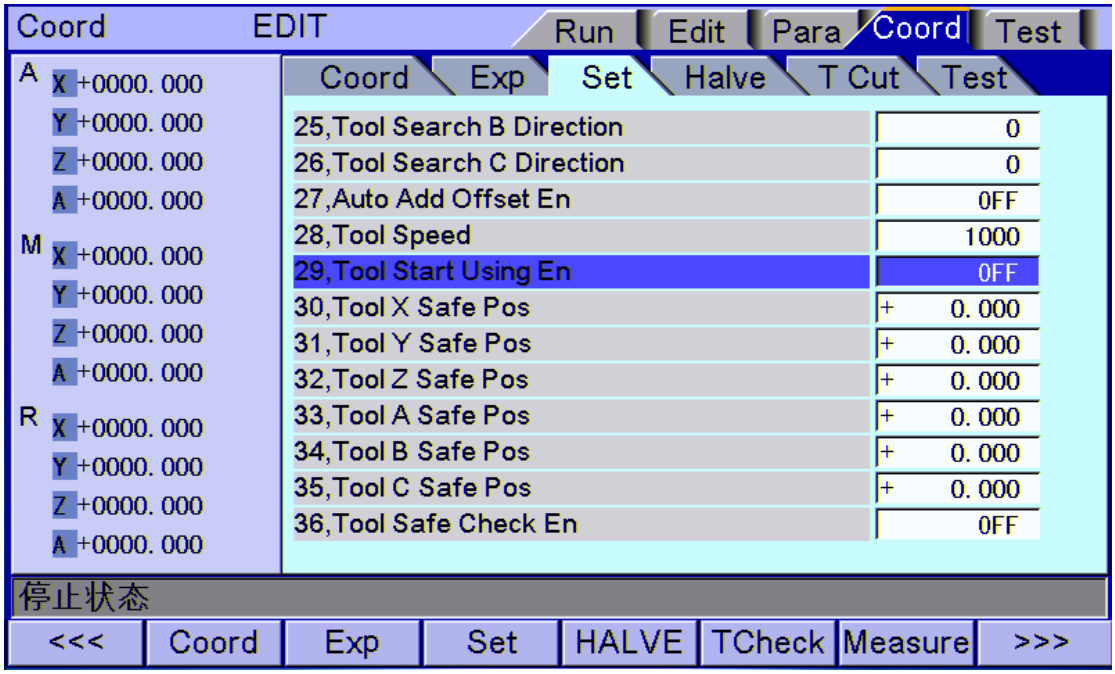
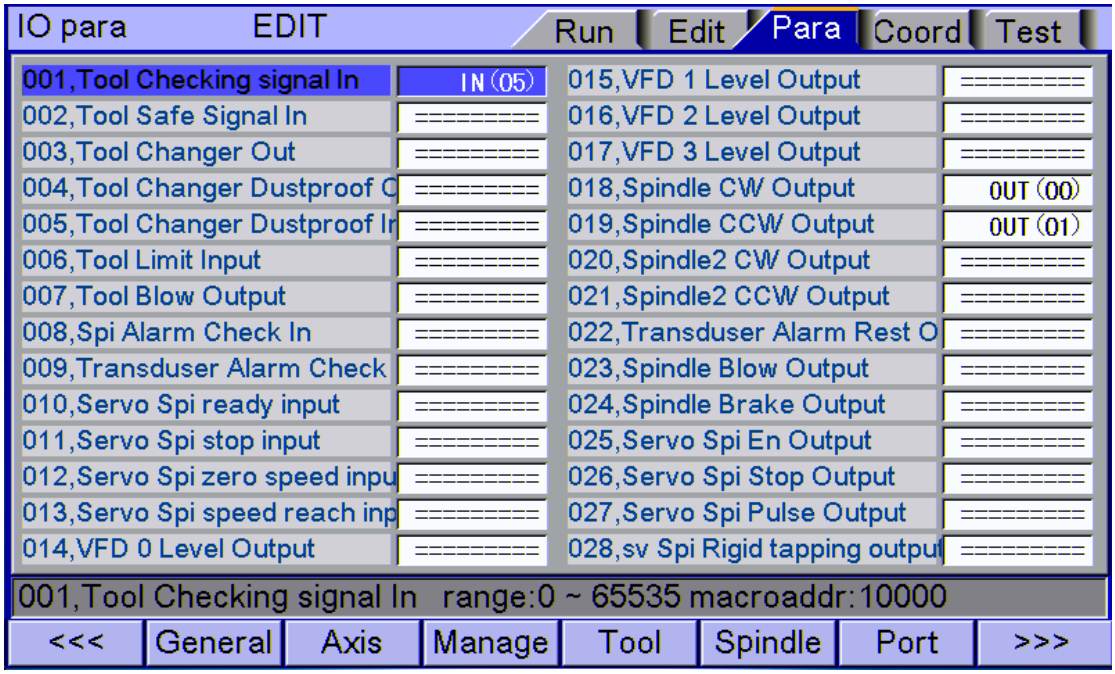
CNC46xx system functions can be achieved on the knife the knife Z axis , A shaft of the knife, and use the same knife instrument for testing, you can switch the Z -axis of the knife, you can also switch the A axis of the knife, the system factory setting is not enabled on knife function to modify the parameters to use. This document describes the system -based version 7.0 or more.

