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# One、 software problem

1 Error code in the device connection:...

Try connect      ErrorCode: 20008

Error code in the device connection: 20008: Unknown network on the connection

Try connect      ErrorCode: 1

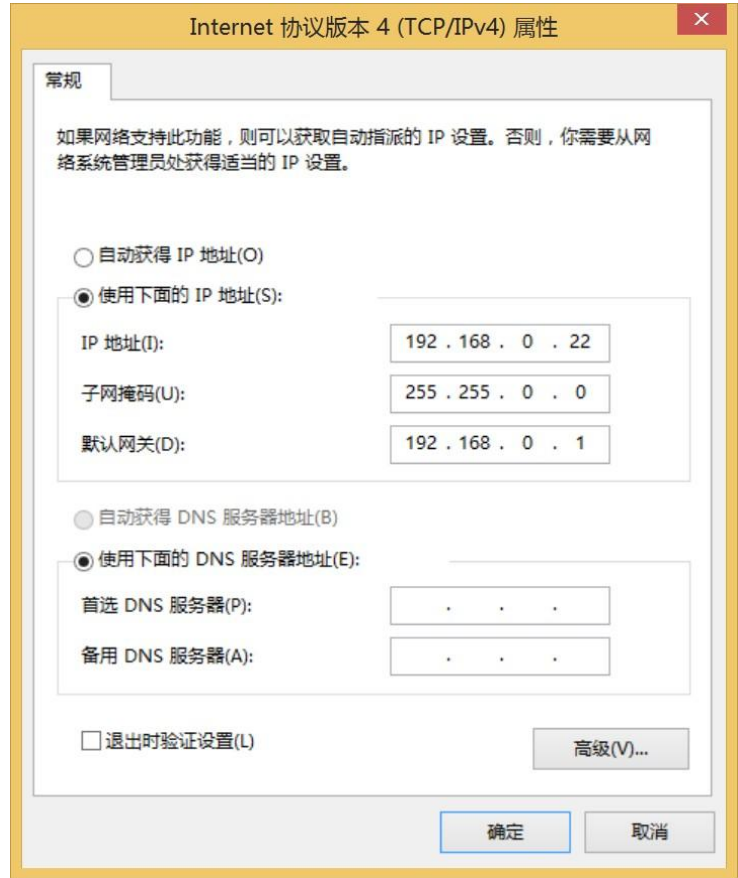
Error code in device connection: 1: no network connection

Try connect      ErrorCode: 3402

Error code in device connection: 3402: Network connection lag

The specific situation of the machine is different, no error code to exclude the reason according to the following method. The error code is just a reference.

(1) Check whether the computer local connection (Ethernet) ip address is correct, as shown in the figure. (Error code 20008)



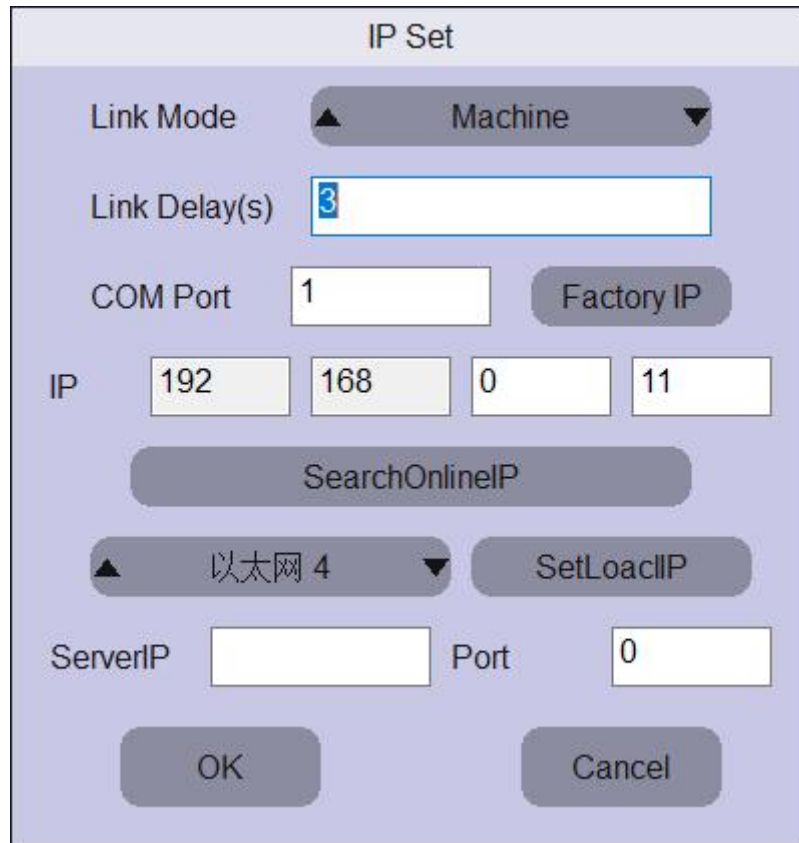
(2) Check whether the equipment is powered on, the card and the switch is powered on. Is the network cable plugged in properly. Whether the dual system switches to the edge patrol system. (Error code # 1)

