

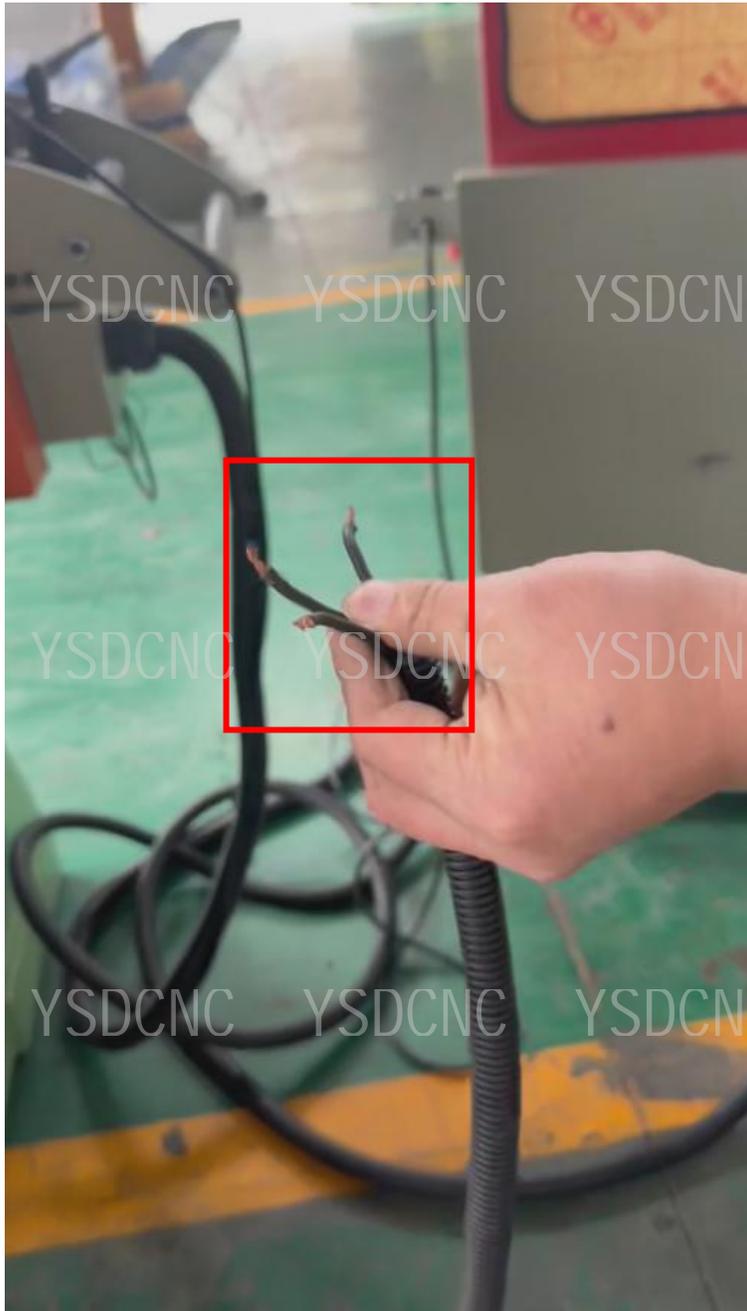
控制系统三根火线接入电源

The control system has three live wires connected to the power supply.



二合一校平材料架三根火线接入电源

The three live wires of the two-in-one leveling material rack are connected to the power supply.



## 冲床三根火线接入电源

The three live wires of the punch press are connected to the power supply.



黄色感应线接触材料感应器架  
图中圈出四个位置  
任意接触一个即可

The yellow induction line contacts the sensor holder. Four positions are circled in the image; simply contact any one of them.

## 接入气动装置

Connect to pneumatic device





开启电源，绿色指示灯亮起

When the power is turned on, the green indicator light illuminates.



打开急停开关

Turn on the emergency stop switch



同时按下“双手启动键”

观察冲床正转还是反转

Press the "Dual Start" button simultaneously and observe whether the punch press rotates forward or backward.



