



# USER GUIDE

**Pirina SML 1000 17031**

**v.10.2012**

## Pirina SML 1000 17031



## Pirina SML 1000 - 17031



The background features a stylized wireframe of a human head with a gear inside, overlaid with a red grid pattern. To the right, there is a stack of several white cardboard boxes, some of which are open.

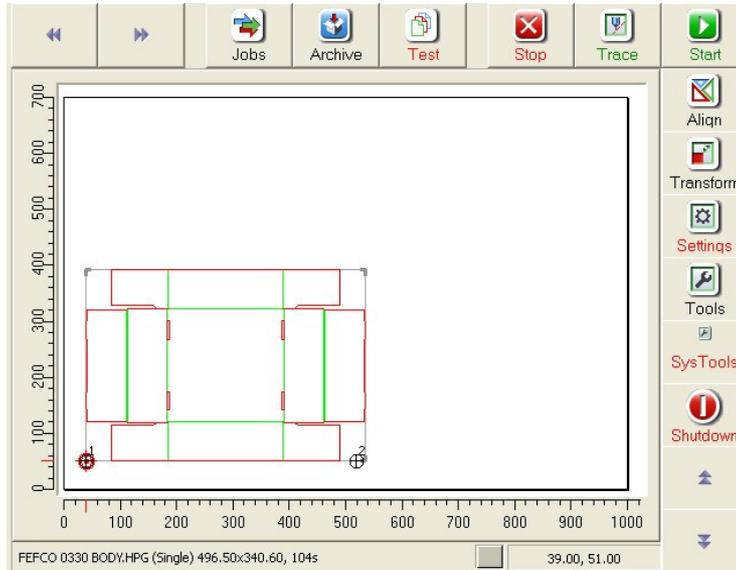
**PIRINA**  
TECHNOLOGIES

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Firmware version: 2.1.29, built on 09.08.2012

100%

Initialize

## Plotter main window (with a loaded job)

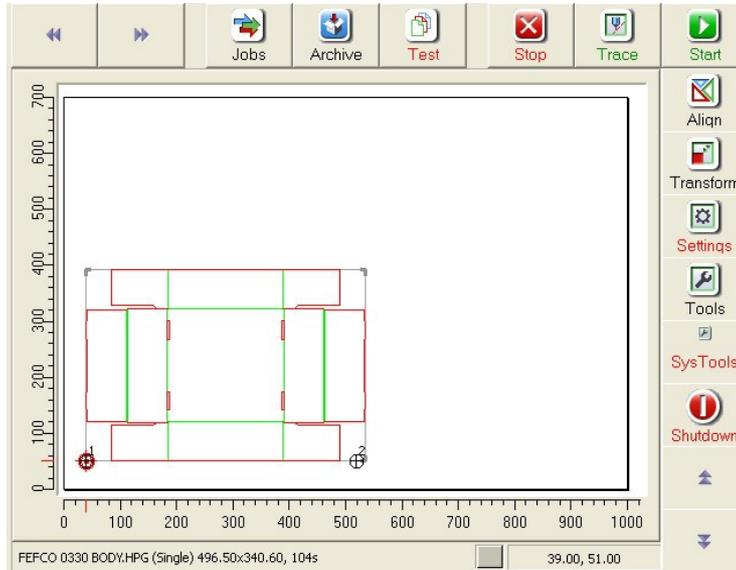


*Loading files*

- Use  to load a new file  
or  to load an archived job

Pay attention which tool head is mounted on the machine and select the respective tool head from the  menu. See *Tools menu* (p. XX) for details.

## Plotter main window (with a loaded job)

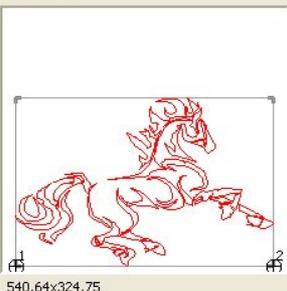


The name of the current job (Fefco 0330 body.hpg in this case), the type of the file – single or double, the dimensions of the file (496.50x340.60) and the estimated time for completing the job (104s) are displayed in the lower left area of the main screen.

## Jobs window

Name	Date ▾	Type
HORSE.HPG	14.08.12	Single
VANQUISH _LL V2.HPG	13.08.12	Single
1000X700 n.LIPSE).HPG	06.08.12	Single
FEFCO 0330 LID.HPG	07.06.10	Single
FEFCO 033_Y 7MM.HPG	07.06.10	Single
FEFCO 033_, 300.HPG	07.06.10	Double
FEFCO 0330 BODY.HPG	05.06.10	Single
DRAWING1.HPG	05.06.10	Single

