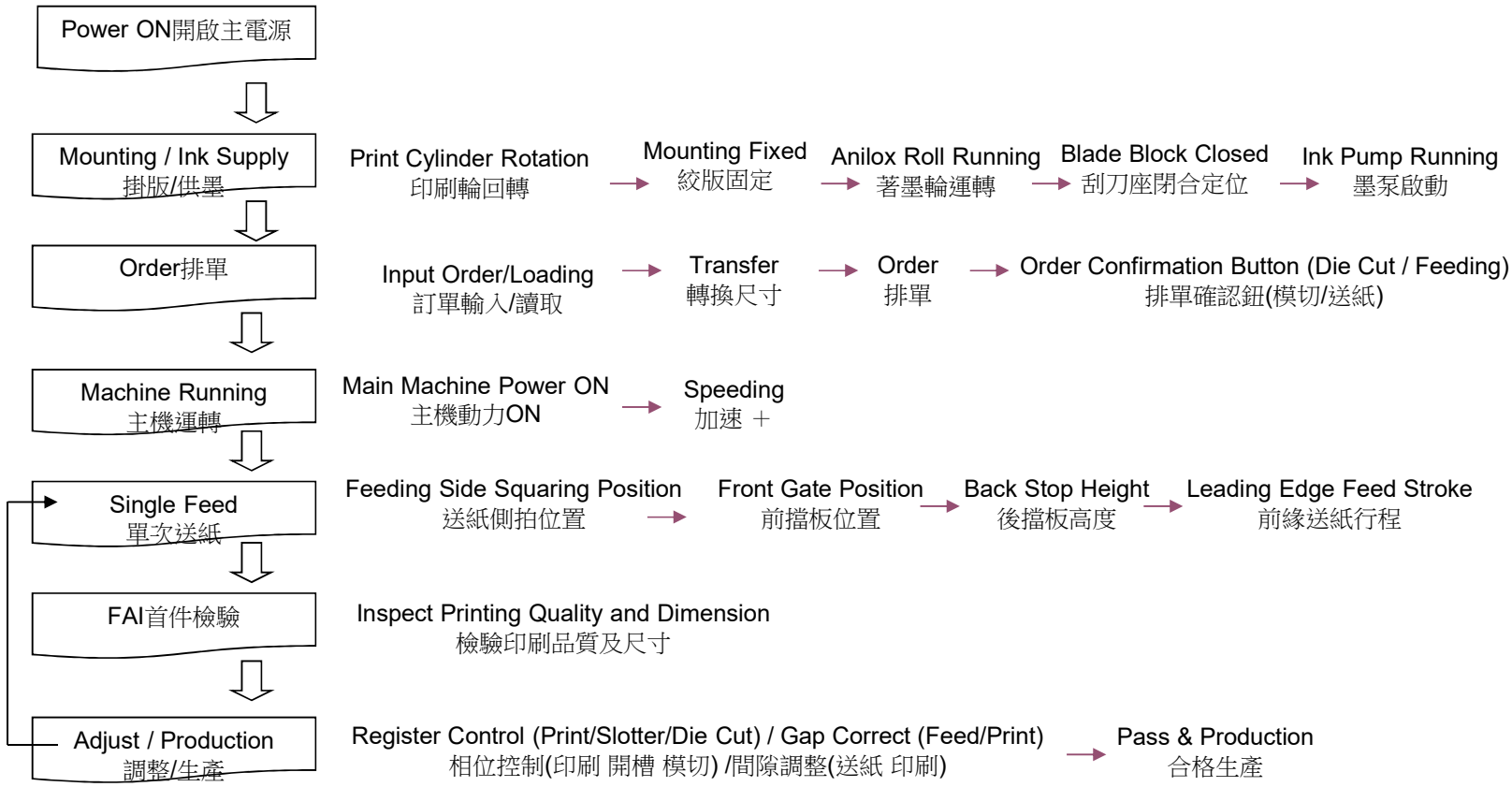
S-1227TV 電腦操作及面板功能說明
Operating System & Control Panel Instruction

Operation Process 操作順序



Power ON 運轉操作
Main Power ON 主機啟動

1. Close all Units and switch MAIN ANCHOR (Feeder-side panel) to LOCK.
閉合所有單元並將機台定位鎖推到“LOCK”位置 (送紙側面板) 。

2. Press the button “ON” in MAIN DRIVE (Feeder Unit) 將主機動力轉至ON(送紙單元).
Press the button “＋” in MAIN DRIVE to increase the speed. Press the button “－” in MAIN DRIVE to decrease the speed.
主機加速按鈕 “＋”增加速至需求速度(速度顯示表“張/分”)，減速時按減速鈕 “－”降低速度。

3. TRANSFER VACUUM and FEED VACUUM will turn to “ON” mode automatically when the MAIN DRIVE is in ON mode. Turn the knobs clockwise / counter clockwise to adjust the vacuum quantity of Transfer and Feed.
主機啟動同時送紙吸力及傳送吸力等二個按鈕開關會自動開到“ON”狀態。
二隻吸風旋鈕開關各別調整送紙吸力及傳送吸力。(並不需要每次調整，依據紙板材質、彎翹度等因素分別調整)。

ATTENTION 備註!

EMERGENCY stop is only used when there are emergency situations. Please follow the normal procedure to shut down the machine in normal situations.
主機動力啟動前按“警鈴”按鈕，警示其它作業人員備註，並檢查工具歸定位避免造成損壞。緊急狀況時按“緊急停止”按鈕機器停止運轉，非緊急狀態時請勿使用。(狀況處理完成需複歸方可重新啟動）

Power OFF 運轉操作
Main Power OFF 主機停止

For temporarily machine stop運轉停止

1. Press the button “OFF” in MAIN DRIVE (Feed Unit).將主機動力轉至OFF(送紙單元) 。

2. TRANSFER VACUUM and FEED VACUUM will turn to “OFF” mode automatically when the MAIN DRIVE is in OFF mode.主機啟動同時送紙吸力及傳送吸力等二個按鈕開關會自動開到"OFF"狀態。

Stop for machine maintenance換單生產，掛版清潔或保養。

1. Press the button “OFF” in MAIN DRIVE (Feed Unit).將主機動力轉至OFF(送紙單元).

2. TRANSFER VACUUM and FEED VACUUM will turn to “OFF” mode automatically when the MAIN DRIVE is in OFF mode.主機啟動同時送紙吸力及傳送吸力等二個按鈕開關會自動開到 “OFF”狀態。

3. Switch MACHINE ANCHOR (Feed Unit) to unlock the machine.將機壁扣轉至Unlock.

4. Open all units.分開所有單元

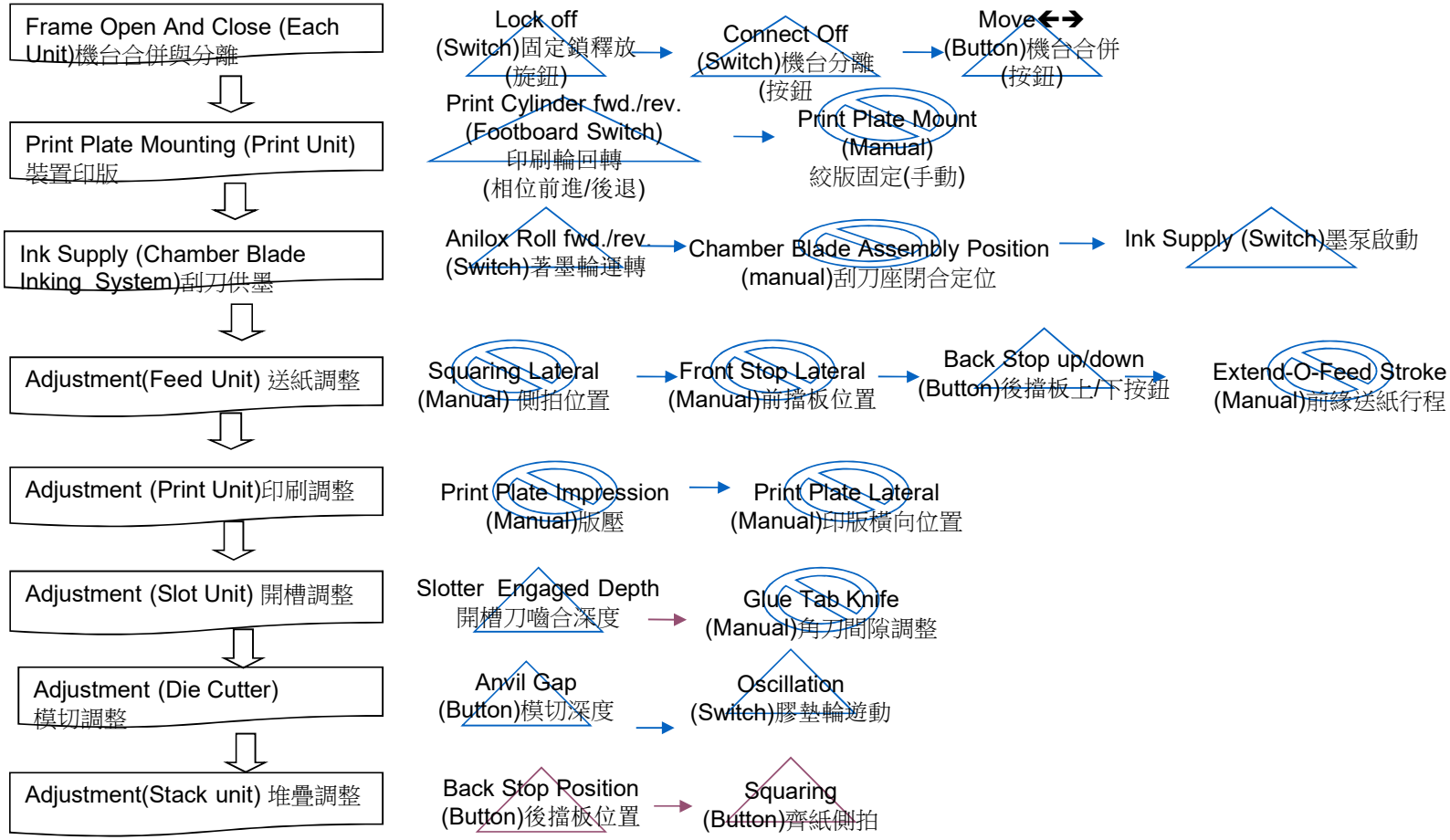
Stop Printing Unit for plate cleaning or mounting停止印刷單元的印板清潔及掛版

1. Switch to OFFLINE in CONNECT of Printer panel to disconnect the Print unit from the system.在印刷面板上開啟離線及同時中斷印刷與電腦系統連線。

ATTENTION備註!

- EMERGENCY stop is only used when there are emergency situations. Please follow the normal procedure to shut down the machine in normal situations.緊急狀況時按"緊急停止"按鈕機器停止運轉，非緊急狀態時請勿使用。（狀況處理完成需複歸方可重新啟動）

Preparation Before Running 運轉前準備
Section to Adjust 調整部位



Preparation Before Running 運轉前準備
Frame Open And Close 各部機台分離與合併

FEEDER OPEN Procedure操作程式

1. Switch MAICHINE ANCHOR to 'UNLOCK' mode in Feeder side panel to unlock machine anchor from ground.送紙單元“機台定位鎖”選擇開關切換至 “UNLOCK”位置。
2. Press FRAME POSITION ➔ by one hand, the other hand press FRAME POSITION push button to move Feeder to the indicative direction.持續押住 “機台移動”按鈕開關(分離方向)依序移動送紙、印刷、開槽等各單元至分離位置，該單元之“機台固鎖”選擇開關切換至 “OFF”位置即可分離。
3. Close the Feeder by the way opposite to that of open.機台合併時反向操作之。

ATTENTION備註!

- Press ALARM to alert people away from the Machine before moving the Units.在開合機壁時，請按下警鈴警告周邊人員
- Keep fingers away when frames are closing
  將手指遠離機壁閉合之處.

SLOTTER / DIE CUTTER OPEN Procedure開槽/模切開啟步驟

- Switch MAIN LOCK to 'UNLOCK 'mode in Feeder side panel to unlock machine anchor from ground.送紙單元“機台定位鎖”選擇開關切換至 “UNLOCK”位置。
- Press FRAME LOCK to 'UNLOCK' (Light OFF) to the unit.按“機台定位鎖”到'UNLOCK' 位置
- Press FRAME POSITION ➔ by one hand, the other hand press FRAME POSITION push button to move the unit to the indicative direction.一手按機台移動,而另一手按機台移動來移動機台。
- Close the unit by the way opposite to that of open.機台合併時反向操作之。

Preparation before Running 運轉前準備
Print Plate Mounting 裝置印版

Procedure操作程式

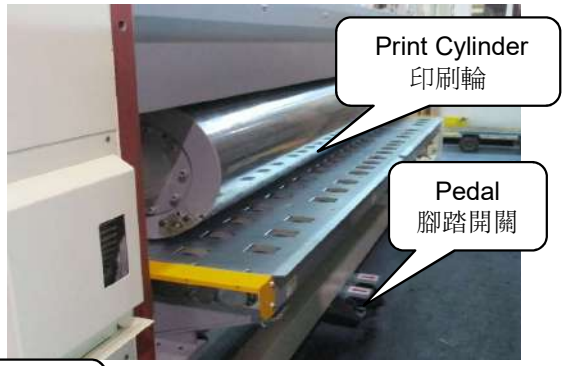
- Insert the head of the print plate into the plate channel.印版前端掛版條插入固定版溝槽內。
- Press the pedal to rotate the print cylinder till the tighten rod facing to the operator. Insert the end of the print plate into the tighten rod.以”腳踏開關”啟動印刷輪回轉至絞版軸面向操作者位置，印版後端插入絞版軸。
- Align the center line of the print plate to parallel with the print cylinder.調整確認印版中心線與印刷輪中心線對齊。
- Fasten the tighten rod (O.S.) properly by a spanner to secure the print plate.以專用掛版扳手轉動絞版軸(位於印刷輪操作側端面)至適當緊度即可固定印版。掛版扳手放回定位。
- Mount the print plate of Print Units in turn.各色印版依序裝置完成。
- Demount the print plate by the way opposite to that of mounting.拆卸印版時與固定印版反向順序操作之。

Remark說明

- Adjust or replace the spring of the tighten rod (D.S.) when the tighten rod cannot fix the print plate properly.無法保持絞版緊度時，應調整絞版軸端(驅動側)盤型彈片緊度或更新彈片。
- The film of the print plate should contact the print cylinder consistently and completely. 絞版緊度以版紙剛好密合貼於印刷輪為適當。

ATTENTION備註!

- After mounting or demounting the print plate, be sure toTAKEAWAY the SPANNER from the tighten rod prior to rotating to print cylinder or starting the Machine for safety.裝卸印版務必將掛版扳手取下，置入扳手定位座，方可轉動印刷輪或機器，避免危及人員、機器。



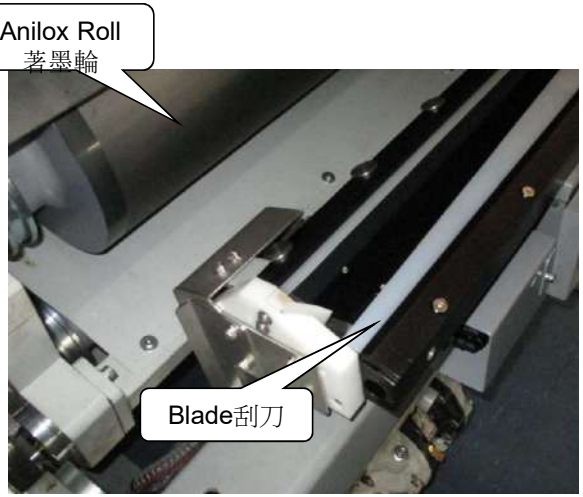
Preparation before Running 運轉前準備
Ink Supply (Doctor Blade System) 水墨供給(刮刀系統)

Procedure操作程式

- The fastening handle at each side should lock while the chamber contacts the anilox roll.刮刀墨室與著墨輪閉合，兩端定位栓固鎖。
- Switch ANILOX POSITION to “AUTO” mode no matter the Machine is running or not.著墨輪位置開關切換至 “自動"位置，啟動著墨輪在轉動狀態。(無論主機是否運轉)
- Switch INK SYSTEM selector to “SUPPLY” mode and press “START” button to supply ink.供墨迴圈選擇開關切換至“供墨”位置，選擇供墨作業模式。按"啟動"按鈕開始自動供墨迴圈。
- Supply ink of each Print Units in turn.依序完成各色供墨操作。

Remark說明

- The chamber seal, the doctor blade, and the scraper blade at each side should be installed properly before the chamber contacts the anilox roll. Also, the chamber seal should spray lubrication before installing.刮刀墨室閉合之前必須檢查墨室兩端密封墊與刮刀片是否裝置妥當，並於密封墊氈毯處塗抹潤滑油脂。
- The ink supply from ink bucket to chamber will take couple seconds.
供墨啟動後會延遲幾秒後待刮刀片與著墨輪密合後才開始供墨乃屬正常現象。
- The anilox roll will not run till the fastening handle at each side locked properly.若兩端密封墊與刮刀片未裝置妥當，則著墨輪無法開作動。
- Ink supply will stop when the pump is broken, the filter is blocked, no ink supply to, the pressure is not enough and so on.泵故障、濾網阻塞、水墨用罄或壓縮空氣壓力不足等現象，皆有可能產生水墨供應中斷。
- The pressure for ink pump is about 4~5kg/cm^2.泵作動壓縮空氣壓力為4~5kg/cm^2。

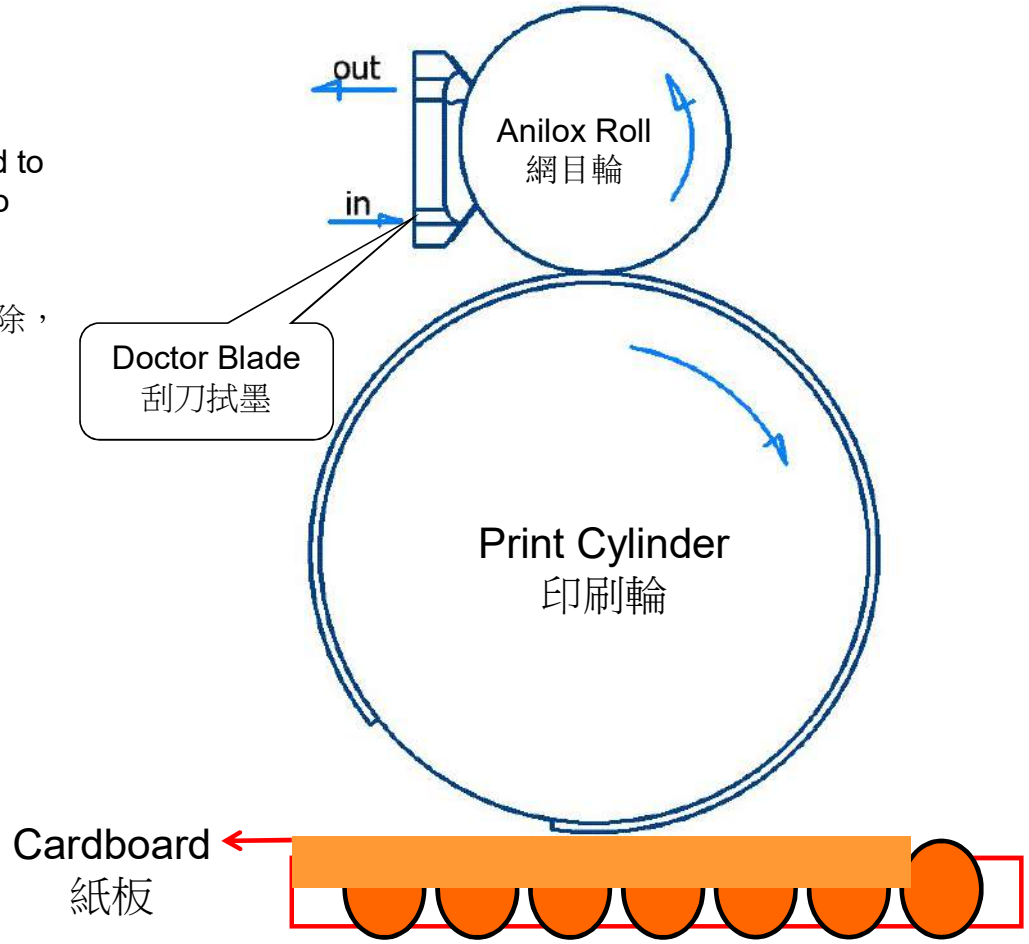


Preparation before Running 運轉前準備
Ink Supply 水墨供給 - Principle 刮刀原理

Principle Of Doctor Blade System 刮刀拭墨系統原理

The ink flows from ink supply system. The anilox roll will touch the ink and be scraped by doctor blade. The ink will be transferred to printer cylinder in ” Print Plate Pressure” way, and be transferred to cardboard in “ Print Plate Pressure” way.

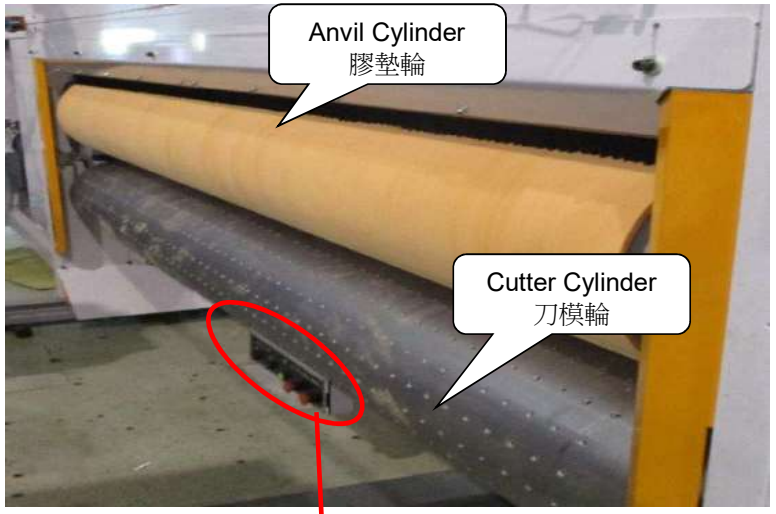
油墨從刮刀供墨系統出來，經由網目輪的細小網點著墨，由刮刀刮除，以轉動方式“版壓”到印刷輪，再”印壓”到紙板上。



Preparation before Running 運轉前準備
Die Cut Mould Mounting 裝置模切刀模

Procedure操作程式

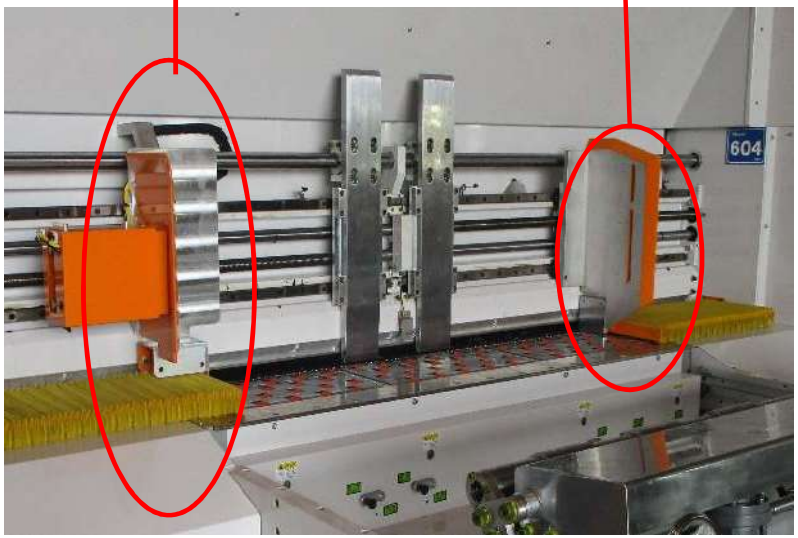
1. Separate the anvil cylinder and the die cut cylinder to the max. Gap by ANVIL GAP setting from touch screen.按”模切間隙”開關刀模輪與膠墊輪間隙分離至最大間隙位置
2. Use FWD / REV button to control the rotation of cutter cylinder.按前進/後退調整刀模輪轉動方向。
3. JOG button to rotate the cutter cylinder a little.寸動鈕可使整機相位(大相位)同時向前轉動。
4. Align the center line of the mould to parallel with the die cut cylinder.刀模中心線與刀模輪中心對齊。
5. Fix the mould to the cutter cylinder by screws. The screws should be tightened from the center to both sides.刀模中間開始依序向兩側鎖緊固定螺絲，確保刀模密合貼於刀模輪。
6. Demount the mould by the way opposite to that of mounting.拆卸刀模時以固定刀模反向順序操作之。

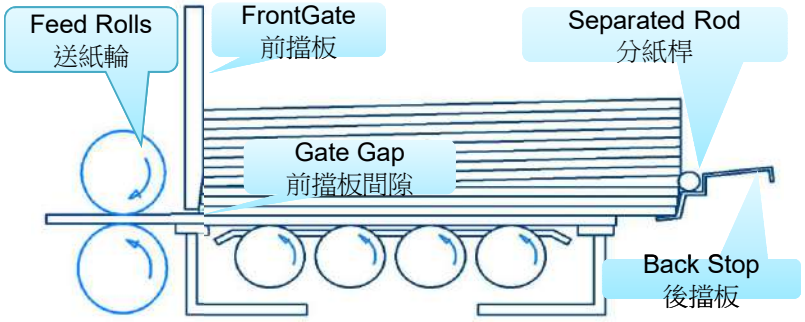


Remark說明

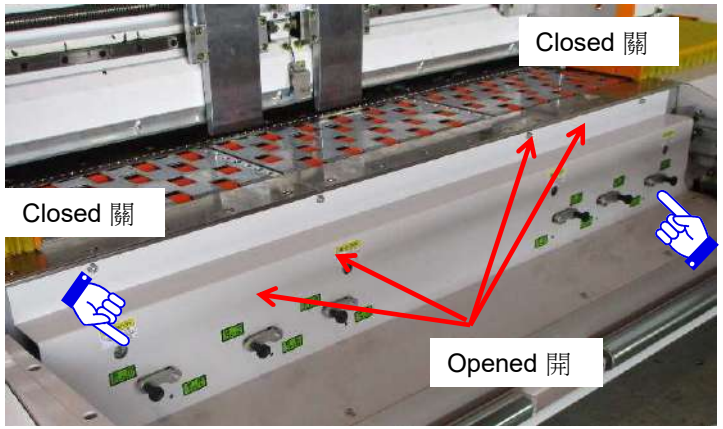
- The cutter cylinder can adjust ±10mm laterally when the center line of the mould cannot correspond to the printing plate.刀模橫向中心位置與印版中心無法對正時，可橫向移動刀模輪位置（左右兩側各10mm）。
- After mounting or demounting the mould, be sure to TAKE AWAY THE SPANNER from the mould prior to rotating the die cut cylinder or starting the Machine for safety. 安裝刀模務必需將扳手取下方可轉動刀模輪或機器，避免危及人員、機器。

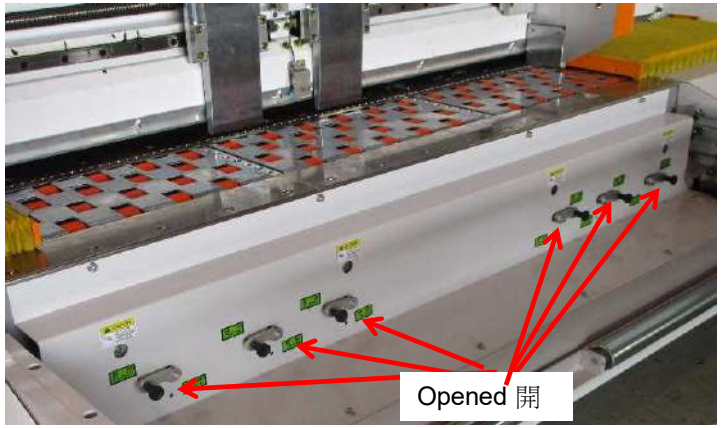
Feeder Unit 送紙單元
Lead Edge Feeding Structure 前緣送紙結構





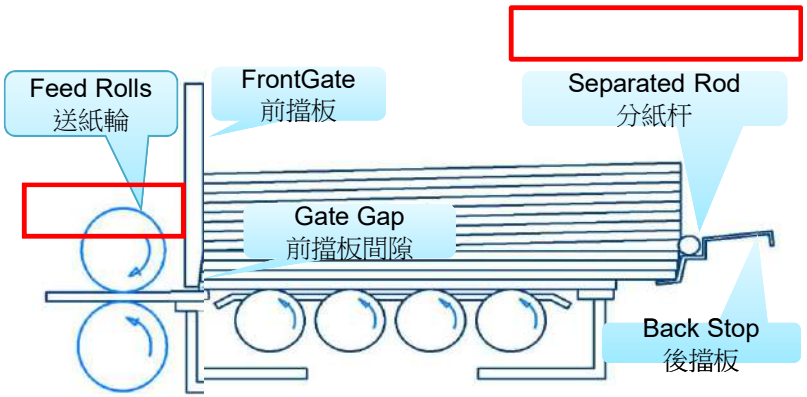
Small Cardboard Partially Covers The bellows
紙板部份覆蓋風箱

