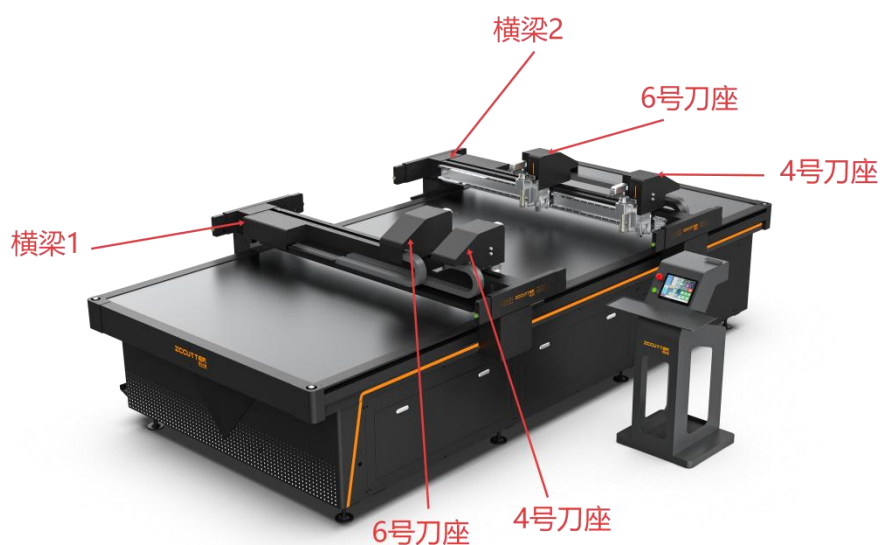


ZCRB 双梁四刀机型使用说明

ZCRB Dual Head Mobility Model User Manual

双横梁四刀座，有两个横梁，每个横梁上面有两个安装刀头的刀座，可同时装置四把刀头同时切割，切割效率是普通机型的四倍，同一个横梁上的两把刀只能切割同样的图形产品，两个横梁可以切割不一样的图形，两个横梁分别为横梁 1 和横梁 2，横梁上两个刀座的代号为 4 号刀座跟 6 号刀座，

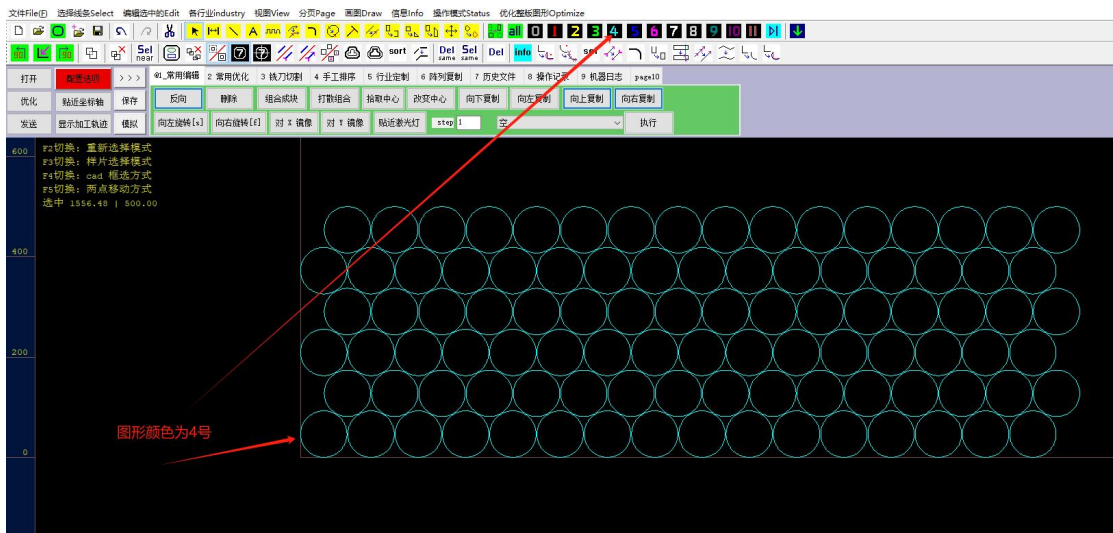
The dual head interchangeable model has two separate tool holders. According to the requirements, two tool heads can be installed for simultaneous cutting, or one tool head can be replaced with another tool for multifunctional processing. The two tool holders are divided into left tool holder and right tool holder, with the left tool holder numbered 6 and the right tool holder numbered 4



