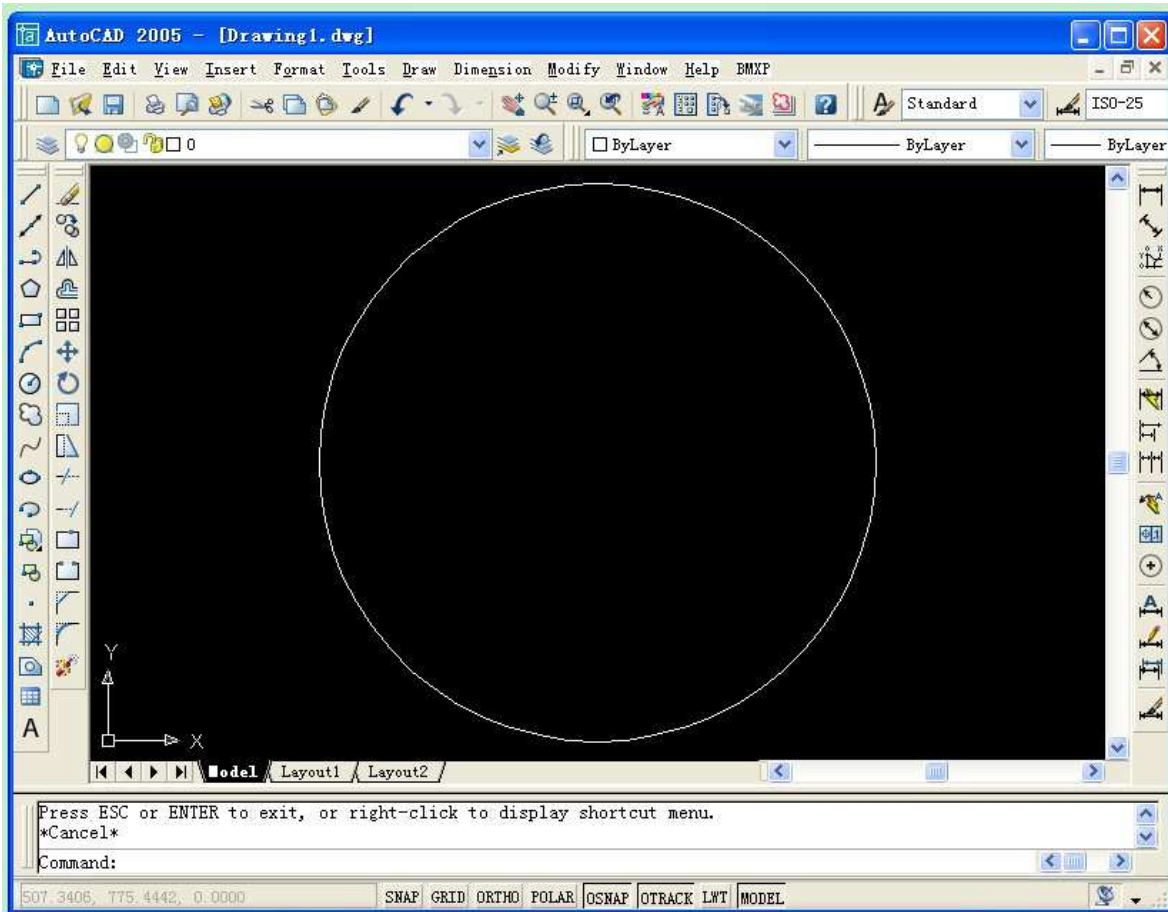
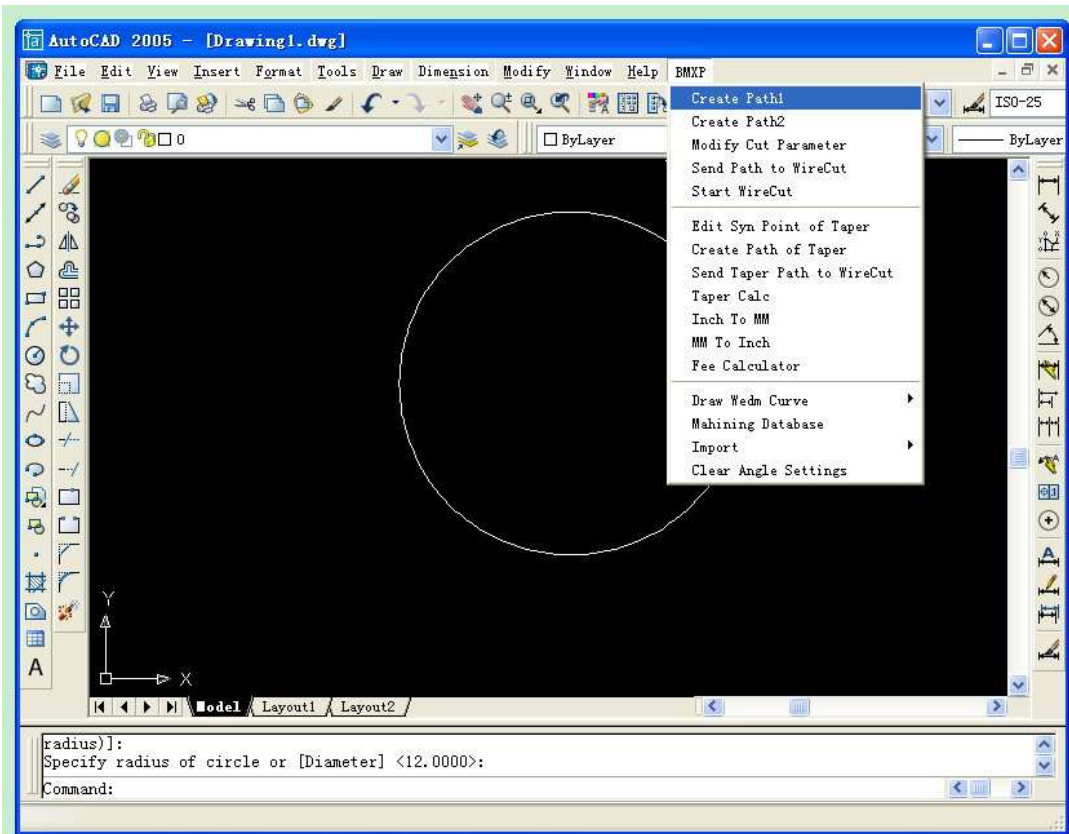