(3) Check whether the local connection status shows that the network cable is pulled out or not connected. If displayed, check the network cable, switch, and computer. (Error code 1, error code 3402)

(4) Check whether the equipment is powered on, the card and the switch. Is the network cable plugged in properly. Whether the dual system switches to the edge patrol system. (Error code # 1)

(5) There are other usb wireless network receiver conflicts on the computer. (Error code 20008)

(6) Open the software device IP setting, and change the simulation mode in the connection mode to LY-C68 or machine mode. (Error code 20008, error code 1)



(7) Open the IP setting of the software device, and search for the IP to see whether the results are consistent with the IP address in the IP setting or in conflict with the local connection ip address of the computer. (Error code 20008)

(8) Plug the board card network cable directly into the computer, and observe whether it can be connected to the machine. Replace the switch, if possible. If not, replace the better quality network cable to try, try a few more. If no computer replacement. Still can not replace the board card. (Error code 20008, error code 3402, error code 20010)

(9) If the software is stuck after opening the ccd interface, and to display the device connection, you need to replace the better quality

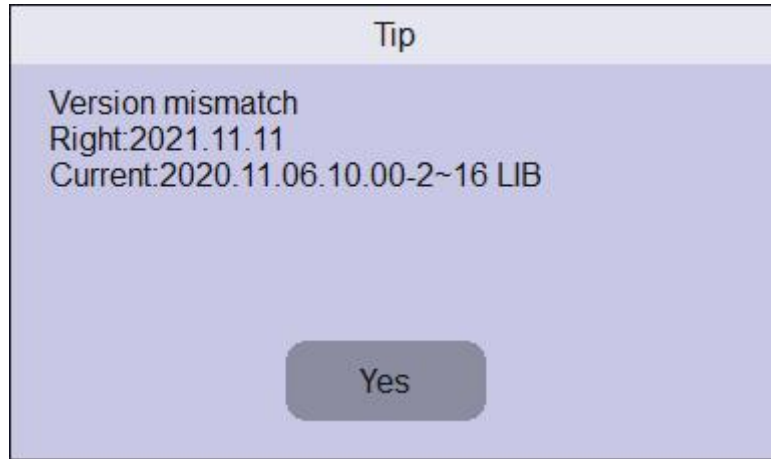
network cable or switch or even the computer. (Error code 3402, error code 20008)

(10) Software poisoning, software deletion and reinstallation.

(11) If you open the software to repeatedly display the device initialization and finally in the display device connection, the software closes, and then reopen the software guide parameters. (Old software requires force import parameters: hold Ctrl + Alt + F3 during device initialization to enter the import parameter interface)

**Init device**

## 2 System mismatch, please device upgrade or version mismatch



(1) Click OK to enter the device upgrade interface, open the corresponding version of the software folder, and open the Mac\_Update.zar document. (Do not close this error reporting interface, you must click OK.)

(2) Error after equipment upgrade, please upgrade firmware.

