Core Assembly Machine Instruction

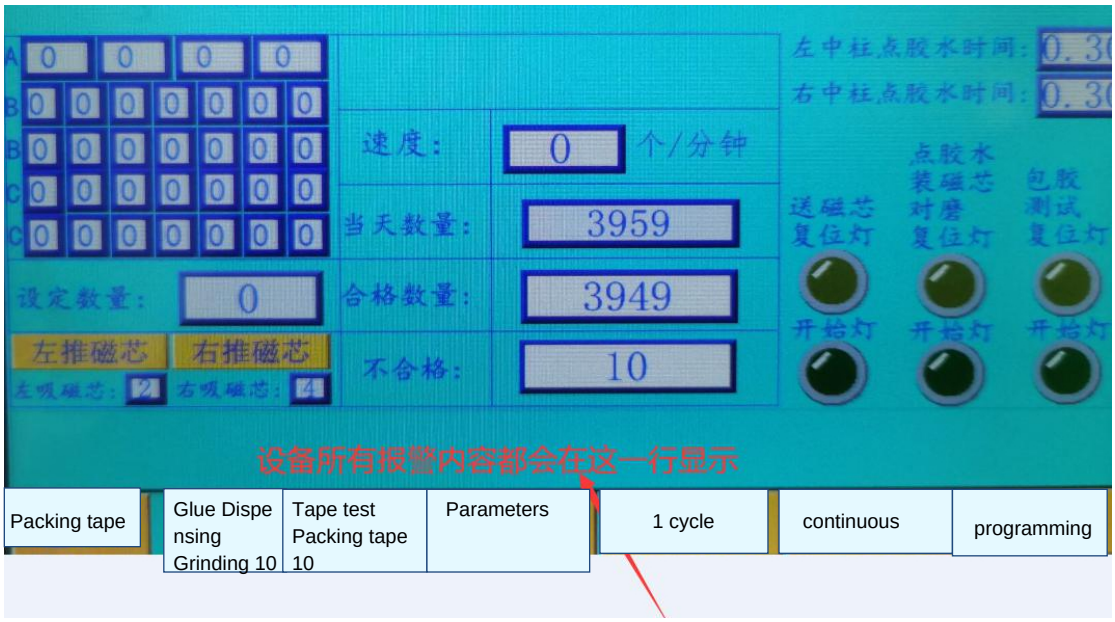
Catalog

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One、Main Interface picture below



All alarm of this equipment will show on this line.

A B C number space on left of display is program thread.

Setting number: machine stop working when qualified quantity reached the setting number.

Speed:the running speed of machine

The number of the day:indicates the machine produce the number of output.

Qualified number: the number of qualified products.(The data can be cleared with long press)

Unqualified number:the number of unqualified products.(The data can be cleared with long press)

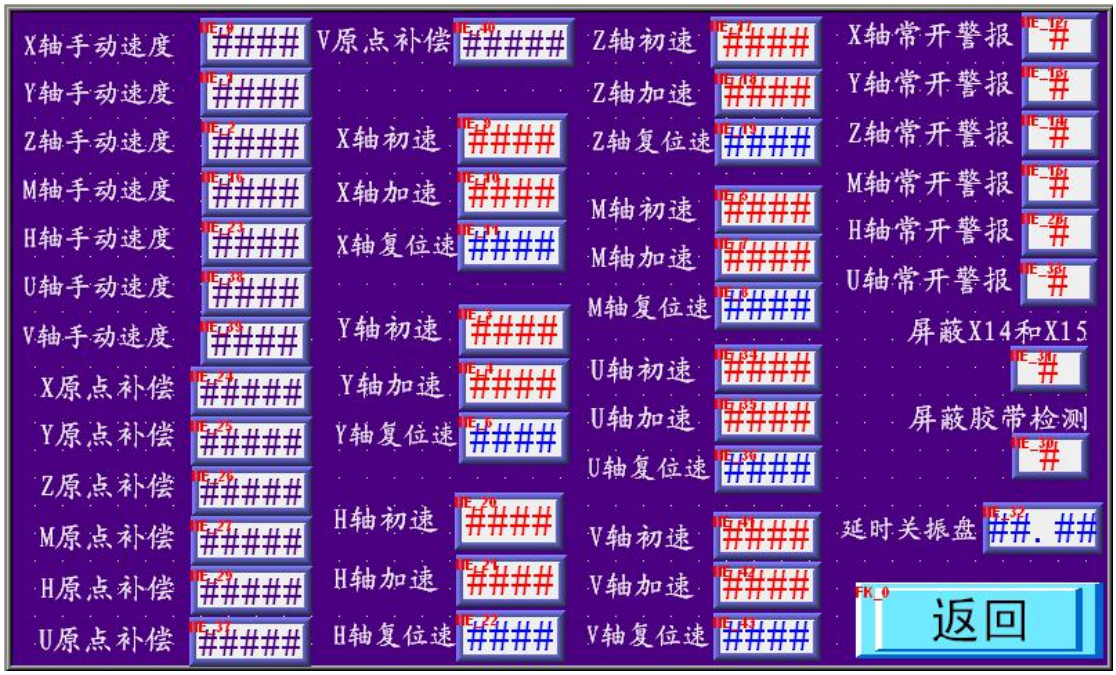
Parameter: click this button to switch parameter setting interface.

