



- 因为此机器为单相电，所以接入两根线（从工厂的总电源线拉一下，把两根火线接入机器的两根火线的位置）
- Because this machine uses single-phase electricity, it needs to be connected to two wires (run a line from the factory's main power line and connect the two live wires to the machine's two live wire positions).
- 注意：
- 如果线正常连接以后，机器点击切割没启动，那么可能就是油泵电机的连接线装反了，只需要更换上面的任意两个线，机器可能就正常切割
- If the machine doesn't start cutting after the cables are properly connected, the problem might be that the oil pump motor's connection cables are reversed. Simply replacing any two of these cables should resolve the issue and allow the machine to cut normally.

打开电源开关

Turn on the power switch





打开急停开关，机器启动

白色电源指示灯亮起

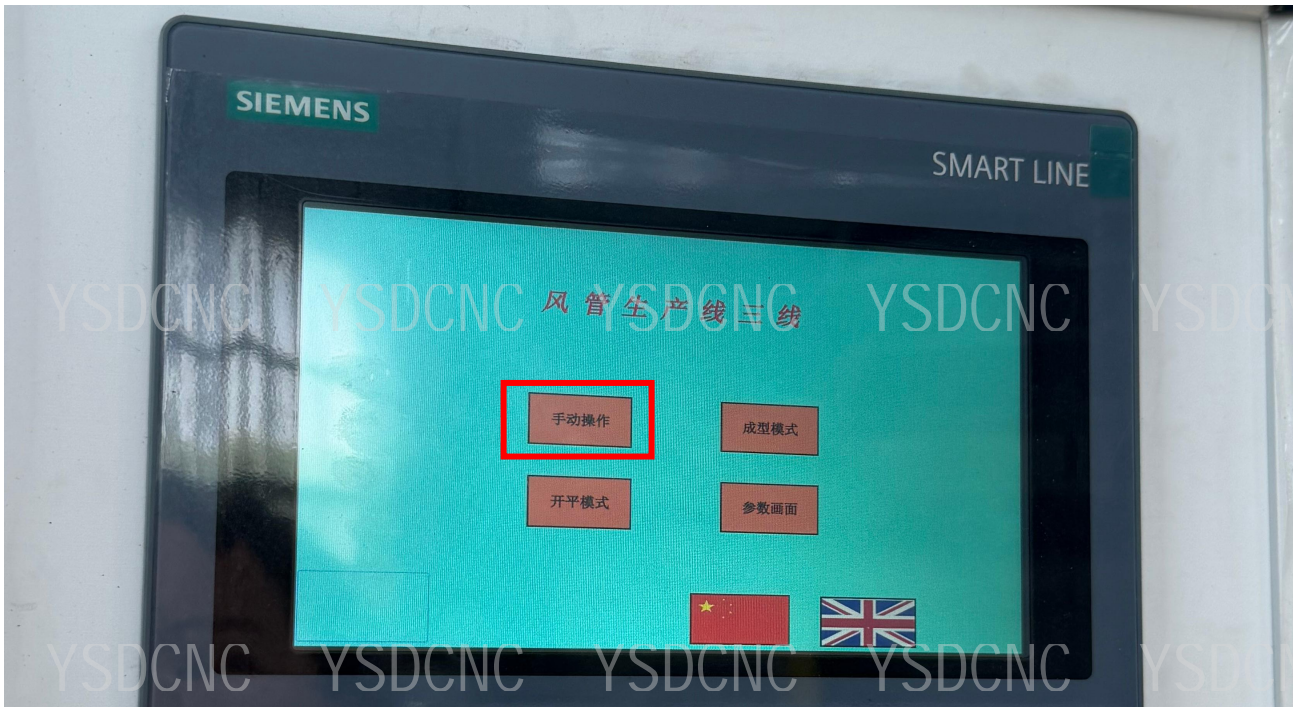
Turn on the emergency stop switch, the machine starts.

The white power indicator light illuminates.



开机后主页面点击国旗可以选择语言

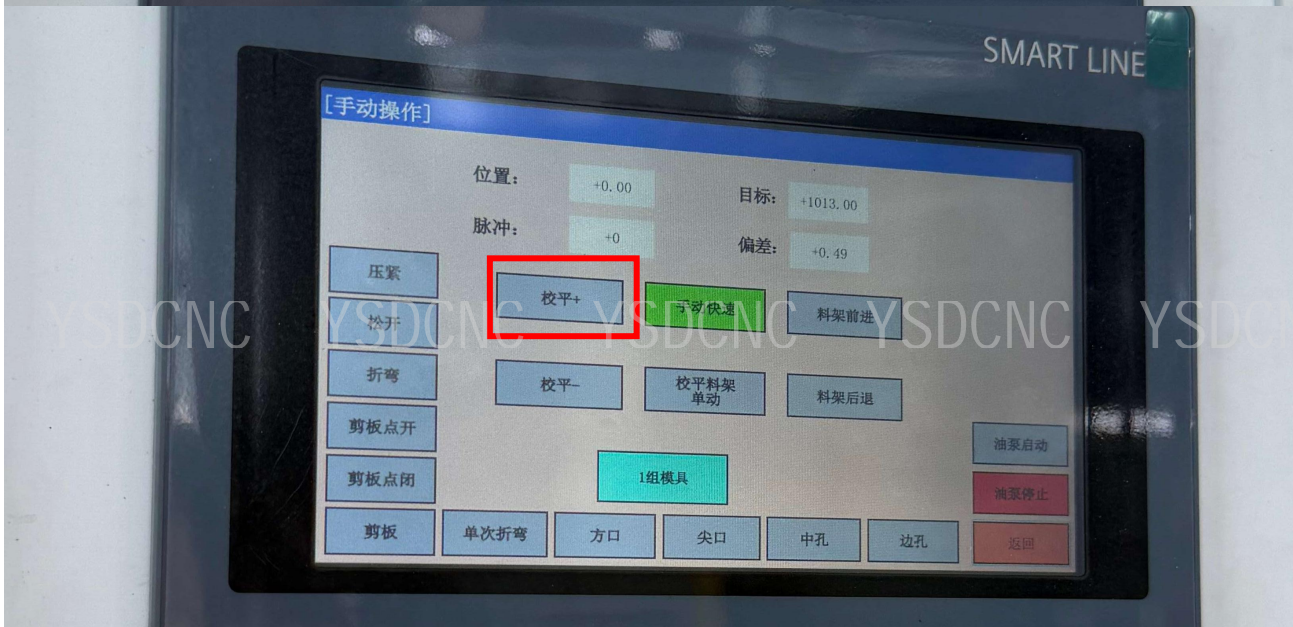
After powering on, click the national flag on the main screen to select the language.



