

Fs-4x Touch screen control system

Single Channel Bag-making Control System

Auto

V6. 0. 5

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An overview of the

Fs-2x touch screen system is a CNC product specially developed by our company for high speed and high efficiency bag-making control. It is composed of high speed special motion control simulation, high efficiency touch screen and stepper motor. Easy to operate, widely used in various types of bag making machines, printing machines, paper cup machines, cutting machines, rewinding machines, food packaging machines and other machines.

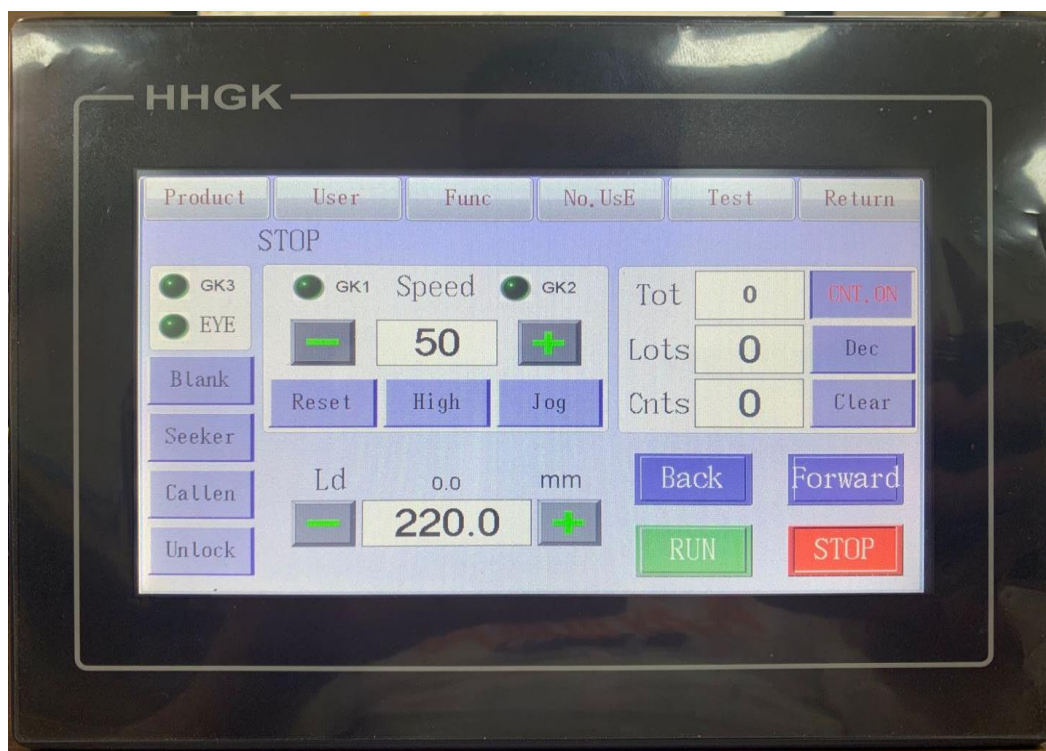
➤ Controller panel

Boot screen



- 按中文按钮进入中文菜单， Press the English button to enter the English menu

➤ HOME



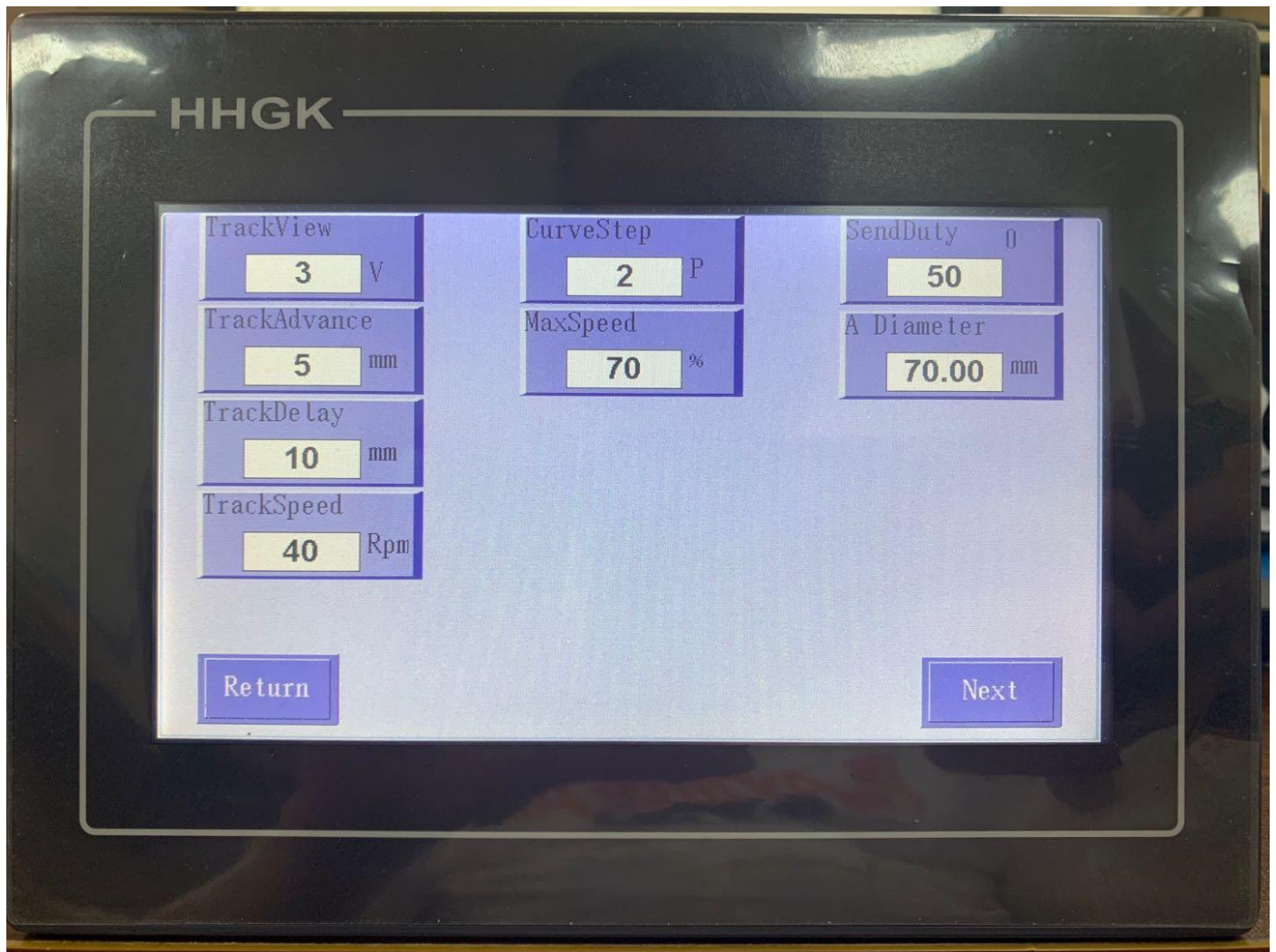
SHOW	Explain
User	The basic parameters that users need to use in actual production operations.
Func	Various functional parameters
No.Use	
Test	Control system above the input and output signal monitoring, including drilling, blowing, ultrasonic testing.
Return	Back to boot interface.
LD	Set the length of the bag
--	Fine-tune length reduction
+	Fine-tune to increase length
State	The current state of the machine, stop, run, tap, Point retreat, overspeed, loss of mark, cut off material, block material
GK1	Low indicator state
GK2	Feeding and high indicator state
GK3	The status of plugging detection and regression signal indicator light
EYE	Follow the photoelectric instructions
Speed	The speed of the machine is Unit per minute.
Reset	The system stopped and reset to the power on state.Any time is valid, please use caution.
High	Automatically pull the knife to a high stop. (Valid when stopped)
Jog	The button that the host inactivates. (Valid when stopped)
Lots	Displays the number of batches currently in production 。
Cnts	Displays the current production quantity.
Dec	Subtract 1 from the current count
Clear	Reset the current count, when the count is 0, continue to press "reset", the batch number will also be reset.
BLANK/Color	White space is fixed length mode, and tracking is color-coded tracking mode.
Seeker	Automatic search for printed punctuation.
Callen	With the search button, the distance between the color code and the lower P color code is automatically measured, and the length is automatically updated.
Unlock	
Back	The push button of the feed motor
Forward	Feed motor feed button.
Run	Machine run button. Press the button and the machine begins to work.
Stop	Machine stop button. Press the button and the machine stops working.