1. Program a drawing, we take a circle for example



2. After drawing, please choose “BMXP”
- Create Path1 (use for one time cutting)
 - Create Path2 (use for multi-pass cutting)
 - Create Path Taper(Use for taper cutting)



3. Input all the parameters for the drawing and click “OK” to next step

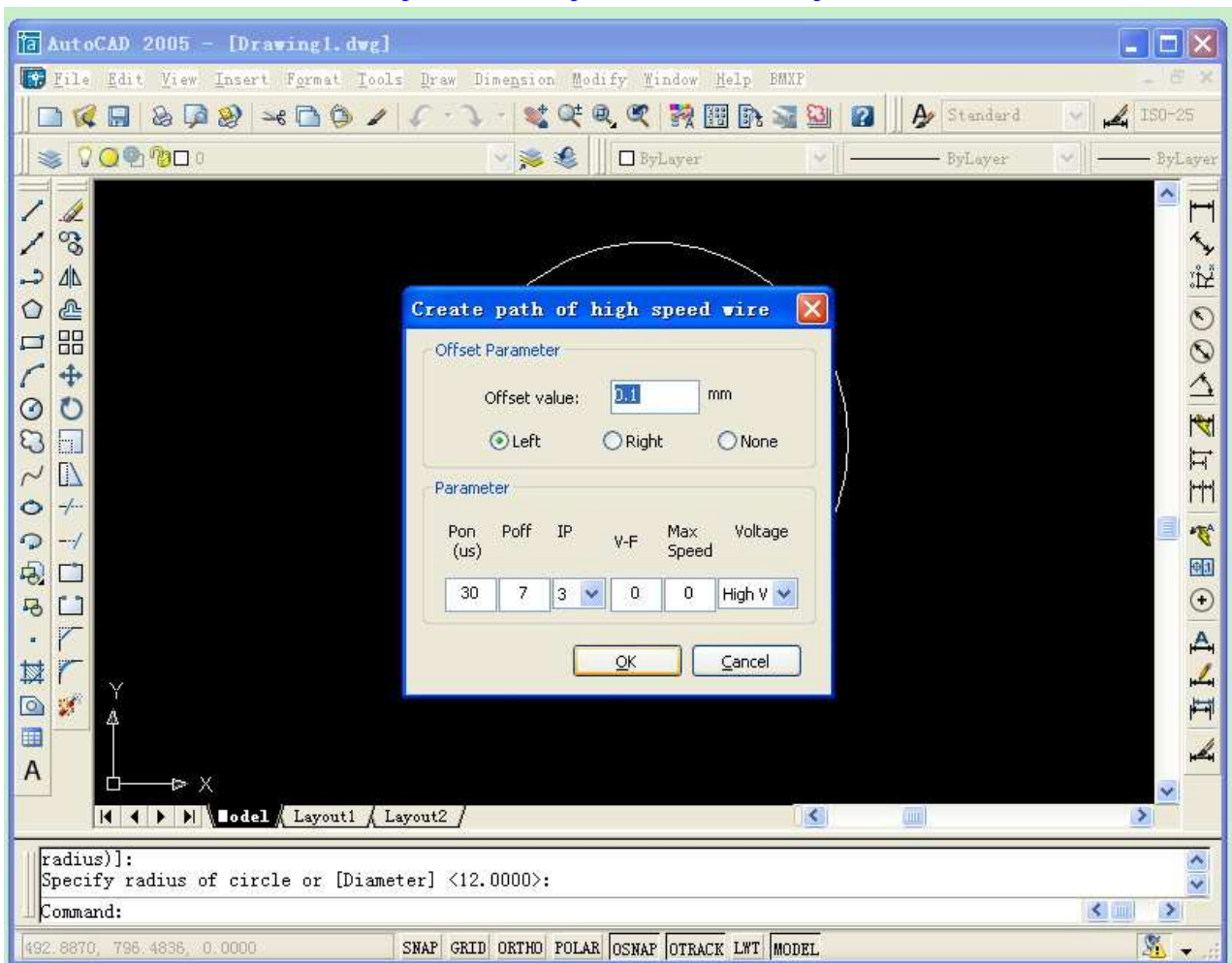
Pon, means the pulse on time, the bigger you choose the Pon, the cutting speed will be higher, but the surface finishing will be worse and the wire easy to be broken.

Poff, means the pulse off time, the bigger you choose the Poff, the cutting speed will be lower, but the surface finishing will be better. And the chips will be easy to remove.

IP, means the Power you choose, the higher you choose, the cutting speed will be faster, but easy to broken the wire and the surface finishing will be worse

