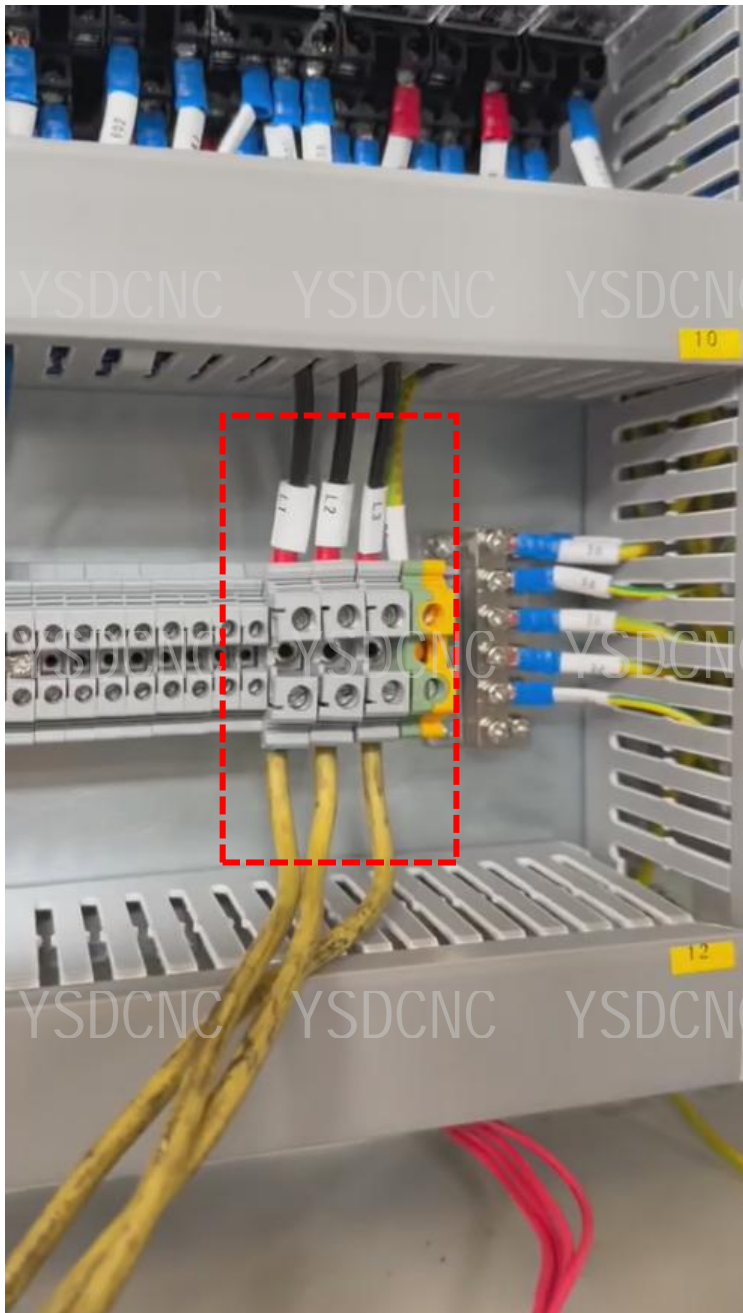


因为机器在运输途中是不允许有液压油，所以需要客户自己准备。

请准备46号抗磨液压油，加入油缸，机器才能启动  
(加油至油缸的三分之二的位置即可)

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. (Fill the tank to two-thirds full.)





接入三根线  
Connect three wires



打开电源开关  
Turn on the power switch



根据电机上的箭头符号观察，  
电机是否正转，顺着箭头方向转动即为正转；  
反之则为反转，假如是反转，需要关闭电源，  
将接入的三根线，调换其中任意两根的位置即可

Observe the arrow symbol on the motor to see if it is rotating in the correct direction. If it rotates in the direction of the arrow, it is rotating in the correct direction; otherwise, it is rotating in the wrong direction. If it is rotating in the wrong direction, turn off the power and swap the positions of any two of the three connected wires.



打开系统电源开关（0 to 1），白色指示灯亮起。  
Turn on the system power switch (0 to 1), and the white indicator light will illuminate.



向右旋转，打开红色急停开关

Turn right to activate the red emergency stop switch.



按下绿色油泵按键启动，机器开始运行

Press the green oil pump button to start, and the machine will begin running.



例如：要剪切的长度为300mm，  
那么我们在XP的位置：输入“300”，  
按下回车确定

For example: If you want to cut a length of 300mm,  
then in the XP field: type "300",  
and press Enter to confirm.



