Touch the key function

1. ⚙️ : Parameter Settings
2. : Air cushion
3. : Read the program
4. ： Save the program
5. △ , ▽ ： Move up and down
6. ： Cutting/no cutting
7. ： intelligent calculate   8. ① Start   9. → ： Enter
10. ↩ ： Return   11. ▽ ： stop

Run the machine in manual

After switch on,the computer will automatically initialize。Paper impeller will go back to machine end and stop. At the moment this page shows the followings:

| Current program No.and step | Current size of paper impeller | Size of front of knife | Air status | Current unit |

Program status

air and press paper choice in current step

program

Current step indication

Knife bed point-

Status of clamp

IR status

Main motor status

Go and back manually, paper impeller running, direction

Current position of paper impeller

2015-06-11 18:46:42   mm

Prog: 2   Cut: 100.00
0.00   T= 2s

1   100.00
2   767.00
3   0.00
4   762.00
5   0.00
6   1069.00
7   538.00
8   0.00

0.00   Semiautomatic mode   C

Cutting indiction

Cutting momery program

Current mode

Enter into program

switch of alignment light

1

operators can control the moving position of paper impeller freely by manual：

Method 1: Press key " ⬆ " or " ⬇ " to control the paper impeller go forward or backward，Press the key " ⏫ " or " ⏬ " to run fastly。

Method 2: Press the position **100.00** ，input the size in pop-up window，press "ENT"，the paper impeller will go to the appointed position.

Micro adjust： rotate hand wheel to micro adjust the position of paper impeller.
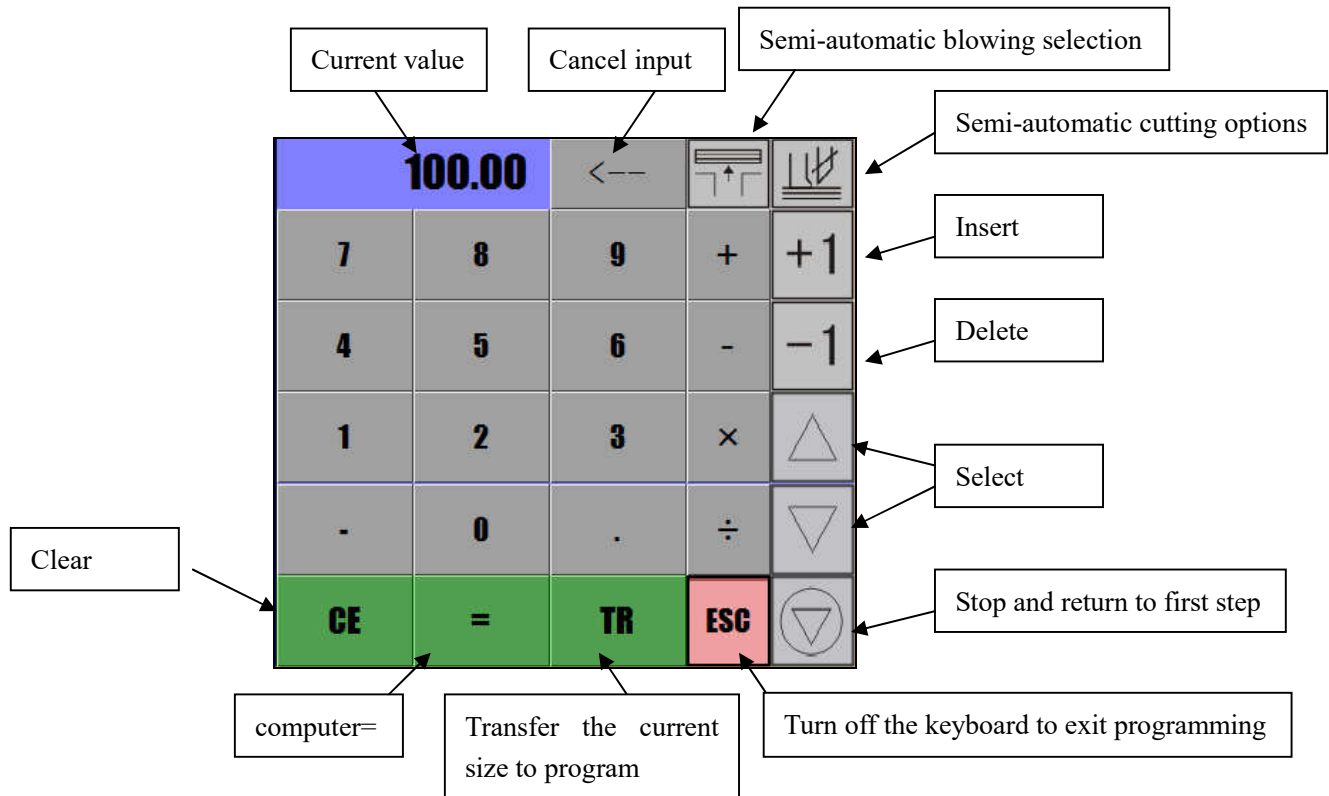
From any other mode changed into manual mode：

