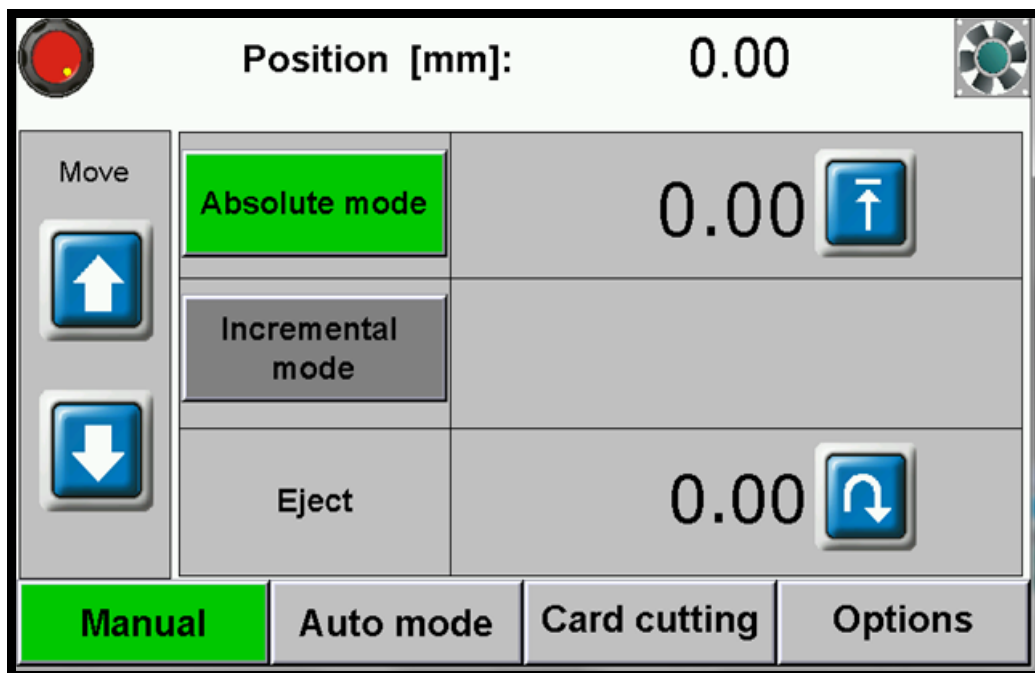


FORMAX[®]

Cut-True 31A / 31H
Guillotine Cutters

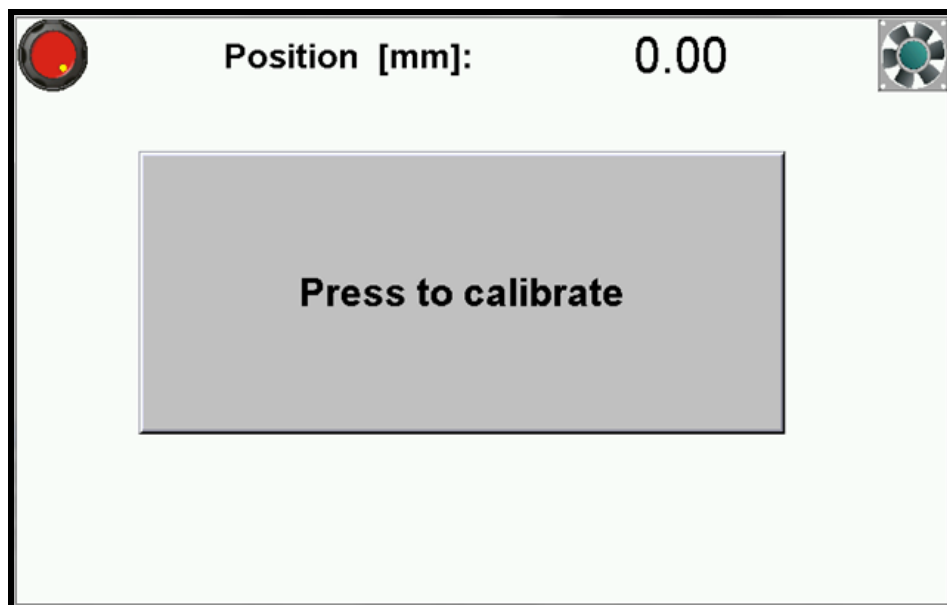
PROGRAM MODULE OPERATOR MANUAL

DOP-B07S410 – 7"



1.MACHINE START.

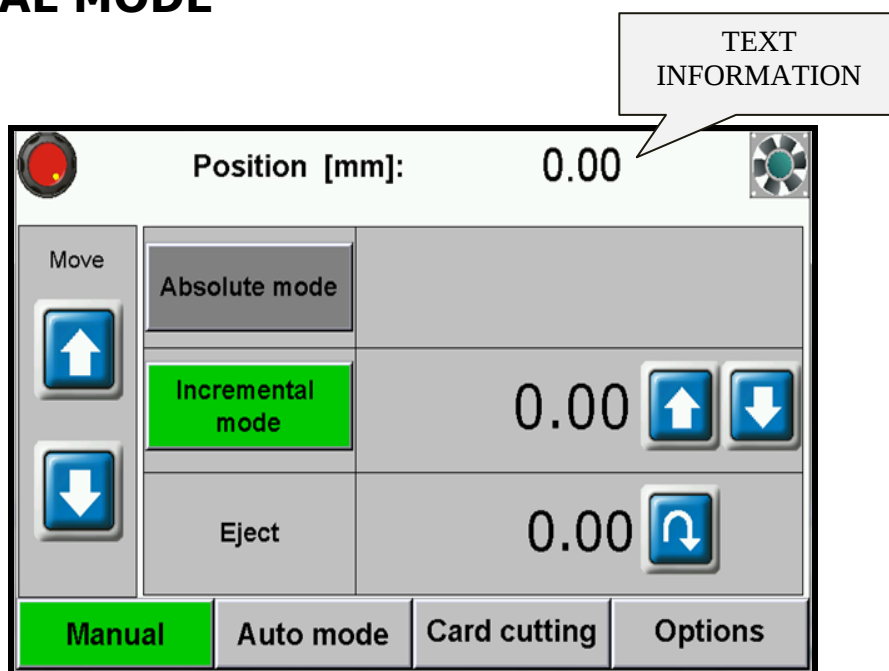
After turning on the machine the starting screen appears



