GLS Multi-ply Cutter Operation Manual

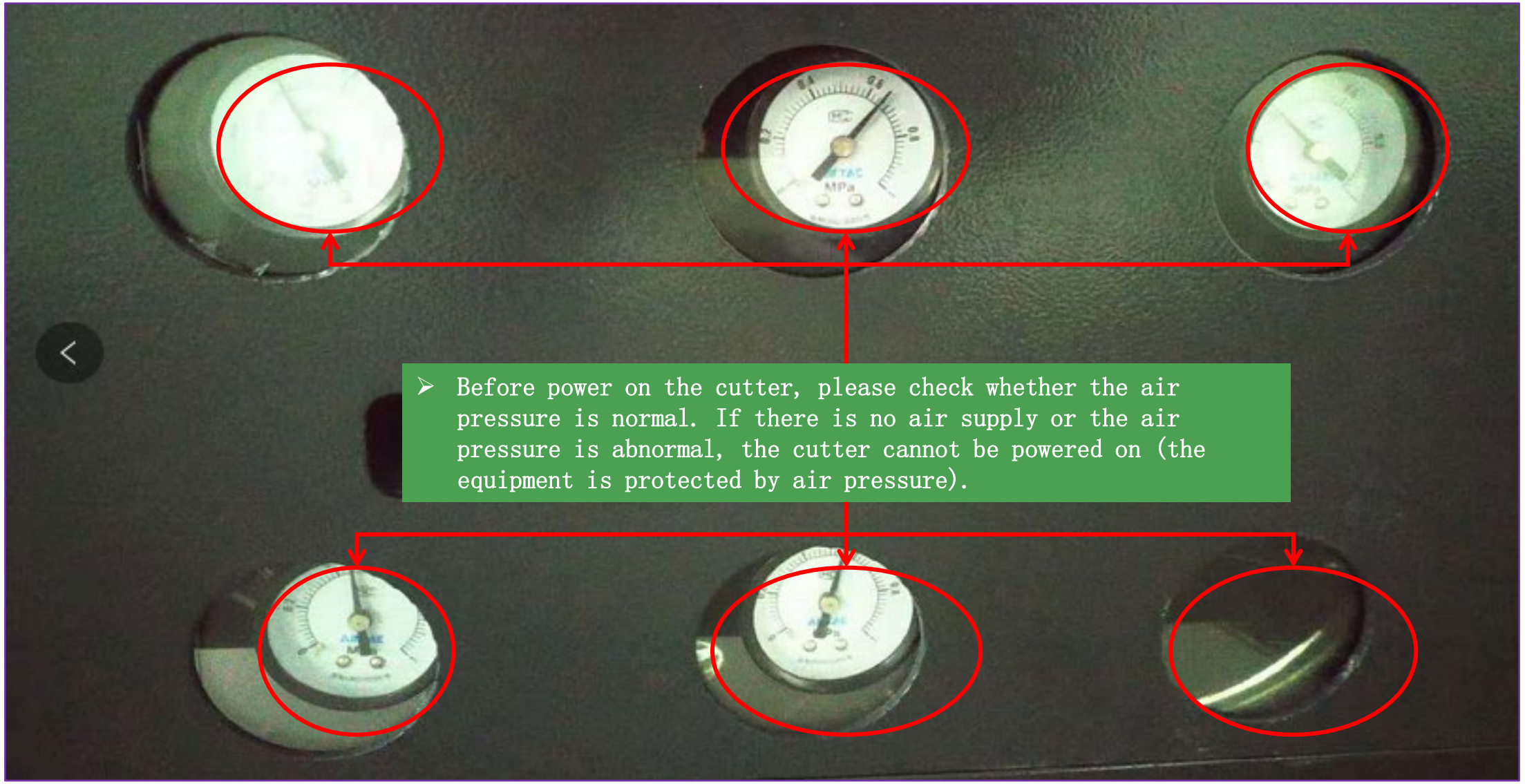
Intelligent cutting creates future!

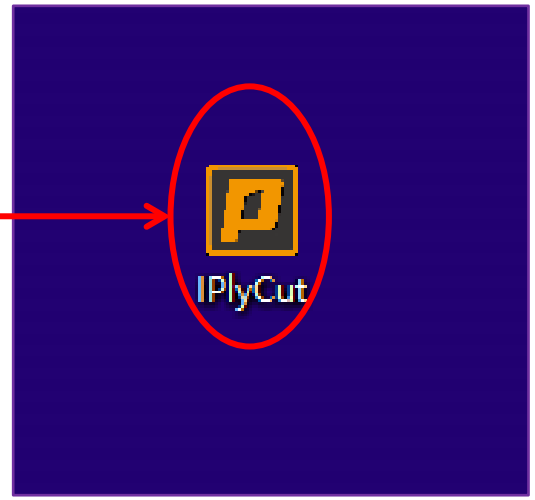
01 Power on the cutter

02 Software

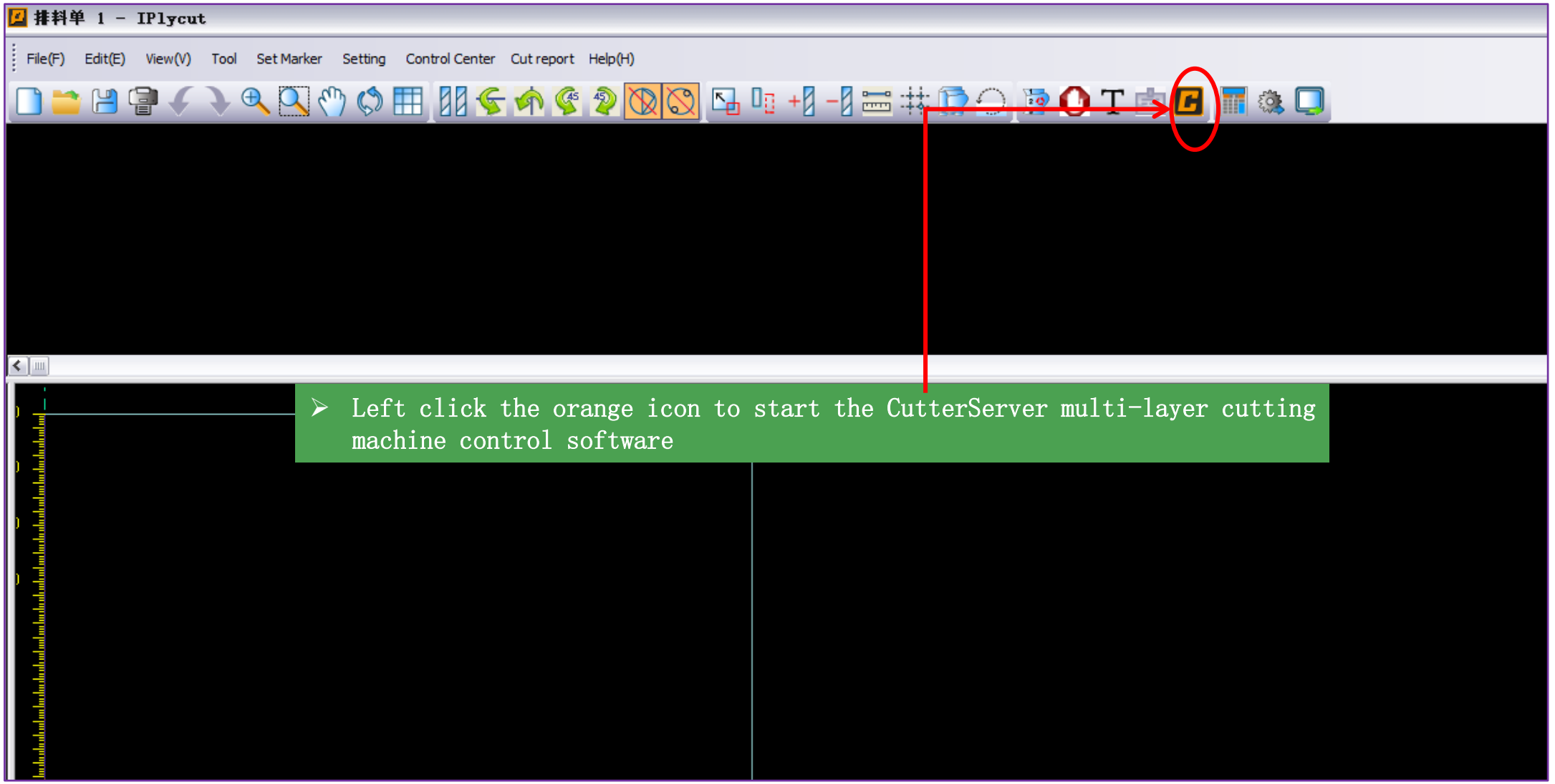
03 Cutting

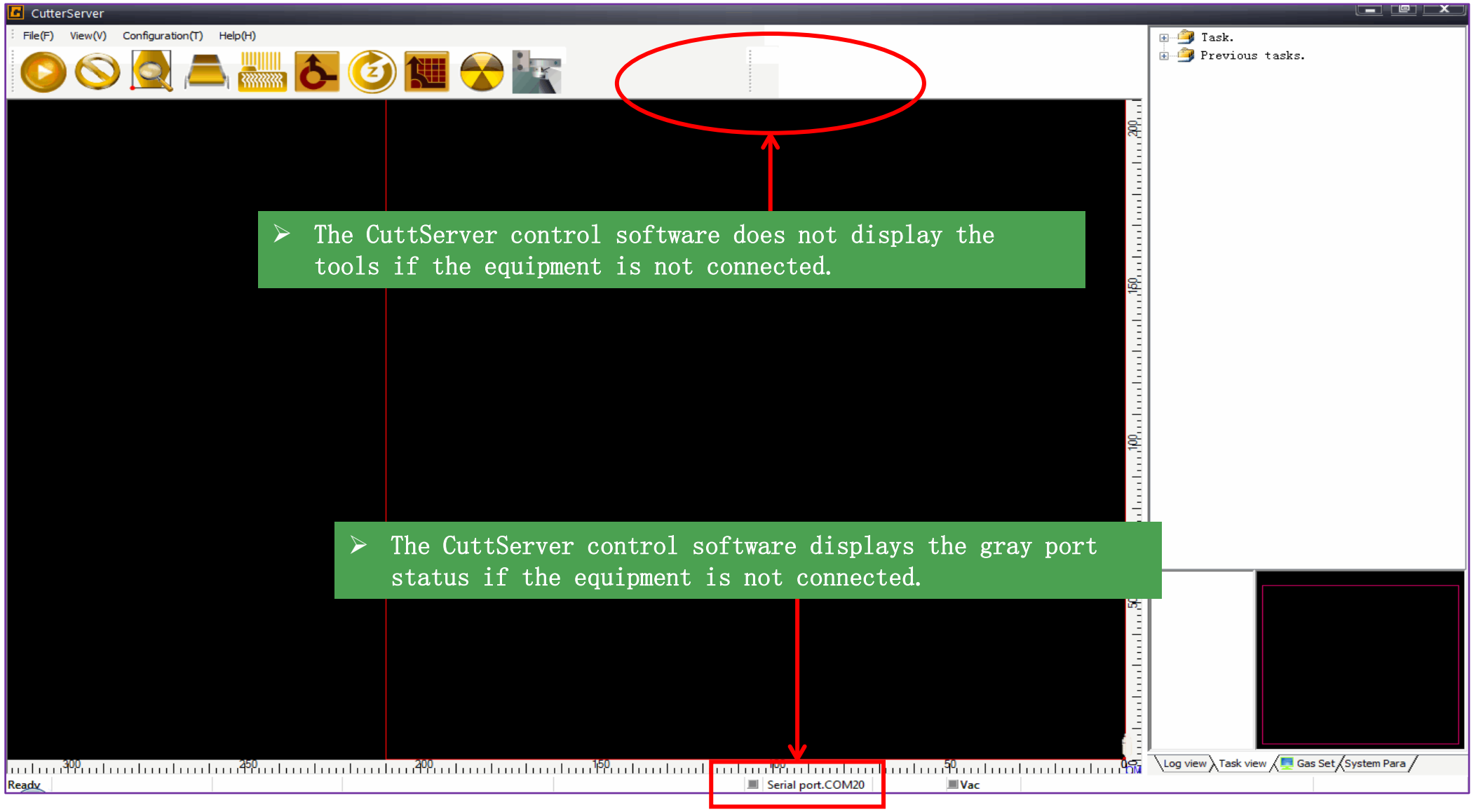
01 Power on the machine

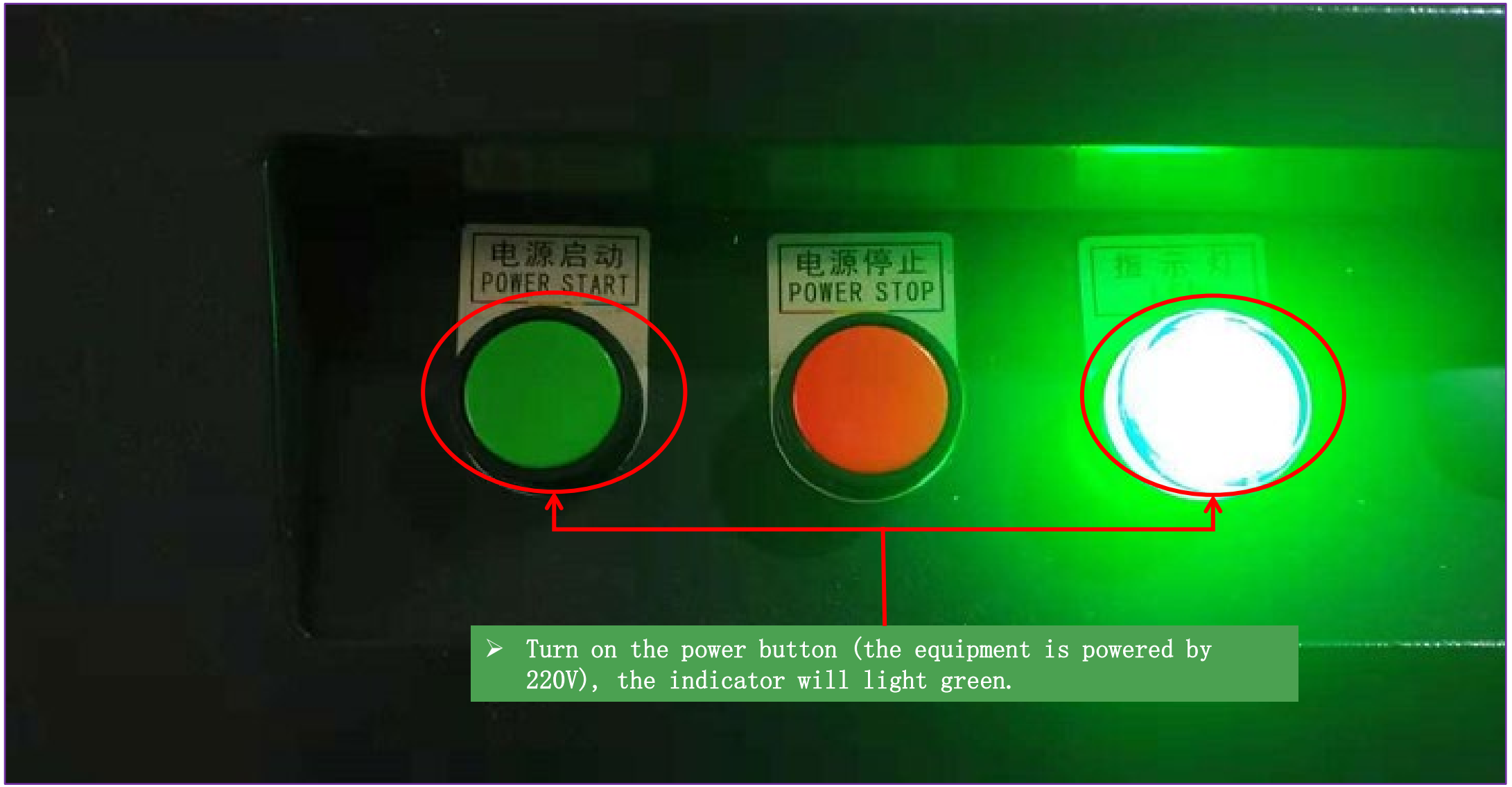

➢ Before power on the cutter, please check whether the air pressure is normal. If there is no air supply or the air pressure is abnormal, the cutter cannot be powered on (the equipment is protected by air pressure).

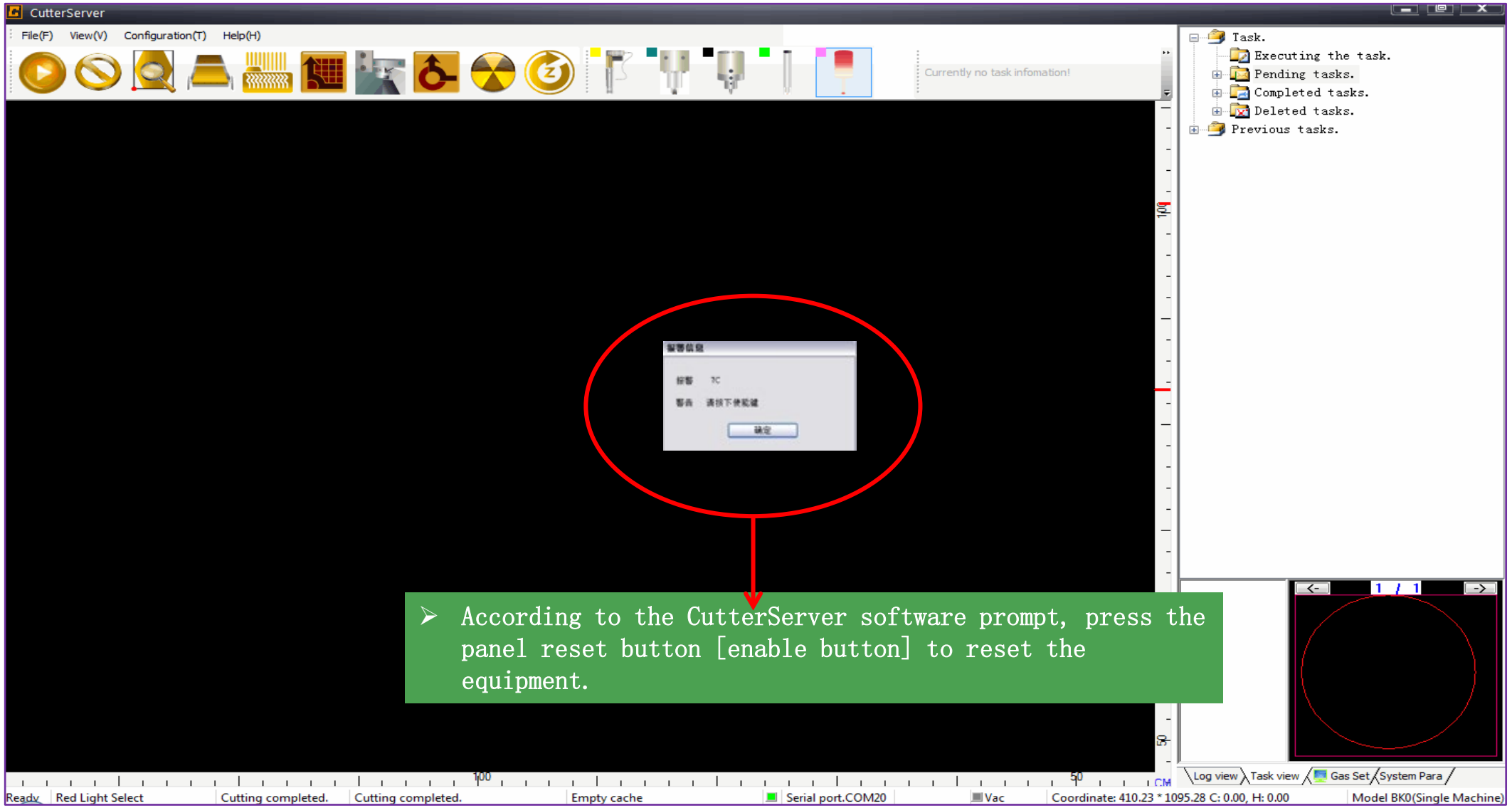


- Turn on the computer, and double-click the "IplyCut" icon to start the software.


排料单 1 - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Setting
Control Center
Cut report
Help(H)
➢ Left click the orange icon to start the CutterServer multi-layer cutting machine control software

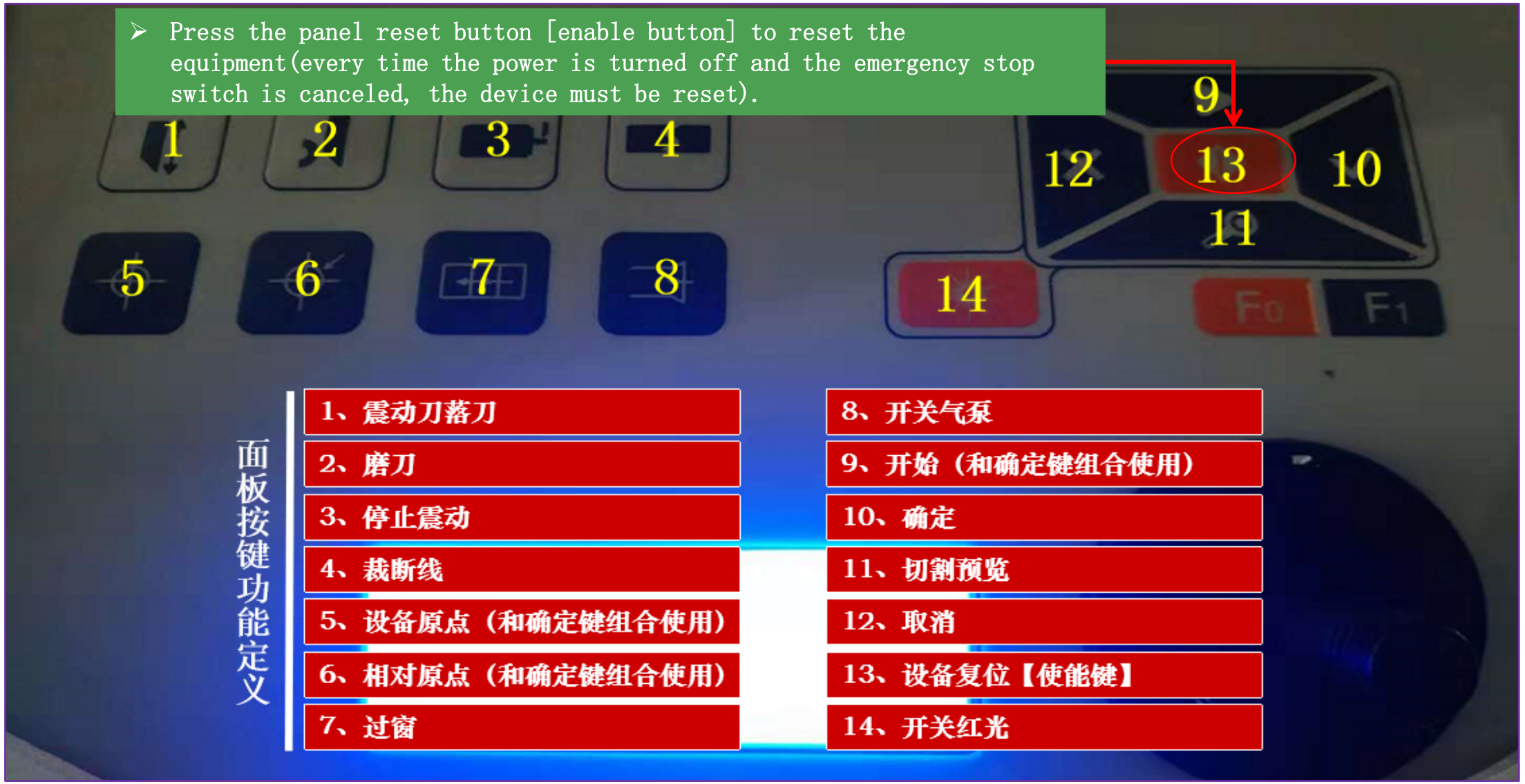

CutterServer
File(F)
View(V)
Configuration(T)
Help(H)
Task.
Previous tasks.
➢ The CuttServer control software does not display the tools if the equipment is not connected.
➢ The CuttServer control software displays the gray port status if the equipment is not connected.
Log view
Task view
Gas Set
System Para
Ready
Serial port.COM20
Vac

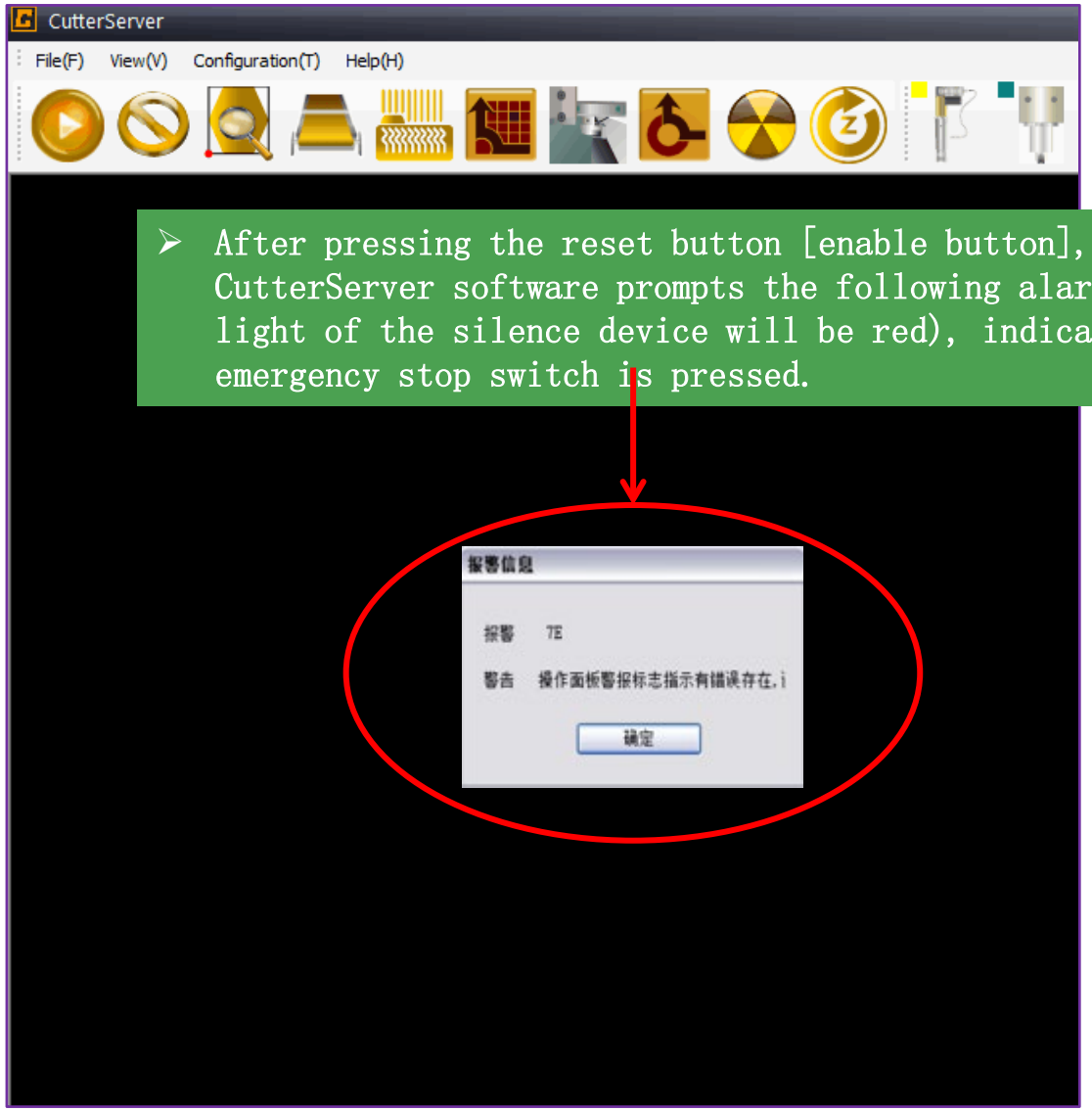

电源启动
POWER START
电源停止
POWER STOP
➢ Turn on the power button (the equipment is powered by 220V), the indicator will light green.



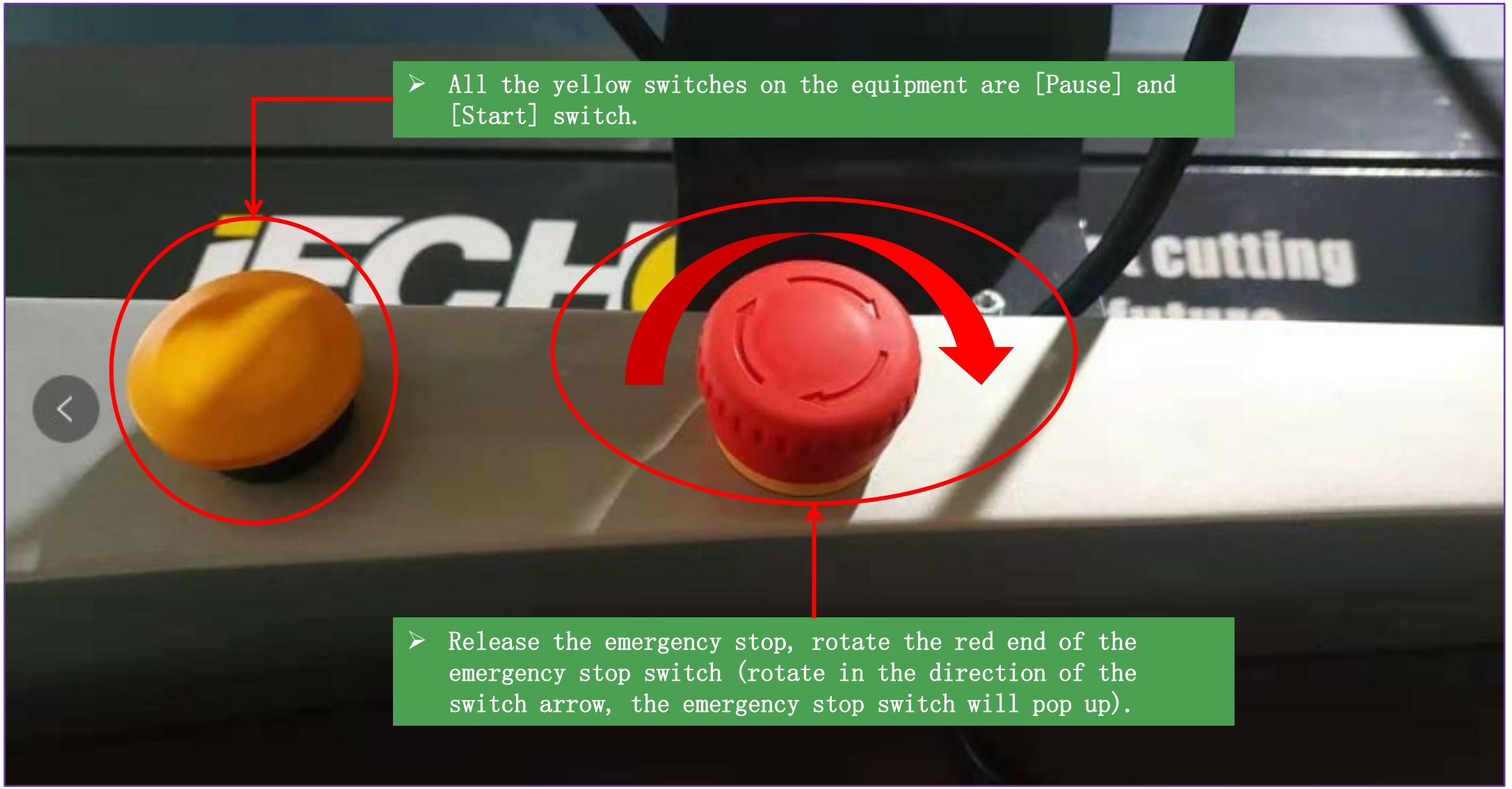
➢ According to the CutterServer software prompt, press the panel reset button [enable button] to reset the equipment.

- Press the panel reset button [enable button] to reset the equipment(every time the power is turned off and the emergency stop switch is canceled, the device must be reset).





- After pressing the reset button [enable button], the CutterServer software prompts the following alarm message (the light of the silence device will be red), indicating that the emergency stop switch is pressed.

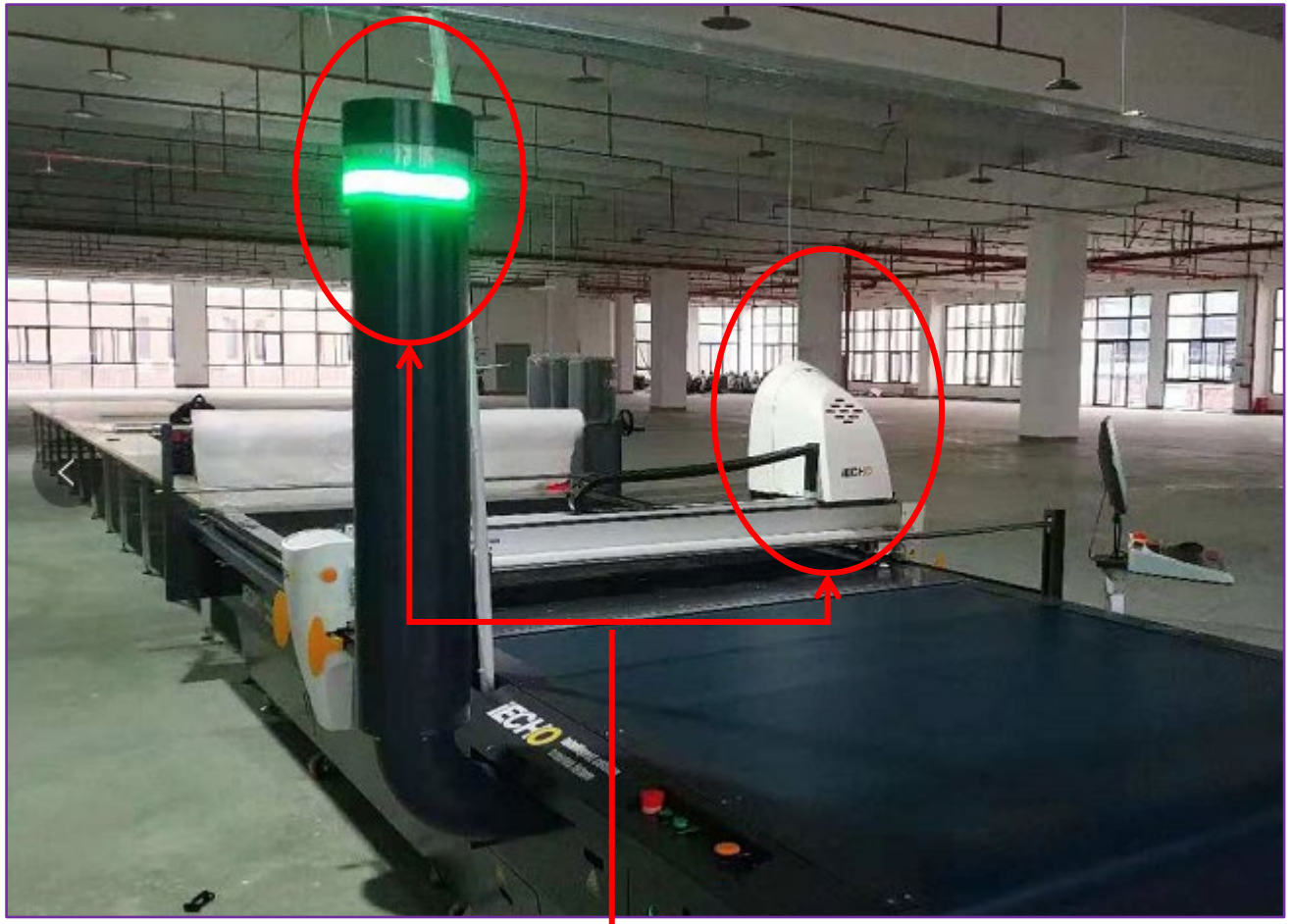

➢ All the yellow switches on the equipment are [Pause] and [Start] switch.
➢ Release the emergency stop, rotate the red end of the emergency stop switch (rotate in the direction of the switch arrow, the emergency stop switch will pop up).

1、 After the emergency stop switch is released, press [Cancel button] to cancel the device alarm.

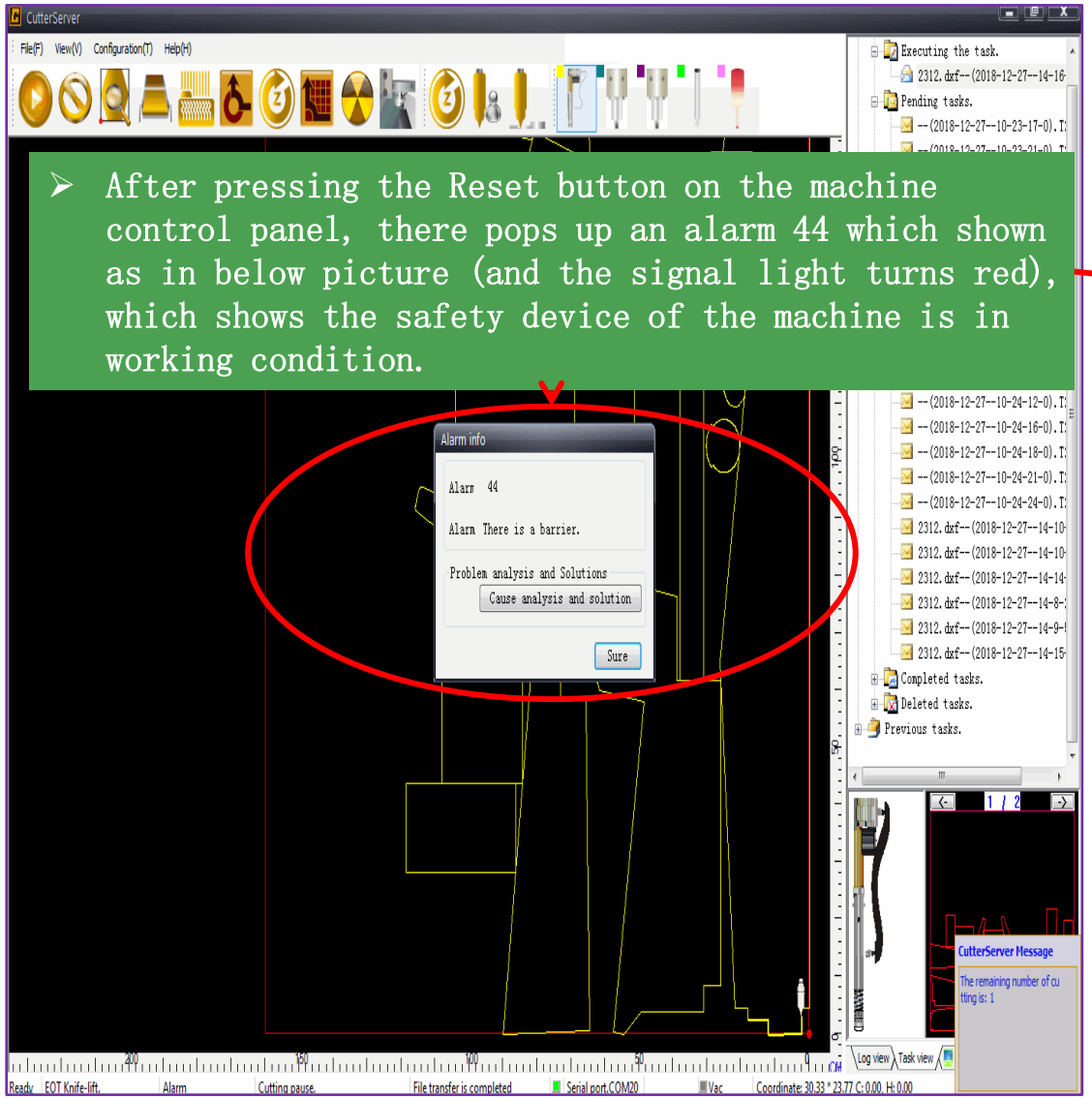
2、Press the reset button [enable button] again to reset the equipment.

面板按键功能定义

1、震动刀落刀	8、开关气泵
2、磨刀	9、开始（和确定键组合使用）
3、停止震动	10、确定
4、裁断线	11、切割预览
5、设备原点（和确定键组合使用）	12、取消
6、相对原点（和确定键组合使用）	13、设备复位【使能键】
7、过窗	14、开关红光



- When the machine resets successfully, the signal light of silence device turns green with the cutting head moving to the origin which is at the right side of the machine.



