

Preface

- This operating instruction is included with machine. Please keep this manual for reference at any time.
- Please read this manual carefully before operating this equipment.
- Due to the technical update and the special requirements of the product, the product may be partially different from the manual description, please in kind prevail, we will add additional instructions as much as possible.
- When the equipment is in normal use, please keep a certain space in front and behind the equipment, as necessary space for operation and maintenance. In addition, please do not obstruct the setting of the heat emission space for this equipment.
- Equipment operating environment: temperature: 5 ~ 25 ℃, relative humidity: 20% ~ 95%, free from direct sunlight, no dew, no splashing water, no oil, no chemical liquid.
- The machine's technician who operates and maintains it must have computer operation skills.
- The computer configured on this machine can only be used for this machine, it is strictly forbidden to carry other movable storage device which can bring virus into the machine, so as to protect the control system.
- The U disk is properly configured to prevent the invasion of virus, and it is strictly prohibited to be used on other computers.
- For personal safety, when the equipment is running or standby, please do not open the front door or chains or the station head cover without taking safety measures, clothing and limbs must not get near the mechanical parts, otherwise, may incur body injury accidents.
- Repeated switching power supply on and off can be one of the reasons for equipment failure. After the power is turned off, please wait for at least 20 seconds before you turn on the power again.
- Do not expose the device to shock or strong vibration, otherwise it may cause malfunction.
- When cutting off the power, proceed the system exit / shutdown process in the following order. If you cut off the power supply or restarted it without following this process, the data can not be saved completely and the hard disk can be



damaged. Exit / Shutdown Procedure: Exit the application \rightarrow exit Windows \rightarrow disconnect the device from power.

- If the equipment is suspended, store the equipment in the proper environment: ambient temperature (0-40) °C, relative humidity (20 ~ 95)%, free from direct sunlight, no dew condensation, no splashing water, no oil and chemical liquid. Protective measures(such as covering cloth) can be taken to prevent dust and moisture.
- Please contact us in case of any questions, please do not operate blindly.

Note: Please note above mentioned matters!

Machine overview:

S-7040 Odd form insertion machine for high-speed, high-precision, high-performance equipment, is specifically developed for odd form components insertion such as large electric capacity and resistor, which integrates three bowel feeders to achieve three Material Selective insertion. Its insertion head grips the odd form components by moving the X, Y units with high insertion precision in the PCB board area, insertion angle is controlled by the steering wheel. The series of control software and operating software is developed by our company independently, all operations are controlled by a computer.

This Odd Form Radial insertion machine has following major advantages:

 \triangle Full computer control, English version operating system, based on the Windows platform, easy to operate, fast, simple, easy to learn.

 \triangle Machine vision technology applied, online automatic programming, automatic correction, automatic identification of the MARK point, highly automotive.

riangle AC servo system provide stable line operation, excluding the instability caused

by line failure, to achieve a stable high-speed, energy saving.



Software Operation

1 Safety check before operation.

Please be aware: the machine for the new installation or long-term idle state, before supply the machine with power and compressed air and operation, we must do following security checks carefully:

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

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

3) Whether the equipment is properly grounded.

4) Ensure no unrelated objects remain in the electronic control box and the machine movable parts.

5) Check if conveyor belt and synchronous belt fall off during transportation.

6) Check if the lead screw, slide track, insertion shaft and other heavy-duty, high-speed operational units are properly connected.

7) Push and pull X, Y, R1, R2, F units to see if they can move smoothly.

8) Check the limit detector and limitation are dislocated or not.

9) Check whether the emergency switch is pressed down, check the overall gas source, the power switch is at the OFF state.

10) Check wiring plug and air pipes between the computer, electric control box, the main and auxiliary parts are properly connected.



<image>

First of all, check the specifications of the power supply and air pressure of the device. For details, please refer to the basic parameters in this manual, and connect the power supply and air pressure as required.

Then turn the red knob switch to ON, the whole device starts to be powered on, and the boot is over; when shutting down, please wait for the software to close.After that, turn off the computer, then turn the red knob switch to OFF, and the shutdown is over.

[START]: The machine continues to run automatically (the first startup needs to be performed in the software [homepage]);

[STOP]: The machine suspends the current action;

[FEEDER]:All feeder stop and start button:

[EMERGENCY]: All axes emergency stop and enable;

3.Software Operating Instructions



Software login: Double-click the desktop icon to open the software and

enter the main page of the software



Introduction to the main interface area

The main interface is divided into five areas: "manual operation area", "function menu area", "shortcut operation area", "status display area", "camera display area";

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"Manual operation area": mainly to set machine and process parameters, which are composed of five modules: [Homepage], [Data Programming], [System Settings], [Hardware] and [Hardware 2]; each module is configured according to the login authority. There is a corresponding operating area;

"Function menu area": other functions;

"Quick operation area": common functions;

"Status display area": machine status;

"Camera display area": image observation.



[Manual operation area] interface introduction

[homepage]

Reminder: !!! When manually debugging, please use speed 1. Generally,

execute [lifting head], [stop position] or [dropping material] before

executing single-axis movement!!!

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1. [Machine reset]: After clicking, the button will turn red, indicating that it is being reset; when it turns green, it indicates that the reset is successful;

2. [Start]: The machine runs production automatically;

3. [Suspend]: The machine suspends production, click [Start] to continue running;

- 4. [Stop]: The machine stops production and throws out materials;
- 5. [Clear Data]: Data reset.

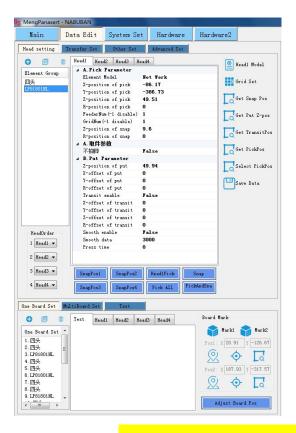


[Data programming]

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping material] before executing single-axis movement!!!

Requires administrator privileges to enter

[Front three heads]



Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping material] before executing single-axis movement!!!



[New combination]:

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[Left/middle/right head retrieving]: Single head performs retrieving action;

[Robot pick-up]: When the component template is [No inserted], the corresponding head at the front/rear part performs the pick-up action at the same time;

[Flying shot test]: execute the flying test action;

[Move to the camera position]: Execute the action of moving to the camera position;

[Pickup Flying Shot]: Coherently execute the actions of [Pickup by Robot Hand] + [Flying Shot Test].