Preview



540.64x324.75

Preserve alignment

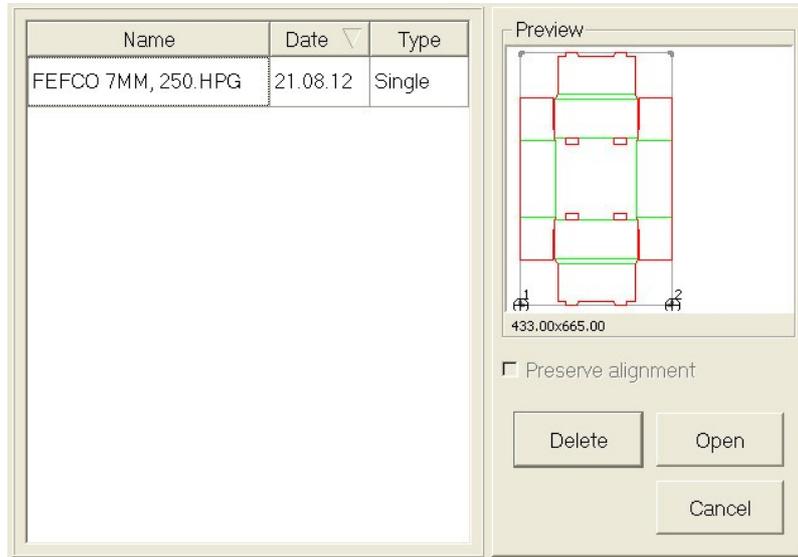
Delete Open

Cancel

Use this menu to select which job to load.

Use ***Preserve alignment*** to keep the alignment you made on a previous job.

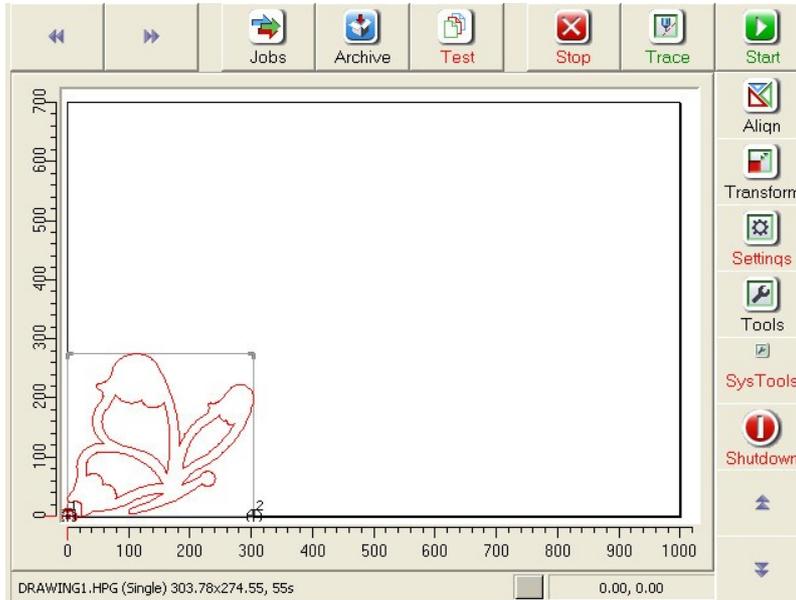
## Archive window



Use this menu to select which job to load (or delete) from the archived jobs.

Use ***Preserve alignment*** to keep the alignment you made on a previous job.

# Align

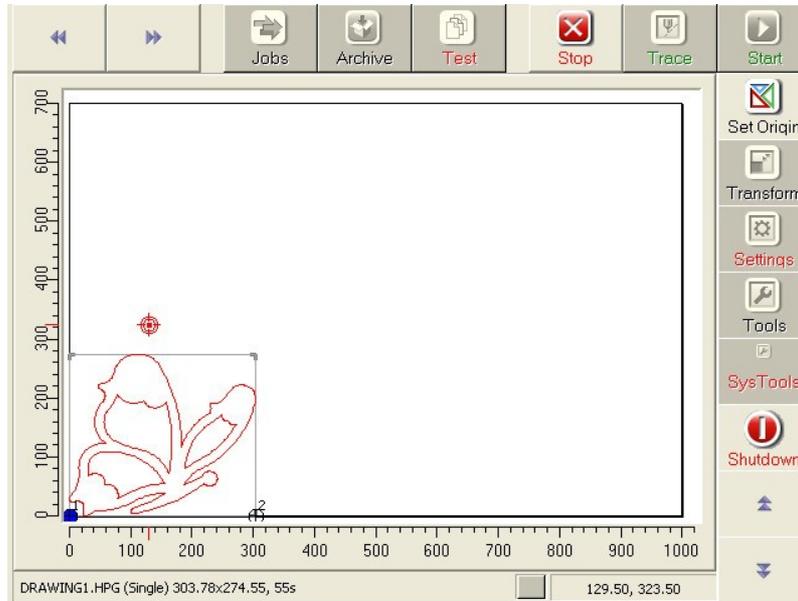


After loading the job you may want to align the file to a desired place on the board. To do so press the



