



(公司官网二维码)

使用说明书 Manual Instruction

创新功能 专利技术 KEEP INNOVATED

CNC铣槽机系列

CNC Mortiser Machine series

型号Model:

GS-28-2×2/ GS-28-3/ GS-28-4 (可定制)



CNC铣槽机系列：
CNC Mortiser machine
series



型号model : GS-28-2×2



型号model : GS-28-3



型号model : GS-28-4

公司微信公众号：



微信服务号ID : czgsmgjx



The Woodworking Machinery Solution Provider

Professional and proved in more than 10 years



Efficiency choice



CNC Mortiser Machine

Continence working with multi spindle in 2 working area.

Drilling, hole enlarging, mortising the straight and arc flute.

Efficiency: 16 pcs/minutes.
7000 pcs in 8 hours.

More series Keep innovated -own 7 tech patents



Tenoning series

- Double-end Mortising Machine (new in 2016)
- Automatic Drilling Tenon Edging Machine



Automatic Drilling series

- Automatic Drilling Tenon Edging Machine
- Automatic Chair Back Drilling Tapping Machine
- Automatic Chamfering Drilling Tapping Machine and other 5



Multi-drilling mortiser/tenoner series

- Automatic Chair Side Plate Tenoning Drilling Machine
- Automatic Chair Front Leg Molding Machine
- Automatic Chair Side Plate Mortising Machine



Copy shapper series

- Automatic Copy Shaper GS-1200/1500/2000

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Wechat public account

产品介绍 Product Introduction

CNC铣槽机 CNC Mortiser Machine

型号Model: GS-28-2×2/ GS-28-3/ GS-28-4

本机特点 Feature:

本机采用多轴双工位循环连续工作，有钻孔、扩孔、铣直槽、圆弧斜槽功能，调机快捷简单、高效（可高达2000个槽/小时，连续8小时作业可完成上千件样条。）

This machine use double/three/four cutter shafts to complete the process of drilling, chambering, mortising. It is simple and efficient when adjusting. (maximum 2000 notchs/hour.)



型号		GS-28-4	GS-28-3	GS-28-(2×2) (子母轴2主2副)
控制系统Controlling system		台湾Taiwan	台湾Taiwan	台湾Taiwan
伺服马达Servo motor	X	1000W	750W	750W
	Y	750W	750W	750W
	Z	750W	750W	750W
刀轴功率Cutter shaft power		4×2.2KW	3×2.2KW	主轴Principal axis: 2×2.2KW, 副轴Subshaft: 2×1.1KW
刀轴转速Spindle speed (turn/minute)		18000轉/分鐘	18000轉/分钟	18000轉/分钟
刀轴间距Cutter shaft distance		160m/m	160m/m	160m/m
加工长度Machine length (can be customized)		950m/m (可定制)	950m/m (可定制)	950m/m (可定制)
机械尺寸Machine size(mm)		2500×1800×2000	2200×1600×2000	2200×1500×2000
机械重量Machine weight		約1200KG	1000KG	1000KG

(机械图片 Machine picture)

备注：

在正常使用的情况下保修一年，终身技术支持。如需售后，请联系我们！

后面是本机的使用说明书，为了延长机械的使用年限和操作流畅度，请务必参照操作的流程！

更多视频操作的介绍，可以扫描下方二维码（本公司的优酷视频网址）选择观看！

Remark:

One year warranty under normal use and still provide technical support when warranty date expire.

Followed by the use of the machine instruction, in order to prolong the usage of the machine and operation fluency, please read the instruction carefully and refer to the process operation as followed.

More video operation please scan the QR code below to watch!



(公司视频优酷频道二维码)
Company video channel



(本机操作运行视频二维码)
This machine video

使用说明书

尊敬的用户 Dear user:

感谢您选择本厂的CNC铣槽机。为了您的安全使用，请仔细阅读本说明书。

Thank you for choosing our product, for your safety using, please read these instructions carefully.

