



# F-1227 校正指導手冊



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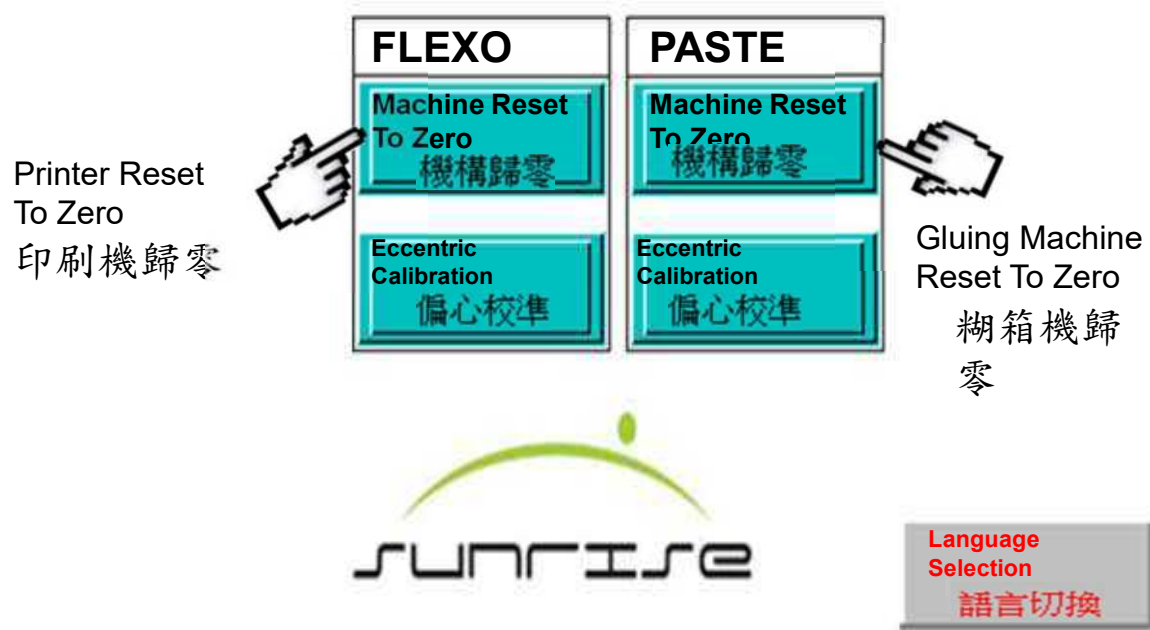
## 1-1. 校正專用人機操作歸零參數路徑

### Calibration For Special HM Operation Reset To Zero Of Parameter Route 校正專用人機操作歸零參數路徑

Main Screen

主畫面

■ Select the calibration machine position, then press the zero setting.  
選擇所要校正的機構位置，按下零點設定。





## 1-1. 校正專用人機操作歸零參數路徑

Machine Reset To Zero Content (FLEXO)  
機構歸零目錄 (FLEXO)

■ Select the calibration machine unit  
選擇所要校正的機構單元。



**Reset to Zero Operation Introduction**  
歸零操作介紹

■ Select the calibration machine position, press 選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

Position lateral move of JOG control  
OS : Toward operating side  
DS : Toward driving side  
位置橫移吋動控制  
OS : 往操作側 DS : 往驅動側

The screenshot shows a control panel titled "Machine Reset To Zero" (機構歸零 (送料部)). It is divided into three columns, each representing a different "Machine Unit" (機台單元). Each column contains the following information:

- Machine Position (機構位置):** A label for the selected unit.
- Current Pulse (目前脈波):** A numerical value, currently showing -1234567890.
- Current Position (目前位置):** A numerical value, currently showing -12345, f12345, and -12.34.
- Buttons:** Below the position display are buttons for "OS" (Toward operating side), "DS" (Toward driving side), "F" (Forward), "B" (Backward), "+", and "-".
- Zero Setting:** A large button at the bottom of each column.

A hand icon indicates a mouse click on the "Zero Setting" button of the middle column.

Machine position forward and backward moving :  
F: Forward  
B: Backward 機構位置前後移動  
F: 前進  
B: 後退

Gap subtraction JOG control  
間隙加減吋動控制

**CONTENT**  
目錄

Return Content Screen  
返回目錄畫面

Reset To Zero Button

Change to next page, previous page  
切換下一頁、上一頁

## Feeder Unit送紙部

Feeder Unit Reset To Zero Page-1  
送紙部歸零頁面 — 1


■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Feeder Unit)**  
機構歸零 (送料部)

OS Side Gate	Front Gate Gap	Pull Collar Lift
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 -12345	<b>Current Position :</b> 目前位置 -12.34	<b>Current Position :</b> 目前位置 -12.34
OS    DS	+    -	+    -
<b>Zero Setting</b> 零點設定	<b>Zero Setting</b> 零點設定	<b>Zero Setting</b> 零點設定

CONTENT 目錄



Feeder Unit Reset To Zero Page-2  
送紙部歸零頁面 — 2

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

Machine Reset To Zero (Feeder Unit) 機構歸零 (送料部)		
<b>Brush Wheel Gap</b> 毛刷輪間隙	<b>Back Stop Position</b> 後擋板位置	<b>DS Side Gate</b> DS側擋板
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 -12345	<b>Current Position :</b> 目前位置 -12.34	<b>Current Position :</b> 目前位置 -12.34
OS    DS	+  -	+  -
<b>Zero Setting</b> 零點設定	<b>Zero Setting</b> 零點設定	<b>Zero Setting</b> 零點設定

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## Print Unit印刷部

Print Unit Reset To Zero Page Of 1st Color  
印刷部歸零頁面第1色

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Printing 1)**  
機構歸零 1

Creasing Gap 版壓間隙	Impression Gap 印壓間隙	Lateral Move Position 橫移位置
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 -123.45	<b>Current Position :</b> 目前位置 -123.45	<b>Current Position :</b> 目前位置 -123.45
<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; height: 40px; text-align: center; font-size: 24px;">+</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; height: 40px; text-align: center; font-size: 24px;">-</div> </div>	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; height: 40px; text-align: center; font-size: 24px;">+</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; height: 40px; text-align: center; font-size: 24px;">-</div> </div>	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; height: 40px; text-align: center; font-size: 24px;">OS</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; height: 40px; text-align: center; font-size: 24px;">DS</div> </div>
<b>Zero Settina</b> 零點設定	<b>Zero Settina</b> 零點設定	<b>Zero Settina</b> 零點設定

**CONTENT**  
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Print Unit Reset To Zero Page Of 2nd Color  
印刷部歸零頁面第2色

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

Machine Reset To Zero (Printing 2) 機構歸零 2		
Creasing Gap 版壓間隙	Impression Gap 印壓間隙	Lateral Move Position 橫移位置
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 -123.45	Current Position : 目前位置 -123.45	Current Position : 目前位置 -123.45
+   -	+   -	OS   DS
Zero Settina 零點設定	Zero Settina 零點設定	Zero Settina 零點設定

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Print Unit Reset To Zero Page Of 3rd Color  
印刷部歸零頁面第3色

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Printing 3)**  
機構歸零 3

Creasing Gap 版壓間隙	Impression Gap 印壓間隙	Lateral Move Position 橫移位置
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 -123.45	<b>Current Position :</b> 目前位置 -123.45	<b>Current Position :</b> 目前位置 -123.45
+    -	+    -	OS    DS
<b>Zero Settina</b> 零點設定	<b>Zero Settina</b> 零點設定	<b>Zero Settina</b> 零點設定

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Print Unit Reset To Zero Page Of 4th Color  
印刷部歸零頁面第4色

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

Machine Reset To Zero (Printing 4) 機構歸零 4		
Creasing Gap 版壓間隙	Impression Gap 印壓間隙	Lateral Move Position 橫移位置
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 -123.45	Current Position : 目前位置 -123.45	Current Position : 目前位置 -123.45
+   -	+   -	OS   DS
Zero Settina 零點設定	Zero Settina 零點設定	Zero Settina 零點設定

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Print Unit Reset To Zero Page Of 5th Color  
印刷部歸零頁面第5色

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Printing 5)**  
機構歸零 5

Creasing Gap 版壓間隙	Impression Gap 印壓間隙	Lateral Move Position 橫移位置
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 -123.45	<b>Current Position :</b> 目前位置 -123.45	<b>Current Position :</b> 目前位置 -123.45
<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">+</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">-</div> </div>	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">+</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">-</div> </div>	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">OS</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">DS</div> </div>
<b>Zero Settina</b> 零點設定	<b>Zero Settina</b> 零點設定	<b>Zero Settina</b> 零點設定

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## Slotter Unit開槽部

Slotter Unit Reset To Zero Page — 1  
開槽部歸零頁面— 1

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Slotter Unit)**  
機構歸零 (開槽部)

Knife 3 刀3	Knife 2 刀2	Knife 1 刀1
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 -1234.5	<b>Current Position :</b> 目前位置 -1234.5	<b>Current Position :</b> 目前位置 -1234.5
OS DS	OS DS	OS DS
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

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Slotter Unit Reset To Zero Page — 2  
開槽部歸零頁面— 2

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

Machine Reset To Zero (Slotter Unit) 機構歸零 (開槽部)		
Front Pre-creaser 1 Gap 前破壞1間隙	Knife 5 刀5	Knife 4 刀4
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 -12.34	Current Position : 目前位置 -1234.5	Current Position : 目前位置 -1234.5
+   -	OS   DS	OS   DS
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

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Slotter Unit Reset To Zero Page — 3  
開槽部歸零頁面— 3

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Slotter Unit)**  
機構歸零 (開槽部)

Creasing Gap 壓線間隙	Front Pre-creaser 5 Gap 前破壞5間隙	Front Pre-creaser 2,3,4 Gap 前破壞2,3,4間隙
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 -12.34	Current Position : 目前位置 -12.34	Current Position : 目前位置 -12.34
+   -	+   -	+   -
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

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## Die Cut Unit 模切部

Die Cut Unit Reset To Zero Page — 1  
模切部歸零頁面— 1

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

Machine Reset To Zero (Die Cut Unit) 機構歸零 (模切部)		
<b>DS Position</b> DS位置	<b>OS Position</b> OS位置	<b>Pull Collar</b> 咬紙輪
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 -12345	<b>Current Position :</b> 目前位置 -12345	<b>Current Position :</b> 目前位置 -12.34
OS DS	OS DS	+ -
<b>Zero Setting</b> 零點設定	<b>Zero Setting</b> 零點設定	<b>Zero Setting</b> 零點設定
<b>CONTENT</b> 目錄	▲ ▼	

Die Cut Unit Reset To Zero Page — 2  
模切部歸零頁面— 2

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Die Cut Unit)**  
機構歸零 (模切部)

Anvil Roll 膠墊輪	Knife Wheel Lateral Move 刀輪橫移
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 -12.34	Current Position : 目前位置 -1234.5
+      -	OS      DS
Zero Setting 零點設定	Zero Setting 零點設定

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Die Cut Unit Reset To Zero Page — 3  
模切部歸零頁面— 3


■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Die Cut Unit)**  
機構歸零 (模切部)

Collar Wheel DS 帶紙環DS	Collar Wheel OS 帶紙環OS
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 -12345	Current Position : 目前位置 -12345
OS DS	OS DS
Zero Setting 零點設定	Zero Setting 零點設定

CONTENT  
目錄



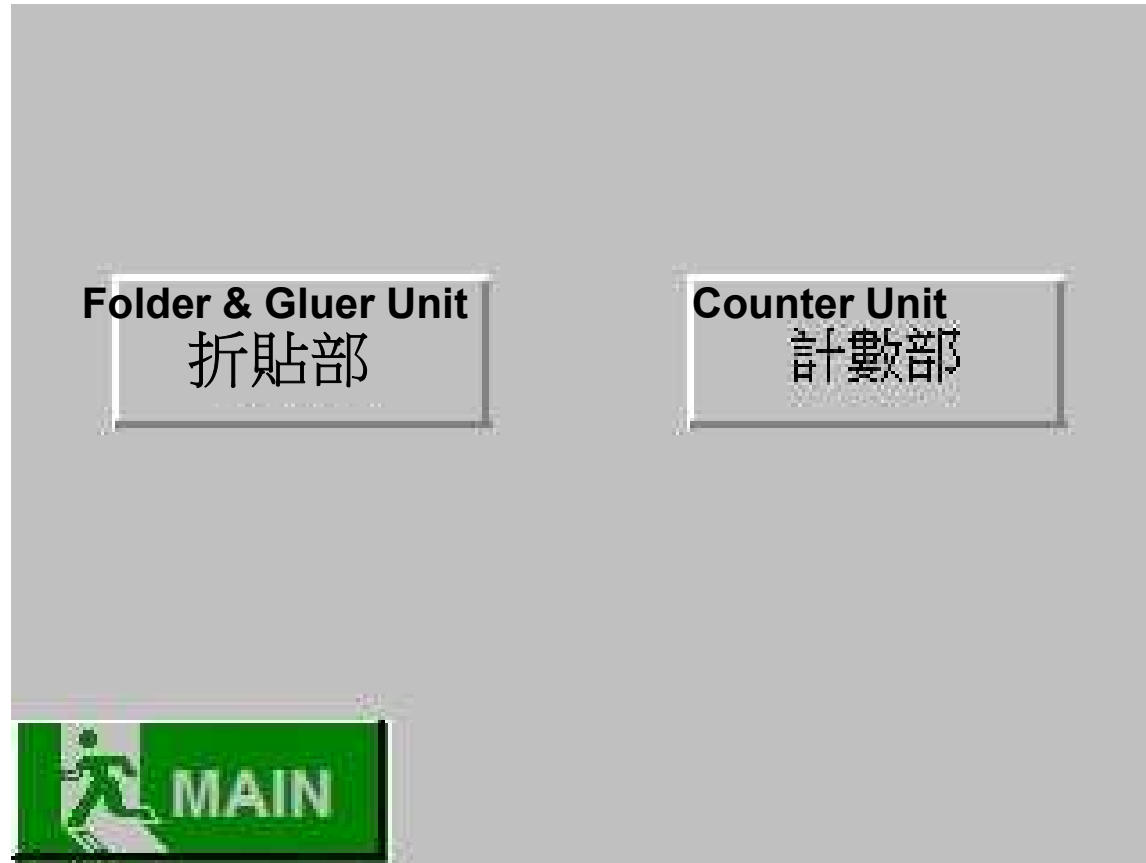


## 1-6. 折貼單元

Machine Reset To Zero Content (PASTE)  
機構歸零目錄 (PASTE)

- Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定



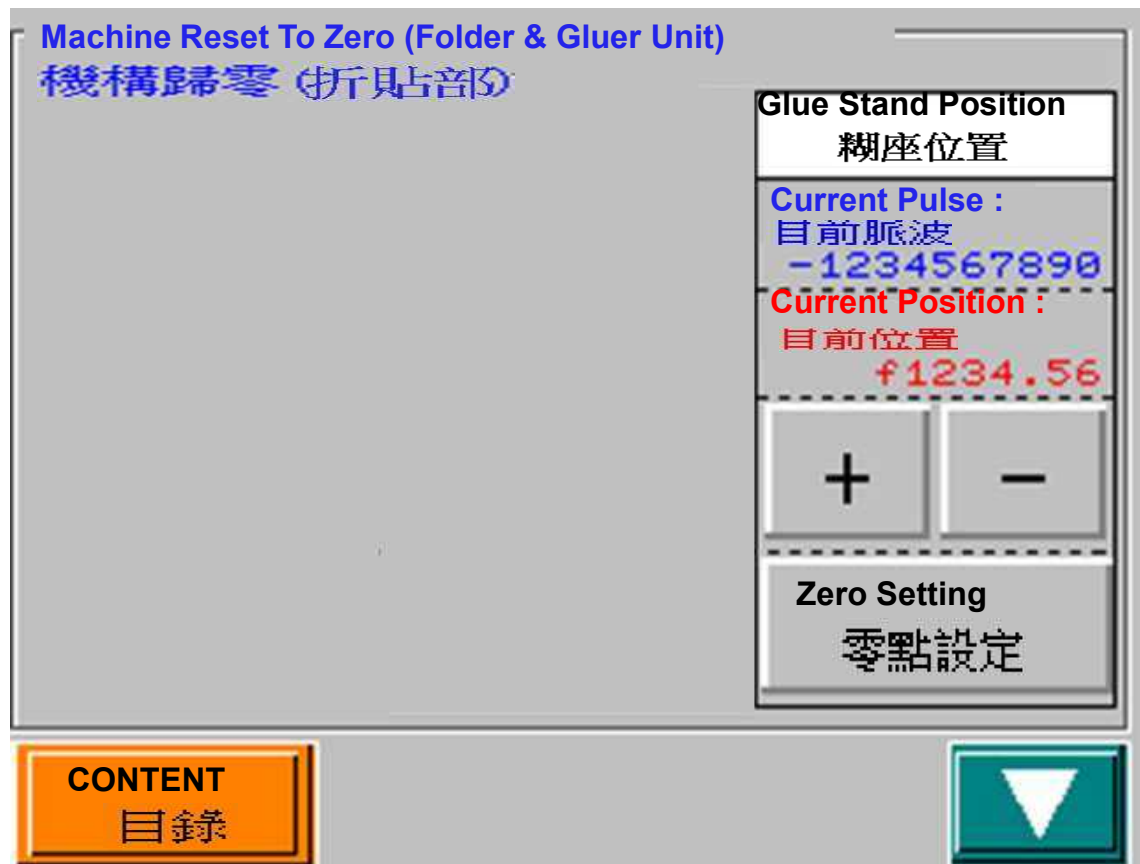


## Folder & Gluer Unit 折貼部

Folder & Gluer Unit Reset To Zero Page - 1  
折貼部歸零頁面— 1

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定



Folder & Gluer Unit Reset To Zero Page - 2  
折貼部歸零頁面— 2

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Folder & Gluer Unit)**  
機構歸零 (折貼部)

OS Side Guide Wheel OS側導輪	OS Folding OS折翼
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 f1234.56	<b>Current Position :</b> 目前位置 f1234.56
<input type="button" value="+"/> <input type="button" value="-"/>	<input type="button" value="+"/> <input type="button" value="-"/>
<b>Zero Setting</b> 零點設定	<b>Zero Setting</b> 零點設定

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Folder & Gluer Unit Reset To Zero Page – 3  
折貼部歸零頁面— 3

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Folder & Gluer Unit)**  
機構歸零 (折貼部)

DS Side Guide Wheel DS側導輪	DS Folding DS折翼
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 f1234.56	Current Position : 目前位置 f1234.56
+      -	+      -
Zero Setting 零點設定	Zero Setting 零點設定

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目錄

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Folder & Gluer Unit Reset To Zero Page - 4  
折貼部歸零頁面— 4

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Folder & Gluer Unit)**  
機構歸零 (折貼部)

