Software Interface

INSTRUCTION MANUAL FOR TESTING PK

Note:

- 1. This document is applicable to whom have basic operating knowledge of IECHO machineries.
- 2. This document is version of July 2019, along with software's updates, testing methods will be simplified.

Bit Configuration (C) Heighting Image: Section Configuration (C) Heighting Heighting

CUTTERSERVER interface in PK machines have a collecting material button icon. If cannot find it, press Ctrl+Alt+Shift+C, open function configuration window, add icon.

Function Co	nfiguration	-	_	_	_	_	_	_	x
Commands	Function	Conf	iguration	Other	functional	settings	Knife holder	configuration	
To add a con command ou	mmand to a to It of this dialog	olbar: j box t	select a catego o a toolbar.	ry and dr	rag the				
Categories:		Comm	nan <u>d</u> s:						
Command to	ool bar	0	Start						
I OOIS TOOI D	ar	0	Pause						
		0	Cancel						
			Preview						
		<u>م</u>	Feeding						

Special Parameters

Parameter	Set		x
Special Para	m		
	Parameter item	Value	<u>^</u>
Machine		РК2	
Machine T	ype	Single Machine	
1Head		BYMACHINEHEAD	
2Head		BYMACHINEHEAD	E
3Head		BYMACHINEHEAD	
4Head		BYMACHINEHEAD	
Length		60	
Width		40	
Serial		PK06041905075	
	Obstacle Detection		ĺ
	Automatic Knife Initialization		ĺ
	Hand Operator	16bit	
	Air Area Adjustment		
	CNC Router Function		
	Valve Function		
	EOT Fault Fast Response (Pause)		
LAIC	CNC Router Fault Fast Response (Pause)		
[A]Com	C Board		
	X Axle(Only Custom Model is Valid)		
	Y Axle(Only Custom Model is Valid)		
	7 Ayla(Only Custom Madal is Valid)		1-
	Import(I) Su	Cancel	

Machine model choose PK2, machine heads are 4, set all type to BYMACHINEHEAD

Socket 1 is TW 1 Socket 2 is CREASE Socket 3 is EOT Socket 4 is TW 2

Correspondence of sockets and tools is fixed. Machines without EOT can remove socket 3 icon in function configuration window.

Machine origin and socket offset

The machine does not have red dot, can set both coordinate of socket 1 and red dot to (0,0), adjust offset of other sockets referring socket 1.

First have to check machine origin, when socket 1 is activated, by changing origin parameter of the machine, set socket 1 in the corner of the table, move the machine head and observe moving range of socket 1, make sure cutting area of socket 1 is inside 600*400 and centered.

Parameter Set Parameter Set * Parameter item Value Unit Range Of Value TUWEN1BLADE Socket1 X-axis offset 0.000 mm -200.000 ~ 1000.000 Y-axis offset 0.000 mm -200.000 ~ 1000.000 Socket A knife and X forwar 0.000 limit -360.000 ~ 360.000 Knife initialization he -0.000 mm -50.000 ~ 200.000 Ŧ Control mode 7 SP 51 ΒN 25 Knife diameter 0.000 mm 0.000 ~ 100.000 Positive angle of knil 0.000 limit -360.000 ~ 360.000 Knife lifting over cut(-0.100 mm -30.000 ~ 30.000 -30.000 ~ 30.000 knife setting over cu 0.300 mm Knife lifting angle 180.000 limit 0.000 ~ 360.000 X eccentric distance 0.350 -100.000 ~ 100.000 mm Y eccentric distance 0.000 -1.270 ~ 1.270 mm X,Y movement speed 1.300 0.010 ~ 1.500 m/s Knife-lower speed. 0.010 ~ 1000.000 3.750 mm/s 0.010 ~ 1000.000 Tool parameters Knife lifting speed 3.750 mm/s G 0.010 ~ 1.500 Movement accelerat 1.000 0.010 ~ 1.500 0.025 G Setting acceleration The maximum knife 5 000 0.000 -. 1.940 -----Read(R) Save(local)(S) Import(I) Apply(A) Exit(E)

Following socket offset configuration method, adjust respectively for socket 2,3,4 offset in relative to socket 1, by selecting socket and modify X and Y axis offset value.

