

WinMulti - Drives

This Page describes the drives screen in the winMulti Service Menu

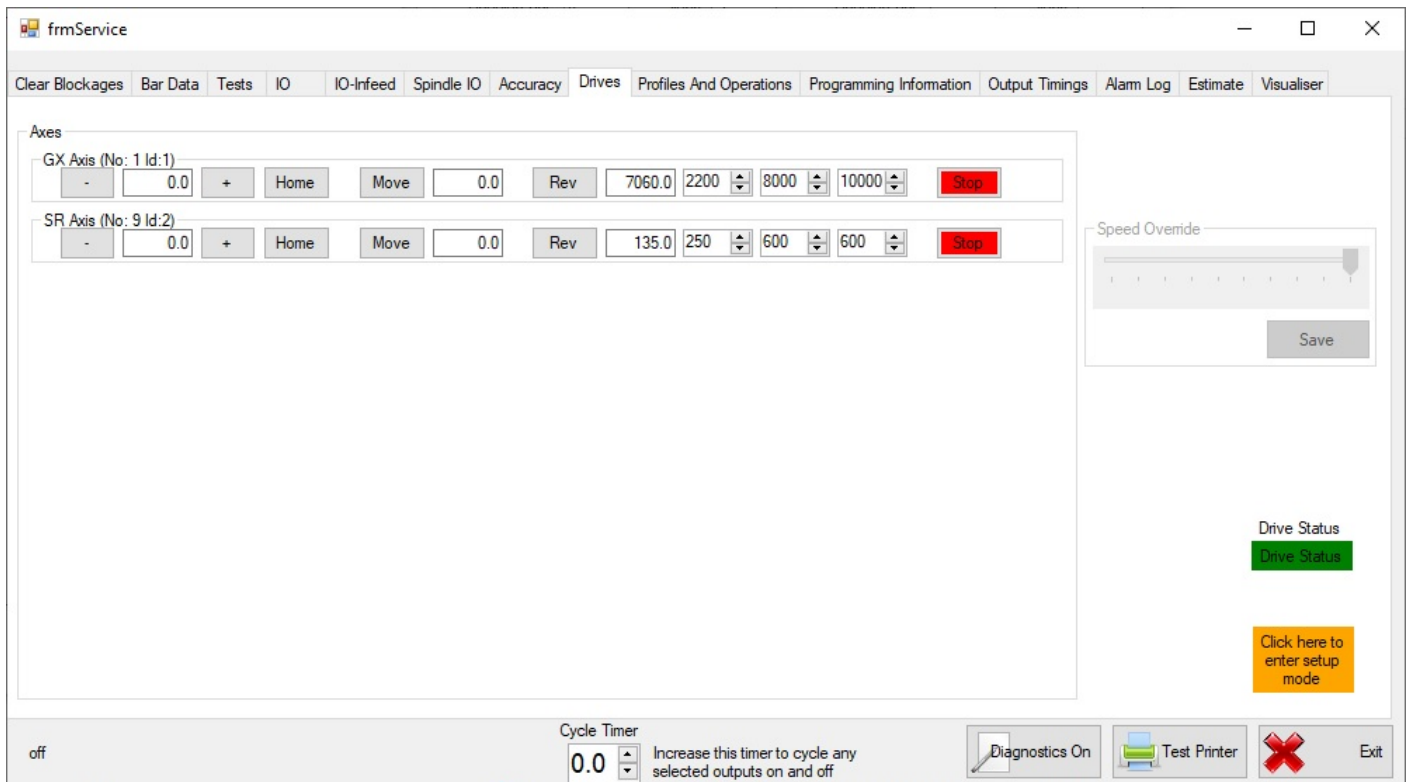
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Drives

The Drives tab allows manipulation of each of the axes. Each Machine type will have different drives as shown below. The manipulation of these can only be performed in **Manual Mode**, to enter manual mode from the main screen press the **STOP** Button once.

Saw Drives



Autocut Drives

Drive	Description
GX Axis	This is the axis for the saw pusher and works from 7060 (end if the infeed bed) to 0 (Saw Blade)
SR Axis	This is the axis for the Saw Blade Rotation and works from 45 to 135 degrees

Axes

+ / - Buttons

Once in Manual Mode tapping on the + and - buttons next to each of the drives will jog the axis in the appropriate direction, and the numbers between the +/- buttons show the current axis position.

Home

Tapping on the Home Button will move the axis back to its home position, as determined in the Settings - Axis screen.