Cảm ơn bạn đã lựa chọn máy khoan và máy đục gỗ tự động. Để an toàn cho bạn, vui lòng kỹ hướng dẫn sử dụng.

1.本机概述General Introduction :

本机原理是用气缸将工件压在工作台上，由电脑控制的铣刀将按照生产要求铣槽。此机的特点是：

1.系统容易操作，调机简单，新手只要培训半天就可以上手。机身小巧，不仅省去占地面积，也使得生产效率更高。

The principle is by using air cylinder to press on the staging, and to be slotted by the milling cutters which controlled by computer. The features of this machine are as below:

1)The system is easy to be operated and simple to adjust, new operator can learn to operate by half day training.

2)The machine size is reasonable, it is not only saving the space but also enhancing the efficiency.

2.本机简介Brief Introduction of Operation Manual :

2.1 每次开机前检查事项Check list before start:

1) 气压是否正常；2) 润滑油是否充足；3) 气动油是否充足。

Whether the air pressure is normal; 2) Whether the lubricating oil is enough; 3) Whether the VT-Q is enough.

2.2 开机 Starting up

1) 电控箱内总开关置ON，变频器通电。

Turns on the total holding place in the electric cabinet, the transducer will electrify;

2) 将面板上的旋钮“电源开关”开启，此时显示屏及电控箱内各部位通电待命，会出现以下画面：

Turns on the panel power switch, therefore, the screen and electric cabinet electrify and ready to start,the following screen appears as below.



(图1 Picture 1: Boot screen 触摸屏)