选择手动操作进入

点击“校平+”开始往前送料

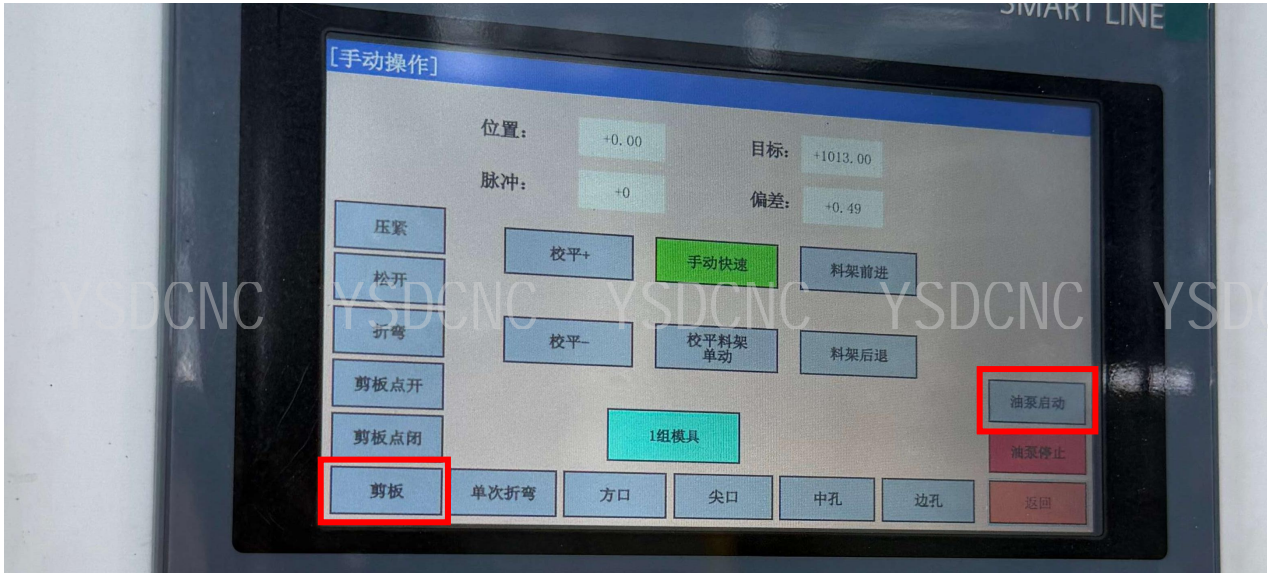
Select manual operation mode and click "Leveling+" to start feeding material forward.



将卷料送出1厘米

Feed the roll of material out 1 cm



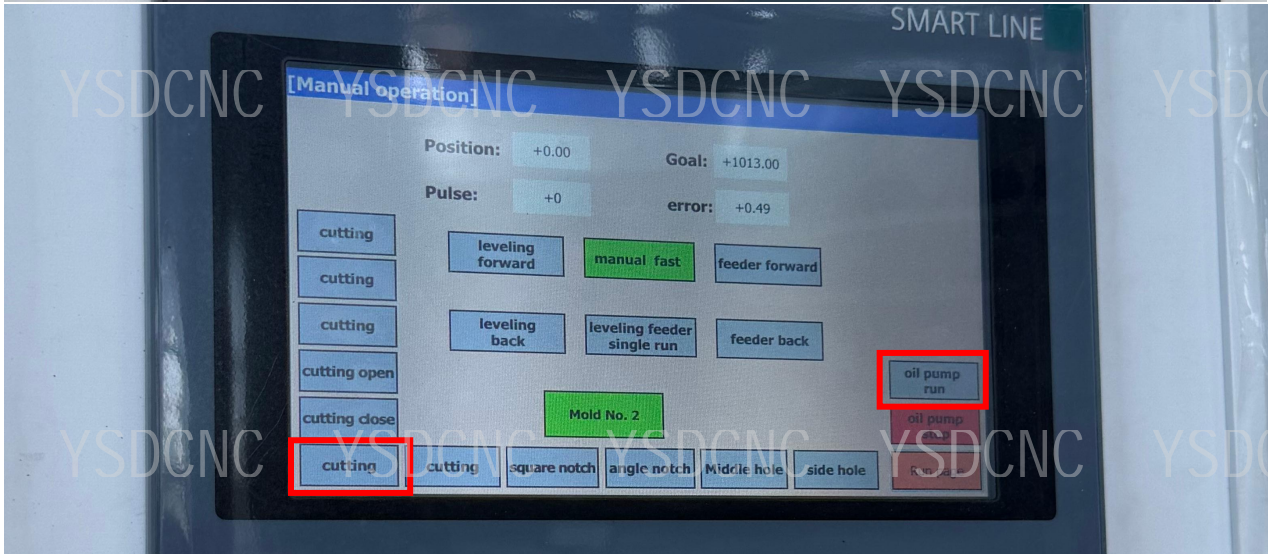


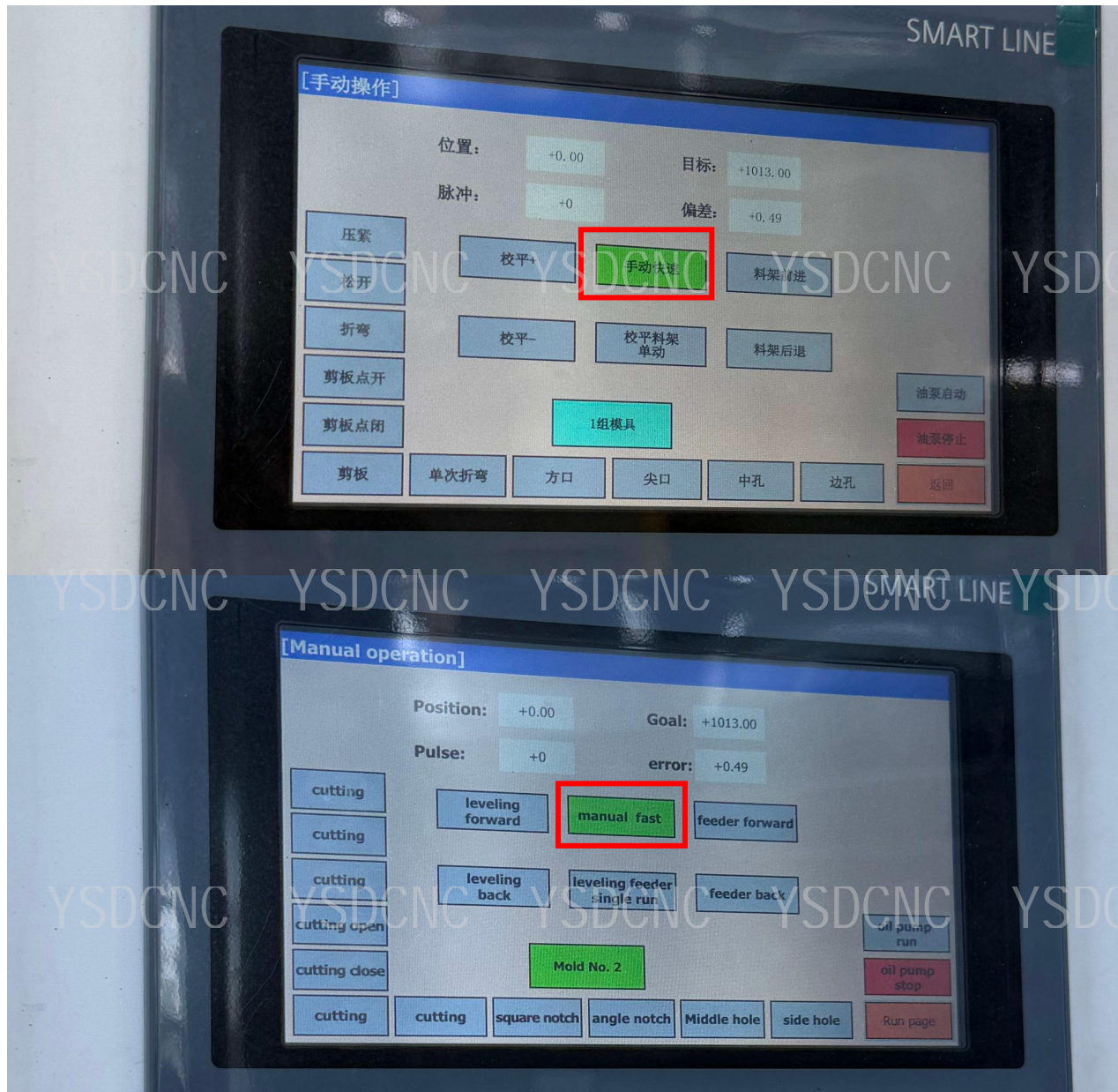
点击“油泵启动”

