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E21 Operation Manual

(Version: V1.04)



ESTUN AUTOMATION CO., LTD

— Total Solution Supplier





Contents

Preface	1
Chapter 1 Product Overview	2
1.1 Product introduction	2
1.2 Operation panel	2
1.3 Displayer	4
Chapter 2 Operation Instruction	5
2.1 Basic operation procedure	5
2.2 Programming	6
2.2.1 Single-step programming	6
2.2.2 Multi-step programming.....	8
2.3 Parameter setting.....	12
2.4 Manual movement	14
Chapter 3 Alarm	16
Appendix Common fault and troubleshooting	18



Preface

This manual describes operation of E21 numerical control device and is meant for operators who are instructed for operation of the device. Operator shall read through this manual and know operation requirements before using this device.

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E21 device provides complete software control and has no mechanical protection device for operator or the tool machine. Therefore, in case of malfunction, machine tool must provide protection device for operator and external part of the machine tool. ESTUN is not responsible for any direct or indirect losses caused by normal or abnormal operation of the device.

ESTUN preserves the right to modifying this manual in the event of function adding or print error.

Chapter 1 Product Overview

1.1 Product introduction

This product is equipped with press brake machine dedicated numerical control device which is applicable to various users. On the basis of ensuring work precision, the cost of numerical control bending machine is reduced significantly.

Features of this product are listed below:

- Positioning control of back gauge.
- Intelligent positioning control.
- Unilateral and bidirectional positioning which eliminates spindle clearance effectively.
- Retract functions.
- Automatic reference searching.
- One-key parameter backup and restore.
- Fast position indexing.
- 40 programs storage space, each program has 25 steps.
- Power-off protection.

1.2 Operation panel


















Operation panel is shown in Figure 1-1.



Figure 1-1 Operation panel

Functions of panel keys are described in Table 1-1.

Table 1-1 Description of key functions

Key	Function description
	Delete key: delete all data in input area on left bottom of displayer.
	Enter key: confirm the input content. If no content is input, the key has the similar function to direction key  .
	Start key: automatic start-up, top left corner of the key is operation indicator LED. When operation is started, this indicator LED is on.
	Stop key: stop operation, top left corner of the key is Stop indicator LED. When initialize normal start-up and no operation, this indicator LED is on.
	Left direction key: page forward, cursor remove
	Right direction key: page backward, cursor remove
	Down direction key: select parameter downward
	Function switch: switch over different function pages
	Symbolic key: user input symbol, or start diagnosis.
	Numeric key: when setting parameter, input value.
	Decimal point key: when set up parameter, input decimal point.
	Manual movement key: in case of manual adjustment, make adjustment object move in forward direction at low speed.
	Manual movement key: in case of manual adjustment, make adjustment object move in backward direction at low speed.
	High speed selection key: in case of manual adjustment, press this key and press  simultaneously, make adjustment object move in increasing direction at high speed, then press  , make adjustment object move in decreasing direction at high speed.

1.3 Displayer

E21 numerical control device adopts 160*160 dot matrix LCD displayer. The display area is shown in Figure 1-2.

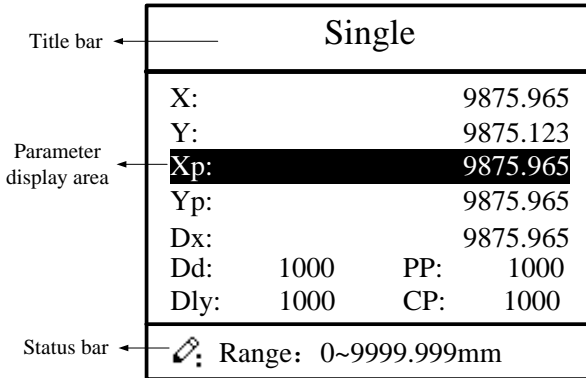


Figure 1-2 Display area

- Title bar: display relevant information of current page, such as its name, etc.
- Parameter display area: display parameter name, parameter value and system information.
- Status bar: display area of input information and prompt message, etc.

