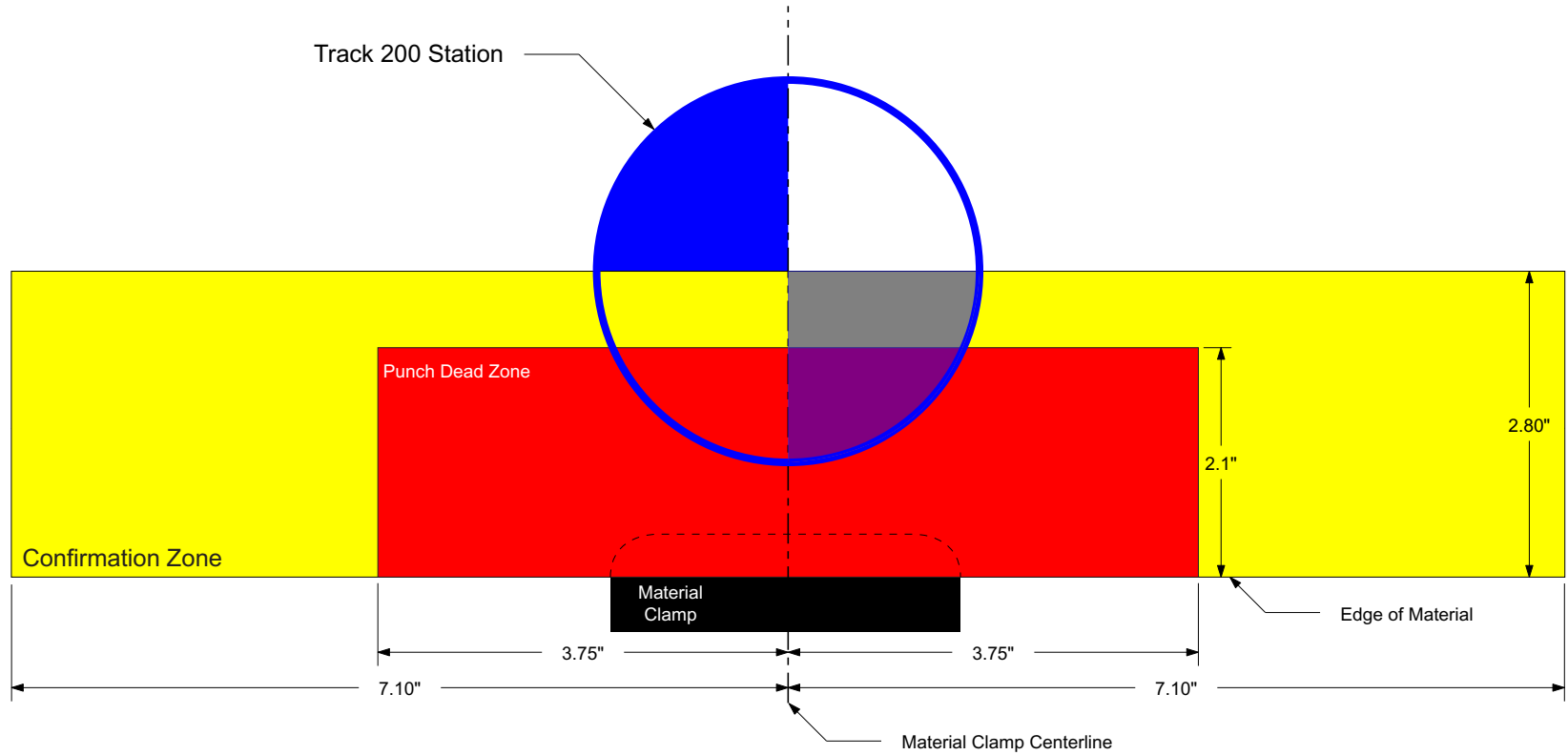
# C Size (2") Station

## C Size Track 200 Stations



## C