

FRONT END PARAMETERS

FRIDAY, 24 JUNE 2005

NO:	NAME:	DESCRIPTION:	UNITS:	RANGE:
CONSOLE PARAMETERS				
1	Display Rounding	0 = Display rounding off. 1 = Display rounding on. 2 = Imperial displays – rounded to 2 D.Ps.	1	0 – 2
2	PIN Required	0 = PIN is always required to enter parameter mode. 1 = PIN is only required once after boot up to access parameter mode.	1	0 – 1
3	Matrix Filter Counter	Controls the amount of filtering applied to the pushbutton matrix.	0.1s	0.0 – 10.0
4	Jog Button Invert	Swaps the function of the Jog buttons on the setworks console: 0 = Normal jog buttons. 1 = Jog buttons inverted.	1	0 – 1
5	Setworks Type Select	0 = MiniMiser single/dual axis system. 1 = Carriage / Slabber system. 2 = Tachikawa Mill 1 Edger. 3 = Tachikawa Mill 2 Edger. 4 = Mahoe Twin Axis.	1	0 - 4
6	UDP Network Address	0 = Master on network, or no network enabled. 1 – 199 = Slave address on network	1	0 - 199
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SET PARAMETERS				
10	Set Mode	0 = Instant set; no stacking of sizes. 1 = Flag set; flag used to move through the set.	1	0 – 1
11	Clear Operation	0 = Standard Operation (entire stack is emptied when Clear is pressed). 1 = Retain Stack (only the entry at the top of the stack is erased).	1	0 - 1
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13	Auto-calibrate Inhibit	0 = Auto-calibrate inhibited. 1 = Auto-calibrate allowed.	1	0 – 1
14	Crash Tolerance	Crash or racking tolerance in a multi-axis system.	0.1mm	0.0 – 2000.0
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DISPLAY PARAMETERS																																																								
20	VPD 1 Format Select	<p>Specifies the data to be displayed in the Loop 1 Vertical Position Display:</p> <table border="1"> <thead> <tr> <th>POS</th> <th>NEXT SET</th> <th>LAYER</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>0 = L1 pos;</td> <td>L1 Next Set;</td> <td>Layer;</td> <td>L1, L2.</td> </tr> <tr> <td>1 = L1 pos;</td> <td>L1 Next Set;</td> <td>L2 pos;</td> <td>L1, L2.</td> </tr> <tr> <td>2 = L1 pos;</td> <td>L1 Next Set;</td> <td>L3 pos;</td> <td>L1, L3.</td> </tr> <tr> <td>3 = L1 pos;</td> <td>L1 Next Set;</td> <td>L4 pos;</td> <td>L1, L3, L4.</td> </tr> <tr> <td>4 = L1 pos;</td> <td>L1 Next Set;</td> <td>Pick State;</td> <td>L1, L3, L4.</td> </tr> <tr> <td>5 = L1 pos;</td> <td>L1 Next Set;</td> <td>L1 counts;</td> <td>L1, L2.</td> </tr> <tr> <td>6 = L1 pos;</td> <td>L1 Next Set;</td> <td>L2 counts;</td> <td>L1, L2.</td> </tr> <tr> <td>7 = L1 pos;</td> <td>L1 Next Set;</td> <td>L1 drive;</td> <td>L1, L2.</td> </tr> <tr> <td>8 = L1 pos;</td> <td>L1 Next Set;</td> <td>L2 drive;</td> <td>L1, L2.</td> </tr> <tr> <td>9 = L1 pos;</td> <td>L1 Next Set;</td> <td>L1 An I/P;</td> <td>L1, L2.</td> </tr> <tr> <td>10 = VPD1-0</td> <td colspan="2">10 bar LED status display</td> <td></td> </tr> <tr> <td>11 = Matrix</td> <td colspan="2">diagnosis displayed in VPD1 Layer.</td> <td></td> </tr> </tbody> </table>	POS	NEXT SET	LAYER	STATUS	0 = L1 pos;	L1 Next Set;	Layer;	L1, L2.	1 = L1 pos;	L1 Next Set;	L2 pos;	L1, L2.	2 = L1 pos;	L1 Next Set;	L3 pos;	L1, L3.	3 = L1 pos;	L1 Next Set;	L4 pos;	L1, L3, L4.	4 = L1 pos;	L1 Next Set;	Pick State;	L1, L3, L4.	5 = L1 pos;	L1 Next Set;	L1 counts;	L1, L2.	6 = L1 pos;	L1 Next Set;	L2 counts;	L1, L2.	7 = L1 pos;	L1 Next Set;	L1 drive;	L1, L2.	8 = L1 pos;	L1 Next Set;	L2 drive;	L1, L2.	9 = L1 pos;	L1 Next Set;	L1 An I/P;	L1, L2.	10 = VPD1-0	10 bar LED status display			11 = Matrix	diagnosis displayed in VPD1 Layer.			1	1 - 11
