

Preface

Before using the machine, please read this book carefully, and make sure you have paid enough attention of the importance of safety. Running the machine properly, you can not only avoid accidents, but also prolong the life of the machine. To make this machine running under best situation, you should do according to the following:

1. Please read the book carefully and make sure that you have understood it well, and then you can do operation, maintenance and attendance.
2. You should keep the book together with the machine; even transport the machine from one place to another.
3. Please keep the book in a place where you can get at any moment, and keep it well.
4. We provide all the buyers with standard service for carrying out one-year's guarantee period (from the machinery shipment, and the wear parts are not under the guarantee period) and lifetime upkeep.
5. During the guarantee period, if there are any problems, such as the machine can not work stably, or something abnormal happens under machinery running, please contact with our Maintenance Department or Sales Department for instant settlement.
6. Beware that the below circumstances are beyond management:
 - 1) Damage caused by improper use
 - 2) Damage caused by tearing down the machine privately.
 - 3) Damage caused by using the improper voltage
 - 4) Damage caused by the force majeure.
7. If you required, we can send our technician for machinery running test, but the buyers should pay all the travel expense (Visa charge, salary--USD 60 per day per person, round-trip air tickets, food, lodging, and local transportation). For machinery Maintaining, you can deliver the machine to our factory to maintain, or ask our technicians to your plant for repair and pay all the travel expense.
8. You can contact with us via telephone call or E-mail, and we will provide you with satisfied service.

Safety Notice

1. Stable voltage is essential to ensure the precision and efficiency of the blades. If the voltage is not stable, the machine will stop automatic, the user must fit out stable power supply (AC 220 \pm 3%, 50-60HZ).
2. To assure safety operation and the disposal of the disturbance of static when you put the machine into use, you should equip the jack of power supply with ground cable and specific power wire.
3. Keeping the ambient environment of running machine clean, neat, and bright. The machine should keep away from soot, corrosive chemicals, and strong electromagnetic field. And the quick temperature rise will not only lead to the machinery function decrease, but also damage the electrical components. (The place where the temperature is high should better have fans for decreasing the temperature.)
4. Never try to use the same switch board together with these which are frequently used, electromagnet or the other things like that too.
5. Lubricate the mechanical drive parts regularly.
6. If the machine can not work stably, please stop to check it out by your operators. Please contact with our Maintenance Department or Sales Department if you can not settle the problems.

Specification

1. Cutting length:	1-9999.9mm
2. Cutting width:	up to100mm
3. Power supply:	AC220V/50HZ
4. Storage number:	10
5. Feeding motor:	Stepping motor
6. Cutting motor:	Alternating motor
7. Wire run-out sensor:	Natural dropping
8. Cutting detect sensor:	Time controlling-2 seconds
9. Overall size:	350mm*250mm*320mm
10. Weight:	27 kgs

Control Board

The following is the picture of control board and buttons' function on the control board.



<SET> is the key for setting programs.

<LEFT> & <RIGHT> are available in moving the cursor left-ward or right-ward.

<+>&<-> are used to adjust the numerical where the cursor stays.

<RESET> is used to unchain self-locking of the motor, make the bundling amount return to Zero and clean away the incorrect data.

<CONFIRM> Press this button, you can store the data that you have set. By this way the computer accept the order you have set.

<CUT> Press this key, the machine runs a whole process to produce one piece of pipe.

<FEED> Press this key, it will feed wire once at the length you have set.

<START> Press this key, it will operate the program, and the cutting number will count from Zero.

<GO ON> Press this key, it will operate the program, and the cutting number will count from the processed number.

<STOP> Press this key, the machine will stop moving after finishing processing a whole wire.

Screen (4027): LCD Display with blue backlight

<EMERGENCY STOP> Refers to emergency button. If the machine can't run with the power on, press the emergency button to run the machine; Or if some emergency situation happened, the machine still is running, press the button to stop the machine.

<POWER> means the main switch.

Setting of Display Modes & Procedure

1. When switch on the machine, the video screen will show a picture below:

M	E	M		L		0	0	+		C	O	U	N	T		S	E	D	
	0			0	0	0	0	0		0	0	0	0	0			0		
CODING				LENGTH					COUNTING AMOUNT					SPEED					

First, press the <SET> key, some figures will be appearing on the screen. For these figures are encode mode, which can store up to 10 processing data from 0#-9#.

Second, press <+> or <-> key, it will show the stored processing data. When you are in need of them, you just pick it out.