System parameters knife description :

1 , the coordinates - > coordinates - > 29 if enabled on the knife --------- set to ON to enable functions on the knife, for OFF is not enabled on the knife .



2 , the parameter - > Port - > 001. detected on the knife enter the port number on the knife set -------- detection signal input port, the system scans for when the knife through the parameter detection sensors in place on the knife if , for example, put on the knife signal line connected to the input board 6 feet 5 the input parameters , input parameters will become IN (05) can, pay attention to the wiring board line number is the value of the ratio parameter one bigger .

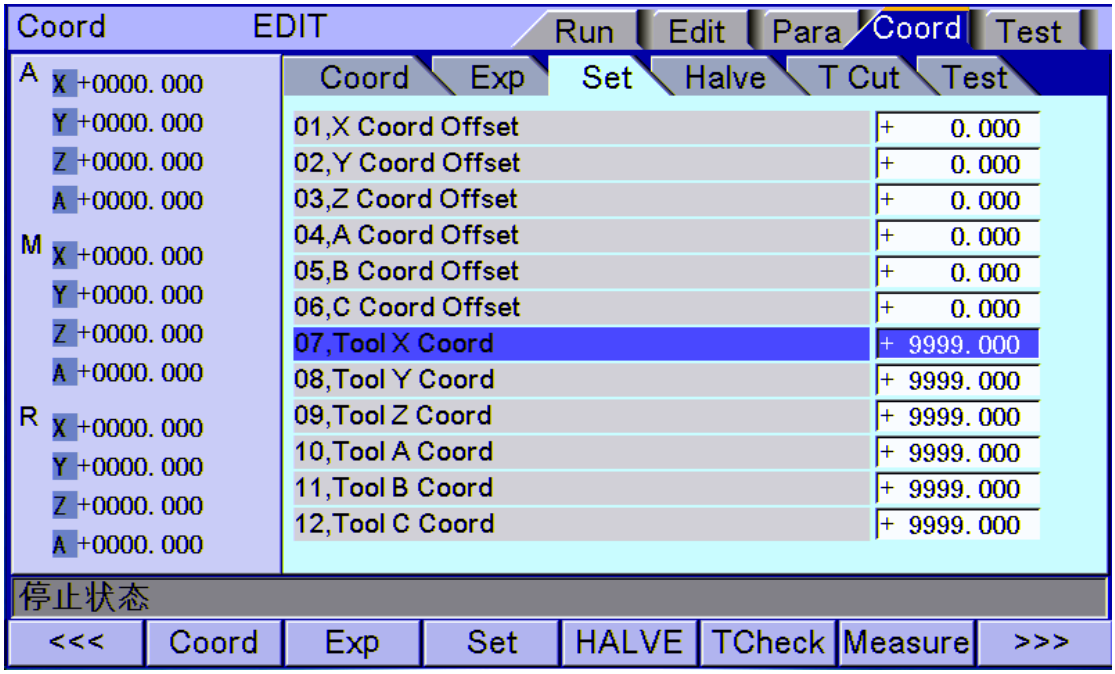


3 , the coordinates - > coordinates - > 7 on the knife X coordinate .

