Caution

1.Please note that the computer can not access the internet,even it is the english system,for Chinese Internet type is different with other country in the world,if connect the computer with internet,the computer will be black screen of death.
2.Never can press "rvs slot" directly,otherwise it will be easy to break the blade on the machine.

YN-VC Manual of operation

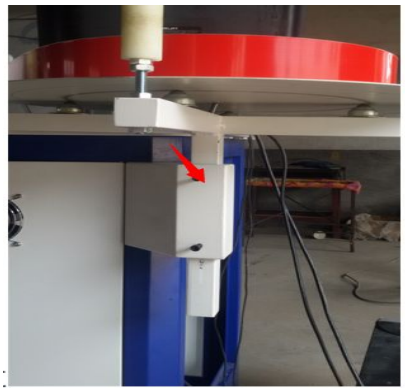
Chart I

Install the machine

@.finally Assembly

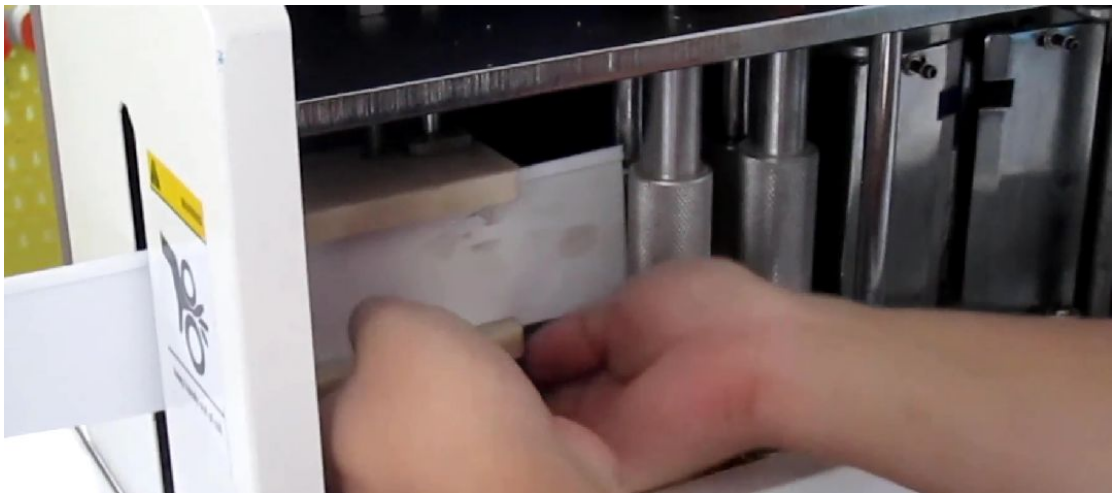
@. first step:assemble tray(Fix the screws on the tray),put the tray on the

tray support,put the coils in the tray support,the coils must be parallel with the tray(Picture A-1)



Picture A-1

Adjust the double yellow Nylon board ,the coil should be in the slot of the Nylon Board(Picture A-2,Picture A-3,Picture A-4)

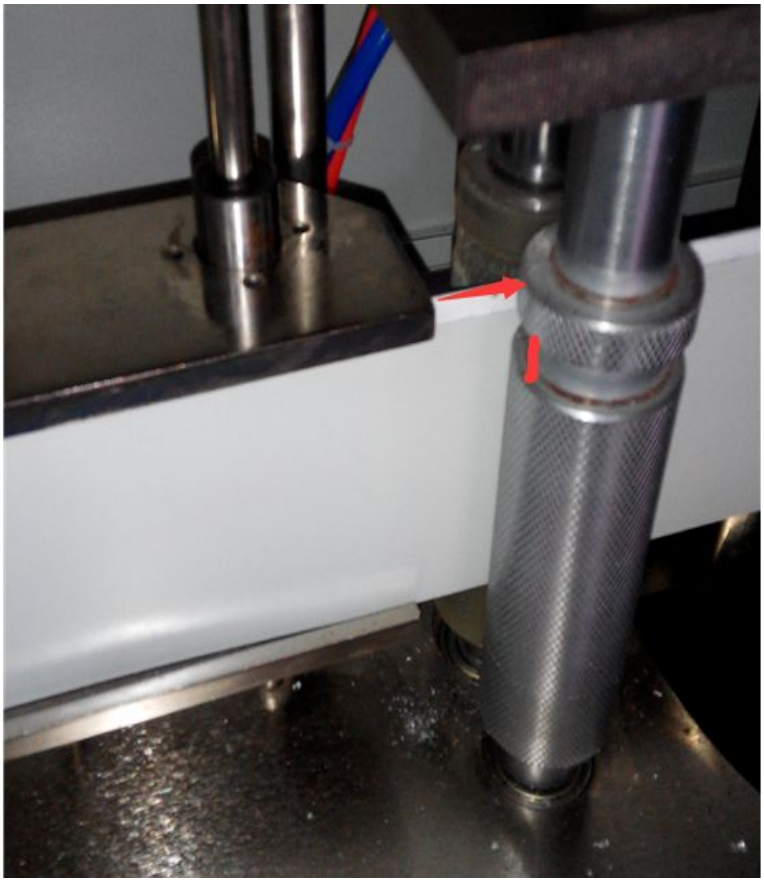


Picture A-2

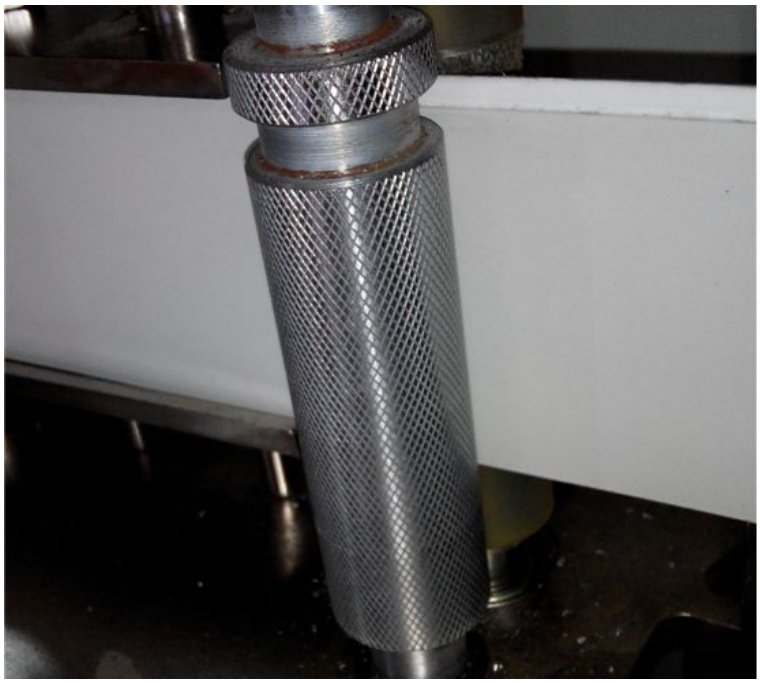
Picture A-3

Picture A-4

The coil height is same with the bar slot(Picture A-5,picture A-6)

