

# Langmuir Titan 25T – Backgauge (Backstop) Adjustment Guide

This guide explains how to adjust the backgauge (backstop) on the Titan 25T CNC Press Brake. Proper adjustment ensures accurate part positioning before each bend and smooth operation of the backgauge system.

## Adjustment Steps

1. **\*\*Power On & Home the Backgauge\*\***: Turn on the machine and home the X and R axes via BendControl.
2. **\*\*Select the Backgauge Tab\*\***: On the touchscreen or control PC, open the 'Backgauge' tab.
3. **\*\*Jog to Position\*\***: Use jog controls (touchscreen arrows or pendant) to move the backgauge fingers to the desired X and R positions.
4. **\*\*Set Reference Edge\*\***: Choose the reference edge in BendControl—Upper Finger Edge or Lower Finger Edge—depending on your die setup.
5. **\*\*Fine Adjustments\*\***: Switch to small jog increments to fine-tune finger placement relative to the die or part edge.
6. **\*\*Adjust Lead Screws if Necessary\*\***: If physical misalignment exists, power down the relevant motor, loosen the locking collar, and rotate the lead screw slightly to align the fingers.
7. **\*\*Bump Off Distance\*\***: In BendControl, set the bump-off distance (how far the backgauge retracts before a bend stroke) to prevent interference.
8. **\*\*Retract Between Bends (Optional)\*\***: Enable retract between bends if you need extra clearance for part removal.
9. **\*\*Save the Position\*\***: For repeat jobs, save the X and R positions as part of a bend program so they load automatically.

## Tips for Smooth Adjustment

- Always home the backgauge before starting a shift to ensure positional accuracy.
- When switching dies, recheck the reference edge alignment.
- Keep the lead screws and guides clean and lightly lubricated to prevent binding.
- Store common X/R positions for frequently bent parts to speed up future setups.