

How to use in manual mode

1. Push the button "Control ON"



2. Press "manual" for manual mode



3. Click on one of the light green bars to enter an adjustment order



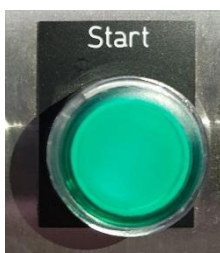
Enter the first bolt and the last bolt of the adjustment

Select "open" or "close"

Enter the adjustment value

Select "one", "part" or "all" bolts

4. Press one of the buttons "Start"



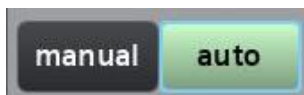
5. When the lip gap is ok go ahead with "How to use in auto mode"

How to use in auto mode

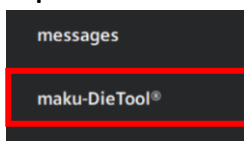
1. Push the button "Control ON"



2. Press "auto" for auto mode



3. Open menu and go back to "maku-DieTool®"



4. Go to process data, check if it's still in flattening mode

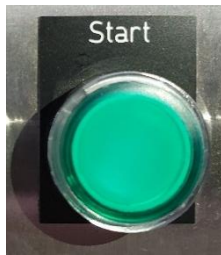
process data		-	+	Total
die bolt no. thickest location:	0			0 µm
die bolt no. thinnest location:	0			0 µm
nominal value product thickness				0 µm
no. of die bolt invalid				0
no. of die bolt in tolerance	0	0	0	0
no. of die bolt in finest	0	0	0	0
no. of die bolt in fine	0	0	0	0
no. of die bolt in coarse	0	0	0	0

→ if 0 µm is entered in "nominal value product thickness" it's running in flattening mode

process data			
die bolt no. thickest location:	83		455 µm
die bolt no. thinnest location:	13		453 µm
nominal value product thickness			0 µm
flattening mode			454 µm
	-	+	Total
no. of die bolt invalid			0
no. of die bolt in tolerance	40	33	73
no. of die bolt in finest	2	0	2
no. of die bolt in fine	0	0	0
no. of die bolt in coarse	0	0	0

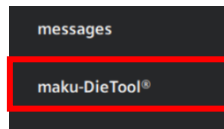
→ here you can see the target value (average, calculated from measured values)

5. Press one of the buttons “Start”



How to save an actual profile

1. Go to menu → “maku-DieTool®”



2. Press “copy profile to target profile”



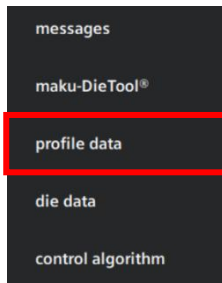
- enter the login (user: “User” / password: “useruser”)
- choose a blank profile recipe → enter a profile name and confirm

How to create a new target profile

1. Press one of the buttons "Stop"



2. Open menu and go to "profile data"



3. Go to "target value table"



4. Enter the desired value for bolt no. 1

→ you can enter a different value for every bolt

OR

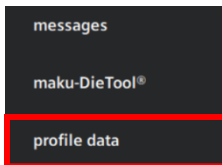
→ press "preset" to overwrite the same value for each bolt

How to load a saved profile

1. Press one of the “Stop” buttons



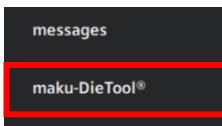
2. Go to menu → “profile data”



→ select the required profile



3. Go to menu → “maku-DieTool®”



4. Press “manual” for manual mode

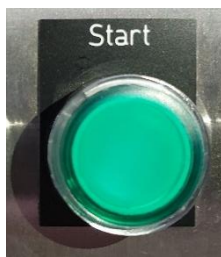


5. Press “preset profile START”



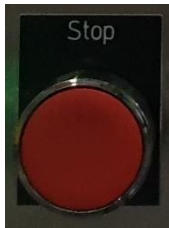
→ enter the login (user: “User” / password: “useruser”)