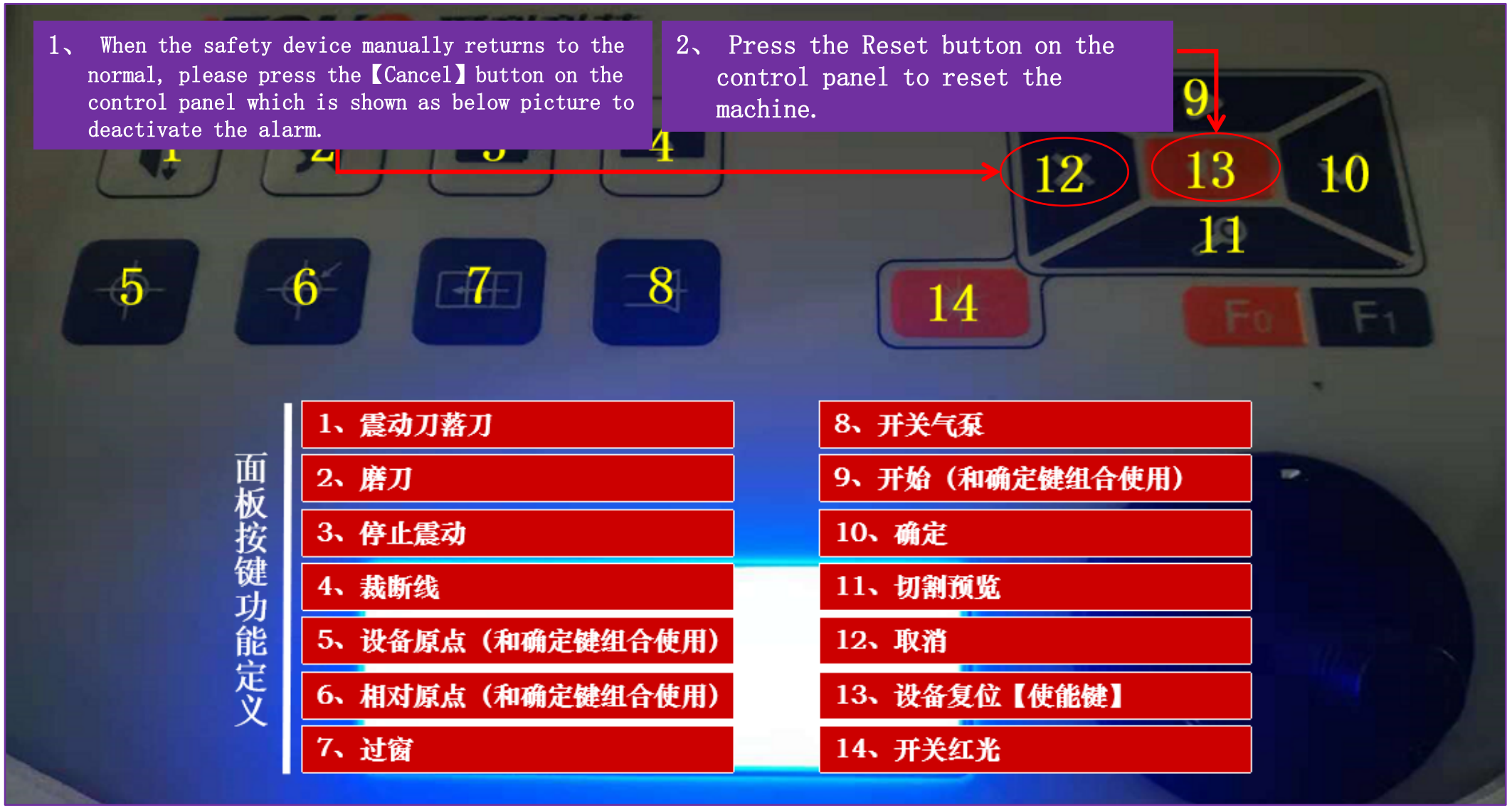
➢ After pressing the Reset button on the machine control panel, there pops up an alarm 44 which shown as in below picture (and the signal light turns red), which shows the safety device of the machine is in working condition.

- The safety device on machine cutting beam are as in the below picture, which shows the safety device is in working condition and needs to deactivate the alarm.

- The safety device on machine cutting beam are as in the below picture, which shows the alarm has been deactivated.

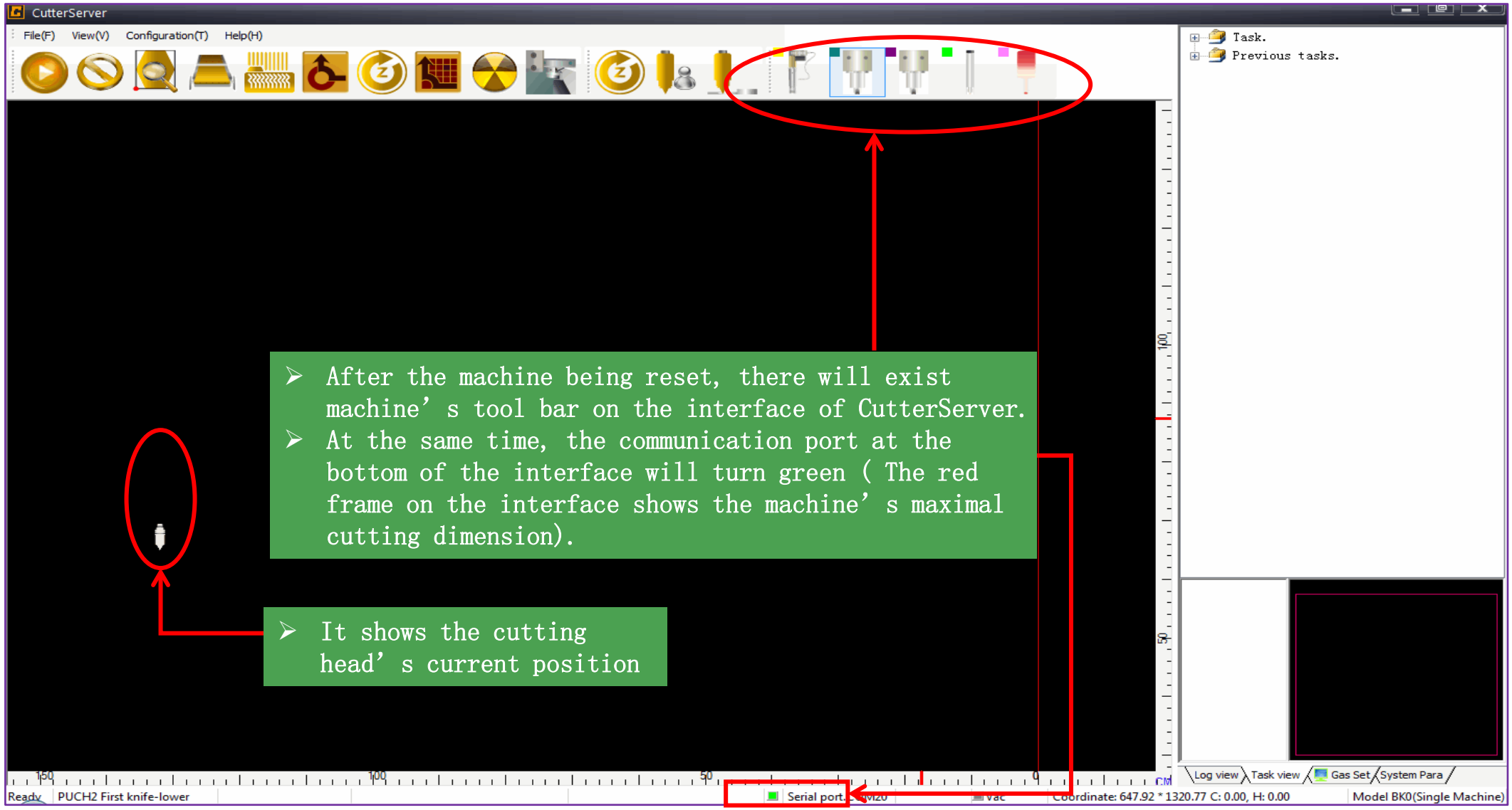
1、 When the safety device manually returns to the normal, please press the【Cancel】button on the control panel which is shown as below picture to deactivate the alarm.

2、 Press the Reset button on the control panel to reset the machine.

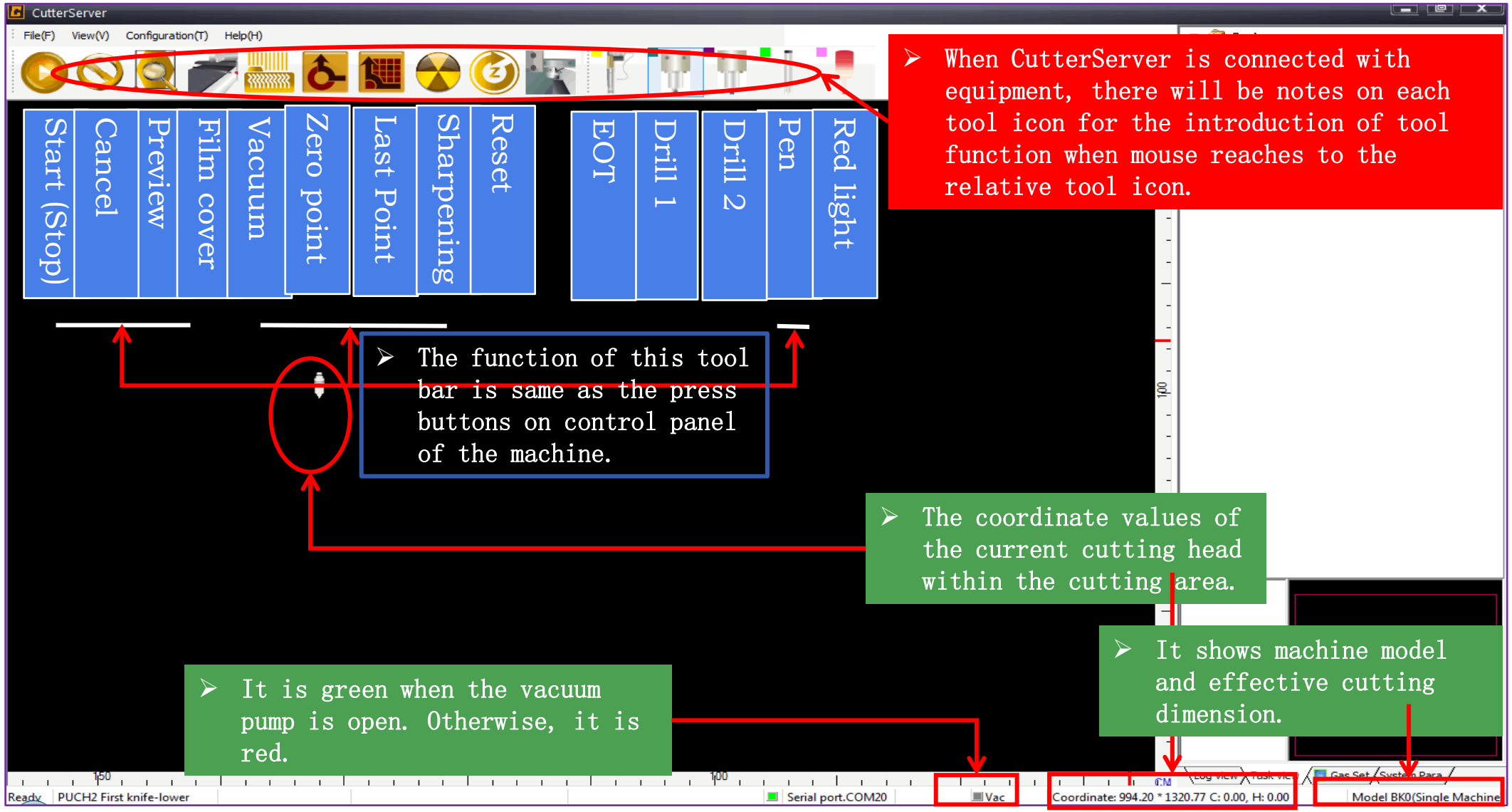


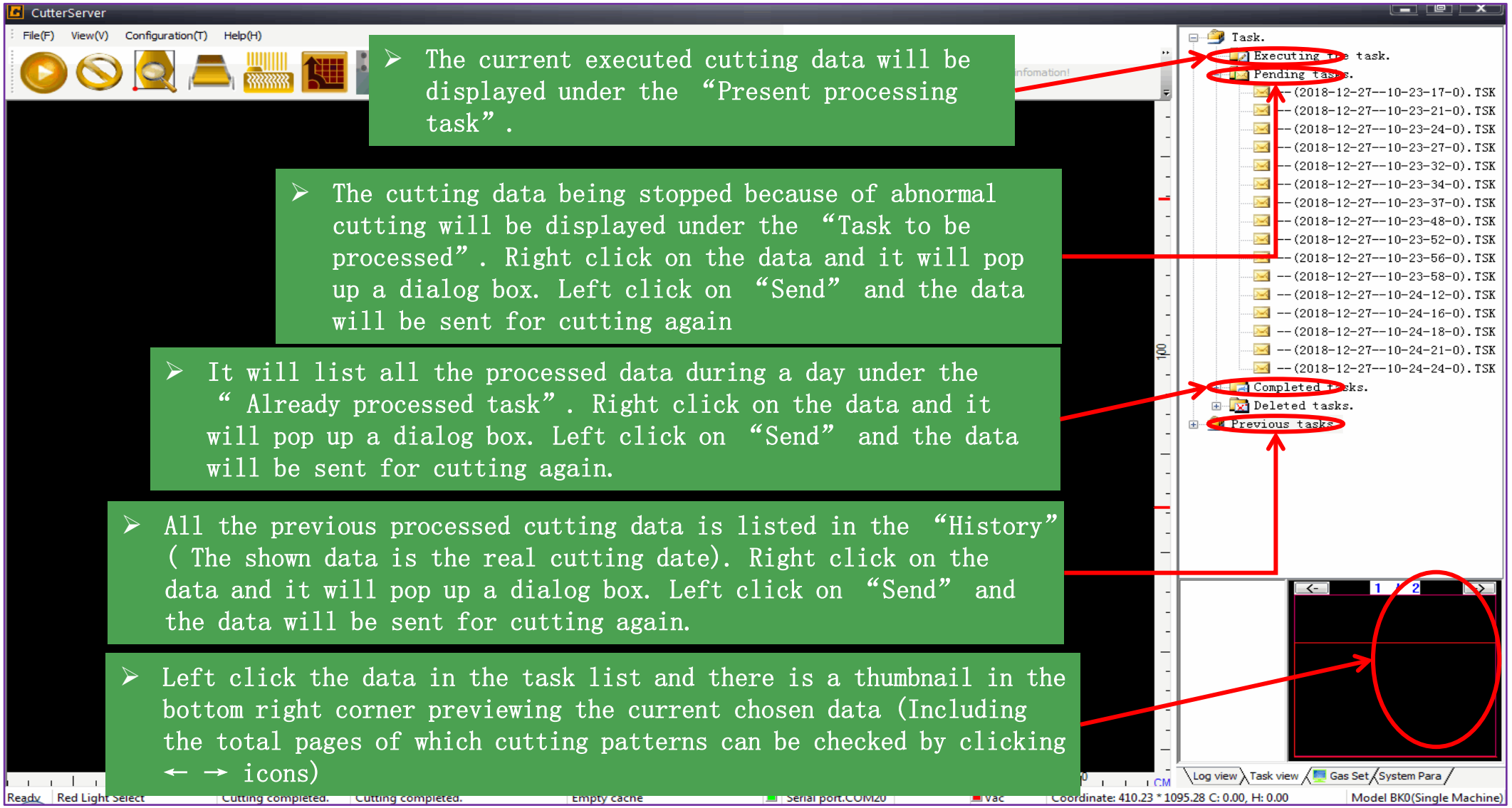
面板按键功能定义

1、震动刀落刀
2、磨刀
3、停止震动
4、裁断线
5、设备原点（和确定键组合使用）
6、相对原点（和确定键组合使用）
7、过窗
8、开关气泵
9、开始（和确定键组合使用）
10、确定
11、切割预览
12、取消
13、设备复位【使能键】
14、开关红光

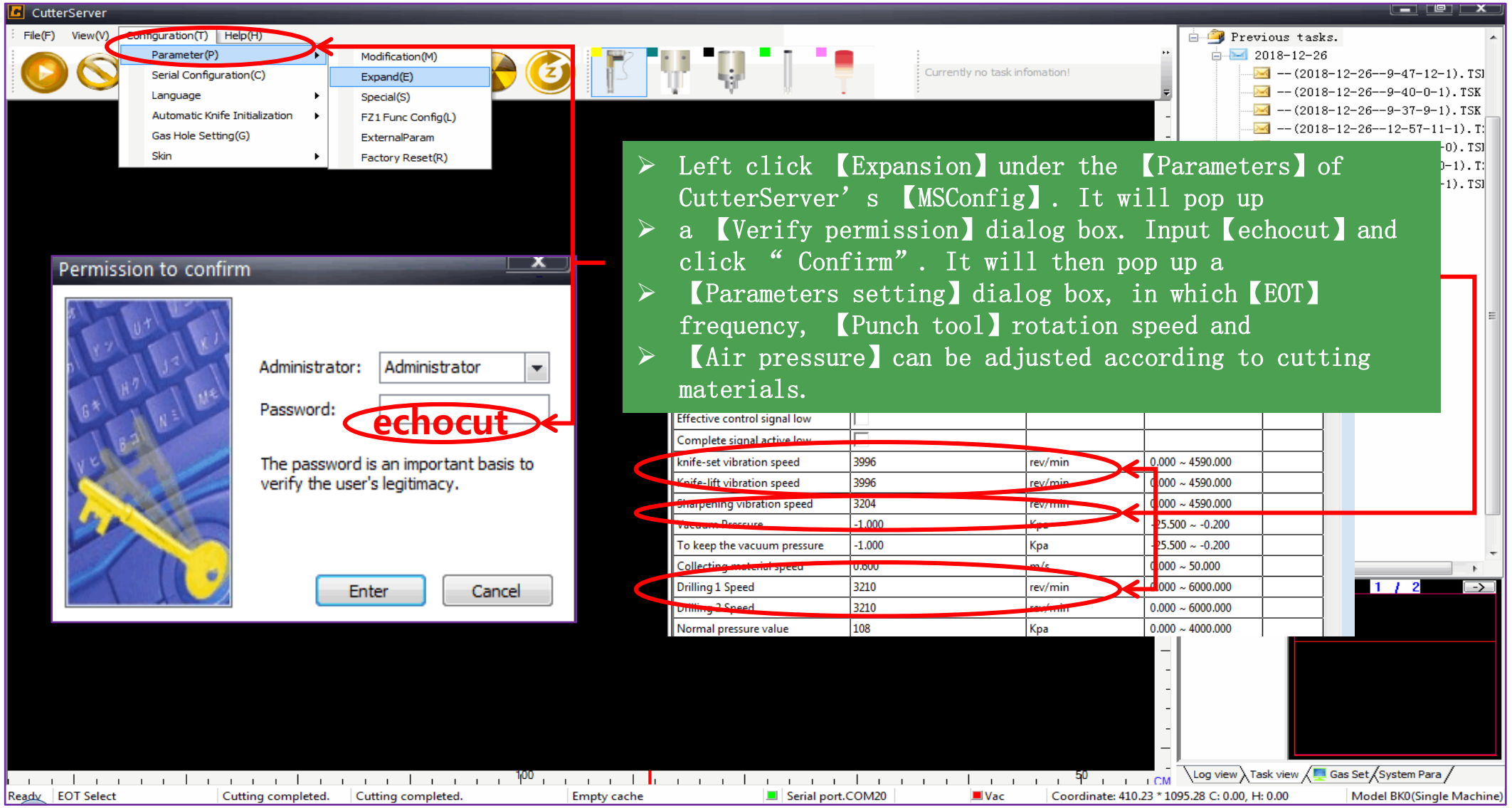

CutterServer
File(F)
View(V)
Configuration(T)
Help(H)
Task.
Previous tasks.
After the machine being reset, there will exist machine's tool bar on the interface of CutterServer.
At the same time, the communication port at the bottom of the interface will turn green (The red frame on the interface shows the machine's maximal cutting dimension).
It shows the cutting head's current position
Log view
Task view
Gas Set
System Para
Ready
PUCH2 First knife-lower
Model BK0(Single Machine)

02 Software

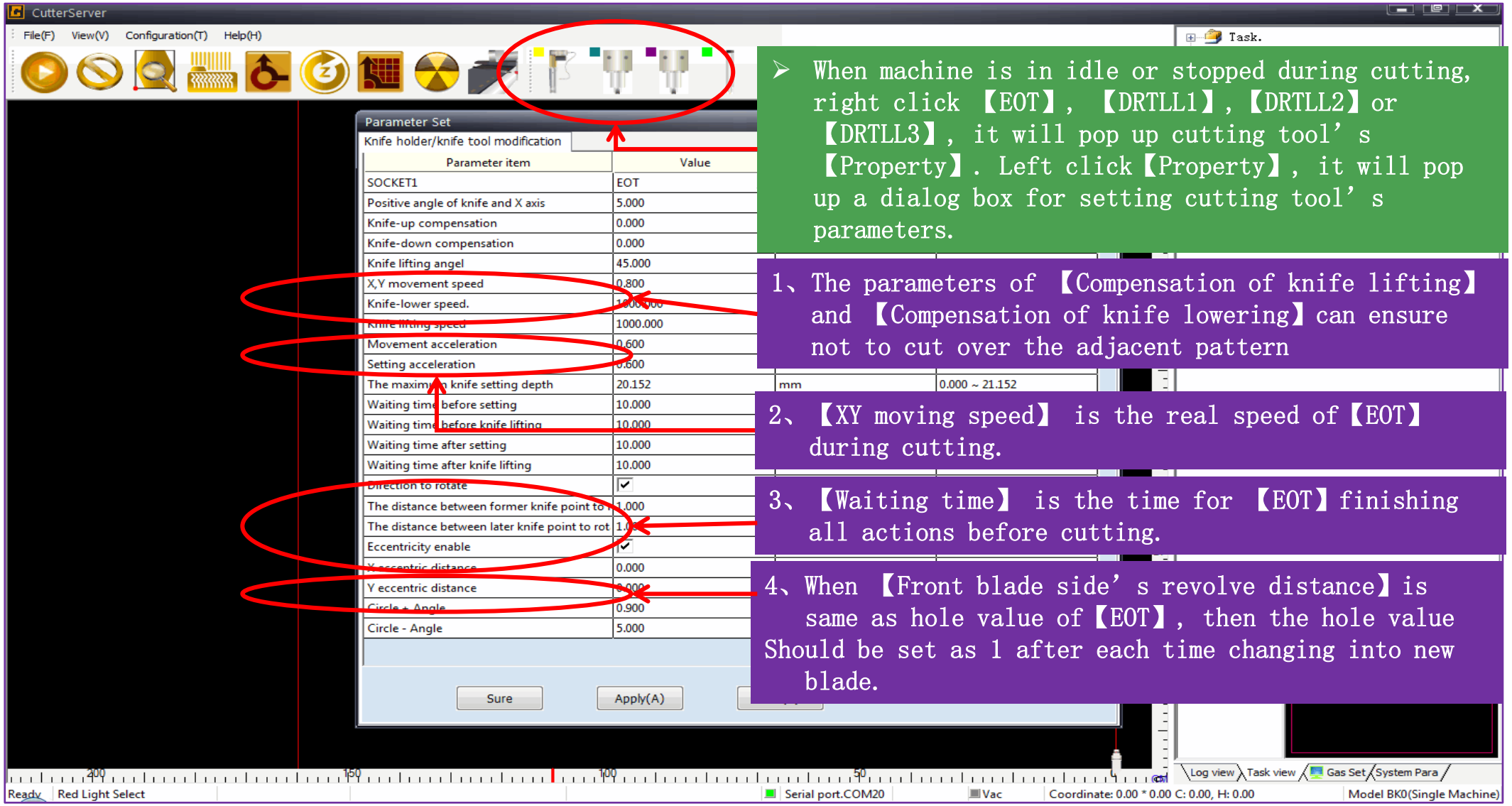

CutterServer
File(F) View(V) Configuration(T) Help(H)
Start (Stop)
Cancel
Preview
Film cover
Vacuum
Zero point
Last Point
Sharpening
Reset
EOT
Drill 1
Drill 2
Pen
Red light
When CutterServer is connected with equipment, there will be notes on each tool icon for the introduction of tool function when mouse reaches to the relative tool icon.
The function of this tool bar is same as the press buttons on control panel of the machine.
The coordinate values of the current cutting head within the cutting area.
It shows machine model and effective cutting dimension.
It is green when the vacuum pump is open. Otherwise, it is red.
Ready
PUCH2 First knife-lower
Serial port.COM20
Vac
Coordinate: 994.20 * 1320.77 C: 0.00, H: 0.00
Model BK0(Single Machine



- The current executed cutting data will be displayed under the “Present processing task”.
- The cutting data being stopped because of abnormal cutting will be displayed under the “Task to be processed”. Right click on the data and it will pop up a dialog box. Left click on “Send” and the data will be sent for cutting again
- It will list all the processed data during a day under the “ Already processed task”. Right click on the data and it will pop up a dialog box. Left click on “Send” and the data will be sent for cutting again.
- All the previous processed cutting data is listed in the “History” (The shown data is the real cutting date). Right click on the data and it will pop up a dialog box. Left click on “Send” and the data will be sent for cutting again.
- Left click the data in the task list and there is a thumbnail in the bottom right corner previewing the current chosen data (Including the total pages of which cutting patterns can be checked by clicking ← → icons)



- Left click 【Expansion】under the 【Parameters】of CutterServer's 【MSConfig】. It will pop up
- a 【Verify permission】dialog box. Input【echocut】and click " Confirm". It will then pop up a
- 【Parameters setting】dialog box, in which【EOT】frequency, 【Punch tool】rotation speed and
- 【Air pressure】can be adjusted according to cutting materials.



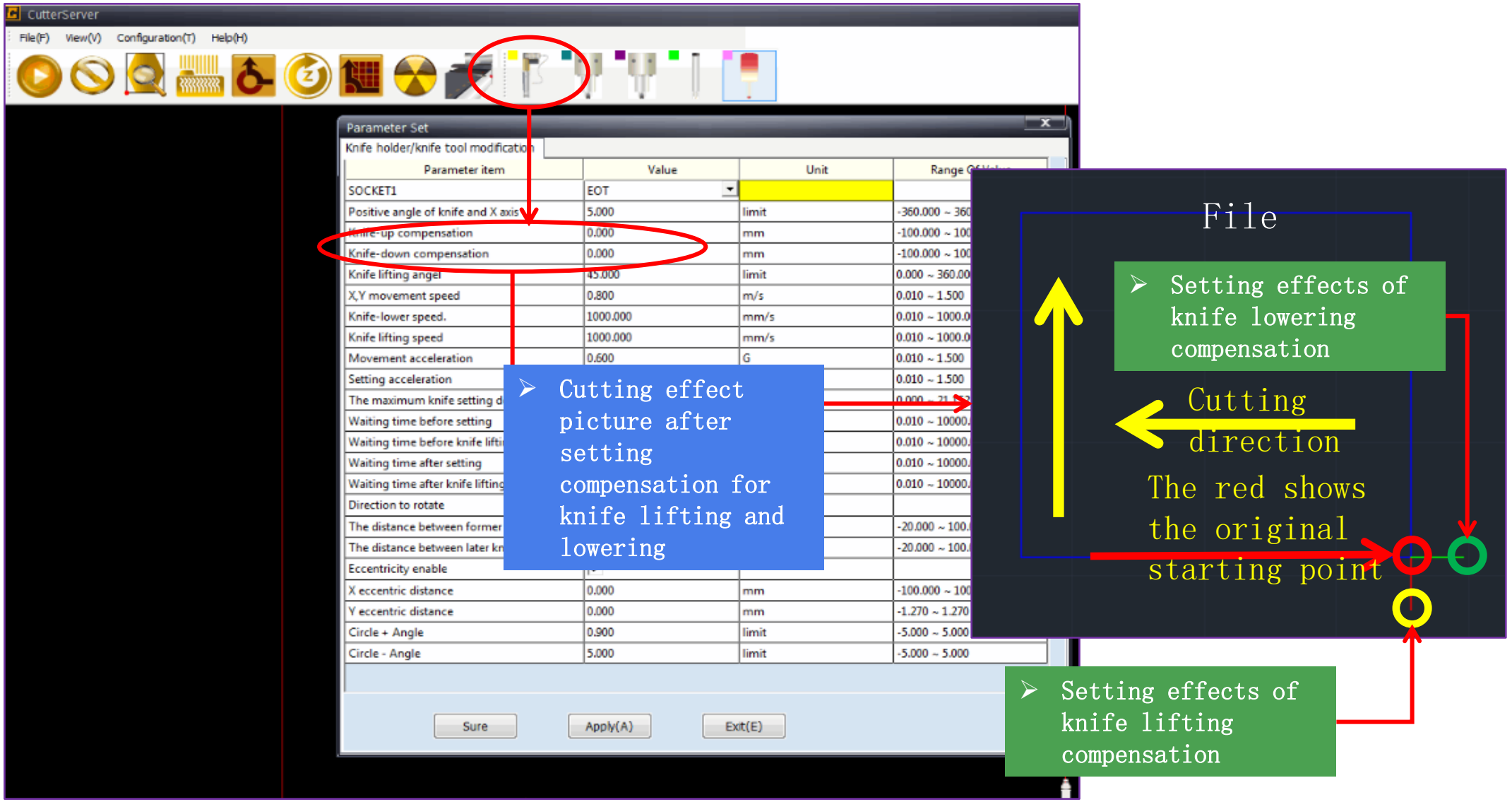
➢ When machine is in idle or stopped during cutting, right click 【EOT】, 【DRTLL1】, 【DRTLL2】or 【DRTLL3】, it will pop up cutting tool’s 【Property】. Left click【Property】, it will pop up a dialog box for setting cutting tool’s parameters.

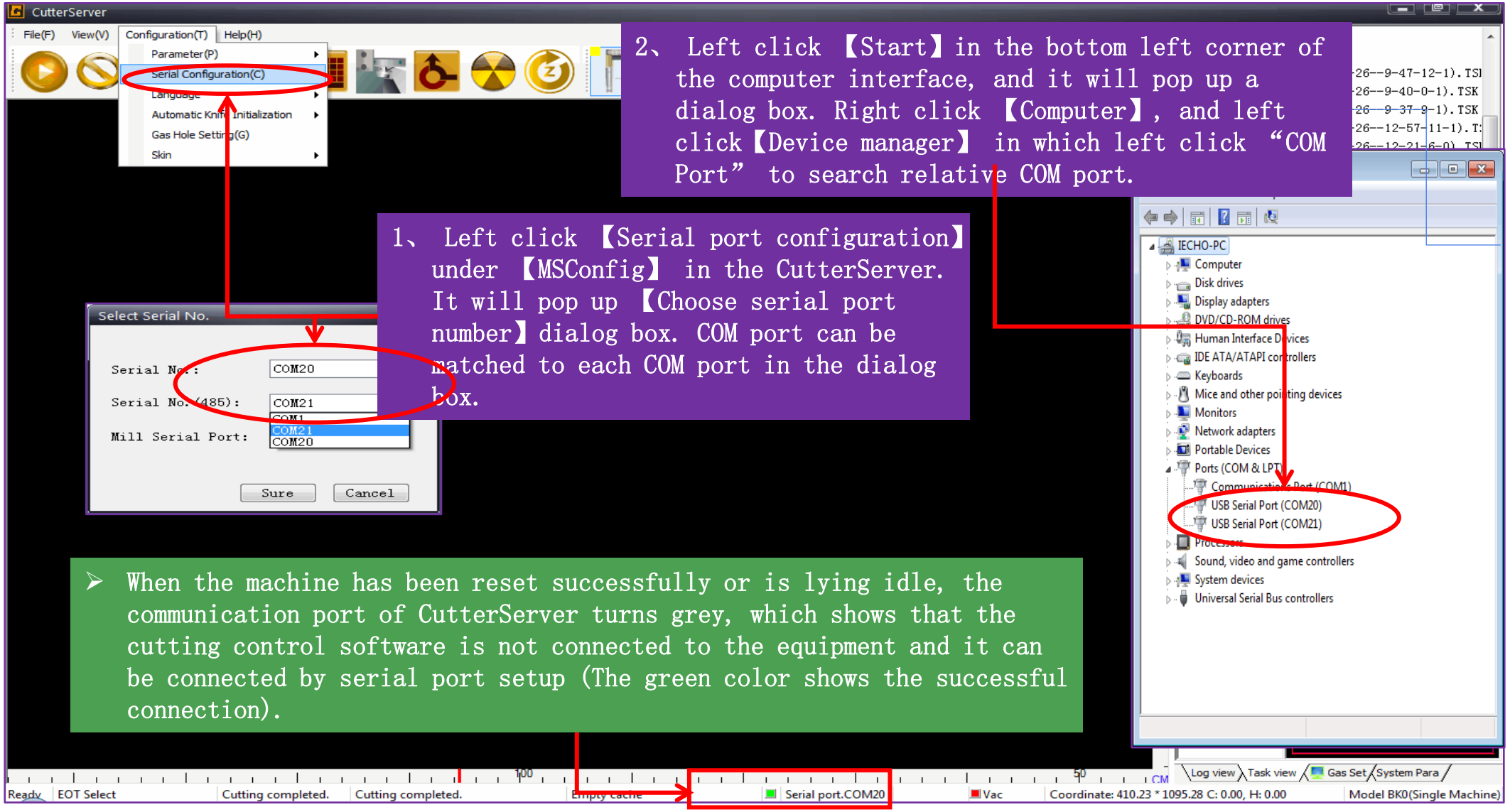
1、The parameters of 【Compensation of knife lifting】 and 【Compensation of knife lowering】can ensure not to cut over the adjacent pattern

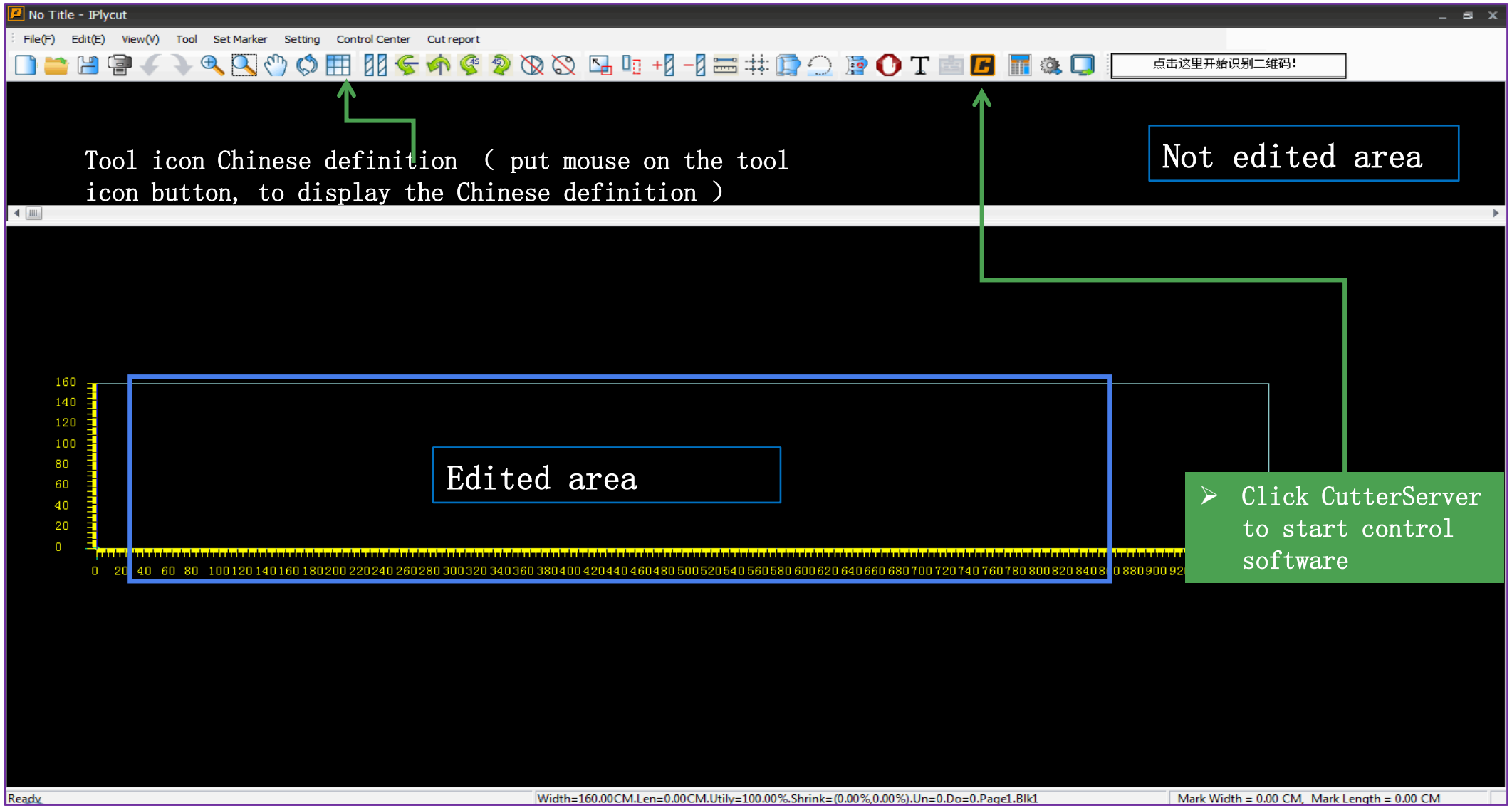
2、【XY moving speed】 is the real speed of【EOT】 during cutting.

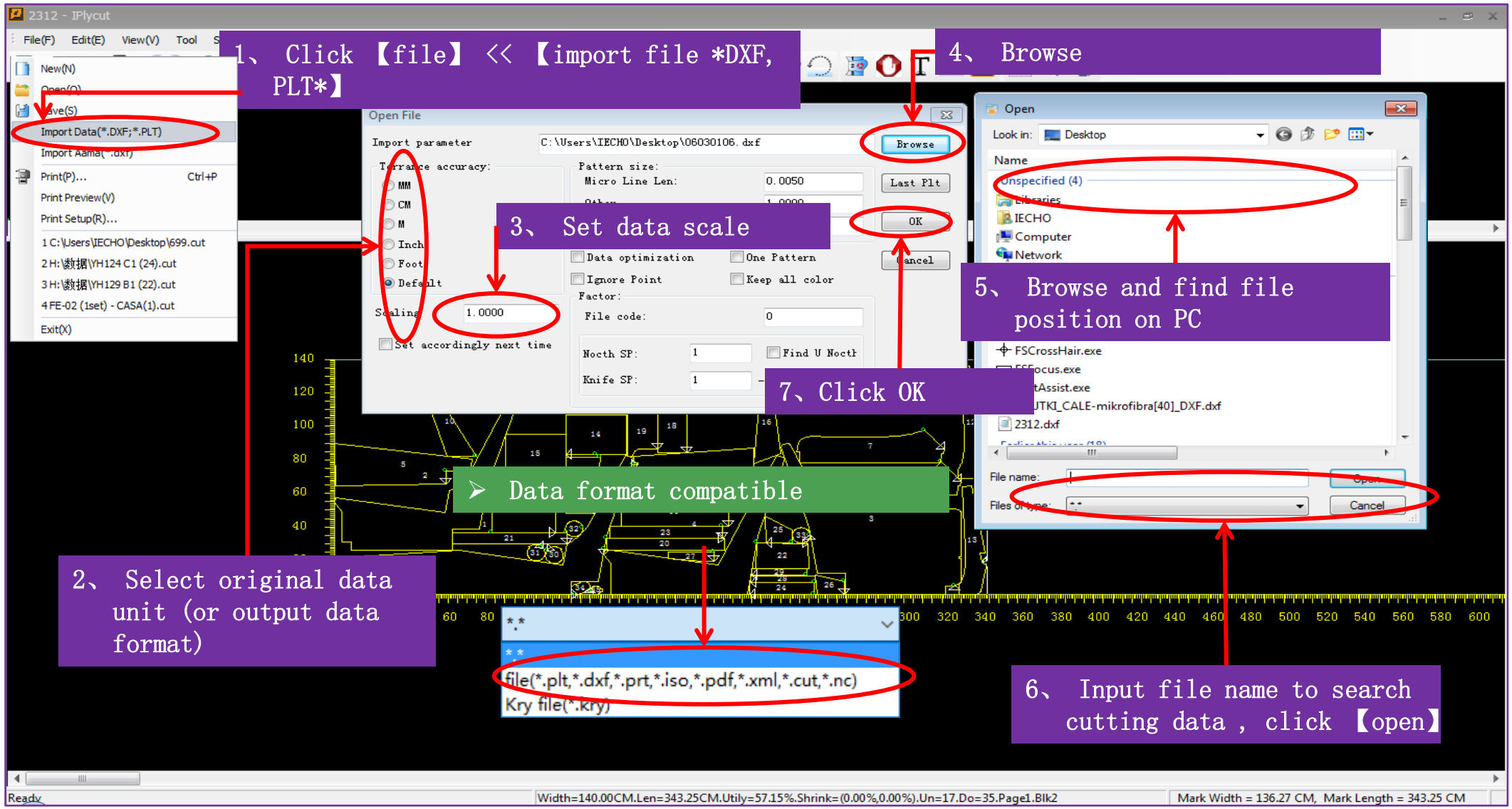
3、【Waiting time】 is the time for 【EOT】finishing all actions before cutting.