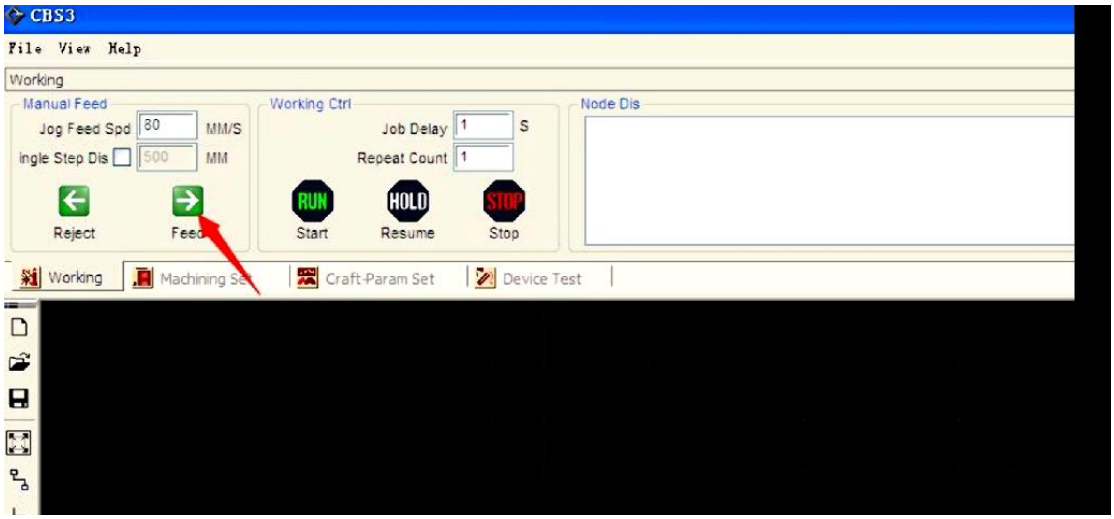


Picture A-5

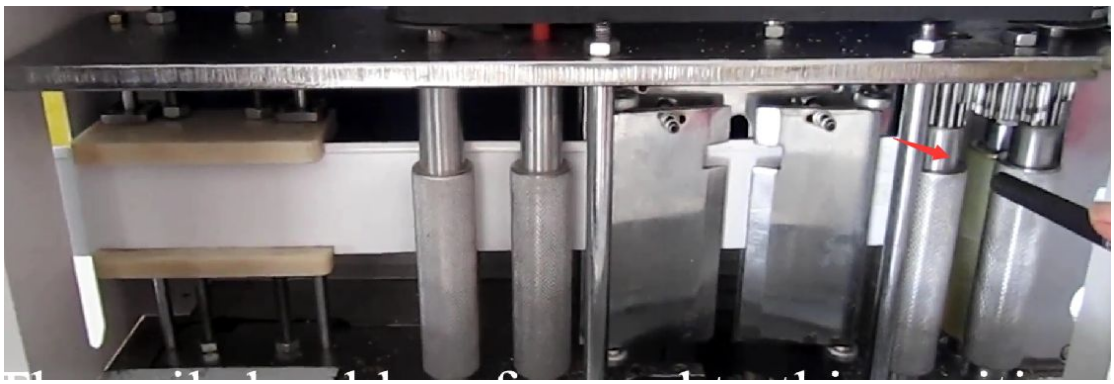


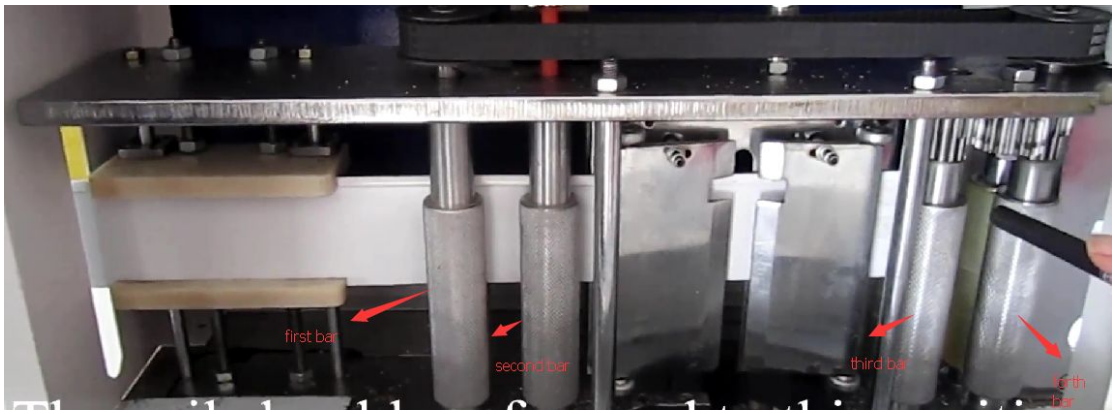
Picture A-6

Press "Feed' in the software(Picture A-7) to keep the coil in the third bar(Picture A-8)



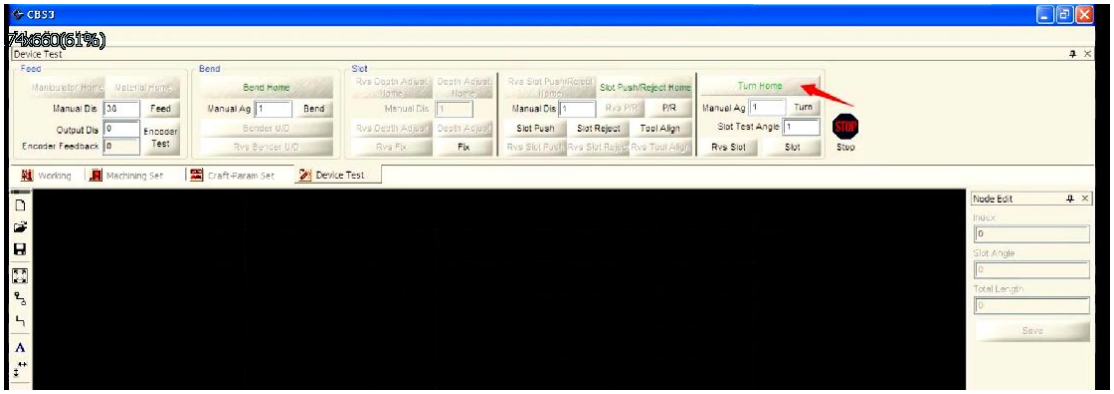
Picture A-7



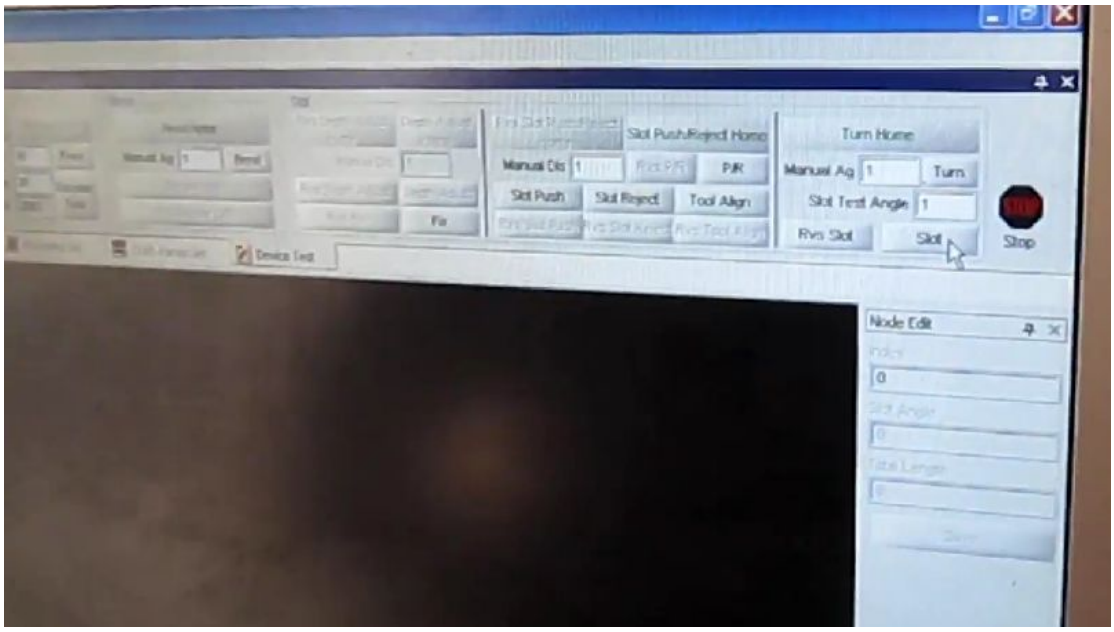


Picture A-8

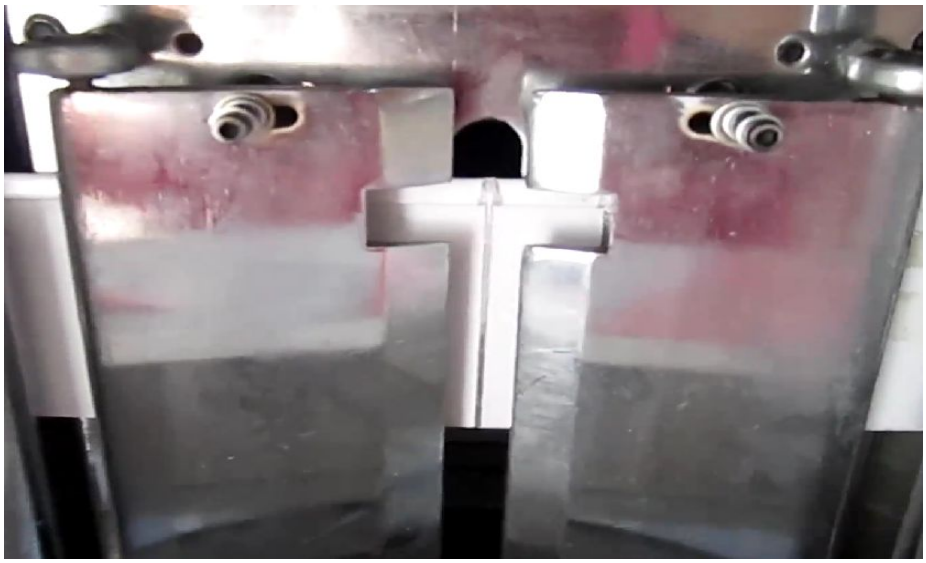
In the software press "Turn home" just one time(Picture A-9),then press "slot"(Picture A-10),the machine will slot in front of coil(Picture A-11),then press "Feed"again(picture A-7),next is to press"RVS-slot"(Picture A-12)



