



of South Florida, Inc.

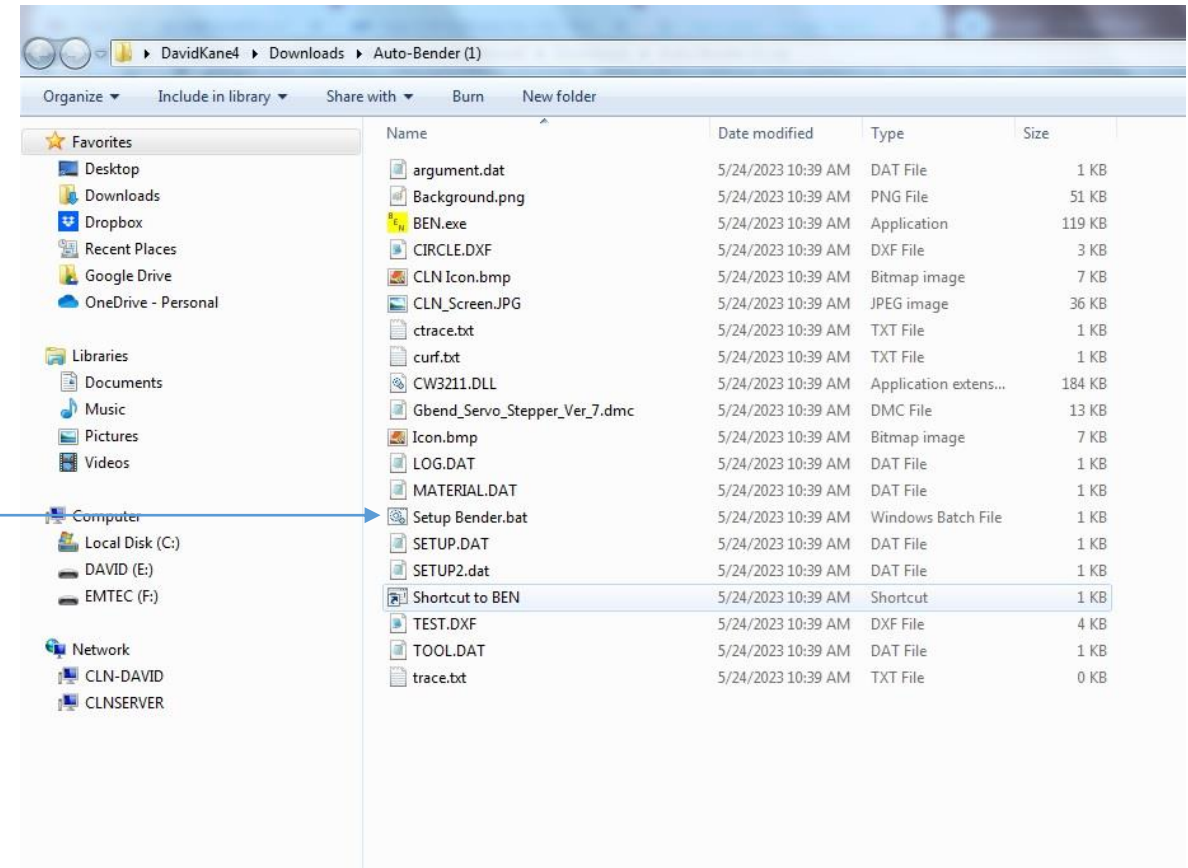
High Performance | Tight Tolerances | Clean Cuts

