WinMulti Software Upgrade - Skip Initialise

Upgrade to machine control software to allow restart from Emergency Stop without reinitialise

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Problem

Following estop, the software system has historically always required a full reinitialise including redatum. This is linked to the past where servo drive systems needed to be powered off on Estop, and had no means of saving the axis positions. It is also a great way of ensuring the system is completely reset properly.
The downside, however, is the amount of time it takes to reset. On machines such as the Autoflow , the bar has to be trimmed and replaced leading to wasted material.

> ...The light curtain on Autoflows A2001 to A2004 is a classic example of this. It is too easy to break the light beam when loading profile

Solution

Following the compliance review of 2022, more emergency stop related devices are needed - for example a light curtain across the infeed table on an autoflow. This means the system is far more likely to get triggered, and hence the time and profile wasted may increase to unacceptable levels

This has led to a new PLC software version (6.4) that will allow the restart of an Emergency stopped bar from where it has stopped. Front end (winMulti) software 6.4.96.0 is also required to provide the parameter

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canSkipInitialise
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If set to true, the restart from Estop process is different. Following the reset of the estop circuit (ES Reset button), the user is presented with 2 options

1. Press Start to continue
2. Press Stop to Abort and Reinitialise

Depending on the machine type, and the situation the machine is in (ie running a bar, loading, unloading, etc) the user will be stepped through the process for restarting where the bar left off

> ...On an Autoflow machine, emergency stop will casue the bar to be released by the gripper. The restart system will step through the regrip process.