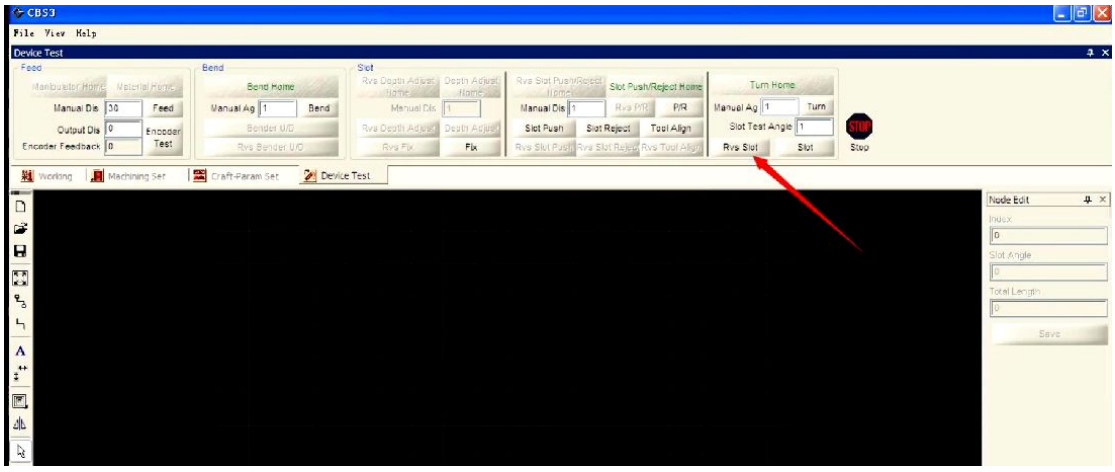
Picture A-9



Picture A-10



Picture A-11



Picture A-12

The machine will slot in back of coil,press"Feed"in software,check the shades(Picture A-13),cut out the aluminum and bend the cutting line to see it is easy to bend or not.(Picture A-14),if it is not suitable,please check the character-Two(How to adjust the slotting thickness on coil),if the thickness of slotting in front and behind all is ok,then start to work by the machine.

Picture A-13

Picture A-14

Connect the earth wires (Picture A-15),then connect the air compressor to the machine,(PictureA-16)

Picture A-15 earth wires connection port

Picture A-16

Turn on the machine(Picture A-17)

Picture A-17

Open the file you already designed in CorelDraw(AI format),press "start",the machine will bending the design automatic.

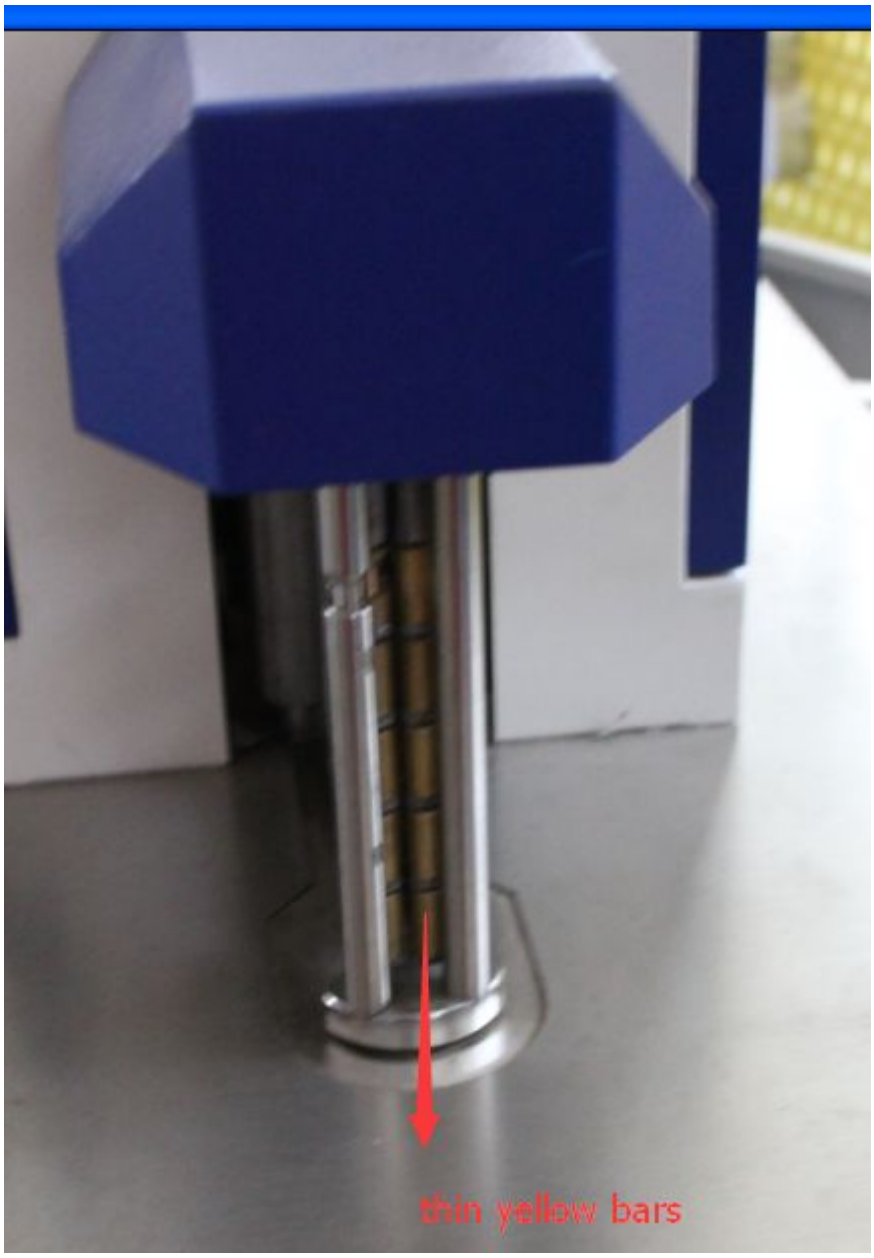
Note: When you design the file in the CorelDraw,when save the files from CorelDraw,the design will be used on channel letter bending machine must be AI format,please save two files at the same time,one is PLT format for cnc router to cut the face of sign letter,another one is AI format for channel letter bending machine to make aluminum sign letter.

Connect the computer to start the machine.