点击“剪板”开始剪切

Click "Oil Pump run"

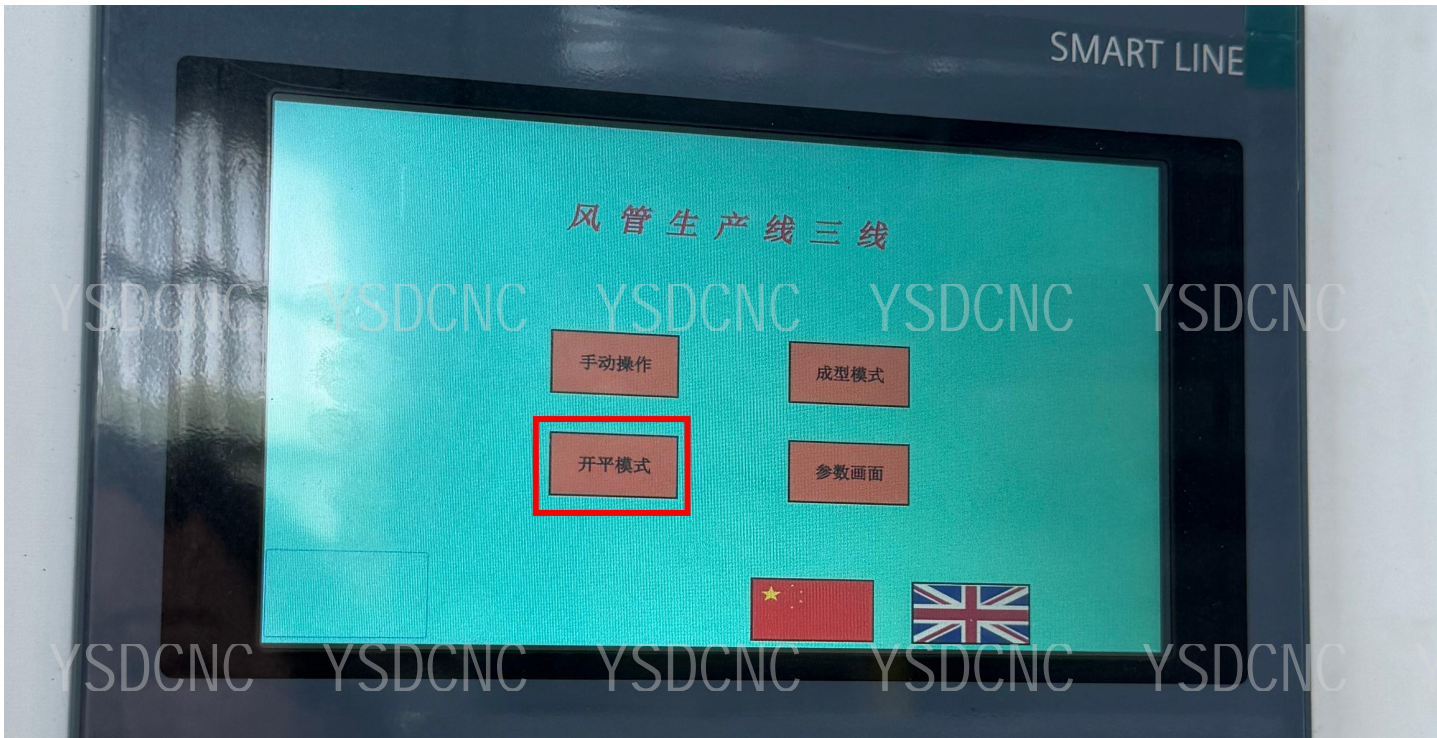
Click "Cutting" to start shearing.





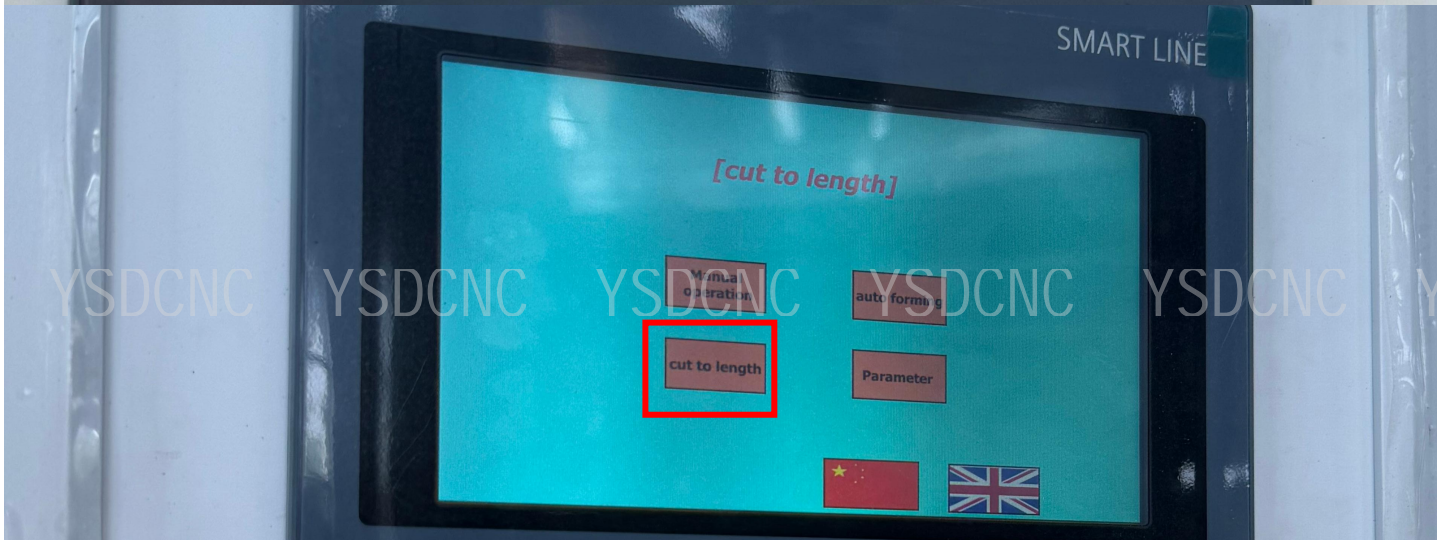
可以使用“手动快速键”，调整送料的速度

You can use the "manual fast" to adjust the feeding speed.



选择“开平模式”进入

Select "cut to length" to enter.