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[Up camera algorithm]: MarkI/MarkR and all types of components to be

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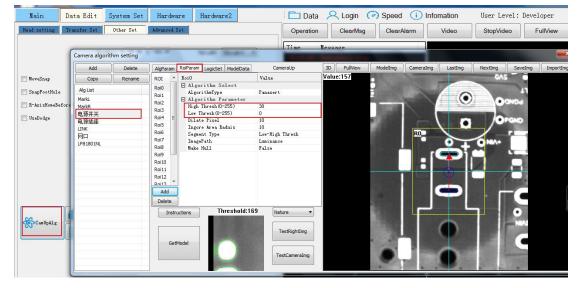
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Shenzhen Southern Machinery Sales And Service Co., Ltd.  $^{\ \ 14}$ 

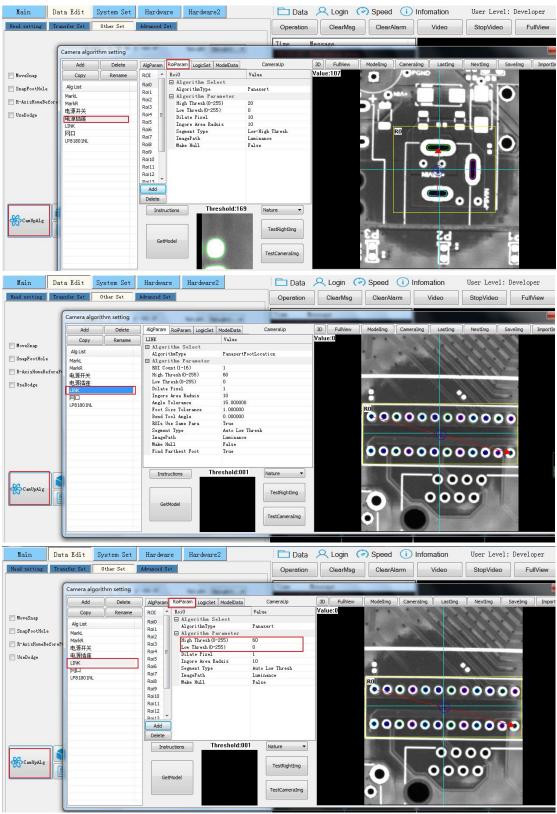


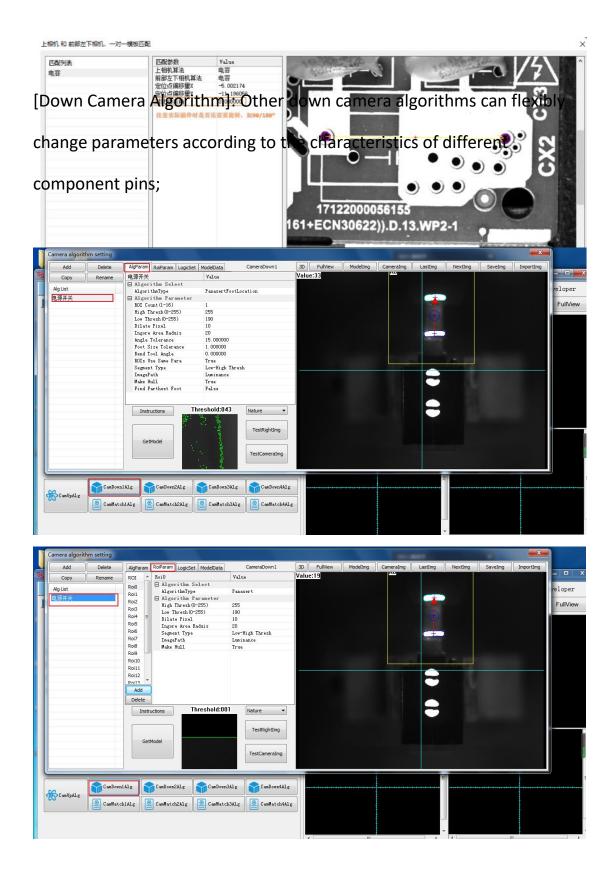
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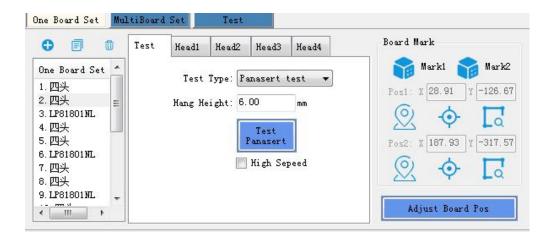


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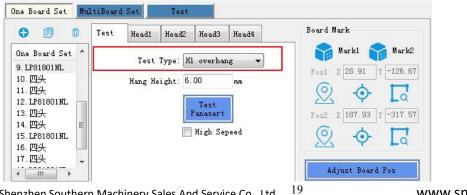
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3 Head3 🔻	Add panasert group	
4 Head4 🔻	Group	ia
One Board Set Mu		
one bourd bet		
0 🗊 0	1	ard Mark
		Sarki Sark2
One Board Set 🔺	Test Type: Panasert test 💌	
1. 四头		os1: X 28.91 Y -126.67
2. 四头 目	Hang Height: 6.00 mm	
3.LP81801NL 4.四头		V Q La
4.四头 5.四头	Test Panasert P	os2: X 187.93 Y -317.57
5. 四天 6. LP81801NL		052. A 101.93 I -311.51
7. 四头	🕅 High Sepeed	(o) the 🗖
8.四头		
9. LP81801NL 🖕		
<		Adjust Board Pos
		najast soare ros

[insertion sequence]: The order of the insertion must be set before the insert test, such as the avoidance position is on the right side of the light source, the front insert sequence is left to middle to right, and the rear is

right to middle to left;

[Left head hanging in the air]:



Shenzhen Southern Machinery Sales And Service Co., Ltd.





# [Test insertion]:

🕒 🗊 🗊 Test Head1 Head2 Head3 Head4	Board Mark
One Board Set 9. LP81801NL 10. 四头 11. 四头 12. LP81801NL 13. 四头 14. 四头 15. LP81801NL 16. 四头 17. 四头	Mark1 Mark2 Pos1: X 28.91 Y -126.67 Pos2: X 187.93 Y -317.57 Adjust Board Pos



[Automatic positioning]: Determine the axis coordinates when the upper camera captures the component and move it to the center of the camera's field of view;

ne Board Set Mu	ltiBoard Set 🛛 🗍	est	
0 🗊 0	Test Head1 He	ad2 Head3 Head4	Board Mark
One Board Set ^ 9 LP81801町. 10. 四头 11. 四头	Snap Pos Camera Pos Model Pos Not Work X-offset of put	X=0.00 Y=-95.58 X=0.00 Y=0.00 X=0.00 Y=0.00 False	Markl Mark2 Pos1: X 28.91 Y -126.67
12. LP81801NL 13. 四头 14. 四头 15. LP81801NL 16. 四头	Y-offset of put		Pos2: X 187.93 Y -317.57
17. 四头		Ŷ	Adjust Board Pos

[Multi-imposition setting]:

One Board Se	t MultiBos	urd Set	Test		
Board Num	Mark1_X	Mark1_Y	Mark2_X	Mark2_Y	Х 0.00 У 0.00
	eed to reco	ord the Mar	oing boards, k point coor		Get Markl X 0.00 Y 0.00 Get Mark2
L					
			the mar	14 C	Delete All



[Rear three heads]

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping components] before

executing single-axis movement!!!

