

DH-6120 Channel Letter Bending Machine Operation Manual

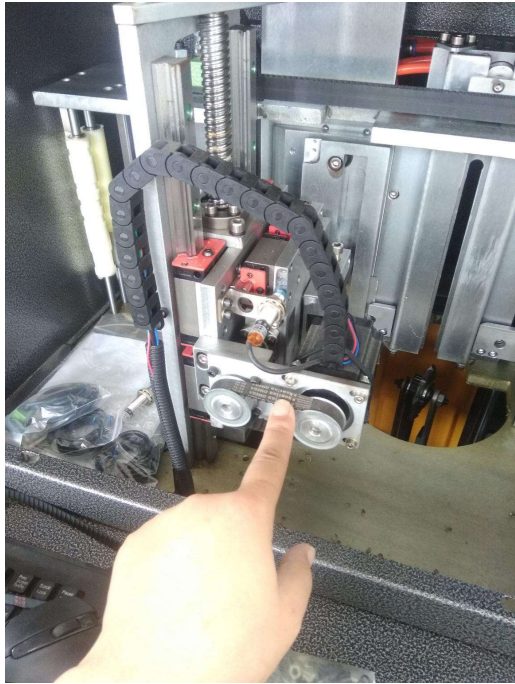
1.The first step, we need to connect power and air input (air pressure about 0.4-0.6mpa)



2.Turn on the machine



3.Use your hand touch this belt, if this belt is loosed and easy to rotary, that means now its aluminum model, if this belt is fixed and hard to rotary, that means now its stainless model



4. Next we test the aluminum first, press this button to transform model.



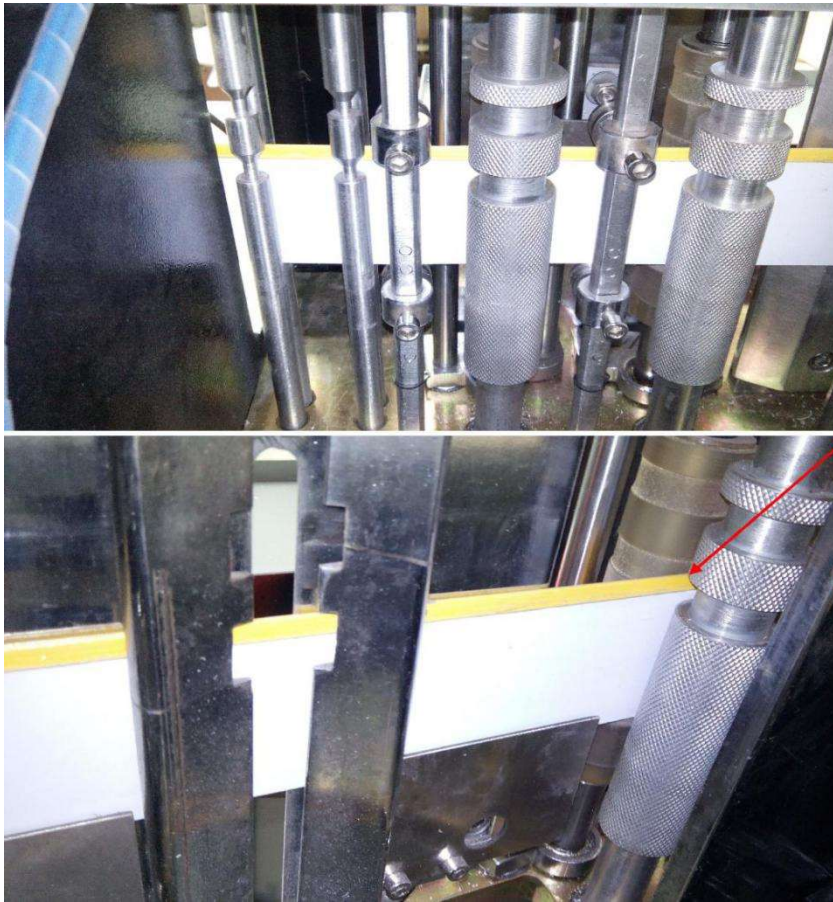
So after you pressing, feel that belt, make sure that belt is loosed (aluminum model)



