

Weldo 3D scanning intelligent wax set machine manual



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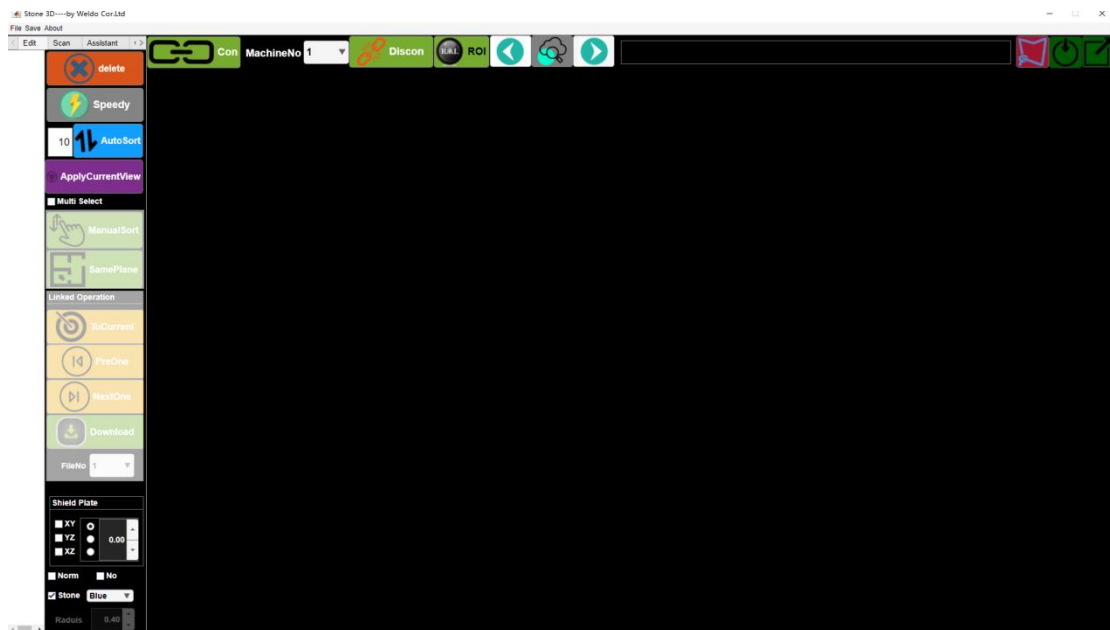
一、 brief introduction

This product is a 3D scanning intelligent wax set machine based on visual detection. Through the 3D camera and the algorithm, the offline programming is realized to automatically set diamonds (gems) on the wax mold.

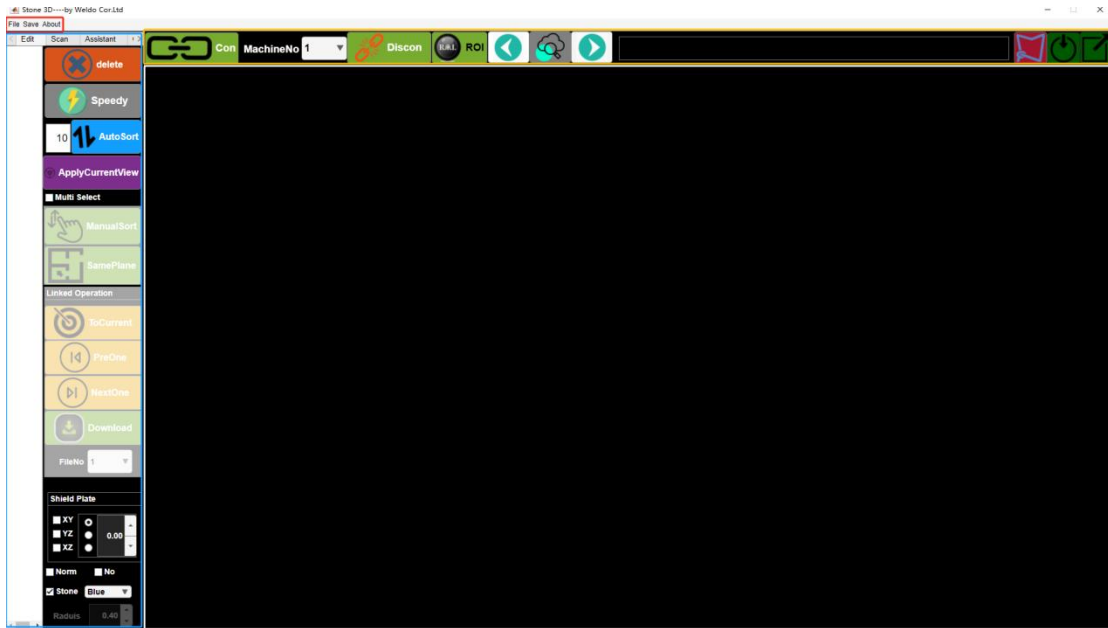
二、 Introduction to the software operation panel

D3DToolkit System is dimension automation independent research and development with machine stone software, the article detailed programming software operation interface, the purpose for users have the overall deep understanding of programming software, for users to master the use of programming software methods and skills, save path programming and parameter setting time, improve the efficiency of production.

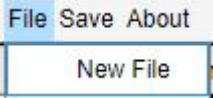
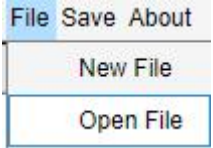
Open D3DToolkit. The default page is Edit File. The page is as follows:

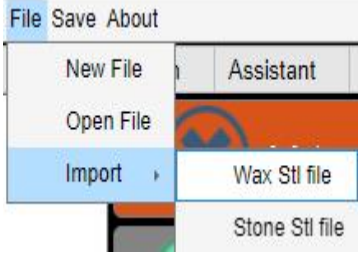

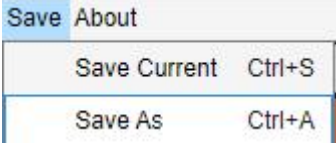



The red box is the software property bar, the orange box is the auxiliary toolbar, the blue box is the operation interface bar, and the white box is the image display bar.




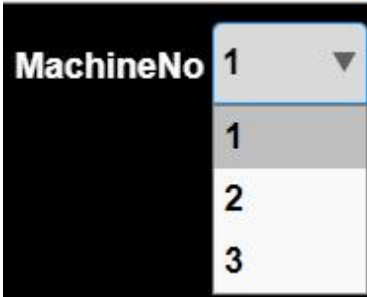

1. Software property bar


Function name	function	picture	remarks
File options			
New File	Generate an interface without drill data based on the current point cloud		Cannot generate a blank interface with a little cloud data
Open File	Empty the current point cloud and drill data, and enter the point cloud and drill interface of the selected file		Can only open.mat document

<p>Import</p>	<p>Empty the current point cloud and drill data and generate the point cloud and drill interface based on the imported stl files</p>		<p>Import the empty mold file and the drill file respectively, which can only be imported.stl document</p>
<p>save options</p>			
<p>Save Current</p>	<p>Save the point cloud and drill data across the current interface in the currently open file</p>		<p>Unable to save without the current file</p>
<p>Save As</p>	<p>Additional files will exist throughout the current interface</p>		<p>If the saved file name is not available, a file save for that name is generated</p>
<p>About the option</p>			
<p>English</p>	<p>The switch interface is in English</p>		<p>The key changes to Chinese after switching</p>

Ver.1.0.1	Current version number		Change with version
upgrade	Upgrade the software version		

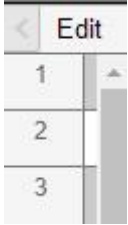
2. Auxiliary toolbar





Function name	function	picture	remarks
Con	The computer is connected to the machine corresponding to the machine number		Each icon of the interface bar will be highlighted from gray. If the connection failure occurs, the common problem is the solution
MachineNo	Select the machine number for the current connection		Select the machine number to open and save the file will also correspond to the configured folder
Discon	Disconnect the current connection from		This feature is only required to unplug the




	the camera		camera
Information prompt box	Displays current information, working status or point data		
Select tools			
Rope tool	A straight line segment is generated based on the position of the two clicks, and a polygon is generated when the number of clicks is greater than three		Click to turn green, press esc to exit, and right-click to cancel the previous point
Reserve tool	Retain the point cloud image selected using the Rope tool frame		
Culling tool	Deletes the point cloud image selected by the frame with the rope tool		




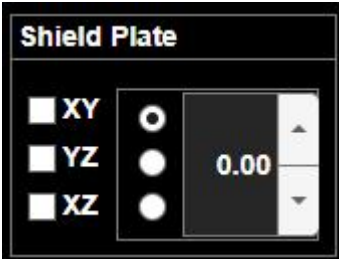

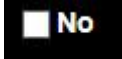

ROI setting	Set the image processed by the selection tool to the image of interest		Used with fusion scanning
Check out the tools in detail			
Detailed view	View the location of the current drill in detail based on the normal view of the current drill and hide other locations		Click it into the grey bottom green ring icon
Observe the last point	Jump to the normal view of the last drill to view the details		
Observe the next point	Jump to the normal view of the next drill		




