


## Manual Pad Test

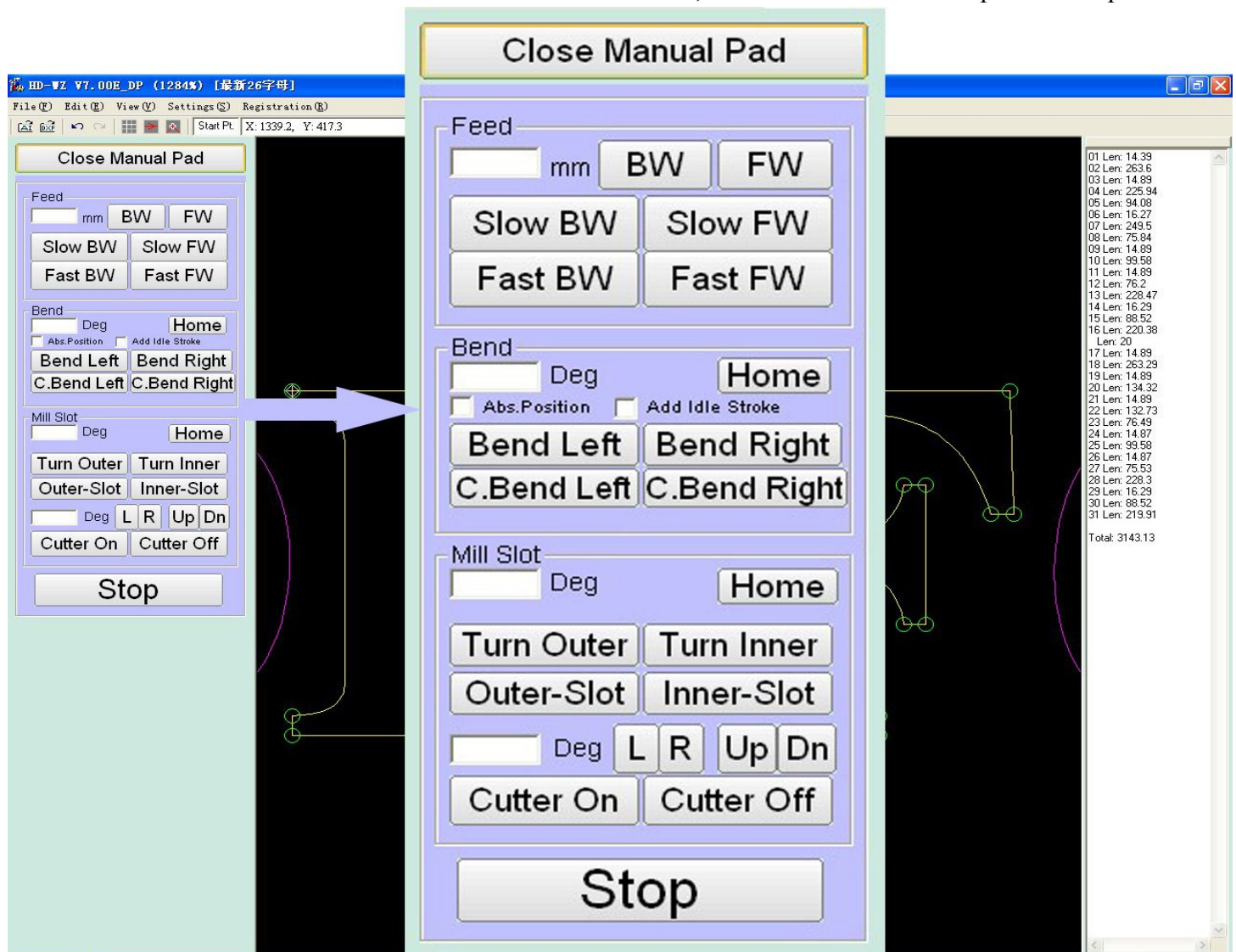
After finish install of the machine, you need to test the machine motions to check if the machine work properly. Here the manual Pad help you to do the testing.

### Manual Pad Introduction:

Use for machine test and adjust.

There are three functions here to finish machine test and adjust. Feed, Bend and Mill Slot.

Click Close Manual Pad , could switch the manual pad to auto pad.



### Feed



mm **BW** **FW**
**BW**-Backward, **FW**-Forward.

Input any value to feed the material according the input value. If without any value input, the material can not move even you click **BW** or **FW**. For example, if input 500mm, and then click **FW**, the material will feed forward 500mm.

 **Slow BW** **Slow FW**
**Slow BW**-Slow Backward, **Slow FW**-Slow Forward.

Click **Slow BW** or **Slow FW**, the material will feed randomly in slow speed. Here no need to input any value.

 **Fast BW** **Fast FW**
**Fast BW**-Fast Backward, **Fast FW**-Fast Forward.

Click **Fast BW** or **Fast FW**, the material will feed randomly in fast speed. Here no need to input any value.

## Bend

Bend

 Deg **Home**  
☐ Abs.Position ☐ Add Idle Stroke  
**Bend Left** **Bend Right**  
**C.Bend Left** **C.Bend Right**
 Deg **Bend Left** **Bend Right**

**Bend Left**- In put any value, the Bending Device will bend the material in anti-clockwise direction accordingly. **Bend Right**-In put any value, Bending Device will bend the material in clockwise direction.

 **C.Bend Left** **C.Bend Right**

**C. Bend Left**-Continuously Bend Left.**C. Bend Right**-Continuously Bend Right.

Click **C.Bend Left** without stop, the bender device will bend the material continuously in anti-clockwise direction. Click **C.Bend Right**, the bender device will bend the material continuously in clockwise direction.

 **Home**

Click **home**, the bender device will come back its home position(home position is the starting position of the bender device working)

## Mill Slot

Mill Slot

 Deg **Home**  
**Turn Outer** **Turn Inner**  
**Outer-Slot** **Inner-Slot**  
 Deg **L** **R** **Up** **Dn**  
**Cutter On** **Cutter Off**
 **Turn Outer** **Turn Inner**
**Never Click here.**

**Outer-Slot** **Inner-Slot**

**Outer-Slot**-Click Outer Slot to test the cutting height of the material in outer bending direction.

**Inner Slot**-Click Inner Slot, the blade will cut 45 degree along the whole wide of the material. Input any value more than 45, the input degree will be slot(cut) here.

**Cutter On** **Cutter Off**

Click **Cutter On**, the blade will work and click **Cutter off**, the blade stop work.

Deg **L** **R**

, **L**-Left. **R**-Right. Input any value, then click **L**, the blade set will turn left accordingly.

**Home**

Click Home, the blade set will come back its home position(home position is the starting position of the blade set working).

**Up** **Dn**

Don't click **up** and **dn(Down)**. Once you click **up** and **Dn**, please close software and machine and then open them again.