This bender is for aluminum

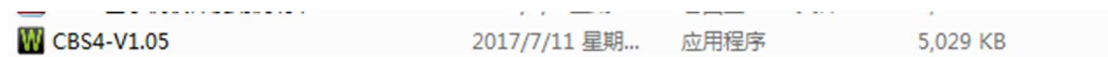
5. The first, we need to feed the material, manual feeding, put the material with cap side in the groove, material up and down with pressure roller fixed, material into iron drive wheel position
6. And we can see, as follow picture, press the button, the rubber wheel will loose, and press twice, the rubber wheel will fix. when we feed the material, we need to loose it.



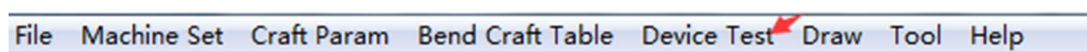


We must ensure the material reach here and make sure the cap side in the groove
 And after finish feeding, we need to fix the material, so we must press the button again.

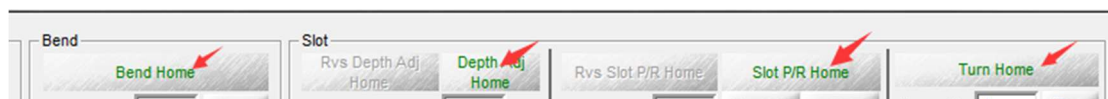
7. Next we open software: CBS4 (aluminum)



8. Open "device test"



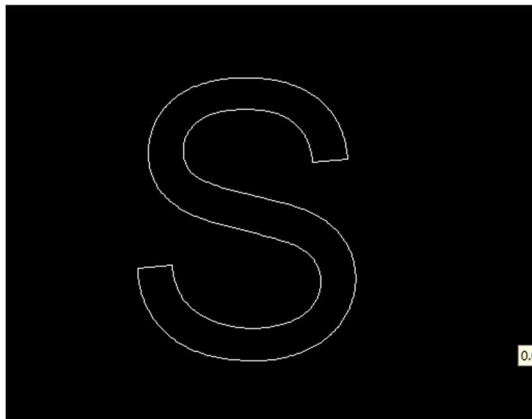
9. Press all home button from right to left



