Langmuir Titan 25T – Backgauge (Backstop) Calibration Guide

This guide outlines the calibration procedure for the Titan 25T CNC Press Brake backgauge (backstop) using BendControl. The process ensures accurate and repeatable positioning for various die and finger configurations.

Calibration Steps

1. Square the Backgauge: Position the backgauge fingers roughly at the 2-inch mark so they align with the table centerline.

2. Home the Backgauge: Use the control software to perform the homing procedure.

3. Place Dies: Set a 4-way die (or segments) on the table to assist with alignment.

4. Align Upper Finger Edge: Jog the backgauge so the upper finger reference edge aligns with the die's outer edge.

5. Adjust Lead Screw: If alignment is off, unplug the motor temporarily and adjust the lead screw.

6. Assign Slot Names: Clearly label each of the six calibration slots for easy reference.

7. Zero Out Values: Reset all X and R calibration values to 0 for each slot.

8. Input Preset Values: Enter manufacturer-recommended X and R values for each configuration.

Recommended Calibration Values

Setting	X (inches)	R (inches)
4■Way Upper	1.181	0
4■Way Lower	0.181	−0.395
2″ Acute Upper	1.181	−0.394
2″ Acute Lower	0.181	−0.789
Small Upper	1.181	0.748
Small Lower	0.181	0.353