button

## Align, step 1



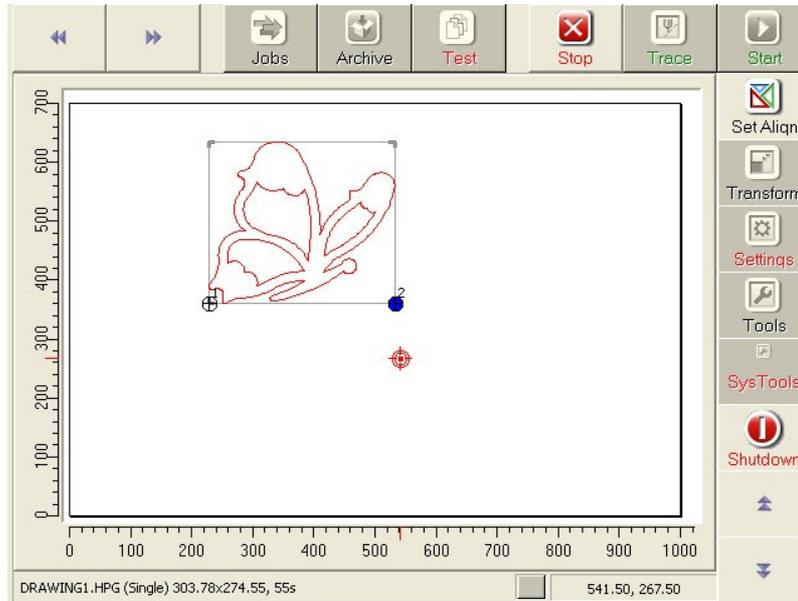
Move the pointer to the desired location and press



The file is moved so that the first market coincides with the pointer.

Note that during the alignment process, only some of the buttons are active.

## Align, step 2



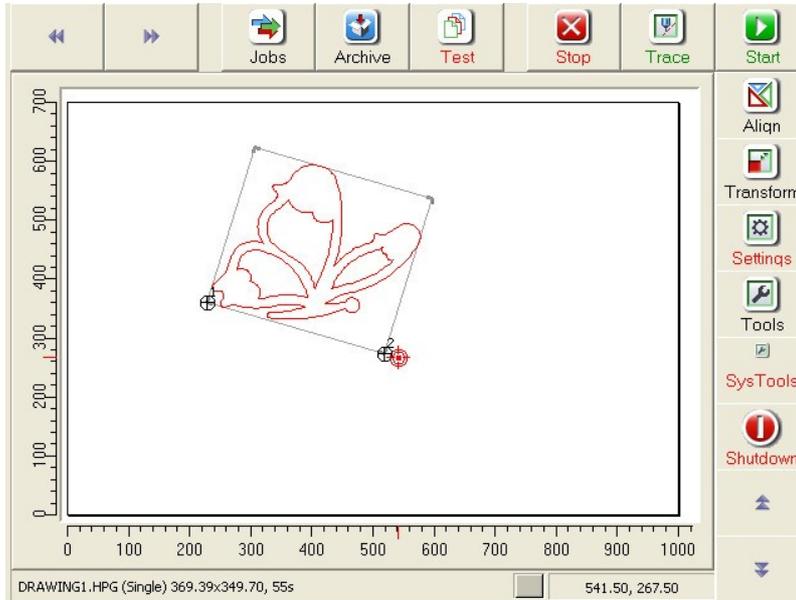
Select the second marker (the color becomes blue), move the pointer to the desired place for the second marker, and press



The file is positioned and you can proceed with the cutting.

Note that during the alignment process, only some of the buttons are active.

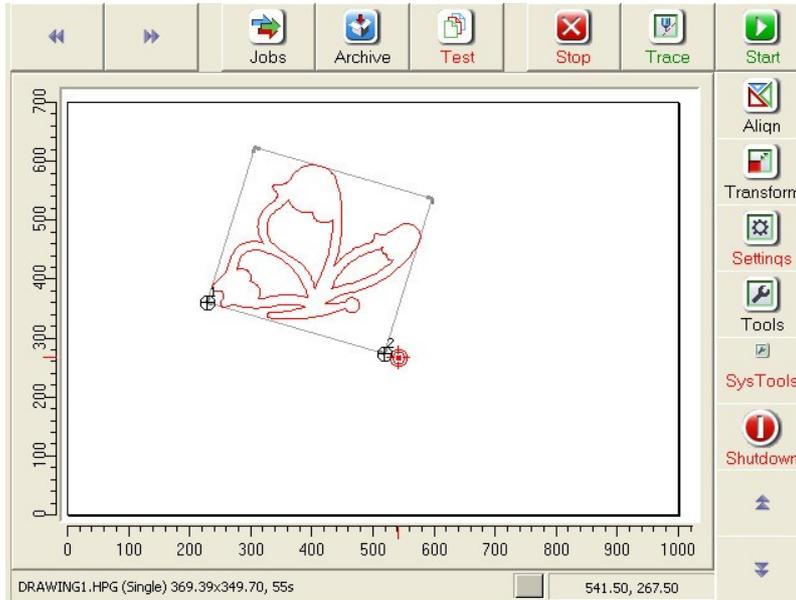
## Cutting and creasing



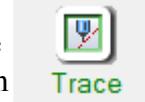
When the file is aligned, press  to begin the cutting and creasing process.