设置长度和剪切数量

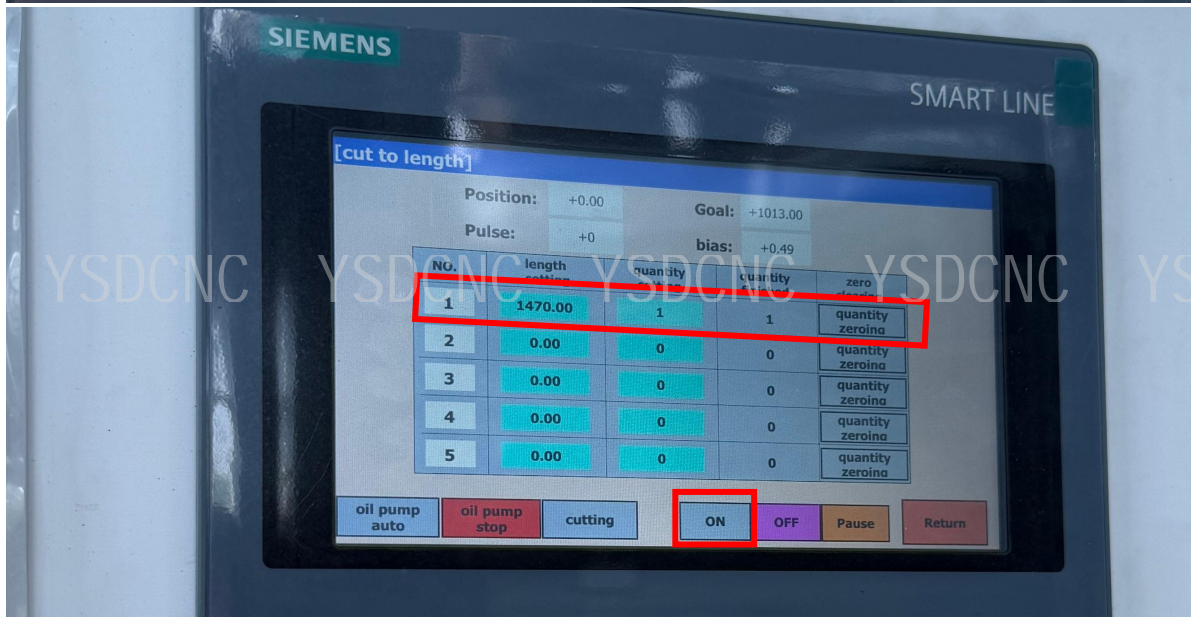
例如我们需要剪切1000mm的板，
将长度设置为“1000”，剪切数量设置为“1”

按下“ON”键开始剪切

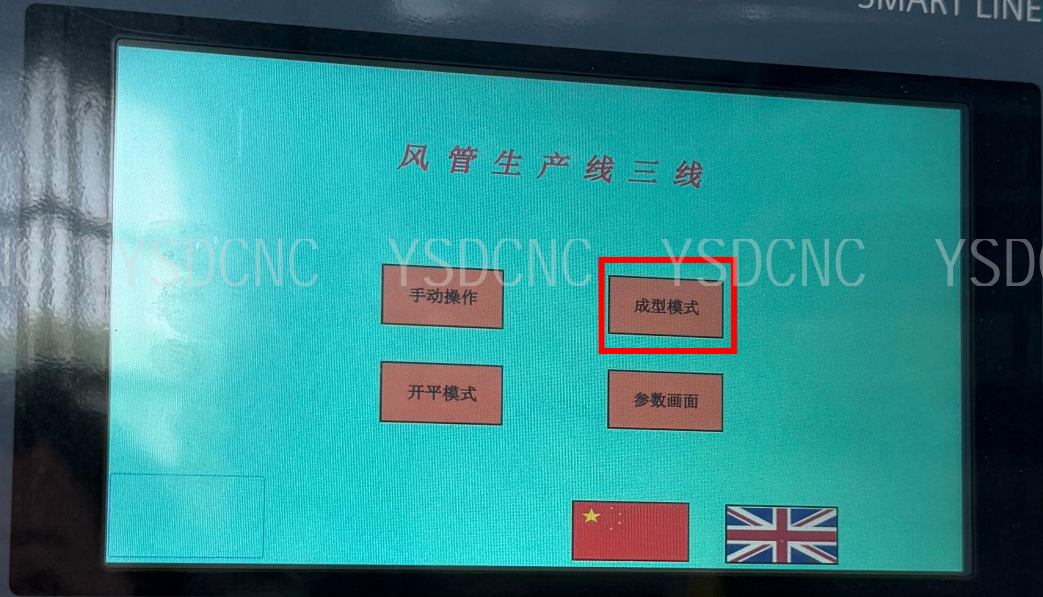
Set the length and cutting quantity.

For example, if we need to cut a 1000mm board,
set the length to "1000" and the cutting quantity to
"1".

Press the "ON" button to start cutting.



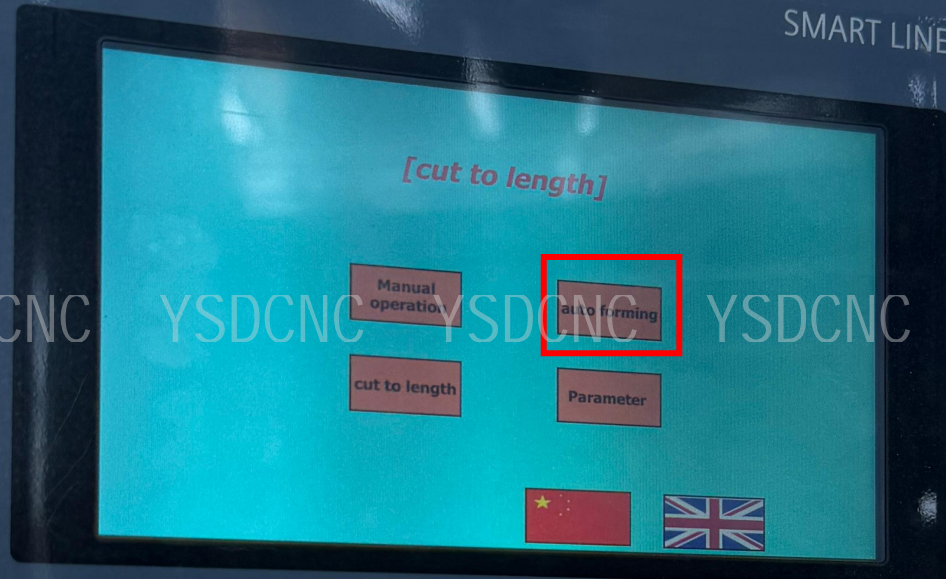
SMART LINE



选择“成型模式”进入

Select "auto forming" to enter.