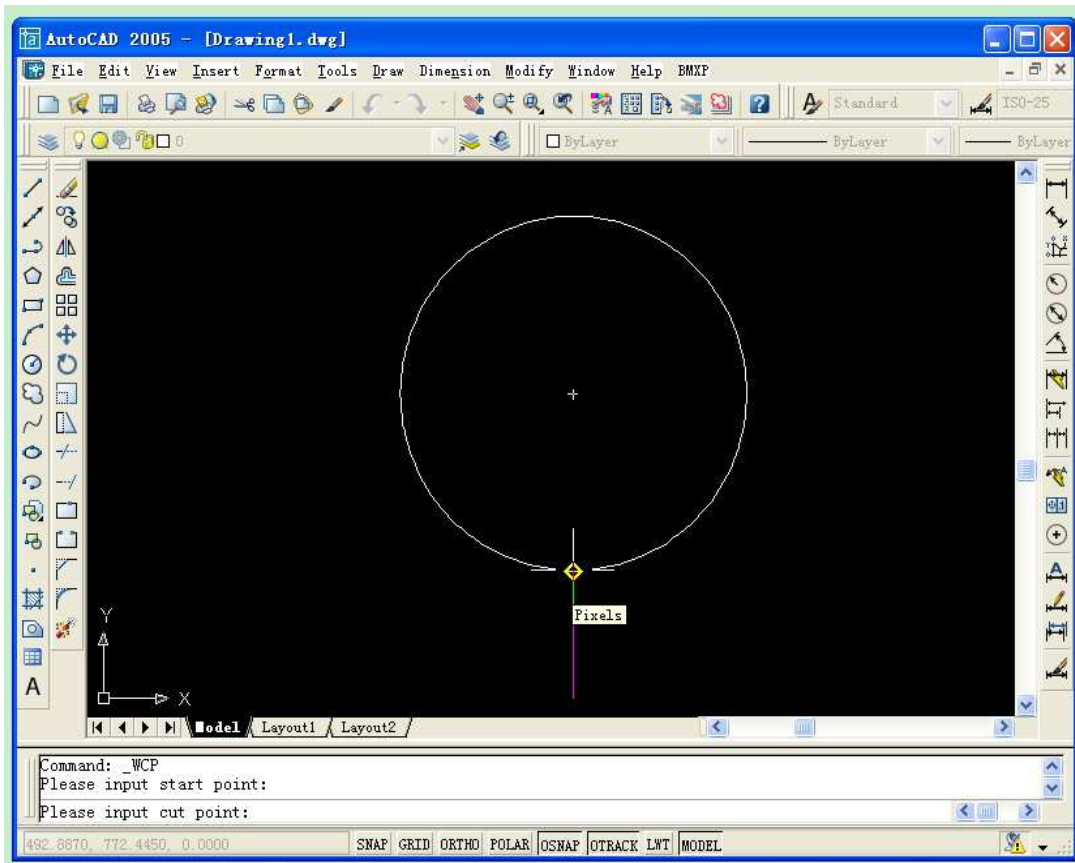
Max speed, means the wire winding drum running speed. During putting the wire to the drum , you should choose the lowest speed level “3”. For normal cutting, we always use level “0” the highest speed.

offset, here we choose Left for example.(we will explain this in follow step)

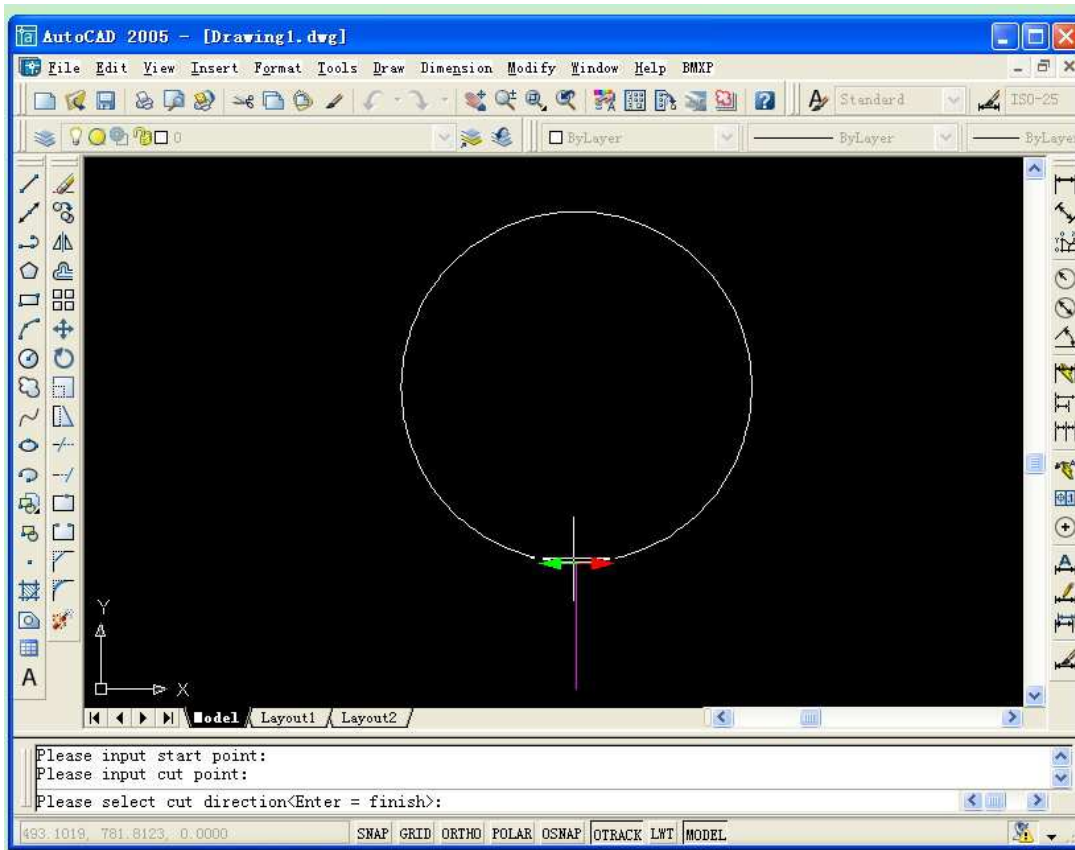


4.This step is for adding the lead-in-out line. You can choose one point out of the drawing as the start point of the line, and choose one point on the drawing as the end point of the line.

