Additional remarks of Altitude Cruise

This document need read together with "Manual of Altitude Cruise"

Preparatory work：

1. switch on machine and start cutterserver.

2. Press safety device when you move machine, we need an error to change

   machine setting

You can get this error, that's what we need.

3. press "Ctrl+shift+alt+M" on keyboard go into machine setting.

Parameter item	Value	
Machine	BK	⌄
Machine Sub	0	⌄
Machine Type	Single Machine	⌄
1Head	DELTA	⌄
2Head	DELTA	⌄
3Head	NULL	⌄
4Head	NULL	⌄
Show		
Length	250	
Width	170	
Serial	BK320180112256	
Obstacle Detection	✔	
Automatic Knife Initialization	✔	
Hand Operator	24bit	⌄
Air Area Adjustment	☐	
CNC Router Function	✔	
Valve Function	☐	
EOT Fault Fast Response (Pause)	☐	
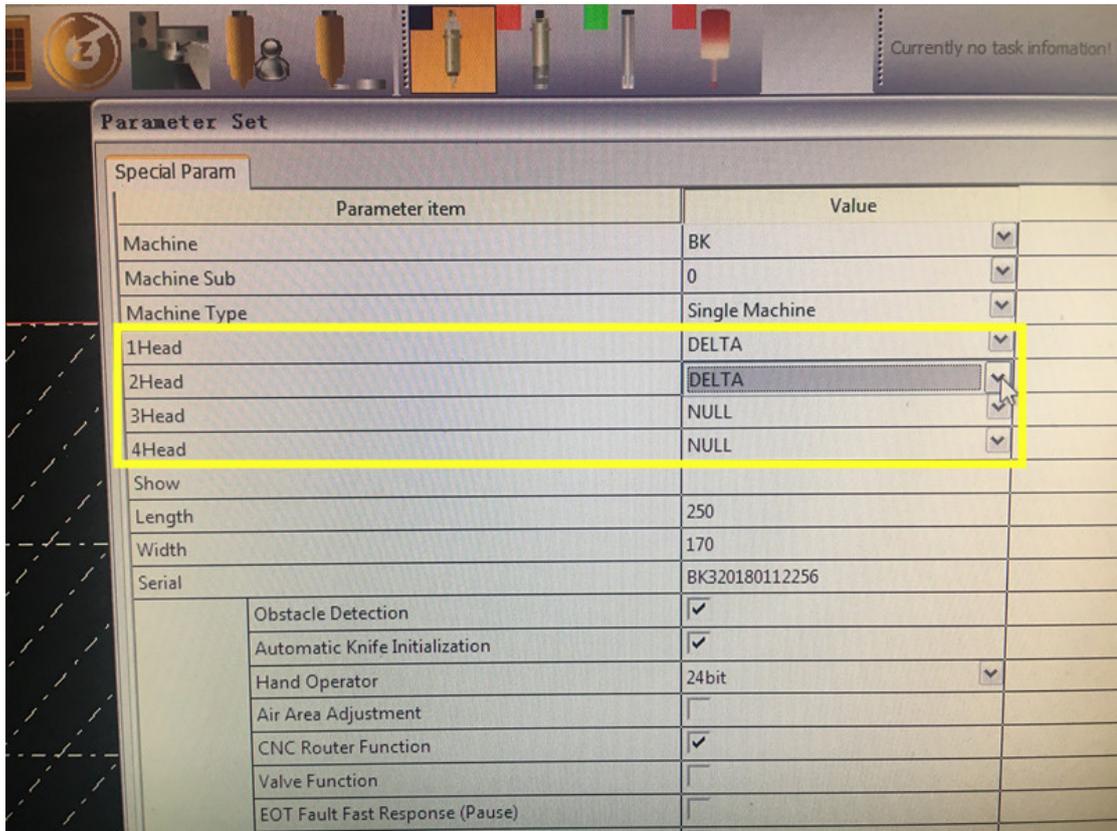
How to set it ?

