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Brush Sanding Machine

ZDBS1000-6RS

Instruction Manual

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# Automatic Polishing Machine Operating System

No.1 boot interface

Start-up interface: This is the first interface. Observe if the yellow alarm bar below the interface has any alarm content. If there is an alarm content, the equipment alarm warning light will also give an audible and visual warning. Please find the cause of the alarm according to the alarm content and solve it.

After the cause of the alarm is eliminated, the "enter the system" operation can be performed.

NO.2 System Interface
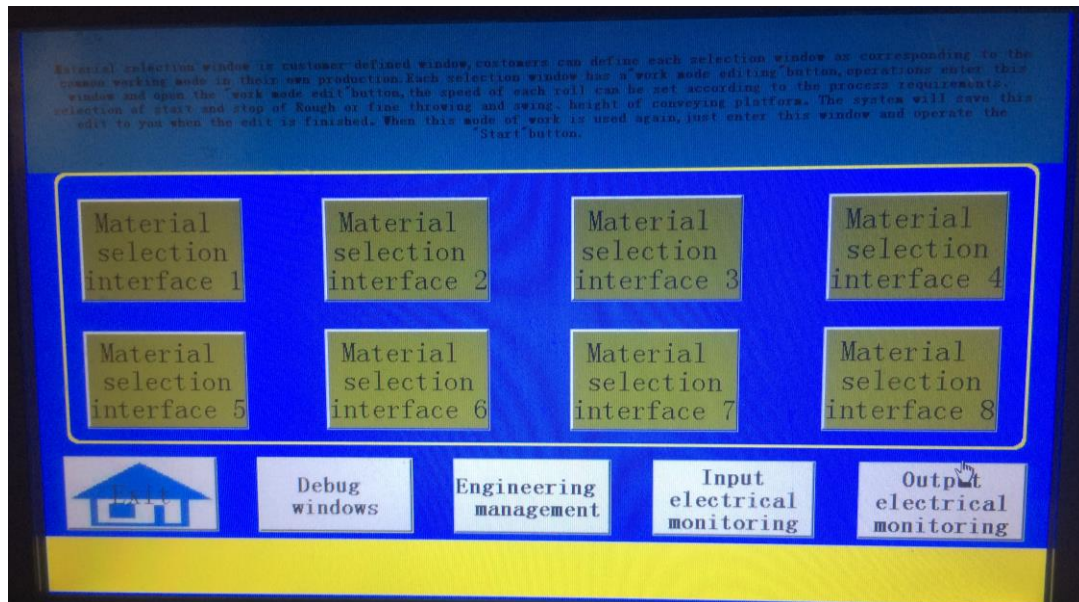
Operation "Enter the system" will enter the interface shown above: This interface is provided with eight material selection buttons, each of which corresponds to a working window. The customer can edit and set the working mode of each material selection window according to different workpieces and process requirements, and save it, so that similar products can be directly processed later.

"Exit System": Press this key to exit this interface and return to the startup interface in Figure 1.

"Debug work window": This interface is used for the debugging of new machines, the process of understanding the machine by new customers, and the later maintenance of equipment.

"Grinding roller height setting": This interface is mainly used to set the height of the grinding roller relative to the conveyor belt and the reference "zero point", as well as limit settings to protect the lifting stroke.

"Project Management" This interface is mainly used to set the operating parameters of the equipment and troubleshoot the electrical equipment by monitoring the status of the operating electrical equipment.

NO.3 Debug Interface

The "A, B, C" four groups of grinding rollers in this window are arranged in the order corresponding to the order from the inlet to the outlet of the equipment.

The upper row of white "input boxes" is the frequency adjustment of the inverter corresponding to each group of grinding rollers and conveyor belts. The operating speed is adjusted by changing the operating frequency of the inverter. The running frequency value 1-50 of the inverter is valid.

The second row of "input box" is to display the height value of each group of grinding rollers relative to the reference zero point, the unit is MM. This input box is only used to display the current height of the grinding roller. You cannot enter a value to modify it. If you need to adjust the height of the grinding rollers, you can use the external "rise" and "down" buttons on each group of grinding rollers to adjust. You can also enter the "roller height setting interface" adjustment.