- please press green button on the screen to start machine control system
- after pressing „**Press to calibrate**“ machine starts the calibration

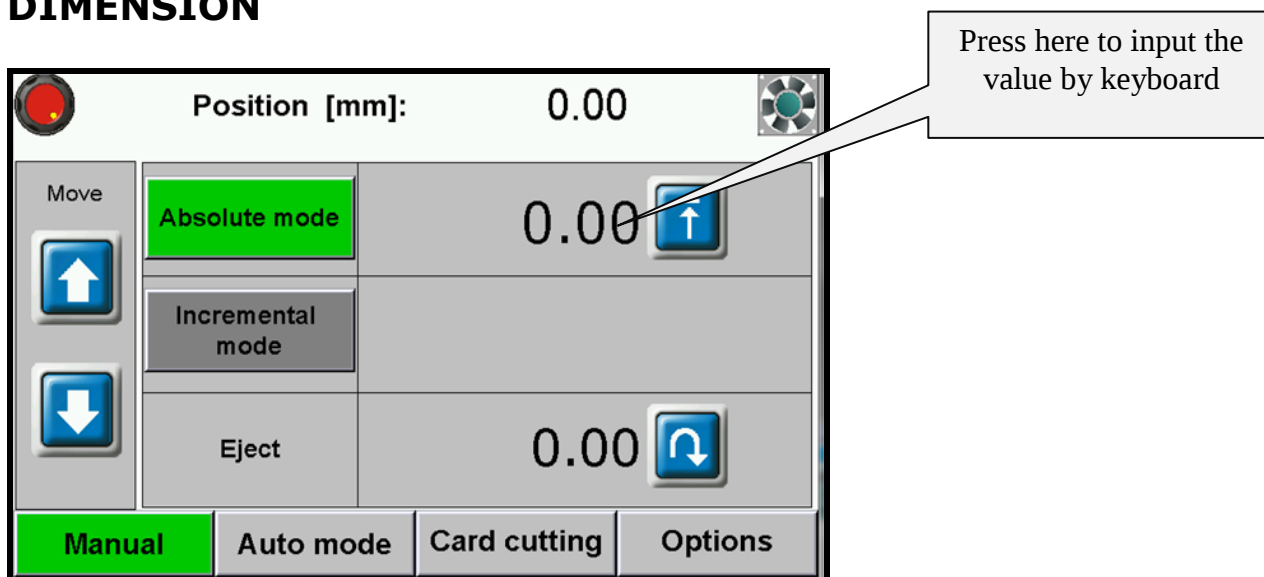
During the calibration backgauge moves to the maximum back position, then moves forward till the moment when calibration sensor will be detected. When the calibration is finished on the screen appears the manual mode.

2.MANUAL MODE



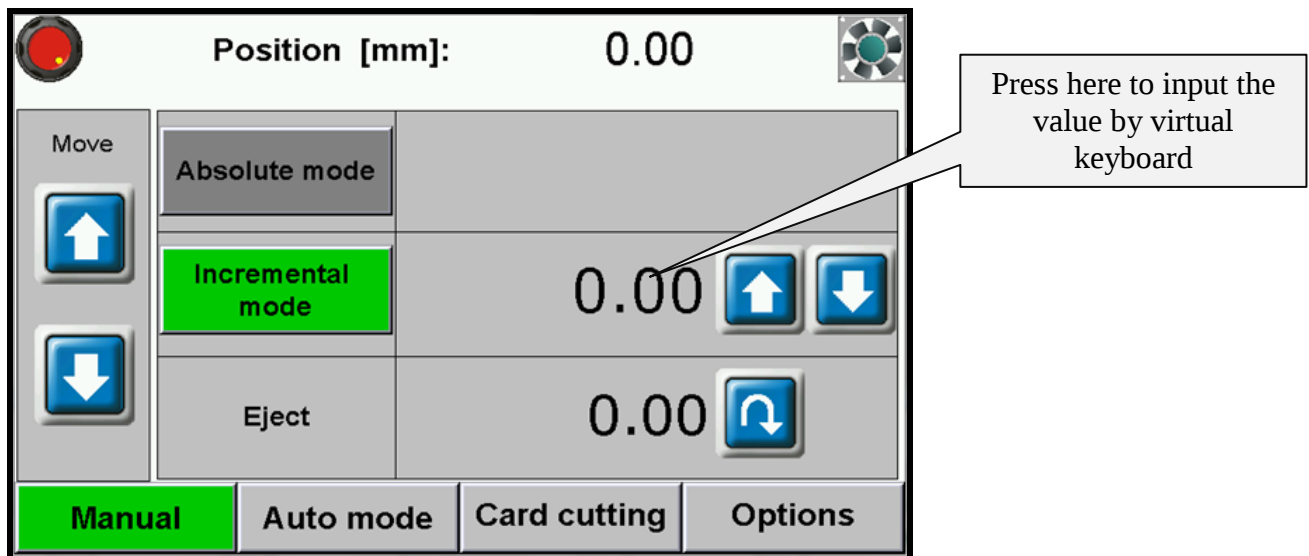
Available functions:

2.1 ABSOLUTE MODE- AUTOMATIC MOVE TO INPUT DIMENSION



To input the required dimension press the dimension on screen and input value by keyboard. Confirm by pressing button **ENT** and press . The backgauge will move to requested position.

2.2 INCREMENTAL MODE- REPEATING SAME DIMENSION ON NEXT STEPS



To move the backgauge at the same dimension multiple times, (forward or back) please input this dimension by pressing it on the screen. Use virtual keyboard and confirm by pressing **ENT** and next by pressing button   Backgauge will automatically move into given position.

It is possible to repeat the move by pressing   .Process can be repeated many times.