根据箭头指示方向转动即为正转

假如冲床是反转，那么就是冲床的火线位置接反了，调转其中两根火线位置再测试为正转即可

Rotating in the direction indicated by the arrow indicates forward rotation.

If the punch press is rotating in reverse, it means the power wires are reversed. Reverse the positions of two of the power wires and test again to confirm forward rotation.



左旋图中圈出旋钮到起动

The circled area in the left-hand rotation diagram indicates the start-up position.

转中请不要  
放入机器里  
DO NOT PUT HANDS  
IN THE MACHINE  
DURING OPERATION



打开手动模式

Turn on manual mode

转中请不要  
放入机器里  
DO NOT PUT HANDS  
IN THE MACHINE  
DURING OPERATION



按下正转按钮，观察送料辊是否正转

Press the forward rotation button and observe whether the feed roller rotates in the correct direction.



送料辊往前滚动即为正转

假如送料辊按下正转钮，但是往后滚动，那么就是二合一校平材料架的火线位置接反了，调转其中两根火线位置再测试为正转即可

The feed roller rotates forward when the button is pressed.

If the feed roller rotates backward when the forward rotation button is pressed, it means the power wires on the two-in-one leveling material rack are reversed. Reverse the positions of two of the power wires and test again to confirm forward rotation.



打开控制系统的急停开关

Turn on the emergency stop switch of the control system.



打开电源开关，电源灯亮起

Turn on the power switch, and the power light will turn on.