TUWEN blade configuration

Parameter Set		_		x
Knife holder/knife tool modification				
Parameter item	Value	Unit	Range Of Value	<u>^</u>
SOCKET1	TUWEN1BLADE			
Positive angle of knife and X axis	0.000	limit	-360.000 ~ 360.000	
Knife-up compensation	-0.100	mm	-30.000 ~ 30.000	
Knife-down compensation	0.300	mm	-30.000 ~ 30.000	
Knife lifting angle	180.000	limit	0.000 ~ 360.000	
X,Y movement speed	1.300	m/s	0.010 ~ 1.500	
Knife-lower speed.	3.750	mm/s	0.010 ~ 1000.000	
Knife lifting speed	3.750	mm/s	0.010 ~ 1000.000	
Movement acceleration	1.000	G	0.010 ~ 1.500	
Setting acceleration	0.025	G	0.010 ~ 1.500	
The maximum knife setting depth	5.000	mm	0.000 ~ 1.840	
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	10.000	ms	0.010 ~ 10000.000	
Waiting time after knife lifting	10.000	ms	0.010 ~ 10000.000	
Direction to rotate	 Image: A start of the start of			
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]
X eccentric distance	0.350	mm	-100.000 ~ 100.000]
V accontria distance	0.000		1 270 - 1 270] -
Sure	Apply(<u>A</u>)	Exit(<u>E)</u>		

Parameter Set				x
Knife holder/knife tool modification				
Parameter item	Value	Unit	Range Of Value	^
Knife-lower speed.	3.750	mm/s	0.010 ~ 1000.000	
Knife lifting speed	3.750	mm/s	0.010 ~ 1000.000	
Movement acceleration	1.000	G	0.010 ~ 1.500]
Setting acceleration	0.025	G	0.010 ~ 1.500]
The maximum knife setting depth	5.000	mm	0.000 ~ 1.840	
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	10.000	ms	0.010 ~ 10000.000	
Waiting time after knife lifting	10.000	ms	0.010 ~ 10000.000	
Direction to rotate				
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				
X eccentric distance	0.350	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	
Down tool mode	PWY mode 💌			
High Time	80.000	ms	5.000 ~ 128.000	
Pressure keep	1	level		
Sure	Apply(<u>A</u>)	Exit(E)		-

Three new parameters added for Tuwen blade:

Down tool mode: set to PWM mode.

High time: full power working time of electromagnet when down tool starts. Pressure keep: tool pressure when is down, there are 5 levels, level 1 is the lowest.

An important parameter of Tuwen blade X eccentric distance: for 1.5 blade normally set to 0.8

For Tuwen blade there is not knife setting depth, to cut materials of different thickness, need to adjust blade length and pressure. Blade length need to be adjusted manually, by rotating knife cap to adjust knife length exposed. Change pressure by setting "pressure keep" parameter.

Creasing tool configuration

Except parameters of knife setting depth, knife lower speed and acceleration are not working, the rest are same as BK,TK machines.

Creasing tool depth adjustment:

Rotate manually knob on the head, clockwise to lift, anti-clockwise to lower. To check knife lower height can operate on software, let it down to observe. When changing different thickness of materials, adjust depth relatively.

Creasing tool pressure adjustment:

Adjust manually pressure regulator, normally no more than 0.4MPa

Oscillating tool configuration

Except parameters of knife setting depth, knife lower speed and acceleration are not working, the rest are same as BK,TK machines.

Note normally oscillating tool on PK model, X eccentric value should be set to 2 theoretically.

