

# Manual

## Semi-automatic Cardboard Drilling Machine



### Technical Parameter

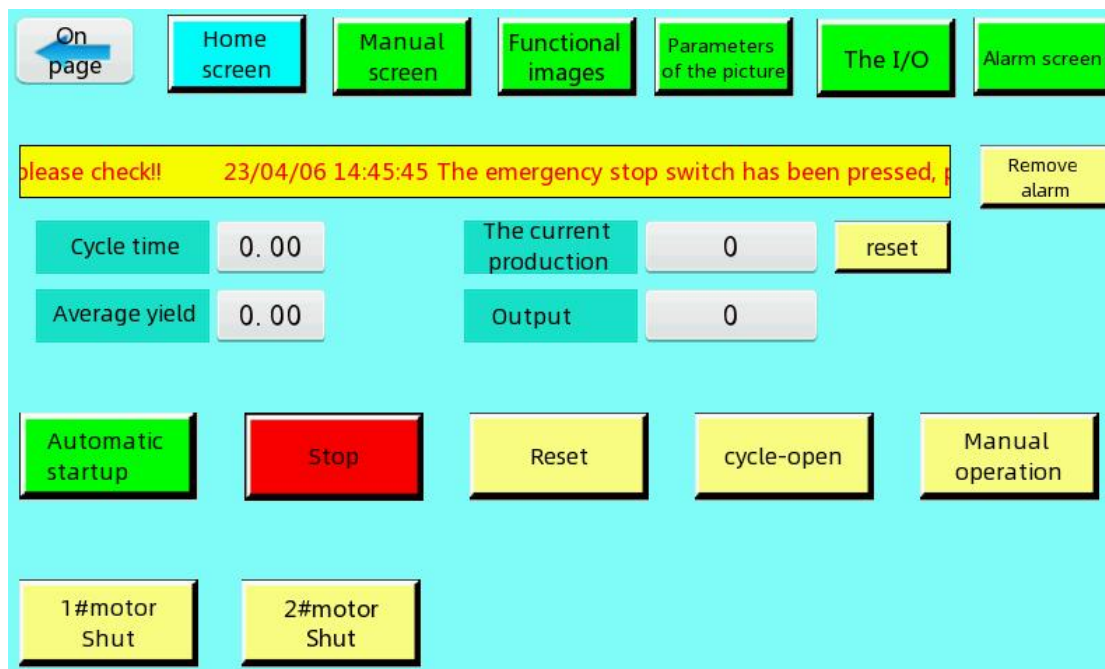
| Model                      | Ky-12H           |
|----------------------------|------------------|
| Dimensions                 | 900*750*1400mm   |
| Total weight               | 130KG            |
| Power                      | 3KW              |
| Production speed           | 20-30 pcs/min    |
| Power supply               | 220V             |
| Air pressure               | ≥0.6Mpa          |
| Min drilling spacing       | 75mm             |
| Max drilling spacing       | 400mm            |
| Nearest drilling distance  | 0mm              |
| Farthest drilling distance | 160mm            |
| Max cardboard size         | 750*600mm        |
| Min cardboard size         | 100*60mm         |
| Driller specifications     | diameterΦ8-Φ20mm |