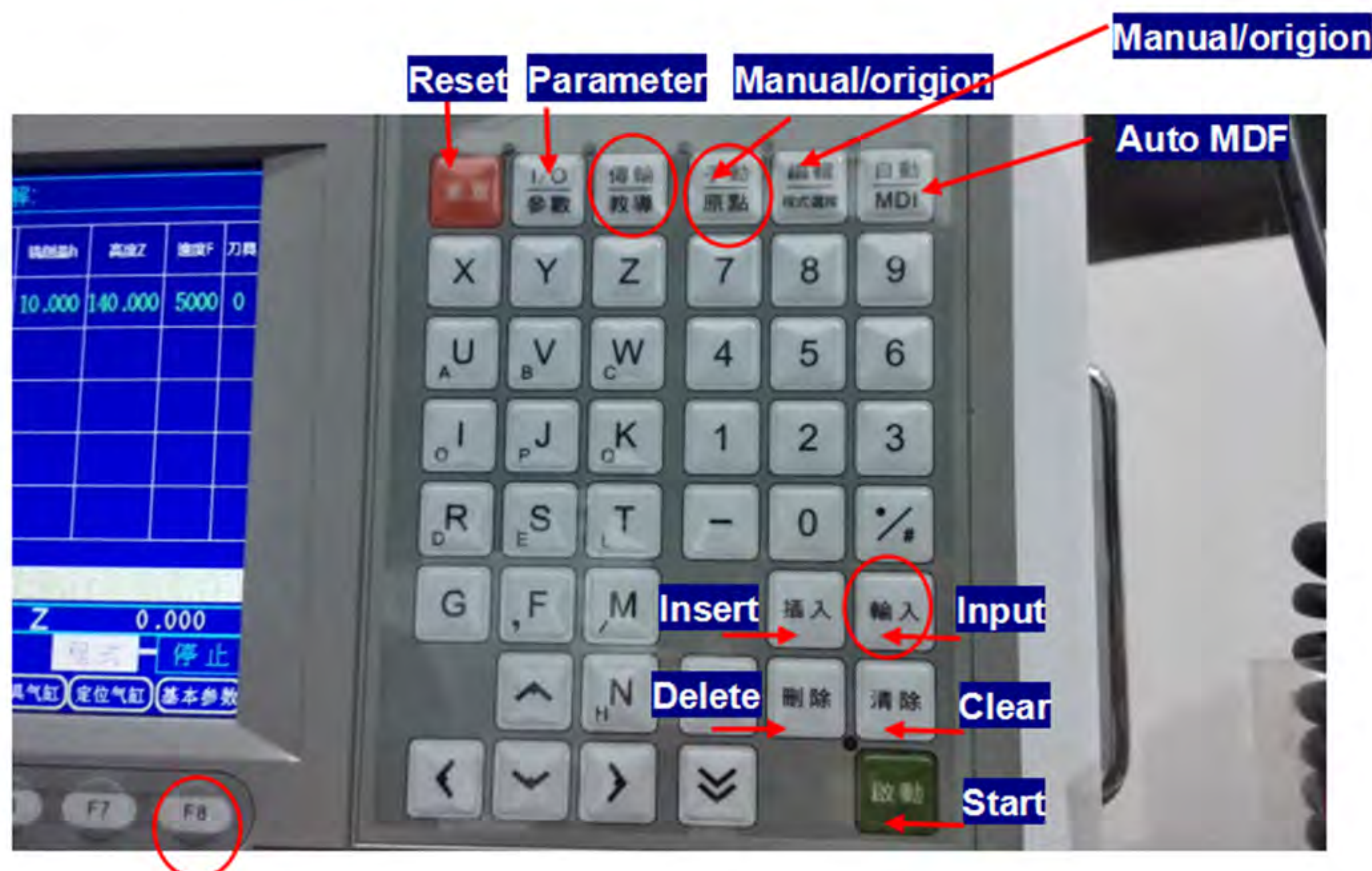


(图2 Picture 2: Total holding place 总开关)

3.调试 Adjusting

1) 打开面板电源，显示器正常显示后按F8；

Turn on the panel power,when the screen is light and then press F8;



(图3 Picture 3: Keyboard 键盘)

