Preface

- A copy of this "Operating Instructions" is included with the machine.
 Please keep this manual for reference at all times.
- Please read this manual carefully before operating this equipment.
- Due to the update of technology and the special requirements of the product, the actual product may differ from the manual, please refer to the actual product, we will try to add additional instructions.
- When the equipment is in normal use, please reserve a certain amount of space in front of and behind the equipment as space required for operation and maintenance. In addition, please do not set up the equipment in such a way as to obstruct the space for heat emission.
- Equipment use environment: temperature: 5 ~ 25 ℃, relative humidity: 20 ~ 95%, not subject to direct sunlight, no dew, no splashing of water, oil, chemical liquid place.
- Operation and maintenance of this machine technicians must be able to use the computer.
- The computer configured on this machine can only be used for this machine, it is strictly prohibited for other uses, it is strictly prohibited to carry a virus of other mobile memory into this machine, so as not to damage the control system.

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- The randomly configured U disk should be strictly prevented from virus intrusion, and it is strictly forbidden to use it on other computers.
- For personal safety, when the equipment is running or standby, please do not open the front door and chain as well as the station head guard without taking any safety measures, and it is strictly forbidden for clothing and limbs to be close to the moving parts of the machinery, otherwise, it may bring accidental injury to the person.
- Repeatedly switching the power supply can be one of the reasons for the equipment to produce malfunction. After power OFF (cut off), please power ON (turn on) again after 20 seconds or more.
- Do not subject the equipment to impact or strong vibration, as this may cause malfunction.
- When you cut off the power of the device, please follow the following order for the system exit/shutdown process. If the power is cut off or restarted directly without executing this process, the data will not be saved intact and the hard disk may be damaged at the same time.
 Exit/shutdown process: Exit the application, exit Windows, and power off the device.
- If the use of the device is suspended, please store the device in the following place: the ambient temperature is (0-40)°C, the relative humidity is (20-95)%, not subject to direct sunlight, no dew, no

splashing water, oil, chemical liquid place. In order to prevent dust, cover measures (such as phi cover) can be considered, but moisture-proof.

• Please contact us if you do not understand, do not operate blindly.

Note: Please pay attention to the above matters!

Machine overview:

S-7000 Odd-Form Insertion machine is a high speed, high precision and high performance equipment, which is a insertion equipment developed by our company specially for large capacitor-resistor and other components that should not be inserted with ordinary insertion machine. It integrates four insertion heads, which can selectively realize selective insertion such as vibration reel bulk material, vertical braiding tape, vertical braiding tape to axial, axial braiding tape. The insertion head is responsible for the acquisition of components, by the movement of X, Y mechanism, to achieve precision insertion in each area of the PCB board, the angle of insertion is achieved by the steering axis control. The series control software and operation software are also developed by our Add: Room 1806, Block 3, Jinyun COFCO, Qianjin 2nd Road, Xixiang, Baoan District, Shenzhen City, China Website: www.smthelp.com

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company, and all operations are controlled by one computer.

This series of machines has the following advantages:

 \triangle full computer control, full Chinese version of the operating system, based on the Windows platform, easy to operate, fast, easy, easy to learn.

 \triangle use machine vision technology, online automatic programming, automatic correction, automatic identification of MARK points, improve the degree of automation.

 \triangle adopt AC servo system to optimize the line, eliminate the instability caused by the line fault, and achieve a stable high speed and energy saving.

Software operation

1. Safety inspection before the operation.

Please note: when the machine is newly installed or long-term idle state, before the power and ventilation of the machine, must carefully do the following safety checks:

1) Check whether the power supply is the specified rated voltage.

2) Check whether the main power supply is connected to the machine, the insurance is intact, and the branch circuit breaker is closed.

3) Whether the equipment is properly grounded.

4) Determine that no irrelevant items remain in the electric control box and on the movable parts of the machine.

5) Whether the conveyor belt and synchronous belt fall off in transportation.

6) Check whether the heavy load and high-speed operation mechanisms such as wire rod, slide rail and Auto Insertion shaft are well connected.

7) Push and pull X, Y, H1, H2, H3, H4 and D organizations by hand to see if the activity is moving smoothly.

8) Check whether the limit detection and limit mechanism are dislocated.

9) Check whether the emergency switch is pressed down, and check whether the main gas source and power switch are in OFF state.