Chapter 2 Operation Instruction

2.1 Basic operation procedure

Basic switch over and operation procedure of the device is shown in Figure 2-1.

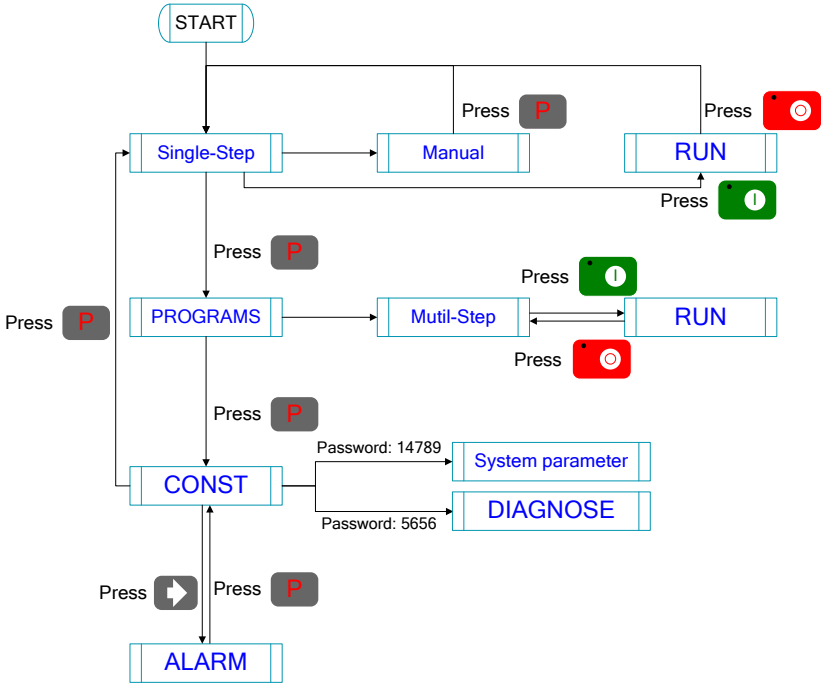



Figure 2-1 Basic Operational Flow

2.2 Programming

The device has two programming methods, which are single-step programming and multi-step programming. User can set up programming according to actual demand.

2.2.1 Single-step programming

 CAUTION
When the parameter X or Y displays ***** on the page, please do not enter the RUN page or Manual page, unless you have reset the teach function of X-axis or Y-axis.

Single-step programming is generally used for processing single step to finish work piece processing. When controller is power on, it will automatically enter single-step program page.

Operation steps

Step 1 After starting up, the device will enter setting up page of single-step program automatically, as shown in Figure 2-2.




Single			
X:			200.50
Y:			120.35
XP:			300.00
YP:			130.50
DX:			50.00
HT:	1000	PP:	100
DLY:	1000	CP:	100
 Range: Between soft lim.			

Figure 2-2 Single-step program setting page


Step 2 Press , select parameter which needs to be set up, press numerical key to input program value, press  to complete input.

[Note] Parameter can only be set when Stop indicator is on.

Setting range of single step parameter is shown in Table 2-1.

Table 2-1 Set up range of single step parameter

Parameter name	Unit	Set up range	Remarks
X	mm/inch	-	Current position of X axis, unable to be modified.
Y	mm/inch	-	Current position of Y axis, unable to be modified.
XP	mm/inch	0~9999.999	Program position of X axis.
YP	mm/inch	0~9999.999	Target position of Y axis.
DX	mm/inch	0~9999.999	Retract distance of X axis.
HT	s	0~99.99	The time between concession signal valid and end hold time output.
DLY	s	0~99.99	In case of single step, delay time for X axis concession.
PP	-	0~9999	Number of preset work piece.
CP	-	0~9999	Number of current work piece.

Step 3 Press , system will execute according to this program, as shown in Figure 2-3.