Ex:

If you removed the second head from machine to install altimeter, you need

set second head to"null".

If your machine doesn't need remove any head you can install altimeter , no

need to change this setting.

Then click apply and switch off machine.

Remove second head ,and install the holder(not altimeter)
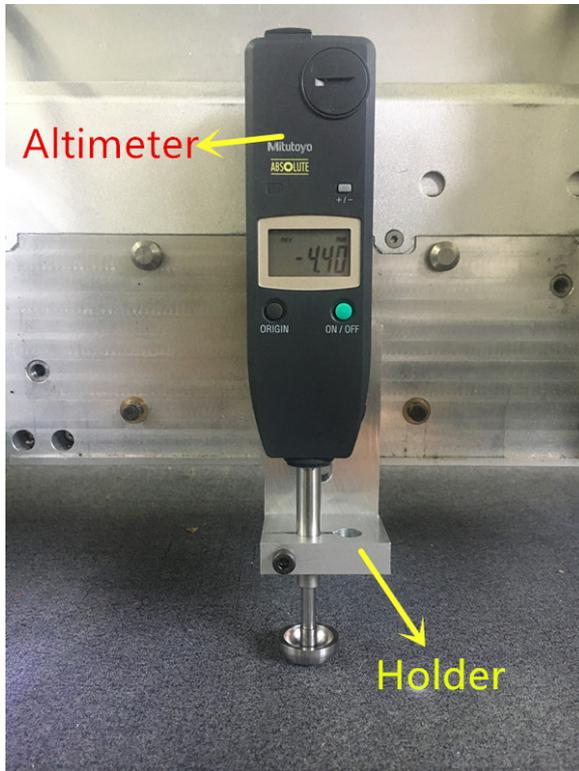
Then switch on machine.And install the altimeter on second head position.

After altimeter installed ,check it if can move up and down easy.

Go into cutterserver, move cutting head to a good position, don't make it too

close the edge of the table.

Open the vacuum, put a paper under the red light, mark the red light point on

the paper.

mark this point
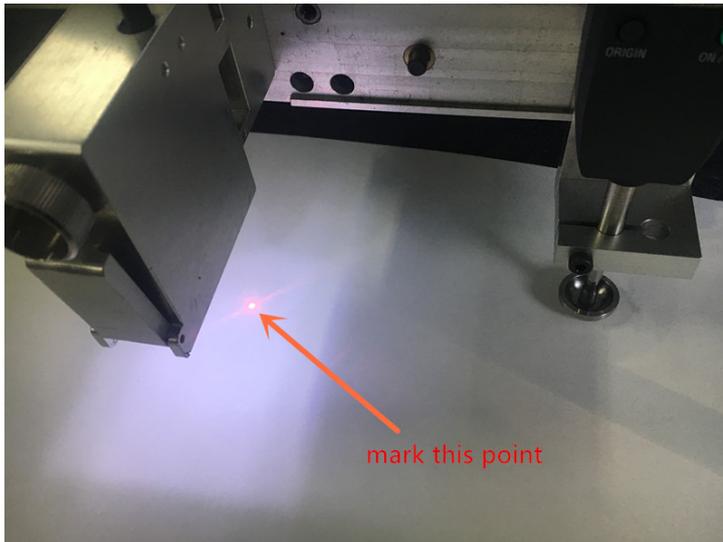
Press "Ctrl+alt+shift+p"