How to make an adjustment to get a right arc

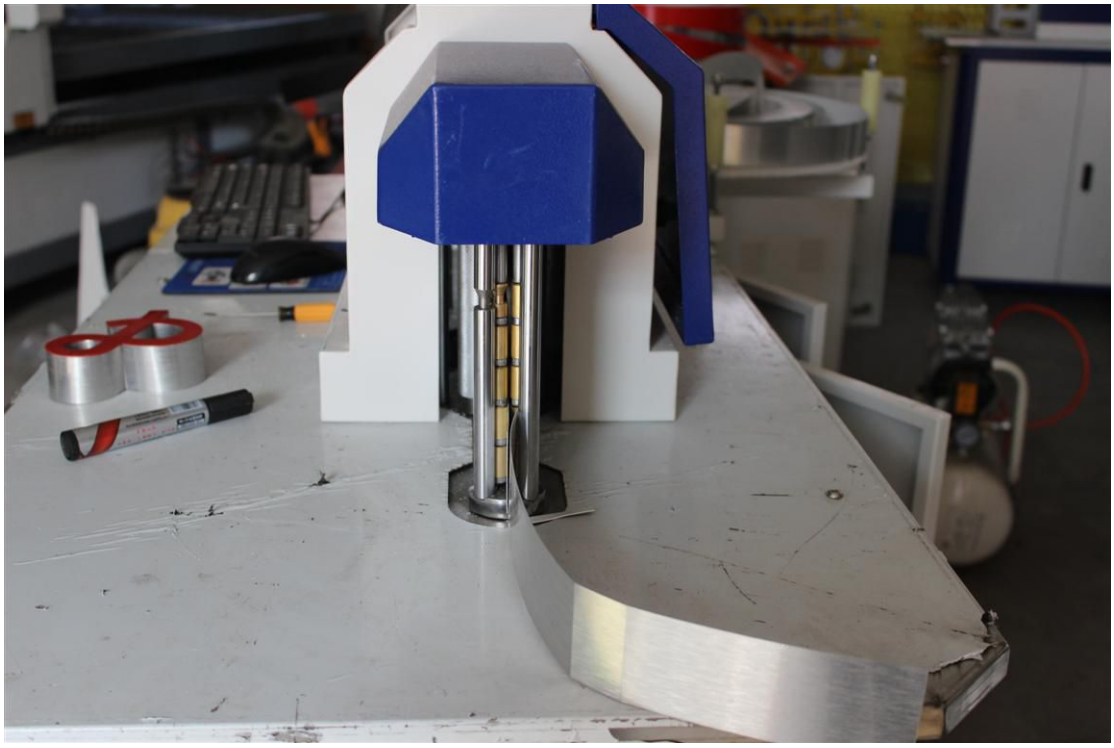
When press "Bend home",the bend bars will stop at its ornignal position,the bending bar right position should be include the yellow thin bar,like the picture

as follow:



Keep the double yellow bars in the middle of double white bar,and this is the right NO in the "bend home correct".When you found the right NO in "bend home correct',keep this NO all the time,do not change it anymore,because this NO is keeping the right position for the bending part.

The machine bend part will bend the aluminum to front as well as to back direction ,when the machine bend the aluminum to back direction,like the picture as follow:



1.If the bending arc is more larger than the arc of sign letter file,it means the power of bending part is too small,so we need to make the power more strong to make a small arc,so we need change the NO in “Front bend air angle” to be bigger than before until to get a right arc with the sample(or the arc in sign letter file)

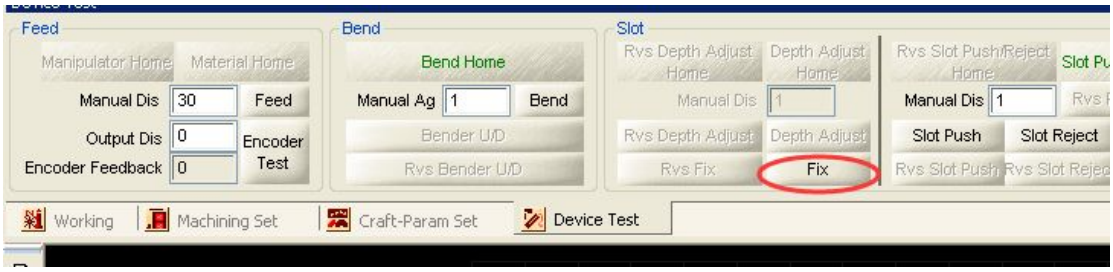
2.If the bending arc which the machine bend the materials into back direction is small compare with the arc in the sign letter file,it means the power of bending bars is too big to bend a suitable arc,so we need change the NO in “front bend air angle” to be smaller number.

3.The principle is same for the arc which is bent from front direction,just the parameter in the “RVS bend air angle” need to be changed.

Note:The number in the “front bend air angle” and “RVS bend air angle’ should be **±5 compare to the original parameter**

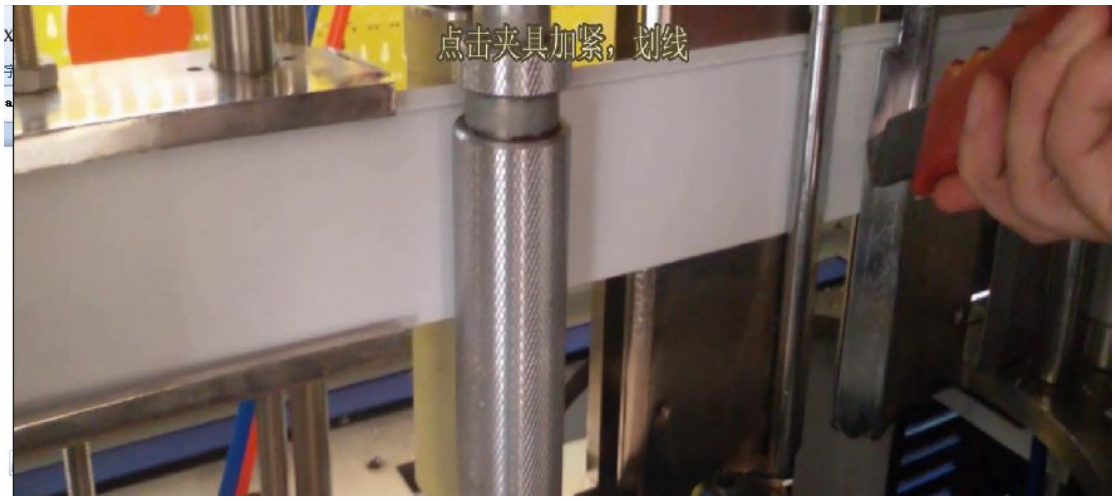
Chart part II

How to adjust the length



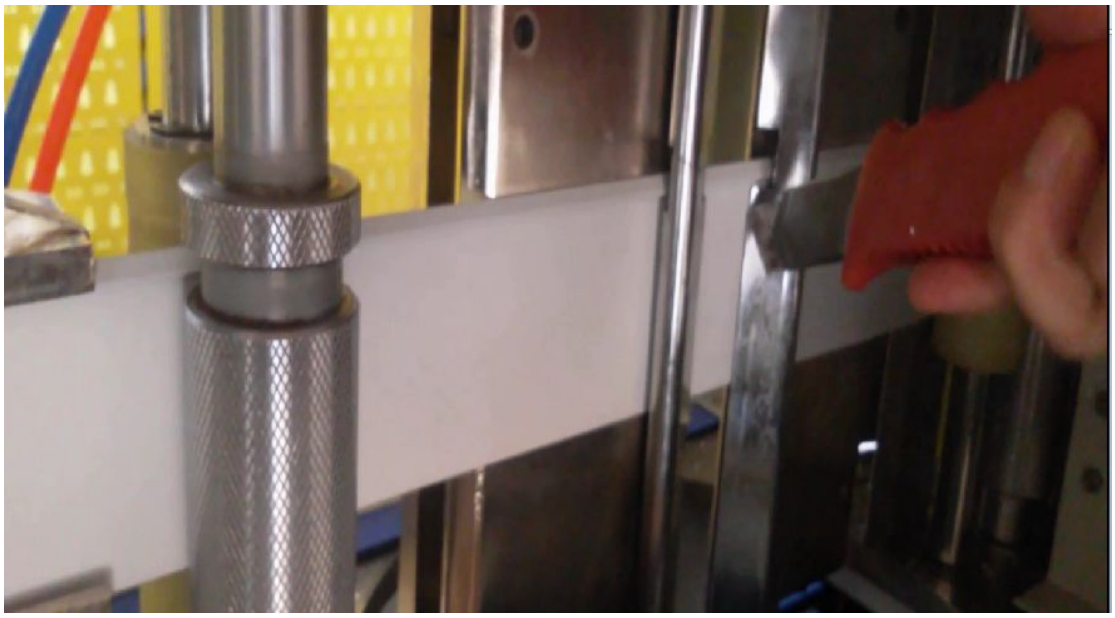
Press "fix",and the board will fix the coil in the machine,then use a pen or knife to cut a line as

mark for the start position,then press "fix" to loose the fix.



