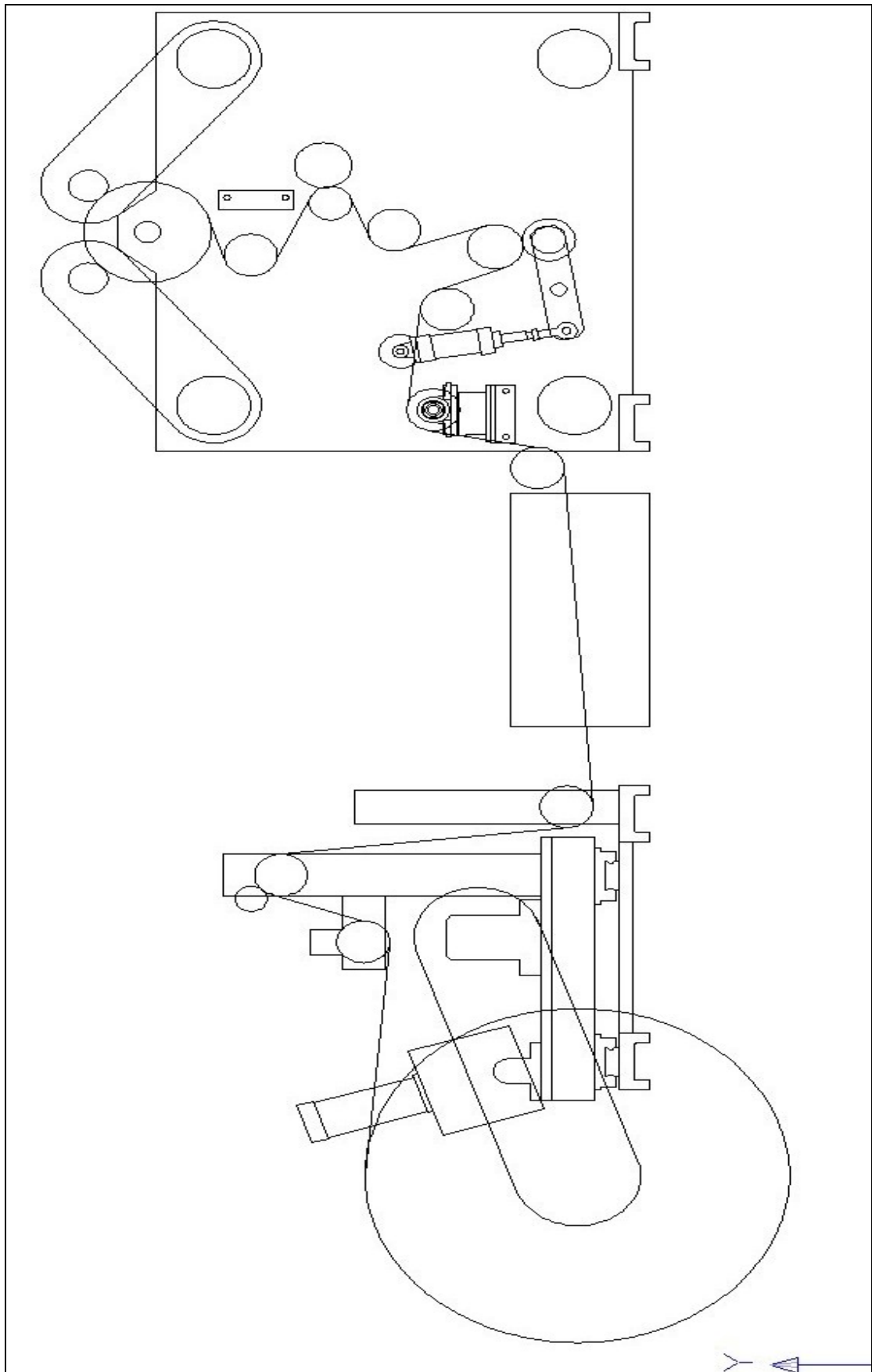


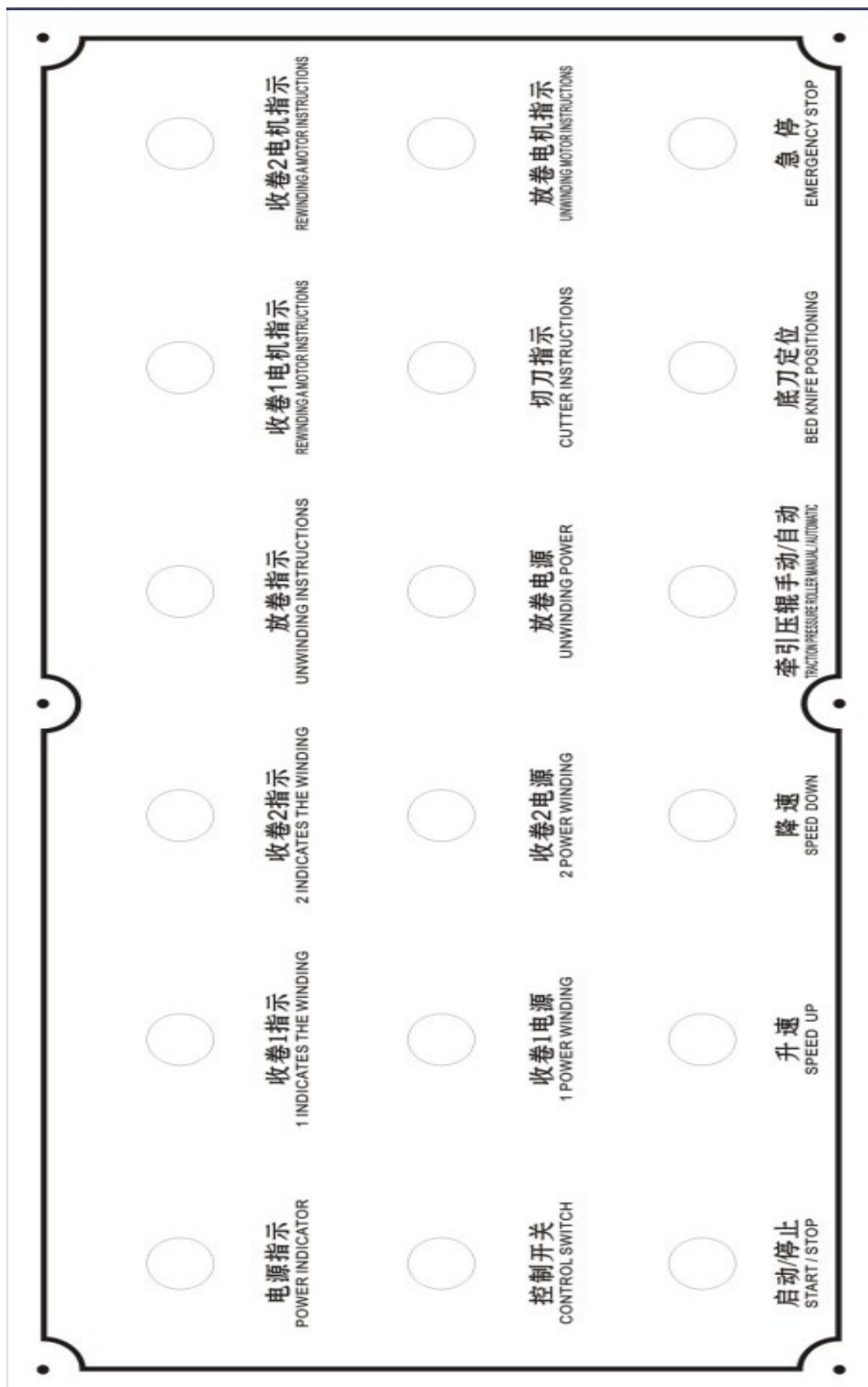
FHQY Series Slitter

Operation Manual

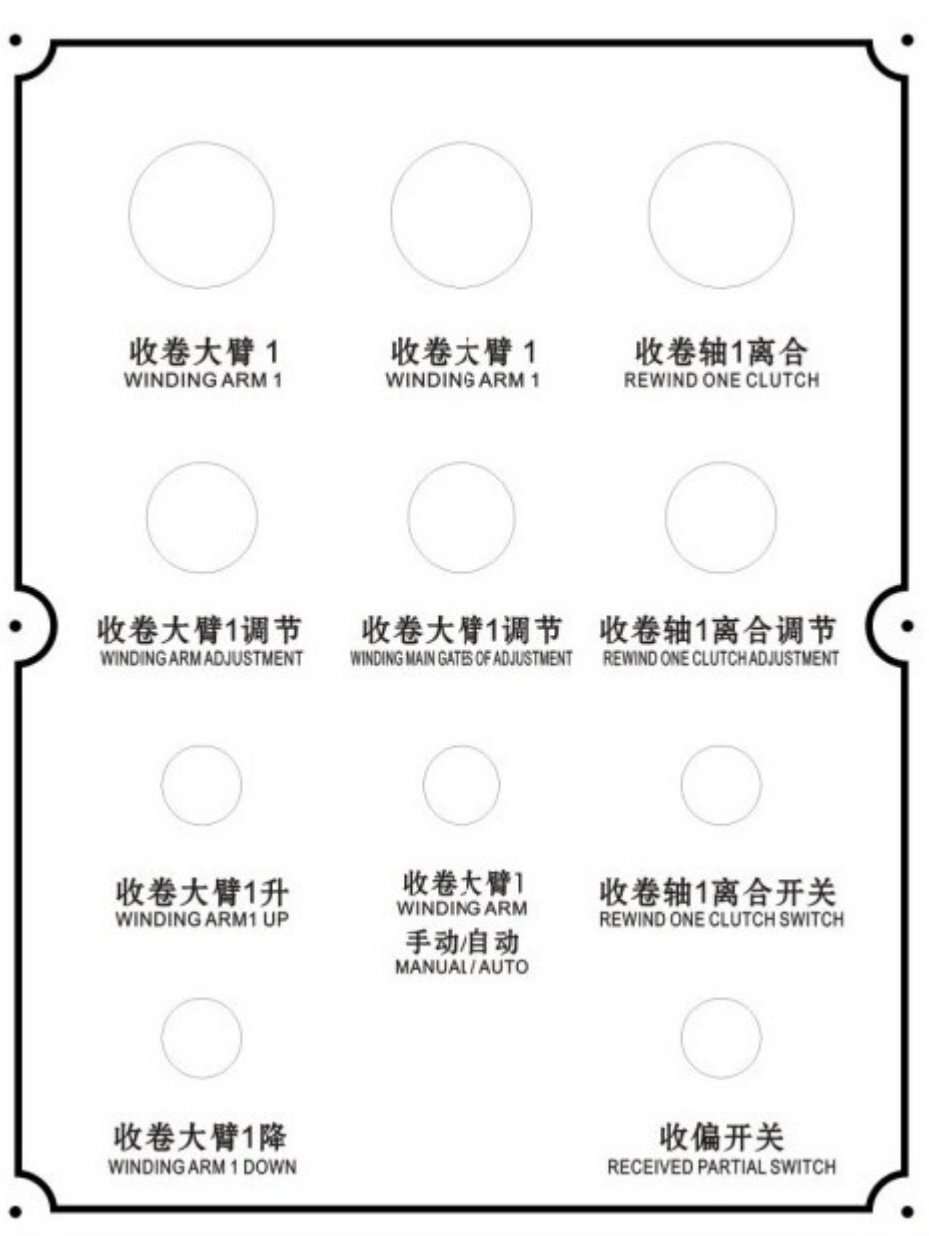
— **Material Running Diagram**



二 Operation Board



- 1 POWER INDICATOR(电源指示): light on/off
- 2 1 INDICATES THE WINDING(收卷 1 指示): no use
- 3 2 INDICATES THE WINDING(收卷 2 指示): no use
- 4 UNWINDING INSTRUCTIONS(放卷指示): no use
- 5 1 REWINDING MOTOR INSTRUCTIONS(收卷 1 电机指示): light on/off
- 6 2 REWINDING MOTOR INSTRUCTIONS(收卷 2 电机指示): light on/off
- 7 CONTROL SWITCH(控制开关): power switch
- 8 1 POWER WINDING(收卷 1 电源): rewinding 1 motor switch
- 9 2 POWER WINDING(收卷 2 电源): rewinding 2 motor switch
- 10 UNWINDING POWER(放卷电源): unwinding motor switch
- 11 CUTTER INSTRUCTIONS(切刀指示): no use
