操作使用说明书

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目　　　录

1.概述

导流片切割机是本公司针对各种翅片切割而开发的一款全自动设备，本设备采用高性能的智能控制器（PLC）和触摸屏组合，操作界面宜人，使用简便，切割效率高，安全性可靠，大大提高了生产效率，深受广大用户的欢迎。

2. 技术参数规格

2．1 使用工作环境

温　　度：0℃-40℃

相对温度：＜80 ％

2．2 电源供给

工作电压：AC380 V±10%　50Hz

3.操作步骤

3.1 面板介绍

本设备操作包括两个部分,触摸屏、脚踏开关。

触摸屏:用于调节切割参数，如速度，切割长度，自动切割次数以及手动调试等各项功能。

脚踏开关：控制设备的自动启动、回原点。

3.2 触摸屏界面

本控制屏包括两个界面：开机界面，控制界面。

1．**开机界面**　系统上电后自动进入此界面，如下图。
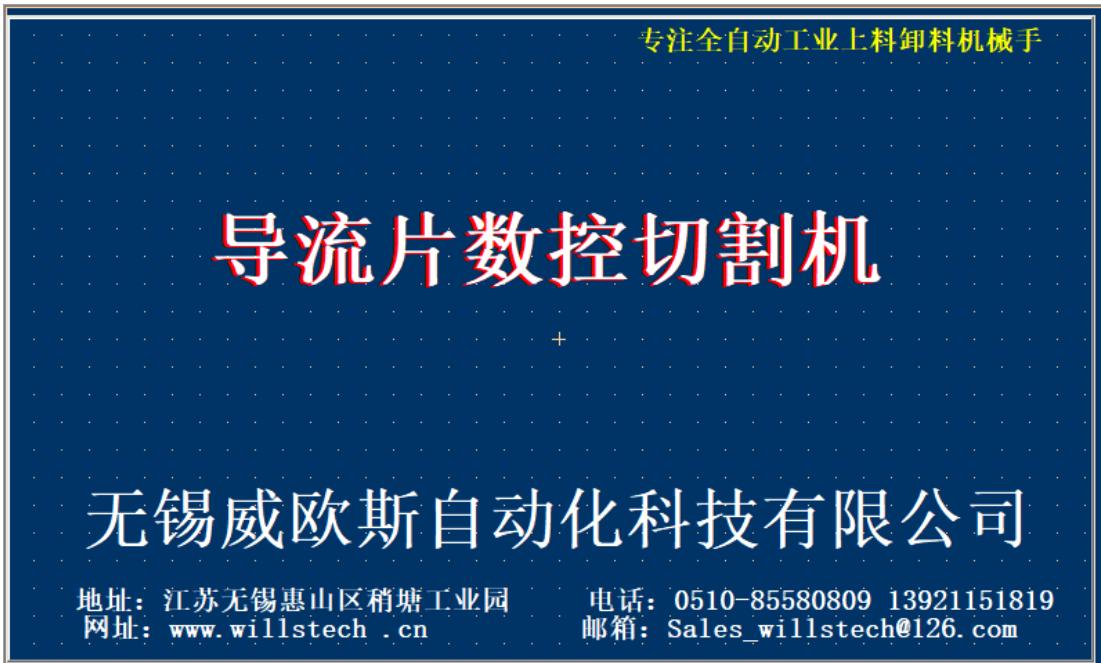
点击触摸屏任意位置进入控制界面，如下图：
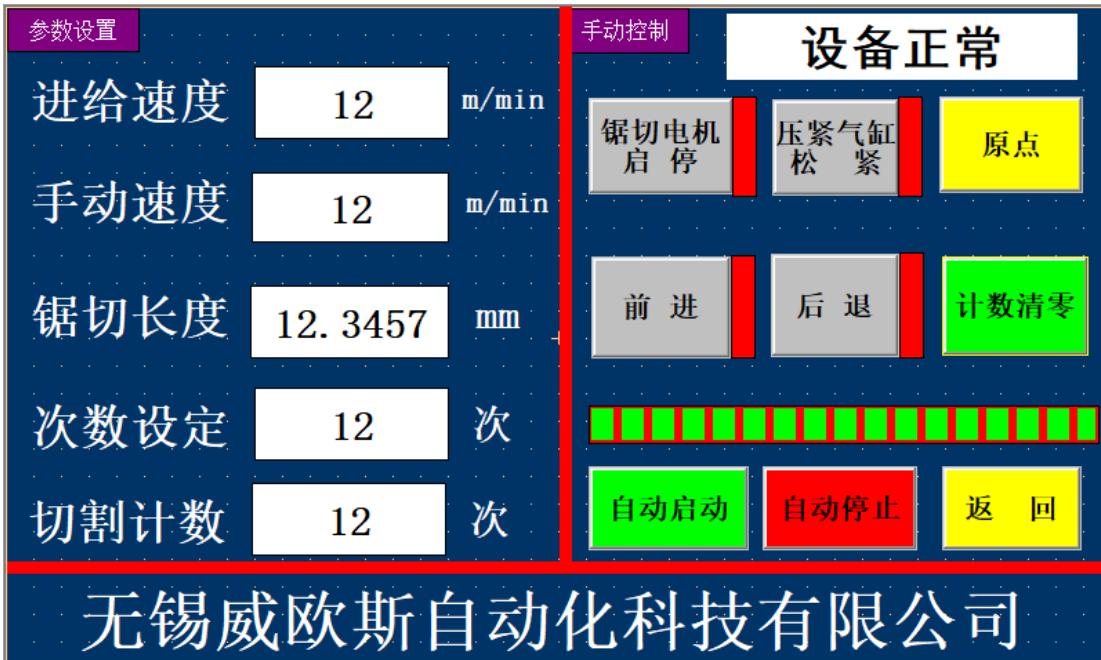
该界面包括了自动模式、手动模式的操作以及参数设定。