Do not forget to switch on the vacuum and to select the correct tool head before starting the job.

# Trace



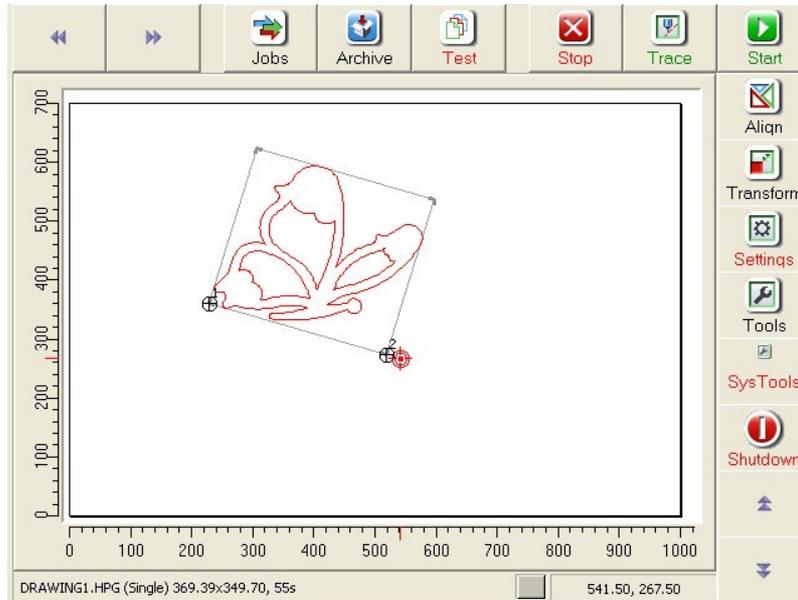
Use  
with



to trace the job  
the light.

The trace function is useful when you want to check allignment on a printed media.

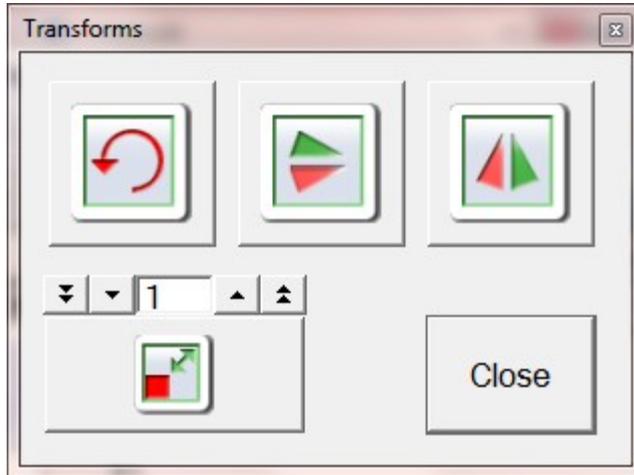
# Stop



Use  to stop the execution of a given job.

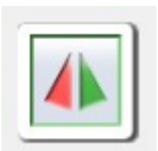
Note that you will not be able to resume from when you stopped, but from the beginning of the job

# Transform



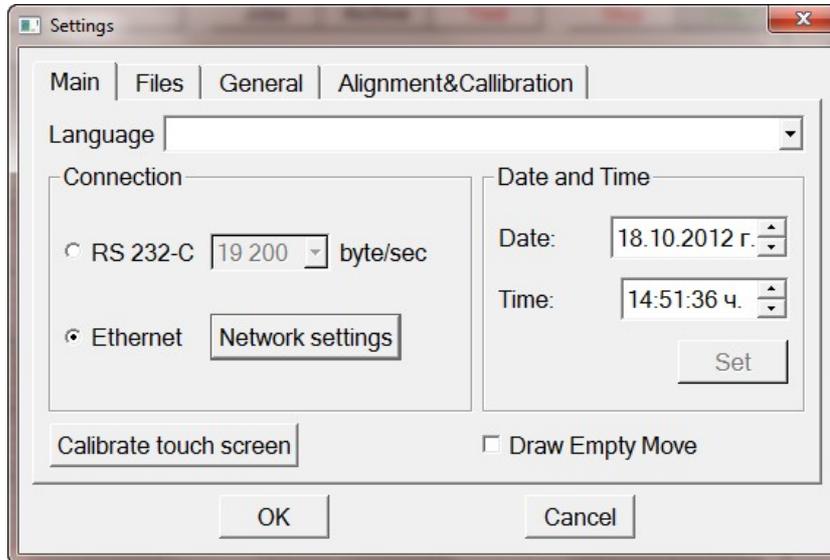
Use  to transform the load.

Use  to rotate the job counterclockwise.

Use  and  to flip horizontally and vertically.

Use  to scale the job. You can scale from 0.5 to 2. Press  to confirm the scaling.

## Settings > Main



Use the language drop-down box to select display language.

In this screen you can set up Date and time.