10) Check whether the wiring plug and air pipe between the computer, electric control box and main and auxiliary machine are well inserted.

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2. Operation interface description, divided into the following three

areas.

🚧 F3000-4-02							
文件程式 制作及修改程式 I/0	信号诊断 马达调试 取	放料位置设定 供料器类型	投置 厂家信息 帮助	信息 后台管理 训	剧出		
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1) Production operation area: This area controls the operation and production of the machine (as shown in the figure above):

Button and selection explanation:

Start: start the Auto Insertion program, each part of the machine to complete the Auto Insertion task.

Stop: The machine stops working and enters the standby state.

Zero: Return the workbench and turntable to the starting zero position.

This is a necessary move before the first shift and Auto Insertion.

Alarm reset: When the machine encounters a Auto Insertion error in the

production process, it will stop working and display the error information

in the shutdown information. When the information is repaired, click the alarm reset and start the production.

Production operation mode:

- 1. Continuous: that is, the continuous execution of the action, directly complete the production quantity.
- 2. Single step: that is, to complete a complete Auto Insertion cycle action.
- Step-by-step: decompose the Auto Insertion action into several steps, completing only one step at each startup.

Mark check

- 1. Detection: perform MARK point correction with the MARK point correction command in the PA sequence command.
- 2. No detection: No MARK point correction command is executed.

Load the PCB board:

- 1. Load PCB board: search the board up the computer according to the normal process.
- Not loading the PCB board: Skip the process of loading the PCB board, and directly start the Auto Insertion, suitable for manual template placement.
- Just over the board: no Auto Insertion action, only flow through the PCB board.

Material feeding selection:

- Feed Auto Insertion: in the Auto Insertion process, the head first to take the material and then Auto Insertion.
- 2. No feed presentation: perform futile insertion action.

Discharge selection:

- Automatic feeding: in the process of Auto Insertion, if the Auto Insertion fails, first move to the feeding position, and then to the feeding position to replace the material feeding
- 2. Manual feeding: in the process of Auto Insertion, if the Auto Insertion fails, stop the alarm, manually remove the alarm, to the feeding position

Times of discharge:

- One time; if the Auto Insertion fails, the number of re-insertion is 1. Whether the insertion is successful or not, the Auto Insertion in the next position is skipped.
- Two times; if the Auto Insertion fails, the rate of re-insertion is at most 2 times. No matter whether the insertion is successful, the Auto Insertion in the next position is skipped.
- 3. Two times; if the Auto Insertion fails, the number of replacement is up to 3 times. Whether the replacement is successful or not, the Auto Insertion in the next position is skipped.

Material feeding test:

1. Detection: In the process of feeding, it is necessary to detect whether

the material is accurately delivered to the position, and then notify the Auto Insertion head to collect the material

2. Non-detection: the station in the process of feeding, when the implementation of the material transport action, do not detect whether the material is in place, all notify the Auto Insertion head to take the material

End of the whole board work: after inserting the current board, stop the Auto Insertion work;

The speed of manually moving the workbench.

Running speed

Adjust the speed of each axis during the Auto Insertion process.



生产操作	
启动	停止
	₹)
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生产模式	Mark检测
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	à
送料检测	抛料选择
☑ 检料1 ☑ 检料2	自动抛料 手动抛料
□ 拾彩 2 □ ↓ ↓ ↓	<u>'</u>
 ☑ 检料3 ☑ 检料4 手动移动工作台速度 	抛料次数
	1次 2次 3次
	à <u></u>
• • • •	□ 整板结束 □ 安全门

2) List of Auto Insertion sequence

Without reading the plugin data, display the company Log,

when Auto Insertion data, display insertion data;

Display the CCD image when the MARK point correction is encountered during production;

3) Operation information area

This area displays the current production information.

运行信息 程序名称:				预设产值: [1000	板	修改套数
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2#:	完成: 0	抛料:	0	4#:	完成: 0	抛料: 0	K)
己加工(颗):				己加工(板)).		

Downtime information

Showing the shutdown during production, it may be alarm information, it may have completed the production task arranged.

Program name

Display the program name that is about or has run. It changes with "opening" different programs.

Preset output value

That is the number of PCB boards to Auto Insertion in production. It stops automatically when the quantity value is reached.