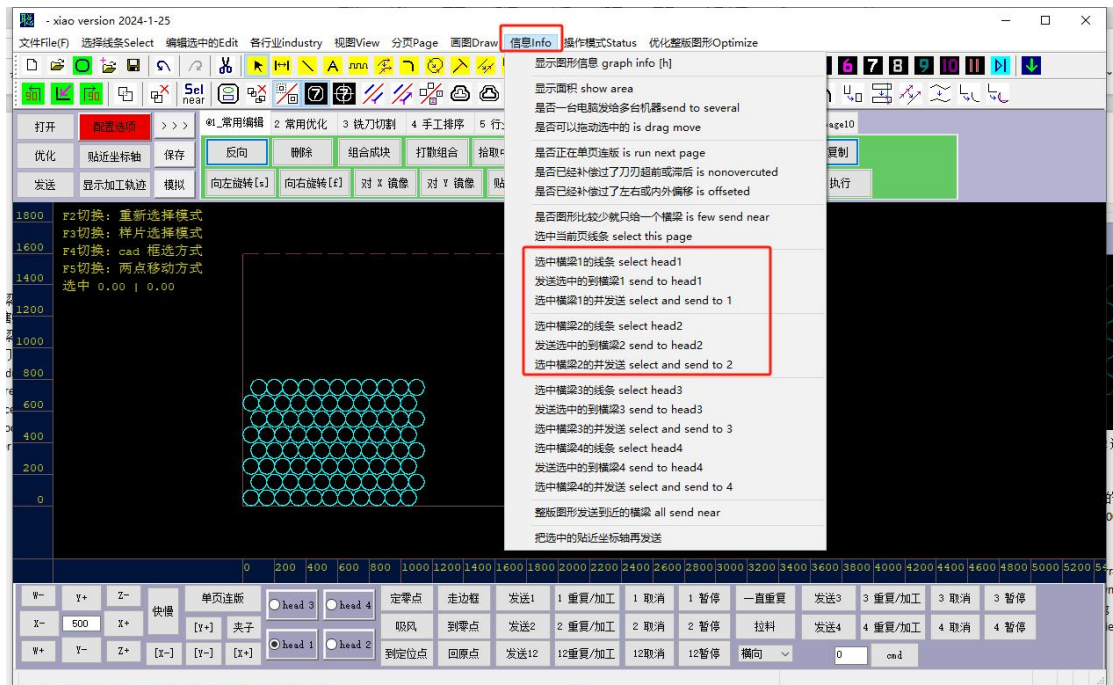
3、双梁四刀怎么做文件 How to make files with double knife mutual movement

双梁四刀有好几种加工方式，需要在制作图形时，使用不同的颜色来区分，如果只需要用一个横梁中的一把刀进行加工，把线条的颜色改成 4 号即可，如下图

There are several processing methods for double knife mutual movement, and different colors need to be used to distinguish when making graphics. If only one knife is needed for processing, change the color of the lines to No. 4, as shown in the following figure