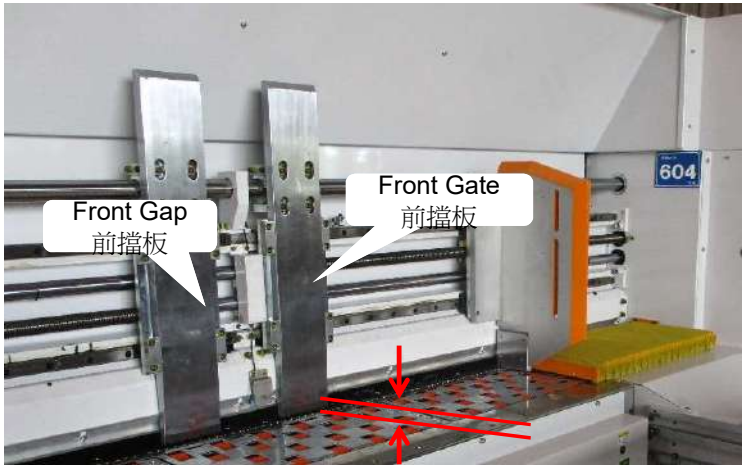


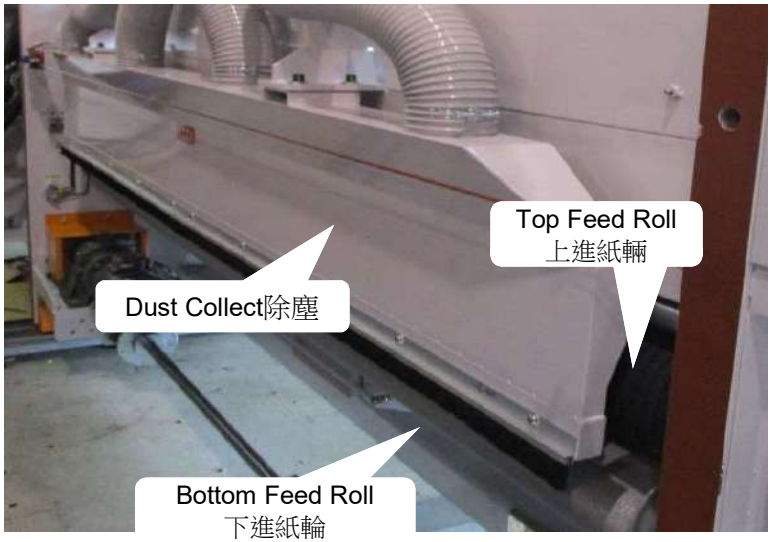


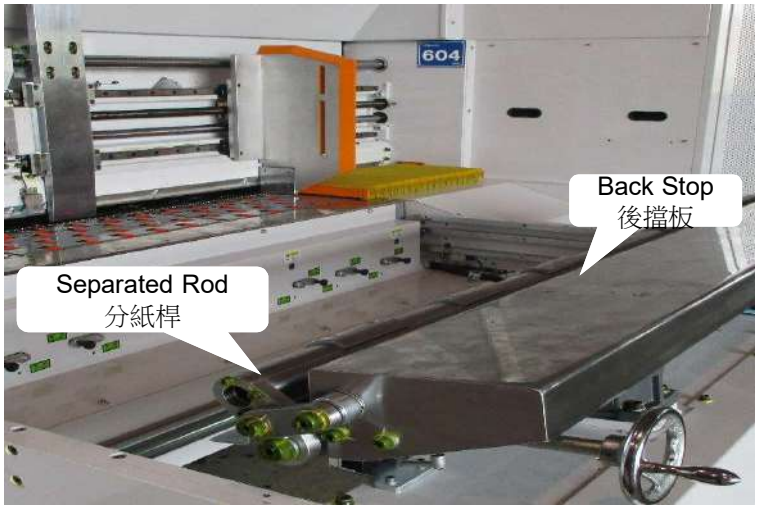
Large Cardboard Completely Covers The bellows
紙板完全覆蓋風箱

Feeder Unit 送紙單元
Lead Edge Feeding Structure 前緣送紙結構

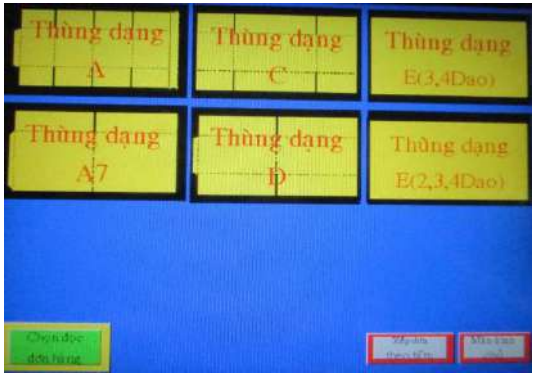




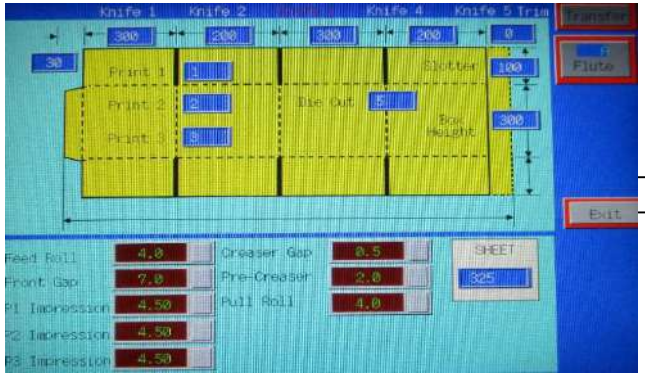




Preparation before Running Auto Setting
排單設定自動調整部位



(Key in the figure in each blank after selecting the box type選擇箱型輸入各項數值)



Auto Adjustment
自動調整部位

(Flute Select)
選擇楞別

- Feeder送紙單元
  - Feed Roll Gap 咬紙輪間隙
  - Front Gap 前擋板間隙
  - Side Guide Gap 側擋板位置
  - Back Stop Position 後擋板位置
- Printer印刷單元
  - Print Register 刷相位
  - Impression 印壓
- Slotter開槽單元
  - Slotter Register 開槽相位
  - Slot Position 開槽間隔
  - Pre-Creaser Gap 破壞輪間隙
  - Creaser Gap 壓線輪間隙
  - Box Depth 紙箱高度
- Die Cutter模切單元
  - Die Cut Register 模切相位
  - Pull Collar Position 咬紙輪位置
  - Pull Collar Gap 咬紙輪間隙
- Folder Gluer糊箱單元
  - Back Stopper 後擋板位置
  - Counter Center 計數部中心
  - Folder Position 折翼位置
  - Gluer Position 糊座位置

Preparation before Running - Order Setting
人機介面排單設定

Procedure操作程式

- “訂單設定操作Order Setting” .

1. Once turn on the power, it will display the main page of HMI 開啟機器電源即自動顯示人機介面首頁畫面。
2. Press “Order Setting ”page 點選進入"訂單輸入"頁。
3. Press “Box Selection” to enter the key in page.點選預定生產"箱型圖"進入輸入頁。
4. Refer box type to key in the dimension for each parts.依據箱型圖輸入訂單各部位尺寸數值。
5. Press “Flute Setting” and will auto change to flute page 點選"楞型設定"自動切換至楞型選擇頁。
6. After press the flute type and go back to order setting page. 點選預定生產的紙板楞型後離開回訂單輸入頁。
7. Press “Transfer” to complete the current machine position for auto judging 點選"尺寸轉換"完成機器現有位置自動判讀。
8. Press Transfer to start the machine all parts adjusting power. Then the screen will auto switch to display page to display the current value of each position ~ current value (left) and setting value (right) 點選“排單”啟動機器各部位調整動力，畫面自動切換至顯示頁，顯示各部位之現在值(左側)與設定值(右側)。

Remark說明

1. When the transfer adjusting for machine each part, the orange light is flashing and also have warming music機器各部位排單調整進行中有橘色燈號閃亮及聲音警示。
2. Press “Auto Stop” will stop the order setting.機器各部位排單調整進行中點選"停止自動"即中止排單調整。
3. Each kind of flute and can pre-set the passing gap. During production, it only select the flute type and will complete the gap setting.各種常用楞型紙板，可預設紙板通過間隙，生產時只需選擇楞型即可完成所有間隙之設定。
4. If it needs to modify each parts of the Flute gap value, it can directly key in the modification value in order setting page.楞型間隙預設值如需做各別部位修正，可直接在排單頁顯示欄位直接設定輸入修正值。

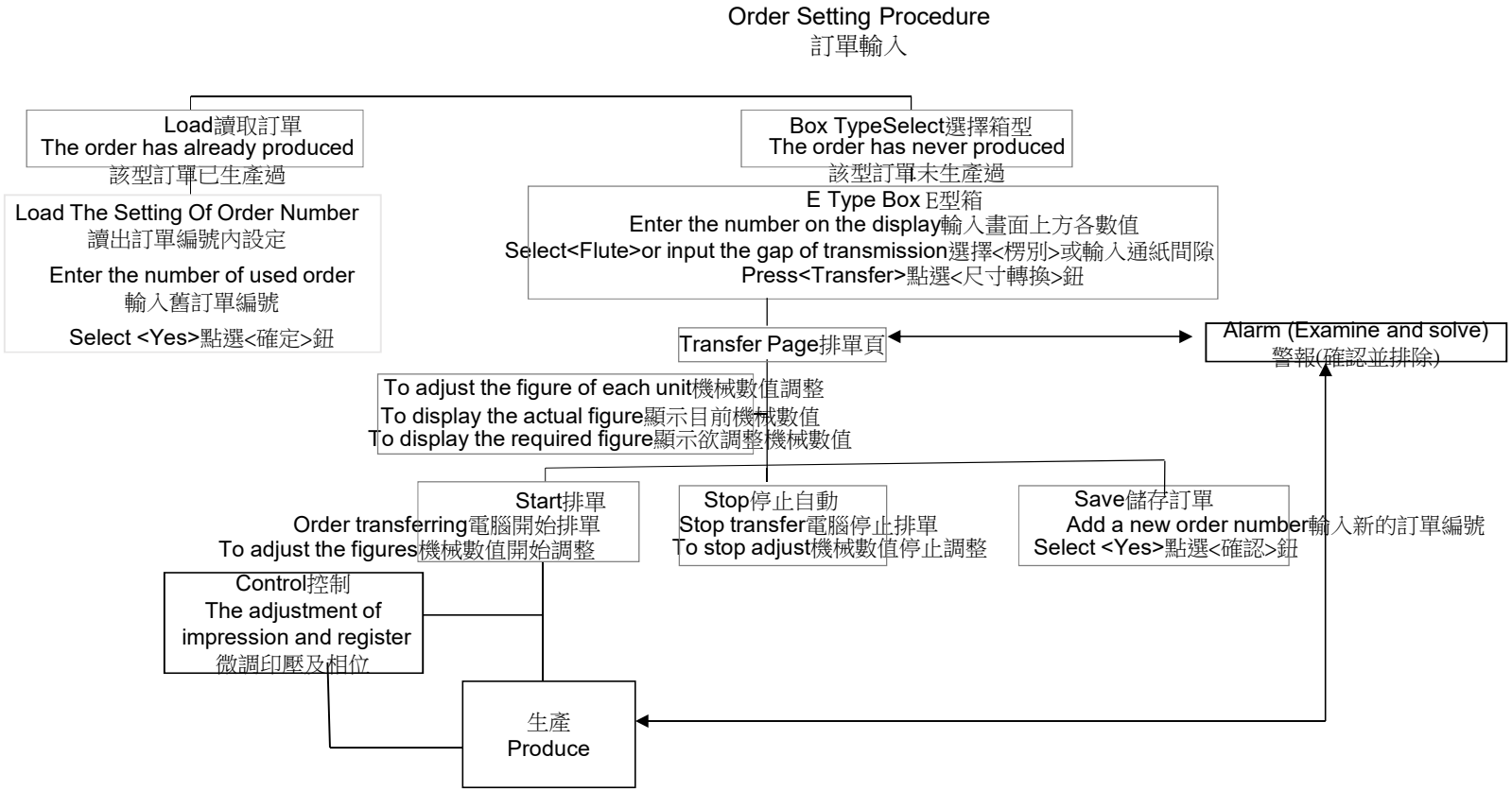
Order Setting
訂單輸入

Box Selection
箱型圖

Flute Setting
楞型設定

Transfer
尺寸轉換

Main HMI - Order Setting Procedure
主人機介面 - 訂單輸入流程



Main HMI – Main
主人機介面 – 首頁

1. 2. 3.

1. The main HMI (Human Machine Interface) is at the right side.主操作人機介面裝置於獨立操作控制台。
2. The Panel Protect page will display when the power is ON. Select PASSWORD on screen. Input:33850780, select ENTER to show the main page.
3. There are some selections in main page首頁功能:

- Order Setting訂單輸入—Show the order setting page to set new order or recall old order. 訂單輸入-點選進入“訂單輸入頁”
- Control控制—Show the control page to adjust the register, Impression gap, box height. 點選進入“控制設定頁”。
- Alarm警報—Show the alarm message, if any. 點選進入“警報顯示頁”。
- Parameter系統參數—Show the parameter page for system parameter setting. 點選進入“系統系統參數頁”。
- Panel Protection面板保護 — Screen Protection螢幕保護。

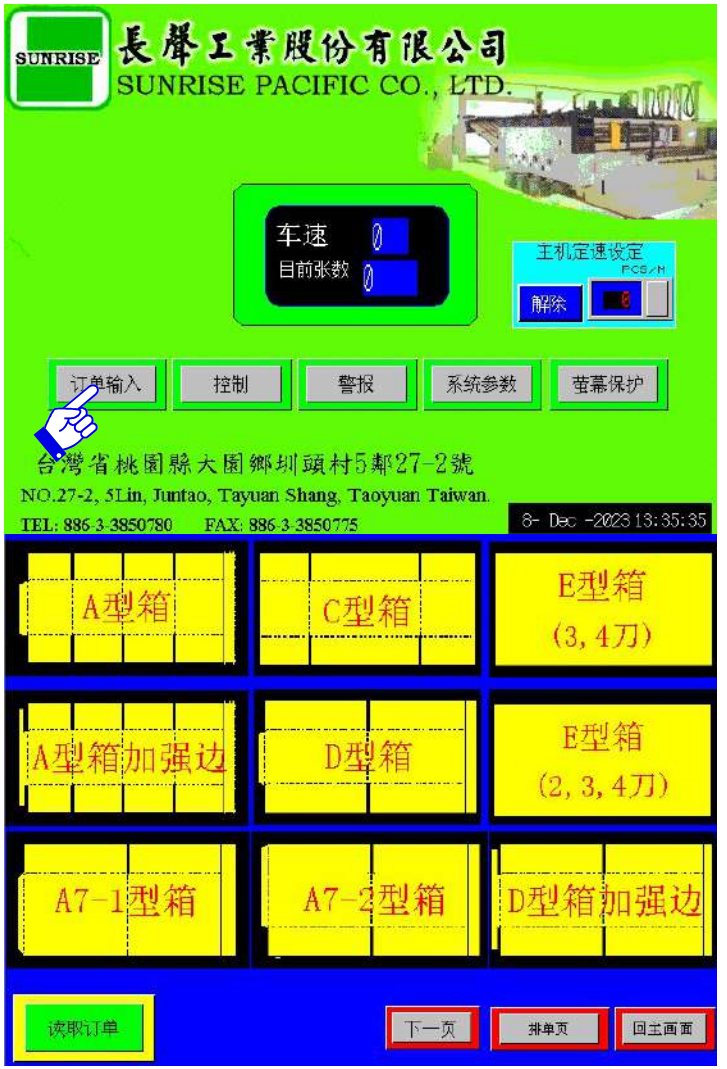
Main HMI - Order Setting
主人機介面 - 訂單輸入頁

Load — When the order is ever produced and the adjustment data is saved in the HMI, the operator can recall the adjustment data by keying in the order No.
此設定乃電腦無法輸入時， 由此訂單輸入畫面輸入.
讀取訂單— 當該筆訂單在過去曾有生產紀錄， 並有訂單編號資料儲存于主人機中， 則操作人員可透過讀取訂單的訂單輸入流程進行訂單處理。

Box Type Select箱型選擇— When the order is new and is never produced, the operator can select Box type to enter the Box dimension page.當該筆訂單在過去未有生產紀錄， 無訂單編號資料儲存于主人機中， 則操作人員可透過箱型選擇的訂單輸入流程進行訂單處理。.

2000 Records memory本人機系統可儲存2000筆訂單。

Remark補充說明
HMI control system and Computer control system is independent. Their order data will not be shared to each other. Therefore, even an order ever produced in HMI control system, it will be new for Computer control system if it never produces in Computer control system.
在訂單資料處理時，電腦系統和人機系統中是各自獨立的， 如果該筆訂單曾在電腦系統中處理， 但並不曾在人機系統中處理， 則該筆訂單對於人機系統而言， 是一筆新的訂單， 適用於箱型選擇的訂單輸入流程進行訂單處理。
於人機系統中所處理的訂單， 該訂單生產紀錄並不會傳送到電腦系統中， 如有安裝辦公室生產系統， 報表中將不會有該筆訂單的生產資料。



Main HMI-Order Setting-Box Type Select-Load
主人機介面-訂單輸入頁-相形選擇-讀取訂單

To load the repeat order from memory.從記憶讀取訂單

- When the order is ever produced before, Click**<Load>** to enter the Load Page在確認欲處理的訂單為舊訂單時， 按下**<讀取訂單>**鈕後， 進入讀出訂單編號內設定頁面.

- After keying in the Order No. press <**ENTER**>, and press <**Yes**> will load the remarks of this order. 輸入舊訂單的訂單編號， 按下<確定>按鈕， 將會自動轉換到排單頁面.
- click**<Transfer>** to enter Transfer page.點選<尺寸轉換>進入尺寸轉換頁。
- click**<Clear Order>** <**Yes**> will display **Wait Moment** to clear the loaded data.點選<訂單清除>會出現等一會，之後再數據消除。

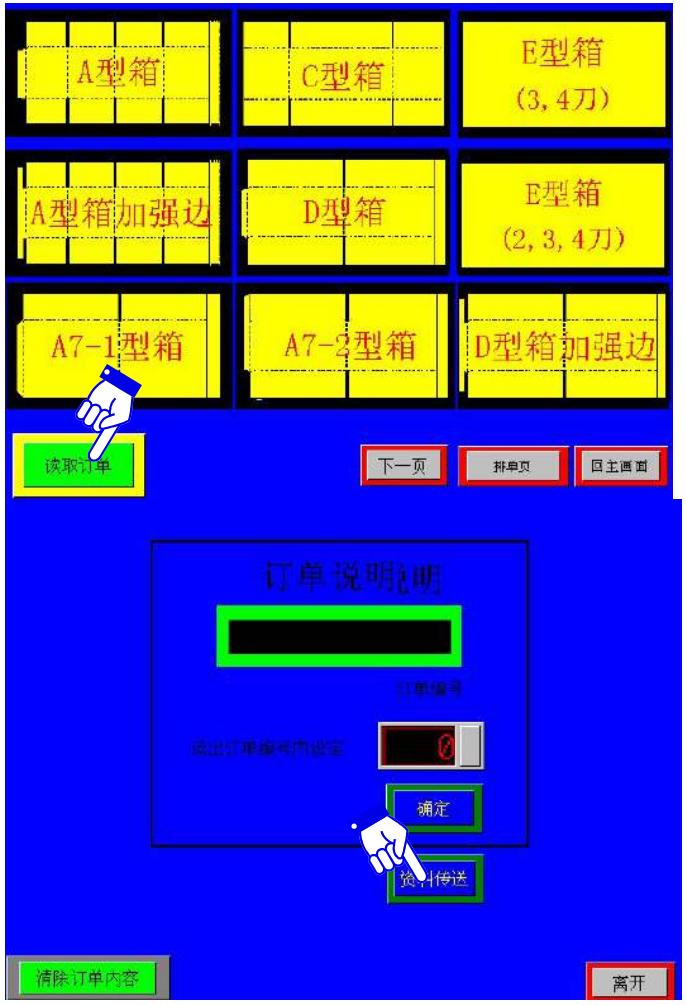
Notes補充說明

- In the Keypad, the functions as following數字鍵功能說明：只需輸入需要的正確數值後，按下

  CLR: Clear all digitals on keypad.輸入有誤時，用來清除字元

  ESC: Close the keypad.離開此畫面

  ENTER: Finish input. 確認



Main HMI-Order Setting-Operation
主人機介面-訂單輸入頁-排單頁

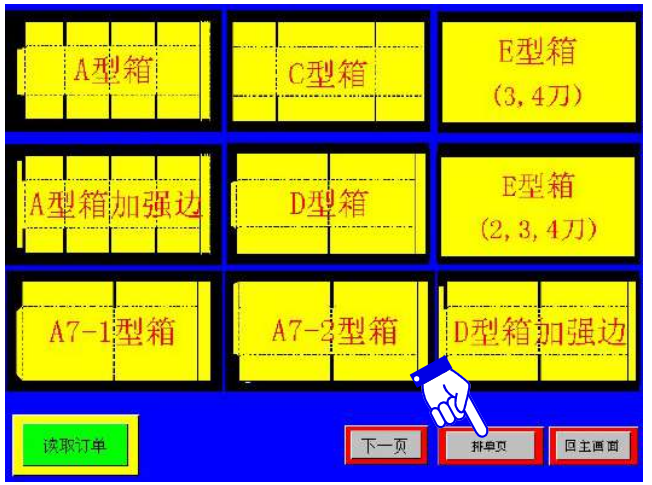
Procedure操作程式

- After entering the Transfer page, the left column of each unit is the actual position of the machine. The right column of each unit is the required new position. When click <**START**>, the machine will start to adjust. The adjustment is finished when the actual position is the same as the required position.

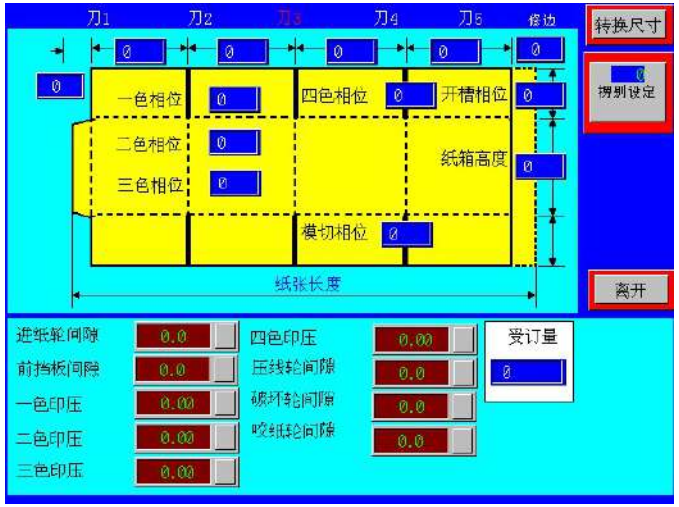
- 進入排單頁面後， 所顯示的數值分別為：目前機械數值：於左側以數值顯示各機械實際位置點。設定機械數值：右側可輸入欲修改的數值， 即可修改.
- 按下<排單>鈕， 確認排單後， 機台將會開始動作， 調整各位置， 當目前機械數值等於設定機械數值時， 可視為調整完成， 即可進入生產。

- When all the adjustment is finished and it is the best setting for produce, the operator can save the setting in HMI for future reference by clicking <**Save**> button. It will require the operator to give an order No. for saving.當各機械位置調整完成， 並經過實際生產確認為最佳位置時， 可按下<儲存訂單>鈕， 進入讀出訂單編號內設定頁面。輸入訂單編號， 按下<確定>按鈕， 將會憶所有的機械位置，並自動轉換到訂單輸入頁面.日後如有相同形式的訂單， 可依照讀取訂單的訂單輸入流程進行訂單處理。

- Click<**STOP**> will stop the adjustment of the machine when the operators give up the adjustment. 在確認排單後， 機台進行調整動作， 按下<停止自動>鈕， 調整動作將被停止。 各機械數值維持在按下<停止自動>當時的數值。



Main HMI-Order Setting-Box Type Select
主人機介面-訂單輸入頁-箱型選擇



To set a new order 設定新訂單

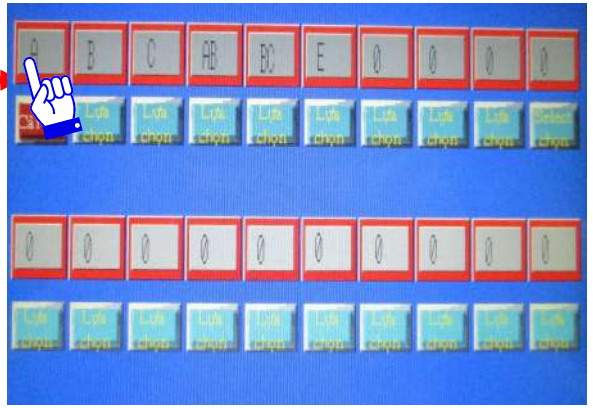
1. After confirming the order is new for HMI control system, enter the box type select.在確認欲處理的訂單為新型訂單時， 選擇箱型便 進入箱型輸入頁面。

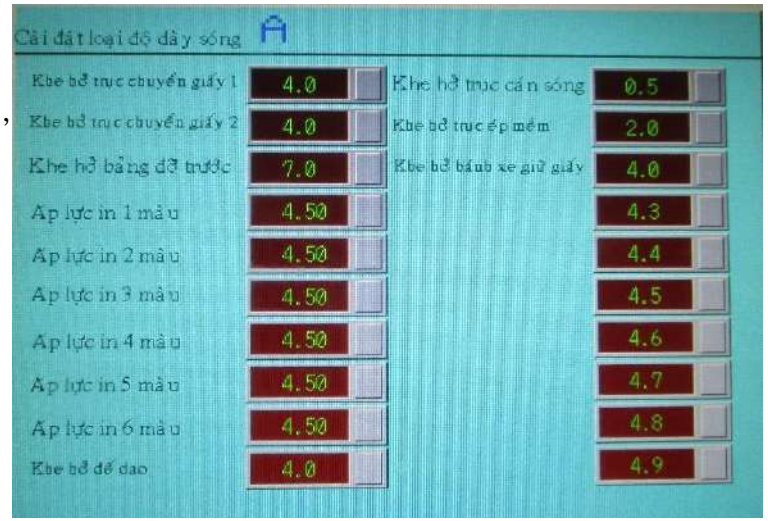
2. Fill in the dimension of the box and select the flute type according to the paper board going to produce.在箱型輸入頁面， 於畫面的上方可稱為尺寸規格輸入區， 於畫面的下方可稱為通紙條件輸入選擇區。

3. When the flute is selected, the suggested gaps for Feed Roll, Front Gate, Px Impression, Slot Gap, Creaser, Pre-Creaser, Pull Roll will display.當楞別選定後，進紙輪、前擋板、印壓、開槽間隙、壓線輪、破壞輪及咬紙會顯示。

4. SHEET — the production quantity.生產數量
Click <Transfer> to enter transfer page.點選<尺寸轉換>進入尺寸轉換>頁。

Main HMI-Order Setting-Box Type Select -Flute
主人機介面-訂單輸入頁-箱型選擇-楞別設定





Remark補充說明

Flute : It can save 20 flute types. Give a name for the flute type, and set up the gap of the below:
楞別設定：共有20種楞別可供儲存，可自行儲存所需的楞別名稱及楞別內容，人機按下楞別鍵後，會出現一密碼畫面輸入，之後才會出現右下角的設定畫面，就可依照楞別之厚度設定個單元間的間隙。

Feed Roll進紙輪
Gate擋板
Px Impression印壓
Slotter Gap開槽間隙
Creaser Gap壓線輪間隙
Pre-Creaser Gap破壞輪間隙
Pull Roll咬紙輪

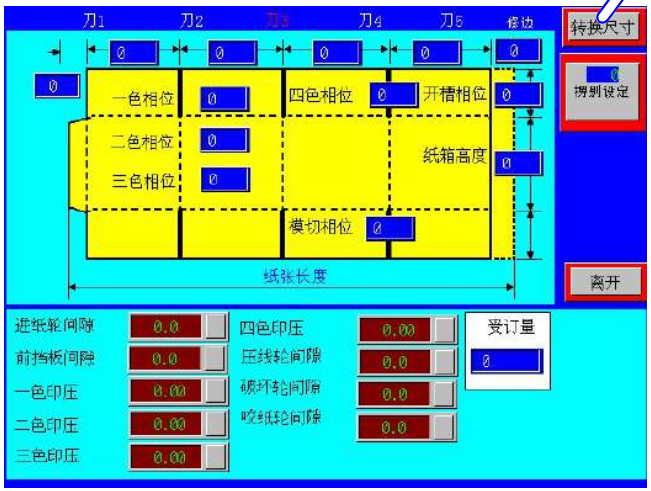
Main HMI-Order Setting-Box Type Select-Transfer
主人機介面-訂單輸入頁-箱型選擇-尺寸轉換

To set a new order 設定新訂單

After confirming the order is new for HMI control system, select the box type to enter the box type menu. 若在人機控制系統內確認為 新的訂單時，點選箱型選擇。
Fill in the dimension of the box and select the flute type according to the paper board going to produce.將箱型的大小填上及再選擇楞別。

When the flute is selected, the suggested gaps for Feed Roll, Front Gate, Px Impression, Slot Gap, Creaser, Pre-Creaser, Pull Roll will display.
當楞別選擇後，對應的進紙輪間隙、前擋板間隙、印壓間隙、開槽間隙、壓線輪間隙、破壞輪間隙及咬紙輪間隙便會顯示出來。

SHEET: the production quantity. 生產數量
Click <Transfer> to enter transfer page.點選<尺寸轉換)進入尺寸轉換頁。



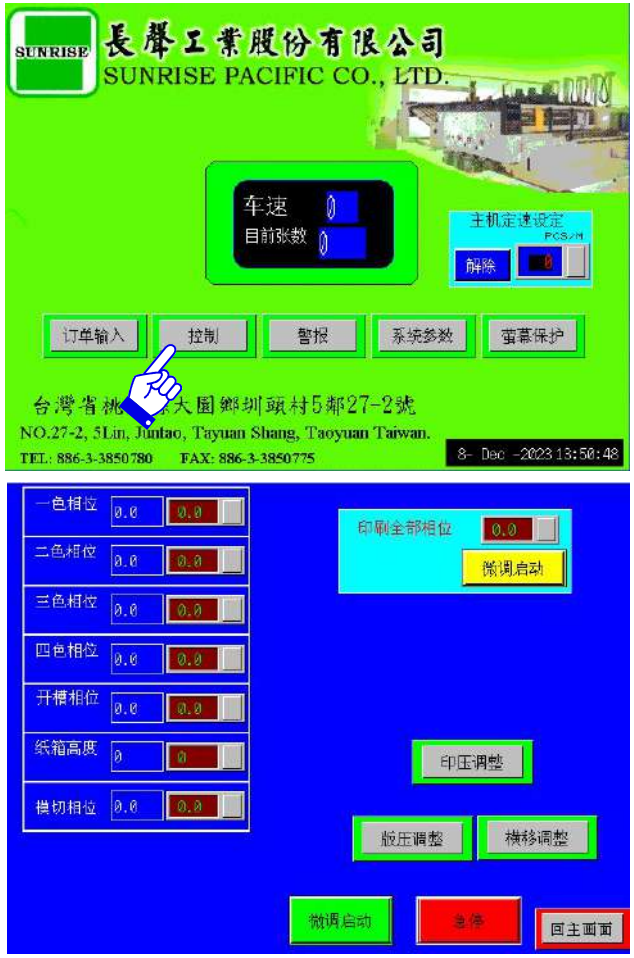
Main HMI-Control
主人機介面-控制(相位)

Fine tuning when machine is running

- During the machine is in adjusting or running, operator can enter the **Control** page to do the fine adjustment of the Register of Printer, Slotter, Die Cutter and Box Depth.在排單頁面按下<排單>按鈕後， 機器進行位置調整處理時，或是在生產進行中， 可以在<控制>頁面進行微調.
- After entering **Control** page, the left column is the actual figures of the machine. The right column is the required new figures.進入控制頁面後，左面欄位是機器的真實數值，而右邊欄位是須要填入的新數值。
- <**All Print Register**> Input figure will be carried to all printing units when click the yellow <**Control**> and <**Yes**>.欲同時調整所有的印刷相位，在印刷全部相位欄 輸入調整值， 按下<**微調啟動**>， 確認啟動後， 每色印刷相位會同時調整。
- Click green <**Control**> , the machine will start to adjust. The adjustment is finished when the actual figure is the same as the required figure. 按下<**微調啟動**>，並確認啟動後， 機台進行微調動作時， 按下<**急停**>鈕後，.將會停止微調動作繼續，各相位位置， 紙箱高度， 和印壓將停止在按下<**急停**>鈕當時的位置，
- Click <**E-STOP**> button to stop adjusting. <**急停**>鈕只控制微調動作的停止，並不會停止整個設備的生產運轉.