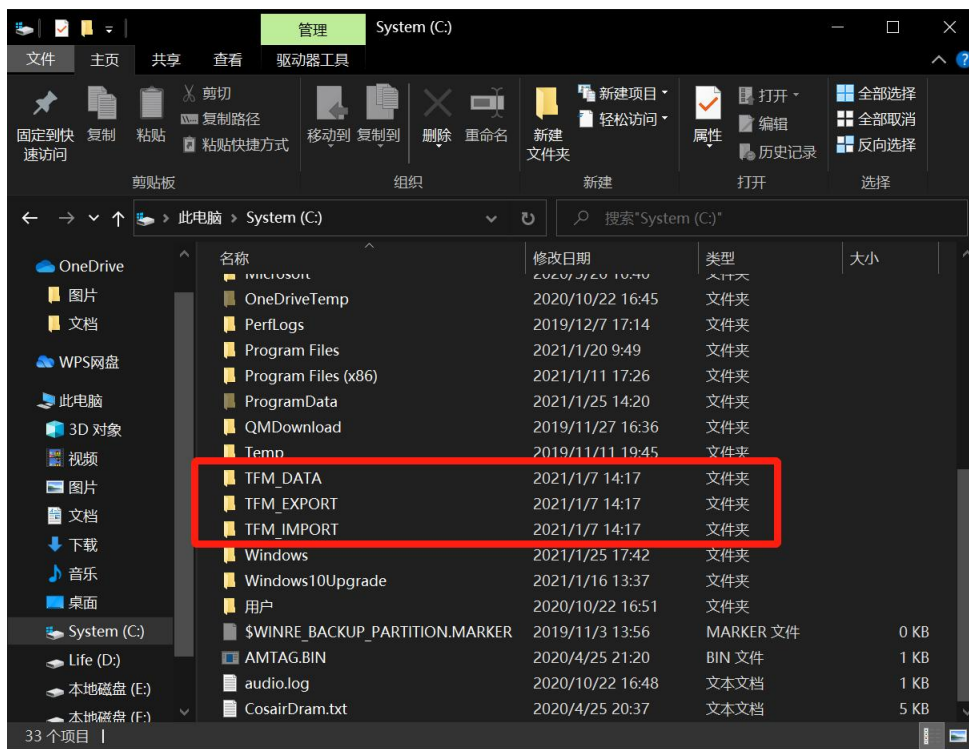
### 3 Open the software flash back or the interface display is incomplete

(1) Close the software, open the computer C disk, and delete the three folder of TFM\_DATE, TFM\_EXPORT, and TFM\_IMPORT files.

(2) Close the software, open the software folder, and delete the FH\_PROJECTOR. CFG document.

(3) Reload the software, and then delete the computer C disk TFM\_DATE, TFM\_EXPORT, TFM\_IMPORT three folders.

(4) Reinstall the computer system, or replace the computer.

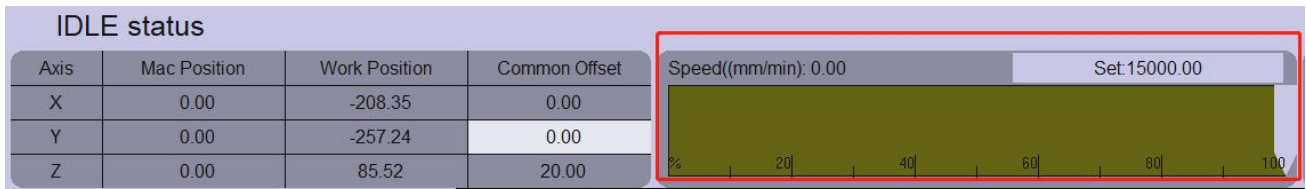




## Two、 machine problem

### 1 The machine cannot be moved

(1) Whether the 3 D carving interface speed feed bar is drawn to the minimum.



(2) Software and equipment upgrade.

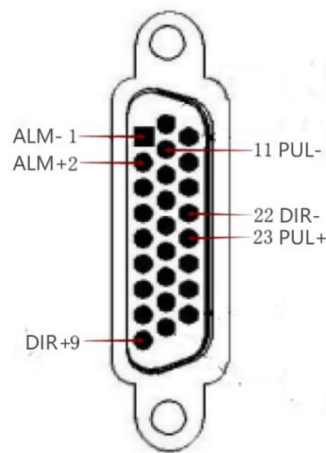
(3) Whether the software has any parameters.