Move & Stop

Type the position required into the Numbers after the Move button. When the move button is then pressed, the drive will attempt to move to the axis position given. Stop can be pressed at any point to halt this movement.

Reverse

The Reverse button reverses the direction of the associated drive.

Numbers

The Numbers after the Reverse button are (In order) Maximum Position, Speed, Acceleration, Deceleration

Speed Override

The speed override slider slows down the motor movements to give the operator time to intervene in diagnostic exercises.

Save

The Save Button saves and setting changes (e.g. Speed Override)

Setup Mode

This puts the machine into setup mode.

Test Printer

This button sends a test label to the printer.

Ecoline

The screenshot shows the 'frmService' application window. At the top is a menu bar with options: Clear Blockages, Bar Data, Tests, IO, IO-Infeed, Spindle IO, Accuracy, Drives, Profiles And Operations, Programming Information, Output Timings, Alarm Log, Estimate, and Visualiser. The main area is titled 'Axes' and contains six rows of controls for different axes:

- X Axis (No: 1 Id:1):** Home, Move (0.0), Rev (4000.0), and three speed limit dropdowns (1500, 1200, 2000).
- Y Axis (No: 4 Id:2):** Home, Move (0.0), Rev (119.0), and three speed limit dropdowns (300, 500, 500).
- Z Axis (No: 5 Id:3):** Home, Move (0.0), Rev (110.0), and three speed limit dropdowns (300, 500, 500).
- G Axis (No: 2 Id:4):** Home, Move (0.0), Rev (54.0), and three speed limit dropdowns (100, 100, 100).
- V Axis (No: 11 Id:5):** Home, Move (0.0), Rev (250.0), and three speed limit dropdowns (100, 300, 300).
- R Axis (No: 6 Id:6):** Home, Move (0.0), Rev (364.0), and three speed limit dropdowns (200, 400, 400).

On the right side, there is a 'Speed Override' slider and a 'Save' button. Below that is a 'Drive Status' indicator showing 'Drive Status' in green, and an orange button that says 'Click here to enter setup mode'. At the bottom of the window, there is a 'Cycle Timer' set to 0.0, a 'Diagnostics On' button, a 'Test Printer' button, and an 'Exit' button with a red X icon.

Ecoline Drives

Drive	Description
X Axis	This is the Gripper axis along the bar and works from the end of the infeed bed to the centre of the tools on the Ring
Y Axis	This is the Axis Away and Toward the operator and works from -104 to 119
Z Axis	This is the Up and Down axis and works from -114 to 110
G Axis	This is the Gripper Forward/Back Axis and works from 23mm from the back fence to 52mm from the back fence
V Axis	This is the V Notch Module axis and works from 5 to 250 home position is around 128mm
R Axis	This is the Ring Angle and works from 0 degrees to 359 degrees, at 90 degrees the tool is closest to the operator.

Flowline / ZX3 Drives

The screenshot shows the 'frmService' application window with a menu bar including 'Clear Blockages', 'Bar Data', 'Tests', 'IO', 'IO-Infeed', 'Spindle IO', 'Accuracy', 'Drives', 'Profiles And Operations', 'Programming Information', 'Output Timings', 'Alarm Log', 'Estimate', and 'Visualiser'. The 'Drives' tab is active, displaying a control panel for six axes:

- X Axis (No: 1 Id:1):** Position 0.0, Rev 6635.0, Max 2000.
- G Axis (No: 2 Id:2):** Position 0.0, Rev 72.0, Max 100.
- Y Axis (No: 4 Id:3):** Position 0.0, Rev 120.0, Max 500.
- Z Axis (No: 5 Id:4):** Position 0.0, Rev 120.0, Max 500.
- R Axis (No: 6 Id:5):** Position 0.0, Rev 363.0, Max 250.
- SX Axis (No: 10 Id:6):** Position 0.0, Rev 6645.0, Max 2000.

Each axis control includes a 'Home' button, a 'Move' field (set to 0.0), a 'Rev' field, and a 'Stop' button. A 'Speed Override' slider is on the right, currently at 100%. Below it is a 'Drive Status' indicator showing 'Drive Status' in green, and a yellow button labeled 'Click here to enter setup mode'. At the bottom, there is a 'Cycle Timer' set to 0.0, a 'Diagnostics On' button, a 'Test Printer' button, and an 'Exit' button with a red X icon.

