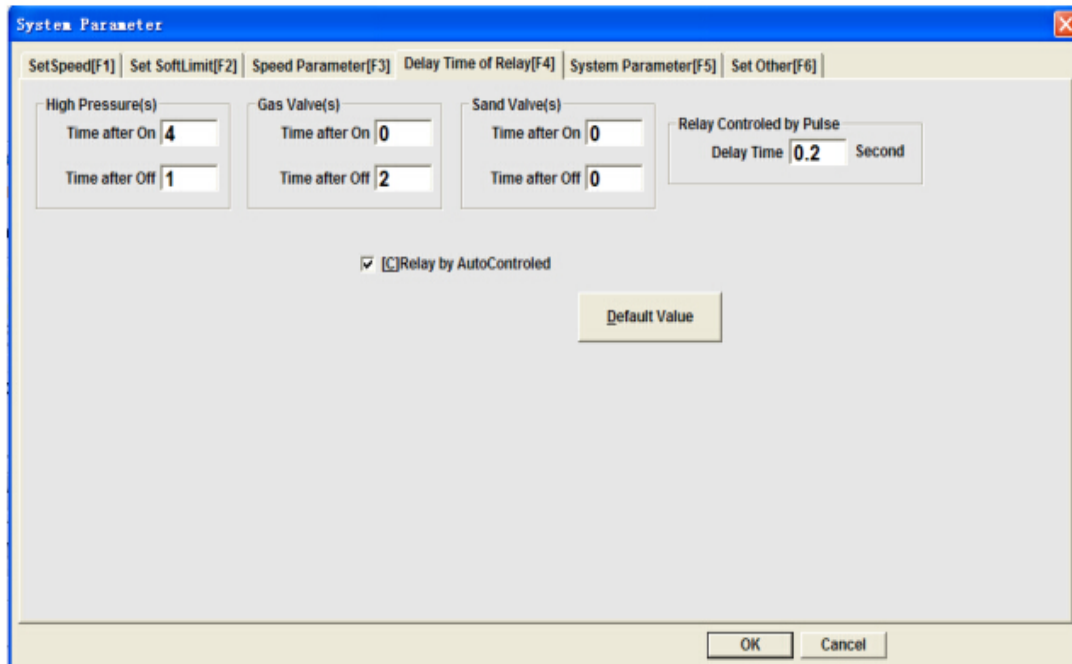


Parameter Setting for Metal Cutting:



HIGH PRESSURE

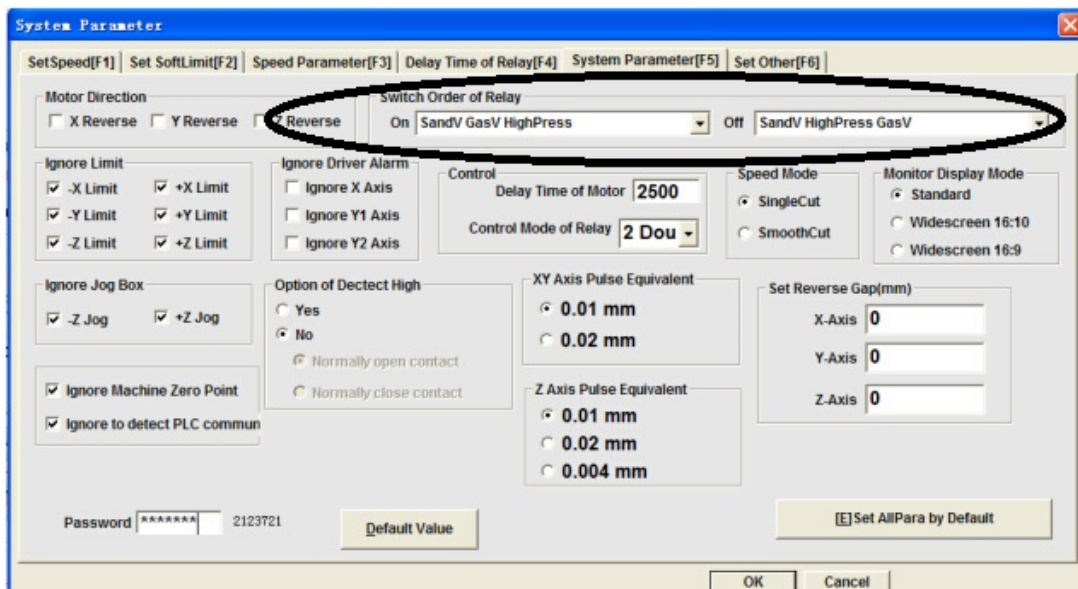
Time after on: This is to set the piercing time, depending on the metal thickness.

