



MOUNTING INSTRUCTIONS FOR DIGIREAD SEP 80208 CONTROL

Customer: _____
 Machine: _____
 Date: _____ Remarks: _____



To view or change the machine parameters press the P key and the LED above the P key will light up. The alpha display will read "ENTER Prog.No". Enter the code number 805. All LED's will light up. The alpha display will change to "EDIT PARAM.". The axis display will read P.01 for parameter 1. Press E to accept the value. C to clear the old value then enter a new value and store the value with the E key. After all values have been entered the LED above the P key goes off and all displays are cleared. Software version SEP2_721

SEP2_718 25-11-2001

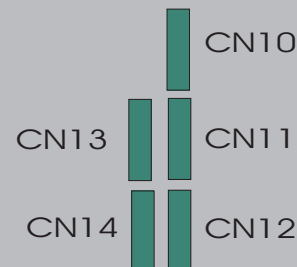
P.01	Proportional factor	X axis	_____	_____
P.02	Differential factor	X axis	_____	_____
P.03	Integral factor	X axis	_____	_____
P.04	Integral limit	X axis	_____	_____
P.05	Scaling factor * 1000	X axis	_____	_____
P.06	Reference offset	X axis	_____	_____
P.07	Position Error limit	X axis	_____	_____
P.08	Acceleration		_____	_____
P.09	Max. Velocity		_____	_____
P.10	Reference speed fast		_____	_____
P.11	Reference evaluation off		_____	_____
P.12	Lag 1=on 0=off		_____	_____
P.13	Reference speed slow		_____	_____
P.14	Software limit X+		_____	_____
P.15	Software limit X-		_____	_____
P.16	Z axis mm 1=on 0=off		_____	_____
P.17	Time delay in msec		_____	_____
P.18	Velocity of Z axis in % of X axis		_____	_____
P.19	Position window X		_____	_____
P.20	Proportional factor	Z axis	_____	_____
P.21	Differential factor	Z axis	_____	_____
P.22	Integral factor	Z axis	_____	_____
P.23	Integral limit	Z axis	_____	_____
P.24	Scaling factor*1000	Z axis	_____	_____
P.25	Reference offset	Z axis	_____	_____
P.26	Position Error	Z axis	_____	_____
P.27	Software limit Z+ neg value		_____	_____
P.28	Software limit Z- pos value		_____	_____
P.29	Positioning window Z		_____	_____
P.30	Password > 1000		_____	_____
P.31	Ref. Window X pos value		_____	_____
P.32	Ref. Window Z pos value		_____	_____
P.33	Bending factor obtuse angles %		_____	_____
P.34	Bending factor acute angles %		_____	_____
P.35	Tool open limit 0=nc 1=no		_____	_____
P.36	Retract limit 0=disabled 1=enabled		_____	_____
P.37	Flipfinger on=1 Flipfinger off=0		_____	_____
P.38	Timeout for no Airpressure in msec		_____	_____
P.39	machine number		_____	_____
P.40	set to zero		_____	_____
P.41	set to zero		_____	_____

9 pin sub D RS 422 transducer input.

1 >-----	channel A
2 >-----	channel Ā
3 >-----	+5 V DC
4 >-----	0 V DC
5 >-----	channel B
6 >-----	channel B̄
7 >-----	channel R
8 >-----	channel R̄
9 >-----	screen

* Switch required only for retract function.

P.11 Bit 0 X ref off
 P.11 Bit 1 Y ref off
 P.11 Bit 2 Z ref off
 P.11 Bit 3
 P.11 Bit 4
 P.11 Bit 5 Z axis off
 P.11 Bit 6 Ser.Test on
 P.11 Bit 7



CN 10

1 >---	+ 10V to drive Z
2 >---	- 10V to drive Z
3 >---	+5V internal
4 >---	0V return Z
5 >---	+ 10V to drive X
6 >---	- 10V to drive X
7 >---	0V return X
8 >---	+5V internal
9 >---	n/c

CN 11 output

1 >---	In position X
2 >---	+24VDC in
3 >---	+24V enable
4 >---	+24VDC in
5 >---	Auto
6 >---	+24VDC in
7 >---	+24VDC in
8 >---	
9 >---	Enable drive X

CN 12 input

1 >---	Auto
2 >---	Start
3 >---	Stop
4 >---	
5 >---	
6 >---	Tool open
7 >---	Retract limit *
8 >---	
9 >---	0V DC

CN 13 output

1 >---	In position Z
2 >---	+24VDC in
3 >---	Enable Drive Z
4 >---	+ 24VDC in
5 >---	
6 >---	
7 >---	
8 >---	
9 >---	

CN 14 input

1 >---	X+ jog
2 >---	X- jog
3 >---	24V on
4 >---	
5 >---	Ref. X
6 >---	Z+ jog
7 >---	Z- jog
8 >---	Ref. Z
9 >---	0V DC