Flowline Drives

Drive	Description
X Axis	This is the Gripper axis along the bar and works from the end of the infeed bed to the centre of the tools on the Ring
Y Axis	This is the Axis Away and Toward the operator and works from -120 to 120
Z Axis	This is the Up and Down axis and works from -120 to 120
R Axis	This is the Ring Angle and works from 0 degrees to 359 degrees, at 90 degrees the tool is closest to the operator.
G Axis	This is the Gripper Forward/Back Axis and works from 22mm from the back fence to 72mm from the back fence
SX Axis	This is the Saw Pusher X Axis and works from the end of the bed to the centre of the saw Blade (0 to -6645)

Microline

Microline Drives

Drive	Description
X Axis	This is the Gripper axis along the bar and works from the end of the infeed bed to the centre of the tools on the Ring
Y Axis	This is the Axis Away and Toward the operator and works from -120 to 120
Z Axis	This is the Up and Down axis and works from -120 to 120
R Axis	This is the Ring Angle and works from 0 degrees to 359 degrees, at 90 degrees the tool is closest to the operator.
G Axis	This is the Gripper Forward/Back Axis and works from 22mm from the back fence to 75mm from the back fence
A Axis	This is the Saw Blade axis forward and back which affects cut length on 45 degree pieces and Arrowheads

ZX4 Drives

ZX4 Drives

Drive	Description
X Axis	This is the Gripper axis along the bar and works from the end of the infeed bed to the centre of the tools on the Ring
Y Axis	This is the Axis Away and Toward the operator and works from -120 to 120
Z Axis	This is the Up and Down axis and works from -120 to 120
R Axis	This is the Ring Angle and works from 0 degrees to 359 degrees, at 90 degrees the tool is closest to the operator.
G Axis	This is the Gripper Forward/Back Axis and works from 22mm from the back fence to 72mm from the back fence
SX Axis	This is the Saw Pusher X Axis and works from the end of the bed to the centre of the saw Blade (0 to -6645)
V Axis	This is the axis for the front V notch blades and affects the base front notch depth
W Axis	This is the axis for the rear V notch blades and affects the base rear notch depth

ZX5 Drives

ZX5 Drives

Drive	Description
X Axis	This is the Gripper axis along the bar and works from the end of the infeed bed to the centre of the tools on the Ring
Y Axis	This is the Axis Away and Toward the operator and works from -120 to 120
Z Axis	This is the Up and Down axis and works from -120 to 120
R Axis	This is the Ring Angle and works from 0 degrees to 359 degrees, at 90 degrees the tool is closest to the operator.
VY Axis	This is the axis for the V notch Module and affects the base front/rear notch depths
SX Axis	This is the Saw Pusher X Axis and works from the end of the bed to the centre of the saw Blade (0 to 7700)
SY Axis	This is the Saw Front/Back axis and affects Cut Lengths on 45 degree pieces, Arrowheads and Y Notches
SR Axis	This is the Saw Blade Rotation Axis

Autoflow Drives

The screenshot shows the 'Drives' tab in the 'frmService' application. It features nine rows of axis controls, each with a position input (0.0), Home, Move, Rev, and Stop buttons. The Rev buttons are labeled with values: 7350.0, 75.0, 100.0, 119.0, 110.0, 361.0, 65.0, 160.0, and 315.0. To the right is a 'Speed Override' slider and a 'Save' button. Below the axes is a 'Drive Status' indicator showing 'Drive Status' in green. At the bottom, there is a 'Cycle Timer' set to 0.0, a 'Diagnostics On' button, a 'Test Printer' button, and an 'Exit' button with a red X icon.

Autoflow Drives

Drive	Description
GX Axis	This is the Gripper axis along the bar and works from the end of the infeed bed to the centre of the tools on the Ring
GY Axis	This is the Gripper Back to Front Axis and works from 20 to 75mm from the back fence
GZ Axis	This is the Gripper Up & Down Axis and works from 27 to 100mm above the bed
Y Axis	This is the Axis Away and Toward the operator and works from -120 to 120
Z Axis	This is the Up and Down axis and works from -120 to 120
R Axis	This is the Ring Angle and works from 0 degrees to 359 degrees, at 90 degrees the tool is closest to the operator.
SY Axis	This is the Saw Front/Back axis and affects Cut Lengths on 45 degree pieces, Arrowheads and Y Notches
SZ Axis	This is the Saw Up/Down axis and affects Cut Height
SR Axis	This is the Saw Blade Rotation Axis

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