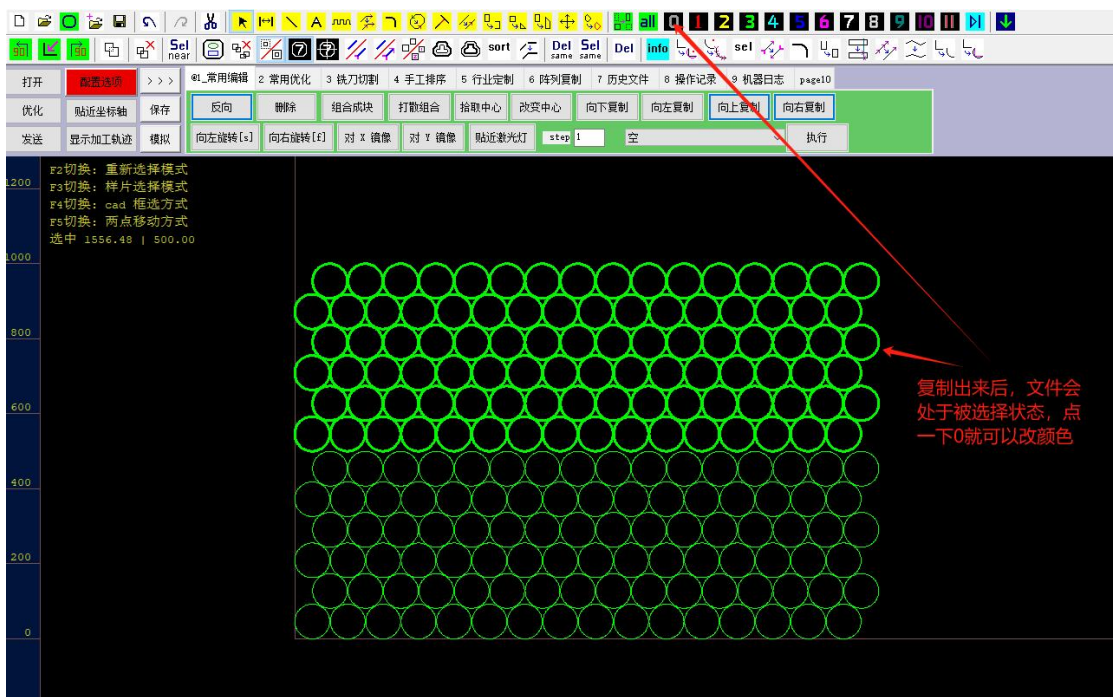
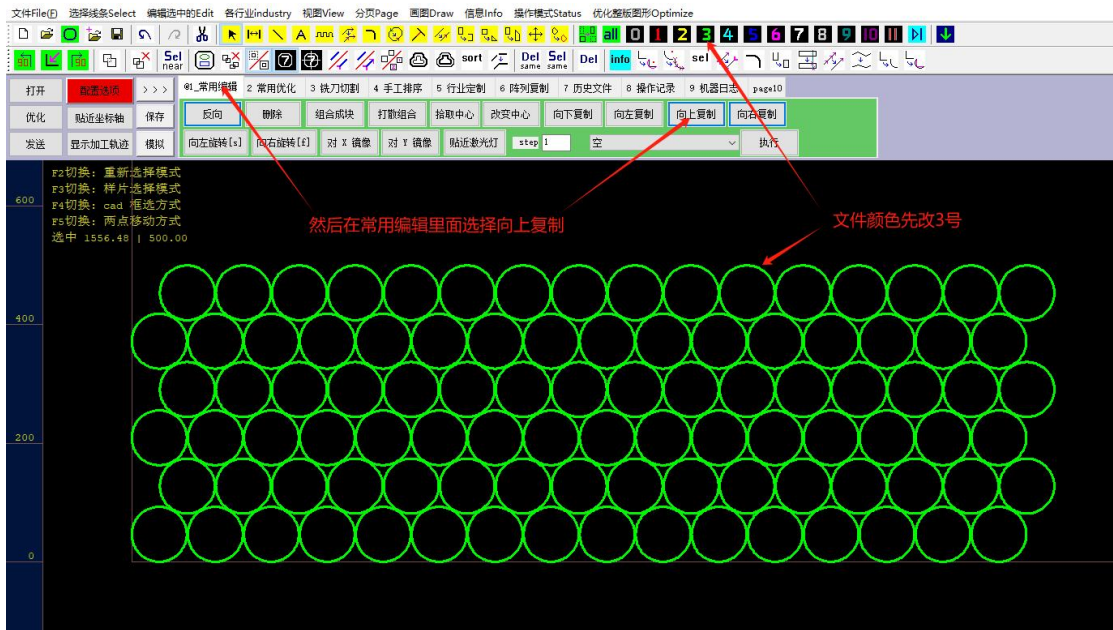