Oscillating tool depth adjustment:

Rotate manually knob on the head, clockwise to lift, anti-clockwise to lower. Can push knob to let blade down, to observe down depth.

Oscillating tool pressing plate pressure adjustment:

Adjust manually pressure regulator, normally no more than 0.4MPa

Oscillating tool blade changing:

Turn off the machine, move machine head to side, rotate oscillating tool to appropriate angle to loose screw. Install new blade following picture shown below. Pay attention to install blade in proper direction.



Parameters related to PK

Parameter Set				
Parameter Set				
Parameter item		Value	Unit	Range Of Value
Adjustment	Measured length	1000.000	mm	0.000 ~ 60000.000
Aujustment	Scheduled length	1000.000	mm	0.000 ~ 60000.000
C.#	Length	600.000	mm	0.000 ~ 600.000
Cutting scope	Width	400.000	mm	0.000 ~ 400.000
	X-axis offset	150.000	mm	-500.000 ~ 600.000
Origin coordinates	Y-axis offset	45.000	mm	-500.000 ~ 400.000
Day offerst	X offset	0.000	mm	-200.000 ~ 1000.000
Pen offset	Y offset	0.000	mm	-200.000 ~ 1000.000
De la la companya de	X offset	0.000	mm	-200.000 ~ 1000.000
Red-light position	Y offset	0.000	mm	-200.000 ~ 1000.000
	X offset	5.000	mm	-200.000 ~ 1000.000
Camera	Y offset	5.000	mm	-200.000 ~ 1000.000
	Height	0.000	mm	0.000 ~ 300.000
	Feeding length	0.800	m	-50.000 ~ 50.000
Feeding	Feeding speed.	0.600	m/s	0.050 ~ 0.600
	Material press time	3.000	s	0.000 ~ 100.000
	Minimum speed	0.006	m/s	0.001 ~ 0.020
	Cutting speed.	0.500	m/s	0.010 ~ 1.500
	Idling speed	0.500	m/s	0.010 ~ 1.500
Speed	Knife lifting speed	1000.000	mm/s	1.000 ~ 10000.000
	Knife lower chood	1.000.000		1 000 - 10000 000

Parameter Set				
Parameter Set				
Parameter item		Value	Unit	Range Of Value
	Overall knife-down s	0.255	m/s	0.010 ~ 0.255
	Cutting acceleration	0.500	G	0.010 ~ 1.500
Annalanation	Empty walking accel	0.500	G	Range Of Value 0.010 ~ 0.255 0.010 ~ 1.500 0.001 ~ 1.500 0.001 ~ 1.500 0.001 ~ 1.500 0.000 ~ 1000.000 1.000 ~ 1000.000 0.000 ~ 50.000 0.000 ~ 50.000 0.000 ~ 50.000 1.000 ~ 100.000 1.000 ~ 100.000 1.000 ~ 400.000 -200.000 ~ 1000.000 -200.000 ~ 1000.000 -360.000 ~ 360.000
Acceleration	Centripetal accelerat	0.200	Unit Range Of Value m/s 0.010 ~ 0.255 G 0.010 ~ 1.500 G 0.010 ~ 1.500 G 0.001 ~ 3.000 G 0.001 ~ 3.000 Circles/s2 1.000 ~ 1000.000 Piece	
	Rotation acceleration	1500.000	Circles/s2	1.000 ~ 1000.000
Cutting mode	·	High-speed cuttin 💌		
Damping mode		No damping 💌		
A circle pulse numb	er	20000.000	Piece	
Flat knife cross qua	ntity	3.000	mm	-50.000 ~ 50.000
Rotating knife laps		0.000	Laps	0.000 ~ 90.000
Absorption in delay	time	0.000	s	0.000 ~ 5.100
Material thickness		30.000	mm	1.000 ~ 100.000
Reduction boundary	/	50.000	mm	1.000 ~ 300.000
The first knife settin	g depth	3.000	mm	1.000 ~ 400.000
Eccentricity enable				
Repeated cutting tir	nes	0.000	times	
Socket1	•	TUWEN1BLADE		
	X-axis offset	0.000	mm	-200.000 ~ 1000.000
	Y-axis offset	0.000	mm	-200.000 ~ 1000.000
Socket	A knife and X forwar	0.000	limit	-360.000 ~ 360.000
	Knife initialization be	0.000		50.000 200.000

