

TK4S3532 Leather cutting machine installation manual

Computer Configuration Requirement:

Computer send with the machine together:

System: Win10

Memory: 16G

CPU: i9

Graphics card: 1050Ti

Note: There are two screens, one of them is touch screen, all the software have been installed, suggest customer to prepare a usb hub.

Power Requirement

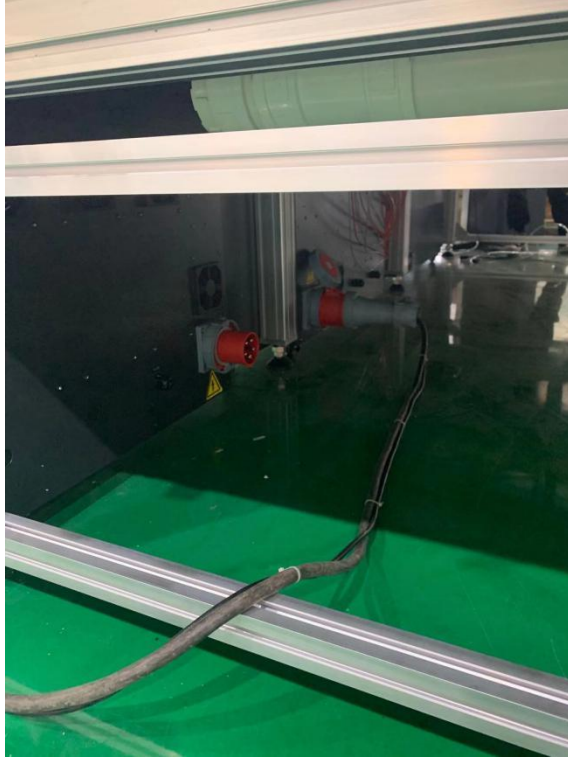
Three -phase Vacuum Pump	Voltage	Electric Current	Wiring System
7.5KW	380V	27.5A	L1、L2、L3、N、G



This machine has 3 pumps

Additional preparation required:

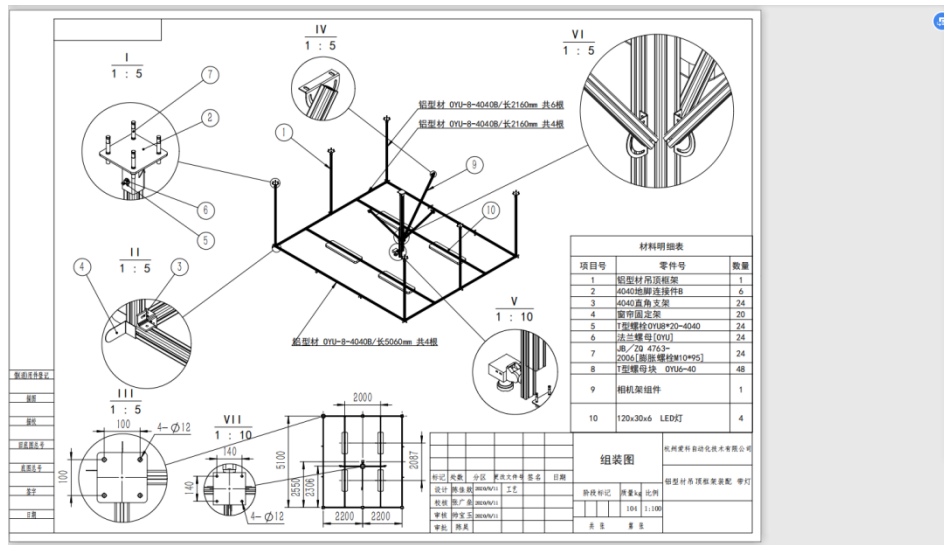
5 wires (L1 L2 L3 N G) cable, for 3 phase power supply from customer factory to machine.