- 12 UNWINDING MOTOR INSTRUCTIONS(放卷电机指示): light on/off
- 13 START/ STOP(启动/停止): start/ stop main motor
- 14 SPEED UP(升速): press this button, the machine will raise the speed to its set up speed; if needs stop during the raising, only need to press the speed down button, it will stop raising speed.
- 15 SPEED DOWN(降速): press this button, the machine will decrease the speed to its set up speed; if needs stop during the decreasing, only need to press the speed up button, it will stop decreasing speed.
- 16 TRACTION PRESSURE ROLLER MANUAL/AUTOMATIC(牵引压辊手动/自动): Manual/ Automatic can be in conversion
- 17 BED KNIFE POSITION(底刀定位): no use.
- 18 EMERGENCY STOP(急停): press this button when emergency happens.



- 1 WINDING ARM 1[收卷大臂 1（左）]: the barometer of rewinding arm cylinder.
- 2 WINDING ARM 1[收卷大臂 1（中）]: the barometer of overcome own weight of the arm.
- 3 REWIND ONE CLUTCH(收卷轴 1 离合): the barometer of the rewinding clutch cylinder
- 4 WINDING ARM ADJUSTMENT (LEFT) [收卷大臂 1 调节（左）]:

adjust the pressure.

5 WINDING MAIN GATES OF ADJUSTMENT (MIDDLE) [收卷大臂 1 调节(中)]: adjust the overcome pressure of the rewinding arm's own weight.

6 REWIND ONE CLUTCH ADJUSTMENT(收卷轴 1 离合调节): adjust the pressure of the rewinding clutch cylinder.

7 WINDING ARM 1 UP (收卷大臂 1 升): the raise of the rewinding arm.

8 WINDING ARM 1 DOWN(收卷大臂 1 降): to down the rewinding arm.

9 WINDING ARM 1 MANUAL/ AUTO(收卷大臂 1 手动/自动): rewinding arm 1 manual / auto switch.

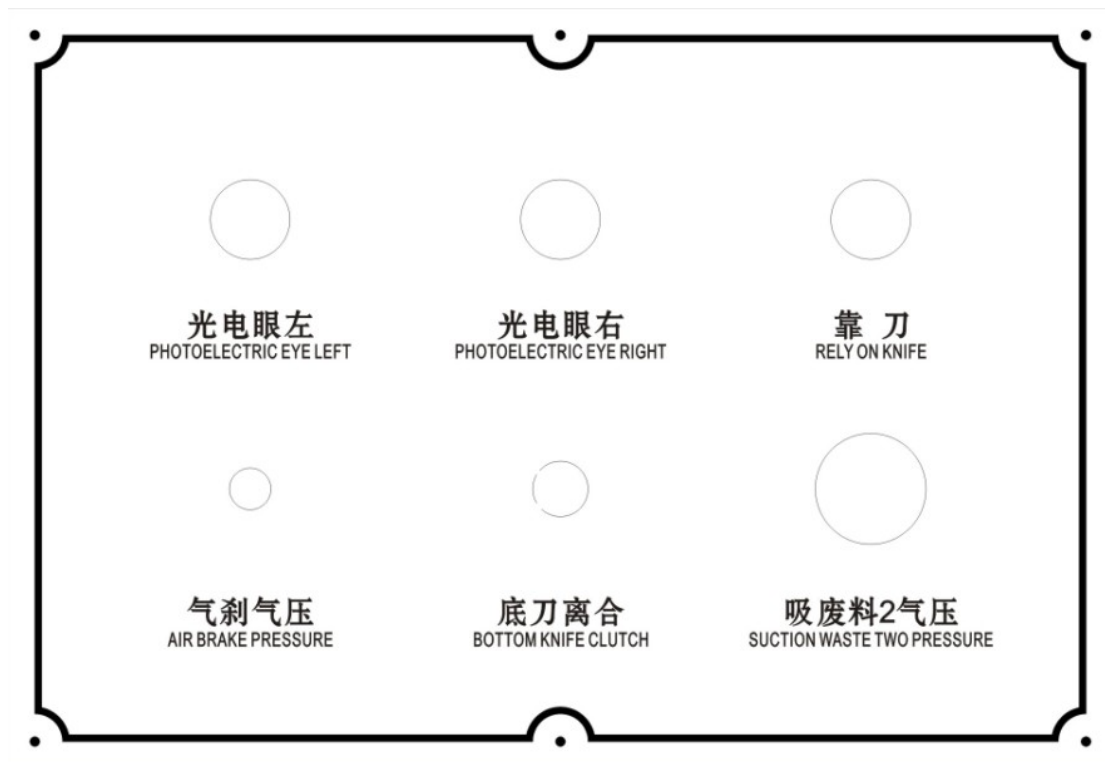
10 REWIND ONE CLUTCH SWITCH(收卷轴 1 离合开关): the rewinding 1 clutch switch.