2) 按提示执行原点动作，快速按“手动/原点”2次，再按F8之后按触摸屏上的“同时归零”，机器自动X、Y、Z轴回原点。

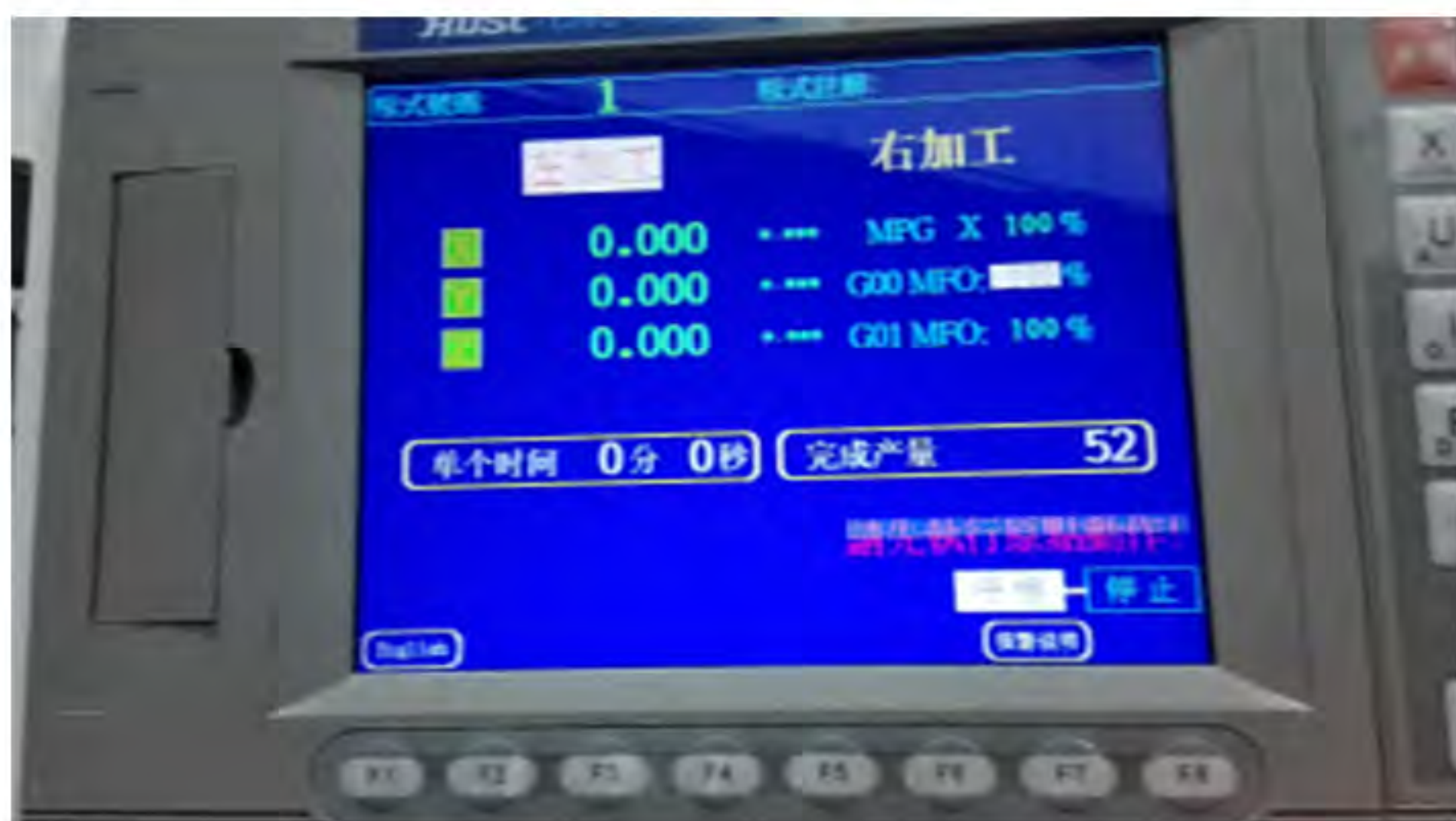
Follow the origin of action according to directions, press the 4th button:手动/原点Manual/origin (at first line on the keyboard.), press F8 button and press “同时归零All go home” (means clear the parameter),the X, Y, Z-axis of the machine will turn back to origin.

3) 按“编辑/程式”选择出现编辑画面，按F1后按触摸屏上的“选择程式”，点击右边数字区选择数字，按“输入”按键确认。

Press 编辑/程式Edit /program on the right side of the keyboard and it will turns out the edit menu on the screen, press F1 button and press “choose pro”,click the right side of the area on the screen and select number, press “Input” button to confirm.

4) 按F2按键或F3按键选择加工区域（左加工/右加工）。

Press F2 button or F3 button to choose the manufacturing workplace (left manufacturing workplace: Area -1 /right manufacturing workplace: Area -2).



(图4 Picture 4: Choosing the manufacturing area 左右加工区域选择)



5) 数据框内类型选择 Select the type of work piece.

- a.圆棒 Circle
- b.方棒 Square
- c.圆弧棒 Arc
- d.线条

在右边数字区选择相应代码，按“输入”输入宽度/直径、深度、铣削量、高度、速度、刀具。

铣削量：每次进刀量，根据产品确定；

Choose the corresponding code at the right side of area on the screen, press “Input” and input the figure of width, depth -H, one mill-h, height-z, speed -F, and cut.