Single component time

Display the average time spent on inserting an item

Single board time

Displays the average time spent after inserting a PCB board

1 #, 2 #, 3 #, 4 #: Display the number of successful and thrown items of

each Auto Insertion head

Materials completed: displays the number of completed Auto Insertions

Processed board: displays the number of completed Auto Insertion units

1. Menu bar instructions



graph 4

1) File program



graph 5

Click on the file import program and it will popup with all the file names The dialog box (as shown below), then click the program name that you need to "open" inside, and then click "Open", the machine accepts the "task" that will perform the program, and overwrites the previous Add: Room 1806, Block 3, Jinyun COFCO, Qianjin 2nd Road, Xixiang, Baoan District, Shenzhen City, China Website: www.smthelp.com Tel: +86-755-83203237; Fax:+86-755-2324049



program.

打开			? 🔀
查找范围(I):	🞯 桌面	•	•
→ 我的文档 3 我的电脑 ○ 网上邻居 ○ 111.x1s ○ 222.x1s			
文件名(M):	111. xls		打开 (2)
文件类型(I):	插件机数据(*.xls)	•	取消

Export program

Click on the file program import program, it will pop up a dialog box to please choose the file name, (as shown below), you can also enter the file name you need in the file name bar, click "Save".

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保存在(I):	📴 桌面	•	•••
→ 我的文档 我的电脑 网上邻居 到111.xls 222.xls			
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保存类型 (<u>T</u>):	插件机数据 (*. xls)	1	取消

Modify the program file

Click on the file program to modify the program file, and it will pop up a dialog box to please select the file name (Figure 6). Then click on the program name that you need to "Open" inside, and click on "Open" again,

and it will be in the office with. Open in the xls format.

2) Make and modify the procedures

🚧 F3000	-4-02									
文件程式	制作及修改程式	I/0信号诊	断 马达调试	取放料位置设定	包 供料	科器类型设置	呈 厂家信息	帮助信息	后台管理	退出
生产操	制作及修改程式 站位信息设置	ť.			序号	X	Y	模板	角度	脚

Make and modify procedures Create or modify the Auto Insertion data with the help of the camera.

Click to Make and Modify the program to make and modify the program, and it displays the following dialog box.

(改及制	作程式					
加模板	修订模板	标定相机与插	件轴 标定	相机		
数据显	示区					
序号	ŵ.	v l 桟	輱 1	角度		
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2	121.414		压器	0 3		
3	-76.072		压器	0 3		
4	-48, 63		压器	0 3		
5	-21.14		压器	0 3 9		
6	6.332		压器	0 3		
7	33.816		压器	0 3	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	
8	61.282		压器	0 3		
9	88.79		压器	0 3		
10	116.348		压器	0 3	· · · · · · · · · · · · · · · · · · ·	
11	116.342		压器	0 3 1		
12	88.794		压器	0 3		
13	61.354		压器	0 3 8		
14	33, 762		压器	0 3		
15	6.408		压器	0 3	8 / E3 /	
16	-21.174		压器	0 3 0 3 🖌	7	
17	-48.692		压器	0 3 🞽		and a second sec
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匹	配角度	0	✔ 度	<u> </u>	手动移动平台速度: 20.0	退出

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茅号	X	Y	模板	角度	脚位	插件轴	^
1	-81.454	-3, 954	变压器	0		3	
2	121.414	-68.738	变压器	0		3	
3	-76.072	-9.372	变压器	0		3	
4	-48.63	-9.62	变压器	0		3	
5	-21.14	-9.62	变压器	0		3	
6	6.332	-9.702	变压器	0		3	
7	33, 816	-9.616	变压器	0		3	
8	61.282	-9.528	变压器	0		3	
9	88.79	-9.614	变压器	0		3	
10	116.348	-9.528	变压器	0		3	
11	116.342	-62.798	变压器	0		3	
12	88.794	-62, 798	变压器	0		3	
13	61.354	-62.716	变压器	0		3	
14	33, 762	-62.876	变压器	0		3	
15	6.408	-62.79	变压器	0		3	
16	-21.174	-62.708	变压器	0		3	
17	-48.692	-62.716	变压器	0		3	×
31						>	1

I Data Display Area: display the Auto Insertion data already generated

II CCD image area: display the position where the camera capture image has had the Auto Insertion match, to help generate the Auto Insertion data, modify the matching difference, and the image responds in real time.



