

Register Mapping SE-4AS-CNC

Register Mapping SE-4AS-CNC Find and Setting Register values.

Contents

Comments

1. Start the machine and don't reset the e-stop.
2. Press "R-button" + entr.
3. You see a little window with "register"
4. Give in (maybe 10) and press entr.
5. You see the actual value.
6. Press again "R-button"..... and so on.

Register Mapping SE-4AS-CNC

AXIS REGISTERS

10	start ramp axis 11 top vertical (DIMA)
11	stop ramp axis 11 top vertical (DIMA)
12	target window axis 11 top vertical (DIMA)
13	reinforcement in target window (command 10)
14	P share speed governor (command 24)
15	I share speed governor (command 26)
16	P share coordination governor (command 34)
17	I share coordination governor (command 36)
18	home position
19	zero shift (1 mm = 100 increments)
20	start ramp axis 21 top horizontal (DIMA)
21	stop ramp axis 21 top horizontal (DIMA)
22	target window axis 21 top horizontal (DIMA)
23	reinforcement in target window (command 10)
24	P share speed governor (command 24)
25	I share speed governor (command 26)
26	P share coordination governor (command 34)
27	I share coordination governor (command 36)
28	home position
29	zero shift (1 mm = 100 increments)
30	start ramp axis 31 bottom vertical (DIMA)
31	stop ramp axis 31 bottom vertical (DIMA)
32	target window axis 31 bottom vertical (DIMA)
33	reinforcement in target window (command 10)
34	P share speed governor (command 24)
35	I share speed governor (command 26)
36	P share coordination governor (command 34)
37	I share coordination governor (command 36)
38	home position
39	zero shift (1 mm = 100 increments)

40	start ramp axis 41 bottom horizontal (DIMA)
41	stop ramp axis 41 bottom horizontal (DIMA)
42	target window axis 41 bottom horizontal (DIMA)
43	reinforcement in target window (command 10)
44	P share speed governor (command 24)
45	I share speed governor (command 26)
46	P share coordination governor (command 34)
47	I share coordination governor (command 36)
48	home position
49	zero shift (1 mm = 100 increments)
60	start ramp axis 61 turning station (SV-4)
61	stop ramp axis 61 turning station (SV-4)
62	target window axis 61 turning station (SV-4)
63	digital offset
64	P reinforcement of positioning governor
65	reference speed
66	maximum speed
67	long start ramp
68	home position
69	zero shift (1 mm = 100 increments)
70	start ramp axis 73 guide block left
71	stop ramp axis 73 guide block left
72	offset
73	home position 400 paces/revs. => 1mm=80 paces
74	vacant
75	start ramp axis 75 guide block right
76	stop ramp axis 75 guide block right
77	offset
78	home position
79	vacant
80	positive software limit switch axis 31
81	negative software limit switch axis 31
90	communication with remote via remote scan 1=yes/0=N
92	Machine running with display
93	rubber holding-down installed 0 = No / 1 = YES
94	time chip exhaust system active
95	amount at which waiting time should begin
96	code for waiting time
97	after emergency stop do not restart machine
98	check if temperatur sensor is active 1=yes

99	operational register for function keys
100	counter
101	counter millions
102	current profile program
103	current program number
104	1 = turn front doors with threshold on turning station
105	machine running with viadukt
106	no 2nd encoder: 0
107	activate when machine has two feed levels
108	rotation stay's on the side when profile is cleaning
109	language selection 0=German 1=foreign language
110	register has code
111	no turning station=0/1=frequency/2=record controls
112	no buffer : 0
113	small window always : 1
115	no curves : 0
116	remote 1 deactivated: 0
117	remote 2 deactivated: 0
118	remote 3 deactivated: 0
119	1 = machine with guide block for interlock
120	profile width tolerance for profile recognition
121	profile height tolerance for profile recognition
122	difference in increments for standstill
123	cycle time for standstill recognition
124	current limiting for feeding
125	calculating register 'Ueinzug'
126	pull-in block forward for small window delay time
127	difference between 1st and 2nd encoder
128	current limiting for feeding small windows
129	offset on current limiting
130	window displayed in mask for automatic mode
131	turning station displayed in mask for automatic mode
132	memory of register "window displayed in mask for automatic mode"
133	memory of register "turning station displayed in mask for automatic mode"
134	input number for "window displayed in mask for automatic mode" - load right side using constant 'KEAutMaskFenster'
135	input number for "window displayed in mask for automatic mode" - load left side using constant 'KEAutMaskFensterL'