Remark備註

- The adjustment in this page can be carried out during the machine is in production.可於生產進行中調整。
- The **E-STOP** button will only to stop the adjusting, not the running of the machine.<**急停**>是將是用進行中的調整停止下來而不是將機台運行中停止下來。



Main HMI-Alarm
主人機介面-警報

During the machine is in adjusting or running, operator can enter the Alarm page to check the error message.在排單頁面按下<排單>按鈕後， 機器進行位置調整處理時，或是在生產進行中，機台出現狀況， 操作人員可以按下主畫面的<警報>鈕後， 進入警報單元選擇頁面， 此頁面共有9個單元選項：

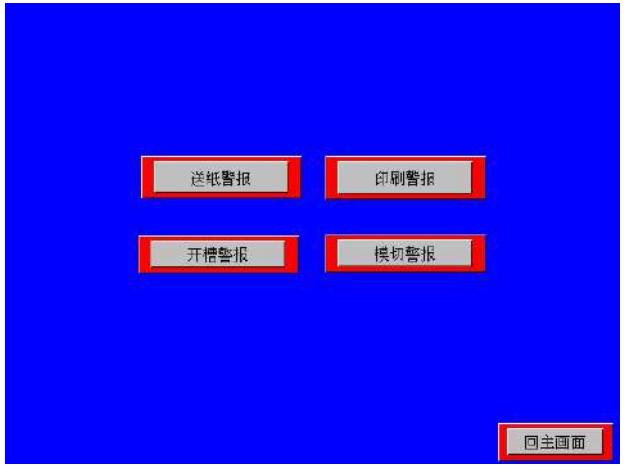
Feeder Alarm送紙警報— Display the error situation of Feed Unit. 顯示送紙異常情況。

Printer Alarm印刷警報— Display the error situation of Print Unit. 顯示印刷異常情況。

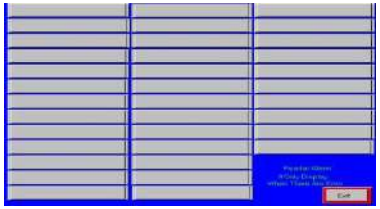
Slotter Alarm開槽警報— Display the error situation of Slotter Unit.顯示開槽異常情況。

Die Cut Alarm模切警報— Display the error situation of Die Cut Unit.顯示模切異常情況。

Staker Alarm疊紙警報 — Display the error situation of Stacker Unit.顯示疊紙異常情況。



Notes
After enter each alarm page, no error message will be shown when there is no error problem.在點選進入各單元警報頁面後， 如該單元沒有狀況， 將會顯示空白頁面。



Please contact with SUNRISE when there is alarm message as following pages, and the problem is not able to be solved by checking process.如遇到無法處理的問題時， 請直接和長聲公司聯絡。

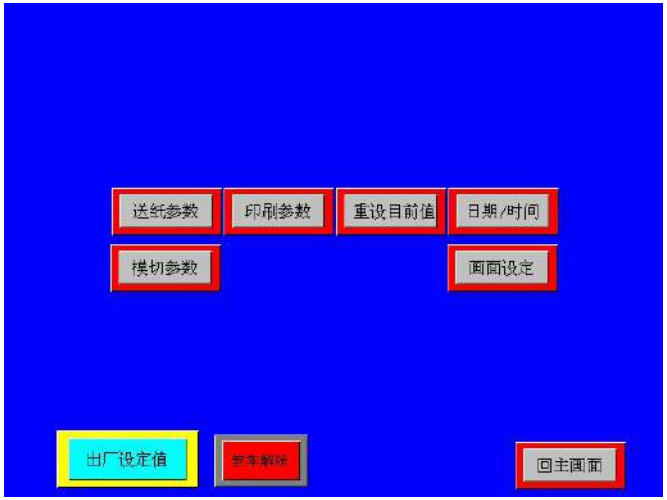
Main HMI-Parameter
主人機介面-系統參數

Operator may need to set the parameter of machine, if necessary .此參數頁設定一般不更動

- **Feeder Parameter**進紙參數 — Change feeder parameter. 提供生產總量顯示、卡紙、回油幫浦等參數。
- **Printer Parameter**印刷參數 — Change printer parameter. 缺墨停紙、著墨時間等參數修改。
- **Position Correct**重設目前值 — Correct machine position. 當實際機械位置與顯示不符時做校正用。
- **Date/Time**日期/時間 — Set new date and time.修改日期/時間。
- **Display**畫面設定：Change display language on screen. 修改顯示語言。
- **Die Cut Parameter**模切參數 — Change Die Cut parameter. 修改模切參數
- **Machine Setting**出廠設定值 — Require secondary password. Or click <**ESC**> to exit the keypad. 須要密碼才可進入。
- **Brake Release** 剎車解除—To free the magnetic brake for register. 解除相位的電磁剎車。
- **Main**回主畫面— Exit and return to Main Page.

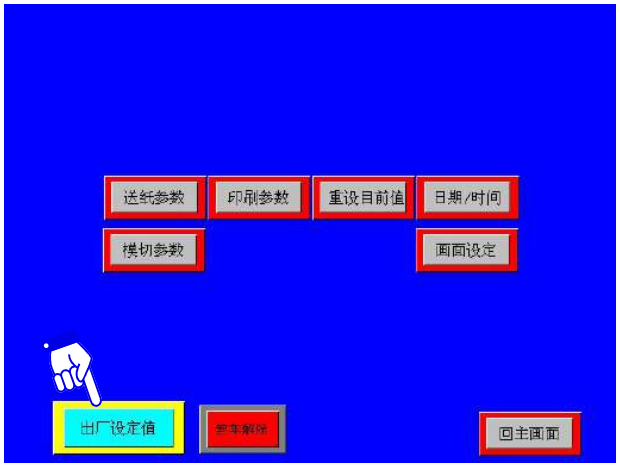
Notes備註:
Don't modify the setting or parameter at random, otherwise, it may cause mechanical problem and do damage to the operator and the machine. 請不再任意變換參數，以免造成機台損壞及操作人員受傷。

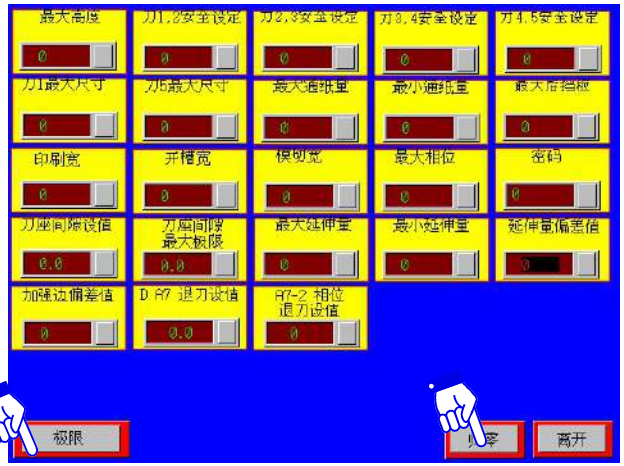
Please contact with SUNRISE if there is any require to do parameter setting.出廠設定值–此設定一般不更動， 裝機人員在機械裝設時已調整設定完成， 如需更改，請洽長聲公司。



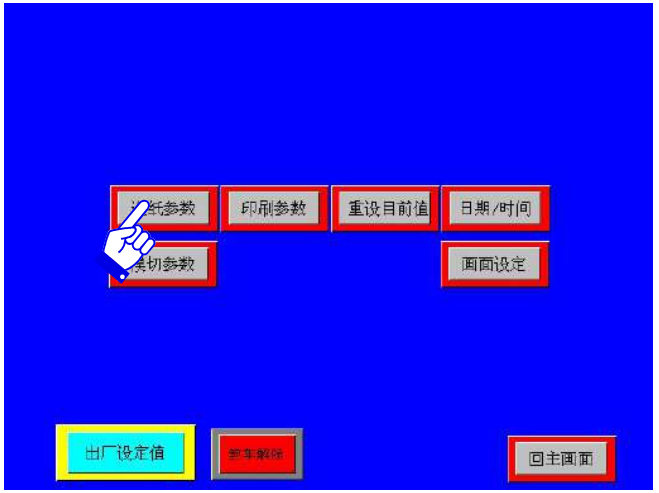
Main HMI-Parameter-Machine Setting
主人機介-系統參數-出廠設定值

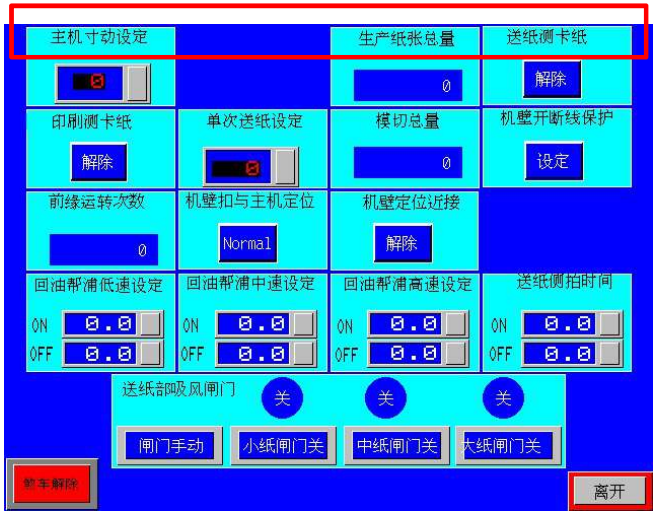
Notes備註：
Don’t modify the setting or parameter at random, otherwise, it may cause mechanical problem and do damage to the operator and the machine. Please contact with SUNRISE if there is any require to do parameter setting.出廠設定值–此設定一般不更動，裝機人員在機械裝設時已調整 設定完成， 如需更改請洽長聲公司。





Main HMI-Parameter-Feeder Parameter
主人機介面-系統參數-送紙參數





Procedure

- **Main Drive Jog Setting主機寸動設定**— Set the speed of main drive jog.設定寸動運轉之速度。
- **Main Drive Speed Setting pcs /m主機定速設定**— The machine will speed up to the setting speed automatically while operator press **Main Drive ON** button in feed panel.**<ON>** will start the function.**<OFF>** will stop the function.可設定機械定速運轉速度。輸入一定速度， 選擇至“設定”後，每次啟動速度便會直接加到此速度。選擇至“解除”則不會自動加速。
- **Total Output生產紙張總量/模切總量/前緣送紙次數** — Display the production amount.顯示累計生產之總數量。
- **Feeder /Printer Jam Detect送紙測卡紙/印刷測卡紙**— It will stops feeding board when there is board jammed in Feed Unit. **<ON>** will start the function. **<OFF>** will stop the function. Usually, when select the clear of Jam function, it should be (1) sensor malfunction, it must clear the jam function to allow board feeding. (2) under the testing, the feed mode select the “Skip” function, it must also clear the feed Jam function to allow board feeding. (3) for partially warp board, it must take longer time to flatten the board, it suggests to clear this function.選擇“設定”時， 在進紙過程中，若有紙板卡在機械內部時，便會自動停止進紙，選擇“解除”， 則取消此功能。一般選擇解除的時機，在於(1)光電開關故障，必需解除此功能，以便進紙。(2)作測試時，若將進紙模式選擇為“隔張進紙”模式，此時“進紙測卡紙”也必須解除，以便進紙。(3)夾有部分彎曲的紙板，需要較長的時間將紙吸平，此時建議作解除。
- **Single Feed Setting單次送紙設定**—Set the quantity of sheet to feed in Single Feed Mode.設定在單次進紙模式下，每按一次所送出的紙張數量。

Main HMI-Parameter-Feeder Parameter
主人機介面-系統參數-送紙參數

Procedure

- **Lead Feed Running Time前緣運轉次數** — Display the total running times of the tread wheel.顯示送紙膠輪共運轉多少次。
- **Oil Pump Low Speed Setting著墨閥低速設定**— Set the speed to pump the oil when the machine is running in low speed.當機台以低速運行時，可調整泵的速度。
- **Oil Pump Mid Speed Setting著墨閥中速設定**— Set the speed to pump the oil when the machine is running in middle speed.當機台速運行時，可調整泵的速度。
- **Oil Pump High Speed Setting著墨閥高速設定**— Set the speed to pump the oil when the machine is running in high speed.當機台高速運行時，可調整泵的速度。
- **Wire Protect連線保護** —The wire will separate automatically when the machine is opened beyond the safe distance. This will protect the wires connected to each units from pulling apart. <ON> will start the function, and <OFF> will stop the function. 當機台打開超過安全距離時，連線便會自動分開。<ON>代表功能已起動，而<OFF>代表功能停止。

Remark備註

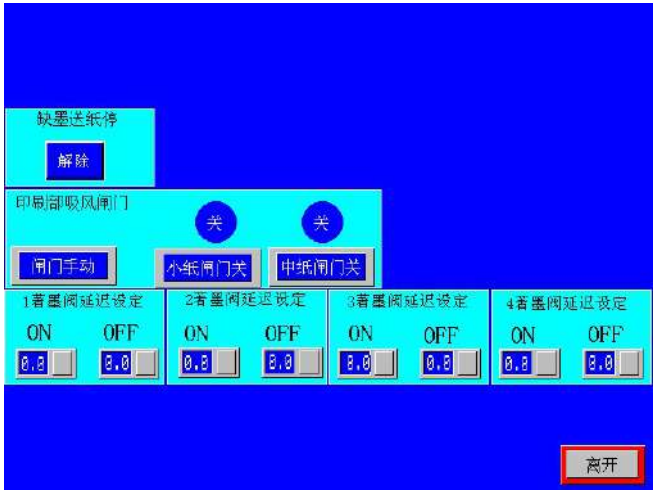
- Don't modify the setting or parameter at random, otherwise, it may cause mechanical problem and do damage to the operator and the machine. 此設定一般不更動， 裝機人員在機械裝設時已設定完成，如需更改， 請洽長聲公司。 Please contact with SUNRISE if there is any problem to do parameter setting .

Main HMI-Parameter-Printer Parameter
主人機介面-系統參數-印刷參數

Procedure

- **Vacuum Transfer Gate印刷部吸風閘門** — In auto mode, openness of Vacuum Transfer Gate will adjust automatically according to Paper Board. In Manual mode, two types of the gates can be selected. One is inside gate, the other is Medium gate. Operator should select the proper gate to transfer the boards. 控制吸風傳送之風門，在自動設定時，風門會根據紙張大小設定。在選擇"閘門手動"後，可控制各風門開關， 開關分為兩段，操作者可依據紙張大小設定風門大小。

- **Anilox Setting著墨閥延遲設定**— <ON> is to set up the time that Doctor Blade / Wipe roll should contact Anilox roll. <OFF> is to set up the time that Doctor Blade / Wipe roll should leave Anilox roll. ON – 設定著墨輪著墨秒數，OFF– 設定離開秒數， 此設定乃確保機械能夠著墨，同時不會著墨過多。



Remark備註：

- Don’t modify the setting or parameter at random, otherwise, it may cause mechanical problem and do damage to the operator and the machine. Please contact with SUNRISE if there is any problem to do parameter setting.

  此設定一般不更動，裝機人員在機械裝設時已設定完成，如需更改， 請洽長聲公司。

Main HMI-Parameter-Position Correct
主人機介面-系統參數-重設目前值

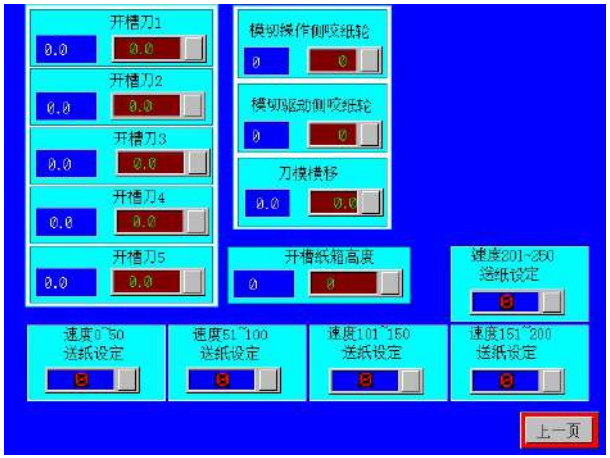
Procedure功能說明：

- While the value displaying in HMI does not correspond with the real position of the machine, or after replacing a new encoder or a new coupling, the operator needs to do gap correct.本畫面在機械實際之位置或間隙與人機畫面顯示之數值不同時，可經由此部分重新設定，使二者相符合。

- One keypad will jump out when clicking the right column . Fill in all the columns according to the correct position of each part. 各欄位之左邊為顯示目前值， 右邊部份可輸入正確值，操作人員在確定機械之實際位置之後，輸入資料即可。

Remark備註

- Don’t modify the setting or parameter at random, otherwise, it may cause mechanical problem and do damage to the operator and the machine. Please contact with SUNRISE if there is any problem to do parameter setting. 請勿任意更改現在值， 否則可能會造成機械損壞。此功能只在長聲公司建議下方可操作。

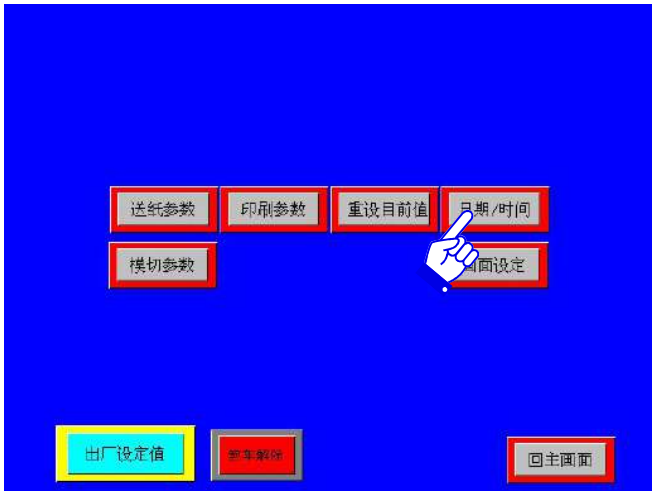


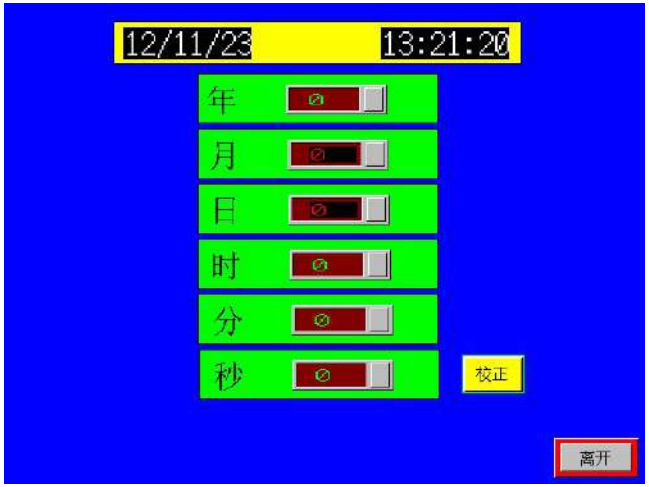
Main HMI-Parameter-Date/Time
主人機介面-系統參數時間/日期

Procedure操作程式

- This page is to reset the Date/Time displaying in HMI.本頁是時間/日期參數設定。

- After entering the figure in the column of **<YY>/<MM>/<DD>/<HH>/<MM>/<SS>**, click**<Correct>** to finish the adjustment.在輸入年/月/日/時/分/秒後，按下<校正>鈕後，即設定完成。

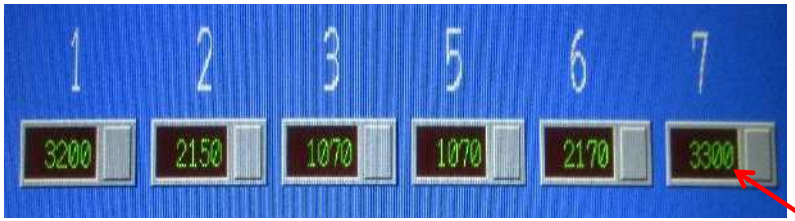


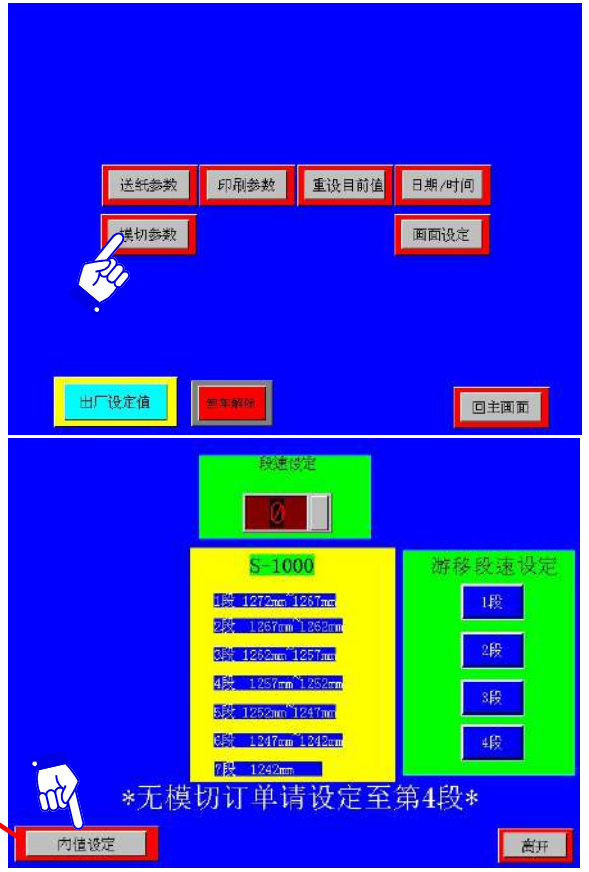


Main HMI-Parameter-Die Cutter Unit
主人機介面-系統參數-模切參數

Speed compensation操作程式

- This page is to set up the speed compensation of the anvil cylinder. After trimming, the outer diameter of the anvil covers will become smaller. Operator has to select the speed section according to the trimmed new diameter of the anvil cover. 此畫面設定模切膠墊輪之運轉速度，在修整過膠墊之後， 根據修整之段數， 選擇新的段數。
- We suggest you to set up in section 4 when the machine is running without die cut job. 在不使用模切作業時，可將速度設定在第四段，減少追速馬達運轉。
- **Parameter Setting內值設定**— Set tolerance for each section if the cut size is not accurate. It requires secondary password. Or click <**ESC**> to exit the keypad. 設定每一段之速度， 若設定速度與實際切出尺寸誤差值大時，需要修改.。進入內值設定必須先輸入密碼。





Trimming Procedure修膠程式：

1. The anvil roll is damaged when cutting for a long time, press ANVIL TRIM to trim the anvil roll first. 當模切一段時間後 ，膠墊輪會出現損壞，此時按修膠墊來修膠墊輪。
2. Switch the spanner to make the gap smaller between anvil cylinder and trimming roll. 轉動扳手可將膠墊輪及修膠輪間隙變小。
3. Set the speed compensation at HMI.再到人機介面調整速度補償。

Main HMI-Parameter-Display
主人機介面-系統參數-畫面設定

Procedure操作程式

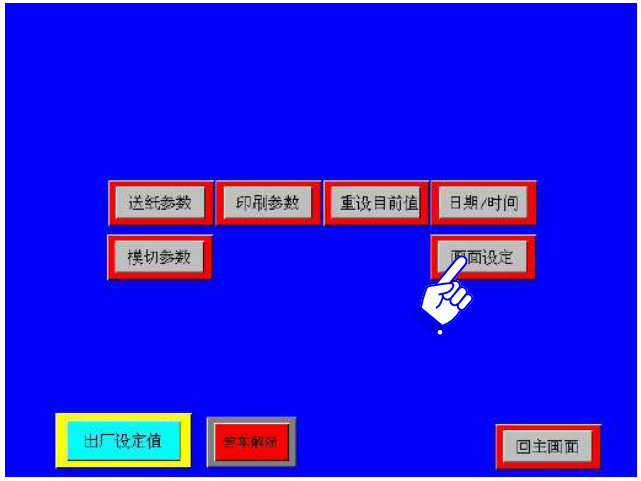
- This page is to adjust the font showing in the HMI.按下主頁內之畫面設定後，會顯示數位鍵，要求輸入密碼。 輸入正確的密碼後，即會出現右圖下方的畫面，提供顯示畫面的語系調整。

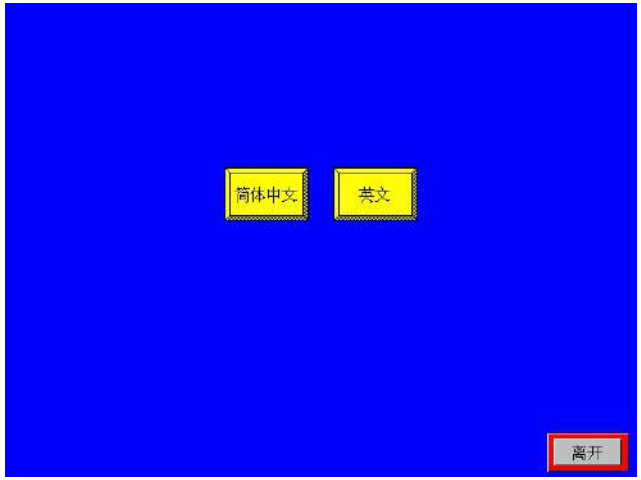
- **<Chinese>** All information will be showed in Traditional Chinese after selected. 按下“**中文**”的方塊，頁面顯示的語系將轉成中文。可以依使用者的習慣，作適當的調整。

- **<English>** All information will be showed in English after selected.按下“**英文**”的方塊，頁面顯示的語系將轉成英文。可以依使用者的習慣，作適當的調整。

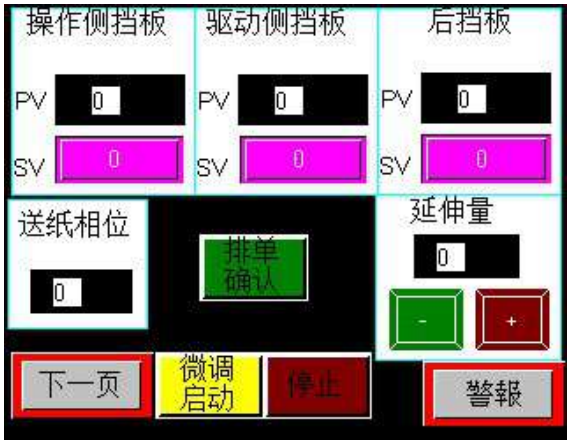
- **<Japan>** All information will be showed in English after selected.按下“**日文**”的方塊，頁面顯示的語系將轉成日文。可以依使用者的習慣，作適當的調整。

- **<Vietnam>** All information will be showed in English after selected.按下“**越文**”的方塊，頁面顯示的語系將轉成越文。可以依使用者的習慣，作適當的調整。





HMI-Feeder Unit
小人機介面-送紙主頁

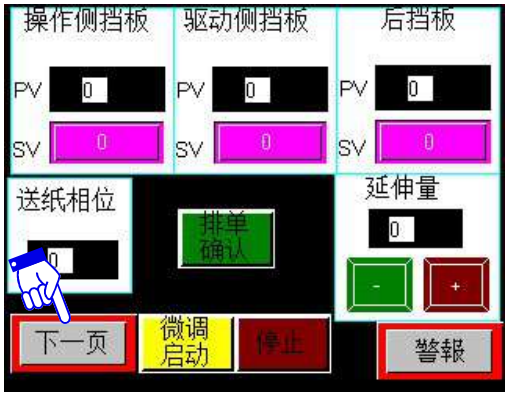


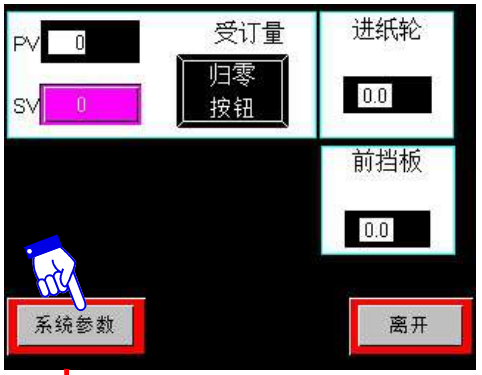
- It displays the **P**resent **V**alue of **O.S**. Side Guide **D**.**S**. Side Guide, Back Stop, ,Feed Roll, Gate gap, and the Register of Feed Unit 顯示目前位置為 操作側側擋板，驅動側側擋板，進紙輪間隙， 後擋板與進紙相位及前擋板間隙。
- When operator clicks the column of **SV**, one keypad will appear. Filling in the figure to adjust. 當操作員用手點擊SV欄時，操作鍵盤便會即時來作調整用。
- **Next** — Move to next page for setting position 往下一頁去.
- **Stop** —Stop moving before it moves to the setting position.
  停止畫面移動。
- **Correct** — After finish keying, press “Correct” to start the JOG until finish.
  輸入完成後， 按下” 微調啟動” ，則開始調整。
- **Main** —Return to main page.