Method: Touch Semiautomatic mode to change。

Note：The above method can be operated when the program is stopped；*Yellow indication not blink means it is stop status; otherwish should press* " ⊘ " *to stop the program, or press* " ↩ " to exit the program.

Program Mode

Program mode allow the operator programming circulated moving of paper impeller. Press " ▦ " or digit area of program when the program is in stop status，it will pop the programming keyboard，if want to exit，press "ESC".

Current value — 100.00

Cancel input — <--

Semi-automatic blowing selection

Semi-automatic cutting options

Insert — +1

Delete — -1

Select — △ ▽

Clear — CE

Stop and return to first step

computer= — =

Transfer the current size to program — TR

Turn off the keyboard to exit programming — ESC

Programming the basic progam：

Method 1、 Press "⊞" or digit area of program, popup keyboard, then the position can be amended, Press "TR" after input the digit, in the same time the cursor will go to the next cut, repeat to input the digit, Press "ESC" exit after finish。Press "CE" to clear it when you input error.

Example

Example:1000.00
        800.00
          0.00
          0.00

Step 1：Press "⊞"

Step 2：Press 1-0-0-0, Then press "TR"

Step 3：Press 8-0-0, Then pres "TR"

Step 4：press "ESC"

Method 2、 *After the first input, Press anyone of*

"$\boxed{+}$-$\boxed{-}$-$\boxed{\times}$-$\boxed{\div}$", *input the digit (cutting width), Press*

"TR" *to enter the digit。 press "ESC" when finished.*

Example

    Example：1000.00
           700.00
           322.00
             0.00
             0.00

Step 1： Press ""

Step 2： Input 1-0-0-0, press "TR"

Step 3： press "$\boxed{-}$"

Step 4： input 3-0-0

Step 5： press "TR"

Step 6： press "$\boxed{-}$"

Step 7： input 3-7-8

Step 8： press "TR"

Method 3、 After input the first size, press one of the key

"$\boxed{+}$-$\boxed{-}$-$\boxed{\times}$-$\boxed{\div}$", input calculate value, press "$\boxed{=}$" to

    observe result, then press "TR" , or press "C".

Example

    Example:1000.00
           500.00
           100.00
             0.00
             0.00

Step 1： Press ""

Step 2： Input 1-0-0-0, press "TR"

Step 3： Press "$\boxed{\div}$"

Step 4： Press digit 2

Step 5： Press "$\boxed{=}$"

Step 6： Press "TR"

Step 7： Press "$\boxed{\div}$"

Step 8： Press 5

Step 9： Press "$\boxed{=}$"

Step 10： Press "TR"

Step 11： Press "ESC"

Instruction of other function in programming status

Blank the program currently in memory, easy to reprogram. Empty the memory, if you do not save and will not affect the internal memory data. Press and hold 3 seconds
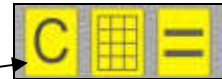
The use of cutting memory function

Press "" , Screen show:Teaching。Then adjust the position manually, cut (every cut will be shown in screen), finished and then press "" to exit。
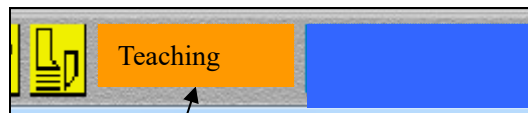
Indication of cutting memory function

Data Storage

The program is stored in momery，it can be used only it is stored in controller，Method as following：

1. press "" , show the menu right side,input group No.then press "ENT"