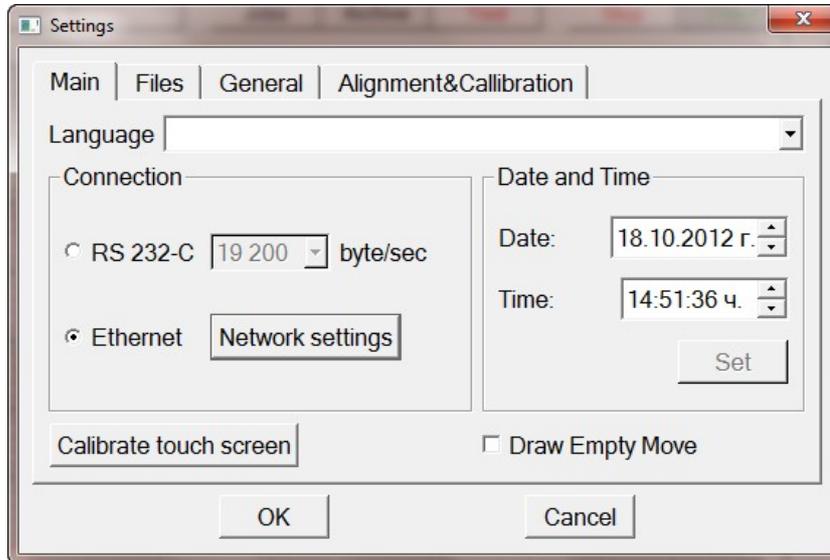
Use the Draw empty move check box to visualize the empty moves when the tools are up.

Select RS 232-C or Ethernet to set up network connection. Select Ethernet and press

**Network settings** to set up a network

Press **Calibrate touch screen** to calibrate the touch screen. Press the centres of the four circles to finish the procedure.

## Settings > Main



Use the language drop-down box to select display language.

In this screen you can set up Date and time.

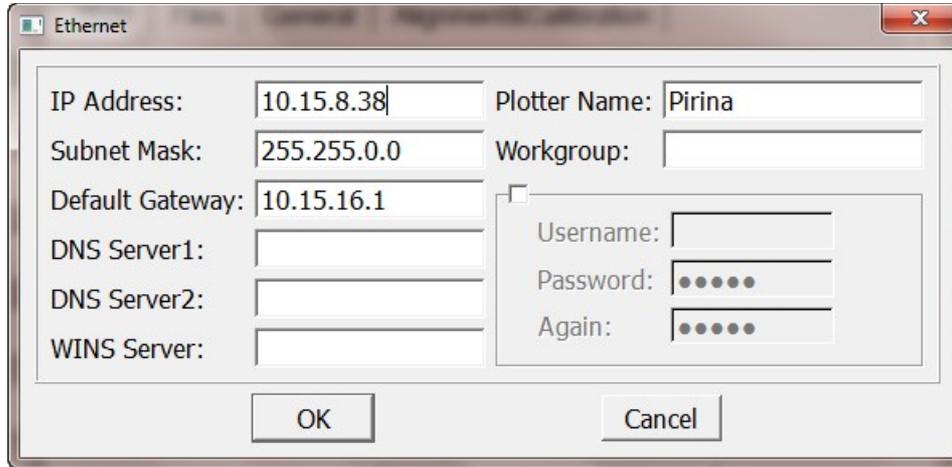
Use the Draw empty move check box to visualize the empty moves when the tools are up.

Select RS 232-C or Ethernet to set up network connection. Select Ethernet and press

**Network settings** to set up a network

Press **Calibrate touch screen** to calibrate the touch screen. Press the centres of the four circles to finish the procedure.

## Settings > Main > Network settings



The screenshot shows a dialog box titled "Ethernet" with a close button (X) in the top right corner. The dialog contains several input fields for network configuration:

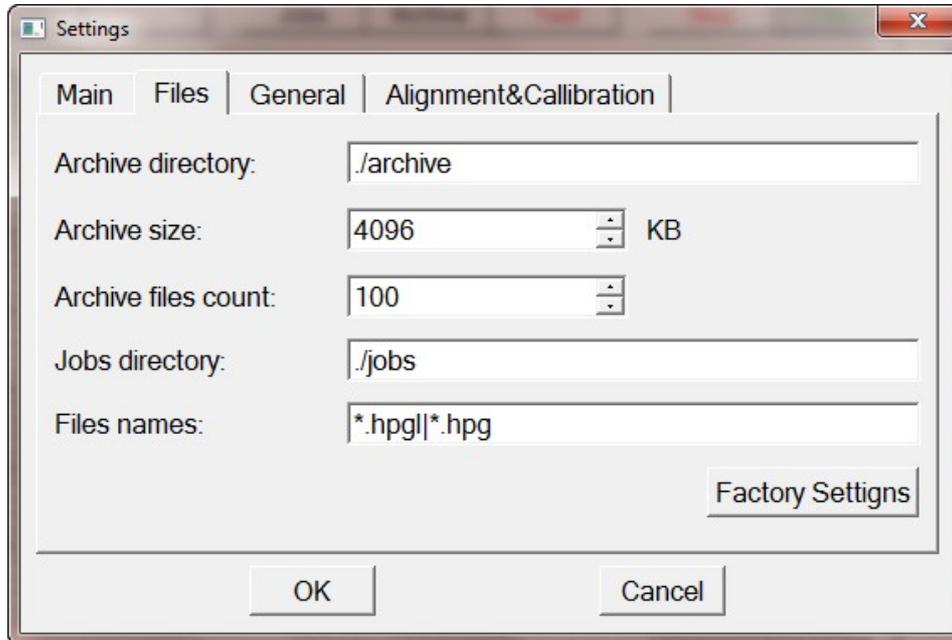
IP Address:	10.15.8.38	Plotter Name:	Pirina
Subnet Mask:	255.255.0.0	Workgroup:	
Default Gateway:	10.15.16.1	<input type="checkbox"/>	
DNS Server1:		Username:	
DNS Server2:		Password:	•••••
WINS Server:		Again:	•••••