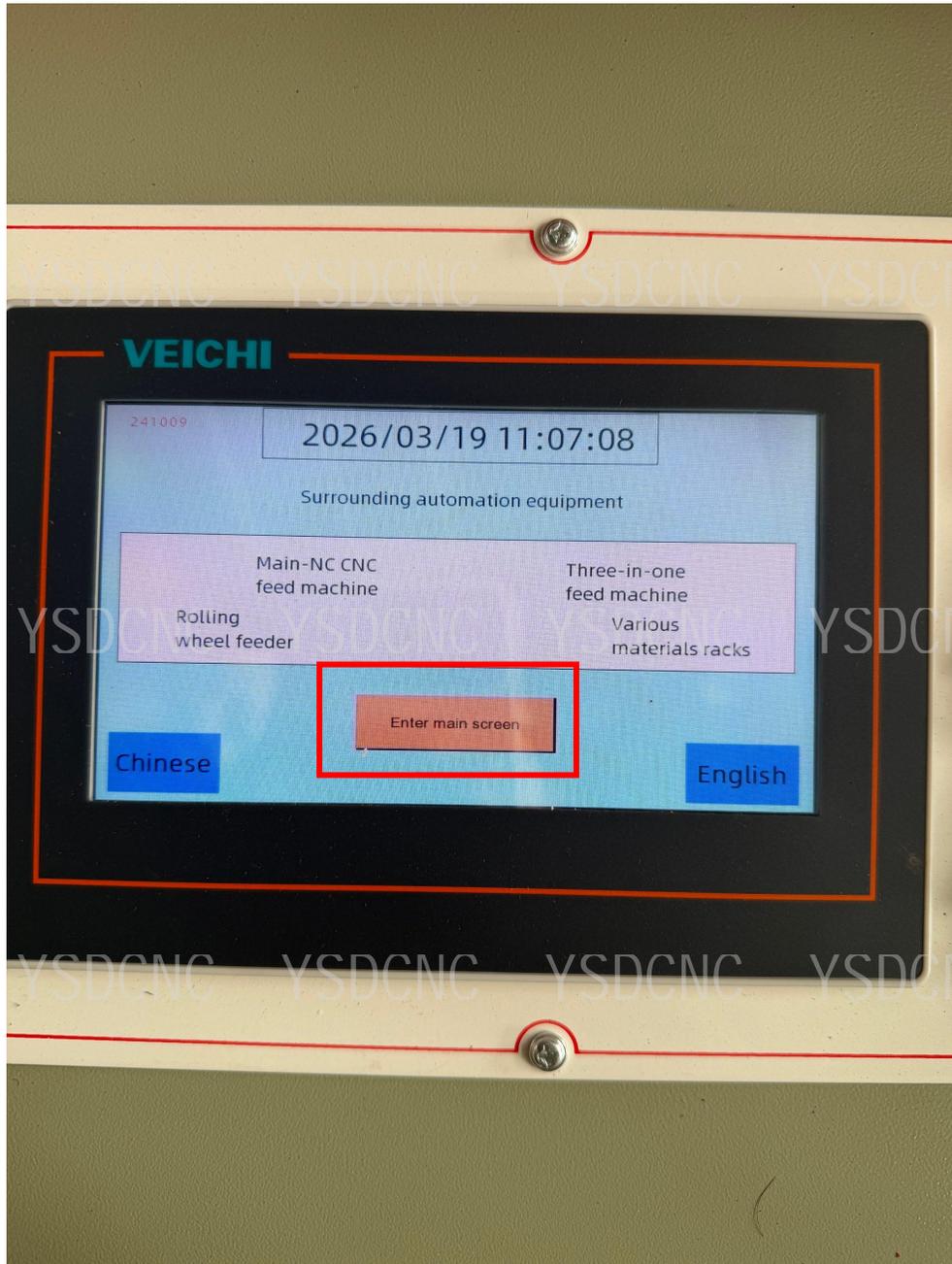
进入开机界面，可以选择语言中文或者英文

Upon entering the boot screen, you can select either Chinese or English as the language.



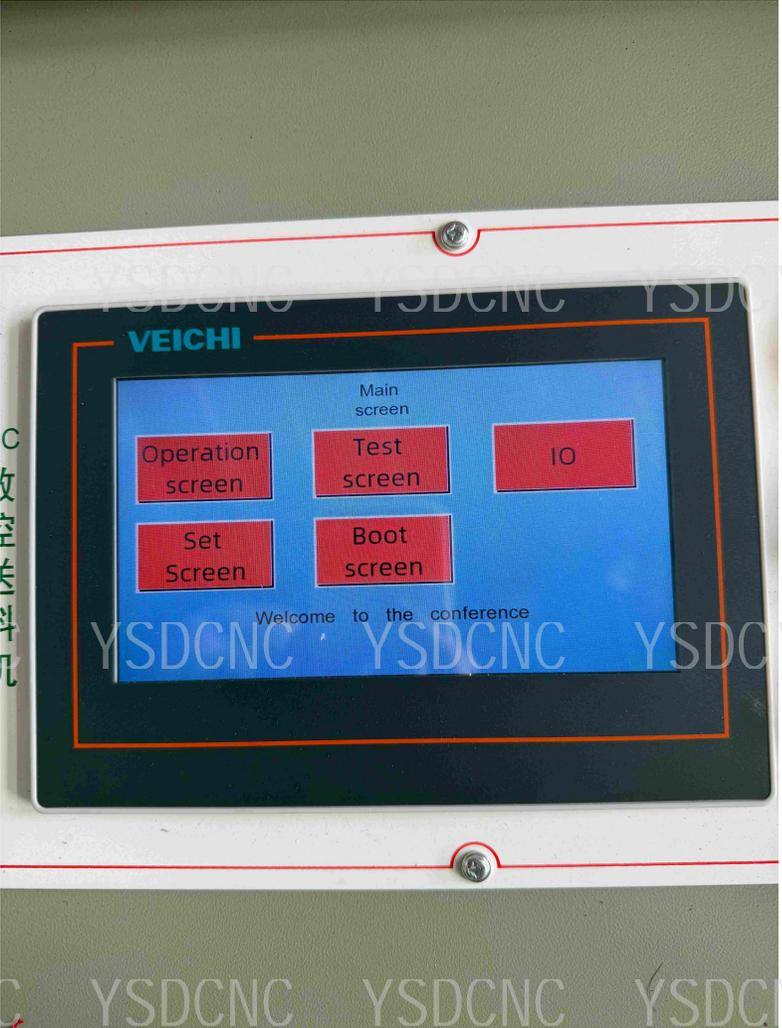
点击进入主界面

Click to enter the main interface



根据需要选择要进入的界面

Select the interface you want to enter as needed.