Note: *If the input group No.is same as current group No.,then the current data of group will be instead of*
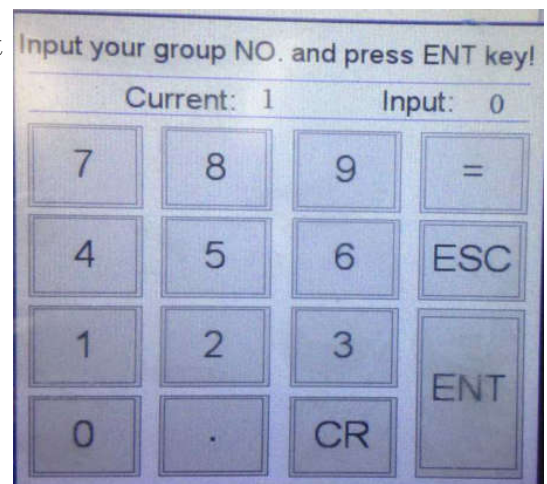
Use of Calculation

Method 1:as follows (manual /semiautomatic mode)

Example:
The position of Paper impeller 923.00, want to cut half

Step 1: press "⊓ 923.00 ⊓" , show
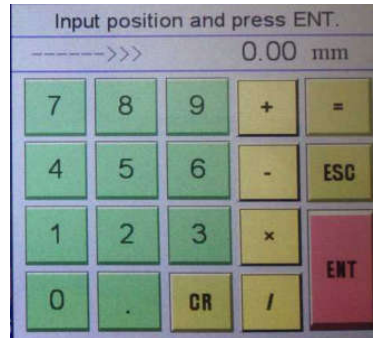
Step 2: press "/"

Step 3: press "2"

Step 4: press "="

Method 2:as follows (manual /semiautomatic mode)

Example:
The position of Paper impeller 500.00, want to cut 200.00 width next.

Step 1: press "⊓ 500.00 ⊓" , show

Step 2: press "-"

Step 3: press "2-0-0"

Step 4: press "="

Instruction of clearing some program

The method as follows (manual /semiautomatic mode)

Example: cancel the program under the 880.00 :

1000.00
990.00
0.00
900.00
880.00
770.00
660.00

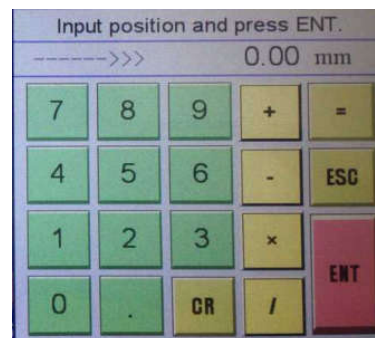**Step 1**：press "△"or"▽"choose

880.00

Step 2： press " C " 2 seconds

Semi-automatic mode

Semi-automatic mode is that the computer controls the position of paper impeller according to the made program. To make a new program or to choose an old program, press"Current mode

" to shift it into semi-automatic mode to ensure the main motor is in start-up status. Choose the start-up position NO. by "△"or"▽"

（press ▽ "the to go back the first knife），then press"◁▷"key，after one cutting action is over, paper impeller will move to the next object. *__When the value of continuous two knives is 0.00,perform to push out the paper, when the value of continuous two knives is 0.00, you can judge that the program is over.__*

For example：
1000.00
800.00
700.00
0.00
800.00
500.00
0.00
0.00
100.00
60.00

When running here,start to push the paper

When running here,the program is over

NOTE：In running status, press"▽"directly to skip this step。

To program the following:
start to cut by the semiautomatic
pattern from third knife position ,
jump directly to 80 then cuts again
 when cuts to120：

1000.00
700.00
322.00
300.00
120.00
100.00
80.00
0.00
0.00

Step 1： Establishes the procedure,the yellow indication bar in fist cutting place.

Step 2： press "Current mode" to shift into semi-automatic mode

Step 3： press "▽" twice to 322.00

Step 4： press "◇" once time

Step 5： cutting start, to 120.00

Step 6：press"▽"twice,the yellow cursor skip from 120.00 to 80

Step 7： Continue cutting

Fully automatic mode

The cutting action in fully automatic mode is same as that in semi-automatic mode. The difference is that the cutting is controlled by computer when it is in fully automatic mode, and air balls and paper pressing are acted according to the program. In other mode, press "" 4 seconds to skip fully automatic mode。

1. assistant function set under automatic mode：

choosing program under fully automatic mode,press" ⫟ ",
air state instruct green.Cancel press " ⫟ " again；
The method of pressing paper but no cutting is same as air set.