Feeding Rod Position 入紙桿位置	Ejecting Rod Position 出紙桿位置	Supporting Rod Up & Down Position 扶紙桿上下位置
Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890	Current Pulse : 目前脈波 -1234567890
Current Position : 目前位置 f1234.56	Current Position : 目前位置 f1234.56	Current Position : 目前位置 f1234.56
+   -	+   -	+   -
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

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## Counter Unit 計數部

Counter Unit Reset To Zero Page — 1  
計數部歸零頁面— 1

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

Machine Reset To Zero (Counter Unit) 機構歸零 (計數部)		
Back Stop Position 後檔板位置	Counter Unit Position 計數部位置	Ejecting Wheel Gap 出紙輪間隙
<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890	<b>Current Pulse :</b> 目前脈波 -1234567890
<b>Current Position :</b> 目前位置 f1234.56	<b>Current Position :</b> 目前位置 f1234.56	<b>Current Position :</b> 目前位置 f1234.56
<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">+</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">-</div> </div>	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">+</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">-</div> </div>	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">+</div> <div style="border: 1px solid gray; padding: 5px; width: 40px; text-align: center;">-</div> </div>
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

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Counter Unit Reset To Zero Page — 2  
計數部歸零頁面— 2

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定





# Main HM Calibration Of Operation Introduction

## 主人機校正操作說明

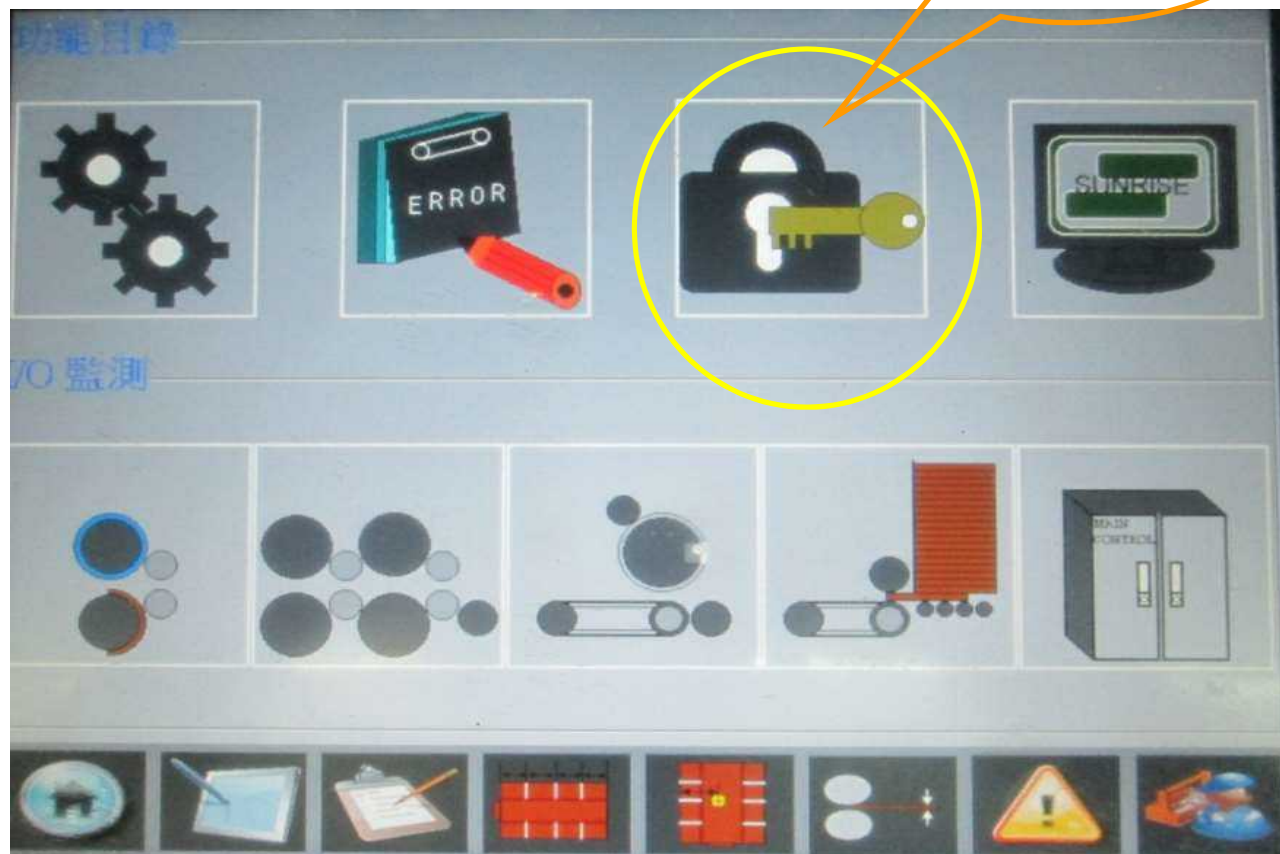
HM Operation Reset To Zero Of Parameter Route 人機操作歸零參數路徑—Main Screen 主畫面



Press Parameter Selection 按下參數選擇

Parameter Selection Page 參數選擇頁面

Parameter Selection Page  
按下參數設定





2-1. 人機操作歸零參數路徑

Parameter Password Setting 參數設定密碼



Password 密碼：  
33850780

Parameter Content 參數目錄





# Feeder Unit 送紙部

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero (Feeder Unit)**  
機構歸零 (送紙部)

Brush Wheel Gap	Back Stop Position	DS Side Gate	OS Side Gate	Front Gate Gap	Pull Collar Lift
毛刷輪間隙	後檔板位置	驅動側側擋板	操作側側擋板	前檔板間隙	咬紙輪升降
Current Pulse : 目前脈波 : -1234567890	Current Pulse : 目前脈波 : -1234567890	Current Pulse : 目前脈波 : -1234567890	Current Pulse : 目前脈波 : -1234567890	Current Pulse : 目前脈波 : -1234567890	Current Pulse : 目前脈波 : -1234567890
Current Position : 目前位置 : -12.3	Current Position : 目前位置 : -12345	Current Position : 目前位置 : -12345	Current Position : 目前位置 : -12345	Current Position : 目前位置 : -12.3	Current Position : 目前位置 : -12.3
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

RETURN 返回

Printer Unit 印刷部

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

Zero Setting  
零點設定

Machine Reset To Zero 機構歸零 **Printer Unit (印刷部)**

Printing 2 Creasing Gap	Printing 2 Impression Gap	Printing 2 Lateral Move Position	Printing 1 Creasing Gap	Printing 1 Impression Gap	Printing 1 Lateral Move Position
印刷2版壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: 123.45 Zero Setting 零點設定	印刷2印壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: 123.45 Zero Setting 零點設定	印刷2橫移位置 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: 1234.5 Zero Setting 零點設定	印刷1版壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: 123.45 Zero Setting 零點設定	印刷1印壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: 123.45 Zero Setting 零點設定	印刷1橫移位置 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: 1234.5 Zero Setting 零點設定
Printing 4 Creasing Gap	Printing 4 Impression Gap	Printing 4 Lateral Move Position	Printing 3 Creasing Gap	Printing 3 Impression Gap	Printing 3 Lateral Move Position
印刷4版壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -123.45 Zero Setting 零點設定	印刷4印壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -123.45 Zero Setting 零點設定	印刷4橫移位置 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -1234.5 Zero Setting 零點設定	印刷3版壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -123.45 Zero Setting 零點設定	印刷3印壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -123.45 Zero Setting 零點設定	印刷3橫移位置 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -1234.5 Zero Setting 零點設定
Printing 6 Creasing Gap	Printing 6 Impression Gap	Printing 6 Lateral Move Position	Printing 5 Creasing Gap	Printing 5 Impression Gap	Printing 5 Lateral Move Position
印刷6版壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -123.45 Zero Setting 零點設定	印刷6印壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -123.45 Zero Setting 零點設定	印刷6橫移位置 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -1234.5 Zero Setting 零點設定	印刷5版壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: 123.45 Zero Setting 零點設定	印刷5印壓間隙 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -123.45 Zero Setting 零點設定	印刷5橫移位置 Current Pulse : 目前脈波: -1234567890 Current Position : 目前位置: -1234.5 Zero Setting 零點設定

RETURN  
返回



**Slotter Unit 開槽部**

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

**Machine Reset To Zero Slotter Unit**  
機構歸零(開槽部)

Creasing Gap	Front Pre-creasing 5 Gap	Front Pre-creasing 2,3,4 Gap	Front Pre-creasing 1 Gap
壓線間隙	前破壞5間隙	前破壞2,3,4間隙	前破壞1間隙
Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890
Current Position : 目前位置: -12.3	Current Position : 目前位置: -12.3	Current Position : 目前位置: -12.3	Current Position : 目前位置: -12.3
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

刀 Knife 5	刀 Knife 4	刀 Knife 3	刀 Knife 2	刀 Knife 1
Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890
Current Position : 目前位置: -1234.5	Current Position : 目前位置: -1234.5	Current Position : 目前位置: -1234.5	Current Position : 目前位置: -1234.5	Current Position : 目前位置: -1234.5
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定

RETURN 返回

▲ ▼

# Die Cut Unit 模切部

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

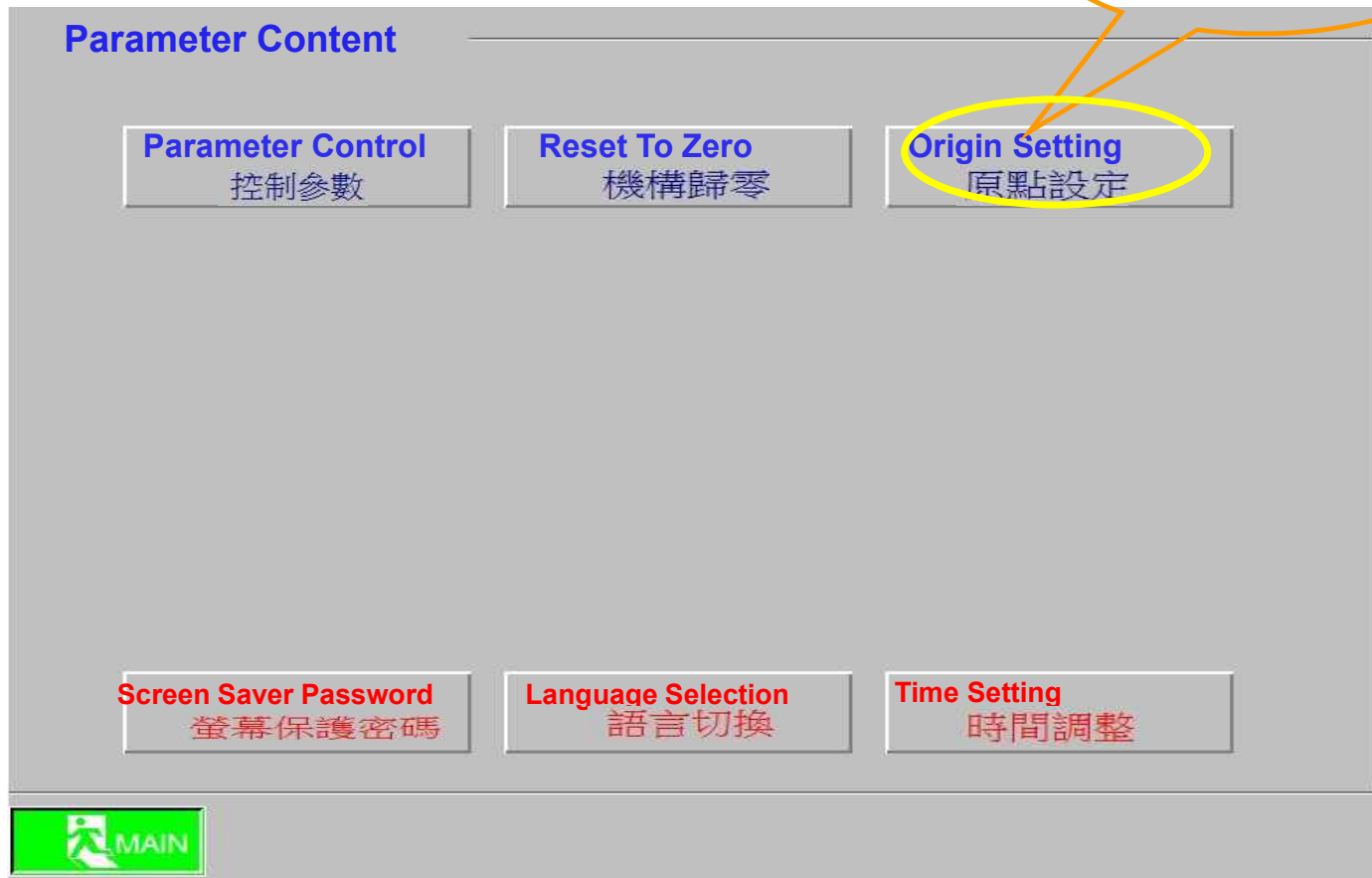
**Zero Setting**  
零點設定

**Machine Reset To Zero Die Cut Unit**  
機構歸零 (模切部)

Anvil Cylinder	Die Cut Wheel Lateral Move	Pull Collar DS Position	Pull Collar OS Position	Pull Collar Gap
<p>膠墊輪</p> <p>Current Pulse : 目前脈波: -1234567890</p> <p>Current Position : 目前位置: 12.3</p> <p>Zero Setting 零點設定</p>	<p>模切輪橫移</p> <p>Current Pulse : 目前脈波: -1234567890</p> <p>Current Position : 目前位置: -1234.5</p> <p>Zero Setting 零點設定</p>	<p>咬紙輪DS位置</p> <p>Current Pulse : 目前脈波: -1234567890</p> <p>Current Position : 目前位置: -12345</p> <p>Zero Setting 零點設定</p>	<p>咬紙輪OS位置</p> <p>Current Pulse : 目前脈波: -1234567890</p> <p>Current Position : 目前位置: -12345</p> <p>Zero Setting 零點設定</p>	<p>咬紙輪間隙</p> <p>Current Pulse : 目前脈波: -1234567890</p> <p>Current Position : 目前位置: -12.3</p> <p>Zero Setting 零點設定</p>
			<p>帶紙環DS</p> <p>Current Pulse : 目前脈波: -1234567890</p> <p>Current Position : 目前位置: -1234.5</p> <p>Zero Setting 零點設定</p>	<p>帶紙環OS</p> <p>Current Pulse : 目前脈波: -1234567890</p> <p>Current Position : 目前位置: -1234.5</p> <p>Zero Setting 零點設定</p>