Menu bar:

添加模板 修订模板 标定相机与插件轴 标定相机

Click Add Template to pop the Add Template dialog:



Method of operation:

First move the template image to be generated to the camera view through the keyboard direction key.

Then, move the mouse cursor to the green rectangular box. When the cursor is on the edge of the rectangular box, press the left mouse button and move the mouse to change the size of the rectangular box. When the cursor is in the middle of the rectangular box cross, press the left mouse button and move the mouse to change the position of the rectangular box. Now through the above operation, make the rectangular frame just frame down the border of the template, generally the position of the PCB board has the outer frame identification.

Adjust the minimum and maximum radius and click to generate the



template data. The foot position data inside the template box is read and generated. Then name the template, click Add, and you add the template. Click Revision Template to pop the Add Revision Template dialog:

据显	示区							A B		- P
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2	121.414	-68.738		0	3	1		COLUMN TO PROVE D		
3	-76.072	-9.372	变压器	0	3			1000 (COLOR)		
4	-48.63	-9.62	变压器	0	3					0.0
5	-21.14	-9.62	变压器	0	3				1 1 1 1	
6	6.332	-9.702	变压器 变压器	0	3			and the second	52.	
7	33.816 61.282	-9.616 -9.528	受压器	0	3					
9	88.79	-9.614	交压器	0	3			Contraction of the		
10	116.348	-9.528	交压器	0	3		1 2 3 4		말해 물 일 수 !	
11	116.342	-62.798		0	3			• •)
12	88.794	-62.798		õ	3					
13	61.354	-62.716		0	3	W/T		I de		81
14	33.762	-62.876		0	3	-				ר_"('
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	1510311	-			AG ALINK					
		-		-						
	最小半	译 3								
					取消修改					
	最大半(7								

Select the template name to revise in the template name, with the diagram showing the original template shape and data, then fine-tune the rectangular box position, or change the minimum radius and the maximum radius, and then regenerate the data. Click Calibrate Camera and Auto Insertion shaft, popping up add calibrate camera and Auto Insertion shaft dialog box:

í	的 政策制度	作程式					δ
1905	5加模板	修订模板	标定相机	与插件轴	标定相机		
	数据显	显示区					
	序号	X	Y	模板	角度 月	即位 插件轴 🔨 💋	
	1	-81.454	-3.954	变压器	0	3	
	2	121.414	-68.738	变压器	0	3	
	3	-76.072	-9.372	变压器	0	3	
	4	-48.63	-9.62	变压器	0	3	
	5	-21.14	-9.62	变压器	0	3 0 0	
	6	6.332	-9.702	变压器	0	3	
	7	33.816	-9.616	变压器	0	3	
	8	61.282	-9.528	变压器	0	3	
	9	88.79	-9.614	变压器	0	3	
	10	116.348	-9.528	变压器	0	3	
	11	116.342	-62.798	变压器	0	3	
	12	88.794	-62.798	变压器	0	3	
	13	61.354	-62.716	变压器	0	3	
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	16	-21.174 -48.692	-62,716	支压器	0	3 3 3 💌	
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1							
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		插件	轴位置	у:	96.410	Y≱h: 0.000	回位
			示定		测试CCD-指	插件轴	

Calibrate the camera position

Move the one-Auto Insertion location to the ROI area of the camera image, click to scale the camera position, and the program matches and records the location of the current platform.

Calibrate the Auto Insertion shaft position

Move the Auto Insertion position used to calibrate the camera position under the Auto Insertion shaft, fine-tune the XY axis, and manually move H, so that H can be inserted in this position, click the calibration Auto

Insertion shaft position program to record the location of the current platform.

The mark is completed

Complete the calibration of the camera position and the calibration of the plugin shaft position and, click, the calibration is completed, the program will calculate the relative position of the insertion position under the camera image and the Auto Insertion axis, and fill in to the two editing boxes on the right.

Test

First move the Auto Insertion position to the camera image ROI area, click on the test program will first correct the specific location in the ROI area, and then automatically move to the Auto Insertion axis below, then you can see whether the data is accurate. **SOUTHERN** MACHINERY

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位置教导						×
┌位置选择一						
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- 各轴当前/ X	位 <u>置</u>	H1 H2		H3 H4		
D轴正传	90 D轴负传90		位	确定	取消	

Click Camera Calibration and pop up the Camera Calibration dialog box

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Regions with only one matching target were selected on the matching board, as shown in Fig.