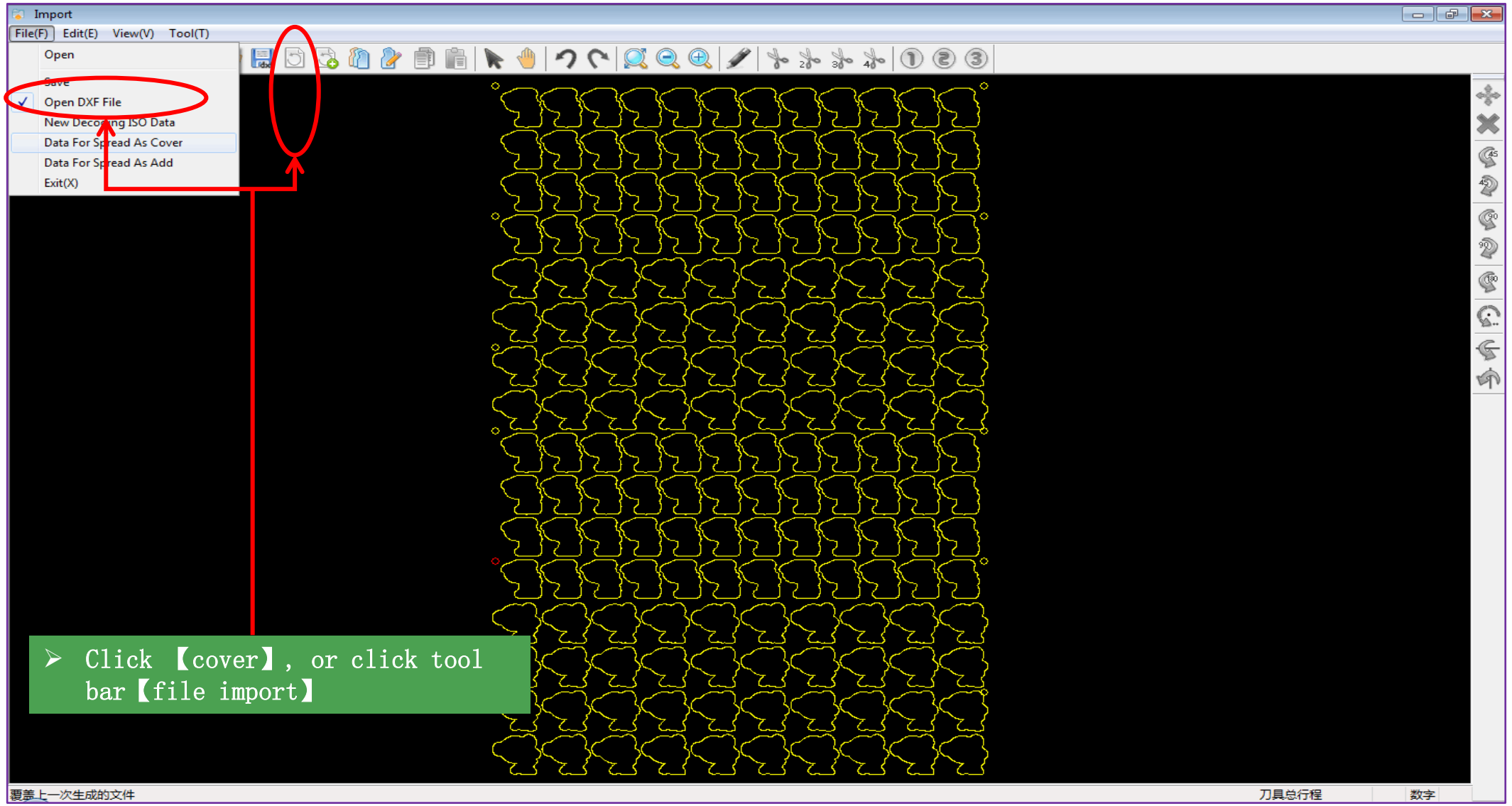
4、When 【Front blade side’s revolve distance】is same as hole value of【EOT】, then the hole value Should be set as 1 after each time changing into new blade.

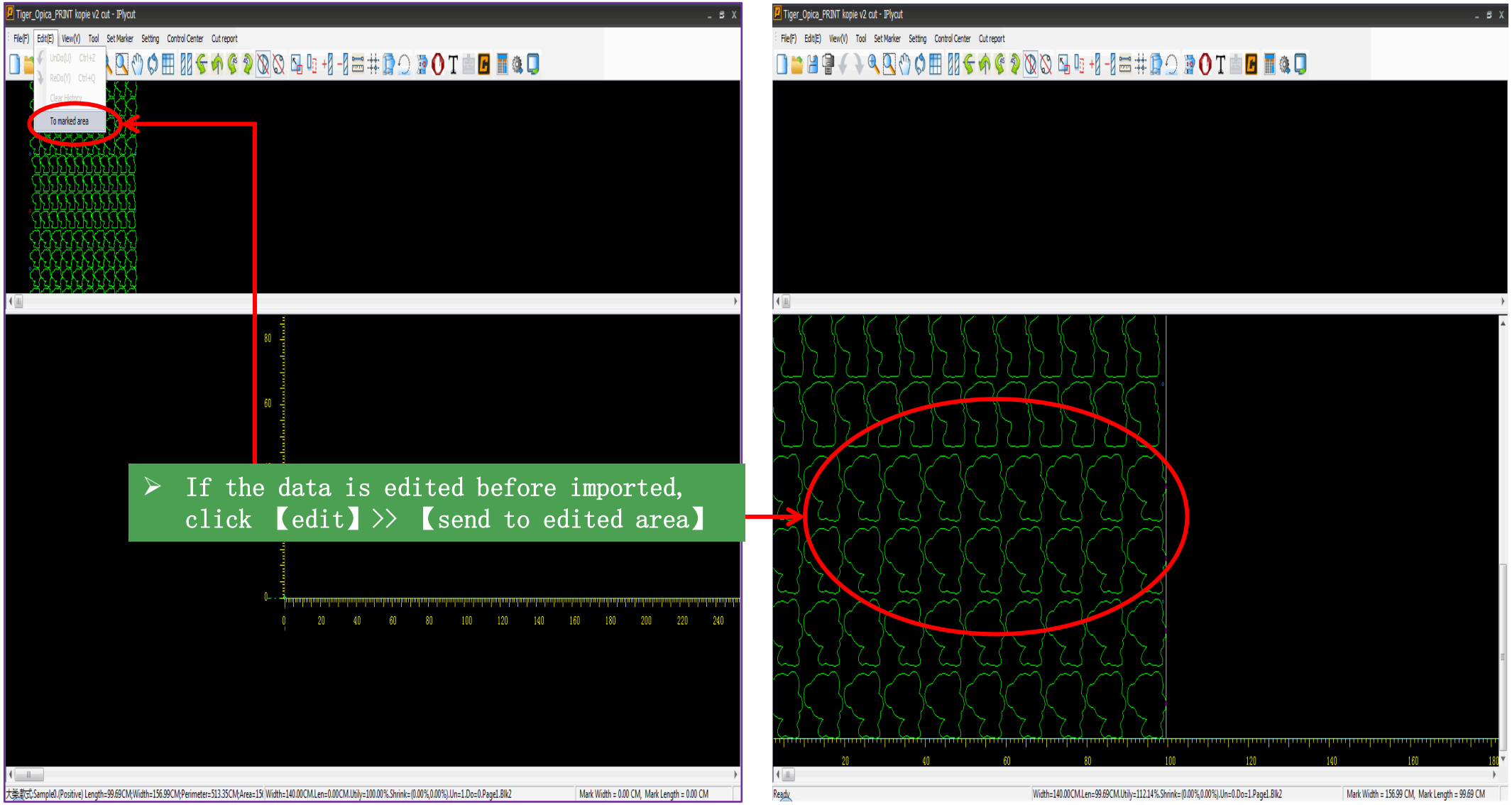

CutterServer
File(F) View(V) Configuration(T) Help(H)
Parameter Set
Knife holder/knife tool modification
Parameter item
Value
Unit
SOCKET1
EOT
Positive angle of knife and X axis
5.000
limit
Knife-up compensation
0.000
mm
Knife-down compensation
0.000
mm
Knife lifting angel
45.000
limit
X,Y movement speed
0.800
m/s
Knife-lower speed.
1000.000
mm/s
Knife lifting speed
1000.000
mm/s
Movement acceleration
0.600
G
Setting acceleration
Waiting time before setting
Waiting time after setting
Direction to rotate
Eccentricity enable
X eccentric distance
0.000
mm
Y eccentric distance
0.000
mm
Circle + Angle
0.900
limit
Circle - Angle
5.000
limit
-5.000 ~ 5.000
Sure
Apply(A)
Exit(E)
Cutting effect picture after setting compensation for knife lifting and lowering
File
Setting effects of knife lowering compensation
Cutting direction
The red shows the original starting point
Setting effects of knife lifting compensation

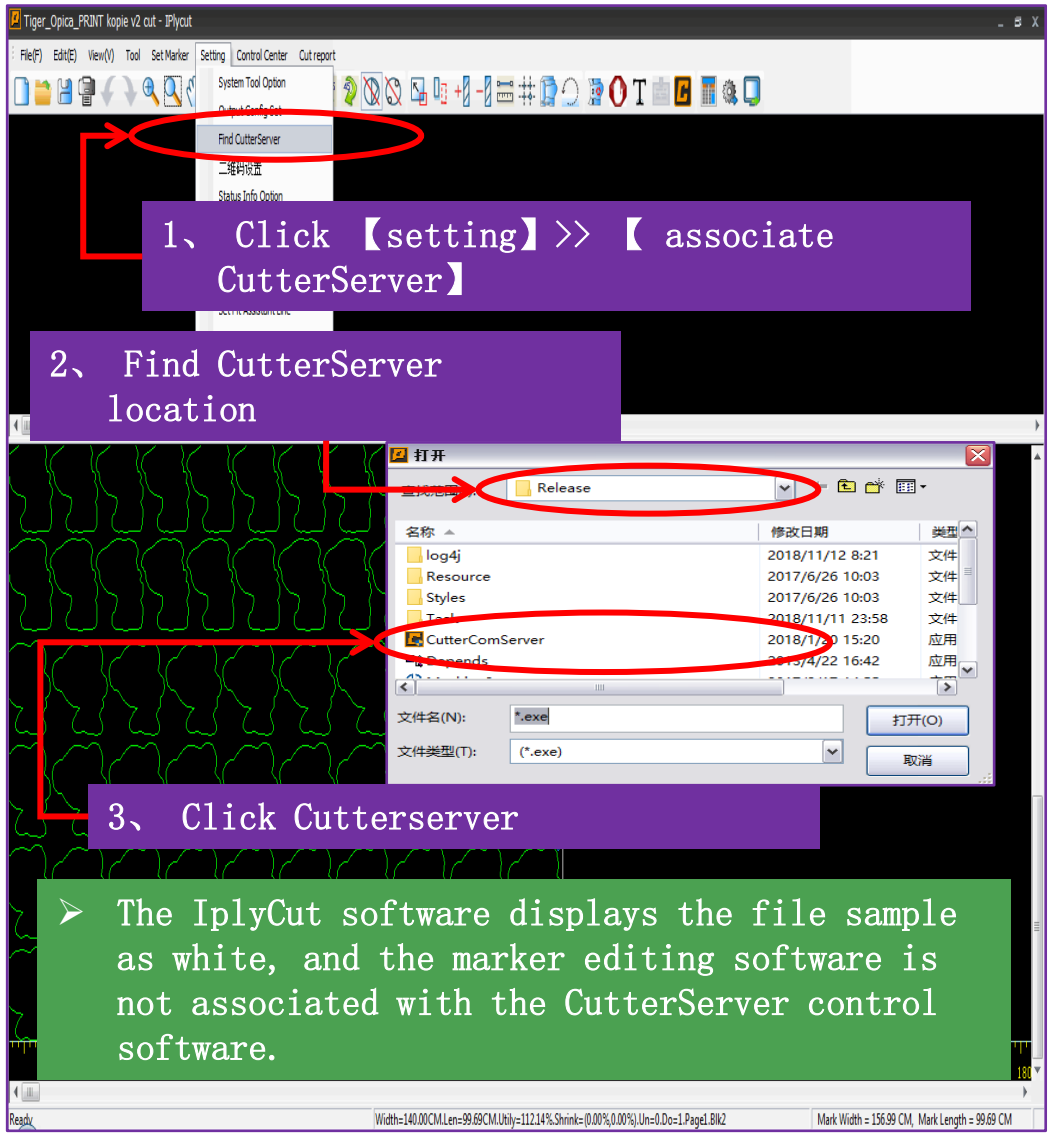

CutterServer
File(F)
View(V)
Configuration(T)
Help(H)
Parameter(P)
Serial Configuration(C)
Language
Automatic Knife Initialization
Gas Hole Setting(G)
Skin
2、 Left click 【Start】in the bottom left corner of the computer interface, and it will pop up a dialog box. Right click 【Computer】, and left click【Device manager】 in which left click “COM Port” to search relative COM port.
1、 Left click 【Serial port configuration】 under 【MSConfig】 in the CutterServer. It will pop up 【Choose serial port number】dialog box. COM port can be matched to each COM port in the dialog box.
Select Serial No.
Serial No.:
COM20
Serial No.(485):
COM21
Mill Serial Port:
COM1
COM21
COM20
Sure
Cancel
IECHO-PC
Computer
Disk drives
Display adapters
DVD/CD-ROM drives
Human Interface Devices
IDE ATA/ATAPI controllers
Keyboards
Mice and other pointing devices
Monitors
Network adapters
Portable Devices
Ports (COM & LPT)
USB Serial Port (COM20)
USB Serial Port (COM21)
Sound, video and game controllers
System devices
Universal Serial Bus controllers
➢ When the machine has been reset successfully or is lying idle, the communication port of CutterServer turns grey, which shows that the cutting control software is not connected to the equipment and it can be connected by serial port setup (The green color shows the successful connection).
Log view
Task view
Gas Set
System Para
Ready
EOT Select
Cutting completed.
Cutting completed.
Serial port.COM20
Vac
Coordinate: 410.23 * 1095.28 C: 0.00, H: 0.00
Model BK0(Single Machine)

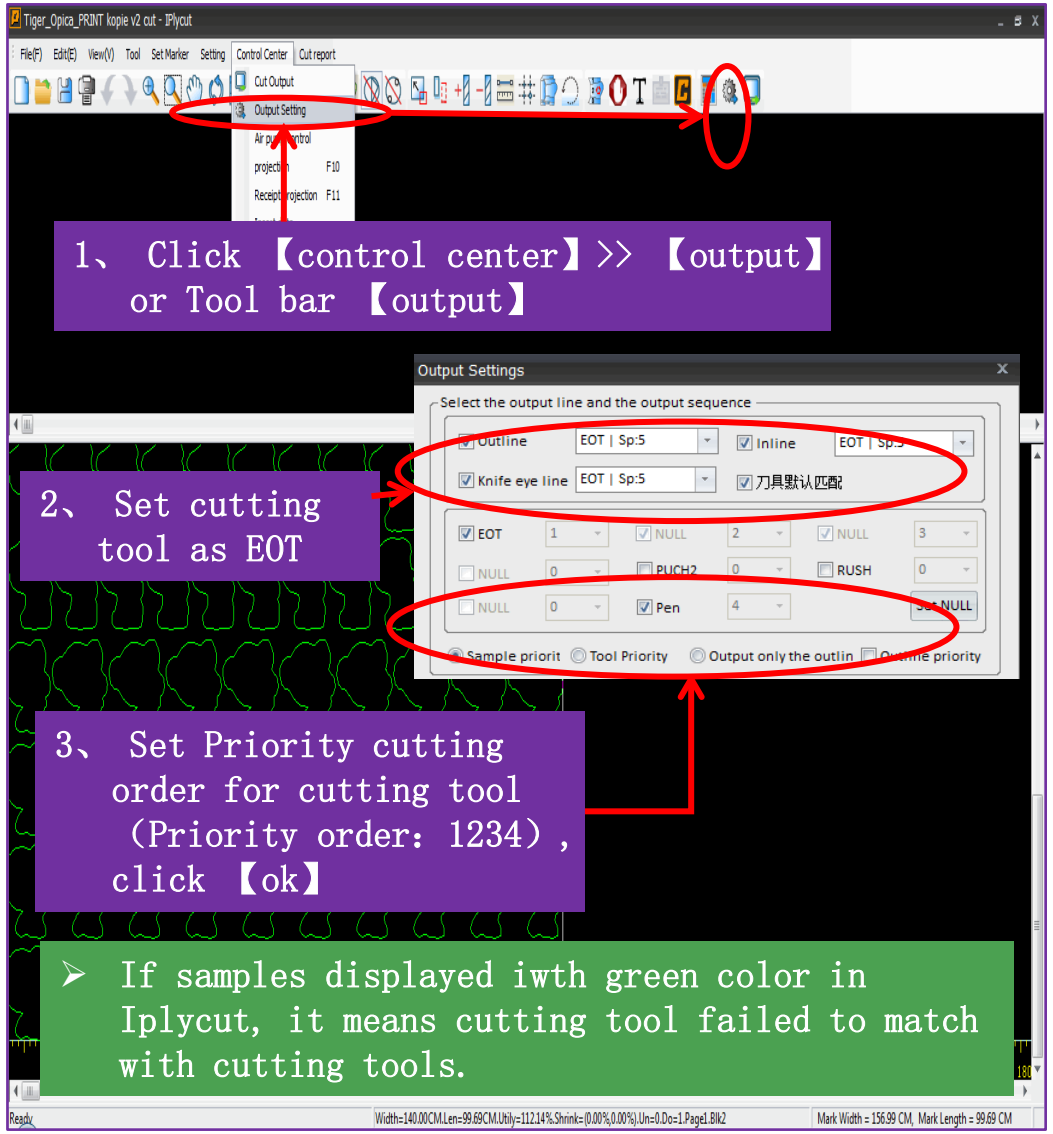

No Title - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
点击这里开始识别二维码!
Tool icon Chinese definition （ put mouse on the tool icon button, to display the Chinese definition ）
Not edited area
Edited area
Click CutterServer to start control software
Ready
Width=160.00CM.Len=0.00CM.Utily=100.00%.Shrink=(0.00%,0.00%).Un=0.Do=0.Page1.Blk1
Mark Width = 0.00 CM, Mark Length = 0.00 CM

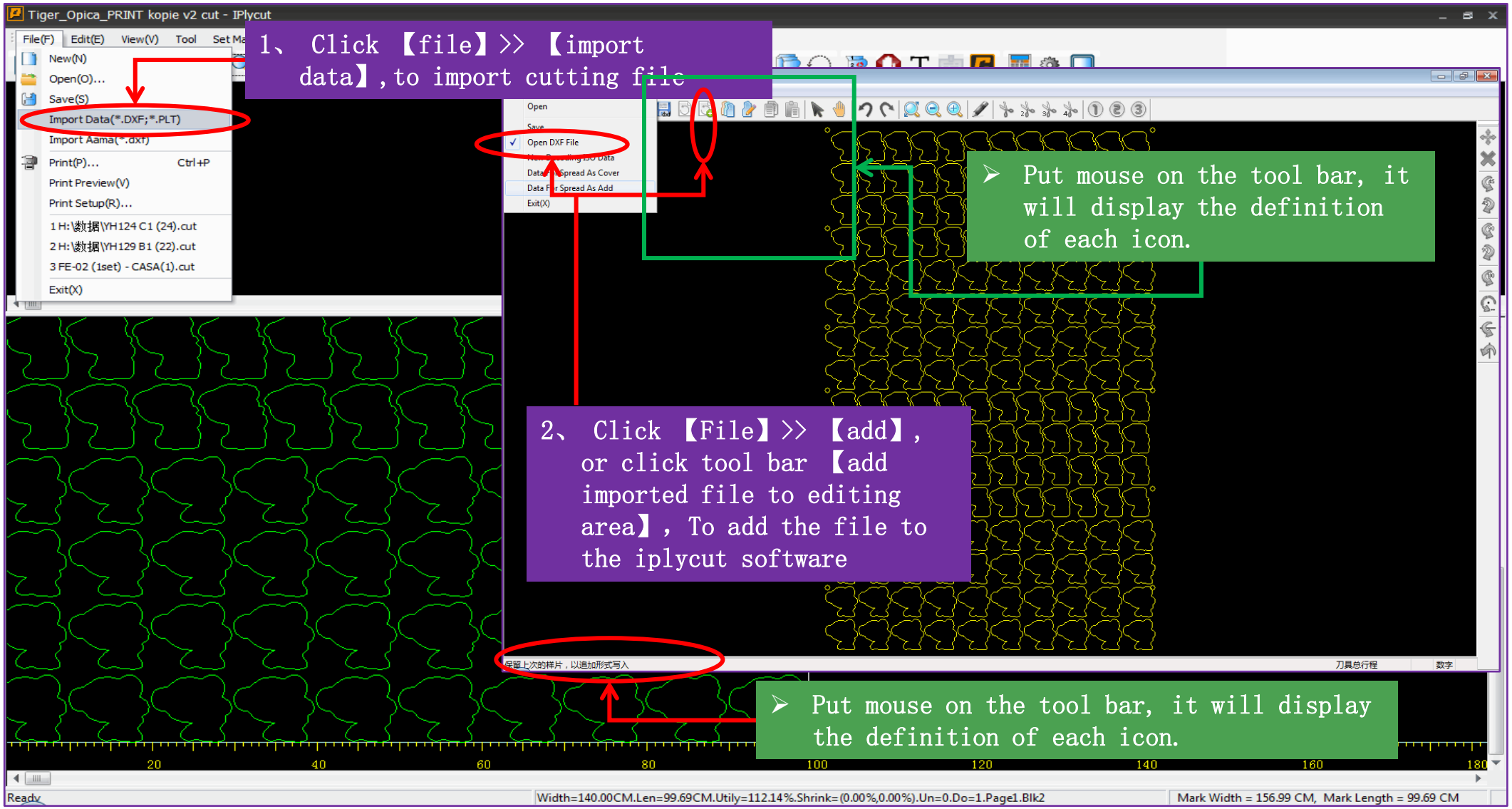

1、 Click 【file】 << 【import file *DXF, PLT*】
4、 Browse
3、 Set data scale
5、 Browse and find file position on PC
7、Click OK
➢ Data format compatible
2、 Select original data unit (or output data format)
6、 Input file name to search cutting data , click 【open】
Import Data(*.DXF;*.PLT)
Open File
Import parameter
Browse
Last Plt
OK
Cancel
Open
Look in: Desktop
Name
Unspecified (4)
IECHO
Computer
Network
FSCrossHair.exe
2312.dxf
File name:
Cancel
file(*.plt,*.dxf,*.prt,*.iso,*.pdf,*.xml,*.cut,*.nc)
Kry file(*.kry)
Ready
Width=140.00CM.Len=343.25CM.Utily=57.15%.Shrink=(0.00%,0.00%).Un=17.Do=35.Page1.Blk2
Mark Width = 136.27 CM, Mark Length = 343.25 CM

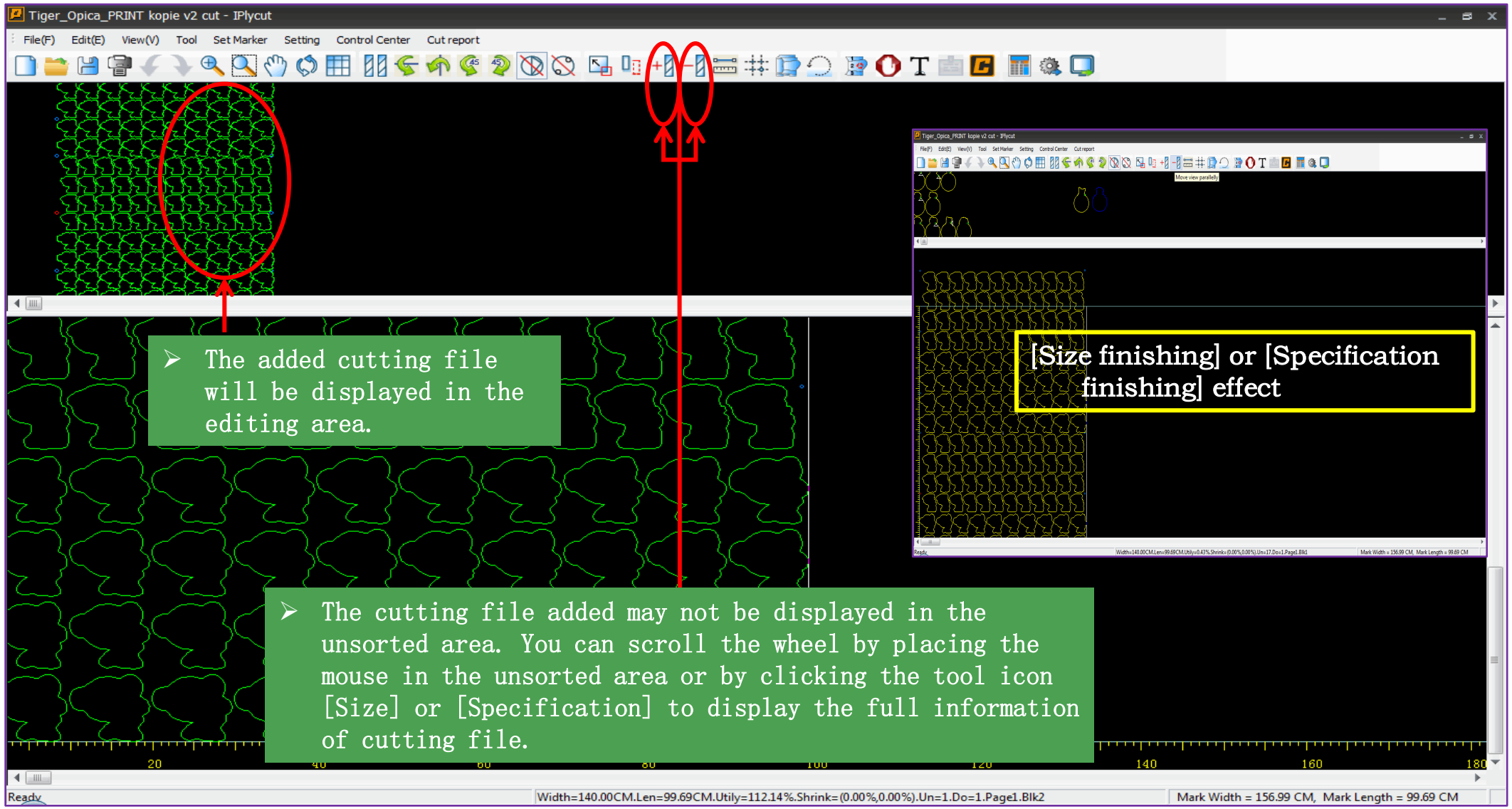

Import
File(F)
Edit(E)
View(V)
Tool(T)
Open
Save
Open DXF File
New Decoding ISO Data
Data For Spread As Cover
Data For Spread As Add
Exit(X)
Click 【cover】, or click tool bar【file import】
覆盖上一次生成的文件
刀具总行程
数字

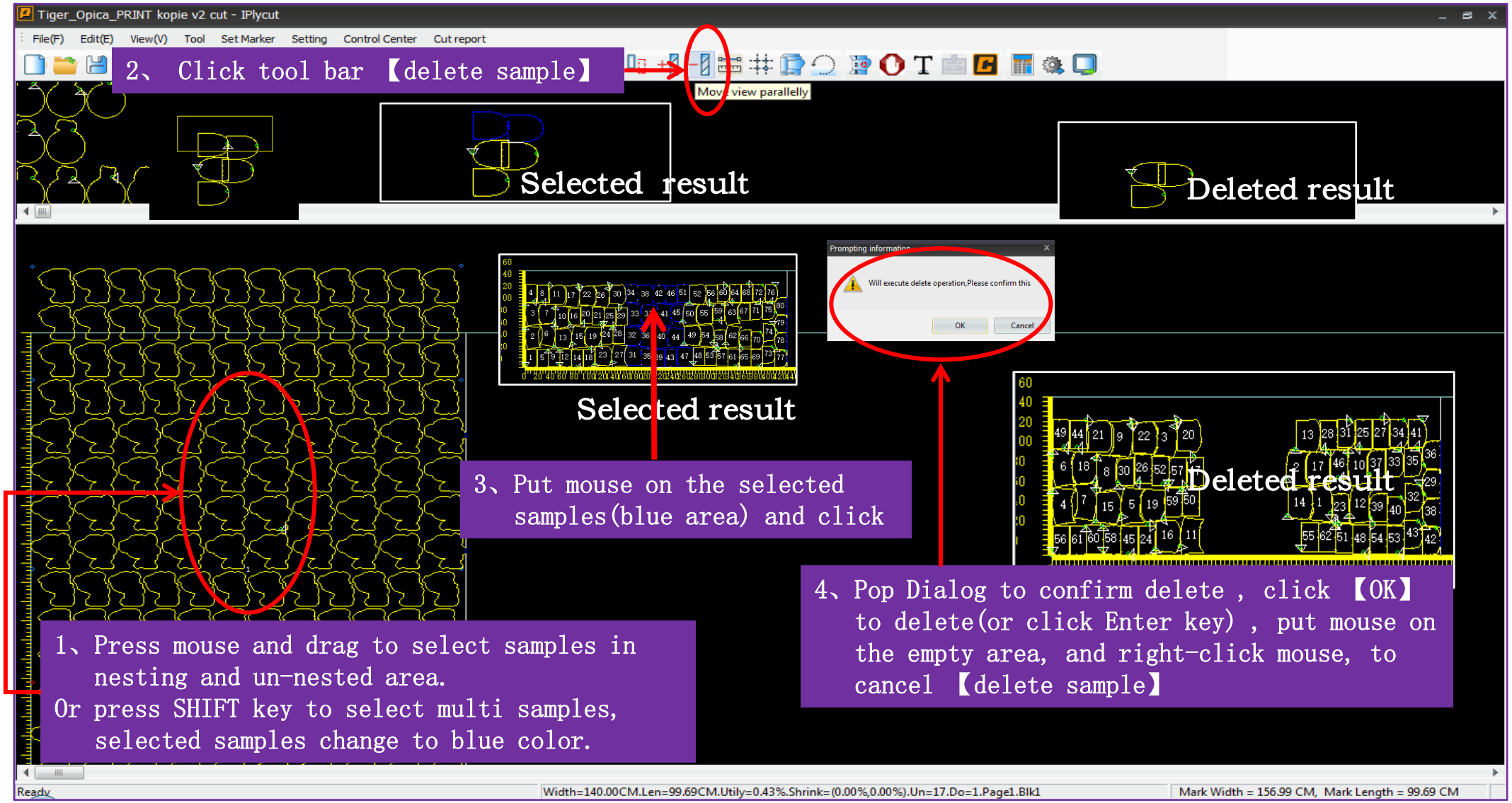

Tiger_Opica_PRINT kopie v2 cut - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
UnDo(U) Ctrl+Z
ReDo(Y) Ctrl+Q
Clear History
To marked area
If the data is edited before imported,
click 【edit】>> 【send to edited area】
Tiger_Opica_PRINT kopie v2 cut - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report


1、 Click 【setting】>> 【 associate CutterServer】
2、 Find CutterServer location
3、 Click Cutterserver
➢ The IplyCut software displays the file sample as white, and the marker editing software is not associated with the CutterServer control software.

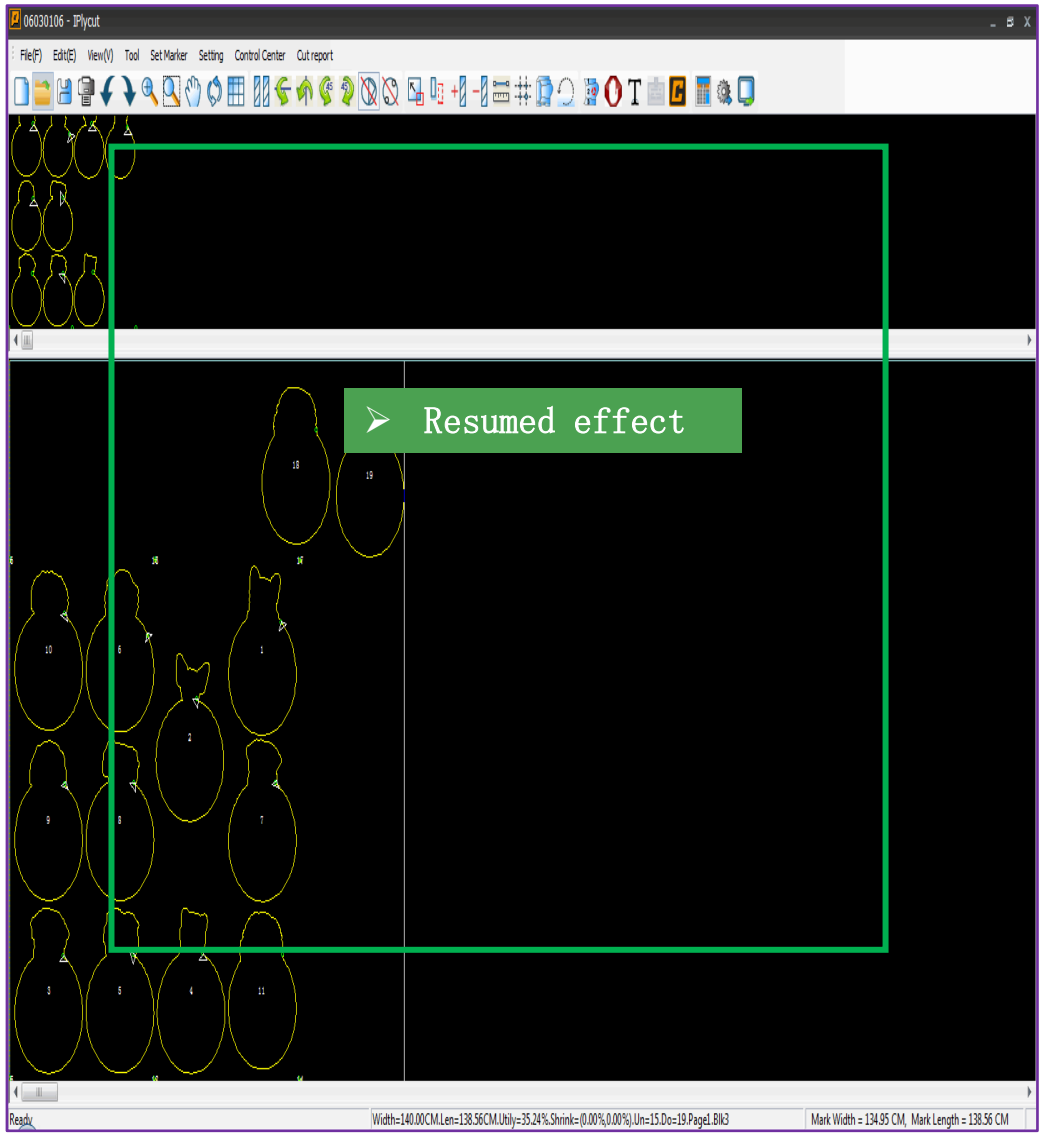

1、 Click 【control center】>> 【output】 or Tool bar 【output】
2、 Set cutting tool as EOT
3、 Set Priority cutting order for cutting tool (Priority order: 1234), click 【ok】
➢ If samples displayed iwth green color in Iplycut, it means cutting tool failed to match with cutting tools.