2.3 MANUAL BACKGAUGE MOVEMENT

The backgauge can be moved manually forwards and backwards by pressing



2.4 PAPER EJECT



By pressing  button operator can remove the paper. The backgauge automatically move forwards by given value and returns to initial position.

2.5 AIR TABLE (OPTIONAL)



Pressing the button  turns on/off air tables.

2.6 NUMERICAL KEYBOARD

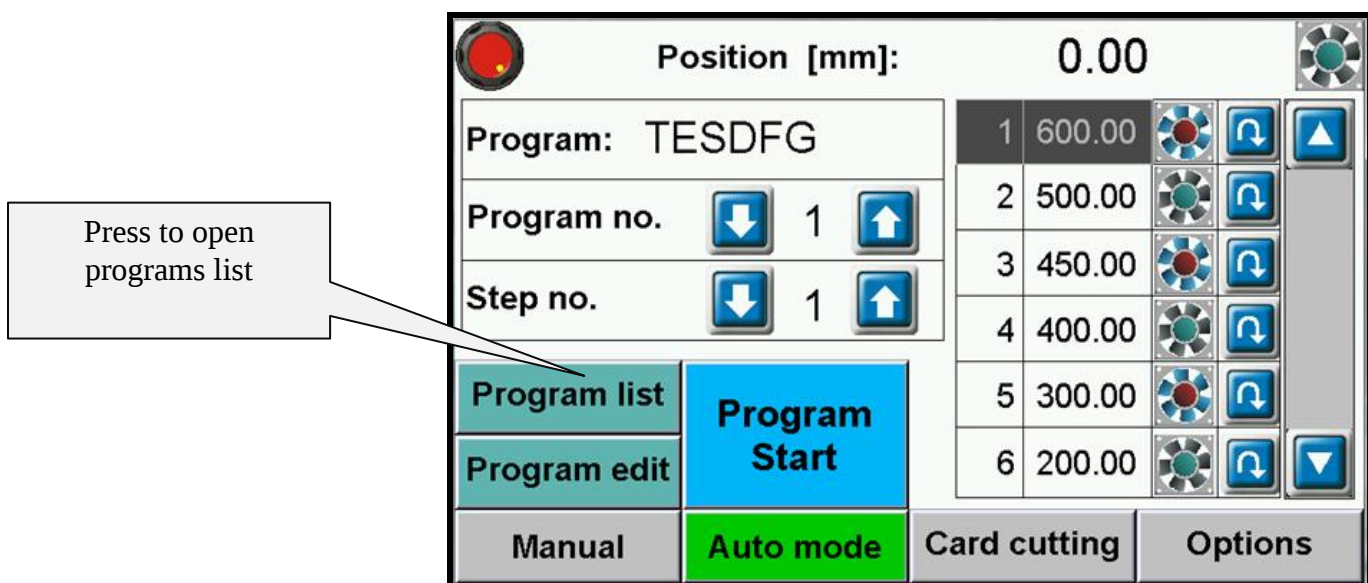


Program module includes calculator function (multiplication, division, addition, subtraction and ()).

3. AUTO MODE- PROGRAMMING

This menu allows the operator to select the program, edit and start program mode. 100 programmed jobs can be stored in memory, including 100 steps (dimensions) in each program. For each step, the operator can program eject, air and paper rotation left/right.

3.1 Program selection



Selecting the program to edit or start.

Program can be selected from the list which appears on screen after pressing program name. Program can be also selected by arrows or input program number.

To scroll through the program list, press the arrows next to the list.

Selecting a program in this window allows users to check dimensions in each step (by arrow buttons) as well as to see if options are on/off such as:

eject  or air table blower 

3.2 Launching program from memory.

To launch the program please select the requested program and press button **PROGRAM START**.

After pressing, the backgauge moves to the dimension saved in step 1 and a new screen appears:



After each cut, the backgauge moves to the next step. When the last cut is made in the selected program the backgauge automatically moves to step 1 and the program can be repeated.

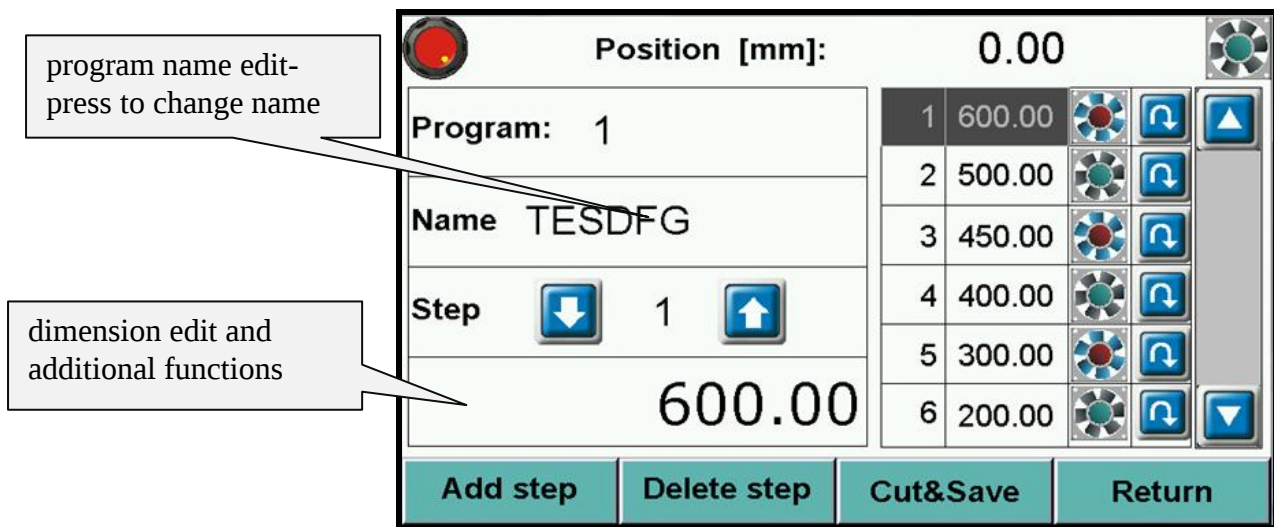
It is possible to skip cuts in a step. Press  to move the backgauge to next step without cutting. Press  to return the backgauge to previous step.

