

TB0384 Software Upgrade to v6 Operator Note

Any number of multiple batches can now be loaded one after the other, including remake batches and pos tests.

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Upgrading to winMulti v6 – Main Points for Machine Operators

User interface

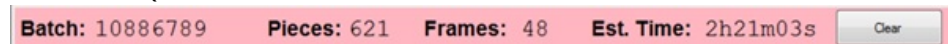
Resetting after a problem

Comments

Upgrading to winMulti v6 – Main Points for Machine Operators

User interface

- Any number of multiple batches can now be loaded one after the other, including remake batches and pos tests. Each batch joins the end of the Work Queue.



- The Clear button will clear a batch from the work queue
- A new Reoptimise button will Reoptimise the sub-batch of the profile / colour combination. This will give you some reoptimisation controls to modify how the software utilises the bar
 - Standard length can be changed if there is a batch of undersized bars
 - Increasing the optTol will make the optimisation “less fussy” on the first few bars which may reduce the number of offcuts overall
 - A second optimiser version can be used which deals with standard sized windows more effectively

Resetting after a problem

- The reset machine button only resets one side of the machine (MH or saw)
- On an Alarm, a Hard Reset will reset and redatum both the saw and Machining Centre Side
- A soft reset resets and redatums just the one side of the machine
- A full “Cold” PLC reset completely reboots the controller system. There is a button for this on the main service screen
- The software “remembers” how far along the bar it has been machined or cut, so on a restart after a problem, it will start from where it left off. There is the option to cut from scratch again, to do this, make sure the bar is removed from the loading area 0 it will tell you on the screen when to do this.