

因为机器在运输途中是不允许有液压油，所以需要客户自己准备。

请准备46号抗磨液压油，加入油缸，机器才能启动

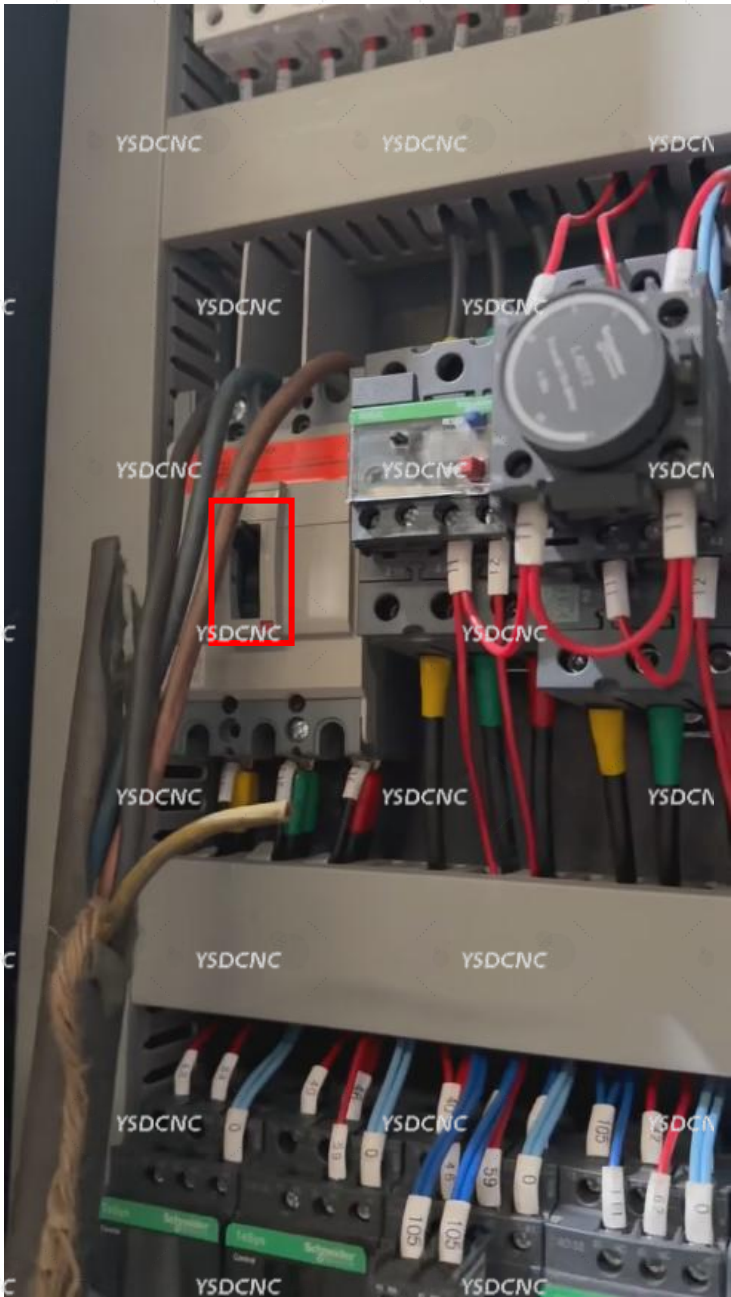
Because hydraulic oil is not allowed during machine transportation, the customer needs to prepare it themselves. Please prepare No. 46 anti-wear hydraulic oil and add it to the cylinder for the machine to start.