11RECEIVED PARTIAL SWITCH (纠偏开关): web guide switch.

The method overcome the rewinding arm's own weight: switch into manual station, press rewinding arm 1 button, down the rewinding arm, adjust the rewinding arm 1 regulating valve(left), decrease the barometric pressure to 0, let the rewinding arm connect with the drum completely, and the switch to automatic station, adjust rewinding arm 1 regulating valve(middle), overcome own weight of the rewinding arm, till the rewinding arm can be moved easily.

The operation method of rewinding arm: after overcome its own weight,

adjust the rewinding arm 1 regulating valve (left) to its needed pressure, switch to manual, the rewinding arm will automatic lifting up, put the paper tube on the air shaft, make the material ready, and pressure start / off button, start the main motor, open the rewinding power, the rewinding will automatic tight the material, adjust the tension of the rewinding, press winding arm 1 down button, the rewinding arm will down, switch to automatic, the machine will work automatically. Note: after slitting, the rewinding arm will change into manual station, the arm will raise up automatically.



1 PHOTOELECTRIC EYE LEFT(光电眼左): the photoelectric eye move left.

2 PHOTOELECTRIC EYE RIGHT(光电眼右): the photoelectric eye

move right.

3 RELY ON KNIFE(靠刀): the up knife press tight on the bottom knife.

4 AIR BARAKE PRESSURE (气刹气压): adjust the brake pressure (when the rewinding is not very circle, it can less the beat of the rewinding arm.)

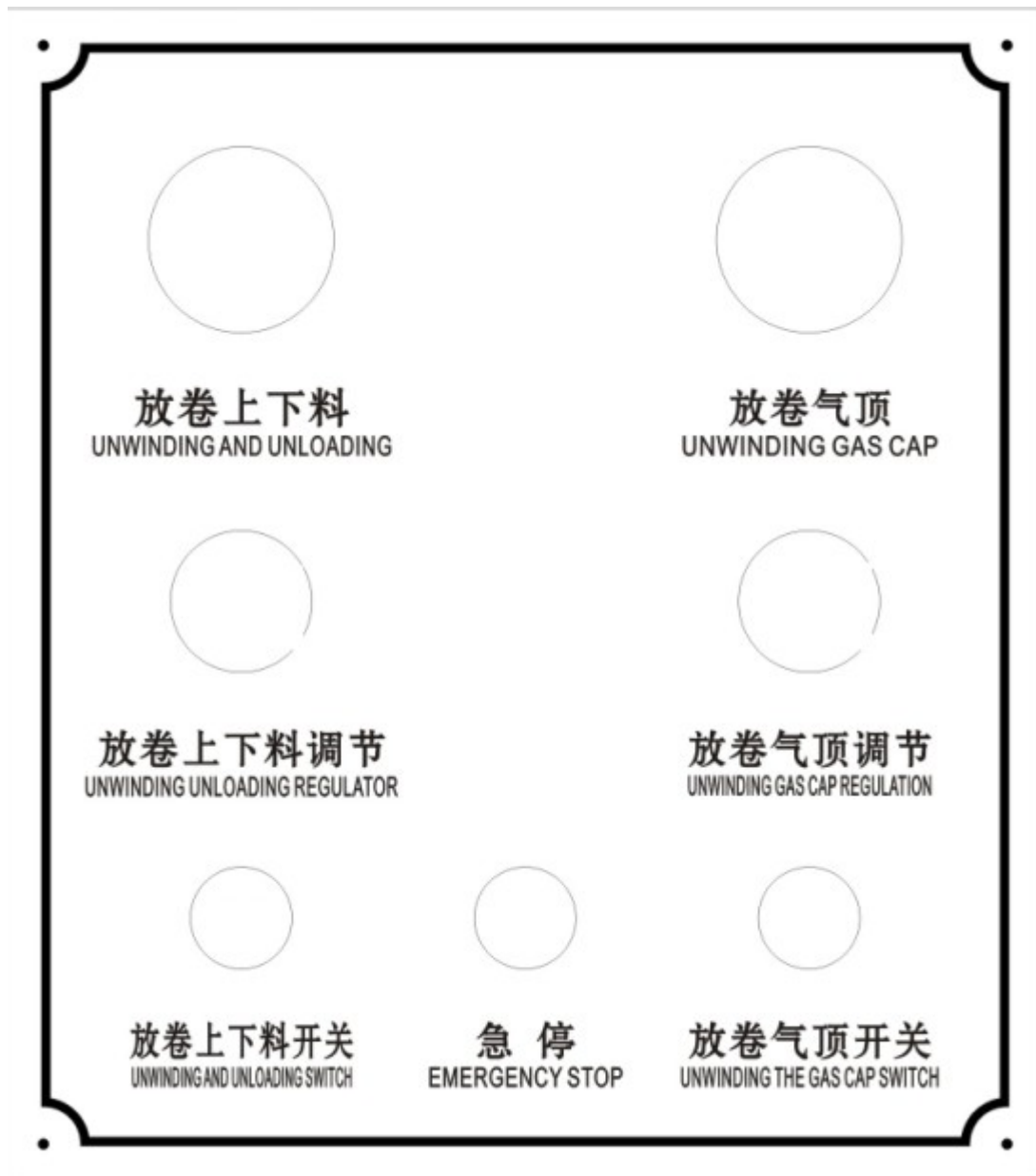
5 BOTTOM KNIFE CLUTCH (底刀离合): the clutch of the bottom knife roller.