再按下绿色的启动键，  
后挡料退让到300mm的位置，机器上放入  
要剪切的板材，踩下脚踏开关开始剪切  
Press the green start button again, the back  
gauge will retract to 300mm, place the sheet  
material to be cut onto the machine, and  
press the foot pedal to start cutting.



## 售后问题之调节刀口间隙

当刀片间隙不合理时，我们需要调节刀口间隙

先按下左图中的红色停止键，再按下右图中所圈出的键“+，-”按键，增加或者减少刀口间隙

### After-sales issue: Adjusting the blade gap

When the blade gap is unreasonable, we need to adjust it. First, press the red stop button in the left image, then press the "+" and "-" buttons circled in the right image to increase or decrease the blade gap.

# 刀口间隙的调节数据，请根据下图的对照表

Please refer to the table below for the adjustment data of the cutting edge gap.

机器润滑指示图  
 The indicating diagram for lubricating the machine



注：1. 钙基润滑脂50%，机械油50%混合后使用  
2. 石墨锂基脂必须加30%机械油混合使用

Note: 1. 50% calcium grease and 50% machine oil are mixed to use.  
2. If you use the lithium grease, you must add 30% machine oil to use it.

润滑点序号 Lubrication points example	润滑点名称 The lubrication point name	油量大小 The amount	润滑周期 The interval hours	润滑油种类及牌号 The type and grade of lubricant
1	上刀架后支承点左右各二点 Two points around the support roller after the upper tool holder	中 Medium	8小时 8 hours	钙基润滑脂 calcium grease
2	上刀架前支承点左右各一点 A point about the point of support at the front of the upper tool holder	小 Small	8小时 8 hours	ZG-3 GB491-84 机械油 machine oil
3	左右活塞杆下端各一点 A point at the lower end of the left and right piston rod	小 Small	4小时 4 hours	N46GB443-84 抗磨液压油 N46 anti-wear hydraulic oil
4	左右后档料丝杆螺母各一点 A point at the wire rod & screw at the left and right back gage.	小 Small	8小时 8 hours	

禁止拆下此标签 FORBIDDEN TO REMOVE THIS LABEL

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安全注意事项  
SAFETY PRECAUTIONS

1. 开机前必须确认机床周围无其他人或障碍物。
2. 禁止超负荷切削。
3. 切削材料时，严禁卸下安全防护栏。
4. 氮气缸中只允许充氮气。

1. It will be unsafe to start a lathe or machine in an area of dead end or in a crowded place.  
2. Overload should not be used.  
3. When the clamped material is steady, forbidden to remove the safety fence.  
4. Nitrogen cylinder filled with nitrogen only allowed.

警告/WARNING



请注意操作安全，严禁将手伸入上下刀口之间，或手伸入刀片下方，否则极易造成严重的人身伤害事故。

Please pay attention to your safety. It is strictly forbidden to put hands between upper blade and lower blade or put fingers under the tool blank, otherwise injury, such as being cut, is prone to happen.

板厚与刀口间隙调整对应表  
The corresponding list for the adjustment of the sheet thickness, the blade edge position and the gap



S 刀口间隙 (mm)  
Blade clearance

h 板厚 (mm)  
Thickness

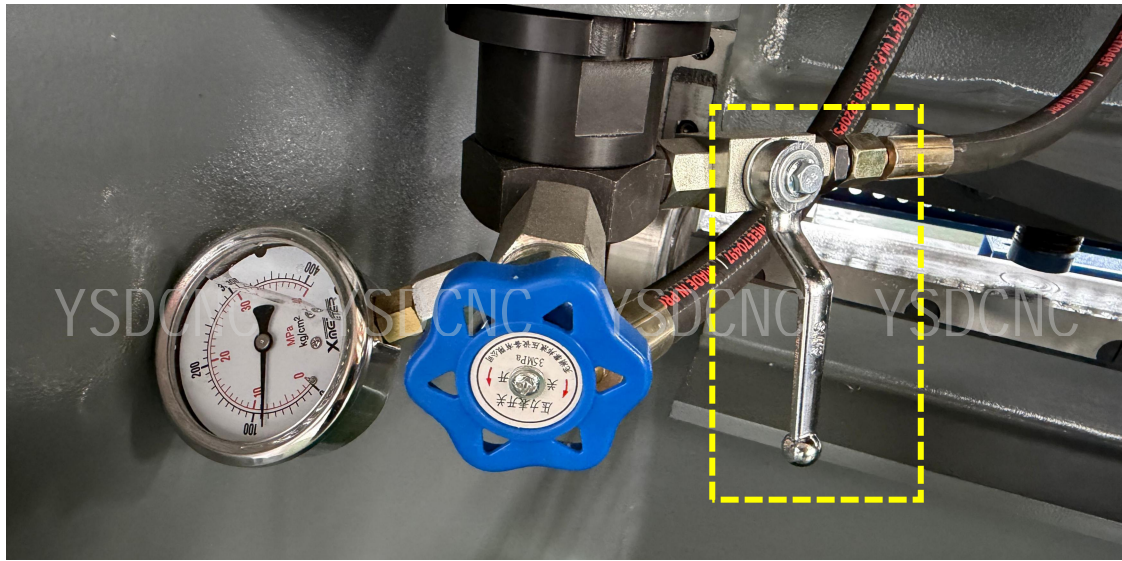
请详细阅读使用说明书和安全操作手册  
 Please read operation manual and safety manual carefully!  
 禁止拆下此标签 FORBIDDEN TO REMOVE THIS LABEL