To stop program please press button **PROGRAM STOP**.

3.3 Program edit and saving.

By pressing the Program Edit button, the operator can edit a previous selected program, including dimension change, program name change, removing a step and turning on/off eject  and air table. 

After selecting program number 1 and pressing Program Edit button, a new screen appears:



To input new program name or change existing name press the window Name. Pressing opens keyboard screen which allows operator to input name.

After program name confirmation cursor automatically appears on the steps list.

To input step dimension or add: eject, air, rotation please press icons located in left bottom corner (edit window)

To save a program to memory, and exit program mode, press the Return button.

Add step -

Delete step - to delete one (current) step

3.4 Cut & Save - function allows user to edit the program by making backgauge move and cut.

After the cut, the backgauge position is automatically saved as a step.

After the next cut, it automatically changes into next step editing.

The screenshot shows the program editor interface. At the top, a red emergency stop button is on the left, and a fan icon is on the right. The text "Position [mm]: 0.00" is displayed. Below this, "Program: 1" is shown. The main area is divided into a "Move" section with up/down arrows and a "Step" section with a "1" button and up/down arrows. A large "0.00" value is shown with an up arrow button. To the right is a table with 6 rows, each containing a step number, a distance value, a fan icon, and a return button. At the bottom are three buttons: "Absolute mode" (highlighted in green), "Incremental mode", and "Return".

Move	Step
	1
0.00	

1	600.00		
2	500.00		
3	450.00		
4	400.00		
5	300.00		
6	200.00		

Absolute mode Incremental mode Return

The screenshot shows the program editor interface in incremental mode. The layout is similar to the previous one, but the "Incremental mode" button at the bottom is highlighted in green. The "Move" section now has up/down arrows. The "Step" section has a "1" button and up/down arrows. The large "0.00" value is shown with up/down arrows. The table on the right is identical to the one in the previous screenshot.

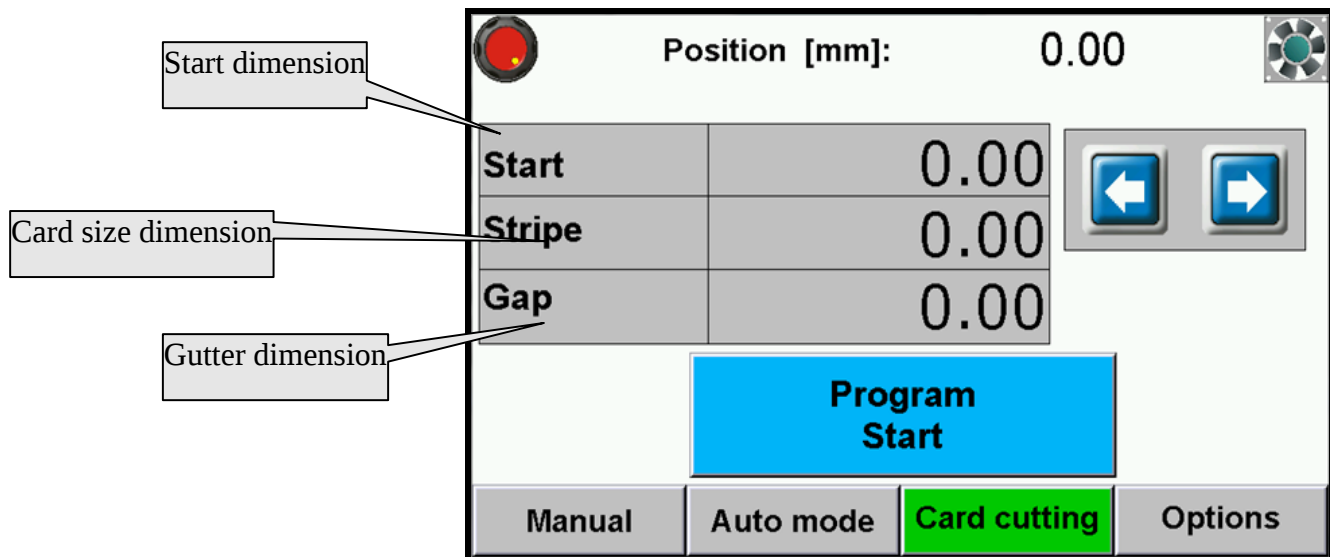
Move	Step
	1
0.00	

1	600.00		
2	500.00		
3	450.00		
4	400.00		
5	300.00		
6	200.00		

Absolute mode **Incremental mode** Return

To exit the program edit mode by making a cut, press the Return button to return to the main menu.

4. CARD CUTTING- This program allows users to make a sequence of cuts with the same distance (card size) or 2 changing dimensions (card size and gutter).



Start dimension -first cut dimension starting the card cutting sequence

Card dimension – dimension of strip

Gutter – if there is a gutter on the sheet. If there is no gutter, enter the card size again

NOTE! Remember to confirm each value but pressing ENT.

After inutting the dimension and pressing Program Start the program starts automatically:

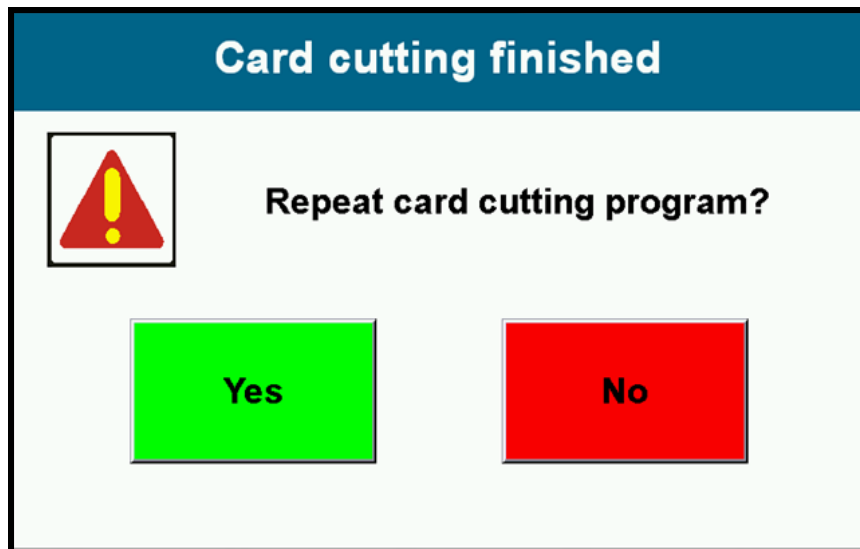


Backgauge moves into starting dimension and after each cut moves automatically to the next.