RETURN 返回

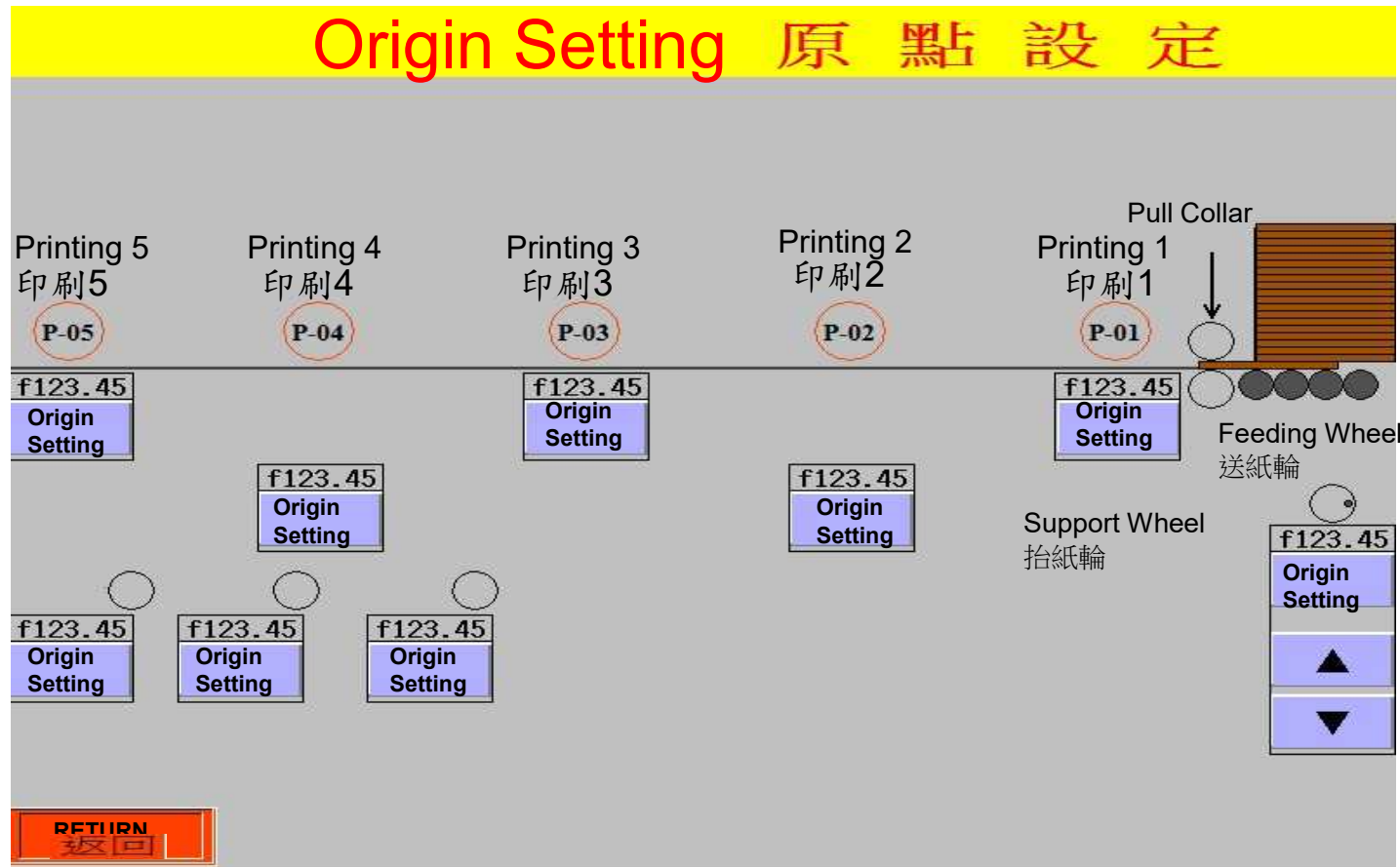
## Register Origin Setting 相位原點設定



Register Origin Setting 相位原點

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

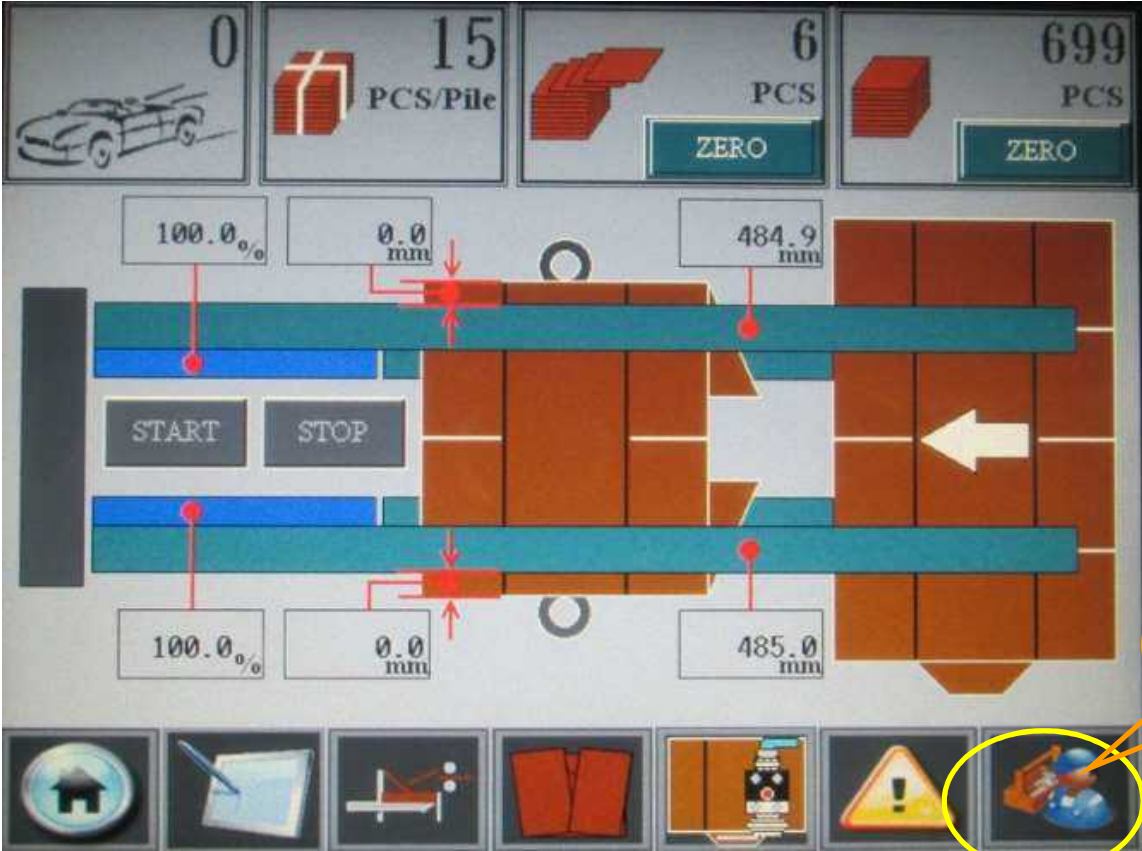




# Folder Gluer HM Operation Reset To Zero Of Parameter Route

## 糊箱機人機操作歸零參數路徑

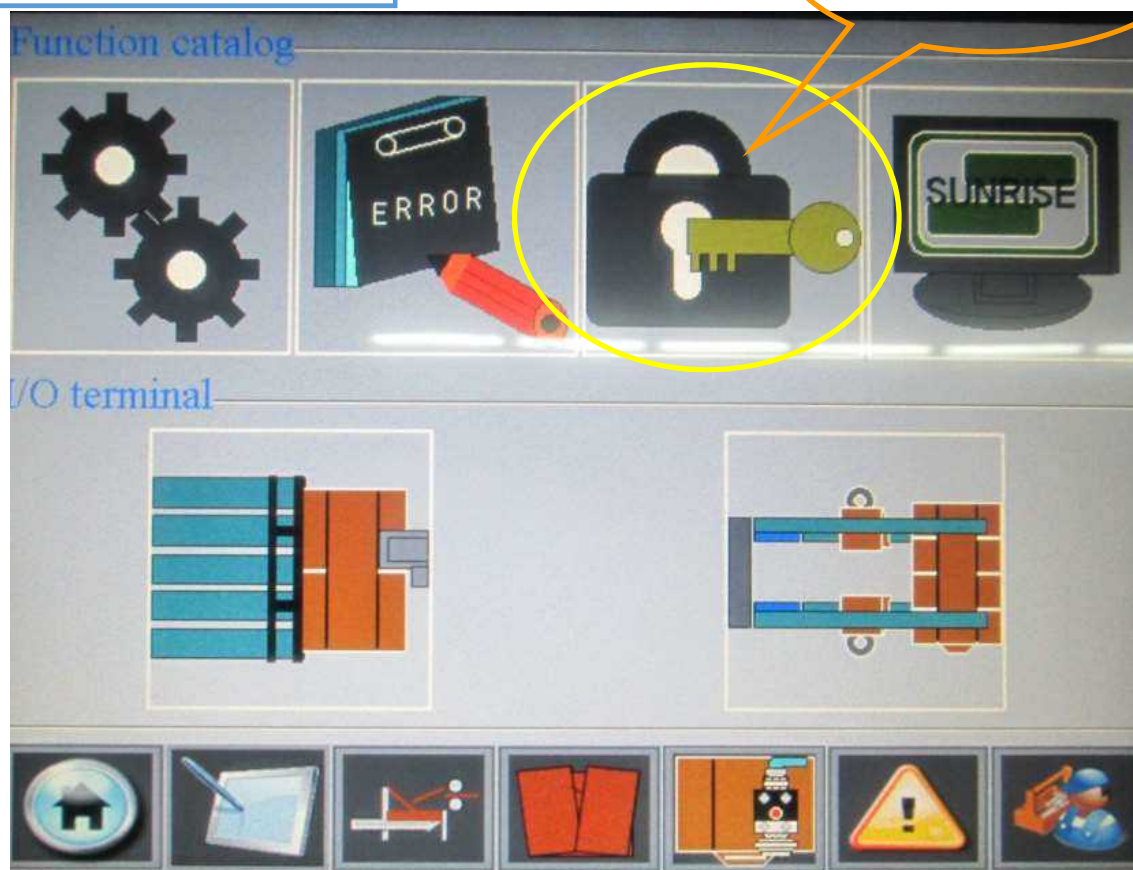
Main Screen 主畫面



Press Parameter Selection 按下參數選擇

Parameter Selection Page  
參數選擇頁面

Press Parameter  
Setting 按下參數設定





### 3-1. 糊箱機人機操作歸零參數路徑

#### Parameter Password Setting 參數設定密碼

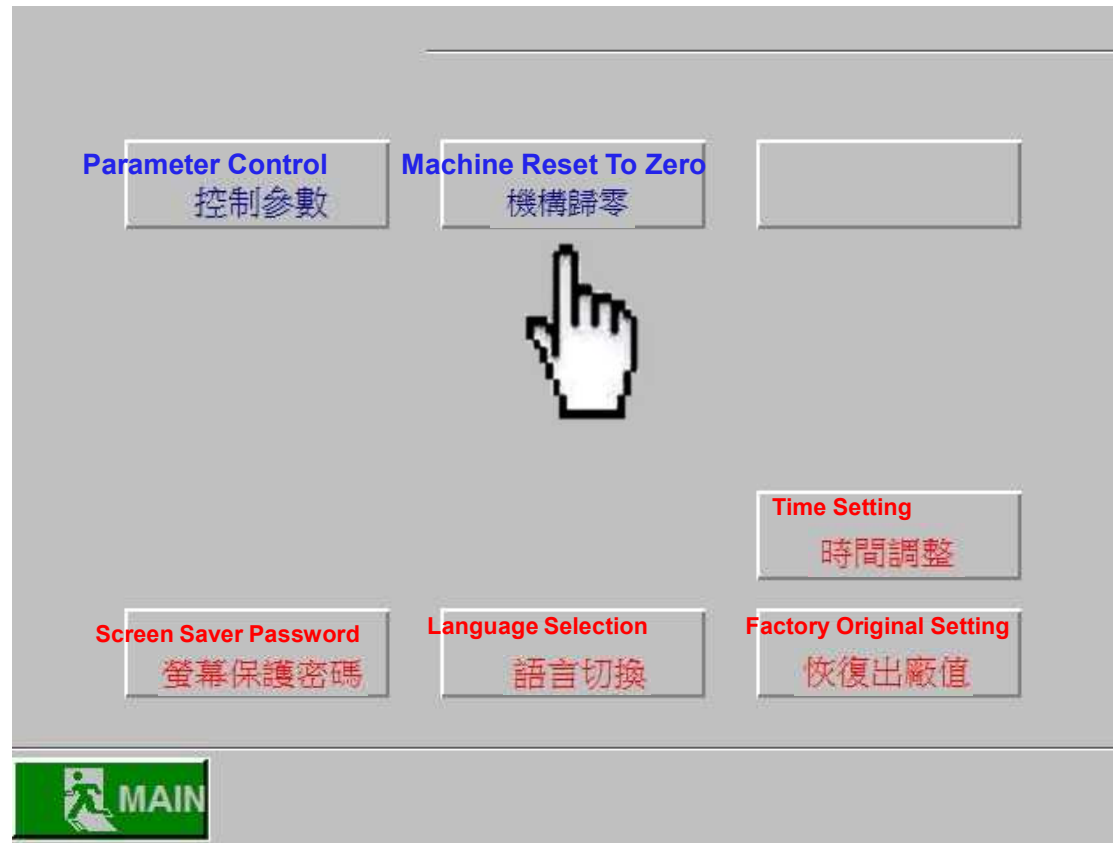


Password 密碼：  
33850780



### 3-1. 糊箱機人機操作歸零參數路徑

#### Machine Reset To Zero Selection 機構歸零選擇





Gluing Machine Reset To Zero — 1  
糊箱機零點設定— 1

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

**Zero Setting**  
零點設定

	Supporting Rod Up & Down Position 扶紙桿上下位置	Ejecting Wheel Gap 出紙輪間隙	DS Side Guide Wheel DS側導輪	DS Folding DS 折翼
	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890
	Current Position : 目前位置: f12345678.90	Current Position : 目前位置: f12345678.90	Current Position : 目前位置: f12345678.90	Current Position : 目前位置: f12345678.90
	F R	F R	F R	F R
	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定
Counter Unit Position 計數部位置	Glue Stand Position 糊座位置	OS Side Guide Wheel OS側導輪	OS Folding OS 折翼	
Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	Current Pulse : 目前脈波: -1234567890	
Current Position : 目前位置: f12345678.90	Current Position : 目前位置: f12345678.90	Current Position : 目前位置: f12345678.90	Current Position : 目前位置: f12345678.90	
F R	F R	F R	F R	
Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	Zero Setting 零點設定	
RETURN 返回				▼



### 3-1. 糊箱機人機操作歸零參數路徑

Gluing Machine Reset To Zero — 2  
糊箱機零點設定— 2

■ Select the calibration machine position, press  
選擇所要校正的機構位置，按下

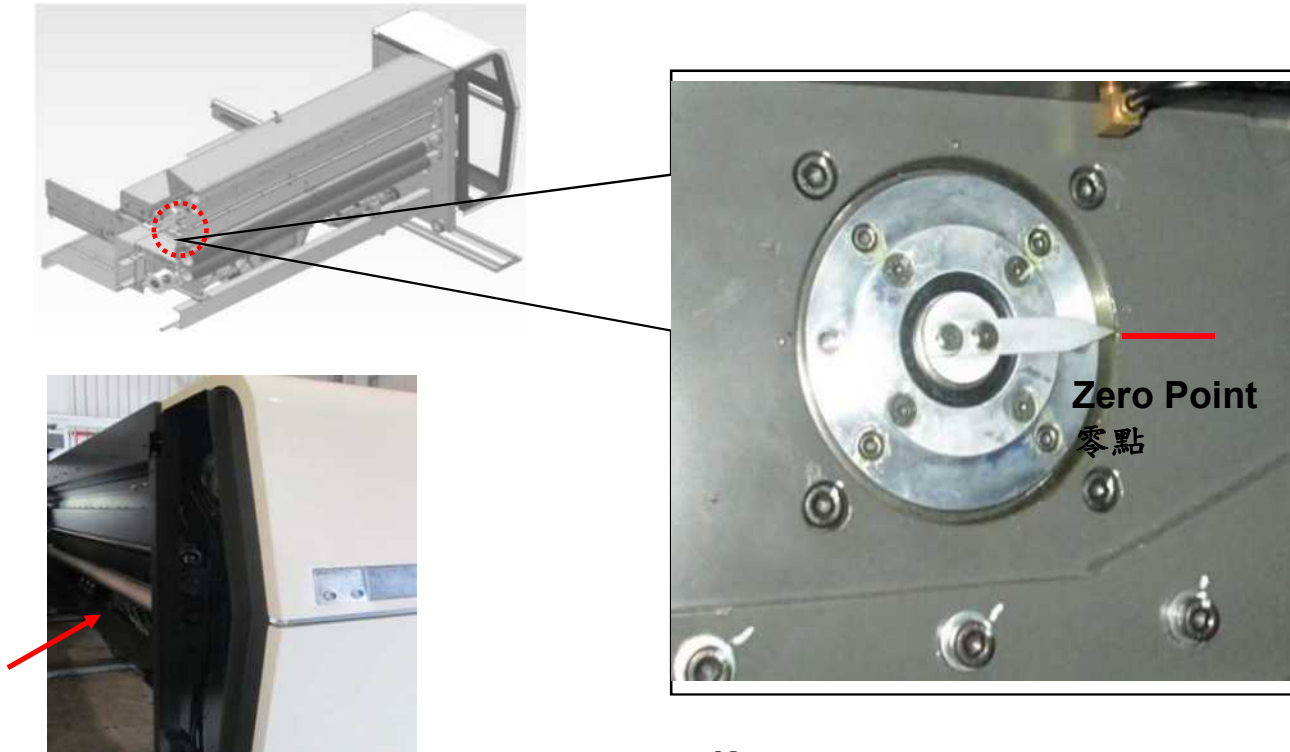
**Zero Setting**  
零點設定

Feeding Rod Position		Ejecting Rod Position		Bundle Stacking Position		Back Stop Position			
入紙桿位置		出紙桿位置		整疊壓紙位置		後擋板位置			
Current Pulse : 目前脈波: -1234567890		Current Pulse : 目前脈波: -1234567890		Current Pulse : 目前脈波: -1234567890		Current Pulse : 目前脈波: -1234567890			
Current Position : 目前位置: f12345678.90		Current Position : 目前位置: f12345678.90		Current Position : 目前位置: f12345678.90		Current Position : 目前位置: f12345678.90			
F	R	F	R	F	R	F	R		
Zero Setting 零點設定		Zero Setting 零點設定		Zero Setting 零點設定		Zero Setting 零點設定			
Bundle Stacking Lift		Ejecting Belt		Catching Lift		Rod of Separating Front & Back		Rod of Separating Up & Down	
整疊壓紙升降		排出皮帶		接紙台升降		分紙桿前後		分紙桿上下	
Current Pulse : 目前脈波: -1234567890		Current Pulse : 目前脈波: -1234567890		Current Pulse : 目前脈波: -1234567890		Current Pulse : 目前脈波: -1234567890		Current Pulse : 目前脈波: -1234567890	
				Current Position : 目前位置: f12345678.90		Current Position : 目前位置: f12345678.90		Current Position : 目前位置: f12345678.90	

RETURN 返回

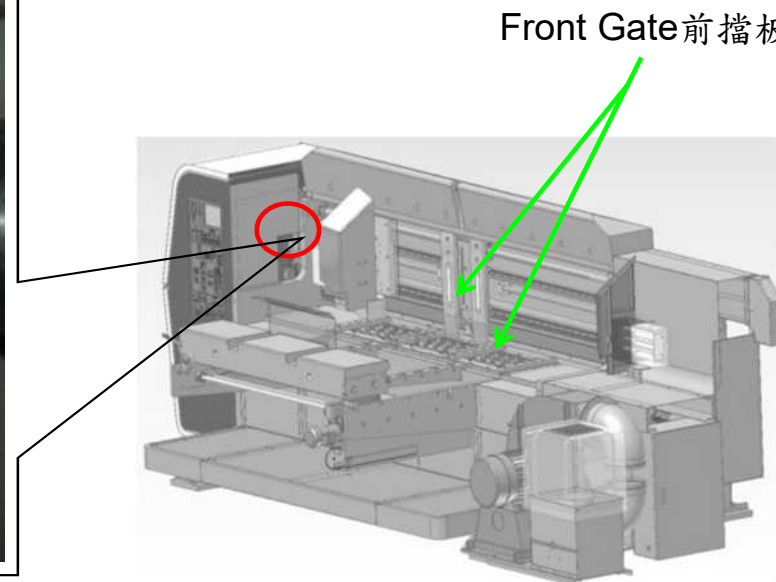
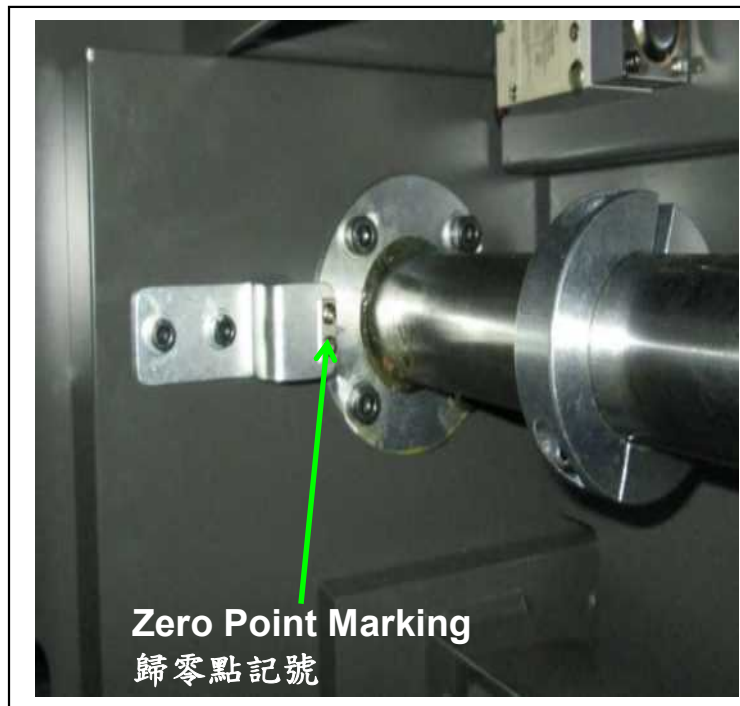
### Front Grate Of Zero Calibration 前擋板零點校正

1. Below the machine, set the grate of origin indicator point toward the feeding side of 90 degree lateral marking position. 在機器下方將柵欄原點指示針指轉向入紙側90度橫線記號的位置。
2. To machine origin setting and press the feeding wheel origin setting. 到機械原點設定按下抬紙輪原點設定。