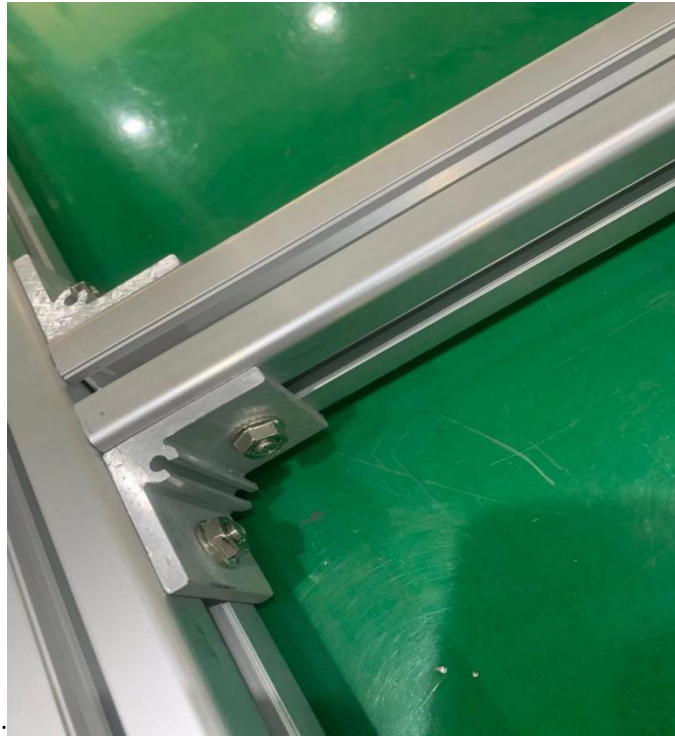
The 2 plugs on the above picture both required three phases 380V input, one is for 2 pumps and the machine, another one is for another pump.

$$QF=3 \text{ pumps} + 1 \text{ electric box} = 27.5*3+10*1=92.5A$$

1: Install the camera frame first

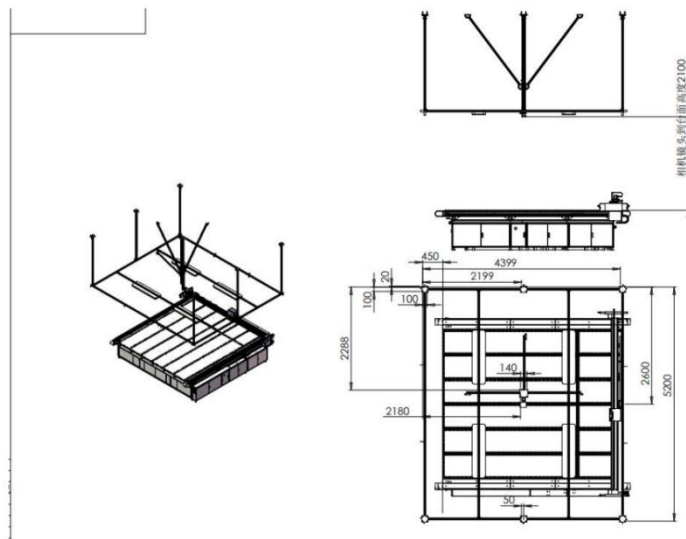


The full photo :



The connections photo:

2:install the camera support frame

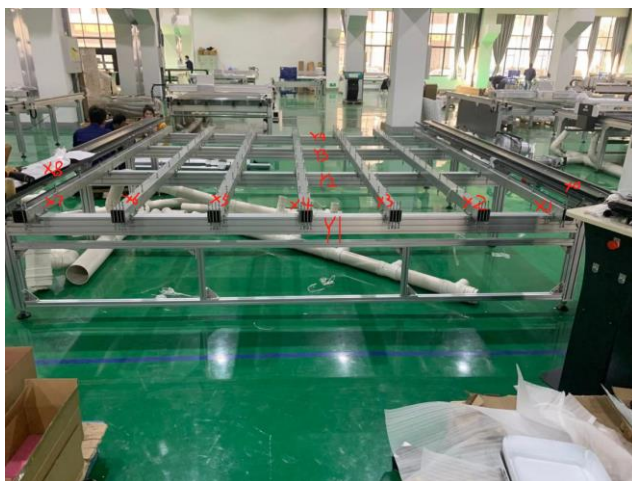
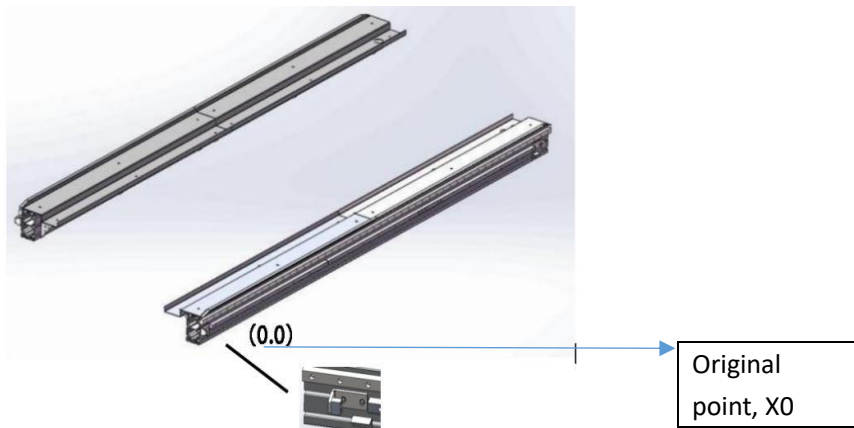