Size Track 200 Stations Auto Index

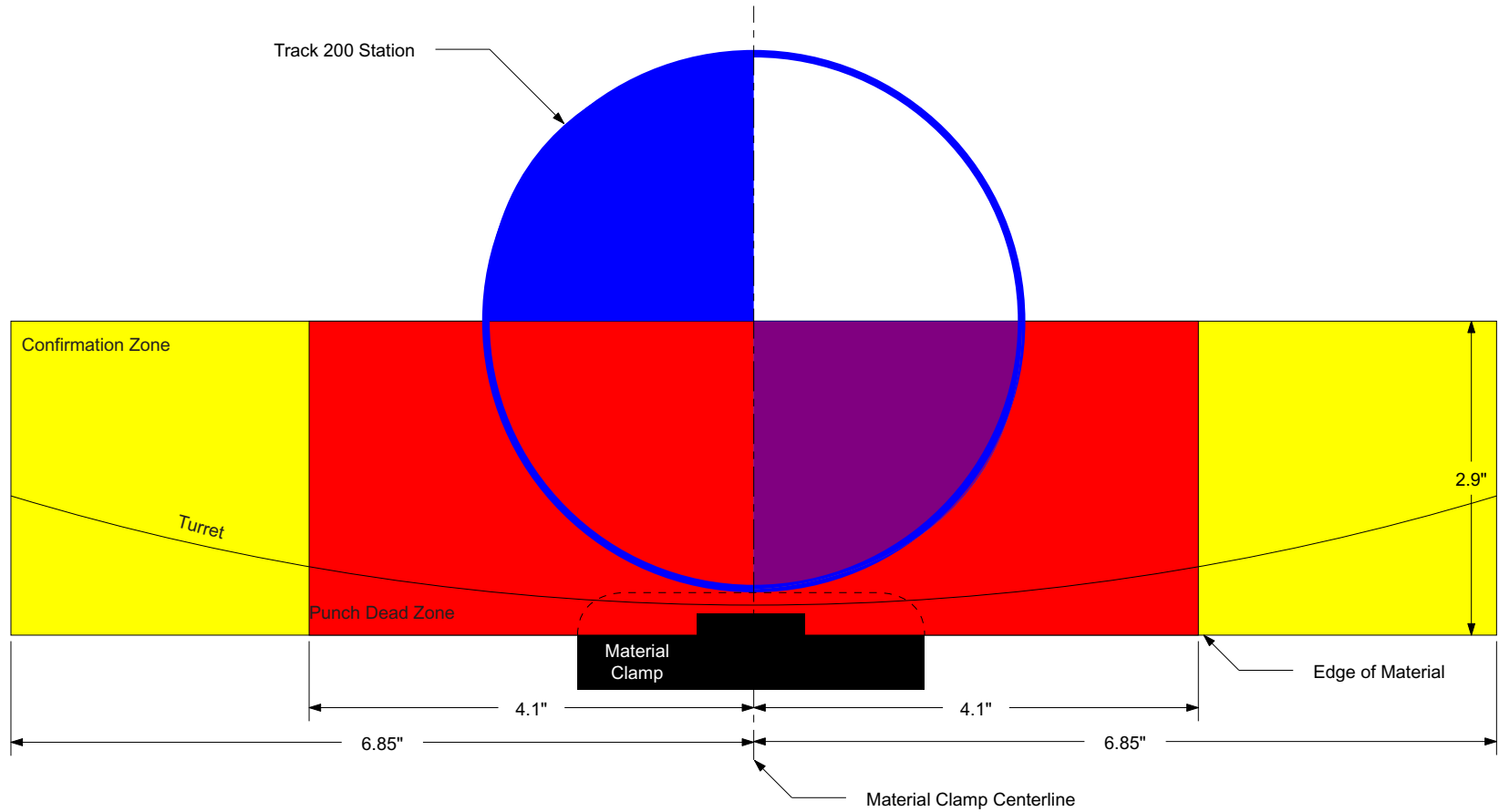