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SHOW	Explain	Min	Max	Default	Unit
Batch.Number	Set the number of single batch shutdowns.	5	9999	100	P
Bats.Pause	Set the amount of downtime for a single batch.0 no stop, 9.9 to the number of batch, direct stop no start.After 0.1-9.8s, stop and start automatically.	0	9.9	2	S
Punch.Delay	Delay the action time of punching.	0	9.99	0.00	S
Punch.Time	Action time of punching.	0	9.99	0.05	S
Regress.Length	Set the regression length with the regression function.	0	99	0	mm
Send.Speed	Set the pace of step traction	0	2000	100	
Work.Type	Select the first operation mode, first cutting knife -> machine first cutting knife after feeding, first feeding -> machine first cutting knife (when the knife is not in the high position, the machine is still first cutting knife work.)			先切刀	
Punch.sw	Punch switch.			开	
Track.Type	Photoelectric tracking mode, automatic <-> white work <-> black work.			自动	
BACK.SW	Low back off - low back off				
Next	Password			8	

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SHOW	Explain	Min	Max	Default	Unit
TrackView	No number of tracking alarms	0	9	3	v
TrackAdvance	Track the advance detection length	0	99	5	mm
TrackDelay	Tracking lag detection length	0	99	10	mm
TrackSpeed	Tracking detection speed (larger, faster)	0	99	40	Rpm
CurveStep	Speed of feeding (larger, more stable, smaller, faster)	0	9	2	P
Maxspeed	Servo or complement the maximum speed	0	150	70	%
SendDuty	The proportion of feeding time in the whole P bag-making cycle	0	99	50	
A Dimeter	Diameter of cots	0	300	70	mm

SHOW	Explain	Min	Max	Default	Unit
Mode	STOP、NO-STOP、BackFirst、Back、NextSTOP、High-Stop、BACK2、BACK3、NoMaster1、TwoLD、HHHC、NoMaster2、BY、BS、XB.WZJ、TwoLD、NoMaster4、NoMaster5、			STOP	
MasterSpdFactor	Set the matching machine ratio. The higher the speed, the slower it will be.	5	999	200	P/M
MasterJOP	Set the speed of the host inching, the greater the speed, the faster.	0.00	50.00	10.00	Hz
Ctrl	AUTO、HALF-AUTO、Mannul.			AUTO	
Default	Restore factory Settings of the machine, please operate carefully.				

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Punch.Para
Blow.Para
Tidy.Para
Spray.Para
Alarm.Para
Lift.Para
WZJ.Para
Unwind.Para
M.LD.Para
Test

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HHGK

Punch②. lag

0.00 S

Punch②. Time

0.05 S

Punch②. SW

Punch. OFF

Punch③. lag

0.00 S

Punch③. Time

0.05 S

Punch③. SW

Punch. OFF

Punch④. lag

0.00 S

Punch④. Time

0.05 S

Punch④. SW

Punch. OFF

Return

Pre

Next

HHGK

Send, Punch1. lag

0.00 S

Send, Punch1. Time

0.05 S

Send, Punch. SW

SendPunchOFF

Punch, Release

0.00 S

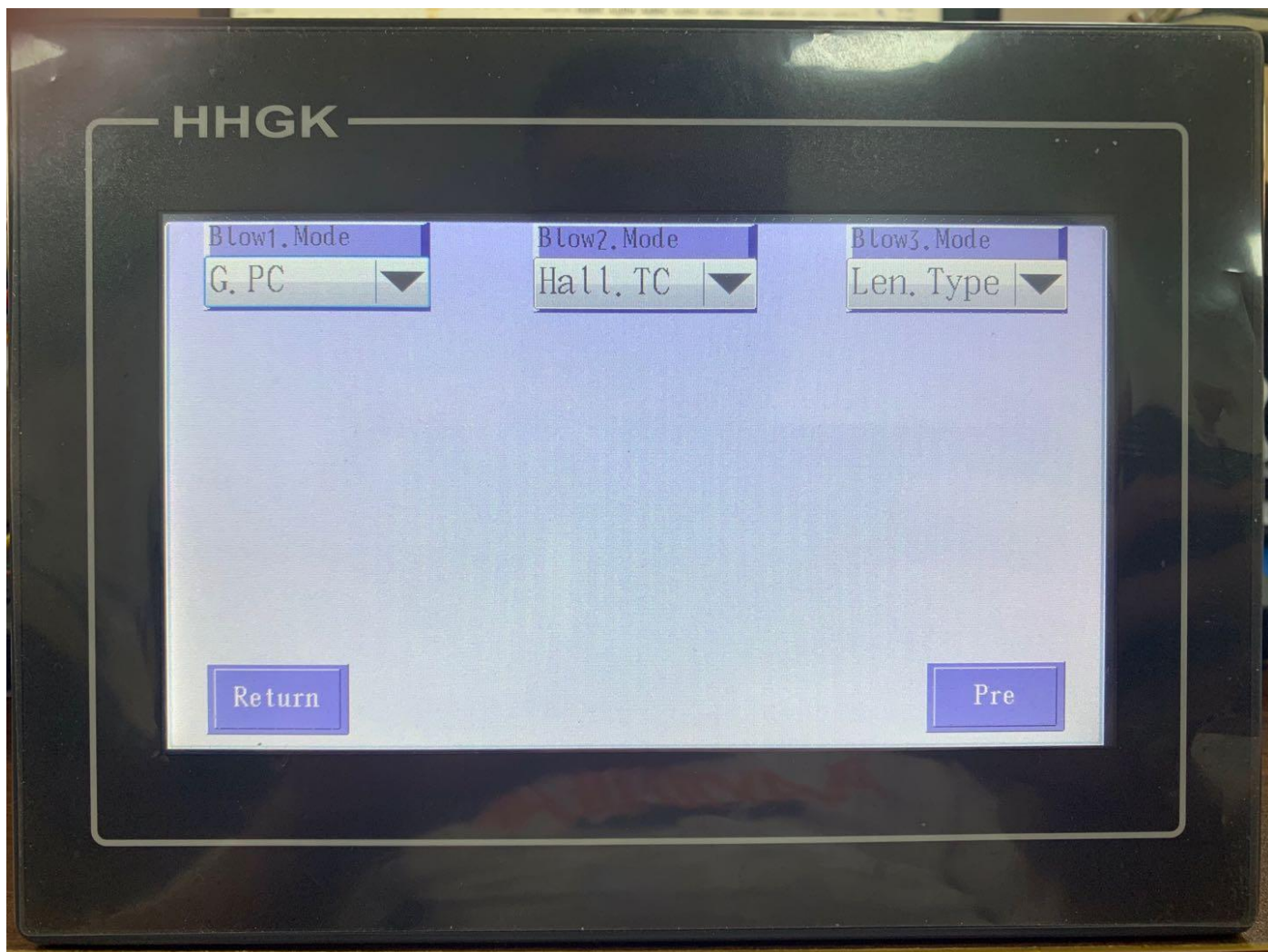
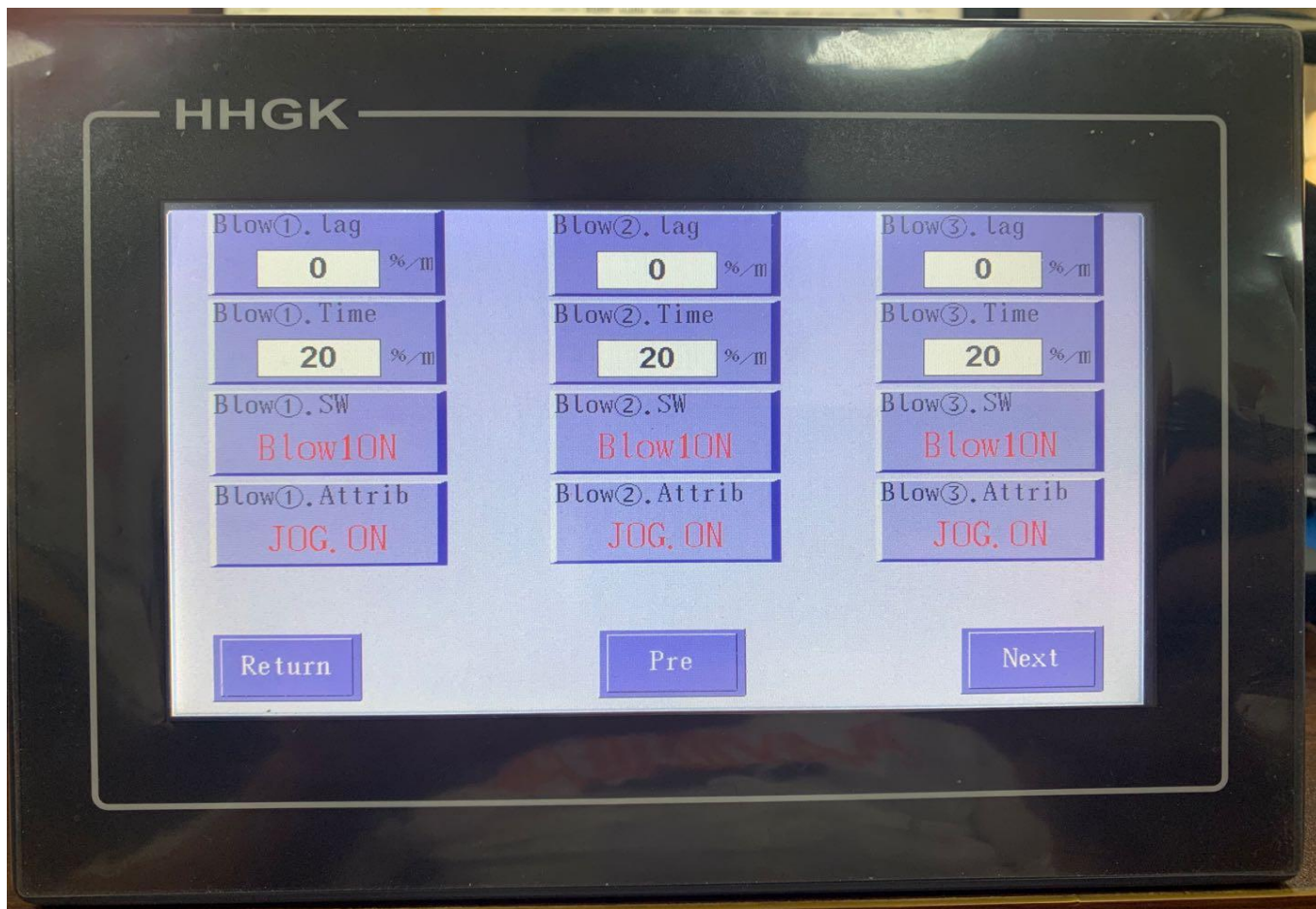
Return