Single	
X:	9875.965
Y:	9875.123
C:	0
PP:	0 mm







Figure 2-3 Single step operation page

Operation example


On single-step program page, program bending depth to 100.0mm, back gauge position to 80.00mm, retract distance to 50mm, concession waiting time to 2s, holding time to 3s, work piece to 10.

Operation steps are shown in Table 2-2.

Table 2-2 Operation steps of single step example

Operation steps	Operation
Step 1	Press  , select "XP" parameter.
Step 2	Input 80.00 by numerical key.
Step 3	Press  , confirm setting of this parameter.
Step 4	Press  , select "YP" parameter.
Step 5	Input 100.0 by numerical key.
Step 6	Press  , confirm set up of this parameter.
Step 9	Press  , select "DX" parameter, "DLY" parameter, "HT" parameter, "PP" parameter respectively.
Step 10	Set up parameter to 50mm, 2s, 3s, 10, 0 by numerical key.
Step 11	Press  , system execute according to this program.


2.2.2 Multi-step programming

 CAUTION
When the parameter X or Y displays ***** on the page, please do not enter the RUN page, unless you have reset the teach function of X-axis or Y-axis.

Multi-step program is used for processing single work piece of different processing steps, realize consecutive implementation of multi-steps, and improve processing efficiency.




Operation step



Step 1 Power on, the device displays the single-step parameter page automatically.

Step 2 Press , switch to program manage page, as shown in Figure 2-4.

PROGRAMS					OP
1	2	3	4	5	
6	7	8	9	10	
11	12	13	14	15	
16	17	18	19	20	
1 program					1ST



Figure 2-4 Program management page


Step 3 Press   , select program serial number, or input program number directly, such as input “1”.

Step 4 Press  , enter multi-step program setting page, as shown in Figure 2-5.

PROGRAM1	
ST:	1
PP:	99
CP:	9
DLY:	100
HT:	0
✎ Range: 0~25	




Figure 2-5 Multi-step program setting page

Step 5 Press , select multi-step programming parameter which requires set up, input setting up value, press , and the set up takes effect.

Step 6 In completion of set up, press , enter step parameter set page, as shown in Figure 2-6.

PROGRAM1		1/ 5ST
X:	5.000	
Y:	12345.000	
XP:	9.000	
YP:	5.000	
DX:	25.00	
RP:	54	
✎ Range: Between soft lim.		

Figure 2-6 Step parameter set page

Step 7 Press , select step parameter that needs to be set up, input program value, press  , and the setup takes effect.





Step 8 Press   to switch over between steps. If the current step is the first step, press  to enter the last page of step parameter setting; if the current step is the last one, press  to enter the first page of step parameter setting. Multi-step parameter setting range is shown in Table 2-3.



Table 2-3 Multi-step parameter setting range

Parameter name	Unit	Setting range	Remarks
Step number of program	-	0~25	Set up total processing step number of this program
Preset work piece number	-	0~9999	Number of work piece to be processed, decreasing piece when more than zero; negative increasing count.
Current work piece number	-	0~9999	Number of finished work piece
Concession delay	s	0~99.99	Time between retract signal and concession execution.
Holding time delay	s	0~99.99	Time between concession signal and end pressurize output
X	mm/inch	-	Current position of X axis, can't be modified;
Y	mm/inch	-	Current position of Y axis, can't be modified;
X target position	mm/inch	0~9999.999	Program position of X axis;
Y target position	mm/inch	0~9999.999	Target position of Y axis;
concession distance	mm/inch	0~9999.999	Distance of X axis concession;
Repeat times	-	1~99	Repeat times required by this step.

Step 9 Press , system will operate according to this program, as shown in Figure 2-7.

