



# MICROTROL ENGINEERING

## ME-1250 CONTROL DESCRIPTION

ME11250-SB052715

THE ME-1250 CNC IS A STATE OF THE ART, MULTI AXIS STRETCH PRESS CONTROL SYSTEM THAT PROVIDES RELIABLE STRETCHING FUNCTION WITH EASY TO USE PROGRAMMING AND OPERATION FUNCTIONS. THE SYSTEM USES INDUSTRIAL STYLE COMPUTERS WITH PLC RELIABILITY TO GIVE THE CUSTOMER THE BEST STRETCHING SOLUTION. BELOW ARE THE FEATURES THE ME-1250 PROVIDES. THERE ARE TWO VERSIONS OF THE CONTROL SOFTWARE THAT ARE STEP BASED PROGRAMMING AND CNC PROGRAM FILE BASED PROGRAMMING.

### HARDWARE:

- 17 INCH TOUCH SCREEN WITH HMI CONTROL SOFTWARE
- NEW ADVANTECH INDUSTRIAL COMPUTER FOR SYSTEM CONTROL AND PROGRAM STORAGE.
- NEW DISTRIBUTED I/O CPAC PLC SYSTEM FOR AXIS AND MACHINE CONTROL
- NEW OPERATOR CONSOLE AND MOTION PB INTERFACE
- UP TO 24 FEEDRATE INTERPOLATED SERVO VALVE AXIS CONTROL
- 16 SOLENOID AXIS POSITION CONTROL
- FEEDRATE OVERRIDE CONTROLS FOR CARRIAGE, TENSION AND TABLES
- 4 PROPORTIONAL PRESSURE CONTROL OUTPUTS
- 32 POSSIBLE PRESSURE SENSORS
- 8 ETHERNET DISTRIBUTED NODE INTERFACES
- SOLID STATE HARD DRIVE FOR PROGRAM STORAGE
- ETHERNET INTERFACE FOR CUSTOMER NETWORKS
- NEW DELTA SERVO AMPLIFIERS
- NEW ANALOG IN/OUT FOR TRANSDUCERS AND EHST PRESSURE VALVES
- ENHANCED MACHINE DIAGNOSTICS SCREENS AND PLC MONITORING
- USB PORTS FOR OFFLOADING PROGRAMS
- OPC KEPCORE SYSTEM
- WEIDMANN INDUSTRIAL CONTROL CONSOLE
- NEW STRIDE INDUSTRIAL NETWORK SWITCHES FOR MODULE COMMUNICATIONS.



SPECIFICATION ME11250-SB052715

2751 PLAZA DEL AMO UNIT 304 - TORRANCE - CALIFORNIA - 90503

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## SOFTWARE:

- WINDOWS 7 PROFESSIONAL OPERATING SYSTEM (XP AVAILABLE)
- CUSTOMIZED HMI OPERATOR INTERFACE
- 7 CYCLE SELECTABLE PRIMARY FUNCTIONS (OBLOCK: UNLOAD, SNUG, PRE, POST, STRETCH, RELAX, AND UNLOAD)
- EACH PRIMARY STEP CAN HAVE UP TO 999 SUB STEPS(NBLOCKS) FOR THE CNC VARIANT AND 15 BLOCKS FOR THE STEP BASED CONTROL.
- PROGRAMMING CAN BE DONE ON CONTROL AND OFFLINE
- 4 OPERATION MODES:
  - AUTO MODE - RUNS CURRENT PROGRAM THROUGH ALL STEPS
  - MDI MODE - RUNS ONE MANUALLY ENTERED NBLOCK LINE
  - MANUAL MODE - ALLOWS THE OPERATOR TO JOG THE MACHINE
  - TEACH MODE - TEACH A NEW PART PROGRAM WITH MANUAL MOVE STEP
- PROGRAMMABLE SCREEN INDICATORS
- ALARM SCREEN
- CALIBRATION SCREEN FOR EASY MACHINE SETUP AND CALIBRATION
- DIAGNOSTICS SCREENS FOR PLC AND ALL DISTRIBUTED I/O MODULES
- SETTINGS SCREEN FOR MACHINE PARAMETERS
- 80 GIGABYTE PART PROGRAM STORAGE
- CUSTOMER ETHERNET PORT FOR PROGRAM TRANSFER
- OFFLINE PART PROGRAM PROGRAMMING
- NON-PROPRIETY PART PROGRAM FORMAT
- PLC LADDER PROGRAM DISPLAY FOR TROUBLESHOOTING
- HMI PROGRAM SOURCE CODE AVAILABLE
- AXIS LAG ERROR DETECTION ON SERVO CONTROLLED AXES
- AXIS SYNCHRONIZATION ERROR DETECTION ON CARRIAGE AND DIE TABLE OR ANY DUAL CYLINDER AXES
- AXIS PROGRAMMABLE SOFT TRAVEL LIMITS
- AXIS NON- MOVEMENT ON SOLENOID CONTROLLED AXES
- DUAL PID INTERPOLATED VELOCITY POSITIONING CONTROL
- FORCE MODE MEASUREMENTS ON DIE TABLE AND TENSION CYLINDERS
- PROGRAMMABLE JAW PRESSURE CONTROL
- PROGRAMMABLE BULLDOZER PRESSURE CONTROL
- RTD TEMPERATURE SENSOR FOR HYDRAULIC OIL
- OVER-TEMP WARNING AND SHUTDOWN PARAMETER CONTROLLED
- SETTABLE MACHINE DEFINITION PARAMETERS
- DISTRIBUTED NODE CONFIGURATION
- FEEDBACK LOSS DETECTION
  - ETHERNET COMMUNICATION
  - 32BIT DIGITAL INPUTS
  - 16 RELAY CONTACT OUTPUTS
  - 8 ANALOG INPUTS (0-10V OR 4-20MA FOR POSITION AND PRESSURE)
  - 4 ANALOG OUTPUTS (0-10V OR 4-20MA FOR SERVOS AND ESHT)



# MICROTROL ENGINEERING

## OPERATOR CONSOLE CONTROLS:

- CARRIAGE JOG JOYSTICK CONTROLS
- TENSION CYLINDER JOYSTICK CONTROLS
- CARRIAGE ROTATION JOYSTICK CONTROLS
- DIE TABLE JOYSTICK CONTROLS
- DIE TABLE ROTATION JOYSTICK CONTROLS
- SWING SELECTOR SWITCH CONTROLS
- OSCILLATION SELECTOR SWITCH CONTROLS
- ROTATION SELECTOR SWITCH CONTROLS
- BULLDOZER JOYSTICK CONTROLS
- LOAD OPERATION PUSHBUTTON
- SNUG OPERATION PUSHBUTTON
- PRE OPERATION PUSHBUTTON
- STRETCH OPERATION PUSHBUTTON
- POST OPERATION PUSHBUTTON
- RELAX OPERATION PUSHBUTTON
- UNLOAD OPERATION PUSHBUTTON
- CYCLE START PUSHBUTTON
- CYCLE PAUSE PUSHBUTTON
- CYCLE CANCEL PUSHBUTTON
- JAW CLAMP/UNCLAMP SELECTOR SWITCHES
- MACHINE ON PUSHBUTTON
- MACHINE OFF PUSHBUTTON
- CONTROL ON PUSHBUTTON
- CONTROL OFF PUSHBUTTON
- ALARM RESET PUSHBUTTON
- FEEDRATE OVERRIDE POT
- EMERGENCY STOP PUSHBUTTON
- AUTO/MANUAL/MDI/TEACH MODE SELECTOR SWITCH

## CNC CONTROL SCREENS:

- MAIN POSITION STATUS SCREEN
- PART PROGRAM EDITING SCREEN
- FORCE YIELD SCREEN
- MACHINE ALARM SCREEN
- MACHINE CONTROL PARAMETERS SCREEN
- SYSTEM CALIBRATION SCREEN
- DIAGNOSTIC MAINTENANCE SCREENS (DISTRIBUTED I/O)
- PLC LADDER SCREEN



# MICROTROL ENGINEERING

## ME1250 STEP PROGRAMMING VARIANT:

THE ME-1250 STEP SOFTWARE VARIANT IS A 7 CYCLES WITH 15 PROGRAMMABLE STEPS FOR EACH CYCLE FOR A TOTAL OF 105 PROGRAMMING STEPS. THIS VERSION OF THE SOFTWARE EMULATES THE CYRIL BATH CONTROL PROGRAMMING METHOD ON OLDER CONTROLS AND ALLOWS THE USER TO RE-USE THEIR EXISTING PROGRAMS THAT HAVE BEEN CREATED OVER THE YEARS. WITH THIS STYLE, THE USER CAN QUICKLY START RUNNING THEIR MACHINE WITH LITTLE OR NO PROGRAMMING REWRITE TIME.