6 SUCTION WASTE TWO PRESSURE (吸废料 2 气压): adjust suction waste pressure.



1 SUCTION WASTE TWO PRESSURE(吸废料 2 气压): adjust the barometer pressure.

2 REWINDING PRESSURE ROLLER (收卷压辊): rewinding roller press material switch.



1 UNWINDING AND UNLOADING(放卷上下料): the barometer of the up & down of the rewinding roller.

2 UNWINDING UNLOADING REGULATOR (放卷上下料调节): adjust pressure of the up & down of the rewinding roller.

3 UNWINDING AND UNLOADING SWITCH(放卷上下料开关): unwinding roller up & down switch.

4 UNWINDING GAS CAP (放卷气顶): unwinding clutch pressure

barometer.

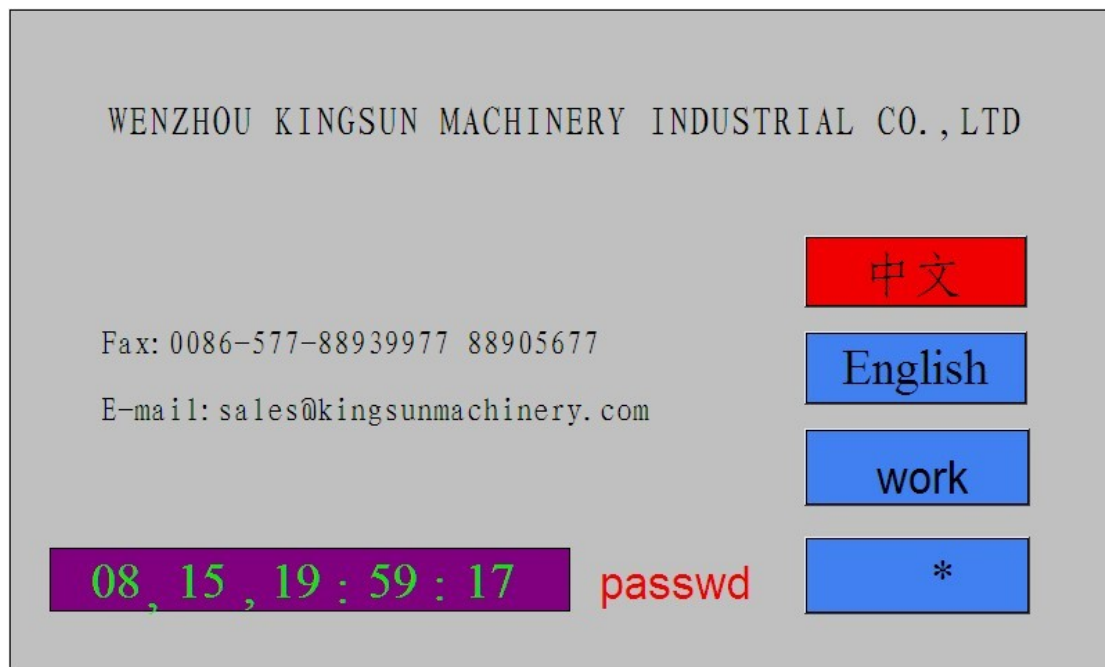
5 UNWINDING GAS CAP REGULATION (放卷气顶调节): adjust the pressure of the rewinding clutch.