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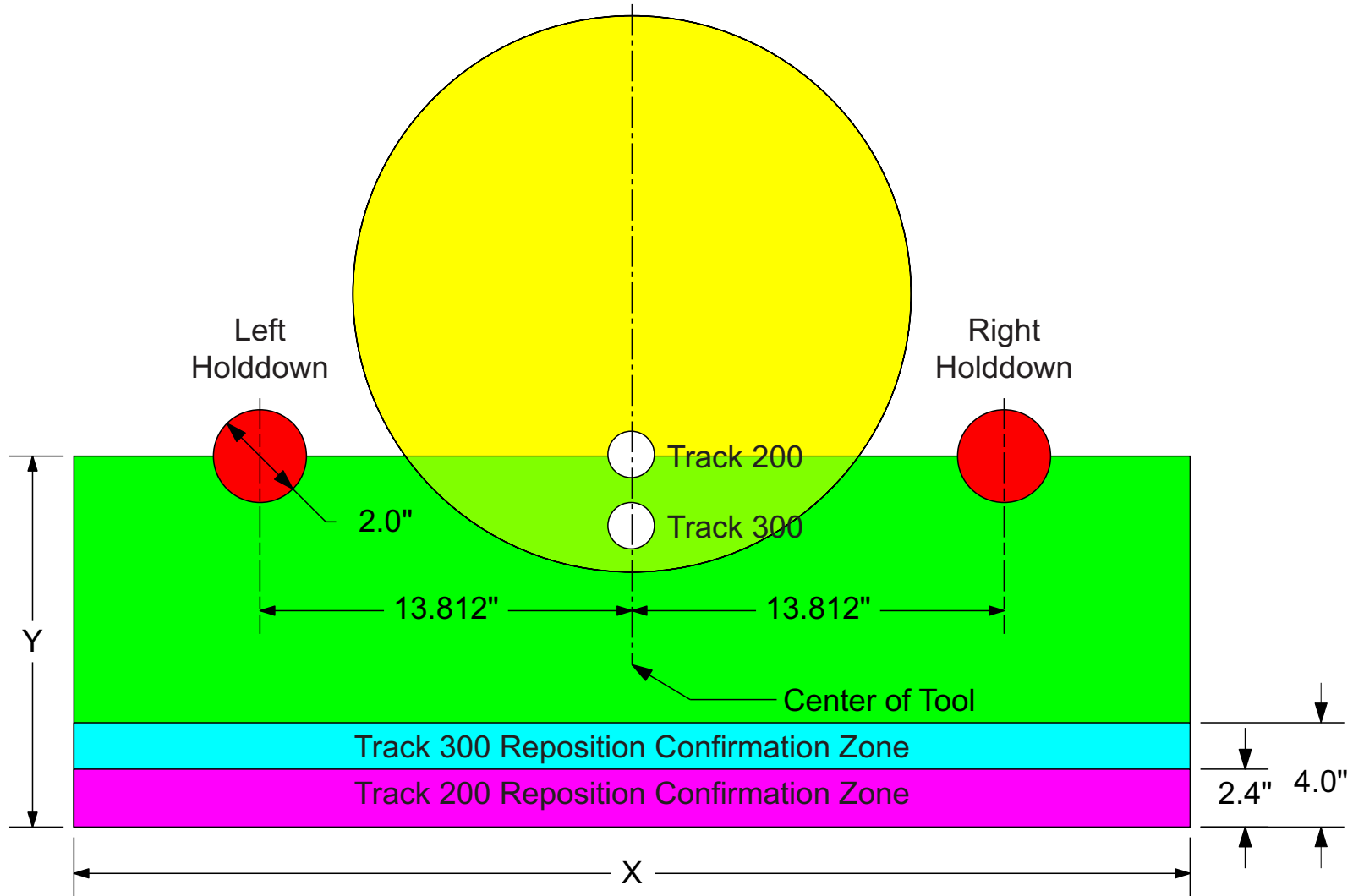
# D Size (3 1/2") Station