Parameter Set					X
Parameter item		Value	Unit	Range Of Value	*
Socket1	•	TUWEN1BLADE			
	X-axis offset	0.000	mm	-200.000 ~ 1000.000	1
	Y-axis offset	0.000	mm	-200.000 ~ 1000.000	
Socket	A knife and X forwar	0.000	limit	-360.000 ~ 360.000	
	Knife initialization he	-0.000	mm	-50.000 ~ 200.000	
	Control mode	7 💌			
	SP	51			
	BN	25			
	Knife diameter	0.000	mm	0.000 ~ 100.000	
	Positive angle of knit	0.000	limit	-360.000 ~ 360.000	7
	Knife lifting over cut(-0.100	mm	-30.000 ~ 30.000	
	knife setting over cu	0.300	mm	-30.000 ~ 30.000	
	Knife lifting angle	180.000	limit	0.000 ~ 360.000	
	X eccentric distance	0.350	mm	-100.000 ~ 100.000	
	Y eccentric distance	0.000	mm	-1.270 ~ 1.270	E
	X,Y movement speed	1.300	m/s	0.010 ~ 1.500	
	Knife-lower speed.	3.750	mm/s	0.010 ~ 1000.000	
Tool parameters	Knife lifting speed	3.750	mm/s	0.010 ~ 1000.000	
	Movement accelerat	1.000	G	0.010 ~ 1.500	
	Setting acceleration	0.025	G	0.010 ~ 1.500	
	The maximum knife	5.000		0.000 - 1.940	T T
Read(R)	Save(local)(<u>S</u>)	Import(I)	Apply(A)	Exit(E)	

Expand parameter

Parameter Set				x
Expand Param				
Parameter item	Value	Unit	Range Of Value	^
Servo uses 485 communication				
485 master slave setup	main 💻			
Feed suspension is allowed to	No cancellation allowed.			
Pressing cylinder Waiting lift tir	0.000	ms	0.000 ~ 12750.000	
The cylinder is lifted first and th	First blow off and then lift th			
Minimum width of cutter (indica	0.000	mm	0.000 ~ 25.500	
No switching to red light.				
Fine tuning value of broken kni	0.000	mm	0.000 ~ 0.255	
Tool1 lead setting	2mm lead of tool1			
Tool2 lead setting	2mm lead of tool2			
Tool3 lead setting	2mm lead of tool3			
Tool4 lead setting	2mm lead of tool4			
Servo uses 485 communication	All motors use MODBUS ex			
Wheel Cutter height compensa	0.000	mm	0.000 ~ 2.560	
PK2 press waiting time	1.000	s	0.000 ~ 1000.000	
PK2 press lift time	1.000	s	0.000 ~ 1000.000	
PK2 receiving time	1.000	s	0.000 ~ 1000.000	
PK2 feeding docking point	790.000	mm	0.000 ~ 65538.000	=
PK2 back distance	5.000	mm	0.000 ~ 255.000	
Manual movement speed	0.000	m/s	0.020 ~ 0.500	
Sure	Cancel	Exit(E)		•

PK2 press waiting time: waiting time after suction cylinder lower down

PK2 press lift time: beam's waiting time after suction cylinder lift up.

PK2 receiving time: material collecting motor's working time when material collecting starts.

PK2 feeding docking point: while feeding, position which beam will move to (position where suction cylinder takes the material).

PK2 back distance: After suction cylinder lift up, distance of the material pushed back. This function is for separating materials. Set to 0 for disable the function.