Time after off: Set to 2

GAS VALVE

TIME after off: Set to 0

No need to change other parameters.



Change the relay on/off sequence as marked in the above picture:

ON: sandV gasV highpress

OFF: sandV highpress gasV

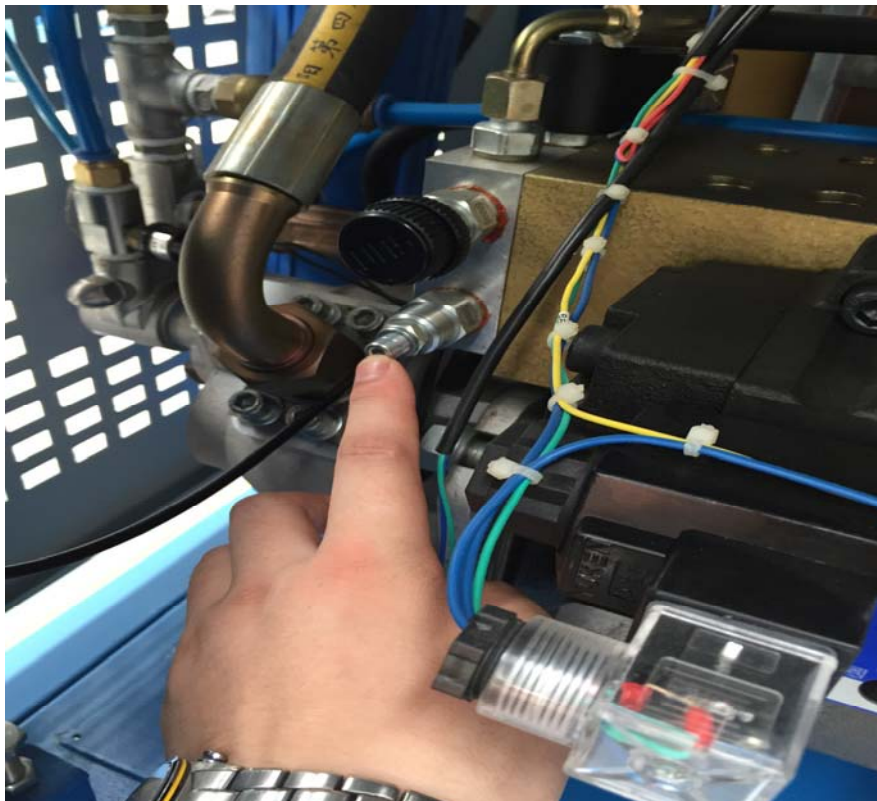
Parameter Setting for Glass Cutting:

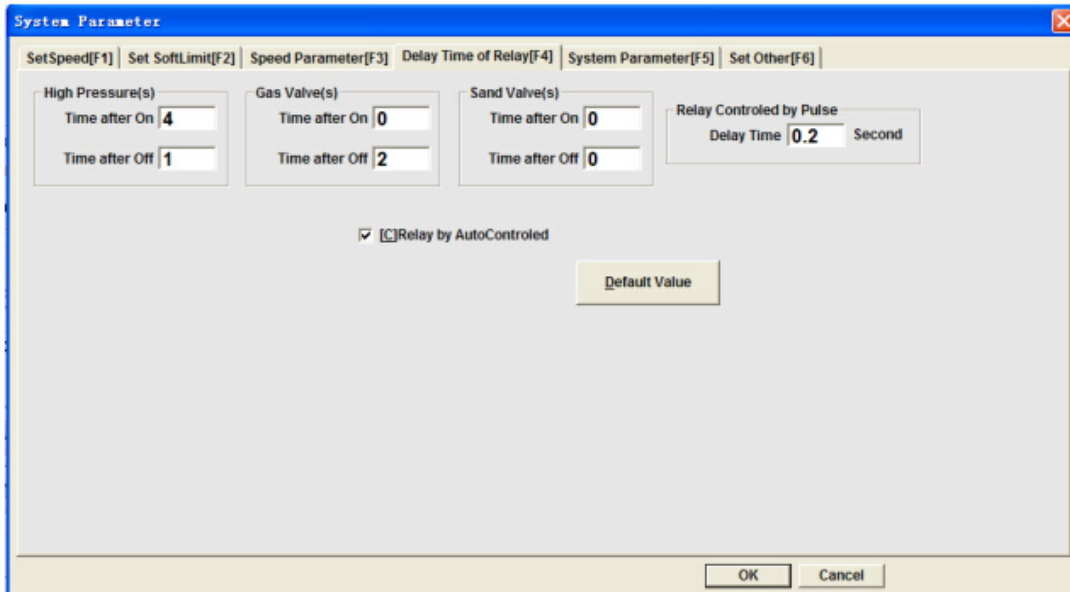
Please first turn down the low pressure to 5Mpa



How to turn down the low pressure:

Open “oil pump”, and open “gas valve” in the software. Turn the valve in below picture to reduce the low pressure.





Parameter Setting:

High Pressure:

TIME after on: This is to set the piercing time, depending on the glass thickness.

TIME after off: 2

GAS VALVE:

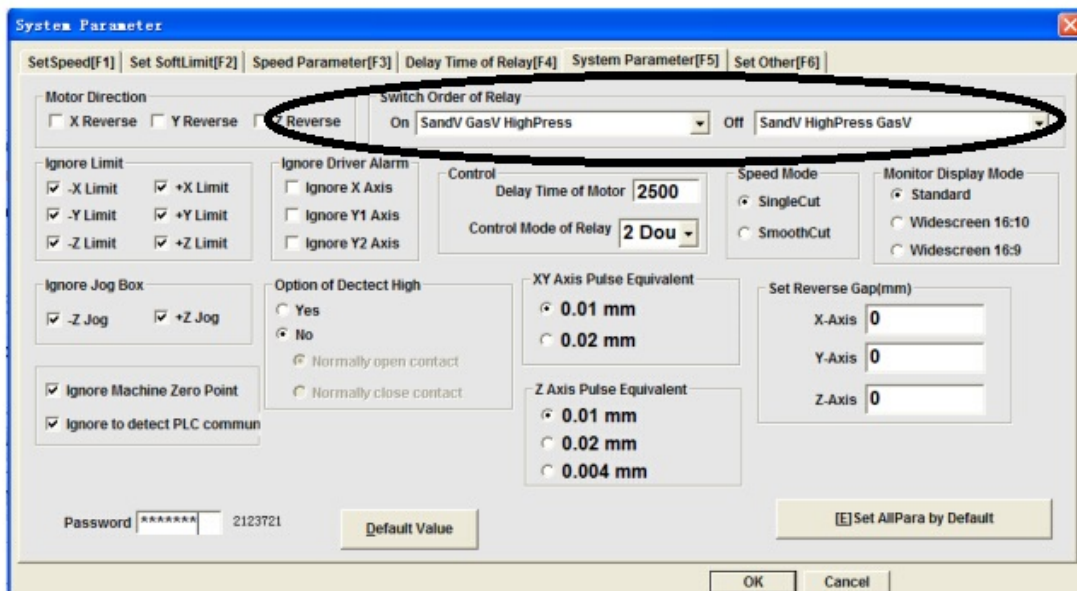
TIME after on: 2

TIME after off: 0.3

SAND VALVE:

TIME after on: 0.5

TIME after off: 0



Change the relay on/off sequence as marked in the above picture.

ON: sandV gasV highpress

OFF: highpress gasV sandV