Parameter item		Value	Unit	
Adjustment	Measured length	1000.000	mm	0.000 ~ 2!
	Scheduled length	1000.000	mm	0.000 ~ 2!
Cutting scope	Length	2500.000	mm	0.000 ~ 2!
	Width	1700.000	mm	0.000 ~ 17
Origin coordinates of…	X-axis offset	-112.000	mm	-500.000 -
	Y-axis offset	18.000	mm	-500.000 ~
Pen offset	X offset	0.000	mm	-200.000 ~
	Y offset	0.000	mm	-200.000 ~
Red-light position	X offset	30.700	mm	-200.000 ~
	Y offset	158.000	mm	-200.000 ~
Feeding	Feeding length	2.000	m	-50.000 ~ 5
	Feeding speed.	0.200	m/s	0.050 ~ 0.6(
	Material press time	3.000	s	0.000 ~ 100
Speed	Minimum speed	0.006	m/s	0.001 ~ 0.02
	Cutting speed.	1.000	m/s	0.001 ~ 10.0
	Idling speed	1.000	m/s	0.001 ~ 10.0
	Knife lifting speed	1250.000	mm/s	1.000 ~ 1000
	Knife-lower speed.	1250.000	mm/s	1.000 ~ 1000
	Maximum rotation spee	3000.000	Circles/minute	100.000 ~ 10(

Change this parameter to make altimeter move to the red-light position(before you change this parameter ,you need take a photo of this parameter ,we need change back later after we finish Altitude Cruise)
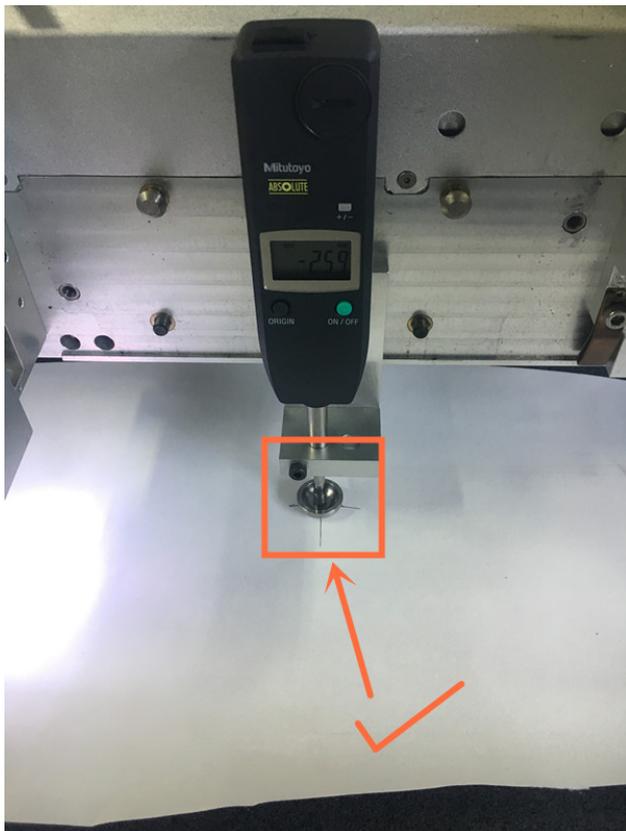
After you done these job, make machine back to original point.

Clean up your felt and table, press "ORIGIN" button make value to 0.00.

Normally, altimeter move up the value is -X.XX ,move down +X.XX, if not ,press

"+/-"button.(Attachment video 3)

4. Connect cables with PC. (Attachment video 1)

5. Check the altimeter communicate with PC is good. (Attachment video2)

6. Go into cutterserver, open vacuum and close cutterserver, keep vacuum
working all the time.

7. Start altitude cruise software.

A:It's will be automatic calculation depend on B and C(after you set B and C value, click OK ,it will be automatic calculation)

B: Frame spacing: to the X-axis, the distance from the first row to the X-axis; to the Y-axis, the distance from the first column to the Y-axis(usually set as 0mm.0mm)

C: Point spacing: for the row: the distance between rows; for the column, the distance between columns (usually set as about 150mm.150mm)

1- Start

2- Input parameters into DSP

3- read parameters from DSP

4- save to the local

5- Input the local values to the DSP board

6- cancel Click this button to end scanning during the process of Altitude Cruise

More details you can read Manual of Altitude Cruise V1.0.0.1