The program calculates the number of pulses moved by the XY axis and the number of pixels moved by the XY axis on the image, and determines the ratio of the distance on the image to the actual distance.

Test camera platform

Move the matching target to any position in the image, if it can automatically return to the center of the camera, to prove a successful calibration.

Match the parameter setting zone

	ERN NERY Southerr	n Machinery Sa	ales and Se	rvice Co., Ltd.
☑显示模	板匹配界面	□显示Mark点	匹配界面 [□手动
模板参数		Mark点匹西	记参数	
模板名称 3	变压器	▼ 最小半径	2	像素
最小半径 3	3 像	素		Parket
最大半径 8	8 像	ま ま 一二値化	10	像素
圆孔数量	个	一数 二值化阈(值 118	
匹配角度() 🔺 度		0	<u> </u>

Display the template matching interface: display the image shape of the selected template;

Display the Mark point matching interface: display the shape of the Mark point matching

Template Name: select the completed template name

Template minimum radius: the minimum matching radius of this template pin circle

Template Maximum radius: the maximum matching radius for this template foothole circle

Number of round holes: number of pin hole circles in this template

Match angle: The match angle for this template; there are four, 0, 90, 180,

270

Mark minimum radius

Minimum target size radius sought within the matching ROI region.

Mark maximum radius

Maximum target size radius sought within the matching ROI region.

Binarized images

Divide the image according to the threshold, into a black and white gray scale map.

Image binarization of the valve values

Adjust the size of the threshold of the segmentation diagram.

Calibration camera platform

IV Matching Area:



Manual coordinates

Move the Auto Insertion coordinates to the image ROI area and directly record the XY coordinates. For PCB plate imaging extremely irregular failure to match, obtain the Auto Insertion location.

SOUTHERN MACHINERY Southern Machinery Sales and Service Co., Ltd.

Check

Replace the resulting Auto Insertion data with the selected row data in the current image ROI region.

Add

Add the resulting insertion data obtained in the current image ROI area to the end of the insertion data list.

Insert

Insert the resulting Auto Insertion data found in the current image ROI region into the location of the currently selected row.

<u>Shift</u>

If the current platform position does not reach the corresponding position of the focus line, then move to the corresponding position;

If the current platform position is in the corresponding position of the focus line, move to the corresponding position of the next line of the focus line.

Delete

Delete the rows rotated in the insertion data list (multiple consecutive rows).

Set up the Mark point

Add the MARK point position correction to the program.

Auto-correction

View from the focus line and correct the insertion data list for the



insertion data.

Suspend

Temporarily stop the browsing correction for the Auto Insertion data.

Offset compensation

Select a row, and then click the shift to move to the corresponding position of the focus row, and click the offset compensation to fine-tune the multiple lines of data before knowing the turntable rotation command or stopping the command after this row.

Array module

After editing an area, you can list several similar modules through this command array.

阵列模块	
第一个基准点位置 X: 0.000 Y: 0.000 写入	X轴方向数量: 1 Y轴方向数量: 1
最后一个基准点位置 X: 0.000 Y: 0.000 写入	 新对象排在原对象后面 新对象排在程序最后面
手动移动平台速度: 2 20	确定即消

Matching a location within the first module and the same location within the last module, then entering the number of modules in the X direction and modules in the Y direction, can generate several parallel module of

Auto Insertion data.

File saving

As with the export program on the menu bar, save the Auto Insertion data of the Auto Insertion data list to a disk file, and automatically add the Stop command if the list does not finally have the Stop or Continue command.

Apply

Save the match parameter to the disk file to automatically load at the next startup.