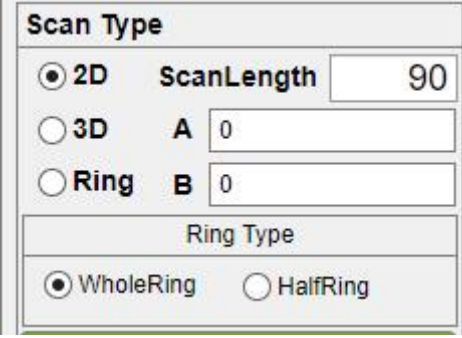
3. Operation interface bar

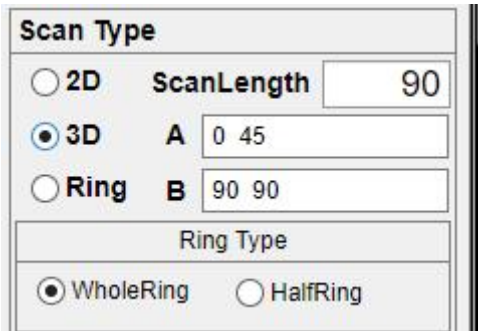
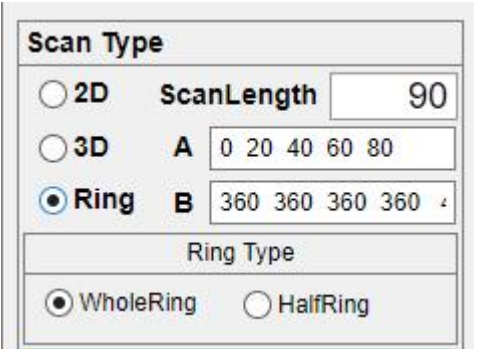
Edit the interface			
Function name	function	picture	remarks
Edit	Select the drill and view the drill location		

Delete	Delete the currently selected drill		Can not delete the delete on the usable keyboard
Speedy	Performance mode switching		The drill size in the gray bottom state is smaller and the operation is faster, and the green bottom state is larger and the position is clearer
AutoSort	Automatic sorting based on the set angle		The larger the Angle, the greater the motion range of the A axis and the more compact the point when the b axis runs
ApplyCurrent View	Set the current view to the primary view		Pressing "1" will bring you back to this view



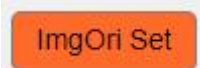

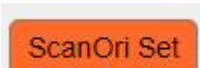

ManuaSorted	Manually order the drill		<p>First select the initial drill number you want to start sorting, then select the drill sequence in the mouse button, click the selected drill in order, you can continue to row down or press esc to exit</p>
SamePlane	Set the selected drill angle as consistent		<p>Set the average and ensure that the selected drills are in the same plane before use</p>
ToCurrent	Bring the Z 1 to the selected drill location		<p>Requia connection to use</p>

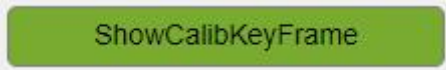



Preone	Bring the Z1 to the location of a drill number before the selected drill		Requia connection to use
Nextone	The Z1 reaches the position of a drill number after the selected drill		Requia connection to use
Download	Download the current drill data to the reference number file		Requia connection to use
ShieldPlate	Three occlusion boards of three different locations are shown		Can adjust the position of each plate, block the back, convenient drawing drill
Norm	Display the normal direction		
No	Display serial number		
Stone	Show the		




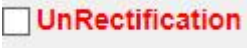
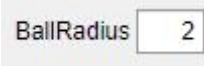
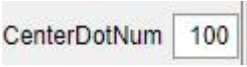
	diamonds and adjust the diamond color		
Raduis	Adjust the drilling radius		Cannot adjust in performance mode
Scan the interface bar			
KeyFrame	Scan an image with the initial pose as the base map		Be sure to do this first before the fusion scan
Fusion Scan	Scan the product from multiple angles and merge the images based on the scan type and roi		The Roi setting function is used with fusion scanning
Scan Type	The plane mode is scanned by plane angle		The B axis data is the interval angle, and the number of sweeps is 360. After setting the parameters,

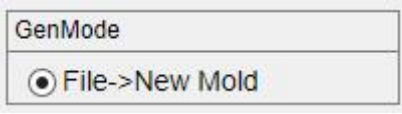
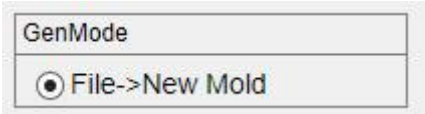



			click the fusion scan for sampling
Scan Type	The stereo mode is scanned by stereo and multi-angle mode		The data of axis A and B is one by one, separated by space, and groups can be added by yourself. The data of axis A is A fixed Angle. After setting the parameters, click fusion scan for sampling
Scan Type	The circular mode was scanned from multiple angles		As the stereo scan type is roughly the same, the whole ring scan and half ring scan can be selected according to the product,







			and the fusion scan can be clicked for sampling
AI Mode	Used before scanning to calibrate image zero and ensure image accuracy		Click and it turns red. Use the four arrow keys to adjust the image so that the red rice icon is in the center of the hole in the upper left corner of the image. Enable this function at all times after removing and inserting the camera
Filter	Remove the scatter, and clear the images		The adjustment parameter can adjust the removal amplitude, and the



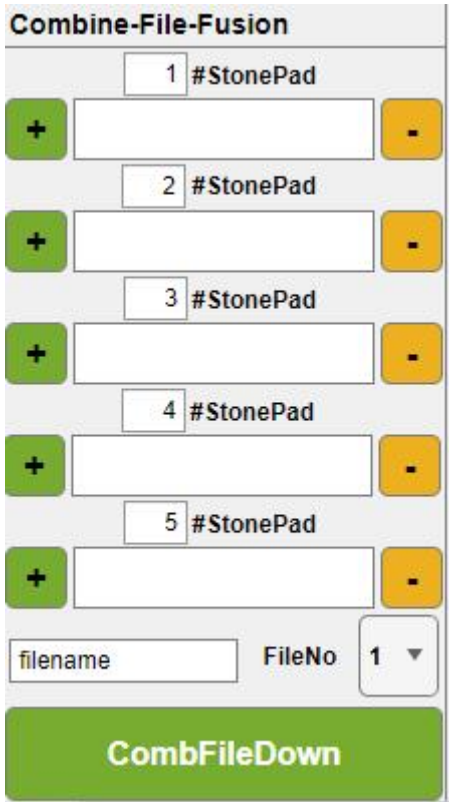

			<p>cancellation</p> <p>filter will</p> <p>return to the</p> <p>initial state</p>
Set enabling			
PinOri Set	Set the needle zero	<input checked="" type="checkbox"/> Enable Setting 	Not use unless re-calibration
Mov2PinOri	Z 1 reaches the needle zero-point position		The default is on the central surface of the hole in the upper left corner of the calibration block
ImgOri Set	Set the figure zero		Not use unless re-calibration
ShowImgOri	Displays the zero-point position of Fig		The default is at the center point of the upper left corner of the calibration fast hole
ScanOri Set	Set the scan zero		Not use unless re-calibration
Mov2ScanOri	Return to the scan zero position		


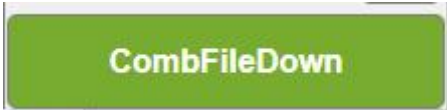
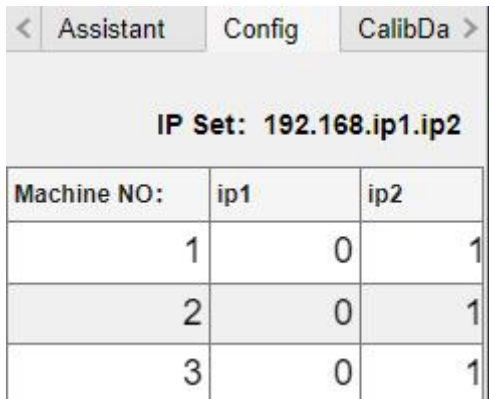
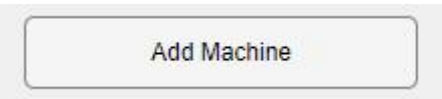
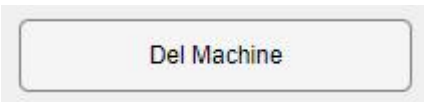

<p>ShowCalib KeyFrame</p>	<p>Displays the keyframe image at factory calibration</p>		<p>Adjust the zero point of the diagram to be adjusted in this diagram</p>
<p>TestAngle</p>	<p>To reach the point according to the set data</p>		<p>The first number is the a-axis angle, the second number is the b-axis angle, to the selected point is the locking point</p>
<p>Calibration enables</p>			
<p>OneKeyCalib</p>	<p>The following three calibrations are made with one click</p>		<p>The calibration operation is not required unless the collision or camera position change of each axis</p>
<p>ImgFusionCalib</p>	<p>Image fusion calibration</p>		<p>ditto</p>

	was performed		
ImageCalib	Conduct the image plane calibration		ditto
Calibr Scan	Conduct the image mechanical calibration		ditto
Calib	Deviation was calculated for the calibration results		ditto
UnReOctification	The scanned image after checking is the initial uncalibrated image		ditto
Ballradius	Set the calibration ball size		ditto
CenterDotNum	Set the number of calibration calculation points		ditto
Assistant interface bar			