6 UNWINDING THE GAS CAP SWITCH (放卷气顶开关): unwinding clutch switch.

7 EMERGENCY STOP (急停): emergency stop button.

三 Man- Machine Interface operating method & explanation

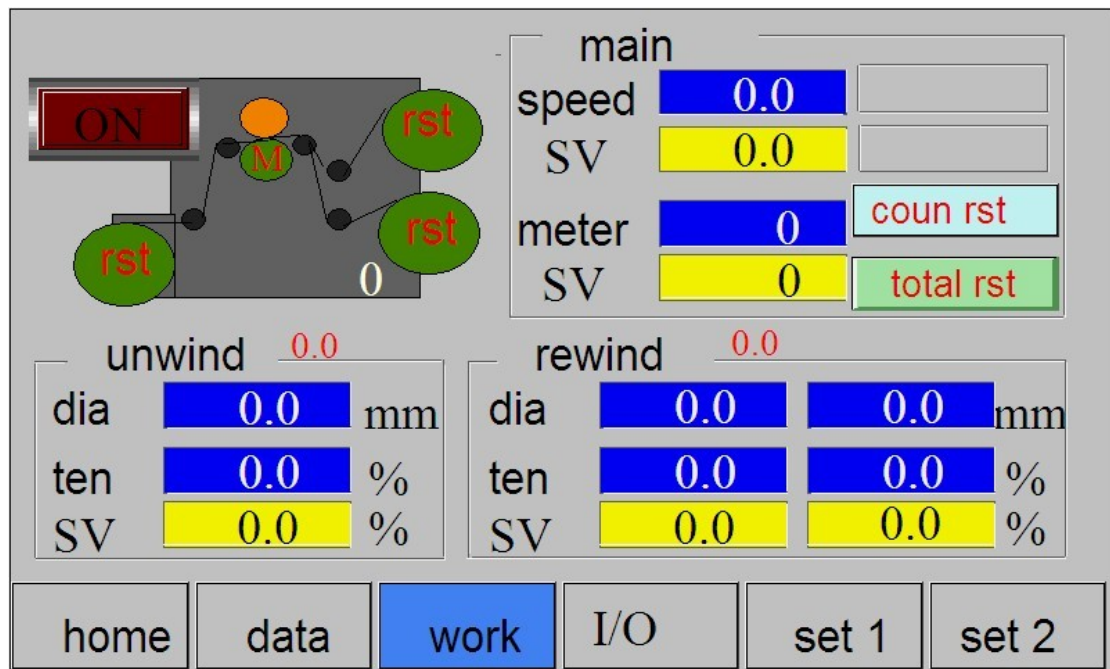
1 Man-machine interface



The definition of the button

<input type="button" value="中 文"/>	Chinese menu
<input type="button" value="English"/>	English menu
<input type="button" value="工 作"/>	Working interface
<input type="button" value="密 码"/>	Input password and go into set1 and set2 interface.

2 Press , into working interface.



The function of the button

open or close the alarm of the rewinding diameter (no use).

Unwinding part

reset the unwinding diameter and tension, only works when machine is ready or stop condition.

Rewinding part

reset rewinding diameter and tension, only works when the machine is ready or stop condition.

Main motor part

shows the present production speed

set the production speed

shows the assembling production meters

set the production meters, the machine will

automatically stop when reaches the amount.

REST METER (米数复位) delete the counting presently.

RESET ASSEMBLE METER (累计复位) delete the counting
of the system.

UNWINDING PART **DIA (直径)** the present diameter of the
unwinding.

TEN (张力) the tension of the present rewinding.

S V set the unwinding previous tension (max 100%)

REWINDING PART **DIA (直径)** the present rewinding dia.

TEN (张力) the present output tension of the rewinding

S V set the previous rewinding tension (max. 100%)

HOME (简介) back to start interface.

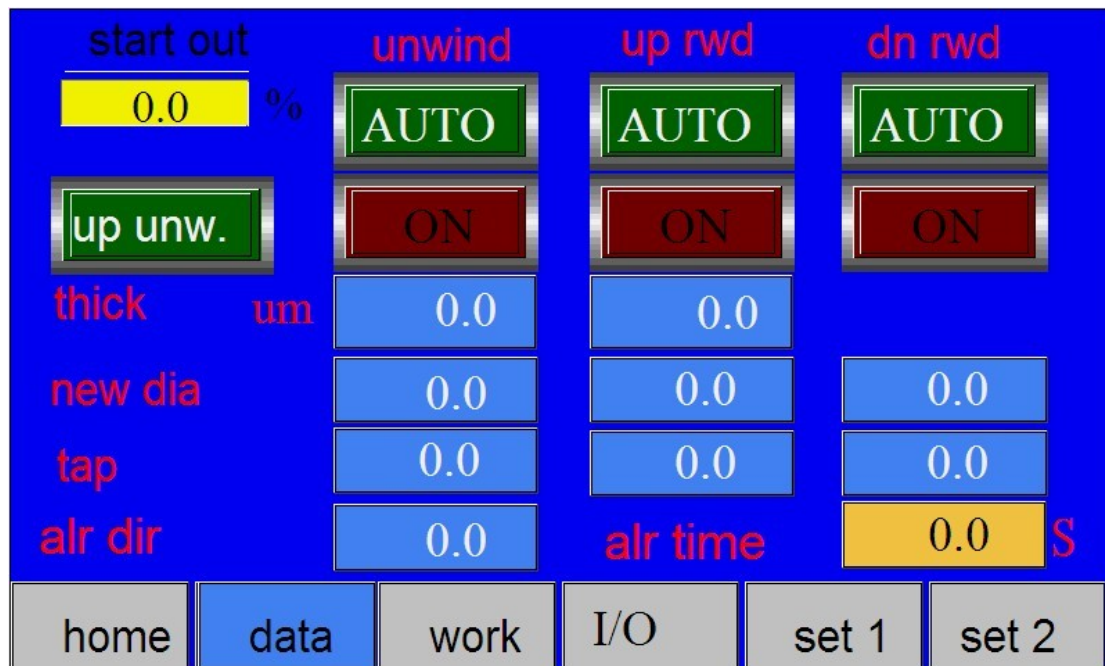
DATA (参数) into data interface.