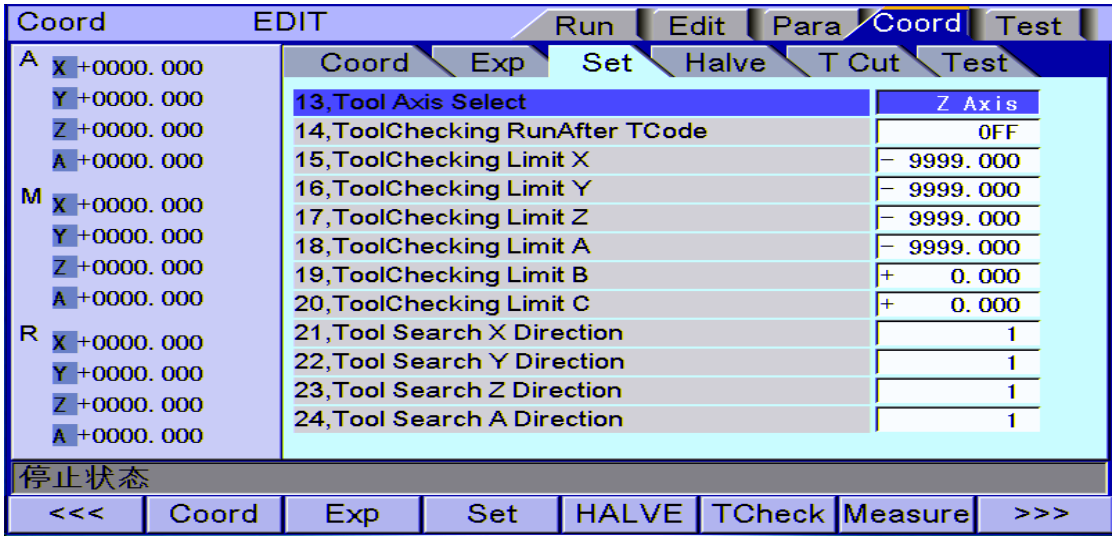
8 Y coordinates on the knife

9 on the knife Z coordinates

10. coordinate ---------- A knife set on the knife mounting location , pay attention to the parameters of the machine coordinate value to the Z-axis of the knife as an example , such as X for 200, Y for 300 Z 100 , the system scans when the knife after , the knife axis Z -axis to move fast machine coordinate 100 , then quickly moved to the X and Y axis machine coordinate at 200 and 300 of the Z -axis signal to start scanning for the knife , which parameter applies only to fixed installation in case the machine at a location for the activities of the knife block knife way , on the knife is a knife at any point , you can set this parameter to 9999 , when the knife system scan directly to the current point on the knife signal.



4 , coordinates - > coordinates - > 13 on the knife shaft election signs ---------- set to start on the knife on the knife shaft , for example, is enabled by default Z Axis Z -axis of the knife A Axis. Press the left arrow key and right arrow keys to switch to the A -axis on the knife , you can select the parameter after the cursor .