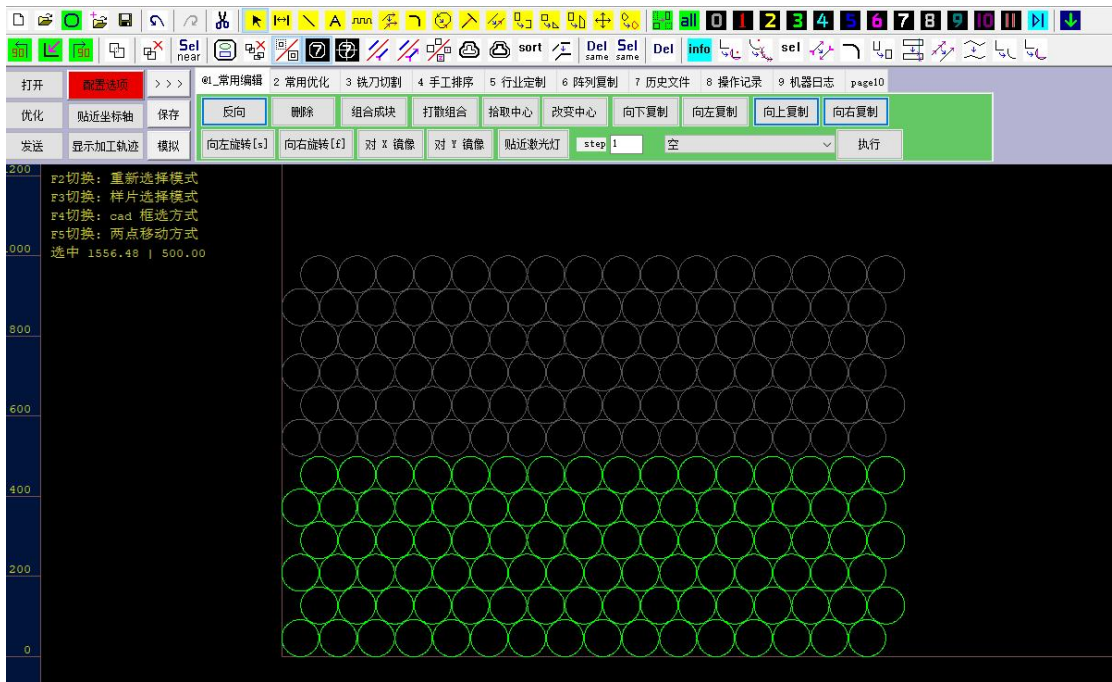
文件做好之后框选图形，在图形信息里面可以选择发送到横梁 1 或横梁 2 进行加工



如果需要一个横梁两把刀同时加工，我们在文件排版的时候，只需要按照材料宽度的一半来进行排版，然后整体复制一下即可，如下图，材料宽度为 1000mm，需要先按照 500mm 的宽度排版文件，然后图形颜色改 3 号，再复制一遍，复制出来的图形改成 0 号

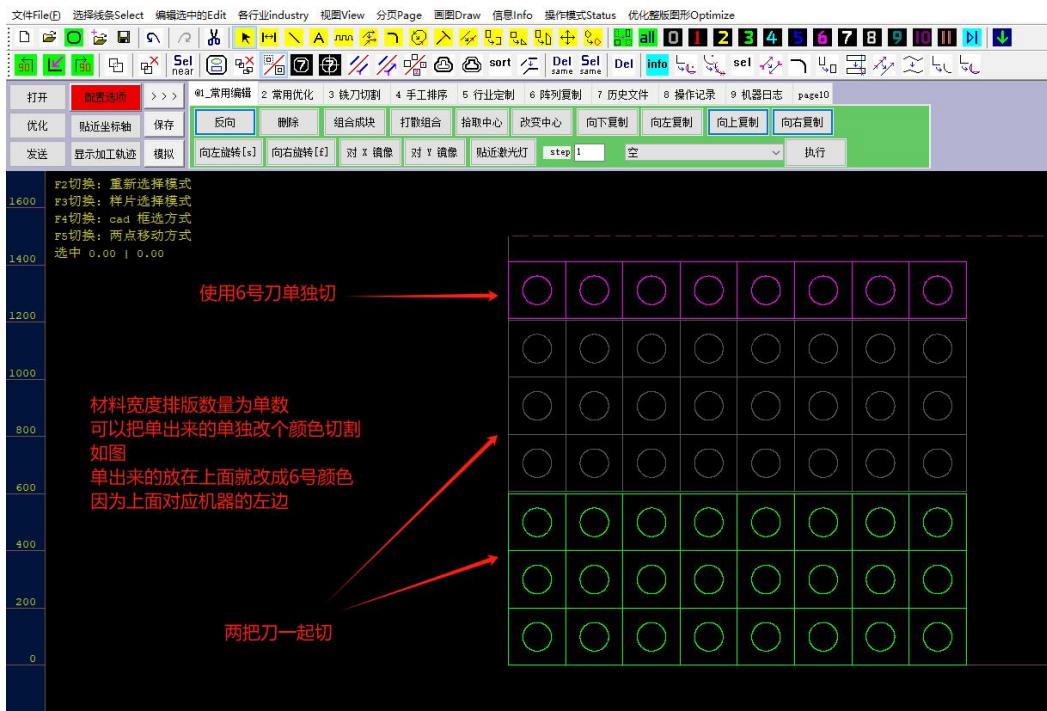
If two knives are needed for simultaneous processing, we only need to arrange the file layout according to half of the material width, and then copy it as a whole, as shown in the figure below. The material width is 1000mm, and the file needs to be arranged according to a width of 500mm first, then the graphic color should be changed to No. 3, and then copied again. The copied graphic should be changed to No. 0