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21	VPD 2 Format Select	<p>Specifies the data to be displayed in the Loop 2 Vertical Position Display:</p> <table border="1"> <thead> <tr> <th>POS</th> <th>NEXT SET</th> <th>LAYER</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>0 = L2 pos;</td> <td>----</td> <td>----</td> <td>----</td> </tr> <tr> <td>1 = L2 pos;</td> <td>L2 Next Set;</td> <td>----</td> <td>L2.</td> </tr> <tr> <td>2 = L2 pos;</td> <td>L2 Next Set;</td> <td>L3 pos;</td> <td>L2.</td> </tr> <tr> <td>3 = L2 pos;</td> <td>L2 Next Set;</td> <td>L4 pos;</td> <td>L2.</td> </tr> <tr> <td>4 = L2 pos;</td> <td>L2 Next Set;</td> <td>Pick State;</td> <td>L2.</td> </tr> <tr> <td>5 = VPD1-0</td> <td colspan="2">10 bar LED status display</td> <td></td> </tr> </tbody> </table>	POS	NEXT SET	LAYER	STATUS	0 = L2 pos;	----	----	----	1 = L2 pos;	L2 Next Set;	----	L2.	2 = L2 pos;	L2 Next Set;	L3 pos;	L2.	3 = L2 pos;	L2 Next Set;	L4 pos;	L2.	4 = L2 pos;	L2 Next Set;	Pick State;	L2.	5 = VPD1-0	10 bar LED status display			1	1 - 5																								
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22	PBD Format Select	<p>Specifies the format of the data to be displayed in the consoles pushbutton displays:</p> <p>0 = Standard button layout 1 = Standard button layout, saw numbers shown 2 = Button layout 2 3 = Button layout 2, saw numbers shown</p>	1	0 - 3																																																				
23	VPD Brilliance Level	Sets the brilliance level of the main displays on the networks console.	1	1 - 7																																																				
24	PBD Dim Brilliance Level	Sets the brilliance level of the pushbutton displays when they are in "dim" (default) mode.	1	1 - 7																																																				
25	PBD Bright Brilliance Level	Sets the brilliance level of the pushbutton displays when they are in "bright" mode.	1	1 - 7																																																				
26	Forwardset Counter Control	<p>0 = F/S counter disabled 1 = F/S counter enabled</p>	1	0 - 1																																																				
27	Edger Absolute Positions	<p>Sets the format that the positions of the saws in an edger system will take:</p> <p>0 = Display saw absolute positions. 1 = Display the gaps between the saws</p>	1	0 - 1																																																				
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HW I/O PARAMETERS				
30	Hardwired Filter Delay	The time delay used to filter the hardwired inputs to the system to avoid the possibility of switch bounce problems.	0.1s	0.0 – 10.0
31	Run Confirm Operation 1	0 = Run confirm input bypassed. 1 = Run confirm input used.	1	0 – 1
32	Flag 1 Operation	0 = Flag input bypassed. 1 = Normal flag operation – interrupted set resumes when flag clears. 2 = Current set is cancelled when flag is opened.	1	0 – 2
33	Flag 2 Operation	0 = Flag input bypassed. 1 = Normal flag operation – interrupted set resumes when flag clears. 2 = Current set is cancelled when flag is opened. 3 = Use “Flag 1” as the input for “Flag 2”.	1	0 - 3
34	Jog Back Flag Override	0 = “Jog Back” overrides the flag input. 1 = “Jog Back” is stopped when the flag opens.	1	0 – 1
35	Pullback Operation	0 = Pullback disabled. 1 = Manual pullback. 2 = Auto pullback. 3 = Preselect auto pullback.	1	0 - 3
36	Pullback Delay	Time delay after the dogs are lowered before the auto-pullback is engaged.	0.1s	0.0 – 10.0
37	Slow Valve Delay	The time delay between the “Fast” and “Slow” valves closing on a two-speed system	0.1s	0.0 – 10.0
38	Run Confirm Operation 2	0 = Run confirm input bypassed. 1 = Run confirm input used. 2 = Run confirm 1 input used for Run confirm 2	1	0 – 2
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HW INPUT SELECTION PARAMETERS				
40	HW IP0 Selection	Specifies the function that HW IP0 will perform: 0 = IP is not used. 1 = Estop. 2 = Run Confirm 1. 3 = Loop1 Flag. 4 = Loop2 Flag. 5 = Prox Switch 1. 6 = Other Prox switches. 7 = Run Confirm 2. 8 = Blowdown. 9 = Flaps.	1	0 - 7