Same as above [front three heads]

## [other settings]

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping components] before executing single-axis movement!!!



Main	Data Edit Sys	stem Set Hau	dware	Hardware2	
Head setting	Transfer Set Ot	her Set Advan	zed Set		
│ MoveSnap │ SnapFootHold │ R-AxisHomeBe │ UseDodge	DodgePos: FickDela FeederDela	y: 0 ms y: 0 ms e: 2.00 mm 2: 40 ms me 70 ms t: 0.00 mm	+ + +		v v v v v v v v v v v v v v v v v v v
CamUpAlg	CamDown1Alg	CamDown2Alg		nDown3Alg	CamDown4Alg CamMatch4Alg
Main	Data Edit Sys	tem Set Har	dware	Hardware2	
Head setting	Transfer Set 0t	her Set Advan	ed Set		
	Ignor LockAv Trans Transf Trans	erDirect: LeftToRi eSection: IgnoreSe iodPos: X 350.99 1 ferDelay: 200 m erDelay2: 300 m ferWidth: 198.00 m sferHome MoveTu	etion1 0.00 s s		



 [Head Clamping Delay]: Delay time after reaching the pick-up position (to prevent not clamping in place);

2. [Head release delay]: the delay time when the insertion is completed (to prevent the head from lifting and flying materials);

3. [Maximum component height]: Based on the height of the flying camera, the avoidance height of the component during the movement of the insertion;



## [advanced settings]

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping components] before executing single-axis movement!!!

Main	Da	ata Ed	li	t	Syst	em Set	Hardw	are	H	lardwa	re	2		
Head setting	Tr	ansfer	Se	t	Othe	er Set	Advanced	Set	]					
	Dr	opPosl	x	-14.4	.5 Υ	-302.38	Head1 Dro	pPos:	DropH	osi	_	•		
	Dr	opPos2	x	326.1	9 Y	-302.38	Head2 Dro	pPos:	DropH	os1	_	•		
		opPos3				230.00	Head3 Dro	-			_	-		
		opPos4				230.00	Head4 Dro					•		
PickPosO X 0.0	)	Y 0.00		Z 0.0	0 C	0.00	PickPos5	X 0.	00 Y	0.00	Z	0.00	С	0.00
PickPos1 X 60.	38	¥ 23.04	۱	Z 31.	07 C	0.00	PickPos6	X 0.	00 Y	0.00	Z	0.00	С	0.00
PickPos2 X 49.	93	Y -432.	71	Z 41.	49 C	0.00	PickPos7	X 0.	00 Y	0.00	Z	0.00	С	0.00
PickPos3 X 60.	38	¥ 23.04	ŧ	z 30.	37 C	0.00	PickPos8	X 60	. 81 Y	21.94	z	30.53	с	0.00
PickPos4 X 60.	38	¥ 23.04	1	z 30.	69 C	0.00	PickPos9	х 38	. 24 Y	-0.65	Z	33.5	С	3. 71
Pick Position				@ F		5 @ 7	0809	1023	ad Sel		6	4	Gett	ickPo
○ 0 ○ 1 ○	Z (	) 3 (C	/ 4	0 5	0	$\circ \circ \circ$	0 9 0 9	۲	10	2 🔘 3	6	24	Jeci	ICHI



## [system settings]

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping components] before executing single-axis movement!!!

Vendor permission is required to enter:

Data Edit	System Se	t Hardware	Hardware	2
<u>s</u>				
.eft to Right 🔻	] Tfer section	3 Section Std 👻	Lock type	Normal Lock
lut to In 🔻	R-axis count	4 🗸	Bend Mac	None
top snap 👻	Tfer Type	[IO control 🗸	Foot Light	On top
cam stop snap 🔻	. ₩-axis	Exist 💌	Put test	Sensor test
In 1 Out 🔻	] Language	English 👻	)	
tion				
t C	am up calib 4p	Cam mo	dule	
et C	am dn1 calib 4p	Cam dni ca	lib cen	Cam up dn1 calib
et C	am dn2 calib 4p	Cam dn2 ca	lib cen	Cam up dn2 calib
et C	am dn3 calib 4p	, 🖉 Cam dn3 ca	lib cen	Cam up dn3 calib
et C	am dn4 calib 4p	Cam dn4 ca	lib cen	Cam up dn4 calib
sition				
s 20.00 mm	FlyDistanc	e 80.00 mm	FlyOffset -	0.34 mm
ed 800.00 m/s	FlyAc	c 0.10 s	FlySmoothTime O	s
SnapPos: X1 15	2.87 152.87	X3 152.87 X4 152.	87 Y -310.31	
SnapZC1: Z 23	.85 C 90.00	SnapZC2: Z 25.1	0 C 90.00	
SnapZC3: Z 23	.85 C 90.00	SnapZC4: Z 25.1	0 c 90.00	
	at cam stop snap t cam stop snap t cam stop snap t in 1 Out t ion t et et et et et et c sition ss 20.00 mm ad 800.00 m/s SnapPos: X1 152	Left to Right  Tfer section Tfer section R-axis count Stop snap Tfer Type t cam stop snap W-axis In 1 Out W-axis In 1 Out Cam up calib 4p et Cam dn1 calib 4p et Cam dn2 calib 4p et Cam dn3 calib 4p et Cam dn4 calib 4p sition ss 20.00 mm FlyDistanc ad 800.00 m/s FlyAc SnapPos: X1 152.87 X2 152.87	Left to Right  Tfer section 3 Section Std  Left to Right Tfer section 3 Section Std  Lut to In R-axis count 4  Cam stop snap Tfer Type IO control  Ter Type IO control  The state stop snap Tfer Type IO control  The stop snap The stop snap Tfer Type IO control  The stop snap The stop sna	Left to Right  Tfer section 3 Section Std Lock type Dut to In R-axis count 4 Bend Mac Stop snap Tfer Type IO control Foot Light Language English The text Language English tion t t Cam dn1 calib 4p Cam dn1 calib 4p Cam dn2 calib 4p Cam dn2 calib 4p Cam dn3 calib 4p Cam dn3 calib 4p Cam dn3 calib 4p Cam dn4 calib 4p Stion stion stion StapPos: X1 152.87 X2 152.87 X3 152.87 X4 152.87 Y -310.31



