

of South Florida, Inc.

High Performance | Tight Tolerances | Clean Cuts

Auto Bender Software Update





- Go to https://www.clnofsouthflorida.com/cnc-machines-tech-support/
- Download the CLN Notcher software.
- Unzip it to the desktop for easy access.
- Double click on the extracted folder.
- Double click on Setup Bender.bat
- If you receive a Windows Protection message that is preventing an unrecognize app from starting. Click More Info then Run Anyway.
- This will make new 2 folders. One folder call Autobender and one called Jobs. (C:\Autobender) (C:\Jobs).

rganize 👻 Include in library 👻	Share with 👻 🛛 Burn 🛛 New folder			
Favorites	Name	Date modified	Туре	Size
🤜 Desktop	argument.dat	5/24/2023 10:39 AM	DAT File	1 KB
🚺 Downloads	Background.png	5/24/2023 10:39 AM	PNG File	51 KB
🙂 Dropbox	BEN.exe	5/24/2023 10:39 AM	Application	119 KB
🔠 Recent Places	CIRCLE.DXF	5/24/2023 10:39 AM	DXF File	3 KB
📙 Google Drive	🔣 CLN Icon.bmp	5/24/2023 10:39 AM	Bitmap image	7 KB
OneDrive - Personal	CLN_Screen.JPG	5/24/2023 10:39 AM	JPEG image	36 KB
	📋 ctrace.txt	5/24/2023 10:39 AM	TXT File	1 KB
🗃 Libraries	📋 curf.txt	5/24/2023 10:39 AM	TXT File	1 KB
Documents	🚳 CW3211.DLL	5/24/2023 10:39 AM	Application extens	184 KB
👌 Music	Gbend_Servo_Stepper_Ver_7.dmc	5/24/2023 10:39 AM	DMC File	13 KB
E Pictures	🛃 Icon.bmp	5/24/2023 10:39 AM	Bitmap image	7 KB
📕 Videos	LOG.DAT	5/24/2023 10:39 AM	DAT File	1 KB
	MATERIAL.DAT	5/24/2023 10:39 AM	DAT File	1 KB
Somputer	> 🚳 Setup Bender.bat	5/24/2023 10:39 AM	Windows Batch File	1 KB
🏭 Local Disk (C:)	SETUP.DAT	5/24/2023 10:39 AM	DAT File	1 KB
BAVID (E:)	SETUP2.dat	5/24/2023 10:39 AM	DAT File	1 KB
EMTEC (F:)	Shortcut to BEN	5/24/2023 10:39 AM	Shortcut	1 KB
	TEST.DXF	5/24/2023 10:39 AM	DXF File	4 KB
🗣 Network	TOOL.DAT	5/24/2023 10:39 AM	DAT File	1 KB
🖳 CLN-DAVID	Trace.txt	5/24/2023 10:39 AM	TXT File	0 KB

Go to the C:\Autobender folder.

- Double click on Setup2.DAT. -
- Open it with notepad.

Desktop				
	Background.png	5/24/2023 10:39 AM	PNG File	51 KB
😺 Downloads	⁸ ¢ _N BEN.exe	5/24/2023 10:39 AM	Application	119 KB
👽 Dropbox	S CW3211.DLL	5/24/2023 10:39 AM	Application extens	184 KB
Recent Places	Gbend_Servo_Stepper_Ver_7.dmc	5/24/2023 10:39 AM	DMC File	13 KB
と Google Drive	🛃 Icon.bmp	5/24/2023 10:39 AM	Bitmap image	7 KB
🗅 OneDrive - Personal	LOG.DAT	5/24/2023 10:39 AM	DAT File	1 KB
	MATERIAL.DAT	5/24/2023 10:39 AM	DAT File	1 KB
Libraries	SETUP.DAT	5/24/2023 10:39 AM	DAT File	1 KB
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🖞 Music	TOOL.DAT	5/24/2023 10:39 AM	DAT File	1 KB
Pictures				
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Local Disk (C:)				
DAVID (E:)				
EMTEC (F:)				
Network				
🖳 CLN-DAVID				
CLNSERVER				

	SETUP2.dat - Notepad
	File Edit Format View Help
	'Use with Config file Ver_7
	'Serial Number TDK 1217
	'Commanded Distance / Actual Distance Moved * CPI or SPCNT = New CPI or SPCNT 'Code
Make sure that the Code=1212	Code=1212
	'Ecoder counts CPI=1664, Make number bigger to make material longer
	'Step motor counts SPCNT=8.345 Make number bigger to make material longer
Save and exit Notepad	SPCNI=8.345
	FEED = 100000
	'Rapid speed for bending tools
	RAPIDS = 100000 Bending speed for bending tools
	BEND = 30000
	'Aliment for X bottom pos # CW
	Adjx=0
	Adiv=-0
	'Make sure that all of the varaibles are sent
	Failod=1
	END

- Go to C:\ Autobender folder.
- Right click on BEN.EXE and create a short cut and move it to the desktop.
- Delete the execrated install folder located on the desktop.
- Reset the machine and double click on the Auto Bender shortcut.
- If a message pops up, when you first start the program. It's either a problem with the Com Port or commutating with the controller. It doesn't matter at this point.
- In the Auto Bender program, go to Tools Setup.
- If you receive a message that says, that the Com Port is not right. Change the com port setting. The software can only be set to 1,2,3 or 4. If you are using a USB to com Port adapter you have to configure the adaptor to 1,2,3,or 4.
- Start the program. If it open with no message then put in all of the settings for setup and setup2.DAT, that are in the back of the manual that you received with the machine.
- If you don't have the settings, then watch this training video to setup the machine. <u>Auto Bender Training Video.</u>

Next	Rotate Point +	Rotate Point -	Zoom +	Zoom -	Run Tool	Trailing tab	Material = .040
	**	* Error ini	Setup	202 - 05			
	Ler	t mouse crit	Communicatio Router bit siz X Offset Y Offset Closed figure	ons Port ze 1=YES 0=NO	i	1] [0.18800]] [50] [500] [1]	
			0	ĸ		Cancel	