Remark備註
- O.S.: Operation Side 操作側.
- D. S.: Drive Side 驅動側.
- PV: Present Value 顯示目前設定量.
- SV: Setting Value 顯示輸入設定量

HMI-Feeder Unit-Parameter
小人機介面-送紙主頁-參數設定

- While the value displaying in HMI does not correspond with the real position of the machine, or after replacing a new encoder or a new coupling, the operator needs to do gap correct. 間隙教導之作用是在機械實際位置與電腦顯示位置不同，或是在更換譯碼器或是連軸器後， 作為校正機械位置與電腦位置用。





Procedure操作程式

- **Front Guide Gap Correct** 前擋板間隙教導頁— To correct the front gate.調整前擋板間隙。
- **Feed Roll Gap Correct** 進紙輪間隙教導頁: To correct the feed roll.調整**Correct** 進紙輪間隙。
- **Display**畫面設 定頁—To change the display language. 變更顯示語言。
- **Limited**極限—Require secondary password.須要密碼才可進入。
- **Main** 主頁—Go to main page.回到主頁。

HMI-Feeder Unit-Parameter-Front Guide Gap Correct
小人機介面-送紙主頁-參數設定-前擋板間隙教導

Procedure操作程式

- Front Guide Gap Correct has 15 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.前擋板間隙教導共分15項，而內部可為左右兩邊， 左邊空格輸入當時間隙所顯示之譯碼器之值， 右邊空格輸入實際間隙。

- After filling in all 15 sets of column, operator can fill in the present value of encoder in “**Pulse Correct**”. It will display the Pulse and Gate Gap on the above two columns. Gap correct is finished when the two are correct. 右邊部份分為三個值， 脈波數值，前擋板間隙教導，和脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時譯碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

Encoder Value解碼器值

Real Gap實際間隙值

HMI-Feeder Unit-Parameter-Feed Roll Gap Correct
小人機介面-送紙主頁-參數設定-進紙輪間隙教導

Procedure操作程式

- Feed Roll Gap Correct has 15 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.進紙輪間隙教導共分15項，而內部可為左右兩邊，左邊空格輸入當時間隙所顯示之譯碼器之值， 右邊空格輸入實際間隙

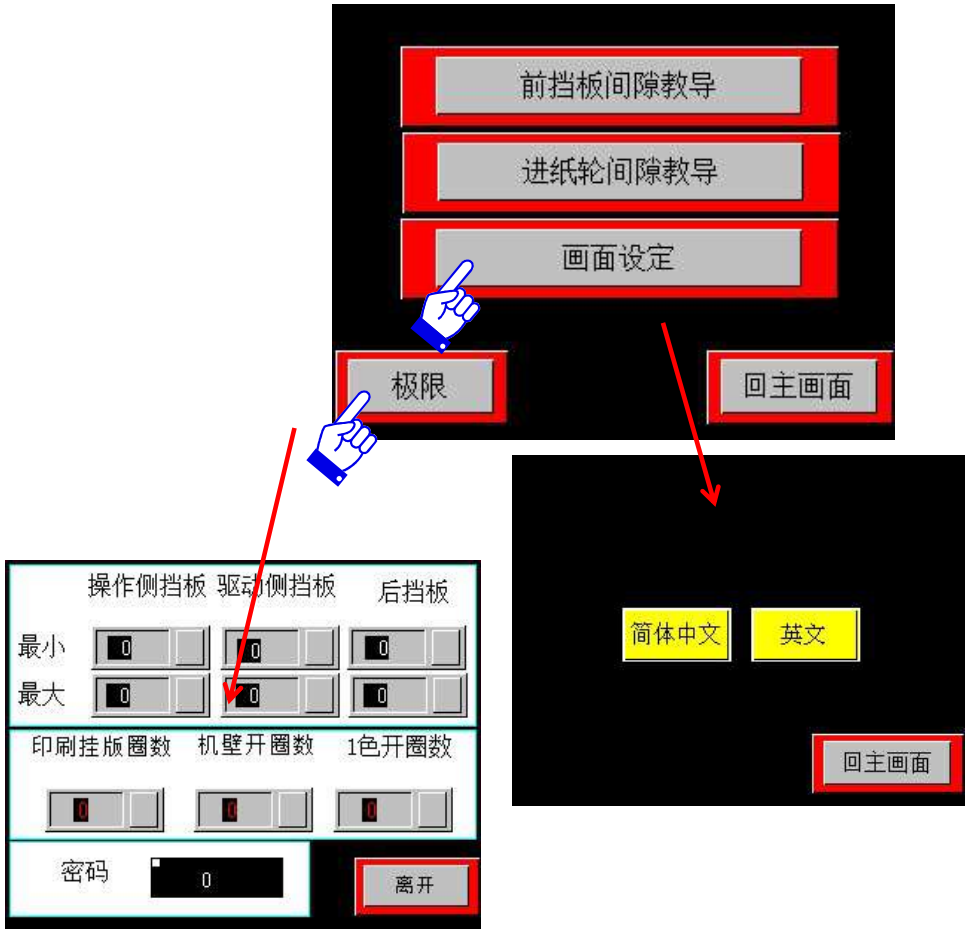
- After filling in all 15 sets of column, operator can fill in the present value of encoder in “**Pulse Correct**”. It will display the Pulse and Feed Roll Gap on the above two columns. Gap correct is finished when the two are correct.右邊部份分為三個值， 脈波數值，進紙輪間隙教導，和脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時譯碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

HMI-Feeder Unit-Parameter-Display Limited
小人機介面-送紙主頁-參數設定-畫面設定/極限

Procedure操作程式

- This page is to adjust the font showing in the HMI.按下主頁內之畫面設定後，會顯示數位鍵，要求輸入密碼。 輸入正確的密碼後，即會出現右圖下方的畫面，提供顯示畫面的語系調整。
- <Chinese> All information will be showed in Traditional Chinese after selected.按下“中文”的方塊，頁面顯示的語系將轉成中文。可以依使用者的習慣，作適當的調整。
- <English> All information will be showed in English after selected.按下“英文”的方塊，頁面顯示的語系將轉成英文。可以依使用者的習慣，作適當的調整。
- <Japan> All information will be showed in English after selected.按下“日文”的方塊，頁面顯示的語系將轉成日文。可以依使用者的習慣，作適當的調整。
- <Vietnam> All information will be showed in English after selected.按下“越文”的方塊，頁面顯示的語系將轉成越文。可以依使用者的習慣，作適當的調整。

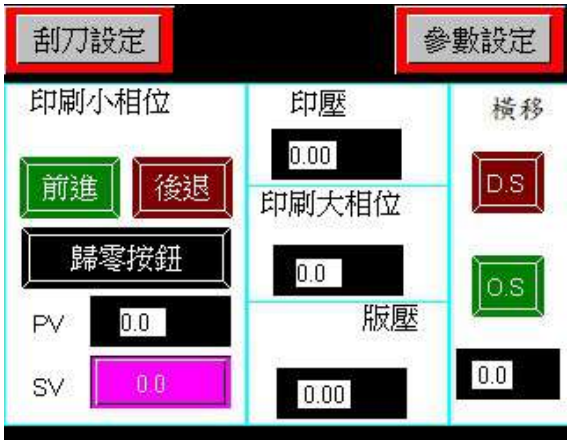
Limited極限—Require secondary password to adjust gap of O.S Side Guide, D.S. Side Guide and Backstop. 須要密碼進入調整操作側的側擋板、驅動側的側擋板及後檔板。



HMI-Printer Unit-Blade System
小人機介面-印刷主頁-刮刀系統

Procedure操作程式

- Register Adjustment印刷小相位— To adjust the register. “PV” is the present value. “SV” is the Setting value. Operator can input figure to “SV” and use “FWD” or ”REV” to adjust.可調整印刷之相位。P.V.顯示現在值，S.V.顯示設定值，操作員可按下S.V.欄位，將出現數位盤， 輸入完畢後，選擇前進，或後退按鈕，便會開始設定。
- Zero歸零按鈕— To reset the figure.若在設定前在欄位上有數位， 可按下此按鈕將欄位上之數位歸零。
- Impression印壓— To display the impression of the printer. 顯示印刷單元之印壓。
- Anilox Gap著墨間隙: To display the anilox gap of the printer.顯示當時之墨間隙 。
- Register印刷大相位— To display the register of the printer. 顯示當時該印刷單元之相位。



HMI-Printer Unit-Blade Setting
小人機介面-印刷主頁-刮刀設定

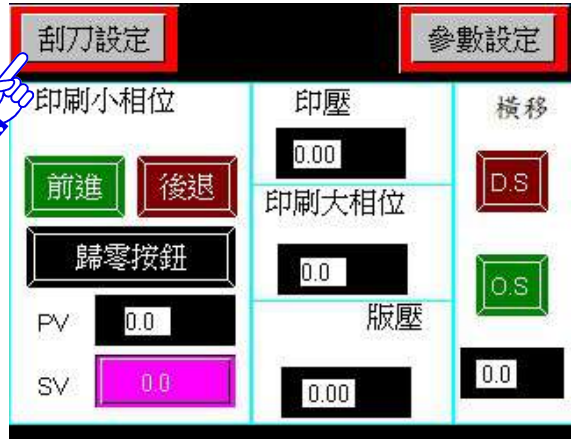
1. Ink Supply Speed供墨設定— Set the ink pump speed at low and run.
   設定供墨泵低及正常運轉速度。

2. Ink Return回墨— Set time of ink return (seconds)－設定回墨之時間。

3. Initial Ink Supply Time供墨快抽時間設定— Set the time of ink pumping to chamber at beginning, the time set in seconds. 設定以高/低速將水墨抽入刮刀墨腔內之時間。 輸入方式為按下空格， 出現數字盤後可輸入。

4. Washing Time1&2洗墨時間設定1&2 — Set the washing cycle time in seconds, include water spray and delay time. 設定墨腔清洗清洗時間， 在清洗過程中可設定兩段清洗的時間。

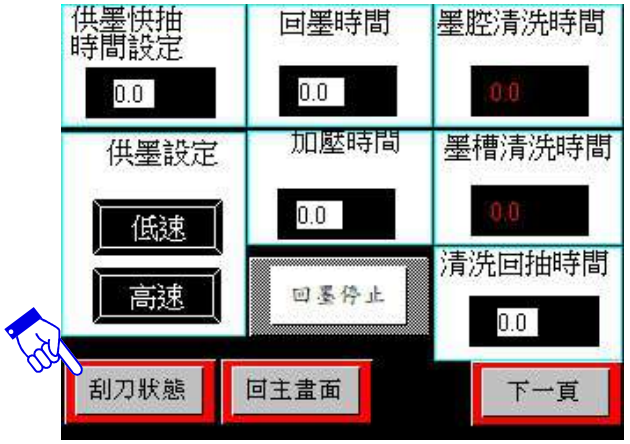
5. Blade Status刮刀狀態 — Enter the blade page進入刮刀輪設定頁。

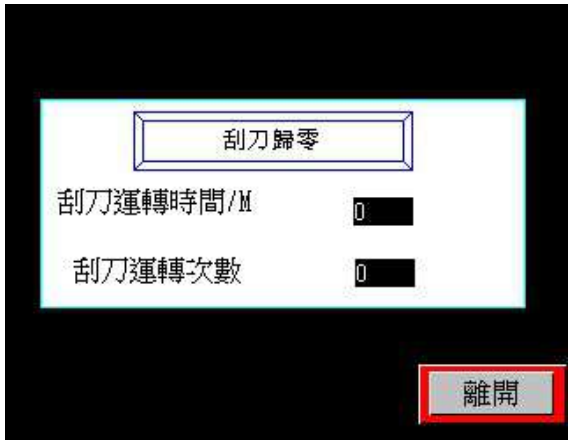


HMI-Printer Unit-Blade System-Blade Status
小人機介面-印刷主頁-刮刀系統-刮刀狀態

- This page displays that running seconds of ink Supply On, the Off/ seconds (low and high speed) ,Return Ink delay and Ink Supply delay.本頁顯示供墨幫浦運轉秒數，與低、中、高速時停止秒數。

- This page also displays that running seconds of ink Return On, the Off/ seconds (low and high speed) , Return Ink delay and Ink Supply delay.本頁顯示回墨幫浦運轉秒數，與低、中、高速時停止秒數。

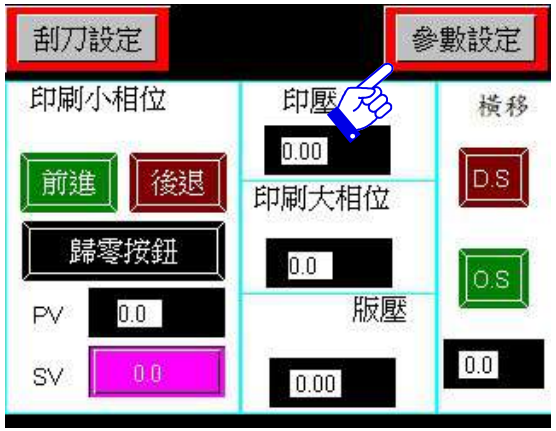


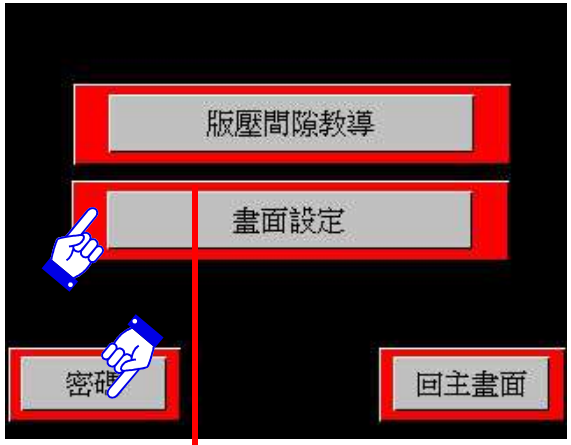


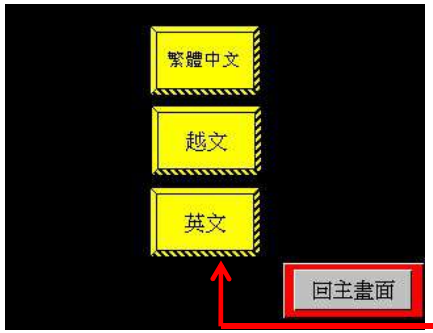
HMI-Printer Unit-Parameter-Password & Display
小人機介面-印刷主頁-系統參數-畫面及密碼設定

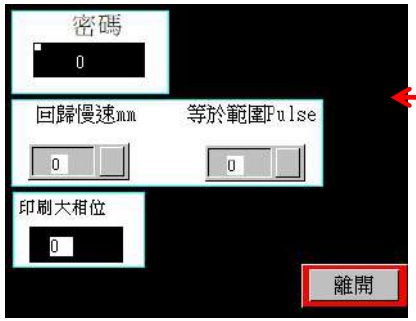
Procedure操作程式

- This page is to adjust the font showing in the HMI.按下主頁內之畫面設定後，會顯示數位鍵，要求輸入密碼。 輸入正確的密碼後，即會出現右圖下方的畫面，提供顯示畫面的語系調整。
- <Chinese> All information will be showed in Traditional Chinese after selected.按下“中文”的方塊，頁面顯示的語系將轉成中文。可以依使用者的習慣，作適當的調整。
- <English> All information will be showed in English after selected.按下“英文”的方塊，頁面顯示的語系將轉成英文。可以依使用者的習慣，作適當的調整。
- <Japan> All information will be showed in English after selected.按下“日文”的方塊，頁面顯示的語系將轉成日文。可以依使用者的習慣，作適當的調整。
- <Vietnam> All information will be showed in English after selected.按下“越文”的方塊，頁面顯示的語系將轉成越文。可以依使用者的習慣，作適當的調整。
    - Password: It takes passwords to enter this page. Usually it has been set up according to the Area of User.
      密碼：更改相位參數。此設定一般不需要更動，裝機人員在機械裝設時已設定完成，如需更改， 請洽長聲公司。







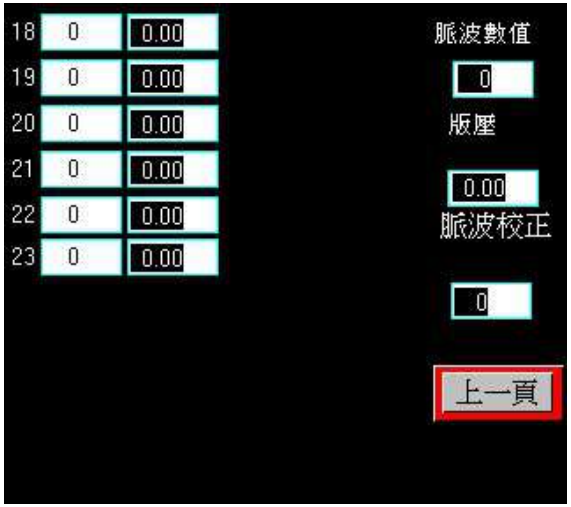


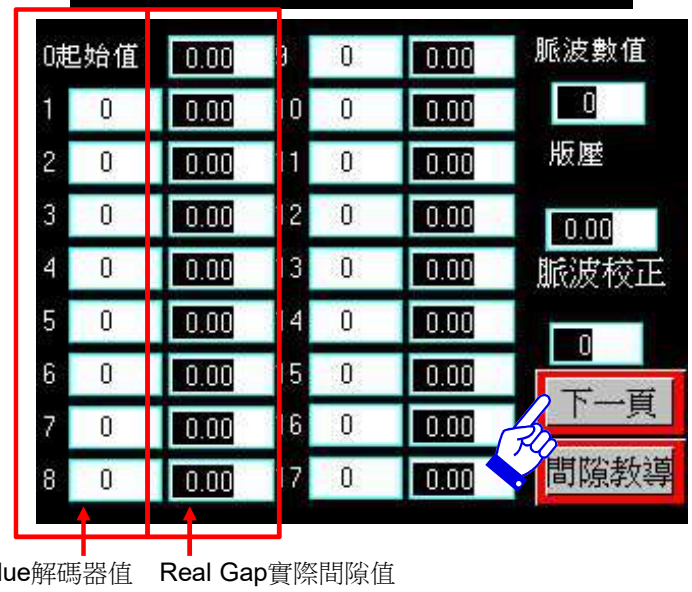
HMI-Printer Unit-Parameter-Anilox Roll Gap Correct
小人機介面-印刷主頁-參數設定-版壓間隙教導

Procedure操作程式

- Anilox Roll Gap Correct has 23 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.板壓間隙教導共分15項，而內部可為左右兩邊， 左邊空格輸入當時間隙所顯示之譯碼器之值， 右邊空格輸入實際間隙

- After filling in all 23 sets of column, operator can fill in the present value of encoder in “**Pulse Correct**”. It will display the Pulse and Feed Roll Gap on the above two columns. Gap correct is finished when the two are correct.右邊部份分為三個值， 脈波數值，板壓間隙教導，和脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時譯碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。





Encoder Value解碼器值　Real Gap實際間隙值

HMI-Printer Unit-Ink Supply (Rubber Roll)
小人機介面-印刷主頁-膠輪系統

Procedure操作程式

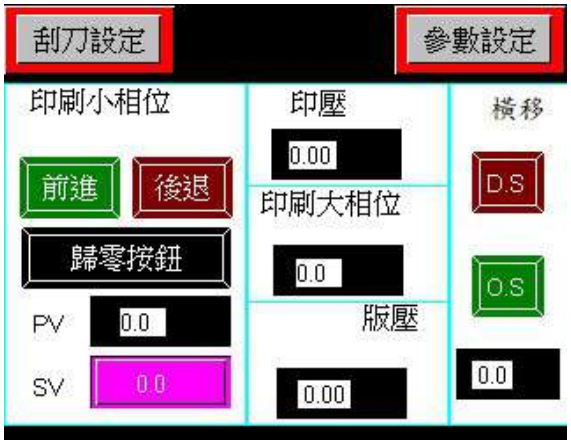
- Register Adjustment印刷小相位— To adjust the register. “PV” is the present value. “SV” is the Setting value. Operator can input figure to “SV” and use “FWD” or ”REV” to adjust.可調整印刷之相位。P.V.顯示現在值，S.V.顯示設定值，操作員可按下S.V.欄位，將出現數位盤， 輸入完畢後， 選擇前進，或後退按鈕，便會開始設定。

- Zero歸零按鈕— To reset the figure.若在設定前在欄位上有數位， 可按下此按鈕將欄位上之數位歸零。

- Impression印壓— To display the impression of the printer. 顯示印刷單元之印壓。

- Anilox Gap著墨間隙: To display the anilox gap of the printer.顯示當時之墨間隙 。

- Register印刷大相位— To display the register of the printer. 顯示當時該印刷單元之相位。



HMI-Printer Unit-Rubber Roll Setting
小人機介面-印刷主頁-膠輪設定

1. Ink Supply Speed供墨設定— Set the ink pump speed at low and run.設定供墨泵低及正常運轉速度。

2. Ink Return回墨— Set time of ink return (seconds)－設定回墨之時間。

3. Initial Ink Supply Time供墨快抽時間設定— Set the time of ink pumping to chamber at beginning, the time set in seconds. 設定以高/低速將水墨抽入刮刀墨腔內之時間。 輸入方式為按下空格， 出現數字盤後可輸入。

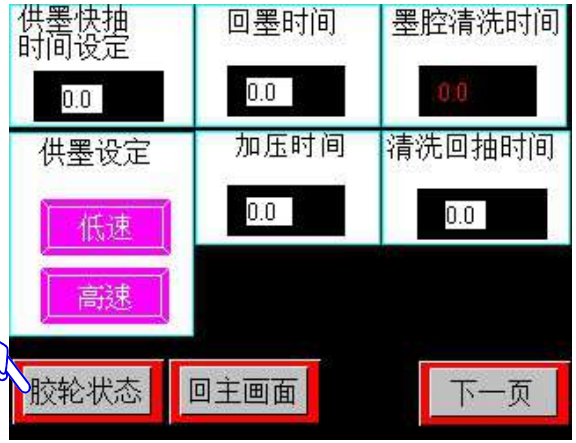
4. Washing Time1&2洗墨時間設定1&2 — Set the washing cycle time in seconds, include water spray and delay time. 設定墨腔清洗清洗時間， 在清洗過程中可設定兩段清洗的時間。

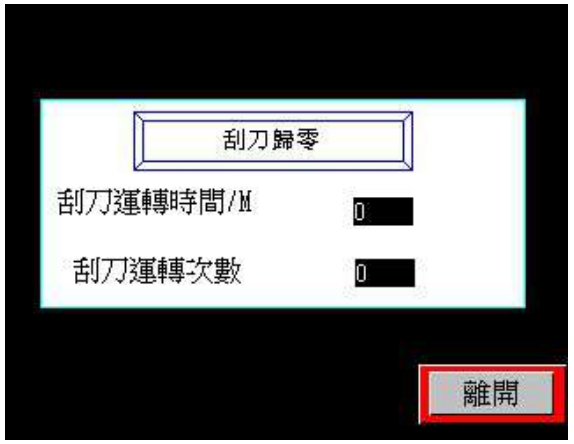
5. Blade Status刮刀狀態 — Enter the blade page進入刮刀輪設定頁。

HMI-Printer Unit-Rubber Roll Status
小人機介面-印刷主頁-膠輪狀態

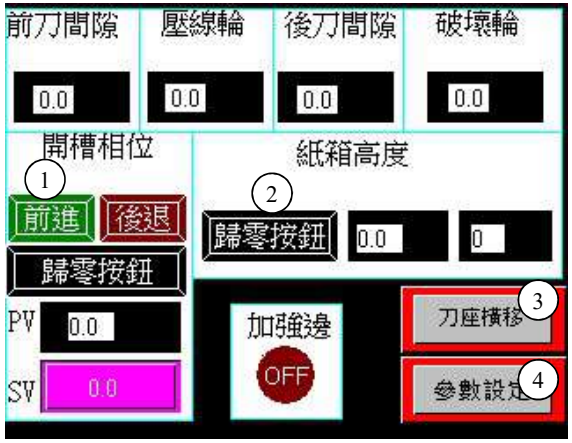
- This page displays that running seconds of ink Supply On, the Off/ seconds (low and high speed) ,Return Ink delay and Ink Supply delay.
  本頁顯示供墨幫浦運轉秒數，與低、中、高速時停止秒數。

- This page also displays that running seconds of ink Return On, the Off/ seconds (low and high speed) , Return Ink delay and Ink Supply delay.
  本頁顯示回墨幫浦運轉秒數，與低、中、高速時停止秒數。





HMI-Slotter Unit
小人機介面-開槽主頁



This HMI is in Slot Unit本頁為開槽單元之人機畫面.

1. **Register Adjustment開槽小相位**— To adjust the register of Slot Unit. Operator has to click**<Zero>** to clear the former figure of **PV** prior to entering a new figure. When operator clicks the column of **SV**, one keypad will appear. After filling in the figure to adjust, click**<FWD/REW>** to decide the rotate direction of the axial of Slotter, Creaser, and Pre-creaser is going to move.可選"相位手動"調整開槽相位。**歸零按鈕**：將P.V.值歸零；S.V.： 設定值， 操作人員可在此部份輸入調整值， 輸入完畢後， 選擇調整方向為"前進"或"後退"， 機械便會自動調整

2. **Box height adjustment 紙箱高度**— To adjust the box depth.顯示紙箱之高度.

3. **Knife Adj.刀座橫移**— To enter the knife adj. page.進入刀座橫移設定頁。

4. **Parameter系統參數**— Require secondary password輸入密碼進入參數頁，間隙教導、畫面設定等功能，請參考送紙主頁之說明。

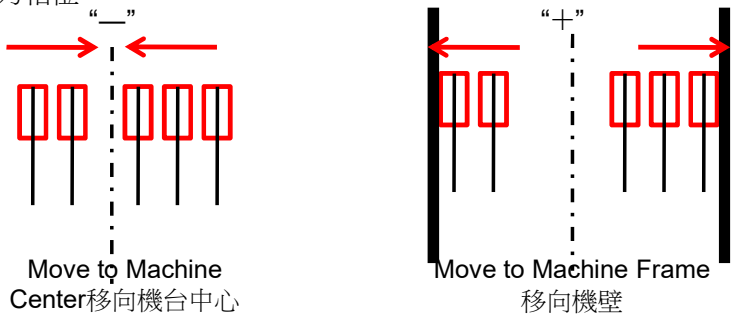
HMI-Slot Unit-Knife Adjust
小人機介面-開槽主頁-刀座橫移

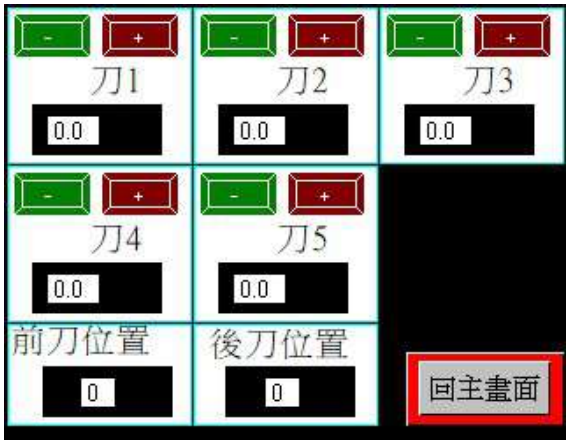
Procedure操作程式

- This page is to adjust the lateral position of the slot knife. After filling in the figure to adjust, click**<+/—>**to decide the direction to move.本畫面可控制開槽刀之橫移位置。
- Click**“+”**, to move the slot knife toward to frame direction. Click **“—”** to move the slot knife toward to machine center direction.**”** +” 值為機械中心朝機壁方向移動，**”** —**”**值朝向機械中心移動。

NOTE注意:

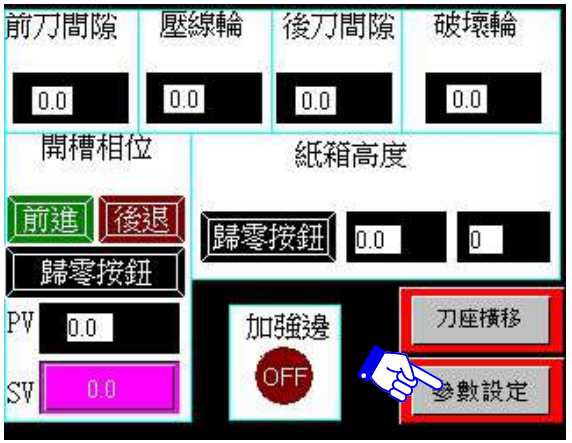
- Before moving knives, the knives should be engaged. Otherwise, the knives will not move. 開槽刀移動前，所有刀必須嚙合。
- The knife position is absolute coordinates. (Machine center position is 0.0) 開槽刀位置是絕對座標(機器中心位置是0.0)
- Adjust trailing register will also adjust the leading register at the same time. 若調整後刀相位時，前刀相位須同時調整。
- Adjust leading register will only adjust itself, but NOT affect the trailing register.調整前刀相位時不會影響後刀相位。