# [camera module]:

Main Data Hardware config	a Edit    System Set	Hardware	Hardware2	: L		Login ( ) Speed (
X-Direct Left to Y-Direct Out to I CamUp Snap Stop sna CamDown Snap 4 cam st OutMsgIO 1 In 1 0	n V R-axis count p V Tfer Type op snap V W-axis	i v O control v ixist v	Lock type Normal Loc Bend Mac None Foot Light On top Put test Sensor tes	k → Ti → 14		ClearMsg ClearAlar sage reency stop 触发
Camera calibration	Cam up calib 4p	Cam mo	dule nera Module Set			
Can dn2 set Can dn2 set Can dn4 set Calibration position LightThickness 20.00 FlySpeed 900.0	Can dn2 calib 4p	Can d Can d Can d Can d Ref D Can d Ke Ke Ke	Module Library seler Camera .dll vsCamera .dll ahengCamera .dll ahengCamera .dll aleaCamera .dll aleaCamera .dll aleaCamera .dll syenceLjxaCamera .dll nGocatorCamera .dll	MvsC	Selection Modi	Lle Config Delete ReconnectAllCam
SnapP SnapZ SnapZ SnapPos1 0°	os: X1 152.67 X2 152.67 C1: Z 23.65 C 90.00 C3: Z 23.65 C 90.00 SnepPos2 0*	(3 152.87 X4 SnapZC2: Z SnapZC4: Z 25.1 os3 0° Sna	U C 90.00 pPost 0° Fly Snap t	est		Cancel

# Calibration preparation:





[Calibration of 4 points on the upper camera]: Establish the relationship between the coordinate system of each camera and the coordinate system of the real world, and determine the resolution of the camera;

Param RoiParam LogicSet	ModelData	Came	raUp	3D	FullView	ModelImg	CameraImg	LastImg	NextIm	g SaveImg	ImportIm
	Value			Value:	129	R. Letter	Constantine too	and the second second	-	1	
Algorithm Select									And in case of	· press	
Algori thmType	Calibrat	tı on					:				
Instructions Th	reshold:01	01 Natu	re 🔻				RO				
GetModel	reshold:01	Те	re •	]			RO			1.10	
	reshold:01	Те	stRightImg tCameraImg		Axis Pos				Camera		
GetModel	reshold:01	Te	stRightImg		Axis Pos Y1: -88.1	46		1: 86.63226	Camera Y1:		Get
GetModel	mm/pix	Tes	stRightImg tCameraImg	]			Get X	1: 86.63226 2: 977.14398	Y1:		Get
GetModel Camera And Axis Calibration Resolution XY: 0.02145		XY-Axis     XX-Axis     X-Axis	stRightImg CameraImg X1: 42.7	738 77	Y1: -88.1	46	Get X Get X		Y1: Y2:	1078.74402	

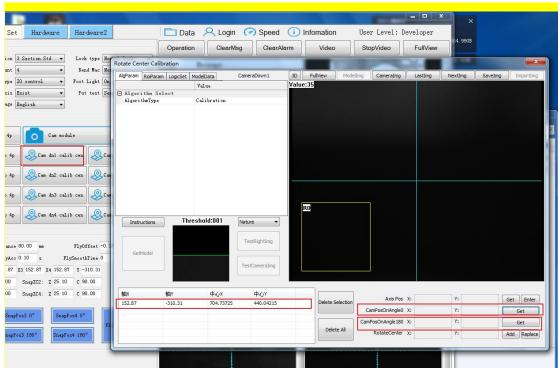


gParan	RoiParam LogicSe	t ModelDat	a (	CameraUp		30	FullView	ModelImg	CameraImg	Las	timg N	lextImg	SaveImg	Impo
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	Segment Type			gh Thresh			100	COLUMN 1			<b>C</b> 3 4	Seat 1		
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				TestCamera	aimg		1.00	0.000	THE DUCK		10000	88L)	CONTRACT.	
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	a And Axis Calibration					-								
Came	a And Axis Calibration Resolution		XY-Axi			A	xis Pos				C	amera I	Pos	
				s X1:	42.738		Y1: -88.146		Get X	1: 86.6	3226	Y1:	1078.74402	Get
	0.02145	mm/pix	O X-Axis							-				
XY:		1	O Y-Axis	X2:	23.67		Y2: -88.146		Get X	2: 977	14398	Y2:	1073.18469	Get
	0.0000000	mm/pix						10						
x:				y2.	23.67		Y3: -69, 192		Get V	3. 973	91058	Y3:	192,79582	Get
x:	0.0000000	mm/pix mm/pix	Enter	X3:	23.67 43.29		Y3: -69.192			<ul><li>3: 973</li><li>4: 57.2</li></ul>	91058	Y3:	192.79582 194.99983	Get

[4-point calibration of the lower left camera]:

[Bottom left camera rotation center]: Angle correction, determine the center coordinates of the rotation





				S-704	0 Od	d Form	Insertior	n Mach	nine Use	r Manual
Set Hardware Hardware2	Rotate Center Cali AlgParam RoiParan ROI Roi0 Roi0 Alg	ⁿ LogicSet Model orithm Select orithmType	ClearMsg Data Car Value FindPoin	ClearAlan meraDown1	rm	video	User Level: Do StopVideo	- C × eveloper FullView	NextImg Save	eing ] [ Importing ]
4p Cam module 5 4p Cam dnl calib cen Cam 5 4p Cam dn2 calib cen Cam 5 4p Cam dn2 calib cen Cam 5 4p Cam dn3 calib cen Cam 5 4p Cam dn3 calib cen Cam	Add high area	with Perset i h Thresh (0-255) Thresh (0-255) bh Fix (0 will ign Modal Ares (Fix) al Ares (Fix) al Ares (Fix) al Ares (Fix) al Ares (Fix) al Ares (Fix) bhology Type ore 0n ROI e Mull nect Ares a zize Segment at Position	255 128	0 Thresh	RO					
ance 60.00 mm FlyOffset -0.3 yAcc 0.10 s FlySmoothTime 0 .87 X3 152.87 X4 152.87 Y -310.31 00 SnapZC2: Z 25.10 C 90.00	GetModel	Thresho		ture    TestRightImg  estCameraImg						
00 SnapZC4: Z 25.10 C 90.00	轴X 152.87	轴Y -310.31	中心X 704.73725	中心Y 440.04215		Delete Selection	Axis Pos CamPosOnAngle0		Y:	Get Enter
SnapPox3 0° SnapPox4 0° F1 napPox3 180° SnapPox4 180°						Delete All	CamPosOnAngle 180 RotateCenter	x:	Y:Y:	Get Add Replace

[Left upper and lower camera alignment]: Determine the coordinate system of the upper and lower cameras;

Up and down camera angle: The angle between camera rotation in the horizontal direction (the rear camera is installed opposite to the front, and the rear camera needs to be setset at 180°);



[Move the front part to the 0 degree standard position]: the heads 1, 2 and 3 on the front part move to the [front camera position], and the Z axis moves to the [mark position]

(1~6)Z], the R axis rotates to the [marking position (1~6)C];

[Move the front part to the 180-degree standard position]: the No. 1, 2 and 3 heads of the front part move to the [front camera position], and the Z axis moves to the [mark position]

(1~6)Z], the R axis rotates 180° from the [marker position (1~6)C];

[Front calibration positioning flying]: execute flying shooting action;

[Light Source Thickness]: Based on the bottom of the light source, the actual height of the light source;

[Top plate position]: the absolute position of the top plate axis;

[Flying speed]: Y-axis speed (according to speed 4 parameter configuration);

[Flying acceleration time]: Y-axis acceleration time (according to speed 4 parameter configuration);

[Flying smoothing time]: Y-axis smoothing time (configured according to speed 4 parameters);

[Flying tail distance]: Y-direction travel from the camera position to the end of flying shooting;

[Flying Compensation]: Time compensation magnification of flying shooting, so that the image positions of stop shooting and flying



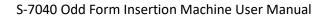
shooting are consistent; F: indicates the front flying shooting; B: indicates rear flying shot

## [hardware]

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping material] before executing single-axis movement!!!