At the bottom of the dialog, there are two buttons: "OK" and "Cancel".

Use this screen to set up the network connection.

The mandatory fields are IP Address, Subnet mask and Default Gateway.

## Settings > Files



The screenshot shows a 'Settings' dialog box with a title bar containing a close button (X). The dialog has four tabs: 'Main', 'Files', 'General', and 'Alignment&Callibration'. The 'Files' tab is selected. It contains five input fields: 'Archive directory' with the text './archive', 'Archive size' with a numeric spinner set to '4096' and the unit 'KB', 'Archive files count' with a numeric spinner set to '100', 'Jobs directory' with the text './jobs', and 'Files names' with the text '\*.hpg|\*.hpg'. A 'Factory Settings' button is located at the bottom right of the dialog area. At the very bottom of the dialog are 'OK' and 'Cancel' buttons.

Archive directory:	<input type="text" value="/archive"/>
Archive size:	<input type="text" value="4096"/> KB
Archive files count:	<input type="text" value="100"/>
Jobs directory:	<input type="text" value="/jobs"/>
Files names:	<input type="text" value="*.hpg *.hpg"/>

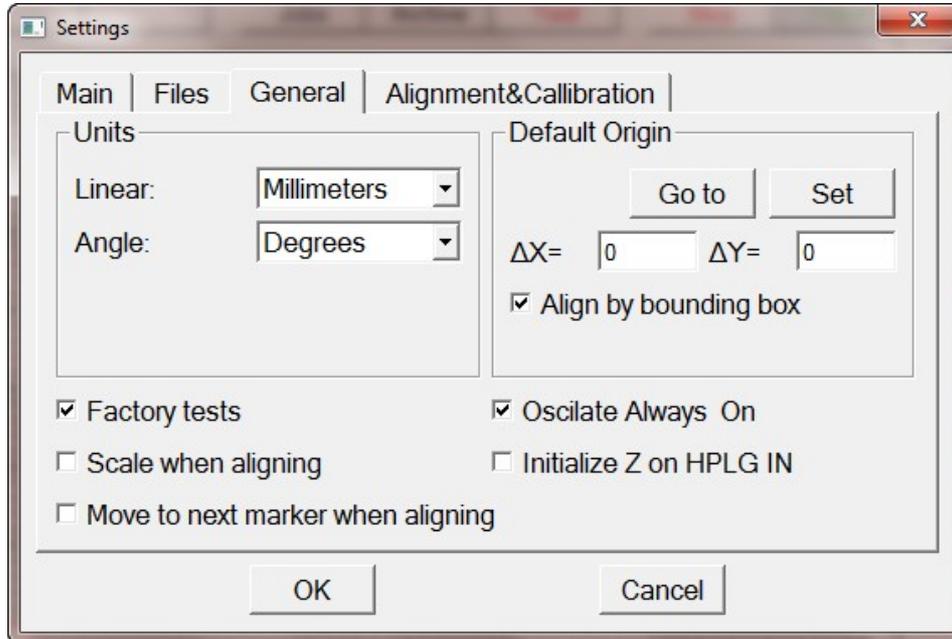
Factory Settings

OK Cancel

Use this screen to set up archive directory, size and file count. You can set up also Jobs directory and recognised file names.

Use the Factory settings button to restore factory settings.

## Settings > General



The screenshot shows a 'Settings' dialog box with the 'General' tab selected. The dialog has four tabs: 'Main', 'Files', 'General', and 'Alignment&Calibration'. The 'General' tab contains the following settings:

- Units:**
  - Linear: Millimeters (dropdown menu)
  - Angle: Degrees (dropdown menu)
- Default Origin:**
  - Buttons: 'Go to' and 'Set'
  - Input fields:  $\Delta X = 0$  and  $\Delta Y = 0$
  - Checkbox:  Align by bounding box
- Factory tests:**
  - Factory tests
  - Scale when aligning
  - Move to next marker when aligning
- Oscillate Always On:**
  - Oscillate Always On
  - Initialize Z on HPLG IN