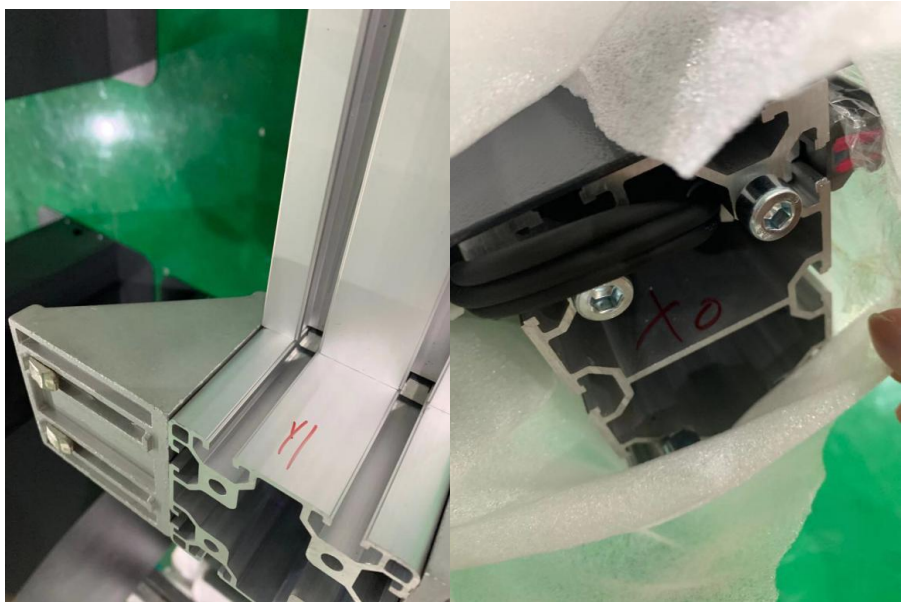
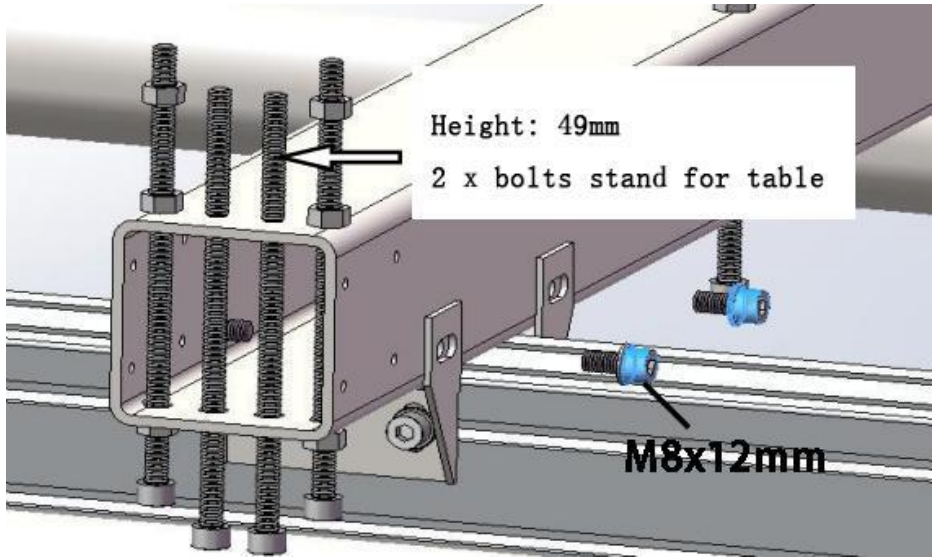


The full video about how to install the camera already sent.

