

Introduction of Tool Parameters

Parameter Set

Knife holder/knife tool modification

Parameter item	Value	Unit	Range Of Value
SOCKET2	EOT		
Positive angle of knife and X axis	4.000	limit	-360.000 ~ 360.000
Knife-up compensation	0.000	mm	-100.000 ~ 100.000
Knife-down compensation	0.000	mm	-100.000 ~ 100.000
Knife lifting angel	45.000	limit	0.000 ~ 360.000
X,Y movement speed	0.200	m/s	0.010 ~ 10.000
Knife-lower speed.	200.000	mm/s	0.010 ~ 1000.000
Knife lifting speed	200.000	mm/s	0.010 ~ 1000.000
Movement acceleration	0.150	G	0.010 ~ 10.000
Setting acceleration	0.100	G	0.010 ~ 10.000
The maximum knife setting depth	74.800	mm	0.000 ~ 75.650
Waiting time before setting	10.000	ms	0.010 ~ 10000.000
Waiting time before knife lifting	10.000	ms	0.010 ~ 10000.000
Waiting time after setting	400.000	ms	0.010 ~ 10000.000
Waiting time after knife lifting	10.000	ms	0.010 ~ 10000.000
Direction to rotate	<input checked="" type="checkbox"/>		
The distance between former knife poi	0.000	mm	-20.000 ~ 100.000
The distance between later knife point	0.000	mm	-20.000 ~ 100.000
Eccentricity enable	<input checked="" type="checkbox"/>		
X eccentric distance	0.000	mm	-100.000 ~ 100.000
Y eccentric distance	0.000	mm	-1.270 ~ 1.270
Circle + Angle	0.000	limit	-5.000 ~ 5.000
Circle - Angle	0.000	limit	-5.000 ~ 5.000

Sure Apply(A) Exit(E)

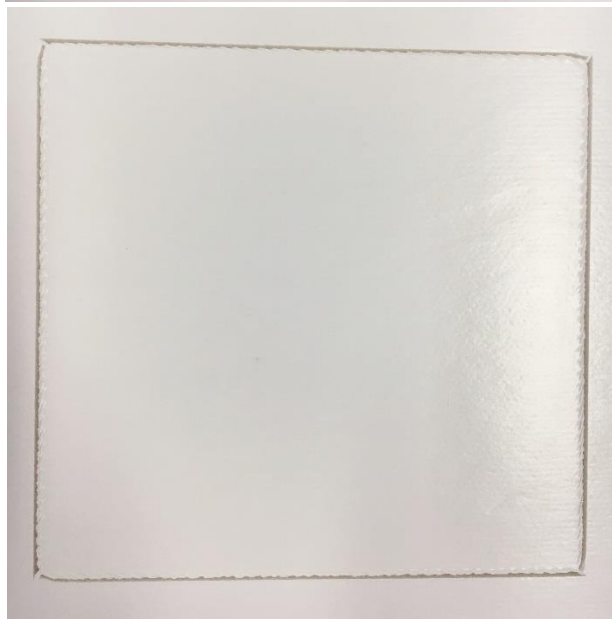
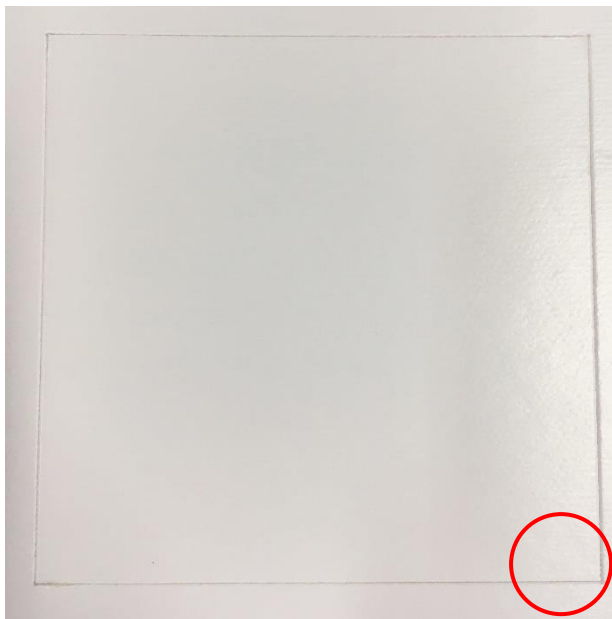
1. Parameter item: Positive angle of Knife and X axis

调整刀片方向与刀片运动方向，使其保持一致。

Direction of blade adjustment and of blade movement should be as the same.

