Description of operation function of CNC Pnael saw

1. Start interface: the initial interface of boot, different models and system picture background is different, but the basic operation keys are basically the same.

1. Current timing of the system: the factory default Beijing time zone. Different countries and regions can be set according to the local time zone. When the products need to be purchased, the time zone requirements can be marked clearly, and they can be set according to the customer requirements when leaving the factory.

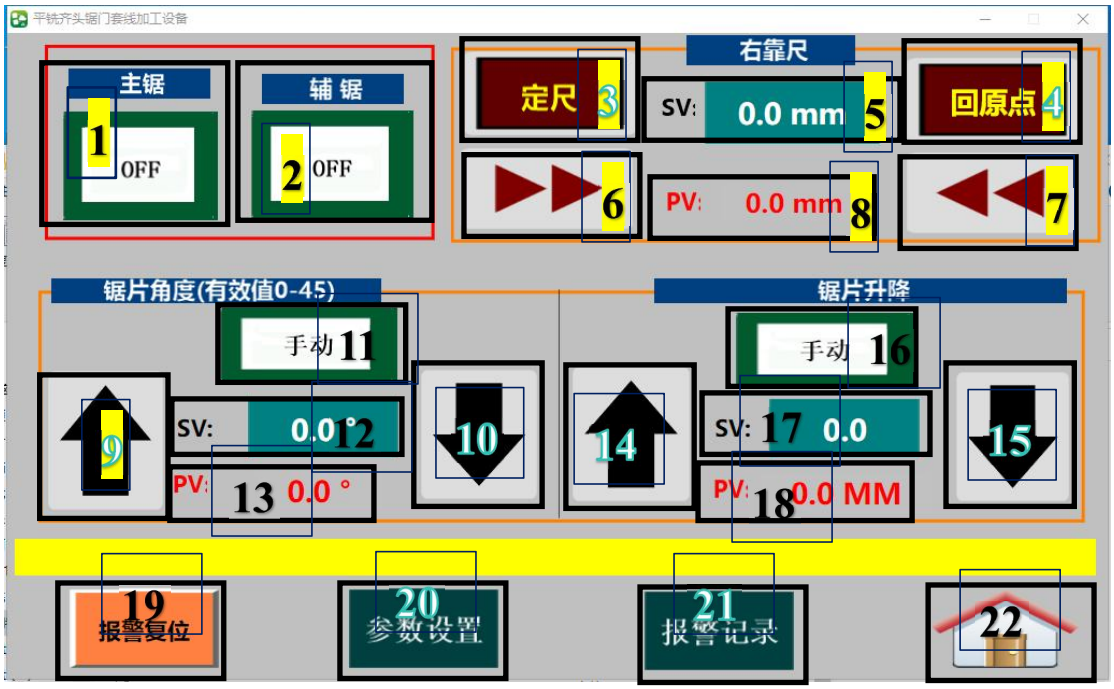
2. Equipment number: it is the machine equipment identification number set by the equipment manufacturer according to its own regulations, and also the equipment identification number code of the manufacturer in the later equipment maintenance and after-sales service.

3. System foreign language: This button is only valid for the outlet equipment.

4. Language in the system: This button is only valid for the outlet equipment.

5. Enter the system: operate this key to enter the operation interface to use the equipment operation.

2. Operation interface: This interface is the main interface for equipment operation



control operation.

1. Main saw (large saw blade) control operation button

Set the "ON" master saw to start, and set the "OFF" master saw to stop.