如果有碰到图形排版出来后，不是双数的情况，那么我们可以把单着的图形改成 4 或 6，等双刀切完后，会用一把刀单独加工单出来的图形，如下图

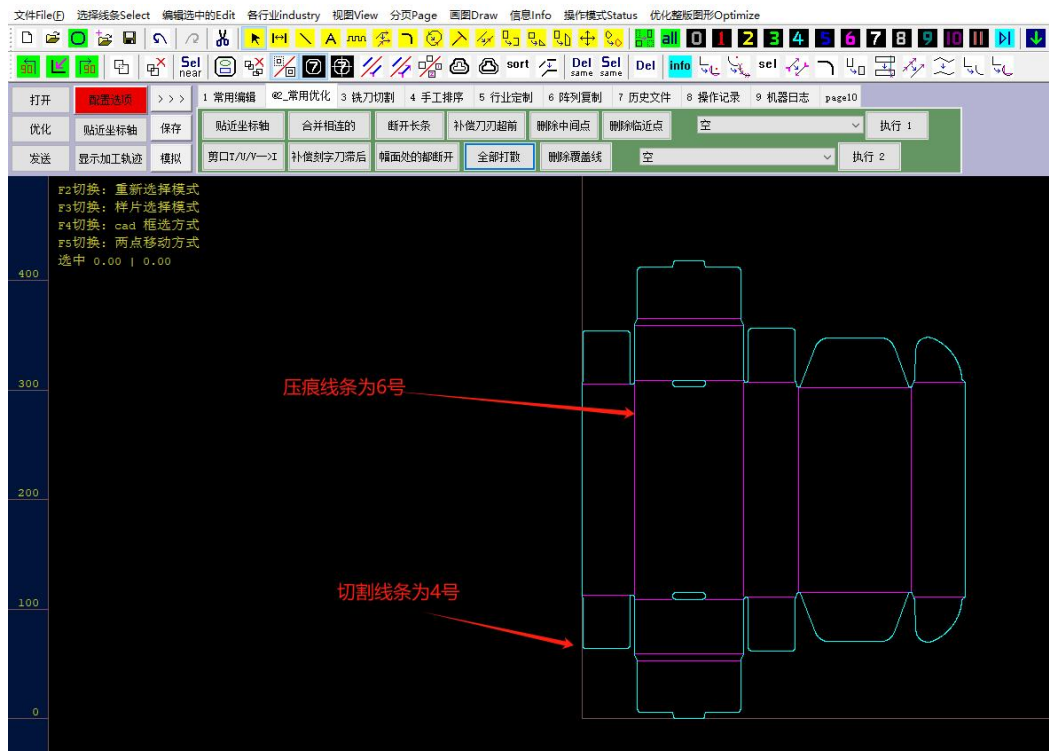
If there is a situation where the graphic layout is not even, we can change the single graphic to 4 or 6. After the double cutting is completed, we will use one knife to process the single graphic separately, as shown in the following figure