Then input 500 in the ngle step dis ,and press "feed",

when it stopped,click "fix" to make an another line,then click "fix" again to loose the coil.



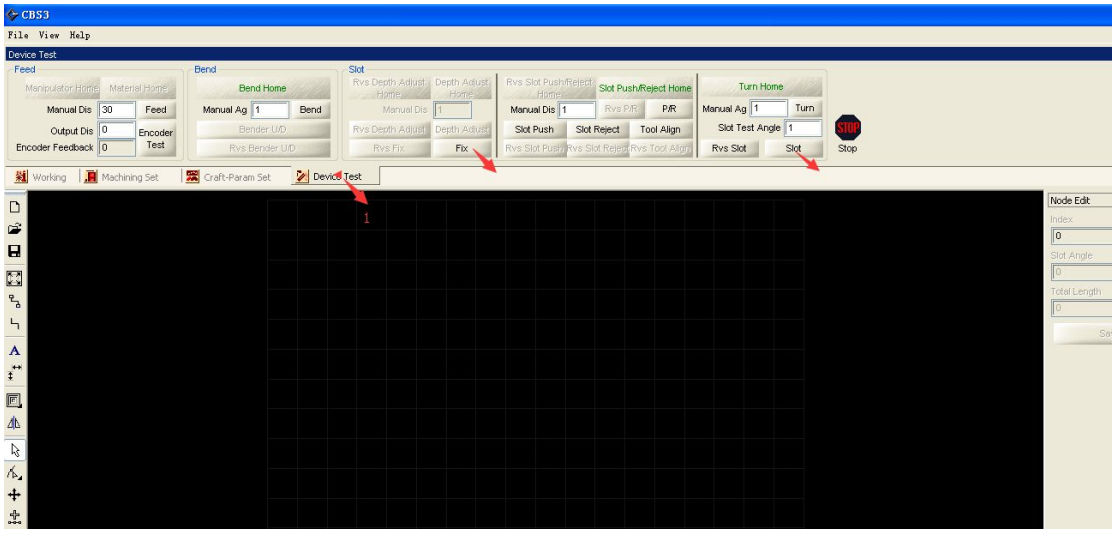
Then press "feed" again to make the coils outward of the machine,then to measure the length between two lines,please keep the length in mm.

Please fill the pulse equivalent and save ,the code is leetro
Close the dialog is ok.

Chart part III

How to adjust the blade to keep slotting thickness on aluminum coil is suitable in front and back of coil

1.Open the software,and open the "device test",first to press"fix" ,the machine will fixed the blade,to check the blade is fixed or not by hand(**Note :please put the computer mouse out of the software window to prevent to hurt people when the people to check the blade is fixed or not by hand**)if the blade is fixed already,then press "slot',the machine will slot a line in front of coil,then press "fix" again to loose the blade,next is to press"feed" to move the coil in ahead,then press"fix",next is to press "RVS slot",now the coil will have line in front of coil as well as back of coil,then press "feed' to export the coil come out of the machine,then cut it down to check the thickness in front of coil as well as back of coil.



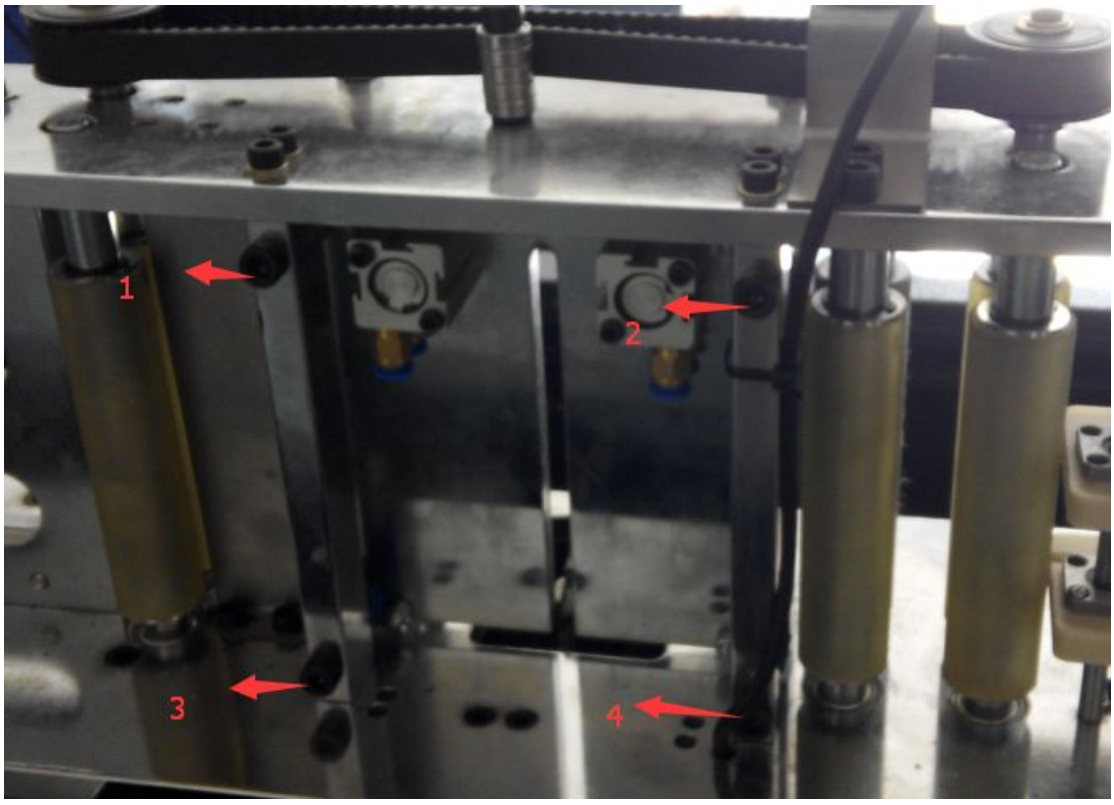
2.If the thickness in front of coil is more light than in the back of coil,then rotate the four screws back of the machine in Clockwise (Picture B-1)

The Principle: When rotate tight the four screws in counterclockwise,the aluminum coil in the machine will come a little in front direction,then the blade will cut a little thick in the coil.

3.If the slotting thickness in front of coil is more thick than the back of coil,then rotate the four screws in Counterclockwise

4.When cut the front and back side ,the front side top is depth, but back side top is shallow, now please small anticlockwise the 1 and 2 screw. If the contrary is the case ,please clockwise rotation.

5.If the front side can cut ,the back side cann’ t cut , please anticlockwise four screws. If back side can cut , but front side cann’ t cut ,clockwise the screw .



PictureB-1

Parameter setting

Note:Normal step which will not damage the machine

1.When you turn on the machine,just press "Turn home" first to see the knife is in right position or not,if it is not in right position,then adjust the parameter as follow

2.At the begin,never press "RVS slot" directly,must be "Turn home"then "Rvs slot"

3.For the machine software parameter,it just different with sereval parameter,others are all same for both machines,the parameter which can be changed as follow:

"

Bend Home Correct	

"