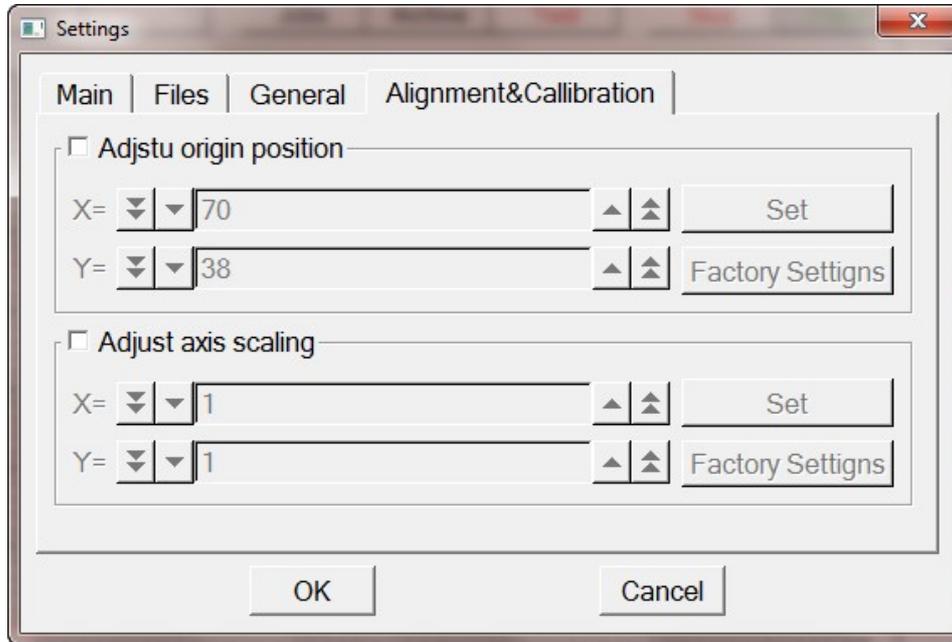
At the bottom of the dialog are 'OK' and 'Cancel' buttons.

Use this screen to set up units for the display. Set the default origin where the file is aligned.

Use factory test checkbox to allow factory test button.

Use Oscillate Always on when you have oscillating toolhead.

## Settings > Alignment&Calibration

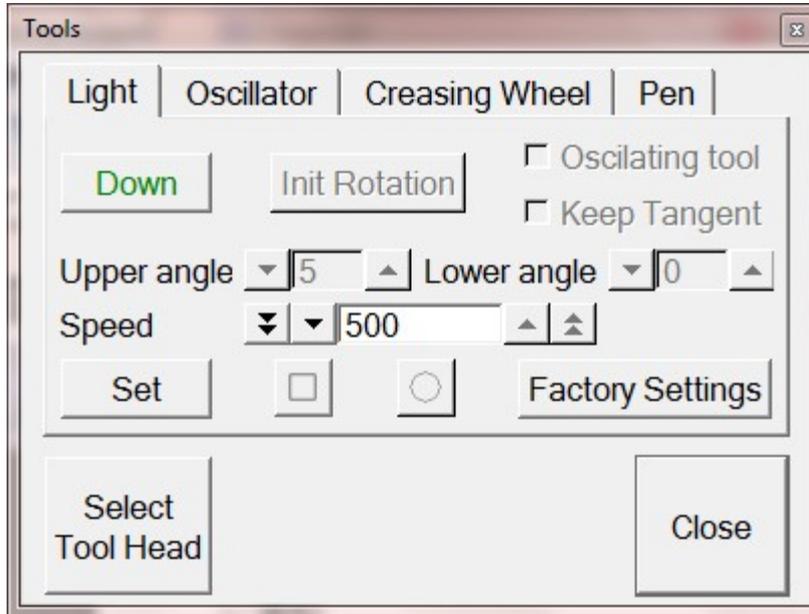


Use Adjust origin position to softwarely correct the origin point.

Use Adjust axis scaling to compensate for inequalities in the axes.

Note: It is recommended that only authorized personel makes changes to the options here

## Tools

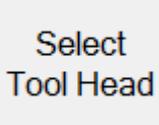


Use this menu to set up the angle which is performed without lifting the tools – between the lower and upper angle.

Also set the tool speed.