"Rough polishing" and "fine polishing" are the coarse and fine gauze rolls corresponding to the rotation direction of the grinding roll. Only one mode can be selected for each group of grinding rollers, and the two modes cannot and will not work at the same time. The bottom row of buttons is the corresponding swing motor control button for each group of grinding rollers.

NO.4 Grinding Roller Height Setting Interface
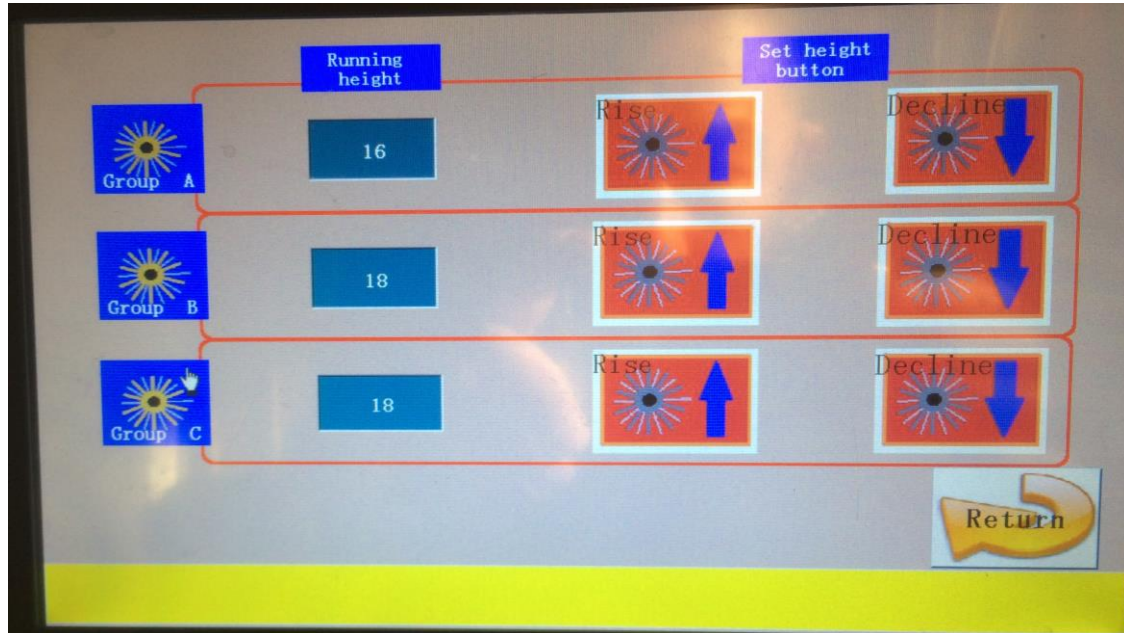
The grinding roller height display box on this interface is the same as that in the debugging window, which can only be used as the display height value, and cannot be directly entered and modified.

The "up" and "down" buttons are equivalent to external buttons. The default of the system is that the reference zero point is the lower limit point. If the grinding roller drops to the display value of "0", a "lower limit alarm" prompt will be issued. It is invalid to operate the "Down" button after issuing the descent alarm.

The value of "Lift Limit Setting" is based on the maximum stroke of the machine as a reference, in order to protect the machine from damage caused by misoperation beyond the stroke range of the machine. When the height of the grinding roller rises to the rising limit value, the system will also issue the "upper limit alarm" prompt. At this time, pressing the "rise" button is also invalid.

Please do not operate the "zero setting" button at will. The equipment has been debugged before leaving the factory, and the reference zero has been set. Only after the equipment is used for a period of time, the reason for the wear of the grinding roller makes the reference zero point have a large error. Only then need to reset the reference zero. How to set the reference zero point: Turn on the "Zero Setting" button on the green light interface, and then operate the "Down" button. It can be defined as the reference zero point when the grinding roller is in full contact with the surface of the conveyor belt. At this point, close the "Zero Setting" button and see if the altitude value is "0"? If it is not "0", we need to turn on and off the "Zero Setting" button again.