3: install the machine frame

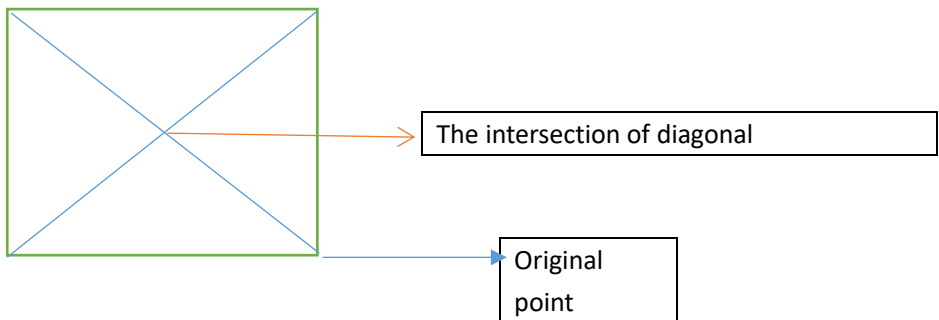
1. All legs install position all marked with red line and numbers. Y numbers all marked on right side of the legs.





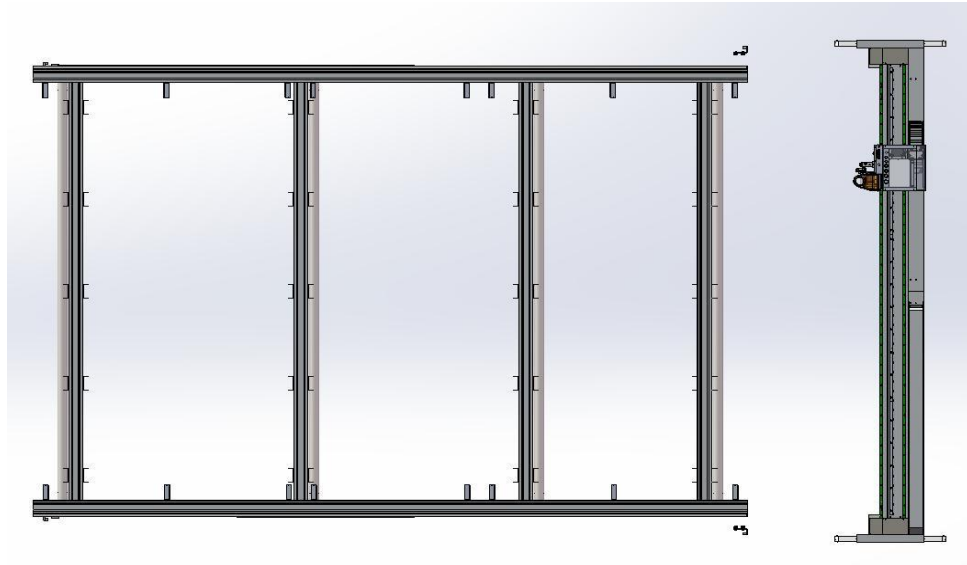
The full video about how to install the frame already sent.

Remind: After finish the frame installation, you need to use ruler to check the frame diagonal. The length difference between the diagonal lines should be less than 0.1-0.2mm.



The intersection of the diagonal lines is aligned with the camera lens position.
 The distance from machine table to camera lens is 2100mm.

After all the legs have been installed and the level, diagonal have been checked, you can install the beam: Keep balance from rear side when assembling the cutting beam, carefully take out the plug in the slider, put the cutting beam onto the side beams, make sure that the pen holder faces to the photoelectric plate. After assembly, put the block slider back and then tighten



the screws.

4: Aluminum platform installation sequence

Totally 6 big aluminum platform and 6 small aluminum platform, the order like following photo:

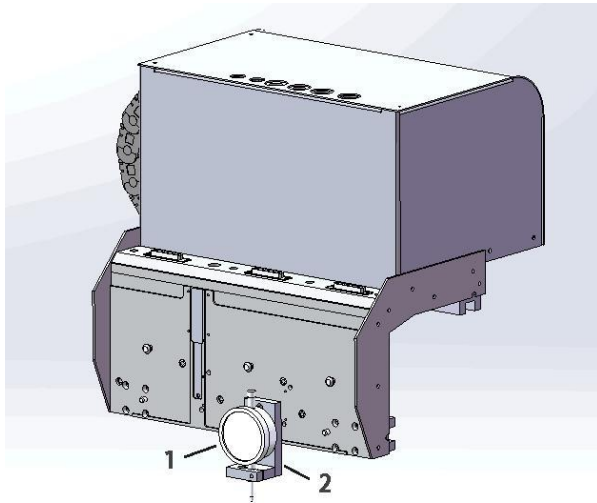
12	11	10	9	8	7
6	5	4	3	2	1

Original
point

There are also some marks on the aluminum platform like the following photo:

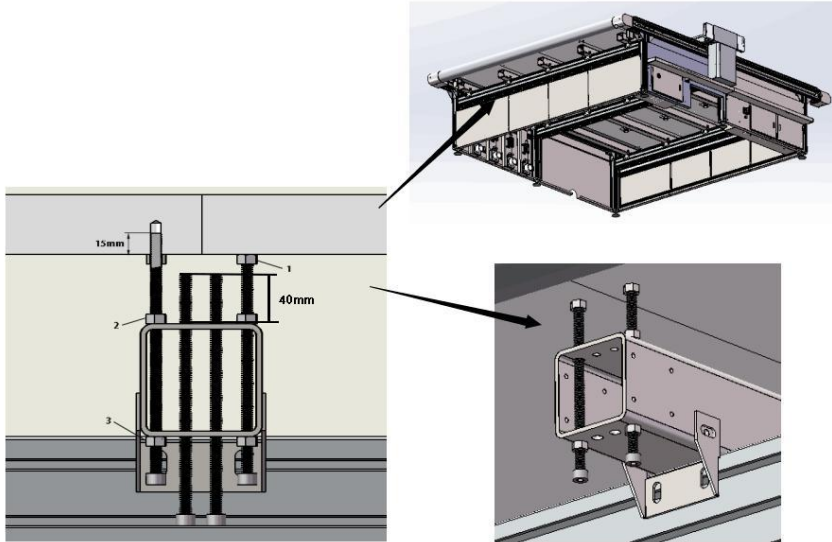


Follow the video to adjust the table level, follow these steps:



Fasten the dial gauge support to the module carriage


- Insert the dial gauge
- Starting from the front right-hand side, set all plates to the same level. Align the vacuum plates



Note:

An assistant must read the dial gauge and provide information about the current height. After adjusting the vacuum plate, remove the mounting bolts for stand table.

- Use the module carriage to move from fastening point to fastening point and measure The deviation.
- Tighten the screw (1) under the table.
- Loosen the screw (2).
- Adjust the screw (2) (3) until the table surface height matches the calculated height (front right) (0.0) position.
- Tighten the screw (2) (3)
- Repeat this adjustment procedure at all positions.
- Check the alignment by taking measurements for all vacuum plates and readjust as necessary.
- Remove the dial gauge and its holder from the head carriage.

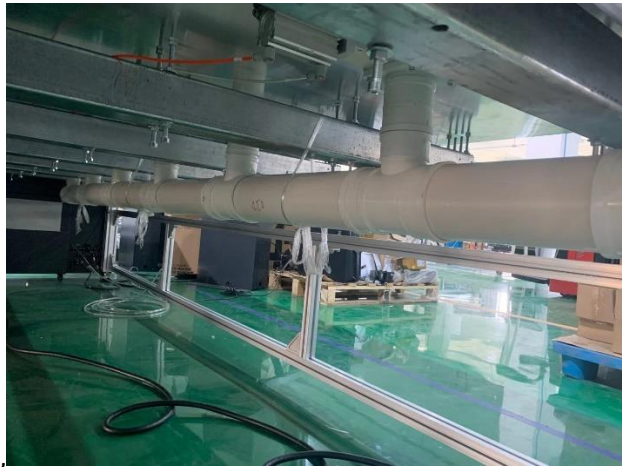
	<p>Dial gauge (resolution of 0.1 mm)</p>	<p>To align the table plate</p>
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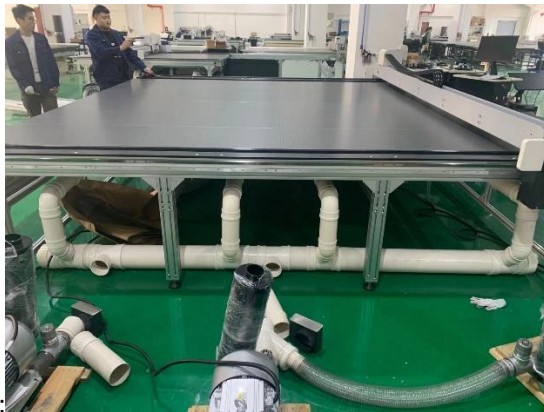
5:install the PVC tube