I / O into PLC I/O

SET 1 (设置 1) enter into set 1 interface (need password on
the start interface)

SET 2 (设置 2) enter into set 2 interface (need password on
the start interface)

3 Press DATA (参数) enter into data interface.



The function of the button

THICK (厚度) set the material thickness, unit um (0.1 丝), more exact of the thickness input, more accurate of the rewinding diameter get.

AUTO tension method 1. 张力方式 1, the system defaulted as AUTO mode.

MAN tension method 2, special tension needed.

O N unwinding and rewinding switch, ON / OFF

UNWINDING PART **NEW DIA (新直径)** set the previous dia.

UNWINDING PART **TAP (锥度)** set unwinding tension decreasing speed (the No. increase, unwind small dia. material, tension will increase.) the system defaulted as 0.

REWINDING PART **NEW DIA (新直径)** the rewinding previous

diameter.

REWINDING PART the rewinding tension increasing speed (it increased, the rewinding big diameter material, the tension will be decreased)

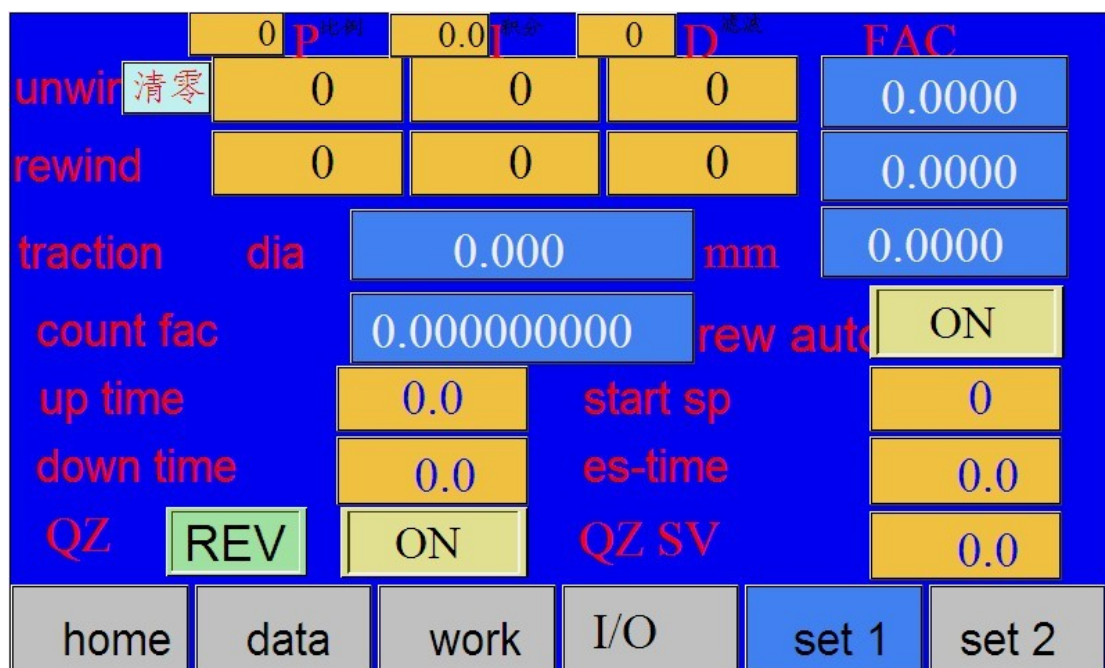
set the unwinding diameter, when it comes to the point, the alarm works. (no use)

set the alarm time, unit seconds (no use)

三 Adjustment (only allowed by professional technician)

1 Back to the first man-machine interface and then input the password: 587.

Press enter into SET 1 interface.



The definition of the button

UNWINDING PART the second counting production capacity (on the condition of automatic unwinding counting diameter)

UNWINDING PART the second counting production time
(on the condition of automatic unwinding counting
diameter)

UNWDING PART slip percentage.

UNWINDIG PART the first counting production capacity
(on the condition of automatic unwinding counting
diameter)

UNWINDING PART the first counting production time (on
the condition of automatic unwinding counting
diameter)

REWINDING PART DEFAULTED

set the traction roller diameter

unwinding, rewinding, traction tune synchronization
the No. increased, the speed of the motor will be
faster. (0.1-5.0)

according to the traction roller
diameter, speed ratio and PC, the No. increased,
the counting will be increased also. (count fac=
traction roller's perimeter / PG / Speed ratio
PG= 600)

the rewinding arm and location
automatic switch (no use)

UP TIME (升速时间) set the time of the increasing speed from

0 to the max. speed. Unit: S

DOWN TIME (降速时间) set the time cost of the decreasing

speed from max. speed to 0. Unit : S

START SP (起步速度) main motor start speed.