## D Size Track 200 Stations



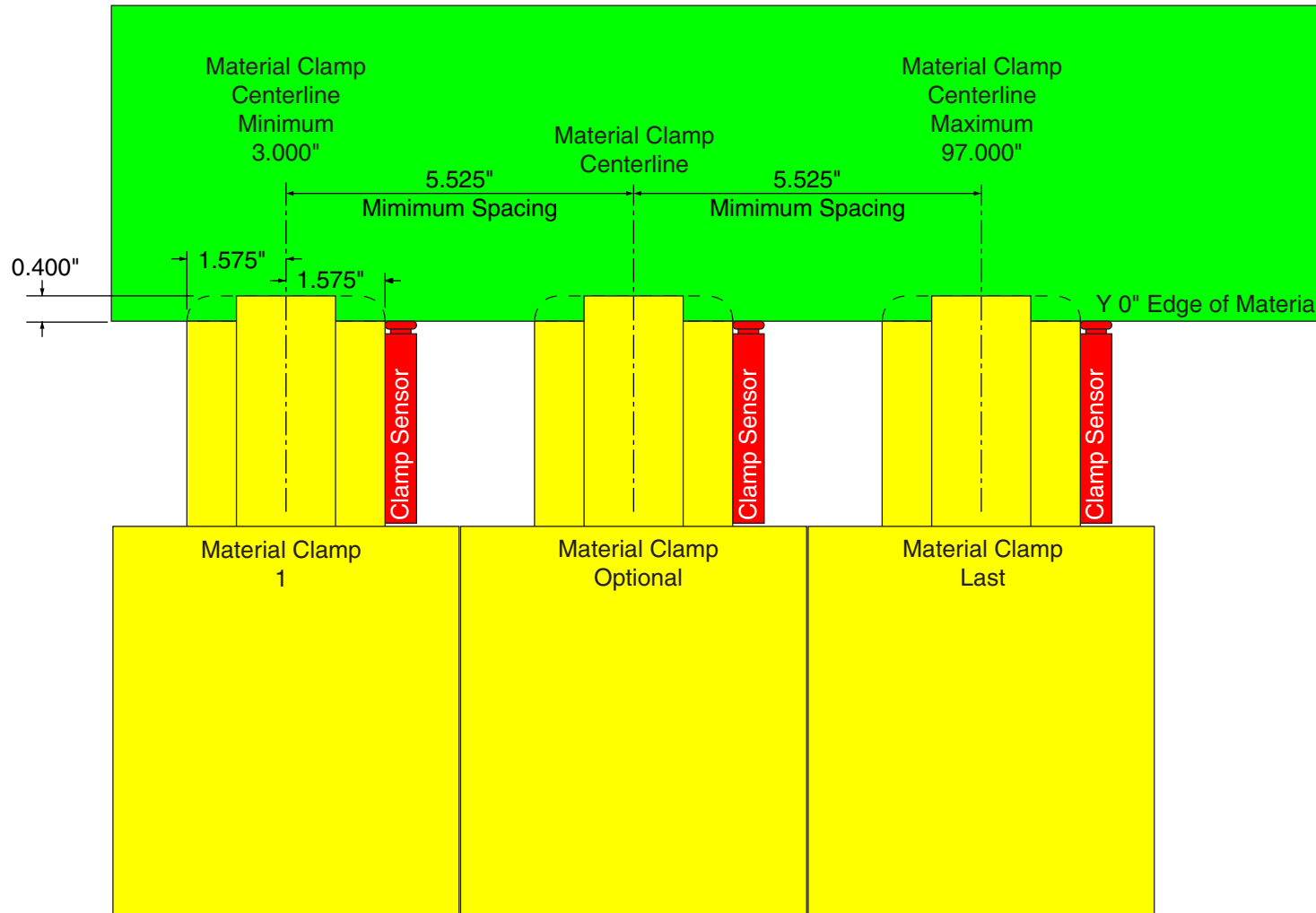
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# Reposition Holddown Locations