SMART LINE





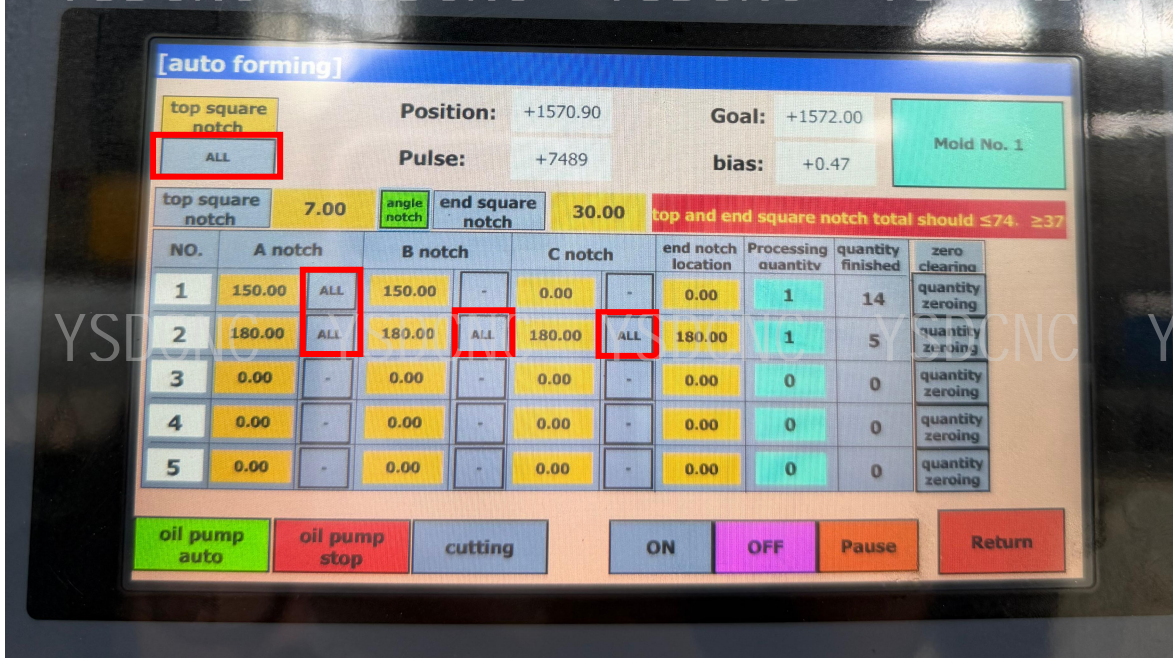
当统一设定选择“复合”功能时，成型就会包含“折弯”和“尖口”两种功能。

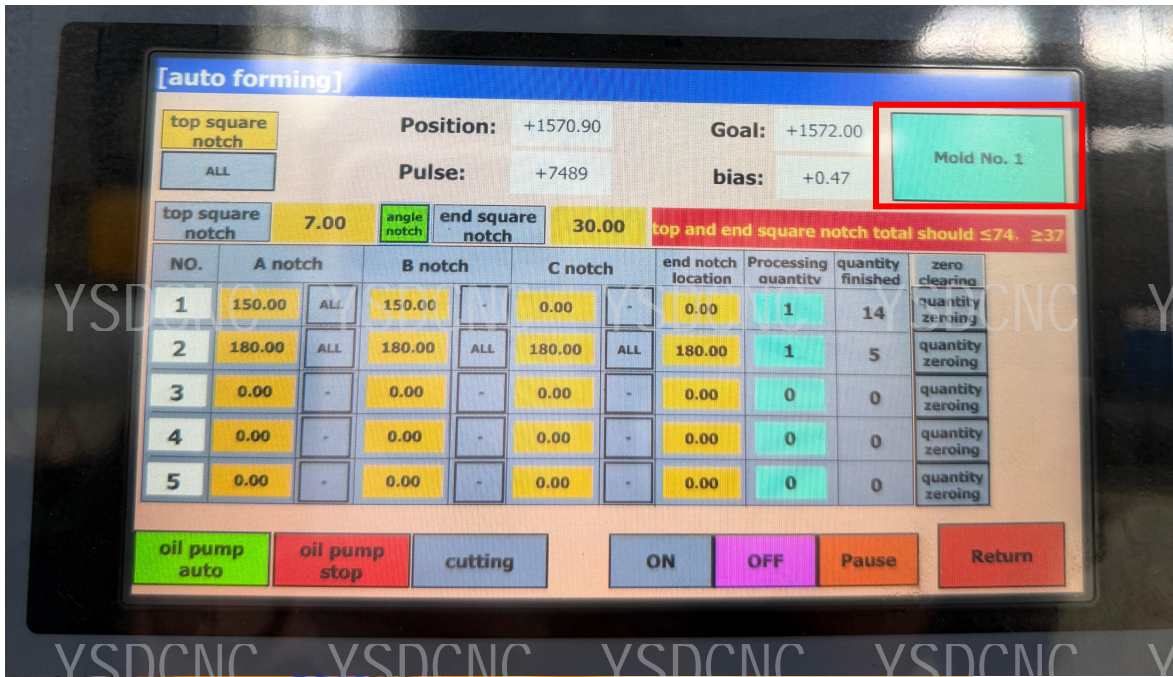
如果选择折弯，成型就只有“折弯”这一种，选择“尖口”，那么成型就只有“尖口”这一种。

When the "ALL" function is selected in the unified settings, the forming process will include both "Bending" and "Sharp mouth" functions.

If "Bending" is selected, the forming process will only be "Bending";

if "Sharp mouth" is selected, the forming process will only be "Sharp mouth".





图中圈出的右边两组为模具1

The two groups circled on the right in the picture are Mold NO.1.



模具1成型为TDF

选择模具1时，尾方口必须要设置成“30”

根据需求设置“L”片的参数和加工数量

按下“ON”启动机器开始送料成型剪切

(图中圈出NO.1即为“L”片的参数)

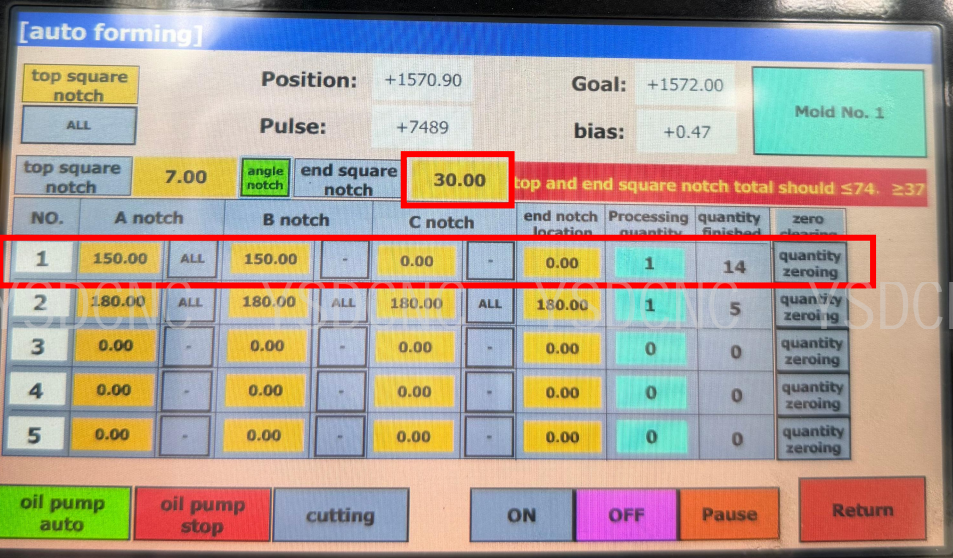
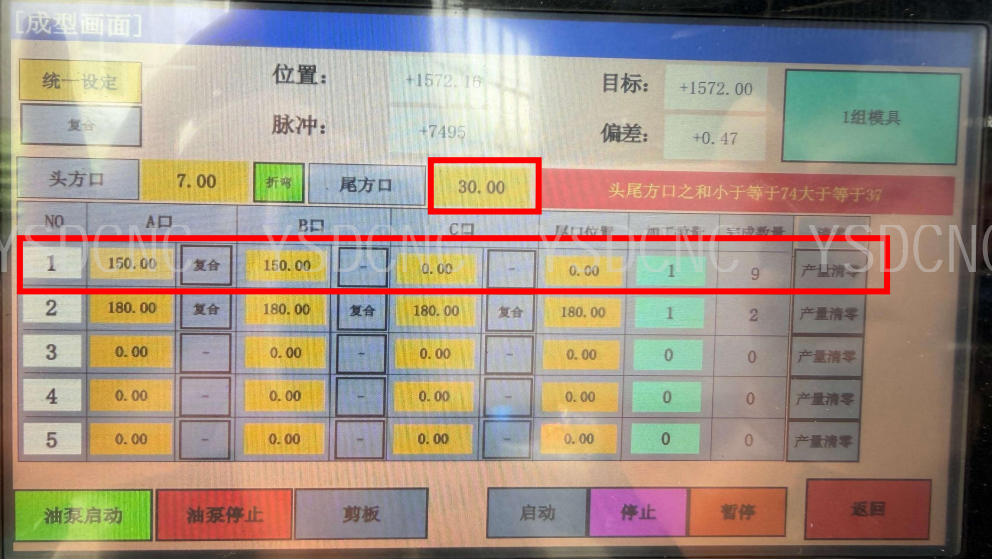
Mold NO.1 forms TDF.