## STEP PROGRAMMING PROGRAMMABLE AXES:

- CARRIAGE POSITION
- CARRIAGE RATES
- CARRIAGE ANGLE
- DIE TABLE POSITION
- DIE TABLE ANGLE
- DIE TABLE RATE
- DIE TABLE FORCE
- TENSION POSITION
- TENSION RATE
- TENSION FORCE
- SWING POSITION (RATE ON SERVO STYLE AXIS)
- ROTATE POSITION (RATE ON SERVO STYLE AXIS)
- OSCILLATE POSITION (RATE ON SERVO STYLE AXIS)
- CENTROID POSITION (RATE ON SERVO STYLE AXIS)
- JAW CURVE
- BULLDOZER POSITION
- BULLDOZER FORCE

## STEP PROGRAMMING CNC FUNCTIONS:

- SINGLE BLOCK
- TEACH MODE STEP SET
- TEACH MODE PRIMARY LOAD STEP SET
- LOAD STEP CNC PROGRAM
- SAVE STEP CNC PROGRAM
- NEW CNC PROGRAM
- INDIVIDUAL CYCLES CAN BE RUN BY PUSHBUTTON CONTROL
- CYCLE SELECTION ENABLE FOR AUTOMATIC CYCLE
- STEP SEQUENCE COUNTER
- PROGRAM SEARCH
- STRETCH RATE OVERRIDE
- ABSOLUTE/INCREMENTAL PROGRAMMING



# MICROTROL ENGINEERING

## STEP PROGRAM EDIT SCREEN

**LOAD CYCLE**

STEP	LEFT CARRIAGE		TENSION		SWING		ROTATE		OSCILL		DIE TABLE		RIGHT CARRIAGE		TENSION		SWING		ROTATE		OSCILL		SPM Rate	Dwell	Force
	POSITION	ANGLE	POSITION	ANGLE	ANGLE	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE			
1	28.00										34.00		28.00										20.0	1.0	
2			5.00												5.00										

**PROGRAM INFORMATION**

Part Number:   
 Tool Number:   
 Material Type:   
 Material Width: Inches   
 Material Length: Inches   
 Elongation: %

**DEFAULTS**

SWRATE: 7.0  
 FORCE TONE: 500  
 DWELL: 1.0

**CURRENT POSITIONS**

	LEFT	RIGHT
CAR POS	27.50	27.50
CAR ANG	0.00	0.00
TEN POS	6.00	6.00
SWING	0.0	0.0
OSCE	0.0	0.0
ROTATE	0.0	0.0
DIE TABR	38.00	0.00
DWELL	0.0	