It shows only pressing paper but no cutting, the time of pressing paper is 1s. Amending this time by running parameter.

It shows no blowing under current step running.

For example:

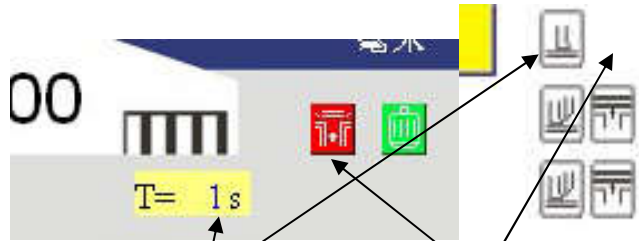|	
1000.00	blowing
700.00	no cutting，
322.00	blowing
300.00	no blowing
0.00	
0.00	

Step 1：Establishes the procedure, the yellow indication bar in fist cutting place.

Step 2：press"Current mode" 2seconds

Step 3：press " ⫟ "

Step 4：press " ▽ "

Step 5：press " ⫟ "

Step 6：press " ▽ "

Step 7：press " ⫟ "

Step 8：press " ↰ "

Note:at any time,hands or arms are strictly forbidden to extend to the range of knife holder！

Instructions of intelligent calculation

$L = 500.00 \times N = 1$

$La = 2.00 \times Na = 1$

$Lb = 15.00 \times Nb = 1$

$Lc = 56.00 \times Nc = 1$

1.	500.00	5.	425.00	9.	0.00
2.	498.00	6.	410.00	10.	0.00
3.	483.00	7.	354.00	11.	0.00
4.	427.00	8.	0.00	12.	0.00

余料: 354.00 mm

The data in this area can be set up.

Operating procedures：use the [icon] → intelligent calculation，enter the above page。

  L：the total cut length

  La：the first cut width, if this width is set as 0, it means the width does not cut.

  Na：the cutting times for the length whose width is La, if here is set as 0, it means the width does not cut.

  Lb：the second cut width, if this width is set as 0, it means the width does not cut.

  Nb：the cutting times for the length whose width is Lb, if here is set as 0, it means the width does not cut.

  Lc：the third cut width, if this width is set as 0, it means the width does not cut.

  Nc：the cutting times for the length whose width is Lc, if here is set as 0, it means the width does not cut.

  N：cut by Na times on La basis →cut Nb on Lb basis→ cut Nc on Lc basis, such regulations are circulated.

After input, press "[icon]"on keyboard, the calculating result will be sent to EMS memory and the system returns to running page. At the moment, start cutting or store the data into the controller for future use.

For example:

Using aptitude operation
Programme as below:

500.00
498.00
483.00
427.00
425.00
410.00
354.00
0.00
0.00

Step 1： Establishes the procedure first, does not guarantee under the programming condition or the running status.

Step 2： press " " key

Step 3： press " " moving cursor to "L=" ,
(the NO. in "L=" here is bickering, if not, it
should press the " ")

Step 4： Press number key 5-0-0 , press "ENT" key

Step 5： In behind "La=" , input number 2 (length=2),
press "ENT" key

Step 6： In behind "Lb=" , input number
15 (length=15) , press "ENT" key

Step 7： In behind "Lc=" , input number
56 (length=56) , press "ENT" key

Step 8： In behind "N=" , input number 1 (total
circle 1 times), presss "ENT" key

Step 9： in behind "Na=" , input number 1(circle 1 times),
press "ENT" key

Step 10： in behind "Nb=" , input number 1 (circle 1times),
press "ENT" key

Step 11： in behind "Nc=" , input number 1 (circle 1times),
press "ENT" key

Step 12： press " " ending

Note：You can add the Margin-cutting data by the way of insert at the front of programme,It can increase the operation data by repeating the steps mentioned above after 0.00。

Parameter setting

Reasonable data settings in the page will directly affect the running capability of paper cutter.