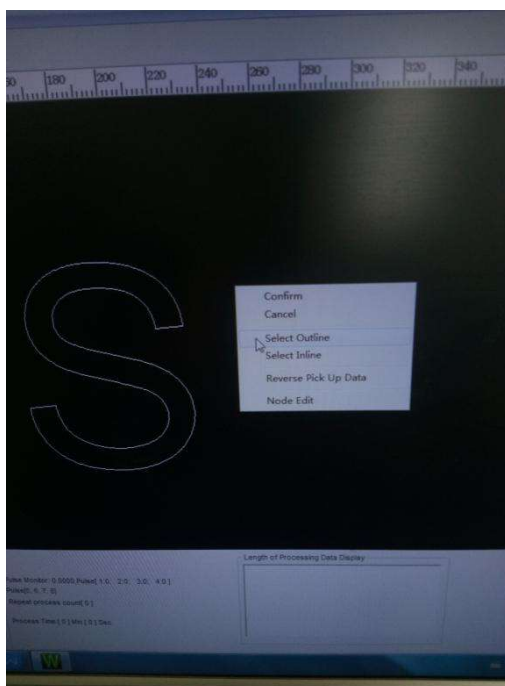
10, Find a file and open it



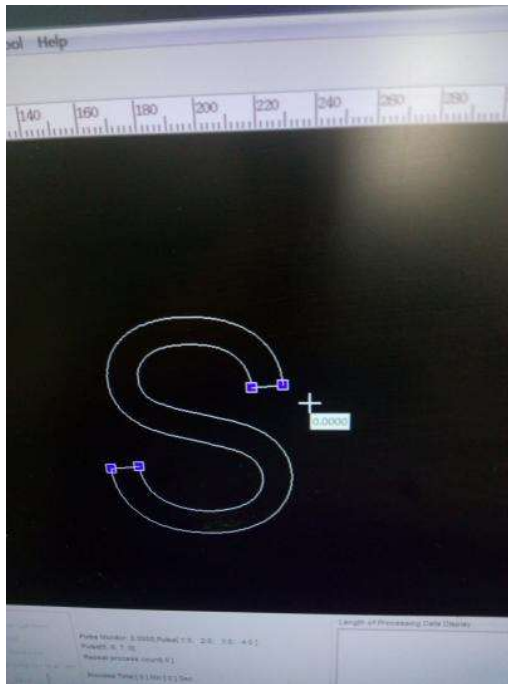
11. Open it



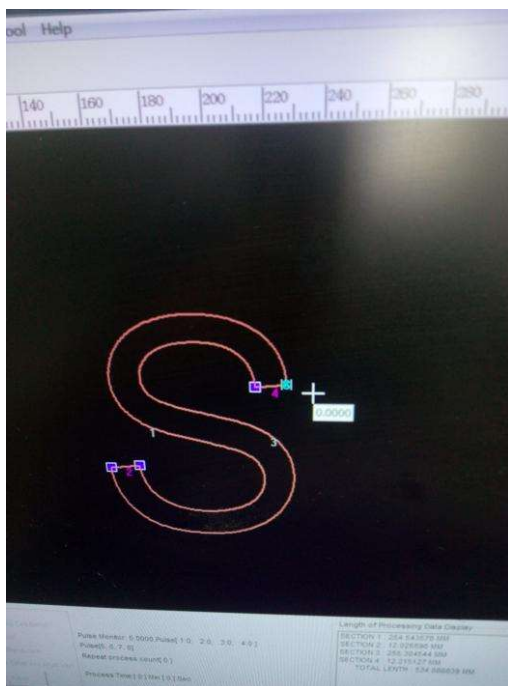
12. Right click in black area and choose select outline



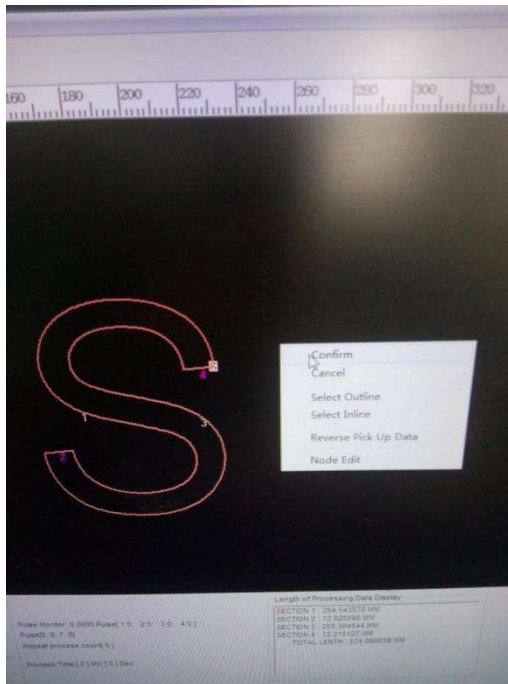
13. Then it shows like this:



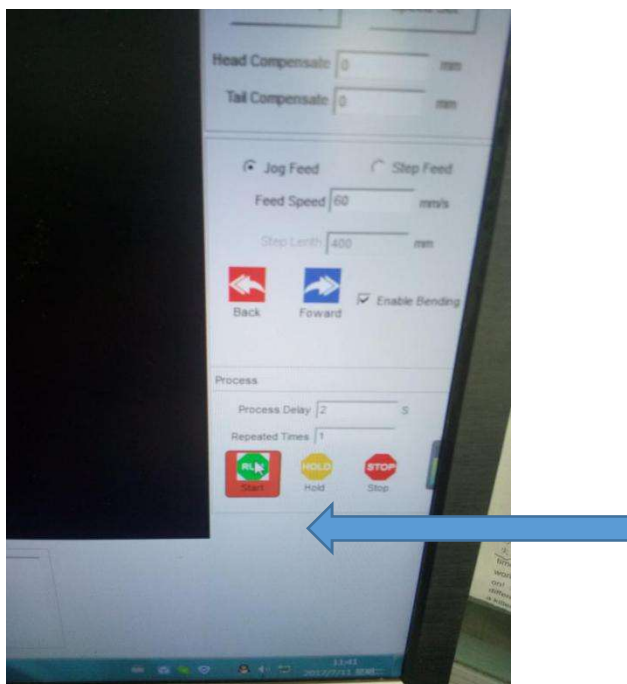
14. Choose a corner point and click it two times, then it will become red.



15. Right click again in black area and choose confirm.



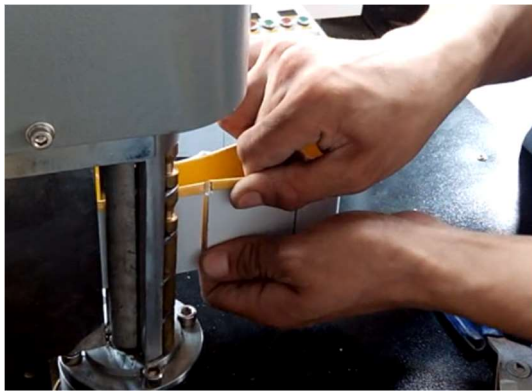
16. Now we have to choose this letter, press start/run.



17. Then the machine will start.



After finishing, break it and bend it follow as the cut line (don't use the first part, break it)

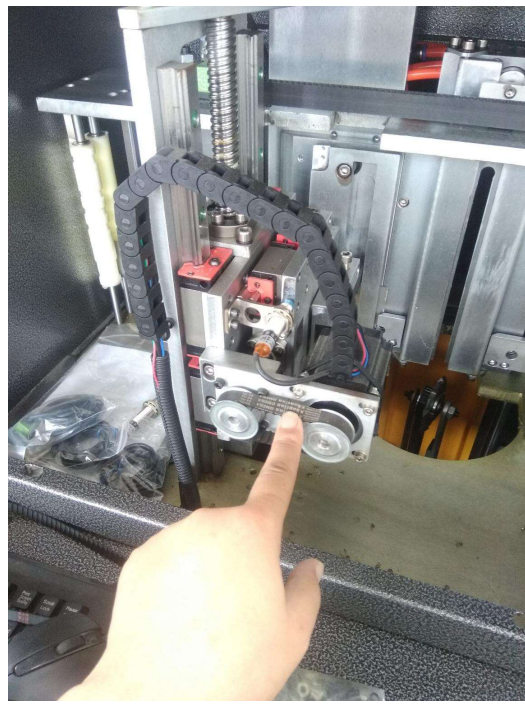


18. Making it



Now aluminum has been finished

1. Press this button to transform the model (stainless model), now you can feel that belt is fixed



2. Exchange material (stainless in the bottom)



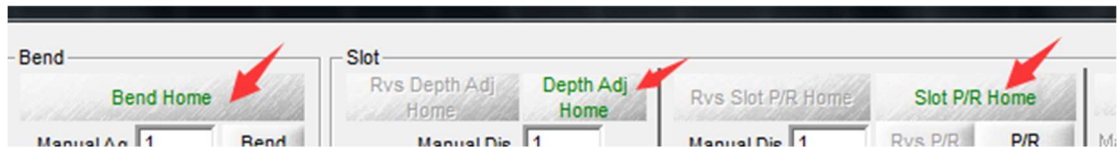
3. Press this button again to fix material



5. Open software CBS4(stainless)

6. Open "device test "again (the same as aluminum)

7. Press all of home button



8. Open the file and try to make it (same as aluminum, please read it carefully)




9.Finish

How to adjust the depth?