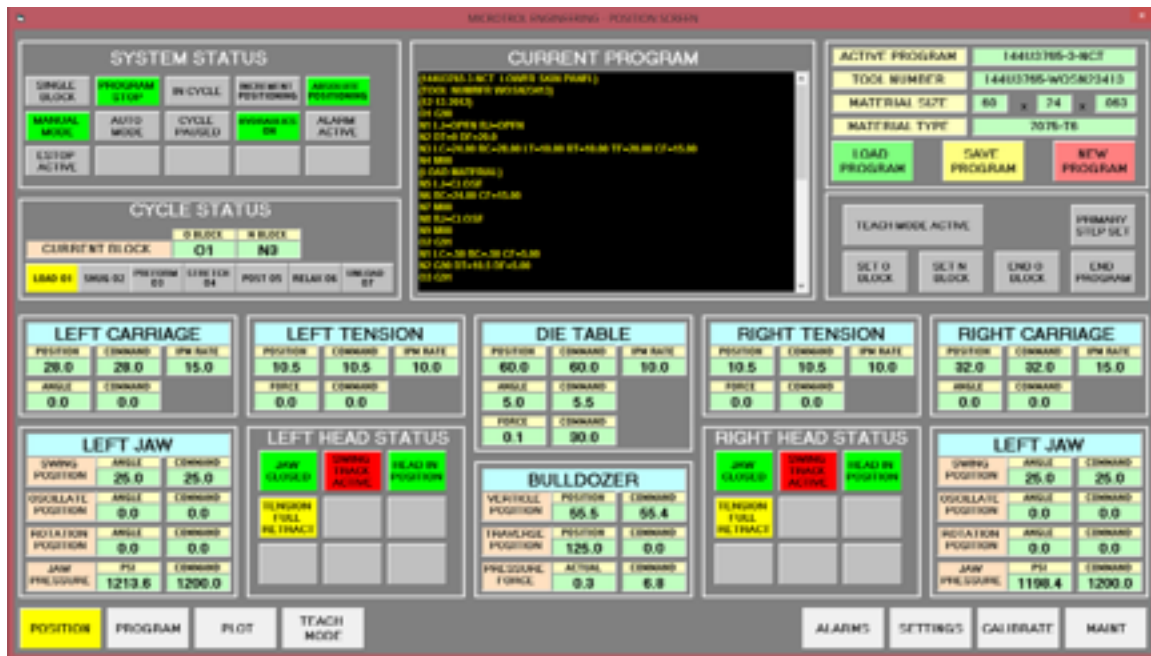
LOAD CYCLE | SNUG CYCLE | PRE FORM CYCLE | FORM CYCLE | POST CYCLE | RELAX CYCLE | UNLOAD CYCLE | Main Screen



# MICROTROL ENGINEERING

## ME1250 NC PROGRAMMING VARIANT:

THE ME-1250 NC SOFTWARE VARIANT IS A TRADITION CNC PROGRAMMING CONTROL THAT OFFERS THE SAME 7 SELECTABLE CYCLES BUT WITH NC TEXT PROGRAMMING METHOD. THIS VARIANT OF THE ME1250 SOFTWARE ALLOWS UNLIMITED PROGRAMMING STEPS PER CYCLE AS THE PROGRAM CAN BE AS LARGE AS THE FILE STORAGE OF THE CONTROL. AXES ARE PROGRAMMED WITH TEXT CODING AS WELL AS MISCELLANEOUS MACHINE FUNCTIONS SUCH AS AUTOMATIC JAW CLAMPING AND PRESSURE SCALING. EACH CYCLE IS SET BY AN O BLOCK AND BASED ON THE NUMBER CAN BE CALLED UP INDIVIDUALLY WITH THE 7 CONTROL CYCLE PUSHBUTTONS FOR MANUAL CYCLE RUNS.





# MICROTROL ENGINEERING

## NC PROGRAMMING PROGRAMMABLE AXES:

- CARRIAGE POSITION
- CARRIAGE RATES
- CARRIAGE ANGLE
- DIE TABLE POSITION
- DIE TABLE ANGLE
- DIE TABLE RATE
- DIE TABLE FORCE
- TENSION POSITION
- TENSION RATE
- TENSION FORCE
- SWING POSITION (RATE ON SERVO STYLE AXIS)
- ROTATE POSITION (RATE ON SERVO STYLE AXIS)
- OSCILLATE POSITION (RATE ON SERVO STYLE AXIS)
- CENTROID POSITION (RATE ON SERVO STYLE AXIS)
- JAW CURVE
- BULLDOZER POSITION
- BULLDOZER FORCE

## CNC FUNCTIONS:

- OPTIONAL STOP
- BLOCK SKIP
- SINGLE BLOCK
- TEACH MODE OBLOCK SET
- TEACH MODE NBLOCK SET
- TEACH MODE PRIMARY STEP SET
- PROGRAM SEQUENCE SEARCH
- LOAD CNC PROGRAM
- SAVE CNC PROGRAM
- NEW CNC PROGRAM
- INDIVIDUAL CYCLES CAN BE RUN BY PUSHBUTTON CONTROL
- CYCLE SELECTION ENABLE FOR AUTOMATIC CYCLE
- STEP SEQUENCE COUNTER
- PROGRAM SEARCH
- STRETCH RATE OVERRIDE
- ABSOLUTE/INCREMENTAL PROGRAMMING