Pre

Next

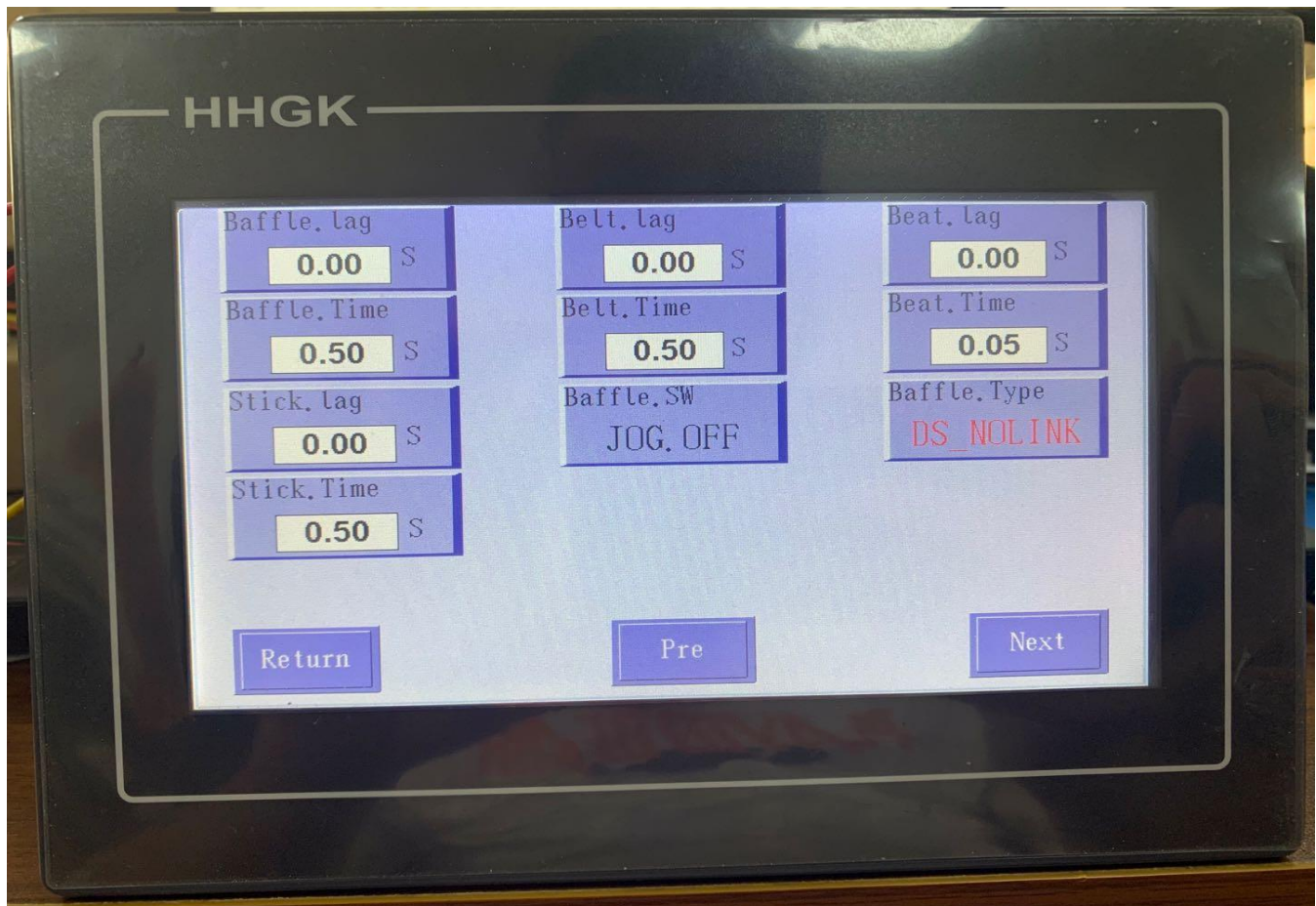
Punch.Para					
SHOW	Explain		Min	Max	Unit
Punch.Lag	Delay start punch		0	9.99	S
Punch.Time	The length of time set for punching		0	9.99	S
Punch.SW 1234	Punch after feeding		Send.Punch.lag	When feeding, start with delay to achieve the effect of early start	
Entrance pointWay	0		Output pointWay	5	
Entrance point	x	x	x	x	x
Default setting	x	x	x	x	x
Output point	Punch1	Punch 2	Punch 3	Punch 4	pay-off Punch
Default setting	Y11	Requires an internal call	Requires an internal call	Requires an internal call	Requires an internal call