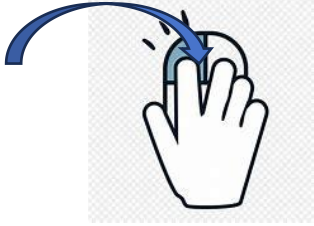

GenMode	The programmed file is assigned to the new mold		The selected drill file needs to be the drill file with data in the drill list
GenMode	The diamond-set file is scanned and fitted to the new mold		The scanned document should be sprayed onto the finished product with white spray to prevent reflection
Mold	The diamond-set file is scanned and equipped with a new mold		Scanning documents must be sprayed on the finished product with a white spray to prevent light reflection
Sone	Select the swept and saved drill less file		
PairStone	Match the drill of the		Select the wax mold position

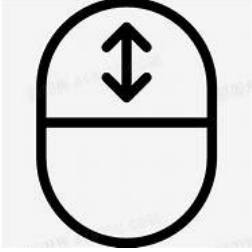
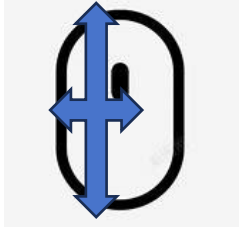
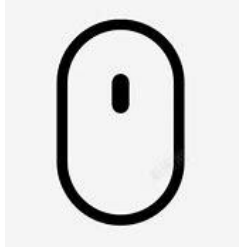

	selected drill die file to the empty die file		by using the rope tool box before use
PairedShow Edit	Register the empty-mode green image to the red image		
1	Set the distance or angle to move once		Adjust for all buttons below at a maximum of 90
Translational regulation	Move in parallel based on the RZ perspective after pressing		
altitude mixture control	Move up and down based on the RY perspective after pressing		
RZ rotation regulation	Rotate and move based on the RZ perspective after pressing		
RY rotation regulation	Rotate and move based		

	on the RY perspective after pressing		
RX rotation regulation	Rotate and move based on the RX perspective after pressing		
Shrinkage	Adjust the shrinkage rate of the design document and the actual wax mold		
Combine-File -Fusion	Ffuse files of multiple models into one file		Select the file with a plus sign, and subtract it to clear the file. Each file drill plate number can be adjusted
Filename	Download the file name to		Files are not being





	the display device		generated on the computer
FileNo	Download the file number to the display device		The maximum is 5
CombFileDown	Download the files that adjust the parameters to the monitor		
Configure the interface bar			
Config	Displays the associated machine and the corresponding ip		
Add Machine	Add the machine to the current camera list		
Del Machine	Delete the list of machines		Must be selected before deleting
Update List	Updated to use after you		


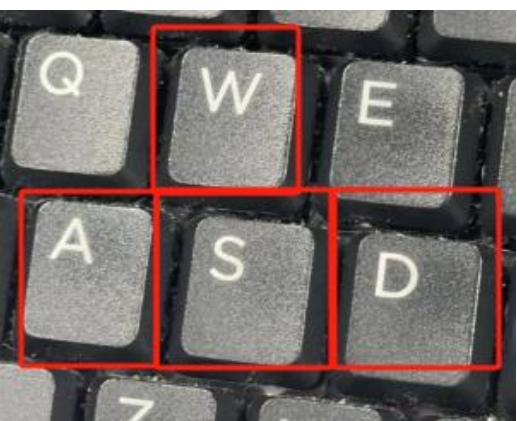
	add or delete														
Calibration data interface bar															
Load	Load the calibration image of the current machine		Displays the calibration data stored by the current machine												
Calibrate the list of data	Displays coordinate data	<table border="1" data-bbox="687 645 1150 831"> <thead> <tr> <th>x</th> <th>y</th> <th>z</th> </tr> </thead> <tbody> <tr> <td>19.8137</td> <td>-0.9365</td> <td>15.24</td> </tr> <tr> <td>13.3649</td> <td>-14.6657</td> <td>15.24</td> </tr> <tr> <td>0.0250</td> <td>10.8121</td> <td>15.25</td> </tr> </tbody> </table>	x	y	z	19.8137	-0.9365	15.24	13.3649	-14.6657	15.24	0.0250	10.8121	15.25	
x	y	z													
19.8137	-0.9365	15.24													
13.3649	-14.6657	15.24													
0.0250	10.8121	15.25													
Go this point	To the calibration coordinate point		Need to place the table calibration fast												
Image display interface															
Left-click	Choose the point		The red cross icon appears												
Left- double click	Double-click the position to automatically find the vertex of the column to generate a drill		Based on the double-click position, find surrounding pillars, automatically draw points, and generate drill holes.												

<p>Click the left mouse button Down and down</p>	<p>Around the point</p>		<p>The red cross icon appears</p>
<p>leave a blank space</p>	<p>Lock the currently selected point</p>		<p>The large red meter word icon appears on the scanning screen, indicating that the function will come to this point. The cross icon with red dot in the middle appears in the editing interface. When the drill is generated, it is generated according to the cross icon with red dot.</p>

<p>The mouse key rolls</p>	<p>Zoom in and zoom in based on the current perspective</p>		
<p>The mouse key Press and drag</p>	<p>image spacing</p>		
<p>Click on the mouse</p>	<p>Select the current drill</p>		<p>The yellow meter icon in the center of the drill represents the selection of the current drill and automatically selects the nearest drill.</p>
<p>Right-click</p>	<p>A. Drating drill based on locked points B. Click where selects the drill and shifts the view to the normal view of the drill</p>		<p>Only locked points can generate the drill, requiring a lock and select. The nearest drill is automatically selected</p>

<p>Master Keyboard Digital 1</p>	<p>Switch to top view (from top)</p>		<p>Facing the perspective is the most commonly used</p>
<p>Master Keyboard Digital 2</p>	<p>Switch to looking up perspective (from bottom up)</p>		
<p>Master Keyboard Digital 3</p>	<p>Switch to rear angle (from back)</p>		
<p>Master Keyboard Digital 4</p>	<p>View ch to front view (front and back)</p>		
<p>Master Keyboard Digital 5</p>	<p>Switch to left view (look from left to right)</p>		
<p>Master Keyboard Digital 6</p>	<p>Switch to right view (look from right to left)</p>		

less-than	View the previous point		
greater than	View the next point		
W	Move the drill up		Move based on the selected drill normal direction
S	Move the drill down		Move based on the selected drill normal direction

A	The drill moves to the left		Move based on the selected drill normal direction
D	The drill moves to the right		Move based on the selected drill normal direction

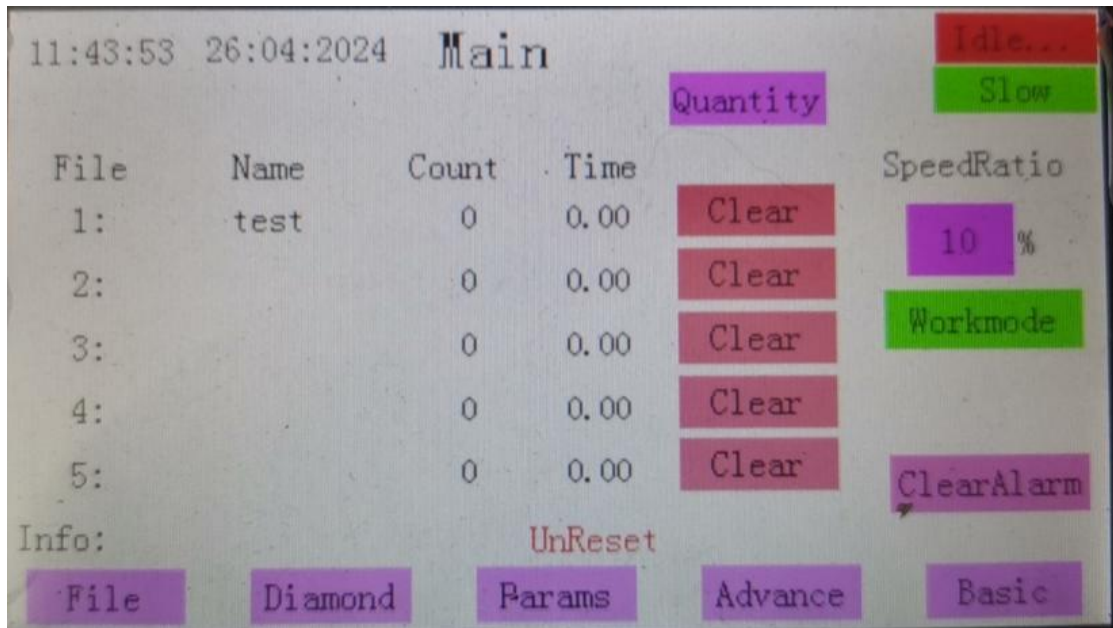
三、 Mechanical section of the machine introduction

name	function	picture	remarks
X axle	shuffling		From left to right (display # 1 + from left to right)
Y-axis (Y1-axis)	shuttle		From inside to outside is the positive direction (the instruction device # 2 + is from inside to outside)


