

SCH Computer fixed-length controller family (SCH— I Type) Version Ver8.1

User Manual

瑞安市辉煌工控设备厂

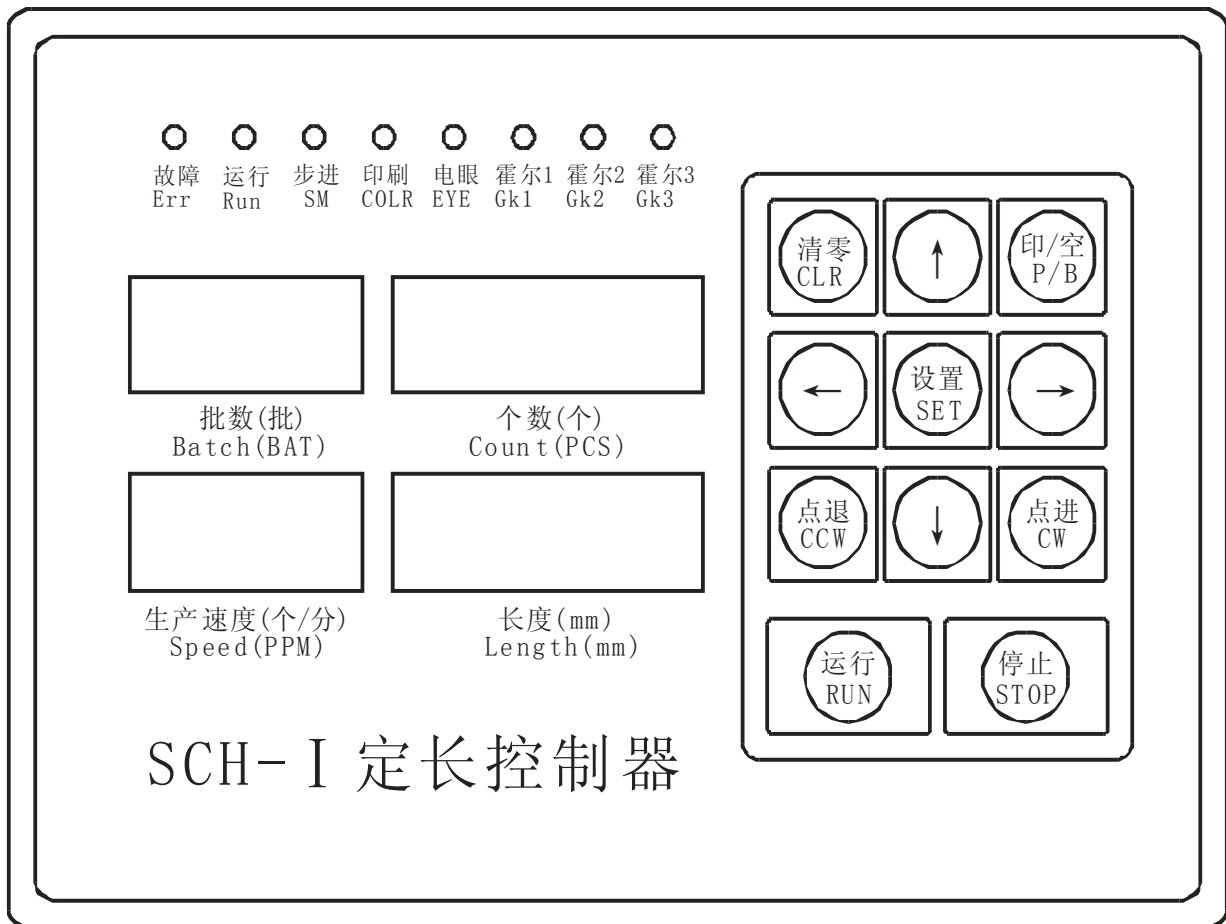
地 址：瑞安市经济开发区

电 话：0577-65602858 传 真：0577-65006599

网 址：WWW.HHGK.CN E-mail: hhgk@hhgk.cn

SCH- I microcomputer system is suitable for fixed-length eagerly machine, Cutting machine, cutter, single-film flexible packaging machines and other machinery. The system is designed in the electrical, optical as a whole, using high-performance single-chip microcomputer as the core, control, high torque, high-precision stepper motor control of fixed-length, high-resolution optical switch track is amended to align with the system's machinery, a high-speed, accurate and stable performance characteristics.