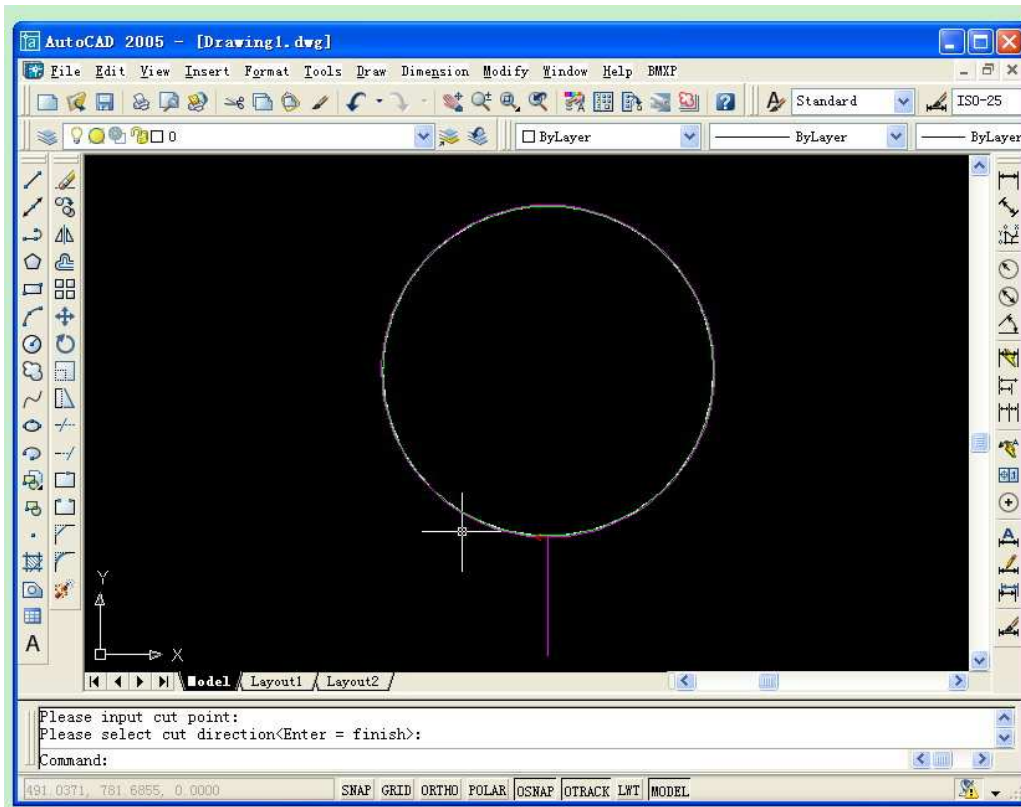
(please attention, the first point should out of the drawing, the second one should on the drawing)



5. Choose the cutting direction. We choose offset "left" in the 3 step. Now is we choose the "red" direction, it will cut along inside of the circle, the hole surface will finishing.(we get female mould)
If we choose the green direction, it will cut along outside of the circle, the small circle column will get better finishing. (we will get male mould)



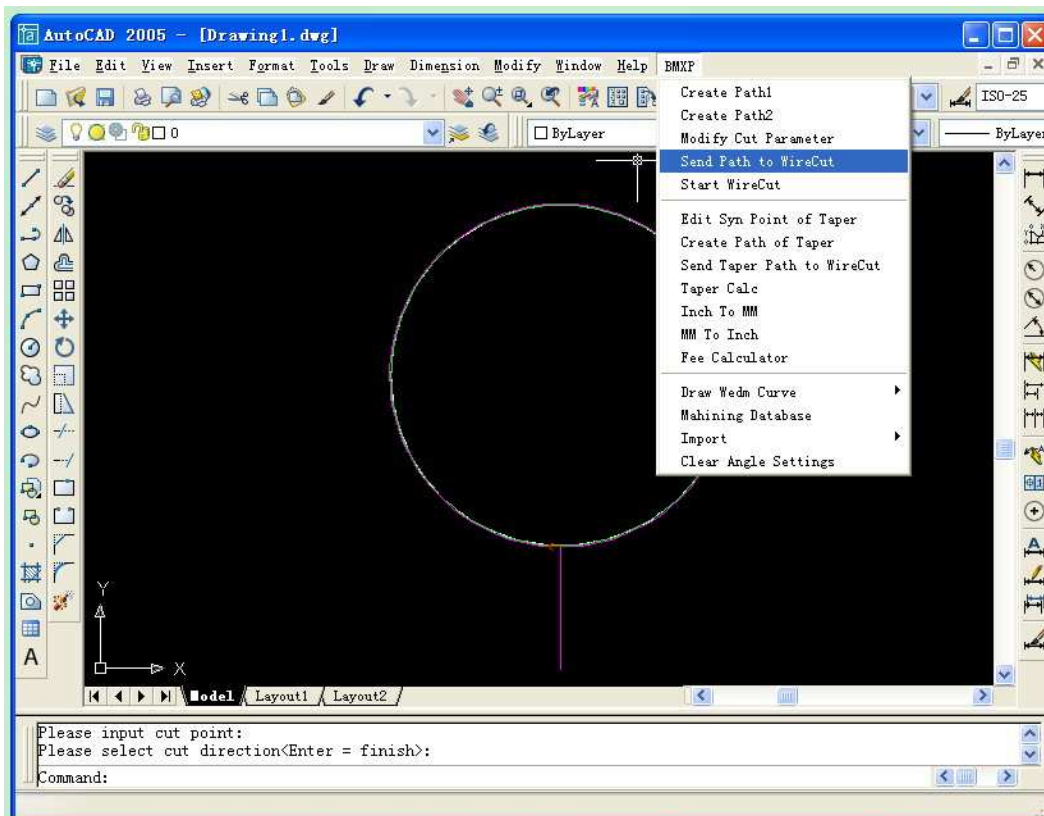
6. You can choose direction by clicking the red or green “arrow”



