

USER GUIDE FOR TOUCH SCREEN NC PANEL

To operate the machine, the user should use the touch screen NC panel. NC panel provides the user to control the backgauge, cutting mode, and pneumatic sheet support system. There are 5 different menu on the panel as listed in below.

1. RUN
2. SETTINGS
3. ALARM
4. MANUAL
5. CUTTING SET

1.RUN

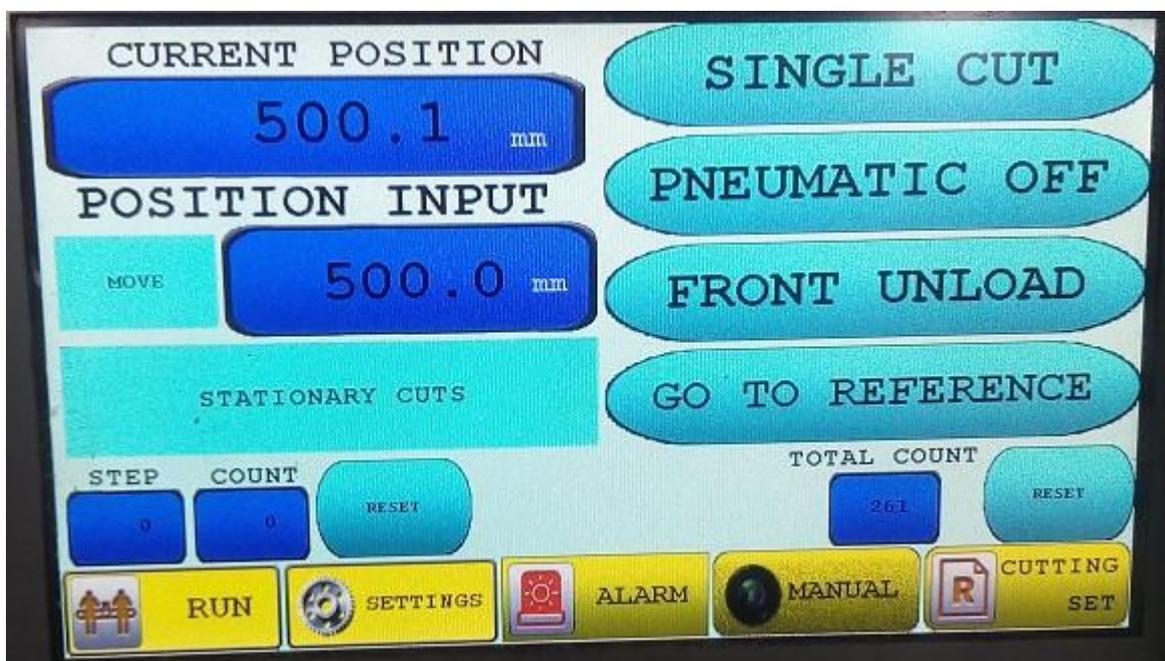


Image 1: RUN

When the main switch is turned on, the NC panel screen appears as shown in the Image 1. Before cutting process, the user should make all settings on this page.

Firstly please see the right top corner. Default setting of the machine for cutting mode is “SINGLE CUT”. If you want to change the cutting mode, you should touch “SINGLE CUT” button and the machine will switch to “CONTINUOUS CUT”.

Secondly, you will see “PNEUMATIC ON/OFF” option below the “SINGLE CUT” button. If you want to work with pneumatic sheet support system, you should leave “PNEUMATIC ON” mode.

Note: Pneumatic sheet support system is disabled in continuous cut. So when the machine switches to continuous cut, pneumatic sheet support system will be off automatically.

Thirdly unloading option has to be chosen. In default, it is adjusted for “FRONT UNLOAD”. If you need back unloading, you can change it by touching on the “FRONT UNLOAD” button.

When you touch on “GO TO REFERENCE” button, the backgauge goes to reference point. Default reference point value is the maximum backgauge limit. Reference point can be changed by the user on “SETTINGS” menu.

On the left top corner, you will see current position of the backgauge. If you want to input a position, touch on “POSITION INPUT” area. A numerical keyboard will appear on the screen as shown in Image 2. Input the position and touch “ENT” button. Then touch to “MOVE” button.