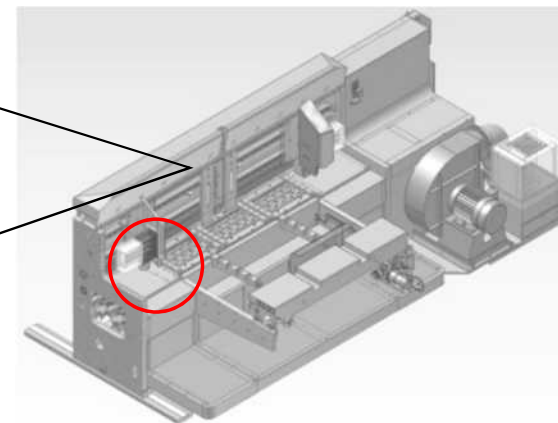
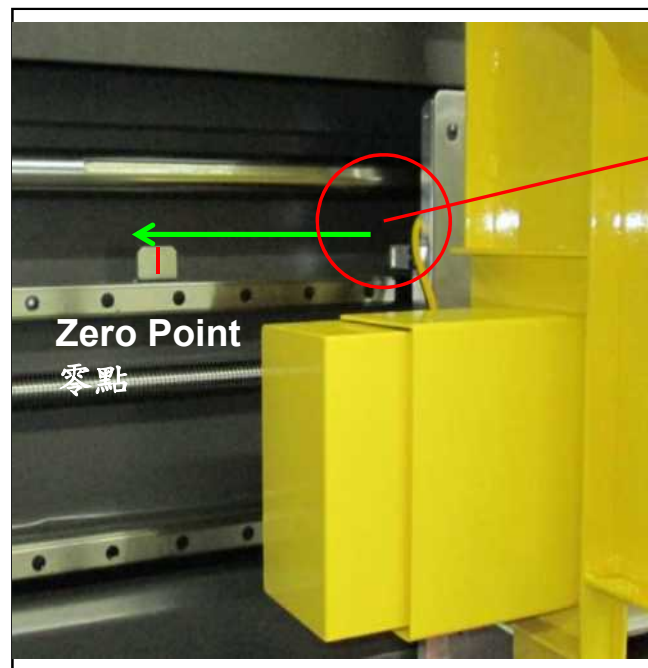
### Front Gate Gap Of Zero Point Calibration 前擋板間隙零點校正

1. Adjust the front gate gap, and set the dial scale zero point toward the indicator as shown as the figure. 調整前擋板間隙將圖示刻度盤零點的刻度對準指針。
2. Go to the main HM or HM calibration of feeding machine reset to zero, and press the front gate of zero point setting. 到主人機或是校正人機內的送紙機構歸零按下前擋板間隙零點設定。



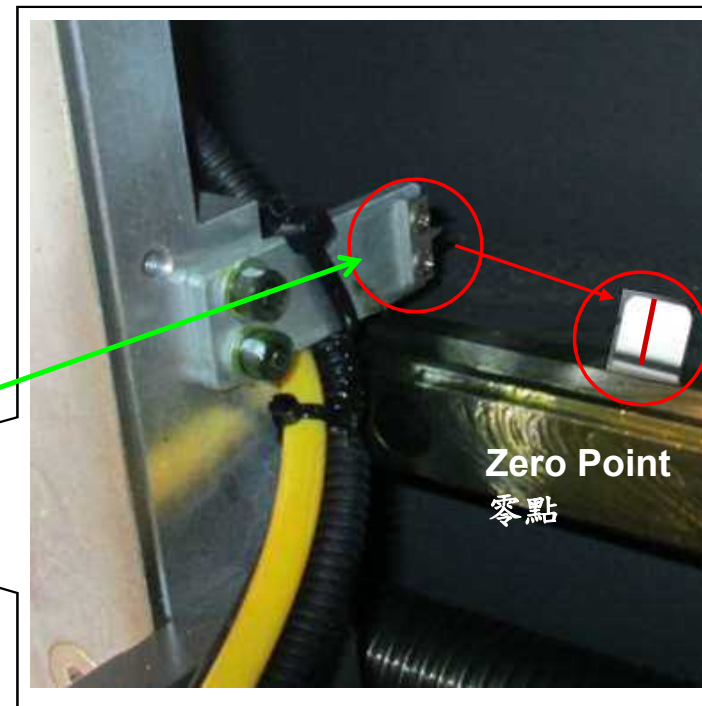
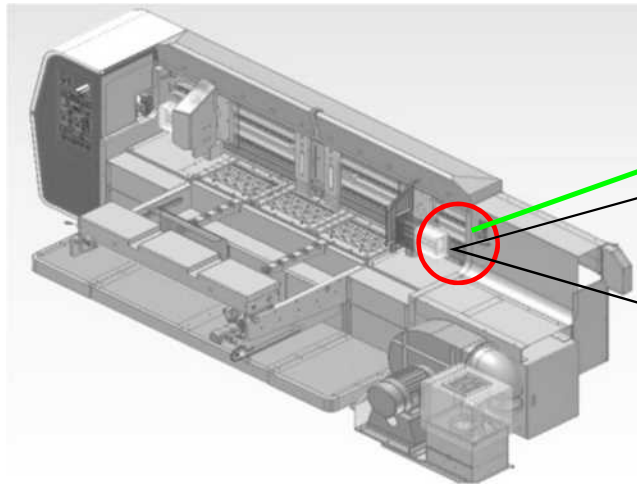
### OS Side Gate Of Reset To Zero Point Calibration 操作側側擋板歸零點校正

1. Move the side gate to the indicator and the marking corresponding position as shown as the figure.  
將側擋板移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of feeding machine reset to zero, and press OS side gate of zero point setting. 到主人機或是校正人機內的送紙機構歸零按下操作側側擋板零點設定。



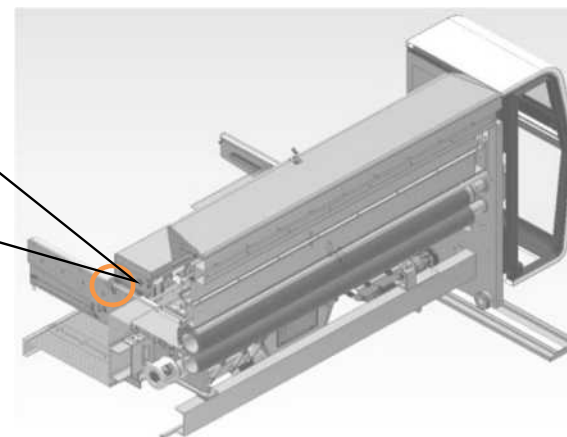
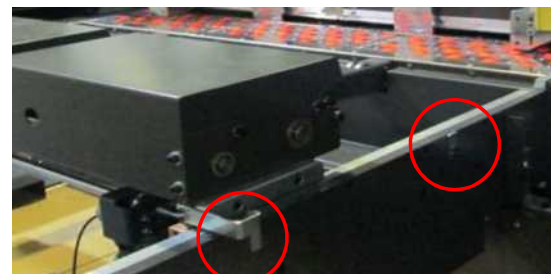
### DS Side Gate Of Reset To Zero Point Calibration 驅動側側擋板歸零點校正

1. Move the side gate to the indicator and the marking corresponding position as shown as the figure. 將側擋板移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of feeding machine reset to zero, and press DS side gate of zero point setting. 到主人機或是校正人機內的送紙機構歸零按下驅動側側擋板零點設定。



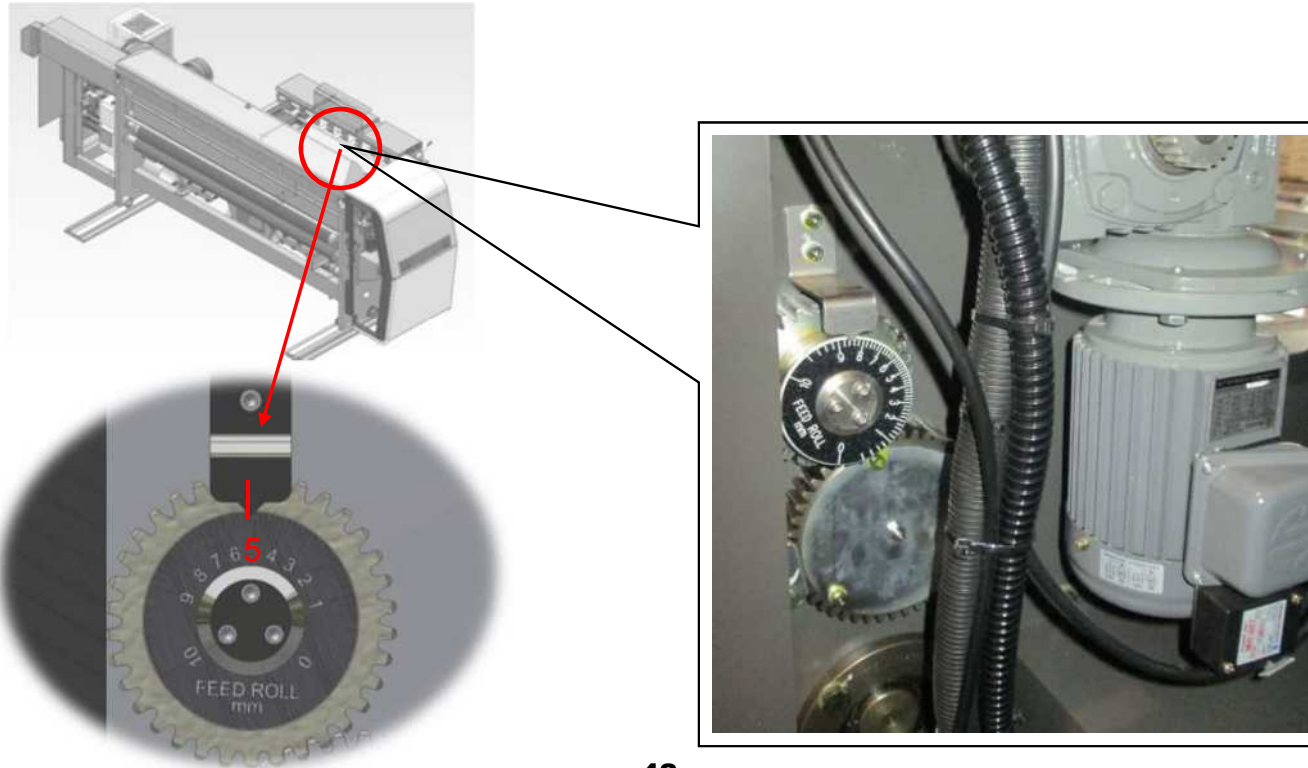
### Feeder Back Stop Of Reset To Zero Point Calibration 送紙後擋板歸零點校正

1. Move the back stop to the indicator and the marking corresponding position as shown as the figure. 將後擋板移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of feeding machine reset to zero, and press the back stop position of zero point setting. 到主人機或是校正人機內的送紙機構歸零按下後擋板位置零點設定。



### Feed Roll Gap Of Zero Point Adjustment 進紙輪間隙零點調整

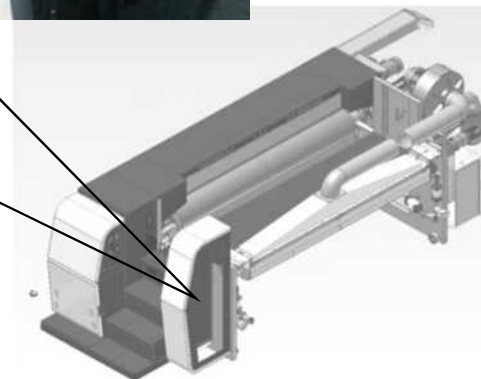
1. Adjust the feed roll gap, and turn the dial scale of 5mm graduation toward the indicator as shown as the figure. 調整進紙輪間隙將圖示刻度盤5mm的刻度對準指針。
2. Go to the main HM or HM calibration of feeding machine reset to zero, and press feed roll of zero point setting. 到主人機或是校正人機內的送紙機構歸零按下進紙輪零點設定。





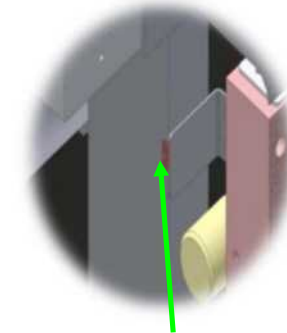
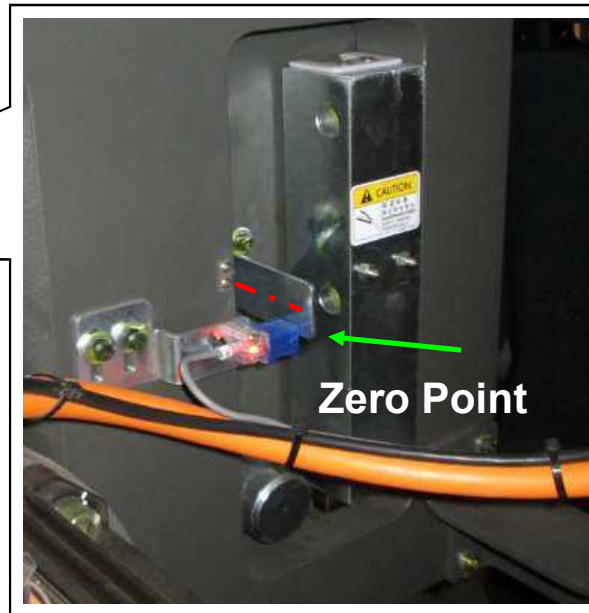
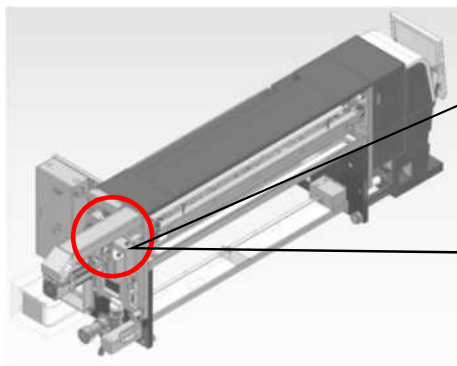
### Brush Roll Gap Of Zero Point Adjustment 毛刷輪間隙零點調整

1. Adjust the brush wheel gap, and turn the dial scale of 5mm graduation toward the indicator as shown as the figure. 調整毛刷輪間隙將圖示刻度盤5mm的刻度對準指針。
2. Go to the main HM or HM calibration of feeding machine reset to zero, and press brush wheel of zero point setting. 到主人機或是校正人機內的送紙機構歸零按下毛刷輪零點設定。



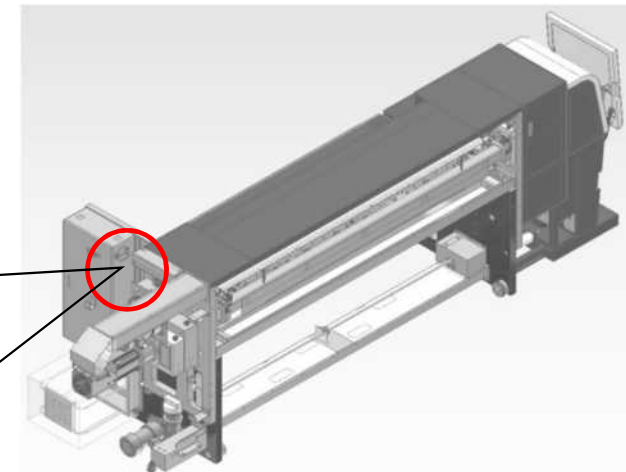
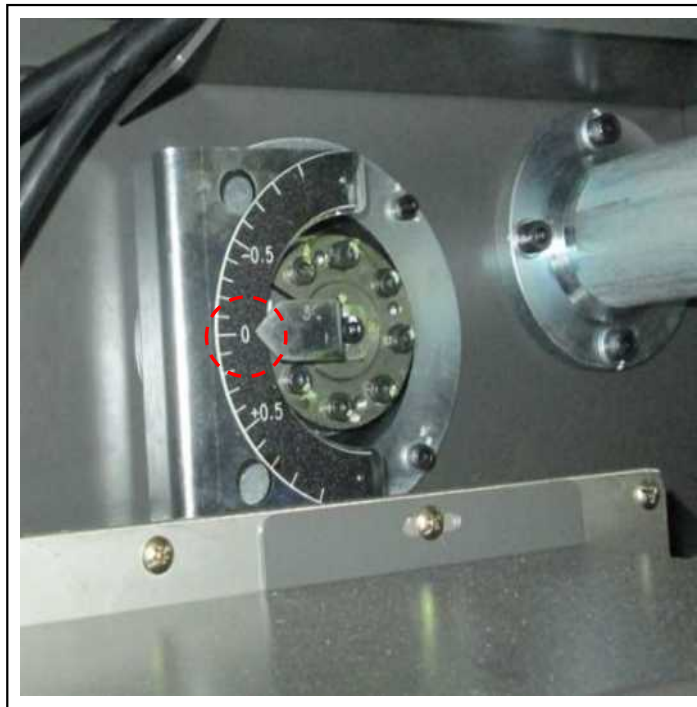
### Impression Gap Adjustment 印壓間隙調整

1. Refer the calibration color block to adjust the impression gap to the scale and indicator corresponding position as show as the figure. 依所要校正的色座調整印壓間隙到圖示刻度與指針相對應位置的。
2. Go to the main HM or HM calibration of printing machine reset to zero, and select the required calibration color block, press the impression gap of zero point setting. 到主人機或是校正人機內的印刷機構歸零選擇要校正的色座按下印壓間隙零點設定。



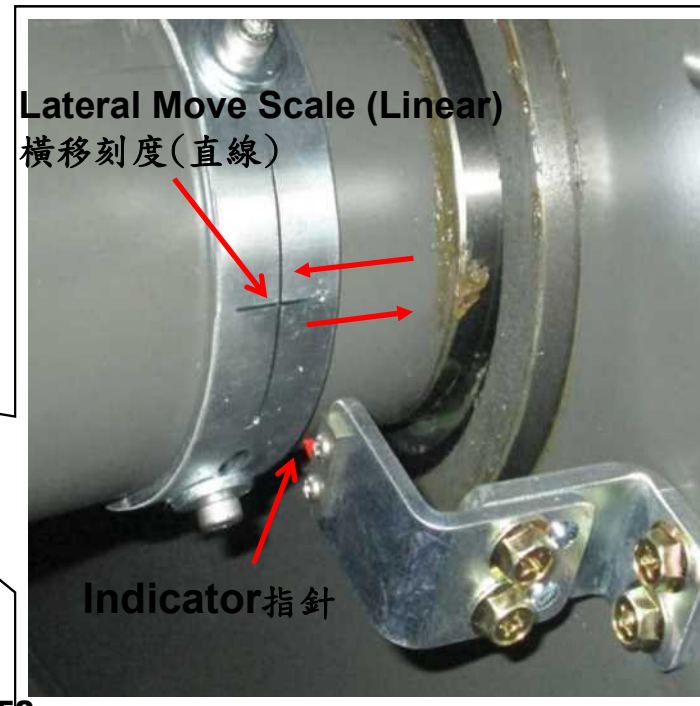
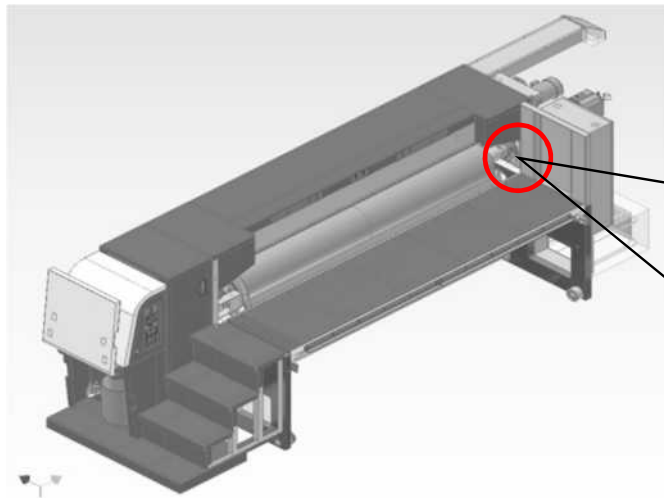
### Plate Pressure Gap Adjustment 版壓間隙調整