If the figure under the MEM shows “0”, it means that this coding is still available for setting new processing data.

What’s more, the messages that have been stored can be revised.

2. The way to set

- 1) Press the <SET> key once, the cursor will be shining at the corresponding coding figure (the indicator light under <SET> is on at this moment). Press the <+> or <-> key to pick out the data that you are in need. or to reset data if there show none. (Beware that once you press key, the buzzer will give out beep.)

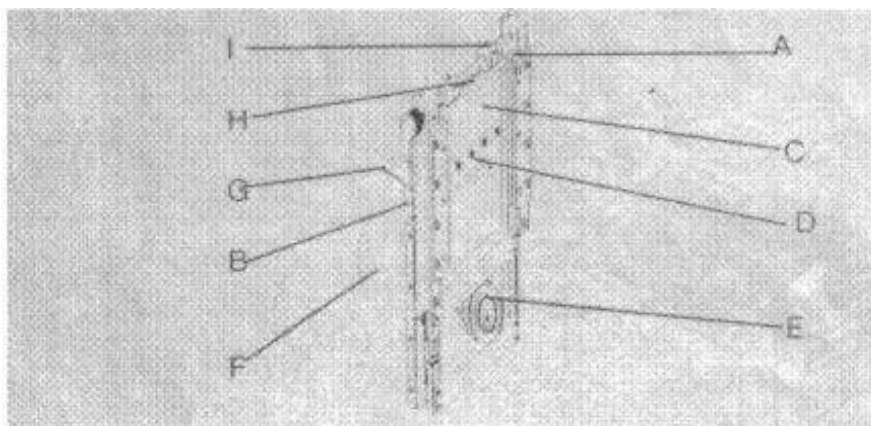
- 2) Press the <SET> key twice (the indicator light under <SET> is on at this moment). The cursor is shining at the first at the first digit under <L>, you can shift it by pressing the <LEFT> or <RIGHT> key, and press <+> or <-> key to adjust the numerical value of it. (Notice: the numerical value is measured by “mm” .)
- 3) Press the <SET> key thrice (the indicator light under <SET> is on at this moment). The cursor is shining at the compensation part “00+” of <L>, press <+> or <-> to adjust the numerical value of it. An increase or decrease in the value is equivalent to 0.1mm.
- 4) Press the <SET> key fourth (the indicator light under <SET> is on at this moment). The cursor is shining at the first digit of bundling amount (or total processing number), and now you can shift it by pressing the <LEFT> or <RIGHT> key, and press <+> or <-> key to adjust the bundling amount (or total number of processing).
- 5) Press the <SET> key fifth (the indicator light under <SET> is on at this moment). The cursor is shining at the processing speed, and you can adjust the processing speed from 0# to 9# by pressing <+> or <-> key.
- 6) Finally, press <CONFIRM> key to make the Digital Cutting Machine accept the instructions, and the same time, the screen twinkles for one time to show that the computer has accepted the instructions simultaneously the indicator light goes off. If the input instruction is incorrect, the buzzer will give out beep if you press the <STAR> key.



3. Wire testing and start to process

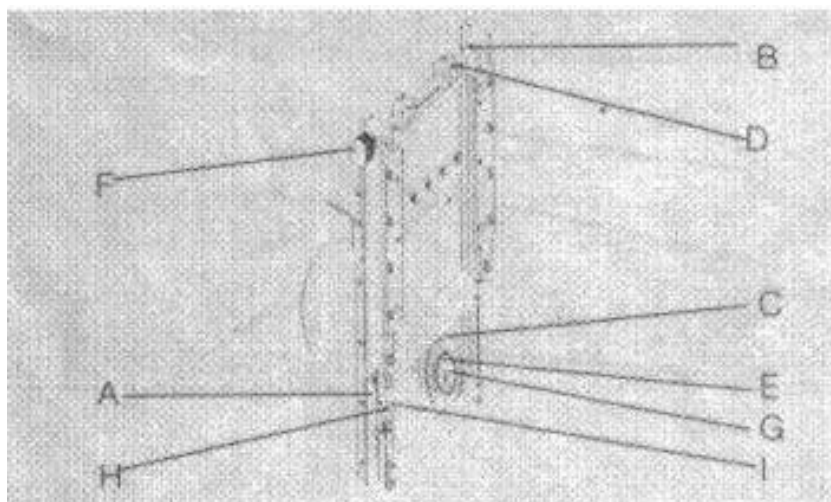
If you have finished the setting, you shall press the <START> key to cut one piece of pipe and to check the precision. If you want to make same adjustments, you can make it by pressing the <SET> key thrice, to change the compensation numerical value. After you finished the setting, please press the <CONFIRM> key again to make the computer has accepted the instructions, simultaneously, the indicator light goes off. If the satisfied with the result, please press the <STAR> key and the machine will carry on continuous processing, simultaneously, the bundling number will start to count from Zero. While if you press the <GO ON> key, the processing number will start from the amount that has been processed.

