



Idle

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IN Ports - 1				IN Ports - 2				OUT Ports - 1				OUT Ports - 2			
1		9	Right Sensor	1	Flat Limit - Top	9	Lower VFD Wa	1		9	Flat Right Turn	1	Flat - Up	9	Mid-Flat State
2	Run	10	Left Sensor	2	Flat Limit - Btm	10	Lower Sensor-	2	Main Motor	10	Flat Trun - Slo	2	Flat - Down	10	
3		11	Flat Slow Pos.	3	Flat Limit - Top	11	Lower Rolling	3	Sharpen+Vacu	11		3	Mid-Flat Left T	11	
4	VFD Warning	12	Flat Zero - Left	4	Flat Limit - Btm	12	Lower Unloade	4	Flat Belt1 +	12	High Speed Lig	4	Mid-Flat Right	12	
5	Knife Broken	13	Flat Slow Pos.	5	Mid-Flat VFD	13		5	Flat Belt1 -	13	Tensen Solenoi	5	Lower Rolling	13	
6	Fan Warning	14	Flat Zero - Rig	6	Mid-Flat Senso	14		6	Flat Belt2 +	14	Loosen Solenoi	6	Lower unloade	14	
7	Safe Door 1	15	X Sensor	7	Mid-Flat Senso	15		7	Flat Belt2 -	15	Clean Cooling	7	Loading OK Lig	15	
8		16	Knife Frame S	8	Mid-Flat Load-	16		8	Flat Left Turn	16	Smooth	8	Mid-Flat State	16	

Ranges

Limitation of X Axis - From 0.0
 Limitation of X Axis - To 4410.0
 Limitation of Z Axis - From 0.0
 Limitation of C Axis - From -285.0
 Limitation of C Axis - To 285.0
 Limitation of Pressor-UpDn - From 0.0
 Limitation of Pressor-UpDn - To 1530.0
 Limitation of Knfie Bar Moving - From 1100.0
 Limitation of Knfie Bar Moving - To 1200.0
 Limitation of Sharpening Adjustment - From 0.0000
 Limitation of Sharpening Adjustment - To 50.0000
 Limitation of X2 Axis - From 0.0
 Limitation of X2 Axis - To 4410.0
 The Safe Distance Between Axis Z and th... 50.0

Parameters of Speed (mm/min OR D./min)

X Hand Speed 30000.0
 Z Hand Speed 30000.0
 C Hand Speed 30000.0
 Idle Running Speed - X Axis 40000.0
 Idle Running Speed - Z Axis 40000.0
 Idle Running Speed - C Axis 40000.0
 Working Speed at Straight Line 30000.0
 Working Speed of Knife Turning 30000.0
 Spped Ratio of Safe Approaching 0.3
 Speed Ratio of the Duplicated Path 3.0
 Hand UpDown Speed of the Pressor 3000.0

A. Servo Zero Settings

Safe Lock

X Axis Zero X Clear X Set
 X2 Axis Zero X Clear X Set
 Z Axis Postion Z Clear Z Set
 C Axis Zero C Clear C Set
 Pressor V Pos. Press V ... Press V Set
 KnifeBar Pos. K-Bar Clear K-Bar Set
 Sharpen Pos. Shar. Clear Shar. Set

States Testing

B. Auto Positioning Check

Test

C. Miscellaneous

Stop Main Axis Force Test

Power Axis Enable Warns Reset

X1- X1+
 X2- X2+
 Z- Z+
 C- C+
 PV1- PV1+
 KB- KB+
 SK- SK+

Sharpen Flat Rotation
 Smooth Rotate +
 Clean Rotate -
 C Go Zero Knife Tense Main Motor
 Knife Loose

Speed Ratio: 80.0%

Pause EMG Stop

Load Vendor Save As Vendor

Read Ini Save Ini

To Machine Drop Edit Admin Settings