5 , coordinates - > coordinates -> 1.X coordinate offset

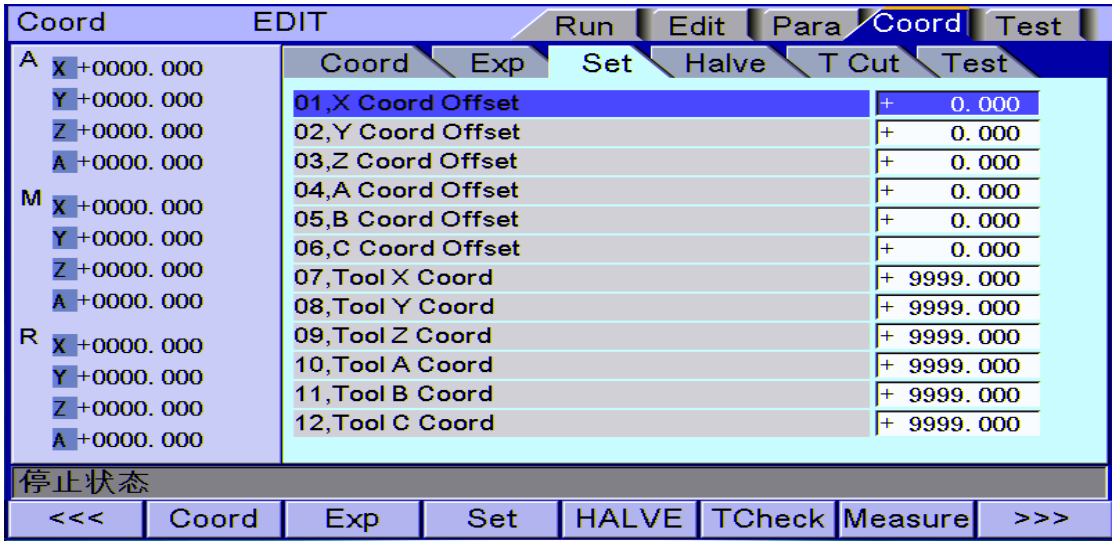
2.Y coordinate system offsets

3.Z coordinate system offsets

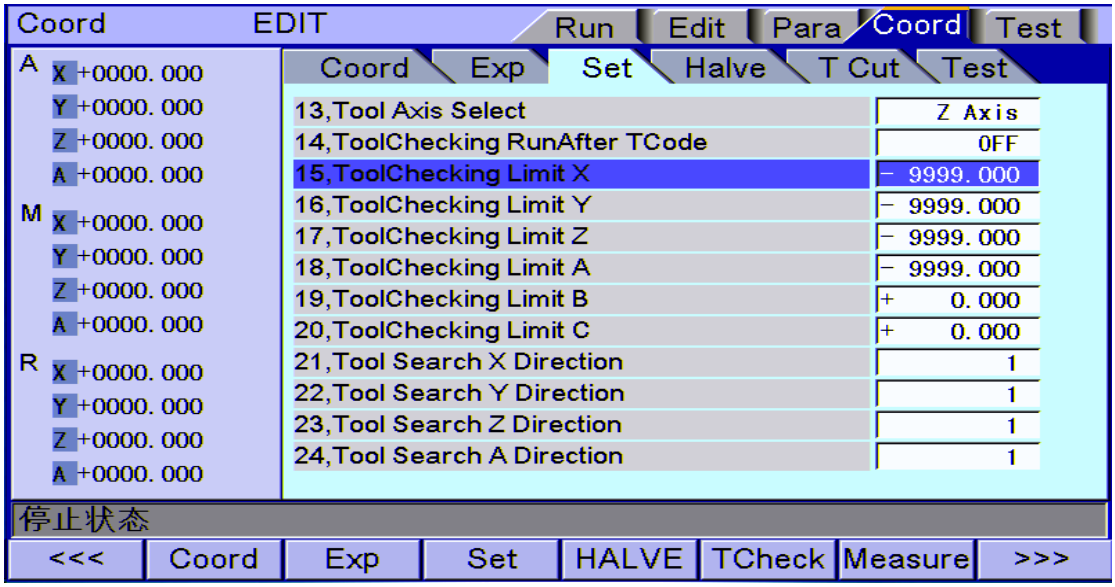
4.A coordinate system offset ----------

Set the work piece coordinate system and the point of the knife offset , for example, to the point of a knife machine coordinate -100 , coordinate offset of 10 , the work piece coordinate system zero point of -100 + 10 = -90 at the work piece zero , the system the point of the knife scanner machine coordinate plus the offset to the work piece zero

position , for a fixed installation on the knife , by measuring this parameter is generally functional test out . First, choose a knife after the work piece coordinate system by measuring function , the system will signal to scan on the knife , put in place after the scanning machine coordinates minus the work piece zero point of the knife at the machine coordinates , the result set of offsets , this parameter can also be entered manually , knife blocks for knives, knife block thickness can be entered into this parameter , in general, the work piece origin point at the top of the knife offset is positive , the work piece points above the knife point on partial shift amount is negative (such as knife blocks) .

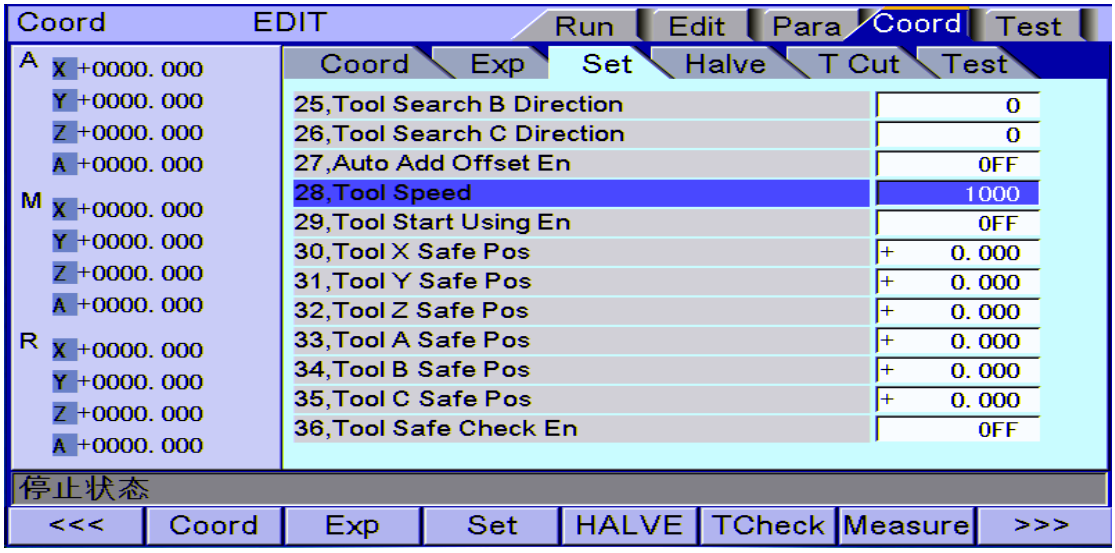


6 , coordinates - > coordinates - > 15 on the knife machine limit ... 21 on the knife search direction ---------- limit set on the machine and coordinate the knife on the knife . search direction , a direction of the search is negative , 0 is a positive direction search .