打开急停开关

Turn on the emergency stop switch



接入三根线  
启动电源开关  
Connect three wires  
Turn on the power switch



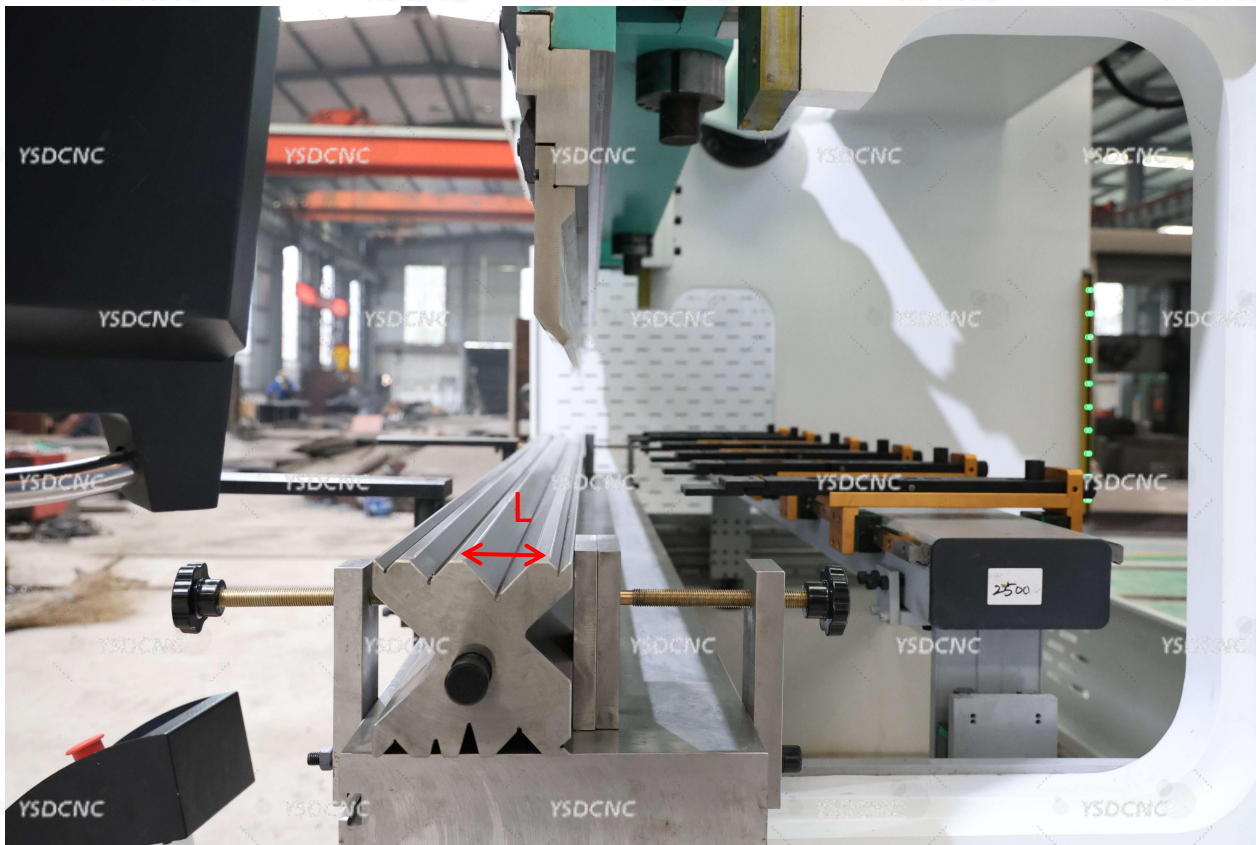
打开电源，白色电源指示灯亮起

When the power is turned on, the white power indicator light illuminates.



启动油泵

Start the oil pump



折弯机下模角度的选取，请测量槽口上面的宽度，按照1:8的比例选取槽口。

举例：如测量出来“L”的距离等于16mm，根据 $16/8=2$ ，那么这个槽口就是用来加工2mm厚度的钢板；

举例：如测量出来“L”的距离等于8mm，根据 $8/8=1$ ，那么这个槽口就是用来加工1mm厚度的钢板。

To select the angle of the lower die on the bending machine, measure the width of the slot and select the slot according to a 1:8 ratio.

For example: If the measured distance of the "L" is 16mm, then according to  $16/8=2$ , this slot is used to process steel plates with a thickness of 2mm.

For example: If the measured distance of the "L" is 8mm, then according to  $8/8=1$ , this slot is used to process steel plates with a thickness of 1mm.