PROGRAM 1	Rp: 1/54
X:	5.000
Y:	12345.000
C:	0
PP: 12345	St: 1/ 5

Figure 2-7 Multi-step programming operation page

Operation example

[Background] One work piece requires processing 50 as shown below;

- First bend: 50mm;
- Second bend: 100mm;
- Third bend: the other direction 300mm;





[Analysis] according to work piece and technological conditions of machine tool:

- First bend: X axis position is 50.0mm; Y axis position is 85.00mm, concession 50mm;
- The second bend: X axis position is 100.0mm; Y axis position is 85.00mm, concession 50mm;
- The third bend: X axis position is 300.0mm; Y axis position is 85.00mm, concession 50mm;








Edit processing program of this work piece on No. 2 program.

Operation procedure is shown in Table 2-4.

Table 2-4 Operation steps of multi-step programming example

Operation step	Operation
Step 1	On single step parameter setting page, press  to enter program selection page.
Step 2	Input "2", press  , enter multi-step general parameter setting page of program 2.
Step 3	Select "Program step", input "3", press  , the setting takes effect.
Step 4	Select "number of preset work piece", input "50", press  , the setup takes effect.




Operation step	Operation
Step 5	Similar to step 3 and step 4, set "current work piece number", "concession delay" and "pressurize time" to 0, 400, 200 respectively.
Step 6	Press  to enter first step setup page of step parameter.
Step 7	Select "X target position", input 50, press  , the setup takes effect.
Step 8	Select "Y target position", input 85, press  , and the setup take effect.
Step 9	Similar to step 7, 8, set up "concession distance" and "repeat times" to 50, 1 respectively.
Step 10	Press  to enter second step setup page of step parameter, the setup method is similar to that of step one.
Step 11	Press  again, to enter third step setup page of step parameter, the setup method is similar to that of step one and step two.
Step12	Press  , return to setup page of the first step.
Step13	Press  , system will operate according to this program.

[Note]

- In completion of multi-step programming, return to start step before launching the system; otherwise, the program will start position processing at current step.
- Press left and right direction key to circulate page turning and browsing among all step parameters.
- Program can be called and revised again.
- In completion of processing all work pieces (50 in the example), system stops automatically. Restart directly will start another round of processing 50 work pieces.

2.3 Parameter setting

User can setup all parameters required for normal operation of the system, including system parameter, X axis parameter and Y axis parameter.

- Step 1** On program management page, press  to enter programming constant page, as shown in Figure 2-8. On this page, programming constant can be set.


CONST	
mm/inch:	0
中文/English:	1
X-tea.in:	10.00
Y-tea.in:	10.00
Release Time:	0.30
Pulse Time:	0.020
Version:	1.06
✎: 0: mm 1: inch	

Figure 2-8 Programming constant page

Range of programming constant setup is shown in Table 2-5.

Table 2-5 Range of programming constant setup

Parameter name	Unit	Range	Default	Remarks
X-tea.in	mm	0~9999.99	10	In teach enable, input current position of X axis
Y-tea.in	mm	0~9999.99	10	In teach enable, input current position of Y axis
mm/inch	-	0 or 1	0	0: mm, 1: inch
中文/English	-	0 or 1	0	0: Chinese, 1: English
Release Time	s	0-99.99	0.3	Continue time of unloading output after starting the system.
Pulse Time	s	0.000-1.000	0.020	The duration of the pulse signal.
Version	-	-	-	Software version information, V refers to version. 1: indicates version number. 0: indicates version level.

Step 2 Input password "1212", press  to enter system parameter setting page, as shown in Figure 2-9.


SYS PARA		1/ 1PG
X-digits:		1
Y-digits:		2
X-safe:		10.0
Y-safe:		5.00
Step delay:		0.5
✎ Range: 0~3		

Figure 2-9 System parameter setting page

Step up parameter, parameter setup range is shown in Table 2-6.

Table 2-6 System parameter setup range



Parameter Name	Unit	Range	Default	Remarks
X-digits	-	0~3	1	Decimal point displayed by X axis position parameter
Y-digits	-	0~3	2	Decimal point displayed by Y axis position parameter
X-safe	mm	0~9999.999	10	X axis keeps low speed in this range
Y-safe	mm	0~9999.999	5	Y axis keeps low speed in this range
Step delay	s	0~99.99	0.5	Interval between valid change step signal and change step operation executed

Step 3 Press , return to programming constant page.