Vendor permissions are required to enter:

Main	1	Da	nta B	Cdit	Sys	stem	Set	Hardw	ware	Hardwar	re2
Red I	Light		1	JpLi ght	1		StartBu	tton	Tfer	Sensor1	SafeDoor
Yellow	Light		۱	JpLi ght	2		PauseBu	tton	Tfer	Sensor2	PutTest1
Green	Light		1	JpLi ght	3	1	ResetBu	tton	Tfer	Sensor3	PutTest2
Buz	zer		F	oot Lig	;ht		EmgBut	ton	Tfer	Sensor4	PutTest3
LastMac	Signal		Nex	tMacSi;	gnal		LastMacI	Ready	Next	MacReady	PutTest4
				Card	set		IO con	trol	Run	test	
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP		MoveTo	
X-Axis	PrfPo	s 6	2. 93	EncPos		mm	Stop	JogN	ĺ	MoveDis	HeadL1 2 2
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP	j	MoveTo	1 <b>1</b>
Y-Axis	PrfPo	s -14	0.55	EncPos		mm	Stop	JogN	í	MoveDis	HeadR1 2 2
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP	í –	MoveTo	1 1
Z1-Axis	PrfPo	s	0.00	EncPos		mm	Stop	JogN	í —	MoveDis	HeadL2 2 2
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP	1	MoveTo	11
Z2-Axis	PrfPo	s	0.00	EncPos		mm	Stop	JogN	í —	MoveDis	HeadR2 2 2
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP	j	MoveTo	
Z3-Axis	PrfPo			EncPos		mm	Stop	JogN	í –	MoveDis	CylinderL 2 2
	Sv0n	_	_	LmtP	LmtN	Alm	Home	JogP	<u> </u>	MoveTo	
Z4-Axis	PrfPo			EncPos		mm	Stop	JogN	í —	MoveDis	CylinderR 2 2
	Sv0n		· · ·	LmtP	LmtN	Alm	Home	JogP	j	MoveTo	
R1-Axis	PrfPo			EncPos		R°	Stop	JogN	í –	MoveDis	CylinderHold 2 2
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP	j	MoveTo	
R2-Axis	PrfPo			EncPos		R°	Stop	JogN	í	MoveDis	CylinderLock 2 2
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP	í —	MoveTo	
R3-Axis	PrfPo			EncPos		R°	Stop	JogN	í	MoveDis	
	Sv0n	_	_		LmtN	Alm	Home	JogP	í —	MoveTo	
R4-Axis	PrfPo			EncPos		R°	Stop	JogN	í	MoveDis	
	Sv0n	Move	Home	LmtP	LmtN	Alm	Home	JogP	1	MoveTo	
W−axis	PrfPo			EncPos		mm	Stop	JogN	í	MoveDis	
		_	_	LmtP	LmtN	Alm	Home	JogP	1	MoveTo	
TransferM	PrfPo			EncPos		mm	Stop	JogN	í	MoveDis	TransferM 2 2
	Sv0n	Move	_	LmtP	LmtN	Alm	Home	JogP	1	MoveTo	
TransferL	PrfPo			EncPos		mm	Stop	JogN	i	MoveDis	TransferL 2 2
	Sv0n	_	· · ·	LmtP	LmtN	Alm	Home	JogP	Ì	MoveTo	
TransferR	PrfPo	_		EncPos		mm	Stop	JogN	i	MoveDis	TransferR 2 2
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## Sports card configuratio

Main	n Da	ata Edit Sy	stem Set	Hardware	Hardware	2	Data 📯 Login 🕝 Speed 🥡	) Infor
Red I	Light	UpLight1	StartB	utton Tfe	rSensor1	SafeDoor	Operation ClearMsg ClearAlarm	
Yellow	Light	UpLight2	PauseB	utton Tfe	rSensor2	PutTest1		
Green	Light	UpLight3	ResetB	utton Tfe	rSensor3	PutTest2	Time Message	
Buz	zer	Foot Light	EmgBu		rSensor4	PutTest3	15:39:04 有报警未清除	
LastMac	cSignal	NextMacSignal	LastMan		MocRoody	PutTaet4	15:39:24 急停触及	×
		Card set		ird setting				1
	SvOn Move	Home LmtP LmtN	Alm }				DA Output Encoder PosCompare Handwheel IoMap	
X-Axis	PrfPos 6	32.93 EncPos	mm S	OCard - First I 1Card - Second	LeadShine DMC1	.000 card		
	SvOn Move	Home LmtP LmtN	Alm J	2Card - Third I	.eadShine DMC10	000 card		
Y-Axis	PrfPos -14	40.55 EncPos	mm S					
	SvOn Move	Home LmtP LmtN	Alm }					
Z1-Axis	PrfPos	0.00 EncPos	mm S					
-	SvOn Move	Home LmtP LmtN	Alm }					
Z2-Axis	PrfPos	0.00 EncPos	mm S					
<b>70</b> 1 1	SvOn Move	Home LmtP LmtN	Alm }					
Z3-Axis	PrfPos	0.00 EncPos	mm S					
74.1.1	SvOn Move	Home LmtP LmtN	Alm 3					
Z4-Axis	PrfPos	0.00 EncPos	mm 2					
	SvOn Move	Home LmtP LmtN	Alm }					
R1-Axis	PrfPos	0.00 EncPos	R° 2					
70 1 1	SvOn Move	Home LmtP LmtN	Alm }					
R2-Axis	PrfPos	0.00 EncPos	R° S					
R3-Axis	SvOn Move	Home LmtP LmtN	Alm }					
NO-WXI 2	PrfPos	0.00 EncPos	R° 2					
R4-Axis	SvOn Move	Home LmtP LmtN	Alm }					
N4-AX15	PrfPos	0.00 EncPos	R° 2		and and a	Internal and a second sec	]	
W-axis	SvOn Move	Home LmtP LmtN	Alm }		D.1C. 1	Provensi		
n axiS	PrfPos	0.00 EncPos	mm	AddCard	DelCard	Reconnect		
ransferM	Sv0n Move	Home LmtP LmtN	Alm )					
ransierM	PrfPos	EncPos	mm	10		9 <b>—</b> 16— 91	±	
ransferL	Sv0n Move	Home LmtP LmtN	Alm Home	JogP	MoveTo	Ture of un 1 1		
ransterL	PrfPos	EncPos	mm Stop	JogN ]	MoveDis	TransferL 2 2		
ransferR	Sv0n Move	Home LmtP LmtN	Alm Home	JogP	MoveTo	T		
r austeilt	PrfPos	EncFos	mm Stop	JogN	MoveDis	TransferR 2 2		



Pulse equivalent: the number of input pulses required for the mechanism to move 1mm; pulse equivalent = the number of pulses for one revolution of the motor ÷ the lead of the screw

For example, the subdivision of the driver is set to 6400 (6400 pulses are required for one revolution of the motor), and the lead screw with a pitch of 5 travels per revolution.