## 手动设置X/Y轴

按下图中所圈出的键进入手动设置，  
使用“+”“-”号对X/Y轴做出调整

X代表后挡料的距离

Y代表滑块上下运行的行程，也就是折弯的深度

Y的数值越大，角度越小

Y的数值越小，角度越大

初次设置的Y值需要客户根据实际尺寸进行测试微调，确定数值以后  
请备注加入程序中，方便后续快速调起使用

Manually Set X/Y Axes

Press the button circled in the image to enter manual settings.

Use the "+" and "-" signs to adjust the X/Y axes.

X represents the distance of the back gauge.

Y represents the vertical travel of the slider, i.e., the bending depth.

The larger the Y value, the smaller the angle.

The smaller the Y value, the larger the angle.

The initial Y value needs to be fine-tuned by the customer based on actual dimensions. After determining the value, please add it to the program for easy recall later.



## 单步设置

选中XP/YP，输入跟X/Y的尺寸一致，

例如X:299.9,那么XP:输入“299.9”

YP同理，Y:175.0,YP:输入“175.0”

按下回车确认即可开始折弯

Single-step setup:

Select XP/YP, and enter the same dimensions as X/Y.

For example, if X: 299.9, then enter "299.9" for XP.

Similarly, if Y: 175.0, then enter "175.0" for YP.

Press Enter to confirm and begin bending.



当我们要停止此时的设备，进行新的设置或者新的工序，按红色的停止按钮，然后点击“p”键

When we want to stop the equipment and proceed with new settings or procedures, press the red stop button, then press the "p" key.



## 多步设置

先停止机器工作，按下“P”键进入程序选择，选择一个程序按下回车键进入开始设置多步

(机器中可以设置多个工件的不同数字代码)

Multi-step setup

First, stop the machine. Press the "P" key to enter program selection. Select a program and press Enter to begin multi-step setup

(Multiple workpieces can be set with different numerical codes in the machine.)



## 设置程序步数

例如：我需要折弯2步，在程序步数输入“2”，按下回车键确认

Set the program steps.

For example: If I need to bend in 2 steps, enter "2" in the program steps and press Enter to confirm.



设置保压时间，正常情况下设置3秒，在程序步数输入“3”，按下回车键确认。

(具体要按照自己实际情况所定)

Set the pressure holding time. Normally, set it to 3 seconds. Enter "3" in the program step count and press Enter to confirm.

(The exact time should be adjusted according to your specific needs.)



按下右箭头键进入折弯第一步设置x/y轴

Press the right arrow key to enter the first step of bending and set the X/Y axes.



## 第一步设置

例如设置：x目标位置为200mm，输入“200”，按下回车确认

(当需要折弯的距离是200mm即设置x值为200)

Setting the first step:

For example, to set the target X position to 200mm, enter "200" and press Enter to confirm.

(When the required bending distance is 200mm, set the X value to 200.)



## 第一步设置

例如设置：Y目标位置为170mm，输入“170”，按下回车确认

(当我们通过手动测试出来需要的目标Y值，就可以直接输入Y值的数据)

Setting up the first step:

For example, to set the target Y position to 170mm, enter "170" and press Enter to confirm.

(Once we have manually determined the desired target Y value, we can directly input the Y value.)

按下右箭头键翻页

进入折弯第二步设置X/Y轴

Press the right arrow key to turn the page. Proceed to the second step of bending and set the X/Y axes.





## 第二步设置

例如设置：X目标位置为200mm，  
输入“200”，按下回车确认

Step 2

For example, set the X target  
position to 200mm,

Enter "200" and press Enter to  
confirm.



## 第二步设置

例如设置：Y目标位置为176mm，输入“176”，按下回车确认

### Step 2

For example, to set the Y target position to 176mm, enter "176" and press Enter to confirm.



### 编程完成

按下左箭头键翻回到第一步的页面，  
按下绿色启动键，即可开始折弯，  
然后开始踩脚踏开关

Programming complete.

Press the left arrow key to return to  
the first step page, press the green  
start button to begin bending.

Then start using the foot pedal switch.