一、 参数设置区说明：

1. 进给速度：自动切割时锯片前进行走速度。

2. 手动速度：手动控制时锯片行走速度。

3. 锯切长度：自动切割时锯片前进长度。

4. 次数设定：设定自动切割次数。

5. 切割计数：已切割次数。

二、手动控制区说明：

1. 设备状态指示（屏幕右上角白色方框）

　(1) 设备正常：设备可正常运转。

　(2) 伺服报警：伺服电机出现故障，设备不能前进、后退，需查明造成故障原因后解决问题，然后断电重启可恢复正常。

　(3) 前限位：锯片到达前方最末端位置。

　(4) 后限位：锯片到达后方最末端位置。

2. 锯切电机 启/停：锯片启动、停止。

3. 压紧气缸 松/紧：气缸压紧、松开。

4. 原点：锯片回到原点位置。

5. 前进：锯片向前行走。

6. 后退：锯片向后行走。

7. 计数清零：已记录的次数数据置零。

8. 自动启动：设备按照给定参数自动运行。

9. 自动停止：使自动运转状态下的设备停止运行。

10. 　返回：返回主界面。

三、使用方法：

1. 手动控制：按上述说明点击各对应功能按钮。

2. 自动控制：

　　方法一（触摸屏控制）：点击屏幕或下方按钮，绿色按钮是

自动启动，红色按钮是自动停止，切割完毕后需回到原点方可再次运行。

　　方法二（脚踏开关控制）：踩下左手边开关自动运行，踩下右手边开关回到原点。

3.急停按钮：切断电源，设备停止运行。

4.注意事项及故障处理方法

1.由于进给电机使用的是伺服电机控制，如果有机械位置卡顿会导致伺服报警，请检查行进路线，并不定期对设备进行检查清理。

2.每次更换锯片在自动运行前需检查锯片卡槽是否到位。

3.气缸或电机不动作，请检查气源或者电源是否打开。

如果出现其他无法处理的情况，请联系售后人员。

附录

电气原理图详情参考　图纸。

Operation Instructions

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catalogue

1. Overview

The guide sheet cutting machine is a fully automatic equipment developed by the company for all kinds of fin cutting. The equipment uses a combination of high-performance intelligent controller (PLC) and touch screen, with pleasant operating interface, easy to use, high cutting efficiency, safety and reliability, which greatly improves the production efficiency and is welcomed by the majority of users.