Press " ", the following parameter page will be displayed：

Blue indication bar. using "△" ro "▽" moving。
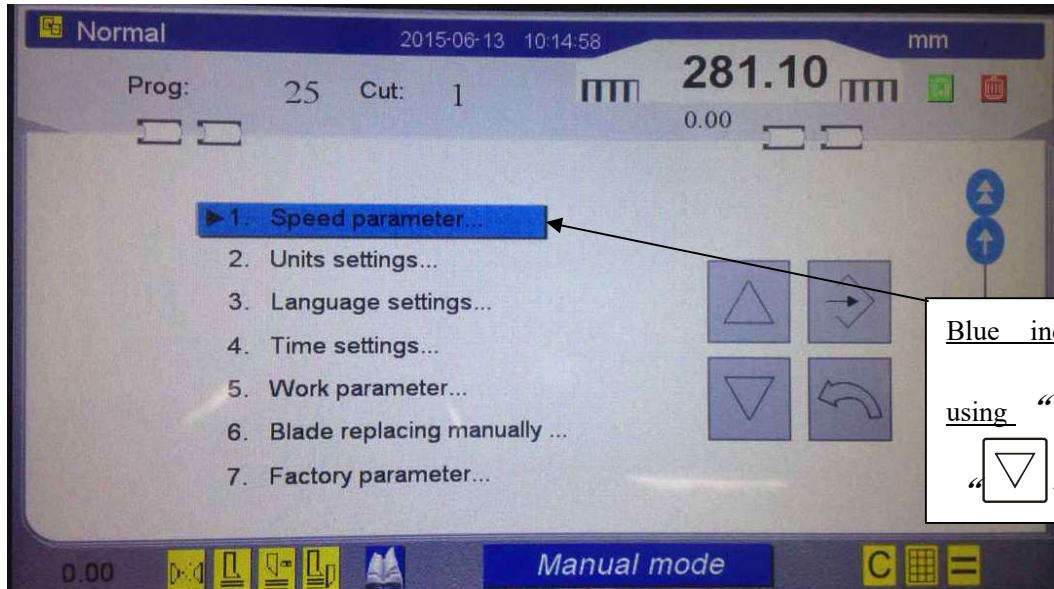
There are 7 items for choosing，use "△" or "▽" to choose，press "⟡" to enter。 Another way is press the words directly to enter next menu.

For example: If you want to set up factory parameter, you can press "factory parameter" directly. You can also press "△" or "▽" to move the yellow bar till "factory parameter", then press ⟡.

1、**speed setting**

Touch blue digital modifying

This parameter decides the amortizing time when paper impeller stops, directly affects the tolerance due to paper inertia while positioning. Generally speaking, it should be set up in 1-5S. The bigger the number is, the more stable it is, but it will lead to the machine running at a lower speed.

After setting, press "⟲" to return the previous page.