41	HW IP1 Selection	Specifies the function that HW IP1 will perform.	1	0 - 7
42	HW IP2 Selection	Specifies the function that HW IP2 will perform.	1	0 - 7
43	HW IP3 Selection	Specifies the function that HW IP3 will perform.	1	0 - 7
44	HW IP4 Selection	Specifies the function that HW IP4 will perform.	1	0 - 7
45	HW IP5 Selection	Specifies the function that HW IP5 will perform.	1	0 - 7
46	HW IP6 Selection	Specifies the function that HW IP6 will perform.	1	0 - 7
47	HW IP7 Selection	Specifies the function that HW IP7 will perform.	1	0 - 7
48	HW IP8 Selection	Specifies the function that HW IP8 will perform.	1	0 - 7
49	HW IP9 Selection	Specifies the function that HW IP9 will perform.	1	0 - 7
50	HW IP10 Selection	Specifies the function that HW IP10 will perform.	1	0 - 7
51	HW IP11 Selection	Specifies the function that HW IP11 will perform.	1	0 - 7
52	HW IP12 Selection	Specifies the function that HW IP12 will perform.	1	0 - 7
53	HW IP13 Selection	Specifies the function that HW IP13 will perform.	1	0 - 7
54	HW IP14 Selection	Specifies the function that HW IP14 will perform.	1	0 - 7
55	HW IP15 Selection	Specifies the function that HW IP15 will perform.	1	0 - 7
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HW OUTPUT SELECTION PARAMETERS				
60	HW OP0 Selection	Specifies the function that HW OP0 will perform: 0 = OP is not used. 1 = Start. 2 = Dogs U/D. 3 = Dogs I/O. 4 = Half Dog. 5 = Tong Dog. 6 = Pullback. 7 = Flipper. 8 = Valve Lock1. 9 = Valve Lock2. 10 = Taper Left. 11 = Taper Right. 12 = Slow Valve1 / Unipolar Rev1. 13 = Slow Valve2 / Unipolar Rev2. 14 = Taper Isolate. 15 = Taper Cancel.	1	
61	HW OP1 Selection	Specifies the function that HW OP1 will perform.	1	
62	HW OP2 Selection	Specifies the function that HW OP2 will perform.	1	
63	HW OP3 Selection	Specifies the function that HW OP3 will perform.	1	
64	HW OP4 Selection	Specifies the function that HW OP4 will perform.	1	
65	HW OP5 Selection	Specifies the function that HW OP5 will perform.	1	
66	HW OP6 Selection	Specifies the function that HW OP6 will perform.	1	
67	HW OP7 Selection	Specifies the function that HW OP7 will perform.	1	
68	HW OP8 Selection	Specifies the function that HW OP8 will perform.	1	
69	HW OP9 Selection	Specifies the function that HW OP9 will perform.	1	
70	HW OP10 Selection	Specifies the function that HW OP10 will perform.	1	
71	HW OP11 Selection	Specifies the function that HW OP11 will perform.	1	
72	HW OP12 Selection	Specifies the function that HW OP12 will perform.	1	
73	HW OP13 Selection	Specifies the function that HW OP13 will perform.	1	
74	HW OP14 Selection	Specifies the function that HW OP14 will perform.	1	
75	HW OP15 Selection	Specifies the function that HW OP15 will perform.	1	
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SPARE PARAMETERS				
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DIAGNOSTIC PARAMETERS				
90	Maximum Loop Time	The maximum time the system has taken to perform a loop since this parameter was last read.	0.1ms	-
91	Running Time	The amount of time the system has been running since the master controller card was last reset.	1 min	-
92	Software Version	The version of software currently running in the master controller card.	0.01	-
93	Plot Sample Period	The length of time after a set is initiated that the system will record the data for the set plotting software.	1 sec	1 - 10
94	Serial Baud Rate	Sets the baud rate for serial communications: 1 = 9600 bps 2 = 14400 bps 3 = 19200 bps 4 = 28800 bps 5 = 38400 bps	1	1 - 5
95	Operator PIN Number	The PIN number used by the operator. This PIN allows access to the "Probe Offset" parameters only.	1	0 – 9999
96	Supervisor PIN Number	The PIN number used by the supervisor. This PIN allows access to all of the parameters for the system.	1	0 - 9999
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