When the machine is under working, the motor is self-locked. If you need to operator it by manual, you should press the <RESET> key to make the motor unlocked, meanwhile, the bundling number will go back to Zero. (Notice: you must press the <CONFIRM> key to make the data stored every time you set.)

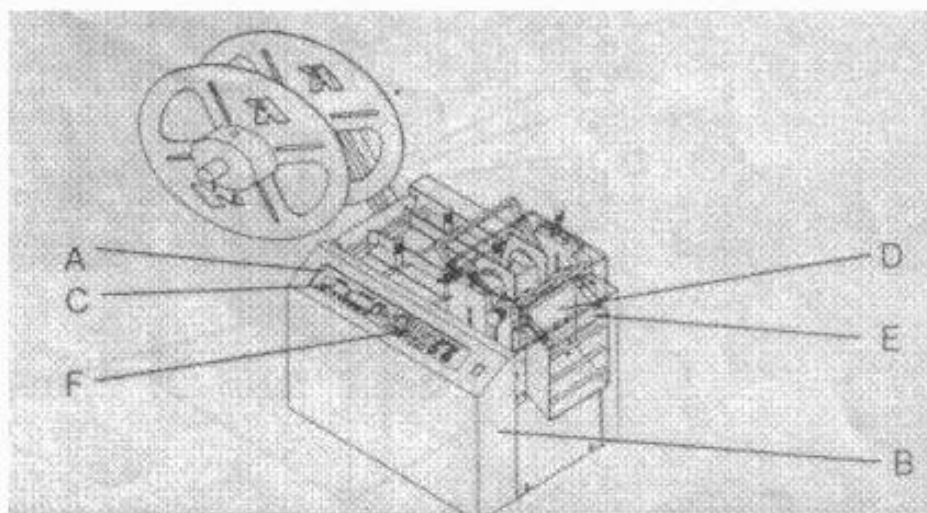
Accessories


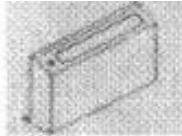





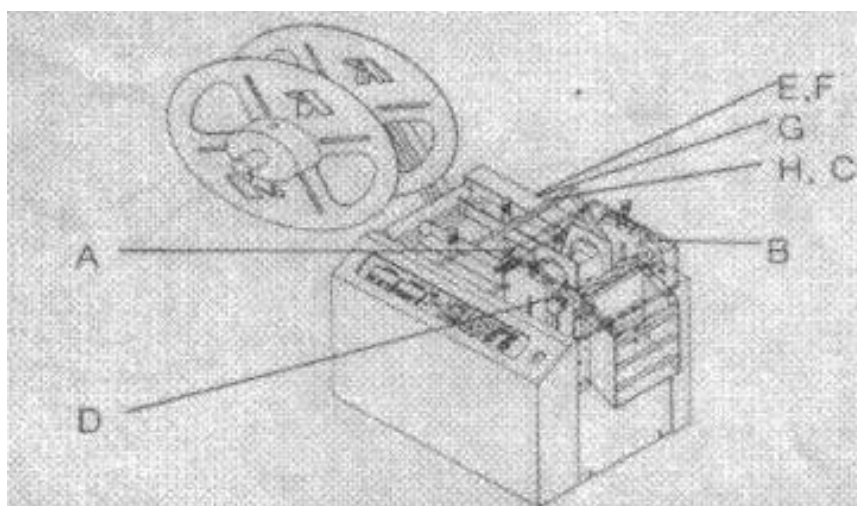
NO.	Figure	Name of the accessory	Coding of the accessory
A			6100-07-02
B		Guard board axis of cutting knife	6100-04-12
C		Bearing of eccentric shaft	6100-07-01
D		Jacket for guard board axis of cutting knife	6100-04-13
E		Eccentric shaft	6100-04-14
F		Small hand-wheel	6100-04-07
G		Balance key for eccentric shaft	6100-07-02
H			
I			