(4) The axial parameter pulse equivalent is not correct and too small, and the dynamic low speed value of each axial point is 0 or very small, which is not easy to detect.

Axis Parameter					
Set	System	Tool	Axis	IO	Carve
	ID	Name	Value	Limits	Effect
	005	Rotation Direction	2	[0,1024]	Home again
X	006	Units	166.925 pulses	[1,50000]	Home again
	007	Max_Frequency	800000 pulses	[100,8e+006]	Immediately
Y	Home				
Z	001	Homing Mode	0	[0,1]	Immediately
	002	Homing Priority	0		Immediately
A	003	Homing Direction	4	[3,4]	Home again
	004	Homing Position	0 mm		Home again
	005	Homing Port	0	[-1,99]	Home again
	006	Homing Offset	2 mm		Home again
	007	Homing High Speed	50 mm/s		Immediately
	008	Homing Low Speed	10 mm/s		Immediately
	009	Homing Accel	300 mm/s <sup>2</sup>		Immediately
	010	Homing Jerk	0 ms	[0,250]	Immediately
	011	Homing Waiting time	0 ms	[0,3000]	Immediately
	012	Check Homing Signal	0	[0,5]	Immediately
	013	Second Home	0		Home again
	014	Second Homing Direction	4	[3,4]	Home again
	015	Second Home Port	-1	[-1,99]	Home again
	016	Second Home OUT	-1	[-1,99]	Home again
	017	Second Homing Offset	0 mm		Home again
	Speed				
	001	Jog High Speed	300 mm/s		Immediately
	002	Jog Low Speed	80 mm/s		Immediately
	003	Jog Accel	600 mm/s <sup>2</sup>		Immediately

(5) Open the tool and move the machine to see whether the axis coordinates have changed. There are change check circuit problems. Mainly view the welding line between the drive pulse line to the card DB head.

(6) The machine moves only in one direction to check the circuit problems. Mainly view the welding line between the drive pulse line to the card DB head.



(7) The dual-system machine is not changed to the CCD edge patrol system, or the relay is damaged.

## 2. The machine moves in the opposite direction

(1) The axis running direction is opposite, so the rotation direction parameter in the axis parameter should be modified and set in the middle of 0-3. (If 0 changes to 2, and 2 changes to 0. If 1 changes to 3, 3 changes to 1. )

### 3 Back to zero anomaly

First, upgrade the equipment

(1) Opposite of return to zero direction:

You need to modify the zero direction inside the axis parameter, with X and Y axes returning to 4, and Z and W axes changing the direction to 3.

The rotation direction is set in the middle of 0-3. (If 0 changes to 2, and 2 changes to 0. If 1 changes to 3, 3 changes to 1. );

The I0 parameter corresponds to the port polarity set error, the limit polarity set to 2 and set to 1.

(2) Zero return to the occurrence of the collider:

Open the I0 test to check whether the origin signal can effectively trigger, can not trigger the check line, and replace the limit.

Check whether the return zero speed of the shaft parameter is set too fast and reduce the speed appropriately.

Check whether the axis parameter back to the zero port is set correctly, according to the I0 test.

Whether the axis parameter back to zero offset is set correctly, the default is 0.

Whether the I0 parameter corresponds to the IN port parameter status is on,

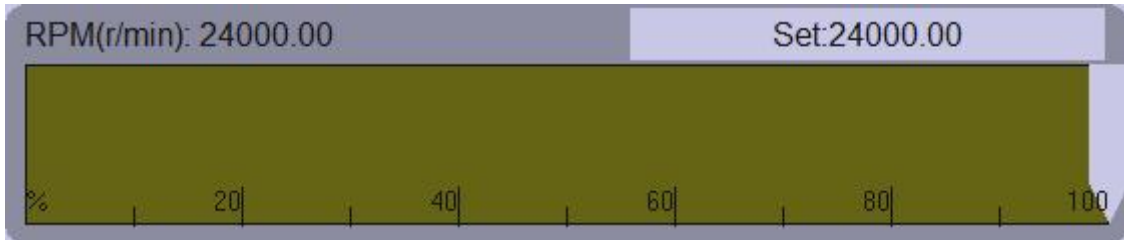
Check that the wiring is correct.