## Start-up preparation

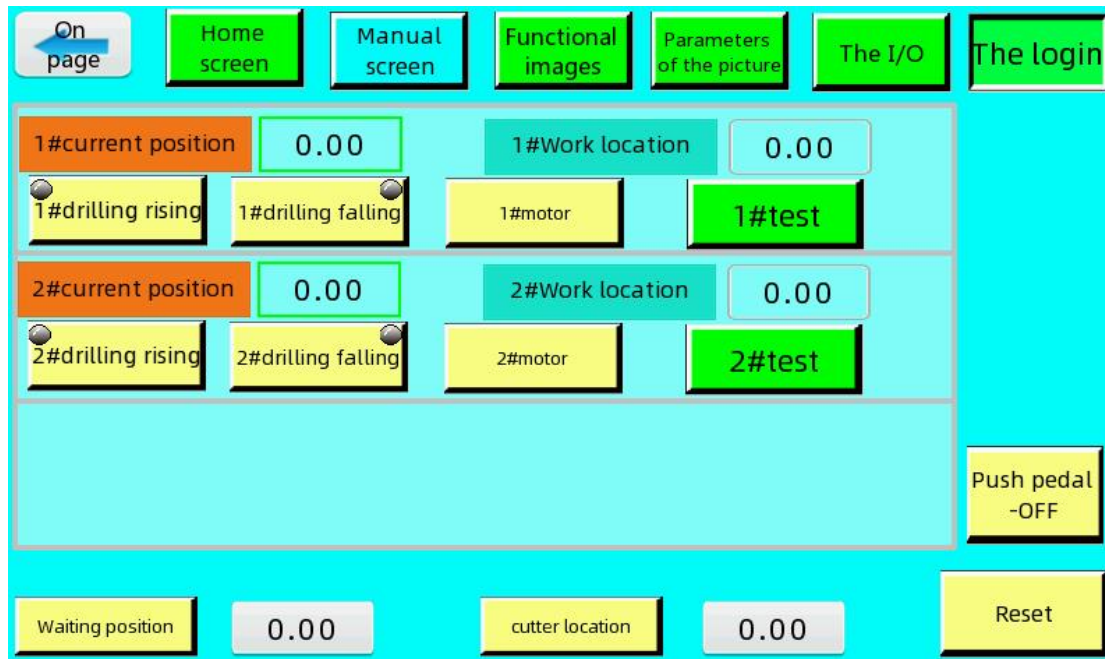
- 1、 Check if the equipment is intact, adjust the machine position and adjust the ground feet so that the castors are off the ground to achieve smooth placement.
- 2、 Turn on the 220V power supply.

## Commissioning

1. Turn the switch to power on the home screen
2. Click "reset"



3. Enter the manual screen



4. Remove the sealing cover from the drilling motor



5. Place a piece of cardboard on the working platform that needs to be drilled.

6. Click "1# drilling falling" and bring the 1# drill bit to a height of approximately 1mm above the cardboard.



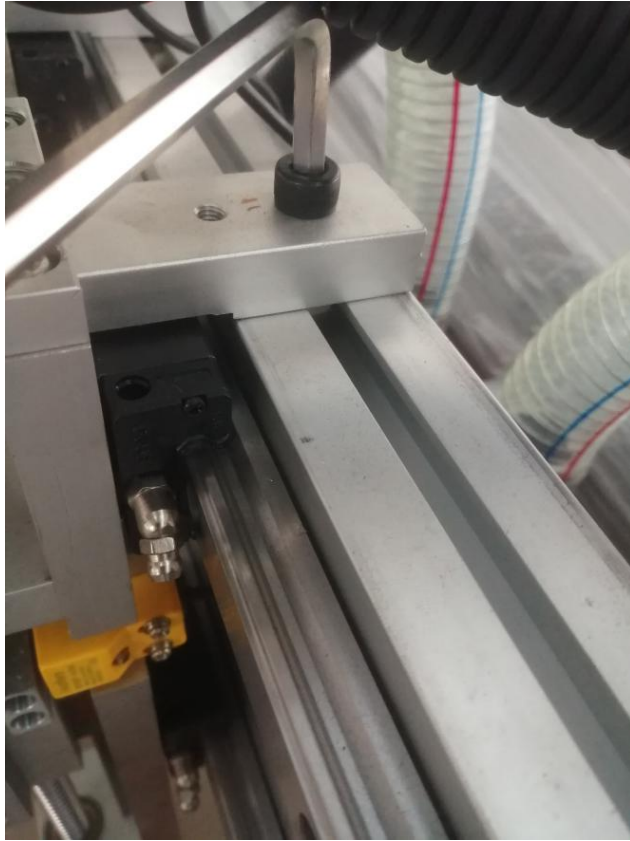
7. Enter the value of "1#current position" into "1#work location".

(Note: To modify the parameters, you need to log in with your password, click "login", enter your password:112233).

8. 2# drill bit also adjusted as 1# drill bit.