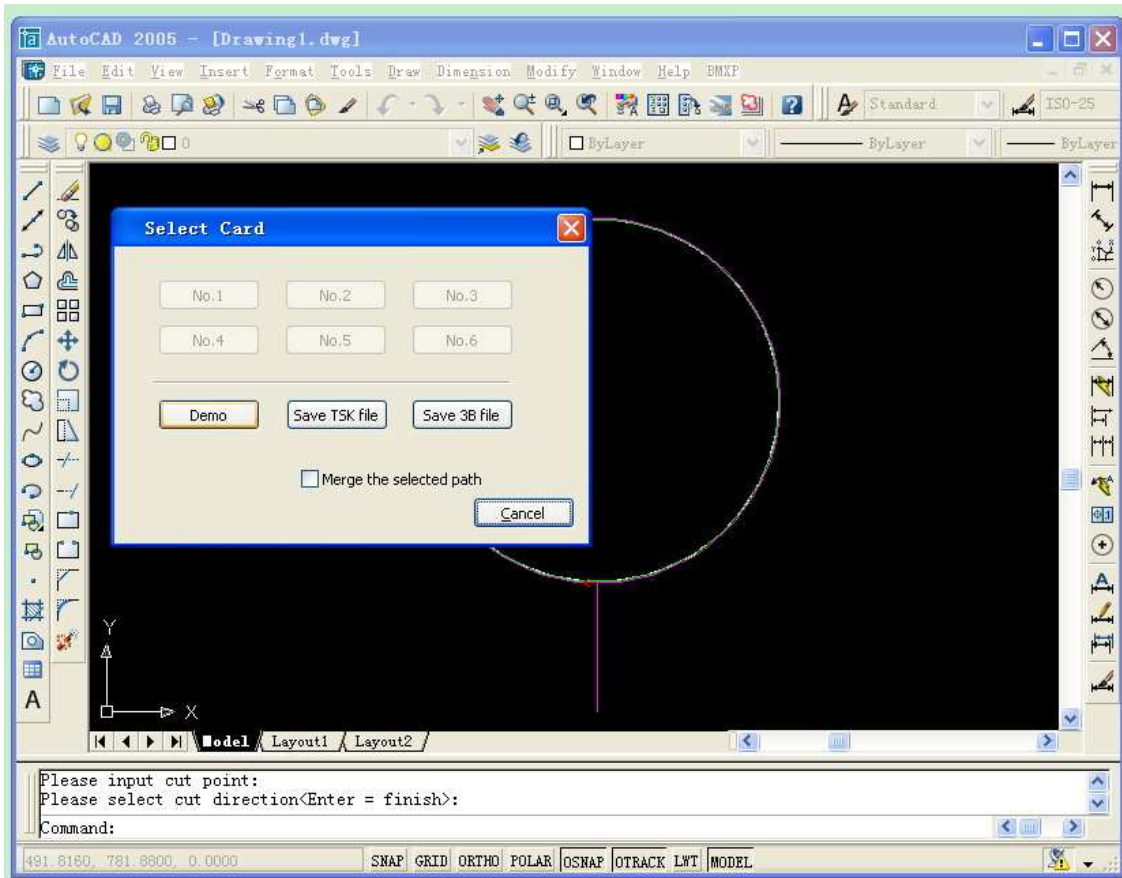
7. If you choose 1,2 in step 2, here you should choose “send path to Wirecut”

If you choose 3. in step 2, here please choose send Taper path to Wirecut.

1. → Create Path1 (use for one time cutting)
2. → Create Path2 (use for multi-pass cutting)
3. → Create Path Taper(Use for taper cutting)

