

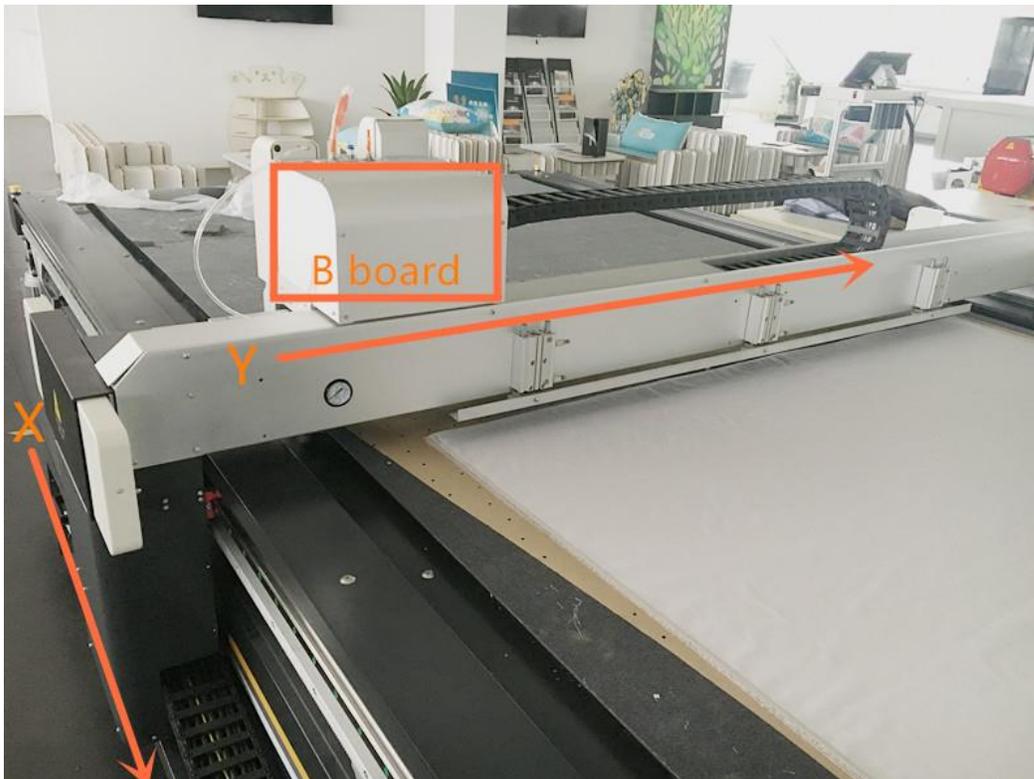
Change punching head to cutting head

Preparations:

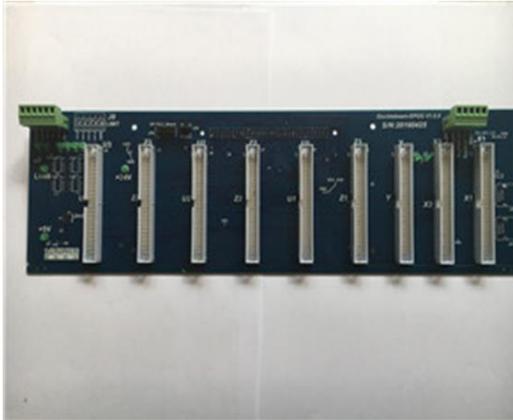
1. Cutting head
2. New DELTA driver for U1 motor
3. Cables : TK3S-19D TK3S-36D TK3S-15P TK3S-02P
4. Common maintenance tools

Operating steps:

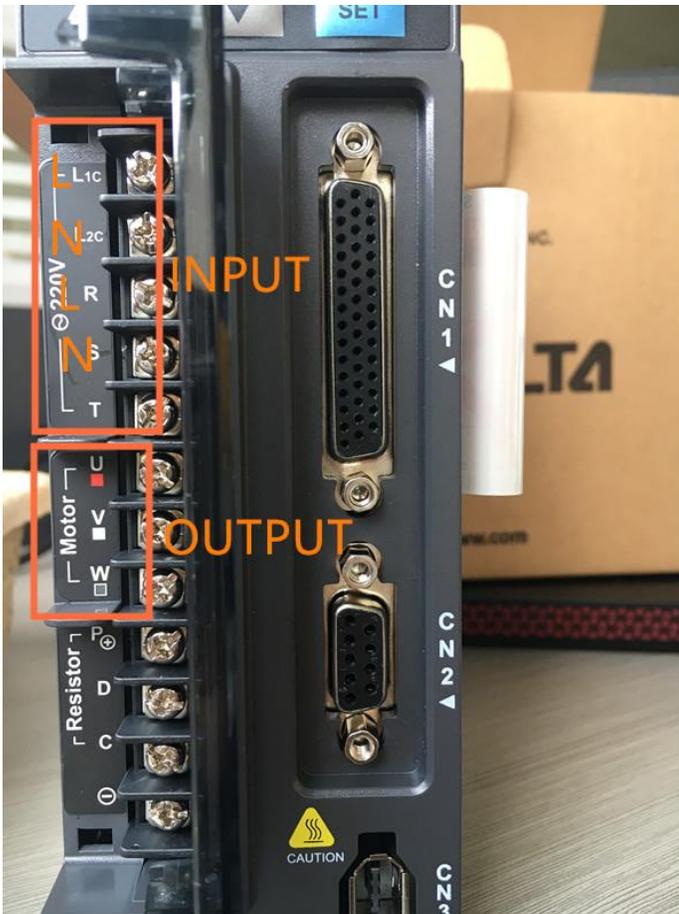
We need change cables from driver to cutting head, it will start from driver, go through X/Y chain then go inside the box behind the cutting head and connect with B board



1. Pull out the electric box, remove the cover and find the EOPS board and Z1 driver.



You can see 'Z1' marked on the top of driver
Remove Z1 output, CN2, GND cables



2. Find a place to fix the new driver, this new driver will be used as U1 driver to control cutting head up and down movement.

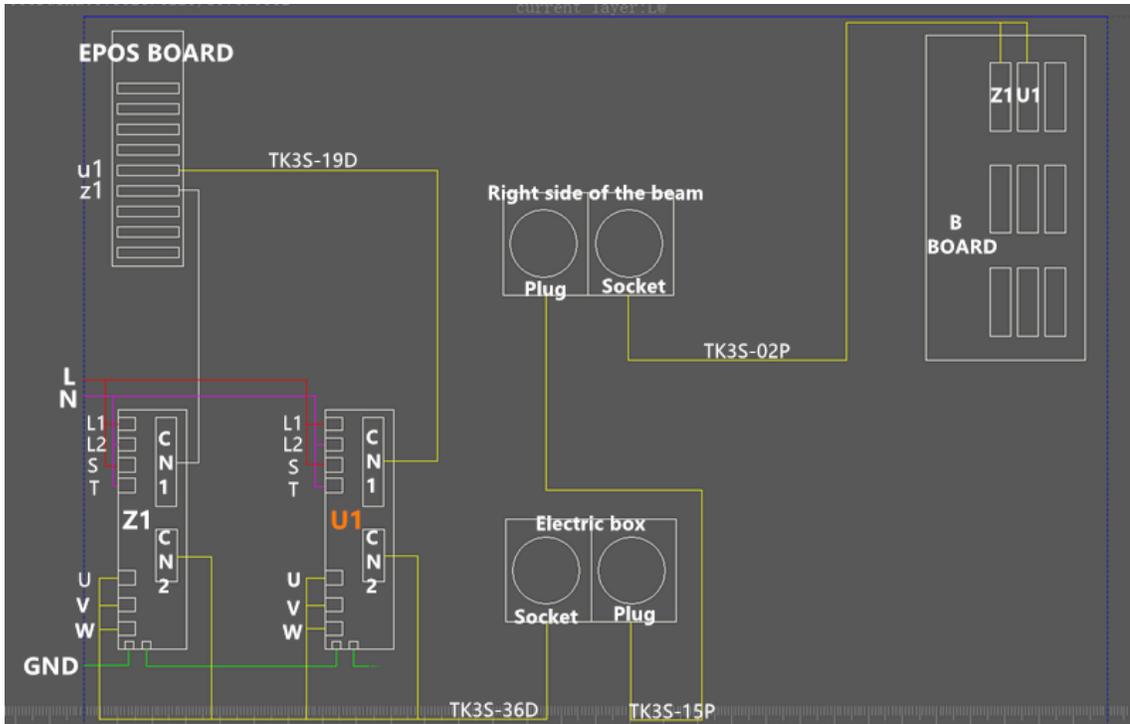
Normally the order of drivers is X1 X2 Y Z1 U1 Z2 U2 Z3 U3. You also can fix it on other place depend on the cables length.