It is possible to skip cut in step. Press button  to move backgauge to next step without cut. Press button  to return backgauge to previous step.

Pressing **Program Stop** stops card cutting program.

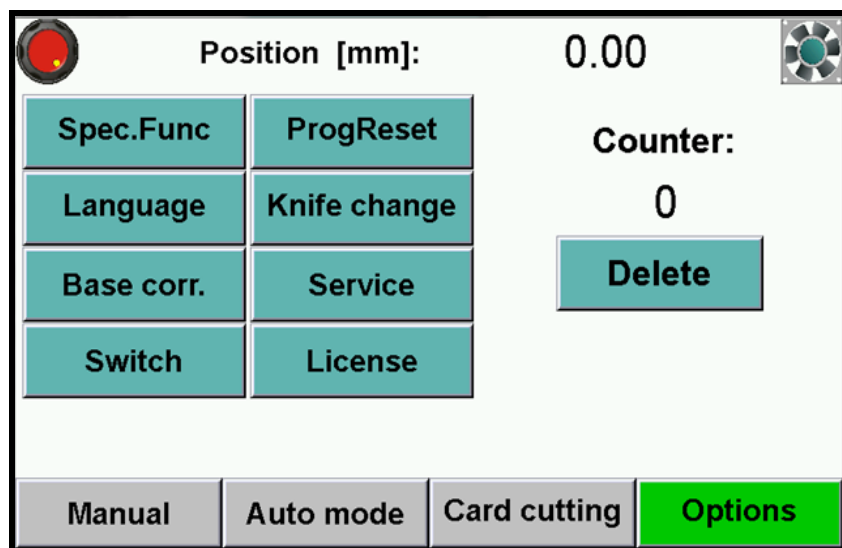
After each cycle when last strip is too narrow to cut, this text will appear:



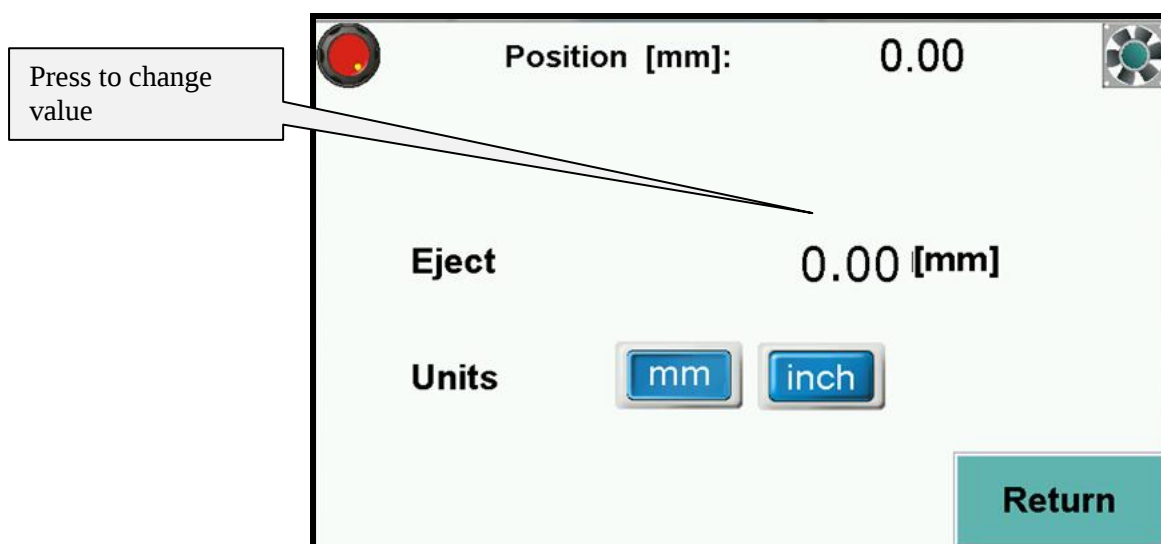
Pressing **YES** moves backgauge automatically into first dimension.

Pressing **NO** exits program.