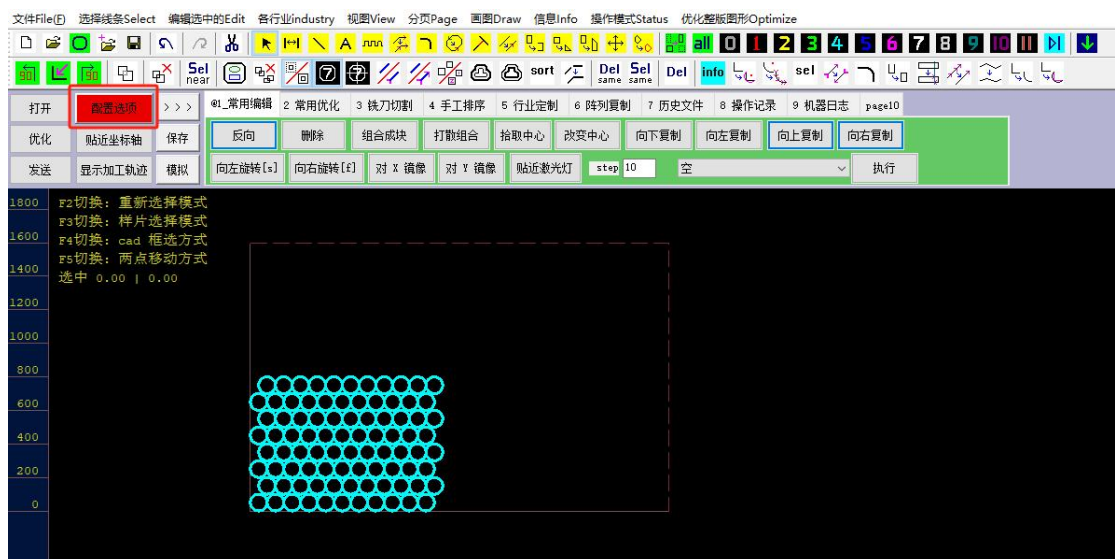
如果需要进行多功能加工，如需要进行切割+压痕，那么我们需要先把左刀（6 号）换

成压轮，然后调节好深度，把需要压痕的线条改成 6 号，切割的线条改成 4 号，如下图

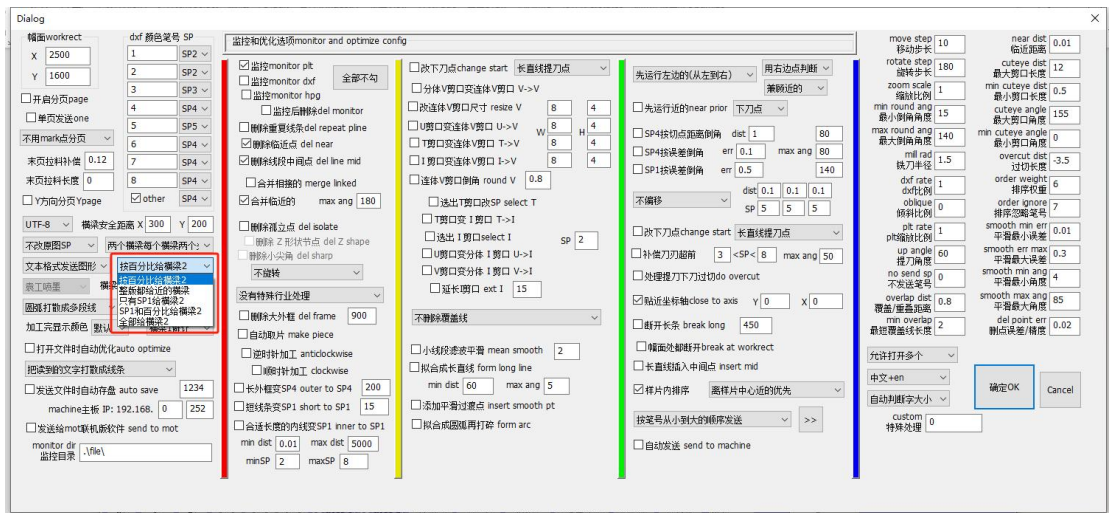
If multi-function processing is required, such as cutting+indentation, we need to change the left knife (No. 6) into a pressing wheel, then adjust the depth, change the line to be indentation into No. 6, and change the cutting line into No. 4, as shown below



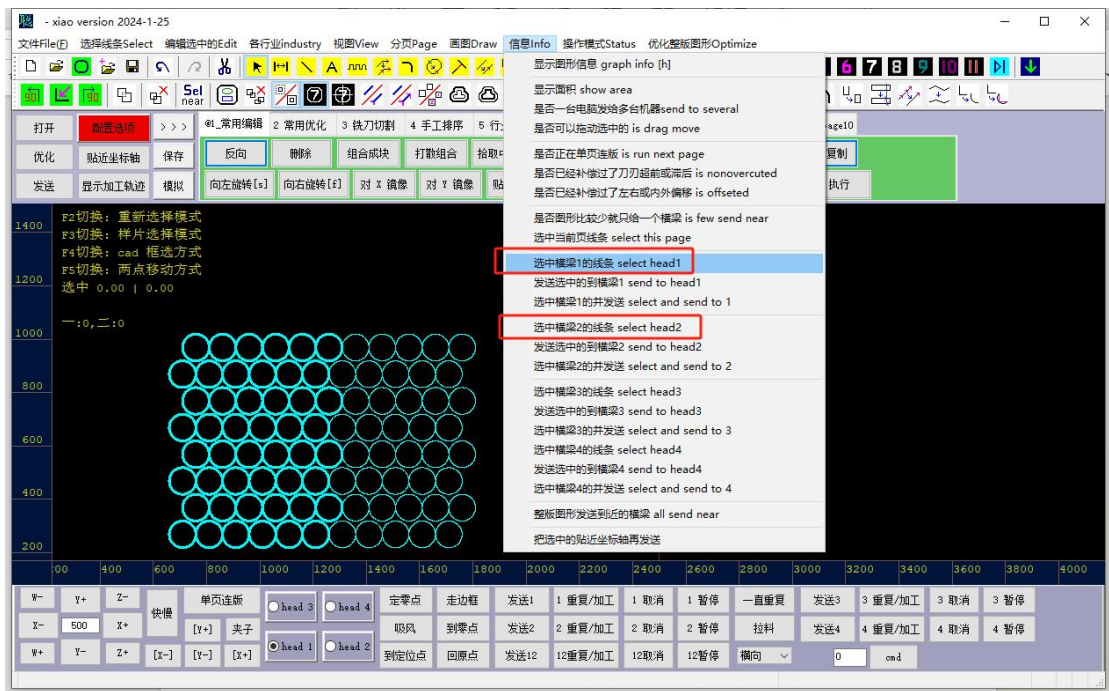
如果需要四把刀同时加工，我们需要先设置好两个横梁之间图形的分配，点开软件左上角的《配置选项》