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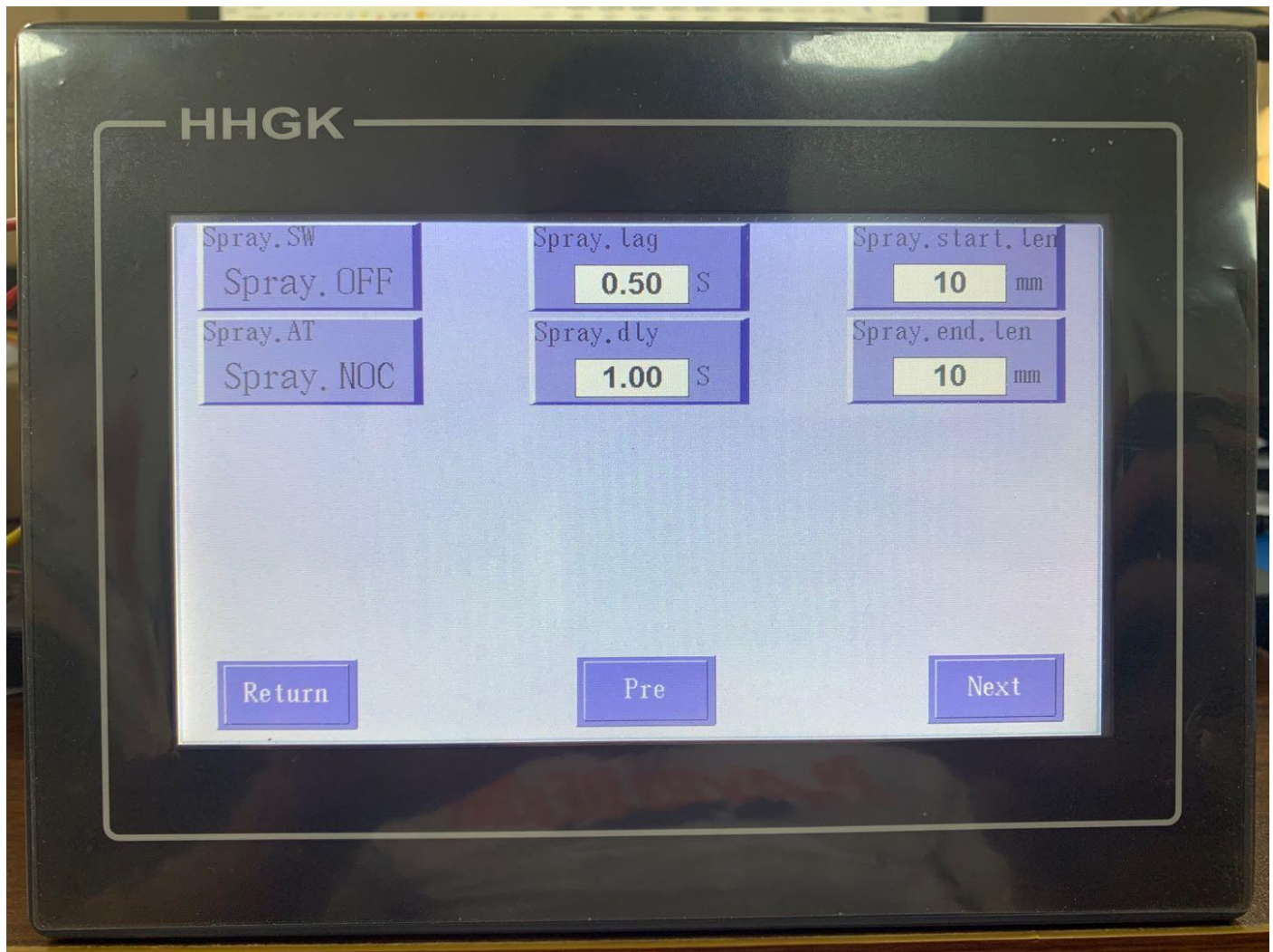
Blow.Para					
SHOW	Explain		Min	Max	Unit
Blow.Lag	Delay start blow		0	9999	%/ms
Blow.Time	The time or length set for blowing		0	9999	%/ms
Blow.Attrib	Select whether or not to blow into the point				
Blow.Mode	Blow.Mode Explain				
G.PC	Blow air while feeding				
Pre.PC	Before feeding, install an input hall, detect when blowing, stop at feeding time (UnitS)				
Hall.TC	Install an input hall that is detected to be blown (UnitS)				
IHall.TC	Install an input hall and blow whenever you want (UnitS)				
Len.Type	When feeding blow, blow according to the length (Unit mm)				
GK1.XC	Blow low when detected (UnitS)				
Hall.XC	Install an input hall, detected to be blowing, the first P bag does not blow (UnitS)				
Entrance pointWay	3		Output pointWay	3	
Entrance point	Blow1	Blow 2	Blow 3	x	x
Default setting	X7	Requires an internal call	Requires an internal call	x	x
Output point	Blow 1	Blow 2	Blow 3	x	x
Default setting	Y5	Requires an internal call	Requires an internal call	x	x

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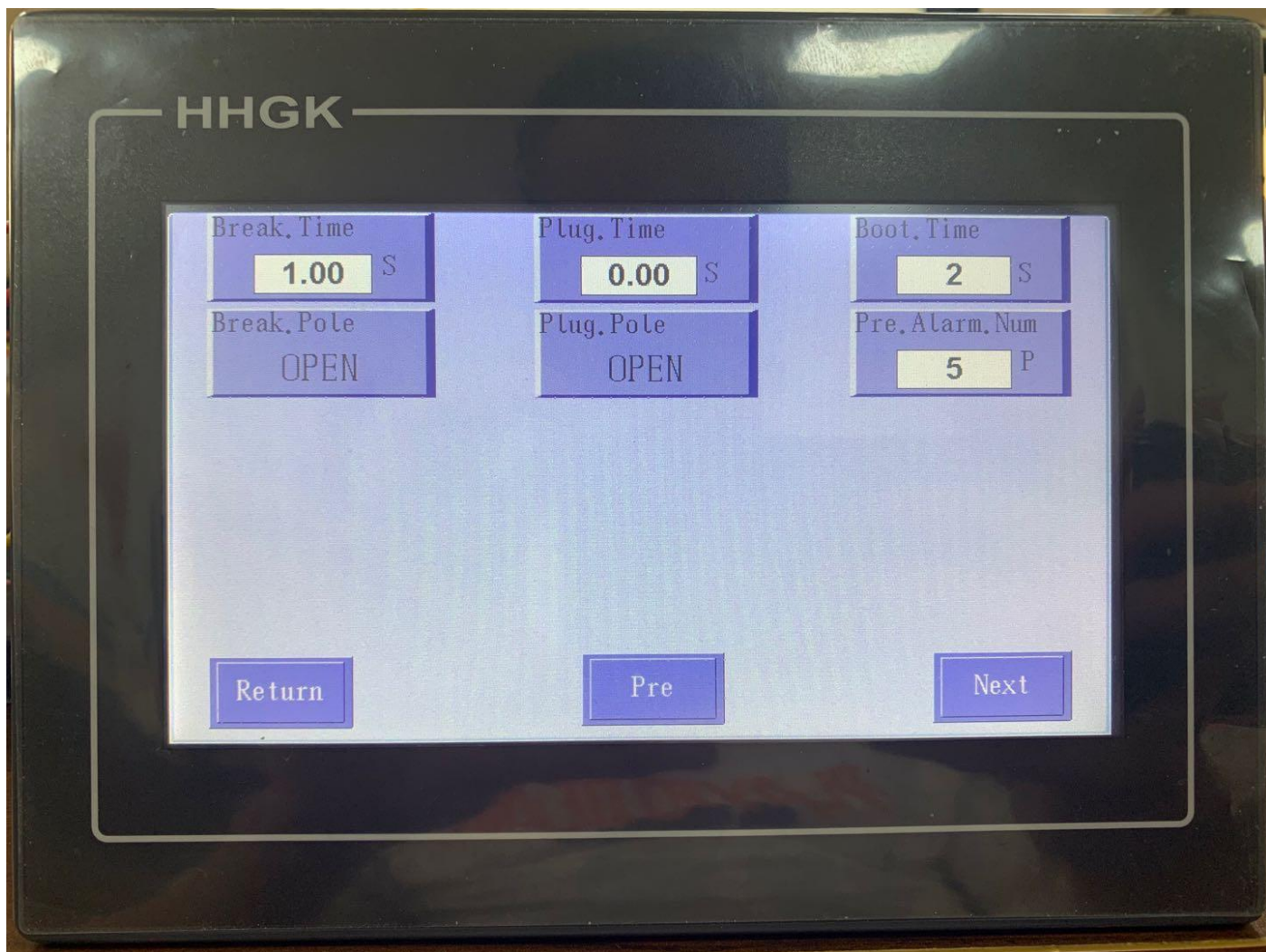
Tidy.Para					
SHOW	Explain		Min	Max	Unit
Baffle.Lag	Delay the start time		0	9.99	S
Baffle.Time	Keep the pin running time		0	9.99	S
Stick.lag	Roll delay start time		0	9.99	S
Stick.Time	Press roll keep running time		0	9.99	S
Belt.lag	Delayed start time of conveyor belt		0	9.99	S
Belt.Time	Conveyor belt keeps running time		0	9.99	S
Beat.lag	Delay the start time of shooting bag		0	9.99	S
Beat.Time	Pat bag to keep running time		0	9.99	S
Baffle.SW	JOG.OFF-----JOG.ON				
Baffle.Type	DS-NOLINK-----DS-LINK				
Put.tags.num	Start batch number of inserts		0	9999	B
Put.tags.Time	The socket maintains the running time		0	9.99	S
Pin.lag	Hot needle delay startup time		0	9.99	S
Pin.Time	Hot needle keep running time		0	9.99	S
Cut.tags.dly	Delay the start time of cutting bid		0	9.99	S
Cut.tags.Time	Cut bid keep running time		0	9.99	S
Fb.lag	Turn over delay start time		0	9.99	S
Fb.sw	FLAP.OFF-----FLAP.ON				
Oil.num	Refueling start batch number		0	9999	P
Oil.Time	Refueling to maintain running time		0	9.99	S
QYB.Time	The front pressing plate keeps running time		0	9.99	S
TC.Unit	Single batch pause time multiple。 0.1Unit100MS-----0.1Unit1S				
Entrance pointWay	0		Output pointWay	10	
Entrance point	x	x	x	x	x
Default setting	x	x	x	x	x
Output point	Baffle	Stick	Belt	Beat	put
Default setting	Y5	Requires an internal call	Y12	Requires an internal call	Requires an internal call
Output point	pin	cut	fb	oil	QYB
Default setting	Requires an internal call	Requires an internal call	Requires an internal call	Requires an internal call	Requires an internal call