刀角度发生偏移的情况下，材料边缘不光滑，起刀点角度不垂直，调整此参数值。

Adjust this parameter when the blade direction is offset which makes the start cutting point not at the right angle and the cutting edge not smooth.

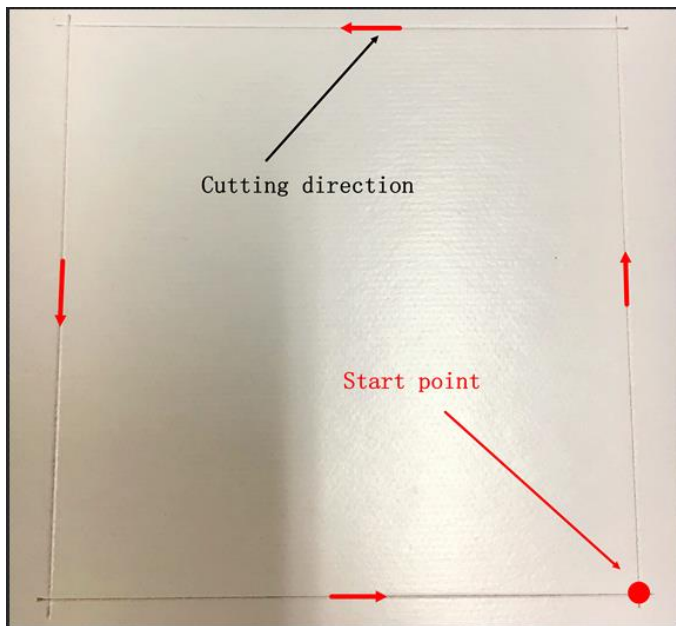


2. Parameter item: Knife-up compensation and Knife-down

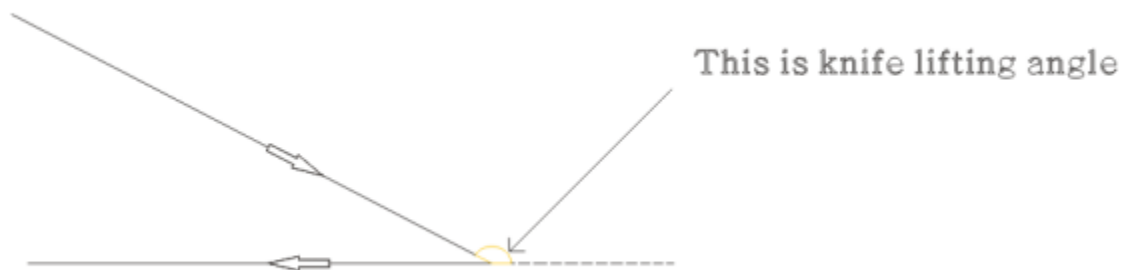
compensation

每一条线段的起点是落刀过切，终点是抬刀过切。数值越大，过切越大，数值可为负值。

At the start cutting point of each cutting line, there is knife-down overcut; and at the end cutting point, there is knife-up overcut. The value is greater the overcut is bigger. The value can be set as negative.



3. Parameter item: Knife lifting angle



当文件转角角度小于设定的抬刀角度，刀切割到这个转角的时候不会抬刀；当角度大于设定的抬刀角度，刀切割到这个转角的时候会先抬刀，然后旋转好方向后，再落刀进行切割。

When the corner in the cutting file is smaller than the set knife lifting angle, the knife won't lift up when cutting this corner; when the corner is larger than the set knife lifting angle, the knife will first lift up when about to cut this corner, and after rotation, the knife lower down to continue cutting.