If you feel the cut depth is a little shallow or a little deep, you can adjust these parameter from this part

“craft parameter” ---vert parameter (follow as picture)

File Machine Set Craft Param.  Bend Craft Table Device Test Draw Tool

Vert Param	
Slot Push/Reject Param	
Material Height	60.0000
Slot Total-Dis	163.0000
Slot Depth Adjust Param	
Material Thick	0.6000
Slot Deep Adjust Home Correct	1.5000
Front Depth Correct	0.0000
Plane Tool Up Dis	1.0000
Plane Tool Down Dis	0.1000
Plane Count	3
Plant Start&End Count	3

1. About "slot deep adjust home correct" this parameter, if you feel both front side and back side are all deep or shallow, you can adjust this parameter

If deep, decrease this number, if shallow increase this number (little by little, for example 0.2)

About "front depth correct", this parameter, if you feel just front side is shallow or deep, you can adjust this number (decrease or increase)

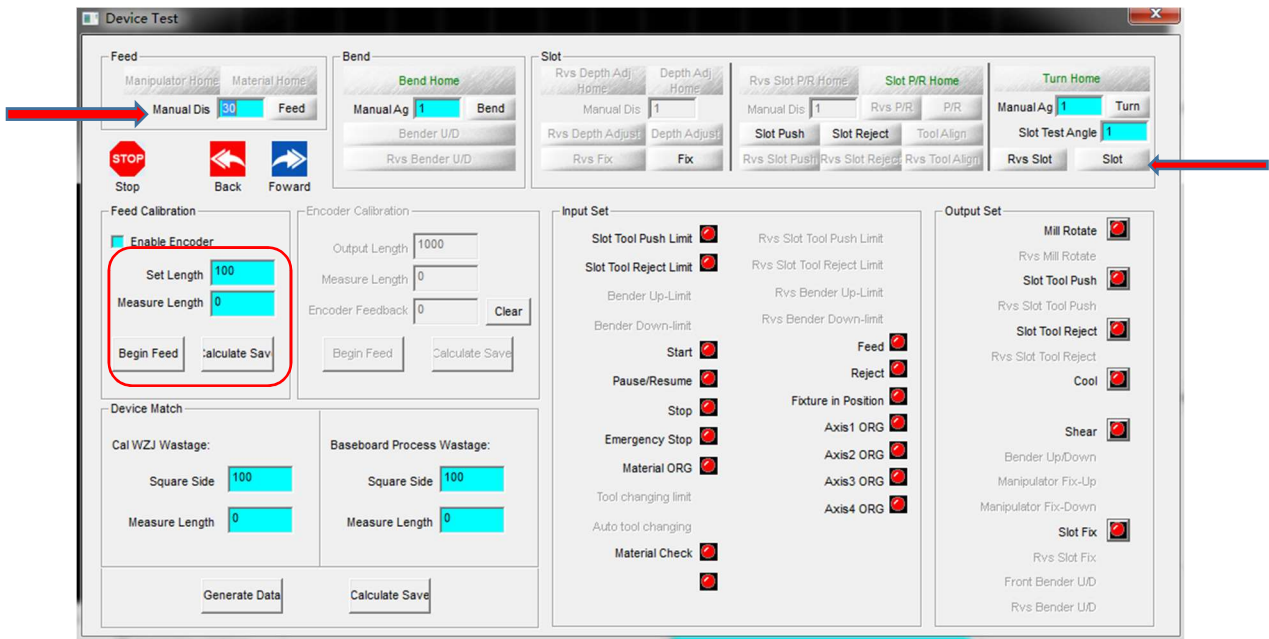
Because stainless model doesn't have back cut, so in this software, it doesn't show back depth correct (but in aluminum model, it has)