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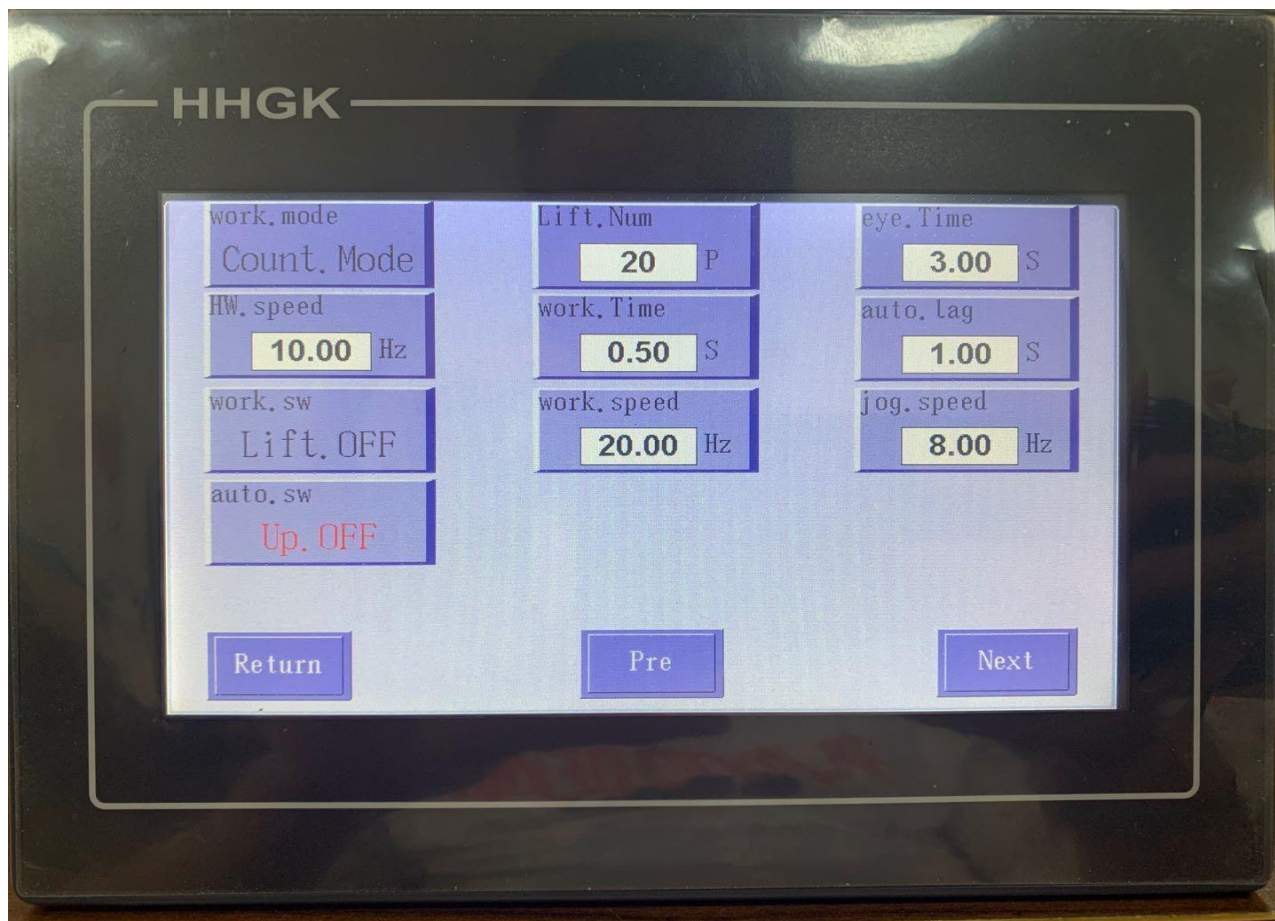
Spray.Para					
SHOW	Explain		Min	Max	Unit
Spray.lag	Spray lag start time when glue is continuously applied		0	9.99	S
Spray.dly	Delay closing time when spraying glue continuously		0	9.99	S
Spray.start.len	The lag start length of the spray when the glue is broken		0	9999	mm
Spray.end.len	Delay closing length of spray when glue is broken		0	9999	mm
Spray.SW	Spray.OFF-----Spray.ON				
Spray.AT	Spray.NOC-----Spray.CTNS				
Entrance pointWay	0		Output pointWay	2	
Entrance point	x	x	x	x	x
Default setting	x	x	x	x	x
Output point	Spray1	spray2	x	x	x
Default setting	Requires an internal call	Requires an internal call	x	x	x