HMI-Slotter Unit-Parameter
小人機介面-開槽主頁-系統參數

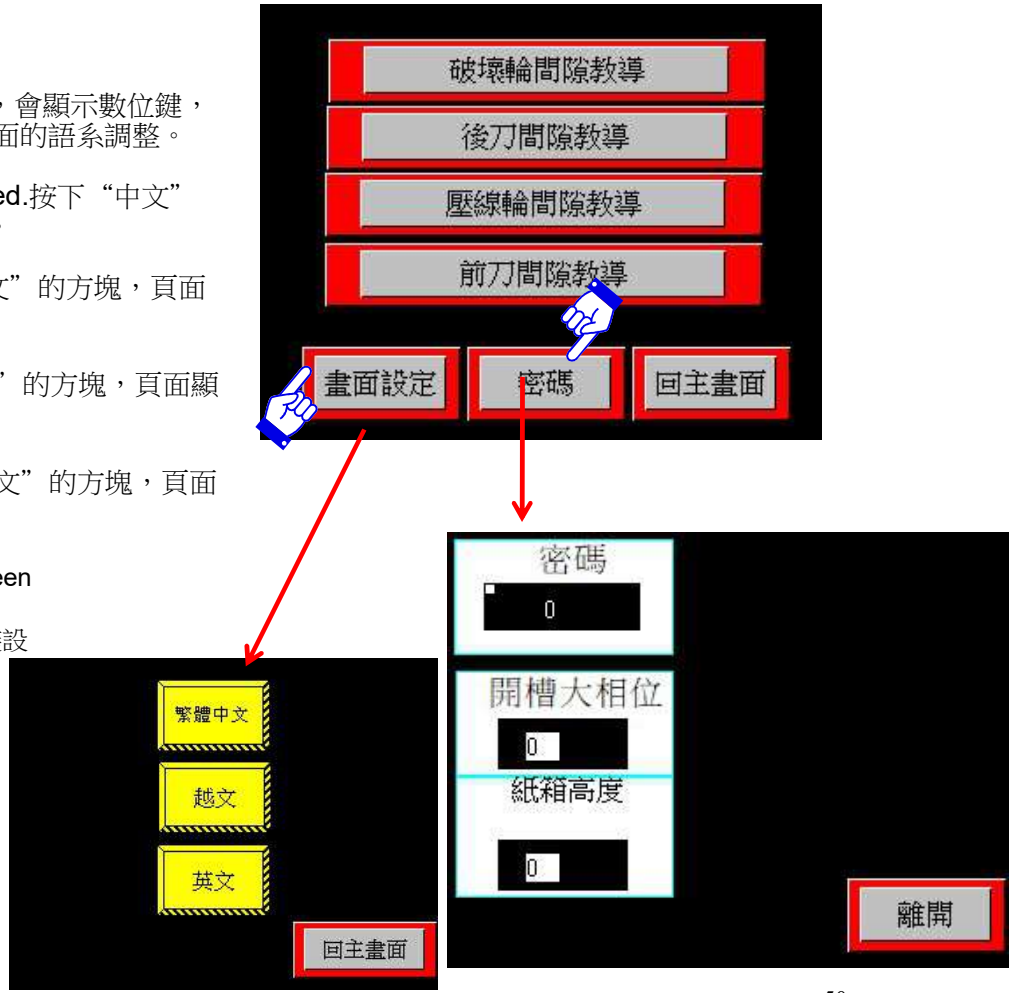
- While the value displaying in HMI does not correspond with the real position of the machine, or after replacing a new encoder or a new coupling, the operator needs to do gap correct.間隙教導之作用是在機械實際位置與電腦顯示位置不同，或是在更換解碼器或是連軸器後， 作為校正機械位置與電腦位置用。
- In Slot Unit, the operator may need to correct the gaps of Pre-Creaser Gap ， Slotter Gap & Creaser Gap when necessary. 開槽單元中，操作員可進行破壞輪 、壓線輪、前刀及後刀間隙教導。
- **Display**畫面設 定頁—To change the display language. 變更顯示語言。
- **Password密碼**— Require secondary password.須要用第二個密碼。
- **Main主頁**— Back to main page.返回主頁



HMI-Slotter Unit-Parameter-Password & Display
小人機介面-開槽主頁-系統參數-畫面及密碼設定

Procedure操作程式

- This page is to adjust the font showing in the HMI.按下主頁內之畫面設定後，會顯示數位鍵，要求輸入密碼。 輸入正確的密碼後，即會出現右圖下方的畫面，提供顯示畫面的語系調整。
- <Chinese> All information will be showed in Traditional Chinese after selected.按下“中文”的方塊，頁面顯示的語系將轉成中文。可以依使用者的習慣，作適當的調整。
- <English> All information will be showed in English after selected.按下“英文”的方塊，頁面顯示的語系將轉成英文。可以依使用者的習慣，作適當的調整。
- <Japan> All information will be showed in English after selected.按下“日文”的方塊，頁面顯示的語系將轉成日文。可以依使用者的習慣，作適當的調整。
- <Vietnam> All information will be showed in English after selected.按下“越文”的方塊，頁面顯示的語系將轉成越文。可以依使用者的習慣，作適當的調整。
    - Password: It takes passwords to enter this page. Usually it has been set up according to the Area of User.
      密碼：更改相位參數。此設定一般不需要更動，裝機人員在機械裝設時已設定完成，如需更改， 請洽長聲公司。



HMI-Slotter Unit-Parameter-Pre-creaser Gap Correct
小人機介面-開槽主頁-系統參數-破壞輪間隙教導

Procedure操作程式

- Pre-creaser Gap Correct has 22 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.破壞輪間隙教導1共分22項，而內部可為左右兩邊， 左邊空格輸入當時間隙所顯示之解碼器之值， 右邊空格輸入實際間隙

- After filling in all 22 sets of column, operator can fill in the present value of encoder in “**Pulse Correct**”. It will display the Pulse and pre-creaser gap on the above two columns. Gap correct is finished when the two are corrected.右邊部份分為三個值， 脈波數值，破壞輪間隙教導，和脈波校正。 在輸入完左邊之空格後，操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

EncoderValue解碼器值　　Real Gap實際間隙值

HMI-Slotter Unit-Parameter-Trialing Gap Correct
小人機介面-開槽主頁-系統參數-開槽後刀間隙教導

Procedure操作程式

- Trialing Gap Correct has 17 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column. Trialing Gap Correct共分17項，而內部可為左右兩邊， 左邊空格輸入當時間隙所顯示之解碼器之值， 右邊空格輸入實際間隙

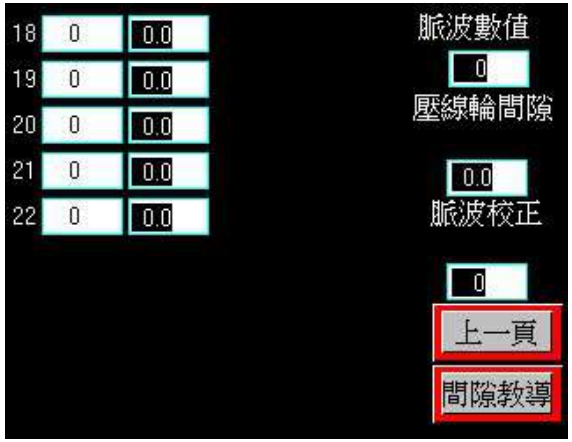
- After filling in all 17 sets of column, operator can fill in the present value of encoder in “**Pulse Correct**”. It will display the Pulse and Trialing Gap Correct on the above two columns. Gap correct is finished when the two are corrected. 右邊部份分為三個值， 脈波數值，開槽後刀間隙，和脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

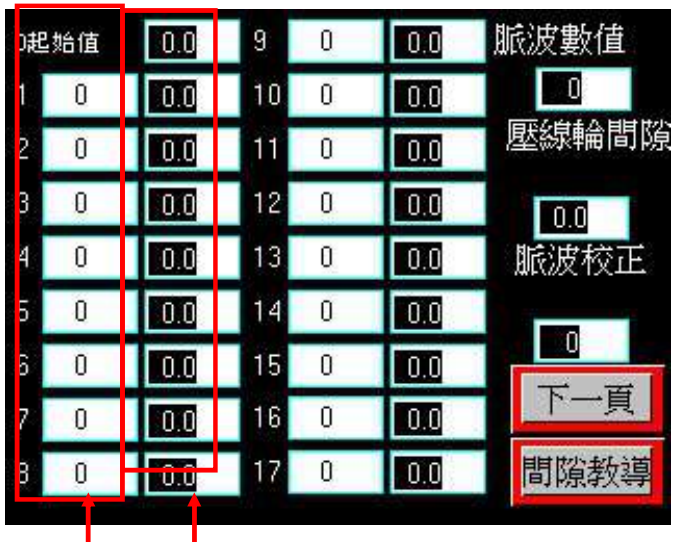
HMI-Slotter Unit-Parameter-Creaser Gap Correct
小人機介面-開槽主頁-系統參數-壓線輪間隙教導

Procedure操作程式

- Creaser Gap Correct has 17 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.壓線輪間隙教導共分17項，而內部可為左右兩邊， 左邊空格輸入當時間隙所顯示之解碼器之值， 右邊空格輸入實際間隙

- After filling in all 17 sets of column, operator can fill in the present value of encoder in "**Pulse Correct**". It will display the Pulse and Creaser Gap Correct on the above two columns. Gap correct is finished when the two are corrected.右邊部份分為三個值，脈波數值，壓線輪間隙教導，和脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。





HMI-Slotter Unit-Parameter-Leading Gap Correct
小人機介面-開槽主頁-系統參數-開槽前刀間隙教導

Procedure操作程式

- Leading Gap Correct has 17 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.開槽前刀間隙教導共分17項，而內部可為左右兩邊， 左邊空格輸入當時間隙所顯示之解碼器之值， 右邊空格輸入實際間隙

- After filling in all 17 sets of column, operator can fill in the present value of encoder in "**Pulse Correct**". It will display the Pulse and Leading Gap Correct on the above two columns. Gap correct is finished when the two are corrected. 右邊部份分為三個值， 脈波數值，開槽前刀間隙教導，和脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

HMI-Die Cutter Unit
小人機介面-模切主頁

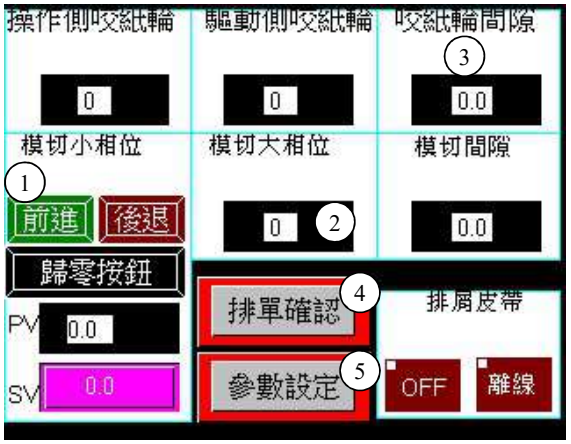
1. **Register Adjustment 模切小相位**— To adjust the register of Die Cut Cylinder. Operator has to click**<Zero>** to clear the former figure of **PV** prior to entering a new figure. When operator clicks the column of **SV**, one keypad will appear. After filling in the figure to adjust, click**<FWD / REW>** to decide the direction that the Die Cut Cylinder is going to rotate.用於調整模切輪相位用。操作人員點選<歸零>可將之前的PV數值重新輸入新的數值。當操作人員點選SV時，會出現一個鍵盤，及將要調整的數值輸入再點選<前進/後退>以決定模切輪轉動方向。

2. **Register模切大相位** — Display the main register of the machine. 顯示模切輪之相位

3. **Pull Roll Gap咬紙輪間隙**—Display the gap the Pull Collar.顯示咬紙輪之間隙。

4. **Correct 排單確認**—Enter the correct page進入排單確認頁。

5. **Parameter參數設定**—Require secondary password. 進入參設設定頁。

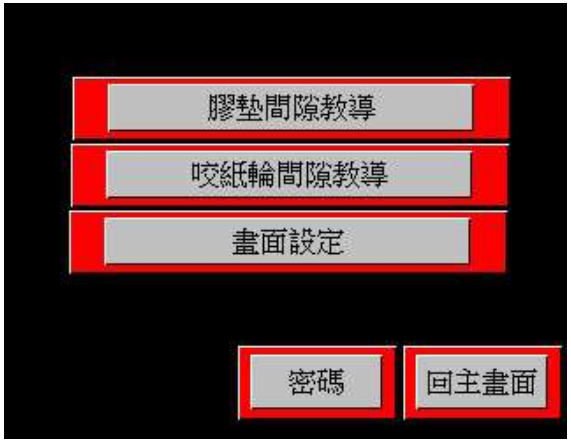


HMI-Die Cutter Unit-Parameter
小人機介面-模切主頁-參數設定

Procedure

- While the value displaying in HMI does not correspond with the real position of the machine, or after replacing a new encoder or a new coupling, the operator needs to do gap correct.間隙教導之作用是在機械實際位置與電腦顯示位置不同，或是在更換譯碼器或是連軸器後，作為校正機械位置與電腦位置用。

- In Die Cut Unit, the operator may need to correct the gaps of Pull Roll Gap and Anvil Gap when necessary.模切單元之間隙教導可調整咬紙輪間隙教導與膠墊間隙教導.

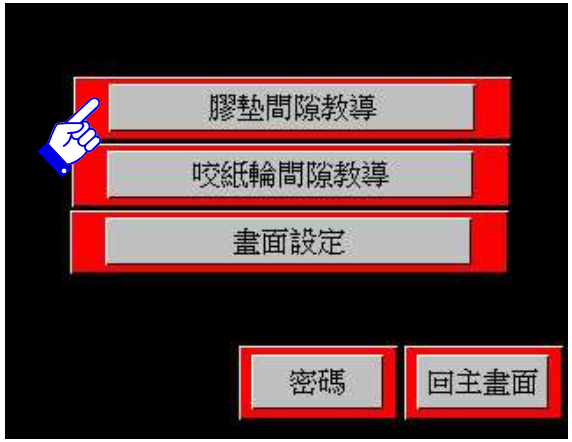


HMI-Die Cut Unit-Parameter-Pull Roll Gap Correct
小人機介面-模切主頁-系統參數-咬紙輪間隙教導

Procedure操作程式

- Pull Roll Gap Correct has 15 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column.咬紙輪間隙教導共分15項，內部可為左右兩邊，左邊空格輸入當時間隙所顯示之解碼器之值， 右邊空格輸入實際間隙。

- After filling in all 15 sets of column, operator can fill in the present value of encoder in “Pulse Correct”. It will display the Pulse and Pull Roll Gap on the above two columns. Gap correct is finished when the two are correct.右邊部份分為三個值， 脈波數值，咬紙輪間隙，和 脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

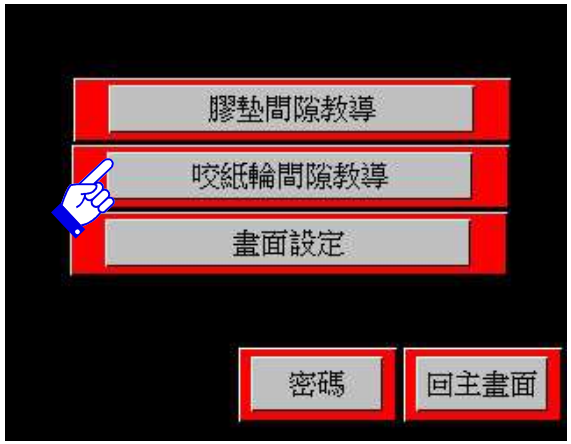


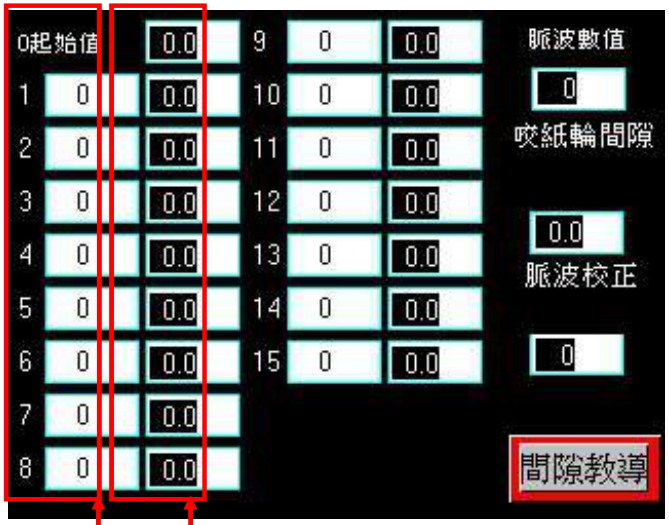
HMI-Die Cutter Unit-Parameter-Anvil Gap Correct
小人機介面-模切主頁-系統參數-膠墊間隙教導

Procedure操作程式

- Anvil Gap Correct has 22 sets of columns. Each set is divided into left and right. Operator has to fill in the encoder value in the left column and actual gap in right column. 膠墊間隙教導共分22項，內部可為左右兩邊， 左邊空格輸入當時間隙所顯示之解碼器之值， 右邊空格輸入實際間隙。

- After filling in all 22 sets of column, operator can fill in the present value of encoder in “Pulse Correct”. It will display the Pulse and Anvil Gap on the above two columns. Gap correct is finished when the two are corrected. 右邊部份分為三個值， 脈波數值，膠墊間隙教導，和 脈波校正。 在輸入完左邊之空格後， 操作人員可以在脈波校正部份輸入當時解碼器顯示之值，之後上方兩個空格便會自動顯示當時之間隙。

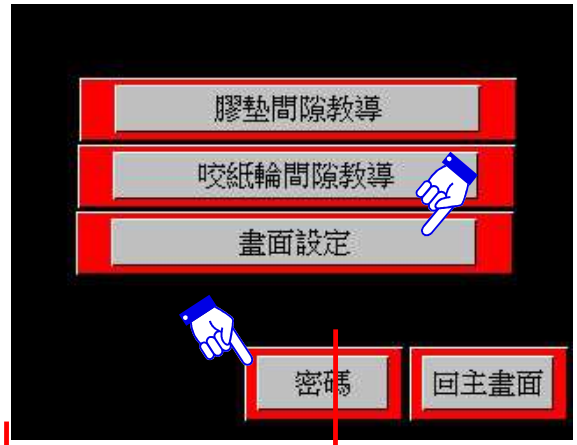


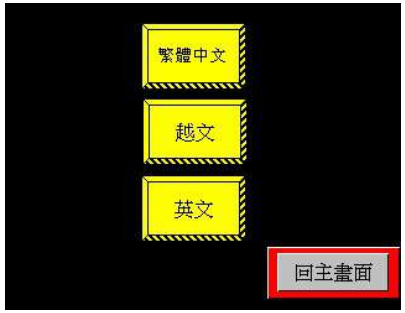


HMI-Die Cutter Unit-Parameter-Password & Display
小人機介面-模切主頁-系統參數-畫面/密碼設定

Procedure操作程式

- This page is to adjust the font showing in the HMI.按下主頁內之畫面設定後，會顯示數位鍵，要求輸入密碼。 輸入正確的密碼後，即會出現右圖下方的畫面，提供顯示畫面的語系調整。
- <Chinese> All information will be showed in Traditional Chinese after selected. 按下“中文”的方塊，頁面顯示的語系將轉成中文。可以依使用者的習慣，作適當的調整。
- <English> All information will be showed in English after selected.按下“英文”的方塊，頁面顯示的語系將轉成英文。可以依使用者的習慣，作適當的調整。
- <Vietnam> All information will be showed in English after selected.按下“越文”的方塊，頁面顯示的語系將轉成越文。可以依使用者的習慣，作適當的調整。
- Password: It takes passwords to enter this page. Usually it has been set up according to the Area of User.
  密碼：更改相位參數。此設定一般不需要更動，裝機人員在機械裝設時已設定完成，如需更改， 請洽長聲公司。





Folder Gluer HMI-Main
糊箱機主人機介面-首頁

1. 2. 3

1. The Folder Gluer main HMI (Human Machine Interface) is at the left side.糊箱主人機界面位於左邊。
2. The Panel Protect page will display when the power is ON. Select PASSWORD on screen.啟動機器電源開關後自動顯示螢幕保護裝置頁，輸入密碼。
3. Input: 33850780, select ENTER to show the main page. 輸入密碼33850780，再按ENTER，便會進入主頁。
4. There are some selections in main page. 主頁內有以下選項。

- Order Setting訂單輸入頁—Show the order setting page to set new order or recall old order.依據箱型圖形輸入訂單設定調整。
- Alarm警報顯示頁—Show the alarm message, if any.顯示各部位機械狀態，依照顯示專案排除障礙，無法自行排除時請與本公司技師聯繫。
- Parameter系統參數頁—Show the parameter page for system parameter setting.更改設定各單元指令引數。
- Servo Control伺服控制—Show the servo setting page.顯示皮帶運動狀況及作出調整。

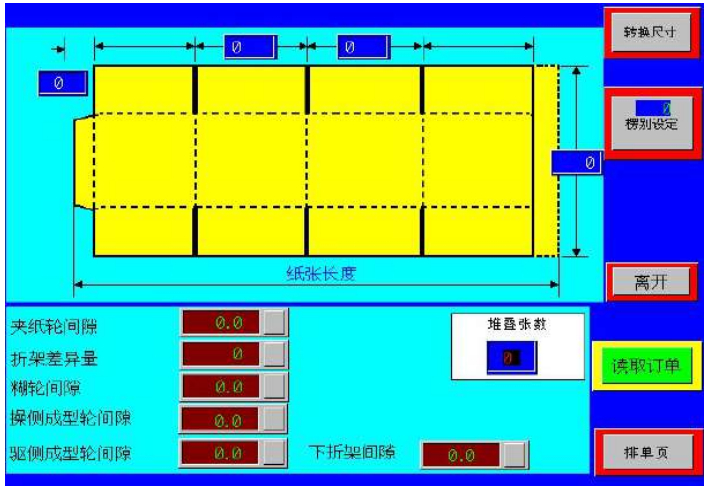
Folder Gluer HMI-Order Setting
糊箱機主人機介面-訂單輸入頁

- **Load讀取訂單**—When the order is ever produced and the adjustment data is saved in the HMI, the operator can recall the adjustment data by keying in the order No.當該筆訂單在過去曾有生產紀錄， 並有訂單編號資料儲存于主人機中， 則操作人員可透過讀取訂單的訂單輸入流程進行訂單處理。

- 2000 Records memory本人機系統可儲存2000筆訂單。

Remark補充說明

- HMI control system and Computer control system is independent. Their order data will not be shared to each other. Therefore, even an order ever produced in HMI control system, it will be new for Computer control system if it never produces in Computer control system.在訂單資料處理時，電腦系統和人機系統中是各自獨立的，如果該筆訂單曾在電腦系統中處理， 但並不曾在人機系統中處理， 則該筆訂單對於人機系統而言， 是一筆新的訂單， 適用於箱型選擇的訂單輸入流程進行訂單處理。於人機系統中所處理的訂單， 該訂單生產紀錄並不會傳送到電腦系統中， 如有安裝辦公室生產系統， 報表中將不會有該筆訂單的生產資料。

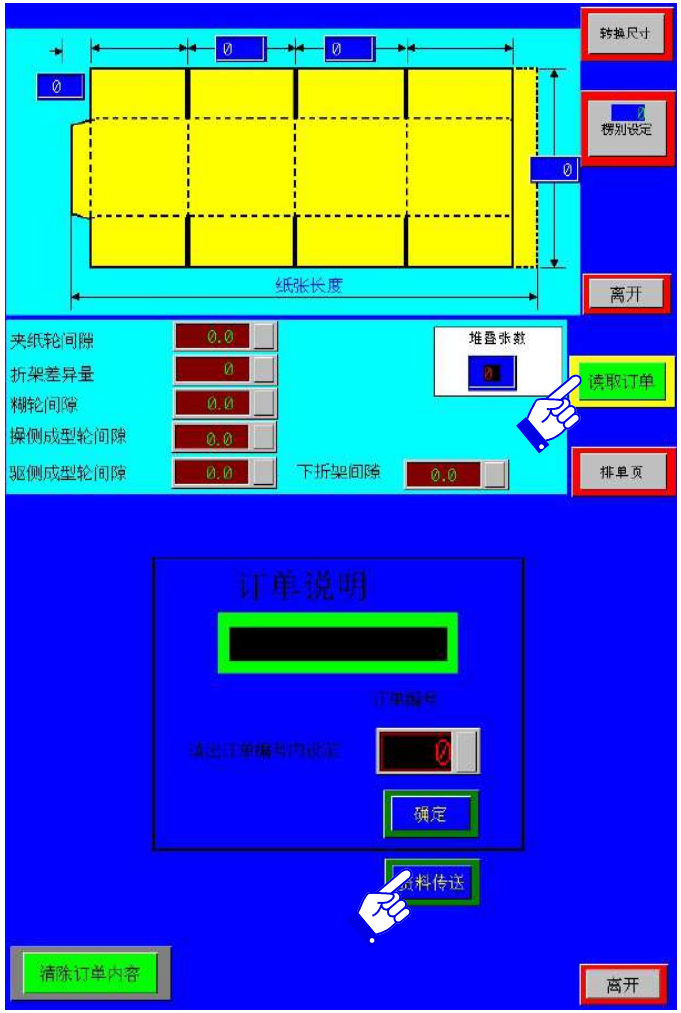


Folder Gluer Main HMI-Order Setting-Load
糊箱機主人機介面-訂單輸入頁-讀取訂單

To load the repeat order from memory.從記憶讀取訂單

When the order is ever produced before, Click<Load> to enter the Load Page.
在確認欲處理的訂單為舊訂單時， 按下<讀取訂單>鈕後， 進入讀出訂單編號內設定頁面.

- After keying in the Order No. press <ENTER>, and press <Yes> will load the remarks of this order. 輸入舊訂單的訂單編號， 按下<確定>按鈕， 將會自動轉換到排單頁面.
- click<Transfer> to enter Transfer page.點選<尺寸轉換>進入尺寸轉換頁。
- click<Clear Order> <Yes> will display Wait Moment to clear the loaded data.點選<訂單清除>會出現等一會，之後再資料消除。

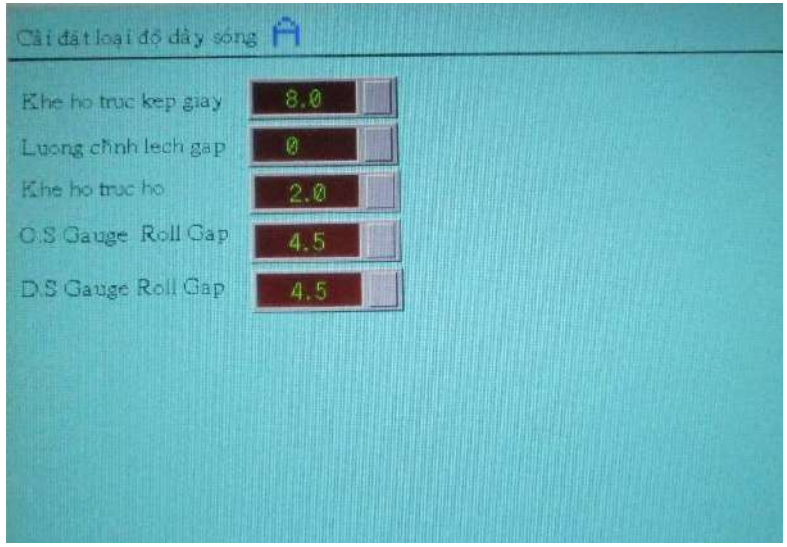


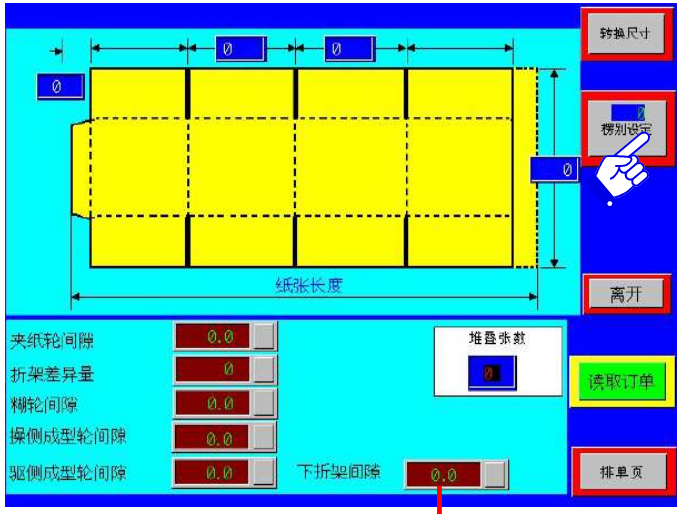
Folder Gluer Main HMI-Order Setting-Flute
糊箱機主人機介面-訂單輸入頁-楞別設定

Remark補充說明

Flute: It can save 20 flute types. Give a name for the flute type, and set up the gap of the below:楞別設定：共有20種楞別可供儲存，可自行儲存所需的楞別名稱及楞別內容，人機按下楞別鍵後，會出現一密碼畫面輸入，之後才會出現右下角的設定畫面，就可依照楞別之厚度設定個單元間的間隙

Press Gap 夾紙輪間隙
Shrinkage 折架差異量
Glue Wheel Gap 糊輪間隙
O.S Gauge Roll Gap 操作側側導輪間隙
D.S Gauge Roll Gap 驅動側側導輪間隙





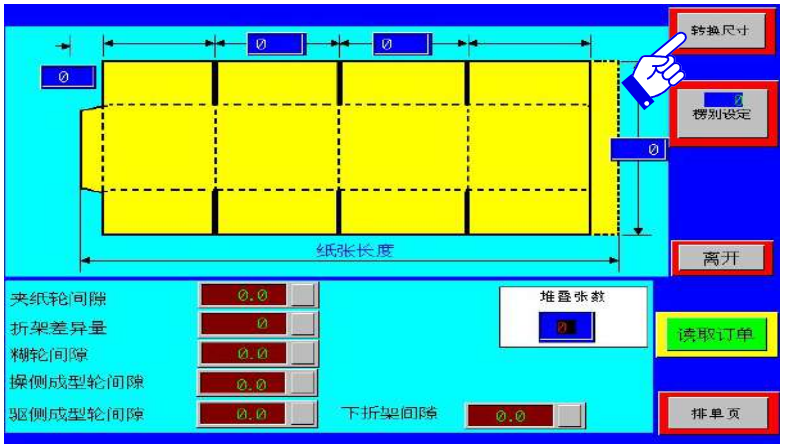
Folder Gluer Main HMI-Order Setting-Transfer
糊箱機主人機介面-訂單輸入頁-尺寸轉換

Procedures操作程式

- After enter the transfer pages and will show below進入尺寸轉換頁面後，所顯示分別為：

1. Gluer折盒部— Displays each machine actual position. When the machine present value is equal to the setting value, it consider the setting is done and can start the production.顯示各機械實際位置點。當目前機械數值等於設定機械數值時， 可視為調整完成， 即可進入生產。

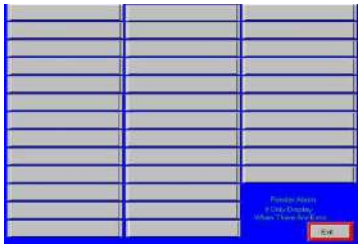
2. Counter Ejector計數排出部— Displays each machine actual position. When the machine present value is equal to the setting value, it consider the setting is done and can start the production.顯示各機械實際位置點。當目前機械數值等於設定機械數值時， 可視為調整完成， 即可進入生產。