再按向下键到“G”这一行  
“+”号代表加大间隙  
“-”号代表减小间隙

Press the down arrow key to navigate to the "G" line.

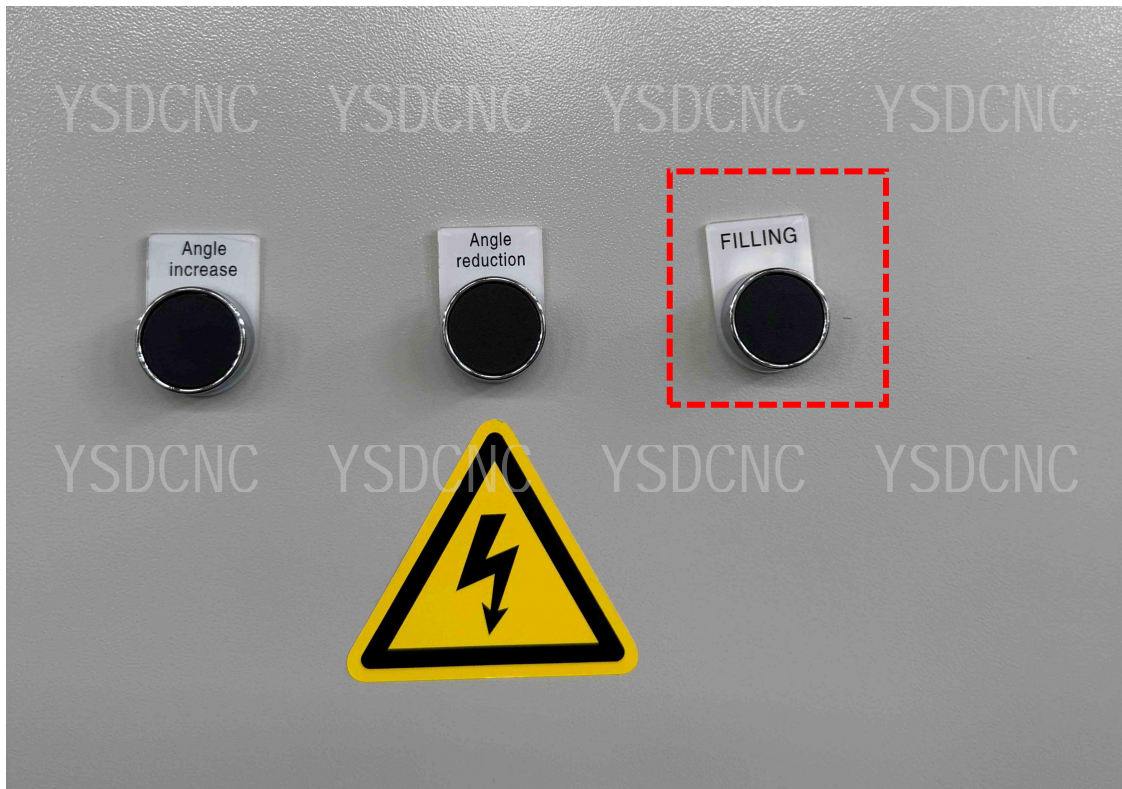
The "+" sign increases the gap, and the "-" sign decreases the gap.



机器长时间使用，刀架会掉下来，怎么让刀架回去？

首先，需要两个人，  
一个负责冲油，一个负责关阀门，  
先把阀门打开，  
然后一个站在那边冲油，  
一个在这边等油压到100的时候，赶紧关阀门。  
(黄色框内为阀门，红色框内为冲油按键)

After prolonged use, the tool holder may fall down.  
How do you get it back in place?



First, you need two people: one to press the oil flushing button and the other to close the valve. Open the valve first.

Then, one person stands there pressing the oil flushing button, while the other waits until the oil pressure reaches 100 and then quickly closes the valve.

(The yellow box indicates the valve, and the red box indicates the oil flushing button)