5. OPTIONS

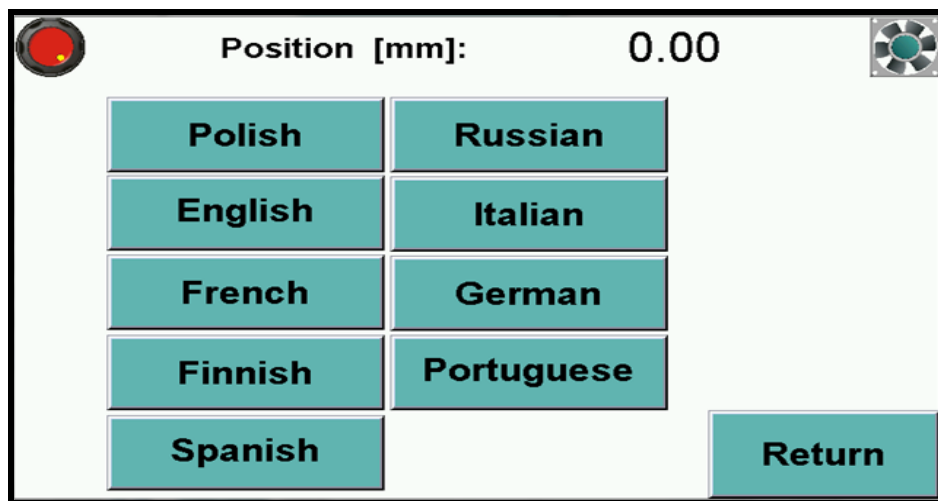


5.1 Special functions



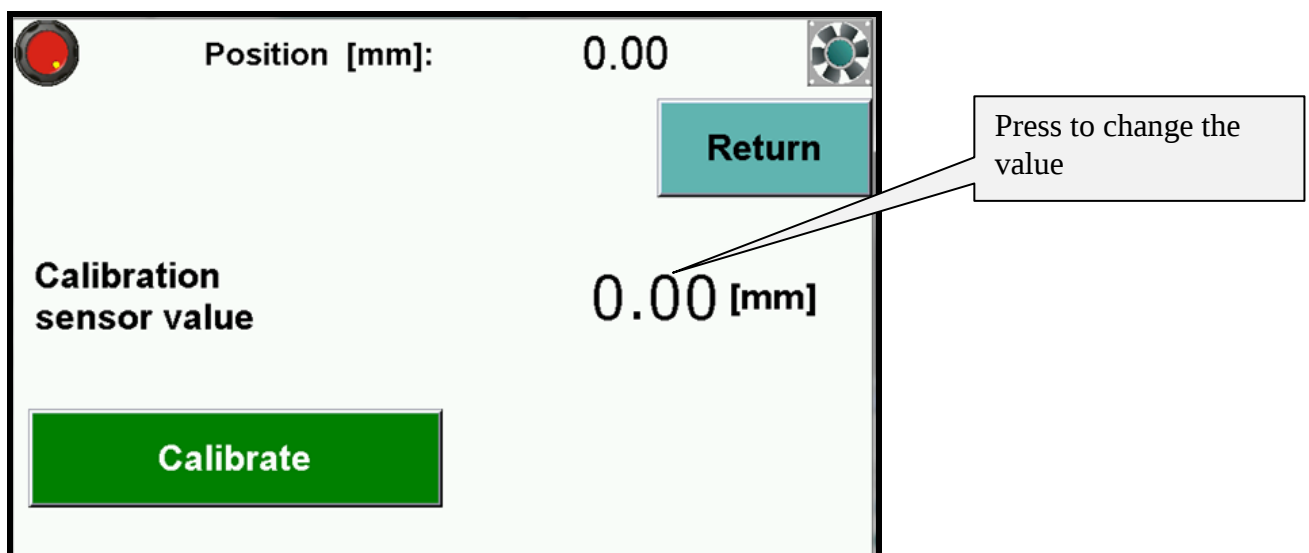
Eject can be set in mm or inches. It is the value by which the paper ream moves forward. After cycle, the backgauge returns to the previous position.

5.2 Language– to enter language selection menu



5.3 Base correction – Base dimension corr.

allows to redo calibration without turning off guillotine and optional correction of dimension (if display dimension does not correspond to real, measured dimension)



When starting machine operator should measure the paper cut and compare with actual display indication. If both dimensions do not correspond to each other input the base correction.

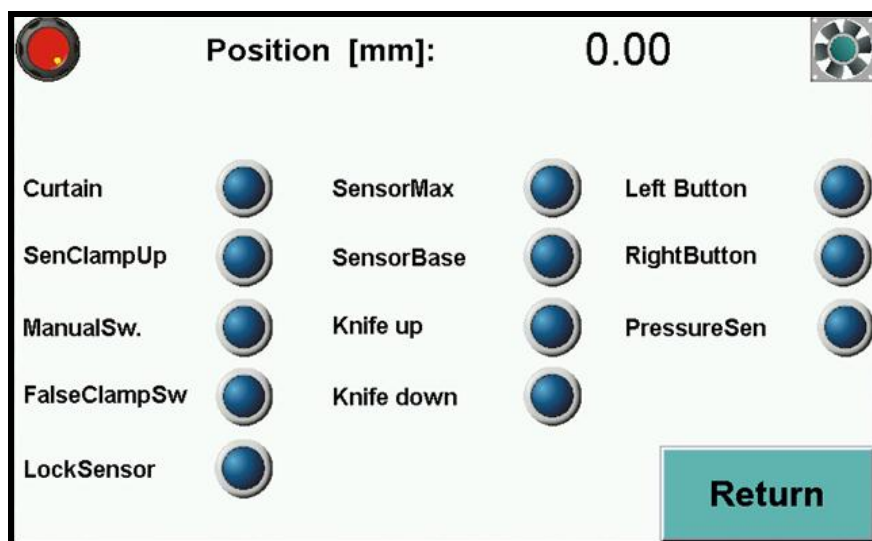
How to make base dimension adjustment:

- move backgauge into position, for example 100.0mm
- cut paper
- measure the size
- if measured size is 103.7mm, the operator should change dimension by increasing the value (difference between screen and real size) 3.7mm in this example. (i.e.: if dimension is 680.0mm, change it to 683.7mm).
- if measured dimension is 98.4mm, make correction by decreasing the value (difference between screen and real size) by 1.6mm.

(example: if dimension of base is 680.0mm, change value to 678.4mm).

After base dimension change press button **Calibrate** to save adjustment.

