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Operation (Turn on)

1. Turn the breaker handle on the center of the left door of the control box to start main power supply.

2. Confirm that air pressure of the main regulator is 0.5Mpa

3. Turn Drive power on.
4. Push in the middle of the button when screen shows the figure of WSD-K2 and the screen switches into Contents screen.

5. Push the Password Manager button
5. In Password Manager Display, authentication for password from level 1 to 4, password change and initialization are available. Set password level for operation authorization.
Operation (Winding wire)

1. Fix the Reel L (Supply side), Reel R (Collect side)
   (Caution) There is a pin on both of the L, R reel. Slot the pin into the hole of the reels.

2. Set a cupped spring washer + a M8 bolt and clench the bolt with torque wrench.

3. Push the TRAVERSER button.
4. Turn L and R motors off from the Manual Traverser. ⇒ S-OFF
   Touch the buttons as follow ⇒ MANUAL→TRAVERSER R→BACK POSITION

4. Wire winding way

- Supply Reel
- Collect Reel
- Work Roller U
- Guide Pulley
- Tension Pulley
- Work Roller L
- Work Roller R
5. After winding wire until collect reel, fix the wire by M4 bolt.

6. Rotate Collect Reel with wire 3 times by hand.

7. Adjust Traverser L position to make wire and Traverser L straight.

8. To measure Reel Diameter, please follow as below
   S-ON → TENSION L & R ON → TENSION CONTROL ON → REEL DIAMETER MEASURE START
Operation (Winding wire II)

1. Push the SETTING button.

2. Check the wire pitch on the reel through the test chart from a wire maker.

3. Confirm the Traverser pitch as follow: SETTING → → TRAVERSER (L and R) PITCH
3. Set wire tension 15N as follow. MAINTENANCE DATA → Wire Tension
Type in tension in WIRE TENSION blank and REGULATOR PRESSURE number is displayed.
4. Put in the Regulator pressure number in Tension regulator, on the front of the device.

5. Please select the buttons as follow. TRAVERSER → MANUAL → INDEX → Type in 5m in DISTANCE and 50m/min in SPEED.
6. Touch the JOG FORWARD button and please check by the left side window that the wire is straight line between Supply traverser and Guide pulley.

7. (1) If the wire is straight line between Supply traverser and Guide pulley, ⇒ OK

7. (2) If the wire is NOT straight line between Supply traverser and Guide pulley, ⇒ NG
Make the wire straight line between Supply traverser and Guide pulley by adjusting Supply Traverser.

7. (3) If the Supply Traverser moves opposite way of the wire way, ⇒ NG
Change the way of Traverser as follow. TRAVERSER L → MANUAL → JOG REVERSE or JOG FORWARD
Operation (Winding wire III)

1. Confirm the every parameter and condition.

2. Confirm the parameter on SETTING
3. PROCESSING TIME and WIRE USAGE is displayed.

※ Wire Usage

Wire running distance (Wire Speed) + Wire usage for slicing

\[ \text{e.g., wire speed: 400m/min,} \]
\[ \text{Acceleration and Deceleration Speed: 3sec} \]
\[ \text{Constant Speed: 24sec} \]
\[ 400 \text{m/min} = 6.6 \text{m/sec} \]
\[ 6.6 \text{m/sec} \times (24 \text{sec} + 3 \text{sec}) = 179.9 \text{m} \]

179.9m + The Number displayed on the MONITOR screen = Amount of all Wire Usage

4. Set tension 15N

5. Reel → MANUAL → INDEX

Set the amount of wire usage you use (+α) and wire speed should be 50m/min.

6. Push the JOG FORWARD button and check by the left side window that the wire is straight line between Supply traverser and Guide pulley.

It could happened that the wire from Supply traverser is out of the Guide pulley, so please see sending wire until finished.
7. 1. If the wire runs off, please push the button.

7. 2. Adjust TRAVERSER L that the wire goes straight from TRAVERSER L to GUIDE PULLEY.

   MANUAL → TRAVERSER L → JOG FRONT or BACK
7. 3. If you stop sending wire and fix the way of wire, check the amount of wire you send and calculate how much more wire you should send. And send the remain amount of wire.

8. After finishing sending wire, send all amounts of wire back to TRAVERSER L by the JOG REVERSE button.
1. Attach work to the Attachment plate by glue and set on the Table.

2. Adjust the distance between work and table, 2mm.
   UP AND DOWN → MANUAL → JOG → JOG UP or JOG DOWN

3. Set INDEX, 0.5·0.1mm, and find the contact position of wire and the work.
   ※When you use rocking, you should push the ROCKING button and make sure work is not contacted the wire.
4. Push the CONTACT POSITION TEACHING button.

5. The CONTACT POSITION is automatically transferred to the SETTING part after pushing the CONTACT POSITION TEACHING button.
6. Push the MENU button.

7. Push the SETTING button.
8. Push the button.

6. Set the parameter of START OFFSET, CUT LENGTH, and UP&DOWN STANDARD SPEED SETTINGS →
Operation (Stage setting)

1. Push the SETTING button

2. Push the Stage setting button
3. Select the range of stages 1-25. After pushing the stage NO, push the Execute Split button.

STAGE SETTING → INPUT
4. Push the MAIN button

5. Select STEP MODE or CONSECUTIVE MODE to set the stage mode.
MAIN → MODE → STEP MODE or CONSECUTIVE MODE
Operation (Shut down)

1. Select the **ShutDown** button on Menu screen.

2. Touch the **ShutDown** button for 3 seconds.
3. Touch the **ShutDown** button one more time.

4. After Screen gets dark, put the main breaker off.