

CHANNEL DEFINITIONS, 58.06 SOFTWARE

- 1) Turn key to Supervisors Position, press 'Quantity' , '#' , then '3'.
- 2) Type access code, 5 6 8 6, press enter.
- 3) 'Load Standard Program?' press 'No'.
- 4) 'Define Channel 1?' press 'Yes'.

OPTIONS	C1	C2	C3	C4	C5	C6	C7	C8
Channel (Enabled/Disabled)								
Force Line (1-8)								
Integrate / Peak								
P Target (96)								
I Target (128)								
Position Sense								
Prox Sense Line (1, 2)								
Read While (On/Off)								
*Backstroke High Limit (On/Off) -Backstroke Headroom (16) -Backstroke Exceptions (On/Off)								
*No Feed (Cons/Cum/Off) -No Feed Exceptions (On/Off)								
Immediate Limits (On/Off)								
Limits (Low & High, Low, High)								
Limits on (SLMH)								
Fixed Limits (Enabled/Disabled)								
Fast Limits (On/Off)								
Trending Limits (On/Off)								
#Exception Limits (Cons/Cum/Off) -Exceptions (Low & High, Low, High)								
Channel Name								

*** Thread Rolling Machines Only**

Machines Using a Diverter Gate Only

- 5) 'Channel Setup Complete', turn key back to Operators Position.

Channel Definitions Glossary, 58.06 Software

- 1) **Channel (Enabled/Disabled)** = Turns on a specific channel in the software.
- 2) **Force Line (1-8)** = An IMPAX can use up to 8 sensor inputs, plugged on to the Satellite Board and this option determines which sensor to use for the channel.
- 3) **Integrate / Peak** = Integrate sensors are the normal force sensors used in Rollers and Headers. Peak sensors are typically used for feed stop monitoring in headers.
- 4) **P Target & I Target** = Values used to establish a baseline in it's calculations.
- 5) **Sense Line (1,2)** = Tells the IMPAX what position sensor is assigned to the channel. Enhanced timing can utilize two proximity sensors for more accurate monitoring in certain machines, i.e. 2Die 3Blow headers.
- 6) **Read While (ON/OFF)** = Determines when the channel will listen to its associated sensor. A cutoff sensor in a header is typically the opposite of the normal forming channels. This setting is important in a roller because it determines the backstroke and idle stroke calculations.
- 7) **Backstroke High Limit (ON/OFF)** = In thread rolling applications it is necessary to ensure parts are not pulled back in to the dies during the backstroke. This threshold, along with the proximity sensor, allows the IMPAX to 'listen' for these errors.
- 8) **Backstroke Headroom (16)** = A setting from 1-255, but is a standard setting of 16. This is the limit above a normal backstroke. Any value felt above this limit will cause a 'Backstroke Error'.
- 9) **Backstroke Exceptions (ON/OFF)** = This setting allows a certain number of bad parts to be accepted. Generally should be turned off.
- 10) **No Feed (Cons/Cum/Off)** = During thread rolling, parts may periodically stop in the feed rail causing a pause in the process. No feeds are either Consecutive (in a row), Cumulative (out of 100) or OFF. Consecutive is the most common application.
- 11) **Immediate Limits (ON/OFF)** = This enables the fastest protection possible in an IMPAX with a learn cycle of 4 strokes.
- 12) **Limits (Low &High, Low Only, High Only)** = Normally set to Low &High limits. Low or High Only can be used for certain applications, such as a short feed sensor.
- 13) **Limits on (S,L,M,H)** = These indicate which tests are activated for this channel. SLMH all on is the normal configuration, utilizing all of the IMPAX monitoring capabilities.
- 14) **Fixed Limits (Enabled/Disabled)** = This can allow operators to set their own limits on the 0 – 255 number scale and bypass the IMPAX calculations for the Tolerance scale.
- 15) **Fast Limits (ON/OFF)** = Allows the IMPAX to display Tolerance recommendations faster than the 150 part learn cycle. Normally turned on.
- 16) **Trending Limits (ON/OFF)** = Normally turned off for IMPAX calculations.
- 17) **Exception Limits (Cons/Cum/Off)** = This option can only be used if a parts diverter controls the output of the machine.
- 18) **Channel Name** = Allows a channel to have a specific name identified with it. Use the '*' on the keypad to switch between numeric and alphanumeric characters.

* For more detailed descriptions of functions please consult the 'IMPAX Supervisors Guides' or call Process Technologies Group for assistance*