Programming: click this button switch to programming interface.

1 period/ automatic cycle: this button can make machine to cycle automatically or work 1 period.

Continuous/single step: this button can make machine operate with single step/continuous operation.(When it is set to single step, machine runs a step by pressing a key.)
Unqualified number: display the unqualified number
Qualified number: display qualified number
Qualified number limit: when qualified number reach the setting value, machine stop running.

Two、Parameter Setting



X axis manual speed: this value indicates X axis jogging speed

Y axis manual speed: this value indicates Y axis jogging speed

Z axis manual speed: this value indicates Z axis jogging speed

M axis manual speed: this value indicates M axis jogging speed

H axis manual speed: this value indicates H axis jogging speed

U axis manual speed: this value indicates U axis jogging speed

V axis manual speed: this value indicates V axis jogging speed

X axis origin compensation: this value indicates after X axis find out origin sensor, then move to this value position, then take this position as the origin.
Y axis origin compensation: this value indicates after Y axis find out origin sensor, then move to this value position, then take this position as the origin.
Z axis origin compensation: this value indicates after Z axis find out origin sensor, then move to this value position, then take this position as the origin.
M axis origin compensation: this value indicates after M axis find out origin sensor, then move to this value position, then take this position as the origin.
H axis origin compensation: this value indicates after H axis find out origin sensor, then move to this value position, then take this position as the origin.
U axis origin compensation: this value indicates after U axis find out origin sensor, then move to this value position, then take this position as the origin.
V axis origin compensation: this value indicates after V axis find out origin sensor, then move to this value position, then take this position as the origin.
X axis initial speed: indicates initial speed of X axis when machine is moving.
X axis acceleration: indicates accelerated speed of X axis when machine is moving.
X axis reset speed: the speed that sense the sensor when the machine X axis reset.
Y axis initial speed: indicates initial speed of Y axis when machine is moving.
Y axis acceleration: indicates accelerated speed of Y axis when machine is moving.
Y axis reset speed:the speed that sense the sensor when the machine X axis reset.

Z axis initial speed: indicates initial speed of Z axis when machine is moving.Z axis acceler ation: indicates accelerated speed of Z axis when machine is moving.

Z axis reset speed: the speed that sense the sensor when the machine X axis reset.

M axis initial speed:indicates initial speed of M axis when machine is moving.M axis accel eration: indicates accelerated speed of M axis when machine is moving.

M axis reset speed:the speed that sense the sensor when the machine M axis reset.

H axis initial speed:indicates initial speed of H axis when machine is moving.H axis acceler ation:indicates accelerated speed of H axis when machine is moving.

H axis reset speed:the speed that sense the sensor when the machine H axis reset.

U axis initial speed:indicates initial speed of U axis when machine is moving.U axis acceler ation:indicates accelerated speed of U axis when machine is moving.

U axis reset speed:the speed that sense the sensor when the machine U axis reset.

V axis initial speed:the speed that sense the sensor when the machine V axis reset.

V axis acceleration:the speed that sense the sensor when the machine V axis reset.

V axis reset speed:the speed that sense the sensor when the machine V axis reset.

Shield X14/X15: when this value is 1, it indicates shielding detect the functionthat the core assembly machine works again.