When selecting Mold NO.1, the tail square opening must be set to "30".

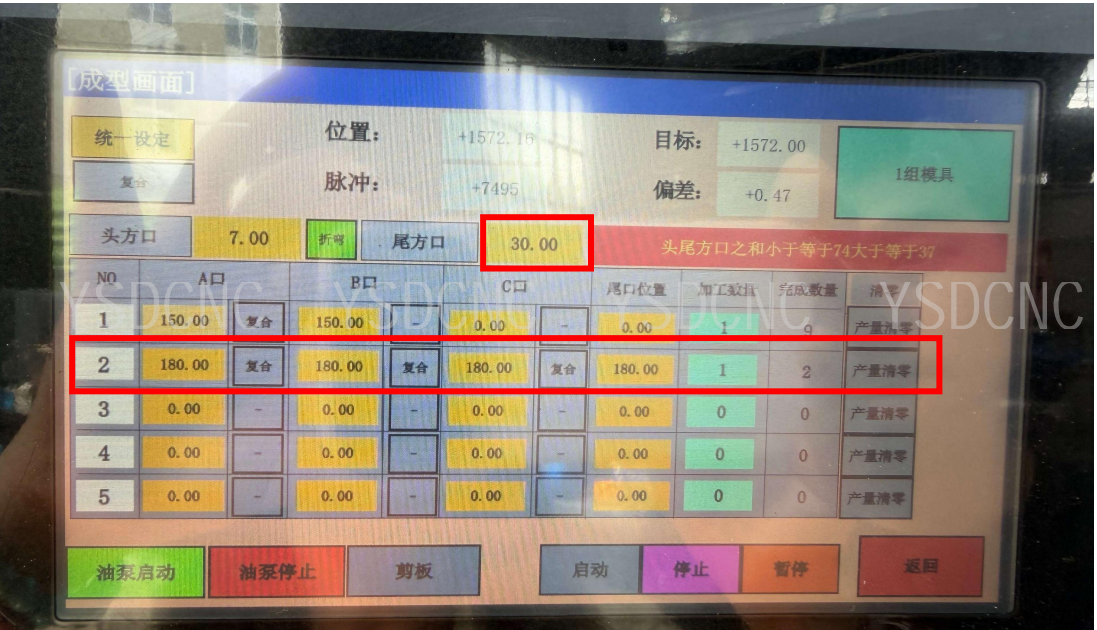
Set the parameters and processing quantity of the "L" sheet according to requirements.

Press "ON" to start the machine to begin feeding, forming, and shearing.

(NO.1 circled in the diagram represents the parameters of the "L" sheet.)



"L" sheet product



模具1成型为TDF

选择模具1时，尾方口必须要设置成“30”

根据需求设置“口”片的参数和加工数量

按下“ON”启动机器开始送料成型剪切

(图中圈出NO.2即为“口”片的参数)

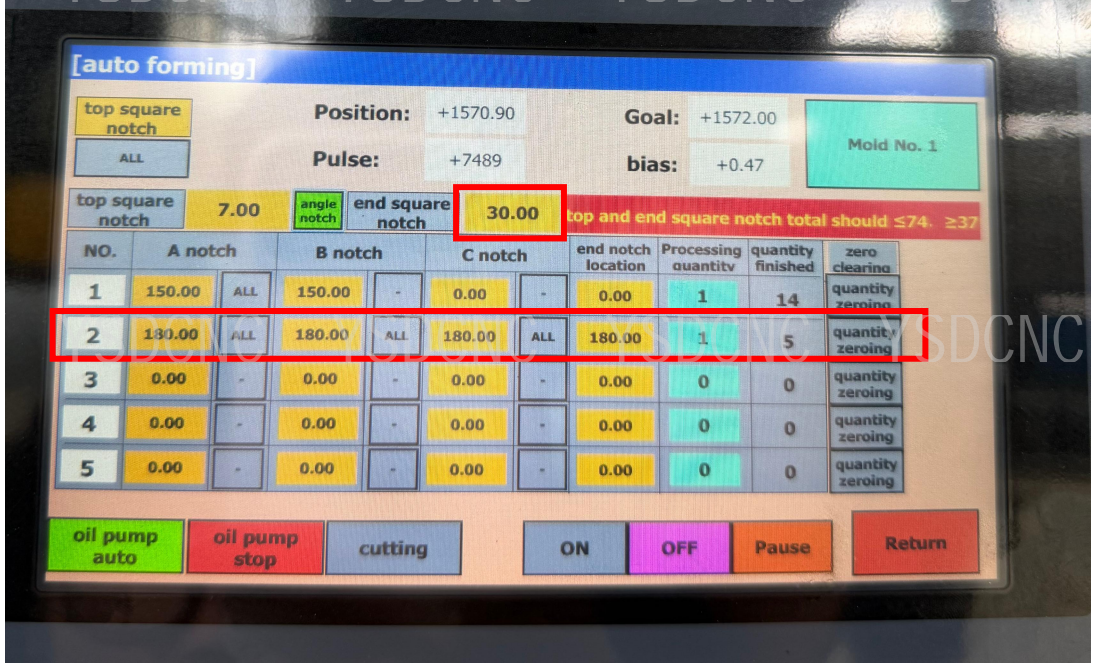
Mold NO.1 forms TDF.

When selecting Mold NO.1, the tail square opening must be set to "30".

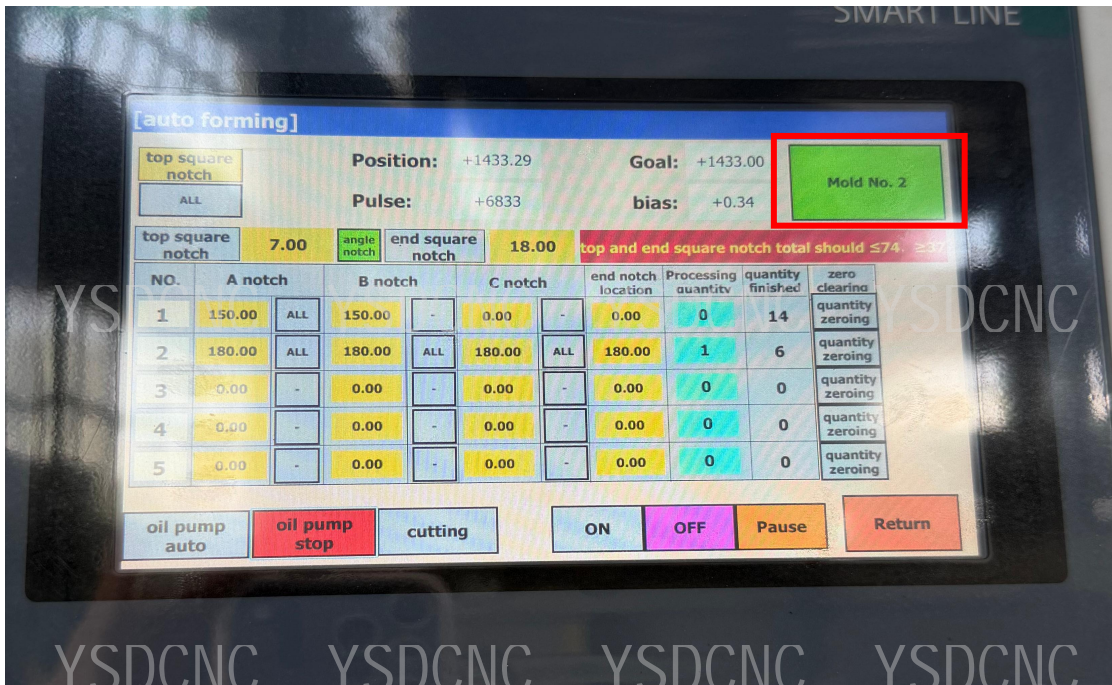
Set the parameters and processing quantity of the “口” piece according to requirements.

