

Changing Control of Transfer to MH Side

How to successfully change the control of the transfer table on an all-in-one machine from the saw side to MH side

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Why Change

JF noted during training that when the saw paused, the MH could only finish the bar it was on but not eject its bar onto the transfer table. If the soft pause then led to a hard reset, the bar was stuck on MH outfeed. This is difficult for the operator to retrieve.

If the MH controls the transfer, the saw can pause, but MH can carry on. This is more efficient and faster

How

Software updates are needed which give a new parameter

```
transferMHControl
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Switching to 1 will change control from the saw side to MH side

Software Versions

winMulti	6.4.32.0
tc3Multi PLC	6.3007

Stoppable Outputs

StoppableOutputs are outputs that need to switch off when the machine is paused - these are generally conveyor motors or blowers. When the machine is restarted from the pause, the outputs are automatically restarted.

Care must be taken to change the "Location" of any relevant stoppableOutputs. This is important because these outputs will deactivate during a pause on the controlling side - if this is wrongly set, the output will switch off when the wrong side is paused.

The location is set via Machine settings, IO screen.

The critical outputs would be the transfer table motors

Machine Settings

Datum Tests Accuracy Parameters Axes Tooling IO Map Clamps X Holds Alarms Profile Colours Notching Fine Adjustment

	Output Code	RefNo	Column	Row	Stoppabl	Location	
	OuC_BmPosO	127	2	1	<input type="checkbox"/>	Both	▼
	OuC_GripH	121	3	1	<input type="checkbox"/>	Both	▼
	OuC_Blwrack	122	3	3	<input type="checkbox"/>	Both	▼
	OuC_Blwrail	272	3	4	<input type="checkbox"/>	Both	▼
	OuC_Roller	124	3	6	<input type="checkbox"/>	Both	▼
	OuC_Chan1	125	3	7	<input type="checkbox"/>	Both	▼
	OuC_CrankFWD	273	3	8	<input type="checkbox"/>	MH	▼
	OuC_CrankREV	274	3	9	<input type="checkbox"/>	MH	▼
	SPIN1	362	11	1	<input type="checkbox"/>	Both	▼
	SPPL1	397	11	2	<input type="checkbox"/>	Both	▼
	SPDP1	54	11	5	<input type="checkbox"/>	Both	▼
	SPIN2	363	12	1	<input type="checkbox"/>	Both	▼
	SPPL2	398	12	2	<input type="checkbox"/>	Both	▼
	SPIN3	364	13	1	<input type="checkbox"/>	Both	▼
	SPPL3	399	13	2	<input type="checkbox"/>	Both	▼

	Input Code	RefNo	Column	Row
▶	InA_ESBut	321	0	0
	InB_GuardFrI	346	0	1
	InB_GuardFrO	347	0	2
	InB_GuardRel	348	0	3
	InB_GuardReO	349	0	4
	InA_ESOk	45	0	6
	InA_START	46	1	0
	InA_STOP	47	1	1
	InA_ESRST	48	1	2
	InA_Auto	160	1	3
	InA_Resume	282	1	5
	InB_YHome	50	2	0
	InB_ZHome	53	2	1
	InB_RHome	56	2	2
	InB_VHome	120	2	3

Save

Alarm Outputs

The alarm "module" column will also need to be updated for any specific alarms that need moving across for saw control to MH control. On recent ZX5 software, there are no alarms in this category, all alarms are done internally.

Machine Settings

Datum Tests Accuracy Parameters Axes Tooling IO Map Clamps X Holds Alarms Profile Colours Notching Fine Adjustment

	RefNo	Input Ref	iState	Output Ref	oState	Timeout	Action	Message	Module	Enbld	DemoH
▶	1	InC_BmPosO	▼ On	OuB_CLV	▼ On	▼ 0	4-Abort	V Notching Attempted Bea...	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	20	InF_AIR	▼ On	<Undefined>	▼ Off	▼ 50	3-Cycle...	Air Pressure Low	Both	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	32	InB_WOVL	▼ On	<Undefined>	▼ Off	▼ 0	3-Cycle...	Rear V overload Tripped	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	33	InB_VOVL	▼ On	<Undefined>	▼ Off	▼ 0	3-Cycle...	V Notch Motor Overload	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	41	InB_InvOk	▼ Off	SPIN1	▼ On	▼ 0	3-Cycle...	Spindle 1 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	42	InB_InvOk	▼ Off	SPIN2	▼ On	▼ 0	3-Cycle...	Spindle 2 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	43	InB_InvOk	▼ Off	SPIN3	▼ On	▼ 0	3-Cycle...	Spindle 3 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	44	InB_InvOk	▼ Off	SPIN4	▼ On	▼ 0	3-Cycle...	Spindle 4 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	45	InB_InvOk	▼ Off	SPIN5	▼ On	▼ 0	3-Cycle...	Spindle 5 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	46	InB_InvOk	▼ Off	SPIN6	▼ On	▼ 0	3-Cycle...	Spindle 6 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	47	InB_InvOk	▼ Off	SPIN7	▼ On	▼ 0	3-Cycle...	Spindle 7 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	48	InB_InvOk	▼ Off	SPIN8	▼ On	▼ 0	3-Cycle...	Spindle 8 Motor Alarm	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	52	SPHM1	▼ Off	SPPL1	▼ Off	▼ 20	3-Cycle...	Spindle 1 Not Home	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	53	SPHM2	▼ Off	SPPL2	▼ Off	▼ 20	3-Cycle...	Spindle 2 Not Home	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	54	SPHM3	▼ Off	SPPL3	▼ Off	▼ 20	3-Cycle...	Spindle 3 Not Home	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	55	SPHM4	▼ Off	SPPL4	▼ Off	▼ 20	3-Cycle...	Spindle 4 Not Home	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>
	56	SPHM6	▼ Off	SPPL6	▼ Off	▼ 20	3-Cycle...	Spindle 6 Not Home	MH	▼ <input checked="" type="checkbox"/>	<input type="checkbox"/>

Save