主锯停止

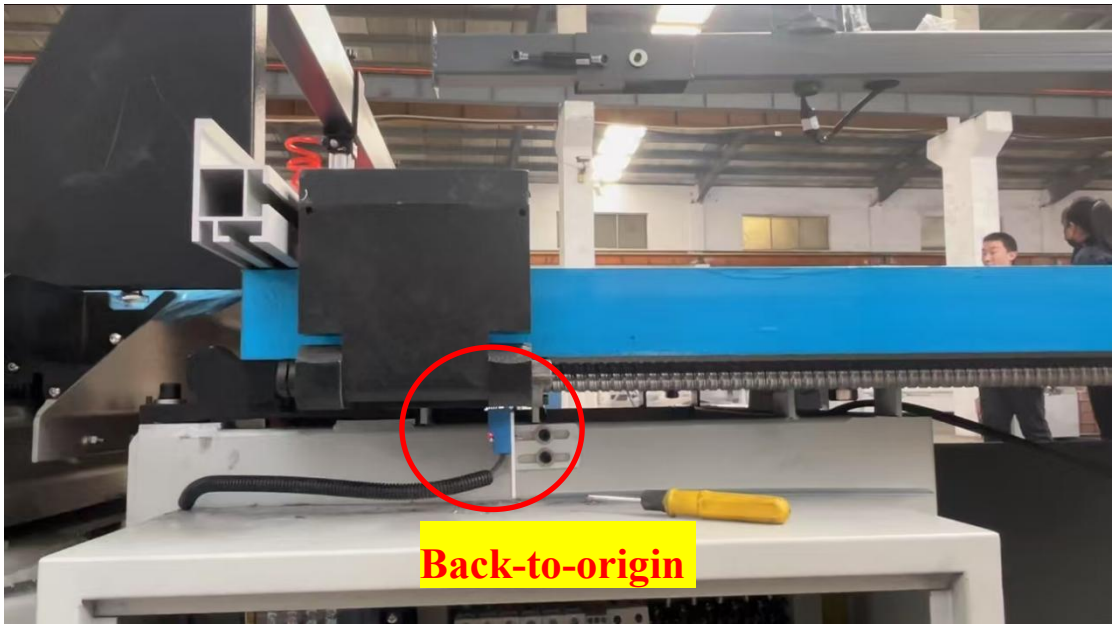
按键状态指示

主锯启动

2. Operation control button of the auxiliary saw (the small saw blade running in the opposite direction relative to the large saw blade)

Set the "ON" auxiliary saw to start, and set "OFF" auxiliary saw to stop.

3. Fixed rule: operate the key and automatically execute the "5 mark".



4. Return to the origin: the key that forces the ruler to go back to its initial point position.

Back to the origin is the dominant work size accuracy key factor, the specific working principle is: no matter by the current position, as long as the operation of the "origin" button, by the ruler will force back to the ruler near the initial position of the blade, and will also put by the ruler "SV" the current value forced into set compensation value (back to the origin by the ruler to the actual value of the blade). The "back to the origin signal sensor" in the figure above is crucial, which is the key signal back to the origin.

5. SV of mark 5: the set coordinate value to be executed by the ruler, and the set by the ruler coordinate position value to be set by the operator according to the production dimension requirements. The maximum set value should not exceed the ruler travel, the minimum set value should not be less than or equal to the compensation value.

6.6 Direction key: this key is a manual operation to control the relative direction to the saw blade.

7.7 Direction pointing key: This key is a manual operation control key to run against the saw blade.

8. PV of mark 8: by the current coordinate value of the ruler.

9.9 direction pointing key: this key is a manual operation to rotate the saw blade from 0-45 degrees,

The vertical direction of the saw blade is regarded as zero, and the maximum tilt angle can be adjusted to 45 degrees.

10.10 direction pointing key: this key is a manual operation control key to rotate the saw blade from 45 degrees-0 degrees,
The vertical direction of the saw blade is regarded as zero, and the maximum tilt angle can be adjusted to 45 degrees.
11. Manual: convert the key "manually" to "automatically" to execute the "12" setting.
12. SV marked 12: the angle rotation value of the saw blade and the saw blade tilt angle value set by the operator according to the production requirements. Do not set the travel beyond the adjustable angles.
13. PV labeled 13: the current angle value of the saw blade.
14.14 direction pointing key: this key is a manual operation to control the saw blade rise key.
15.15 direction key: This key is a manual operation to control the saw blade drop.
16. Manual: convert the key "manually" to "automatically" to execute the "17" setting.
17. SV marked 17: To perform the lifting height value, and the saw blade height value is to be set by the operator according to the production requirements. Do not exceed the adjustable height trip.
18. PV labeled with the number 18: the current height value of the saw blade.
19. Alarm reset: This key is to eliminate the alarm content in the yellow alarm bar. If the key can not eliminate the alarm content, please read the following alarm content carefully. Handle the key after handling the related problem of the alarm content. When there is an alarm content in the alarm bar, the equipment cannot operate normally.
20. Parameter setting: The key requires the permission password 0001. Enter the correct permission password to enter the interface to modify or view the operation parameters.
21. Alarm record: The key can enter to view the alarm record generated in the operation of the equipment. The engineer can understand the operation of the equipment through the alarm record, and can also help troubleshooting the operation fault of the equipment.
22. Number 22 key: This key can exit the current operation interface and return to the opening interface.