1. Adjust the plate pressure gap to the scale 0mm and the indicator corresponding position as shown as the figure. 調整版壓間隙到圖示刻度0mm與指針對應位置的。
2. Go to the main HM or HM calibration of printing machine reset to zero, and select the required calibration color block, press the plate pressure gap of zero point setting. 到主人機或是校正人機內的印刷機構歸零選擇要校正的色座按下版壓間隙零點設定。



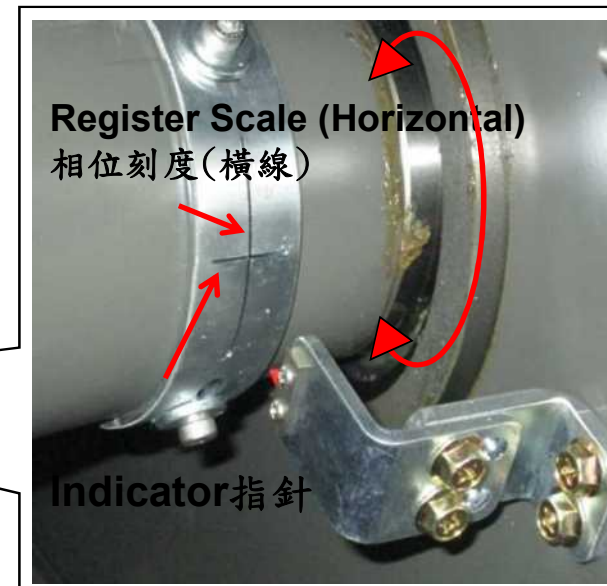
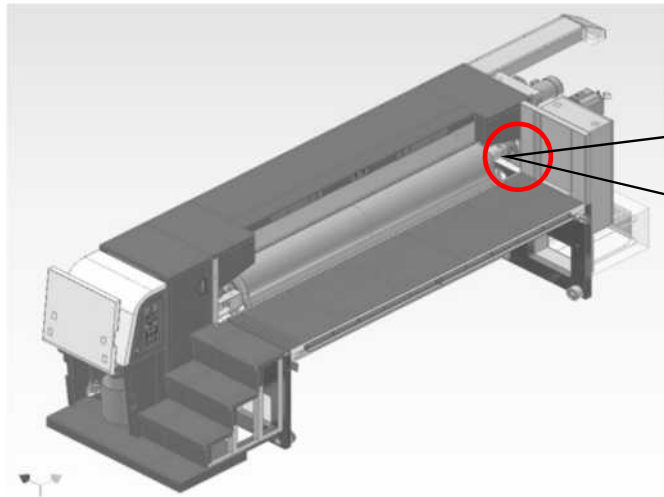
### Print Cylinder Lateral Move Of Zero Point Calibration 印刷輪橫移零點校正

1. Move the print cylinder to the indicator and the scale corresponding position as shown as the figure. 將印刷輪移動到圖示指針與刻度相對應的位置。
2. Go to the main HM or HM calibration of printing machine reset to zero, and select the required calibration color block, press the lateral move position of zero point setting. 到主人機或是校正人機內的印刷機構歸零選擇要校正的色座按下橫移位置零點設定。



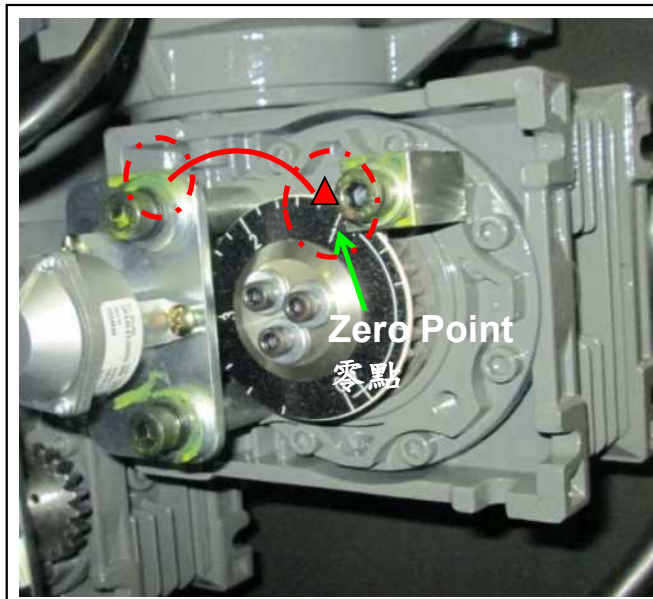
### Print Cylinder Register Of Zero Point Calibration 印刷輪相位零點校正

1. Turn the print cylinder to the indicator and the horizontal scale corresponding position as shown as the figure. 將印刷輪旋轉到圖示指針與橫向刻度相對應的位置。
2. Go to the main HM of origin setting, select the required calibration color block, and press origin setting. 到主人機內的原點設定選擇要校正的色座按下原點設定。

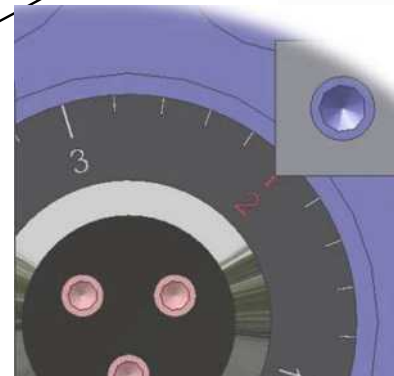
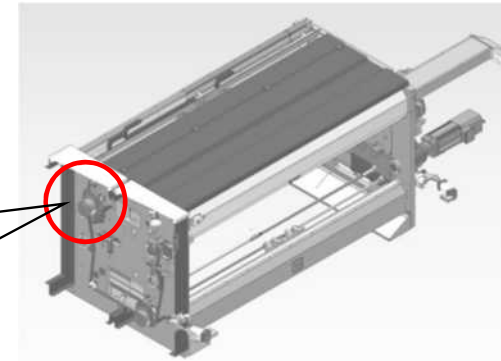


### Pre-creaser 1st Knife Gap Adjustment 破壞輪第1刀間隙調整

1. Adjust the 1st pre-creaser gap to the scale 2 and the indicator corresponding position as shown as the figure. 調整第1刀破壞輪間隙到圖示刻度2與指針相對應位置的。
2. Go to the main HM or HM calibration of slotter machine reset to zero, press the pre-creaser 1 gap of zero point setting. 到主人機或是校正人機內的開槽機構歸零，按下破壞輪1間隙零點設定。

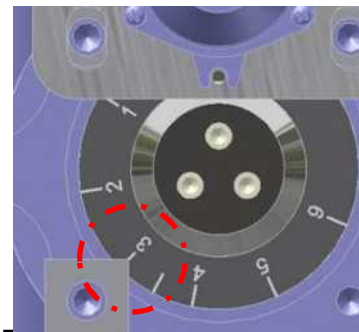
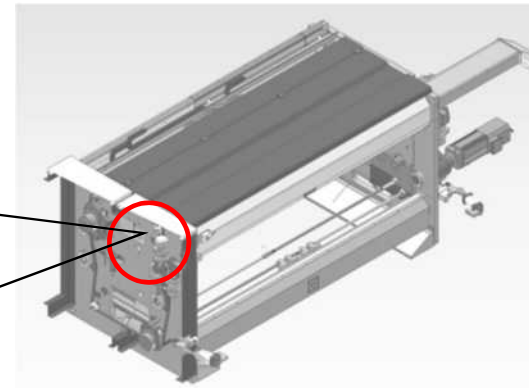
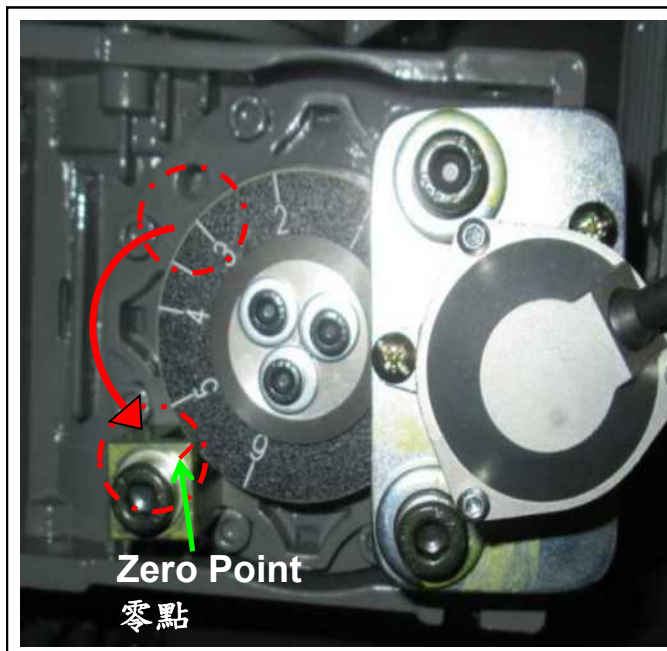


54



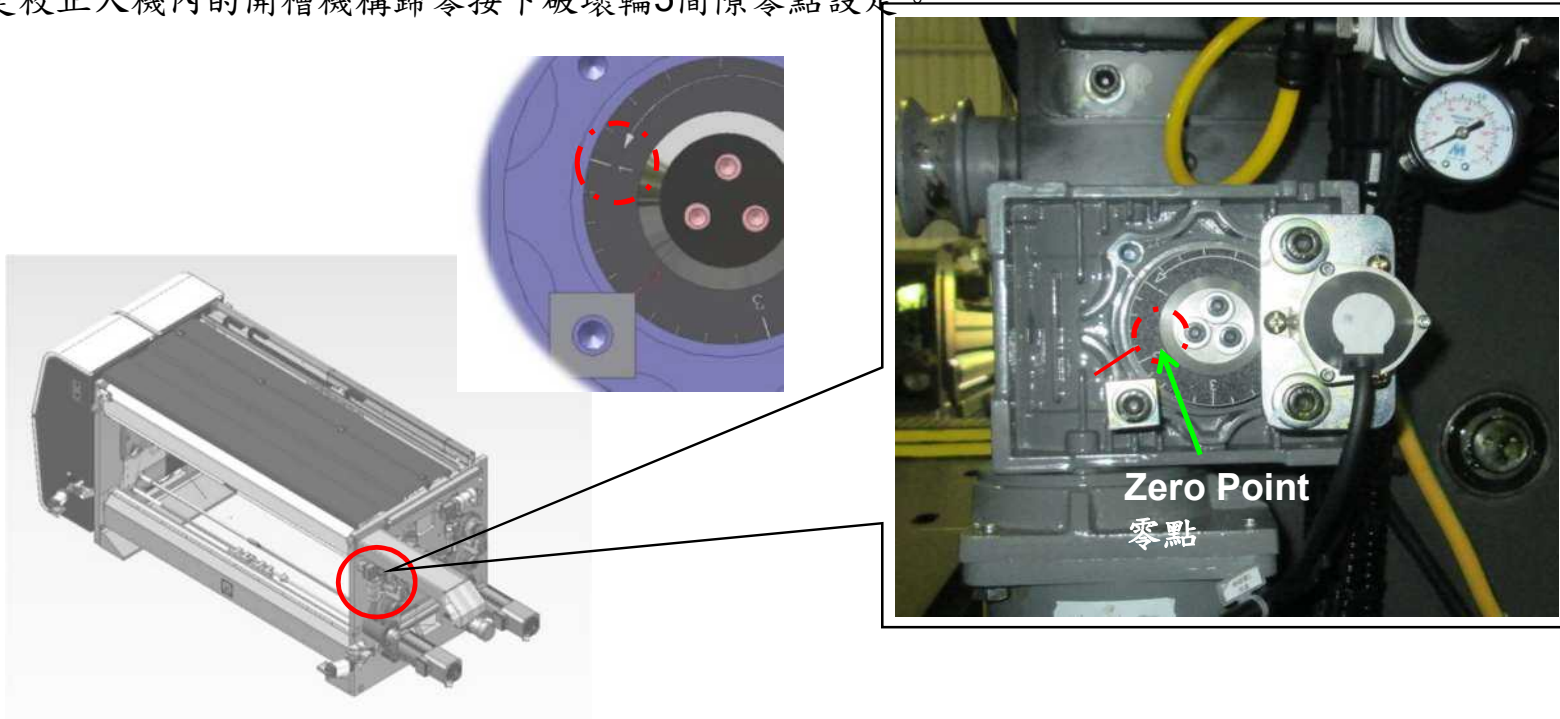
Pre-creaser 2nd, 3rd, 4th Knife Gap Adjustment 破壞輪第2,3,4刀間隙調整

1. Adjust the 2nd, 3rd, 4th pre-creaser gap to the scale 3 and the indicator corresponding position as shown as the figure. 調整第2,3,4刀破壞輪間隙到圖示刻度3與指針相對應位置的。
2. Go to the main HM or HM calibration of slotter machine reset to zero, press the pre-creaser 1 gap of zero point setting. 到主人機或是校正人機內的開槽機構歸零按下破壞輪1間隙零點設定。



### Pre-creaser 5th Knife Gap Adjustment 破壞輪第5刀間隙調整

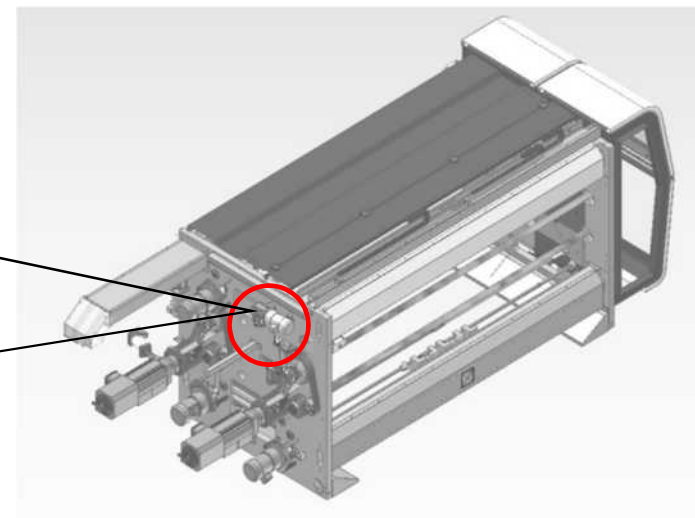
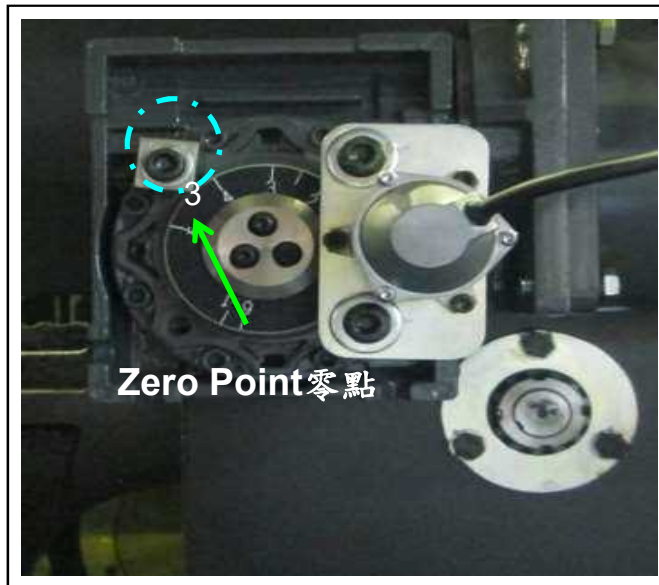
1. Adjust the 5th pre-creaser gap to the scale 2 and the indicator corresponding position as shown as the figure. 調整第5刀破壞輪間隙到圖示刻度2與指針相對應位置的。
2. Go to the main HM or HM calibration of slotter machine reset to zero, press the 5th pre-creaser gap of zero point setting. 到主人機或是校正人機內的開槽機構歸零按下破壞輪5間隙零點設定。





### Creaser Wheel Gap Adjustment 壓線輪間隙調整

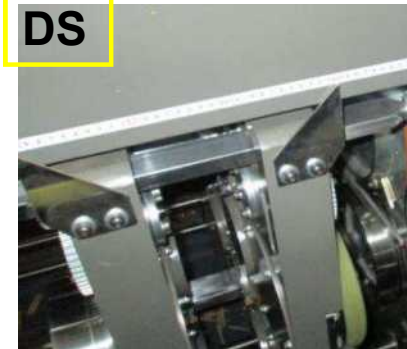
1. Adjust the creaser wheel gap to the scale 3 and the indicator corresponding position as shown as the figure.調整壓線輪間隙到圖示刻度3與指針相對應位置的。
2. Go to the main HM or HM calibration of slotter machine reset to zero, press the creaser wheel gap of zero point setting.到主人機或是校正人機內的開槽機構歸零按下壓線輪間隙零點設定。



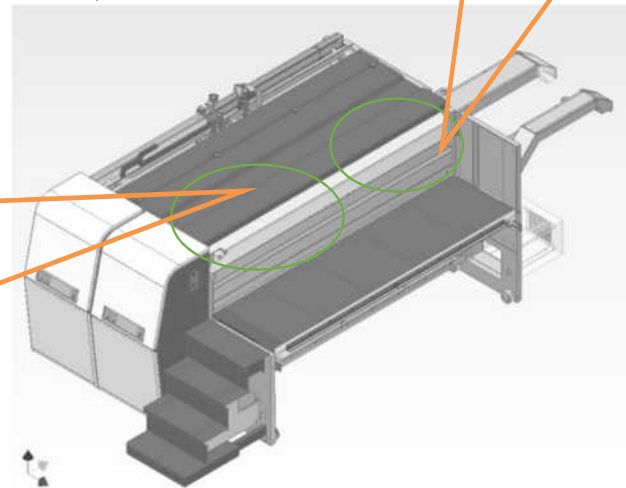
Slotter Stand Lateral Move Adjustment 開槽刀座橫移調整

1. There are totally five lateral move slotter knife  
開槽刀橫移總共有5刀。
2. Move the required calibrated knife to the indicator and the marking corresponding position as shown as the figure. 將要校正位置的刀移動到圖示指針與記號相對應的位置。
3. Go to main HM or HM calibration of slotter machine reset to zero, press the required calibrated knife of zero point setting.  
到主人機或是校正人機內的開槽機構歸零按下要校正刀具零點設定。