4. Parameter item: X,Y movement speed

切割速度

Cutting speed

5. Parameter item: Knife-lower speed and Knife lifting speed

刀下落速度，刀抬起速度。

6. Parameter item: Movement acceleration

Cutting acceleration

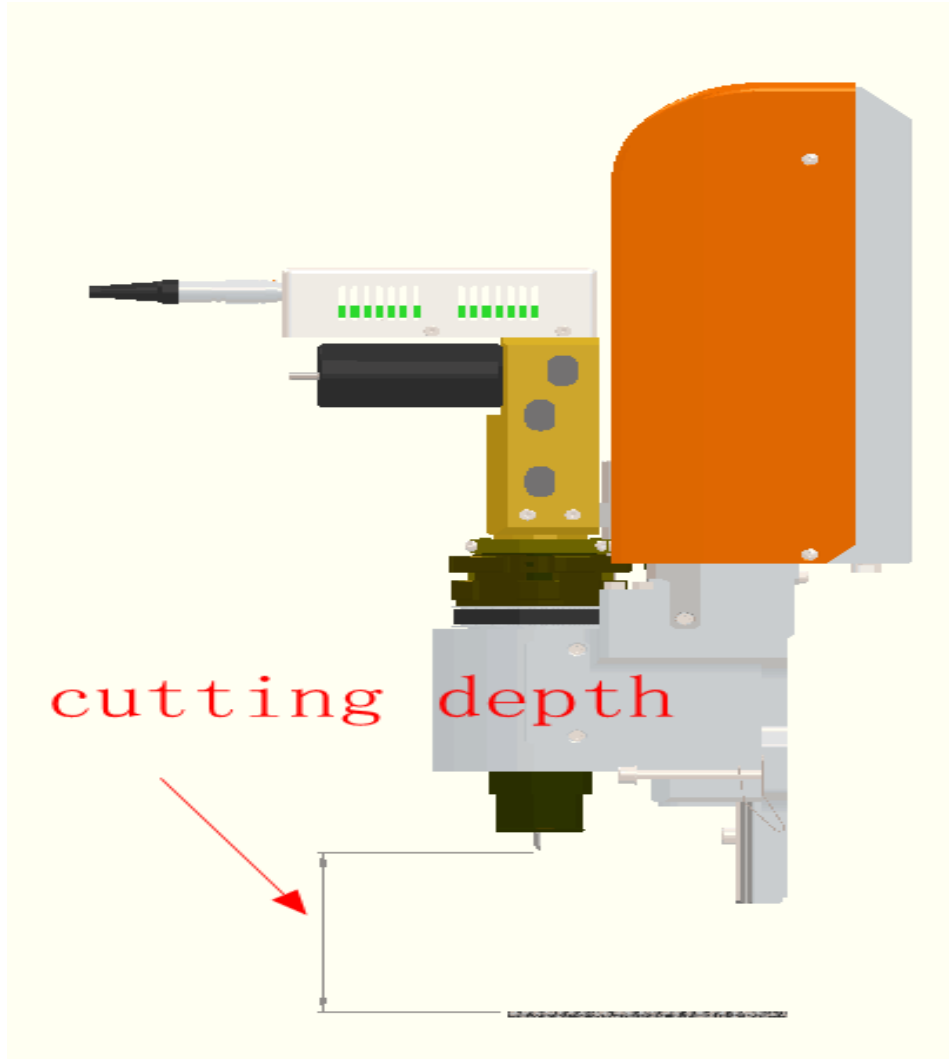
7. Parameter item: Setting acceleration

设置加速度

8. Parameter item: The maximum knife setting depth

从刀尖到毛毡上表面的距离为最大落刀深度。

The maximum knife setting depth is the distance between the nose of tool and the surface of cutting underlay.