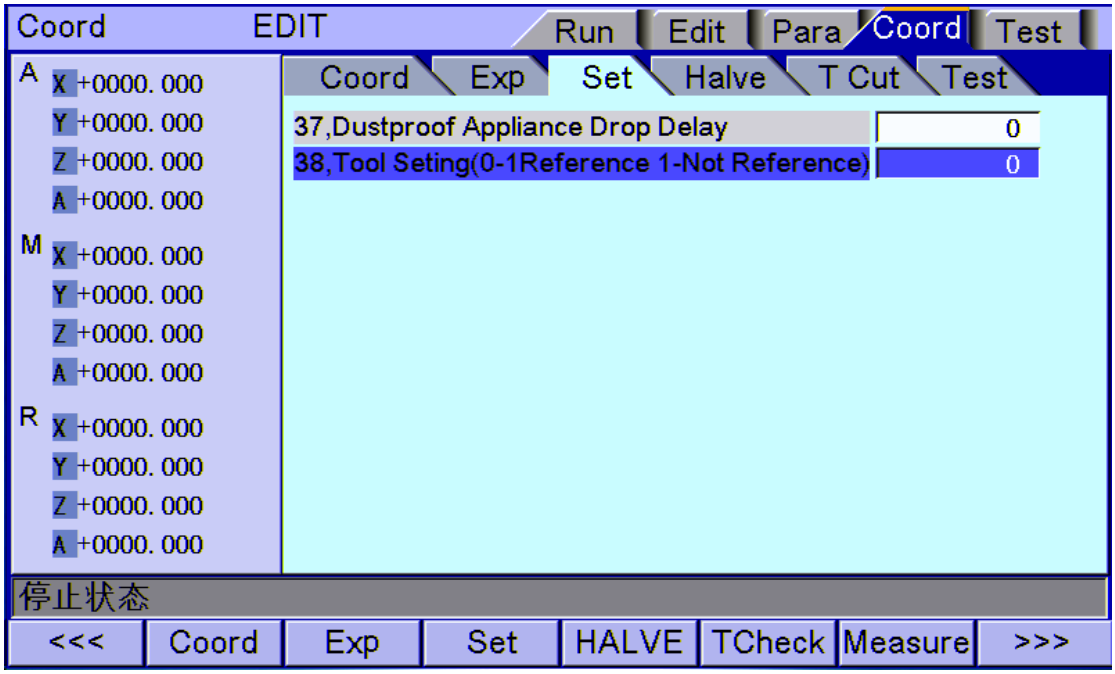


7 , coordinates - > coordinates - > 28 ---------- scanning speed on the knife set the system searches for the search speed knife signal , the default is 1000mm / min, such as setting the Z axis of the knife. when , Z -axis negative direction began to search for the knife signal on to 1000mm / min speed of the search until after the knife sensed signal , the system is

switched relocation scan for slow scan speed on the knife signal.



8 , coordinates - > coordinates - > 38 ---------- after the knife way to set the system for handling the knife scanner after the end of the knife the way , the scan is completed a non-benchmark knife will work piece datum position calculation is set to the coordinate system , such as work piece zero coordinate scanned -90 , set the system will coordinate values of -90 to the coordinate system settings in the Z-axis (Z -axis of the knife), the set of coordinate system is a coordinate set in the currently selected coordinate system , in the program by calling the coordinate system instructions to achieve length compensation , 0 is the base of the knife blade mode settings after scanning tool will compensate for the value of the 1st correction the length of the compensation amount which , for example, the 2nd time on the knife , the system value is set to put the knife correction amount of the 2nd length compensation value , and then call the G43 H2 achieve length compensation , the 1st knife meant as a reference tool in the program is in the measurement coordinate offset when the amount to be measured to the 1st blade , the correction amount of the compensation amount is generally 1 to 0 .



On the knife using steps and trouble shootings:

1 According to the system requirements , the modified parameters , system diagnostics to diagnose the input signal screen , active level is correct, the diagnostic screens such as IN5 red light indicates a detected low as 0 , bright green light that detects high level 1, and then confirm the level of the corresponding parameters are correct , when setting error scanning speed and direction will not normal.

2. After the scan is completed , the work piece by moving the machine to zero , to confirm the compensation value is correct.

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