2、 **unit setting**

current unit：

1. mm ← current unit

2. inch
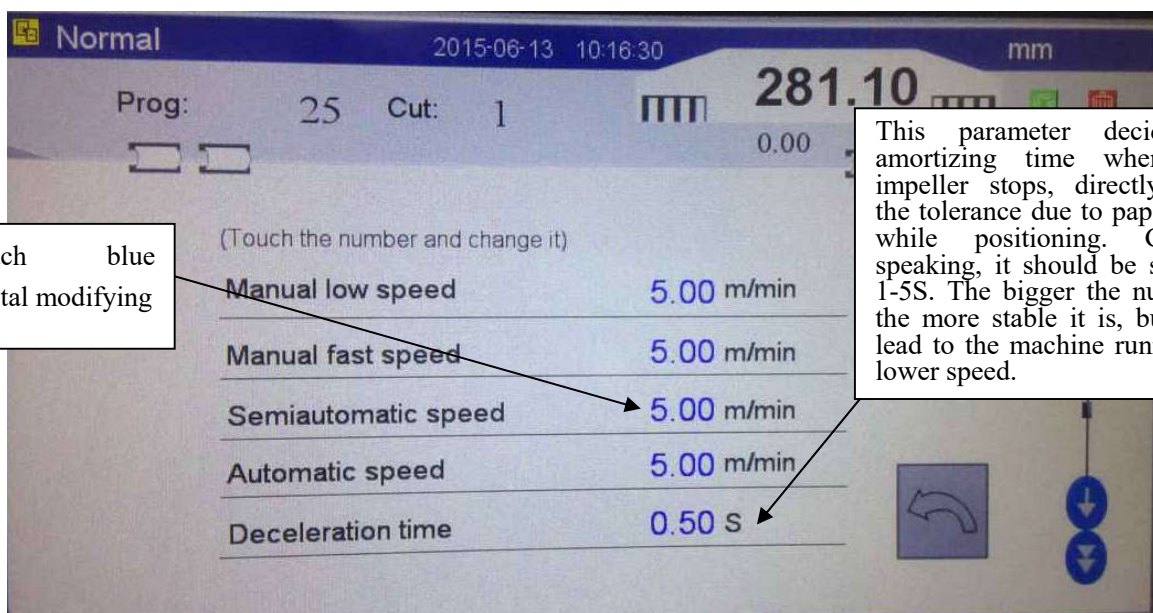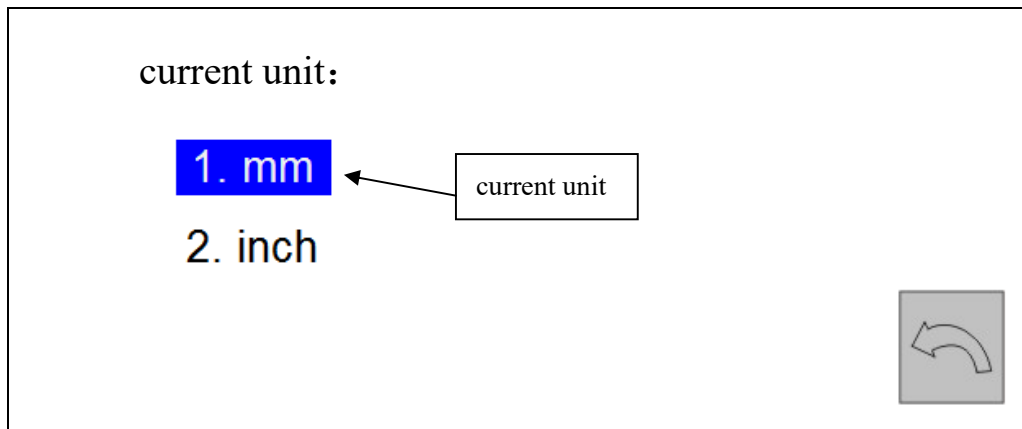
Touch the unit directly， press "⟲" to return。

3、 **Language Setting**

Current language:

(Touch the number and change it)

中文   English   Español

Touching the national flag you need language can take effect. After setting,press "⟲" to return.

Current language is English

4、 **time setting**

System time tune:

(Touch the number and change it)

2015 - 6 - 13 10 : 16 : 2

1. First touch the number to be modified

2. Then modify the time on the ejected keyboard in screen, after that, press ENT to input, or press ES to quit.

After setting, press " ⟲ " to return the previous page.

5、running parameter

This means how long it takes to wait until clamp bar works after the motor of paper impeller stops.

This means the stopping time of paper pressing in fully automatic mode when knife doesn't work, only clamp bar does.

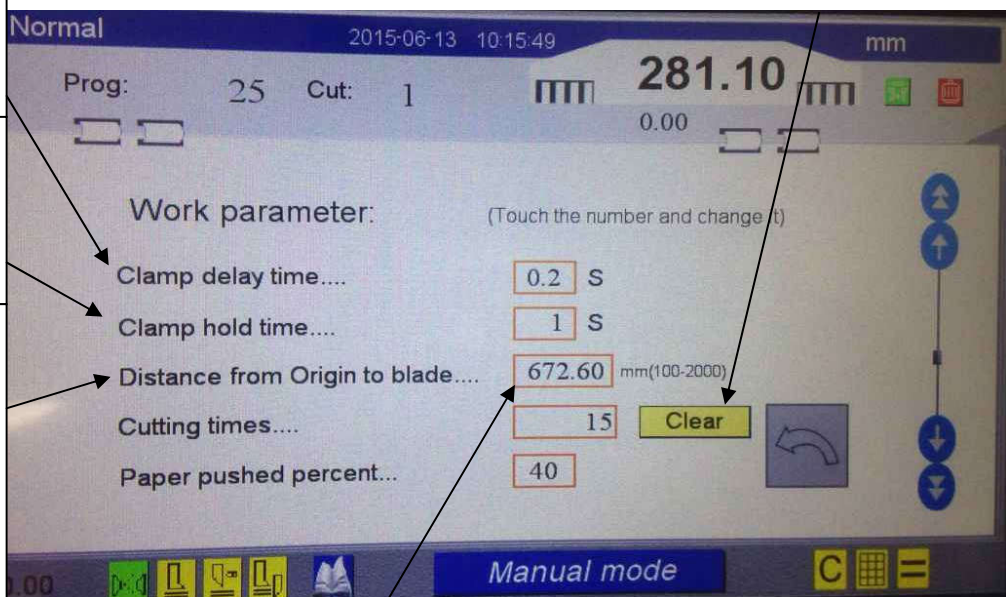The distance from knife surface when paper impeller is at original place. **This parameter should be precisely measured before input, otherwise it leads to cutting tolerance.**