Image2: Position Input

In this section, you will also see cut counter and step counter. You can reset both by using “RESET” buttons on the touch screen.

2.SETTINGS



Image 3. SETTINGS

In this menu, you can adjust some parameters such as “PNEUMATIC START DELAY”, “PNEUMATIC FINISH DELAY”, “REFERENCE POSITION”, “BACKGAUGE MANUAL SPEED”, “BACKGAUGE MAXIMUM SPEED” and “BACKGAUGE MINIMUM SPEED” as shown in the Image 3. If you want to change a parameter touch on the box where the parameter value exists and input the new parameter. You can also change the language.

3.ALARM

When machine has encountered an error it stops working and fail light on the electrical box would show up. When this happens, you can switch to this menu and you can see the failure type.

4.MANUAL

If you need to control the backgauge, machine or pneumatic sheet support system manually, you can use this menu. Please see the Image 4. You can move the backgauge manually with arrows on the screen. You can move the upper beam by “GUILLOTINE UP” and “GUILLOTINE DOWN” buttons. You can move the pneumatic pistons by “PNEUMATIC UP” and “PNEUMATIC DOWN” buttons. For instance, sheet may be clamped between upper and lower blades during cut. At that point, you should use “GUILLOTINE UP” button to move the upper beam.

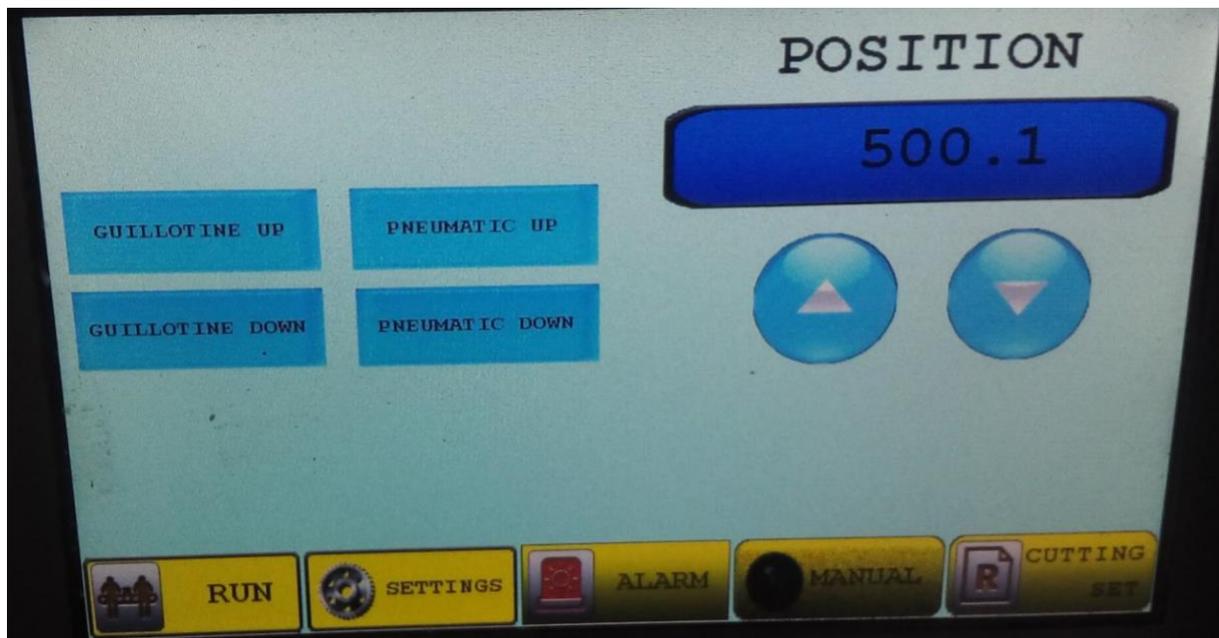


Image 4. MANUAL

5.CUTTING SET



Image 5. CUTTING SET

If you want to make cutting program, you can use this menu. You can set 30 different set positions and step size as shown in the Image 4. To set a program, you should enter a position and the number of cuts for that position.

An example program:

1. 150.00 10
2. 200.00 2
3. 215.00 5
4. 85.00 10
5. 350.00 20
6. 150.00 0 (program stops when you enter 0 for number of cuts)

If you have any further questions, please contact us.