2. Technical specifications

2. 1Use the working environment

Temperature: 0℃-40℃

Relative temperature: ＜80 %

2. 2Power Supply

Operating voltage: AC380 V±10% 50Hz

3. Procedure

3. 1Panel Introduction

The operation of this equipment includes two parts, touch screen and foot switch.

Touch screen:used to adjust cutting parameters, such as speed, cutting length, automatic cutting times and manual debugging.

**Foot switch：** control the automatic start of the device, back to the origin.

3.2Touch Screen Interface

The control screen includes two interfaces: boot interface and control interface.

1 . Startup screen This screen is displayed automatically after the system is powered on, as shown in the following figure.
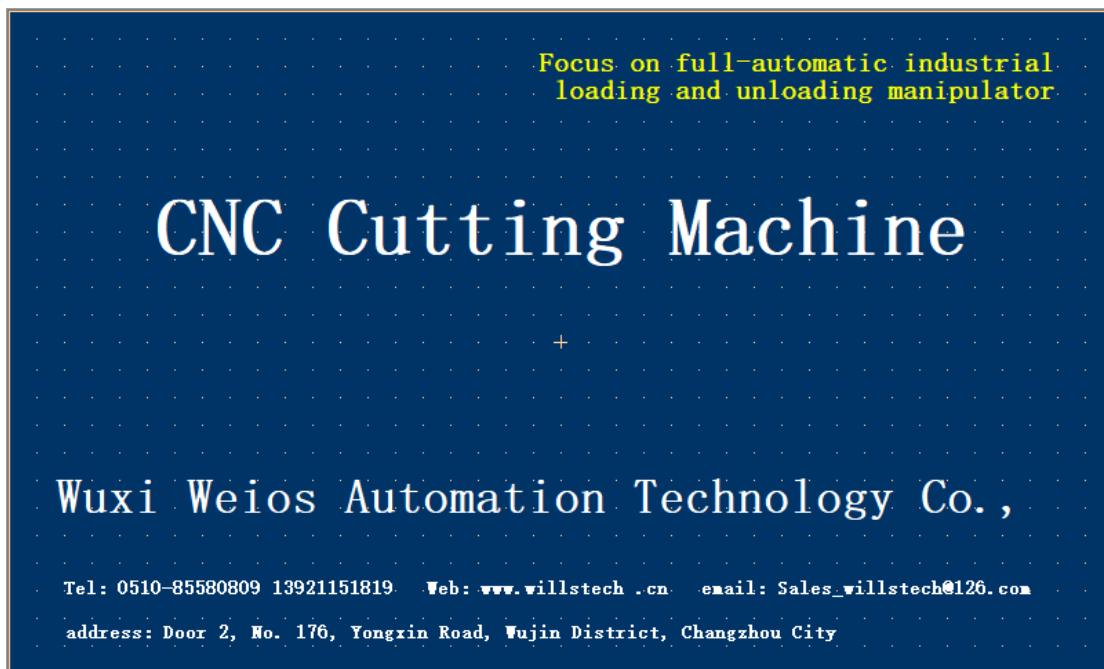
Click anywhere on the touch screen to enter the control interface, as shown in the following figure:

Parameter setting			Manual control		The equipment is normal
Feed rate	12	m/min	Sawing motor start stop	Press cylinder loose tight	origin
Manual speed	12	m/min	Forward	after	Count clear
Sawing length	12.3457	mm			
Number setting	12	time	Automatic start	Auto stop	return
Cut count	12	time			