高度：高度指刀具在加工产品表面接触时的Z轴数值；

速度：机器加工时各伺服速度，正常为5000；

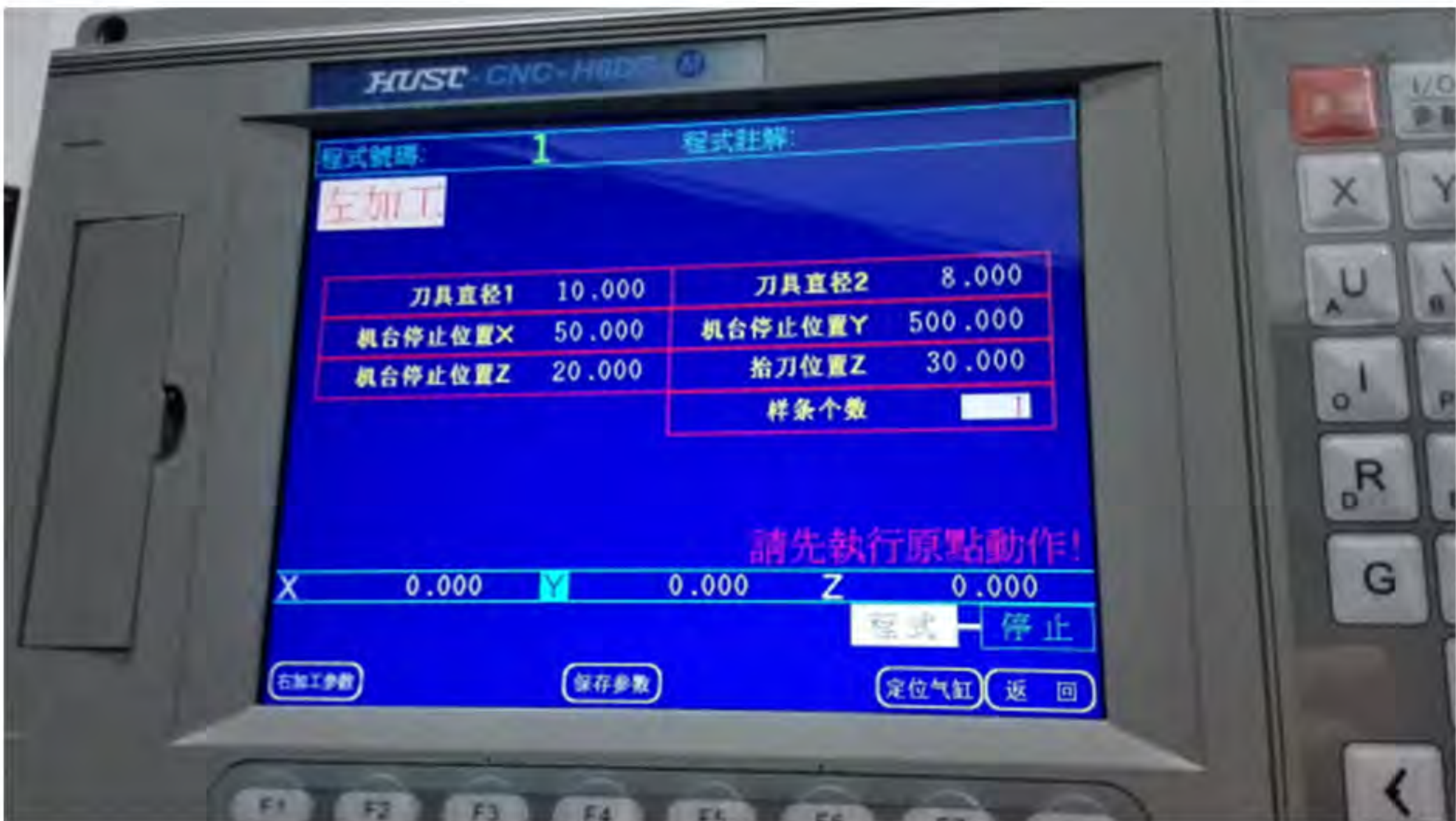
刀具：默认为大主轴加工，需要小主轴加工时设置为1，调机时按F6按键并点击触摸屏上的“刀具气缸”，再由小主轴定位。

One mill-H means cutting feed in each time by certain needs;

Height-Z: means the Z -axis figure when cutter touch the surface of work piece;

Speed -F: means the servo speed when the machine is working, normal set is 5000;

Cutter: default in manufactured by the big spindle, if need the small spindle, can set 1, when adjusting, press F6 button and and click the “cutter cylinder” on the screen, and the small spindle will position.)