---End

2.4 Manual movement








In single-step mode, axis movement can be controlled by pressing key manually. This method helps user to adjust machine tool and work piece.

Step 1 On single step parameter setup page, press  or  to enter manual page, as shown in Figure 2-10.



MANUAL	
X:	9875.965
Y:	9875.123
✎ X current pos.	


Figure 2-10 Manual page


- Step 2** Press , operate at low speed in increasing direction.
 Press , operate at low speed in decreasing direction.
 Press , press  at the same time, and operate at high speed in increasing direction.
 Press , press  at the same time, and operate at high speed in decreasing direction.
- Step 3** Press  return to single step parameter setting page.

---End

Chapter 3 Alarm

The device can detect internal or external abnormality automatically and send out alarm prompt. Alarm message is available on alarm list.

Step 1 On programming management page, press  to enter programming constant page.

Step 2 On programming constant page, press  to enter "Alarm history" page to view all alarm history.

As shown in Figure 3-1, the latest 6 alarms, alarm number and causes can be viewed on this page.

ALARM RECORD	
A.24	Mach. Not read

Figure 3-1 Alarm history page

Alarm history and message is shown in Table 3-1.

Table 3-1 Alarm number and alarm message

Alarm number	Alarm name	Alarm description
A.01	Count reached prompt	Count reaches preset value
A.02	XPos < minimum	X position value is less than minimum value
A.03	XPos > maximum	X position value is more than maximum value
A.04	YPos < minimum	Y position value is less than minimum value
A.05	YPos > maximum	Y position value is more than maximum value
A.06	X out of lmt.	X position value is out of the limited value.
A.07	Y out of lmt.	Y position value is out of the limited value.
A.11	Count reached shut-down	When count reaches preset value, system shut down automatically.
A.12	Beam is not on upper dead point	In single step and multistep mode, slider is not on upper dead center.



Alarm number	Alarm name	Alarm description
A.13	X Un-teachIn	Reset the teach function of X-axis
A.14	Y Un-teachIn	Reset the teach function of Y-axis
A.21	Oil pump not started	Oil pump signal loss
A.22	Encoder failure	Encoder voltage is too low.
A.25	Drive mode err	Neither the drive mode of X-axis and Y-axis is double-frequency converter, please check it.
A.41	Parameter storage error	-
A.42	Abnormal power failure	-
A.43	System self-checking error	-

---End



Appendix Common fault and troubleshooting

Fault phenomena	Trouble shooting
When power on, the device will not display.	<ul style="list-style-type: none"> • The electrode of power supply terminal is connected error; please see the information of power nameplate. • Voltage is too low. • Electrical outlet is not connected.
When X axis programming is operating, the back gauge motor does not move, but Y AXIS motor moves.	Two motors are reversed. Reconnect.
When program is operating, motor does not move.	<ul style="list-style-type: none"> • Check whether mechanical part has been locked or slider returns to upper dead center. • Check whether the motor wiring is connected well.
Motor can't switch from high speed to low speed.	<ul style="list-style-type: none"> • Check whether high-low speed signal has been sent or motor power is too small. • Check whether the parameter of distance conversion is correct.
When the device is in multi-step programming, the program can't change step.	Check when slider is on upper dead center, START terminal is connected to +24V or not.
When the device is in multi-step programming, the program can't count.	Check when slider is on upper dead center, START terminal is connected to +24V or not.
When programming is operating, the device loses control.	<ul style="list-style-type: none"> • Check whether encoder cable is connected or not. • Check whether the motor-direction wiring is correct (X+, X-, Y+, Y-).
When programming is operating, the device actual position will not display or change.	Check whether encoder wiring is correct or encoder cable is connected well.



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