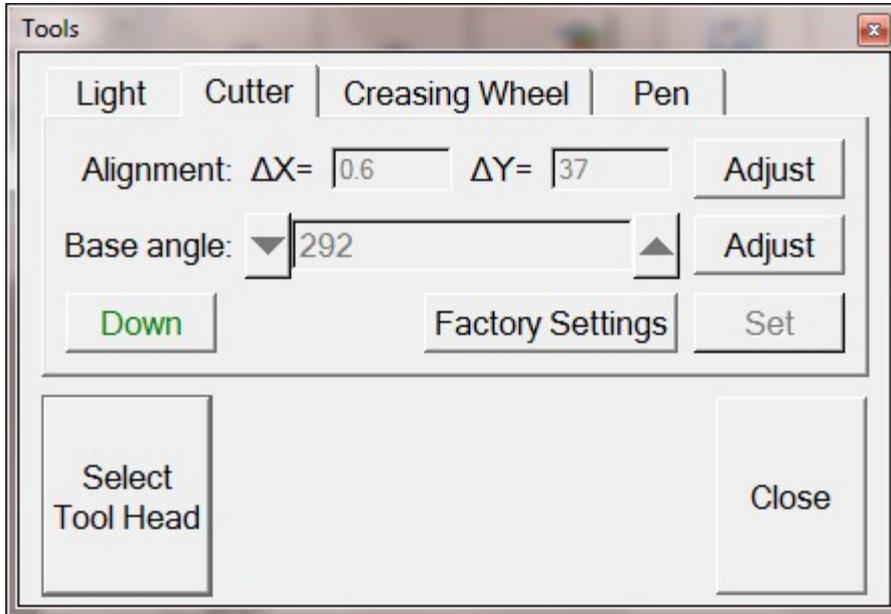
Use  or 

to cut a test square or circle.

Use  to select the desired toolhead (standard or oscillating) for your jobs.

Select  
Tool Head

## Sys tools

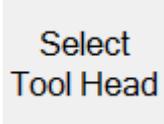


Use this menu to align the tools to the light.

Press **Adjust** and use the arrows to drive the light to the cross made by the selected tool and press **Set** when ready.

Use **Base angle** to make corrections to the initial rotation of the instruments.

Use **Factory settings** to restore factory defaults.

Use  to select the desired toolhead (standard or oscillating) for your jobs.

Select  
Tool Head

## **Changing Heads, Tools, Instruments**

To see the correct procedure for changing toolheads, tools and knives, please check the videos in the attached CD.

Before changing toolheads or instruments be sure that the plotter is switched off or the emergency stop button is pressed!

## **Maintenance**

The monthly maintenance includes:

- Clean the outside surfaces of the plotter and look for possible wear and tear;
- Carefully inspect the cables and their connectors;
- Lightly coat the rubbing parts of the plotter with machine oil;
- Check the tension of the belts of the electric motors and the linear movements;
- Switch on the plotter and see if the software boots properly.

Always refer to an authorised technician to fix problems that you notice during monthly maintenance, except for cable exchanges that you can do yourself.

Long-term maintenance should be performed every six months and includes:

- Perform the same operations as for monthly maintenance;
- Clean the control block with alcohol or other cleaning agent suitable for soft LCD monitors;
- Check the cable connectors and clean the connecting elements with alcohol;
- Check the isolation along the whole length of the cables;

## Troubleshooting

The plotter does not start, there is no light and the control block does not start:

Check for the following:

Is the plotter connected to the electric grid?

Is the emergency shut off switch pressed?

Is there electricity available?

The plotter turns on, but there is no pneumatic pressure and the tools can not move up/down:

Check for the following:

Is the compressor unit switched on and connected to the plotter?

Are the pressure regulators set to zero pressure?

Is there a leak of pressurized air from the pneumatic tubes?

The plotter does not receive data and does not perform the set task:

Check the following:

Are the communication cables and ports to the PC properly connected?

Are the communication cables and ports on the plotter properly connected?

The plotter is moving, but the carton is not creased nor cut:

Check the following:

Is the cutting knife broken?

Is the set cutting depth enough?

Is the set creasing depth enough?

Is the set air pressure enough?

The plotter stops suddenly while working:

Check the following:

Is there electrical supply?

Is there accumulation of dirt on the rubbing parts of the plotter?

Are the terminal switches engaged (in an attempt to move the toolhead outside of the working area)?

Always refer to an authorized technician to fix problems that you notice during plotter operation. **ATTENTION!** It is strictly forbidden to open the covers and panels of the plotter except by authorized technicians or service centers. Opening the plotter voids the warranty.

## Warranty

The warranty period is 12 months from the date of delivery to the customer. The warranty is valid only if the plotter has been used for its intended purpose according to these instructions and guidelines.

If during the warranty period the plotter malfunctions due to improper use or storage by the customer, the repairs are paid for by the customer;  
The transport expenses for warranty repairs are split by the customer and the manufacturer.

Before calling the service center:

Try to troubleshoot the problem yourself.

Switch off the plotter and wait for one minute. Switch it on again and check if the problem persists.

If after the checks described above the plotter still does not work properly, please call your local service center.

Please provide:

Short description of the defect or problem; pictures or video are highly appreciated;

The exact model name and number of the plotter;

The serial number of the plotter;

Your contact name, address (including the postal code), telephones and e-mail.

# PIRINA

TECHNOLOGIES



## Pirina Technologies Corp.

Tsarigradsko Shosse Blvd., 7 km, ZIT Corp.1, Entr. B  
1784 Sofia, Bulgaria

Tel: 00359 2 974 3430  
Fax: 00359 2 974 0308  
Mobile: 00359 888 929 738  
e-mail: sales@pirinatech.com

[www.pirinatech.com](http://www.pirinatech.com)