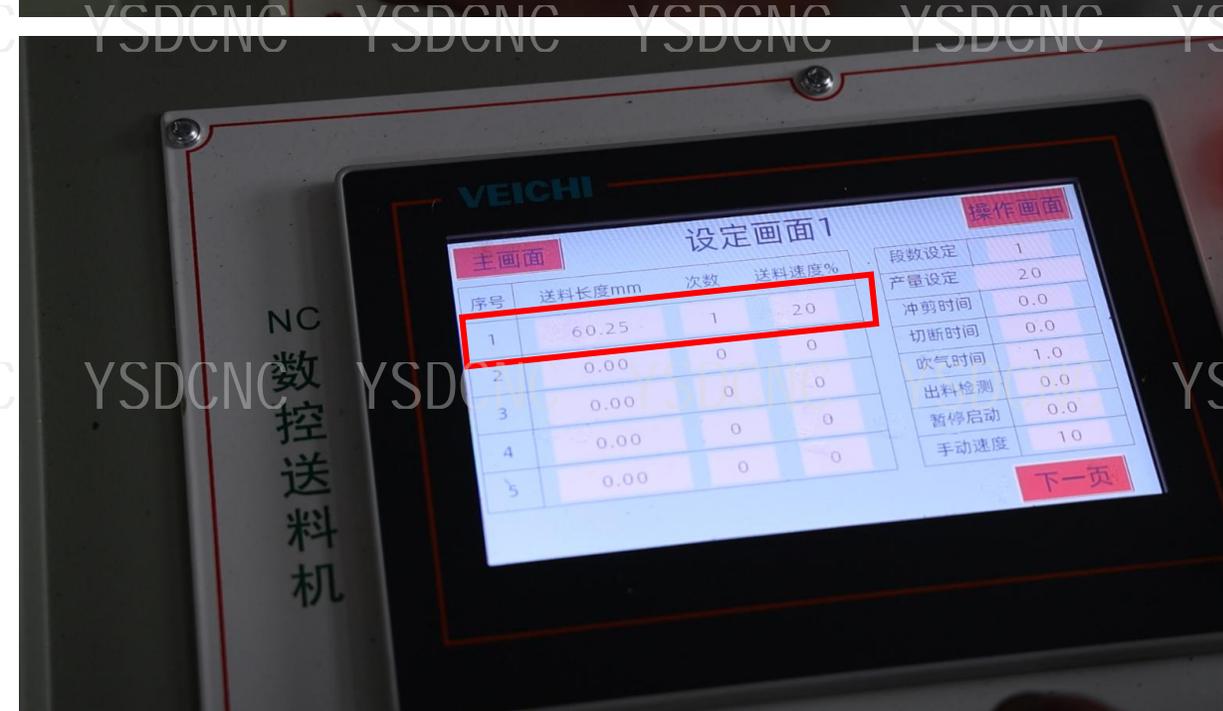


进入设定页面，设置要冲压工件的尺寸

这个数据是根据角码材料的长度输入的，每个角码的长度是不一样的，所以需要咨询对应的模具厂家，告知模具所需的初始材料是多少mm

Enter the settings page and set the dimensions of the workpiece to be stamped.

This data is entered based on the length of the corner code material. The length of each corner code is different, so you need to consult the corresponding mold manufacturer to inform them of the required initial material length in mm.



序号	送料长度mm	次数	送料速度%
1	60.25	1	20
2	0.00	0	0
3	0.00	0	0
4	0.00	0	0
5	0.00	0	0

段数设定	1
产量设定	2.0
冲剪时间	0.0
切断时间	0.0
吹气时间	1.0
出料检测	0.0
暂停启动	0.0
手动速度	10

先将卷料装上料架，再将四个料架固定器安装在料架上

First, load the coiled material onto the material rack, then install the four material rack fasteners onto the material rack.



摇杆可以控制卷料的松紧程度

The joystick controls the tension of the roll.





把料放进送料辊前端，  
两旁滚轮压紧料，  
然后使用内六角螺丝旋紧图中圈出的两个孔

Place the material into the front end of the feed roller,

where the rollers on both sides press the material down,

and then tighten the two holes circled in the diagram using Allen screws.