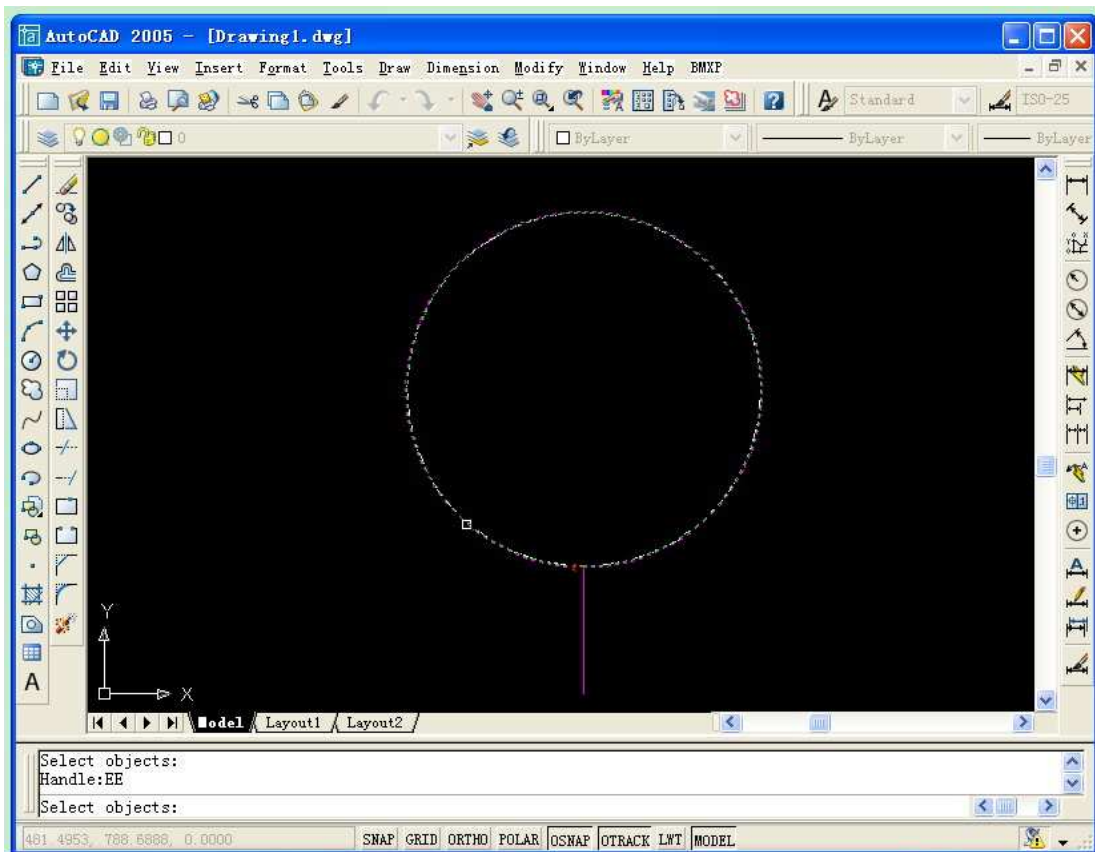


8. Please choose **NO1** card.

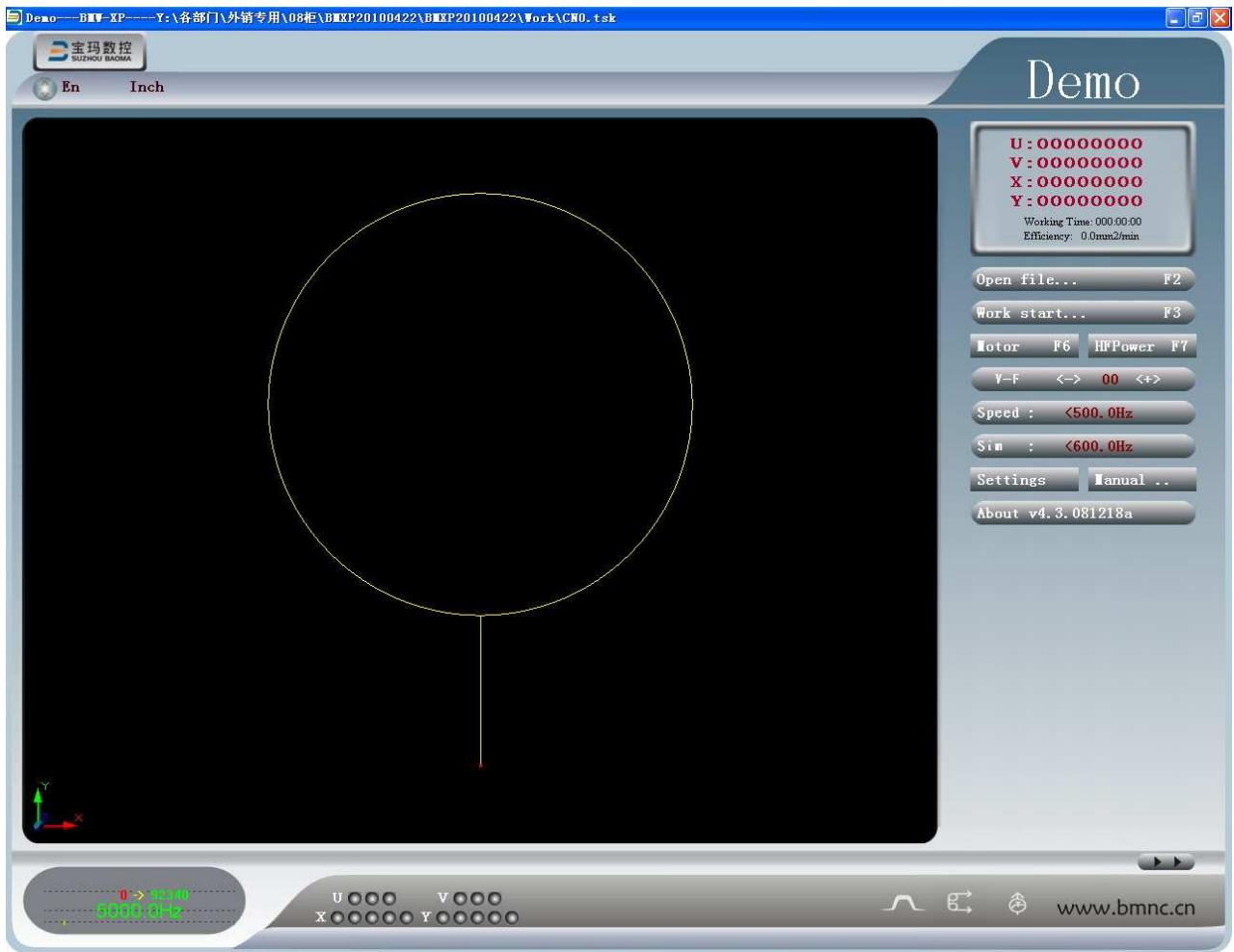


9. Now click the drawing with left button of the mouse to choose the drawing.

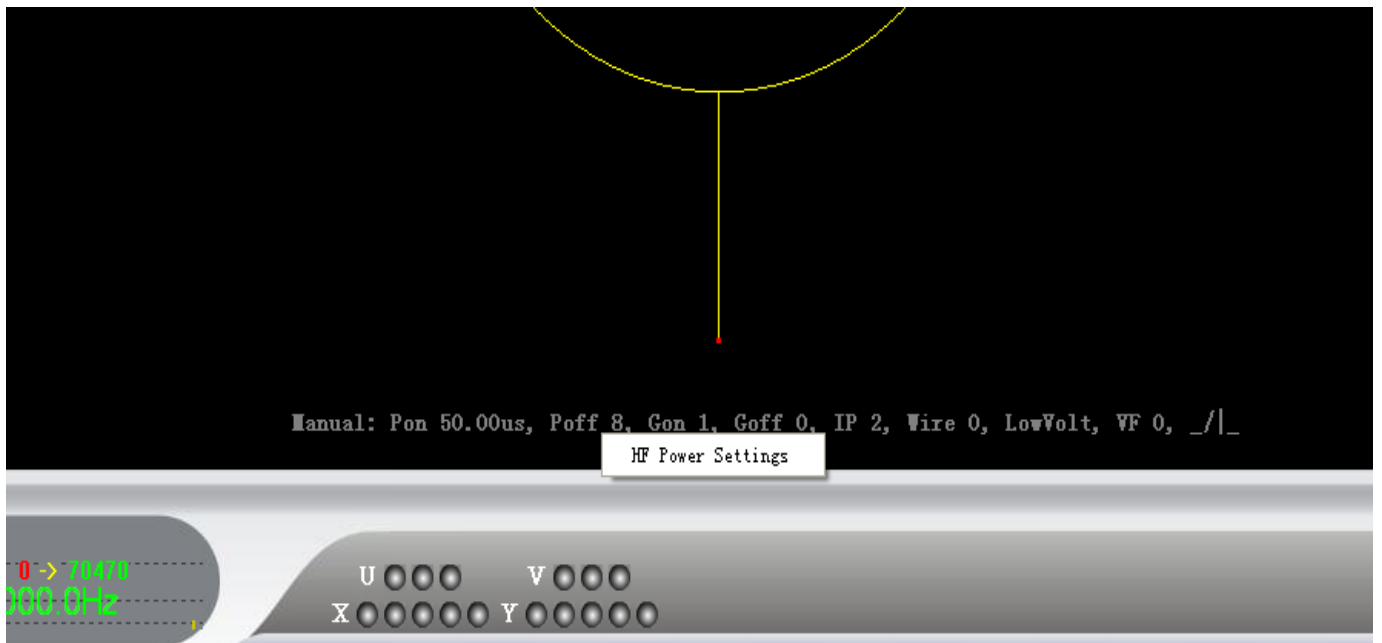
Then click one time the right button of the mouse to send the drawing