Press "ON" to start the machine to begin feeding, forming, and shearing.

(NO.2 circled in the diagram represents the parameters of the “口” piece.)

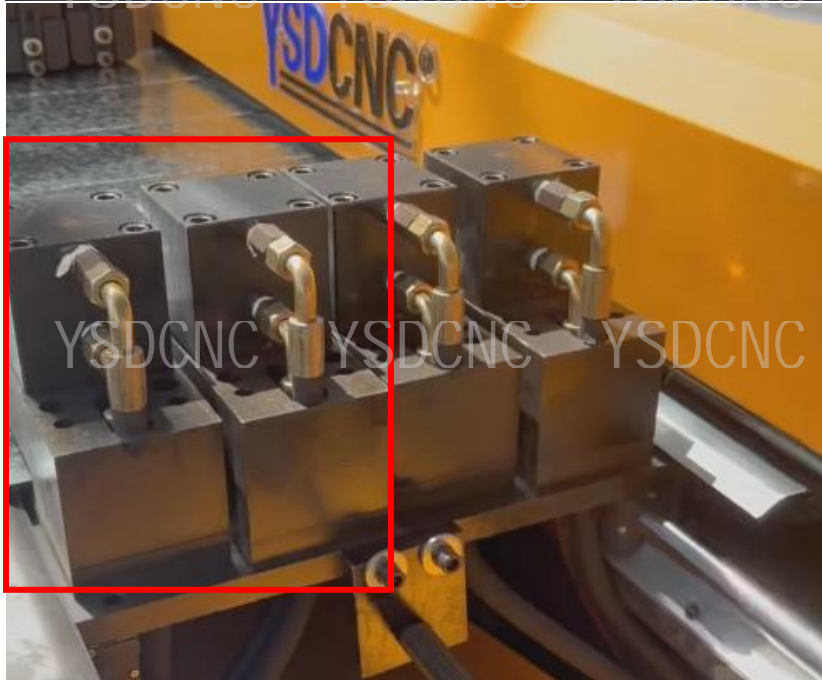


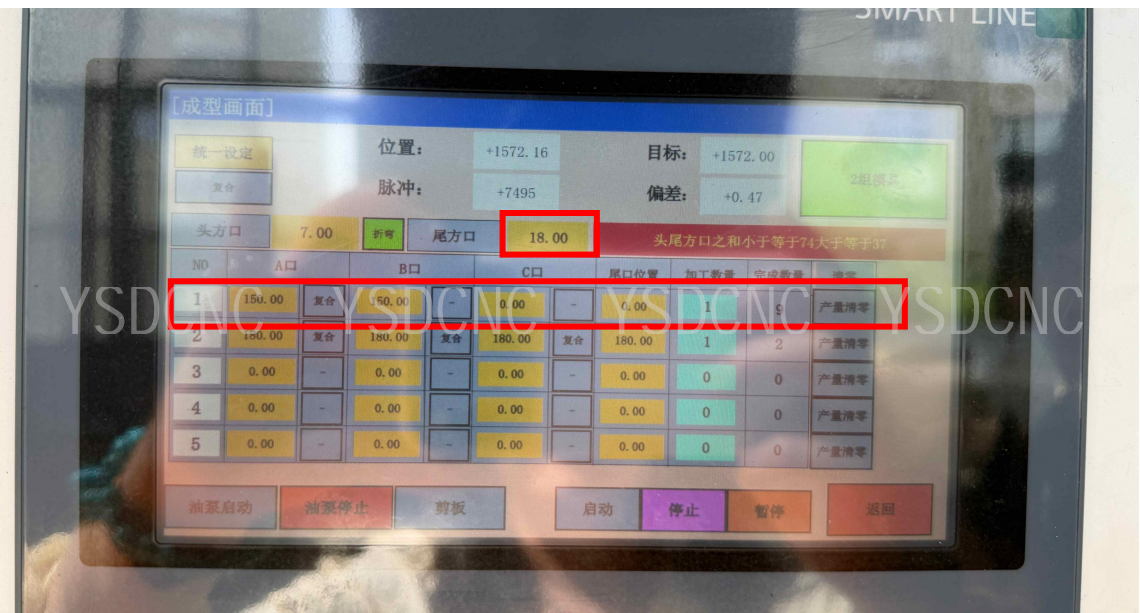
“口”sheet product



图中圈出的左边两组为模具2

The two groups circled on the left in the picture are Mold NO.2.





模具2成型为SC

选择模具2时，尾方口必须要设置成“18”

根据需求设置“L”片的参数和加工数量

按下“ON”启动机器开始送料成型剪切

(图中圈出NO.1即为“L”片的参数)

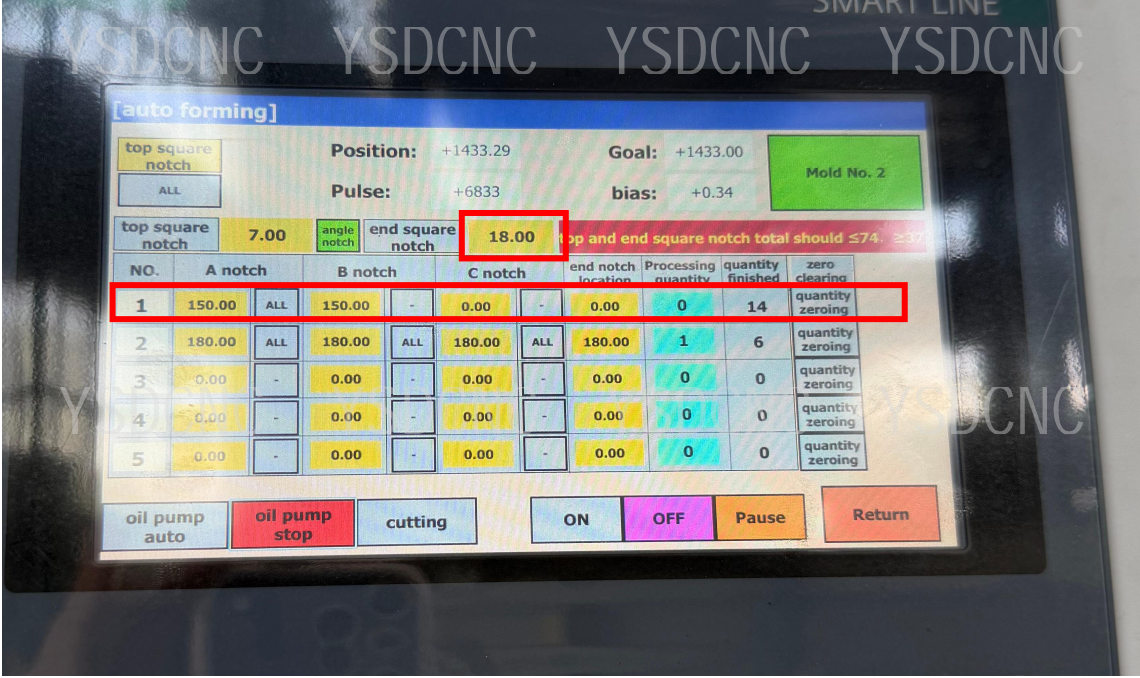
Mold NO.2 forms SC.

When selecting Mold NO.2, the tail square opening must be set to "18".

Set the parameters and processing quantity of the "L" piece according to requirements.

Press "ON" to start the machine to begin feeding, forming, and shearing.

