

# Guillotine

## ESTUN E21S Controller Operation

**SINGLE:** Common page that is used by anyone who wants to re-write a job.

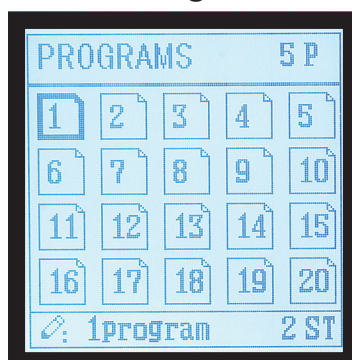


- X** - (X Back gauge actual position)
- XP** - (X Program Position) - Back gauge distance from the blade
- DX** - (Distance of Back Gauge Retraction) - Amount the back gauge will retract when cutting
- PP** - (Program Pieces) - Number of pieces to be cut
- DLY** - (Delay Retraction) - Time delay in seconds for the back gauge to retract when cutting
- CP** - (Completed Pieces) - Amount of pieces that have been completed
- TMR** - (Timer) - Set timer to ensure material cuts all the way through - Approx. 1 sec = 600mm

**Operation:** With XP highlighted, type 100 and press the enter button. Continue the same process until all parameters have been entered and then press green program start button. The controller will now find X position. Once it has found position you can start cutting material.

**Example:** This job will cut 100mm. There is no retraction and no delay. There are 4 pieces to cut and 0 pieces have been completed so far. The blade will travel approximately 1200mm.

### PROG: Program management page



This page gives access to all the saved programs, there are 40 programs and ability to save 25 steps for each program.

**Operation:** Press the **P** (program button) until Program management page has been located. Enter 1 and press enter, this will take you straight to the Product Information Page for program No-1.

## PROG: Product Information page



| PROGRAM1    |      |
|-------------|------|
| ST:         | 2    |
| PP:         | 5    |
| CP:         | 4    |
| DLY:        | 1.00 |
| TMR:        | 3.00 |
| Range: 0~25 |      |

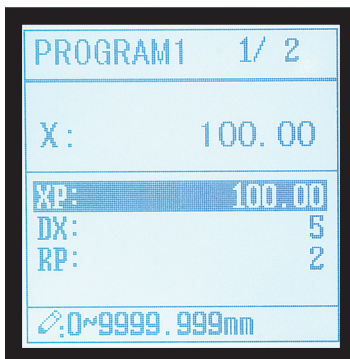
This page lets you enter parameters for the pieces to be cut.

- ST** - **(Steps)** - How many different length pieces to be cut in 1 program
- PP** - **(Programmed Pieces)** - Number of pieces to be cut
- CP** - **(Completed Pieces)** - Amount of pieces that have been completed
- DLY** - **(Delay Retraction)** - Time delay in seconds for the back gauge to retract when cutting
- TMR** - **(Timer)** - Set timer to ensure material cuts all the way through - Approx. 1 sec = 600mm

**Operation:** With ST highlighted type 2 and press the enter key, this will save parameter and PP will then be highlighted. Continue until all desired parameters have been entered.

**Example:** This program has 2 different length pieces to be cut and is repeated 5 times. 4 pieces have been cut, the back gauge has a 1 second delay and the blade has a cut width of 3 seconds.

## PROG: Bend information page



| PROGRAM1 1/ 2       |        |
|---------------------|--------|
| X:                  | 100.00 |
| XP:                 | 100.00 |
| DX:                 | 5      |
| RP:                 | 2      |
| Range: 0~9999.999mm |        |

This page lets you enter information for each individual cut.

- X** - **(X Back Gauge - actual position)**
- XP** - **(X Program Position)** - 100mm back gauge distance from the blade
- DX** - **(Distance of Back Gauge Retraction)** - 5mm back gauge retraction
- RP** - **(Repeat)** - This cut will be repeated 2 times

**Operation:** With X highlighted, type 100 and press the enter button. Continue the same process until all desired parameters have been entered. Once all cuts have been completed press arrow across and enter parameters for step 2.

**Example:** Program 1 has 2 steps and step 1 will be repeated before program moves to step 2.