5. 4 Diagnostics

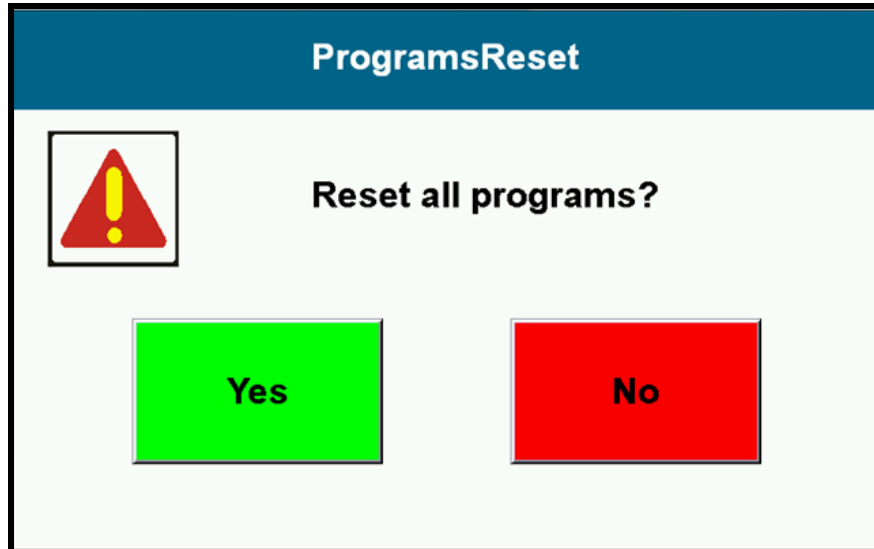


Allows operator to check control system elements like optical sensors, limit switches, buttons, micro switches.

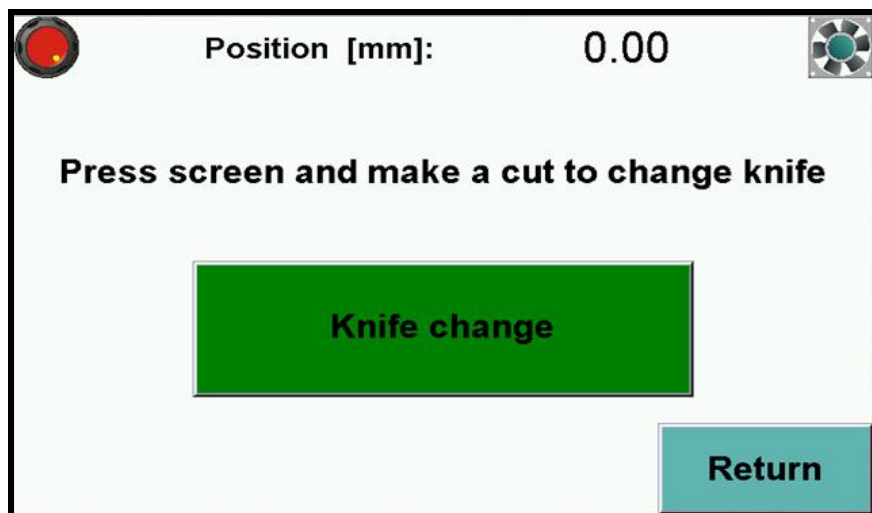
Back lighted button means that this element is active

5.5 Reset programs – program cancelling.

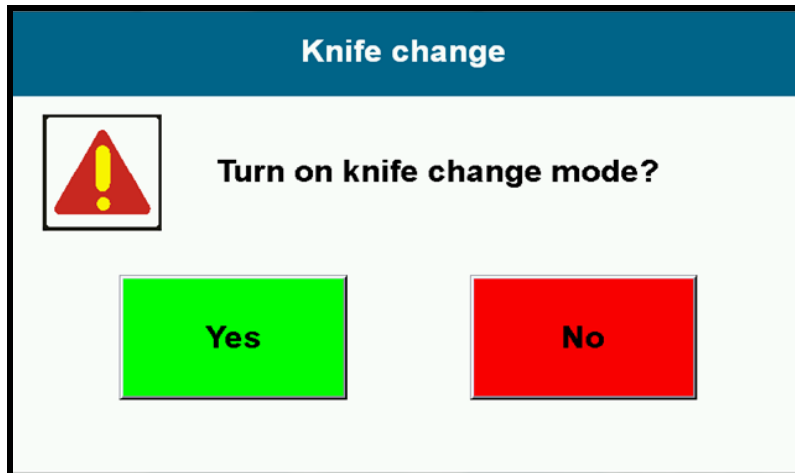
This options resets all saved programs.



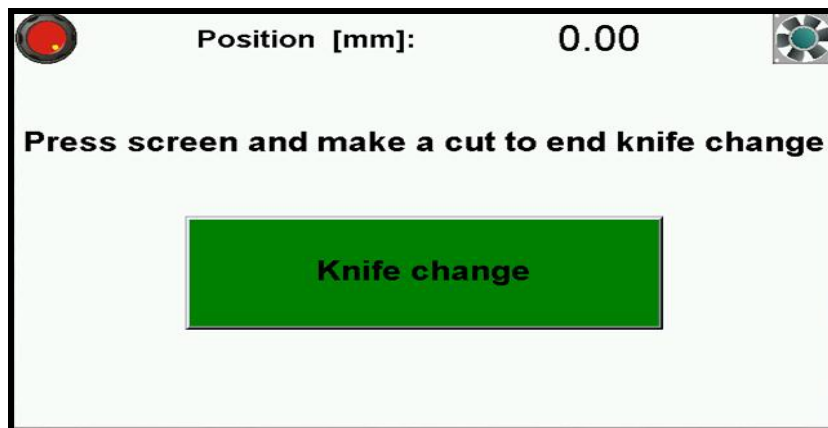
5.6 Kinfe Change - to enter knife change mode Knife Change button



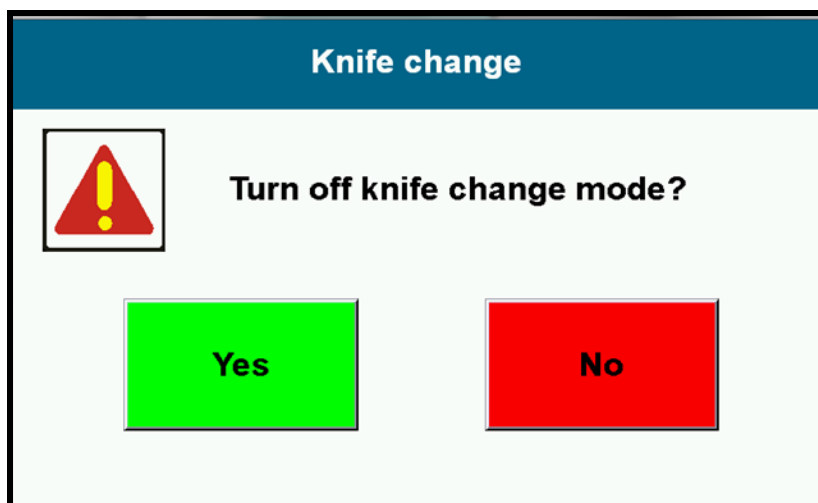
After pressing text on screen appears to confirm **Turn on knife change mode?**



Confirm and make a cut to put knife into lower position.
After knife change (please refer to Operator Manual for procedure), press the Knife Change button again



text appears **Turn off knife change mode?** By pressing the mode is being closed.