DS

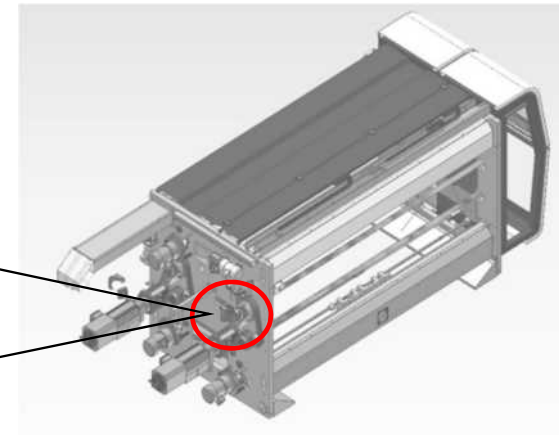
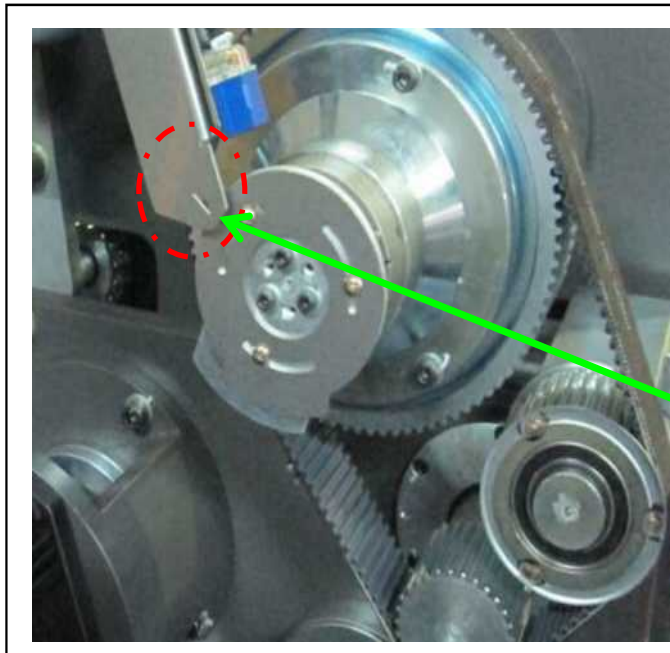


OS



Leading Knife Register Of Origin Adjustment 前刀相位原點校正

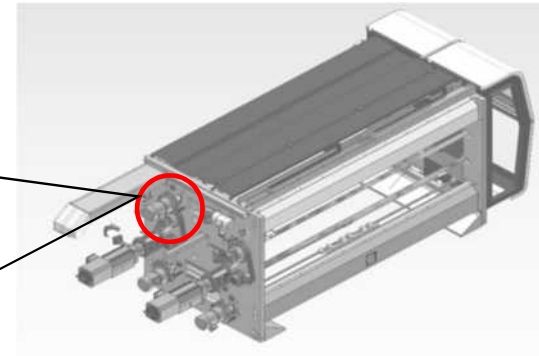
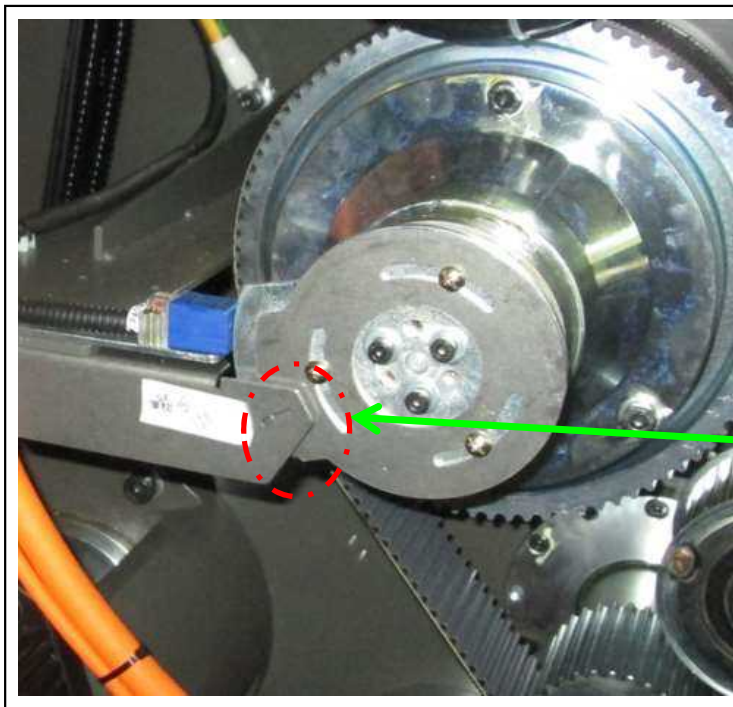
1. Turn the leading knife register to the indicator and the dial scale corresponding position as shown as the figure. 將前刀相位旋轉到圖示指針與刻度盤相對應的位置。
2. Go to the main HM of origin setting, press the leading knife origin setting. 到主人機內的原點設定按下前刀原點設定。



Indicator and Dial Scale  
Corresponding position  
指針與刻度盤相對應位置

Trailing Knife Register Of Origin Adjustment 後刀相位原點校正

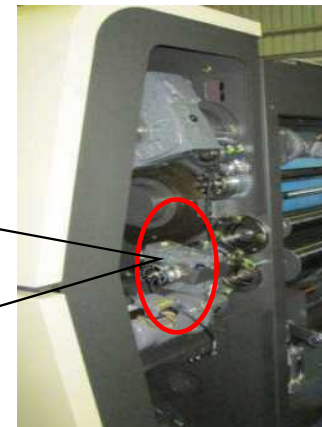
1. Turn the trailing knife register to the indicator and the dial scale corresponding position as shown as the figure. 將後刀相位旋轉到圖示指針與刻度盤相對應的位置。
2. Go to the main HM of origin setting, press the trailing knife origin setting. 到主人機內的原點設定按下後刀原點設定。



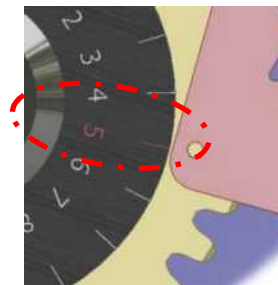
Indicator and Dial Scale  
Corresponding position 指針與  
刻度盤相對應位置。

### Pull Collar Gap Adjustment 咬紙輪間隙調整

1. Adjust the pull collar gap, and turn the dial scale to 5mm graduation position toward the indicator as shown as the figure.  
調整咬紙輪間隙將圖示刻度盤5mm的刻度對準指針。
2. Go to the main HM or HM calibration of die cut machine reset to zero, and press pull collar of zero point setting.  
到主人機或是校正人機內的模切機構歸零按下咬紙輪間隙零點設定。

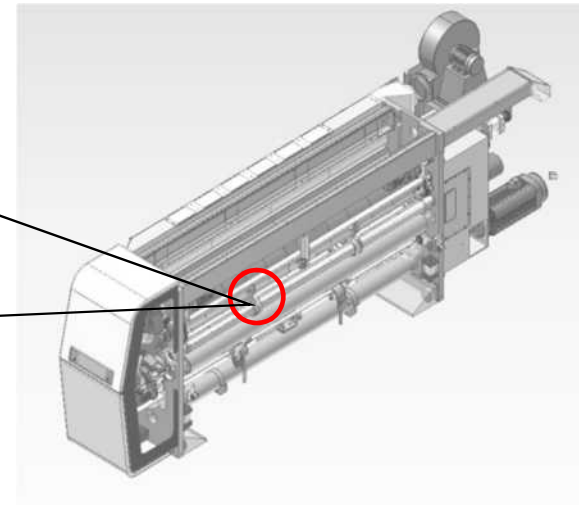
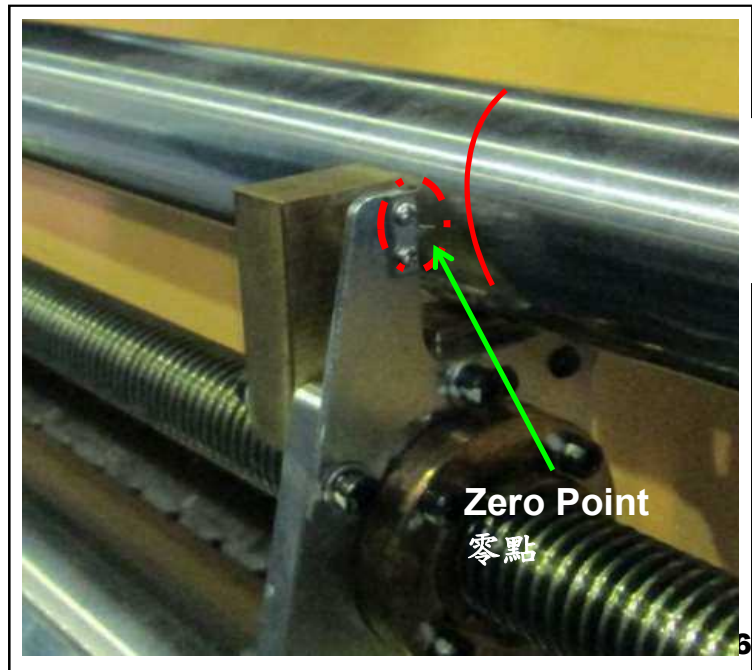


Indicator  
指針



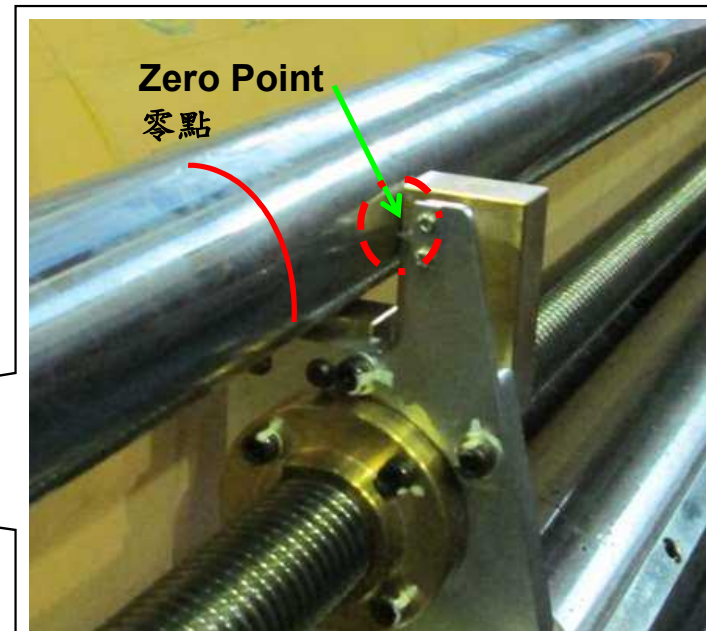
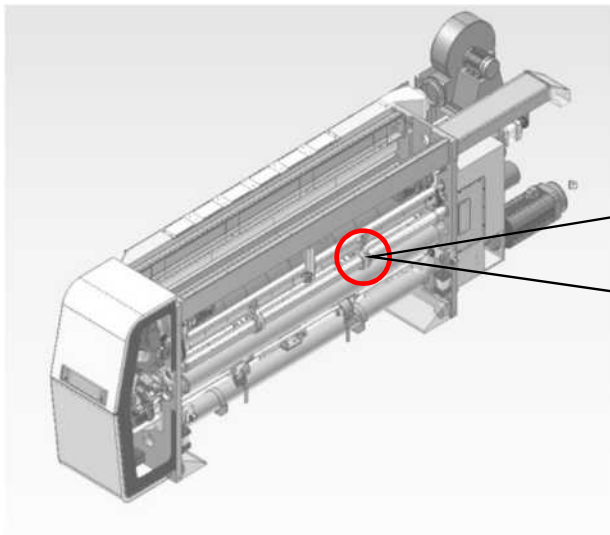
OS Pull Collar Position Calibration 操作側咬紙輪位置校正

1. Move the pull collar to the indicator and the marking corresponding position as shown as the figure. 將咬紙輪移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of die cut machine reset to zero, and press the OS pull collar position of zero point setting. 到主人機或是校正人機內的模切機構歸零按下操作側咬紙輪位置零點設定。



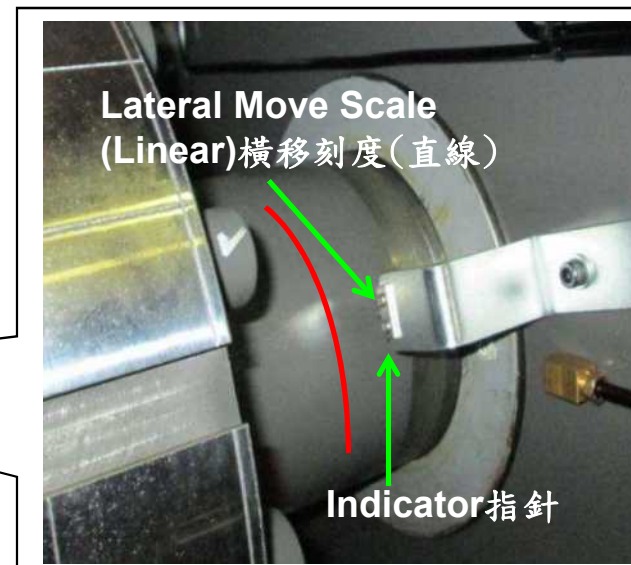
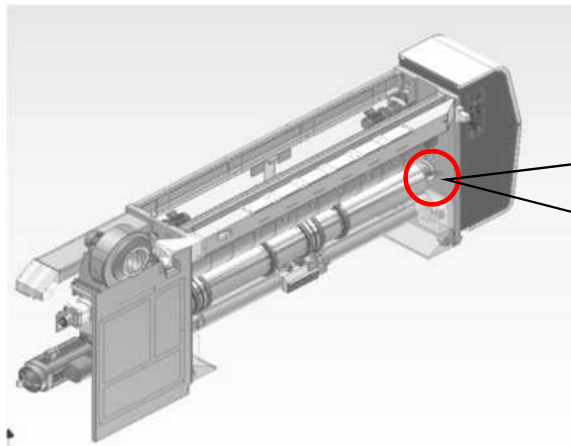
### DS Pull Collar Position Calibration 驅動側咬紙輪位置校正

1. Move the pull collar to the indicator and the marking corresponding position as shown as the figure.  
將咬紙輪移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of die cut machine reset to zero, and press the DS pull collar position of zero point setting. 到主人機或是校正人機內的模切機構歸零按下驅動側咬紙輪位置零點設定。



### Knife Wheel Lateral Move Calibration 刀輪橫移校正

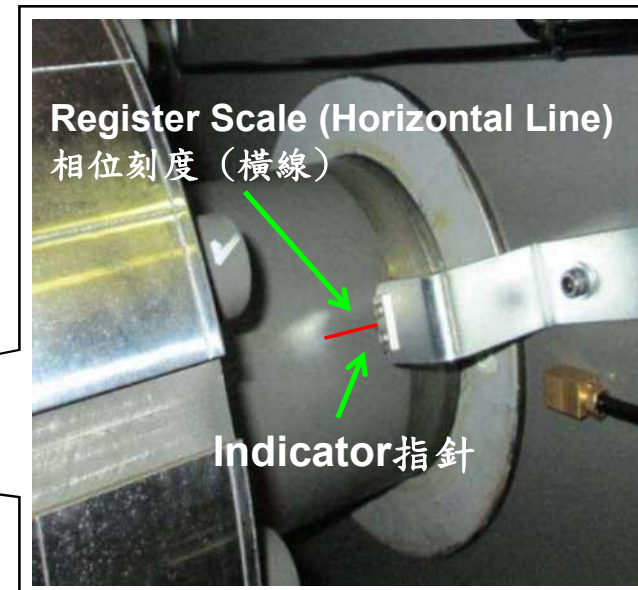
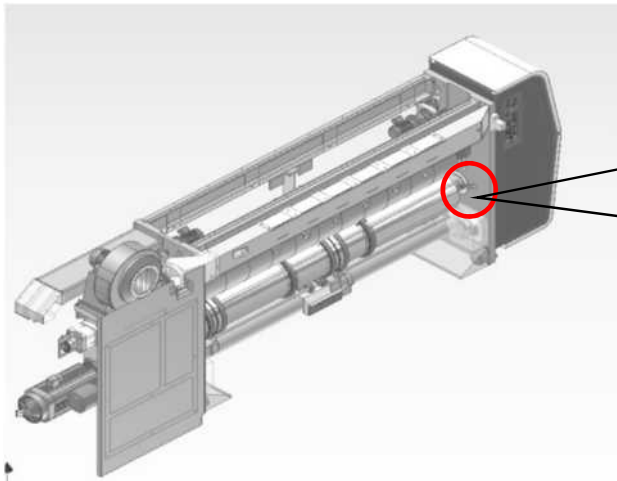
1. Move the knife wheel to the indicator and the marking corresponding position as shown as the figure. 將刀輪移動到圖示指針與刻度相對應的位置。
2. Go to the main HM or HM calibration of machine calibration, press the knife wheel lateral move of zero point setting. 到主人機或是校正人機內的機構校正按下刀輪橫移零點設定。





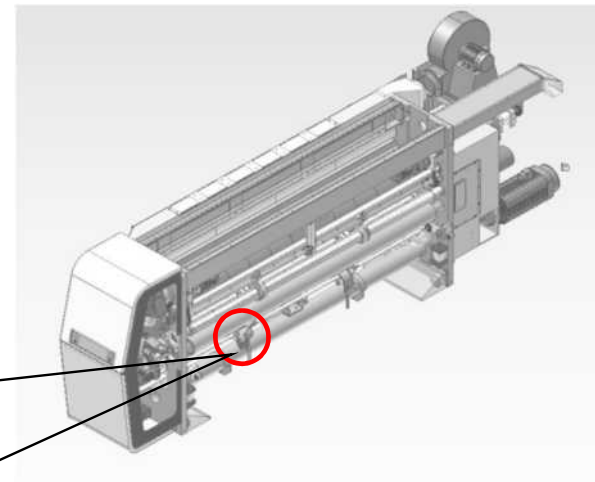
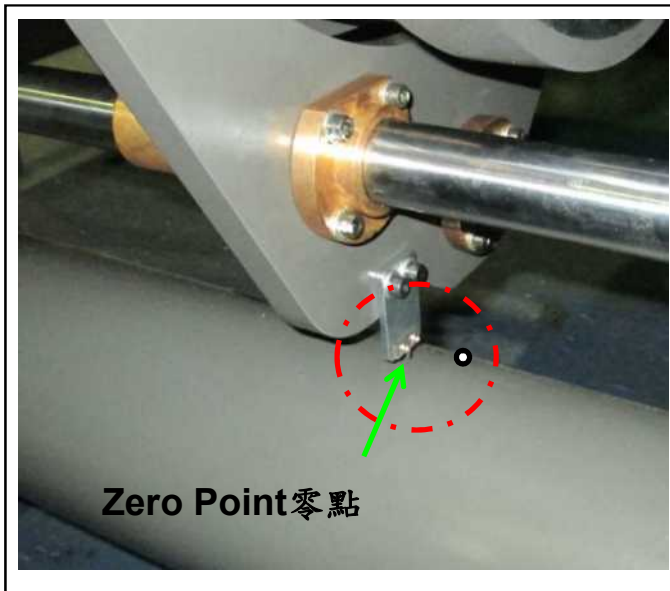
### Knife Wheel Register Calibration 刀輪相位校正