Front Bend Air Angle	35.0000
Rvs Bend Air Angle	35.0000

Turn Tool Home Correct	36.0000

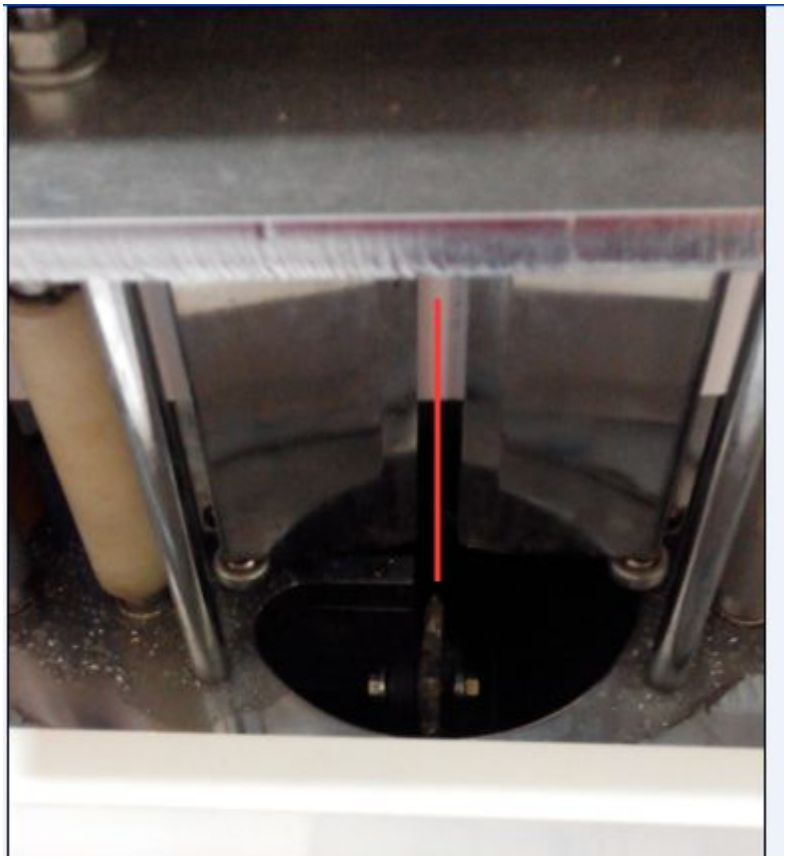
Slot Push/Reject Home Correct	5.0000

Turn Tool Home Correct	

Except these parameter can be changed,others please all keep it with the original parameter

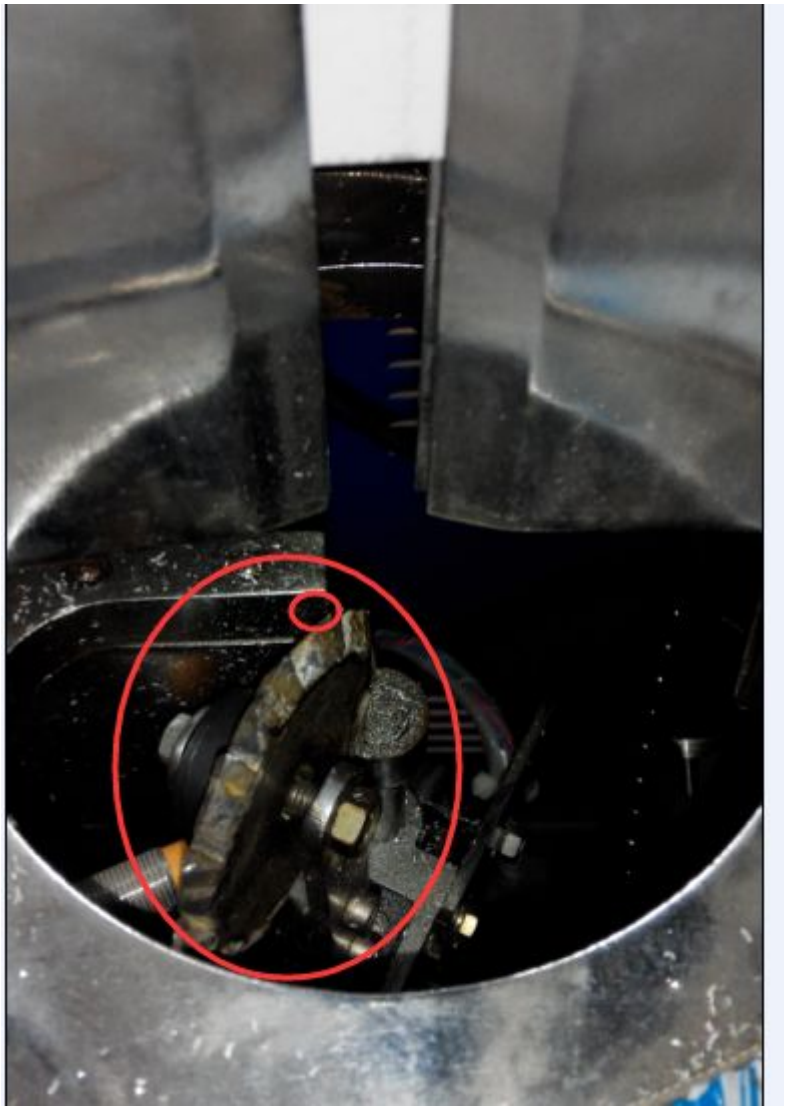
Chart I:How to adjust the knife into right position

1.There is one situation that will damage the machine by slotting knife,so here is the step how to adjust the knife in the right position,please check the step as follow:



Knife Right position(Picture C-1)

If the slotting knife position is not in the front of board,it is the declining like the picture as follow:



If the knife is declining,the knife will easy to damage the machine,so now we need adjust the parameter in the software to make the knife into right position.Now we need change the parameter in Slot-parameter(Picture C-3) ,now modify the NO in the "turn tool home correct"(More larger NO,the knife will move to right side,for example,right now the NO is 25,if you change it into 26,the knife will move to right a little),change the NO in "turn tool home correct" until to find the right position.

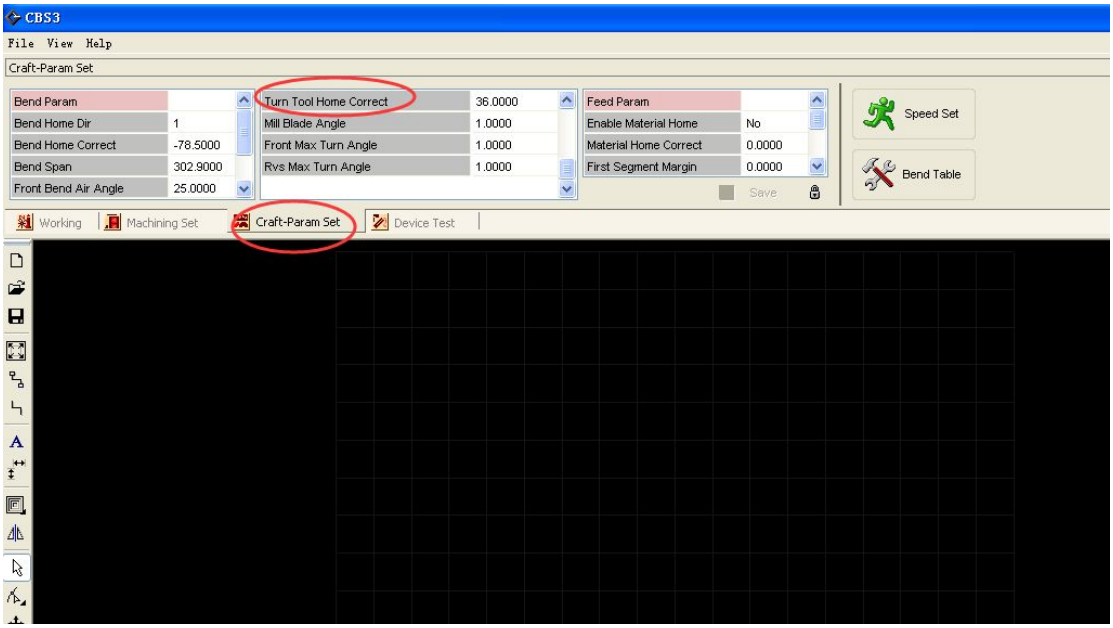
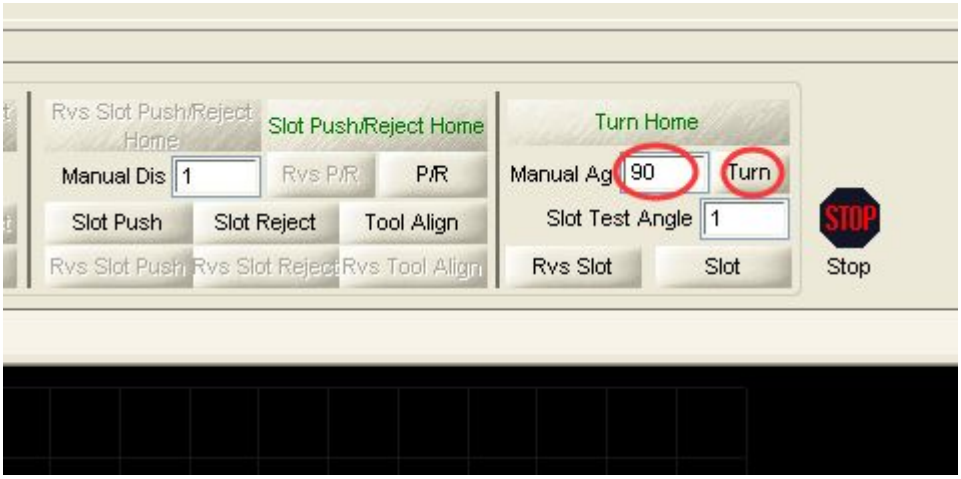