# MICROTROL ENGINEERING

## CNC PROGRAM PREPARATORY AND MISCELLANEOUS CODES FOR NC VARIANT CONTROLLER:

- G00 RAPID POSITIONING (NO FEEDRATE NEEDED)
- G01 FEED POSITIONING
- G04 - PROGRAM DWELL
- G90 - ABSOLUTE POSITIONING
- G91 - INCREMENTAL POSITIONING
- M00 - PROGRAM STOP
- M01 - OPTIONAL PROGRAM STOP
- M10 - SWING POSITIONING MODE
- M11 - SWING TRACKING MODE
- M12 - JAWS CLOSE COMMAND
- M13 - JAWS OPEN COMMAND
- M14 - BULLDOZER TRAVERSE RETRACT
- M15 - BULLDOZER TRAVERSE ADVANCE
- M30 - END PROGRAM COMMAND
- M99 - SUB-SEQUENCE END
- ( ) - ENCLOSED BRACKETS HOLD COMMENTS)





# MICROTROL ENGINEERING

## CNC PROGRAM AXIS DEFINITIONS:

- LC - LEFT CARRIAGE POSITION COMMAND
- RC - RIGHT CARRIAGE POSITION COMMAND
- LA - LEFT CARRIAGE ANGULAR COMMAND
- RA - RIGHT CARRIAGE ANGULAR COMMAND
- LT - LEFT TENSION POSITION COMMAND
- RT - RIGHT TENSION POSITION COMMAND
- DT - DIE TABLE POSITION COMMAND
- DA - DIE TABLE ANGULAR COMMAND
- CF - CARRIAGE FEEDRATE COMMAND
- TF - TENSION FEEDRATE COMMAND
- DF - DIE TABLE FEEDRATE COMMAND
- LJ - LEFT JAW COMMAND
- RJ - RIGHT JAW COMMAND
- DN - DIE TABLE FORCE COMMAND
- TN - TENSION FORCE COMMAND

## EXAMPLE STRETCH CNC PROGRAM:

```
(144U3765-3-NCT LOWER SKIN PANEL)
(TOOL NUMBER WOSN23413)
(12-13-2012)
O1 G90
N1 LJ=OPEN RJ=OPEN
N2 DT=0 DF=20.0
N3 LC=24.00 RC=28.00 LT=10.00 RT=10.00 TF=20.00 CF=15.00
N4 M00
(LOAD MATERIAL)
N5 LJ=CLOSE
N6 RC=24.00 CF=15.00
N7 M00
N8 RJ=CLOSE
N9 M00
O2 G91
N1 LC=.50 RC=.50 CF=5.00
N2 G90 DT=10.5 DF=5.00
O3 G91
N1 M10 (SWING TRACKING ON)
N2 LC=-.75 RC=-.75 DT=3.5 CF=7.50 DF=10.00
N3 M11 (SWING TRACKING OFF)
O4 G91
N1 LT=1.5 RT=1.5 TF=2.5
N2 G04 WD=1.00
O6 G91
N1 LT=-.5 RT=-.5 TF5.0
O7 G90
N1 RJ=OPEN LJ=OPEN
N2 LT=20.00 RT=20.0 LS=0 RS=0 TF=20.00
N3 LC=28.00 RC=28.00 CF=20.00
N4 M30
```