Parameter Set				x
Expand Param				
Parameter item	Value	Unit	Range Of Value	*
Compressor Pressure Ratio	0.000		0.000 ~ 2.550	
FZ Auxiliary Plate Model	GLK 👤			
Vacuum Pressure start time	0.000	s	0.000 ~ 25.500	
FZ1 Board Warning Lights Flash				
The percentage of the upper li	0.000		0.000 ~ 100.000]
Automatic Knife Initialization	Mobile point finding]
Grinding Compensation Angle	0.000	degrees	0.000 ~ 360.000	
V-notch Compensation	0.000	mm	0.000 ~ 2.550	
Grinding Indent	0.000	micrometer	0.000 ~ 255.000	
Use PN Feeding Length	 ✓ 			
After Over Window Wait Time	0.000	s	0.000 ~ 127.000	E
before Over Window Wait Time	0.000	s	0.000 ~ 127.000	
Is PT3 rotate				
PT3 rotate speed	0.000	rev/s	0.000 ~ 255.000	
Splint 1 High 1	0.000	mm	0.000 ~ 655.000	
Splint 2 High 1	0.000	mm	0.000 ~ 655.000	
Head 1 High origin	0.000	mm	0.000 ~ 655.000	
Head 2 High origin	0.000	mm	0.000 ~ 655.000	
Head 3 High origin	0.000	mm	0.000 ~ 655.000	
Splint 1 Rotate 1 Adjust Value	0.000	degrees	-12.800 ~ 12.700	
C PLODING AND INC.	0.000		10.000 10.700] -
Sure	Cancel	Exit(E)		

Camera configuration

IBrightCut Settings >> Hardware configuration, settings as per pictures below.

noi	Tools	View	Setti	ngs	Explain			1		
-		0	-	Opt	tions			45	45	50
				Har	dware co	nfiguration				
				Def	Fault tool of	olor				
t:1 rdi	UCIII	. 202	-	CCI	D settings					
TUT		.002.		Aut	to Oparati	on Setting				
198				Bar	Code Set	ting				
				Sta	rt CutterS	erver				
option	n	_	_	_	_		_	_	_	
Hard	ware									
Visua	I Setting	Mo	del			PK				
			Marks			USB Came	ra	•		
			Camera	name	•	USB2.0 Car	mera	•	C	
						Deta				
			Image			D610		•		
			Materia	thick	ness measu	ring device				
							_			
						确定		取消		应用(A)

option	
Hardware	Visual mode
Visual Setting	
	© iKnow+CCD
	© iPicture
	© ACC
	确定 取消 应用(A)

Then click update button as shown in picture to update camera list.

option			
Hardware Visual Setting	Model	РК	
	Marks	USB Camera	
	IBrightCutSettin	a list updated	
	M	ОК	
		OK Cancel Apply	

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Options	
parameter Config	
Unit value	
🔘 nm	View background Black
) cm	View Scale 1 🚖
() m	Trajectory simulation speed
Inch	Slow Fast
Foot	☑ Hardware circle:
) Default unit	The original 💌 around circl 💌
Scale 1	CCD Max page length 2500 mm
	MergeLine Threshold 0.1 mm
PLT pretreatment	Match rule Data Color 💌
🔽 Arc Optimize	Visual Mode
	Save Exit

Camera offset adjustment

(1) Create layer

Click 👎 📑 🔍 create a new layer, double click on this layer, set layer

configuration as TW and choose TW1 tool, click 'save'

🔲 Layer properties		_	×
Method	TW TW1	•	ET10 •
Layer name	New layer	1	Û
Layer color	-	1	
Line type	Solid line		
Cutting mode	Standard 💌		l l
General Advance	d		
Bleeding value	0 mm		
Cutting speed	0 m/s	Cutting acceleration	Level0(Min.) ×
		Cor	firm Cancel