DIMA-Axes Speed Levels REGISTERS	
140	RELATIVE reference speed
141	RELATIVE reference drive speed
142	RELATIVE feeding speed
143	RELATIVE teaching-in speed
144	RELATIVE minimum speed
145	ABSOLUTE maximum speed
146	RELATIVE feeding speed when turning station is started
147	RELATIVE high speed during teaching in
148	RELATIVE unloading speed with small windows
149	SM3 card reference speed
150	SM3 card maximum speed
Laser	
156	Laser Speed
226	y-startpoint
227	x-startpoint
394	0= no laser
882	tolerance
883	zero point (Setup tool)
REGISTERS Delay Times	
160	error messages delay time
161	clamp standstill delay time
162	emergency stop delay time
163	lower groove knife forward delay time
164	upper groove knife forward delay time
165	vacant
166	internal-corner knife forward delay time
167	lower drill motor forward delay time
168	upper drill motor forward delay time
169	feeding device forward delay time
170	clamps forward delay time
171	clamps backward delay time
172	HIR/RIMU/KIU delay time
173	HRB/RIMO/KIO/upper HIR delay time
174	2nd RIMO knife delay time
175	2nd RIMU knife delay time
176	upper tool 7 delay time
177	lower tool 7 delay time
178	blowing off delay time
179	pivot drill delay time
180	disc on delay time
181	disc off delay time

182	2nd height pull-in block forward delay time
183	guide blocks forward delay time
184	2nd width guide blocks forward delay time
185	3rd width guide blocks forward delay time
186	turning station slide delay time
187	message display turnaround time
188	delay time when horn becomes active
189	horn interval delay time
190	interlock blocks forward delay time
191	start feed offset delay time
192	banner speed LCD9 (loop)
Axis Positions REGISTERS	
200	position free for teaching in
201	axis 11 maintenance position
202	axis 21 maintenance position
203	axis 31 maintenance position
204	axis 41 maintenance position
205	start position feed axis 41 for small windows
206	position axis 41 how far feed enters
207	position axis 41 for manual feeding
208	axis 41 unloading position for small windows
209	pull-in block after insertion distance
210	vacant position axis 41 if tool 22
211	intermediate position axis 41 enabling disc to work
212	position axis 11 from where disc machining starts
213	position axis 21 from where disc machining starts
214	position from where disc axes 11/21 linearly go to home position
215	surfacing position axis 41 for small windows
216	home position after drill motor axis 11 pivoting
217	home position after drill motor axis 21 pivoting
218	free position for lower HIR lowering
219	free position for RIMU lowering
220	free position for RIMO entering
221	free position for upper HIR moving outward
222	position axis 41 for rubber holding-down forward
223	position axis 31 for rubber holding-down up
224	position axis 41 for rubber holding-down back
225	position axis 31 for rubber holding-down down
226	Startposition Axis 11 for the 2.bright
227	Startposition Axis 21 for the 2.bright
228	offset value for transport in and out for small windows
229	vacant

Turning Station (frequency converter) with 1 or 2 Turning Wagons REGISTERS	
230	turning station's turning speed
231	position up to which turning station moves slowly while turning
232	turning station's regular speed
233	minimum speed
234	position where turning station feeds window unit quickly
235	slide extending position
236	light-spot scanner on side position
237	centre position
238	position offset after corner has reached centre light-spot scanner
239	maximum turning position
240	2nd turning wagon delivery position
241	maximum delay time for 2nd turning wagon unloading on its own
242	transfer position for trial run of 2nd turning wagon
243	position for taking 2nd turning wagon
244	position for fast unloading
245	delivery position (1st turning wagon)
246	delay time after light-spot scanner on the side
247	frequency converter turning station delivery position with one turning wagon
248	minimum turning station speed for small windows
249	regular turning station speed for small windows
250	maximum turning station speed for small windows
251	turning bolt forward delay time
252	centre position with first door corner
253	maximum door turning position in opposite direction
254	position up to which turning station moves slowly while turning a door
255	light-spot scanner on side position with doors in opposite direction
256	watingtime acrossacross drive first rotation
257	position acrossacross drive to drive in homeposition
258	special software register by 2.car, transport in and out small sizes
260	Position window lost
261	rotation speed in window
262	Safety position from rotation station when the value 1 is in the register 108
263	position acrossacross drive to drive in homeposition (DOOR)
264	Safety position from 2.rotation station when the value 1 is in the register 108
Turning Station	
270	number of corners to be cleaned
271	delay time when turning station starts
272	additional information (small window, offset value 1)
273	profile program for online welder
274	corner counter
275	vacant
276	hight of the window by hand over in On-Line at turning station