1. Control panel



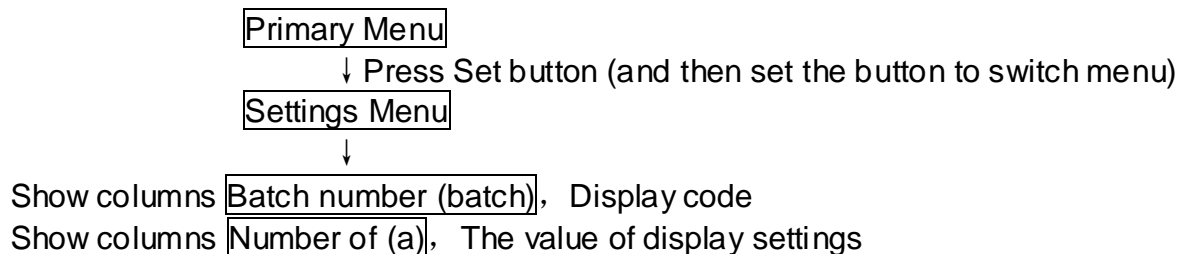
2. Panel Description

lamp	Function Description
故障 (Err)	Failure alarm light
运行 (Run)	Host running lights
步进 (SM)	Step pulse output light
印刷 (COLR)	Work for the printing light
电眼 (EYE)	Electric eye lit when there is signal input (X2 port)
霍尔 1 (Gk1)	Hall signal input when there is low light (X0 port)
霍尔 2 (Gk2)	Feeding with the high Hall lit a signal input (X1 port)
霍尔 3 (Gk3)	Backward Hall are lit when the signal input (X3 port)

Display (primary menu)	Function Description
批数 (批) Batch (BAT)	The current number of batches bag
个数 (个) Count (PCS)	The current number of bag
生产速度 (个/分) Speed (PPM)	The current pace of work
长度 (mm) Length (mm)	Set the length of the bag

KEY	Function Description
设置 (SET)	Enter the settings menu (to switch menu), as in the settings menu within 30 seconds without key operation, Automatically save data and exit to the primary menu
↑	Settings menu, set the value of plus 1. The primary menu for the automatic target-seeking function keys (print bags valid)
↓	Settings menu, set the value of minus 1 The primary menu for the function keys count minus 1
←	Settings menu, set the bit left Primary menu, function keys for a total stop (reset button)
→	Settings menu, set the bit shifted to the right Primary menu, the host jog
清零 (CLR)	Clear the production count, the number of zero, clear the batch number
印/空 (P/B)	Printing method and a blank bag bag mode switch
运行 (RUN)	Machine running
停止 (SOTP)	Stop the machine (cutter automatically stop at a high level)
点进 (CW)	Stepping forward pull material (run-time invalid)
点退 (CCW)	Stepping backward pull material (run-time invalid)