9. Set the value of the "waiting position" (Note: the value of the "waiting position" are usually about 20mm smaller than the value of the "work location").

10. Adjust the distance between the two drill bits, loosen "locking screw"



11. Turn “the adjustment handle” and adjust the cardboard position so that the drill bit is well positioned for drilling the cardboard.



12. Position the cardboard with the positioning block and lock the locking screws.

13. Click "1# drilling" and wait 3 seconds for the motor to reach a steady speed and click on "test". Finish the test to see if the drill holes are in the correct position. 2# is tested in the same way.

14. Attach the sealing cover (Note: the bottom of the seal must be 2mm lower than the drill tip, the drill bit must not protrude).

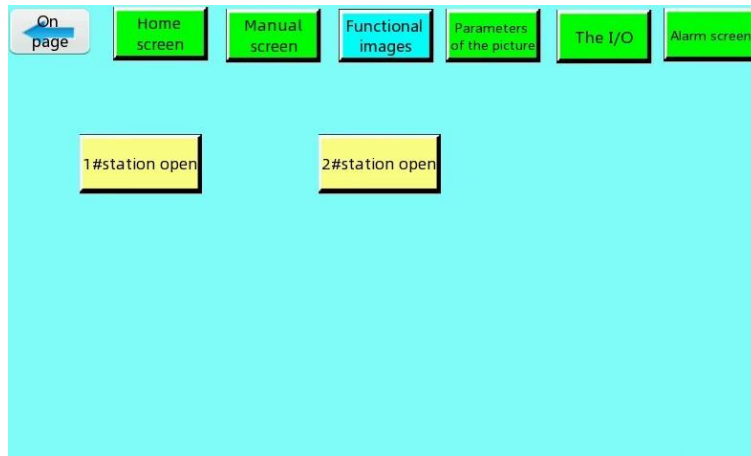
15. Drilling depth is adjusted by adjusting the coordinates of the drilling work position. If the value are large, the hole is deep, if they are small, the hole is shallow. Turn off the drilling motor when the test is complete.

16. Go to the automatic page, turn on the drilling motor and vacuum cleaner. Put the cardboard on the platform, click "start" and see if the drilling meets the requirements.

17. After the commissioning is completed, switch the "cycle open", switch the "manual mode" to "automatic mode" and then start the production work.

## **Single and double hole switching**

1. Go to the "functional images"



2. When drilling 1 hole, open "1# station" or "2# station".

3. When drilling 2 holes, open "1# station" and "2# station" at the same time.

## **Replace the drill bit**

1. Remove the seal cover of the drill bit.

2. Use an open-end spanner to jam the nut on the motor shaft and motor shaft respectively, reverse the force and spin the nut loose to remove the drill bit.

3. Fit the new drill bit to the highest position and lock the nut slightly to prevent the drill bit from falling off.

4. Click "cutter location" to lower the drill into place and place a piece of cardboard approximately 2mm thick underneath the drill.

5. Loosen the nut on the motor and pull the two drills down so that the tip of the cutter touches the surface of the cardboard and then lock the nut.

6. Click "reset", enter a number 1 larger than the value of the cutter location in the "work location" and then carry out a drilling test to see if the drilling depth is up to standard.

## **Device screen and operation in detail**

1. What is displayed in the equipment page represents what mode.

2. The current production in the home screen is zeroed: long press "reset" behind the current production until 0 is displayed.

3. "automatic speed" in the parameter page: this speed is the speed at which the drilling motor rises and falls during automatic operation.

4. "manual speed": This speed is the speed at which the drilling motor rises and falls at the manual point.

5. "depth of the speed": This speed is the speed at which the drilling depth is reached, and the speed affects the effect of drilling.

6. "Depth of the position": the depth is generally smaller than the thickness of the cardboard to be drilled.

7. "cycle time": this time is awaiting time to drill again.

## **Daily maintenance**



- 1.Keep the machine clean.
- 2.Regularly wipe the guide rails and filaments and other moving places, and add a small amount of machine oil (about twice a week, depending on the working environment to increase or decrease).
- 3.Vacuum cleaner to clean dust once a shift, depending on the working conditions on site.