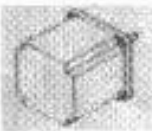







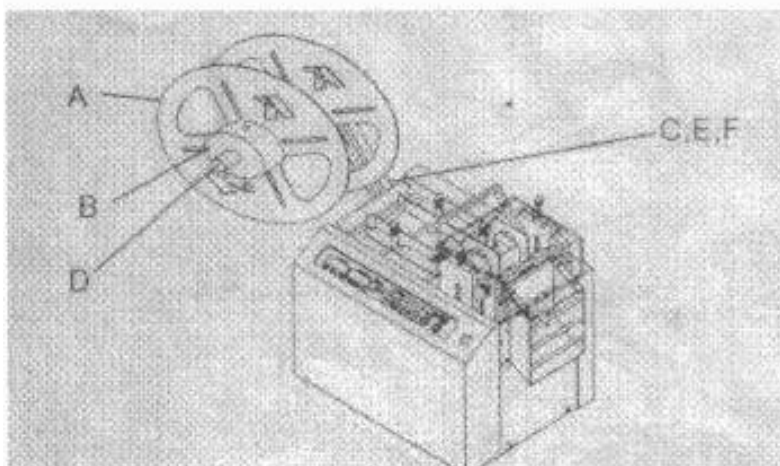
NO.	Figure	Name of the accessory	Coding of the accessory
A		Upper slide fixing support	6100-04-08
B		Down blade support	6100-04-17
C		Up blade	6100-04-09
D		Down blade	6100-04-16
E		Snap ring	6100-07-03
F		Cut motor	6100-07-04
G		Upper guide for down blade plate	6100-03-06
H		Material pressing plate	6100-04-21
I		Material pressing spring plate	6100-04-22

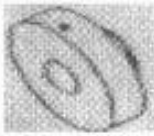






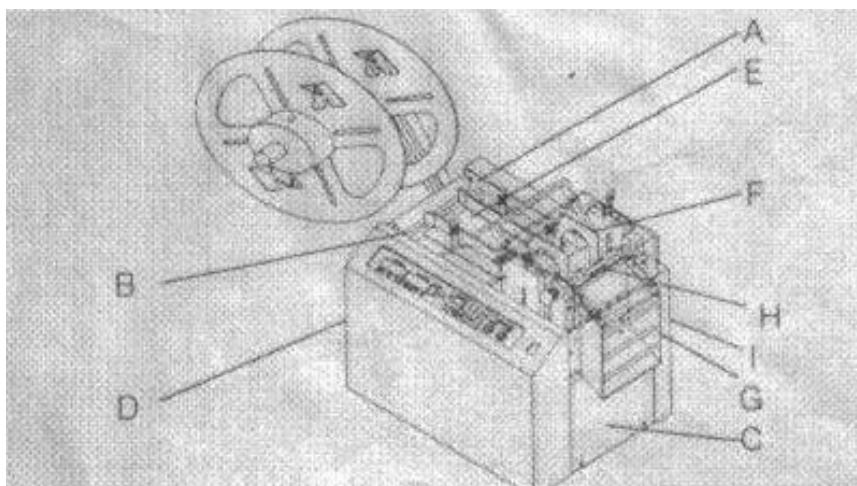
NO.	Figure	Name of the accessory	Coding of the accessory
A		Keyboard aux plate	6100-07-02
B		Front case	6100-07-02
C		Liquid crystal display	6100-07-02
D		Safety cover	6100-07-02
E		Front safety cover	6100-07-02
F		Front membrane	6100-07-02
G			
H			
I			

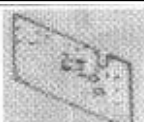
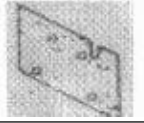
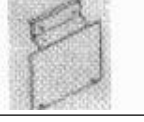
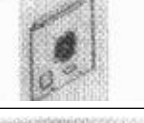