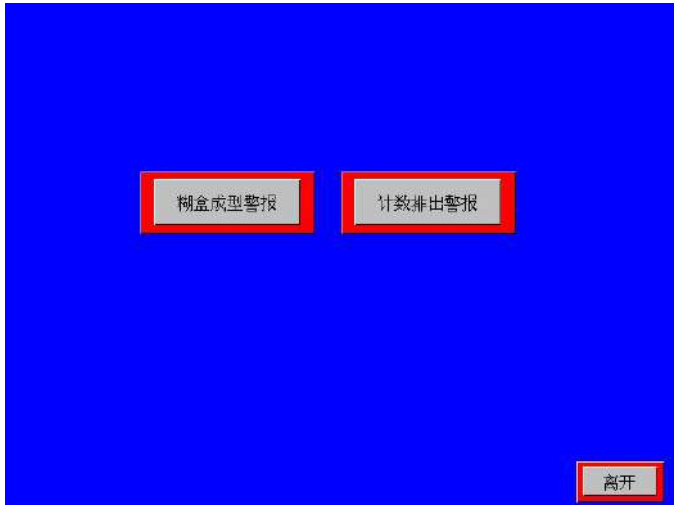


Folder Gluer Main HMI-Alarm
糊箱機主人機介面-警報

Procedure操作程式
During the machine is in adjusting or running operator can enter the **Alarm** page to check the error message.在排單頁面按下<排單>按鈕後， 機器進行位置調整處理時， 或是在生產進行中，機台出現狀況， 操作人員可以按下主畫面的<警報>鈕後， 進入警報單元選擇頁面， 此頁面共有下列選項：

- **Folder Gluer Alarm糊盒成型警報** — Display the error message of Folder Gluer Unit. 顯示糊盒成型異常訊息。
- **Counter Ejector Alarm計數排出警報**— Display the error message of Counter Ejector Unit. . 顯示計數排出異常訊息。





Notes注意

- After enter each alarm page, no error message will be shown when there is no error problem.在點選進入各單元警報頁面後， 如該單元沒有狀況，將會顯示空白頁面。

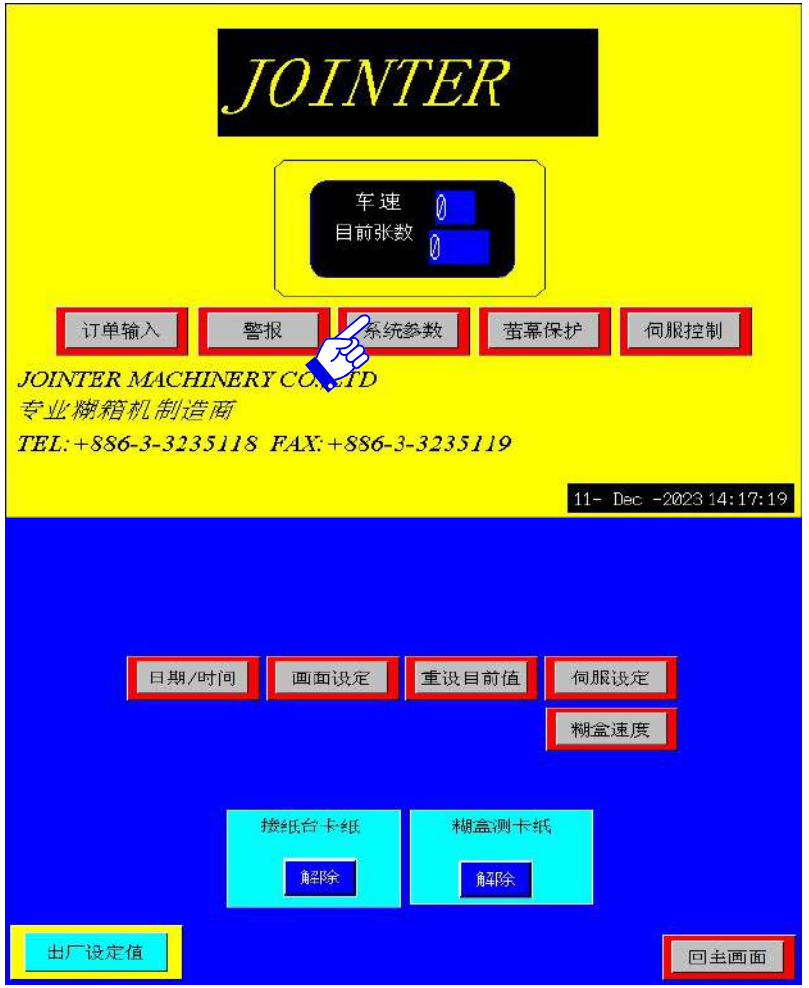
Folder Gluer Main HMI-Parameter
糊箱機主人機介面-系統參數

Operator may need to set the parameter of machine, if necessary.若有須要，操作人員將機台參數作調整。

- **Date/Time日期/時間**— Set new date and time.修改日期/時間。
- **Display畫面設定**—Change display language on screen.
- **Position Correct重設目前值**—Correct machine position.修改顯示語言。
- **Servo伺服設定**—Change Servo parameter.提供生產總量顯示、卡紙、回油幫浦等參數。
- **Gluer Speed Setting糊盒速度** —Set the gluer speed.調整印刷速度和糊盒皮帶的速度比，切勿更動。
- **Machine Setting出廠設定值**—Require secondary password. Or click **<ESC>** to exit the keypad.此設定一般不更動， 裝機人員在機械裝設時已調整設定完成， 如需更改，請洽長聲公司。
- **Folder Jam Detect糊盒測卡紙**—To activate the detection of box jam by **ON**. 選擇“設定”時， 在紙箱堆疊過程中，若有卡紙便會全機停止，選擇"解除"， 則取消此功能。
- **Main**回主畫面— Exit and return to Main Page.回到主頁面。

Notes操作重點：

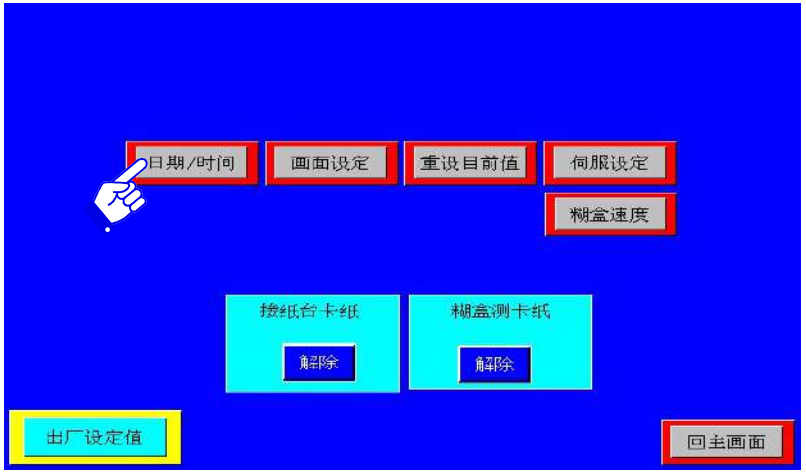
- Don’t modify the setting or parameter at random, otherwise, it may cause mechanical problem and do damage to the operator and the machine. Please contact with SUNRISE if there is any require to do parameter setting.
- 出廠設定值–此設定一般不更動， 裝機人員在機械裝設時已調整設定完成， 如需更改，請洽長聲公司。

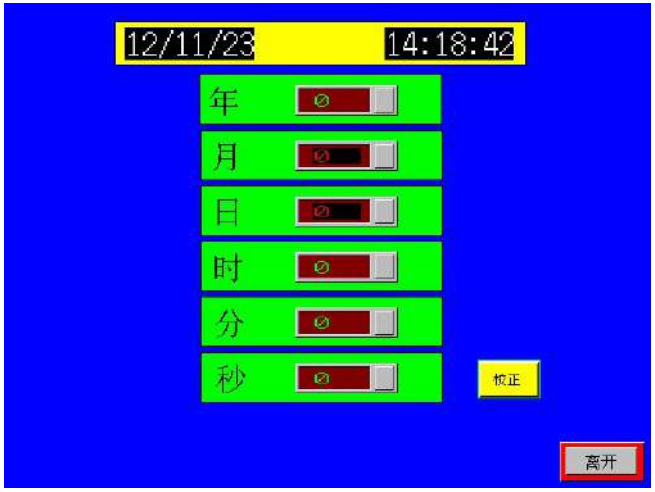


Folder Gluer Main HMI-Parameter-Date/Time

糊箱主人機介面-系統參數-日期/時間設定

This page is to reset the Date/Time displaying in HMI.本頁是時間/日期參數設定。After entering the figure in the column of YY>/<MM>/<DD>/<HH>/<MM>/<SS>, click<Correct> to finish the adjustment.在輸入年/月/日/時/分/秒後，按下<校正>鈕後，即設定完成。

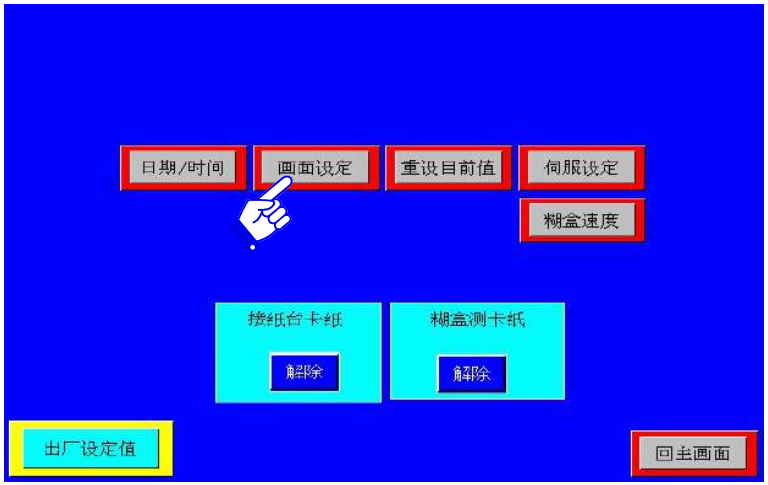


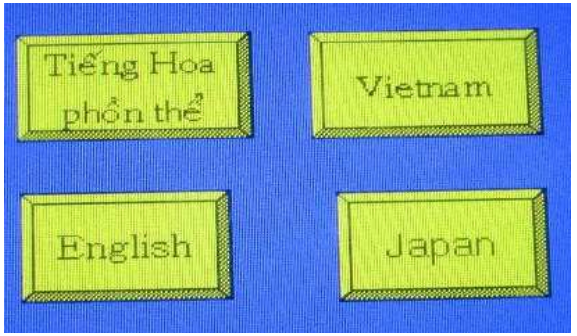


Folder Gluer Main HMI-Parameter-Display
糊箱機主人機介面-系統參數-畫面設定

Procedure操作程式

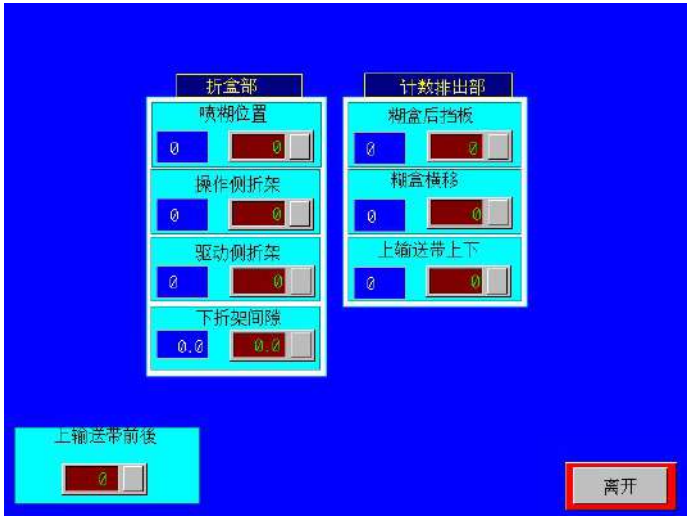
- This page is to adjust the font showing in the HMI.按下主頁內之畫面設定後，會顯示數位鍵，要求輸入密碼。 輸入正確的密碼後，即會出現右圖下方的畫面，提供顯示畫面的語系調整。
- <Chinese> All information will be showed in Traditional Chinese after selected.按下“中文”的方塊，頁面顯示的語系將轉成中文。可以依使用者的習慣，作適當的調整。
- <English> All information will be showed in English after selected.按下“英文”的方塊，頁面顯示的語系將轉成英文。可以依使用者的習慣，作適當的調整。
- <Japan> All information will be showed in English after selected.按下“日文”的方塊，頁面顯示的語系將轉成日文。可以依使用者的習慣，作適當的調整。
- <Vietnam> All information will be showed in English after selected.按下“越文”的方塊，頁面顯示的語系將轉成越文。可以依使用者的習慣，作適當的調整。





Folder Gluer Main HMI-Parameter-Position Correct
糊箱機主人機介面-系統參數-重設目前值

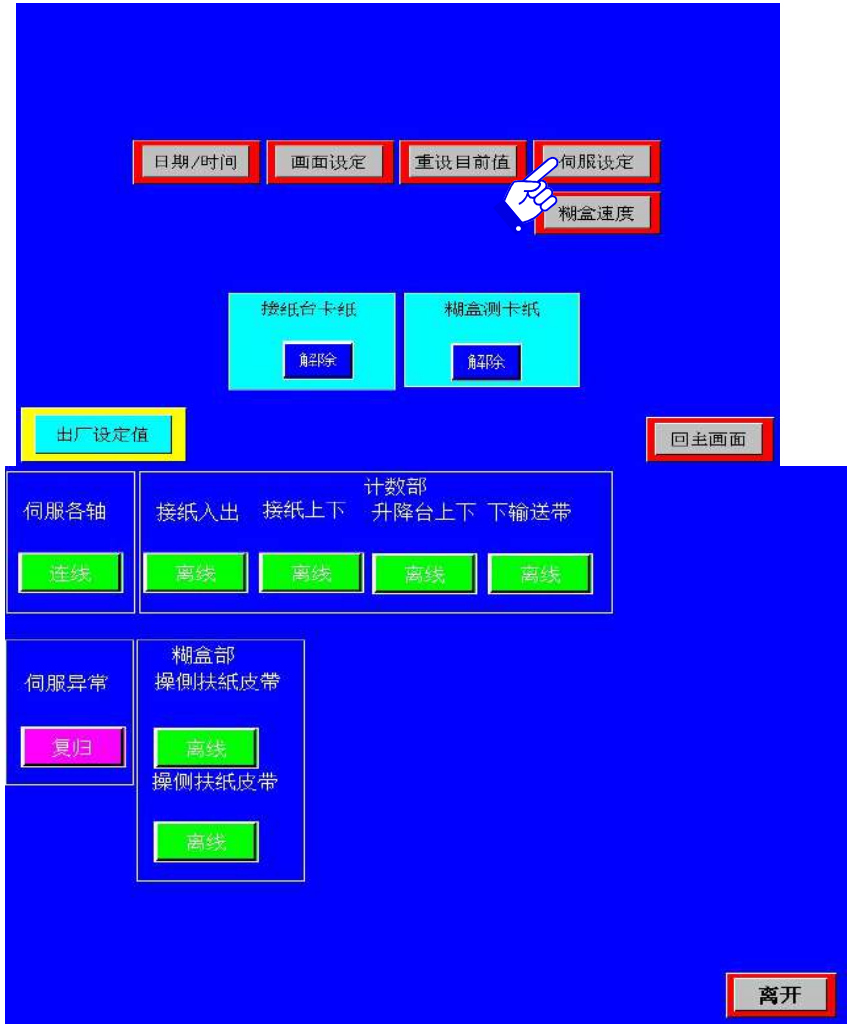
- While the value displaying in HMI does not correspond with the real position of the machine, or after replacing a new encoder or a new coupling, the operator needs to do position correct.本畫面在機械實際之位置或間隙與人機畫面顯示之數值不同時， 可經由此部分重新設定，使二者相符合。
- **IN GLUER UNIT折盒部**—the operator may need to correct the position of Glue station, O. S. Guide or D.S. Guide. 折盒部，操作人員可進行噴糊位置，操作側折架及驅動側折架等調整。
- **IN COUNTER EJECTOR UNIT計數排出部**—the operator may need to correct the position of Back stopper, Lateral Adjustment of Counter Ejector unit, or Upper Conveyor up/ down.計數排出部，操作人員可進行糊盒後擋板，糊盒橫移，及上輸送帶上下等調整。



Folder Gluer Main HMI-Parameter-Servo
糊箱機主人機介面-系統參數-伺服設定

- **Servo enable伺服各軸**— To set all servo controlled Counter Ejector movement ON or OFF at the same time. E.g. **Ledge In/Out**, **Ledge Up/Down**, **Elevator Up/Down**, **Lower Conveyor**. 選連線則接紙入出、接紙上下、升降臺上下及下輸送帶等可同步連線或離線。

- **Servo Error伺服異常** —To reset the servo control if any abnormal errors occur. 當系統意外停電或不正常當機等因素造成伺服動做不正常時，按複歸可使以上各伺服控制的動作重新歸位。



Folder Gluer Main HMI-Parameter-Glue Speed Setting
糊箱機主人機介面-系統參數-糊盒速度設定

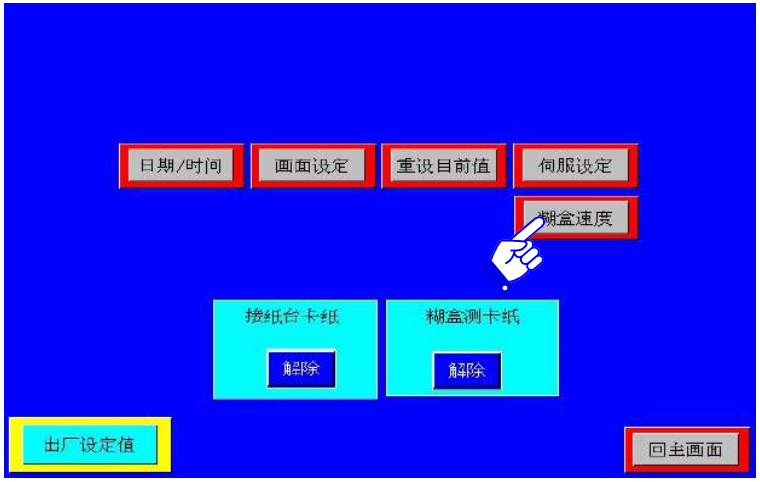
Function Description功能說明

Printer speed and Gluer speed setting印刷機車速及糊盒頻率

- To adjust the printing speed from 0 to 250, the relative speed of the folder gluer belt can get the best speed.調整印刷速度從0至250張時，糊盒皮帶的相對速度比，以得到最佳配速。

Notes注意重點:

- Don’t modify the setting or parameter at random, otherwise, it may cause jam and do damage to the operator and the machine. Please contact with SUNRISE if there is any require to do parameter setting.請勿任意更改現在值， 否則可能會造成卡紙。此功能只在長聲公司建議下方可操作。



Folder Gluer Main HMI-Glue Speed Setting-Upper Belt Speed Correct
糊箱機主人機介面-糊盒速度設定-上皮帶教導

Procedure操作程式

上皮帶教導共分3項，取低中高三個速度教導， 左邊空格低中高車速，右邊空格輸入依照轉速表量測實際線速度微調實際頻率

Notes注意重點

- Don’t modify the setting or parameter at random, otherwise, it may cause jam and do damage to the operator and the machine. Please contact with SUNRISE if there is any require to do parameter setting.請勿任意更改現在值， 否則可能會造成卡紙。此功能只在長聲公司建議下方可操作。

Folder Gluer Main HMI—Glue Speed Setting-Bottom Belt Speed Correct
糊箱機主人機介面-糊盒速度設定-下皮帶教導

Procedure操作程式

下皮帶教導共分3項，取低中高三個速度教導， 左邊空格低中高車速，右邊空格輸入依照轉速表量測實際線速度微調實際頻率

Notes注意重點:

- Don’t modify the setting or parameter at random, otherwise, it may cause jam and do damage to the operator and the machine. Please contact with SUNRISE if there is any require to do parameter setting.請勿任意更改現在值， 否則可能會造成卡紙。此功能只在長聲公司建議下方可操作。

Folder Gluer Main HMI—Glue Speed Setting-O.S Belt Speed Correct
糊箱機主人機介面-糊盒速度設定-操作側修正皮帶教導

Procedure操作程式
操作側皮帶教導共分3項，取低中高三個速度教導， 左邊空格低中高車速， 右邊空格輸入依照轉速表量測實際線速度微調實際頻率

Notes注意重點:

- Don’t modify the setting or parameter at random, otherwise, it may cause jam and do damage to the operator and the machine. Please contact with SUNRISE if there is any require to do parameter setting.請勿任意更改現在值， 否則可能會造成卡紙。此功能只在長聲公司建議下方可操作。

Folder Gluer Main HMI-Glue Speed Setting-D.S Belt Speed Correct
糊箱機主人機介面-糊盒速度設定-驅動側修正皮帶教導

Procedure操作程式
驅動側皮帶教導共分3項，取低中高三個速度教導， 左邊空格低中高車速， 右邊空格輸入依照轉速表量測實際線速度微調實際頻率

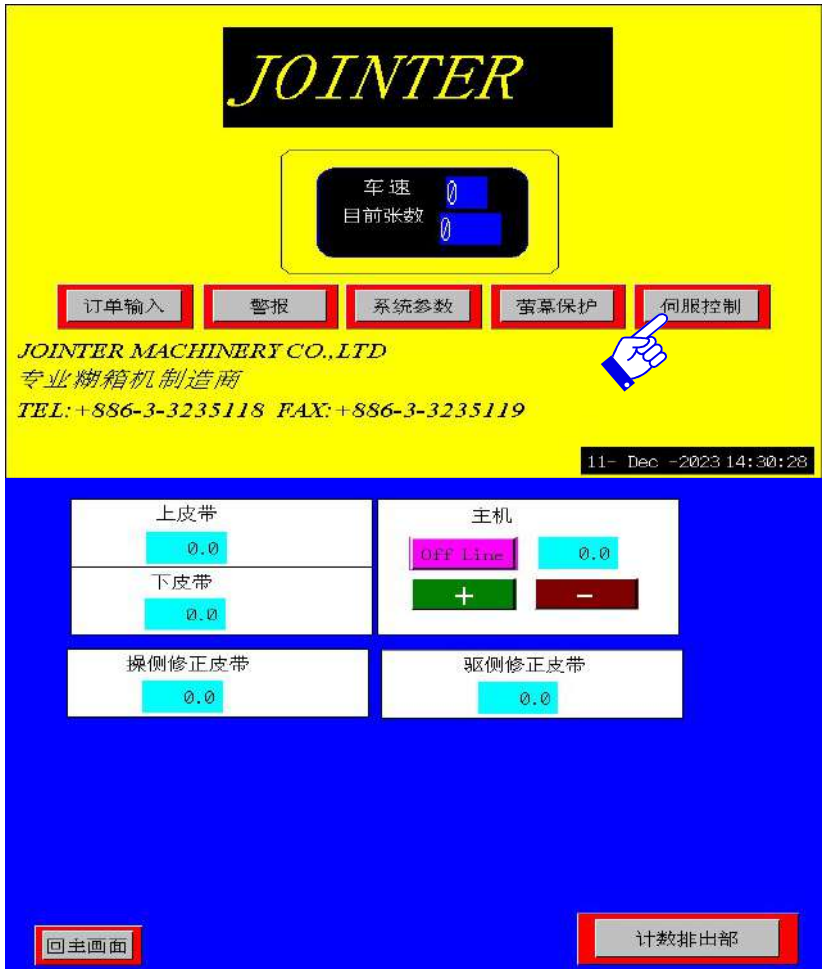
Notes注意重點

- Don’t modify the setting or parameter at random, otherwise, it may cause jam and do damage to the operator and the machine. Please contact with SUNRISE if there is any require to do parameter setting.請勿任意更改現在值， 否則可能會造成卡紙。此功能只在長聲公司建議下方可操作。

Folder Gluer Main HMI-Servo Control
糊箱機主人機介面-伺服控制

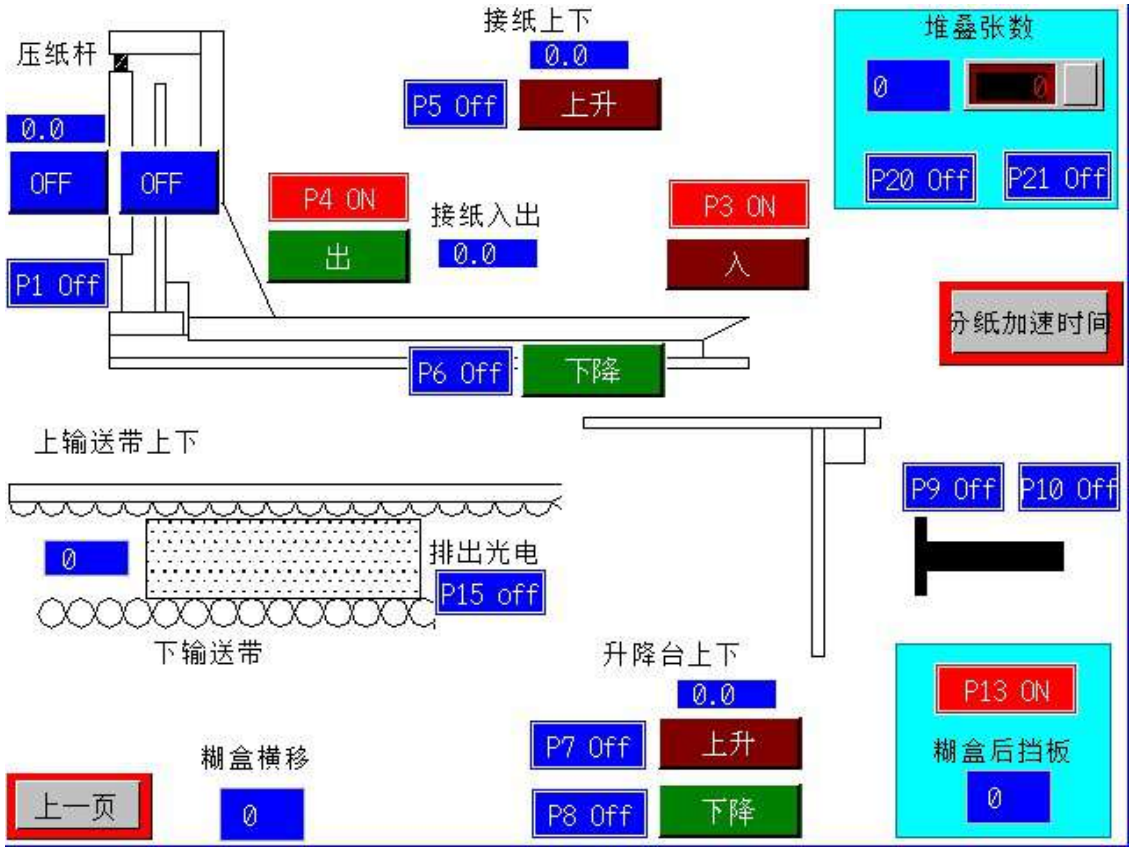
To display the speed of belts as followings顯示下列各皮帶的速度:

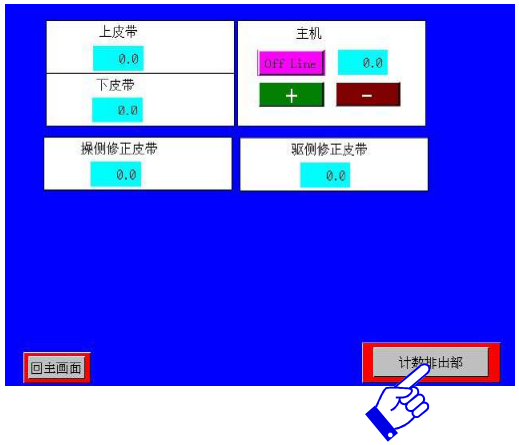
- **Folding Upper Belt Speed**上皮帶速度
- **Lower Belt Speed**下皮帶速度
- **O. S. Correct Belt Speed**操作側修正皮帶速度：可修正”魚尾”現象
- **D. S. Correct Belt Speed**驅動側修正皮帶速度：可修正”魚尾”現象
- **Main Speed主機**: To set FG Unit Inline or Off line and adjust the speed by＋ or－.設糊箱機為連線或離線，以＋or－控制速度。



Folder Gluer Main HMI-Servo Control
糊箱機主人機介面-伺服控制

To Show the proximity sensors location and ON / OFF at each movement. 顯示各近接開關的位置即每個動作的ON / OFF

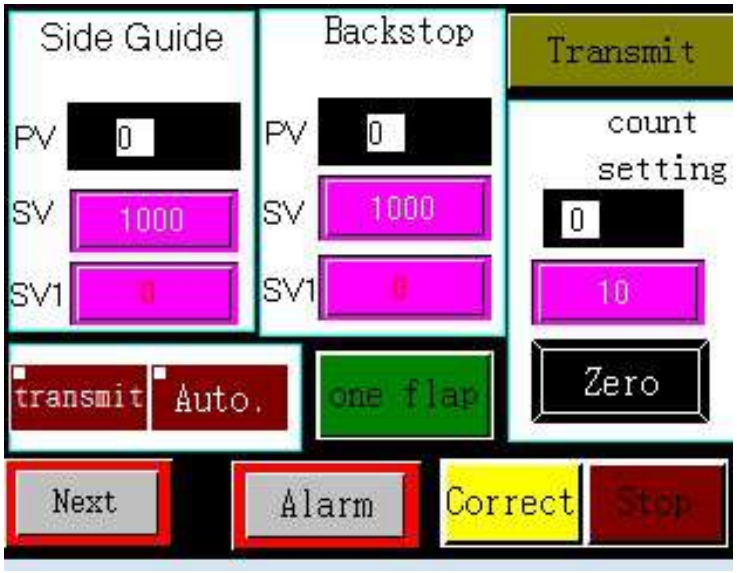




HMI小人機介面 - STKC 積下機

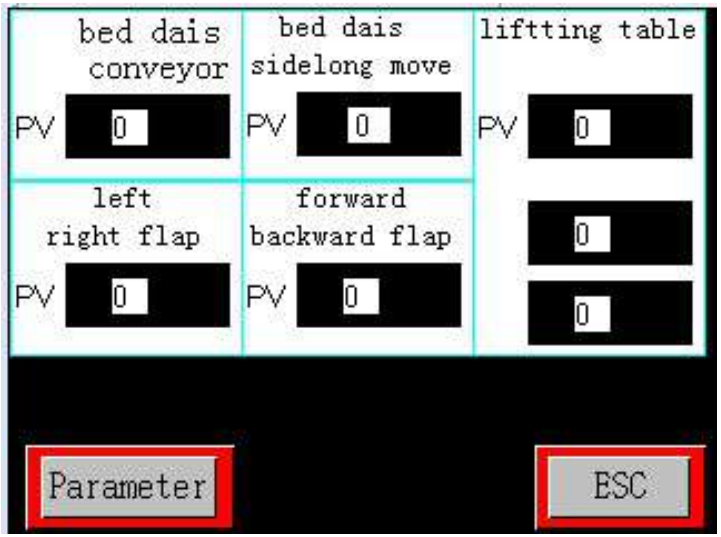
- It displays the **P**resent **V**alue of Side Guide, Back Stop, count setting ,mode change ,one flap/two flap 顯示目前位置為側檔版，後檔板，堆疊收料次數，模式切換，1拍/2拍。
- When operator clicks the column of **SV**, one keypad will appear. Filling in the figure to adjust. 當操作員用手點擊SV欄時，操作鍵盤便會即時來作調整用。
- **Next** — Move to next page for setting position 往下一頁去.
- **Stop** —Stop moving before it moves to the setting position. 停止畫面移動。
- **Correct** — After finish keying, press “Correct” to start the order setting until finish. 輸入完成後， 按下”排單啟動”則開始排單。
- **Alarm** —Alarm page. 警報頁