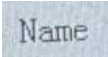
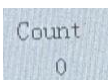
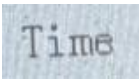
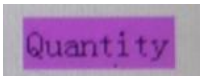
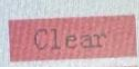
Z-axis (Z1 Z2 Z3 Z4)	reciprocate		From bottom up is the positive direction (display device # 3 + is from bottom up)
A axle	Turn inside and outside		Rising from the bottom to the positive direction (display # 4 + is outward upward)
B axle	Left and right rotation		Counterclockwise rotation (display # 5 + counterclockwise)
Drill Plate Shaft (Y2 axis)	shuttle		From inside to outside is the positive direction (the display instrument # 6 + is from inside to outside)
air switch	The whole machine on electricity		The push is the machine
decantor	The machine on the gas		Slide to the right is the machine ventilated, rotating the lid to adjust the air pressure
Clip platform	Fixed workpiece		Rotate the rod to clamp or loosen the workpiece
Take the drill platform	Fixed diamond version		Hold the drill plate through the block and magnet, default three drill boards namely drill number 1,2,3
Heating panel	Heat the diamond		Press the button to start the heating, which can display and set the heating temperature
vacuum generator	Make vacuum Inhale and breathe		Check the pressure vacuum to determine whether there is a


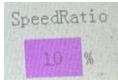
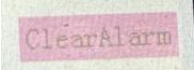
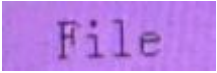
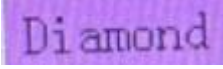
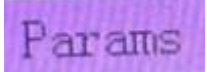
			drill
The suction mouth extends the rod	Connect the suction mouth		Adjust the suction nozzle position through the screw
suction nozzle	Drill drill		Release the screwscrew and replace the suction nozzle
signal lamp	State prompt		Red light alarm, green light always on work, green light flashing connection software
Quick controller	quick-operating		Start the file, return to the stop position, and make an emergency stop

四、Introduction to the handle section



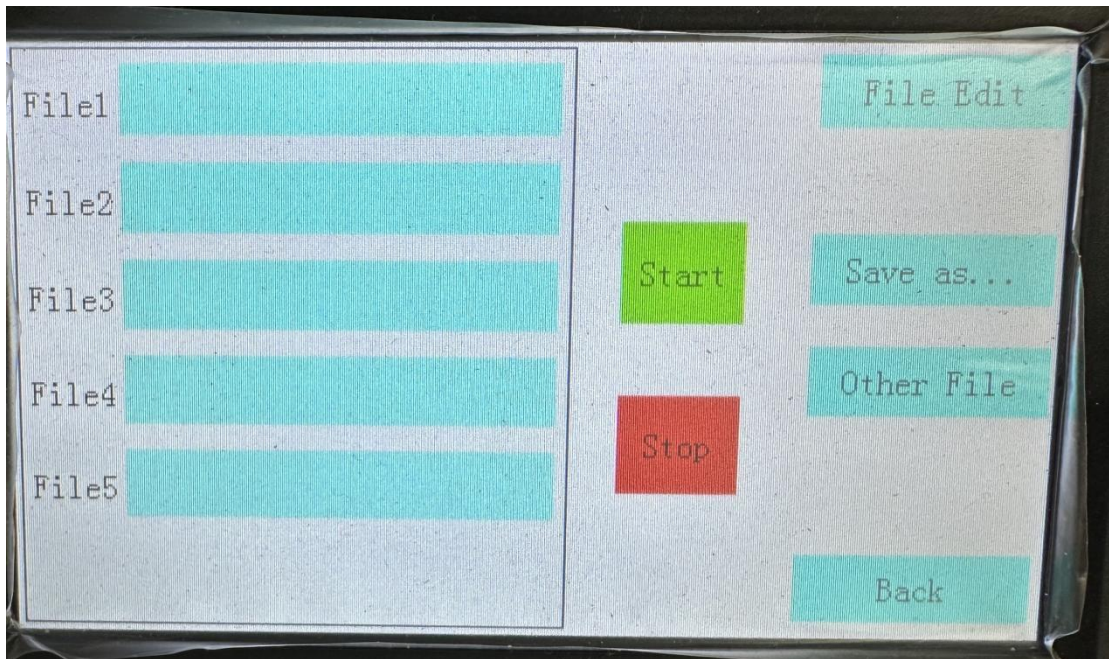
1. Main interface

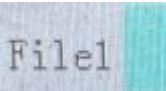


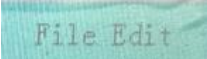
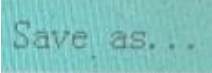
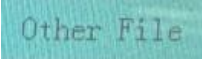
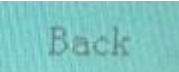
name	function	picture	remarks
file	Number of corresponding initiator file numbers		
name	The corresponding download file name		
count	Number of products currently produced		
time	Current production of a single product at time		
Quantity	Enter the diamond statistics		
Clear	Empty the current production data		

Idle	operative mode		
Slow	Displays the current speed gear position		
Speedratio	Adjust the processing rate		
Workmode	Show running mode		
ClearAarm	Clear the current alarm		
file	Enter the file management interface		
Diamond	Display the current alarm status		
params	Enter the drill board setting interface		
advance	Go to the global parameter interface		
Basic	Enter the Advanced Settings interface		

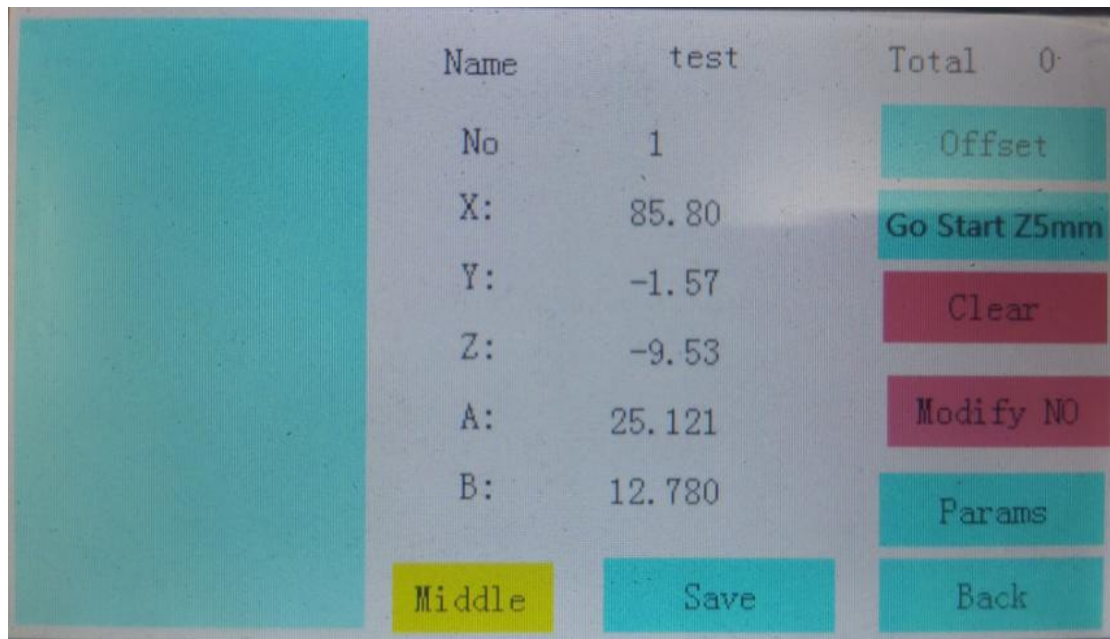
2. file management

(1) file management

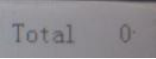
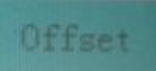
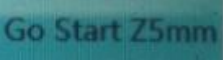
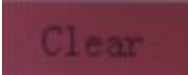
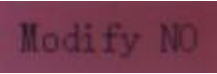

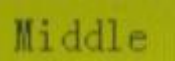
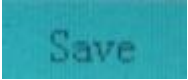



name	function	picture	remarks
File 1	Displays the file number and the file name		
Start	Start the selected file		
stop	to halt production		
file edit	Edit the selected file		
save as	Export the files selected in the file information list to the file repository		
Other files	Go into the file repository		
back	Return to the previous page		