Shield tape test: when this value is 1, it indicates the function that the machineworks again wh ile shield test tape wrap materials.
Delay close vibrator: when vibrator detect fiber optic detect there are materials,it vibrate for m any more seconds until stop vibrate.

Three、Programming
1、Assembly core motor programming





X clamping materials position: indicates X axis move to the clamping materialscoordinate of asse mbly core.

X discharge position: indicates X axis move to discharge coordinate of taping

X middle position: indicates X axis coordinate of middle position

M clamping materials position: indicates M axis move to the clamping materials coordinate of test position.

M discharge position: indicates M axis move to discharge coordinate of test position.

U clamping materials position: indicates X axis move to the clamping materials coordinate of test position

U discharge position:indicates U axis move to discharge coordinate of location of sorting qualified products

U middle position: indicates U axis coordinate of middle position

X axis speed: the running speed of X axis

Y axis speed: the running speed of Y axis

Z axis speed: the running speed of Z axis

M axis speed: the running speed of M axis

H axis speed: the running speed of H axis

U axis speed: the running speed of U axis

V axis speed: the running speed of V axis

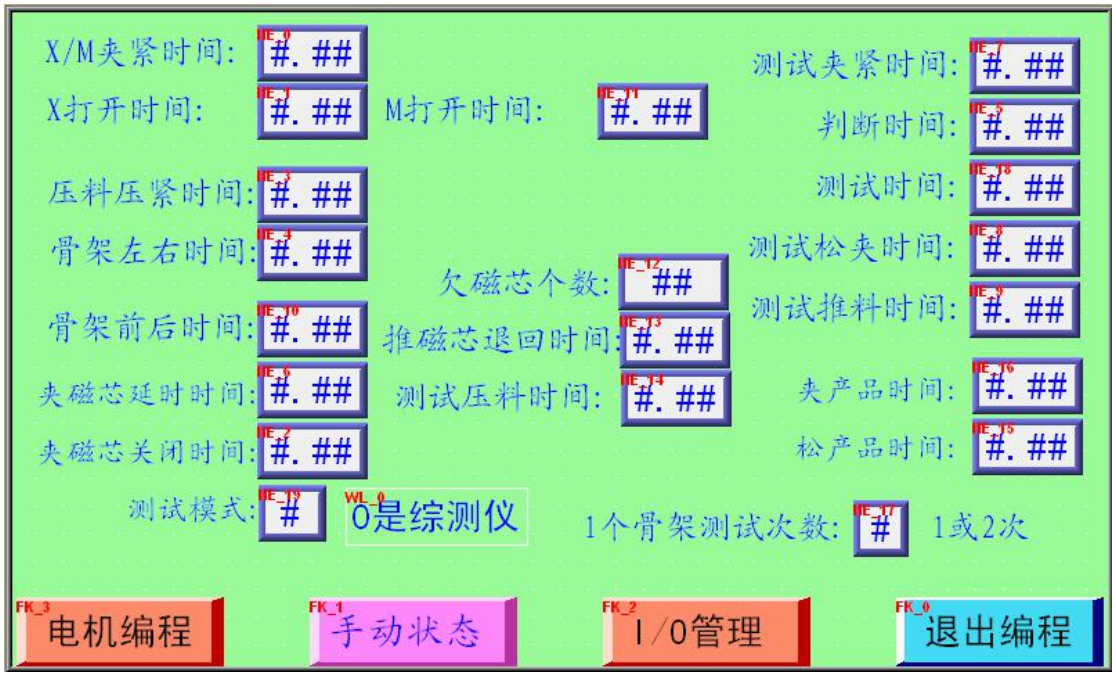
X＜the value start feeding: indicates when X axis coordinate less than this value, start the step that transport bobbins.

X＞the value start Z axis: when X axis coordinate more than this value, it starts rotating disk rotates.

Z＞the value start M axis: when Z axis coordinate more than this value, activate M axis to clamp materials.

Z＞the value start Y17: when Z axis coordinate more than this value, activate Y17 to cut tape.

H<the value start Y axis: when when H axis coordinate less than this value, activate Y axis encapsulating.
Z half-turn position: indicates the coordinate of half turn of Z axis taping disk.H axis positio n: indicates H axis coordinate while cutting tape.
V axis position: indicates V axis coordinate when machine is testing.
The number of Y axis rotation turns: indicates the number of taping.
2. Assemble core time programming



X/M clamp time: indicates delay of clamping cylinder of X/M axis opening action.