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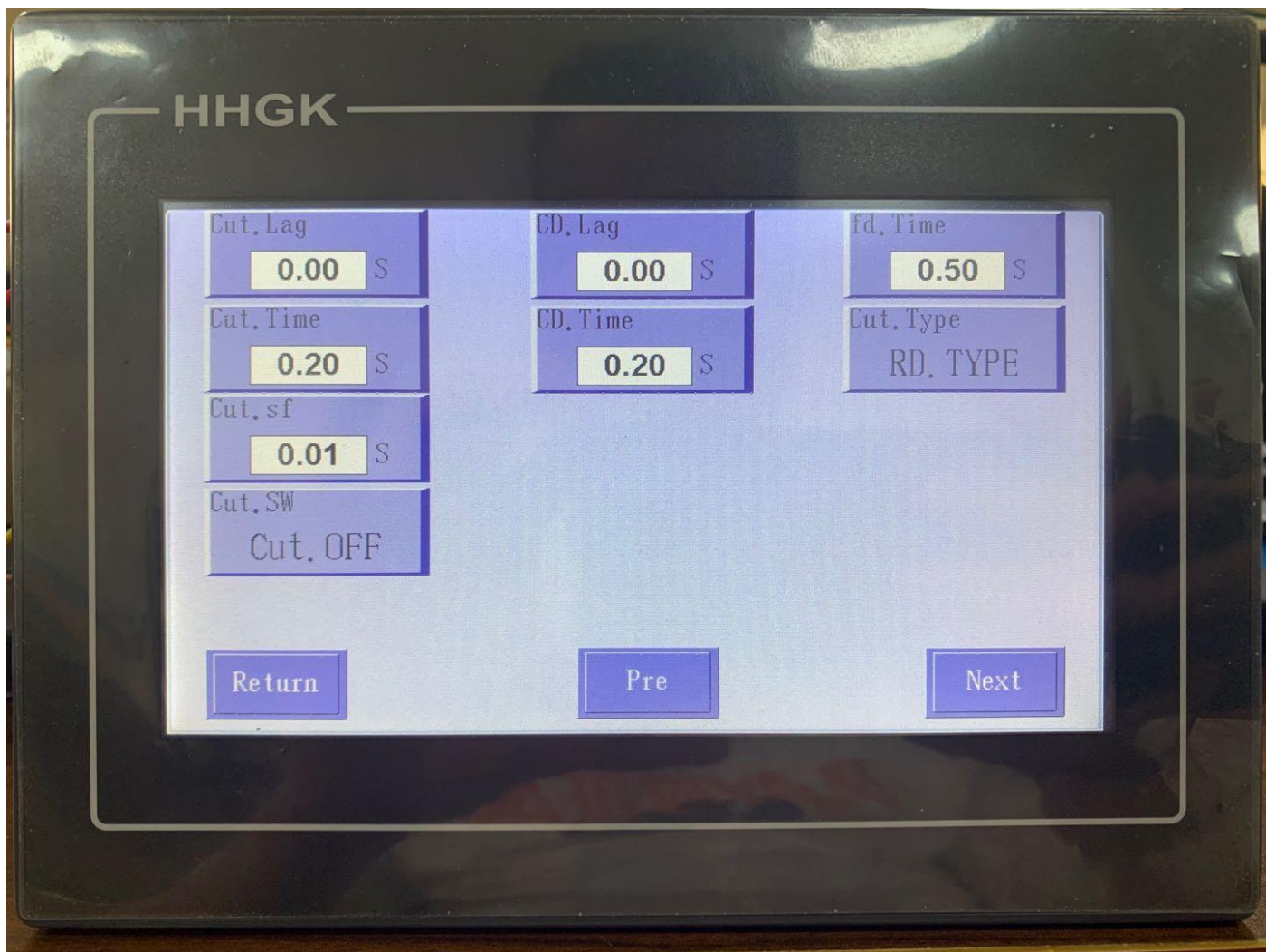
Alarm.Para					
SHOW	Explain		Min	Max	Unit
Break.Time	Breaking inspection time		0	9.99	S
Break.Pole	OPEN () -----CLOSE ()				
Plug.Time	Blocking detection time		0	9.99	S
Plug.Pole	OPEN () -----CLOSE ()				
Boot.Time	Alarm time when the machine is turned on		0	6	S
Pre.Alarm.Num	Batch number will be notified in advance		0	9999	P
Entrance pointWay	3		Output pointWay	2	
Entrance point	Break1	Break2	Plug	x	x
Default setting	X14	Requires an internal call	Requires an internal call	x	x
Output point	Speaker	Speaker2	x	x	x
Default setting	Y10	Requires an internal call	x	x	x

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Lift.Para					
SHOW	Explain		Min	Max	Unit
Work.mode	Count.Mode-----EYE.Mode				
Work.sw	Lift.OFF-----Lift.ON				
Auto.sw	UP.OFF-----UP.ON				
HW.speed	Back frequency		0	50	Hz
Lift.Num	The number of work		0	9999	P
Work.Time	The time the work is kept running		0	9.99	S
Work.speed	Speed at work		0	50	Hz
Eye.Time			0	9.99	S
Auto.lag	The time of the startup lag		0	9.99	S
Auto.lag	The velocity of inching		0	50	Hz
Entrance pointWay	6		Output pointWay	2	
Entrance point	Lifting the lower limit	Lifting cap	Lift up	Rise and fall down	Lifting points
Default setting	Requires an internal call	Requires an internal call	Requires an internal call	Requires an internal call	Requires an internal call
Entrance point	Lifting return	x	x	x	x
Default setting	Requires an internal call	x	x	x	x
Output point	On the elevator	Under the elevator	x	x	x
Default setting	Requires an internal call	Requires an internal call	x	x	x

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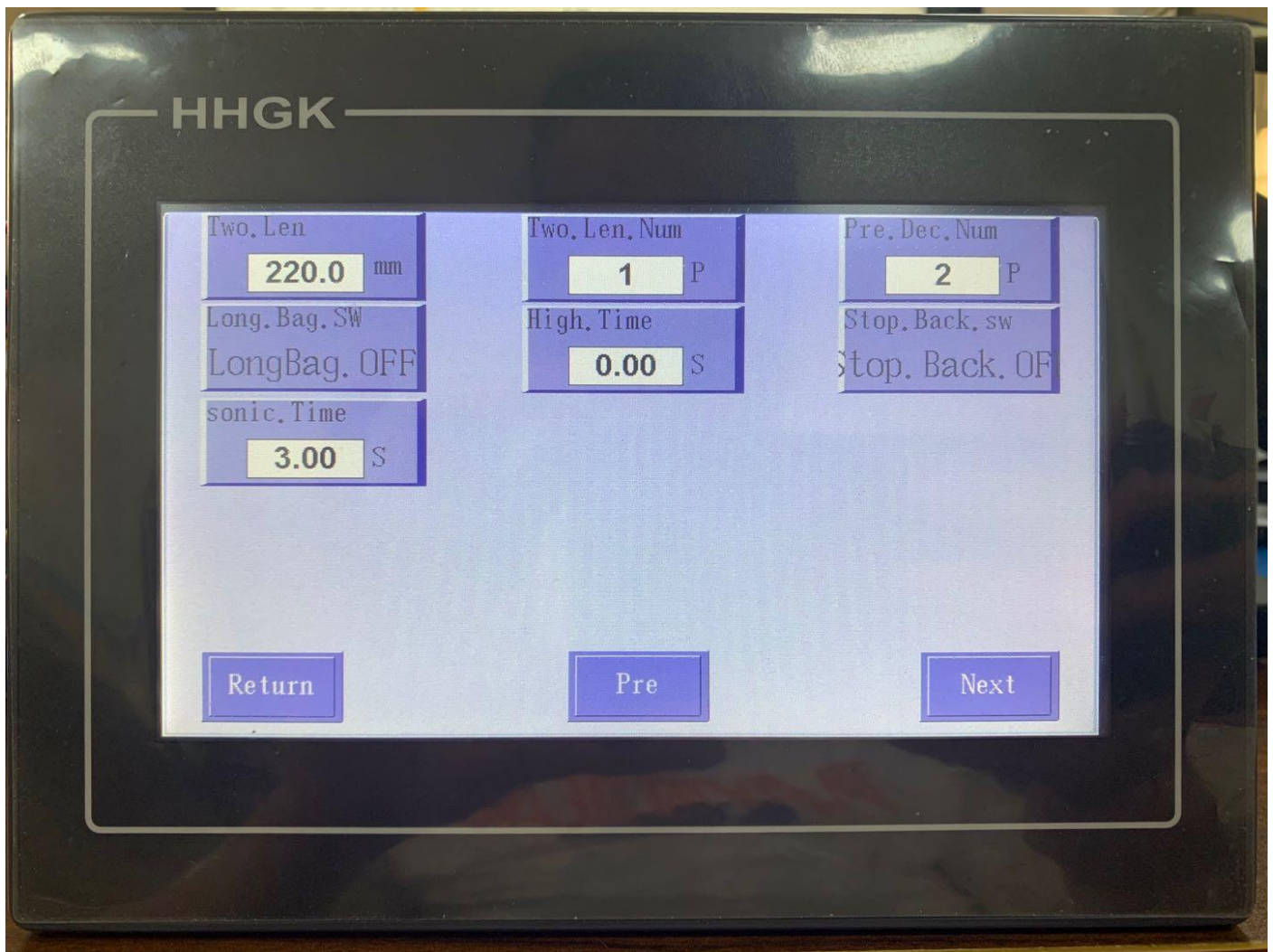
WZJ.Para					
SHOW	Explain		Min	Max	Unit
Cut.Lag	The cutter delays the start time		0	9.99	S
Cut.Time	The cutter keeps running time		0	9.99	S
Cut.sf	Cutter release running time		0	9.99	S
Cut.SW	Cut.OFF-----cut.ON				
CD.Lag	Delay the start time of the sack		0	9.99	S
CD.Time	Drop bag keep running time		0	9.99	S
Fd.Time	Flying knife keeps running time		0	9.99	S
Cut.Type	RD.TYPE-----COLR.TYPE				
Entrance pointWay	3		Output pointWay	4	
Entrance point	Fly knife origin	Heaveho limit	Heaveho start	x	x
Default setting	Requires an internal call	Requires an internal call	Requires an internal call	x	x
Output point	No host knife	Lost bag	Fly knife left	Fly knife right	x
Default setting	Requires an internal call	Requires an internal call	Requires an internal call	Requires an internal call	x