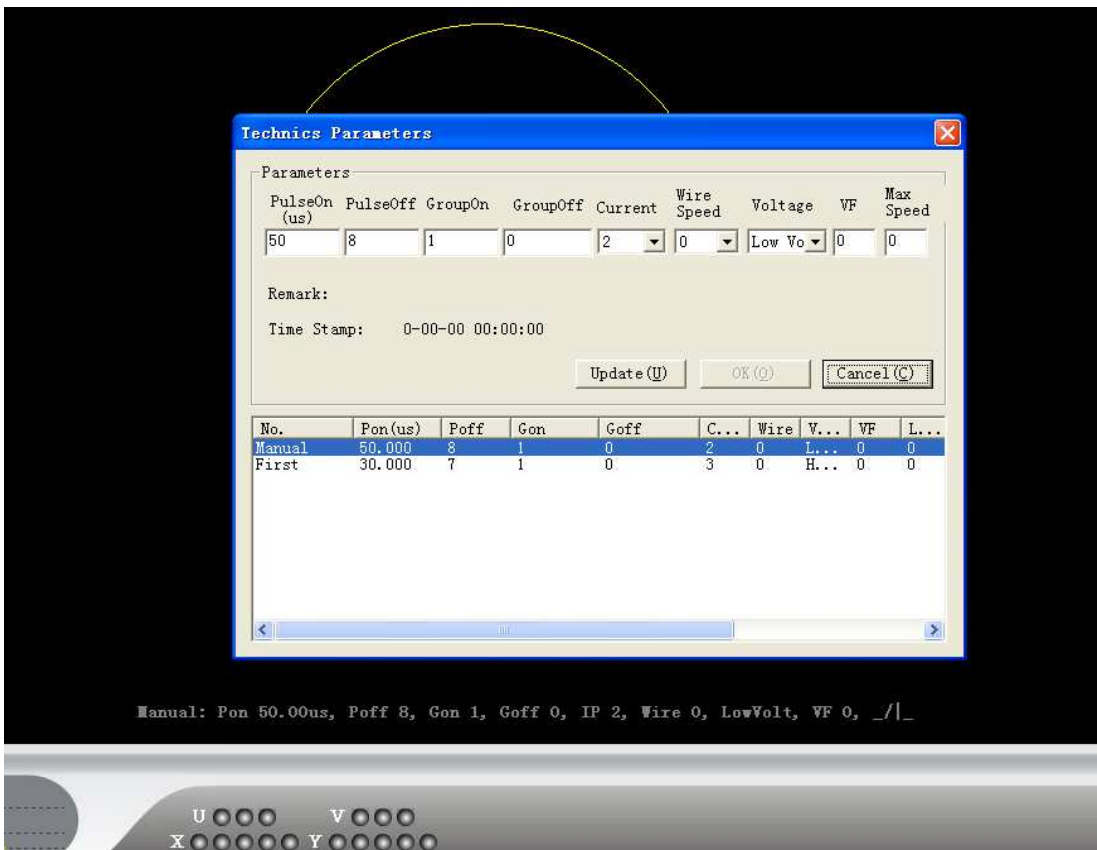
10. You will see the drawing has been send to the processing interface.



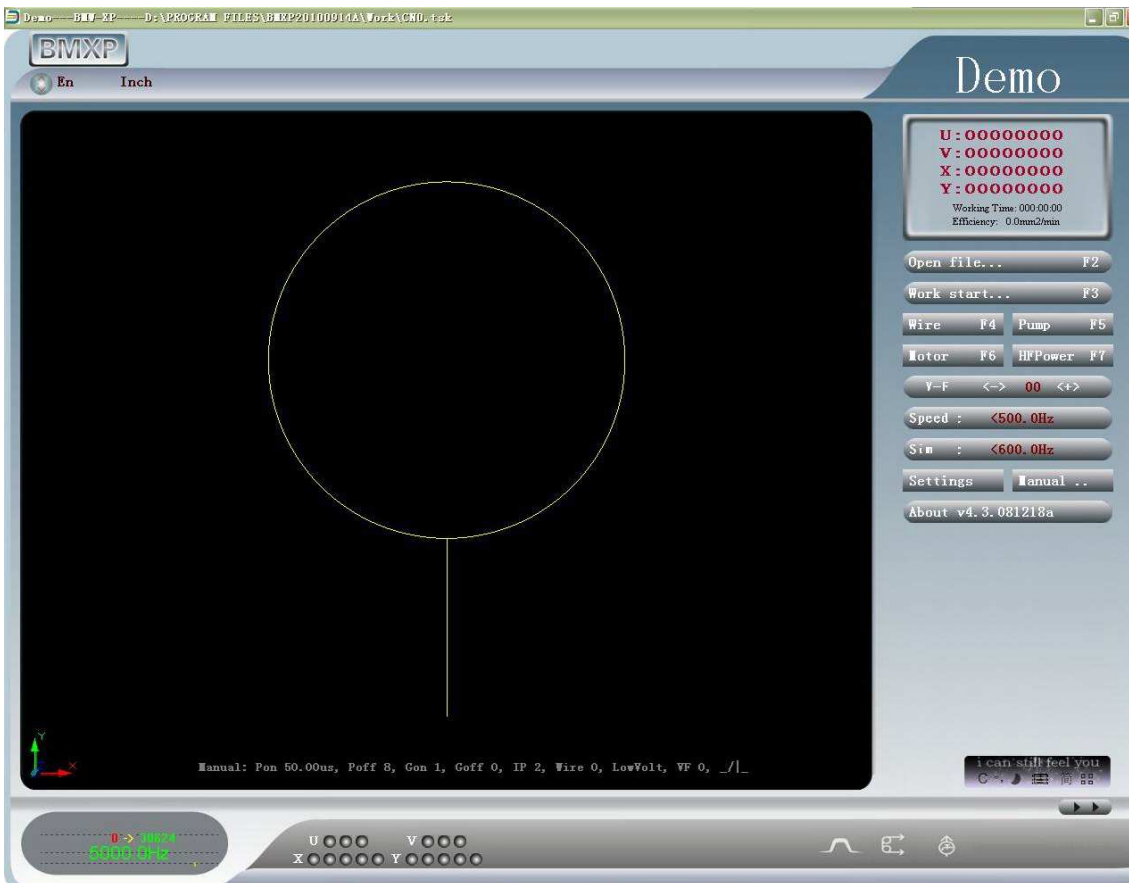
11. Setting the parameters. Please –right-click the mouse. And choose the HF power setting.