3. Because we removed Z1 and U1 driver cables are go to same socket as head 1 socket, so you need use new cable TK3S-36D to replace the old head1 socket cables.

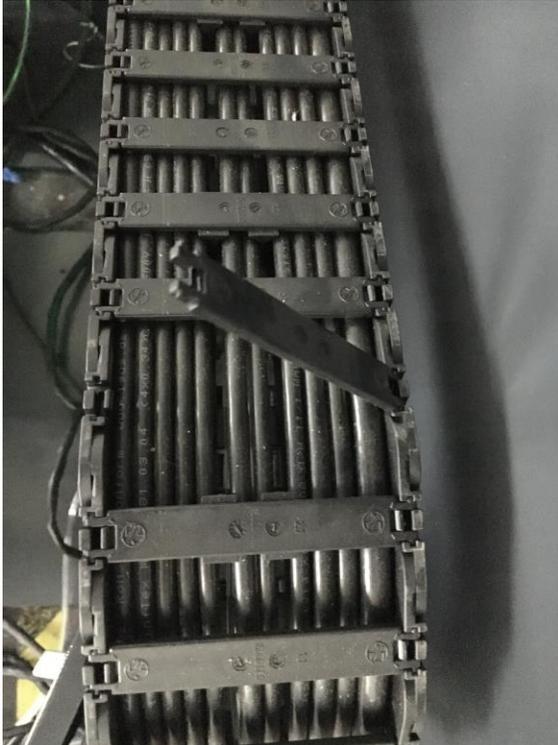
Connect TK3S-19D cables from EPOS board to U1 driver.

Use a cable jump from Z1 driver L1/L2 to U1 driver.

Don't forget connect the GND.



4. Use TK3S-15P cable to replace the old one.
You need open the X chain and put new cable inside and take the old one out.
The chain can be opened on one side.



Open the box which is on the right side of the beam, you'll see many sockets inside. Find the old head1 socket and replace it.



Follow the old cables you can know how to lead the new one goes to right place.

5. Use same ways to connect TK3S-02P on Y direction.

change. Z1 driver was used as punching head, now we change it to cutting head, so we need change Z1 driver parameters.