List of station position information



站位号	元件名称	元件方向	元件高度	数量	命令	
1						
2						
3						
4						

And you can select the element name here

The feeding station of the element can be replaced

3) I / O signal diagnosis

》断						
I			DO			
IN01-01]1号有无料检测	● [IN32 -02] 4号插	件检测 (● □ OUT01 -01] 夹爪1	•	🗌 OUT14 -02] 3号送料气缸	(
N02-01] 2号有无料检测	•		□ OUT02 -01] 夹爪2	•	🗌 OUT15 -02] 3站折弯气缸	(
N03-01] 3号有无料检测	•		OUT03 -01] 夹爪3	•	□ OUT16 -02] 3站辅助折弯气	1
N04-01] 4号有无料检测	•		□ OUT04 -01] 夹爪4	•	🗌 OUT17 -02] 3站切脚气缸	(
N09-01] 位置1有无板检测	•		🗌 OUT05 -01] 轨道马达	•	🗌 OUT18 -02] 4号定位气缸	(
N05-01] 位置2有无板检测	•		□ OUT06 -01] 挡板1	•	🗌 OUT19 -02] 4号送料气缸	(
N06-01] 位置3有无板检测			□ OUT07 -01] 挡板2	•	🗌 OUT20 -02] 4站折弯气缸	(
N07-01] 位置4有无板检测	 折弯气缸折弯时 间: 	0 ms	; □ OUT08 -01] 挡板3	•	🗌 OUT21 -02] 4站辅助折弯气	1
N11-01] 安全确认	● 夹料气缸夹料时	100 ms	🗌 OUT09 -01] 红灯	•	🗌 OUT22 -02] 4站切脚气缸	(
N12 -01] 停止生产		102		•	🗌 OUT23 -02] 夹板气缸	(
N13-01] 紧急停止	 夹料气缸放料时 间: 	150 ms	□ OUT11 -01] 黄灯	•	OUT24-02] 定位气缸	(
N14-01] 安全门			OUT12-01] 相机开关灯	•		
N15-01] 启动	● 定位气缸定位时 间:	200 ms	: OUT01 -02] 蜂鸣器	•		
N16-01] 下一段要求送板	● 挡板气缸动作时	80	□ OUT02 -02] 通知上一段送板	•		
N01 -02] 1号项料升到位	间:	ma	□ OUT03 -02] 1号定位气缸	•		
N02 -02] 1号顶料降到位	● 夹板气缸动作时		□ OUT04 -02] 1号送料气缸	•		
N08 -02] 2号项料升到位	● 间:	ms	□ OUT05 -02] 1站折弯气缸	•		
N09-02] 2号项料降到位	● 送料气缸送料时	100 ms	□ OUT06 -02] 1站辅助折弯气			
N17 -02] 3号顶料升到位	• 切纸气缸切纸时		□ OUT07 -02] 1站切脚气缸	•		
N18 -02] 3号项料降到位	例:例:	me	□ OUT08 -02] 2号定位气缸	•		
N24 -02] 4号项料升到位	● 轨道加载板延时	300 ms	□ OUT09 -02] 2号送料气缸	•		
N25 -02] 4号项料降到位	● 时间:	19 - 19 - 19 - 19 - 19 - 19 - 19 - 19 -		•		
N15-02] 1号插件检测	 辅助折弯气缸动 作时间: 	100 ms		0		
N16-02] 2号插件检测			OUT12-02] 2站切胸气缸	•		
IN31 -02] 3号插件检测	 顶板上升动作时 间: 	200 ms		•		

DI

1, 2, 3, 4 Material detection: detect the material delivery signal at the feeding station

Position 1, 2, 3, 4 Board signal detection: plate signal detection at 4 positions on the guide rail



马达测试										×
- 马达参数设 <u>置</u>	移动距离 回原速度 mm (低) mm/s	E 回原速度; s (高)mm/s	起步速度 mm/s	运行速度 mm/s	加减速 ms	每转脉 pulse	中每转行租 mm	呈当前位置 mm	Ξţ	〕原
X: 回原点 →+ →+	1.000 10.0	20.0	100	300	60	10000	20,00	0.000	•	•
Y: 回原点 -↓ ↑+	1.000 10.0	20.0	100	300	60	10000	20.00	0.000	•	•
D: □原点 →+ →+	1.000 15.0	20.0	100	300	60	10000	360, 00	0.000	•	•
F: 回原点 →+ →+	10.000 3.0	5.0	3	20	30	10000	10.00	0,000	•	• •
11 回原点 -↓ ↑+	0.000 2.0	3.0	20	70	100	10000	10.00	0,000	•	•
H2 回原点 -↓ ↑+	0.000 2.0	3.0	10	60	90	10000	10.00	0.000	• •	•
H3 回原点 -↓ ↑+	0.000 2.0	3.0	30	80	90	10000	10.00	0.000	•	•
H4 回原点 -↓ ↑+	0.000 2.0	3.0	20	70	100	10000	10.00	0,000	•	• •
平台停机位	抛料位置设置							F	送一颗米	的距离
X: 23.114 设置	X: 29.876	设置							F 1.0	00
Y: 56.358 测试	Y: -101.306	测试							测	山武
XY轴工作速度设置					i - i	4 - 4	Ó	1 I I	i i	20.0
XY轴取料的速度 X 500	Y 500			ſ	加士安平		<u>~</u>		_	<u>, ann</u>
XY轴插件的速度 X 200	Y 200			L	保存参数		停.			退出