(图片5 Picture 5: Left manufacturing area 左加工)

例1：钻孔（圆棒）

按编辑/程式选择，按F2按键进行左加工，类型按1-输入，直径10-输入，深度20-输入，铣削量10-输入，高度140-输入，速度5000-输入，刀具默认为0，按F5按键编辑，用手轮调节XYZ轴，让刀具对准产品的样品需加工的位置。按F5，F6按键分别记录坐标，再按F4保存参数。

Example: Drilling (circle)

Press Edit /program and press F2 button for left manufacturing (Area 1), input 1 for the type, input 10 for the width (diameter), input 20 for the depth, input 10 for the one mill -H, input 140 for the height, input 5000 for the speed, the cutter is 0 as default. Press F5 to edit and input the figure of X, Y, Z-axis, and make the cutter aiming at the work piece’ s position. Press F5, F6 button to record the coordinate respectively, and press F4 to save to the parameter.

6) 基本参数设置

- A “刀具直径1” 为大主轴实际安装刀具直径;
- B. “刀具直径2” 位小主轴实际安装刀具直径;
- C. “机台停止位置X” 为每次加工完毕X轴停止位置, 正常为50.
- D. “机台停止位置Y” : 正常设置为500;
- E. “机台停止位置Z” : 正常设置为20;
- F. “抬刀位置” : 正常设置为30;
- G. “样条个数” : 按产品加工需要设置, 最大为3.

输完各程式数据后, 按右上角自动/MDI, 再按F5按键, 再点击屏幕上的“手轮模拟”, 再按机台面板“左启动”或“右启动”2秒。慢慢转动手轮, 机台刀具会按你所对点的数据对产品加工。如果确认无误, 可再按F5按键, 直接对产品自动加工。

Basic parameter setting:

- A. “Position X1” is the actual installed cutter diameter of the big spindle.
- B. “Position X2” is the actual installed cutter diameter of the small spindle.
- C. “Stop position X” is the stop position of X -axis when fix manufacturing, the normal set is 50.
- D. “Stop position Y” : normal set is 500.
- E. “Stop position Z” : normal set is 20.
- F. “Cutter position” : normal set is 30.
- G. “Cutter diameter” : for the manufacturing needs, the maximum is 3.

When finish inputing the figures, press 右上角自动/MDI (Auto/MDI) button, and press F5 button and click “Simulation” on the screen, then press “左启动” (start left area) or “右启动” (start right area) in 2 seconds. Turn the hand wheel slowly, the cutter will manufacture according to the data which inputted. If confirm, then press F5 button and the machine will operate automatically.



(图片6 Picture 6: Machine panel 控制面板)

(图片7 Picture 7: Hand wheel手轮)

7) 关机流程：1) 关闭面板开关；2)电控箱内总开关置OFF。

Shut down process: 1) shut down the switch on the panel; 2) shut down the switch in the electric cabinet.

3 . 注意事项Note :

- 1) 刀具务必正确安装及锁紧。更换刀具时应关闭总电源，并将插销按下。
- 2) 本机装有气压开关，当未接气管或气压不够时，整机将不能启动。
- 3) 定期检查各部件，若有损坏，请立即更换以确保机械的正常功能。
- 4) 避免小孩及参观者靠近机器，尤其在机器运转的时候！
- 5) 保持工作场所清洁，下班时用风枪清洁机身。

1) The cutter need to be installed correctly and be tight. When changing the cutter please ensure the electricity is off. And press the plug.

2) It contains the air cylinder in the machine, when it does not connect the air tube or the pressure is not enough, the machine cannot start.

3) Check each spare components by fixed period, if any broken, please change immediately for the normal function of the machine.

4) Please avoid the kids and visitor to get close to the machine, especially when the machine revolve.

5) Keep the working space in neat and clean the machine with blow gun when finish work.