Remark備註
- PV: Present Value 顯示目前設定量.
- SV: Setting Value 顯示輸入設定量



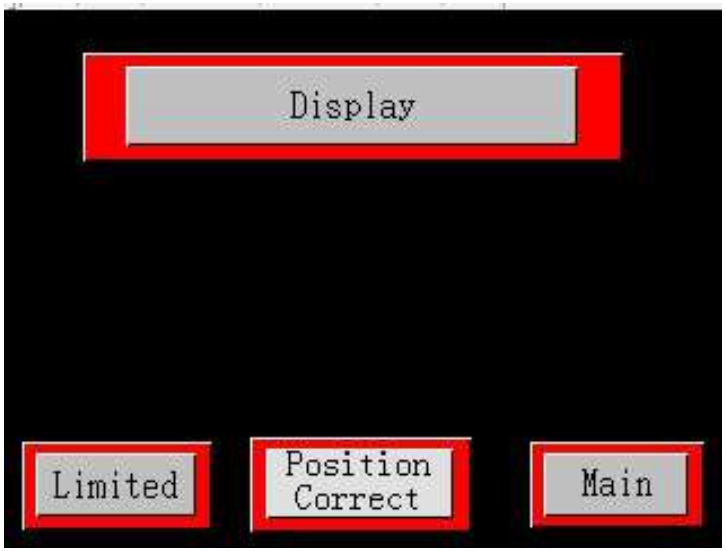
HMI小人機介面 - STKC 積下機

- It displays the **P**resent **V**alue of bed dais conveyer, bed dais sidelong move, lifting table, Side Guide, Back Stop, one flap/two flap 顯示目前位置為床台皮帶，床台位置，升降，側拍板，後拍板，1拍位置/雙拍位置
- Show current location 顯示目前位置
- **ESC** — leave 離開
- **Parameter** — Parameter setting 參數設定



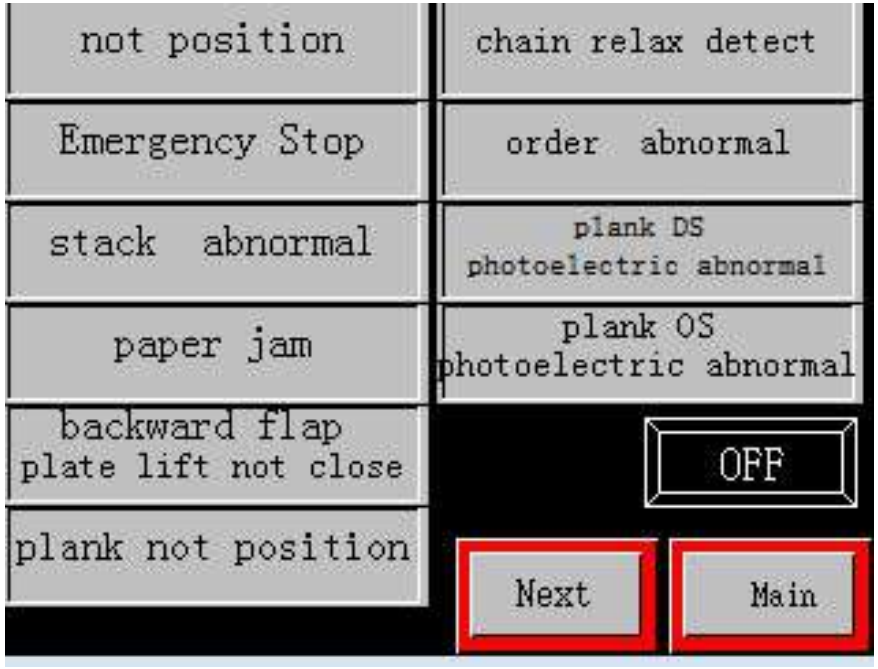
HMI小人機介面 - STKC 積下機

- **Display** — language modification 語言修改
- **Limited** — Limit setting 極限設定
- **Position correct** — Position correction 位置校正
- **Main** — Back to main screen 回主畫面



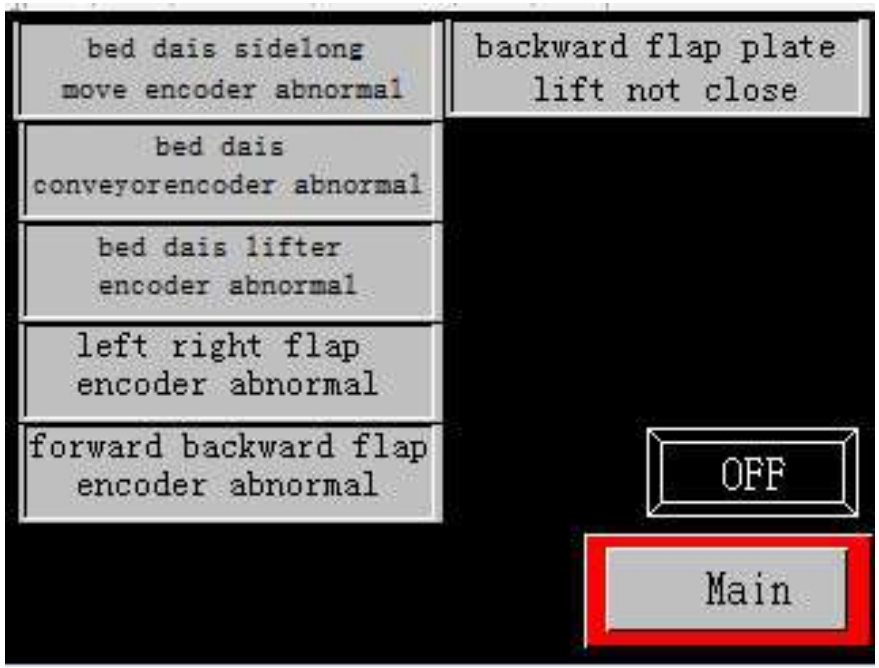
HMI小人機介面 - STKC 積下機

- **Alarm page 1**

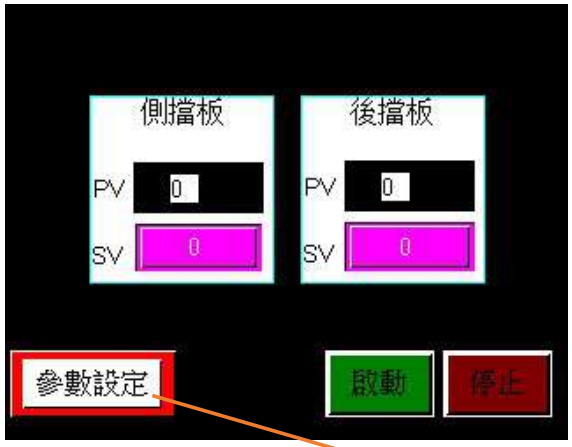


HMI小人機介面 - STKC 積下機

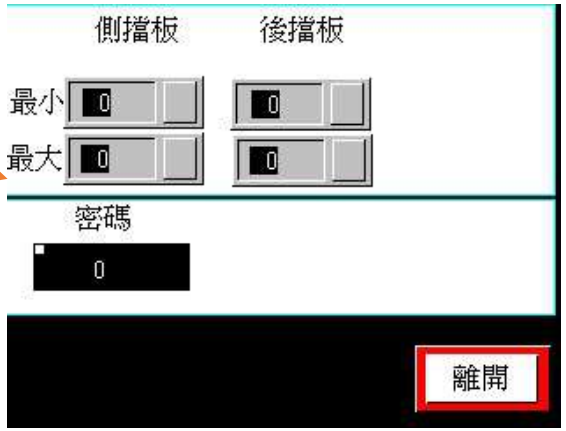
- **Alarm page 2**



HMI 小人機介面 – STK 標準堆疊



1.顯示目前位置為 側檔版，後檔版
2.參數設定頁校正極限位置



SAFE GUARDING DEVICE
安全設施 (FLEXO)

ATTENTION備註!

PUSH BUTTON EMERGENCYSTOP & ALARM緊急停止按鈕開關&警鈴

- EMERGENCY STOP 緊急停止— Operators of machines should be aware that using an emergency stop button can result in the complete shutdown of a machine.當發生緊急狀況時，按下此鈕，可使機器緊急停止，但使用緊急停止按鈕，會導致機器完全關閉。機器操作者只有在緊急情況下使用此鈕，一般停機請按照正常程式慢慢減速後關閉主機動力。
- Twist-to-reset design require users to twist the button in order to reset the switch and resume operation.欲解除此緊急停止開關時，僅需將紅色按鈕依順時針方向旋轉。
- Press ALARM button to alert people away from the Machine before open or close the Units or activate any moving section.警鈴-移動各部位前，必需確保移動範圍內無雜物並按警鈴， 通知附近人員離開，以策安全.

Feeder進紙

Back Stop後擋

Die Cut模切

SAFE GUARDING DEVICE
安全設施(FFG)

ATTENTION備註!

PUSH BUTTON EMERGENCY STOP &ALARM緊急停止按鈕開關&警鈴

- EMERGENCY stop緊急停止— Operators of machines should be aware that using an emergency stop button can result in the complete shutdown the machine.當發生緊急狀況時，按下此鈕，可使機器緊急停止，但使用緊急停止按鈕，會導致機器完全關閉。機器操作者只有在緊急情況下使用此鈕，一般停機請按照正常程式慢慢減速後關閉主機動力。
- Twist-to-reset design require users to twist the button in order to reset the switch and resume operation.欲解除此緊急停止開關時，僅需將紅色按鈕依順時針方向旋轉。
- Press ALARM button to alert people away from the Machine before open or close the Units or activate any moving section.警鈴-移動各部位前，必需確保移動範圍內無雜物並按警鈴， 通知附近人員離開，以策安全。

Gluer (side)噴糊(側邊)

Ejector出紙

Counter計數

SAFE GUARDING DEVICE
安全設施(ROPE TYPE)

ATTENTION備註!

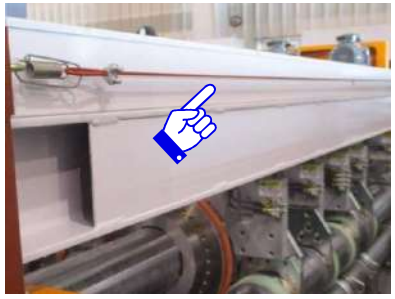
ROPE PULL EMERGENCY STOP緊急停止拉線開關

- *When a machine absolutely must be stopped (e.g. emergency situations), rope pull emergency stop is used to immediately initiate a complete and safe stop by pulling the red rope.當機器必須被完全停止(例如緊急狀況)時，只要拉動紅沙拉繩可立即停止機械運作。*
- *Press-to-reset design require users to press the button in order to reset the switch and resume operation. 按下紅線末端的藍色按鈕可解除此緊急停止開關。*

Feeder送紙

Printer (Front)印刷(前)

Slotter (Front)開槽(前)

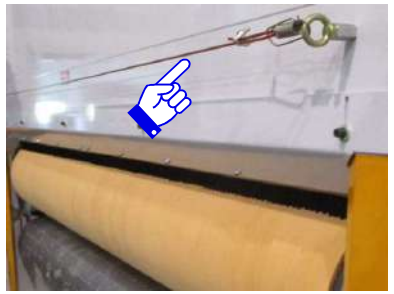


Die Cutter (Front) 模切(前)

Printer (Back)印刷(後)

Slotter開槽(後)

Die Cutter (Back)模切(後)



Reset Button解除開關

Feeder Unit 送紙單元 – Function 面板功能

1. EMERGENCY警急停止— Refer to safeguarding instruction in general information.請參考本冊開頭安全介紹。

2. BUZZER警鈴— Refer to safeguarding instruction in general information.
請參考本冊開頭安全介紹。

3. FEED VALVE送紙風門— To control the vacuum gate. 控制吸風風門開關。
- CLOSE關閉—vacuum gate close, cardboard is held by vacuum.吸風風門關閉,紙板被吸風傳送箱吸住。
- OPEN開啟 — vacuum gate open, cardboard is released.吸風風門開啟,紙板鬆開。

4. FEED ROLL GAP進紙輪間隙— To adjust the gap between rubber roller and steel roller at the exit of Feeder according to cardboard thickness.根據紙板厚度調整進紙輪間隙(膠輪與鐵輪)。
- ＋： Enlarge the gap for thick cardboard.加大間隙.
- －： Reduce the gap for thin cardboard.縮小間隙

5. SQUARING側拍— Control the side guiding plate at operator side. 操作側側拍板。
OFF — Stop the squaring patting.停止側拍
ON — Start the squaring patting.開始側拍

Feeder Unit 送紙單元 – Function 面板功能

6. SIDE GUIDE側擋板位置—To adjust the position the gap of side guiding plates to allow one cardboard delivery.調整前檔版間隙以便確保只有一張紙板能通過。

- ← O.S.操作側 → ：Two way button to adjust the plate position at operator side.
  兩方向鈕可供調整操作側擋板位置
- ← D.S.驅動側 → ：Two way button to adjust the plate position at driver side.兩方向鈕可供調整驅動側擋板位置

7. FEED送紙—When the machine is in running, press the button as below to decide the board feeding mode.當機器運轉時，按下以下按鈕決定送紙模式。

- STOP停止— Stop feeding 停止送紙
- CONTINUE連續 —Continue Feeding (Producing).在生產鐘連續送紙
- SKIP隔張 — Feed one board when the print cylinder turns 2 rotation.
  (If the board size is over the standard range in Continue Mode）當印刷輪轉動
  兩圈時，傳送一張紙。(如果紙張在連續模式時，大於標準紙張大小）
- SINGLE單次 — Feed one/two boards then stop feeding.送1,2張紙即停止送紙

8. GATE GAP前擋板間隙— To adjust the gap of front gate to ensure only “one” cardboard is delivered.
調整前檔版間隙以便確保只有一張紙板能通過。

- ↑： Adjust the gate up. 加大間隙
- ↓： Adjust the gate down. 縮小間隙

9. BACK STOP後擋板位置— Move “back stopper” (rear guide) position.移動後擋板的位置。

- FWD前進 — Move forward for smaller cardboard. 將位置前移來符合較小的紙張。
- REV後退 — Move backward for larger cardboard. 將位置後移來符合較大的紙張。
  ↑ — Adjust the back stop up.上升擋板。
  ↓ — Adjust the back stop down.下降擋板

Feeder Unit 送紙單元
Side Panel Function 面板功能(側邊面板)

1. DUST COLLECTOR除塵 —Vacuum cleaner with hair brush to reduce dust on board.利用抽風機及毛刷將紙板上的落塵清除。
   - OFF 關閉— Stop the vacuum cleaner. 停止抽風機運作。
   - ON 開啟— Start the vacuum cleaner. 開啟抽風機運作。

2. MAIN ANCHOR機台定位鎖 —To lock or unlock Feeder unit on rails.鎖定送紙單元是否固定在軌道上。
   - UNLOCK開鎖— Unlock Feeder unit from rails.送紙單元無固定在軌道上。
   - LOCK上鎖— Lock Feeder unit as machine anchor.送紙單元固定在軌道上。

3. FRAME POSITION機台移動 — Press FRAME POSITION by one hand, the other hand press FRAME POSITION push button to move Feeder to the indicative direction. 將”機台定位鎖”轉至”UNLOCK”，右手按下”機台移動”再以左手按下”機台移動 ← →”進行移動。

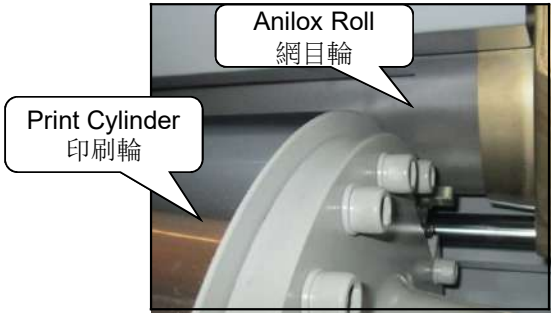
4. RETURN to its previous memorized register before Unit open. 複歸：回到先前記憶的參數位置

NOTE.備註: The MAIN POWER cannot turn ON before MACHINE ANCHOR turns to LOCK. 在機台固鎖被固定前，請勿打開主機動力。

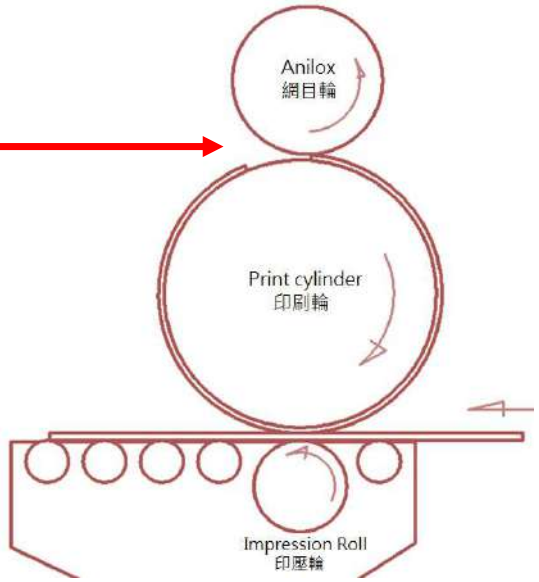
Printer Unit 印刷單元
Structure (Blade System) 結構 & 壓力調整(刮刀系統)

Procedure操作程式

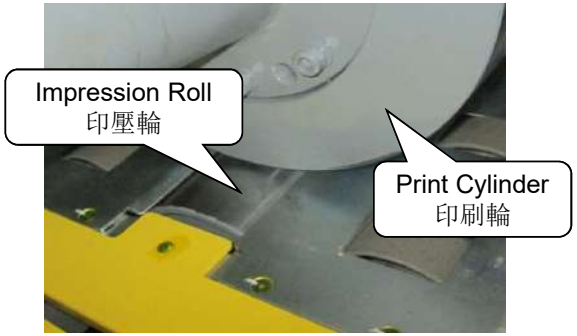
Print Plate Pressure “版壓” (The gap between anilox roll and print cylinder著墨輪與印刷輪間隙）The whole print plate should have even and consistent ink from anilox roll（the thickness and hardness of the print plate may have the deviation). It refers the scale table, and use the spanner to adjust the pressure to suitable level.以印版能夠均勻著墨為適當。（印 版厚度、硬度會有些許差異）參考刻度表，使用版手轉動調整器使版壓的壓力適當。



（著墨輪與印刷輪間隙）



Impression Pressure”印壓”（The gap between impression roll and print cylinder印刷輪與印壓輪間隙）The whole sheet should have even and consistent ink from the print plate. (refer the thickness of the sheet and other condition to adjust it). Using the + / - button to adjust the impression pressure level, or adjust through the HMI setting.
以紙板能夠均勻著墨為適當。(隨紙板厚度及其它影響因素調整）使用 + / - 鈕去調整印壓的大小， 或使用人機裡設定進行調整。



（印刷輪與印壓輪間隙）

Printer Unit 印刷單元
Panel Function(Blade System) 面板功能(刮刀系統)

1. INK SYSTEM供墨系統—Control ink system by 3 ways selector.以三段選擇開關控制
   - STOP停止—Stop ink pump, no ink supply.先按停止，再按啟動鈕，則停止墨泵動作，墨腔自動退開。
   - SUPPLY供墨 —Start to pump ink from ink bucket to ink chamber.先按供墨，再按啟動鈕，開始從墨桶供墨到墨腔。
   - WASH洗墨 —To wash Anilox roll by programmed procedures.按洗墨，再按啟動鈕，控制系統依據設定值自動進行清洗程式，行程終止泵停止運轉。
   - START啟動—Start to activate the function selected from above 4 ways selector.確認並執行上述選擇開關動作，以防誤觸。

2. ANILOX POSITION 著墨輪位置—Control Anilox roll position by 4 ways selector.以四段選擇開關控制
   - ATTACH著墨 —Move Anilox roll close to Print Cylinder.著墨輪貼近印刷輪。
   - AUTO自動—Control the position by inline function.著墨輪位置依機器運轉自動控制。
   - DETACH分離 —Move Anilox roll away from Print Cylinder.著墨輪離開印刷輪。

3. PRINT PLATE PRESSURE板壓
   ＋： Increase the gap pressure between anilox roll and print cylinder.加大印壓輪與印刷輪之間的間隙
   －： Decrease the gap pressure between anilox roll and print cylinder.縮小印壓輪與印刷輪之間的間隙

4. IMPRESSION印壓
   ＋： Increase the gap pressure between impression roll and print cylinder.加大印壓輪與印刷輪之間的間隙
   －： Decrease the gap pressure between impression roll and print cylinder.縮小印壓輪與印刷輪之間的間隙

5. REGISTER印刷相位— Selector switch to rotate the register選擇開關來調相位
   FWD前進— Rotate the register forward相位向前轉
   REV後退— Rotate the register backward相位向後轉
   MAU人手— Manual rotate the register人手轉動相片
   AUTO自動— Auto rotate the register“自動”由電腦控制。

6. WASTE WATER DISPOSITION排廢水— Remove the waste water after washing將洗墨後的廢水排走。

Printer Unit 印刷單元
Ink Washing Procedures (Blade System) 洗墨程式(刮刀系統)

Procedure操作程式

When the job is finished, be sure to follow the steps to clean the anilox roll and the chamber.印刷工作完成或更換其它顏色水墨時依照下列程式操作。

1. Ink supply turn to ”STOP” and press “START” to stop the pump running.供墨選擇開關切換至“停止”位置，壓下“啟動”按鈕，行程終止泵停止運轉。

2. Remove the ink bucket and the ink supply pipe insert to the clean water bucket.行程終止後移開墨桶，入墨管改插入清水桶、回墨管改插入廢水管，以便進行清洗作業。

3. Ink supply turn “WASH” and press “START” . The system will base on the setting to perform the auto cleaning until finish.供墨選擇開關切換至“洗墨”位置，壓下“啟動”按鈕控制系統依據設定值自動進行清洗程式，行程終止泵停止運轉。

4. Turn the switch of ANILOX POSITION to “DETACH” to separate the anilox roll after cleaning. This will make the anilox roll free from damage. 清洗作業完成將供墨選擇開關切換至“停止”位置，著墨輪位置選擇開關切換至“分離”位置。

5. After finish the cleaning, it should open the ink chamber and use the dry cloth to completely clean up the blade, chamber seal and both side sealing pad. 清洗自動行程結束著墨輪停止運轉後必須把刮刀墨室掀開，以沾水濕潤之乾淨柔軟抹布擦拭刮刀片、封刀片、兩端封墊及墨室內側清除殘留之墨漬。

Control (Register) 相位調整

Procedure操作程式

- Control控制

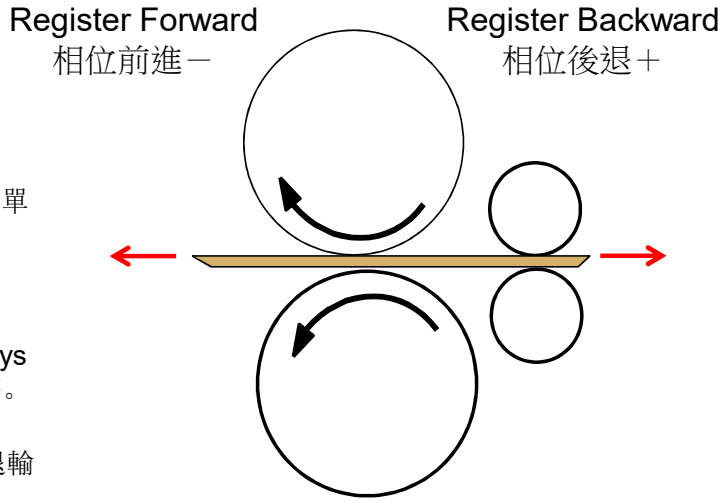
1. Adjust the setting on CNC computer.相位調整方式
2. Adjust the Setting on Main HMI.主人機介面"設定"調整。
3. Adjust the setting on each HMI.(Located in each function panel) 單元人機介面(位於各單元操作面板)“電動"調整。
4. Adjust the setting on each panel of unit.各單元操作面板按鈕開關“手動"調整。

- Control by auto setting, enter the register to adjust the position.
- Control by manual setting, click “FWD” or “REV” to adjust the position. The HMI displays the register.以“電動"方式調整者，輸入調整數值之後選擇"前進"或"後退"按鈕啟動調整。
- Select the section before inputting , press “－” to move forward and “＋” to move backward. Press “Control” to start.人機輸入時，先選欲調整部位，前進輸入－值，後退輸入＋值，按“微調起動”即開始自動依輸入尺寸調整。

Remark說明

1. Use each way to adjust, the computer and the main HMI display the figure simultaneously.使用各種調整方式，電腦及主人機同步顯示現在數值。

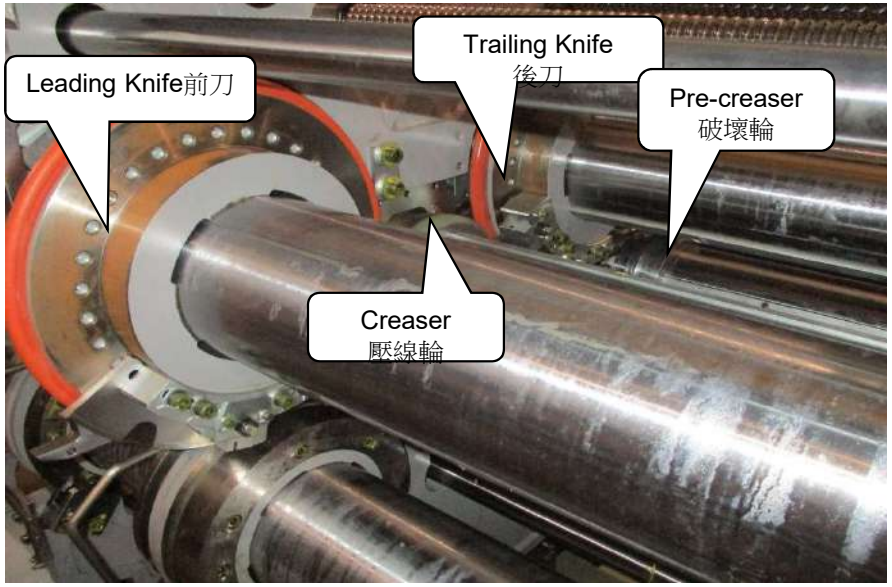
2. Please adjust the cylinder to standard when the encoder is unlock(substitute the new encoder or coupling) with the main cylinder (feeder ,printer, slotter ,and die cutter), or the machine can’t read the register.解碼器與主軸（前緣送紙輪軸、印刷輪、開槽刀軸、刀模軸）鬆脫過（例如更換解碼器或解碼器聯軸器等）必須重新校正主軸歸零點位置，否則訂單設定時無法正確排定相位位置。

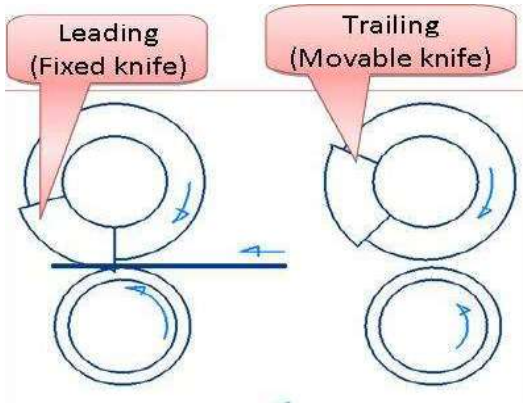


Printer印刷

Slotter開槽/ Die Cut模切

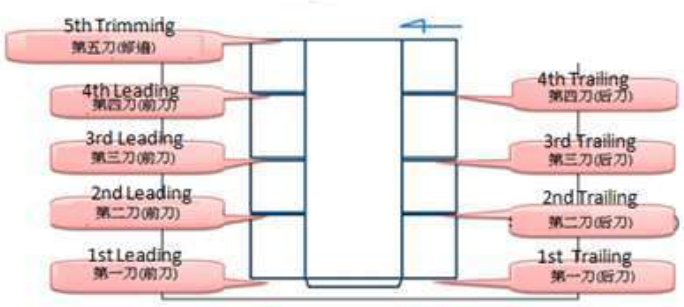
Slotter Unit 開槽單元
Structure 結構





Slotter unit is divided into four parts開槽單元分為四個部份：

- Pre-Creaser破壞輪— Crease the line at which to be folded. 在紙箱需要折成棱角的地方，先壓下第一次的壓痕。
- Trailing後刀—Cut the rear position of cardboard.將紙張分為兩部份，先將紙板後部份開槽切開。
- Creaser壓線輪—Crease the line again at which to be folded.在紙箱需要 折成棱角的地方，再行壓下第二次的壓痕定 型，以利紙板折成箱。
- Leading前刀— Cut the front position of cardboard.將紙張分為兩部份，再將紙板前部份開槽切開。