(3) Always be prompted to return to zero:

Check if the coordinates change, if there is a change, open the I0 test to check whether the origin signal can be effectively triggered.

## 4 The spindle does not rotate when cutting

(1) Whether the 3 D carving rotation speed feed bar is drawn to the minimum.



(2) Check whether the state of the IO parameter A OUT analog output port is turned on to 1.

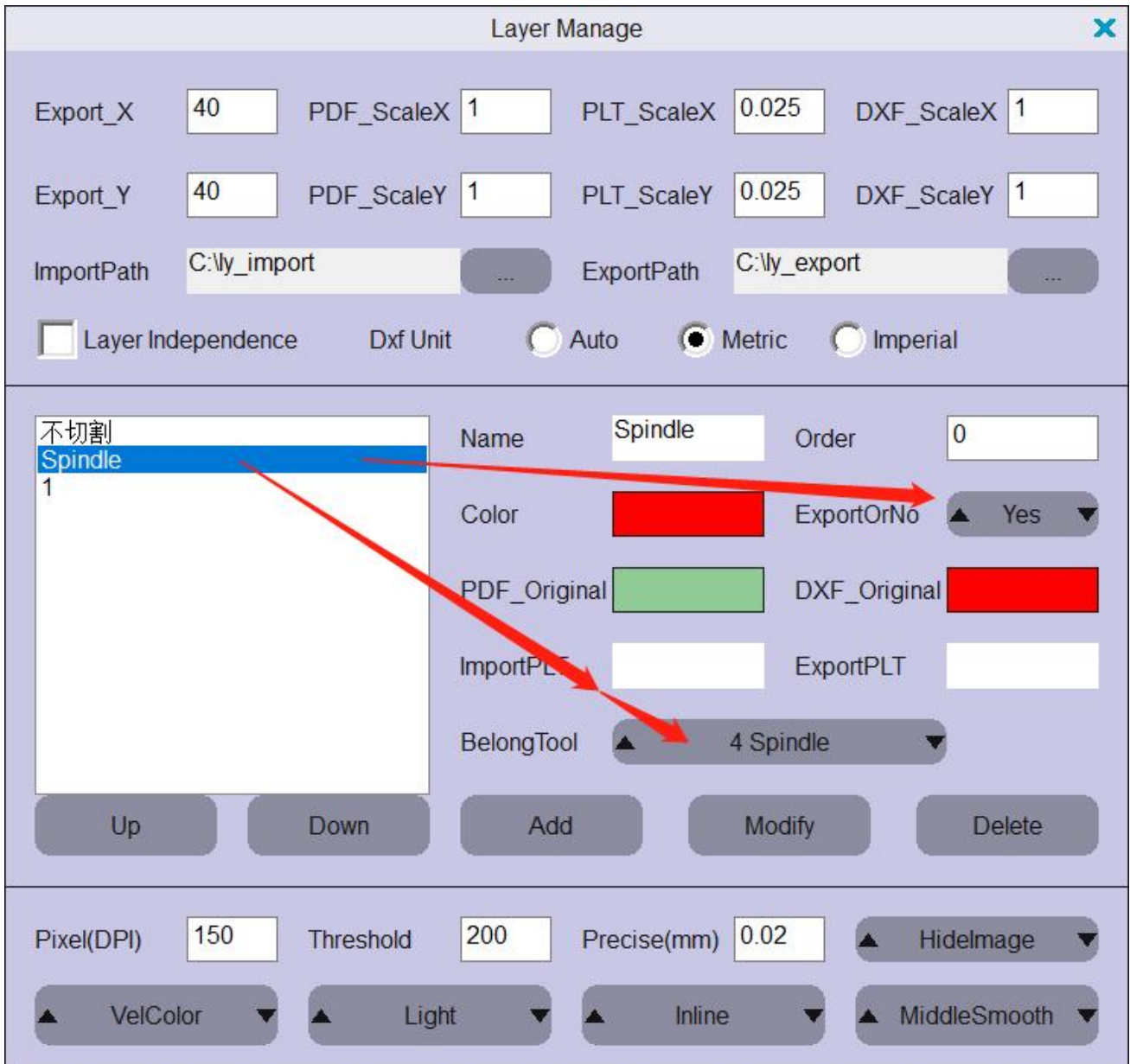
IO Parameter					
Set	System	Tool	Axis	IO	Carve
	ID	Name	Value	Limits	Effect
	AOUT0				
IN	001	Status	1	[0,1]	Immediately
	002	Scale	5.85	[1e-006,1e+007]	Immediately
OUT	003	Minimum	0		Immediately
	004	Maximum	42000		Immediately
AOUT	005	Opening Delay Time	1000 ms	[0,100000]	Immediately
PUMP	006	Closing Delay Time	3000 ms	[0,100000]	Immediately