Wuxi Weios Automation Technology Co., Ltd
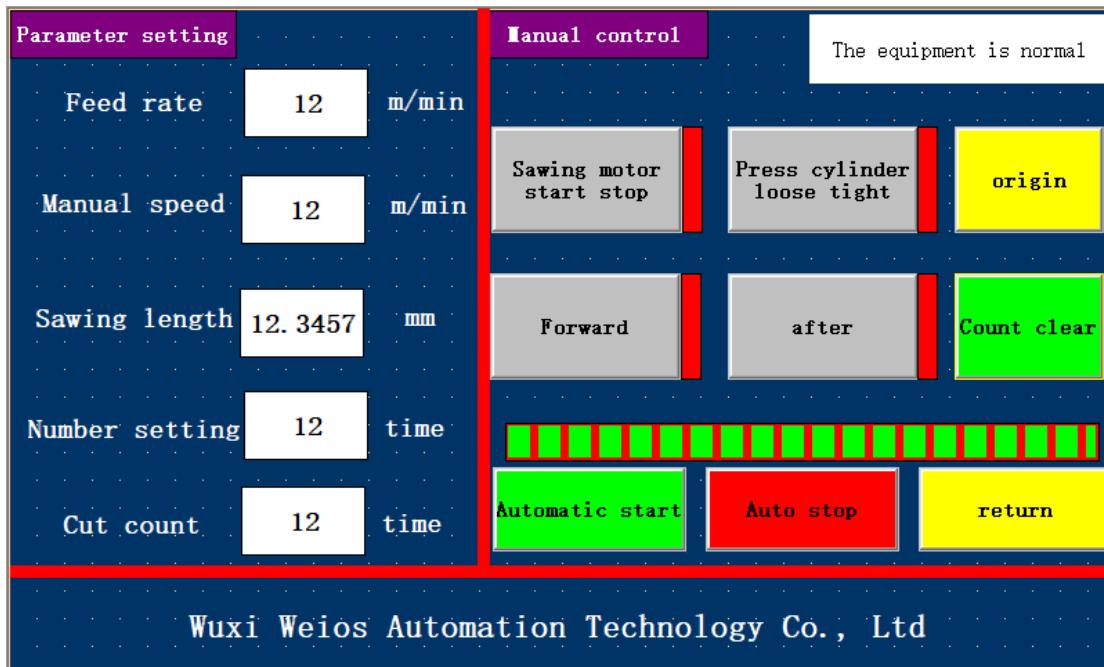
This interface includes automatic mode, manual mode operation and parameter setting.

一、 Parameter setting:

1. Feed rate: forward speed of saw blade during automatic cutting.

2. Manual speed: The walking speed of saw blade under manual control.

3. Sawing length: forward length of saw blade during automatic cutting.

4. Frequency setting: Set automatic cutting frequency.

5. Cut count: the number of cuts.

二、 Manual control:

1. Device status indicator (white box at upper right corner of screen)

(1) The equipment is normal: the equipment can operate normally.

(2) Servo alarm: when the servo motor fails and the equipment cannot move forward or backward, it is necessary to find out the cause of the failure and solve the problem, and then power off and restart to restore normal.

(3) Front limit: saw blade reaches the front end position.

(4) Rear limit: saw blade reaches the rear end position.

2. Sawing motor start/stop: saw blade rotation and stop.

3. Press the cylinder loose/tight: Cylinder compression release.

4. Origin: The saw blade returns to the origin position.

5. Forward: The saw blade moves forward.

6. after: The saw blade goes backwards.

7. Count reset: Set the recorded times data to zero.

8. Automatic start: The device runs automatically according to the given parameters.

9. Auto stop: stop the operation of the equipment under automatic operation.

10. Return: Return to the main screen.

三、 Three, use method:

Manual control: Click the corresponding function buttons according to the above instructions.

1. Automatic control:

Method 1 (touch screen control) : Click the button on the screen or below. The green button is to start automatically, and the red button is to stop automatically. After the cutting is finished, it can be started again only after returning to the origin.

Method 2 (foot switch control) : Press the switch on the left hand side to operate automatically, and press the switch on the right hand side to return to the origin.

2. Emergency stop button: cut off the power and the device stops running.

4. Precautions and Troubleshooting

1. Since the feed motor is controlled by servo motor, if there is mechanical position stuck, servo alarm will be caused. Please check the traveling route and check and clean the equipment irregularly.

2. Check whether the saw blade slot is in place before automatic operation every time the saw blade is replaced.

3. If the cylinder or motor does not act, please check whether the air source or power supply is turned on. If there are other situations that cannot be handled, please contact after-sales personnel.

Appendix

Refer to separate drawings for details of electrical schematic diagrams.