(NO.1 circled in the image represents the parameters of the "L" piece.)



"L" sheet product

模具2成型为SC

Mold NO.2 forms SC.

选择模具2时，尾方口必须要设置成“18”

When selecting Mold NO.2, the tail square opening must be set to "18".

根据需求设置“口”片的参数和加工数量

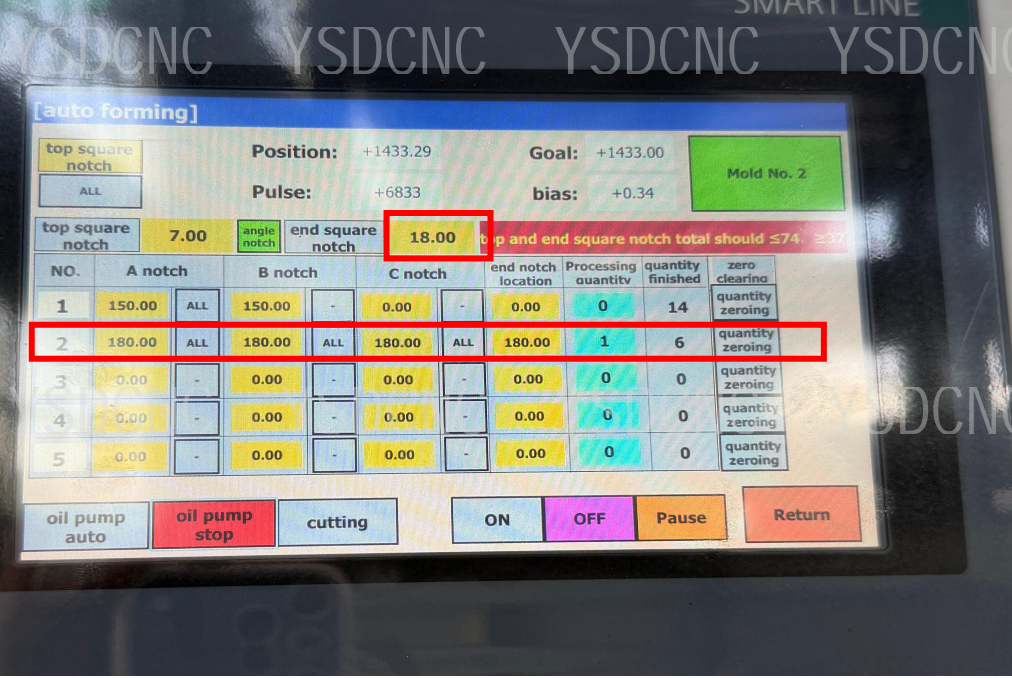
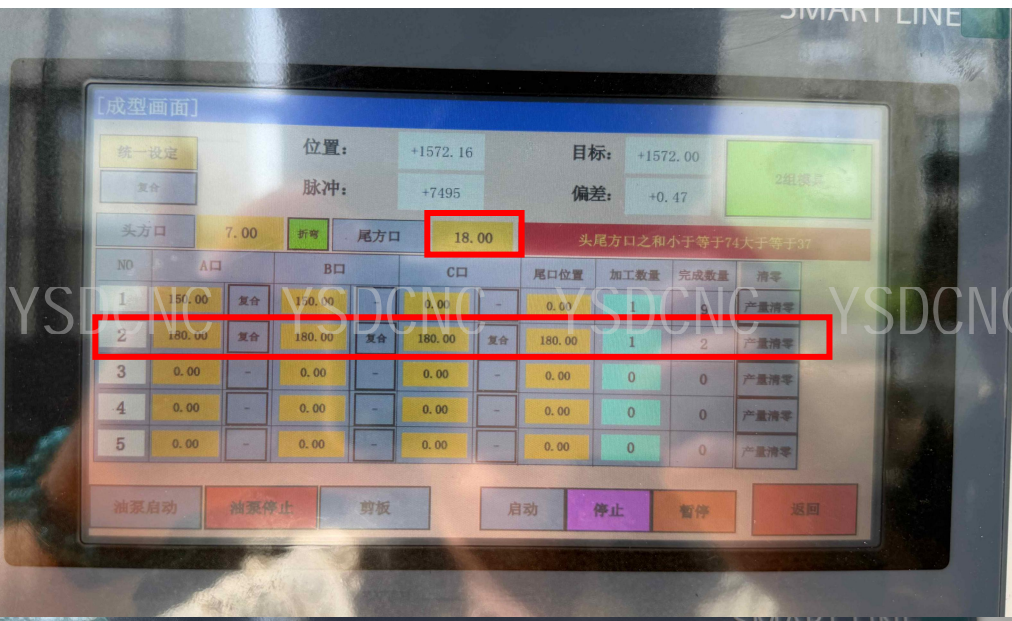
Set the parameters and processing quantity of the “口” piece according to requirements.

按下“ON”启动机器开始送料成型剪切

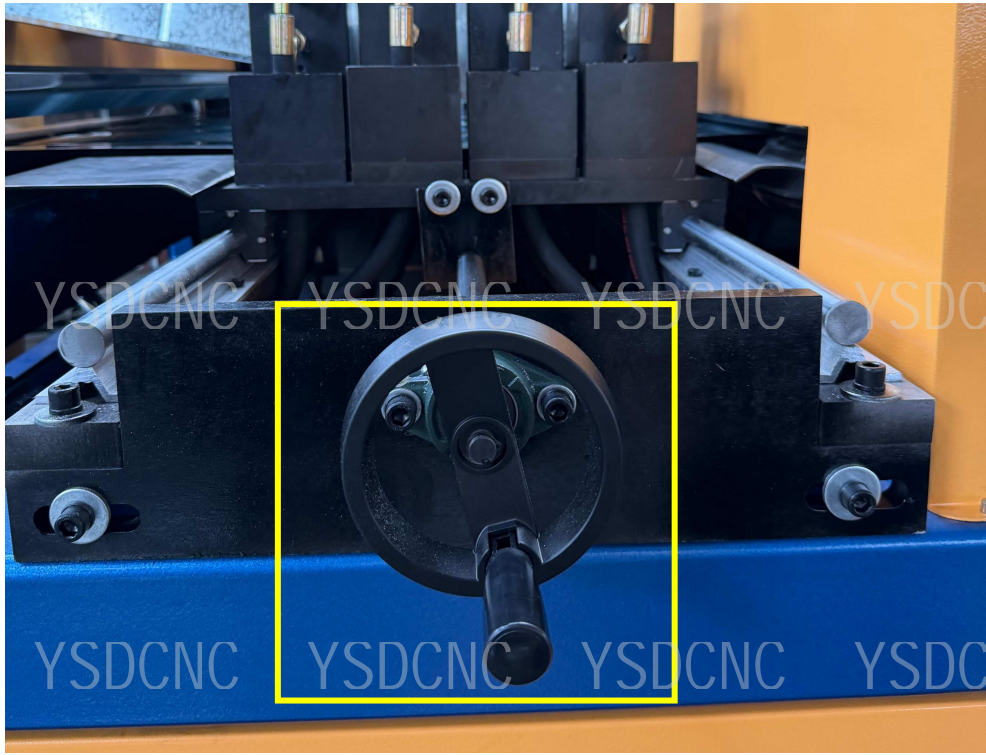
Press "ON" to start the machine to begin feeding, forming, and shearing.

(图中圈出NO.2即为“口”片的参数)

(NO.2 circled in the image represents the parameters of the “口” piece.)



“口”sheet product



摇动手柄控制模具前进后退，
以此决定切口的深浅。

Crank the handle to control the mold's forward and
backward movement, thus determining the depth of
the cut.