Chart II How to adjust parameter avoid the knife damaged on machine

1.Now press "turn" like in the picture

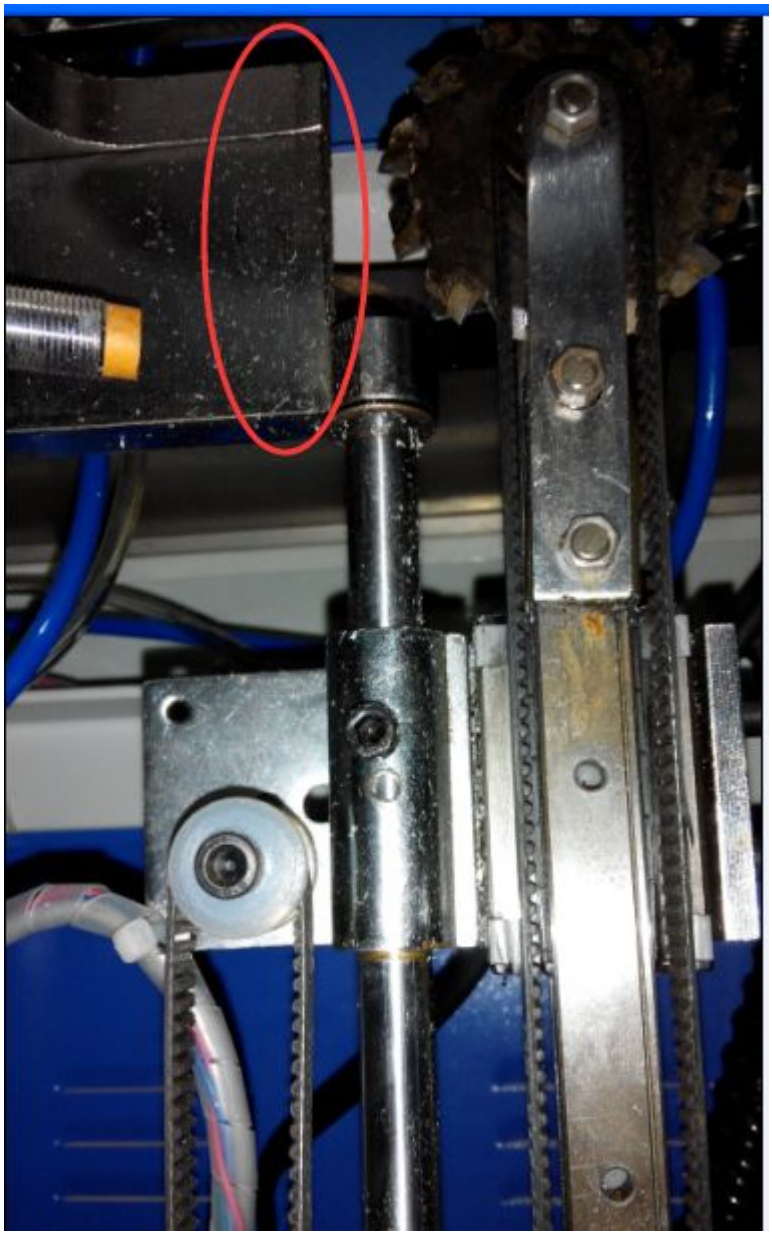


Picture C-4

After you press "turn",please check the knife is hitting the iron board or not(Picture C-5),if it is hit the iron board,then need to change the NO into "slot param----slot push/reject home correct"

Picture C-5

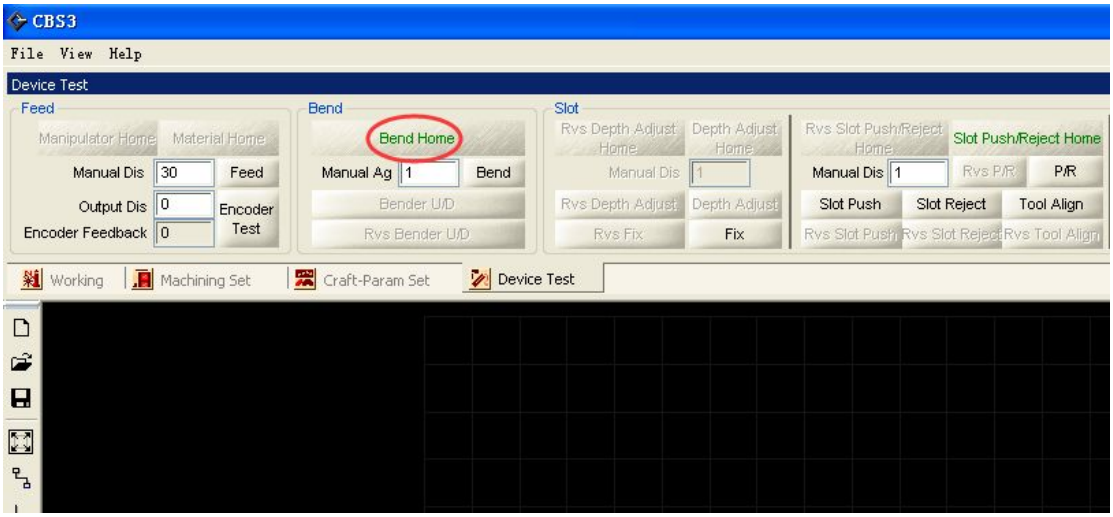
If the knife is hitting the iron board,then adjust the parameter in "slot param---slot push/reject home correct",the NO more larger,the knife will move to down side.The NO more small,the knife will move to upside.(Note:when the knife move downside,the knife also keep can not hit the iron board under the machine,like picture C-6)



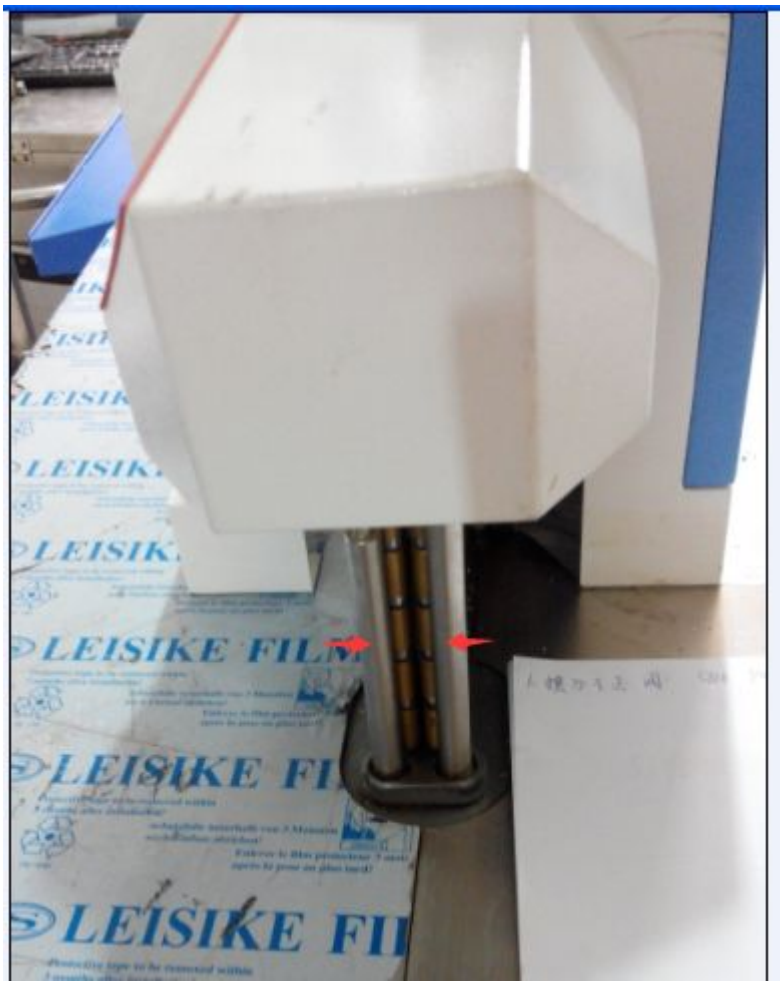
Picture C-6

Chart III how to adjust the parameter for bending part

1.Press"Bend home" (Picture C-7)to see which position of the bending part stoped,the right position is as follow:(picture C-8)