Auto Bender Software Update



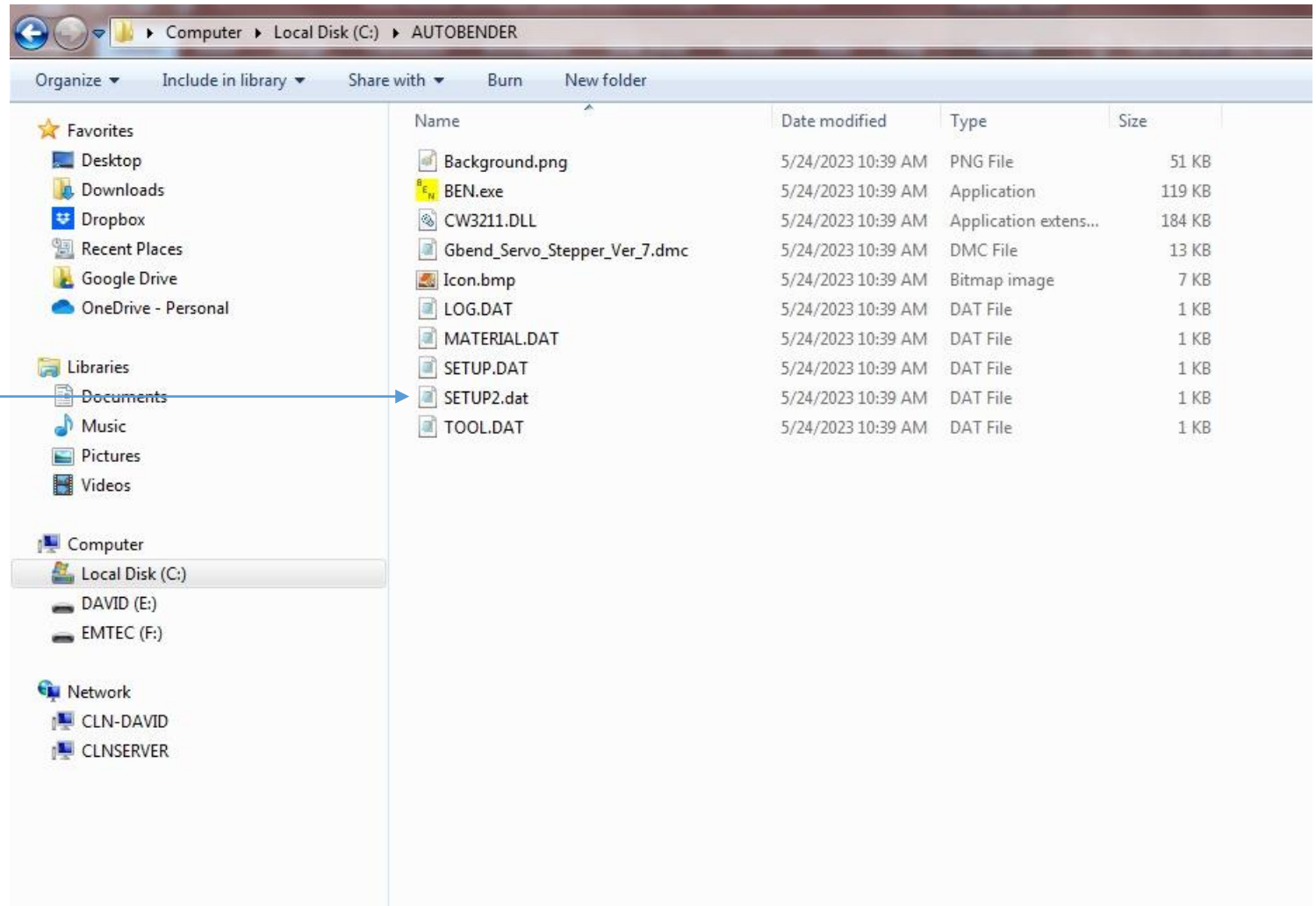
Software update

- 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 unrecognized 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).