Click MORE in output settings, and do not select any feature in this interface

Bar Code		
Material box	Setting of automatic operation of CCD.	J
Lay New layer	Move cutting head to the specified point before task starts X: 100.00 Y: 100.00 Get Coordinates	•
	🔲 End page's automat	
	Dpen vacuum pump before task starts	
	Turn off vacuum pump when task is completed	
Output setti	🗌 Vacuum area control	
Repeated	Setting vacuum area according to cutting area	
Cut time Page set	O Instant open vaccum area when cutting	m
Number X Distance	Save	m
OutputMod	e Manual start 💌 More	

(2) Press Shift+Ctrl+Alt+P keys. Set red-light position coordinates as (0,0)mm.

Parameter Set				
Parameter item	1	Value	Unit	Range Of Value
	Measured length	1000.000	mm	0.000 ~ 60000.000
Adjustment	Scheduled length	1000.000	mm	0.000 ~ 60000.000
C. H	Length	600.000	mm	0.000 ~ 2500.000
Cutting scope	Width	400.000	mm	0.000 ~ 1600.000
	X-axis offset	150.000	mm	-500.000 ~ 2500.000
Origin coordinate	Y-axis offset	45.000	mm	-500.000 ~ 1600.000
D (()	X offset	0.000	mm	-200.000 ~ 1000.000
Pen offset	Y offset	0.000	mm	-200.000 ~ 1000.000
Ded Kale and Star	X offset	0	mm	-200.000 ~ 1000.000
Red-light position	Y offset	0	mm	-200.000 ~ 1000.000
	X offset	5.000	mm	-200.000 ~ 1000.000
Camera	Y offset	5.000	mm	-200.000 ~ 1000.000
	Height	0.000	mm	0.000 ~ 300.000
	Feeding length	0.745	m	-50.000 ~ 50.000
Feeding	Feeding speed.	0.600	m/s	0.050 ~ 0.600
	Material press time	3.000	s	0.000 ~ 100.000
	Minimum speed	0.006	m/s	0.001 ~ 0.020
	Cutting speed.	0.800	m/s	0.010 ~ 1.500
	Idling speed	0.800	m/s	0.010 ~ 1.500
Speed	Knife lifting speed	-1.#QO	mm/s	1.000 ~ 10000.000
I	Knife lower speed	1 #00	mm/c	1 000 10000 000
Read(R)	Save(local)(S)	Import(I)	Apply(<u>A</u>)	Exit(E)

(3) Draw a 100x100mm rectangle at coordinate (200,200)mm



will send the cutting date to CutterServer.

CutterServer will make machine cut 100x100mm rectangle in coordinate

- (200,200)mm.
- (4) Open CCD

Click on CCD, there will be a CCD configuration setting panel shown as below.

	Effect					
0-65	1 mail		的主要	22.72		an nor
2.7.		1.1	n star .		1 2 4	M to.
		4.带出书	中气情的	HERE	11-1-1	142
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	and a second second	1107104 3018 20	12 12 12 19 11	CONTRACTOR:	115 1 - 2	1.463(1)???
	Sec. Sec.		10.00	10000	Sec. Sec.	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
197						$\frac{1}{2}$
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Cold	or coord	ination	۲		•	•
Cold	or coord	ination	۲		۲	•
Cold	or coord Coordir	ination nates	۲		۲	•
Cold Current	or coord Coordir	ination nates	() S	elect s	© setting	•
Cold Current Point	or coord Coordir Coord	ination nates di	S	elect s	© setting	•
Cold Current Point X1 V1	or coord Coordin Coord	ination nates di	s	elect s	©.	•
Current Point X1 Y1 X2	or coord Coordir Coord	ination nates di	S I I	elect s	setting	•
Current Point X1 Y1 X2 Y2	or coord Coordir Coord	ination nates di	S I I	elect s	© setting	•
Current Point X1 Y1 X2 Y2	or coord Coordir Coord	ination nates di	S I I	elect s	setting ata:	•
Cold Current Point X1 Y1 X2 Y2	Coordir Coord	ination nates di	S I I I	elect s	setting ata:	•