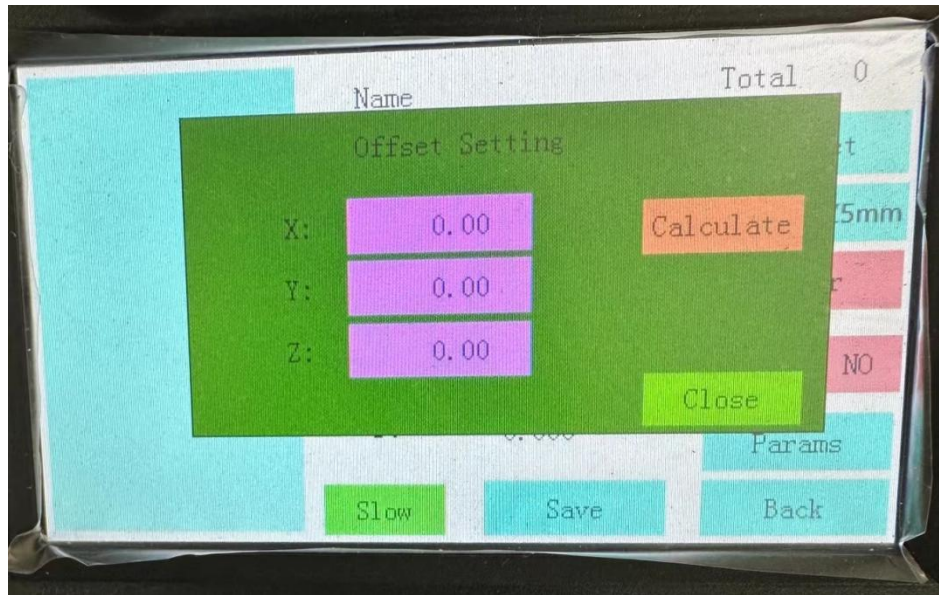
(2) file edit

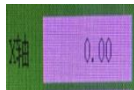

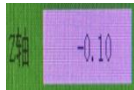
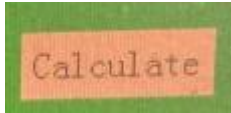
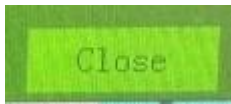


name	function	picture	remarks
No	Displays the drill position sort and drill size for the corresponding drill board number		
name	Displays the file name	Name test	
No	Show the drill board number	No 1	
X axle	Show X axis coordinates	X: 85.80	
Y axle	Y axis coordinates are shown	Y: -1.57	
Z axle	The Z axis coordinates are shown	Z: -9.53	
A axle	Show axis A coordinates	A: 25.121	
B axle	Show B axis coordinates	B: 12.780	

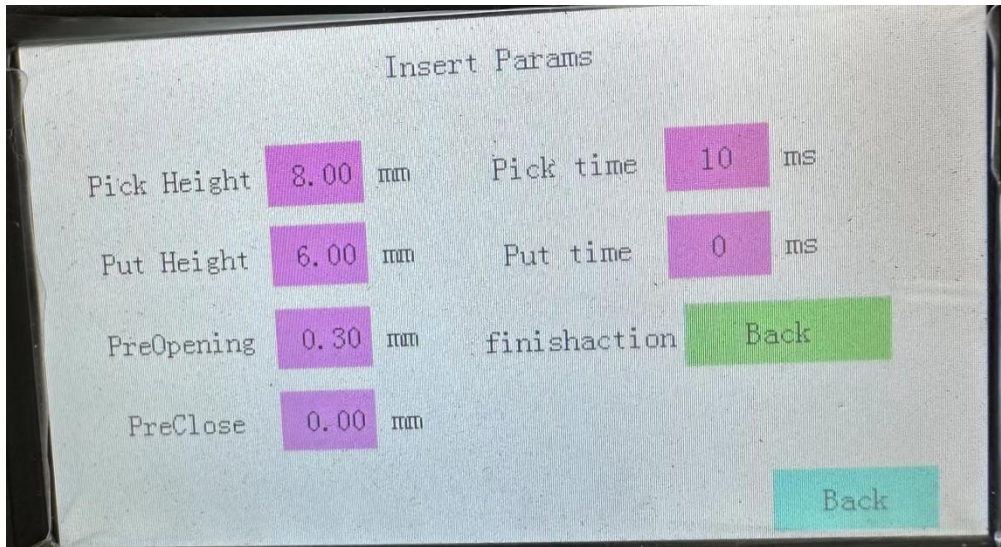
Total	Displays the total number of the current file points		
offset	Enter the position compensation interface		
Go start Z 5mm	The Z1 reaches about 5mm above the first point		
Clear	Empty the drill bit information for the current file		
modify No	Batch to modify the current file point drill number		
params	Enter the diamond set parameter interface		
middle	Displays the current speed		
Save	Save the changes to the file		
back	Save and return to the previous interface		

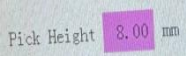
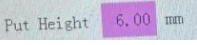
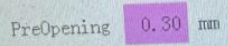
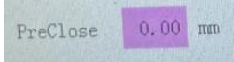
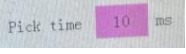

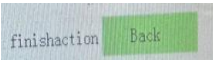
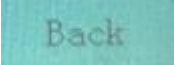
① offset setting



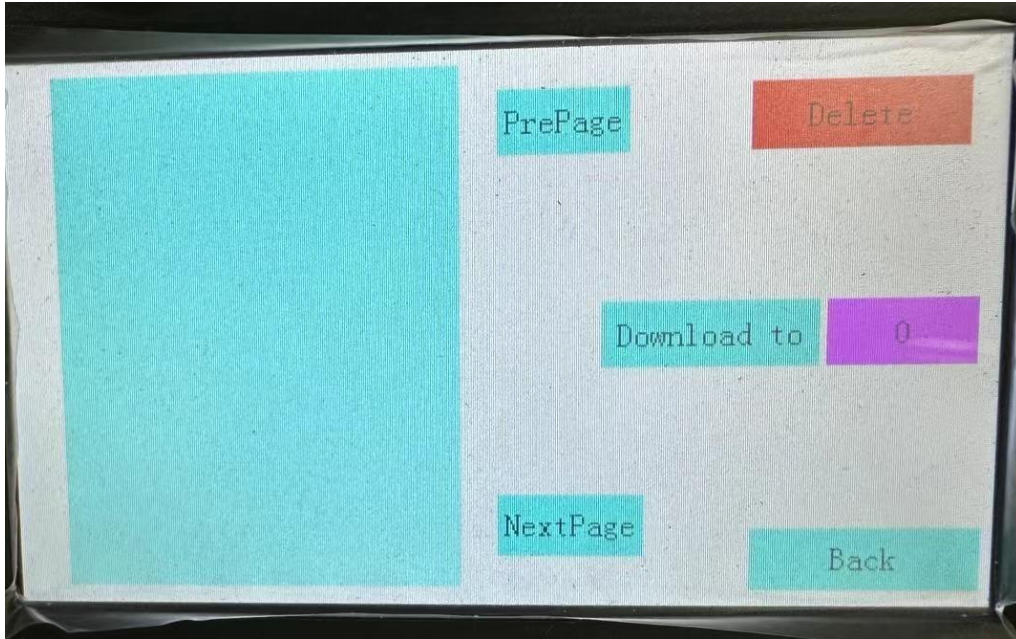
name	function	picture	remarks
X axle	The overall point position is offset in the x-axis direction		This parameter is generally not modified
Y axle	The overall point position is offset in the y-direction		This parameter is generally not modified
Z axle	The overall point position is offset in the z-direction		When the height is not uniform, the deepening is negative, and the opposite is positive
calculate	Automatically calculate the triaxial offset		Based on the adjustment of the first point, generally do not need to use
close	Close the position compensation interface		

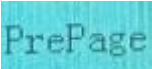

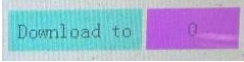
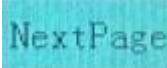
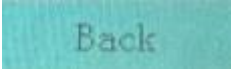
② Insert params



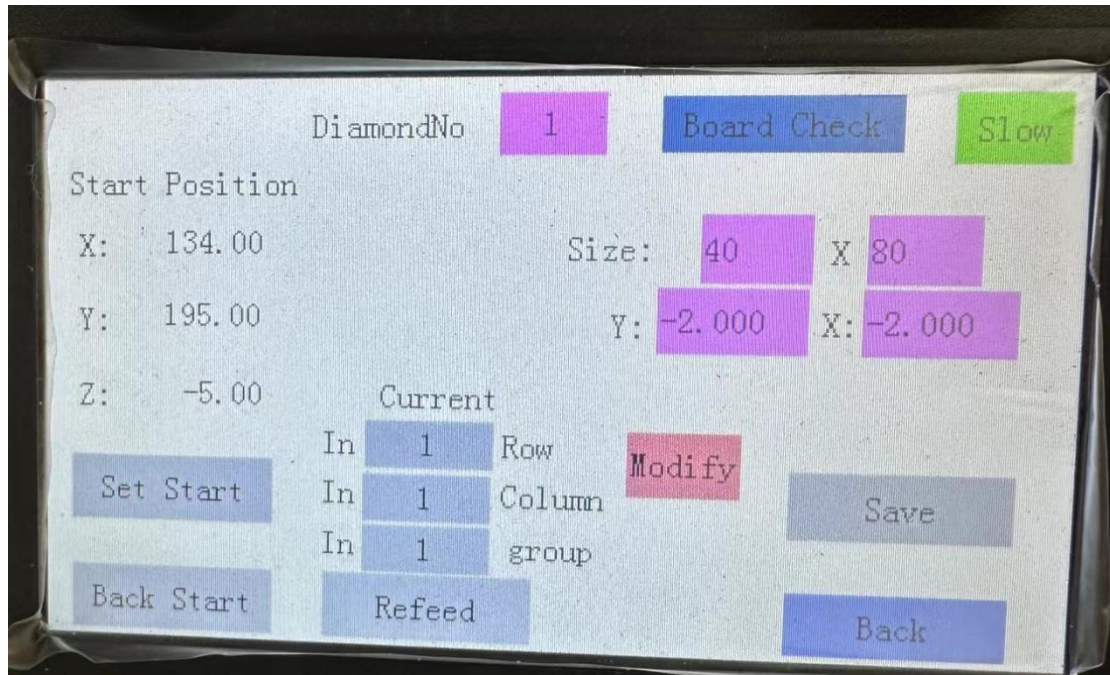
name	function	picture	remarks
Pick Height	Raise the specified distance before moving during production drilling		Setting it too low may cause a collision
Put Height	Raise the last nozzle and move from the next nozzle		Setting it too low may cause a collision
PreOpening	The nozzle starts inhaling at a specified distance above the drill		Too high of the set may lead to improper suction drilling
PreClose	The mouthpiece closes the suction at a specified distance above the hole position		Too high may lead to drilling instability
Pick time	Stay on the drill board for a specified time when drilling		Set too low may lead to the suction on the drilling
Put time	Stay in the hole position for a specified time when drilling		Set too low may lead to unstable drilling release
finishaction	Set the machine position after producing a product		
back	Save and return to the previous interface		