X opening time: indicates delay of cylinder action of X axis OFF.

M opening time: indicates delay of press bobbins action.

The time of press materials: indicates press bobbins action delay.

The time of bobbins L and R: indicates delay of push bobbin cylinder.

The time of bobbins Fr and Back: indicates delay of front and back of insert bobbin action.

Clamp core delay: after pushing core forward for so long, then clamp core.

The time of clamp core close: indicates delay of cylinder of no clamping core action.

Test model: 0 means with tester, 1 means test plate mode.

The number of lack of magnetic core: when magnetic core fiber test no materials, machine will work many times then stop.

The time of pushing magnetic core back: the time of status of magnetic core cylinder action OFF.

The time of test press material: the time of test press material cylinder action

The time of test clamp: delay of test needle move forward after sensor detect in place.

Test time: overall time spent testing

Test time and think time, according to test content, less content and less time, more content and more time.

The time of test loose clamp: delay of test needle move backward action

The time of pushing material: delay of pushing material to test cylinder action

Clamp product time: U axis clamp cylinder clamp material delay

Loose product time: U axis clamp cylinder loose material delay.

The numbers of 1 bobbin test: the value indicates 1 product test how many times (if products are tested 2 times, only one time of these 2 times passed will be qualified, 2 times are all unqualified as unqualified)

3、Magnetic core motor programming



X axis clamp material position: indicates the left initial position coordinate of absorb magnetic core.

X axis set material position: indicates position coordinate of put magnetic core down to conveyor on left

X insert froth position: indicates the position coordinate of insert froth on left

Y axis clamp material position: indicates right initial position coordinate of absorb magnetic core.

Y axis set material position: indicates position coordinate of put magnetic core down to conveyor on right

Y insert foam position: indicates the position coordinate of insert froth on right

Z up offset: indicates the left core disk rises the offset coordinate of one foam disk.

Z down offset: indicates the left core disk decreases the offset coordinate of one foam disk.

M up offset: indicates the right core disk rises the offset coordinate of one foam disk.

M down offset: indicates the right core disk decreases the offset coordinate of one foam disk.

The line number of foam board is according to actual line number, line spacingi s manually moved to the last line, minus the first line coordinate number, get the value divide by the line number of foam board(less one line) get the line spacing value.

V/U limit will alert if pushing core mechanism reach the input value and not reach the limit yet, there is magnetic core get stuck or core direction is different V/U pushing core sensor, sensing a core will stop pushing the core V/U.

X axis speed: the running speed of conveyor X axis

Y axis speed: the running speed of conveyor Y axis

M axis speed: the running speed of conveyor M axis

H axis speed: the running speed of conveyor H axis

U axis speed: the running speed of conveyor U axis

V axis speed: the running speed of conveyor V axis

Line spacing: the spacing coordinates of the two rows of cores connected.

Line number: indicates the numbers of core on 1 foam box.

4.Core time programming



Left top delay: indicates the left suction core seat move up delay

Left bottom delay: indicates the left suction core seat move down delay

Left suction core delay: indicates the action that the left suction cylinder move downd elay.

Left release core delay: indicates the action that the left release cylinder move up delay.

Forward push left core delay: indicates the action that left push core forward delay.

Backward push left core delay: indicates the action that left push core backward action delay

Left insert foam delay: indicates left insert foam delay

Left back foam delay: indicates left back foam delay

Left conveyor belt delay: indicates after the left conveyor belt stop for long time, then put core in it.

Left foam plate delay:indicates after left back foam plate move for long time,then move shaft to attract core.

Left conveyor belt sensor: indicates the time of left test core

The right top delay: indicates right suction core seat move upward action delay

The right bottom delay: indicates right suction core seat move upward action delay

Right suction core delay: indicates right suction core cylinder moving down action delay

Right discharge core delay: indicates right discharge core cylinder moving up action delay

Right push core backward delay: indicates right push core moving forward action delay

Right push core backward delay: indicates right push core backward action delay

Right insert foam delay: indicates left insert foam delay

Right back foam delay: indicates right back foam delay

Right conveyor belt delay: indicates after left conveyor belt stop for long time, then put core.

Right foam plate delay: indicates after foam plate back right for long time, then move shaft to attract core

Right conveyor belt sensor: indicates the time of right test core.