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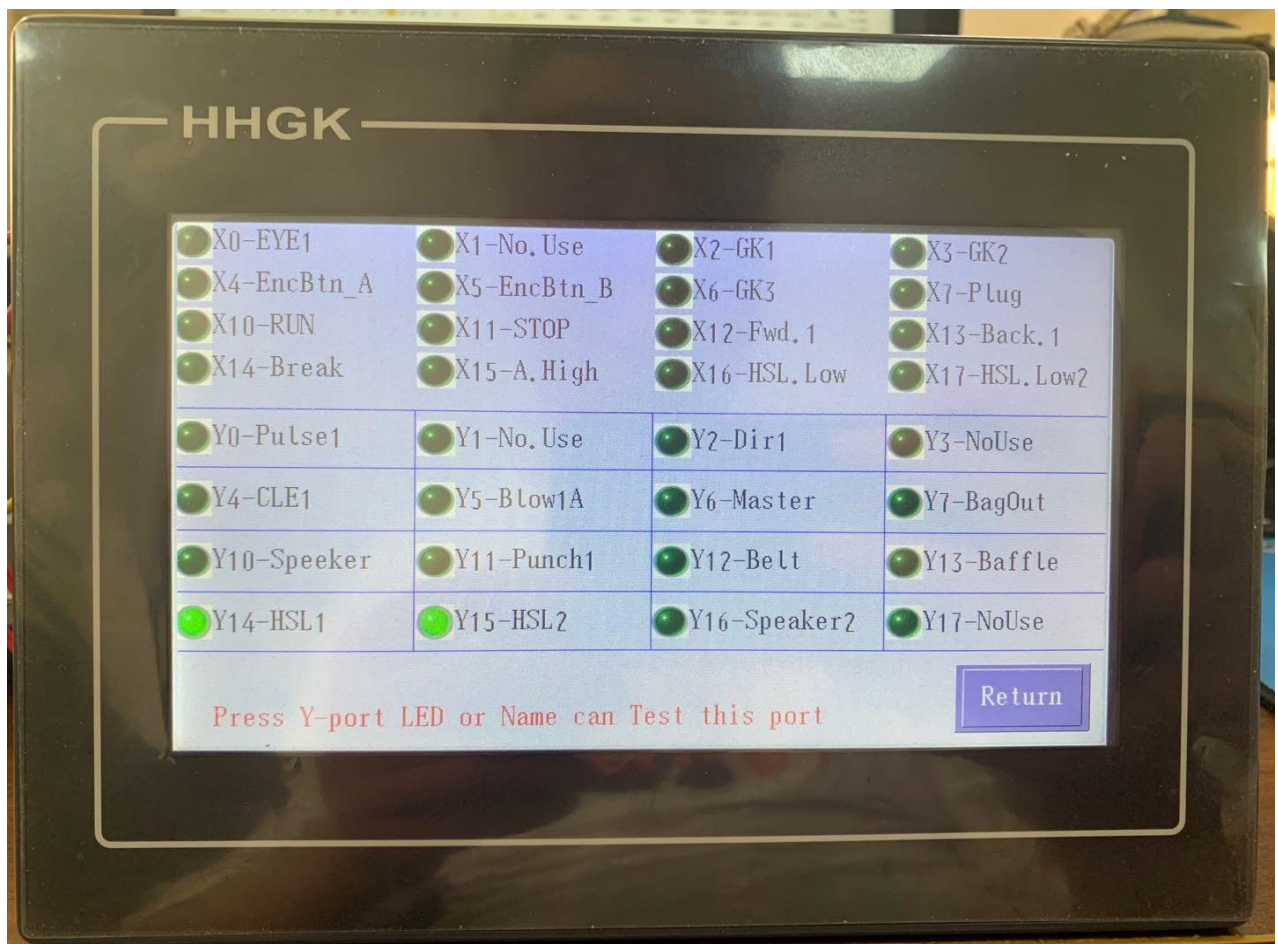
Unwind.Para					
SHOW	Explain		Min	Max	Unit
Feed.JOG	When the machine is stopped, the material is inching to the low position		0	50	Hz
Feed.Factor	Feeding coefficient ratio (larger, slower, smaller, faster)		10	500	M
Feed	Discharge switch (can be turned off separately)				
Feed.PRE	Pre-delivery upon startup		0	50	Hz
Entrance pointWay	2		Output pointWay	2	
Entrance point	HSL.Low1	HSL.Low2	AD1	AD2	x
Default setting	X16	X17	Use with displacement	Use with displacement	x
Output point	HSL1	HSL2	DA2	DA3	x
Default setting	Y14	Y15	analog output	analog output	x

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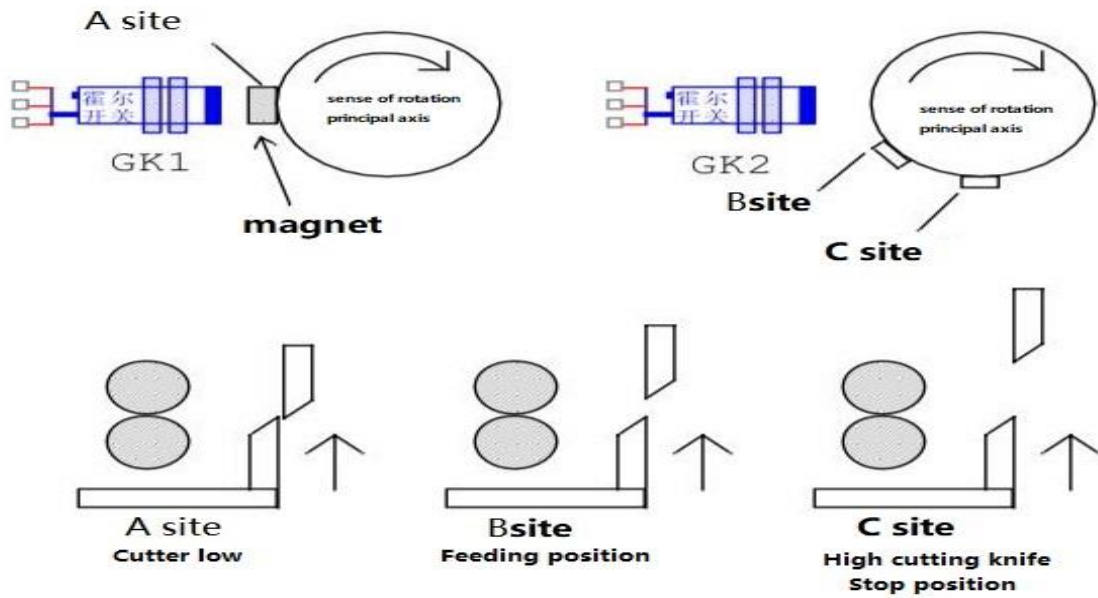
M.LD.Para					
SHOW	Explain		Min	Max	Unit
Two.Len	Second bag length		0	999	mm
Two.Len.Num	Number of second lengths		1	99	P
Pre.dec.Num	Batch number decelerate in advance number		0	10	P
Long.Bag.SW	LongBag.Off-----LongBag.ON				
High.Time	Long bag mode pause at high level for a period of time		0	9.99	S
Stop.Back.SW	Stop.Back.OFF-----Stop.Back.ON				
Sonic.Time	Ultrasonic wave time		0	9.99	S
Entrance pointWay	0		Output pointWay	1	
Entrance point	x	x	x	x	x
Default setting	x	x	x	x	x
Output point	Ultrasonic 1		x	x	x
Default setting	Requires an internal call		x	x	x