PROGRAM COMMENT  
PROGRAM COMMENT  
PROGRAM COMMENT  
O BLOCK 1 SET LOAD CYCLE  
OPEN BOTH JAWS  
MOVE DIE TABLE TO 0 POSITION  
PROGRAM STOP  
PROGRAM COMMENT  
CLOSE LEFT JAW  
RIGHT CARRIAGE TO 24 AT 15IPM  
PROGRAM STOP  
CLOSE RIGHT JAW  
PROGRAM STOP  
SNUG MODE, INCREMENTAL POS  
CARRIAGES OUT .5" A5 5IPM  
DIE TO 10.5" AT 5IPM ABSOLUTE  
PRE MODE INCREMENTAL MODE  
SWING IN TRACK MODE  
SWING TRACKING OFF  
STRETCH MODE, INCREMENTAL MODE  
TENSIONS 1.5" AT 2.5IPM  
WAIT 1 SECOND  
RELAX MODE, INCREMENTAL MODE  
TENSION IN .5 AT 5IPM  
UNLOAD MODE, ABSOLUTE MODE  
OPEN BOTH JAWS  
TENSIONS TO 20" AT 20IPM  
CARRIAGES TO 28" AT 20IPM  
END OF PROGRAM

SPECIFICATION ME11250-SB052715

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EXAMPLE CONTROL SCREENS:  
MAIN STATUS SCREEN

**PART INFORMATION**

PART NUMBER: 3311-4B  
 TOOL NUMBER:   
 PART WIDTH:   
 PART LENGTH:   
 MATERIAL:   
 ELONGATION:

**SEQUENCE**

SEQUENCE: STOP  
 STEP: 0/0  
 PART PROGRAM CYCLES:   
 CYCLES TO RUN IN AUTOMATIC MODE:   
 DRUG, FOC, FORM, POST, RELAX

**MACHINE POSITION**

	LEFT		RIGHT	
	COMMAND	POSITION	POSITION	COMMAND
CARRIAGE AXIS	27.72	27.73	27.68	27.68
CARRIAGE ANGLE	-0.01	-0.02	-0.02	0.0
TENSION POSITION	11.63	11.63	11.63	11.63
TENSION FORCE		15.1	0.0	
SWING POSITION	6.7	6.6	5.9	5.9
ROTATION POSITION	0.0	0.0	-0.2	-0.2
OSCILLATE POSITION	0.0	0.0	0.0	0.0

**RIGHT HEAD STATUS**

JAW CLOSED, SWING LOCKED, FRONT WRT'S JAW ON, TENSION FULL (RETRACT), TENSION BACK ON, HEAD IN POSITION

**LEFT HEAD STATUS**

JAW CLOSED, SWING LOCKED, LEFT WRT'S JAW ON, TENSION FULL (RETRACT), TENSION BACK ON, HEAD IN POSITION

**DIE TABLE**

DIE TABLE POSITION: 27.88, 27.89  
 DIE TABLE ANGLE: -0.09, -0.06  
 DIE TABLE FORCE: 0.0

**BULLDOZER**

VERTICLE POSITION: 0.0, 22  
 PRESSURE FORCE PSI TONS: 1, 0

**Microtrol Engineering Inc**  
 2751 Plaza Del Amo, Unit 304  
 Torrance, CA 90503  
 (310) 480-7093

Auto Mode Select, DONT PRESS ME, Manual Mode Select

Buttons: Edit, Alarms, Diagnostics, Parameters, Calibration



# MICROTROL ENGINEERING

EDIT SCREEN

STEP	LEFT CARriage		TENSION		SWING		ROTATE		OSCILL		DIE TABLE		RIGHT CARriage		TENSION		SWING		ROTATE		OSCILL		F/M Rate	Fwd/Rev	Force
	POSITION	ANGLE	POSITION	ANGLE	ANGLE	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	POSITION	ANGLE	ANGLE	ANGLE	POSITION	ANGLE	POSITION	ANGLE			
1	28.00										34.00		28.00										20.0	1.0	
2			5.00														5.00								

	CURRENT POSITIONS	
	LEFT	RIGHT
CAR POS	27.50	27.50
CAR ANG	0.00	0.00
TEN POS	6.00	6.00
SWING	0.0	0.0
OSCIL	0.0	0.0
ROTATE	0.0	0.0
DIE TABL	38.00	0.00
SWELL	0.0	

**PROGRAM INFORMATION**

Part Number:	
Tool Number:	
Material Type:	
Material Width: Inches	
Material Length: Inches	
Elongation: %	

**DEFAULTS**

SWELL:	7.0
FORCE TONS:	500
DWELL:	1.0

**CONTROL BUTTONS:** RECORD STEP, TEACH MODE ON, CLEAR PROGRAM, SAVE EDITS, DELETE STEP, RESET STEP, LOAD PROG, NEW PROG, SAVE PROG