Slotter Unit 開槽單元
Panel Function面板功能

1. CREASER GAP 壓線輪間隙：
- Panel Control ＋/－ to adjust the gap使用面板 ＋/－ 鈕調整間隙
- HMI setting人機面板中設定間隙

2. PRE CREASER GAP破壞輪間隙：
- Panel Control ＋/－ to adjust the gap使用面板 ＋/－ 鈕調整間隙
- HMI setting人機面板中設定間隙

3. SLOTTER GAP開槽前刀及後刀間隙: Adjust leading and trailing gap (knife and knife stand)調整公刀與母刀的間隙(刀與刀座)
- By Leading Cutter ＋/－to adjust the gap.使用面板”前刀＋/－ 鈕調整間隙
- By Trailing Cutter＋/－, to adjust the gap使用面板”後刀” ＋/－鈕調整間隙
- Glue tap gap same as the slotter gap角刀間隙調整亦相同

4. KNIFE ENGAGED刀嚙合： Pressing this button will engage the male slotter knife with the female slotter knife. Light goes ON when knives engaged.當要以手動方式調整開槽位置時， 必須先將刀嚙合後， 才能移動刀座。在按下按鍵後，開槽刀便會運轉至刀嚙合之位置， 到達定位時，指示燈將會亮起。

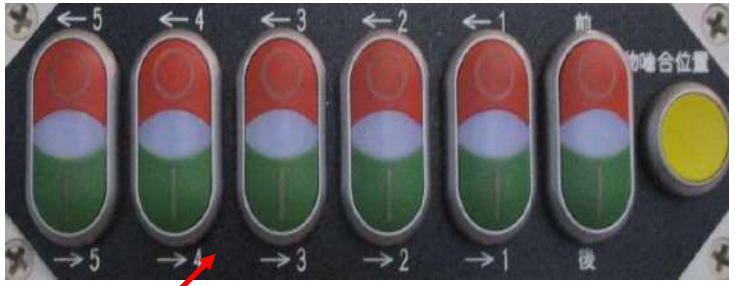
5. BOX DEPTH紙箱高度：
- “＋” Increase box depth 可增加紙箱高度
- “－” Decrease box depth可降低紙箱高度

6. ENTRYPROTECT入內保護 — Press this button when operator enter inside the machine for maintenance, cleaning or plat mounting.作業人員進入機內進行保養、清潔或拆換印版前須先行按此按鈕後此可進入機內。

Attention注意!
It must do the knife engaged . After that it can do theHMIadjusting1務必將刀嚙合再行使用人機進行調整。

Slotter Unit 開槽單元
Back Panel Function 後面板功能

←→：Control knives lateral moving控制刀做橫移動。

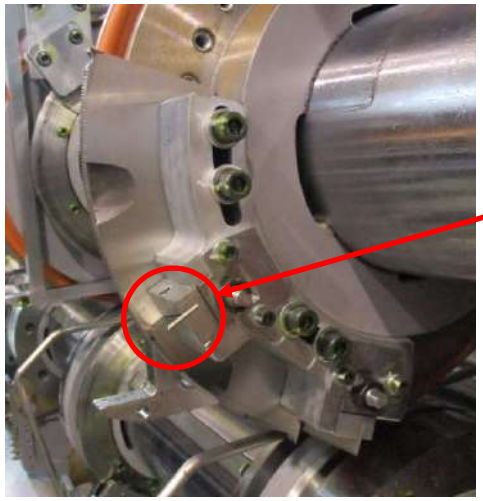


REGISTER 開槽相位：

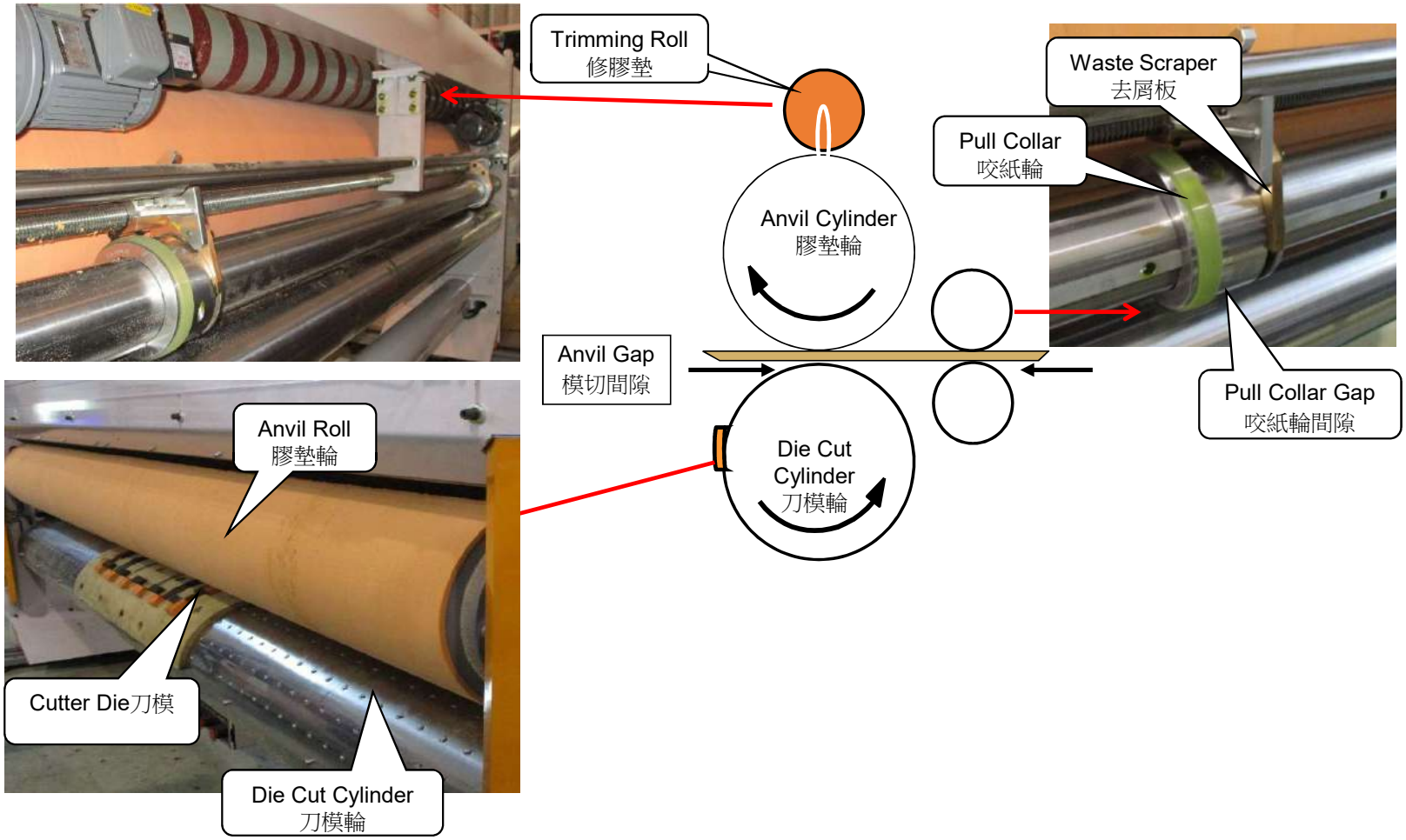
- Selector switch to Manual can rotate the register by REV/FWD button可以按壓按鈕移動相位”前進”或”後退”。

- KNIFE ENGAGED刀嚙合：Pressing this button will engage the male slotter knife with the female slotter knife. Light goes on when knives engaged.當要以手動方式調整開槽位置時， 必須先將刀嚙合後， 才能移動刀座。

- GAP OF GLUE TAB BLADE角刀間隙： Adjust the gap by spanner to make the cardboard cut exactly 使用板手調整間隙大小，讓紙板貼合邊能夠切斷為適當。



Die Cutter Unit 模切單元 Structure結構



Die Cutter Unit 模切單元
Panel Function 面板功能

1. OSCILLATION膠墊輪遊動— To ON or OFF the lateral moving of anvil (rubber) cover roller, keep it ON when cutting, that can prolong the lifetime of anvil covers. 膠墊輪左右來回橫移，避免刀模重複切在同 一點， 可延長膠墊壽命。 ON：開始膠墊輪遊移;OFF：停止膠墊輪遊移

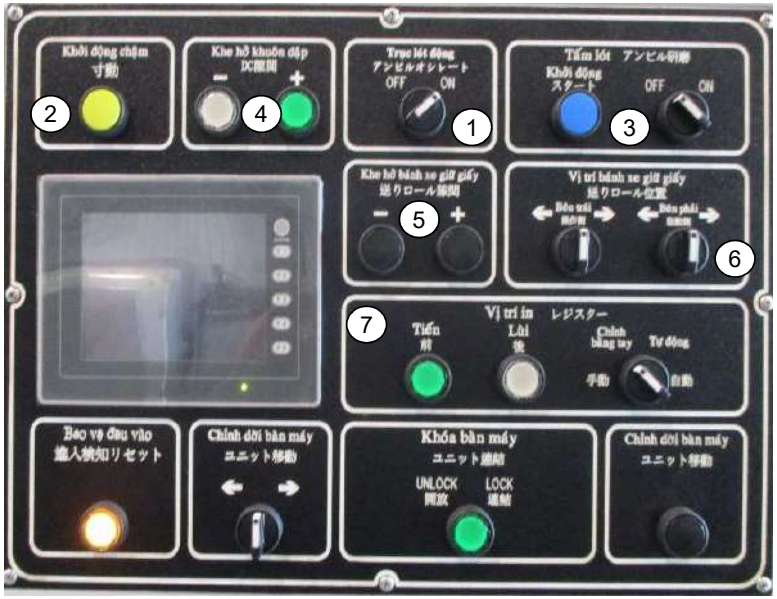
2. JOG寸動
   Slowly rotate all register of DIE CUT units rotation drives by the last PRINT unit.每次按下寸動鈕將微轉動一次刀模輪。

3. ANVILTRIM修膠墊—Repair the anvil to flatten膠墊輪修整平滑
   ON： Start trimming the anvil and press START
   開始修膠墊，接著按下”啟動”
   OFF：Stop trimming the anvil and press START
   停止修膠墊，接著按下”啟動”

4. ANVILGAP模切間隙 — Adjust the gap to let the cardboard go through. 調整間隙讓紙張通過。
   ＋：Increase the gap加大間隙.
   －：Decrease the gap.縮小間隙

5. PULL COLLAR GAP咬紙輪間隙
   ＋： Enlarge the gap for thick cardboard.加大厚紙板間隙
   －： Decrease the gap for thin cardboard.縮小薄紙板間隙

6. PULL COLLAR咬紙輪 —Adjust the pull collar position.調整咬紙輪位置。
   ←D.S.驅動側➔: To move driver side pull ring position. 驅動側咬紙輪左右移動
   ←O.S.操作側 ➔:To move operator side pull ring position.操作側咬紙輪左右移動



7. REGISTER模切相位
   Set the knob to MANU mode, and press FWD or REV to move the die cut register. If set to AUTO, it will be controlled by the computer.
   將旋鈕轉至”手動”可以按壓按鈕移動相位”前進”或”後退”。
   轉至”自動”由電腦控制。

Die Cutter Unit 模切單元
Back Panel Function 後側面板說明

1. CUTTER CYLINDER刀模輪
   Rotate the register by REV/FWD button.可以按壓按鈕移動相位”前進”或”後退”。

2. JOG寸動
   Slowly rotate DIE CUT units.微轉動刀模輪。

3. STOP停止
   Under the emergency status, when press this button, only stop the die cut unit running.緊急狀況時，按下此鈕，可使模切部緊急停止。

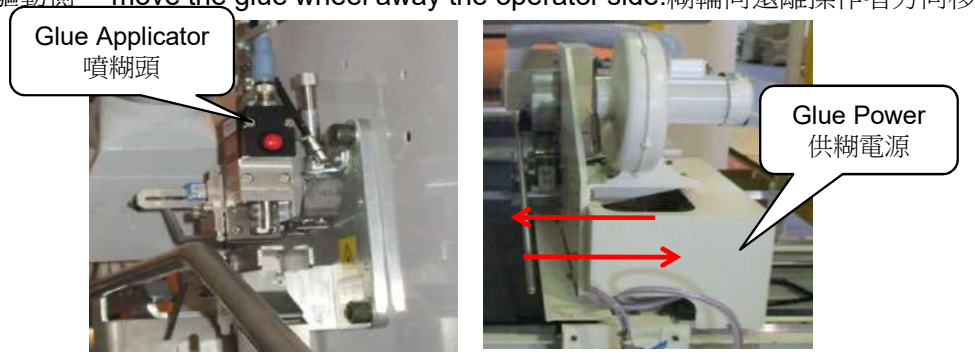
4. EMERGENCY主機停止
   Refer to safeguarding instruction in general information.當發生緊急狀況時，按下此鈕，可使機器緊急停止，但使用緊急停止按鈕，會導致機器完全關閉。

Folding & Gluing Unit 糊合部
Panel Function面板功能

1. EMERGENCY STOP警急停止—see safeguarding請參 考本冊開頭安全介紹。
2. STRIPPER BLOWER去屑風車— Wind Scraper power switch去屑風車電源開關。
   ON開 :Activate the wind scraper.去屑風車起動
   OFF關:Stop the wind scraper.去屑風車關閉

Folding & Gluing Unit 糊合部
Panel Function 面板功能

3. GLUE POSITION噴糊站— Control the glue wheel left & right lateral moving控制糊輪左右橫移
   O.S.操作側— move the glue wheel to operator side.糊輪向操作者方向移動。
   D.S.驅動側— move the glue wheel away the operator side.糊輪向遠離操作者方向移動。



4. GLUE POWER供糊電源: Pump power switch供糊幫浦 電源開關。
   ON開 :Activate the glue pump to start glue supply.糊幫浦起動。
   OFF關:Stop the glue pump.糊幫浦關閉。

5. D.S.GUIDE驅動側折翼— Lateral guide move toward to driving side橫移折翼到驅動側。

6. O.S. GUIDE操作側折翼— Lateral guide move toward to operating side橫移折翼到驅動側。橫移折翼到操作側。

D.S. GUIDE　　O.S. GUIDE

Ejector 出紙部 - Panel Function面板功能

1. EMERGENCY STOP警急停止— Refer safety instruction請參考本冊開頭安全介紹。

2. JOG寸動—Slowly move the folding belts when press one time.每次按下寸動鈕將微轉動一次折紙皮帶。

3. BELT SUCTION折翼風車— To turn ON/OFF the belt suction.
將折翼風車開動或停止。

4. BLOWER ON/OFF風車風門 — To turn ON or OFF the power of blower.開動或停止風車風門運轉。

5. BLOWER FLOW CONTROL風量控制— Turn the knobs clockwise / counter clockwise to adjust the blowing quantity of the blower.以順時針或反時針方向轉動按鈕來調整風量。

6. AIR OUTLET吹風出口— To open or close the leaf of 3 sections air throttles to press the folded box down by wind.將壓紙風車的三道風門打開或關閉以將折迭好的箱紙往下壓。
ON— Open the leaf, air blowing down.將風門打開使風往下壓。
OFF— Close the leaf to block air blowing.將風門打關閉以停止風往下壓。

Counter 計數部 - Panel Function 面板功能

1. RESET機械複歸 —Set the movement of stacking, counting, ejecting back to original datum point. When power is ON or after serious jam, the movement cycle is not finish or stop half way, use this function to set back. 將堆疊，計數及出紙的動作回到原先的設定點。當開機時或嚴重卡紙時，又或操作過程還未完成及中途停止。可使用該複歸按來還原原先設定。

2. UPPER CONVEYOR紙迭排出壓紙桿— Adjust the level of pressing rollers UP/ DOWN.調整壓紙桿上下位置。

3. LATERAL ADJ計數部橫移—Lateral move the COUNTER EJECTOR unit toward to Operator Side or Driver Side.將計數排出移動到操作側或驅動側。

4. FEED送紙—controls the feeding mode控制送紙模式

- STOP停止—Stop feeding停止送紙。
- CONTINUE連續— Continue Feeding，(Producing)連續送紙Continue Feeding，(Producing)
- SKIP隔紙—Feed one board when the print cylinder rotate twice. (The dimension of board is over the standard range in CONTINUE Mode）當印刷輪轉動兩次便送出一紙板。
  (而紙板大小會超出連續模式的標準範圍)
- SINGLE單次— Feed one board then stop feeding.送紙部送出一張紙板便停止運轉。

Counter 計數部 - Panel Function面板功能

5 . MAIN SPEED主機速度— Adjust the machine speed at FEED unit.調整送紙單元送紙速度。

- ＋ increases the speed of the main motor. 增加主機運轉速度。
- － decreases the speed of the main motor. 降低主機運轉速度。

6. MAIN MOTOR主機啟動— Control the power of COUNTER EJECTOR when this unit is OFF LINE.當計數排出部在離線時,此功能可控制計數排出動力。

- STOP停止—Stop motor of COUNTER EJECTOR unit.將計數排出部馬達停止運轉。
- START啟動—Start motor of COUNTER EJECTOR unit.將計數排出部馬達啟動運轉。

7. EMERGENCY / BUZZER 警急停止：see safeguarding請參考本冊開頭安全介紹。

8. REGISTER ADJ.相位調整— Adjust the register of the Print unit, Slot Unit and Die Cut unit.調整印刷，開槽及模切相位。

PRINTER印刷— The register of each color will be adjusted at the same time by FWD. or REV. button.每種顏色的相位可由前進或後退來控制。

1 P第一色— The register of 1st color will be adjusted by FWD. or REV. button.第一色可由前進或後退按鈕來控制。

2 P第二色— The register of 2nd color will be adjusted by FWD. or REV. button. 第二色可由前進或後退按鈕來控制。

3 P第三色— The register of 3rd color will be adjusted by FWD. or REV. button.第三色可由前進或後退按鈕來控制。

4P第四色— The register of 3rd color will be adjusted by FWD. or REV. button.第四色可由前進或後退按鈕來控制。

Counter 計數部 - Panel Function面板功能

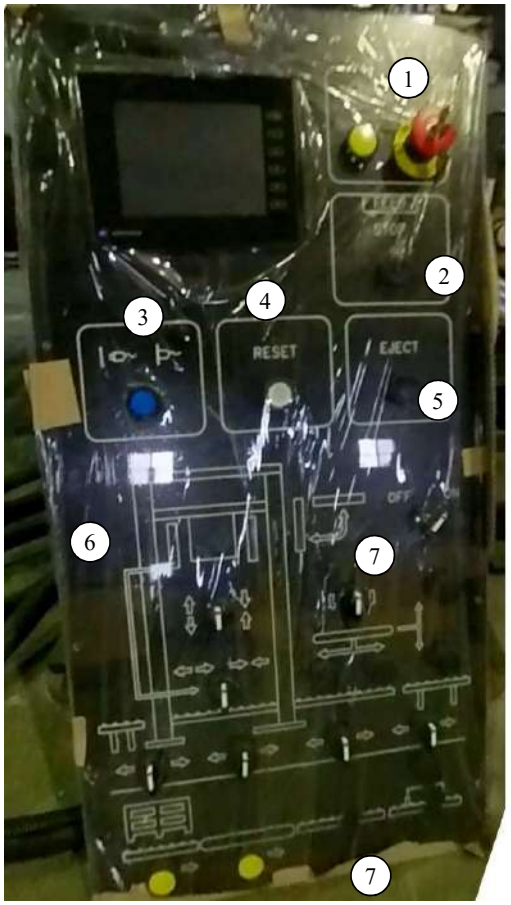
9. SLOTTER開槽—The register of slotting knives will be adjusted by FWD. or REV. button.開槽刀相位可由”前進”或“後退”按鈕來調整.
BOX DEPTH紙箱高度— Increase the box height by＋ button, reduce the box height by－button. 按” ＋”按鈕增加紙箱高度 ；按” －”按鈕減少紙箱高度

10. DIE CUT模切 — The register of die cut will be adjusted by FWD. or REV.模切相位可由前進或後退按鈕來調整。

11. GAP ADJ.間隙調整— Adjust the gap of the SLOT Unit and DIE CUT unit.調整開槽及模切間隙。
PRECREASER破壞輪— Increase the pre-creaser gap by＋ button, reduce the pre-creaser gap by－ button.按” ＋”按鈕增加破壞輪間隙；按” －”按鈕減少破壞輪間隙。
TRAILING CUTTER開槽後刀— Increase the trailing gap by＋ button, reduce the trailing gap by－ button.按” ＋”按鈕增加後刀間隙；按” －”按鈕減少後刀間隙。
CREASER壓線輪— Increase the creaser gap by＋ button, reduce the creaser gap by－ button按” ＋”按鈕增加壓線輪間隙；按” －”按鈕減少壓線輪間隙。
LEADING CUTTER開槽前刀—Increase the leading gap by＋ button, reduce the leading gap by按” ＋”按鈕增加開槽咬紙輪間隙；按” －”按鈕減少開槽咬紙輪間隙。
DIE CUT PULLROLL 模切咬紙輪—Increase the pull roll gap by＋ button, reduce the gap by－ button. 按” ＋”按鈕增加前刀間隙；按” －”按鈕減少前刀間隙。
DIE CUT ANVIL模切膠墊—Increase the anvil gap by＋ button, reduce the anvil cap by－ button. 按” ＋”按鈕增加前刀間隙；按” －”按鈕減少前刀間隙。

12. BOTTOM BELT SPEED COMPENSATION差速補償— To rectify the “fish tail” by increase (＋) or decrease (－) the belt speed at Operator Side or Driver Side. 按 “＋”或“－“來調整操作側或驅動側的皮帶速度差異。

STKC 積下機 - Function面板功能



1. EMERGENCY警急停止— Refer to safeguarding instruction in general information.
   BUZZER警鈴— Refer to safeguarding instruction in general information.

2. FEED STOP 送紙— Stop feeding 停止送紙

3. ONLINE & OFFLINE 連線&離線— Only switch offline during maintenance
   只有維修時切換離線

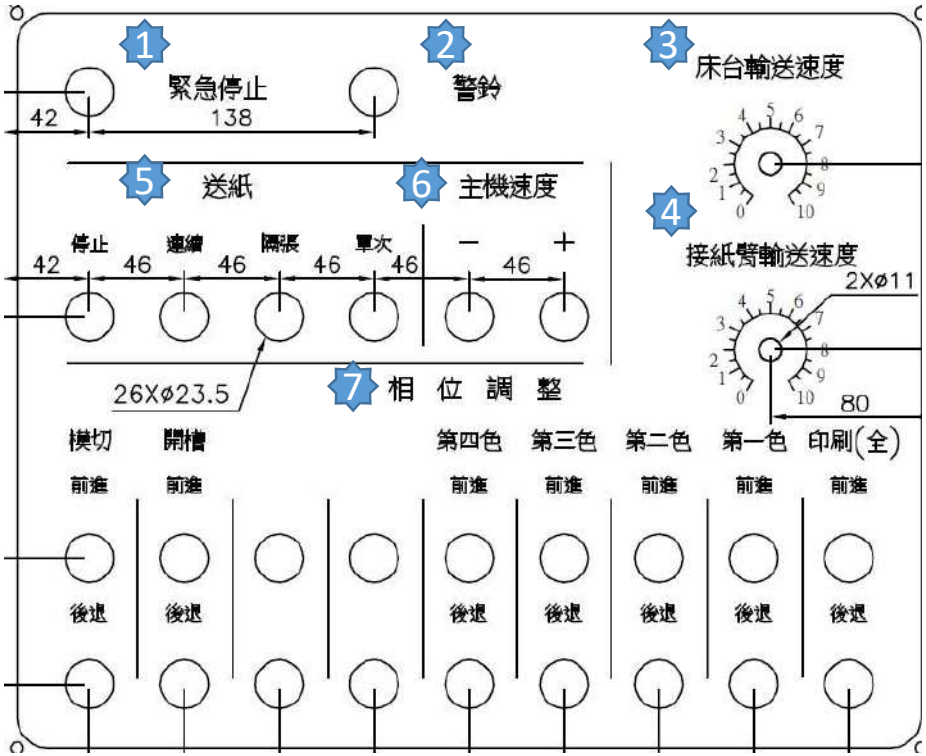
4. RESET機械複歸—Set the movement of stacking back to original datum point. When power is ON or after serious jam, the movement cycle is not finish or stop half way, use this function to set back. 將堆疊動作回到原先的設定點。當開機時或嚴重卡紙時，又或操作過程還未完成及中途停止。可使用該複歸按來還原原先設定

5. Eject 堆疊排出 — pasteboard 排出

6. Institutional movement 機構上下左右移動— Move the position manually 手動移動位置

7. plank conveyor move 輸送機移動— Move the position manually 手動移動位置

STK 面版功能



1. EMERGENCY警急停止— Refer to safeguarding instruction in general information.

2. BUZZER警鈴— Refer to safeguarding instruction in general information.

3. 床台輸送速度 — 0~10段VR旋鈕調整床台皮帶速度

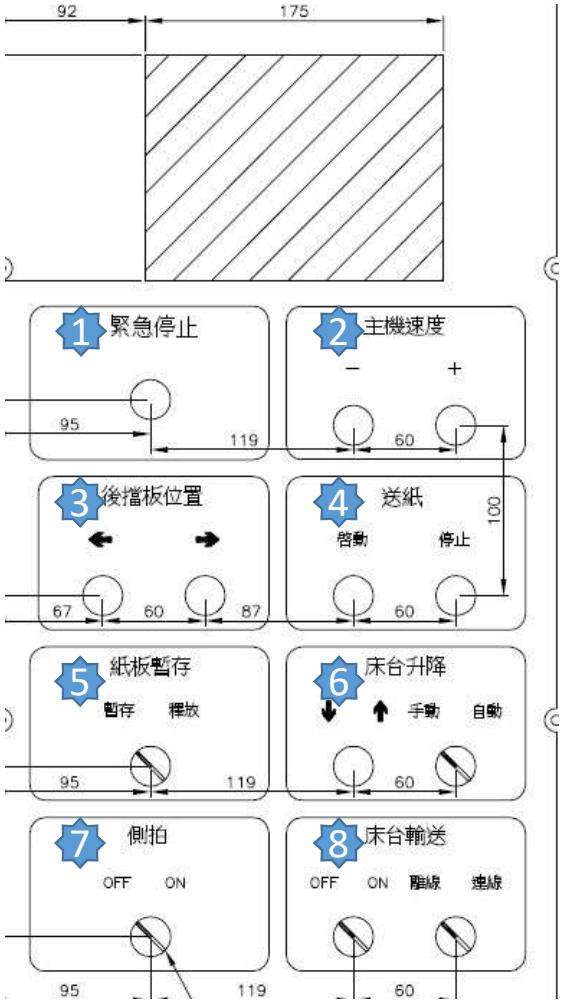
4. 接紙臂輸送速度 — 0~10段VR旋鈕調整接紙臂皮帶速度

5. 送紙 — 1.停止送紙按鈕 2.連續送紙按鈕 3. 隔張送紙按鈕 4. 單張送紙按鈕

6. 主機速度 — 印刷機加速(+) 印刷機減速(-)

7. 相位調整 — 手動調整相位前進後退
a) 一到四色相位前進後退按鈕
b) 開槽相位前進後退按鈕
c) 模切相位前進後腿按鈕
d) 印刷(全) 同時動作全部印刷相位前進後退按鈕

STK 面版功能



1. EMERGENCY警急停止— Refer to safeguarding instruction in general information.

2.主機速度 — 印刷機加速(+) & 印刷機減速(-)

3.後檔板位置 — 前後方向吋動

4.送紙 — 啟動連續送紙 & 停止送紙

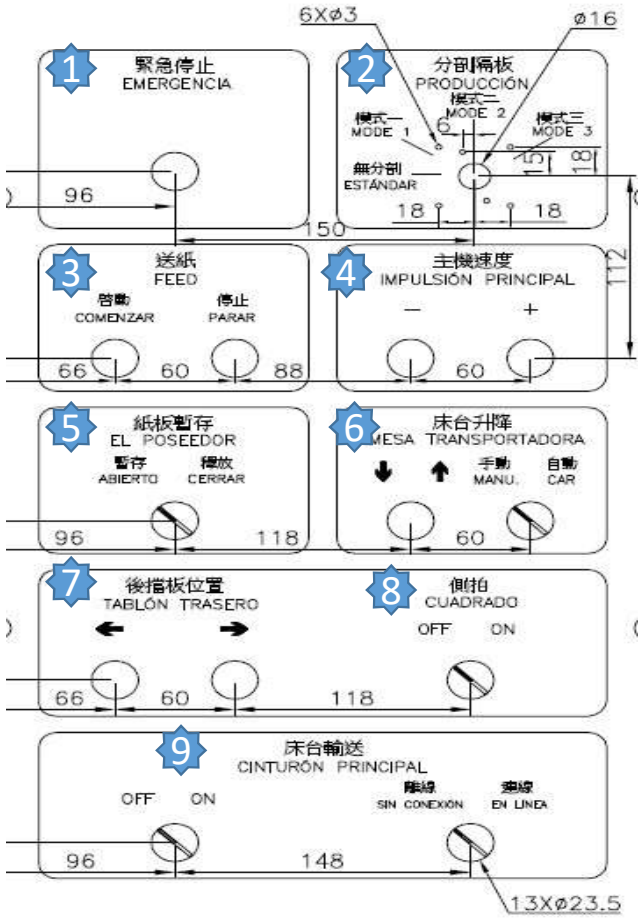
5. 紙板暫存 — 切換暫存版汽缸狀態1.暫存位置 2.釋放位置

6. 床台升降 — 選擇手動模式並切換↑↓旋鈕可手動控制床台升降、自動模式則依照程式控制自動上升

7.側拍 — OFF為不使用停在預設位、ON則透過程式控制持續拍打整紙

8.床台輸送 — OFF為不使用、ON為使用中，選擇離線在ON狀態時持續運轉，連線狀態則由程式控制床台輸送時積點

VTK 面版功能



1. EMERGENCY警急停止— Refer to safeguarding instruction in general information.

2. 分剖隔板 — 選擇分剖模式

3. 送紙 — 啟動連續送紙 & 停止送紙

4. 主機速度 — 印刷機加速(+) & 印刷機減速(-)

5. 紙板暫存 — 切換暫存版汽缸狀態1.暫存位置 2.釋放位置

6. 床台升降 — 選擇手動模式並切換↑↓旋鈕可手動控制床台升降、自動模式則依照程式控制自動上升

7. 後檔板位置 — 前後方向吋動

8. 側拍 — OFF為不使用停在預設位、ON則透過程式控制持續拍打整紙

9. 床台輸送 — OFF為不使用、ON為使用中，選擇離線在ON狀態時持續運轉，連線狀態則由程式控制床台輸送時積點