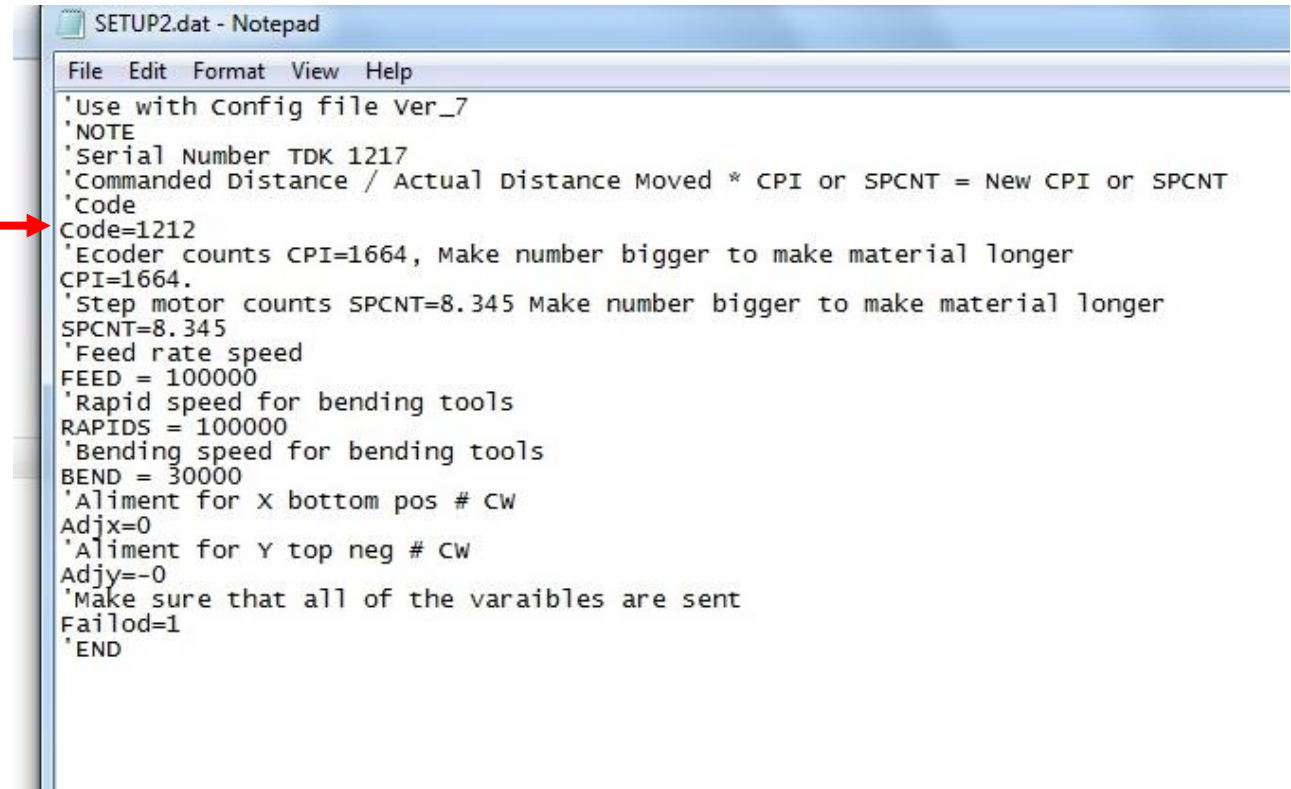
Software update

- Go to the C:\Autobender folder.
- Double click on Setup2.DAT.
- Open it with notepad.



Software update

- Make sure that the Code=1212
- Save and exit Notepad



```
File Edit Format View Help
'Use with Config file ver_7
'NOTE
'Serial Number TDK 1217
'Commanded Distance / Actual Distance Moved * CPI or SPCNT = New CPI or SPCNT
'Code
Code=1212
'Ecoder counts CPI=1664, Make number bigger to make material longer
CPI=1664.
'Step motor counts SPCNT=8.345 Make number bigger to make material longer
SPCNT=8.345
'Feed rate speed
FEED = 100000
'Rapid speed for bending tools
RAPIDS = 100000
'Bending speed for bending tools
BEND = 30000
'Aliment for X bottom pos # CW
Adjx=0
'Aliment for Y top neg # CW
Adjy=-0
'Make sure that all of the variables are sent
Failod=1
'END
```

Software update

- 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. [Auto Bender Training Video.](#)