(5) Set offset

Make sure the center cross mark coincides with rectangle corner (200,200).

ommon	Effect			
			6	
			\nearrow	
Col	or coordir	nation	•	۲

click on 'get the coordinate' then get present coordinate (X1,Y1), right click on X1 or Y1, Set the X\Y offset choose [set x/y offset] from the dialog box,



then input 200 in both [X offset] and [Y offset],

🖪 X/Y Offset		x
X Offset	200 Y Offset	200
	ОК С	ancel

then click OK to save the parameter.

(6) fill in coordinates

The software prompts for new coordinate



Fill coordinate in Red-light position

Parameter item		Value	Unit	Range Of Value
	Measured length	1000.000	mm	0.000 ~ 60000.000
Adjustment	Scheduled length	1000.000	mm	0.000 ~ 60000.000
e	Length	600.000	mm	0.000 ~ 2500.000
Cutting scope	Width	400.000	mm	0.000 ~ 1600.000
	X-axis offset	150.000	mm	-500.000 ~ 2500.000
Origin coordinates	Y-axis offset	45.000	mm	-500.000 ~ 1600.000
D (()	X offset	0.000	mm	-200.000 ~ 1000.000
Pen offset	Y offset	0.000	mm	-200.000 ~ 1000.000
Red light perities	X offset	68.89	mm	-200.000 ~ 1000.000
Red-light position	Y offset	43.59	mm	-200.000 ~ 1000.000
	X offset	5.000	mm	-200.000 ~ 1000.000
Camera	Y offset	5.000	mm	-200.000 ~ 1000.000
	Height	0.000	mm	0.000 ~ 300.000
	Feeding length	0.745	m	-50.000 ~ 50.000
Feeding	Feeding speed.	0.600	m/s	0.050 ~ 0.600
	Material press time	3.000	s	0.000 ~ 100.000
	Minimum speed	0.006	m/s	0.001 ~ 0.020
	Cutting speed.	0.800	m/s	0.010 ~ 1.500
	Idling speed	0.800	m/s	0.010 ~ 1.500
Speed	Knife lifting speed	-1.#QO	mm/s	1.000 ~ 10000.000
	Kaife lower coord	1 #00	mmle	1 000 10000 000

Note: Generally, X,Y offset only need to be set for the first time and should set again when install new software, uninstall the camera or head.

Automatic continuous cutting

1. Open file, set layers.



3. Set cut times, output mode set to Direct cutting, feed mode set to Sheet automatic feed.

() iECHO	РК	Testing Manual
	Output settings:	
	Repeated Cutting Setting	
	Cut times 0 Distance 0	mm
	Page settings	
	Number X 1 Number Y 1	
	Distance X O mm Distance Y O	mm
	OutputMode Direct cutting - M	ore
	Page size X 238.6 mm Page size Y 53.	7
	Feed mode:	
	Feed mode Sheet automatic feed -]
	Docking settings:	
	Docking methods Not specify position -	

4. Make ready the material, turn on pump, click manual feed and send material to table, then manually open camera window, move camera to the first position point.

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5. Click "More" in "Output settings", open "Setting of automatic operation". Check box "Move cutting head to the specified point before task starts", and click Get coordinates. Then click save and exit.



5. Exit camera window, click start cut and automatic cutting begins.

Notes about automatic continuous cutting

- 1. First need to set suction cylinder's operating position. And PK2 feeding docking point in Expand parameter
- Adjust anti-static air tube's position and air pressure.
 Loose knob, can adjust up and down position of air blow hole.
- 3. Set material collecting time.
- If material can't separate properly, can increase air blow time or use back function.
 PK2 press lift time and back distance in Expand parameter.
- 5. In case of feeding material but the table does not finish reset operation, a window of wait PLC to be ready will pop-up. When feed and reset is finished, click confirm to finish.

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