Press here 1 second to cancel the data

1. first touch the parameter to be modified
2. Then modify the data on screen keyboard, after that, press ENT to input, or press ESC to quit.

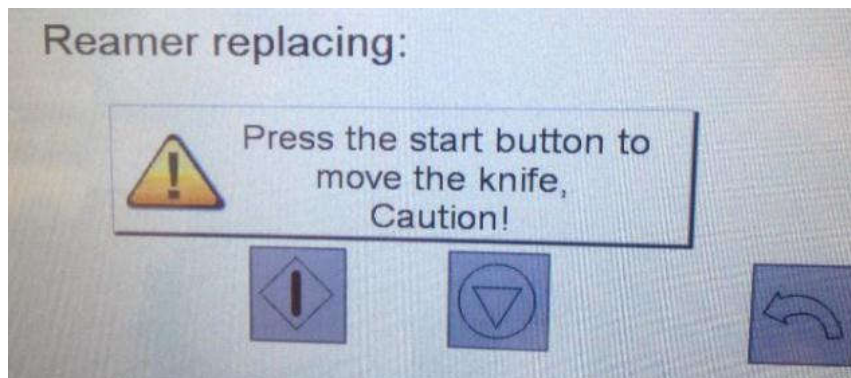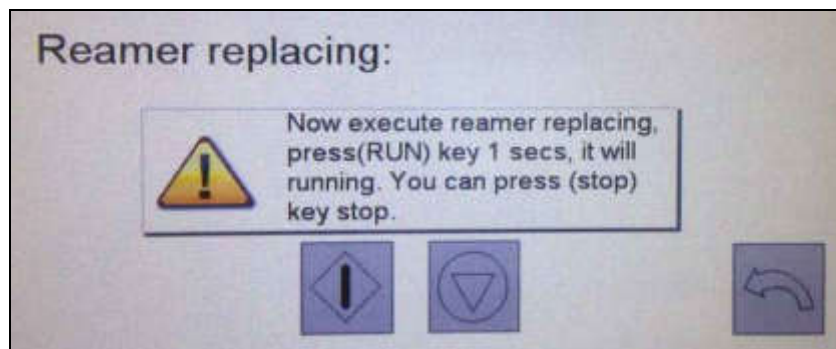After setting, press " ⟲ " to return the previous page.

For example:

Change the origin and cutting-place distance from 1300.00mm to 1298.20mm

Step 1： press " ⟦⚙⟧ "

Step 2： press number 5, enter parameter setting

Step 3： using finger to press number 1300.00
2seconds

Step 4： in a small window dap, input
"**8888**" ;**L**=here input number 1298.20

Step 5： Press "**OK**" key

Step 6： checking the number changed number 1298.20

Step 7： press " ⟦↩⟧ " to return

Note: when the screen display value and the actual cutting
of the absolute position is not the same, first base
(by: off again), if the base no problem, you can adjust
the distance the origin to the cutter.