③ Other file

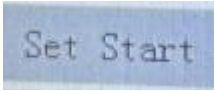
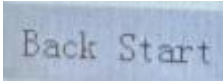
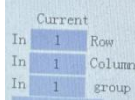
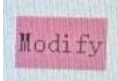
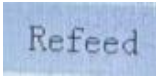

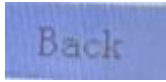


name	function	picture	remarks
	Display the stored file name		
prepage	Turn the page up		
deleted	Delete the selected file		
Download to	Download files from the file repository into five working files in the file management interface		0 corresponds to the outside of the 1 1 corresponds to the outside of the 2 and so on
next page	Turn down the page		
back	Return to the previous interface		

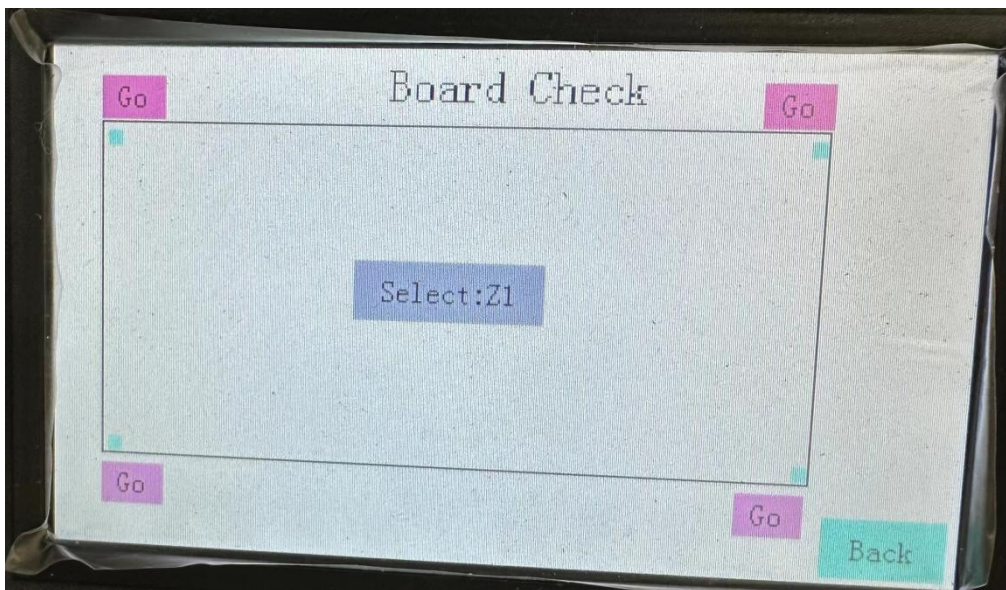
3. DiamondNo




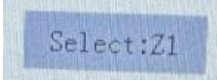
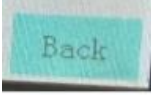
name	function	picture	remarks
X axis coordinates	Displays the current drill disc starting point X-axis coordinates		
Y axis coordinates	Displays the Y-axis coordinates of the current drill disc start point		
Z axis coordinates	Displays the Z-axis coordinates of the current drill disc start point		
DiamondNo	Current drilling plate number		
board check	Enter the drill board calibration interface		
slow	Displays the current speed		
Size	Displays the drill plate specifications		Number of rows x column Number of directions and

			spacing input information on the drill board
Set start	Set the current position to the starting point of the current drill board		
Back start	Back to the starting point of the set current drill board		
current	Displays the current grab drill position		
modify	Go to modify the current grab drill interface		
Refeed	Reset the grab position to the first one		
save	Save the information on the current interface		
back	Save and return to the previous interface		

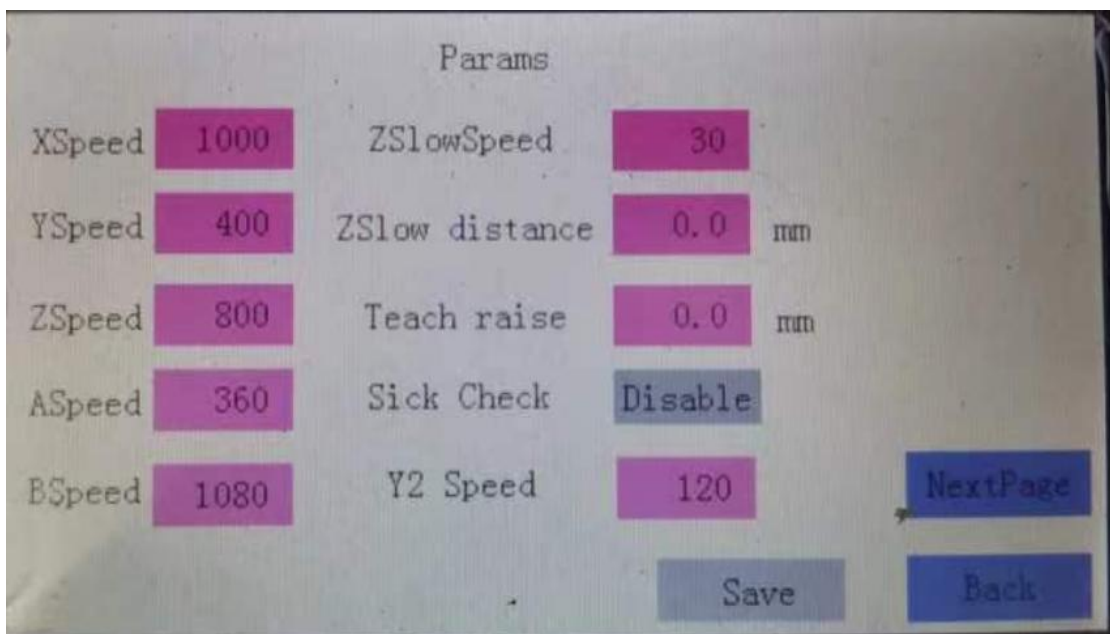
(1) Drilling plate effect quasi boundary

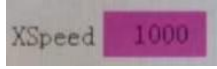
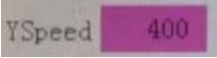


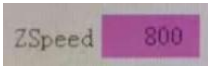
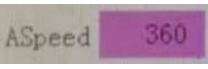
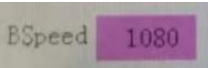
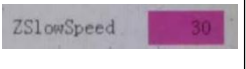

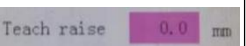
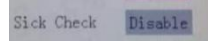
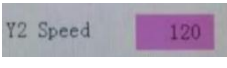
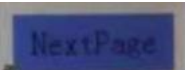
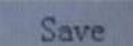
name	function	picture	remarks
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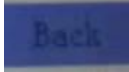
GO	The point where the currently selected z reaches the selected corner		
Select Z: Z1	Displays the currently selected z-axis		
Back	Return to the previous interface		