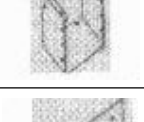




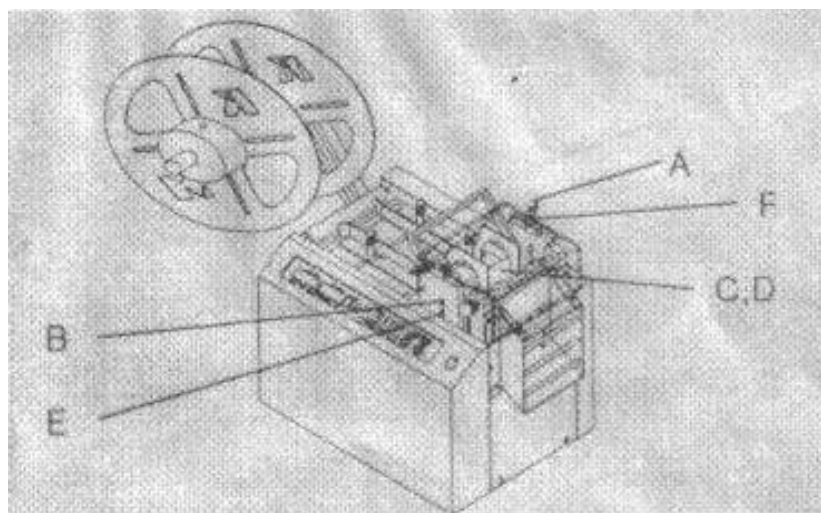
NO.	Figure	Name of the accessory	Coding of the accessory
A		Upper roller shifting knob	6100-03-05
B		Upper roller plate	6100-03-09
C		Roller driving stepping motor	6100-07-05
D		Upper roller support bearing	6100-07-06
E		Lower roller support bearing	6100-07-07
F		Roller driving timing belt	6100-07-08
G		10XL timing pulley	6100-03-13
H		38XL timing pulley	6100-03-12
I			


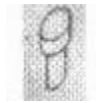






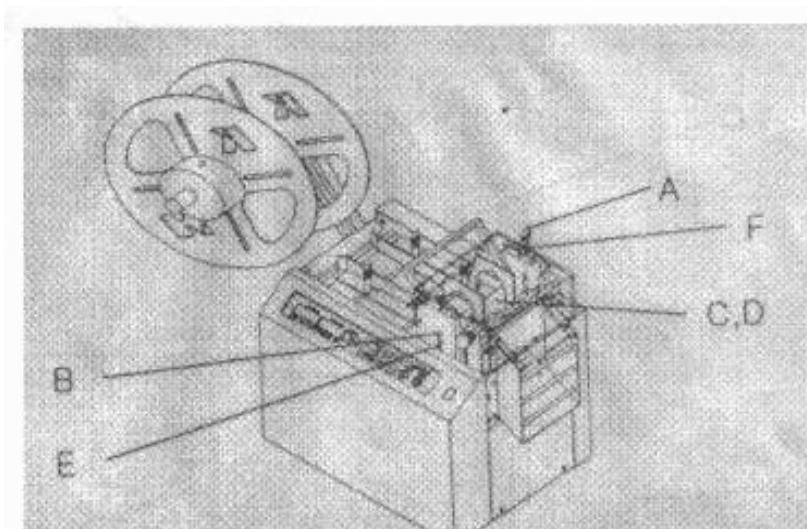
NO.	Figure	Name of the accessory	Coding of the accessory
A		Material support plate	6100-07-02
B		Material support plate fixing unit	6100-07-02
C		Material hanging supporting bar stopper	6100-07-02
D		Material hanging shaft	6100-07-02
E		Material hanging support bar	6100-07-02
F		Material hanging supporting bar fixing unit	6100-07-02
G			
H			



NO.	Figure	Name of the accessory	Coding of the accessory
A		Stepping motor fixing unit	6100-06-06
B		Body drive fixing unit	6100-06-07
C		Receiver fixing plate	6100-05-03
D		Power supply fixing plate	6100-06-10
E		Guide fixing upper plate	6100-02-07
F		Material supply guide	6100-02-02-02
G		Material receiver	6100-05-04
H		Material pressing plate	6100-04-21
I		Rear case	6100-06-02



NO.	Figure	Name of the accessory	Coding of the accessory
A		Pressure bolt for upper roller	6100-03-01
B		Spring aux shaft	6100-03-07
C		Lower feed roller	6100-03-11
D		Upper feed roller	6100-03-10
E		Upper roller pressing spring	6100-03-08
F		Safety cover pressing spring	6100-03-02
G			
H			
I			



NO.	Figure	Name of the accessory	Coding of the accessory
A		Body lower plate	6100-06-05
B		Body cross support	6100-06-04
C		Supporting plate cross shaft	6100-06-01
D		Material inlet roller fixing shaft	6100-02-09
E		Material inlet roller	6100-02-08
F		Deed roller fixing shaft	6100-05-02
G		Shaft aux shaft	6100-03-03
H		Material guide fixing bolt	6100-02-01
I			