

Basic Operations

Basics



WinMulti - Run and Exit
Running and terminating the winMulti Program

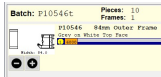


WinMulti - Main Screen
Main screen icons on winMulti



WinMulti - Load a Batch
This page will inform the operator how to load a Batch in winMulti

Bar Queue



WinMulti - Changing The Colour Identification Box
How to use the colour identification box to indicate profile colour and loading orientation

Manual Input



WinMulti - Performing a Manual Input
This page will instruct the operator how to add a manual input piece to the bar queue.



WinMulti - Adding Cuts to the Manual Input Piece
This page will instruct the operator in the correct Procedure to add cuts to the manual input profile.

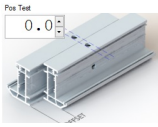


WinMulti - Manual Input Cuts on an Autoflow or Microline
This page will explain how to add manual cuts on an Autoflow or Microline

Basic Tests



WinMulti - Datum Test
This page will describe how to perform a Datum Test



WinMulti - Postest

This page will describe how to generate a Postest (operation position test), and is used to set the distance relationship between routed holes and the saw blade so that routed pieces line up correctly back to back.

Remakes



WinMulti - Remakes

This will inform the operator how to remake pieces in winMulti

Offcuts



WinMulti - Offcuts

This page will inform the operator how to add/Remove an Offcut

Alarms

Service Diagnostics



WinMulti - Problem Bars and Bar Data

This page gives troubleshooting advice and looks at the Pieces on the Bar Data screen within the Service Menu



WinMulti - Advanced Bar Data

This page is a more in depth explanation of the Bar Data Tab

IO Testing



WinMulti - IO Screens - Autoflow

This page shows each of the IO Screens on an Autoflow and describes each Input/Output

Legend Wire Label	IO Ref	Color	Output
1	IA_Grind		Grinder Inhibit
2	IA_Masscut1		
3	IA_Masscut2		
4	IA_GDHome		
5	IA_GDZero		
6	IA_GDHome		
7	IA_GDHome		
8	IA_GDZero		

Stuga Machine IO Dictionary - Inputs

List of input references used on Stuga Machines

Drive Testing



WinMulti - Drives

This Page describes the drives screen in the winMulti Service Menu

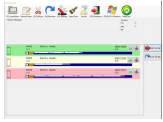
Settings

Profile Settings



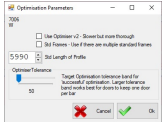
For sawing modules running from winMulti (including flowlines with integrated control), there is an option to reduce the cut is managed through an additional sensor on the saw cut stroke cylinder. This is particularly useful on saws with a 500mm blade wide or tall profiles) but a reduced cycle time can be gained by reducing the saw cut stroke time by limiting its travel on short

Advanced Procedures



Recovery of Bar Queue following winMulti Crash

Recovering the bar queue to match the number of bars on transfer table following a crash on winMulti



WinMulti - Advanced Optimisation

This page will explain the options for advanced optimisation

References