4.1) Motor commissioning

Set the movement amount and movement speed of each axis, and then move the axes according to the arrow direction on the button, test whether the time movement direction of each axis matches the direction indicated on the arrow; test whether the positive and negative limit successively is valid and installed.

Test whether each axis can return to the origin and the origin position is correct.

The positive and negative limits are the abbreviation of the photoelectric switching signal in the maximum limit position of the positive and negative direction of each axis.

The "Zero Point" detection signal is set by the origin.

Platform shutdown X: the actual position of the X axis after the bench "zero"

Platform downposition Y: the actual position of Y axis after the bench "zero"

Feed throwing position: Platform position of the Auto Insertion head throwing when the Auto Insertion fails

XY shaft material pickup speed: XY is the speed when it drives the Auto Insertion head to fetch the material.

XY axis Auto Insertion speed: XY drive Auto Insertion head take Auto Insertion speed.

<u>☆料位置设定</u>		1 1		H轴选择 插件轴H1 ❤	送料站位选择 送料站1
×, y	H1	H2 H3	H4	取料位置设置 X: 69.956 Y: -138.806	设置此位置为取料位置 XY移到取料位置
□夹爪1 □定位1	□夹爪2 □切脚2	□夹爪3 □切脚3	□夹爪4 □定位4	н3. 415	I曲移到取料高度
 ○ 点动 点动位移 ○ <u> </u>	xr位移 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一	— 1.0 _{H位移} -]	0.10	放料高度设置 放料高度1 Height-1: -2. 241	置此位置为放料高度1
各轴当前位置 X 0.000 Y 0.000	H1 0.0 H2 0.0		0.000	放料高度2 Height-2: 2.505	置此位置为放料高度2

5) Material collection position setting

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Set the feeding height of each feeding shaft and the position of XY shaft, feeding height 1, and discharge height 2.

Each insertion axis and each feed station corresponds to a set of data.

The setting method is to press the movement direction icon of the corresponding axis with the mouse, and the corresponding axis moves in the corresponding direction. When the movement is in place, release the mouse, and then record the current position.

6) Feeder type setting



供料器1#		供料器2#
	⊙ 振动盘供料	○振动盘供料
	○ 立式编带供料(折弯)	◎ 立式编带供料 (折弯)
	○ 立式编带供料(不折弯)	○ 立式编带供料 (不折弯)
	○卧式编带供料	○卧式编带供料
供料器3#		供料器4#
	○振动盘供料	◎ 振动盘供料
	⊙ 立式编带供料(折弯)	○ 立式编带供料 (折弯)
	○ 立式编带供料 (不折弯)	○ 立式编带供料(不折弯)
	○ 卧式编带供料	○卧式编带供料
	确定	退出

7) Manufacturer information

After clicking on the manufacturer information, the FactoryInfo.pdf document in the application directory opens.

If this file does not exist, prompts appears.

Help

Click Help for S7000 E L P in the application directory.pdf document.

If this file does not exist, prompts appears.

Softdog

After clicking on Help, the dialog box pops up.

加密狗 若加密狗不正确, 厂家,再向厂家索	请将读取的机器码发送给 要新的加密狗	X
机器码: 读取	2.机器码 退出	
分期本期累计使用时	1间: 0 小时 0 分 小时	-
分期本期剩余使用时 	1间: 720 小时 0 分 小时 明,诸支付下一期款项并向厂家	-
素要密码解锁 本机编号:	ist-4000-021	
分期付款总期数:	10	
已经支付的期数:	1	
解锁密码:		
	解锁	

If the dongle of the current machine is not correct, please read the machine code and send it to the manufacturer for a new dongle.

If the installment payment method is adopted, the installment valid use time has arrived, the dongle lock, please send the machine number and the period number to be paid to the manufacturer, and ask for the unlock password to unlock.

8 Background management



Exit

Click to exit, then exit the program.