

How to use the machine

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Assembly:

Unit legs:

The machine is divided into three parts. The storage unit, the measuring unit and the cut unit. Before putting all parts together, the table legs of the measuring and storage unit need to be unfolded and screwed in place by the angle parts, which are preassembled on the units.



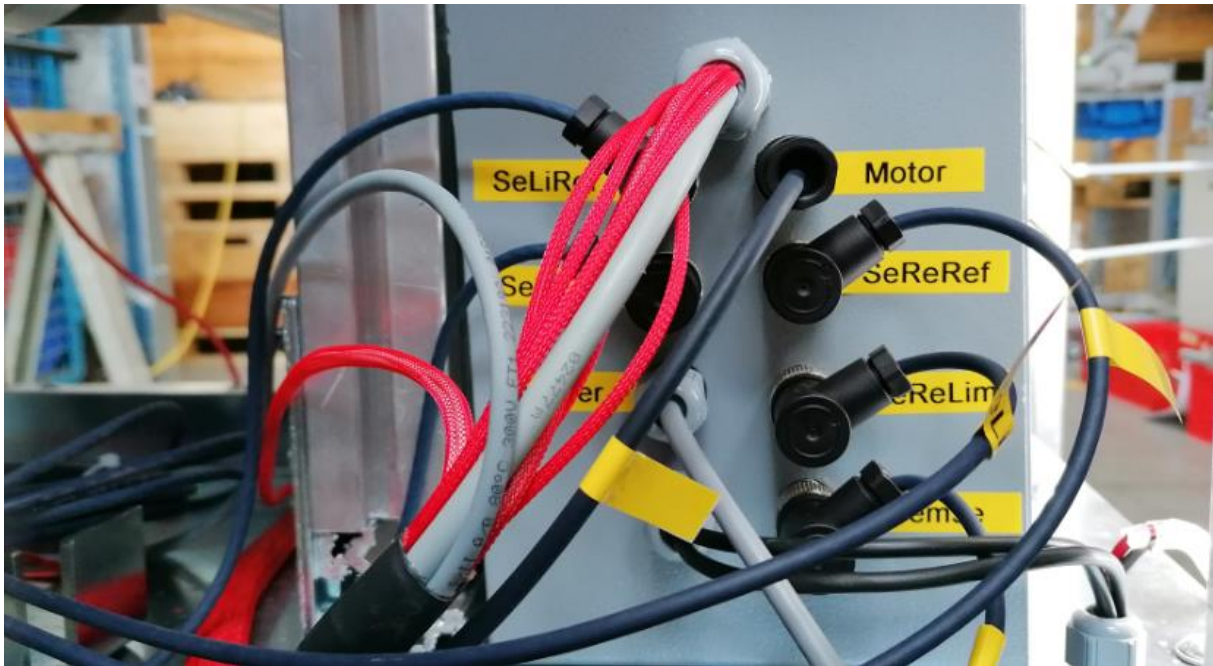
General assembly:

Having the cut unit in the middle, the storage is mounted on the left hand side and the measuring unit is mounted on the right hand side. To hold all parts in their places, the units are screwed together by the preassembled knot sheets.



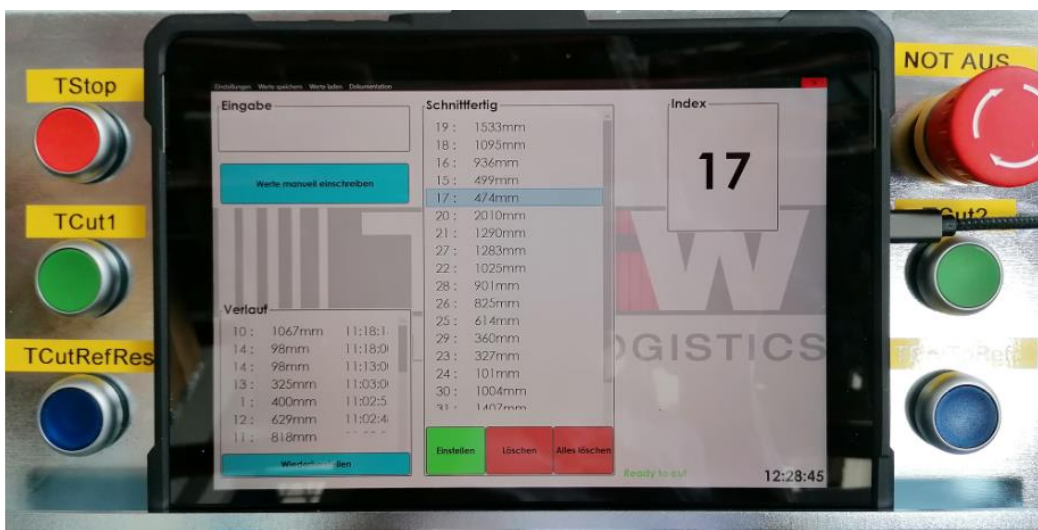
Cables:

After that, the cables, hanging from the measuring unit, need to be screwed in the M12 socket, coming out of the control cabinet. Each cable and socket is named and need to be put in the right place (e.g. SeLimLi to SeLimLi). If not, errors might occur.



Tablet:

Finally, the tablet needs to be put in the intended place and the USB type C cable needs to be plugged in. The microcontroller, which is controlling the whole machine, depends on the plugged in USB-cable. If not, the microcontroller has no voltage to operate and therefore the machine is not working. After all these parts are correctly assembled the app on the tablet (ReadIn-Program) can be started and then it should be ready to work with.



While working:

Getting started:

Firstly, turn on both switches (yellow / red and black / grey) on the back of the machine. Secondly, both motors need to know their reference point. For the knife, the left blue button needs to be pressed. For the limiter, the right blue button needs to be pressed. Furthermore, the distance between the limiter and the knife needs to be measured and typed in into the parameter settings in the ReadIn-Program to guarantee the correct length. After that, the machine should be ready to go. If not check error section.

Digital tape measure:

To read in the lengths that need to be cut, a digital tape measure is included in the machine. The lengths are measured like with a normal tape measure. The only difference is that there is a button, which is located next to the display where the length is shown. When this button is pressed, the measured length is transmitted to the ReadIn-Program. If lengths are not transmitted, check if there is a little Bluetooth-symbol displayed on the tape measure. If not the tape measure might be out of range, then the machine needs to be closer to you. If the machine is close, check if the Bluetooth receiver is connected to the tablet. If so, the small status led on the receiver should be on. Also reopen the digital tape measure port in the ReadIn-Program if necessary.



Setting lengths:

To set a length on the limiter, the limiter must know where he is. To do that the blue button (LimiterRef) needs to be pressed. The limiter then drives itself to

the left reference sensor. If not, voltage might not be applied to the machine or the USB type C cable is missing. After that, a length can be chosen from the list on the ReadIn-Program. This is achieved by clicking on the length which is to cut and pressing the green set button on the tablet. After pressing the button, the limiter will move itself to the chosen position.

Cutting:

To cut the pieces, the two green buttons need to be pressed simultaneously. After pressing the buttons, the motor will turn 360° and the cut is done. This can be stopped by pressing the red stop button or letting go of one of the two green buttons. If the motor is not turning, check the error messages on the ReadIn-Program.

Errors

The whole machine is not working:

- Possible fixes:
 - Check if the machine is turned on (the yellow / red and grey / black switch need to be turned on)
 - Releasing the emergency stop switch
 - Plugging in the USB type C cable to the tablet

Knife not moving:

- Possible fixes:
 - Carefully open the switch cabinet and check if the voltage ok led on the dc-dc converter is on. If not the input, voltage is too high. Disconnect the battery charger if connected.

Knife turning in unusual ways:

- Possible fixes:
 - Do not press the start buttons too fast between the cuts. Wait until the animation is finished before pressing the buttons again.

Knife does not turn anymore after hold:

- Possible fixes:
 - When the stop button is pressed or the start buttons are released while turning, it might happen that the knife is not turning anymore. In this case, press the blue reference button of the knife and try again. If the knife does not move after that, turn the machine off and on again and reference the knife again.