Press Yes and make a cut to exit knife change mode.

5.7 Service – to enter service mode

Press **Service** button. Keyboard appears on screen to input service code XXXX and press **ENTER**.

*****				Esc
0	1	2	3	CLR
4	5	6	7	DEL
8	9	A	B	Enter
C	D	E	F	

NOTE! The code is for service information only

SERVICE	
Dimensions	Test
Encoder	Counter: 0
Factory	
Calibration	
License	
Return	

5.7.1 SERVICE- dimensions.

Min dim.1	0.00	mm	Return
Min dim.2	0.00	mm	
Max dim.	0.00	mm	

- **Min. dim. 1** – min. value for guillotine backgauge automatic move in program mode (with false clamp)

- **Min. dim.2** – min. value for guillotine backgauge automatic move in program mode (without false clamp)

- **Max. dim.** – max. value for guillotine backgauge automatic move in program mode

5.7.2 Service– Encoder

Return

Screw rot.

5.00 mm/rot

Encoder type

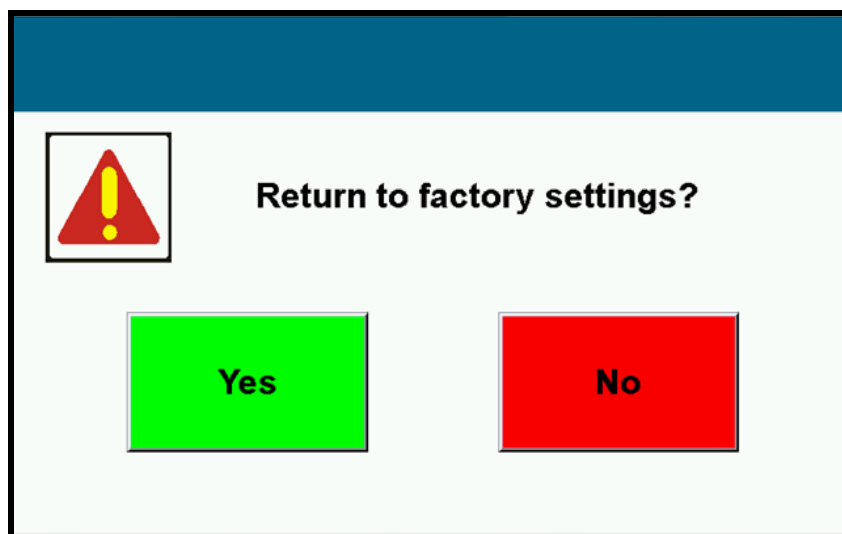
600 pls/rot

- **screw rot.** – mm by lead screw rotation (backgauge)

- **encoder type** – impulses per rotation of encoder

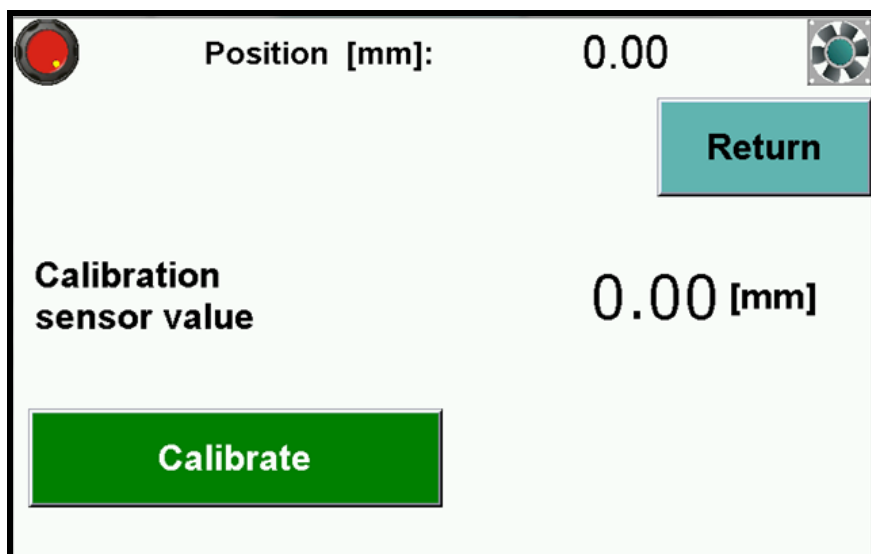
5.7.3 Service – Factory settings

All parameters in windows **Dimension** and **Encoder** can be cancelled by function **Factory settings** (but may need readjustment depending on equipment in the machine)



Press **Yes** to return to factory settings.

7.4 Service – Calibration



Calibration– allows to repeat calibration without machine turn off and dimension correction if needed. (see **5.3 Base correction**)

5.7.5 Service – Test

Cut time	0.0	Clamp time	0.0
Return delay	0.0	Pressure time	0.0
Off move	0.00	Return	
Move	0.00		
RH speed	0.00		
RL speed	0.00		
Position [mm]:	0.00	0.00	
Incremental mode	0.00	↑	↓

press and input value by keyboard

- **Off move** –distance before dimension when backgauge drive is off
- **Move**– distance where fast backgauge movement is off before reaching position (how long backgauge moves slowly into dimension)

Speed RH - frequency of backgauge speed movement

Speed RL - frequency of backgauge speed, move on the dimension

In the Position table, the first dimension is actual dimension of paper
seconde is dimension close to actual