感谢使用我们的机械！如有任何问题，请联系我们！

Thank you for using our machine, if any questions, please contact us!

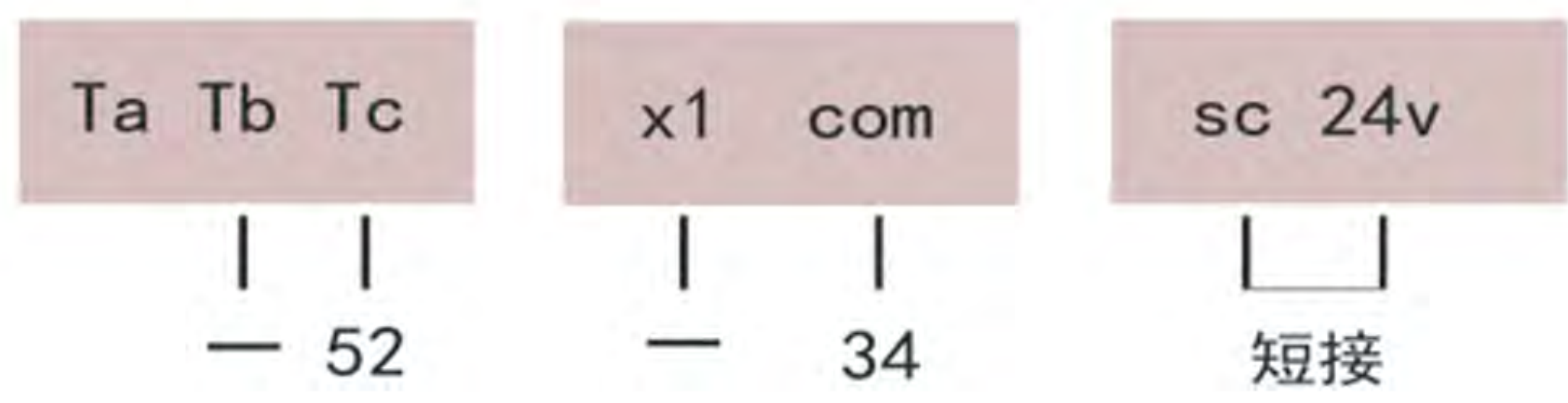
附件1：参数设置参考

HUST-CNC-H6DA-H			
参数设定	X轴	Y轴	Z轴
解析度 (分子)	21550	17950	10000
解析度 (分母)	10000	10000	10000
马达方向 0/1	1	1	1
最高速度 MM/MIN	30000	35000	12000
原点第一段速度	2500	3000	2000
原点GRID速	1500	500	100
找原点方向	1	1	1
找GRID方向	0	0	0
原点偏移值	5.000	5.000	3.000
+软极限	1100.000	1000.000	200.000
-软极限	- 5.000	- 5.000	- 500.000
手动速度	4000	6000	2000
对刀杆偏置值X1	0.000	对刀杆偏置值X2	0.000
对刀杆偏置值Y1	0.000	对刀杆偏置值Y2	0.000
		开启主轴时间	4 S
		机台刀具个数 (2或4)	4



附件2：变频器和伺服参数

力士乐变频器



- b0.000 - 2
- C1.07 - 电流马达 11A小 5.5A
- C1.08 - 电机频率 300
- C1.09 - 18000
- E0.00 - 0
- E0.01 - 1
- E0.09 - 300
- E0.08 - 300 -先输
- E0.07 - 300
- E2.15 - 14 - 继电器、故障
- E0.26 - 4S

西林变频器

- F0.02 2
- F0.03 0
- F0.11 300
- F0.13 3.5
- F1.04 300
- F2.08 300

台达伺服参数

- P1 -37 负载比
- P1-00 - 0 P1-01 -0
- P1-44 - 16 P1-45 - 1
- P2-10 - 101 P2-15 - 0
- P2-16 - 0 P2-17 - 0
- P2-18 - 0 P2-22 - 7