**NAVIGATION BUTTONS:** LOAD CYCLE, SNUG CYCLE, FINE FORM CYCLE, FORM CYCLE, POST CYCLE, RELAX CYCLE, UNLOAD CYCLE, Main Screen



# MICROTROL ENGINEERING

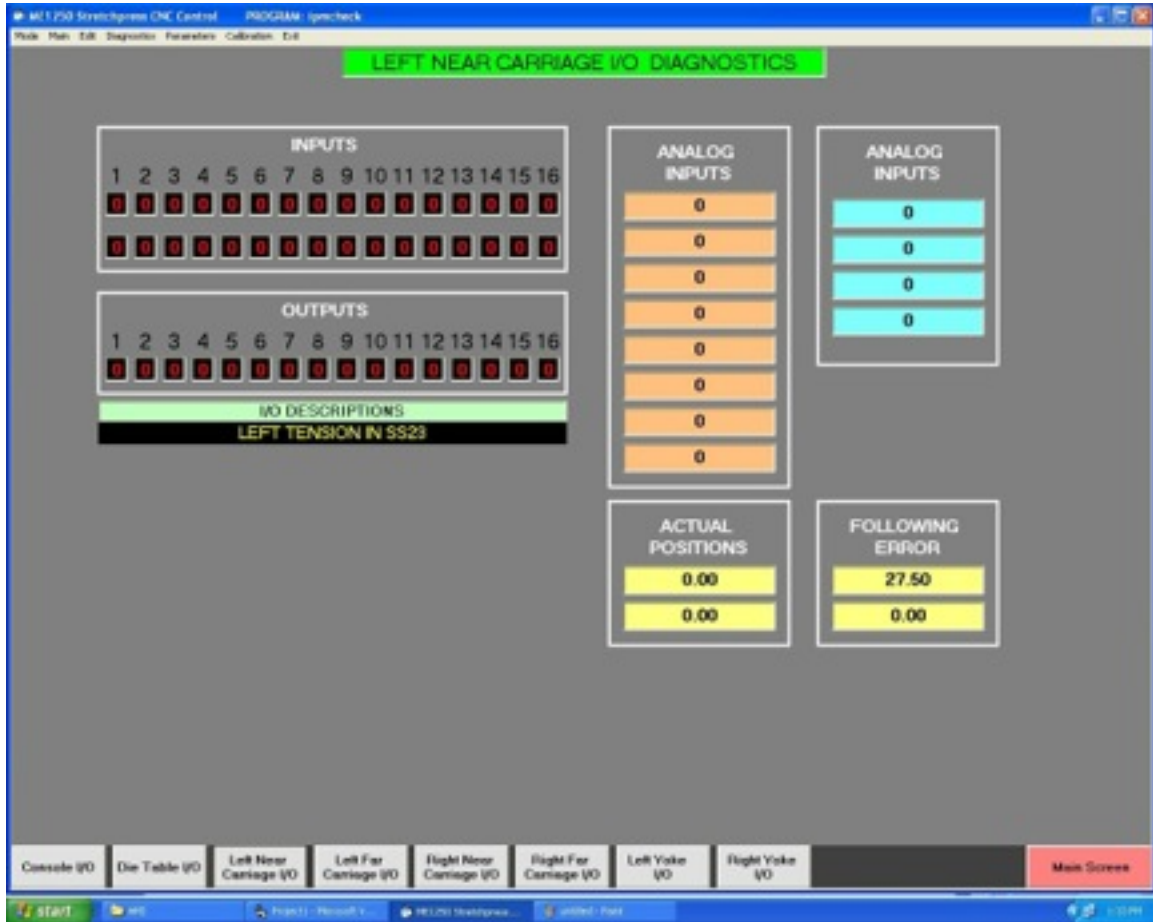
## ALARM SCREEN

DATE	TIME	ALARM
3/14/2016	1:23:58 PM	Hydraulic Filter Clogged Warning
3/14/2016	1:23:58 PM	Die Table Far Filter Clogged Warning
3/14/2016	1:23:58 PM	Die Table Near Filter Clogged Warning
3/14/2016	1:23:58 PM	Left Carriage Far Filter Clogged Warning
3/14/2016	1:23:58 PM	Left Carriage Near Filter Clogged Warning
3/14/2016	1:23:58 PM	Right Carriage Far Filter Clogged Warning
3/14/2016	1:23:58 PM	Right Carriage Near Filter Clogged Warning
3/14/2016	1:23:58 PM	Left Tension Filter Clogged Warning
3/14/2016	1:23:58 PM	Right Tension Filter Clogged Warning
3/14/2016	1:23:58 PM	CB1 Control 30 Power Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB4 Electrical Switch Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB12 Node 1 Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB22 Node 2 Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB32 Node 3 Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB42 Node 4 Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB52 Node 5 Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB62 Node 6 Circuit Breaker Tripped
3/14/2016	1:23:58 PM	CB72 Node 7 Circuit Breaker Tripped
3/14/2016	1:23:58 PM	Hydraulic Oil Level Low
3/14/2016	1:23:58 PM	Hydraulic Overhaul Fan Alarm
3/14/2016	1:23:58 PM	Node 1 Not Ready Alarm
3/14/2016	1:23:58 PM	Node 2 Not Ready Alarm
3/14/2016	1:23:58 PM	Node 3 Not Ready Alarm
3/14/2016	1:23:58 PM	Node 4 Not Ready Alarm
3/14/2016	1:23:58 PM	Node 7 Not Ready Alarm