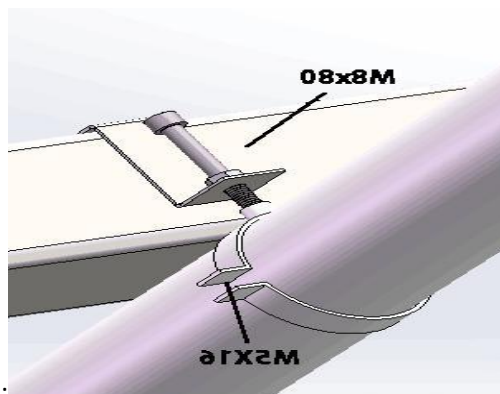
Combine the PVC tube outside the machine, totally 4 unit.



Then install the PVC tube under the table,

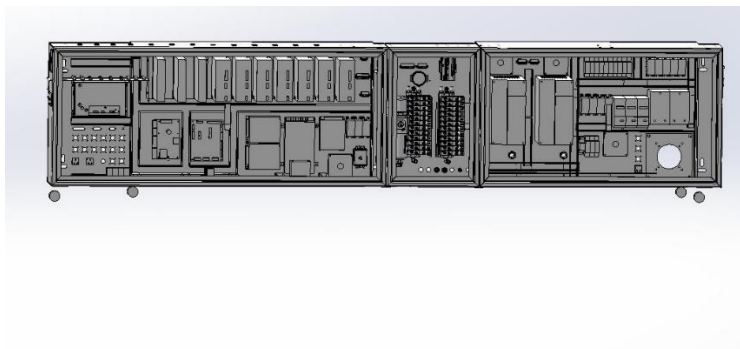
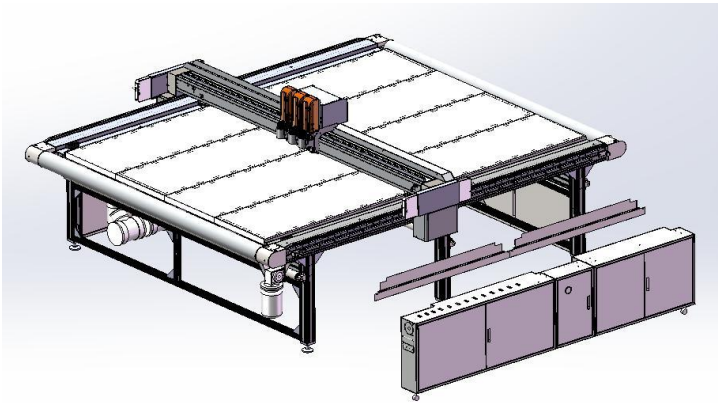


Full photo:



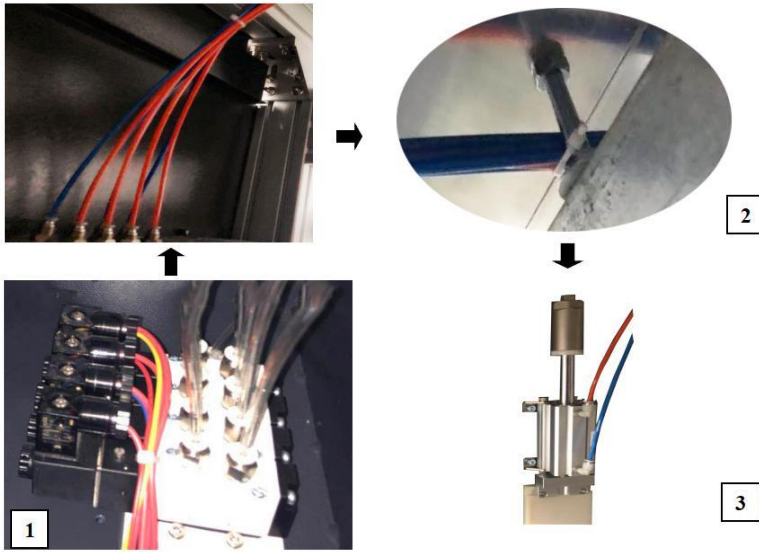
Use this one to fix the PVC tube:

6: install the electric box



Then use the screw to fix the electric box:

After the PVC tube and electric box have been installed, follow the label connect the air tube from air control box to the cylinder under the table.



7: install the felt

This machine is static table, doesn't have conveyor, so first need to install this:



cover to fix the felt.

On both front and behind have this one to install the