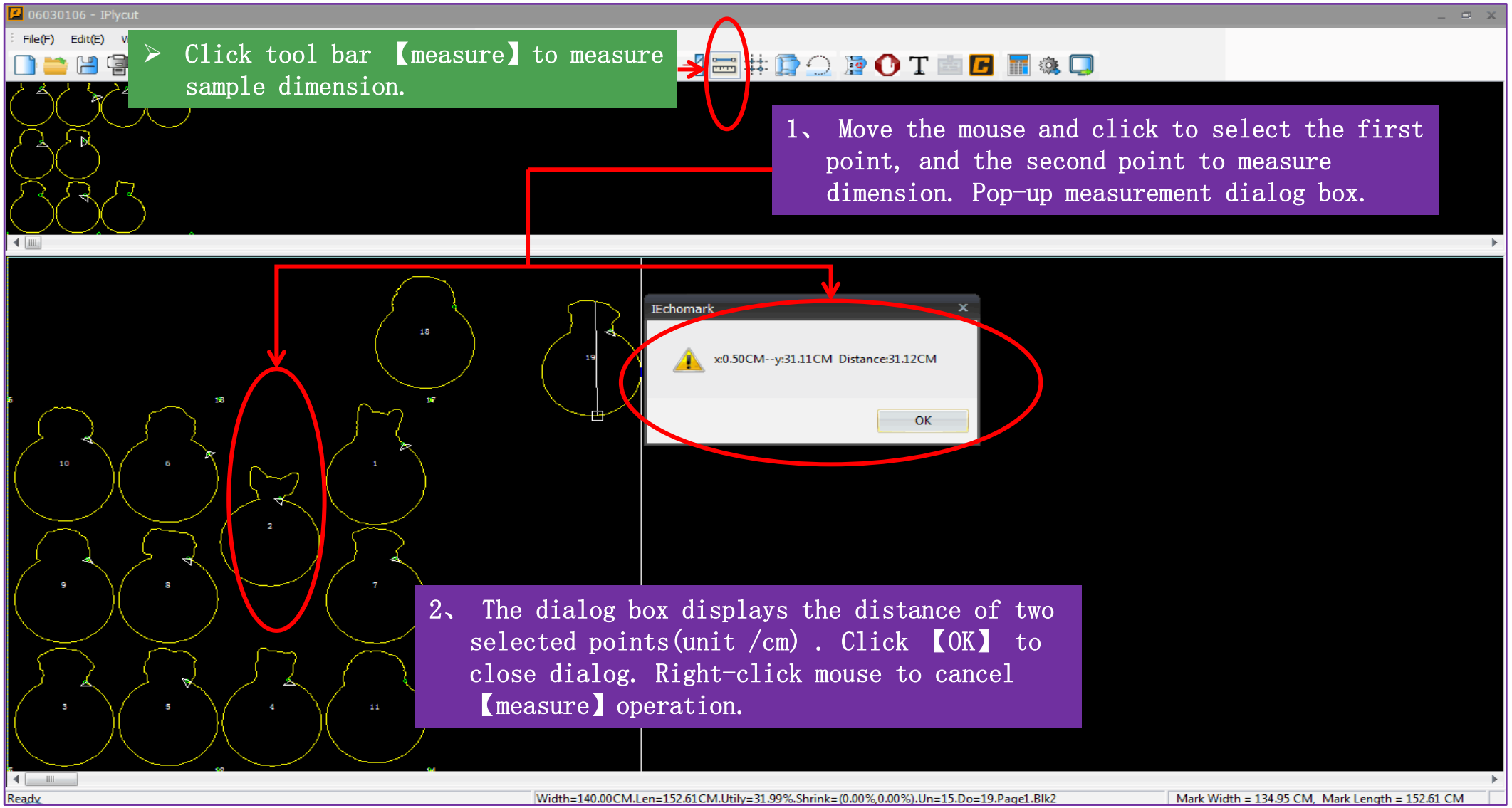

Tiger_Opica_PRINT kopie v2 cut - IPlycut
File(F)
Edit(E)
View(V)
Tool
New(N)
Open(O)...
Save(S)
Import Data(*.DXF;*.PLT)
Import Aama(*.dxf)
Print(P)... Ctrl+P
Print Preview(V)
Print Setup(R)...
1 H:\数据\YH124 C1 (24).cut
2 H:\数据\YH129 B1 (22).cut
3 FE-02 (1set) - CASA(1).cut
Exit(X)
1、 Click 【file】>> 【import data】,to import cutting file
Open
Open DXF File
Exit(X)
➢ Put mouse on the tool bar, it will display the definition of each icon.
2、 Click 【File】>> 【add】, or click tool bar 【add imported file to editing area】, To add the file to the iplycut software
➢ Put mouse on the tool bar, it will display the definition of each icon.
20
40
60
80
100
120
140
160
180
Ready
Width=140.00CM.Len=99.69CM.Utily=112.14%.Shrink=(0.00%,0.00%).Un=0.Do=1.Page1.Blk2
Mark Width = 156.99 CM, Mark Length = 99.69 CM

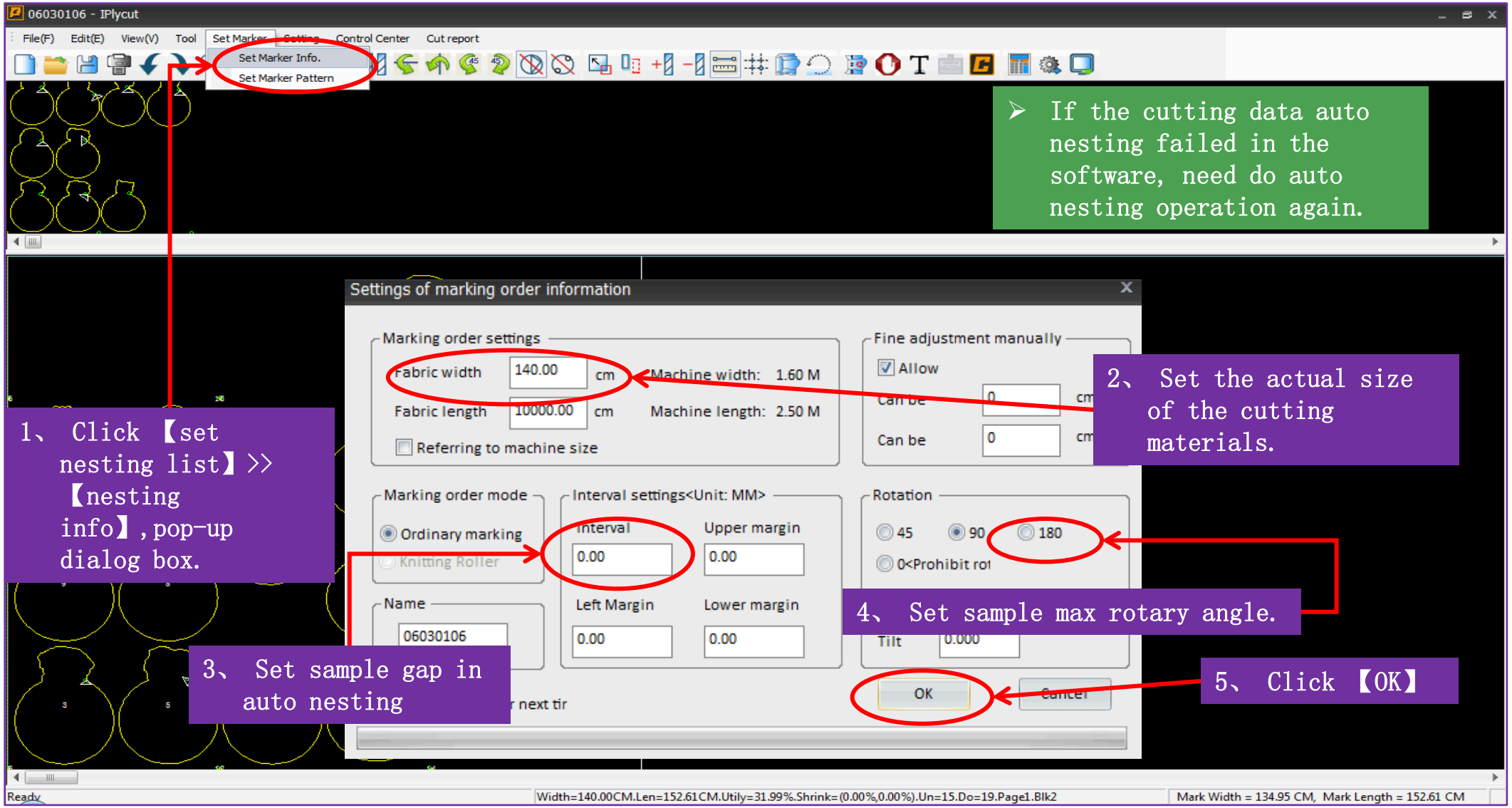

Tiger_Opica_PRINT kopie v2 cut - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
➢ The added cutting file will be displayed in the editing area.
[Size finishing] or [Specification finishing] effect
➢ The cutting file added may not be displayed in the unsorted area. You can scroll the wheel by placing the mouse in the unsorted area or by clicking the tool icon [Size] or [Specification] to display the full information of cutting file.
20 40 60 80 100 120 140 160 180
Ready
Width=140.00CM.Len=99.69CM.Utily=112.14%.Shrink=(0.00%,0.00%).Un=1.Do=1.Page1.Blk2
Mark Width = 156.99 CM, Mark Length = 99.69 CM

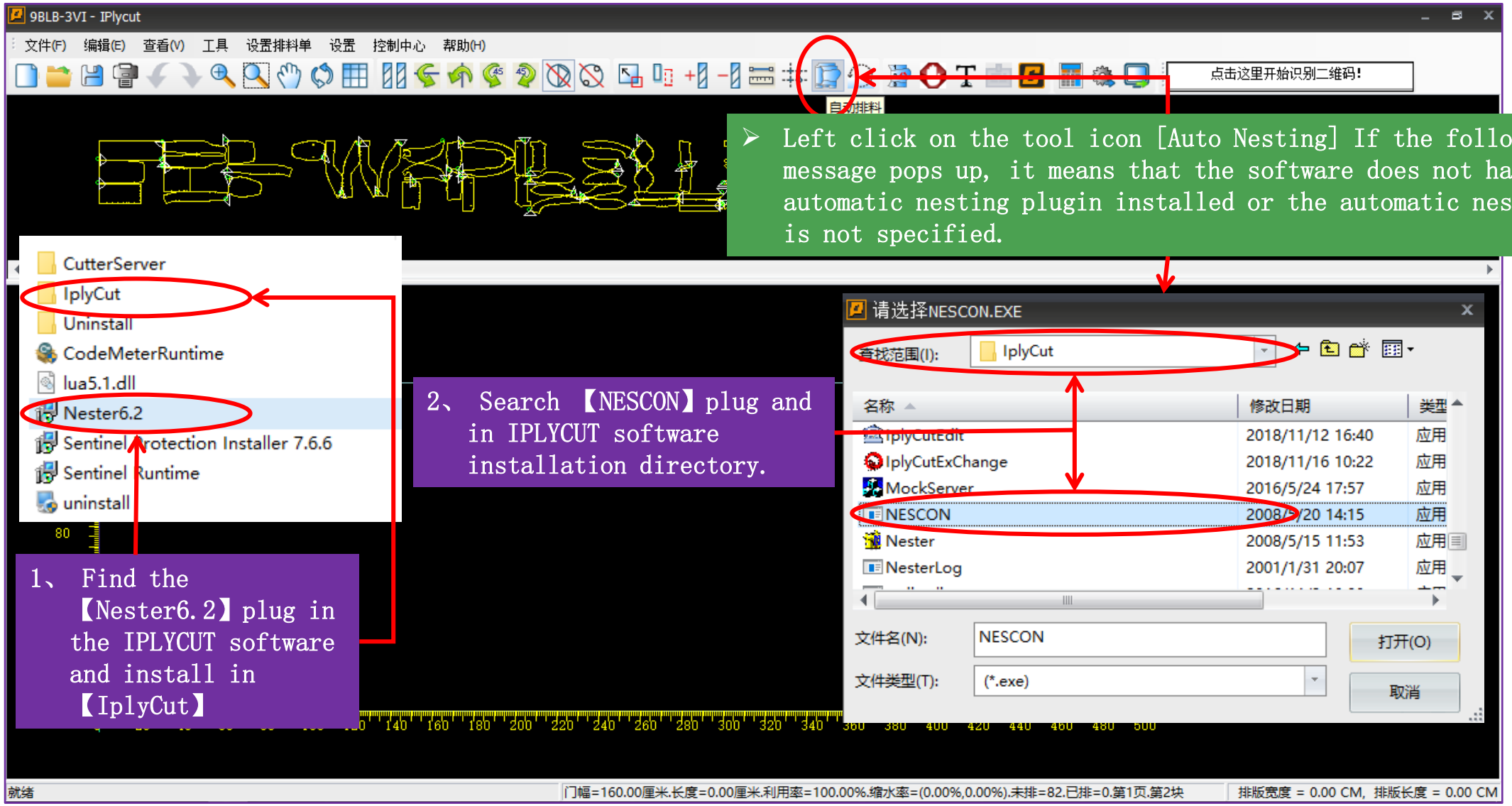

Tiger_Opica_PRINT kopie v2 cut - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
2、 Click tool bar 【delete sample】
Move view parallelly
Selected result
Deleted result
Selected result
Prompting information
Will execute delete operation,Please confirm this
OK
Cancel
Deleted result
3、Put mouse on the selected samples(blue area) and click
1、Press mouse and drag to select samples in nesting and un-nested area.
Or press SHIFT key to select multi samples, selected samples change to blue color.
4、Pop Dialog to confirm delete , click 【OK】 to delete(or click Enter key) , put mouse on the empty area, and right-click mouse, to cancel 【delete sample】
Ready
Width=140.00CM.Len=99.69CM.Utily=0.43%.Shrink=(0.00%,0.00%).Un=17.Do=1.Page1.Blk1
Mark Width = 156.99 CM, Mark Length = 99.69 CM

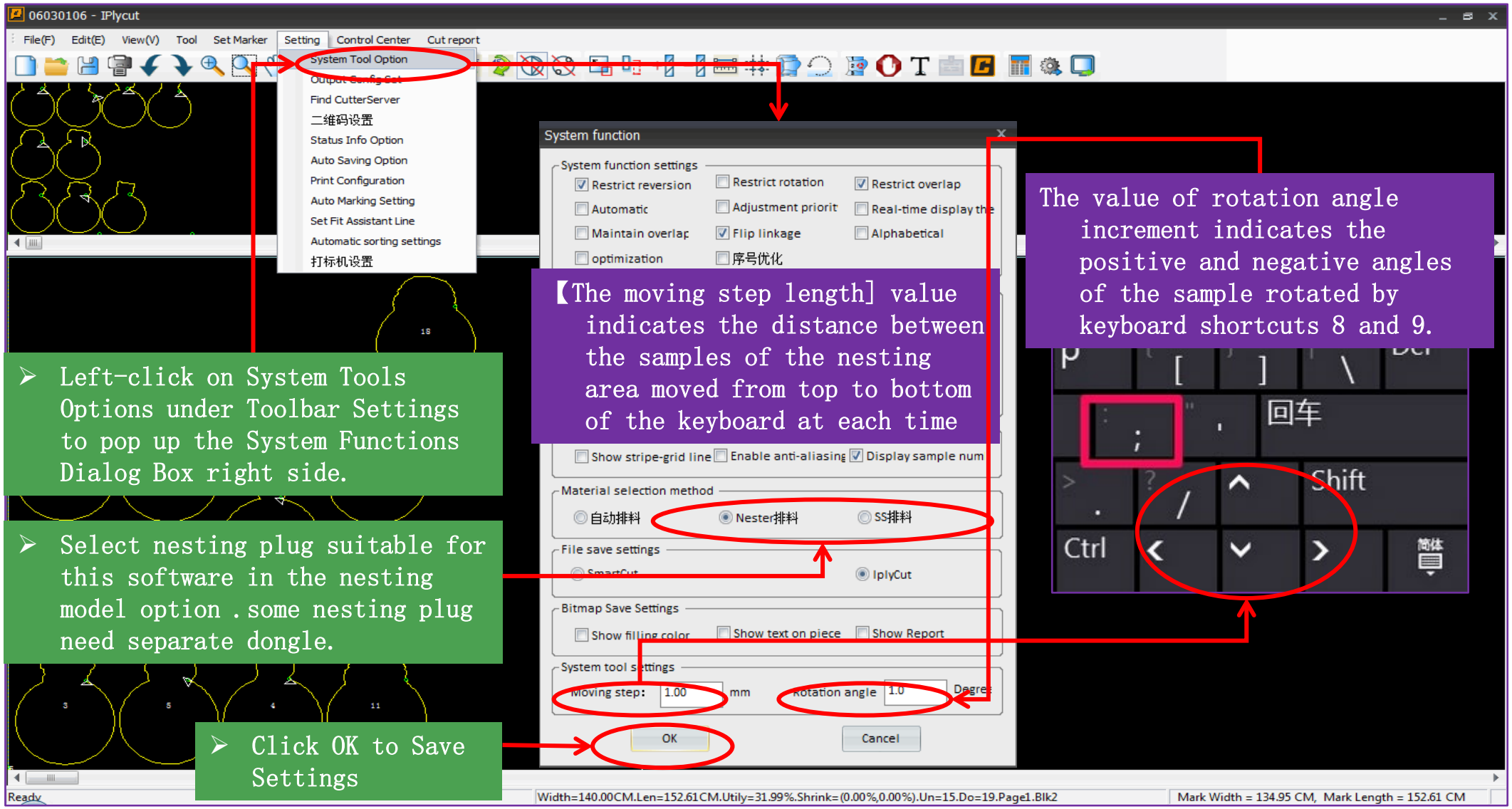

06030106 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
➢ Click tool bar 【Cancel】or 【repeat】, back to last operation state.
Mark Width = 134.95 CM, Mark Length = 138.56 CM

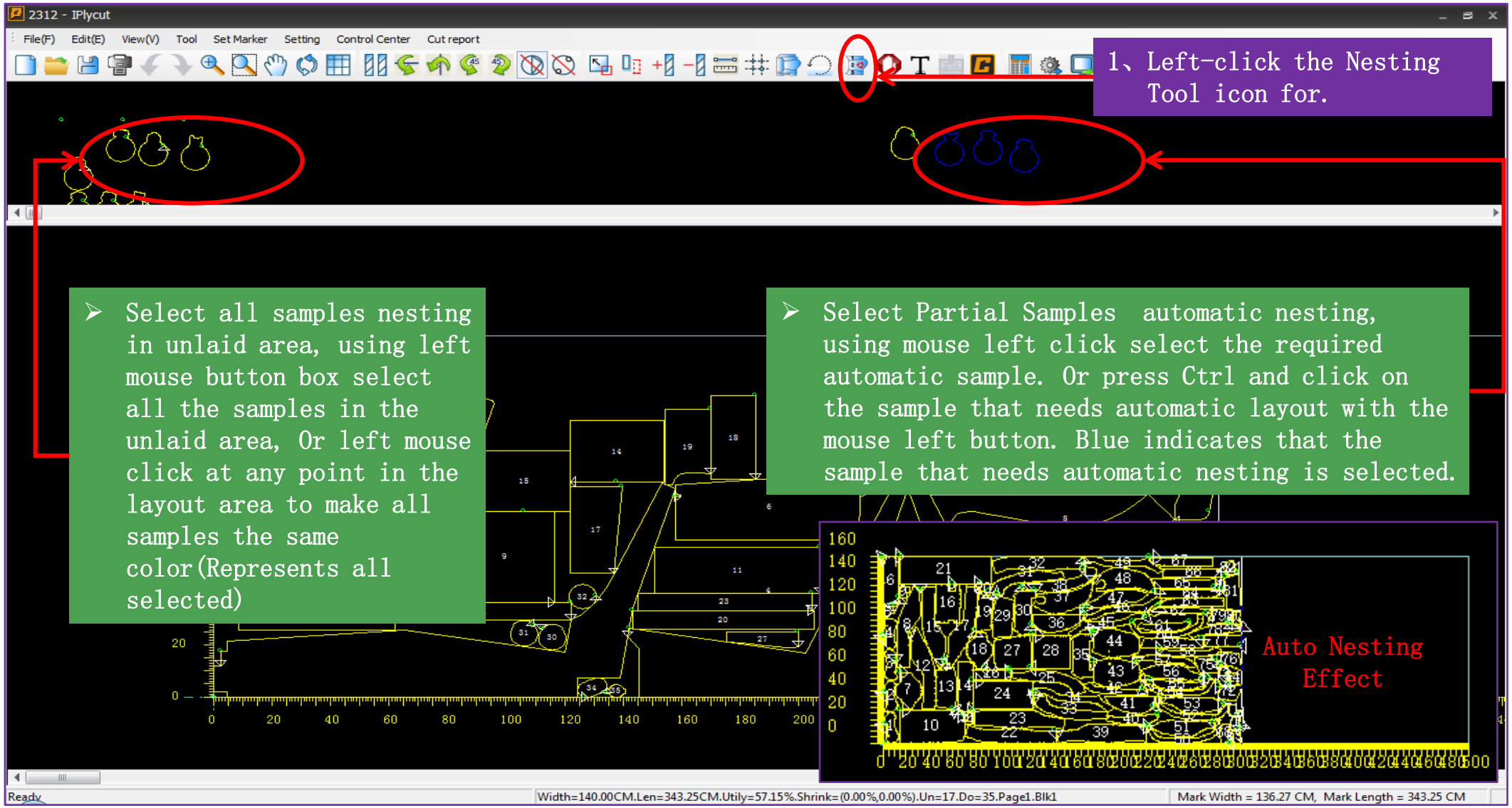

06030106 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
➢ Resumed effect
Ready
Mark Width = 134.95 CM, Mark Length = 138.56 CM

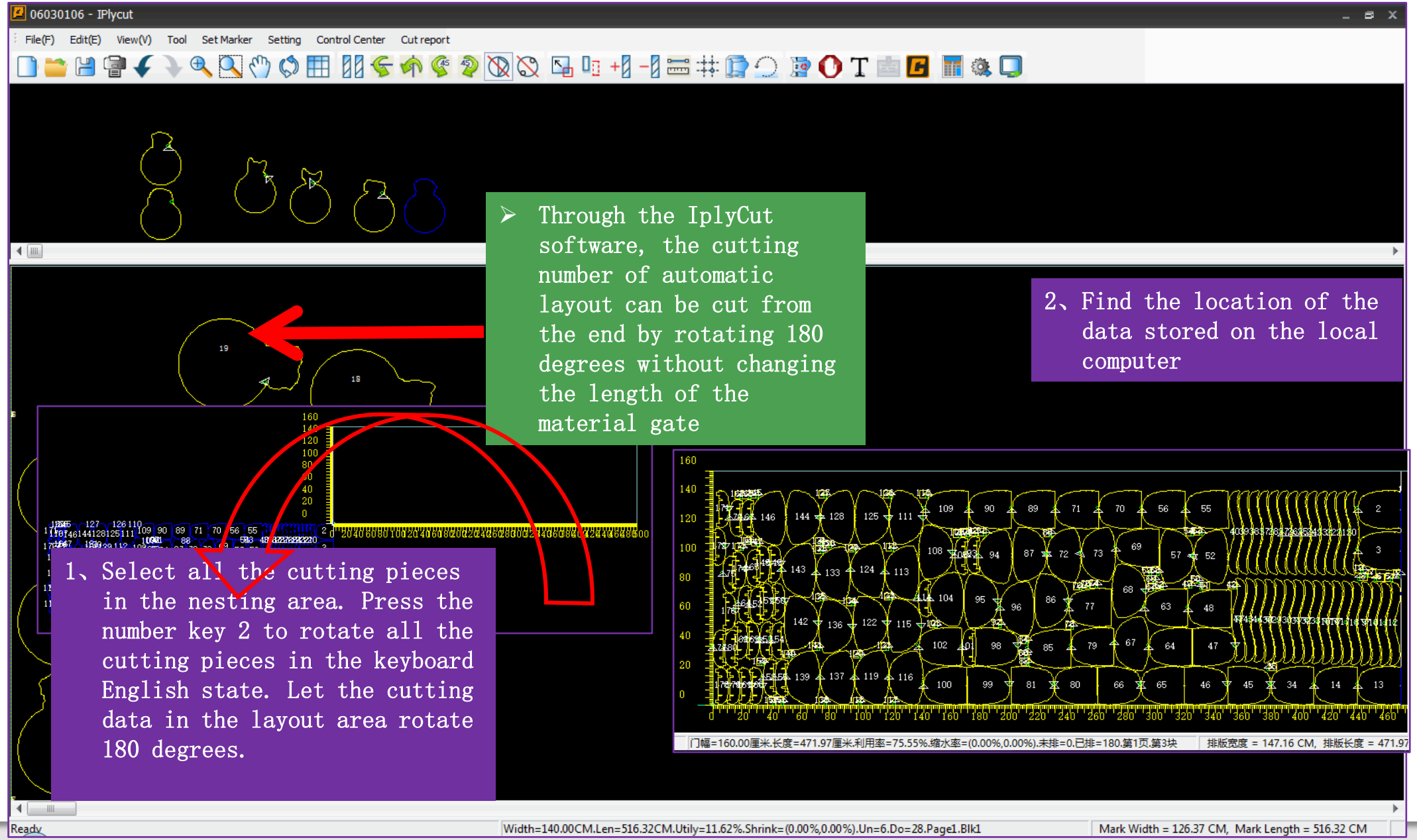

06030106 - IPlycut
File(F)
Edit(E)
➢ Click tool bar 【measure】to measure sample dimension.
1、 Move the mouse and click to select the first point, and the second point to measure dimension. Pop-up measurement dialog box.
IEchomark
x:0.50CM--y:31.11CM Distance:31.12CM
OK
2、 The dialog box displays the distance of two selected points(unit /cm) . Click 【OK】 to close dialog. Right-click mouse to cancel 【measure】operation.
Ready
Width=140.00CM.Len=152.61CM.Utily=31.99%.Shrink=(0.00%,0.00%).Un=15.Do=19.Page1.Blk2
Mark Width = 134.95 CM, Mark Length = 152.61 CM

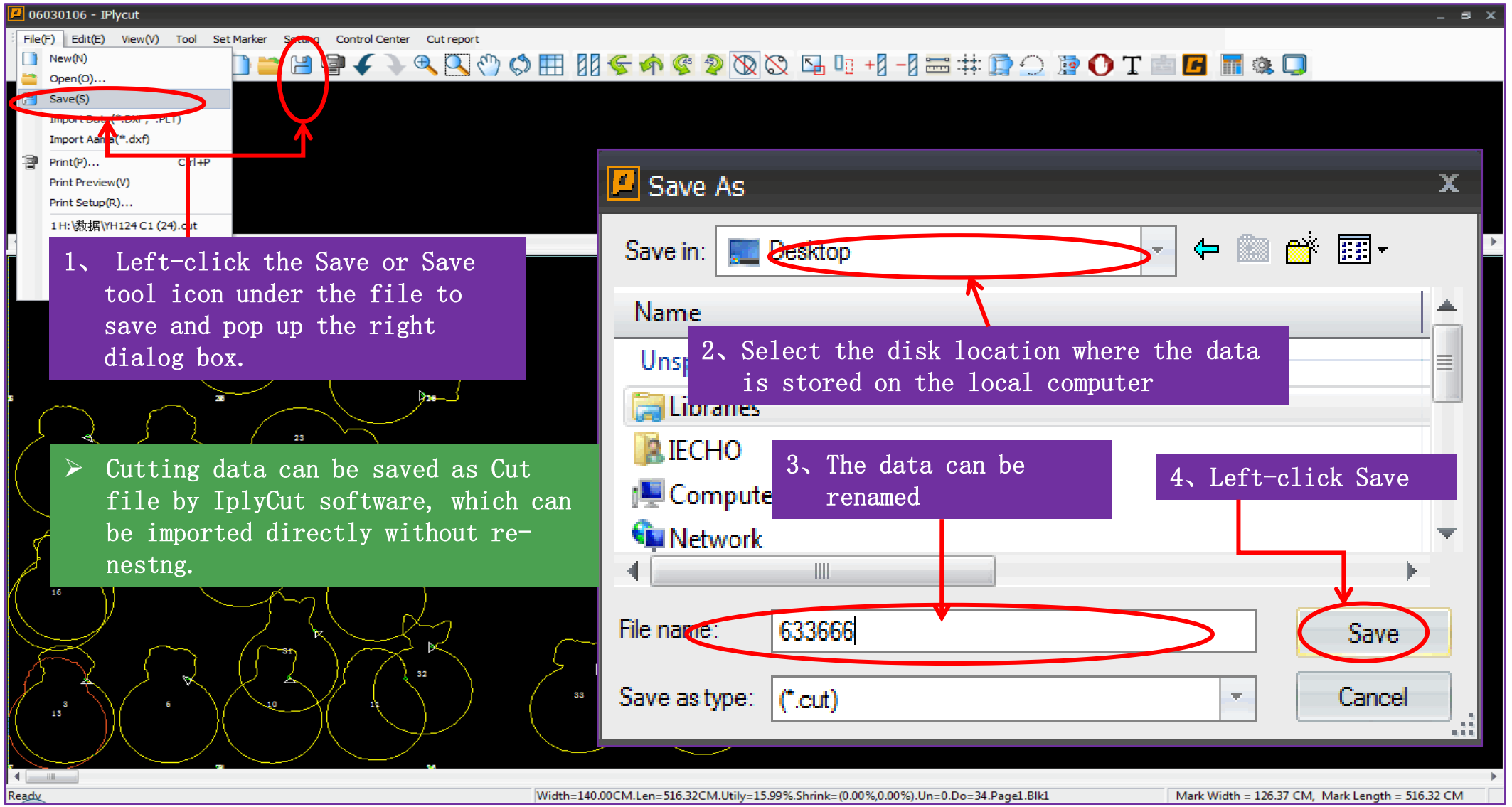

06030106 - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Setting
Control Center
Cut report
Set Marker Info.
Set Marker Pattern
➢ If the cutting data auto nesting failed in the software, need do auto nesting operation again.
Settings of marking order information
Marking order settings
Fabric width
140.00
cm
Machine width: 1.60 M
Fabric length
10000.00
cm
Machine length: 2.50 M
Referring to machine size
Fine adjustment manually
Allow
Can be
0
cm
Can be
0
cm
1、 Click 【set nesting list】>> 【nesting info】,pop-up dialog box.
2、 Set the actual size of the cutting materials.
Marking order mode
Ordinary marking
Knitting Roller
Interval settings<Unit: MM>
Interval
0.00
Upper margin
0.00
Left Margin
0.00
Lower margin
0.00
Rotation
45
90
180
0<Prohibit rot
4、 Set sample max rotary angle.
Name
06030106
3、 Set sample gap in auto nesting
Tilt
0.000
next tir
OK
Cancel
5、 Click 【OK】
Ready
Width=140.00CM.Len=152.61CM.Utily=31.99%.Shrink=(0.00%,0.00%).Un=15.Do=19.Page1.Blk2
Mark Width = 134.95 CM, Mark Length = 152.61 CM

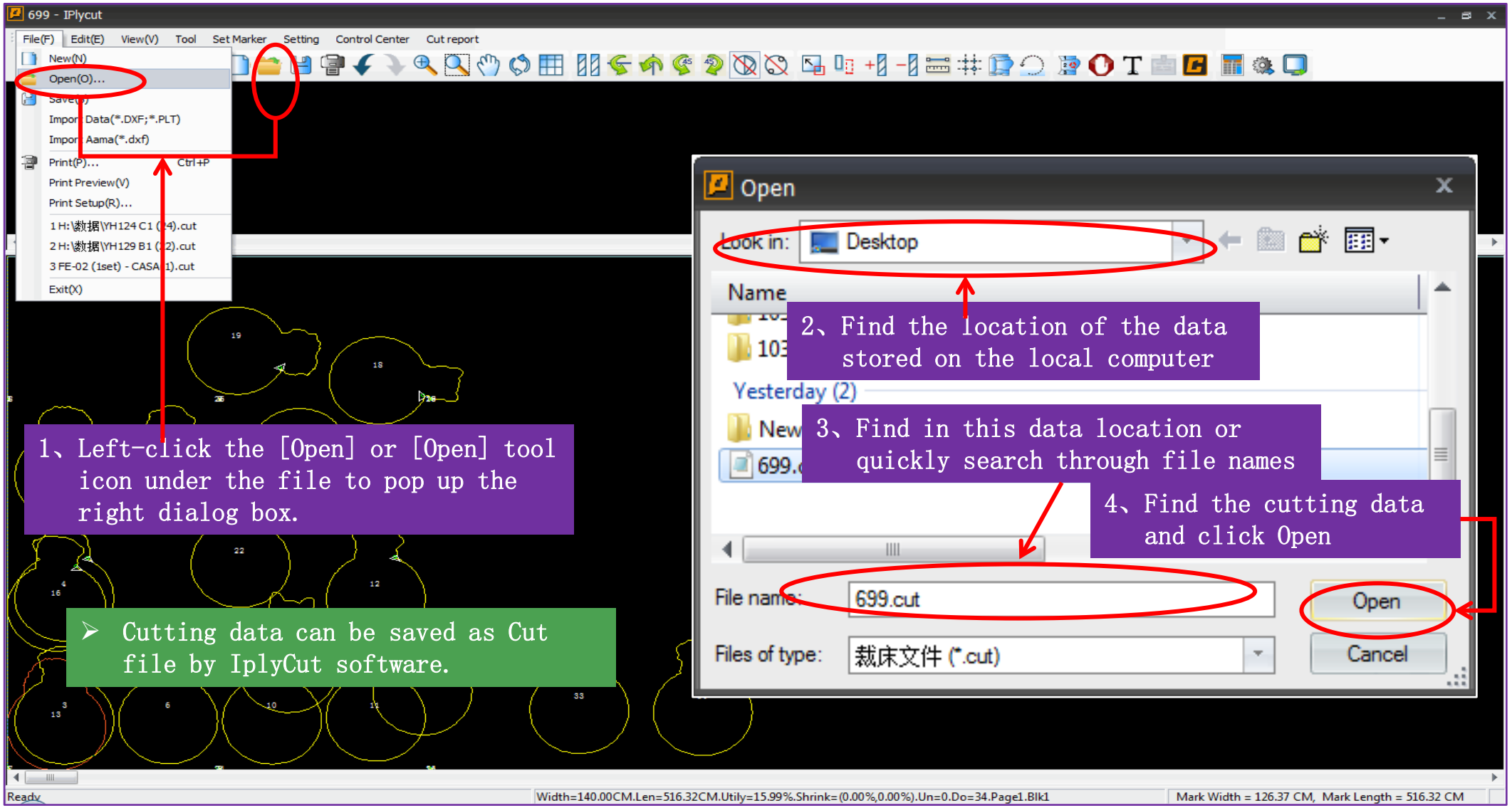

9BLB-3VI - IPlycut
文件(F) 编辑(E) 查看(V) 工具 设置排料单 设置 控制中心 帮助(H)
点击这里开始识别二维码!
自动排料
CutterServer
IplyCut
Uninstall
CodeMeterRuntime
lua5.1.dll
Nester6.2
Sentinel Protection Installer 7.6.6
Sentinel Runtime
uninstall
➢ Left click on the tool icon [Auto Nesting] If the following message pops up, it means that the software does not have the automatic nesting plugin installed or the automatic nesting is not specified.
2、 Search 【NESCON】plug and in IPLYCUT software installation directory.
1、 Find the 【Nester6.2】plug in the IPLYCUT software and install in 【IplyCut】
请选择NESCON.EXE
查找范围(I): IplyCut
名称 修改日期 类型
IplyCutEdit 2018/11/12 16:40 应用
IplyCutExChange 2018/11/16 10:22 应用
MockServer 2016/5/24 17:57 应用
NESCON 2008/5/20 14:15 应用
Nester 2008/5/15 11:53 应用
NesterLog 2001/1/31 20:07 应用
文件名(N): NESCON
文件类型(T): (*.exe)
打开(O)
取消
就绪
门幅=160.00厘米,长度=0.00厘米,利用率=100.00%,缩水率=(0.00%,0.00%),未排=82,已排=0,第1页,第2块
排版宽度 = 0.00 CM, 排版长度 = 0.00 CM

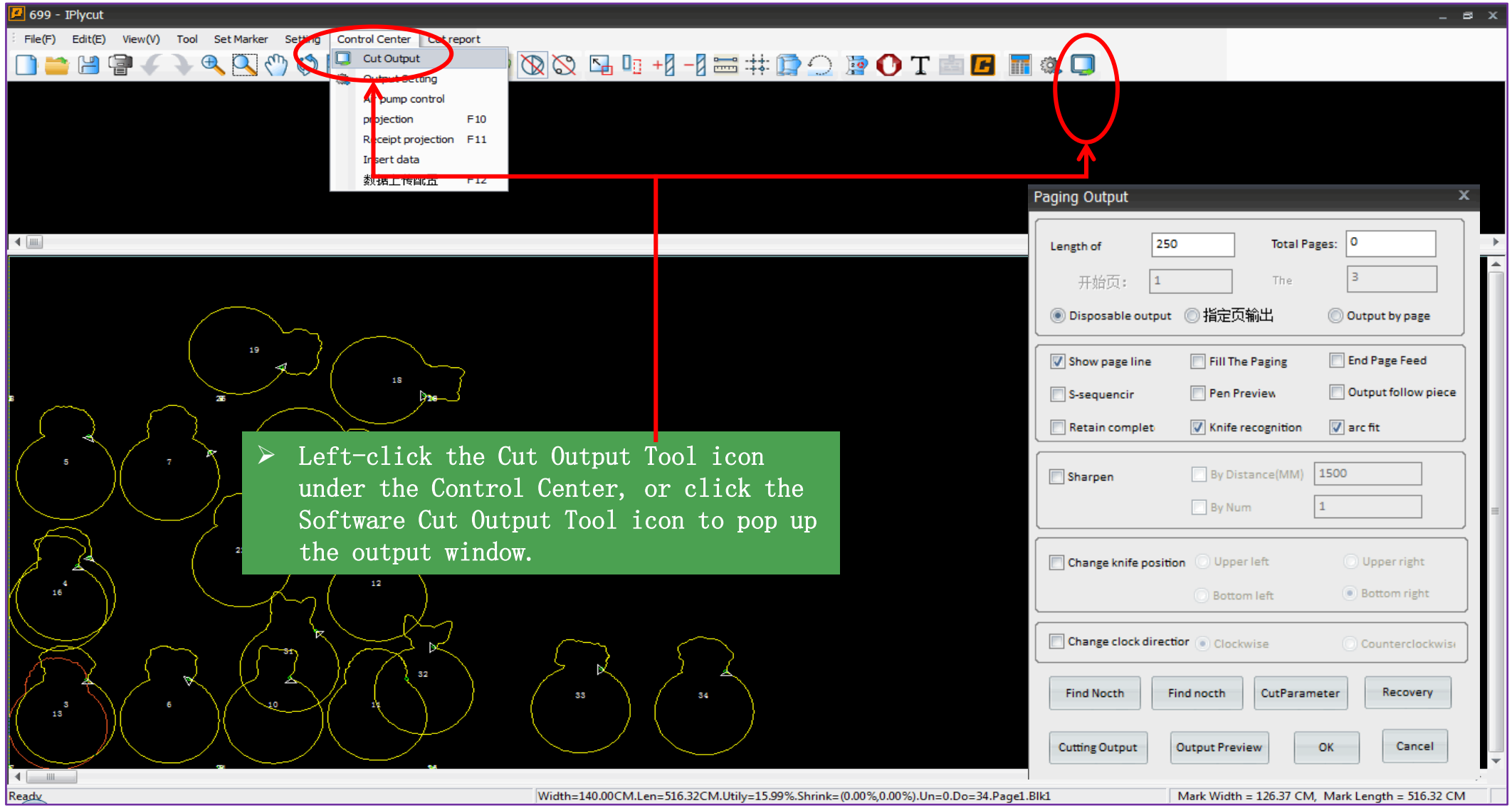

06030106 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
System Tool Option
Find CutterServer
二维码设置
Status Info Option
Auto Saving Option
Print Configuration
Auto Marking Setting
Set Fit Assistant Line
Automatic sorting settings
打标机设置
System function
System function settings
Restrict reversion
Restrict rotation
Restrict overlap
Automatic
Adjustment priorit
Real-time display the
Maintain overlap
Flip linkage
Alphabetical
optimization
序号优化
Show stripe-grid line
Enable anti-aliasing
Display sample num
Material selection method
自动排料
Nester排料
SS排料
File save settings
SmartCut
IplyCut
Bitmap Save Settings
Show filling color
Show text on piece
Show Report
System tool settings
Moving step: 1.00 mm
Rotation angle 1.0 Degree
OK
Cancel
Ready
Width=140.00CM.Len=152.61CM.Utily=31.99%.Shrink=(0.00%,0.00%).Un=15.Do=19.Page1.Blk2
Mark Width = 134.95 CM, Mark Length = 152.61 CM
Left-click on System Tools Options under Toolbar Settings to pop up the System Functions Dialog Box right side.
Select nesting plug suitable for this software in the nesting model option . some nesting plug need separate dongle.
Click OK to Save Settings
【The moving step length] value indicates the distance between the samples of the nesting area moved from top to bottom of the keyboard at each time
The value of rotation angle increment indicates the positive and negative angles of the sample rotated by keyboard shortcuts 8 and 9.
回车
Shift
Ctrl

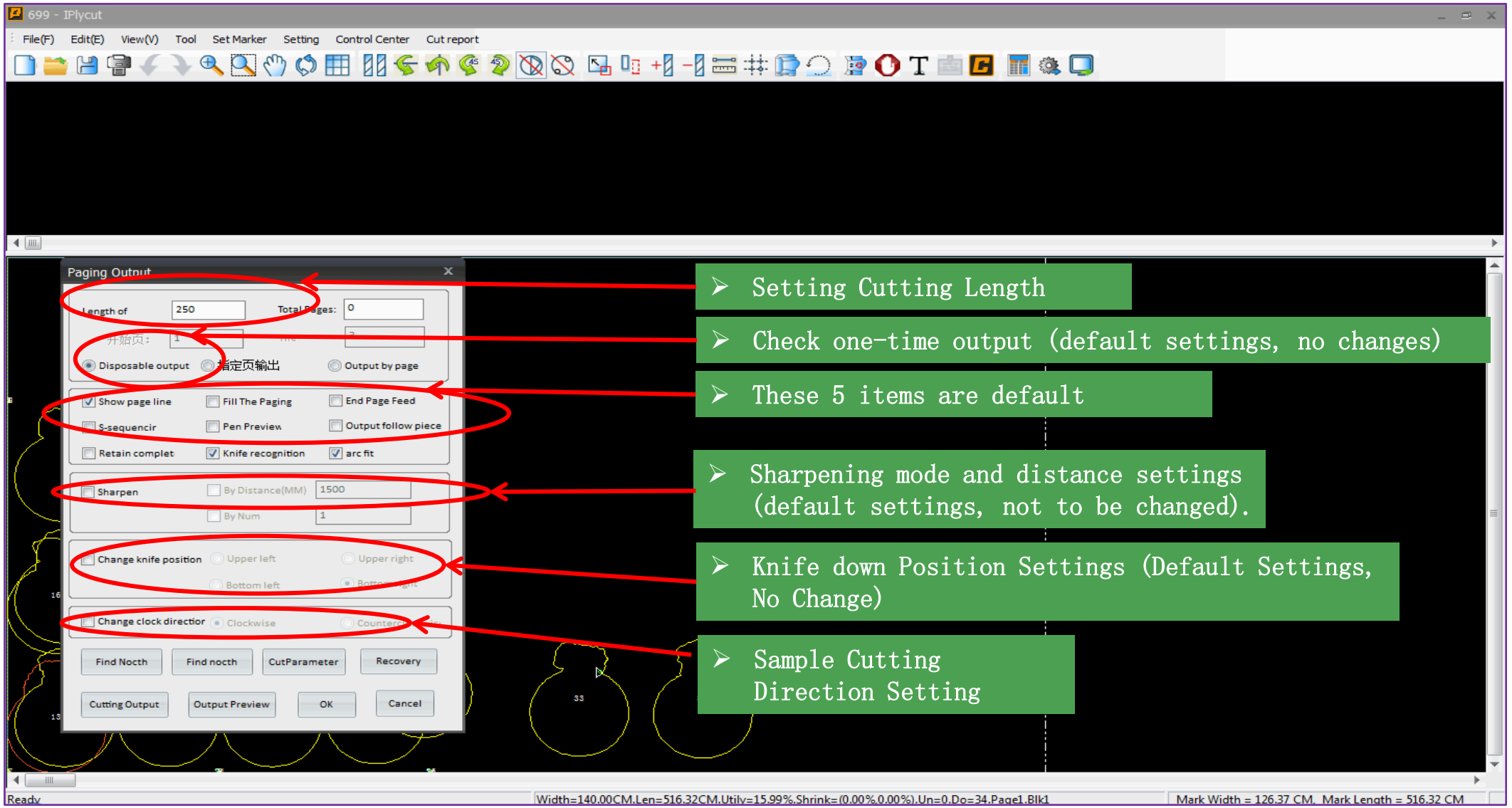

2312 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
1、Left-click the Nesting Tool icon for.
➢ Select all samples nesting in unlaid area, using left mouse button box select all the samples in the unlaid area, Or left mouse click at any point in the layout area to make all samples the same color(Represents all selected)
➢ Select Partial Samples automatic nesting, using mouse left click select the required automatic sample. Or press Ctrl and click on the sample that needs automatic layout with the mouse left button. Blue indicates that the sample that needs automatic nesting is selected.
Auto Nesting Effect
Ready
Width=140.00CM.Len=343.25CM.Utily=57.15%.Shrink=(0.00%,0.00%).Un=17.Do=35.Page1.Blk1
Mark Width = 136.27 CM, Mark Length = 343.25 CM