# MICROTROL ENGINEERING

## DIAGNOSTIC SCREEN







# MICROTROL ENGINEERING

## CALIBRATION SCREEN

MEI1250 ServoPress CNC Control PROGRAM: B1370311.488  
File Help Edit Diagnostic Parameters Calibration Exit

**AXIS CALIBRATION**

LOAD CURRENT PARAMETERS
SAVE AXIS PARAMETERS

		ACTUAL ANALOG POS	SET MINIMUM IN VALUE	SET MAXIMUM IN VALUE		FEEDBACK OUT MIN	FEEDBACK OUT MAX
START DIE TABLE CALIBRATION	DIE TABLE FAR AXIS	11454	2302	30149	SELECT	0	85
	DIE TABLE NEAR AXIS	11242	2105	30009	SELECT	0	85
START LEFT CARTRIDGE CALIB	LEFT CARTRIDGE FAR AXIS	15575	6481	32523	SELECT	0	79.5
	LEFT CARTRIDGE NEAR AXIS	15550	6496	32477	SELECT	0	79.5
START RIGHT CARTRIDGE CALIB	RIGHT CARTRIDGE FAR AXIS	15538	6452	32534	SELECT	0	79.5
	RIGHT CARTRIDGE NEAR AXIS	15592	6544	32555	SELECT	0	79.5
START LEFT TENSION CALIB	LEFT TENSION CYL AXIS	29686	4102	29620	SELECT	0	11.625
START RIGHT TENSION CALIB	RIGHT TENSION CYL AXIS	29021	3551	28999	SELECT	0	11.63
START LEFT SWING CALIB	LEFT SWING AXIS	6778	2723	57690	SELECT	0	90
START LEFT ROTATE CALIB	LEFT ROTATE AXIS	21987	5381	38521	SELECT	10	-10
START LEFT OSCILLATE CALIB	LEFT OSCILLATE AXIS	24926	17161	32655	SELECT	-10	10
START RIGHT SWING CALIB	RIGHT SWING AXIS	5442	1869	56420	SELECT	0	90
START RIGHT ROTATE CALIB	RIGHT ROTATE AXIS	22330	5810	39491	SELECT	-10	10
START RIGHT OSCILLATE CALIB	RIGHT OSCILLATE AXIS	27060	21313	32819	SELECT	-10	10
START BULLDOZER CALIB	BULL DOZER AXIS	15689	15806	65447	SELECT	0	38

Main Screen

START | Micro ServoPress | ServoPress (v1.3.2) | ServoPress - Home | 11:01 AM



# MICROTROL ENGINEERING

## PARAMETER SCREENS





# MICROTROL ENGINEERING

## PLC SCREENS