5mm, pulse equivalent: 6400÷5=1280 pulses;

Rotate the R axis by 1°: 6400÷360=17.78 pulses, and rotate 10, 100, and 1000 circles respectively to correct the pulse equivalent.

# [IO control]:

Main	D	ata Edit	System	Set	Hardwar	e Hardware	2	Data	a 🕂 Login
Red Light UpLight1			StartButton		TferSensor1	SafeDoor	Operation	n ClearMsg	
Yellow Light UpLight2			PauseBu	tton	TferSensor2	PutTestl			
Green	Light	UpLi ght3		ResetBu	tton	TferSensor3	PutTest2	Time	Message
Buz	zer	Foot Ligh	it	EmgBut	ton	TferSensor4	PutTest3	15:39:04	有报警未清除
LastMad	Signal	NextMacSig	nal	LastMacF	leady	NextMacReady	PutTest4	15:39:24	息得触友
		Card s	et	IO con	trol	Run test		15.40.09	
X-Axis	SvOn Mov	e Home LmtP 1	LmtN Alm	Home	JogP	MoveTo	HeadL1	1	
A-AX1 S	PrfPos	62.93 EncPos	mm	Stop	JogN	MoveDis	ReadLi 2	2	
Y-Axis	SvOn Nov	e Home LmtP I	LmtN Alm	Home	JogP	MoveTo	HeadR1	1	
I AAIS	PrfPos -1	40.55 EncPos	mm	Stop	JogN	Moy IO contro	0.0		
Z1-Axis	SvOn Mov	e Home LmtP 1	LmtN Alm	Home	JogP	Mo	01	10 C	
	PrfPos	0.00 EncPos	mm	Stop	JogN	Mo O Inp	ut 🔘 Output	CardNo 0 💌	NoteID 0
Z2-Axis	SvOn Mov	e Home LmtP ]	LmtN Alm	Home	JogP	Mo			
	PrfPos	0.00 EncPos	mm	Stop	JogN	Mo			5 6 7
Z3-Axis		e Home LmtP 1	LmtN Alm	Home	JogP	Mo 8	9 10	11 12	13 14 15
	PrfPos	0.00 EncPos	mm	Stop	JogN	Mo 16	17 18	19 20	21 22 23
Z4-Axis		e Home LmtP 1		Home	JogP	Mo 24	25 26	27 28	29 30 31
	PrfPos	0.00 EncPos	mm	Stop	JogN				
R1-Axis		e Home LmtP 1		Home	JogP	Mo 32	33 34	35 36	37 38 39
	PrfPos	0.00 EncPos	R°	Stop	JogN	<b>Mo</b> 40	41 42	43 44	45 46 47
R2-Axis	SvUn Mov	e Home LmtP 1 0.00 EncPos	LmtN Alm R°	Home	JogP	Mo 48	49 50	51 52	53 54 55
		e Home LmtP 1		Stop Home	JogN	Mo 56	<b>5</b> 7 <b>5</b> 8	59 60	61 62 63
R3-Axis	PrfPos	0.00 EncPos	LmtN Alm R°	Stop	Jogr	Mot			
	1	e Home LmtP 1		Home	JogP	MoveTo			1
R4-Axis	PrfPos	0.00 EncPos	R°	Stop	Jogr	MoveDis			
		e Home LmtP ]		Home	JogP	MoveTo		0 0	
W-axis	PrfPos	0.00 EncPos	mm	Stop	JogN	MoveDis			
	SvOn Moy	e Home LmtP 1	LmtN Alm	Home	JogP	MoveTo	1	1	
ansferM	PrfPos	EncPos	mm	Stop	JogN	MoveDis	Transfer# 2	2	