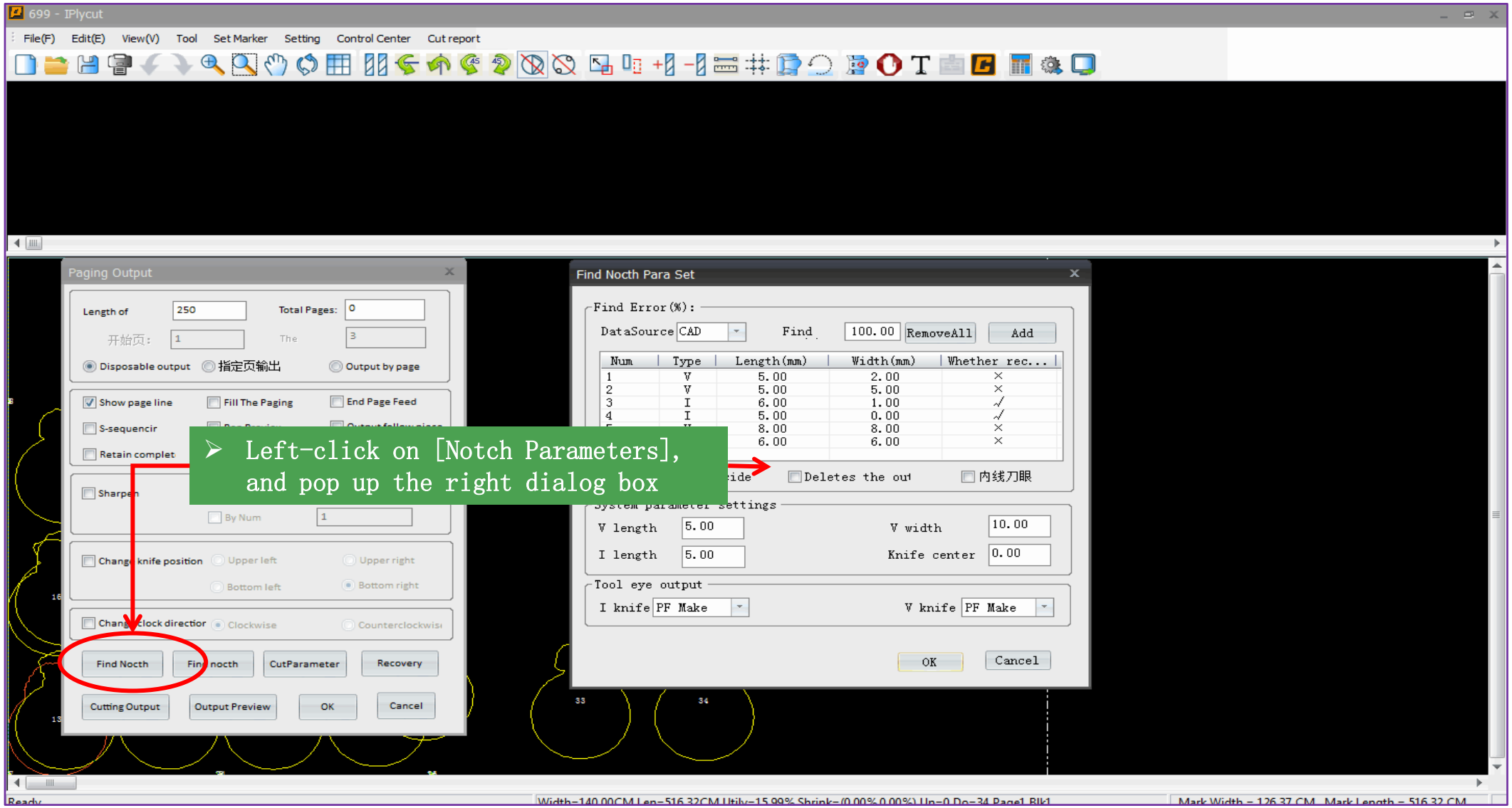

06030106 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
➢ Through the IplyCut software, the cutting number of automatic layout can be cut from the end by rotating 180 degrees without changing the length of the material gate
2、Find the location of the data stored on the local computer
1、Select all the cutting pieces in the nesting area. Press the number key 2 to rotate all the cutting pieces in the keyboard English state. Let the cutting data in the layout area rotate 180 degrees.
Ready
Width=140.00CM.Len=516.32CM.Utily=11.62%.Shrink=(0.00%,0.00%).Un=6.Do=28.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

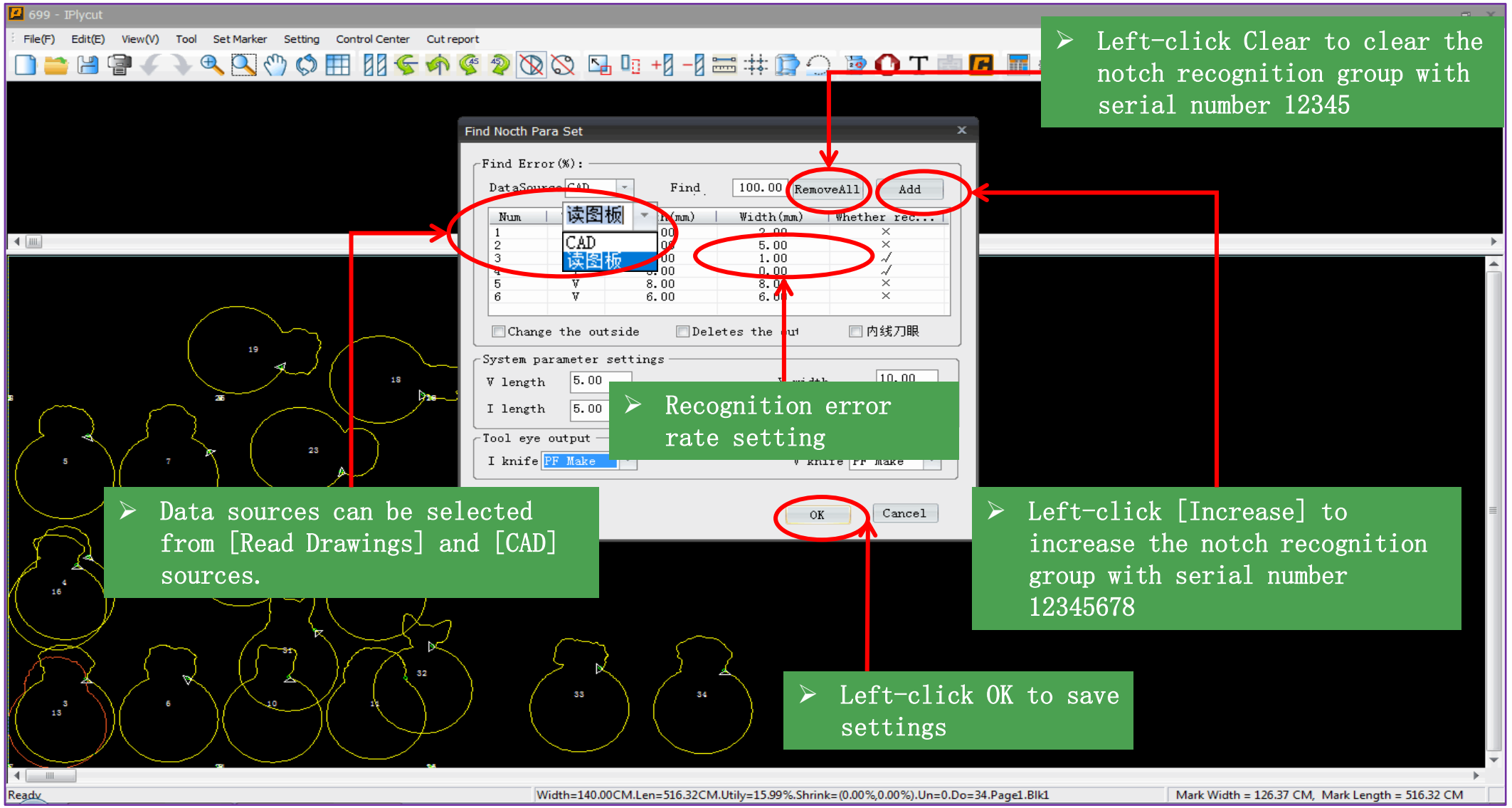

06030106 - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Control Center
Cut report
New(N)
Open(O)...
Save(S)
Import Aama(*.dxf)
Print(P)...
Print Preview(V)
Print Setup(R)...
1 H:\数据\YH124 C1 (24).cut
1、 Left-click the Save or Save tool icon under the file to save and pop up the right dialog box.
➢ Cutting data can be saved as Cut file by IplyCut software, which can be imported directly without re-nestng.
Save As
Save in:
Desktop
Name
Libraries
IECHO
Compute
Network
2、Select the disk location where the data is stored on the local computer
3、The data can be renamed
4、Left-click Save
File name:
633666
Save as type:
(*.cut)
Save
Cancel
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

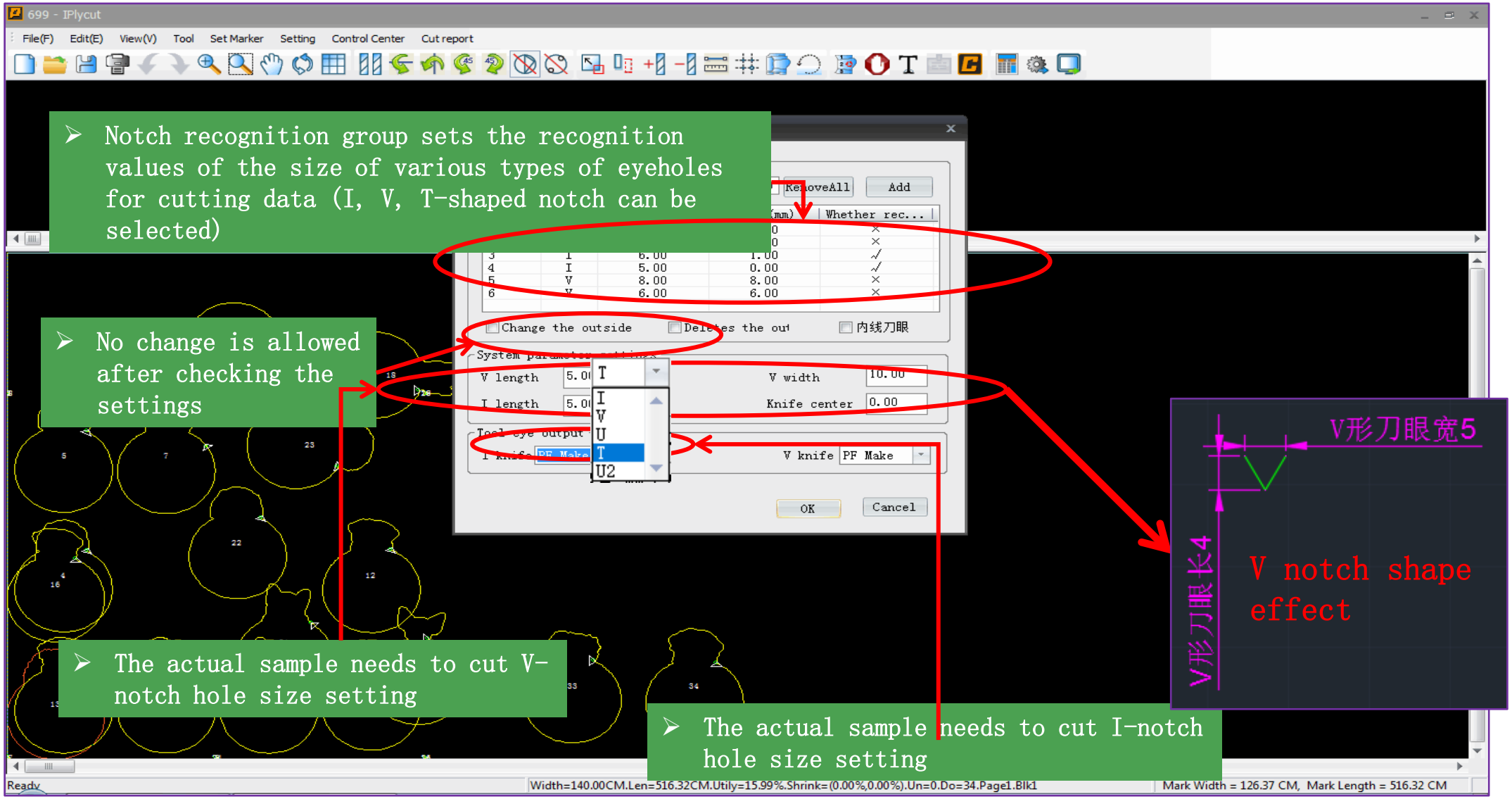

699 - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Setting
Control Center
Cut report
New(N)
Open(O)...
Data(*.DXF;*.PLT)
Aama(*.dxf)
Print(P)... Ctrl+P
Print Preview(V)
Print Setup(R)...
1 H:\数据\YH124 C1 (24).cut
2 H:\数据\YH129 B1 (2).cut
3 FE-02 (1set) - CASA 1).cut
Exit(X)
1、Left-click the [Open] or [Open] tool icon under the file to pop up the right dialog box.
Open
Look in: Desktop
Name
Yesterday (2)
2、Find the location of the data stored on the local computer
3、Find in this data location or quickly search through file names
4、Find the cutting data and click Open
699.cut
File name:
Files of type:
裁床文件 (*.cut)
Open
Cancel
Cutting data can be saved as Cut file by IplyCut software.
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

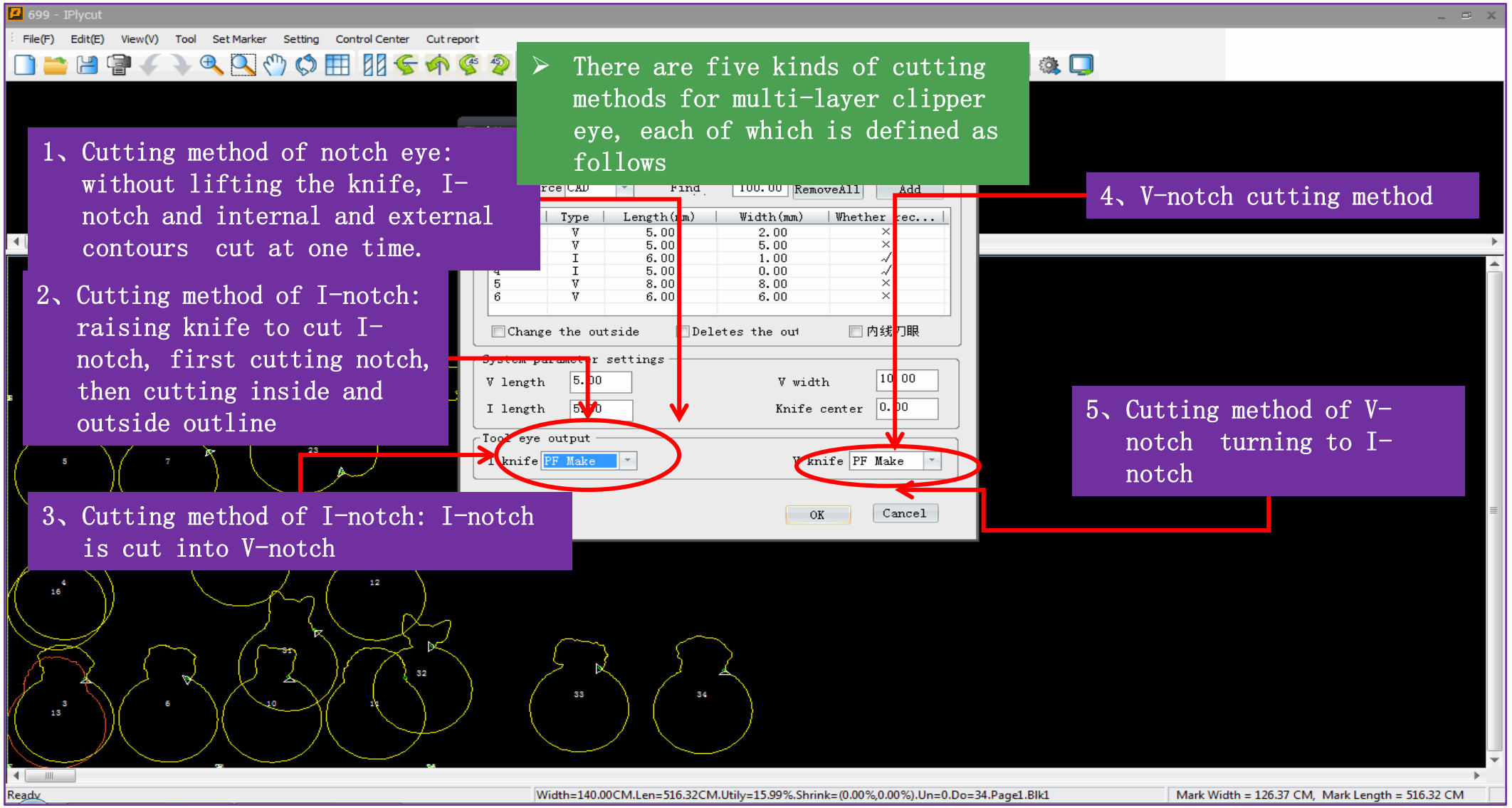

699 - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Setting
Control Center
Cut report
Cut Output
projection F10
Receipt projection F11
Insert data
Paging Output
Length of
250
Total Pages:
0
开始页:
1
The
3
Disposable output
指定页输出
Output by page
Show page line
Fill The Paging
End Page Feed
S-sequencir
Pen Preview
Output follow piece
Retain complet
Knife recognition
arc fit
Sharpen
By Distance(MM)
1500
By Num
1
Change knife position
Upper left
Upper right
Bottom left
Bottom right
Change clock direction
Clockwise
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Output Preview
OK
Cancel
Left-click the Cut Output Tool icon under the Control Center, or click the Software Cut Output Tool icon to pop up the output window.
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

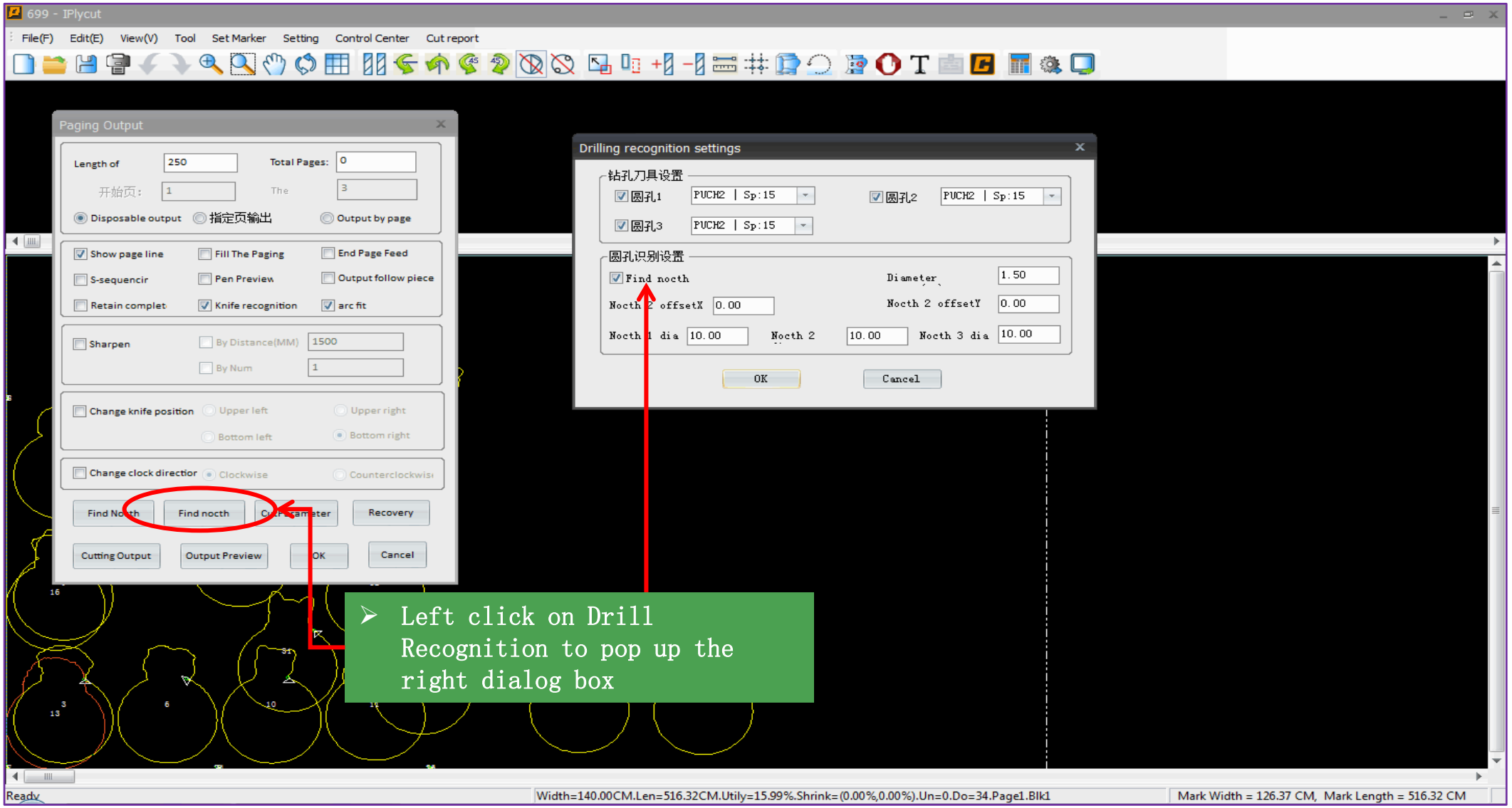

699 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Paging Output
Length of 250
Total Pages: 0
Disposable output
Output by page
Show page line
Fill The Paging
End Page Feed
Pen Preview
Output follow piece
Knife recognition
arc fit
Sharpen
By Distance(MM) 1500
By Num 1
Change knife position
Upper left
Upper right
Bottom left
Change clock direction
Clockwise
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Output Preview
OK
Cancel
Ready
Width=140.00CM,Len=516.32CM,Utily=15.99%,Shrink=(0.00%,0.00%),Un=0,Do=34,Page1,Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM
➢ Setting Cutting Length
➢ Check one-time output (default settings, no changes)
➢ These 5 items are default
➢ Sharpening mode and distance settings (default settings, not to be changed).
➢ Knife down Position Settings (Default Settings, No Change)
➢ Sample Cutting Direction Setting

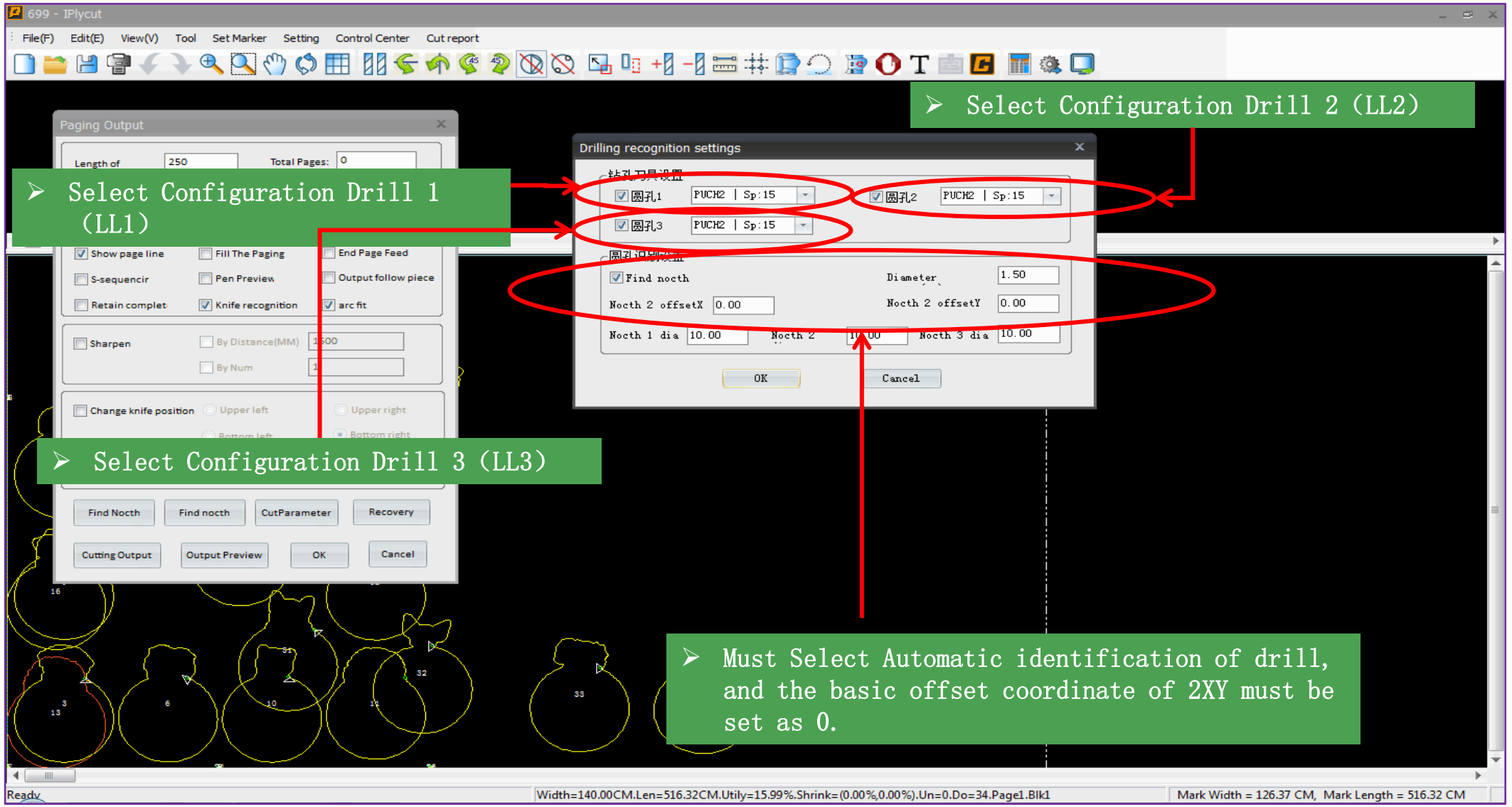

699 - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Setting
Control Center
Cut report
Paging Output
Length of
250
Total Pages:
0
开始页:
1
The
3
Disposable output
指定页输出
Output by page
Show page line
Fill The Paging
End Page Feed
S-sequencir
Retain complet
Sharpen
By Num
1
Change knife position
Upper left
Upper right
Bottom left
Bottom right
Change clock direction
Clockwise
Counterclockwise
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Output Preview
OK
Cancel
Left-click on [Notch Parameters], and pop up the right dialog box
Find Nocth Para Set
Find Error(%):
DataSource
CAD
Find
100.00
RemoveAll
Add
Num
Type
Length(mm)
Width(mm)
Whether rec...
1 V 5.00 2.00 ×
2 V 5.00 5.00 ×
3 I 6.00 1.00 √
4 I 5.00 0.00 √
8.00 8.00 ×
6.00 6.00 ×
Deletes the out
内线刀眼
System parameter settings
V length
5.00
V width
10.00
I length
5.00
Knife center
0.00
Tool eye output
I knife
PF Make
V knife
PF Make
OK
Cancel
Ready
Mark Width = 126.37 CM Mark Length = 516.32 CM

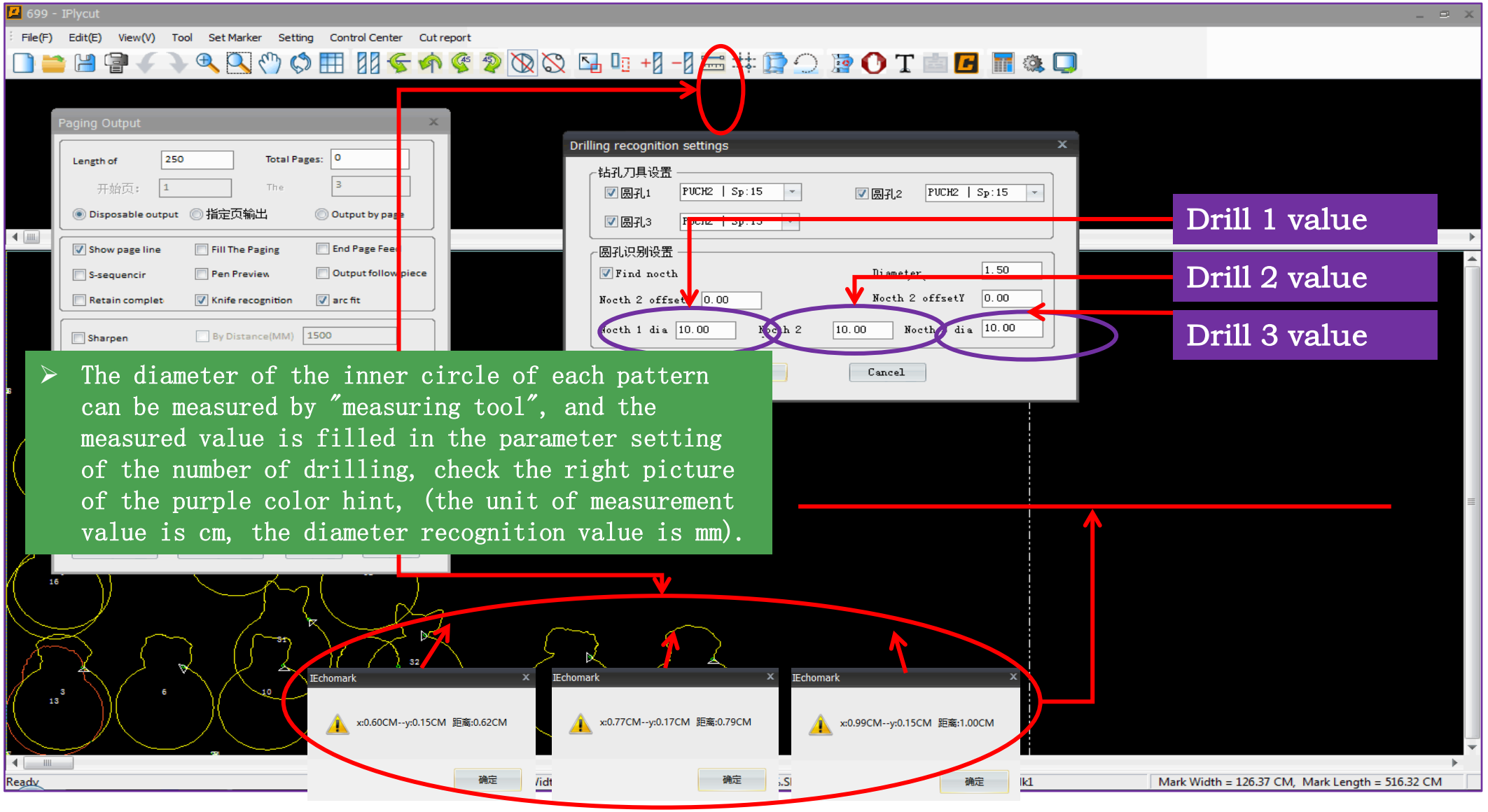

699 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Find Nocth Para Set
Find Error(%):
DataSource CAD
Find
100.00
RemoveAll
Add
Num
Width(mm)
Whether rec...
读图板
CAD
读图板
Change the outside
Deletes the out
内线刀眼
System parameter settings
V length 5.00
I length 5.00
Tool eye output
I knife PF Make
OK
Cancel
Left-click Clear to clear the notch recognition group with serial number 12345
Recognition error rate setting
Data sources can be selected from [Read Drawings] and [CAD] sources.
Left-click [Increase] to increase the notch recognition group with serial number 12345678
Left-click OK to save settings
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

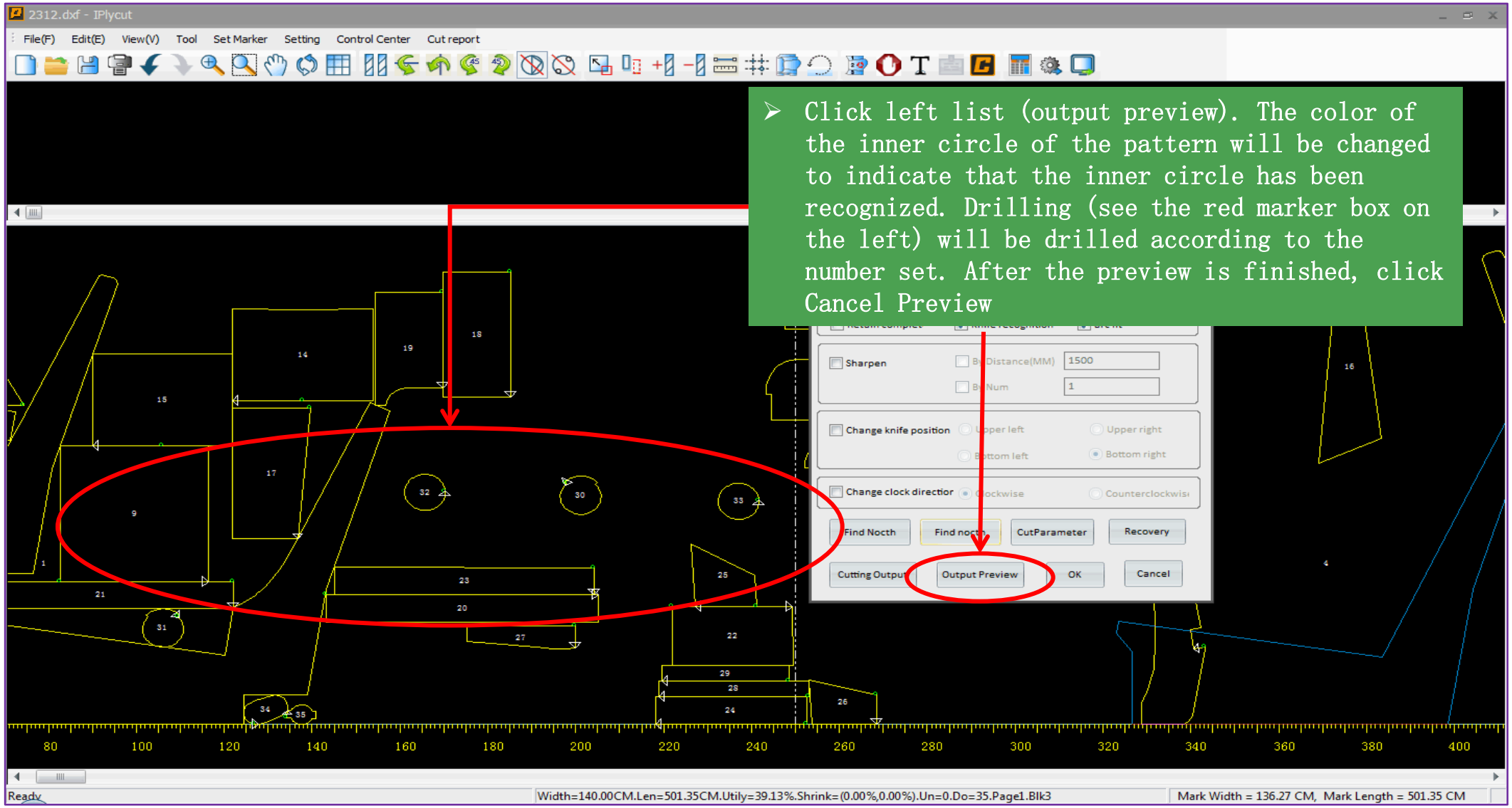

699 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Notch recognition group sets the recognition values of the size of various types of eyeholes for cutting data (I, V, T-shaped notch can be selected)
No change is allowed after checking the settings
The actual sample needs to cut V-notch hole size setting
The actual sample needs to cut I-notch hole size setting
V形刀眼宽5
V形刀眼长4
V notch shape effect
Change the outside
内线刀眼
V length
I length
V width
Knife center
V knife
PF Make
OK
Cancel
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

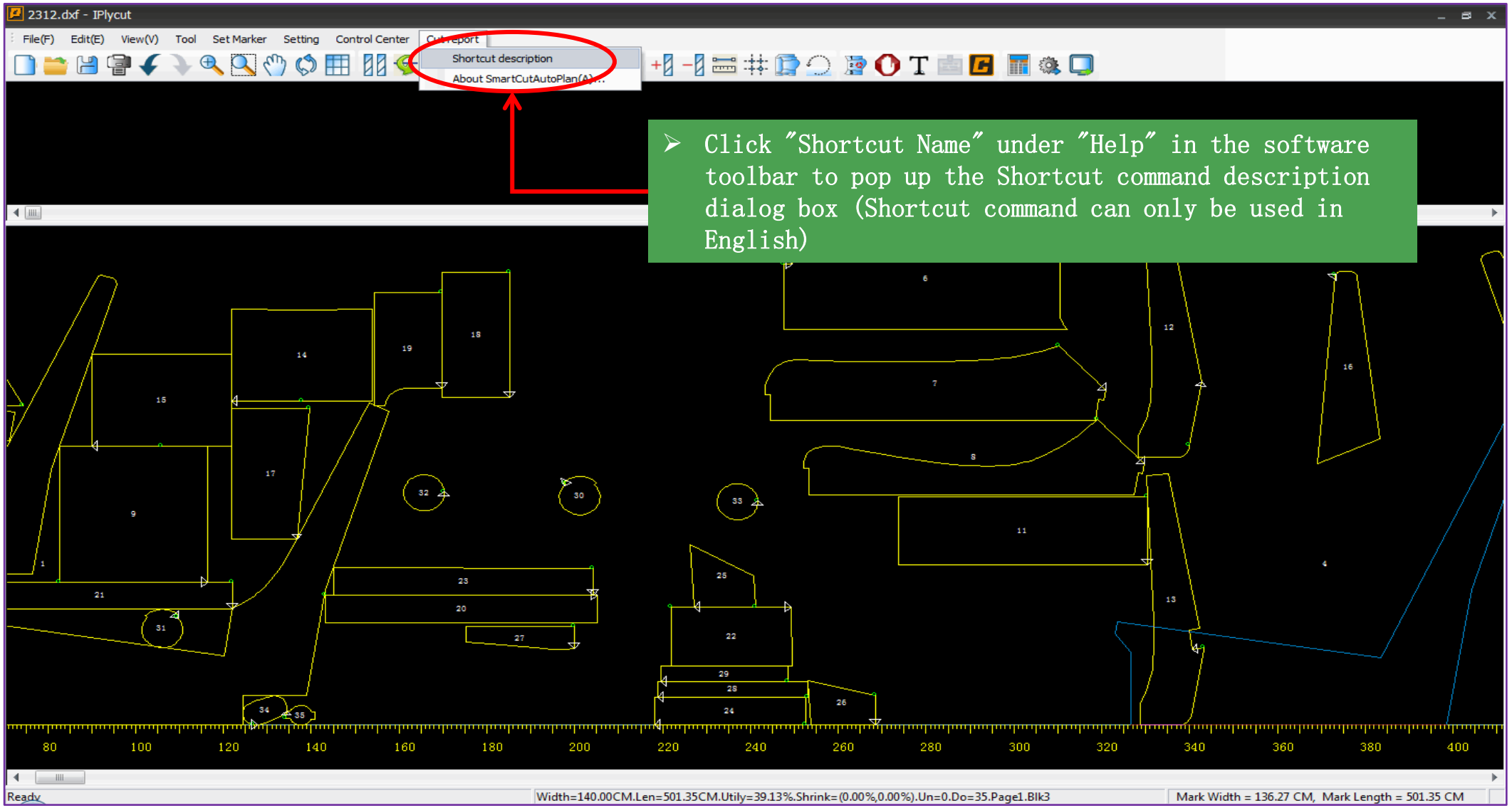

699 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
There are five kinds of cutting methods for multi-layer clipper eye, each of which is defined as follows
1、Cutting method of notch eye: without lifting the knife, I-notch and internal and external contours cut at one time.
2、Cutting method of I-notch: raising knife to cut I-notch, first cutting notch, then cutting inside and outside outline
3、Cutting method of I-notch: I-notch is cut into V-notch
4、V-notch cutting method
5、Cutting method of V-notch turning to I-notch
Type Length(mm) Width(mm)
Change the outside
Deletes the out
V length
I length
V width
Knife center
Tool eye output
I knife PF Make
V knife PF Make
OK
Cancel
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM


699 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Paging Output
Length of 250 Total Pages: 0
开始页: 1 The 3
Disposable output 指定页输出 Output by page
Show page line Fill The Paging End Page Feed
S-sequencir Pen Preview Output follow piece
Retain complet Knife recognition arc fit
Sharpen By Distance(MM) 1500
By Num 1
Change knife position Upper left Upper right
Bottom left Bottom right
Change clock direction Clockwise Counterclockwise
Find North Find nocth Cut Parameter Recovery
Cutting Output Output Preview OK Cancel
Drilling recognition settings
钻孔刀具设置
圆孔1 PUCH2 | Sp:15
圆孔2 PUCH2 | Sp:15
圆孔3 PUCH2 | Sp:15
圆孔识别设置
Find nocth
Diameter 1.50
Nocth 2 offsetX 0.00
Nocth 2 offsetY 0.00
Nocth 1 dia 10.00 Nocth 2 10.00 Nocth 3 dia 10.00
OK Cancel
Left click on Drill Recognition to pop up the right dialog box
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

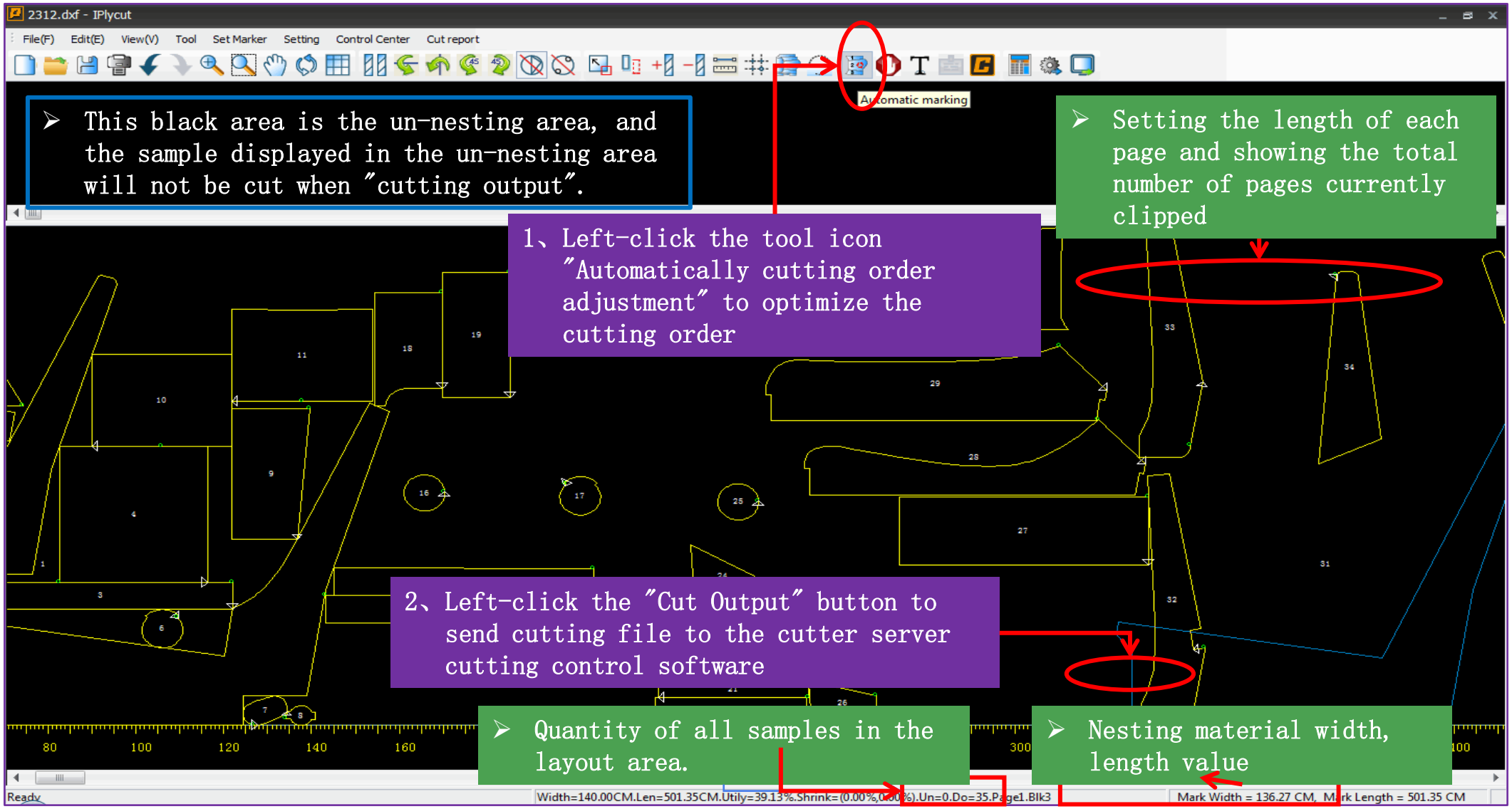

699 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Paging Output
Length of 250 Total Pages: 0
Show page line
Fill The Paging
End Page Feed
S-sequencir
Pen Preview
Output follow piece
Retain complet
Knife recognition
arc fit
Sharpen
By Distance(MM)
By Num
Change knife position
Upper left
Upper right
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Output Preview
OK
Cancel
Drilling recognition settings
圆孔1 PUCH2 | Sp:15
圆孔2 PUCH2 | Sp:15
圆孔3 PUCH2 | Sp:15
Find nocth
Diameter 1.50
Nocth 2 offsetX 0.00
Nocth 2 offsetY 0.00
Nocth 1 dia 10.00
Nocth 2
Nocth 3 dia 10.00
OK
Cancel
Select Configuration Drill 2 (LL2)
Select Configuration Drill 1 (LL1)
Select Configuration Drill 3 (LL3)
Must Select Automatic identification of drill, and the basic offset coordinate of 2XY must be set as 0.
Ready
Width=140.00CM.Len=516.32CM.Utily=15.99%.Shrink=(0.00%,0.00%).Un=0.Do=34.Page1.Blk1
Mark Width = 126.37 CM, Mark Length = 516.32 CM

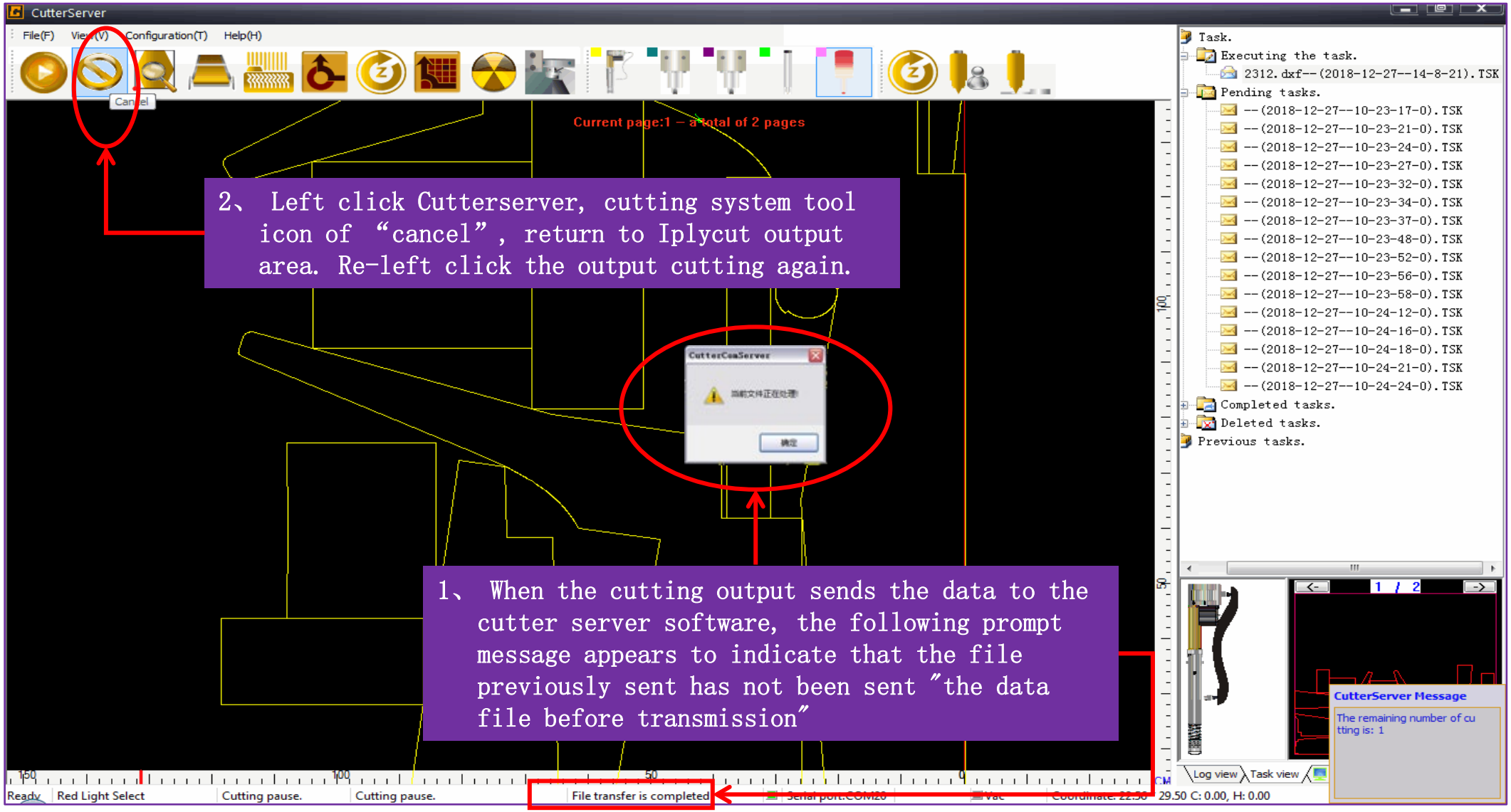

699 - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Paging Output
Length of 250
Total Pages: 0
开始页: 1
The 3
Disposable output
指定页输出
Output by page
Show page line
Fill The Paging
End Page Feed
S-sequencir
Pen Preview
Output follow piece
Retain complet
Knife recognition
arc fit
Sharpen
By Distance(MM) 1500
Drilling recognition settings
钻孔刀具设置
圆孔1 PUCH2 | Sp:15
圆孔2 PUCH2 | Sp:15
圆孔3
圆孔识别设置
Find nocth
Diameter 1.50
Nocth 2 offset 0.00
Nocth 2 offsetY 0.00
Nocth 1 dia 10.00
Nocth 2 10.00
Nocth dia 10.00
Cancel
Drill 1 value
Drill 2 value
Drill 3 value
The diameter of the inner circle of each pattern can be measured by "measuring tool", and the measured value is filled in the parameter setting of the number of drilling, check the right picture of the purple color hint, (the unit of measurement value is cm, the diameter recognition value is mm).
IEchomark
x:0.60CM--y:0.15CM 距离:0.62CM
确定
IEchomark
x:0.77CM--y:0.17CM 距离:0.79CM
确定
IEchomark
x:0.99CM--y:0.15CM 距离:1.00CM
确定
Ready
Mark Width = 126.37 CM, Mark Length = 516.32 CM

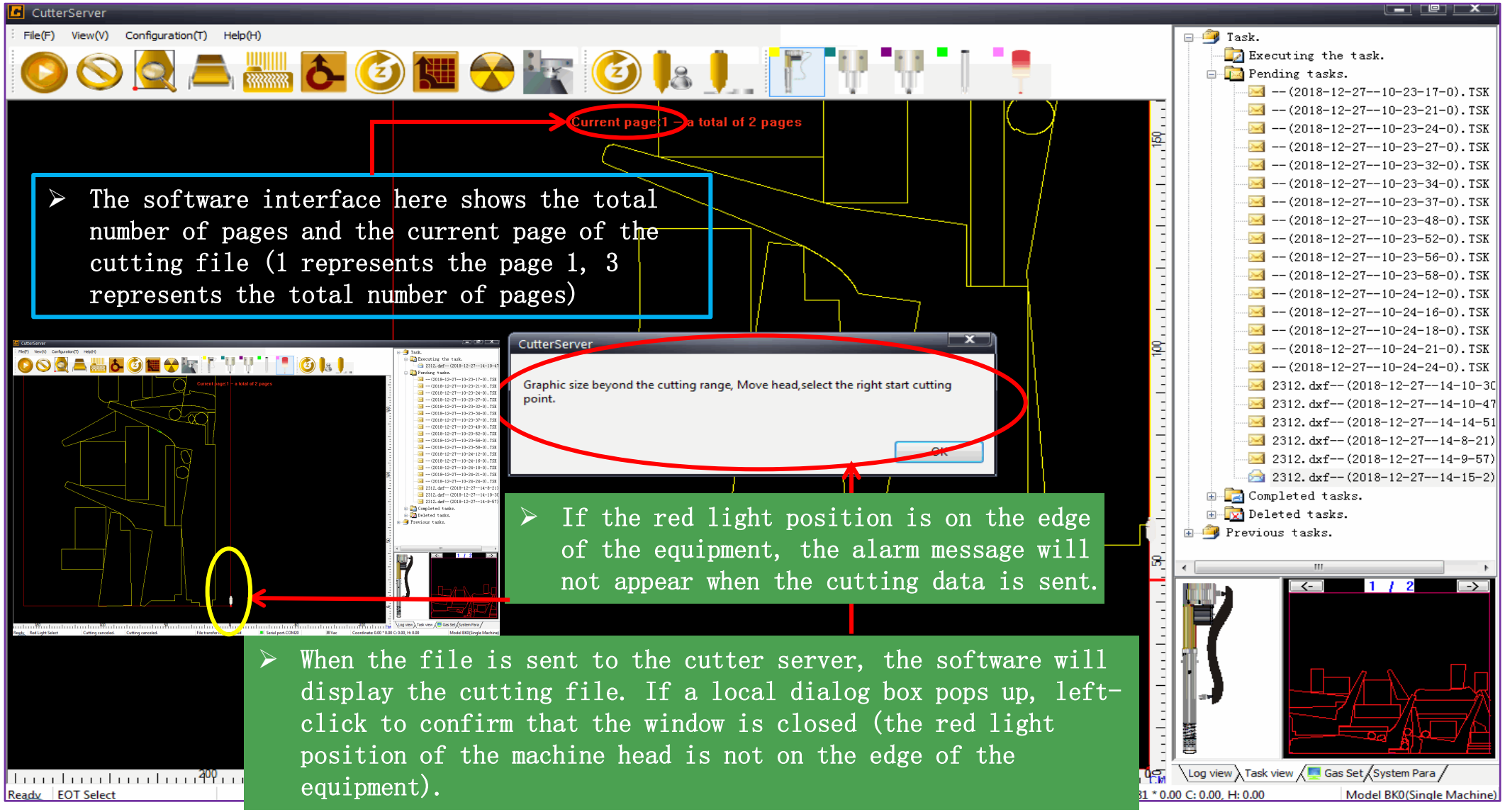

2312.dxf - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Click left list (output preview). The color of the inner circle of the pattern will be changed to indicate that the inner circle has been recognized. Drilling (see the red marker box on the left) will be drilled according to the number set. After the preview is finished, click Cancel Preview
Sharpen
By Distance(MM)
1500
By Num
1
Change knife position
Upper left
Upper right
Bottom left
Bottom right
Change clock direction
Clockwise
Counterclockwise
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Output Preview
OK
Cancel
80 100 120 140 160 180 200 220 240 260 280 300 320 340 360 380 400
Ready
Width=140.00CM.Len=501.35CM.Utily=39.13%.Shrink=(0.00%,0.00%).Un=0.Do=35.Page1.Blk3
Mark Width = 136.27 CM, Mark Length = 501.35 CM

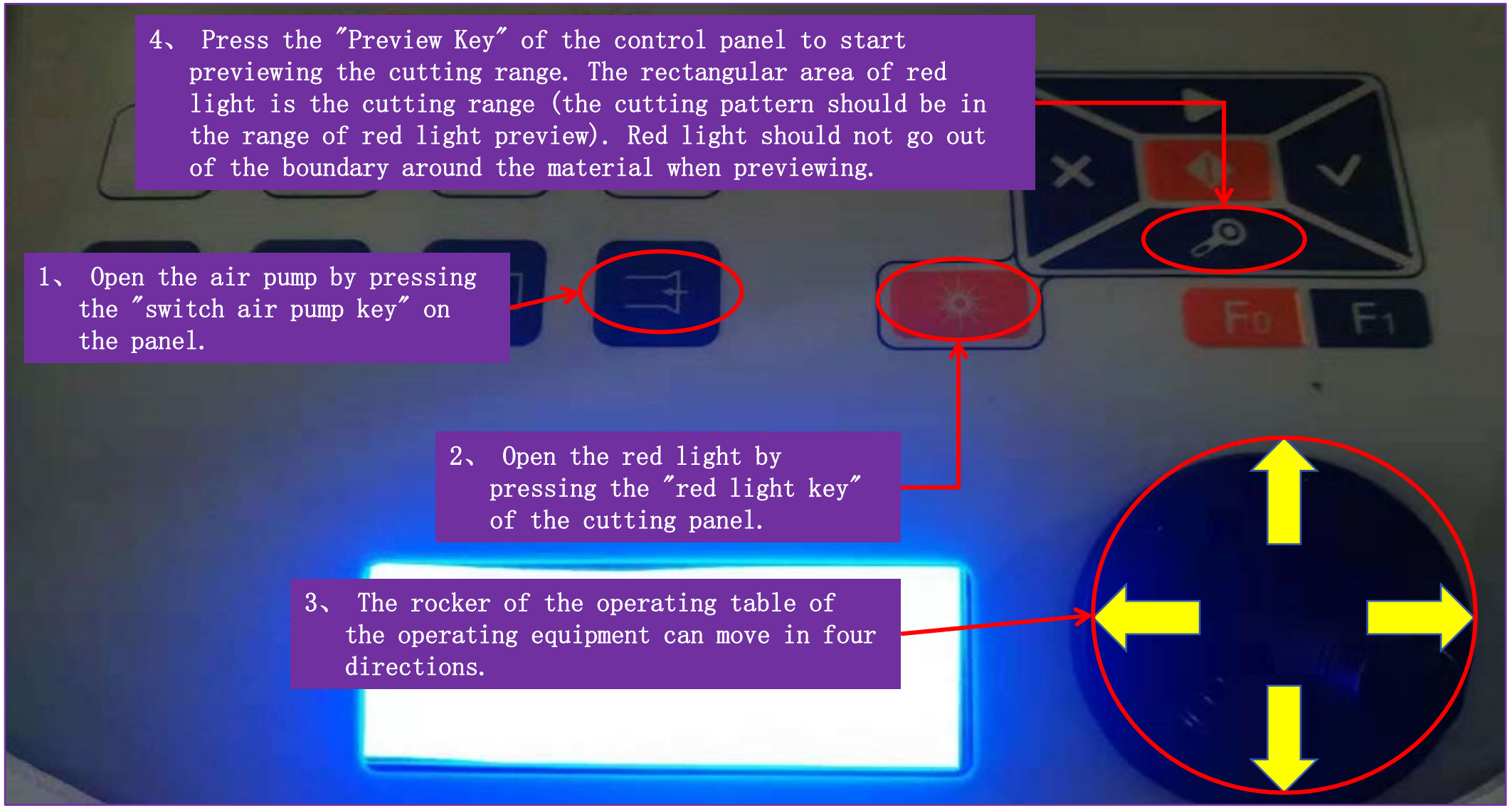

2312.dxf - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Setting
Control Center
Cut report
Help
Shortcut description
About SmartCutAutoPlan(A)...
➢ Click "Shortcut Name" under "Help" in the software toolbar to pop up the Shortcut command description dialog box (Shortcut command can only be used in English)
80
100
120
140
160
180
200
220
240
260
280
300
320
340
360
380
400
Ready
Width=140.00CM.Len=501.35CM.Utily=39.13%.Shrink=(0.00%,0.00%).Un=0.Do=35.Page1.Blk3
Mark Width = 136.27 CM, Mark Length = 501.35 CM

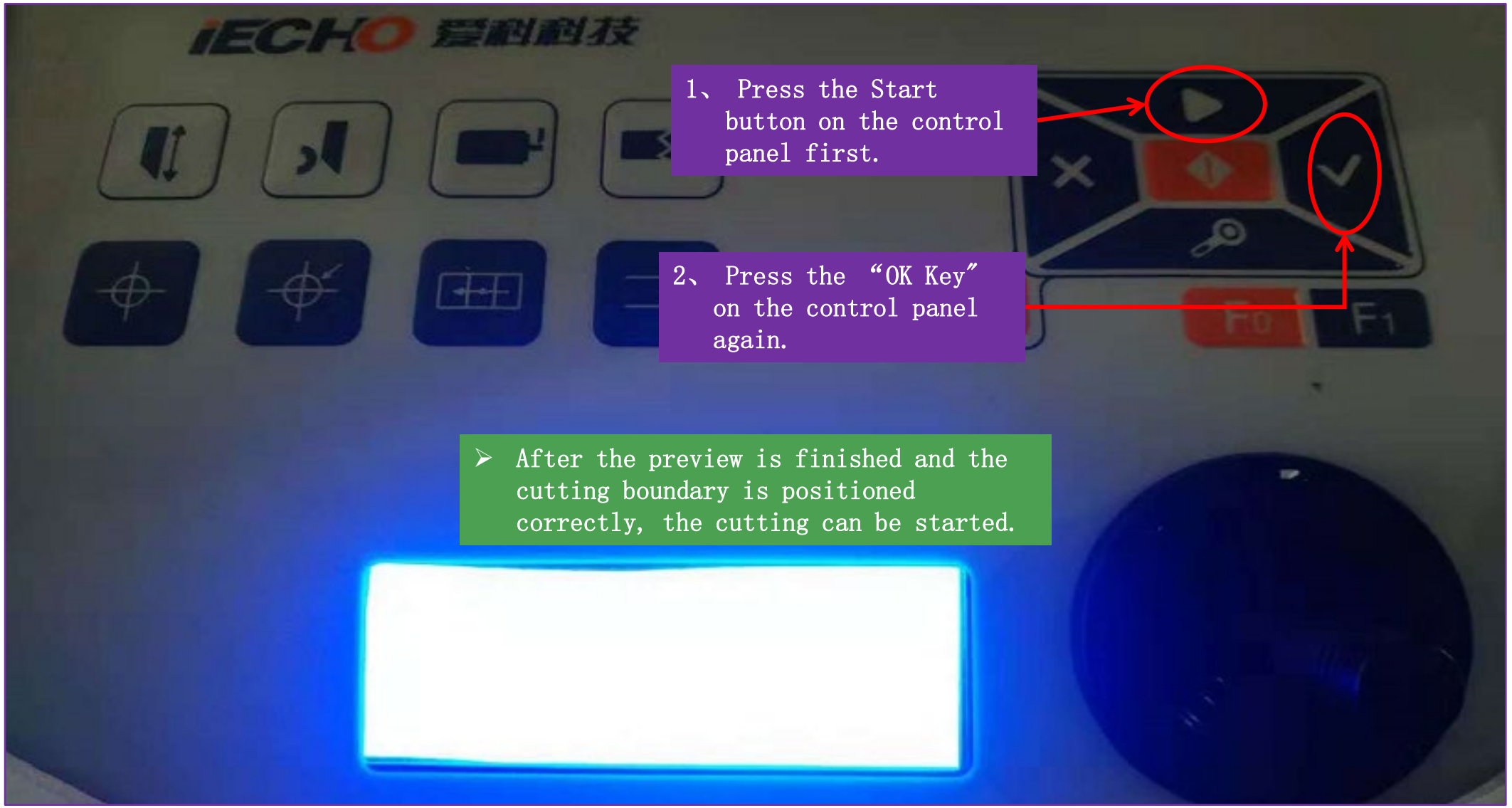
03 Cutting

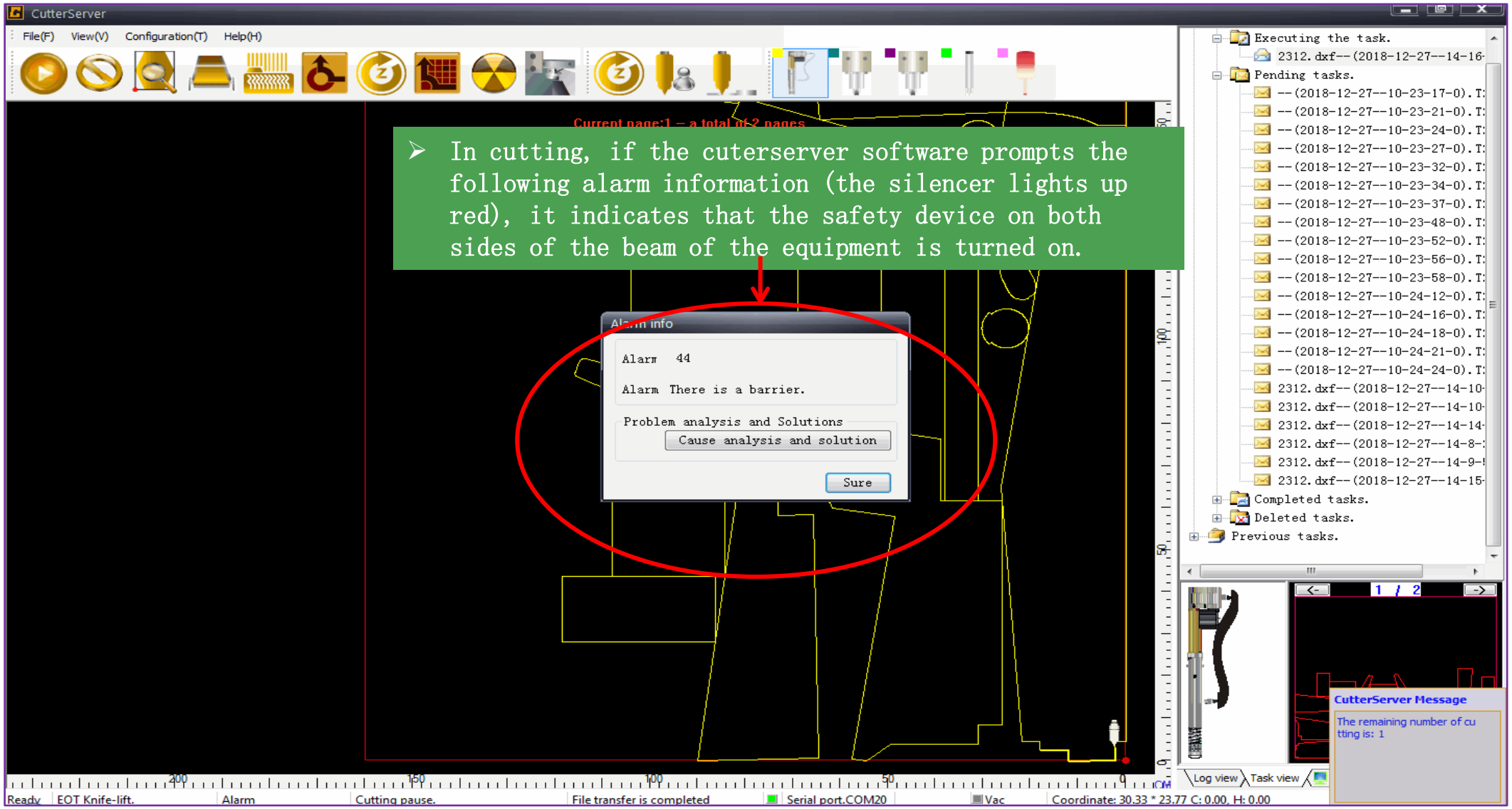

2312.dxf - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Automatic marking
➢ This black area is the un-nesting area, and the sample displayed in the un-nesting area will not be cut when "cutting output".
1、Left-click the tool icon "Automatically cutting order adjustment" to optimize the cutting order
➢ Setting the length of each page and showing the total number of pages currently clipped
2、Left-click the "Cut Output" button to send cutting file to the cutter server cutting control software
➢ Quantity of all samples in the layout area.
➢ Nesting material width, length value
Ready
Width=140.00CM.Len=501.35CM.Utily=39.13%.Shrink=(0.00%,0.00%).Un=0.Do=35.Page1.Blk3
Mark Width = 136.27 CM, Mark Length = 501.35 CM


CutterServer
File(F)
Configuration(T)
Help(H)
Cancel
Current page:1 — a total of 2 pages
2、 Left click Cutterserver, cutting system tool icon of “cancel”, return to Iplycut output area. Re-left click the output cutting again.
1、 When the cutting output sends the data to the cutter server software, the following prompt message appears to indicate that the file previously sent has not been sent ″the data file before transmission″
Task.
Executing the task.
2312.dxf--(2018-12-27--14-8-21).TSK
Pending tasks.
--(2018-12-27--10-23-17-0).TSK
--(2018-12-27--10-23-21-0).TSK
--(2018-12-27--10-23-24-0).TSK
--(2018-12-27--10-23-27-0).TSK
--(2018-12-27--10-23-32-0).TSK
--(2018-12-27--10-23-34-0).TSK
--(2018-12-27--10-23-37-0).TSK
--(2018-12-27--10-23-48-0).TSK
--(2018-12-27--10-23-52-0).TSK
--(2018-12-27--10-23-56-0).TSK
--(2018-12-27--10-23-58-0).TSK
--(2018-12-27--10-24-12-0).TSK
--(2018-12-27--10-24-16-0).TSK
--(2018-12-27--10-24-18-0).TSK
--(2018-12-27--10-24-21-0).TSK
--(2018-12-27--10-24-24-0).TSK
Completed tasks.
Deleted tasks.
Previous tasks.
1 / 2
CutterServer Message
The remaining number of cutting is: 1
Log view
Task view
Ready
Red Light Select
Cutting pause.
Cutting pause.
File transfer is completed
29.50 C: 0.00, H: 0.00


CutterServer
File(F) View(V) Configuration(T) Help(H)
Current page:1 – a total of 2 pages
The software interface here shows the total number of pages and the current page of the cutting file (1 represents the page 1, 3 represents the total number of pages)
CutterServer
Graphic size beyond the cutting range, Move head,select the right start cutting point.
OK
If the red light position is on the edge of the equipment, the alarm message will not appear when the cutting data is sent.
When the file is sent to the cutter server, the software will display the cutting file. If a local dialog box pops up, left-click to confirm that the window is closed (the red light position of the machine head is not on the edge of the equipment).
Task.
Executing the task.
Pending tasks.
Completed tasks.
Deleted tasks.
Previous tasks.
Log view
Task view
Gas Set
System Para
Ready
EOT Select
Model BK0(Single Machine)

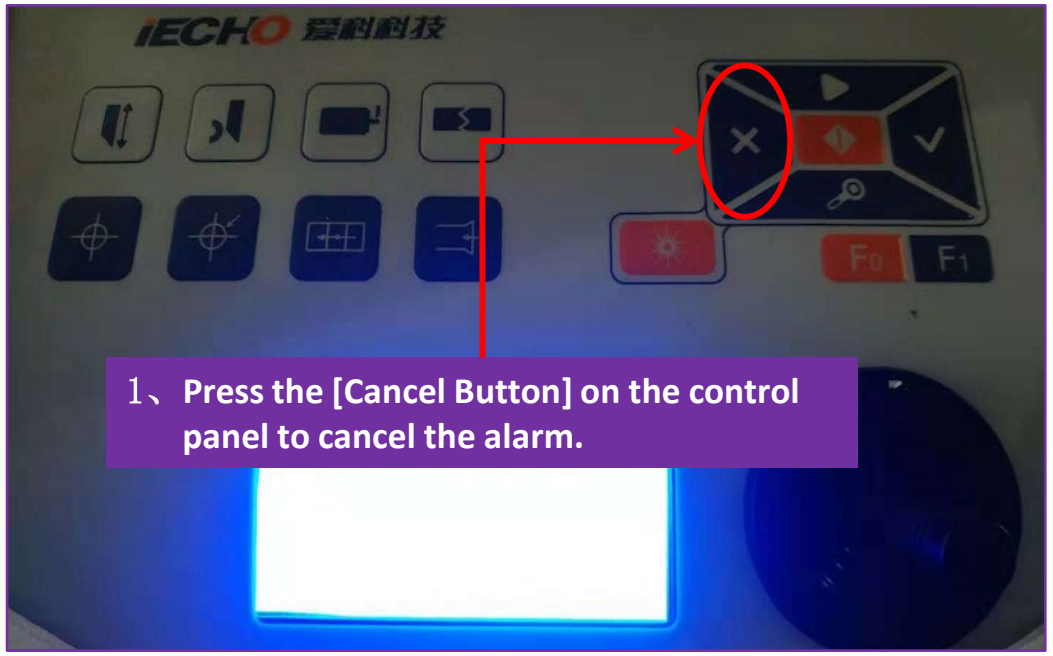

4、 Press the "Preview Key" of the control panel to start previewing the cutting range. The rectangular area of red light is the cutting range (the cutting pattern should be in the range of red light preview). Red light should not go out of the boundary around the material when previewing.
1、 Open the air pump by pressing the "switch air pump key" on the panel.
2、 Open the red light by pressing the "red light key" of the cutting panel.
3、 The rocker of the operating table of the operating equipment can move in four directions.
F0
F1


iECHO 爱科科技
1、 Press the Start button on the control panel first.
2、 Press the “OK Key” on the control panel again.
F0
F1
➢ After the preview is finished and the cutting boundary is positioned correctly, the cutting can be started.


CutterServer
File(F) View(V) Configuration(T) Help(H)
In cutting, if the cuterserver software prompts the following alarm information (the silencer lights up red), it indicates that the safety device on both sides of the beam of the equipment is turned on.
Alarm info
Alarm 44
Alarm There is a barrier.
Problem analysis and Solutions
Cause analysis and solution
Sure
Executing the task.
Pending tasks.
Completed tasks.
Deleted tasks.
Previous tasks.
CutterServer Message
The remaining number of cu tting is: 1
Log view
Task view
Ready
EOT Knife-lift.
Alarm
Cutting pause.
File transfer is completed
Serial port.COM20
Vac
Coordinate: 30.33 * 23.77 C: 0.00, H: 0.00

1、 This status of the safety device indicates that it has been turned on (an obstacle is reported during cutting).

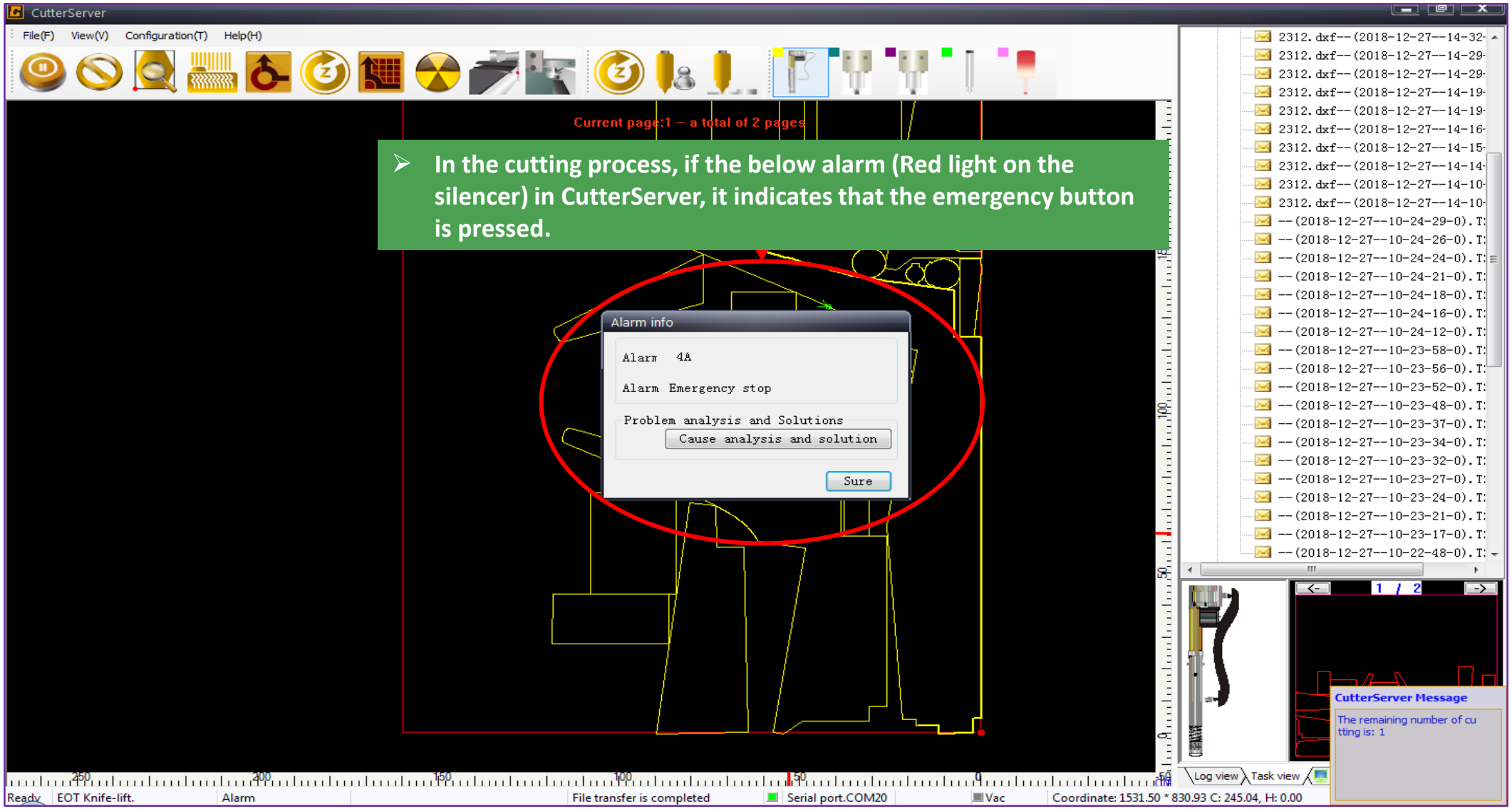
2、 This status of the safety device indicates that it is normal, no obstacle.



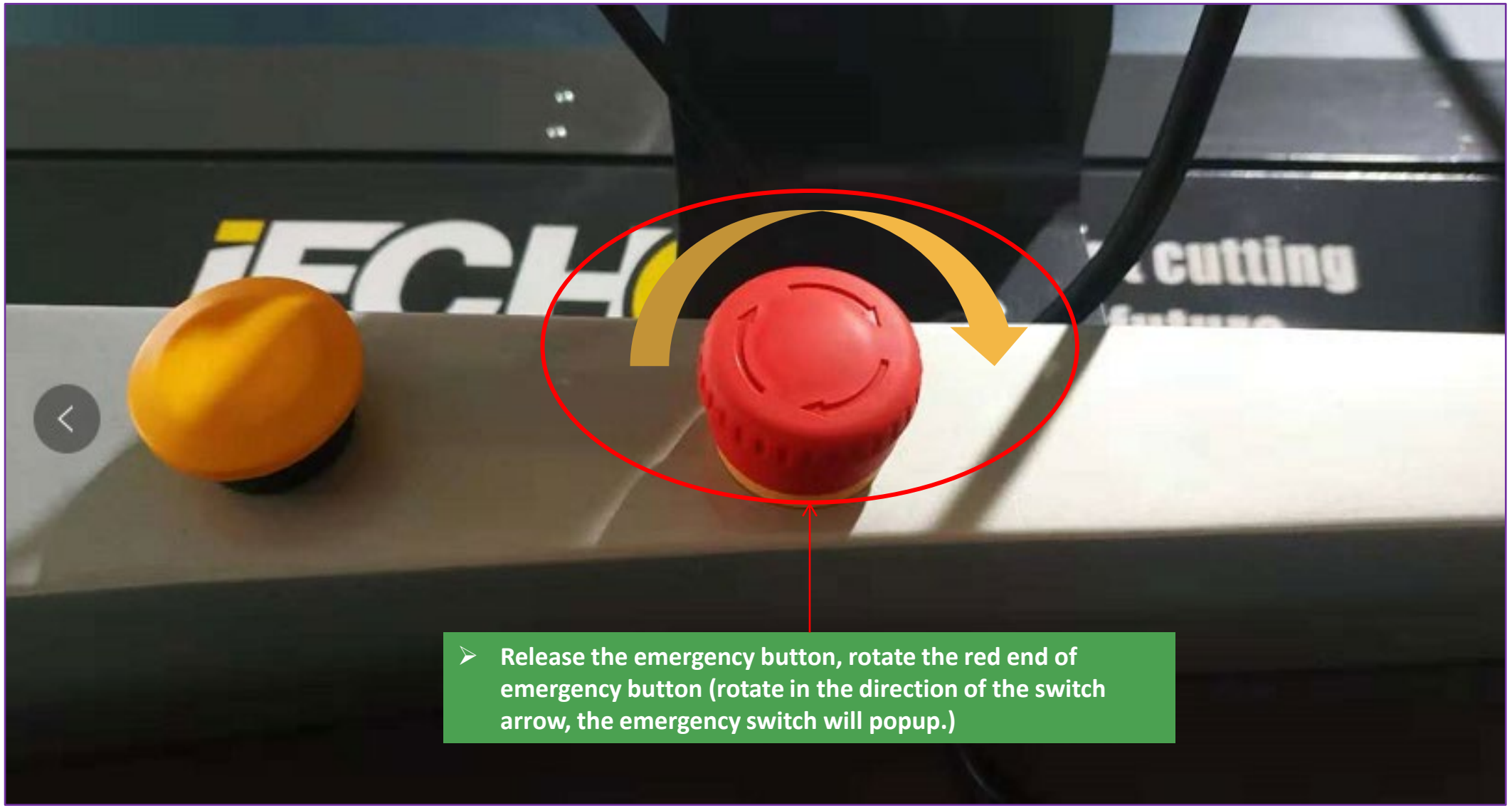
1、Press the [Cancel Button] on the control panel to cancel the alarm.