(3) Check whether the OUT (default OUT 11) port state of the IO parameter spindle is open to 1.

(4) Check whether the spindle "output port" of the process parameters corresponds to the board card out port.

(5) Equipment upgrade of the software.

(6) Whether the spindle output in the layer is open.



(7) Correct whether "output enable is on" is checked.

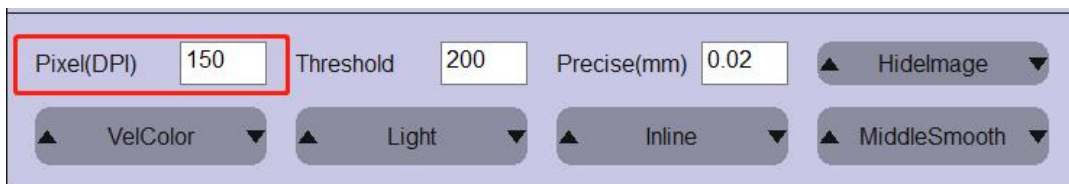
## Three、 map problem

### 1 Import the JPG, TIF bitmap dimension problem

#### (1) Wrong drawing dimensions:

Layer management resolution (DPI) is inconsistent with the resolution (DPI) of imported pictures;

The mapping software exports the file as not millimeter or inch.



#### (2) The graphic size and lines are not smooth enough:

The optimization option is set to 0.1 or 0.2, and the gray threshold is appropriately adjusted small;

Redraw it in HD.

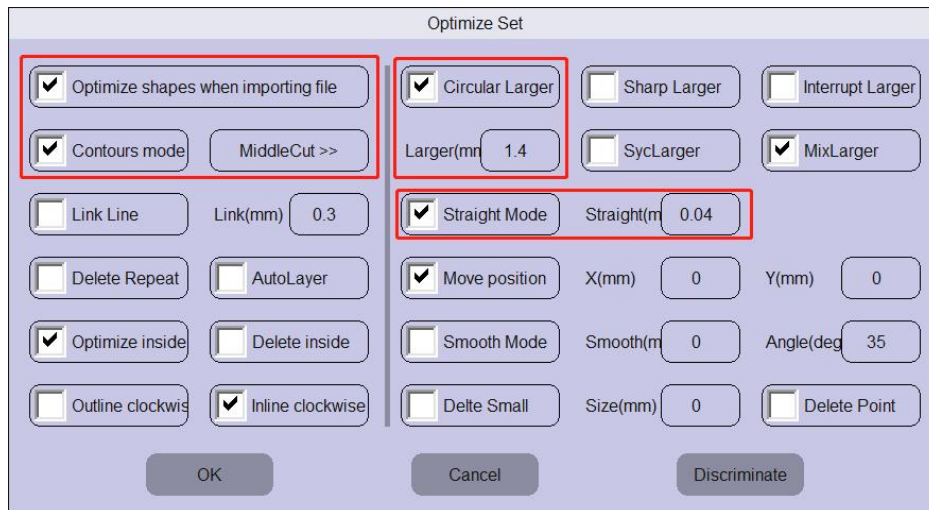
#### (3) Misfigure:

Gray scale threshold is too small, the normal value is between 200-250;

The spacing between files and drawings is small or too small (the spacing must be greater than twice the expanded edge or the diameter of the tool);

Layer management changes to be low or not smooth. The optimization option is too large.