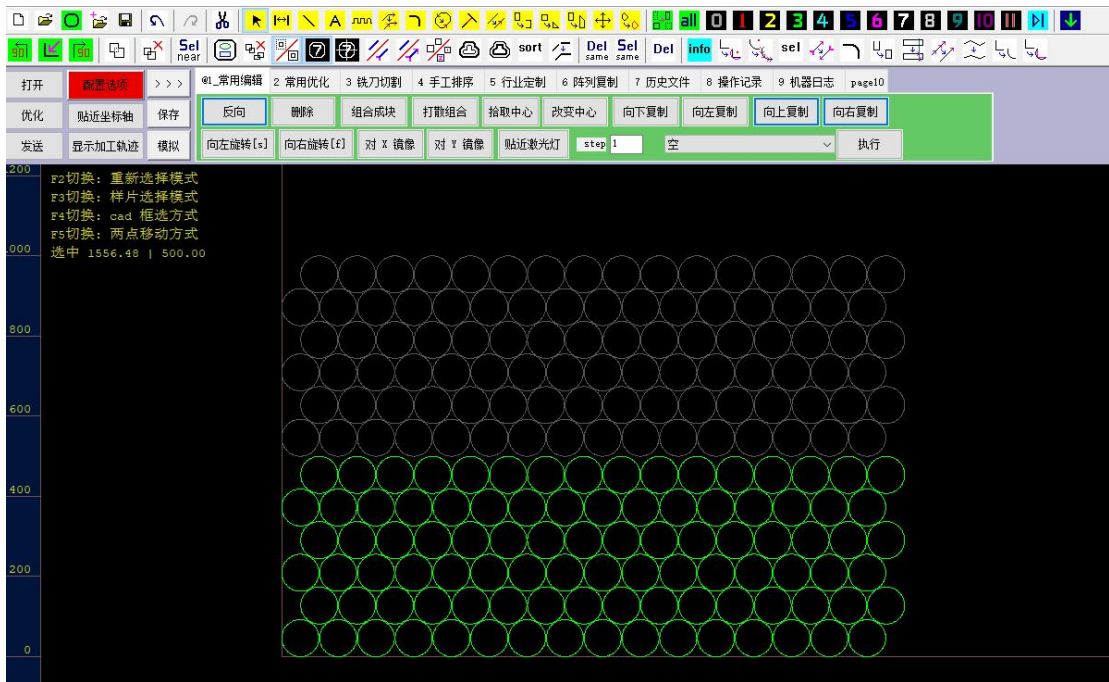
找到分配选项



大部分情况下，使用按百分百分分配，每个横梁各占百分之五十即可，设置好分配后，可以在图形信息里面选中预览，观察分配是否合适



分配设置好之后，需要调整文件的颜色，如果只是单色，那么两个横梁会各有一把刀头加工，另外一把刀头闲置，我们需要把文件颜色改成下面 3 号颜色，上面 0 号颜色，才能实现四把刀同时加工