9. Parameter item: Waiting time before setting

落刀前等待的时间。

10. Parameter item: Waiting time before knife lifting

抬刀前等待的时间。

11. Parameter item: Waiting time after setting

落刀后等待的时间。

12. Parameter item: Waiting time after knife lifting

抬刀后等待的时间。

13. Parameter item: Direction of rotate

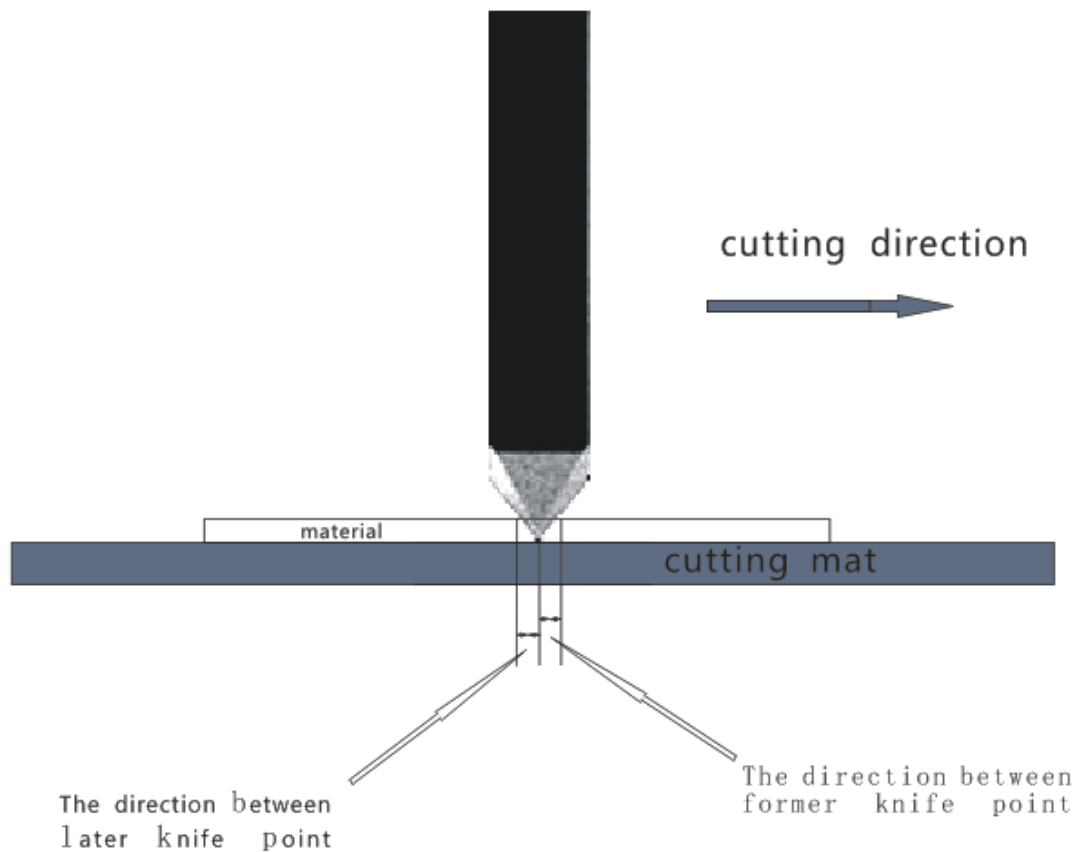
不选择此选项，刀具在切割样片的时候将不会抬刀，此选项只在使用 UDT 和 MILL 的时候可以选择不选择。

Without this, knife won't lift up during cutting; only when using UDT and MILL, it is allowed to not choose this parameter.

14. Parameter item:

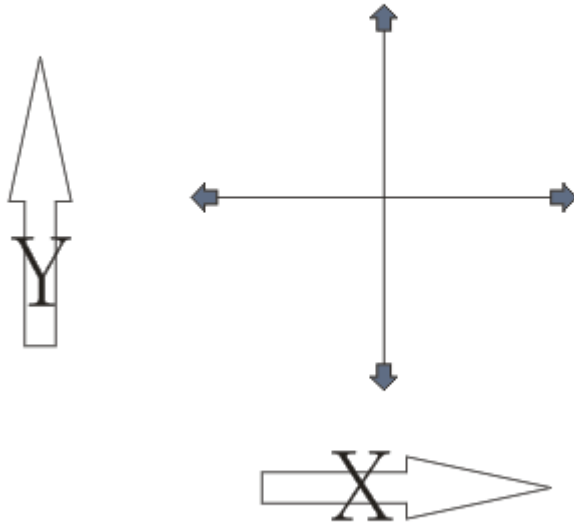
The direction between former knife point

The direction between later knife point



此参数用于切割厚材料时，当切割圆柱形的时候，调节上下表面大小一致。

Adjust this parameter to keep the top and bottom sides with the same size when cutting cylinder on the thick material.

15. Parameter item:**Eccentricity enable****X eccentric distance****Y eccentric distance**

X,Y 方向来回各切一条直线，如果不重合可以调整此参数。

Cut a line to and fro on both X- and Y- axis. Adjust this parameter when the two lines on the same axis not coincide.

16. Parameter item: Circle + angle and Circle - angle

当切割硬度较高的材料时，如圆形接口不重合，可调整此参数，仅硬件圆有效。

Adjust this parameter when cutting hard materials and the start and end

points of cut circle not on the same level. (only applicable for the hardware circle)