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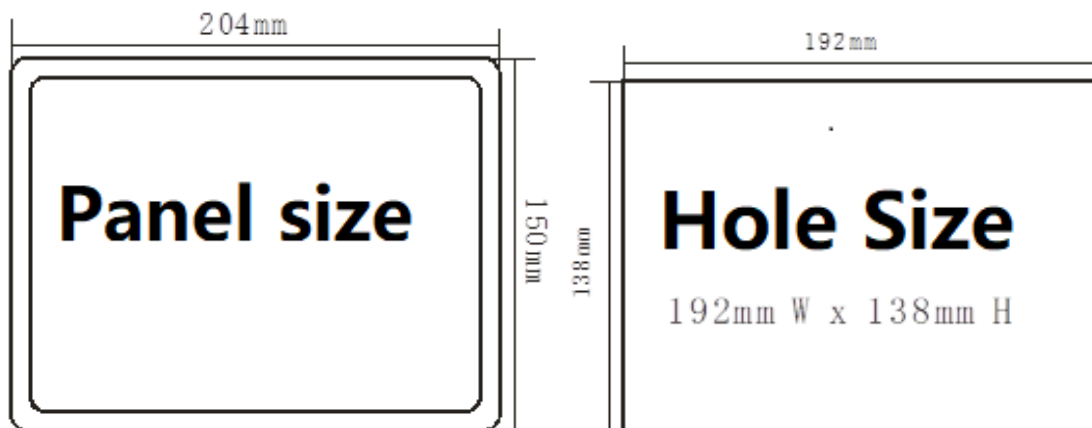
Note: press the Y mouth lamp or text can test the port

- Input sensor logic diagram



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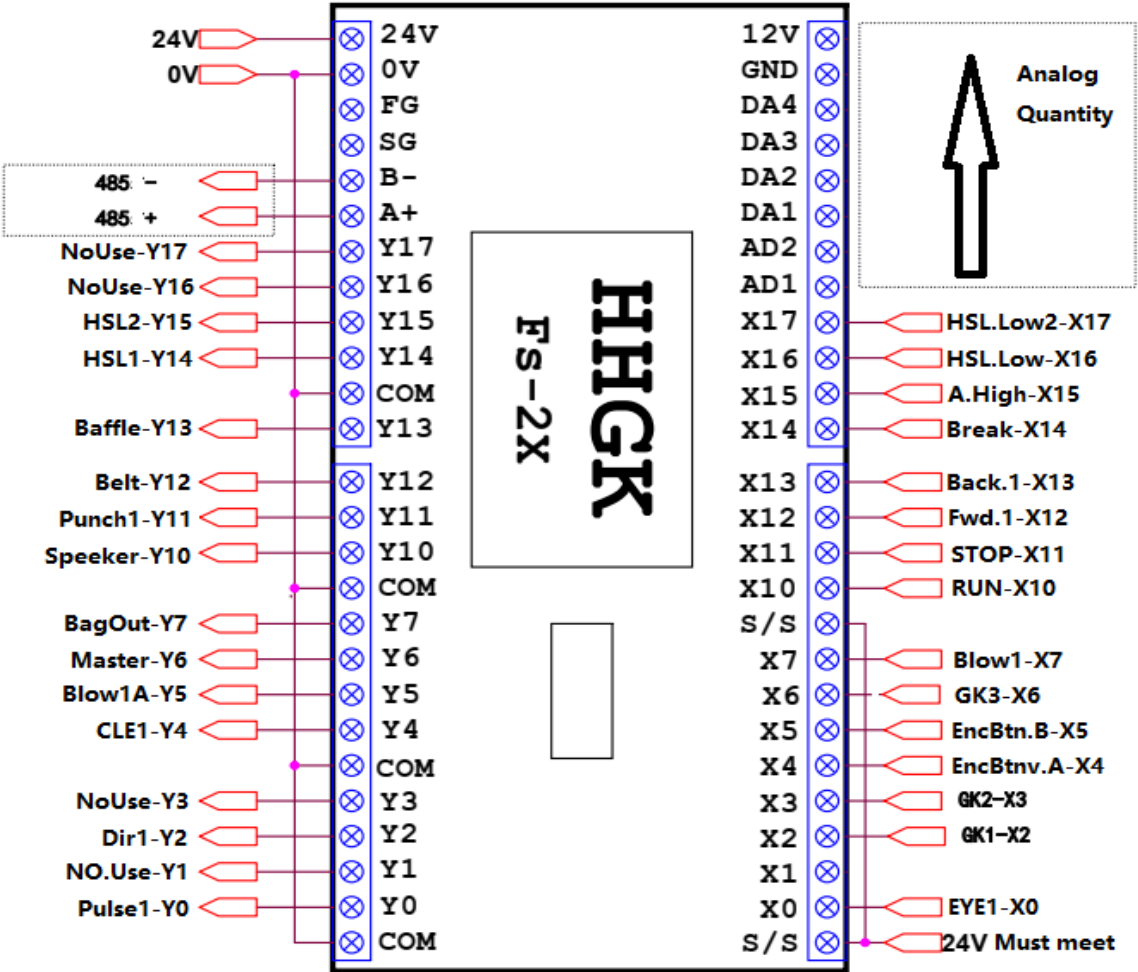
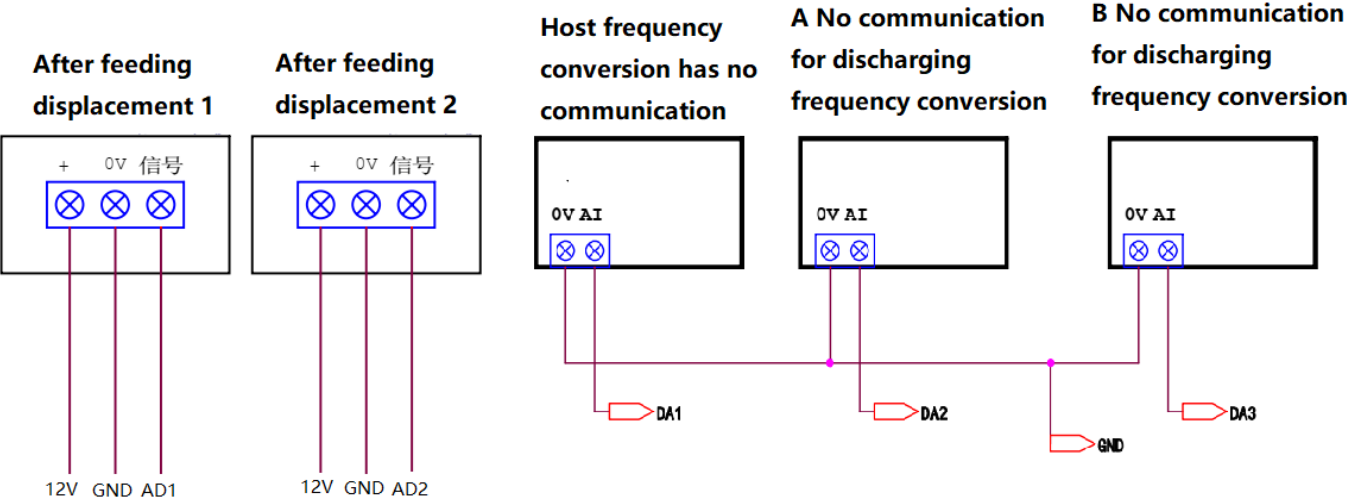
Hole Size



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The wiring drawing



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