NO.5 Material Selection Interface
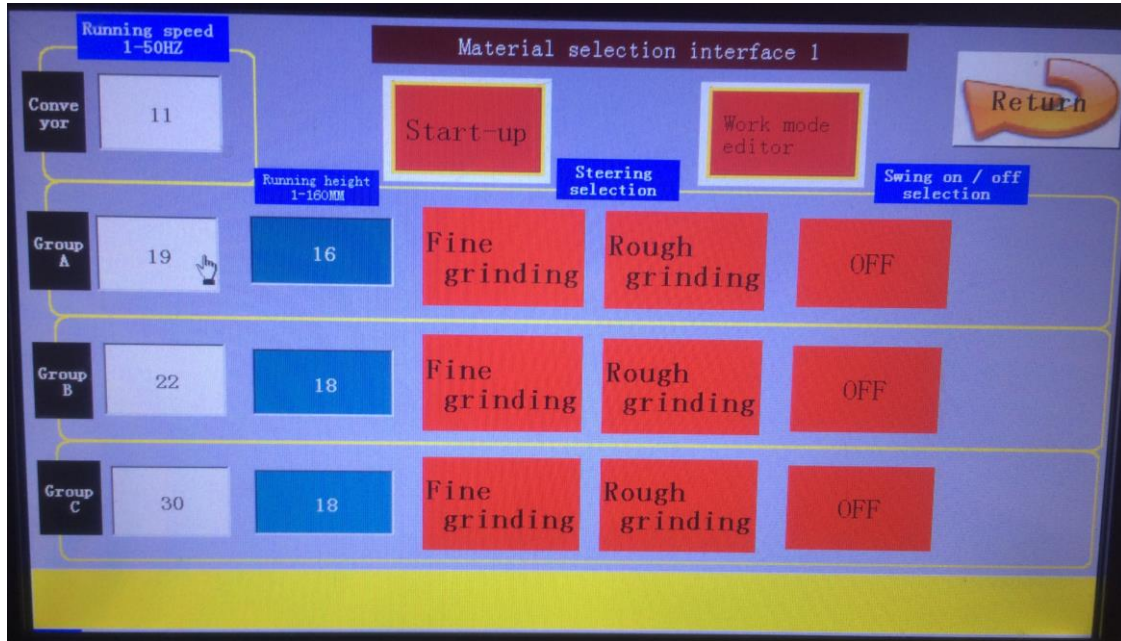
The selection of "material selection window" is basically equivalent to the automatic working mode, please ensure that each electrical appliance operates normally. This interface can be edited according to the customer's machining process requirements.

The running speed and roller height setting value should be set before "start". Do not modify the setting value after turning on the "start" button. When the working mode needs to be changed for process requirements, the "Start" and "Working Mode Edit" buttons should be turned on at the same time to modify the working mode. The parameter data and working mode of each material selection interface have a memory function. When the customer changes the parameter value and edited working mode, it will be automatically saved. When process of the same kind of workpiece next time, it can work directly.