12. You will see follow Picture. Please change GroupOn is “1”, GroupOff is “0”, Current you can choose 1-6. The higher you choose, the cutting speed will be higher, but the wire easier to broken.



13. Then you click “Update”, “OK”, you will see the following images.



“Open file”: If you click “open file” button or use shortcuts”F2” or right-click” open file”, will pop up the drop-down menu,choose”open file”, will pop up the dialog box which is shown below, you can click on anyone type of the file types, then choose the file which you want to process, open it and begin to process(ISO-G CODE,AUTOCUT etc.)

“Motor”: this keystroke is used to lock or unlock the motor for the axis

“HF Power”: this keystroke is used to open or turn off the power

“Wire”: this keystroke is used to open or turn off the wire winding

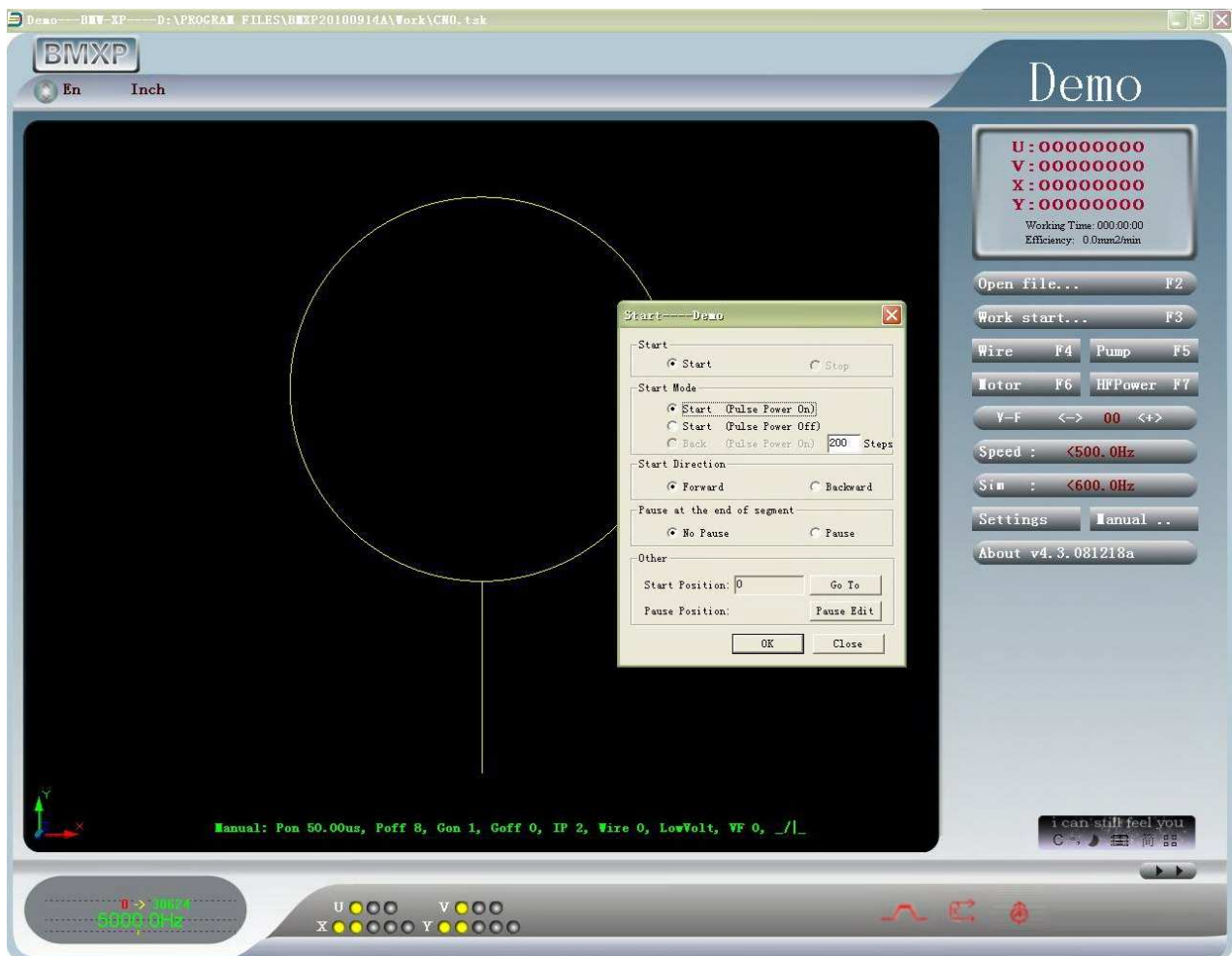
“Water”: this keystroke is used to open or turn off the pump

“V-F”: This order is used to keep the processing steadily, processing thick work-piece will make the program not steady, and it needed to be changed with a big number to make the process run steadily. Click the red number, the dialog will be display on the screen. The V-F number within the range of 0-500

“Speed”: ax speed with work-piece, to limit max process speed , unit: step/s(Hz)

“Sim”: Max speed without work-piece, to limit the max process speed without work-piece, unit: step/s (Hz)

14. Before cutting, you should make sure the wire is vertical with the work piece, and then you should turn on “Wire”, “HF Power” to make sure the wire can touch the work piece, and then you will see the sparks and adjust it. Then you should turn on “Pump”, you will see the water flowing, then click “Motor”, and the X axis and Y axis can not be moved. At last, you click “Work Start”; you will see the image as follows:



Start (Start: start to process; Stop: stop working)

Attention: Do not exit the program on working, please stop processing before exit.

Start Mode:

Start (Pulse Power On): Open the power, and start cutting

Start (Pulse Power Off): the machine move according the program without open the power.

Back: Open the power and back to appointed steps. (The appointed steps can be set while you setting the interface and will saved until you revised the setting next time)

Start Direction :(Forward: processing direction is as the same as the direction of the trace, Backward :processing direction is opposite to the direction of the trace.)

Pause at the end of segment (No pause cutting: there is only trace during the work, it will step when the process is finished. Pause: it will stop when a section of line was finished.)

15. Then you click “OK”, it will begin cutting. Please see the images as follows.