1. Move the knife wheel to the indicator and the marking corresponding position as shown as the figure. 將刀輪移動到圖示指針與刻度相對應的位置。
2. Go to the main HM of die cut origin setting, press the die cut wheel of origin setting. 到主人機內的模切原點設定按下模切輪原點設定。



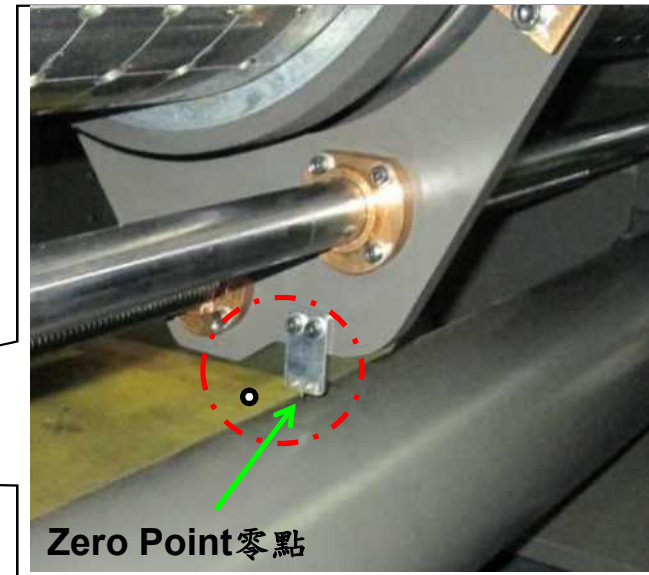
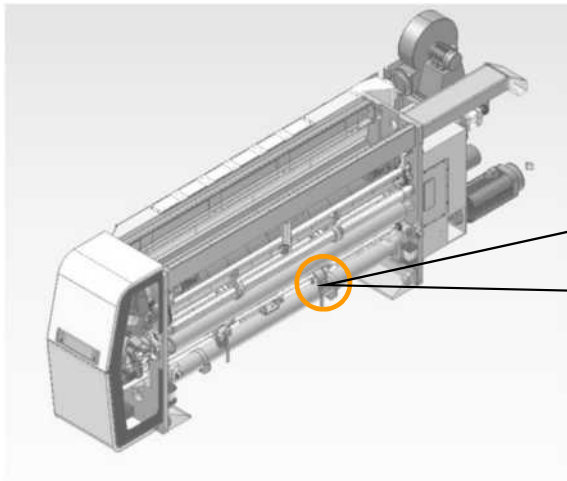
OS Collar Wheel Lateral Move Calibration 操作側帶紙環橫移校正

1. Move the collar wheel to the indicator and the marking corresponding position as shown as the figure. 將帶紙輪移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of die cut machine reset to zero, press the OS collar wheel gap of zero point setting 到主人機或是校正人機內的模切機構歸零按下操作側帶紙輪間隙零點設定。



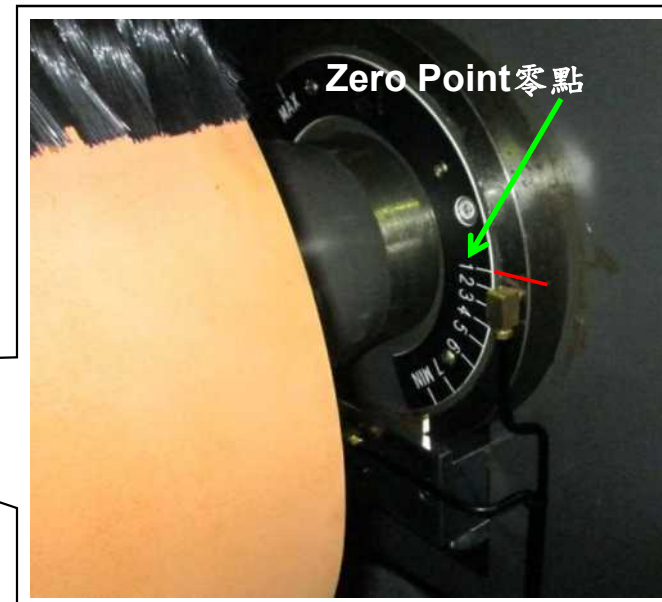
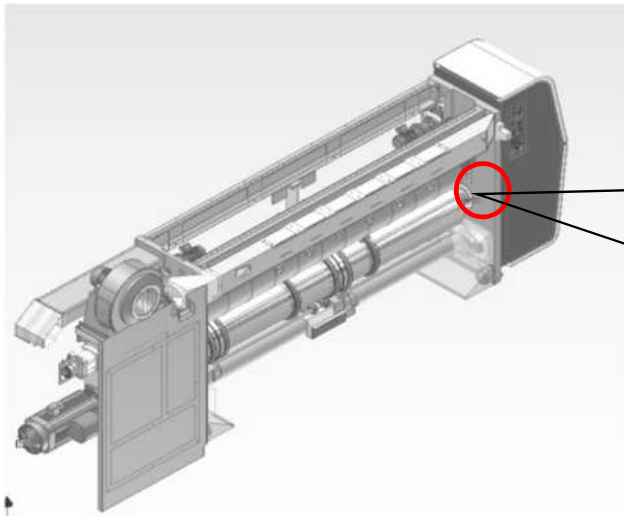
### DS Collar Wheel Lateral Move Calibration 驅動側帶紙環橫移校正

1. Move the collar wheel to the indicator and the marking corresponding position as shown as the figure. 將帶紙輪移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of die cut machine reset to zero, press the DS collar wheel gap of zero point setting 到主人機或是校正人機內的模切機構歸零按下驅動側帶紙輪間隙零點設定。



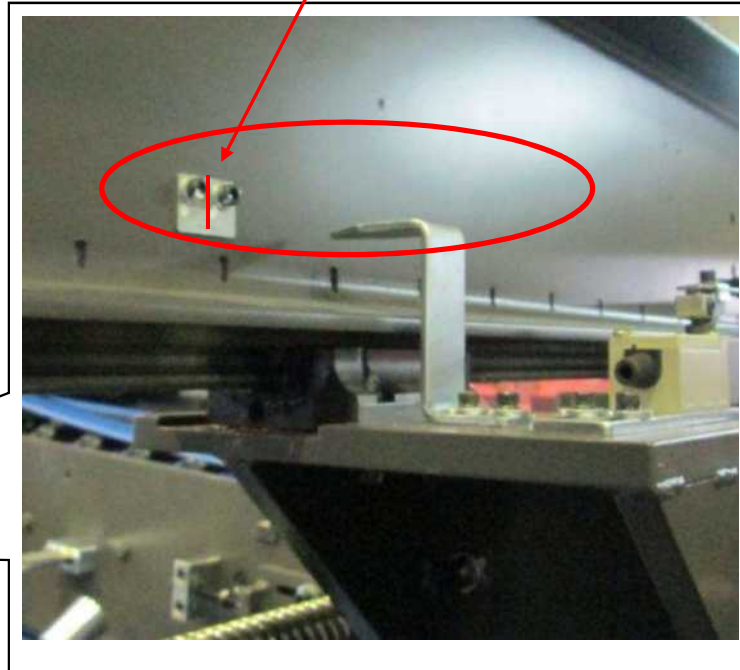
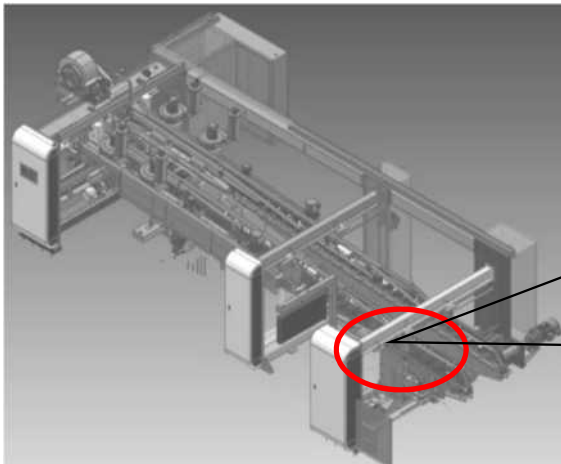
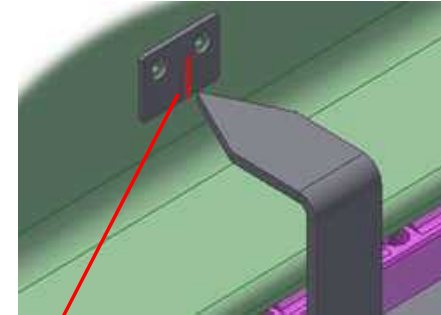
### Die Cut Gap 模切間隙

1. Adjust the pull collar gap, and turn the dial scale first stage graduation toward the zero marking as shown as the figure. 調整咬紙輪間隙將圖示刻度盤1段的刻度對準零點記號。
2. Go to the main HM or HM calibration of die cut machine reset to zero, and press the gap of zero point setting. 到主人機或是校正人機內的模切機構歸零按下間隙零點設定。



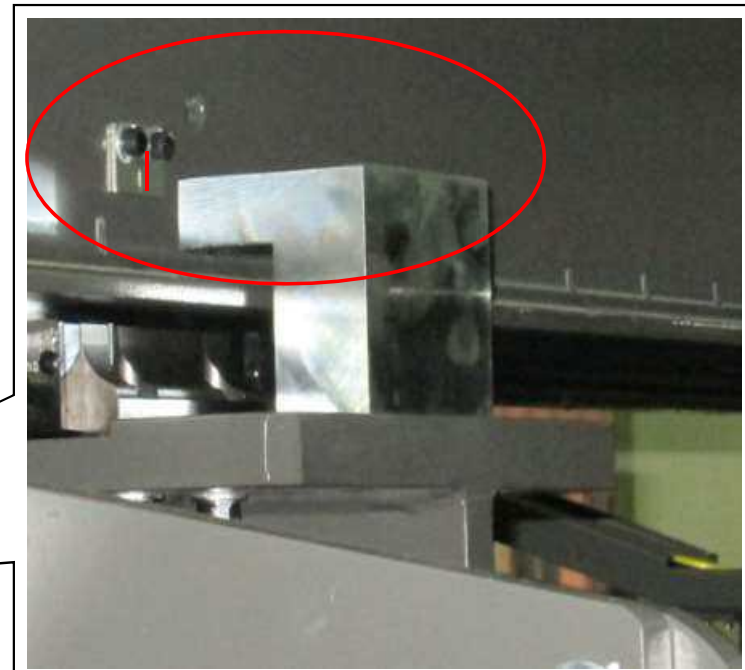
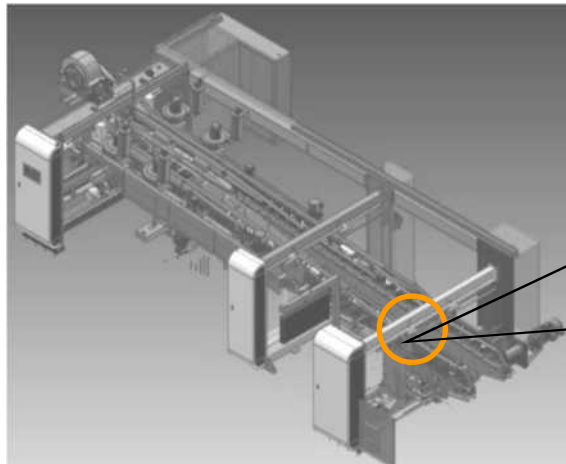
## Glue Stand Position Adjustment 噴糊座位置調整

1. Move the glue stander to the indicator and the marking corresponding position as shown as the figure. 將噴糊座橫移到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of folder gluer machine reset to zero, press the glue stander position of zero point setting. 到主人機或是校正人機內的折貼機構歸零按下噴糊座位置零點設定。



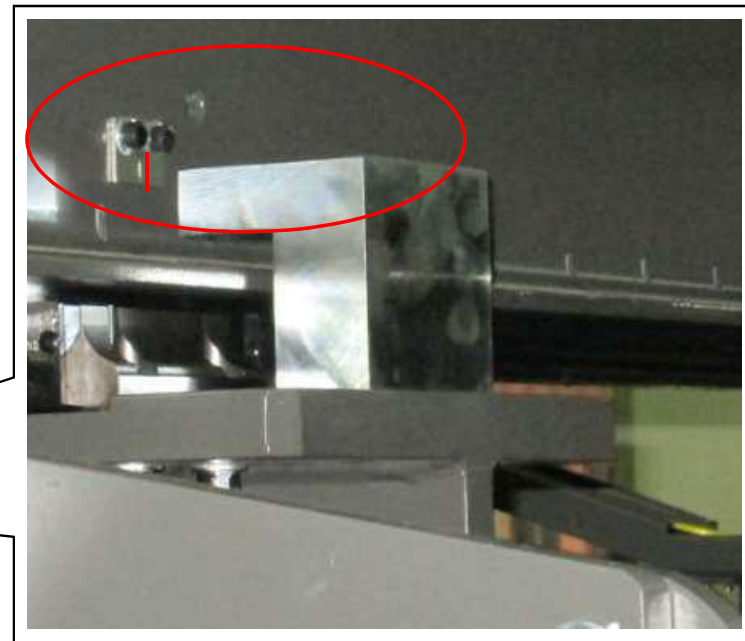
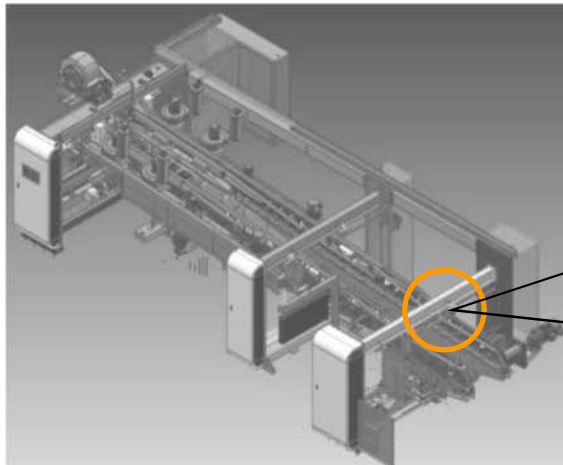
### Operating Side Of Folding Position Adjustment 操作側折翼位置校正

1. Move the operating side of folding to the indicator and the marking corresponding position as shown as the figure. 將操作側折翼橫移到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of folder gluer machine reset to zero, press the OS glue stander position of zero point setting 到主人機或是校正人機內的折貼機構歸零 按下操作側折翼位 置零點設定。



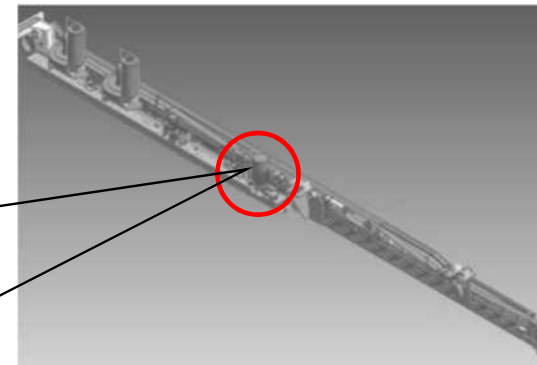
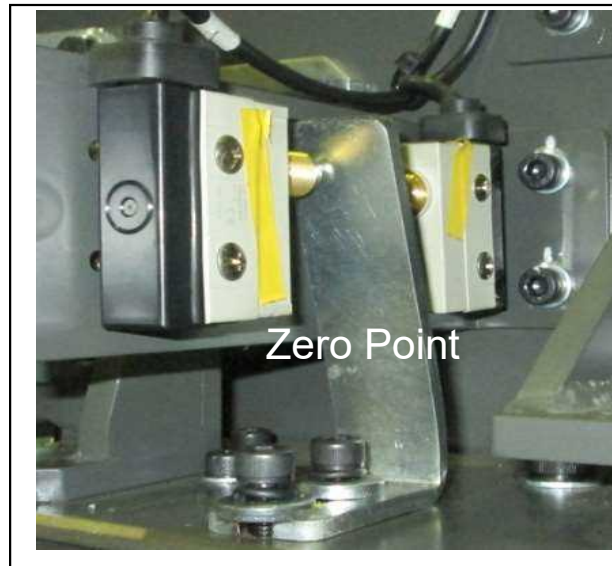
### Driving Side Of Folding Position Adjustment 驅動側折翼位置校正

1. Move the driving side of folding to the indicator and the marking corresponding position as shown as the figure. 將驅動側折翼橫移到圖示指針與記號相對應的位置。
2. Go to main HM or HM calibration of folder gluer machine reset to zero, press the DS glue stander position of zero point setting 到主人機或是校正人機內的折貼機構歸零 按下驅動側折翼位置零點設定。



### Operating Side Of Side Guide Wheel Gap Adjustment 操作側側導輪間隙校正

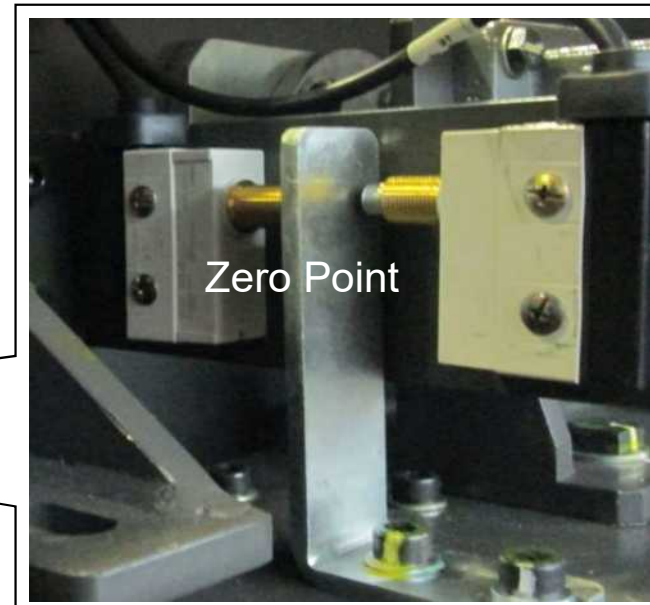
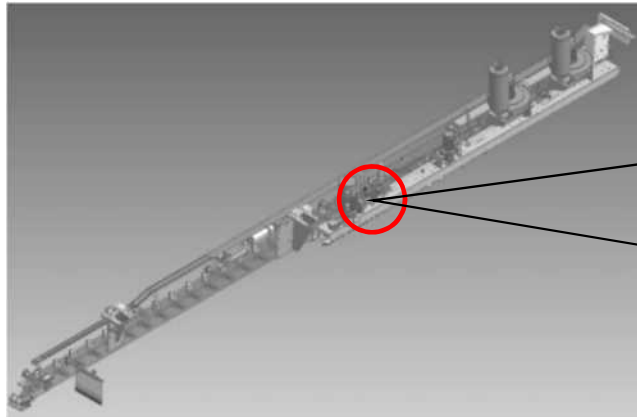
1. Move the operating side of side guide wheel gap to the indicator and the marking corresponding position as shown as the figure. 將操作側側導輪間隙移動到圖示指針與記號相對應的位置。
2. Go to main HM or HM calibration of folder gluer machine reset to zero, press the OS side guide wheel gap of zero point setting. 到主人機或是校正人機內的折貼機構歸零按下操作側側導輪間隙零點設定。