Vert Param	
Enable Depth Front Adj	Yes
Slot Critical Angle	165.0000
Slot Span	0.0000
Slot Depth Adjust Param	
Material Thick	0.6000
Slot Deep Adjust Home Correct	0.6000
Front Depth Correct	2.3000
Rvs Depth Correct	0.0000
Turn Tool Param	
Turn to Reverse Dir	-1
Turn Tool Home Dir	1
Turn Tool Home Correct	20.0000

So when you feel the depth is shallow or deep, adjust these three parameters.

How to adjust the length?

If you feel the size is smaller or bigger than the letter, you can adjust the length from this parameter



The first, please ensure your letter height, for example, you want to make a 30cm height letter, then please measure the length of material,

Slot--fill into 500(manual Dis) ---Feed just one time----slot----feed----slot----forward----come out then measure the second part, check it whether is 500mm.

1. If the second part is 500mm, that means its correct, then you need to check the letter that you cut by router (maybe the mode is not correct. do you have laser machine? the letter cut by laser machine is more exactly than CNC router)

2.if the second part is not 500mm, that means the length is not correct, then you need to adjust the length from this part (the red frame)

For example, you measure the second part is 499mm, then “set length”: 500mm (this is the length that you set: manual Dis.) and “measure length” fill into 499mm (this number is the length that you measure) ----then press “calculate save” button, remember just press one time, then test again until the length is correct.

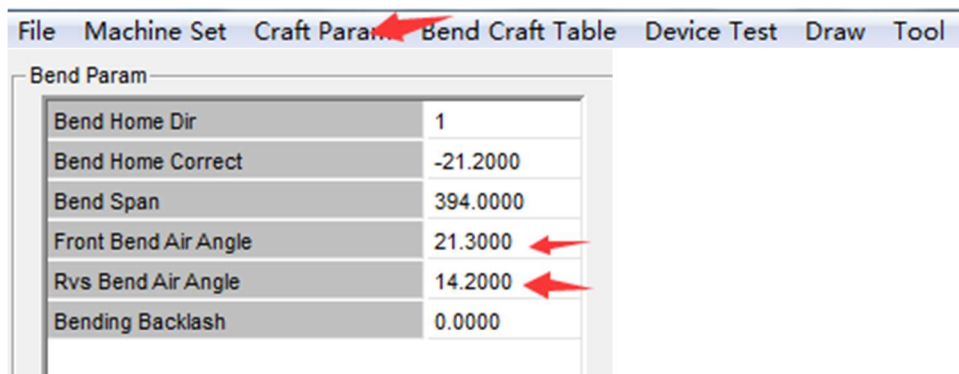
Slot--fill into 500(manual Dis) ---Feed just one time----slot----feed----slot----forward----come out then measure the second part, check it whether is 500mm.

After you correct the length, and the length is right, the letter is still small than the letter, you need to check the letter cut by CNC router.

How to adjust curve?

If you feel the curve degree is not good, and it can't suit the letter, for example, the curve is big or small so the letter from bending machine and CNC router can't suit, you can adjust this parameter

"craft parameter" --bend parameter



Bend Param	
Bend Home Dir	1
Bend Home Correct	-21.2000
Bend Span	394.0000
Front Bend Air Angle	21.3000
Rvs Bend Air Angle	14.2000
Bending Backlash	0.0000

From this picture, you can see, it include two parameters, front bend air angle can adjust back side, and "Rvs bend air angle" can adjust front side, about this, you can have a try, change one number (one of these two), try to make a letter, then you will see the curve (back or front) is changed, then you will know which parameter can control backside and which one can control front side