3、**Parameter setting: This interface is the main interface for modifying and viewing the device operation parameters.**

1. Number 1 parameter: This parameter is forbidden to be modified under the guidance of the technical personnel of the equipment manufacturer.

2. Number 2 parameter: This parameter is not allowed to be modified under the guidance of the technical personnel of the equipment manufacturer.

3. Saw blade lifting stroke: please set according to the specific size of the saw blade beyond the table.

4. Angle correction: When the Angle of the saw blade does not match the actual number display value, open this key (permission password abc123), and then force the saw blade to the standard zero through the manual button to adjust the Angle.

5. Saw blade Angle zero: after following the "4 Angle correction" operation method, then operate this key (permission password abc123), that is, the current Angle value can be forced to zero.

6. Saw blade height zero: when the height of the saw blade is not consistent with the actual height, then force the saw blade to the platform by adjusting the manual button of the saw blade height, and then operate this key (permission password abc123), that is, the current height value can be forced to zero.

7. Number 7 parameter: This parameter is not allowed to be modified under the guidance of the technical personnel of the equipment manufacturer.

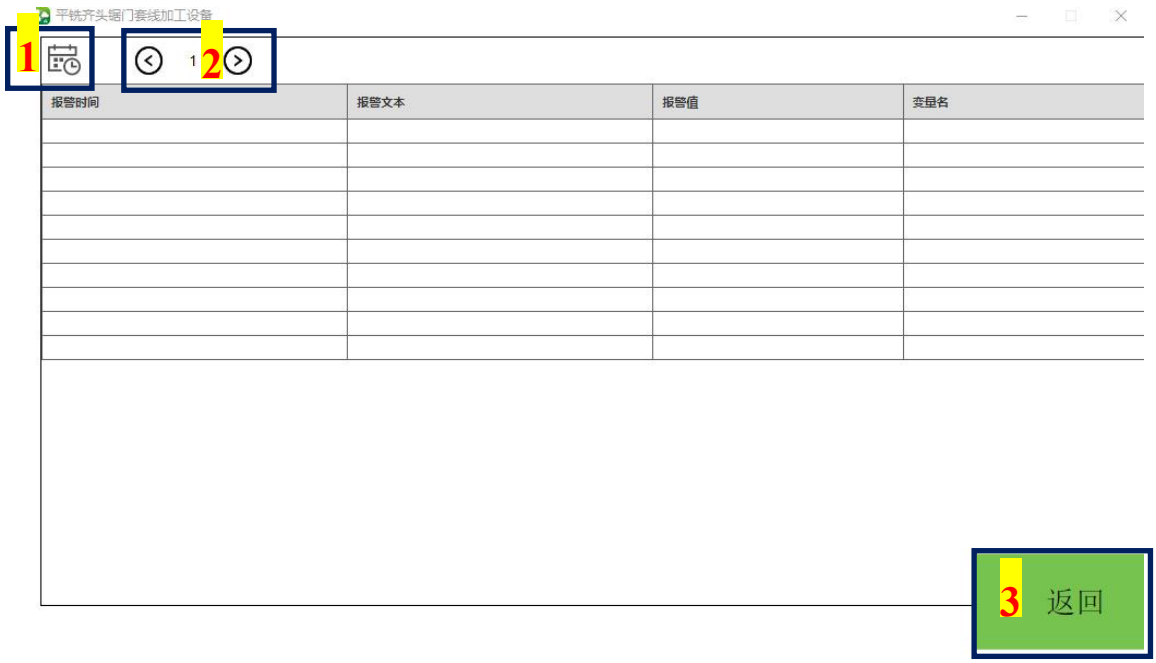
8. Compensation by ruler data: this parameter is the value of compensation by the ruler to the saw blade back to the origin. This value must be consistent with the actual value, otherwise it will affect the accuracy of the working size.

9. Backward limit value: This parameter is to protect the operator from transmitting the wrong working data, and the ruler and the saw blade vacuum cover collide. Be sure to set the data correctly.

10. Exit: operate this key to close the current parameter interface and return to the operation interface.

11. ID 11 Data status: This number saw is prohibited without operation, and it is used to monitor the operating status of the PLC controller.

4、Alarm record: This interface is to check the alarm situation generated in the operation of the equipment.



1. Mark Number 1 icon: This icon is an accurate view of the alarm record at a certain time by inputting the time.

2. Mark 2 icon: This icon is to check the alarm record by turning the left and right keys.

3. Return: This icon can be closed to the current interface and return to the operation interface.