WinMulti - Performing a Manual Input

This page will instruct the operator how to add a manual input piece to the bar queue.

Contents

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Select Profile		Single Operations Create Pieces Create Windows Components Manual Saw Cuts			
OrderBy	1				
	Alphanmueric	Select Operation			
		DFB DRAINS_SWC Drain Front Bead	^		
546725	DOOR T SASH	DFR DRAINS_SWC Drain Front Rebate			
	62mm Outerframe Gask	DRB DRAIND_SWC Drain Rear Bead			
	82mm T Transom/Mulli	DRR DRAIND_SWC Drain Rear Rebate			
	82mm Z Transom/Mulli	DTF DRAINS_SWC Drain Top Face			
	Comp Large Outerfram	EFB DRAINEQS Drain Front Bead EQ			
546771	Tilt & Turn	EFR DRAINEQS Drain Front Rebate EQ			
546776	Tilt & Turn	EXCF SP3S Excluder Front			
546815	52mm Outer 5C	HINCVP8F HOLE5 [Not Used]			
546825	62mm Outer 5C	K100X15F SL1Z2PT2 Door Keep 100 x 15 Front			
	72mm Outer 5C	KD68X15F SL1Z2PT2 Door Keep 68 x 15 Front		5 Positio	
546845	52mm Outer 6C	KD70X18F SL1Z2PT2 Door Keep 70 x 18 Front			
546855	Case T Sash 5C	KD75X18F SL1Z2PT2 Door Keep 75 x 18 Front		400	
546885	Case T Sash 5C	KD85X15F SL1Z2PT2 Door Keep 85 x 15 Front 4			
546910	Door Z Sash	KPADHF SL1Z2PT2 Paddock Hook Keep Front		Add Op	5
546920	Door T Sash	KPADLF SL1Z2PT2 Paddock Latch Keep Front	v 🔳		
546930	62 Rev Outerframe	-			1
546940	Fully Rev Sash			Add Al	l
546940R	Fully Rev Sash				7
546950	Fully Rev T Transom/	To Cut 7			
546960	Fully Rev Z Transom/:v	400.0 KPADHF Paddock Hook Keep Front			
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	Length 1000		0	Cicdin	ľ
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- 1. Profile Sorting and Selection. Here you can sort the profiles by Popularity or In Alphanumeric Order. Once that is done, scroll down and select the profile you wish to add to the bar queue.
- 2. Piece Length. This is either the length of the profile you are adding to the queue (at least 700mm), or if you intend to cut the profile in step 10, then this is the length of the cut required.
- 3. Single Operations Tab. This tab is used if you wish to simply add an operation, or multiple operations to the bar you selected in step 1. This will not cut the profile. (cuts can be added in step 10)
- 4. List of Operations. Here is the list of Operations that are available on the selected profile, scroll down and click on the operation you require.
- 5. Position. Type in the position of the operation from the gripper end of the bar, be aware, the position is generally the centre of the prep, try to keep the whole prep at least 300mm from the start and end of the bar to ensure it is clamped securely. this will increase accuracy. if the operation is too close to either end of the bar then it may not be clamped at certain points within the operation.
- 6. Add Op. Once the operation has been selected and a position entered, then click the add Op Button to add it to the list. Steps 4-6 can be repeated for multiple operations, please allow space between the preps, so one does not run into another.
- 7. To Cut. This is the list of operations added to the profile selected
- 8. Clear All. If you have made a mistake click this to clear the 'To Cut' List and return to step 4.
- 9. Enter / Cancel. If you simply wish to rout an operation/operations on the profile without any cuts, then click the Enter Button. this will adc the profile to the bar queue. (please note on a Flowline / ZX the piece once prepped will need to be retrieved from the transfer table, it will not be added to the saw cutting list. To abort the process, click on the cancel button. If you wish to perform saw cuts on the profile, then skip this step.

10. Create Pieces. Once the operations have been added to the profile, click on the Create Pieces tab and continue with WinMulti - Adding Cuts to the Manual Input Piece

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