277	1 = grid active
278	on-line gister for STF-H
279	on-line gister for STF-H
Buffer Station REGISTERS	
280	
281	width of the window by hand over in on-line, buffer station input side
282	width of the window by hand over in on-line, buffer station output side
283	hight of the window by hand over in on-line, buffer station input side
284	hight of the window by hand over in on-line, buffer station output side
285	buffer forward delay time (idle travel)
286	buffer advance STOP delay time
287	cooling-down period
288	profile program when welder online entrance
289	profile program when welder online exit
290	additional information on entrance
291	additional information on exit
292	profile program when welder online centre
293	additional information on centre
294	vacant
Correction Values REGISTERS	
295	x-axis upper groove correction value
296	y-axis upper groove correction value
297	x-axis upper internal corner correction value
298	y-axis upper internal corner correction value
299	x-axis top drilling correction value
300	y-axis top drilling correction value
301	x-axis upper HRB correction value
302	y-axis upper HRB correction value
303	x-axis upper RIMO correction value
304	y-axis upper RIMO correction value
305	x-axis upper KIO correction value
306	y-axis upper KIO correction value
307	x-axis upper tool 7 correction value
308	y-axis upper tool 7 correction value
309	x-axis pivot drill correction value
310	y-axis pivot drill correction value
311	x-axis upper HIR correction value
312	y-axis upper HIR correction value
313	vacant
314	vacant
315	x-axis lower groove correction value
316	y-axis lower groove correction value

317	x-axis lower internal corner correction value
318	y-axis lower internal corner correction value
319	x-axis bottom drilling correction value
320	y-axis bottom drilling correction value
321	x-axis lower HIR correction value
322	y-axis lower HIR correction value
323	x-axis lower RIMU correction value
324	y-axis lower RIMU correction value
325	x-axis lower KIU correction value
326	y-axis lower KIU correction value
327	x-axis lower tool 7 correction value
328	y-axis lower tool 7 correction value
329	x-axis top rotary grinder
330	y-axis top rotary grinder
331	x-axis bottom rotary grinder
332	y-axis bottom rotary grinder
333	x-axis disc correction value
334	y-axis disc correction value
335	height measurement correction value
336	x-axis SEB
337	y-axis SEB
Cleaning Selection REGISTERS	
360	upper internal corner cleaning selection (0 = OFF)
361	lower internal corner cleaning selection (0 = OFF)
362	top grooving cleaning selection (0 = OFF)
363	bottom grooving cleaning selection (0 = OFF)
364	top drilling cleaning selection (0 = OFF)
365	bottom drilling cleaning selection (0 = OFF)
366	disc cleaning selection (0 = OFF)
367	HRB cleaning selection (0 = OFF)
368	lower HIR cleaning selection (0 = OFF)
369	RIMO cleaning selection (0 = OFF)
370	RIMU cleaning selection (0 = OFF)
371	KIO cleaning selection (0 = OFF)
372	KIU cleaning selection (0 = OFF)
373	upper tool 7 cleaning selection (0 = OFF)
374	lower tool 7 cleaning selection (0 = OFF)
375	pivot drill cleaning selection (0 = OFF)
376	upper HIR cleaning selection (0 = OFF)
377	vacant

Startposition top tools for Profiles	
7960	x-groove
7961	y-groove
7962	x-inner corner
7963	y-inner corner
7964	x-driller
7965	y-driller
7966	x-hrb
7967	y-hrb
7968	x-rimo
7969	y-rimo
7970	x-kio
7971	y-kio
7972	x-tool7
7973	y-tool7
7974	x-pivot drill
7975	y-pivot drill
7976	x-hir
7977	y-hir
7978	facant
7979	facant
7980	facant
7981	facant
7982	x-groove
7983	y-groove
7984	x-inner corner
7985	y-inner corner
7986	x-driller
7987	y-driller
7988	x-hir
7989	y-hir
7990	x-rimu
7991	y-rimu
7992	x-kiu
7993	y-kiu
7994	x-tool7
7995	y-tool7
7996	facant
7997	facant
7998	facant
7999	facant
8000	x-disc
8001	y-disc

factor for profile	
8970	x-factor for the profiles 100 x 120
8971	y-factor for the profiles 100 x 120
8972	x-factor for the profiles 200 x 240
8973	y-factor for the profiles 200 x 240
Info	
8190	cpu version
8191	machine number