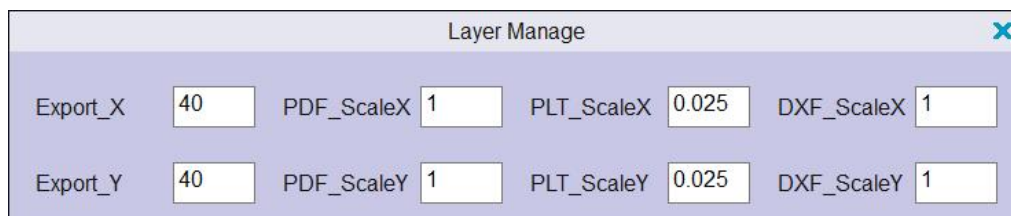




## 2 Import DXF, PLT vector graph problems

(1) The unit of the exported DXF vector diagram is wrong, and the exported unit should be mm.

(2) The PLT import size stretch, and the layer management PLT-X and PLT-Y parameters are set to 0.025.



## 3 Unable to import the drawing

(1) Bit map (JPG, TIF) fills the non-cut white figure area with other colors;

Vector diagram (DXF, PLT) to delete the uncut graphics;

(2) Layer management resolution (DPI) is inconsistent with the imported image resolution (DPI);

(3) Re-map it in HD.

## Four、fold CCD cutting problem

### 1 Cut figure leakage edges

(1) If the white edges are uniform, the offset value can be changed at the actual offset distance according to the correction CCD interface.

(2) Check whether the offset value is set correctly, and correct the selection tool cross test.

(3) Check the flatness of the equipment table.

(4) Check the diagonal line of the equipment.

(5) Do the cross test at the 4 corners of the equipment, first correct the cross test at the lower left corner of the equipment, and then do the test at the other 3 corners of the equipment respectively. If the other 3 cross tests are inconsistent, please check for the gap of the equipment X axis or the assembly of the equipment beam.

(6) The graphics are white around, and the optimization options are too large.

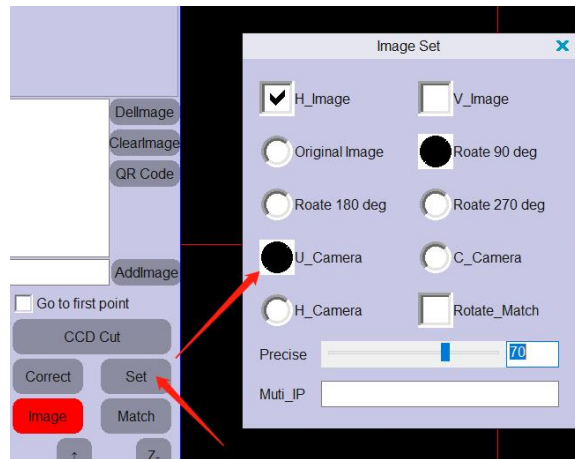
(7) Please use hd pictures for UV printing. There are virtual pixel edges in low pixel pictures, so the expanded edge expansion value of the optimization option can be reduced appropriately.

(8) Check the perpendicularity of the spindle and camera of the equipment.

## 2 Open the CCD and display the black screen

(1) Remove the dust cover on the lens; check the camera lens exposure to a minimum.

(2) The CCD setting camera is checked correctly (select: common camera or Medway camera).



(3) Whether the camera drive is installed. Camera drive is poisoned, reinstalled.

(4) Camera driver installation is not successful (camera driver installation, please close the anti-virus software and firewall).

(5) Check whether the equipment is powered on, the camera and the switch. Is the network cable plugged in properly.

(6) Check whether the local connection status shows that the network cable is pulled out or not connected. If displayed, check the network cable, switch, and computer network port.