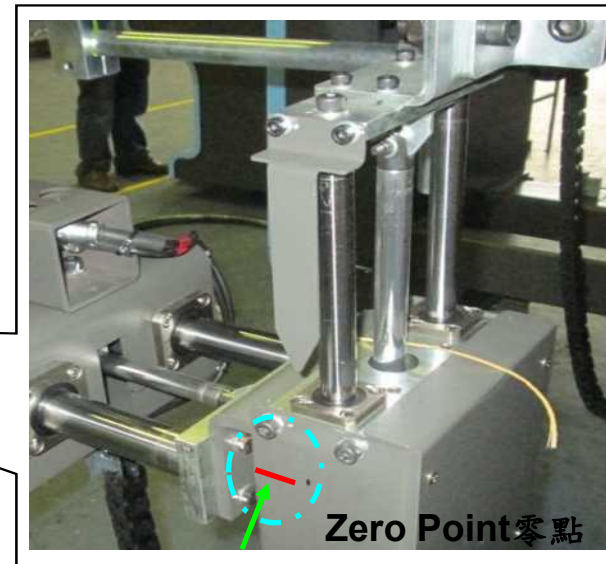
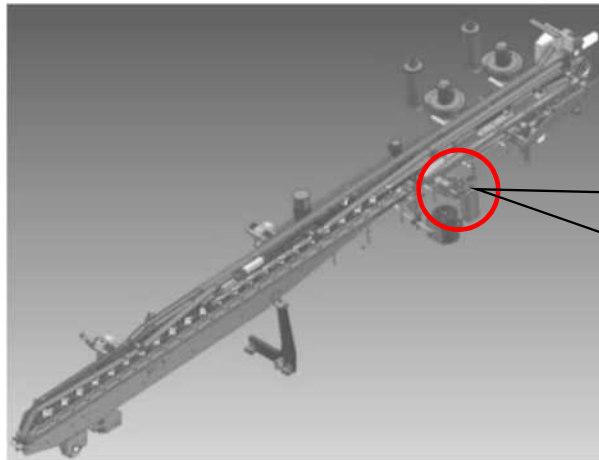
### Driving Side Of Side Guide Wheel Gap Adjustment 驅動側側導輪間隙校正

1. Move the driving side of side guide wheel gap to the indicator and the marking corresponding position as shown as the figure. 將驅動側側導輪間隙移動到圖示指針與記號相對應的位置。
2. Go to main HM or HM calibration of folder gluer machine reset to zero, press the DS side guide wheel gap of zero point setting 到主人機或是校正人機內的折貼機構歸零按下驅動側側導輪間隙零點設定。



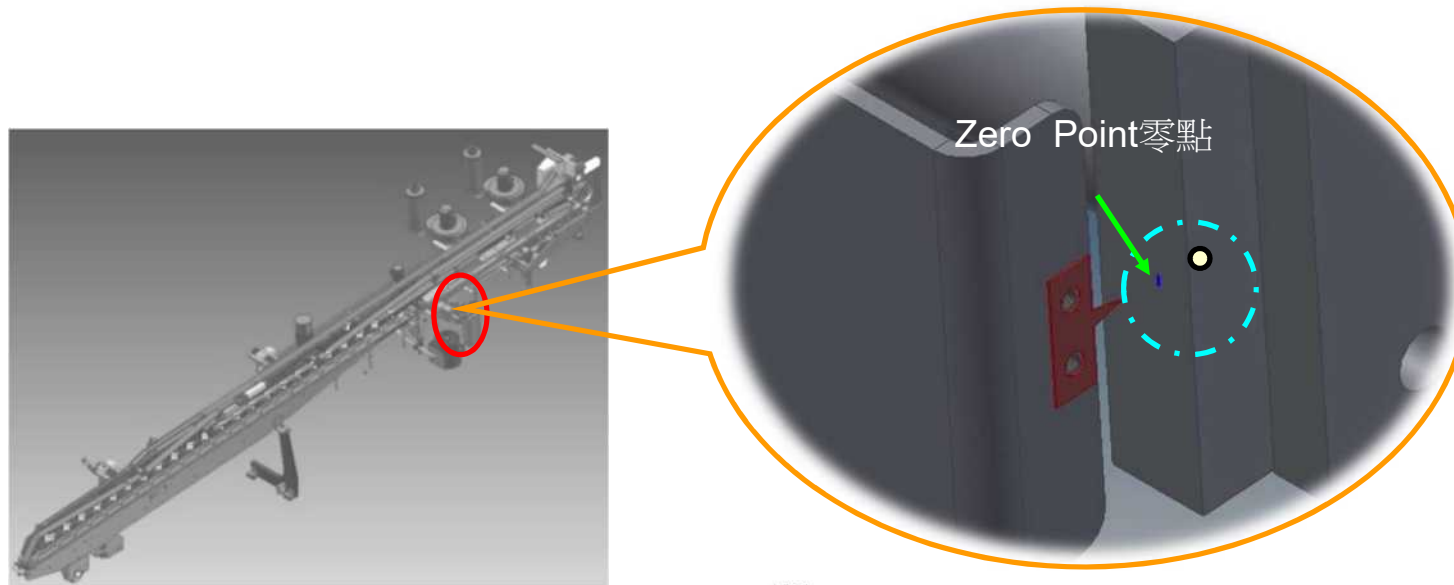
Supporter Electrical Cylinder 扶紙電動缸 - Feeding Side Of Height position Calibration 入紙側高低位置校正

1. Move the supporter electrical cylinder of feeding side of height position to the indicator and the marking corresponding position as shown as the figure.  
將扶紙電動缸入紙側高低位置移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of folder gluer machine reset to zero, press the supporter rod of vertical position of zero point setting.到主人機或是校正人機內的折貼機構歸零按下扶紙桿上下位置零點設定。



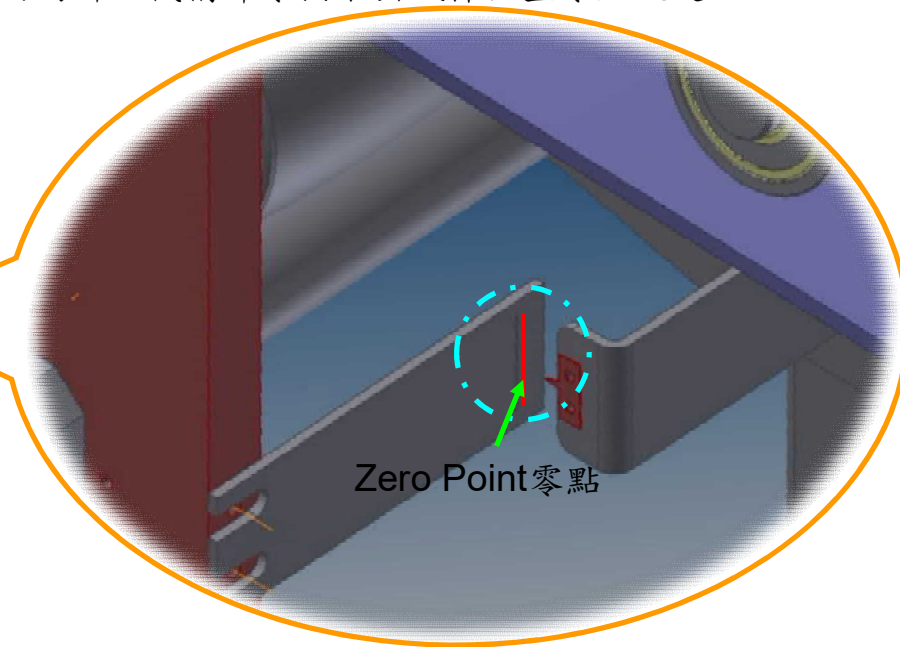
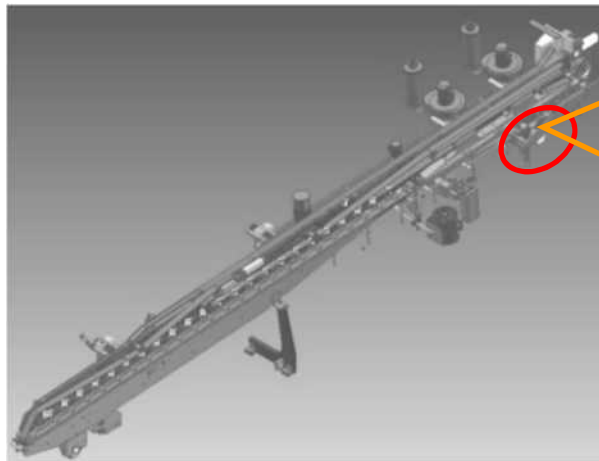
### Supporter Electrical Cylinder 扶紙電動缸 - Feeding Side Of Lateral Move Position Calibration 入紙側橫移位置校正

1. Move the supporter electrical cylinder of feeding side of lateral move position to the indicator and the marking corresponding position as shown as the figure. 將扶紙電動缸入紙側橫移位置移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of folder gluer machine reset to zero, press the supporter rod position of zero point setting. 到主人機或是校正人機內的折貼機構歸零按下入紙桿位置零點設定。



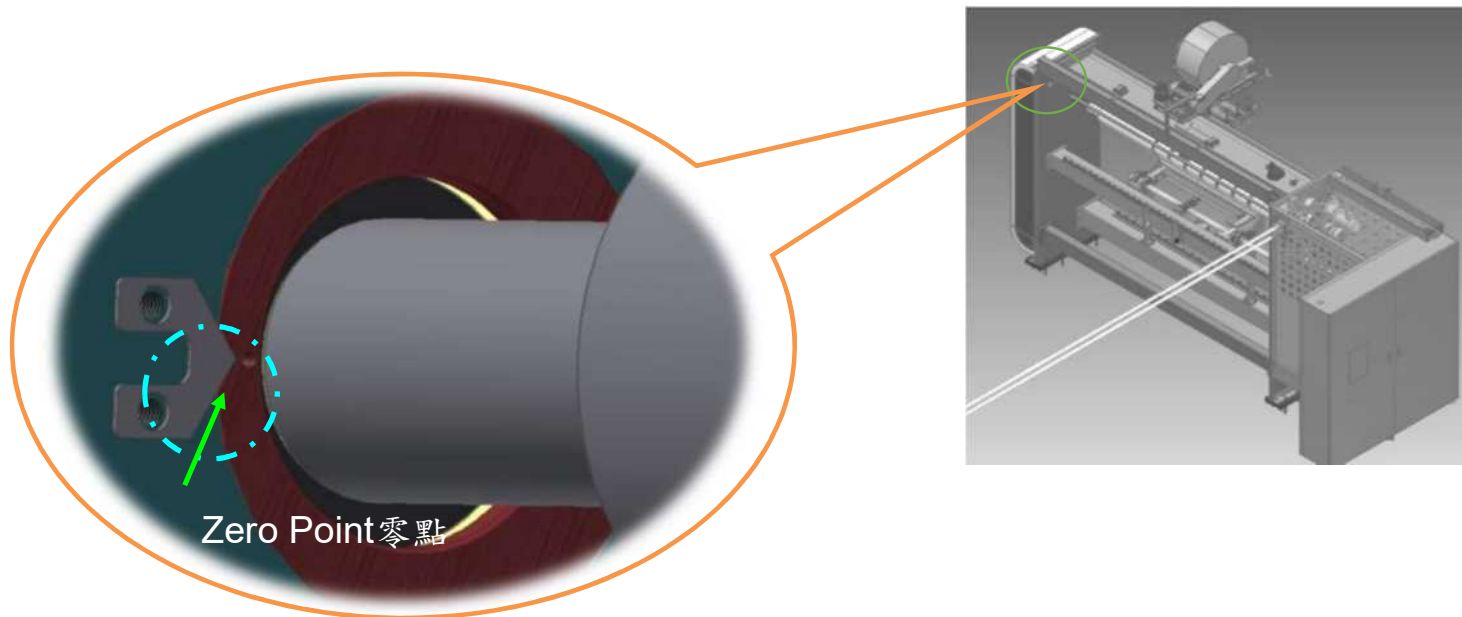
Supporter Electrical Cylinder 扶紙電動缸– Ejecting Side Of Lateral Move Position Calibration 出紙側橫移位置校正

1. Move the supporter electrical cylinder of ejecting side of lateral move position to the indicator and the marking corresponding position as shown as the figure. 將扶紙電動缸出紙側橫移位置移動到圖示指針與記號相對應的位置。
2. Go to main HM or HM calibration of folder gluer machine reset to zero, press the supporter rod position of zero point setting. 到主人機或是校正人機內的折貼機構歸零按下出紙桿位置零點設定。



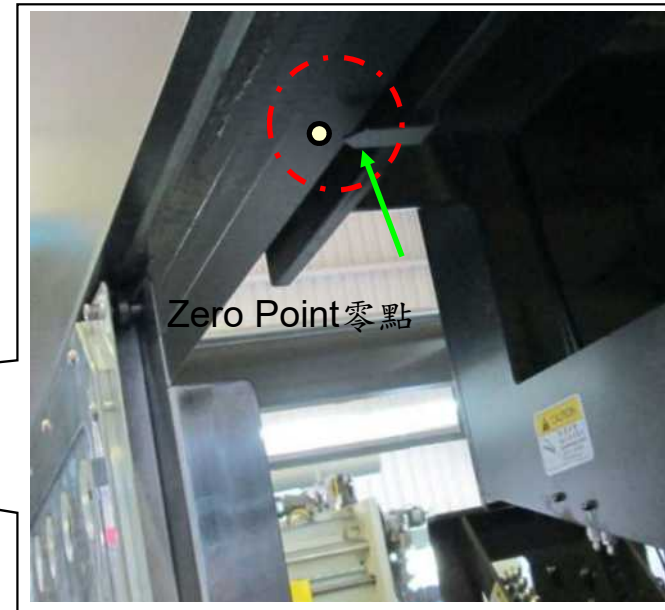
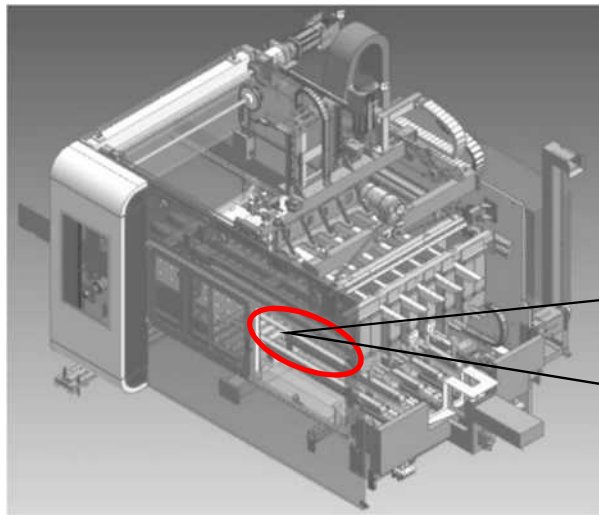
### Ejecting Wheel Gap Calibration 出紙輪間隙校正

1. Move the ejecting wheel gap to the indicator and the marking corresponding position as shown as the figure. 將出紙輪間隙移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of folder gluer machine reset to zero, press the ejecting wheel gap zero point setting. 到主人機或是校正人機內的折貼機構歸零按出紙輪間隙零點設定。



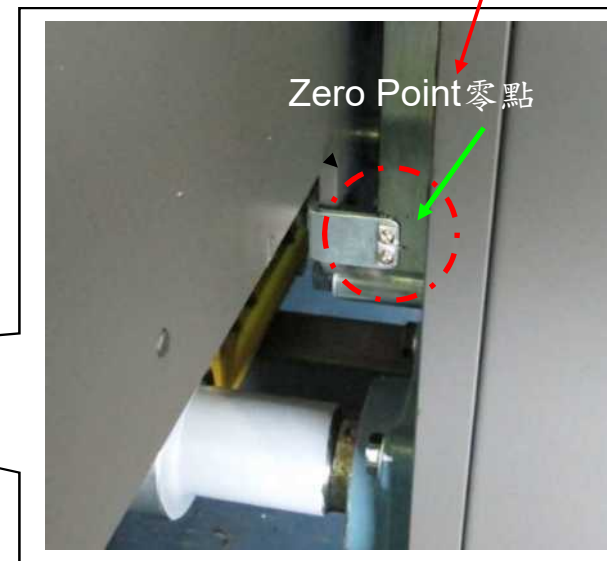
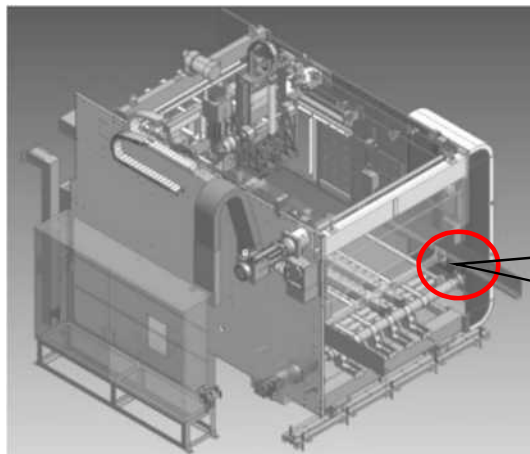
## Counter Back Stop Position Calibration 計數後擋板位置校正

1. Move the counter back stop to the indicator and the marking corresponding position as shown as the figure. 將計數後擋板移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of counter reset to zero, press the counting back stop of zero point setting. 到主人機或是校正人機內的計數機構歸零按計數後擋板零點設定。



### Stack Of Pressing Paper Lift Position Calibration 整疊壓紙升降位置校正

1. Move the counting stack of creasing paper to the indicator and the marking corresponding position as shown as the figure.  
將計數整疊壓紙移動到圖示指針與記號相對應的位置。
2. Go to main HM or HM calibration of counter reset to zero, press the counting stack of creasing position of zero point setting. 到主人機或是校正人機內的計數機構歸零按計數整疊壓紙位置零點設定。



### Counter Unit Of Lateral Move Position Calibration 計數部橫移位置校正

1. Move the counter unit to the indicator and the marking corresponding position as shown as the figure. 將計數部移動到圖示指針與記號相對應的位置。
2. Go to the main HM or HM calibration of counter reset to zero, press the counter unit of zero point setting. 到主人機或是校正人機內的計數機構歸零按計數部零點設定。