## [Machine run-in]:

	And a state of the			1				Data 🔍 Login 🥝 Spee	
Red I		UpLight1		tartBut		TferSensor1	SafeDoor	Operation ClearMsg Clea	Alarm
Yellow		UpLight2		'auseBut		TferSensor2	PutTestl	Time Nessage	
Green		UpLight3		lesetBut		TferSensor3	PutTest2	11me message 15:39:04 有报警未清除	
Buz		Foot Light		EmgButt		TferSensor4	PutTest3	15-39-24 刍停钟发	
LastMad	251 gnal	NextMacSignal		astMacRe	ady	NextMacReady	PutTest4	15:40:09 Emergency stop	
		Card set		IO cont	rol	Run test			
X-Axis		Home LmtP LmtN 2.93 EncPos	Alm	Home Stop	JogP JogN	MoveTo MoveDis	HeadL1 1 2 2		
Y-Axis	SvOn Move PrfPos -14	Machine run t	est	-1/	(T. D.)				
Z1-Axis	<mark>SvOn</mark> Move PrfPos	<b>H</b> Count S	500	Dela	y: 50 ms	5 Head: Head1	▼ 5° ▼ Alg		
Z2-Axis	<mark>SvOn</mark> Move PrfPos	H O. C MoveBAn	lF	X-M	oveLAndR	Z-MoveVAndD	RotateAccuracyT est		
Z3-Axis	SvOn Move PrfPos	H							
Z4-Axis	<mark>SvOn</mark> Move PrfPos	H HeadsMov	ve	¥-M	oveBAndF	R-MovePAndN	ContrlPanel		
	SvOn Move	H							
R1-Axis			▼] S	et					
R1-Axis R2-Axis	PrfPos SvOn Move	0.0 Speed3	▼ S	et Stop	JozN	MoveDis	2 2		
R2-Axis	PrfPos SvOn Move PrfPos	0.0 Speed3			JogN JogP	MoveDis MoveTo	2 2		
	PrfPos SvOn Move PrfPos SvOn Move	0.0 Speed3 H 0.00 EncPos	R° (	Stop	Jogn Jogp Jogn				
R2-Axis R3-Axis	PrfPos SvOn Move PrfPos SvOn Move PrfPos	0.0 Speed3 H 0.00 EncPos Home LmtP LmtN	R° Alm	Stop Home	JogP	MoveTo	2 2		
R2-Axis	PrfPos SvOn Move PrfPos SvOn Move PrfPos SvOn Move	0.0 Speed3 H 0.00 EncPos Home LntP LntN 0.00 EncPos	R° Alm R°	Stop Home Stop	JogP JogN	MoveTo MoveDis	2 2		
R2-Axis R3-Axis R4-Axis	PrfPos SvOn Move PrfPos PrfPos SvOn Move PrfPos	0.0 Speed3 H 0.00 EncPos Home LmtP LmtN 0.00 EncPos Home LmtP LmtN	R° Alm R° Alm	Stop Home Stop Home	JogP JogN JogP	MoveTo MoveDis MoveTo	22)	00	
R2-Axis R3-Axis	PrfPos SvOn Move PrfPos PrfPos SvOn Move PrfPos SvOn Move SvOn Move	0.0 Speed3 H H Home LmtP LmtN 0.00 EncPos Home LmtP LmtN 0.00 EncPos	R° Alm R° Alm R°	Stop Home Stop Home Stop	JogP JogN JogP JogN	MoveTo MoveDis MoveTo MoveDis	<u> </u>	0 0	
R2-Axis R3-Axis R4-Axis W-axis	PrfPos SvOn Move PrfPos SvOn Move PrfPos SvOn Move PrfPos PrfPos	0.1     Speed3       H     H       Home     LmtP       Kome     LmtP       LmtP     LmtN       0.00     EncPos       Home     LmtP       LmtP     LmtN       0.00     EncPos       Home     LmtP       LmtP     LmtN	R° Alm R° Alm R° Alm	Stop Home Stop Home Stop	JogP JogN JogP JogN JogP	MoveTo MoveDis MoveDis MoveDis MoveTo			
R2-Axis R3-Axis R4-Axis W-axis	PrfPos SvOn Move PrfPos SvOn Move PrfPos SvOn Move PrfPos PrfPos	0. 0 Speed3 H 0. 00 EncPos Home LmtP LmtN 0. 00 EncPos Home LmtP LmtN 0. 00 EncPos Home LmtP LmtN 0. 00 EncPos	R° Alm R° Alm R° Alm mm	Stop Home Stop Home Stop Home Stop	JogP JogN JogP JogN JogP JogN	MoveTo MoveDis MoveTo MoveTo MoveTo MoveTo		0.0	
R2-Axis R3-Axis R4-Axis W-axis cansferM	PrfPos Sv0n Nove PrfPos Sv0n Nove PrfPos Sv0n Nove PrfPos Sv0n Nove PrfPos	0.0 Encros More Latr Latr 0.00 Encros Mone Latr Latr 0.00 Encros Mone Latr Latr 0.00 Encros Mone Latr Latr 0.00 Encros	R° Alm R° Alm R° Alm Mm Alm	Stop Home Stop Home Stop Home Stop	JogP JogN JogP JogP JogP JogN JogP	HoveTo MoveDis MoveDis MoveDis MoveDis MoveDis	Transfert 1 U		
R2-Axis R3-Axis R4-Axis W-axis cansferM	PrfPos Sv0n Nove PrfPos Sv0n Nove PrfPos Sv0n Nove PrfPos Sv0n Nove PrfPos	0.         Speed3           0.         EncFos           Mome         LncF           Mome         LncF           None         LncF           Mome         LncF           SncFos         LncF	R° Alm R° Alm R° Alm Alm Alm	Stop Home Stop Home Stop Home Stop Stop	JogP JogN JogP JogN JogP JogN JogN JogP	MoveTo MoveDis MoveTo MoveTo MoveDis MoveTo MoveDis	Transferil         1         1           Z         Z         Z		
R2-Axis R3-Axis R4-Axis	PrfPos Svin, Move PrfPos Svin, Move PrfPos Svin, Move PrfPos Svin, Move PrfPos Svin, Move PrfPos Svin, Move PrfPos	0. 00 EncPos None LatP LatN None LatP LatN	R° Alm R° Alm R° Alm Alm Alm	Stop Home Stop Home Stop Home Stop Home	JogP JogN JogP JogP JogP JogN JogP JogH JogP	MoveTo MoveDis MoveTo MoveTo MoveTo MoveTo MoveTo MoveTo	Transferli 1 1 2 2 Transferli 1 1		

# [Hardware 2]

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping material] before executing single-axis movement!!!

		S-7040 Odd Form Insertion Machine User Manual
Main	Data Edit	System Set Hardware Hardware2
Stations		
Station1 2	1 2 Station2	1         1         1         1         1         1           2         2         Station3         2         2         Station4         2         2
Station5 1	1 2 Station6	1         1         1         1         1         Card set           2         2         2         2         Card set         2
Station9	1 2 Station10	1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1         1
Station13	1 2 Station14	1         1         1         1         1           2         2         2         Station16         1         1

## [Function menu area] interface introduction

[Document]

1. [Load data]: Load the selected data file into the software, including axis, camera algorithm and process parameters, etc.;

- 2. [Save data]: save data to the specified file path;
- 3. [Save data as]: data backup;
- 4. [On the camera] etc.

[set up]:

lardware conf	ïg						Ope
X-Direct	Left to Rig	ht 🔻	Tfer section	3 Section Std 👻	Lock type	Normal Lock	· .
Y-Direct	Out to In	•	R-axis count	4 🔹	] Bend Mac	None	▼ Time 15:39
CamUp Snap	Stop snap	-	Tfer Type	IO control 👻	] Foot Light	On top	15:39
CamDown Snap	4 cam stop	snap 🔻	₩-axis	Exist 👻	Put test	Sensor test	• 15:40
OutMsgIO	1 In 1 Out	•	Language	English 👻	]		
💦 Cam dni	set	Car	m dn1 calib 4p			1.000 100 1001 10	
Cam dni	set	Car	m dn1 calib 4p		nera Set Hikrobot - K78	1 m m 401 m	
Cam dn2	set	Car	m dn2 calib 4p	Rota		eftRightFlip	TopBottomFlip
Cam dn3	set	Car	m dn3 calib 4p	ScanCa	mraZoom	Triger Mode Sof	t •
Cam dn4	set	Car	m dn4 calib 4p			Exposure 100	
				MoveZoom	1	Gain 10.	9854



[Exposure time]: The time to press the shutter, the longer the time, the brighter the captured image, and it is easy to over- or under-exposure missing details;

[Gain]: Control photosensitivity, the bigger the gain, the brighter the image, and the more noise signal will be amplified.

[Trigger mode]: trigger camera photo mode, soft: soft trigger; Line0: falling edge; Line1: rising edge;



[Save Image]: Save the current camera image;

[Load Image]: Load the selected image path into the software.