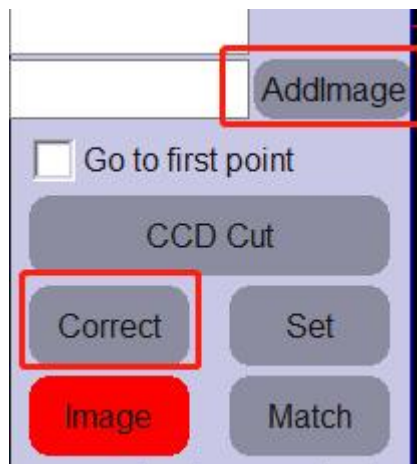
(7) Camera default IP cannot be used, need to manually set the camera IP (demonstration program right-click attribute-open file location-open folder TOOLS-double click open Gigabit network camera

settings-left click dialog box upper left camera-lower right corner set camera IP, secondary IP cannot be with local connection and card IP conflict-change click Update IpAddress to save set IP).

(8) Camera damage. Replace the camera.

### 3. The C C D interface operation problem

(1) Right-click the movement direction and distance in the CCD display interface, and CCD fine-tuning movement distance is abnormal: CCD is required to increase the template calibration.



## 4 The C C D localization cut has failed

### First, upgrade the equipment

(1) Failure of image matching: there is no template increase or the template contrast difference. It is recommended to adjust the light to increase the template again or add the template again at different positions. The positioning point is too aside, resulting in the surrounding environment of the cutting plate leakage is too much black

(2) No printable figure: figure not check layer color not check output, check that the layer management associated hardware is consistent with the name; if the software exceeds the set range (yellow frame), press the keyboard HOME key to close to the coordinates, whether the plate display exceeds the limit; the offset value is not set correctly.

(3) Failed to set the print head information: the graphics in the software is beyond the set range (yellow box), and the plate placement exceeds the limit. Whether the software is poisoned, reinstall the software.

(4) The machine does not move after the completion point: the equipment upgrade is required.

(5) The machine does not move when finding the point: the pulse equivalent value of X and Y axis parameters is too small. (More than 120).

(6) When finding the point, the machine ran over or did not reach the positioning point: the camera recalibrates, check whether the drawing in the software is consistent with the actual injection drawing size, and whether the direction of the imported drawing is consistent with the direction of the material. Picture resolution (DPI) is consistent with the resolution (DPI) in layer management.

(7) CCD moving point 1 fails: the positioning point is too close to the limit switch, the equipment cannot move during automatic calibration, and the material needs to be moved to a certain position; during the positioning calibration, the equipment cannot move, check the equipment and drive; the pulse equivalent of X and Y axis parameters is too small (requiring pulse equivalent above 120).

(8) The CCD moving data is less than the minimum (large) X (Y) axis value. The material is too pulled aside and beyond the travel of the machine. Wrong anchor point order.

## 5 Cut abnormal

(1) Cutting arc Angle speed is very slow or very fast: change the process parameters of small circle radius, small circle speed, minimum small circle speed. (Typical speeds are 10mm, 80 mm/s, and 20 mm/s, respectively.)

Tool Parameter					
Set	System	Tool	Axis	IO	Carve
ID	Name	Value	Limits	Effect	
Speed					
4 Spindle	001	Stop Angle	40 deg	[0,180]	Immediately
	002	Deceleration Angle	10 deg		Immediately
5 CCD	003	Radius	10 mm		Immediately
17 三维雕刻	004	Circle Speed	80 mm/s		Immediately
	005	Minimum Circle Speed	20 mm/s		Immediately
	006	NoLift Speed	0 mm/s		Immediately
	007	Z Lifting Speed	40 mm/s		Immediately
	008	Z Down Speed	20 mm/s		Immediately
	009	Automatic Speed	100 mm/s		Immediately
	010	Automatic Accel	400 mm/s <sup>2</sup>		Immediately
	011	Automatic Jerk	30 ms	[0,250]	Immediately

(2) Vibrator knife and pneumatic knife cutting cutting lifting:

The stop angle of the process parameters is reduced. (Usually 35° -40° );

Process parameters The Z-axis knife lifting mode is changed to 0.

(3) Vibrating knives and pneumatic knives are cut too frequently:

The stop angle of the process parameter is changed greatly. (Usually 35° -40° );

Graphic nodes are not smooth and improve graphics quality. (See three map problem for details)