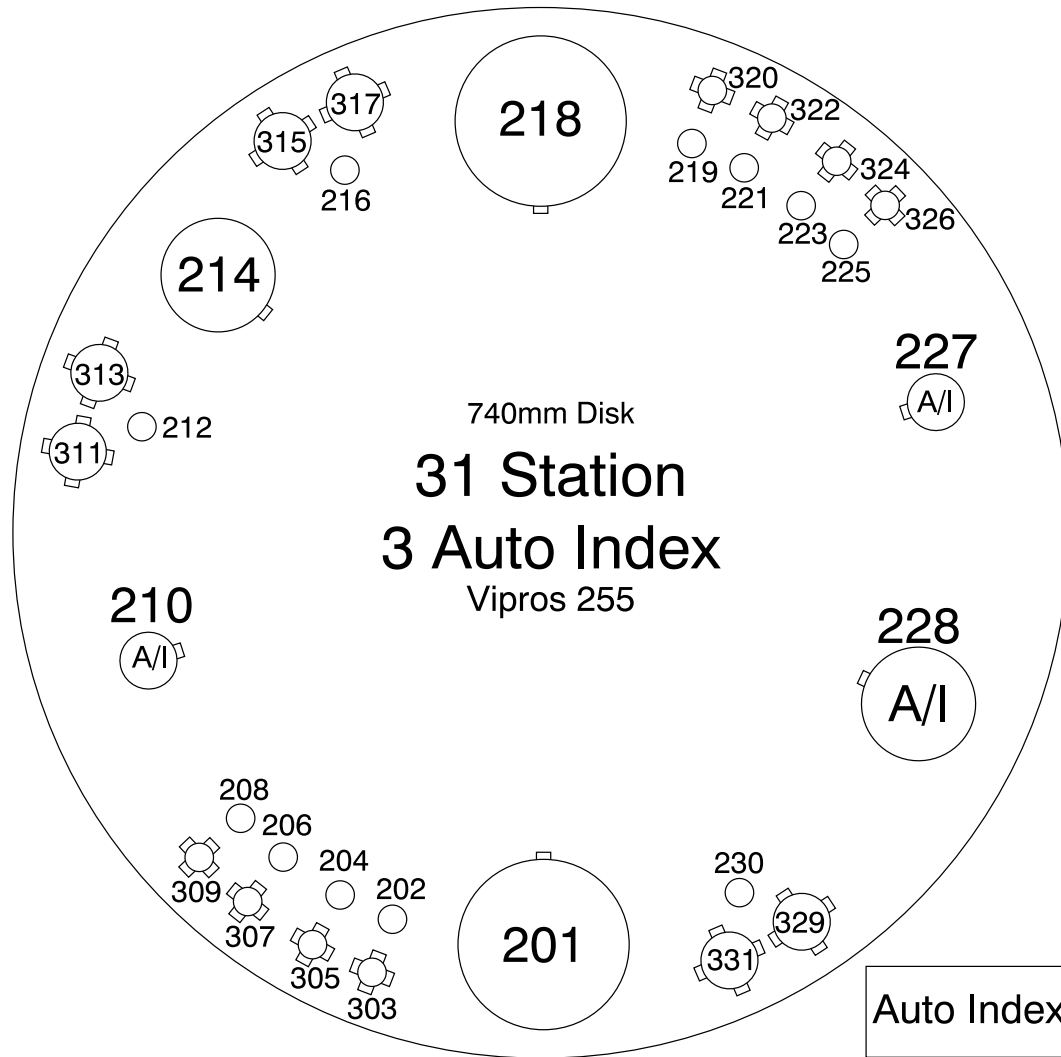
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# Material Clamp Location



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# 31 Station Turret



	Maximum Size Round	Number of Stations (keyed)
A	1/2" (12.7mm)	19 (8)
B	1 1/4" (31.7mm)	6 (6)
C	2" (50.8mm)	1 (1)
D	3 1/2" (88.9mm)	2 (2)
Auto Index	B 1 1/4" (31.7mm)	2 (2)
	C 2" (50.8mm)	1 (1)

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