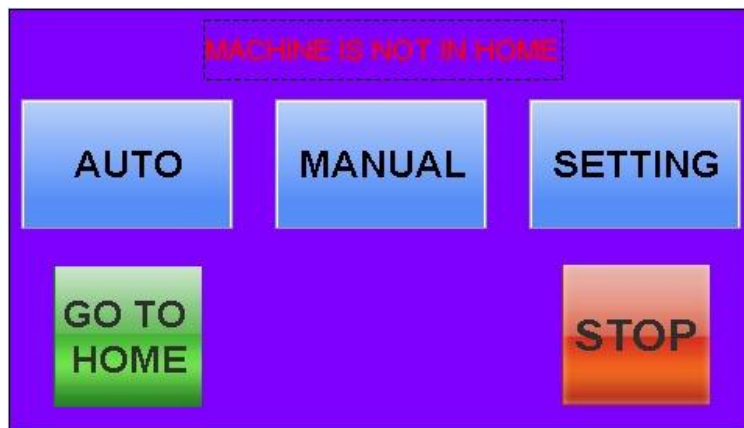

User Guide for SCG Test Notch Machine

After ensuring the single-phase cable is connected, turn on the device using the power switch located next to the control panel.

Once the panel is powered on, if the device is not in the HOME position, press the green GO TO HOME button on the screen.



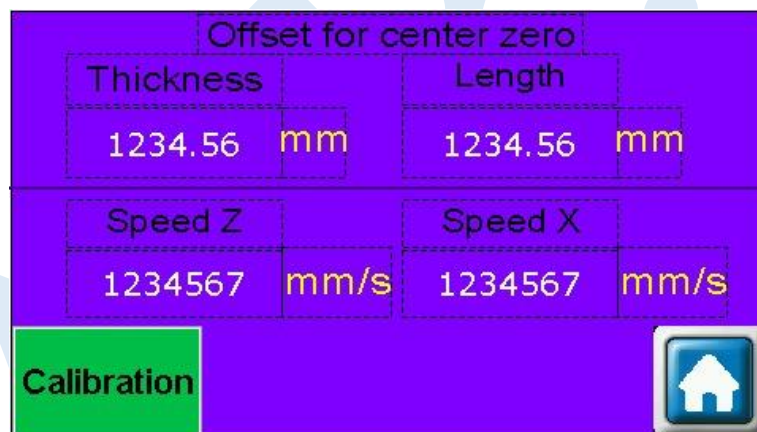
Note: If you want the device to automatically perform the requested process, this step is essential.

1. By selecting the GO TO HOME option, the device's cutting tool moves to the left and aligns at the origin point along the X and Z axes (length and height). The message MACHINE IS IN HOME will appear on the display.



1. On this screen, the following options are available:
 - **AUTO:** For performing the process automatically.

- **MANUAL:** For moving the cutting tool along the length and height directions and turning the cutting blade (**Cutting Blade**) on or off outside of automatic mode.
- **SETTING:** For applying offsets related to thickness, starting point length, and speed in the length and height directions.
- The calibration menu is also located in this section.
In the following, the **MANUAL** and **SETTING** menu sections will be explained in sequence.



1. After completing the settings (if needed), proceed to the sample notching process by selecting the **AUTO** button from the main menu.

MACHINE IS NOT IN HOME

Thickness		Length	
12.34	mm	123.45	mm
1234.56	mm	1234.56	mm

START

STOP



1. On this screen, in the **Thickness** section, enter the wall thickness of the sample at the notch location in millimeters. (Tap the thickness number field, input the value using the on-screen keyboard, and press **ENT**.) Also, enter the notch length in the **Length** section. Below the thickness and length fields, the current position of the cutting blade is displayed in terms of height and horizontal alignment, respectively.
Note: According to the national standard 13605, the notch depth should be 2 mm $\pm$ 20% of the wall thickness at the intended location, and the length should equal the outer diameter of the pipe.
2. Now, place the sample (prepared according to the specified dimensions for the hydrostatic test) onto the groove on the upper surface of the device. Using the up and down buttons next to the panel, lower the movable clamp (plate) until it rests on the sample and secures it firmly. (The pipe must not move during the cutting process.)
3. To start the process, press the **START** button. The blade will move from the HOME position and, upon reaching the center, create a notch with the specified depth and length on the designated area.
4. After the notching process is complete, the blade stops and returns to its central position.
5. To repeat the process (for the next notch), lift the sample holder plate, rotate the sample for the next notch, lower the holder plate to secure the pipe again, and press **START** once more.