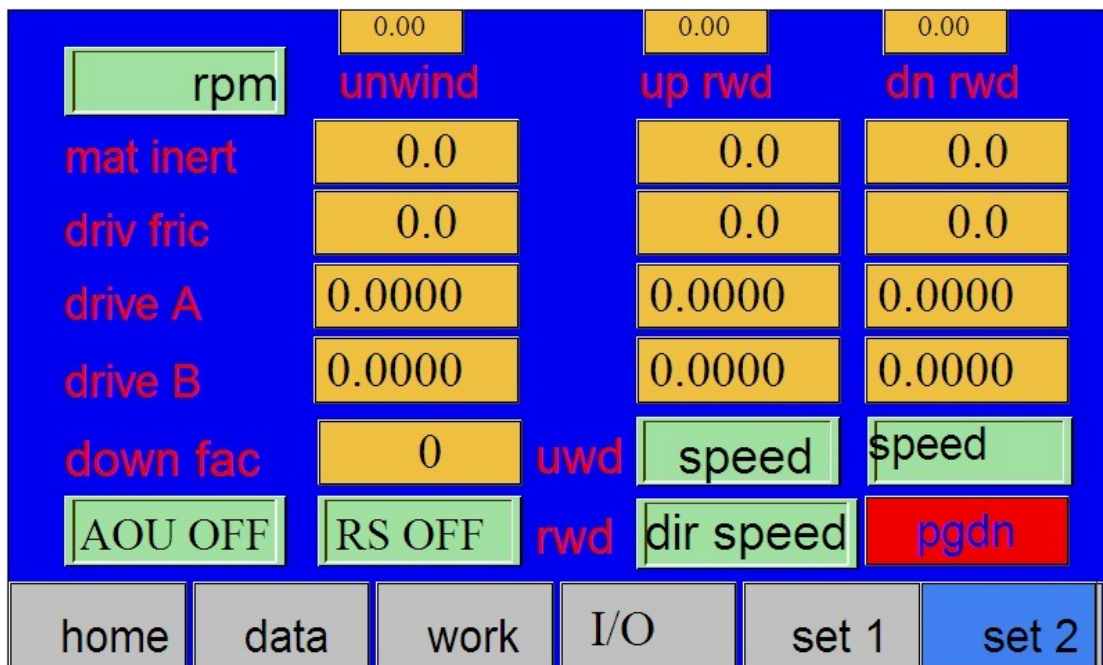
ES- TIME (急停时间) the emergency stop time from max.

speed to 0, unit: S.

Q Z after stop the machine, the extra output tension control switch of the air shaft and slip shaft.

QZ SV set the extra tension control of the air and slip shaft, after stop the machine.

2 Press **Set 2 (设置 2)** enter into SET 2 interface.



The function of the button

RPM (线速度) rewinding air and slip shaft slip method (no use)

MAT INERT (材料惯量) the rewinding and unwinding tap.

UNWINDING PART DRIVE FRIC **传动摩擦** after up to high speed, the tension will change, if decreased, the unwinding high speed tension will be decreased.
(Only for decrease)

REWINDING PART DRIVE FRIC **传动摩擦** after up to high speed, the tension will change, if decreased, the unwinding high speed tension will be increased.(only for increase)

UNWINDING PART DRIVE A **传动惯 A** during speed decreasing, tension will change, the No. Increased, the unwinding tension will increase.

REWINDING PART DRIVE A **传动惯 A** during speed increasing, the tension will change, the No. Increased, the tension of rewinding will increase.

UNWINDING PART DRIVE B **传动惯 B** during speed increasing, tension will change, the No. increased, the tension of unwinding will decrease.

REWINDING PART DRIVE B **传动惯 B** during speed decreasing, tension will change, the No. increased, the tension of unwinding will decrease.

DOWN FAC (降速系数) set the meters, after almost reached the amount, the speed will down until stop, the No. is increased, the down speed is faster.

Uwd (放) set the diameter counting method of unwinding, total three modes.

Meter (米 数) adopts diameter counting mode.

SPEED (速 度) 和 **rotation speed(转 数)** adopt approaching switch decreasing material thickness to count the diameter.

SPEED (速 度) 和 **RPM 线速度** adopt machine rpm speed and unwinding speed to calculate the diameter.

Rwd 收 rewinding diameter calculate mode, the system defaulted as diameter in.

AOU ON rewinding arm didn't locate, the machine can increase the speed switch On/ OFF

RS ON automatic reset the rewinding diameter counting on/off.

3 Press **PGDN (下 页)** 按钮, enter into next page.

stop fac	0.00	0.0	unwind	up rwd	dn rwd
init dia	0.00		0.00	0.00	0.00
dia fac	0.0000		0.0000	0.0000	0.0000
fwd fac	0		0	0	0
rev fac	0		0	0	0
min dir	0.0		0.0	0.0	0.0
max dir	0.0		0.0	0.0	0.0
Tap dir	0.0		0.0	0.0	0.0
home	data	work	I/O	set 1	set 2

The definition of the button

STOP FAC (停增益) the increasing fac of the unwinding tension after stop the machine.

INIT DIA (初始直径) the paper tube diameter of the unwinding air shaft, unit: mm, 3 inch, the input diameter is 96mm.

DIA FAC (直径因子) when the diameter deviation calculated is very big, the No. is increased, the diameter will be increased. System defaulted as 1.000

UNWIND PART FWD FAC 正转因子 when the machine running in positive direction, the No. increased, the friction between unwinding and motor part will be decreased, it will less the unwinding tension.

REWINDING PART FWD 正转因子 when the machine running in positive direction, the No. increased, the friction

between unwinding and motor part will be decreased, it will larger the rewinding tension.

REV FAC (反转因子) system defaulted as 0

MIN DIR (最小直径) system defaulted as 0

MAX DIR (最大直径) set the max working diameter of

unwinding and rewinding.

After all set up, please input the password 0 on the first man-machine interface, then exit the adjust interface.