NO.6 Input Electrical Monitoring
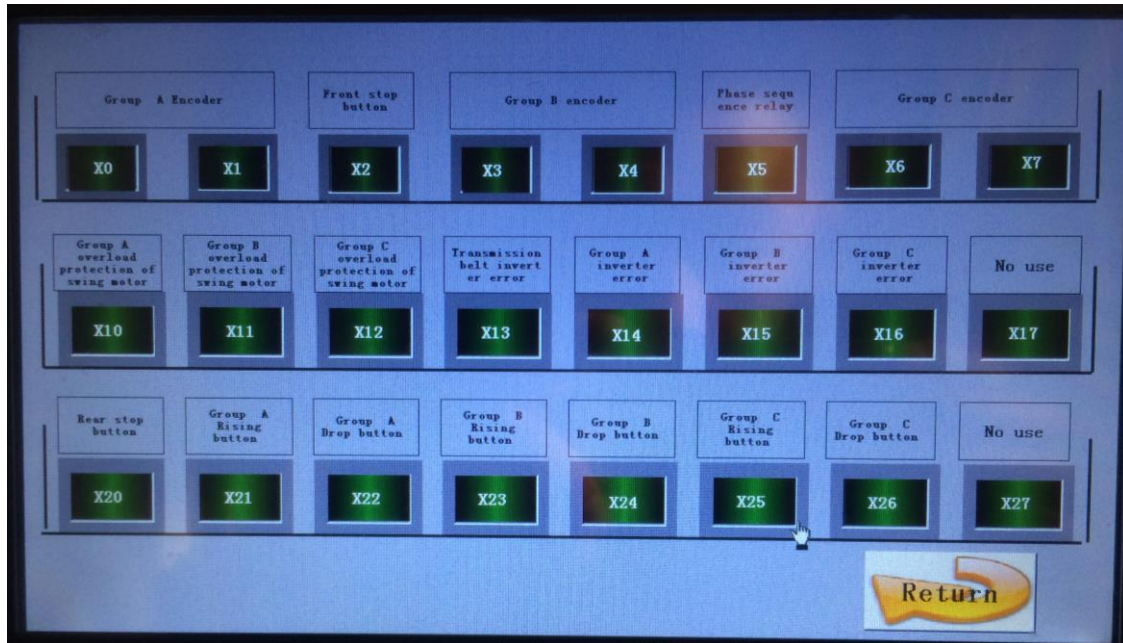
In this interface, the electrical devices corresponding to each input point of the PLC controller on the device are marked. If the electrical appliances in the running state are different from the electrical appliances in the non-running state, it can be reference for later maintenance. You can refer to the monitoring status of this interface to determine whether the appliance is working properly and troubleshoot.

NO.7 Output Electrical Monitoring
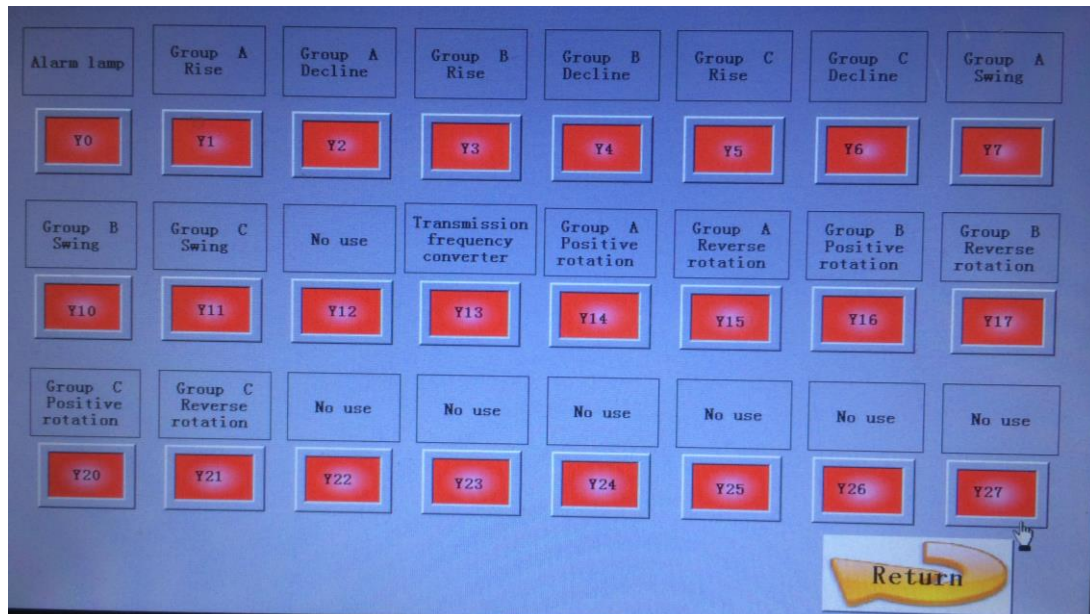
This interface is to mark the electrical devices corresponding to each output point of the PLC controller on the device. If the electrical appliances in the running state and the electrical appliances in the non-running state have a color difference, it can be reference for later maintenance. You can refer to the monitoring status of this interface to determine whether the appliance is working properly and troubleshoot.

The system is password protected for some interfaces or keys that are not allowed to be changed at random. Please save the password properly for professional operators, and do not tell non-professional operators. The password is 666888.