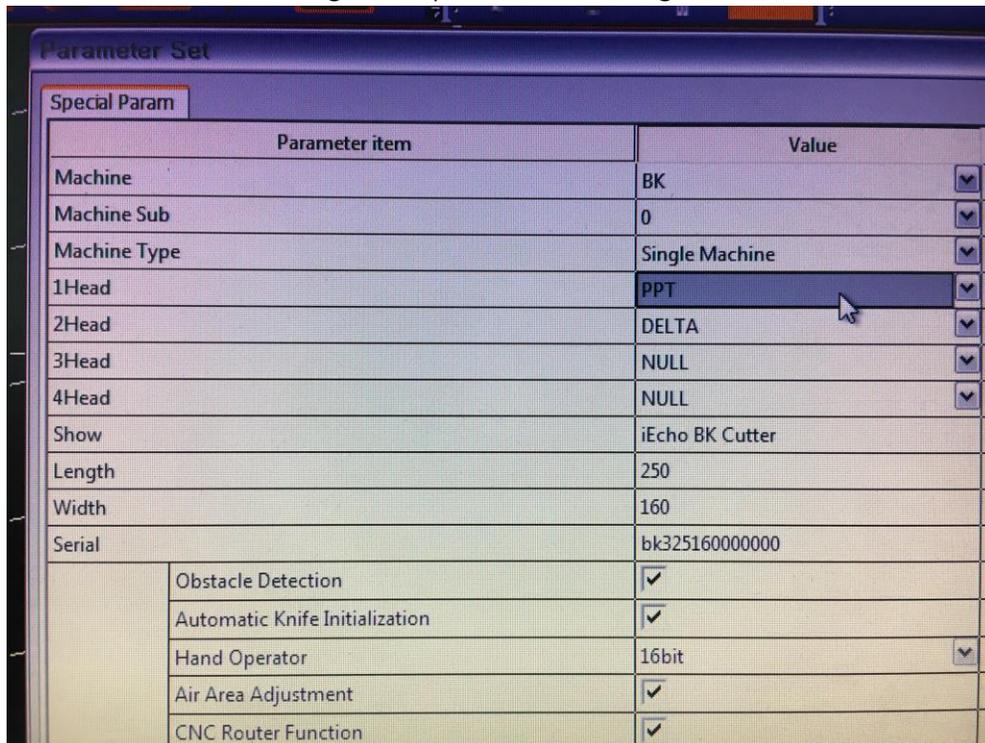
Switch on power, press MODE goes into parameter setting, change p1-44 parameter from 16 to 40, then press SET to save your changing.

7. Change machine setting:

Open Cutterserver and start machine.

Go into cutterserver, because it's first time start machine, so there must has an error in cutterserver, it's normal. After we change the setting, it will be ok.

Press shift+alt+ctrl+M, go into parameter setting



Parameter item	Value
Machine	BK
Machine Sub	0
Machine Type	Single Machine
1Head	PPT
2Head	DELTA
3Head	NULL
4Head	NULL
Show	iEcho BK Cutter
Length	250
Width	160
Serial	bk32516000000
Obstacle Detection	<input checked="" type="checkbox"/>
Automatic Knife Initialization	<input checked="" type="checkbox"/>
Hand Operator	16bit
Air Area Adjustment	<input checked="" type="checkbox"/>
CNC Router Function	<input checked="" type="checkbox"/>

Find head1, change PPT to DELTA.

Apply your changing then restart machine.

8. Set head1 position:

Install a tool (CUT1 OR EOT) on head1, and calibrate its cutting depth.

Put paper on the table and select the red light, move the red dot on the paper, use a pen to mark this position.

Select head1 tool and make it down to touch the paper, check this position if it is same with red light position.

Press alt+shift+ctrl+P,

Material thickness	5.000	mm
The first knife setting depth	5.000	mm
Eccentricity enable	<input checked="" type="checkbox"/>	
Compatible With The Old Version	<input type="checkbox"/>	
Repeated cutting times	0.000	time
Socket1	PUCH1	
Socket	X-axis offset	46.000 mm
	Y-axis offset	-124.800 mm
	A knife and X forward A	90.000 limit
	SP	14
	Tool No	13
	Positive angle of knife a	0.000 limit
	Knife lifting over cut(kn	0.000 mm
	knife setting over cut(K)	0.000 mm
	Knife lifting angel	3000.000 limit

Socket 1 is head 1, change X/Y axis offset, make head1 lift down position same with red light position.

If you set correct, 3 heads will cut in same position.