# [user]

1. [User Login]

Main	Data Edit	System Set	Hardware	Hardware2		Data	R Login	Speed	(i) Infomation	User Level: I	Developer
ardware confi	ε					Operation	ClearMs	g ClearA	larm Video	StopVideo	FullVie
X-Direct	Left to Right 💌	Tfer section 3:	Section Std 💌	Lock type No	mal Lock 💌						-
Y-Direct	Dut to In 👻	R-axis count 4	•	Bend Mac No	ne 💌		lessage 有报警未清除				1
CamUp Snap	Stop snap	Tfer Type IO	control 💌	Foot Light On	top 💌	15:39:24	白奴音不須厥 急停触发				A. 1991
anDown Snap [	4 cam stop snap 💌	] W-axis Ex	ist 🔹	Put test Se	nsor test 🔹 💌	15:40:09 H					
OutMsgIO	1 In 1 Out 👻	Language En	glish 👻						100		
amera calibra	tion								1.1.1.1		- <b>E</b> -
Can up se		am up calib 4p	Can modu	1.					1000		<b>IK</b> -
		an up carro up									D.
🚬 Can dni s	et 🚺 Ca	am dnl calib 4p	🖉 Cam dni cali	b cen 🕺 Car	up dn1 calib						G
<b>a</b>		am dn2 calib 4p	🔊 Cam dn2 cali		up dn2 calib						Topla
Can dn2 s	et 🚺 🖬 La	am dn2 calib 4p	Stan dn2 call	b cen							ALC: NOT THE OWNER.
Can da3 s	et Co	um dn3 calib 4p	🖉 Can dn3 cali	b cen 🕺 Ca	Login						
						Administrator Administrator					
Can da4 s	et Ca	am dn4 calib 4p	🖉 Cam dn4 cali	b cen 🕺 Ca	Password:	SuperAdmin Developer					
alibration po	sition										
Li ghtThi ckne	ss 20.00 nm	FlyDistance 80	0.00 nm	FlyOffset -0.	OK	Cance	1				
FlySpe	ed 800.00 m/s	FlyAce 0.	10 s F1	ySmoothTime 0	5	1					
	SnapPos: X1 152	2.87 %2 152.87 %3	152.87 14 152.87	Υ -310.31							
	SnapZC1: Z 23.	85 C 90.00	SnapZC2: Z 25.10	C 90.00							
	SnapZC3: Z 23.	85 C 90.00	SnapZC4: Z 25.10	C 90.00			ŧ.				
						0 0				1	
SnapPos1 0	° SnapPos2	0° SnapPos	s3 0° SnapP	os4 0°							
SnapPos1 18	0° SnapPos2	180° SnapPoz	3 180° SnapPo	s4 180°	y Snap test						
		1		~**				-	12.5.6	4	
					_						

- 2. [Change Password]
- 3. [Logout]: The authority will be replaced with the lowest level "Operator".

# [speed]

[Speed 1]: Speed 1 is used for debugging, and speed 4 is used for automatic inserted;

[Speed setting]: the speed configuration of each axis;

MengPanase	ert - NABUBAN Data Edit	System Set	Hardware	Hardware2	🗖 Data 🔗 Login	Speed (i) Infomation	User Level: Developer
Hardware conf		Joyottan be	indi avdi o		Operation ClearMsg		StopVideo FullView
	Left to Right -	Tfer section	3 Section Std 👻	Lock type Normal Lock	Time Message	Speed2	
CamUp Snap		Tfer Type		Foot Light On top	15:39:04 有报警未清除 15:39:24 急停触发	C Speed3	
	4 cam stop snap 🕶	W-axis Language		Put test Sensor test 💌	15:40:09 Emergency st	Speed4	
Samera calibr			ingirian .			Speed Setting	

#### [information]

-Axis			
-Axis -Axis 2-Axis 2-Axis 3-Axis 4-Axis 2-Axis 2-Axis 2-Axis 3-Axis 4-Axis			
2-Axis 3-Axis 4-Axis			
1-Axis 2-Axis			
3-Axis 4-Axis		1	
-Axis			

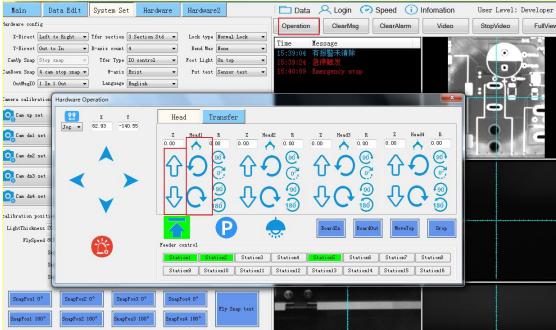
# **[**Quick Operation Area] Interface Introduction

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping material] before

#### executing single-axis movement!!!

1. [Clear alarm]: Reset the alarm reminder on the logic of the program;

2.[ControlPanel]:





#### [hand wheel]:

Nain Da	ta Edit Sys	tem Set Hard	ware Hardware2	🗖 Data 🛛 🔍 Login	Speed (i) Info	mation User Level	: Developer
Hardware config X-Direct Left t Y-Direct Out to CamUp Snap Stop s CamDown Snap 4 cam OutMsgIO 1 In 1	In	section 3 Section 5 s count 4 fer Type IO control W-axis Exist anguage English	tid • Lock type Hornal Lock • • Bend Hac Hone • • Foot Light On top • • Fut test Sensor test • •	Operation         ClearN           Time         Message           15:39:04         有报警未清閒           15:39:24         合機故           15:40:09         Emergency at	\$	Video StopVideo	FullView
Comera calibration Com up set Com dni set Com dn2 set	Hardware Operatic	Y	Head Transfer Stopi	, Stoj	R		
Cam dn3 set Cam dn4 set calibration positic LightThickness 20	< ,	*	Transferl	TransferM	TransferR	Drop	
FlySpeed 80 Si Si Si	6		Feeder control		Station5 Station7 Stat tstion14 Ststion15 Ststi		
SnapPosl 0° SnapPosl 180°	SnapPos2 0° SnapPos2 180°	SnapPos3 0° SnapPos3 180°	SnapFost 180° Fly Snap test				

[Clear all axis alarms]: reset the alarm information on the driver;

[Lighting lamp]: top light source, illuminate the interior during manual debugging;

[Vacuum pump]: Generate negative pressure, suitable for negative pressure clips;

[Top]: Execute top action according to the thickness of the top;

[Parking position]: The safe position of the machine standby;

[Board Feed]: When there is a board sensed, execute the board feeding action;

[Outboard]: When the board is sensed, execute the board out action;

[Lift the head]: All the Z axes return to the safe position (please pay attention to the Z axis position during manual debugging);

[Throwing]: Execute throwing action

- 3. [Clear information]: Reset the information reminder on the logic of the program;
- 4. [Overall display]: All camera images are displayed as a whole;
- 5. [Stop/Photo]: Execute photo mode;
- 6. [Video Mode]: Execute video mode.

# [Status display area] interface introduction



# operation logic

Reminder:!!! When manually debugging, please use speed 1. Generally, execute [lifting head], [stop position] or [dropping material] before executing single-axis movement!!!

Access board 1->Pickup parameter 2->Up and down camera algorithm setting 3-> template matching 4->Single/multiple imposition setting 5-> Imposition Correction 6->Left, middle and right suspended 7->inserted parameter 8 >test inserted 9-> run automatically 10

# Line distribution

1. Line distribution is divided into: main circuit diagram, IO wiring diagram, wiring diagram, etc.

2. Working area signal: including track signal distribution, feeding signal distribution, XY axis signal distribution, Z axis signal distribution.

3. Driver board line signal: including emergency stop, component light source, front safety light curtain, rear safety light curtain, driver board, air pressure detection, fluorescent lamp, etc.Line distribution.