6. Press one of the “Start” buttons

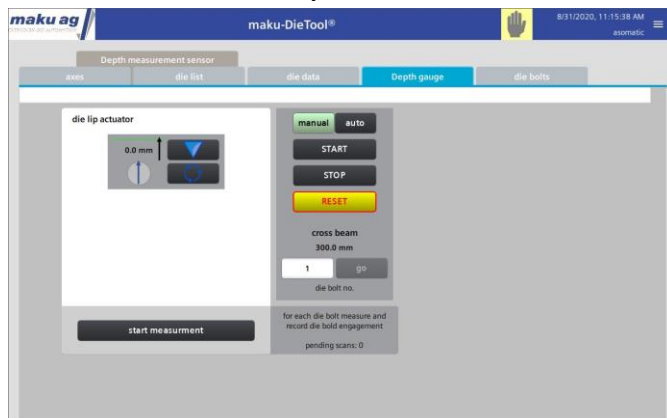


Measure the bolt height

1. Press one of the “Stop” buttons, choose manual mode and press one of the “Start” buttons



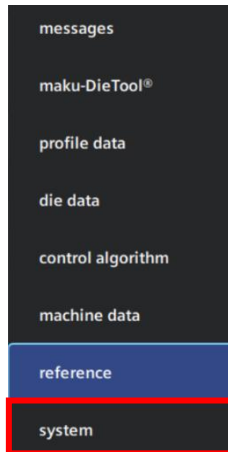
2. Go to the menu → “reference”
3. Go to the tab “depth measurement sensor”



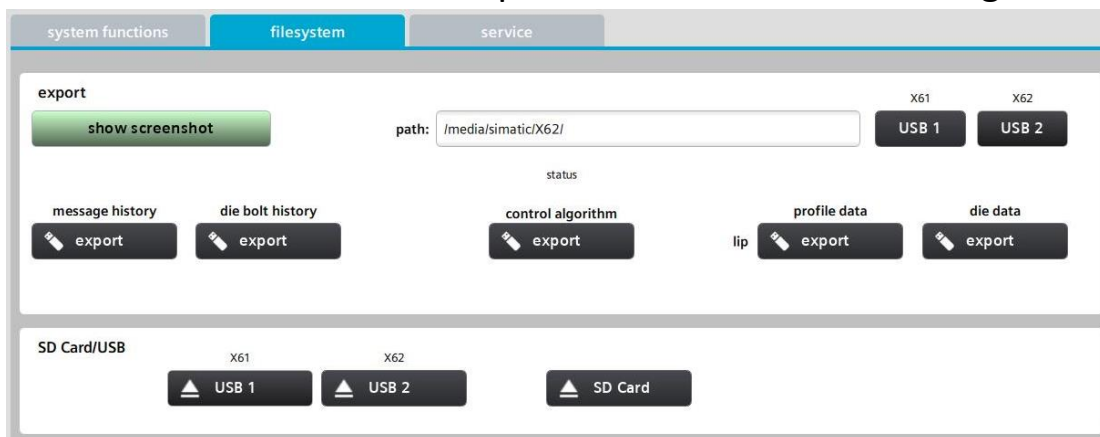
4. Press the button “start measurement”
5. enter the login (user: “User” / password: “useruser”)
→ the actuator is going to tap on every bolt head with an offset of about 5mm to save the new bolt height

How to export data to USB flash drive

1. Put the USB flash drive into port X61
2. Go to menu → system → filesystem



3. Click on the “USB 1” (port X61)
4. Press one of the buttons “export” and wait until it turns green



5. Go ahead with the other “export” buttons

Logins

For operators:

User: User
Password: useruser

For responsible:

User: A
Password: makumaku

Error messages and troubleshooting

524 emergency stop (push button control on)

Release the emergency stop button and press "Control ON"

562 cross beam in soft end position negative

563 cross beam in soft end position positive

Move the carriage 15 cm/6 inch away from the side plate of the tool and press "Control ON"

86 failure SERVO cross beam out of working area

Move the carriage 15 cm/6 inch away from the side plate of the tool, click the reset button on the screen and press "Control ON"