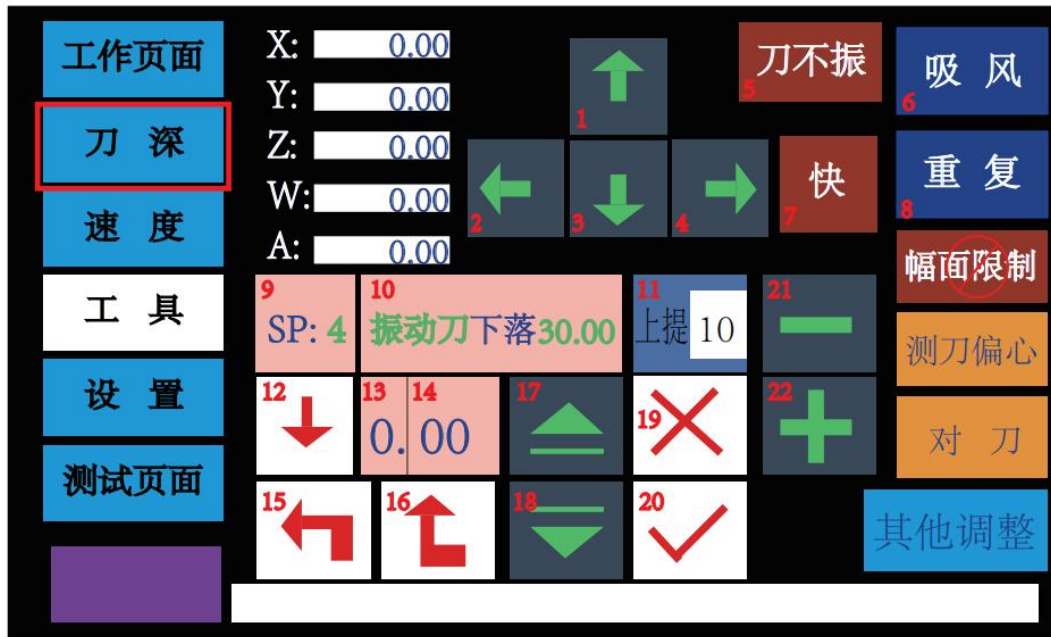
然后点击软件下面的《发送 12》即可同时把文件传输到两个横梁



1. 双梁四刀怎么调刀深 How to adjust the depth of the double blade mutual movement

触摸屏点开刀深界面，先选取需调整刀头的序号，如需要调整左边刀头选到 SP6，调整右边刀头选择 SP4，点击下图中的 9 或 10 可以进行切换选取，调刀深有两种方法，一种是上下调整法，如果换了不同长度的刀，不确定刀的大致深度，就需要通过点击 18 使刀头下降，点击一次下降的距离取决于 13 和 14，单位是 mm，控制刀片下降到台面后，打勾（20）即可保存，还有一种是加减调整法，通过第一种方法调整后，深度还不理想，需要增加或者减少，可以点击 21 或 22 进行加减，加代表深，减代表浅，加减一次的数值取决 13 和 14，加减后不需要打勾，会直接保存生效

Click on the touch screen to open the depth interface. First, select the serial number of the blade that needs to be adjusted. If you need to adjust the left blade to SP6 and the right blade to SP4, click on 9 or 10 in the following figure to switch and select. There are two methods for adjusting the depth of the blade. One is the up and down adjustment method. If you change the length of the blade and are unsure of its approximate depth, you need to click on 18 to lower the blade. The distance of one click depends on 13 and 14, and the unit is mm. After controlling the blade to descend to the table, check the box (20) to save it. There is also an addition and subtraction adjustment method. After adjusting with the first method, the depth is not ideal and needs to be increased or decreased. You can click on it. 21 or 22 can be added or subtracted, with the addition representing depth and the subtraction representing shallowness. The value of one addition or subtraction depends on 13 and 14, and there is no need to check the box after addition or subtraction. It will be saved and take effect directly



注意：双刀调深度时，调好 SP4 和 SP6 后，需选择到 SP3 点一下勾号（20），系统会对两个刀头的深度进行计算，可能会改变 SP4 或 SP6 的下落数值，但实际深度不会改变，如不进行这一步操作，双刀加工会提示参数错误，只要 SP4（右刀）或 SP6（左刀）任意深度有调整都需重复这一步

触摸屏侧面有一个切换开关，可以切换横梁控制，按下后可以控制调整另外一个横梁

Attention: When adjusting the depth of the dual tool, after adjusting SP4 and SP6, you need to select SP3 and click the check mark (20). The system will calculate the depth of the two tool heads, which may change the drop value of SP4 or SP6, but the actual depth will not change. If this step is not performed, the dual tool machining will prompt parameter errors. As long as SP4 (right tool) or SP6 (left tool) has any depth adjustment, this step needs to be repeated