Example: the actual cutting place is more than the showing value in screen 1mm, adjust the origin and cutting place distance 1mm.
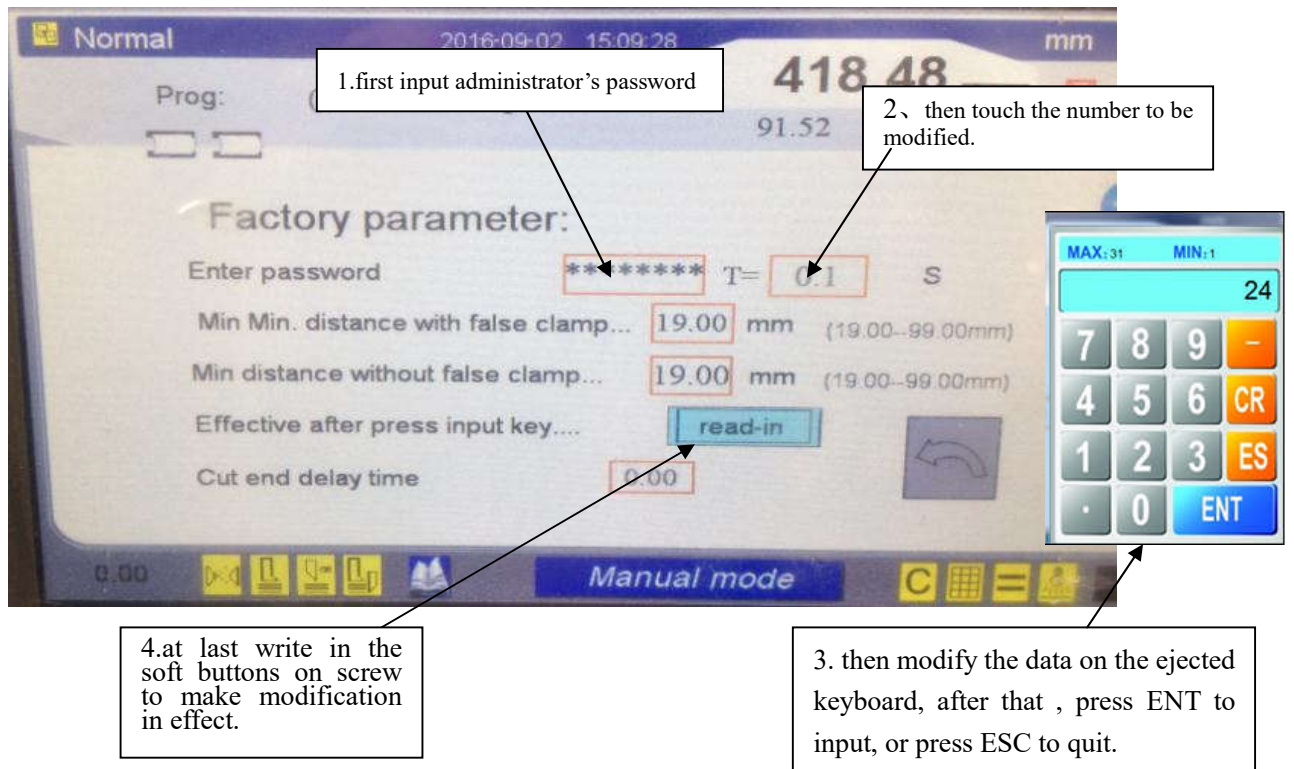
6、 replace knife

Knife-replacement is used according to screen information, after setting, press " ⟦↩⟧ " to return the previous page.

7、factory parameter

1.first input administrator's password

2、 then touch the number to be modified.

4.at last write in the soft buttons on screw to make modification in effect.

3. then modify the data on the ejected keyboard, after that , press ENT to input, or press ESC to quit.

administrator's password：87654321

Note: to change the factory parameter needs administrator's password.

After setting, press "⟲" to return the previous page.

Cutting knife bed time delay:, When cutting, After running to the control switch, knife bed, Will not return, but continue to cut; Knife bed after completion of the set time to return to the highest position. Apply to the blade wear.

such as: factory knife bed time delay is set to 0 seconds, after 5 mm blade wear, should first adjust the mechanical part, to operate a computer, knife bed time delay is set to 0.3 seconds.

The knife bed time
delay from 0 seconds
to 0.3 seconds

Step 1：press　"⌗"

Step 2：press number 7, enter the factory
　　　　parameter Settings

Step 3：According to the knife bed delay
　　　　behind the number in the box

Step 4：In the small window, enter 0.3

Step 5：Press the "ENT" button

Note: when the blade wear, should first adjust the mechanical part, that the sword bed can be cut to the lowest position; To adjust the corresponding computer parts (that is, the knife bed time delay setting)