2、Press the yellow [Pause Start] switch on the side of the control to continue cutting.

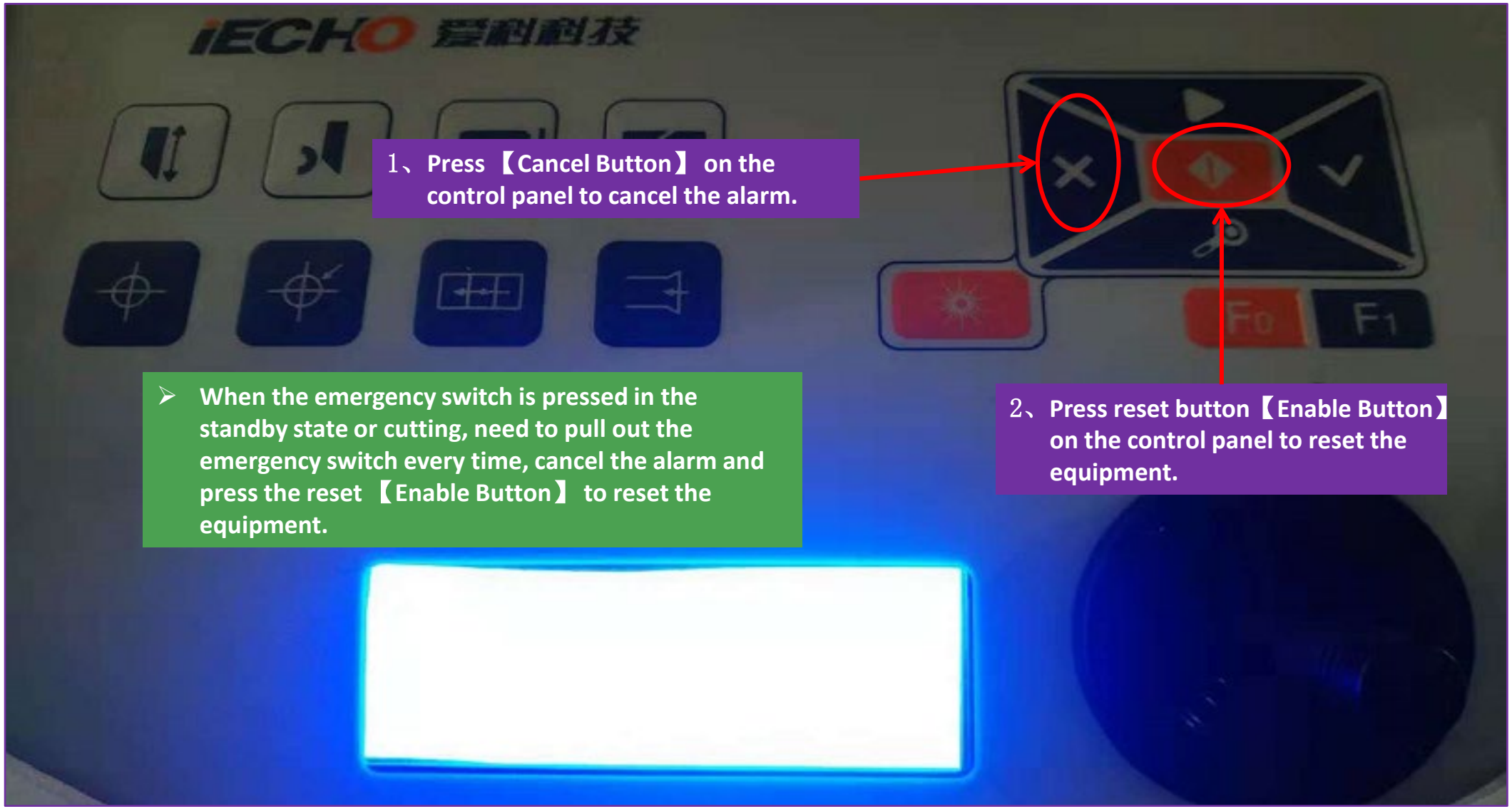
- All the yellow buttons of this equipment are [Pause Start] switch, press this button to pause in the cutting process, and press it to cut again.

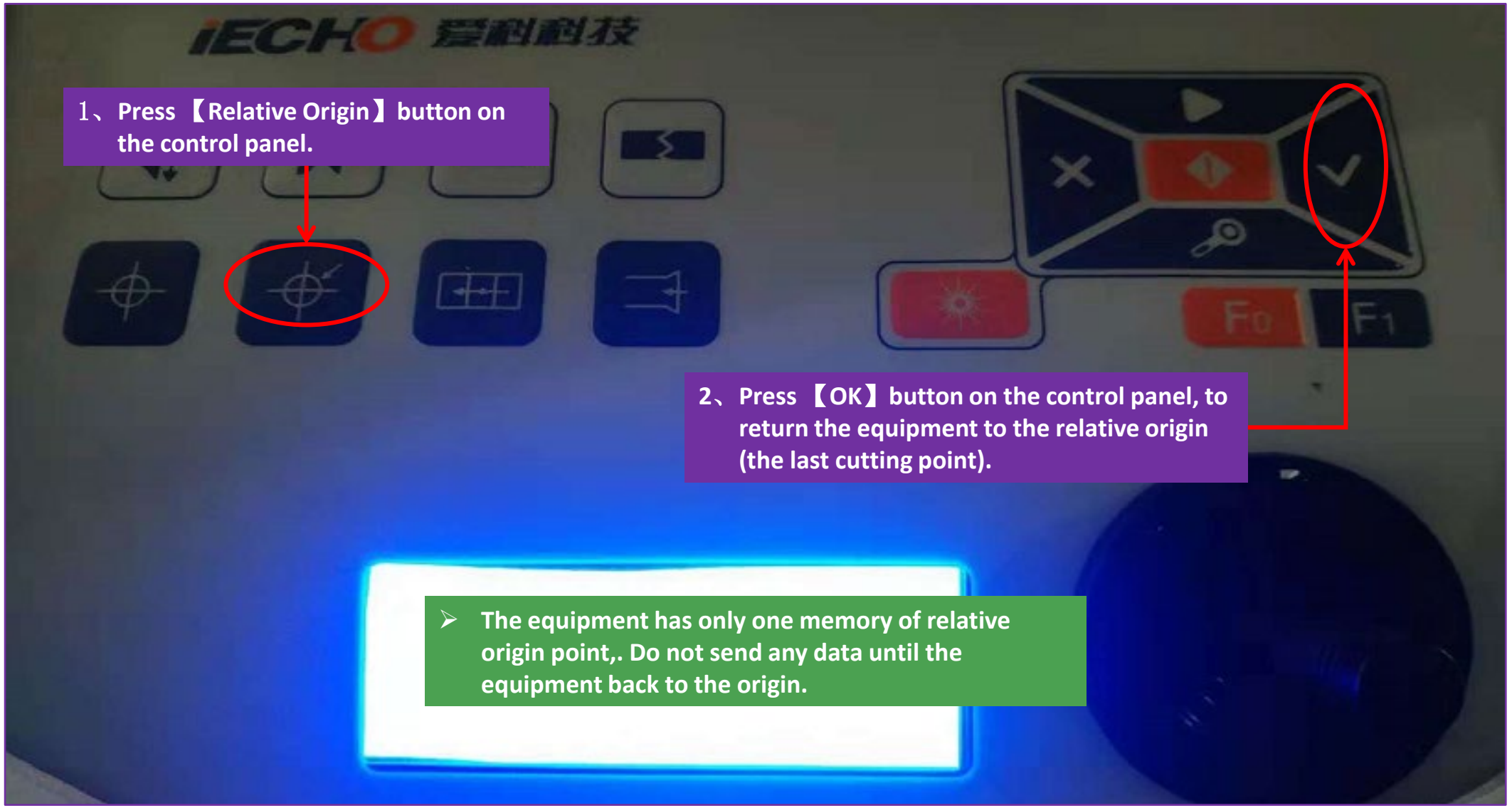


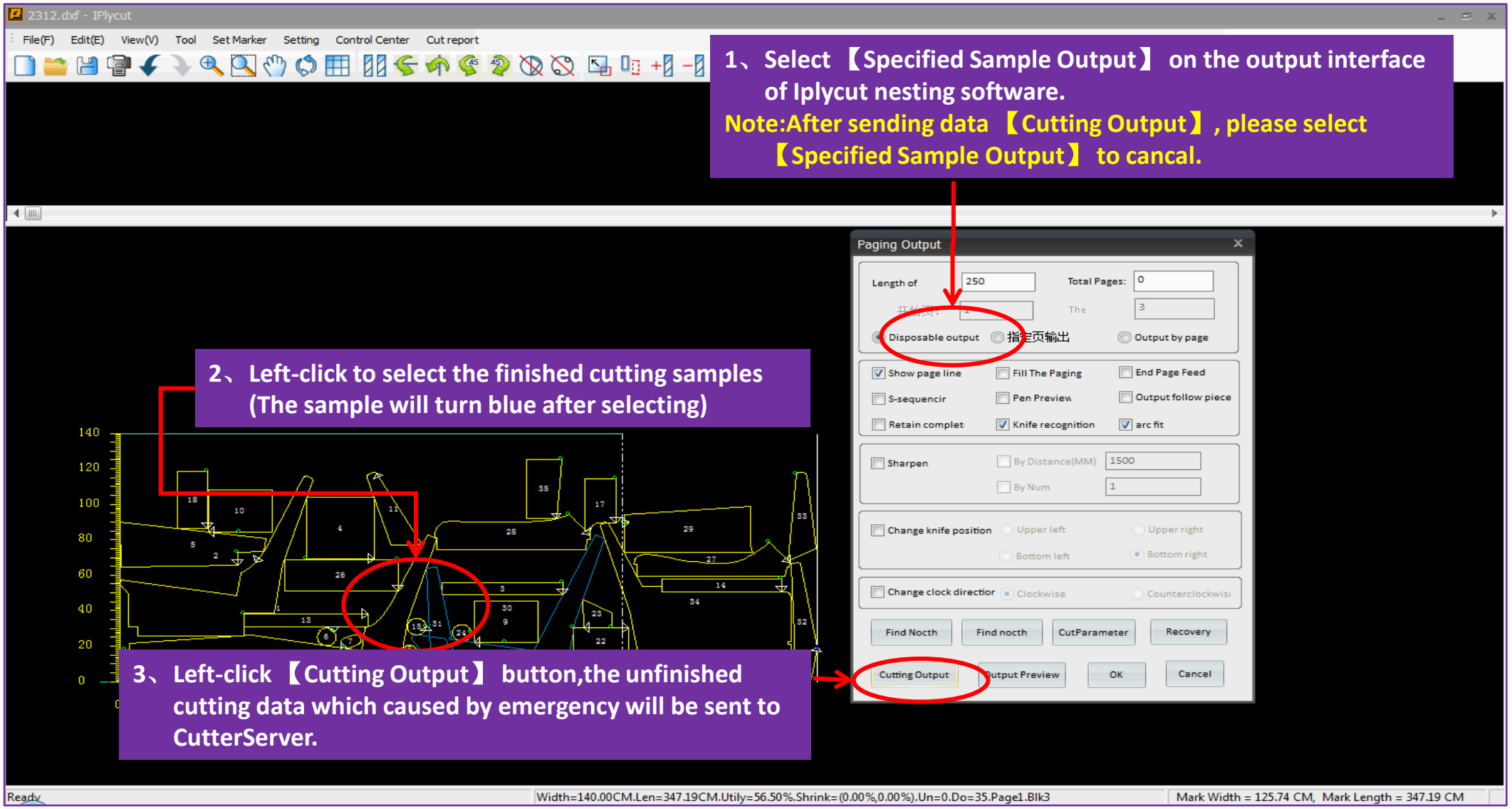
- In the cutting process, if the below alarm (Red light on the silencer) in CutterServer, it indicates that the emergency button is pressed.

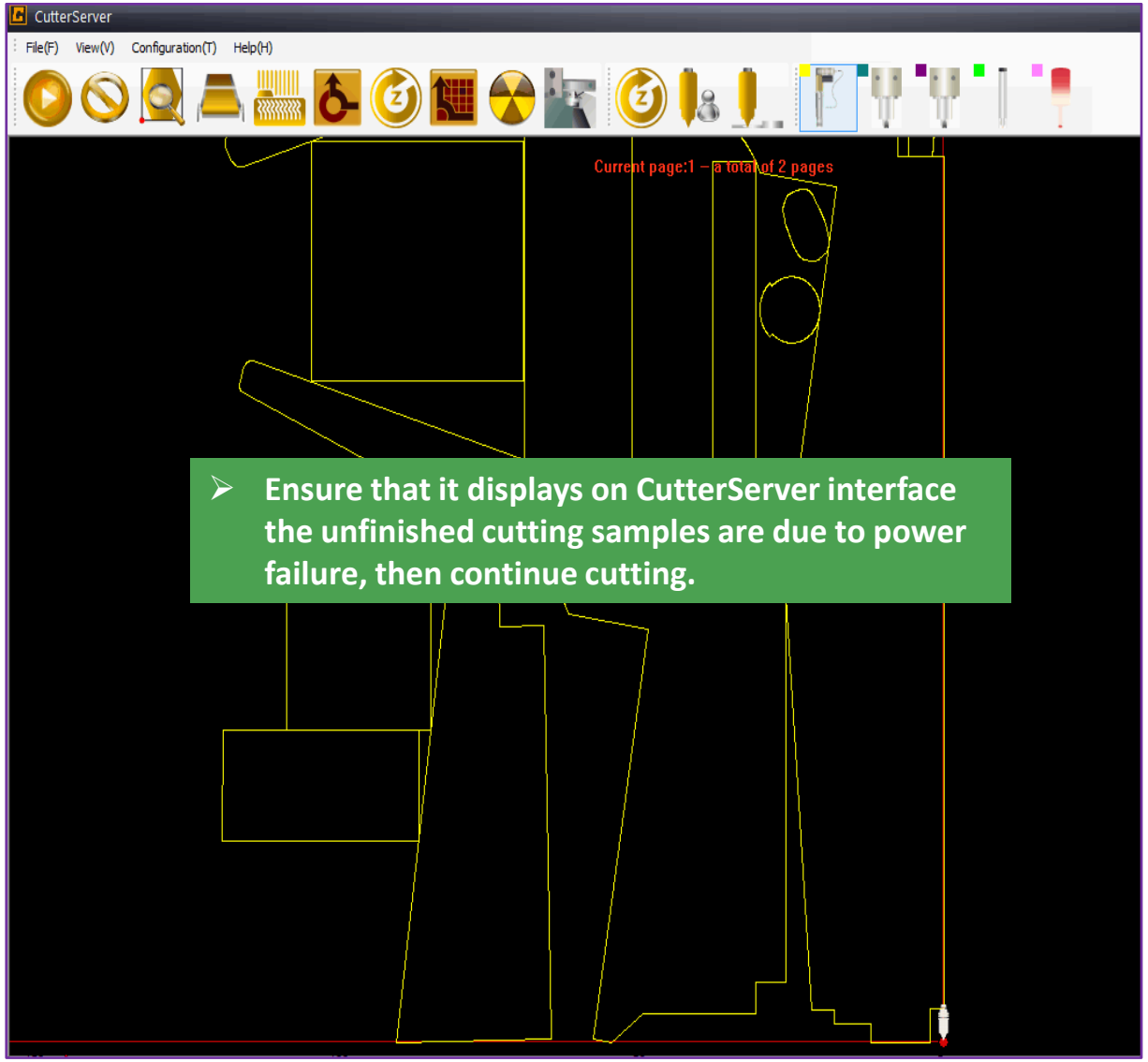


- Release the emergency button, rotate the red end of emergency button (rotate in the direction of the switch arrow, the emergency switch will popup.)

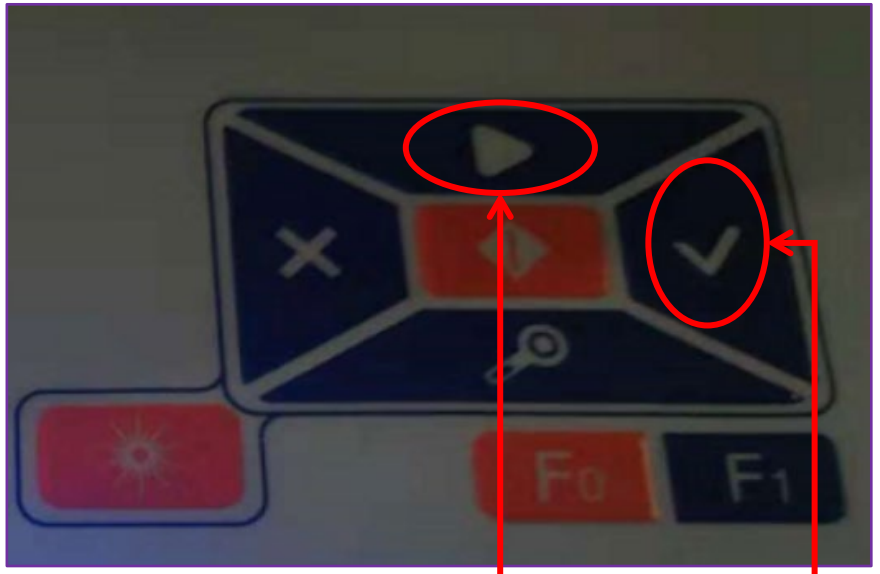

iECHO 爱科科技
1、Press 【Cancel Button】 on the control panel to cancel the alarm.
F0
F1
➢ When the emergency switch is pressed in the standby state or cutting, need to pull out the emergency switch every time, cancel the alarm and press the reset 【Enable Button】 to reset the equipment.
2、Press reset button【Enable Button】on the control panel to reset the equipment.


1、Press 【Relative Origin】button on the control panel.
2、Press 【OK】button on the control panel, to return the equipment to the relative origin (the last cutting point).
➢ The equipment has only one memory of relative origin point,. Do not send any data until the equipment back to the origin.


2312.dxf - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
1、Select 【Specified Sample Output】 on the output interface of Iplycut nesting software.
Note:After sending data 【Cutting Output】, please select 【Specified Sample Output】 to cancal.
2、Left-click to select the finished cutting samples (The sample will turn blue after selecting)
3、Left-click 【Cutting Output】 button,the unfinished cutting data which caused by emergency will be sent to CutterServer.
Paging Output
Length of
250
Total Pages:
0
The
3
Disposable output
指定页输出
Output by page
Show page line
Fill The Paging
End Page Feed
S-sequencir
Pen Preview
Output follow piece
Retain complet
Knife recognition
arc fit
Sharpen
By Distance(MM)
1500
By Num
1
Change knife position
Upper left
Upper right
Bottom left
Bottom right
Change clock directior
Clockwise
Counterclockwis
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Output Preview
OK
Cancel
Ready
Width=140.00CM.Len=347.19CM.Utily=56.50%.Shrink=(0.00%,0.00%).Un=0.Do=35.Page1.Blk3
Mark Width = 125.74 CM, Mark Length = 347.19 CM



- Ensure that it displays on CutterServer interface the unfinished cutting samples are due to power failure, then continue cutting.



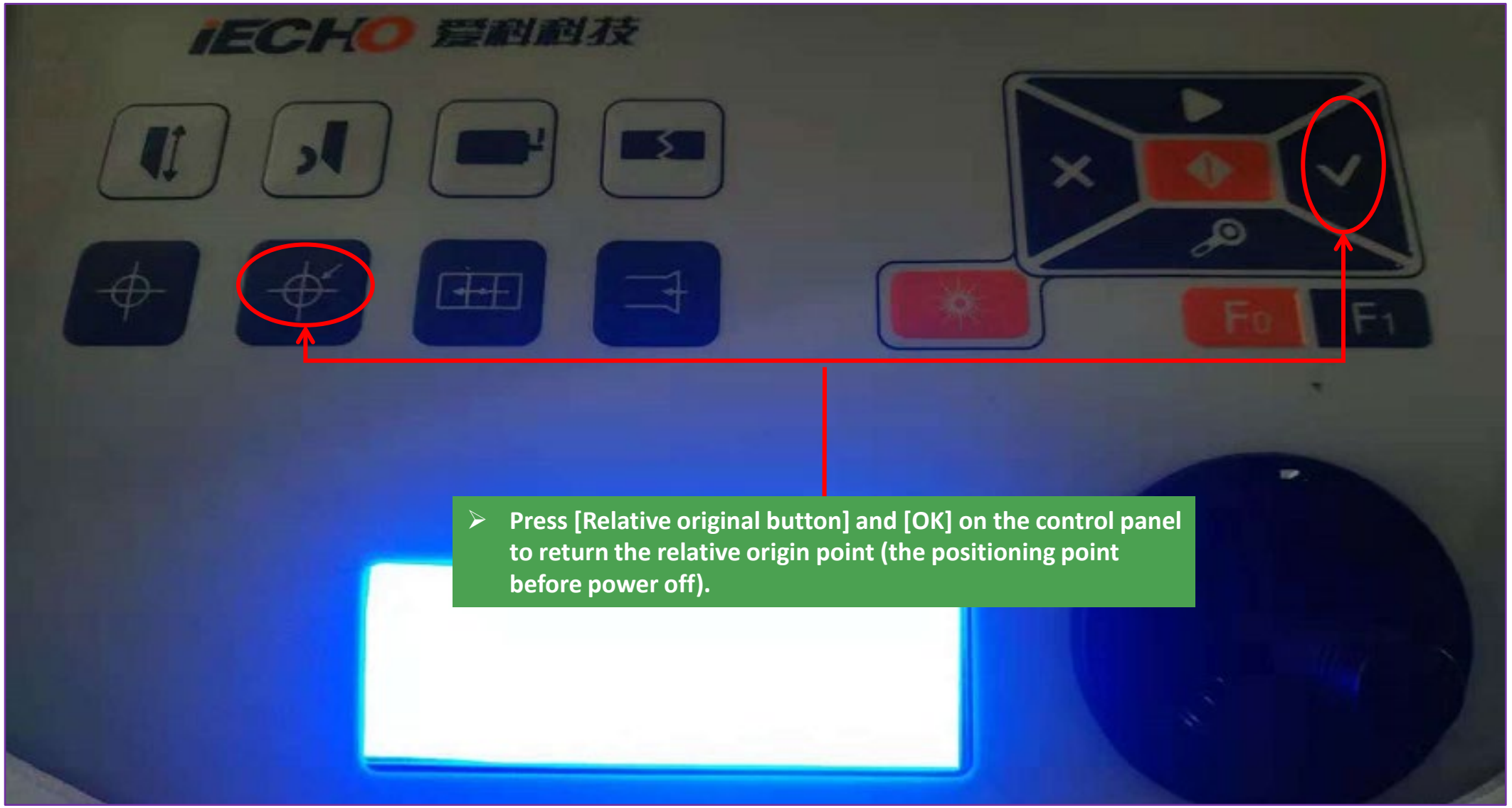
1、Press【Start】button on control panel.

2、Press【OK】button to start cutting.

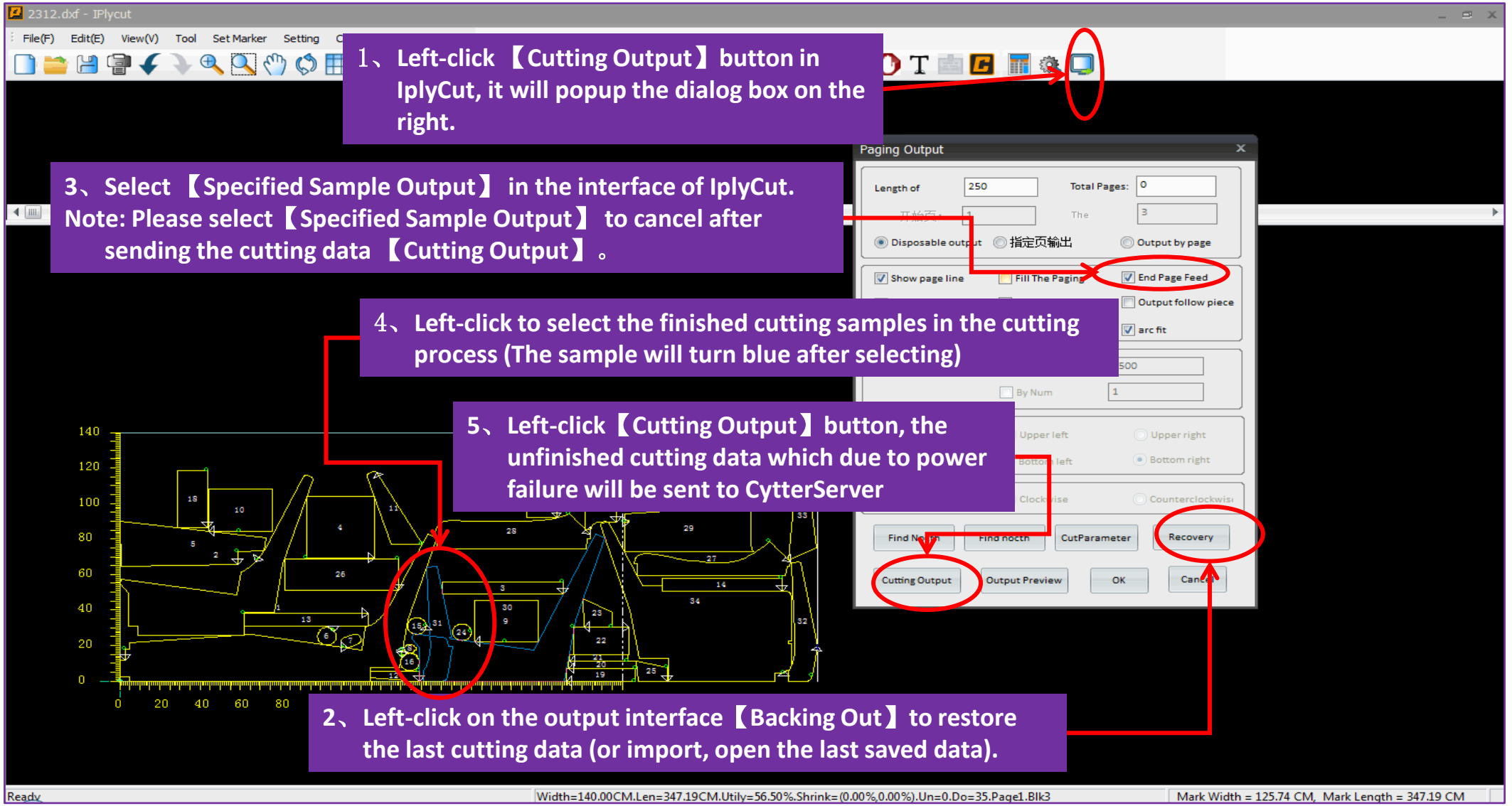
- In the cutting process, if the equipment suddenly lose power and continue to cut again as follows.

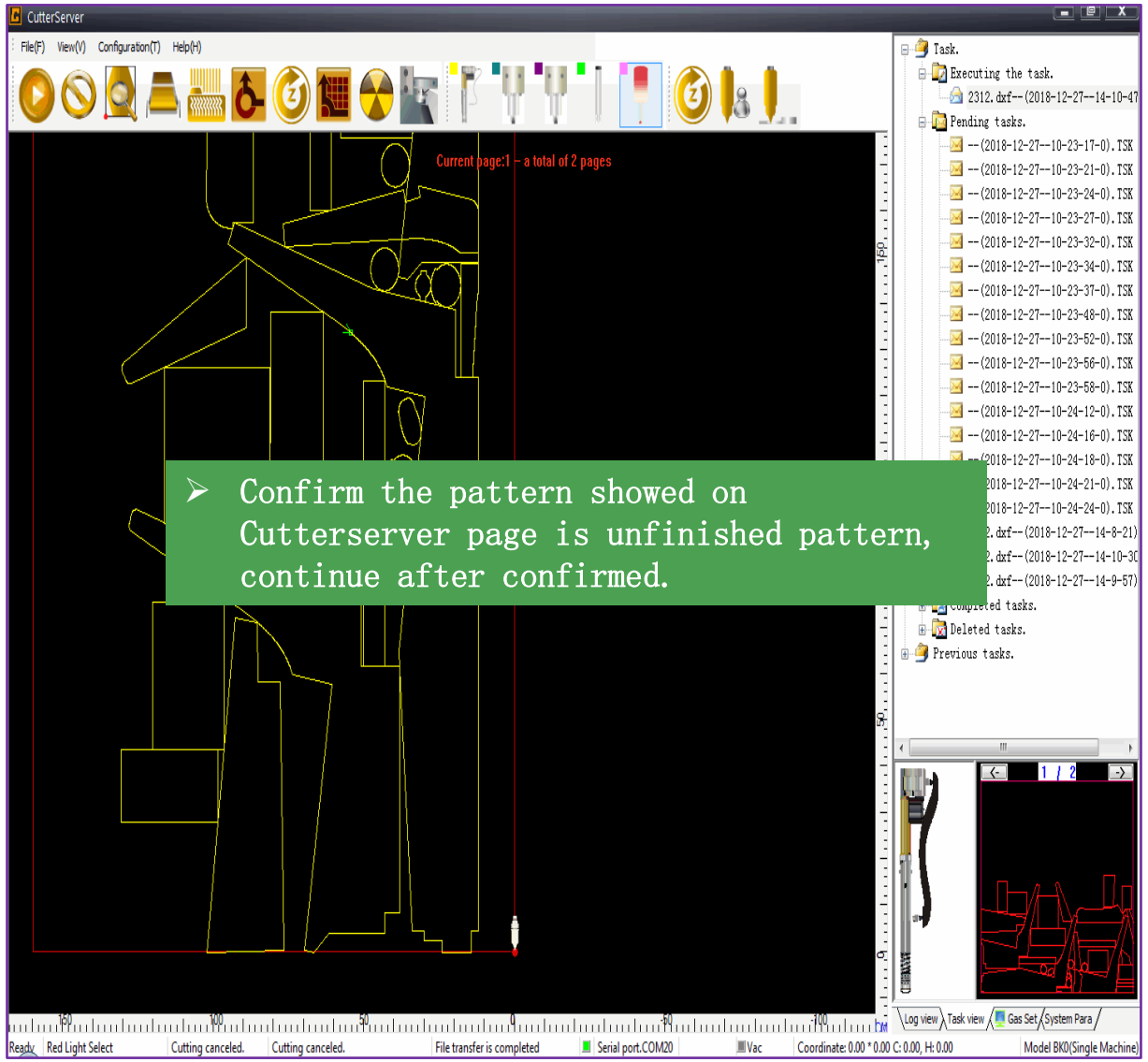
1、Power on the equipment, turn on the computer and nesting, cutting control software.

2、Reset the equipment.

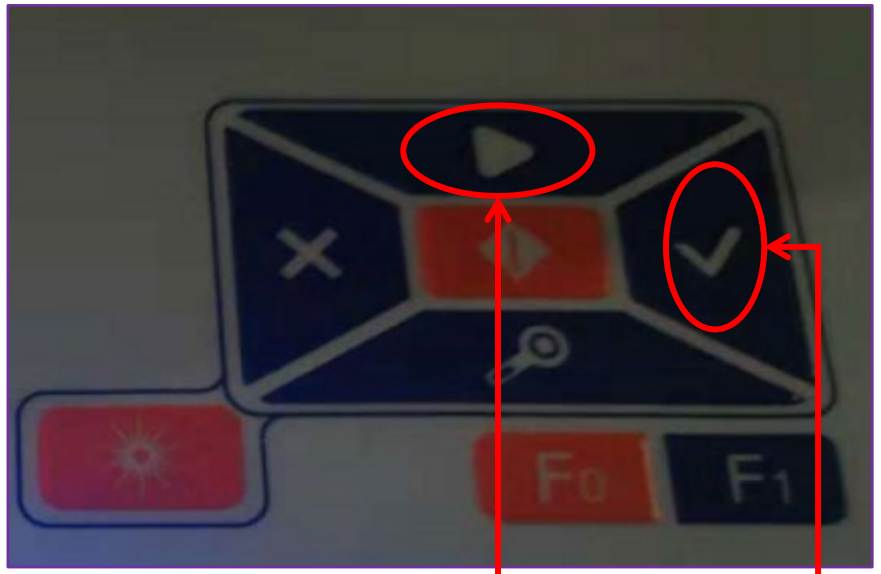


- Press [Relative original button] and [OK] on the control panel to return the relative origin point (the positioning point before power off).


2312.dxf - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting
1、Left-click 【Cutting Output】button in IplyCut, it will popup the dialog box on the right.
3、Select 【Specified Sample Output】 in the interface of IplyCut.
Note: Please select【Specified Sample Output】 to cancel after sending the cutting data 【Cutting Output】。
4、Left-click to select the finished cutting samples in the cutting process (The sample will turn blue after selecting)
5、Left-click【Cutting Output】button, the unfinished cutting data which due to power failure will be sent to CytterServer
2、Left-click on the output interface【Backing Out】to restore the last cutting data (or import, open the last saved data).
Paging Output
Length of
250
Total Pages:
0
Disposable output
指定页输出
Output by page
Show page line
Fill The Paging
End Page Feed
Output follow piece
arc fit
By Num
Upper left
Upper right
Bottom right
CutParameter
Recovery
Cutting Output
Output Preview
OK
Ready
Width=140.00CM.Len=347.19CM.Utily=56.50%.Shrink=(0.00%,0.00%).Un=0.Do=35.Page1.Blk3
Mark Width = 125.74 CM, Mark Length = 347.19 CM



- Confirm the pattern showed on Cutterserver page is unfinished pattern, continue after confirmed.



1. Click START button on control panel.

2. Click CONFIRM button on control panel and confirm to start cutting.

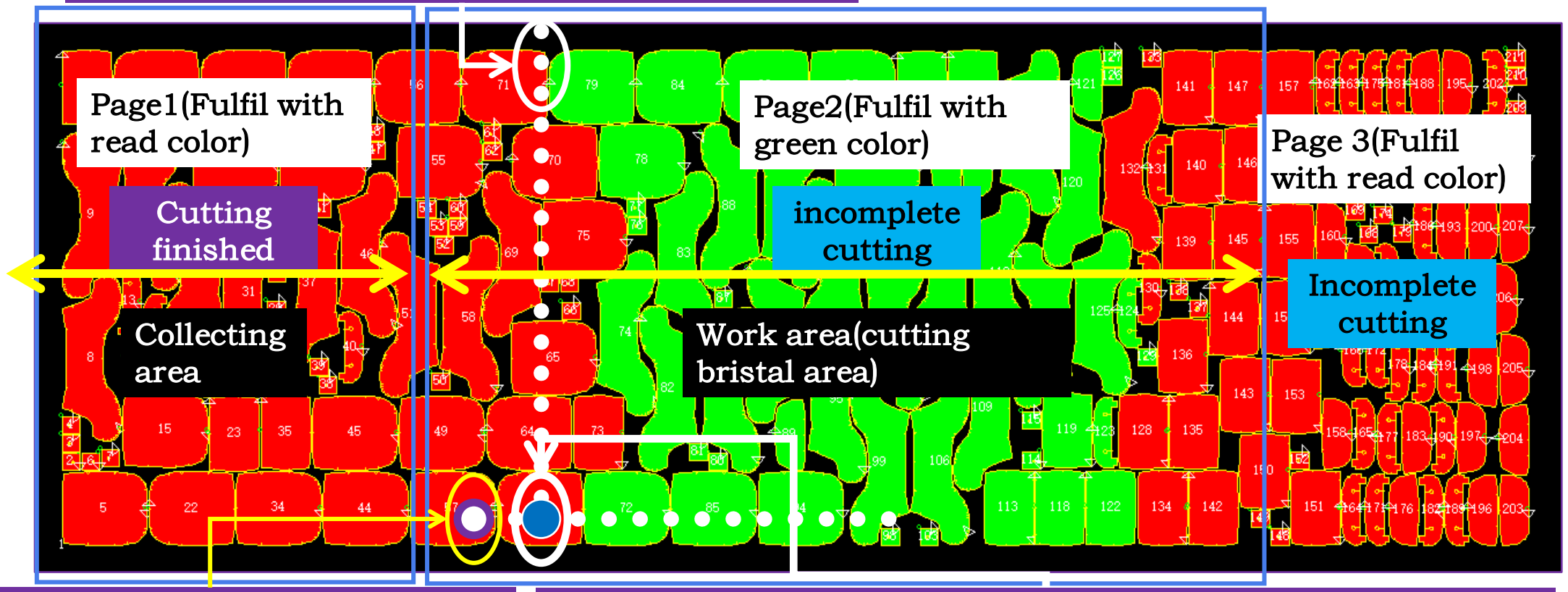
➢ If electricity fails when transfer feeding, restart cutting job as follows

1、 Connected the power, open PC,nesting, cutting control software.

2、Reset

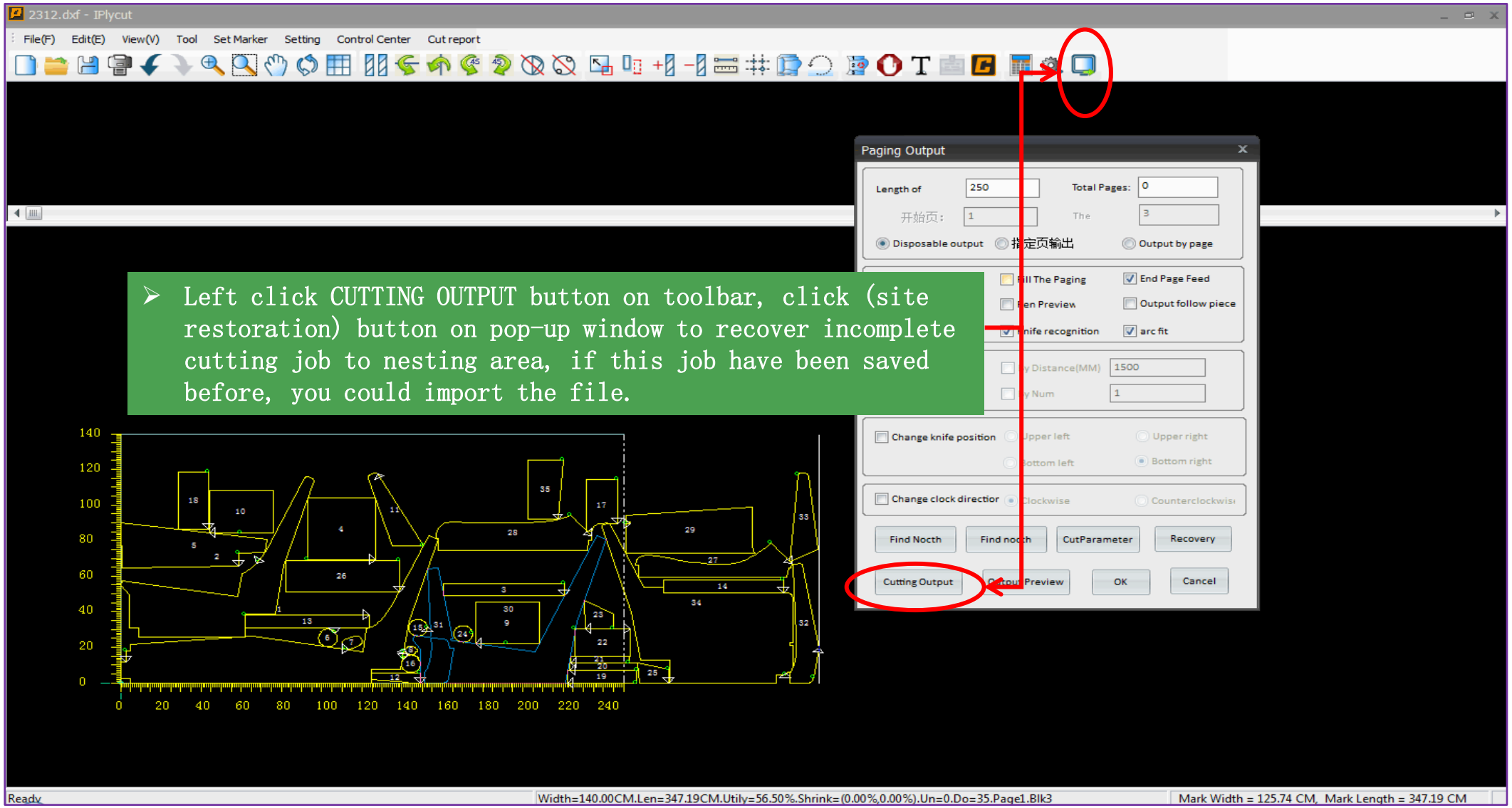
3、 3. Hold Conveyor button or FORWARD or BACK button for conveyoring, feeding the material to last cutting point approximately(Make sure the cutter could reach).