4. global parameter

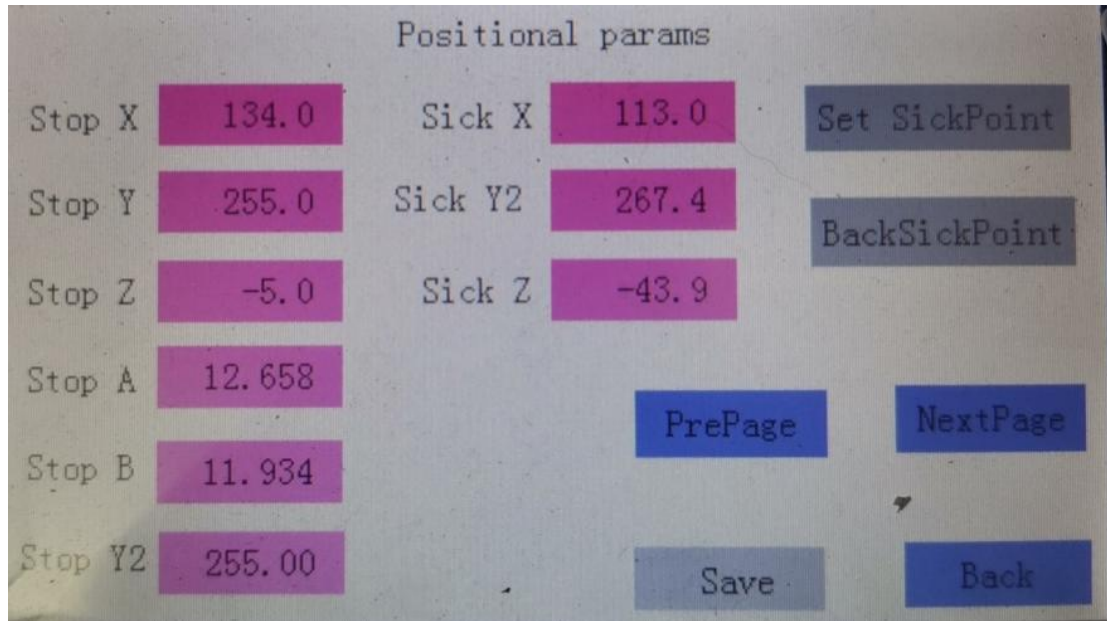


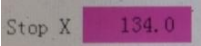


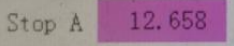
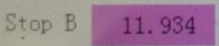
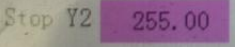

name	function	picture	remarks
X axis speed	Show X-axis speed		It can be modified according to the requirements, and setting it up too fast may cause risks
Y axis speed	Y-axis velocity is shown		It can be modified according to the requirements, and setting it up too fast may cause risks

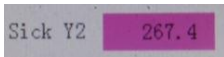

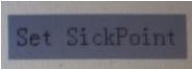
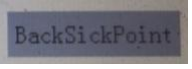
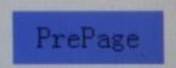

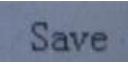
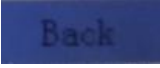
Z axis speed	The Z-axis velocity is shown		It can be modified according to the requirements, and setting it up too fast may cause risks
Axis A speed	Show the A-axis speed		It can be modified according to the requirements, and setting it up too fast may cause risks
B axis speed	Show B-axis speed		It can be modified according to the requirements, and setting it up too fast may cause risks
Z slow speed	Displays the Z slow fall speed during drilling		Modifiable according to the requirements
Z slow distance	Displays the Z slow fall distance during diamond setting		It can be modified according to demand and must be less than drill release elevation
Teach raise	When showing the teaching point, determine the nozzle elevation distance after the point		Continuous teaching and multi-point display can be modified
Sick check	Display the drill suction detection function status		Test has no drill board suction drill
Y2 speed	Displays the drill board shaft speed		It can be modified according to the requirements, and setting it up too fast may cause risks
next page	Switch interface		
Save	Save the current setting		

Back	Return to the previous interface		
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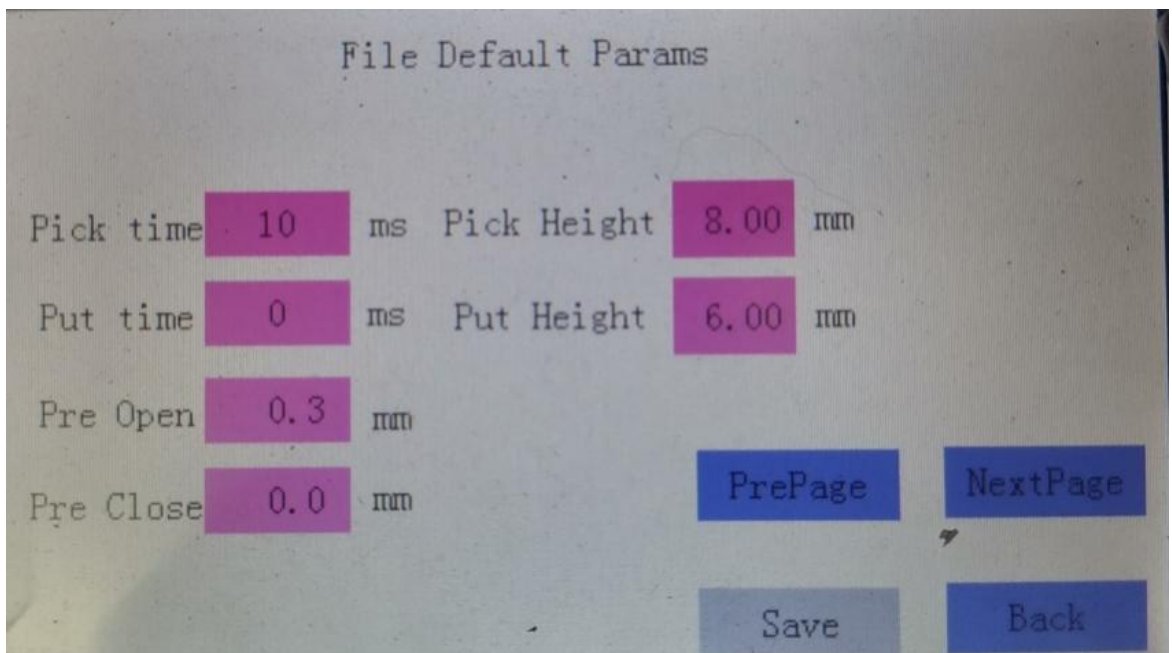
(1) Benchmark point parameters

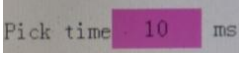

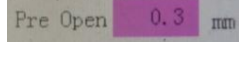
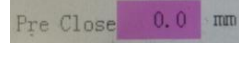
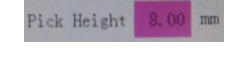
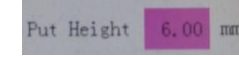
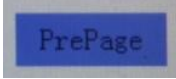

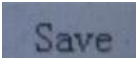
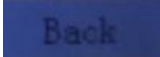


name	function	picture	remarks
Stop X	Displays the shutdown X axis position coordinates		
Stop Y	Display the Y-axis position coordinates of the stop position		
Stop Z	Show the coordinates of the parking position Z-axis position		
Stop A	Displays the coordinates of the downposition A		
Stop B	Displays the parking position B-axis position coordinates		
Stop Y2	Displays the coordinates of the shaft shaft		
Sick X	Displays the X-axis position coordinates of the opposite point		Generally, no adjustment is required

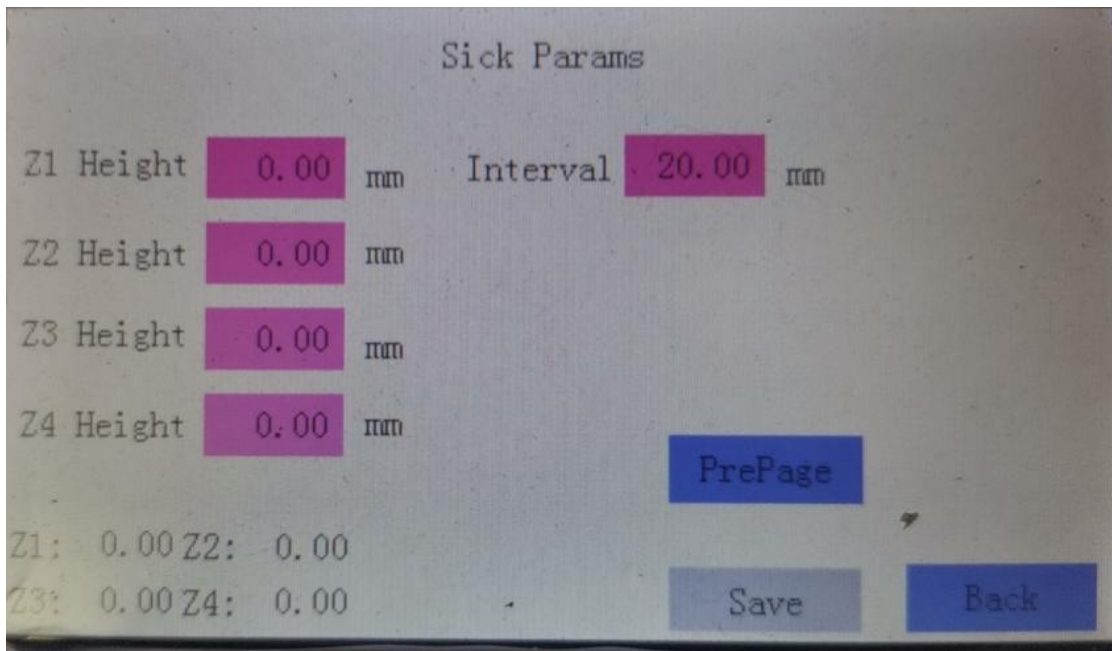
Sick Y2	Displays the coordinates of the pin drill pad axis		Generally, no adjustment is required
Sick Z	Coordinate of the Z-axis position of the opposite needle point is displayed		Generally, no adjustment is required
Set Sick Point	Set the current position to the opposite pin point		Generally, no adjustment is required
Back Sick Point	Return each axis to the opposite pin point position		It can be adjusted after the needle change
Prepage	Back to the previous page		
next page	Go to the next page		
Save	Save the current setting		
Back	Return to the previous interface		