3. Parameter setting method



4. Parameter Description

Function Code	Description	MIN	MAX	INIT	Units
L	Bag length	10	3000	220	mm
S	Stepping speed, 0 fastest and the slowest 99	0	99	18	档
d	The number of the value of a single batch	6	9999	100	个
7	Downtime, 0 non-stop, nine will not automatically boot after shutdown Air cut times (with specific models to determine)	0	9	0	秒次
U1	Optical methods of work, 0 automatic, a black work, the work of two white	0	2	0	
P	Into the lower menu, password, factory value of 0008	0	9999	0	
H	Stepping curve, lifting the speed gradient, one the fastest and slowest 9	1	9	4	
H1	Step lowest frequency (electric eye tracking speed)	0	20	3	%
H2	The maximum step frequency, step you can run the highest speed	0	99	99	%
b	The diameter of the feed rod	30.0	200.0	70.0	mm
U	Electro-optical tracking number of a target-seeking unlimited	1	5	3	次
U3	Electric eye tracking ahead of schedule length of	0	30	3	mm
U4	Electric eye tracking lag length of the	0	50	10	mm
F1	Punch switch, 0 off, 1 open	0	1	0	
F2	Punch Time	0	999	30	ms
F3	Punch delay time	0	999	0	ms
E	Model selection, 0 downtime type (earnest machine), a non-stop model (hot looking), 2 to send back the first type, three-step retirement models	0	3	0	
C	Regression length	0	99	0	mm
A1	Function switch, 0 the first evacuation cutter material, a cutter, after the first feeding	0	1	0	
A2	High speed down the first two hours	0	9	0	秒
A3	Sealing optical delay time, 0 non-sealing test	0	6	0	0.5 秒
P1	The lower menu, password, factory value of 2858	0	9999	0	
--	Bag machine operating restrictions on number of batches	0	9999	0	
P2	Change Password	0	9999	2858	

Note: To enable the approved limit the number of functions, according to the following methods to set,

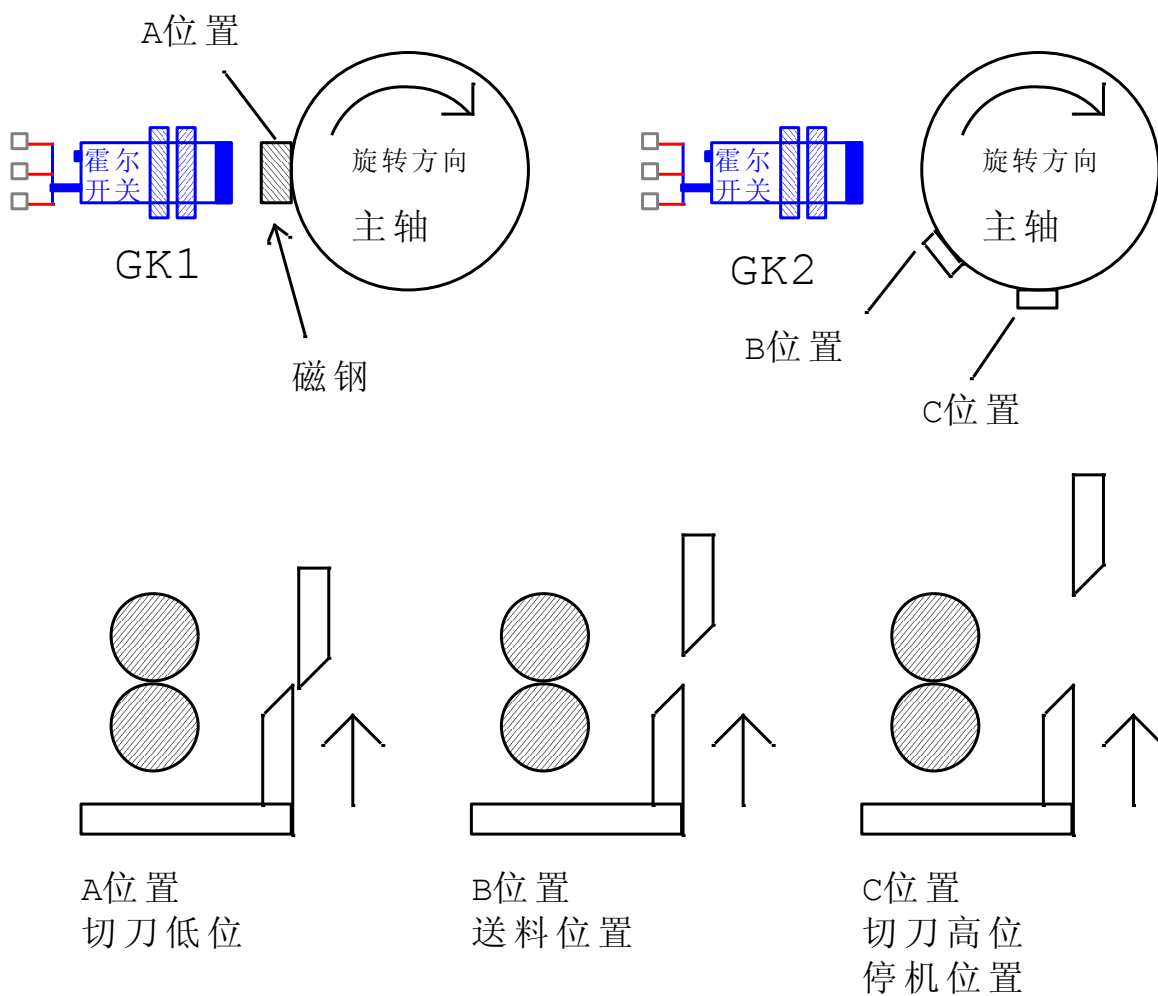
λ Press Set key to the P1 level menu, enter the factory password 2858