2、 Move rocker on cutter, turn on red light, move tool head to the nearest position of original point on first page of finished pattern.

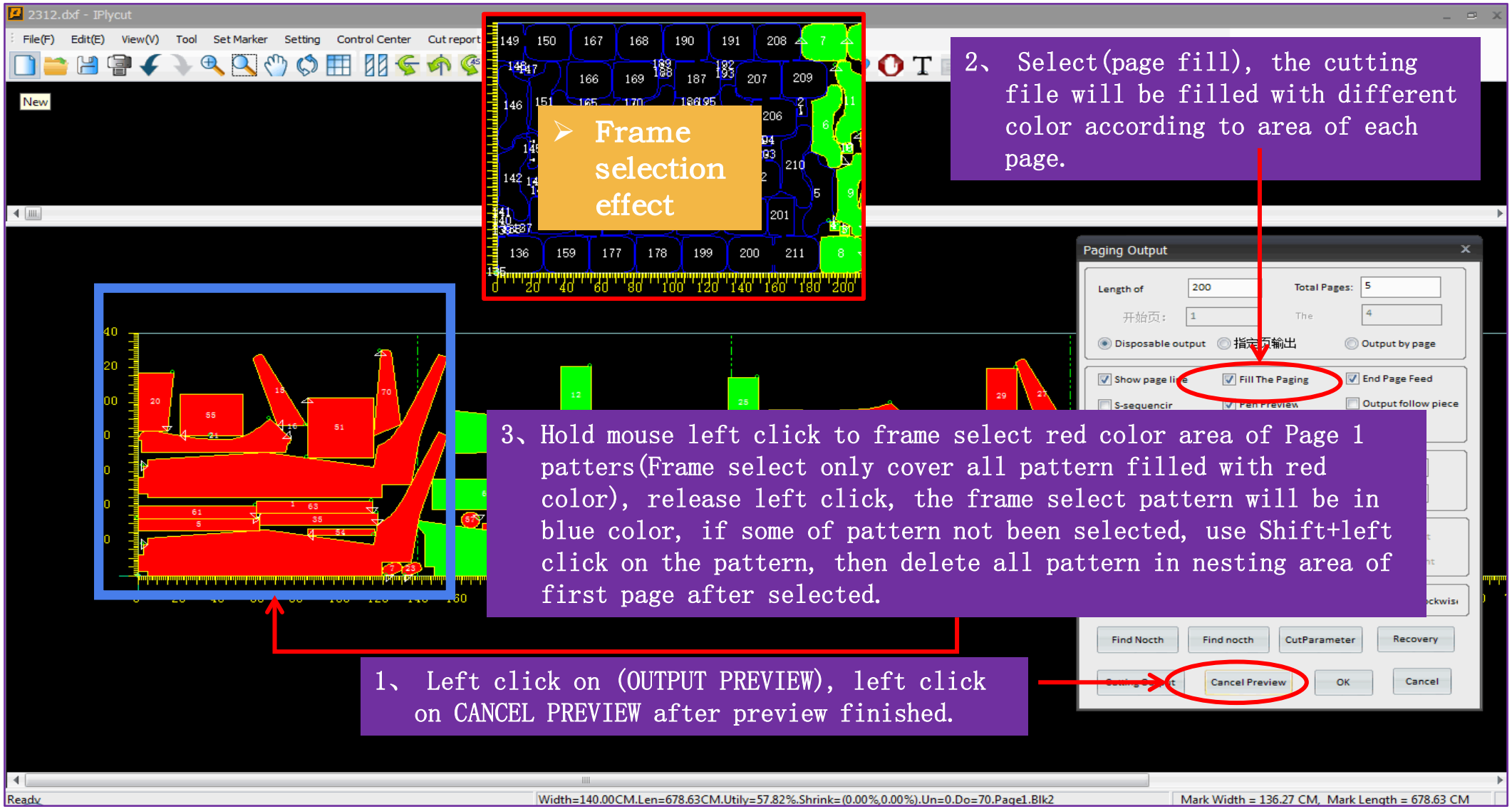


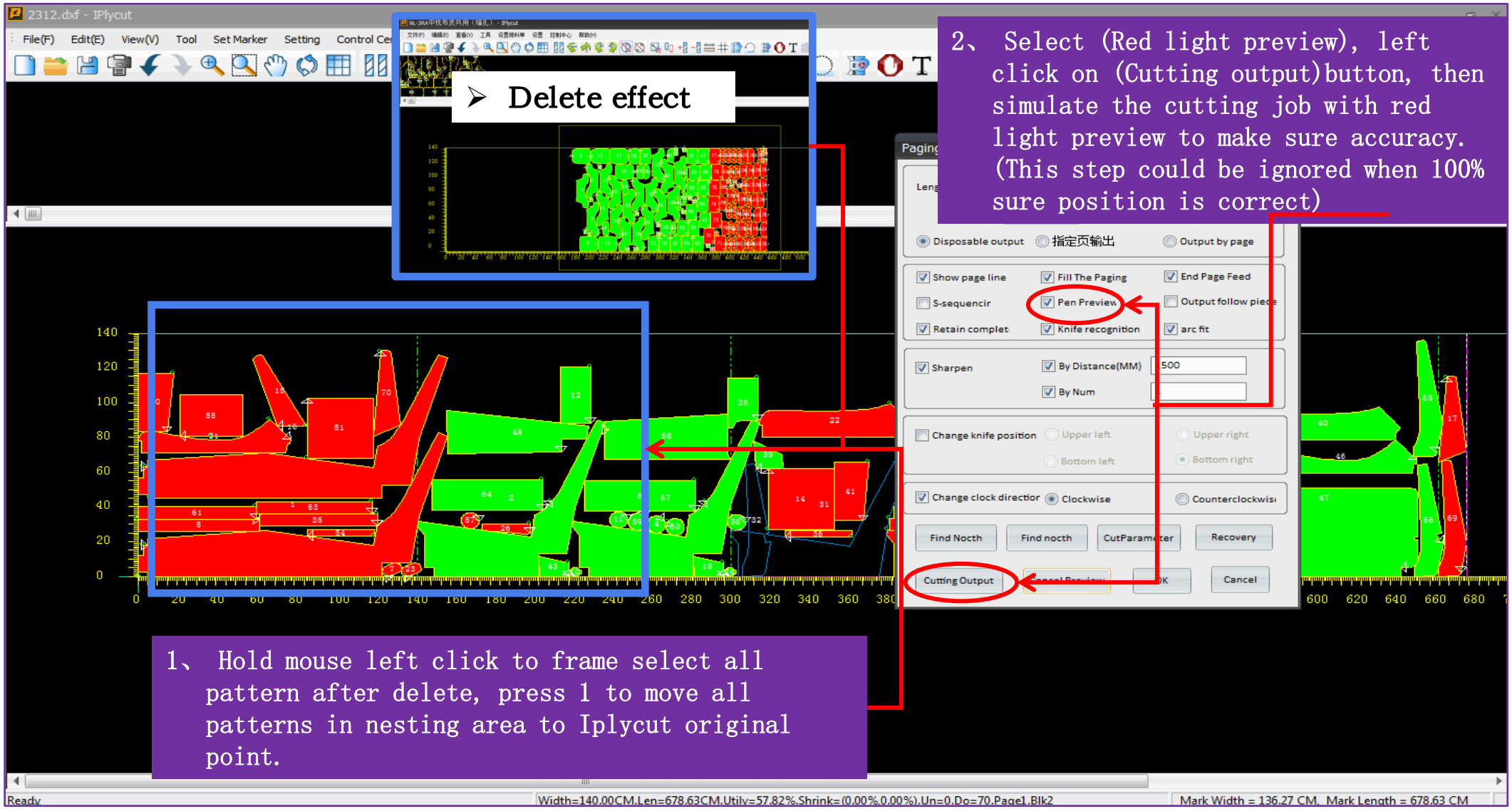
1、 When machine back to Relative original position, turn on vacuum and red light, make marks of the position of red light on material when necessary.

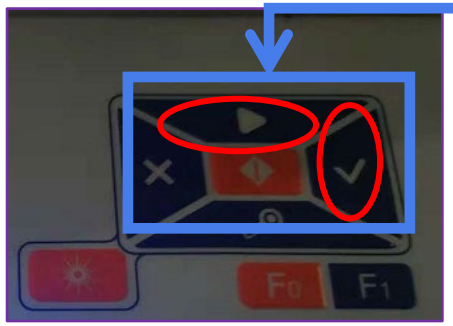
3、 Move rocker, turn on red light, move tool head vertical (Keep tool head move by Y axis only), move red light to the position of extension line of relative point on X axis(This is the new locating point).



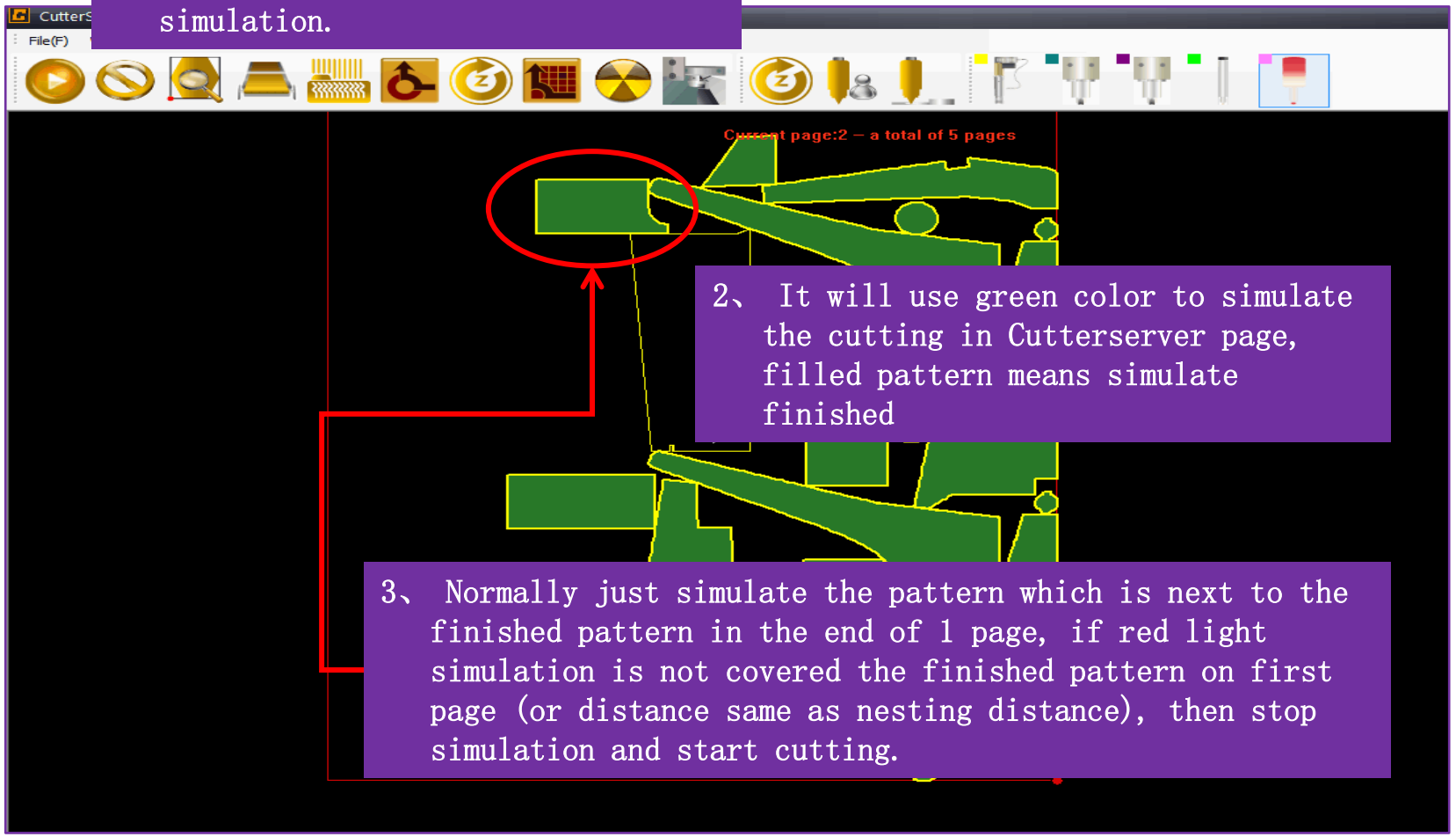
- Left click CUTTING OUTPUT button on toolbar, click (site restoration) button on pop-up window to recover incomplete cutting job to nesting area, if this job have been saved before, you could import the file.


2312.dxf - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
New
Frame selection effect
2、 Select(page fill), the cutting file will be filled with different color according to area of each page.
Paging Output
Length of 200
Total Pages: 5
开始页: 1
The 4
Disposable output
指定页输出
Output by page
Show page line
Fill The Paging
End Page Feed
S-sequencir
Pen Preview
Output follow piece
Find Nocth
Find nocth
CutParameter
Recovery
Cancel Preview
OK
Cancel
3、Hold mouse left click to frame select red color area of Page 1 patters(Frame select only cover all pattern filled with red color), release left click, the frame select pattern will be in blue color, if some of pattern not been selected, use Shift+left click on the pattern, then delete all pattern in nesting area of first page after selected.
1、 Left click on (OUTPUT PREVIEW), left click on CANCEL PREVIEW after preview finished.
Ready
Width=140.00CM.Len=678.63CM.Utily=57.82%.Shrink=(0.00%,0.00%).Un=0.Do=70.Page1.Blk2
Mark Width = 136.27 CM, Mark Length = 678.63 CM


2312.dxf - IPlycut
File(F)
Edit(E)
View(V)
Tool
Set Marker
Setting
Delete effect
2、 Select (Red light preview), left click on (Cutting output)button, then simulate the cutting job with red light preview to make sure accuracy. (This step could be ignored when 100% sure position is correct)
Disposable output
指定页输出
Output by page
Show page line
Fill The Paging
End Page Feed
S-sequencir
Pen Preview
Output follow piece
Retain complet
Knife recognition
arc fit
Sharpen
By Distance(MM)
By Num
Change knife position
Upper left
Upper right
Bottom left
Bottom right
Change clock direction
Clockwise
Counterclockwise
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Cancel
1、 Hold mouse left click to frame select all pattern after delete, press 1 to move all patterns in nesting area to Iplycut original point.
Ready
Width=140.00CM,Len=678.63CM,Utily=57.82%,Shrink=(0.00%,0.00%),Un=0,Do=70,Page1,Blk2
Mark Width = 136.27 CM, Mark Length = 678.63 CM



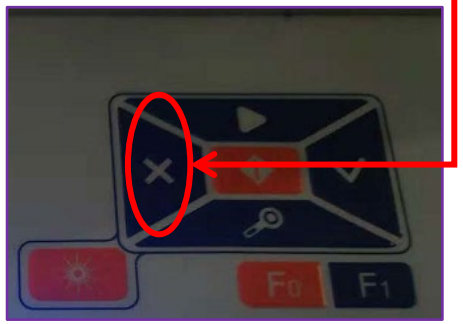
1、 Press (Start) & (Confirm) button on control panel to start simulation.

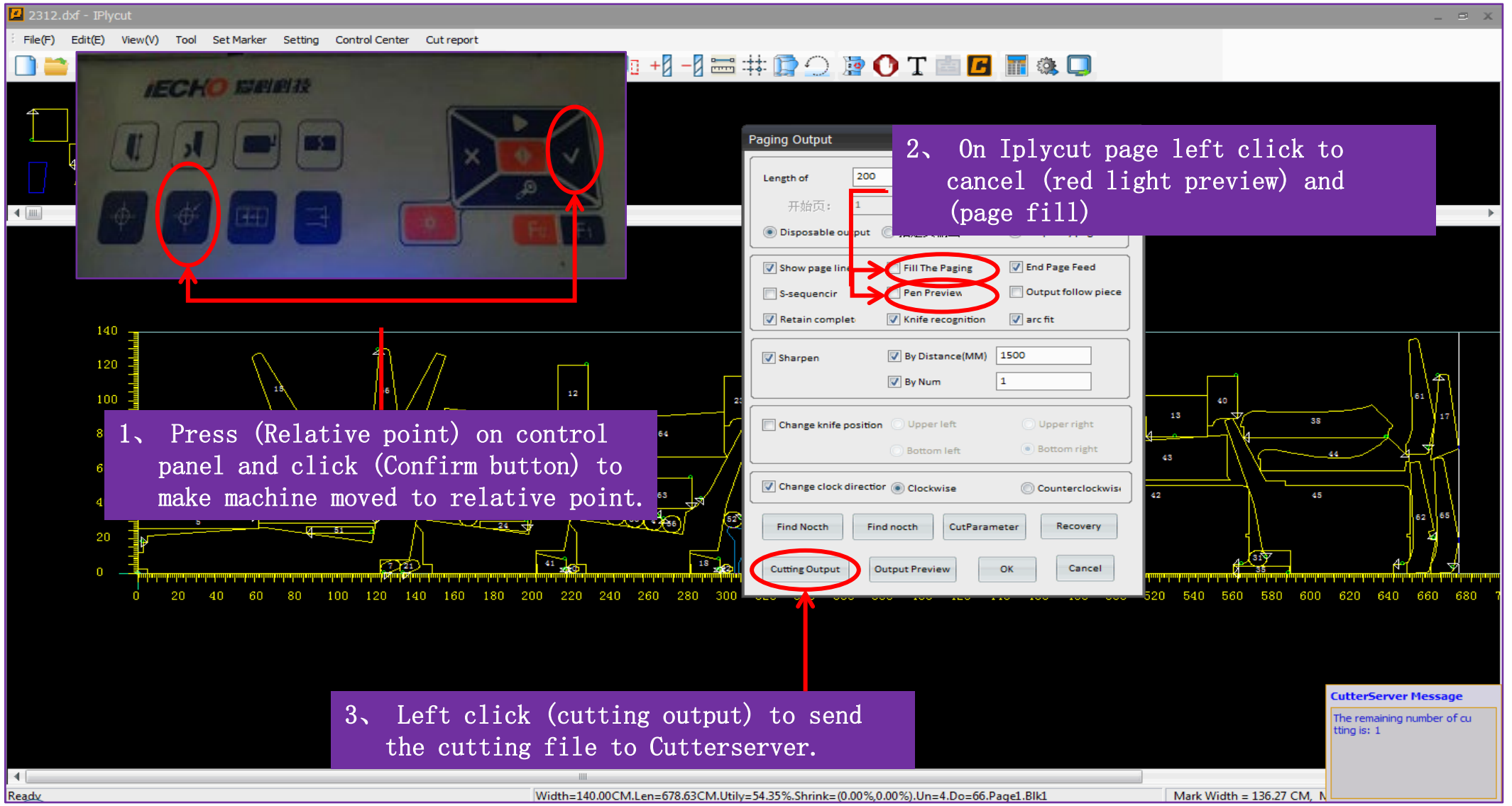


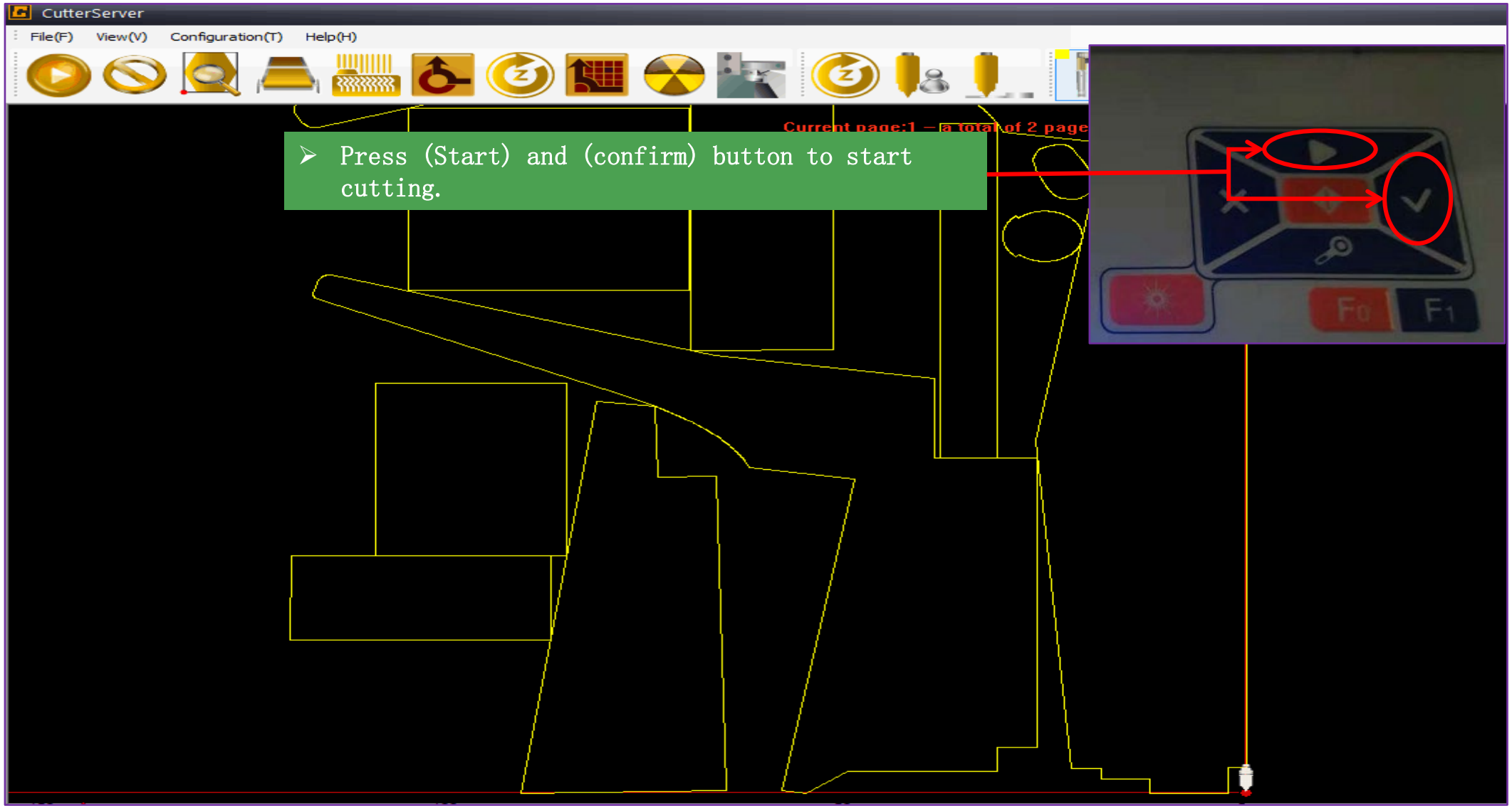
2、 It will use green color to simulate the cutting in Cutterserver page, filled pattern means simulate finished

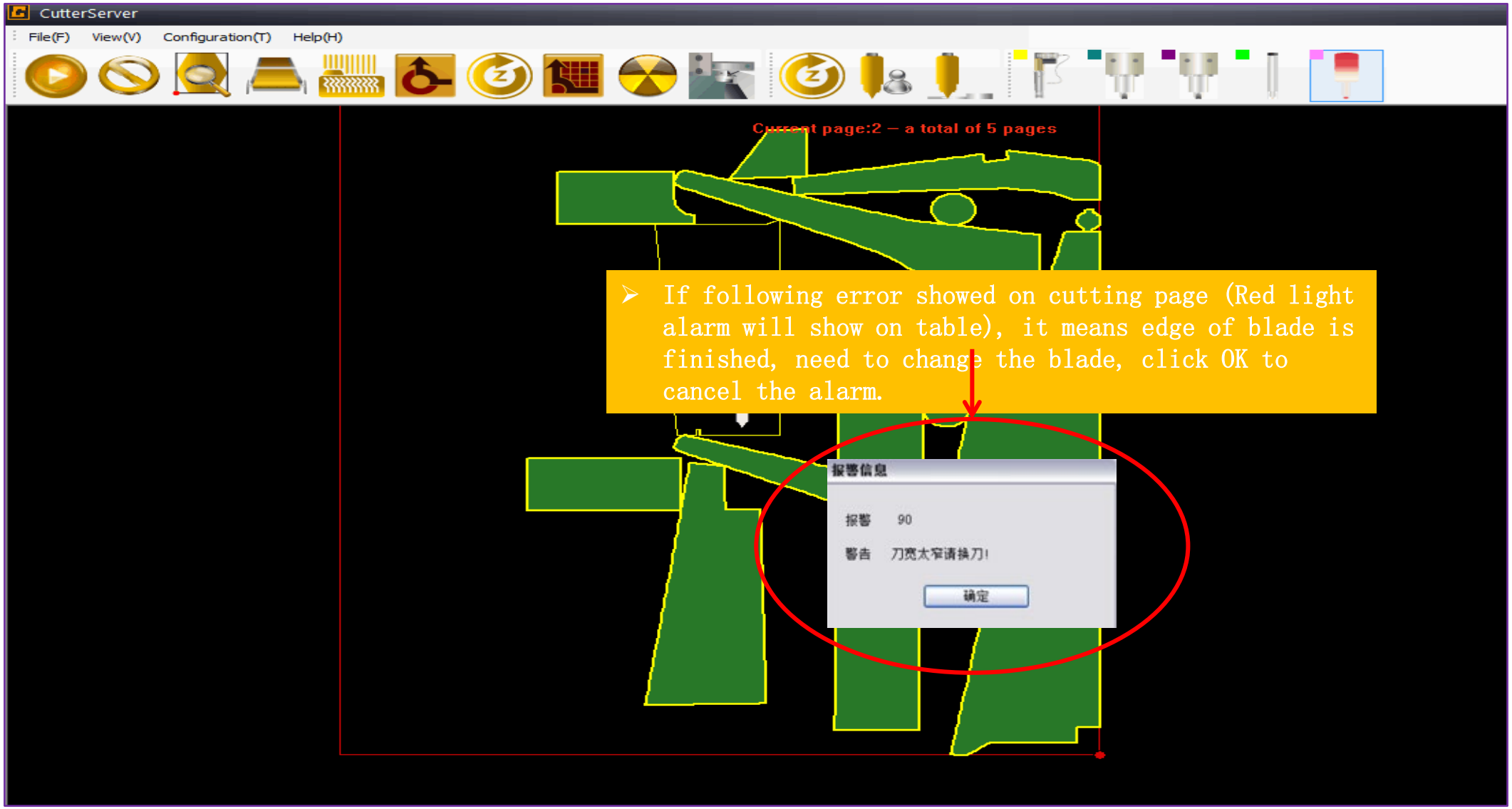
3、 Normally just simulate the pattern which is next to the finished pattern in the end of 1 page, if red light simulation is not covered the finished pattern on first page (or distance same as nesting distance), then stop simulation and start cutting.

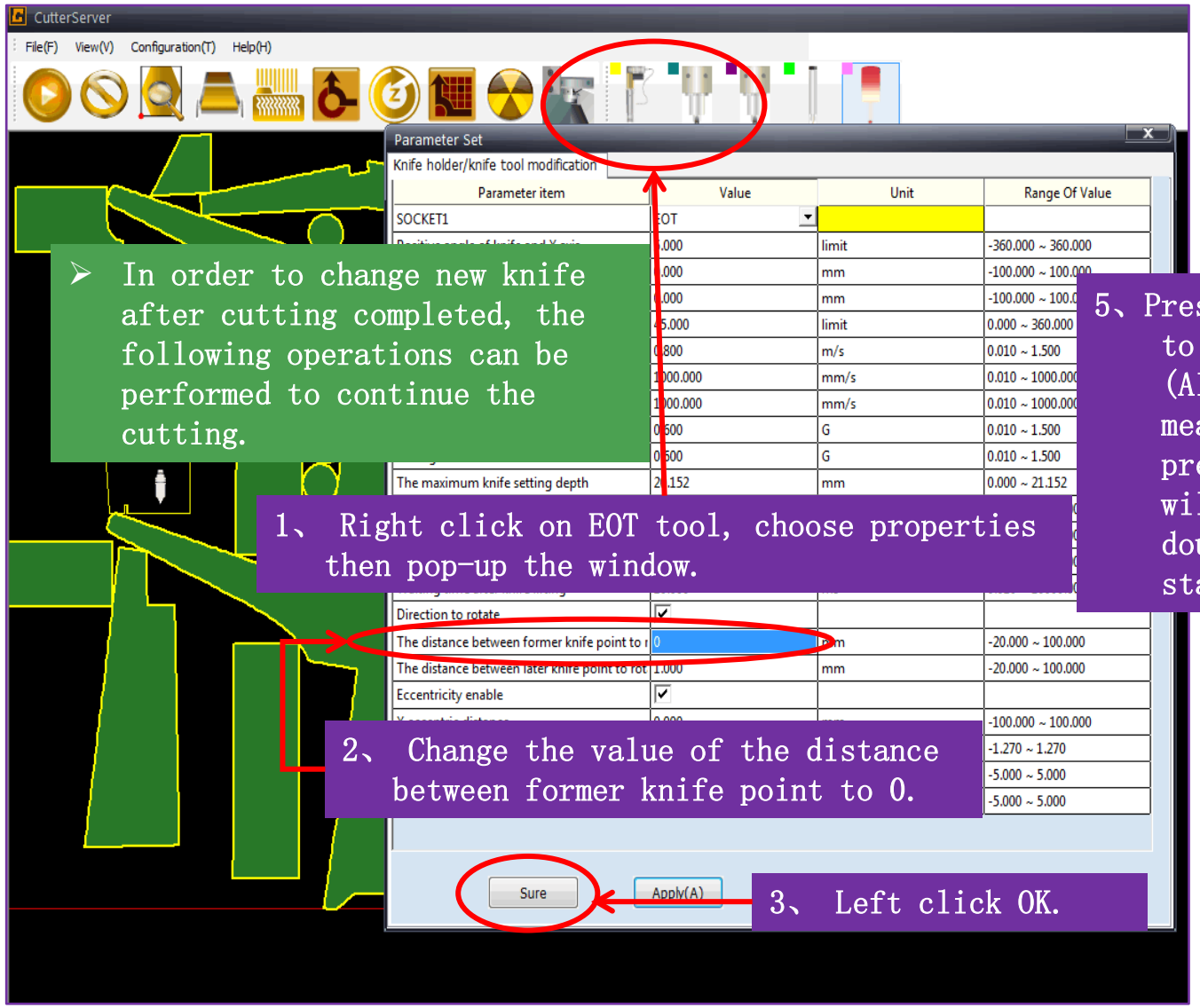
4、 Press(Cancel)Button on control panel to cancel simulation.




2312.dxf - IPlycut
File(F) Edit(E) View(V) Tool Set Marker Setting Control Center Cut report
Paging Output
Length of
200
Disposable output
Show page line
Fill The Paging
End Page Feed
S-sequencir
Pen Preview
Output follow piece
Retain complet
Knife recognition
arc fit
Sharpen
By Distance(MM)
1500
By Num
1
Change knife position
Upper left
Upper right
Bottom left
Bottom right
Change clock direction
Clockwise
Counterclockwise
Find Nocth
Find nocth
CutParameter
Recovery
Cutting Output
Output Preview
OK
Cancel
1、 Press (Relative point) on control panel and click (Confirm button) to make machine moved to relative point.
2、 On Iplycut page left click to cancel (red light preview) and (page fill)
3、 Left click (cutting output) to send the cutting file to Cutterserver.
CutterServer Message
The remaining number of cutting is: 1
Ready
Width=140.00CM.Len=678.63CM.Utily=54.35%.Shrink=(0.00%,0.00%).Un=4.Do=66.Page1.Blk1
Mark Width = 136.27 CM


CutterServer
File(F)
View(V)
Configuration(T)
Help(H)
Current page:1 — a total of 2 page
➢ Press (Start) and (confirm) button to start cutting.
F0
F1


CutterServer
File(F)
View(V)
Configuration(T)
Help(H)
Current page:2 – a total of 5 pages
If following error showed on cutting page (Red light alarm will show on table), it means edge of blade is finished, need to change the blade, click OK to cancel the alarm.
报警信息
报警 90
警告 刀宽太窄请换刀!
确定



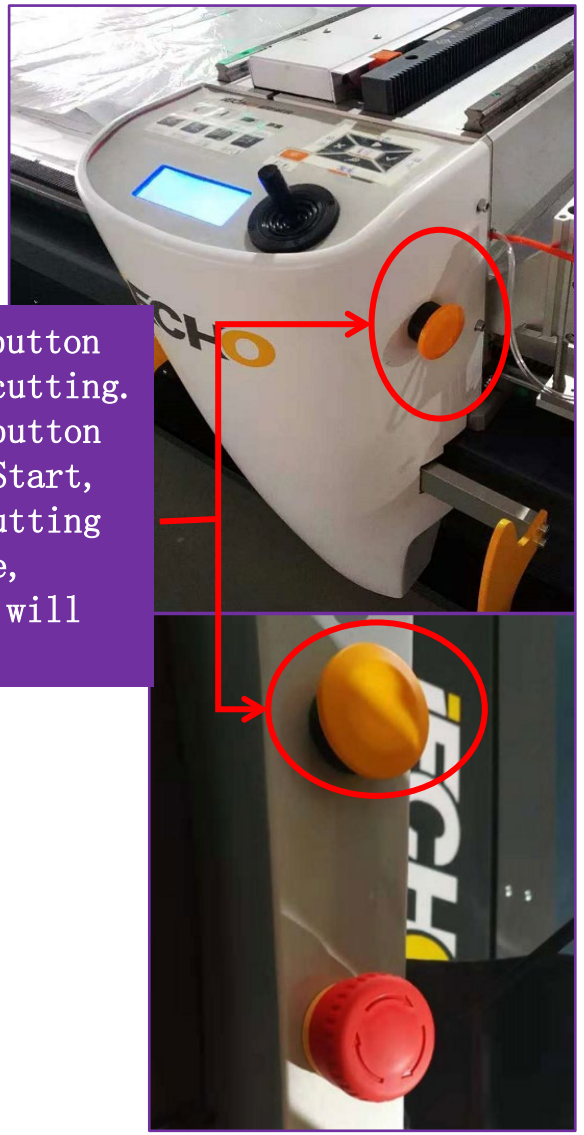
➢ In order to change new knife after cutting completed, the following operations can be performed to continue the cutting.

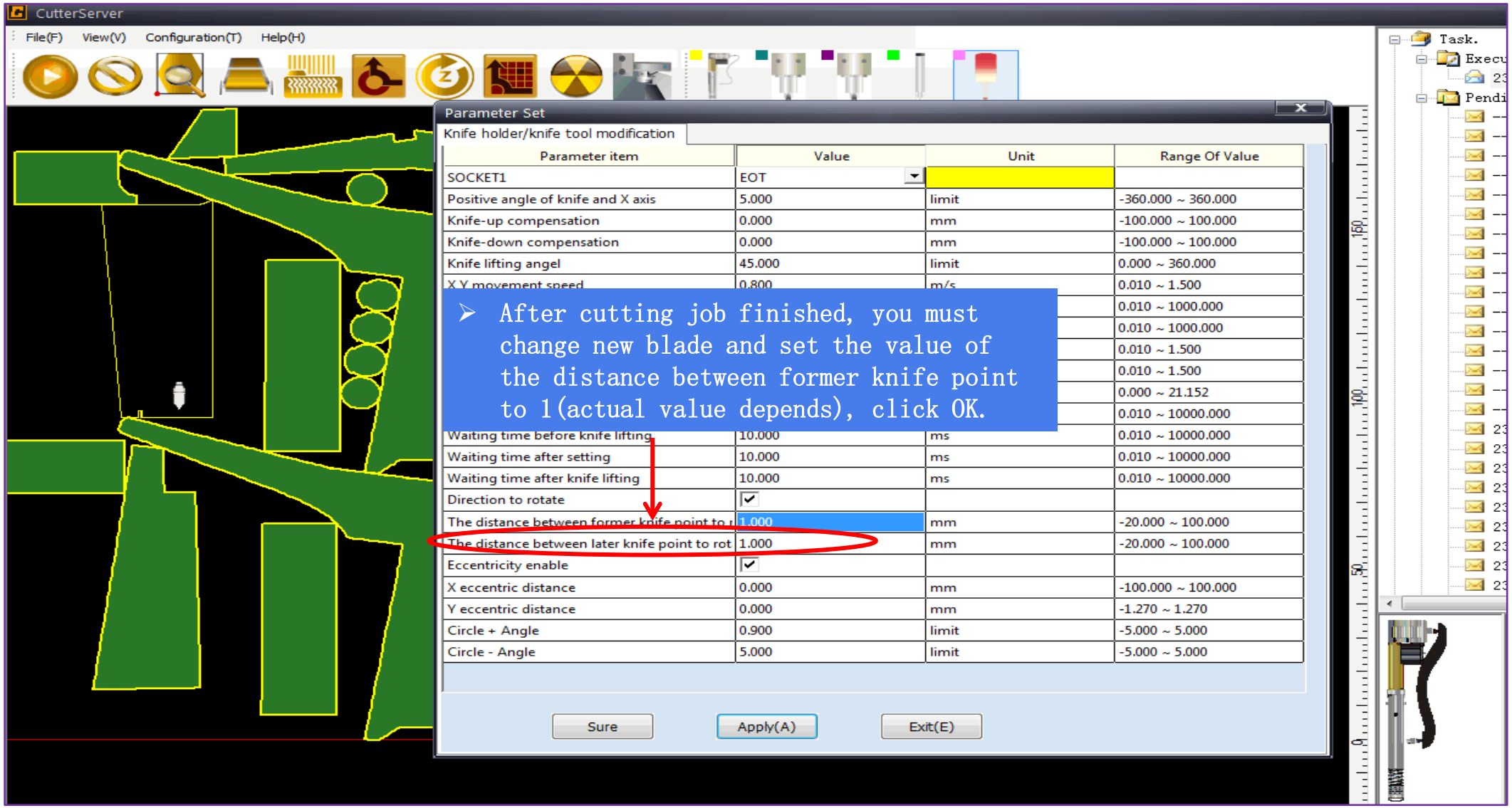
1、 Right click on EOT tool, choose properties then pop-up the window.

2、 Change the value of the distance between former knife point to 0.

3、 Left click OK.

5、Press yellow button to continue cutting. (All yellow button means Pause/Start, press when cutting will be pause, double press will start)




CutterServer
File(F)
View(V)
Configuration(T)
Help(H)
Parameter Set
Knife holder/knife tool modification
Parameter item
Value
Unit
Range Of Value
SOCKET1
EOT
Positive angle of knife and X axis
5.000
limit
-360.000 ~ 360.000
Knife-up compensation
0.000
mm
-100.000 ~ 100.000
Knife-down compensation
0.000
mm
-100.000 ~ 100.000
Knife lifting angel
45.000
limit
0.000 ~ 360.000
X Y movement speed
0.800
m/s
0.010 ~ 1.500
0.010 ~ 1000.000
0.010 ~ 1000.000
0.010 ~ 1.500
0.010 ~ 1.500
0.000 ~ 21.152
0.010 ~ 10000.000
Waiting time before knife lifting
10.000
ms
0.010 ~ 10000.000
Waiting time after setting
10.000
ms
0.010 ~ 10000.000
Waiting time after knife lifting
10.000
ms
0.010 ~ 10000.000
Direction to rotate
The distance between former knife point to r
1.000
mm
-20.000 ~ 100.000
The distance between later knife point to rot
1.000
mm
-20.000 ~ 100.000
Eccentricity enable
X eccentric distance
0.000
mm
-100.000 ~ 100.000
Y eccentric distance
0.000
mm
-1.270 ~ 1.270
Circle + Angle
0.900
limit
-5.000 ~ 5.000
Circle - Angle
5.000
limit
-5.000 ~ 5.000
Sure
Apply(A)
Exit(E)
Task.
Execu
Pendi
After cutting job finished, you must change new blade and set the value of the distance between former knife point to 1(actual value depends), click OK.

IECHO GLS Multi-ply Cutter

Hangzhou IECHO Science & Technology Co., Ltd.