(2) File default parameters

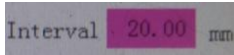
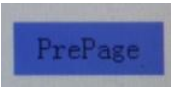

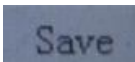
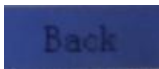


name	function	picture	remarks
Pick time	Displays the delay time of the default needle for each file		A large number of missed leaks can increase time
Put time	Displays the delay time of the default needle at the drill position		Drilling instability can increase the time
Pre Open	Displays the distance each file defaults on suction above the drill		Generally, no adjustment is required
Pre Close	Shows the distance that each file closes off by default above the hole position		Generally, no adjustment is required
Pick Height	Shows the distance each file default raises before moving after drill suction		Adjust according to the flatness of the model
Put Height	Displays the distance each file is elevated by default after drill placement		Adjust according to the flatness of the model
pre page	Back to the previous page		
next page	Make the next page		
Save	Save the current setting		
Back	Return to the previous interface		

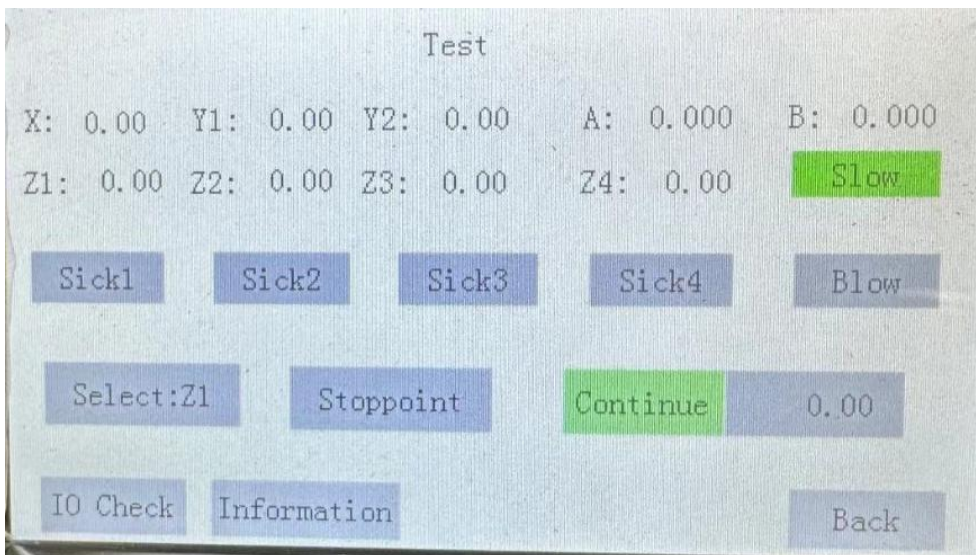
(3) Sick parameters

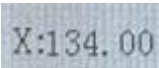
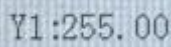
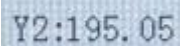


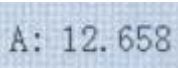
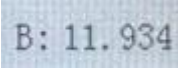
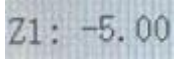
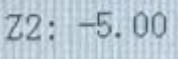
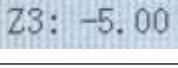
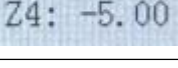

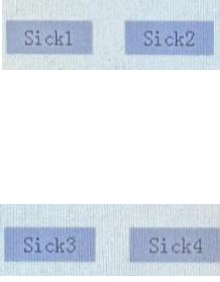
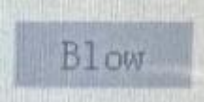
name	function	picture	remarks
Z1 height	Displays the complement required for the current Z axis and standard Z axis height		Z 1 is the standard Z-axis height, with a default of 0
Z2 height	Displays the complement required for the current Z axis and standard Z axis height		Generally, no adjustment is required
Z3 height	Displays the complement required for the current Z axis and standard Z axis height		Generally, no adjustment is required
Z4 height	Displays the complement required for the current Z axis and standard Z axis height		Generally, no adjustment is required

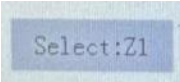
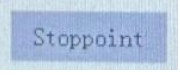

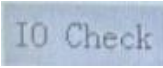
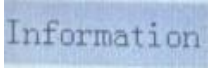
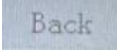
interval	Interval values between the mouthpiece		The default is 20, generally no adjustment
prepage	Return to the previous page		
next page	Go to the next page		
Save	Save the current data		
Back	Return to the previous interface		

5. function testing

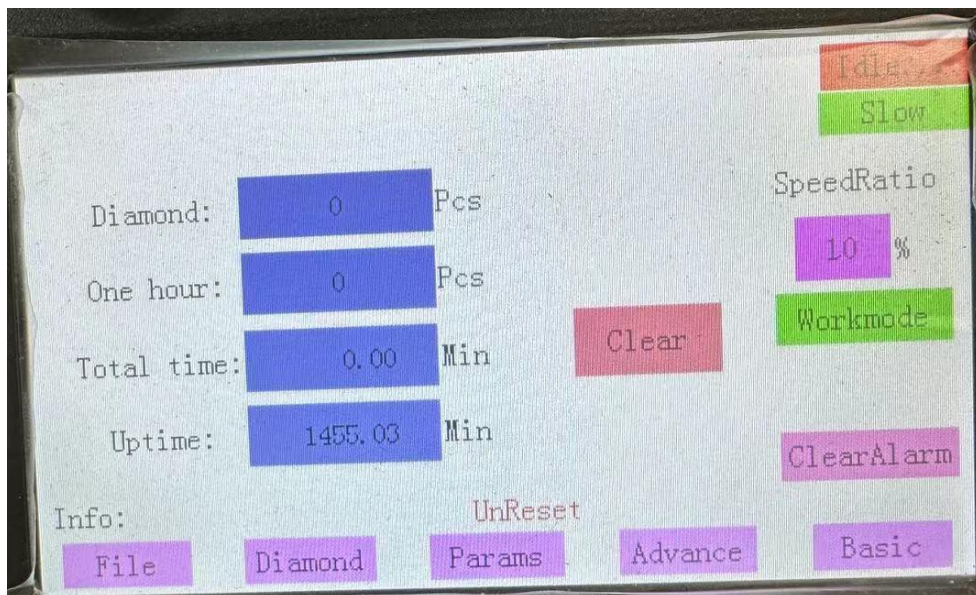


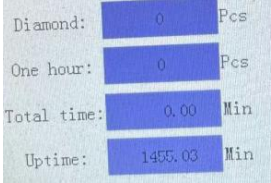
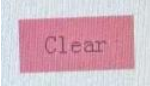

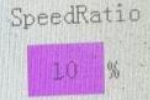

name	function	picture	remarks
X	Displays the current X-axis position coordinates		
Y1	Displays the current Y (Y1) axis position coordinates		
Y2	Displays the coordinates of the current drill board (Y2) axis position		

A	Displays the current A-axis position coordinates		
B	Displays the current B-axis position coordinates		
Z 1	Displays the current Z1 axis position coordinates		
Z2	Displays the current Z2 axis position coordinates		
Z3	Displays the current Z3 axis position coordinates		
Z4	Displays the current Z4-axis position coordinates		
slow	Displays the current speed		
Sick 1	Displays the current inspiratory state of the nozzle 1		The air suction pressure may also be blocked inside the suction nozzle
Sick 2	The current inspiratory state of the suction nozzle 2 is displayed		The air suction pressure may also be blocked inside the suction nozzle
Sick 3	The current inspiratory state of the suction nozzle 3 is displayed		The air suction pressure may also be blocked inside the suction nozzle
Sick 4	The current inspiratory state of the suction nozzle 4 is displayed		The air suction pressure may also be blocked inside the suction nozzle
Blow	Show four suction status		Blowing gas for four suction nozzle blowing together, blowing gas can dredge the suction nozzle internal plug

select Z1	The current moving Z axis is Z several		The non-drill board calibration interface and this interface default to Z1
Stoppoint	Return to the shutdown position		
continue	Show motion mode		It can be switched to fixed length motion, which runs at medium speed by default, and will switch to continuous operation mode after running once
IO check	Conduct the IO monitoring list		
Information	Make the system information list		
back	Return to the previous interface		

6. Quantity



name	function	picture	remarks
Diamond	Total production since startup		
One hour	Number of diamonds produced per hour since startup		
Total time	The time from when the machine started processing to now		
Uptime	The time since the machine was powered on		
Clear	Clear the production data on the left to zero		
Idle	Show current running status		
Slow	Display current manual speed		
SpeedRatio	Display current production rate		
Workmode	Show current machine mode		
ClearAlarm	Clear alarm button	