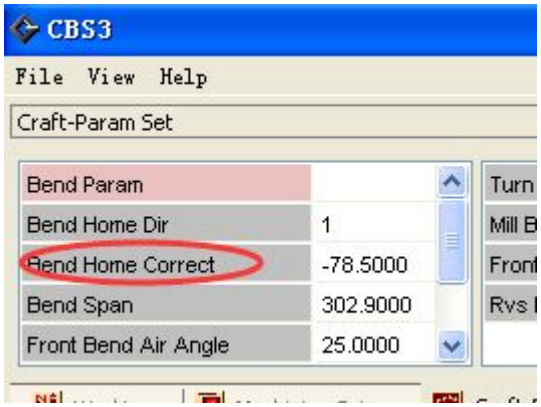


Picture C-7



Picture C-8

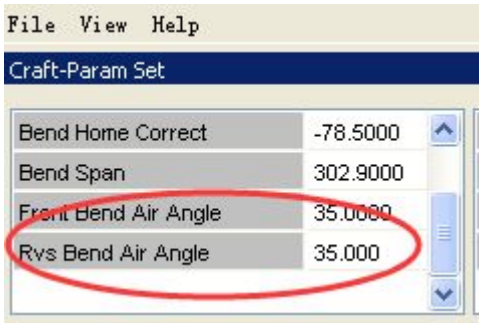
If the bar is not in front of two white bars,then adjust the parameter "Bend home correct"(Picture C-9)



Picture C-10

And the NO more larger,the bar will move to right.

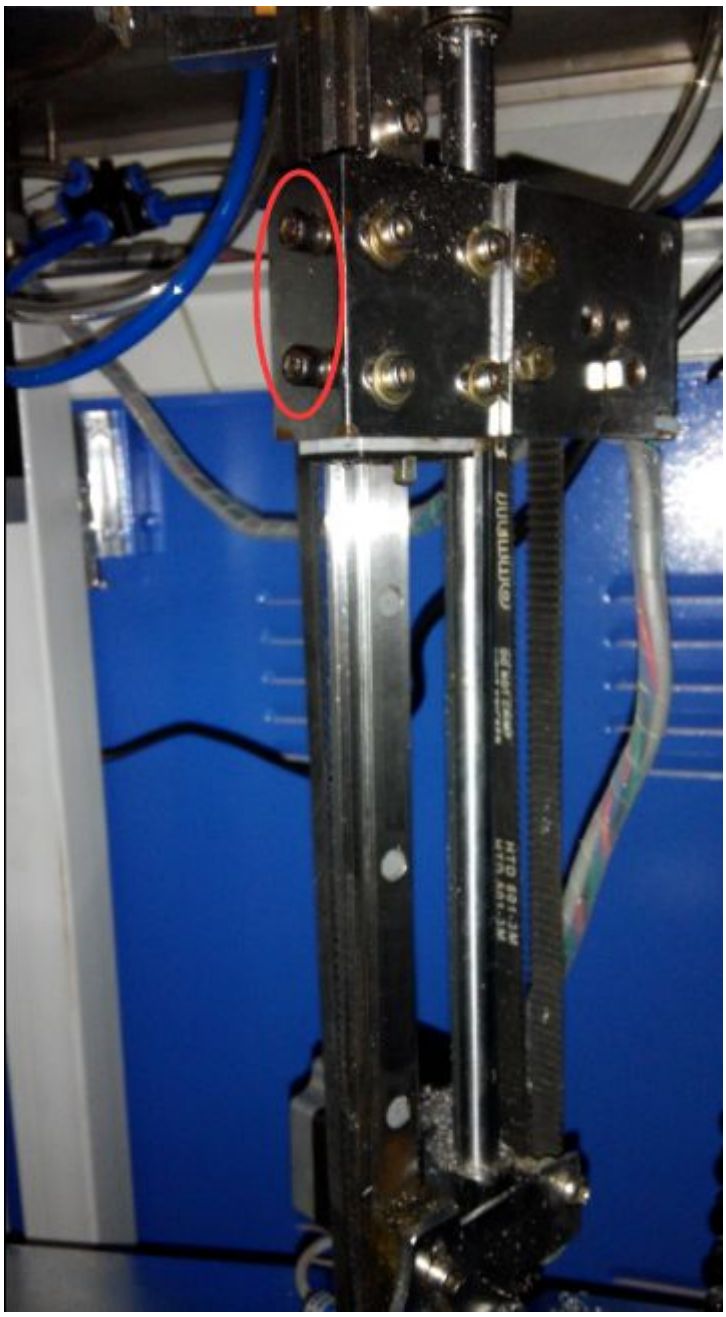
If the bending angle is not suitable,then need to adjust the parameter in the "front bend air angle".the NO in it more larger,the angle will be more small.Same with "Rvs bend air angle"



Picture C-11

Chart IIII How to adjust the cutting thickness

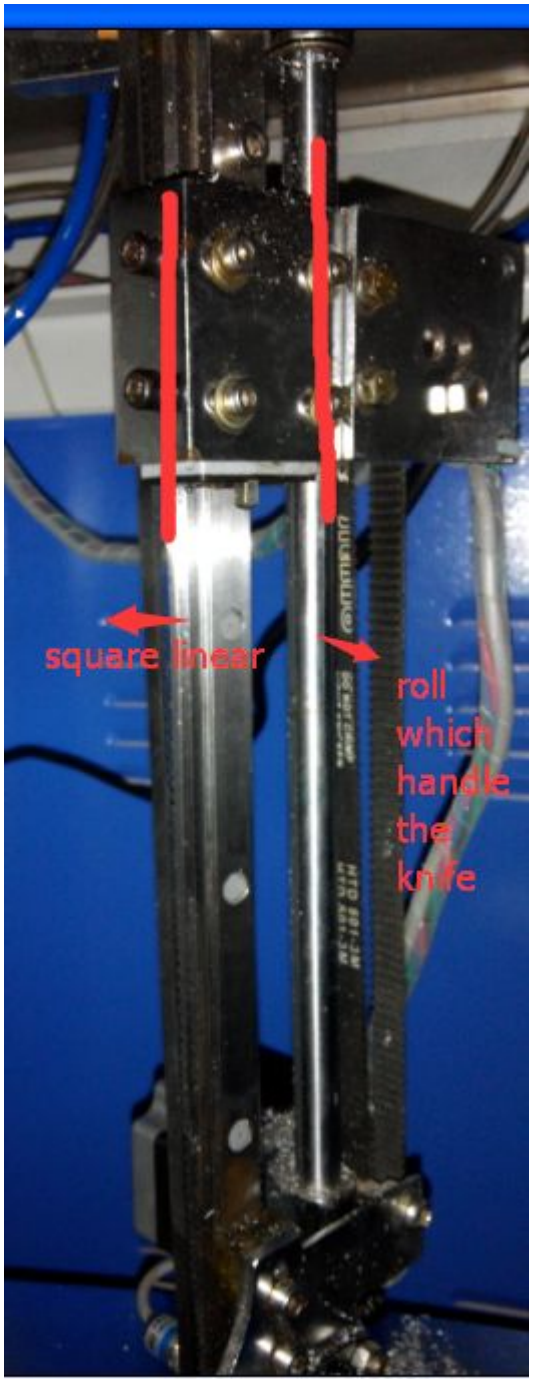
When the knife can not cut the aluminum in front or behind,we need adjust the two screws under the machine,check the picture as follow:



Picture C-12

When you tight the two screws,the knife will far away from the center of coil,so in this way,the knife will hard to cut the coil,at this time,loose the two screws,the roll which control the knife will close to the center of coil,so it will can cut coil in front as well as back.

The roll who handle the knife must be Parallel with the square linear,check the picture as follow:



Picture C-13

If it is not parallel,need to adjust the four screw which connected the roll and square linear,like the picture C-14

Picture C-13