把辅助手臂向上抬起，  
送料辊松开，把料送进送料辊  
料送进辊后，辅助手臂向下放使辊能够压  
紧料

Raise the auxiliary arm upwards,  
releasing the feed rollers and feeding the  
material into them.

After the material is fed into the rollers, lower  
the auxiliary arm downwards so that the  
rollers can press the material firmly.



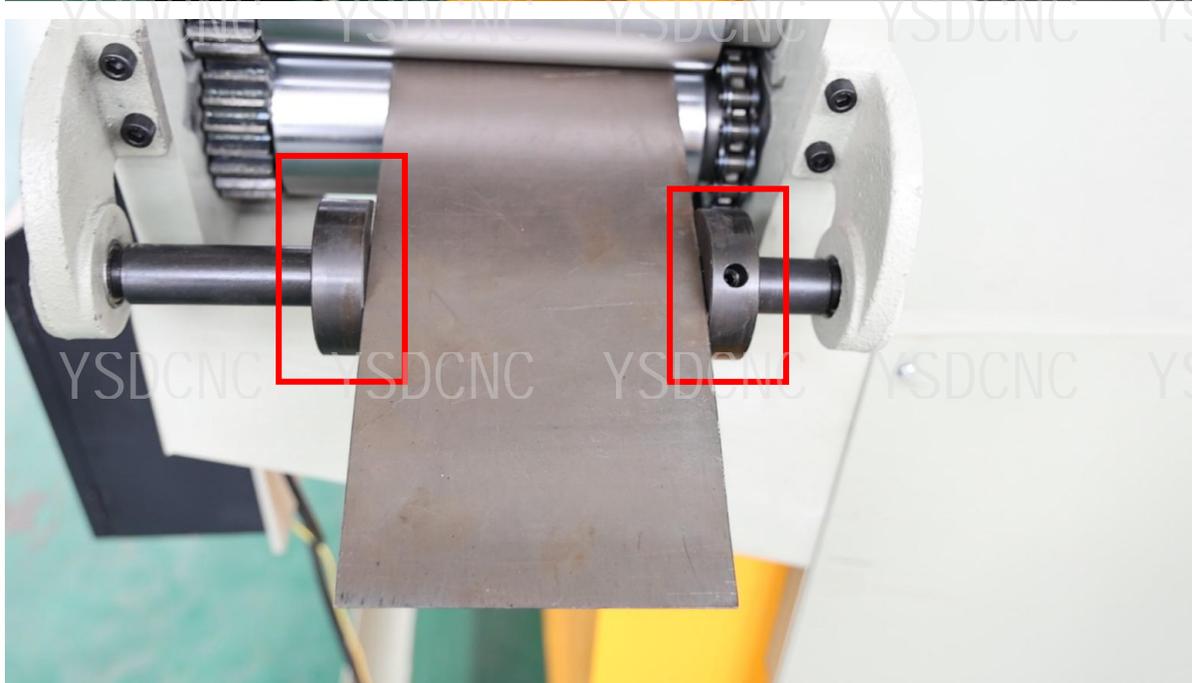
手动模式下，按正转按钮开始送料  
In manual mode, press the forward button to start feeding.



料送出来后,

把图中圈出的两个滚轮对齐料出来的位置并  
夹紧

After the material is fed out, align the two  
rollers circled in the diagram with the  
material's exit position and clamp them.



滚轮夹紧后，用内六角螺丝旋紧图中圈出的两个小孔

After clamping the rollers, tighten the two small holes circled in the diagram with an Allen screw.





料往前送至冲床

The material is fed forward to the punch press.

在控制系统上将旋钮旋至放松功能

Turn the knob to the release function on the control system.





使用遥控操作按下手动前进按钮，将料送入冲床内

Press the manual forward button using the remote control to feed the material into the punch press.





卷料送至冲压模具处时，将图中所圈的两颗螺丝夹紧卷料并锁紧

即可正常送料开始冲压

When the coiled material is fed to the stamping die, clamp and tighten the two screws circled in the diagram. Then, normal feeding and stamping can begin.