λ Press Set key to enter the - - the menu layer, set up to limit the number of grant

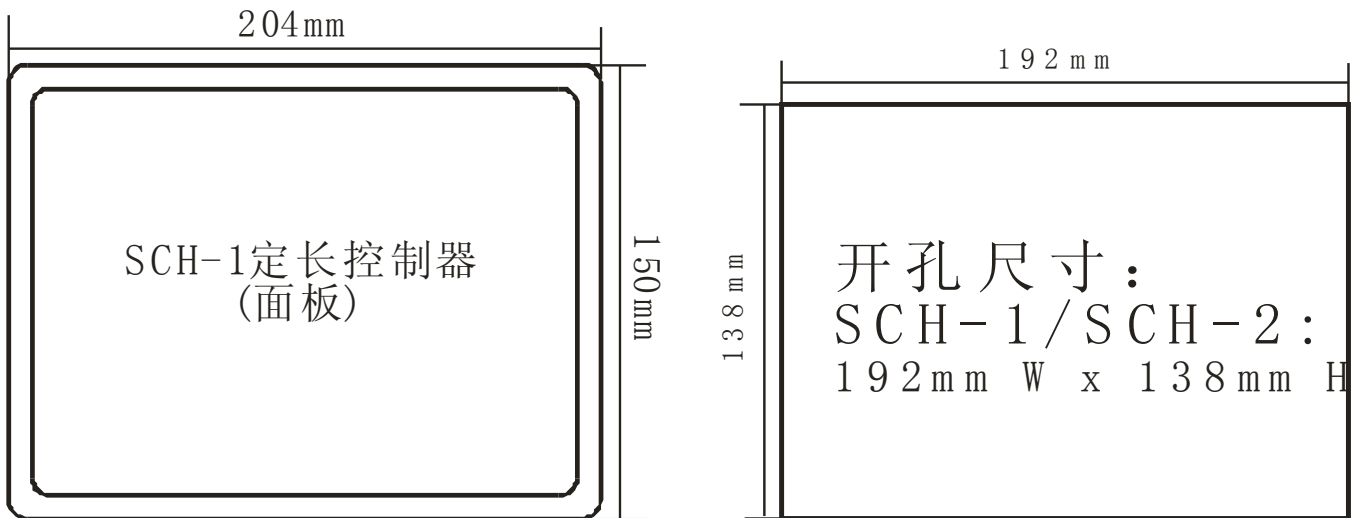
λ Press to set the menu button to the P2 level, change the factory password, remember password for your own good

λ To Jilao modified password, if the password is forgotten, only to return for board factory, and remember

5. Input sensor logic diagram



6. Hole Size



7. The drive is set

Single-step controller, the drive step-step distance is 2000

Double-step controller, the drive step-step distance is 1000

Note: In the run-time, according to an external point of entry or point back button, for the count by a function.

If you choose to step back machine model, the blocking material be replaced with electric eye backwards Hall.

