

Cycle Count Output for eDART™

Description

This is an optional software tool for the eDART that turns on an output after a selected number of good cycles have been released by the “Diverter Controls”. It can be used in two ways:

- To turn on a light or sound when a machine requires attention by shop floor personnel. For example, if automation is not moving completed boxes of finished parts an operator can be alerted to do so.
- To move or index a box of completed parts automatically and reset to start the same number again. Since only good parts are counted the box should contain the actual number of good parts selected since those discarded are not counted.

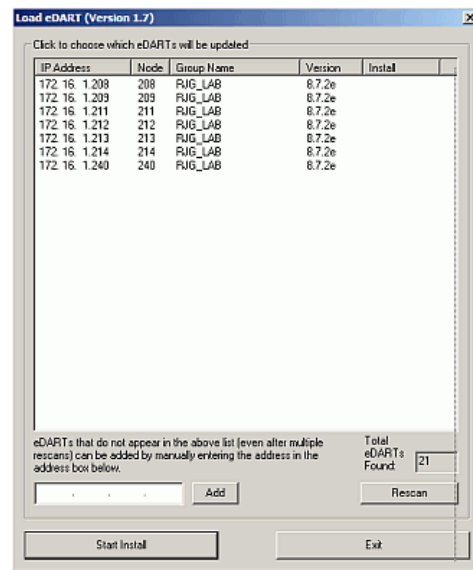
Installation

Installation uses the normal procedures for installing eDART software.

1. Make a network connection to the eDART, either from a portable computer and crossover cable or through the plant network and eDART Data Manager (EDM)
2. Open the file containing the installer files using a .zip format extractor (such as Winzip) and save the files into a temporary place.
3. Open the folder where the temporary files are and run edart_installer.exe. This will bring up a window similar to the one at the right.
4. Check the software version for the eDART(s) on which you will be installing. They should be at least at release 8.9.
5. Select by clicking on the machine to which you wish to install. If you have a license to install on more than one machine use the CTL key while clicking to select multiple machines. Use the shift key while clicking to select a whole block.

Note: If the network prevents the installer from finding the eDARTs you can enter their IP addresses in the field next to “Add”, click “Add” for each and then select them as above. EDM users can place the files in a folder under the shared “\\edm\RJG Installs” and then install the software from the EDM console.

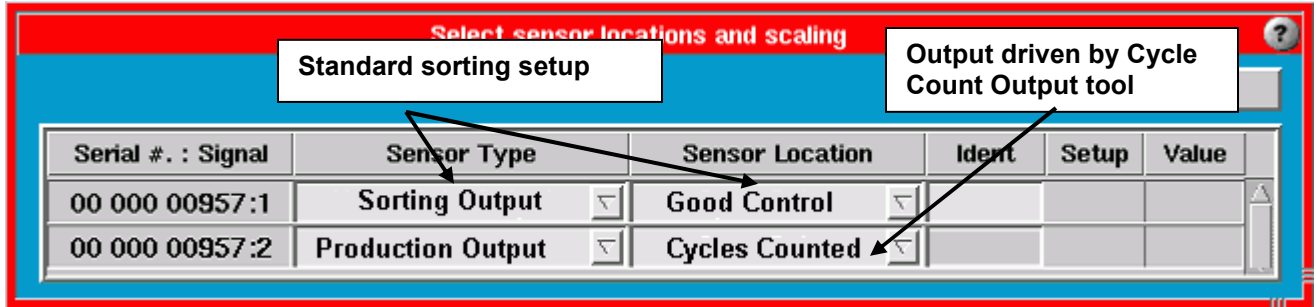
6. Click “Start Install” to start the install.
7. The Alternating Gate install is automatic so you do not have to re-start the eDART or the job on a running eDART. You may move immediately to the “Setup” step below once the installer reads “Completed” next to each eDART.



Setup

Setting Output Names

The “Cycle Count Output” tool only counts parts designated as “Good” in the Diverter Controls. Thus it only works if you have physical part sorting working using a “*Sorting Output*” in the Sensor Locations. Open Sensor Locations, select an unused OR2-D output and name it “*Production Output / Cycles Counted*”.



Starting the Cycle Count Output Tool

After accepting the Sensor Locations and all the software is started you “attach” the Cycle Count Output to the mold using the usual method of the Architect. It is found on the Architects “Production” tab.

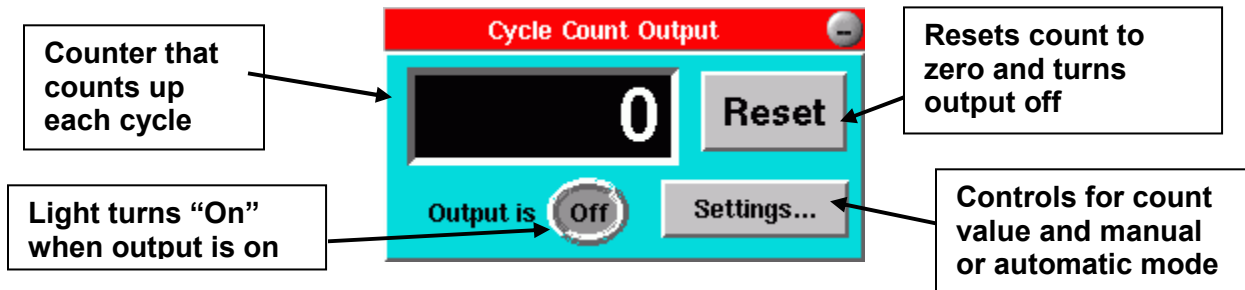
Here are two possible methods:

- To make the Cycle Count Output run only on the current mold simply drag it to the mold workspace.
- If it always runs on this particular machine press the “Machine” icon (large button on left) and drag it into that workspace.

Generally you would not have it running on all molds or machines because the output and associated part handling equipment would not exist for all of them.

Using the Software

Once started the Cycle Count Output tool appears like this (with explanations):

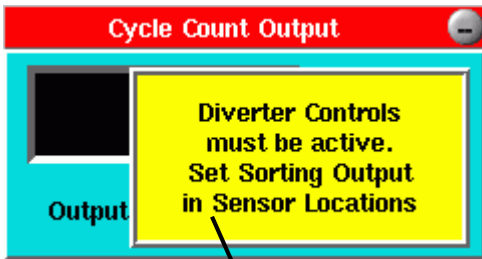


You may wish to position it in a certain way and make a new view (“Main Menu”, “Views”).

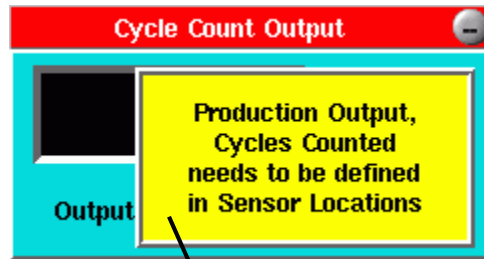
The cycle counter counts up until it reaches the value set up in the “Settings...” controls and then turns the Production Output / Cycles Counted output on. When someone presses the reset button it turns the output off and saves a note in the summary data.

Yellow Warning Boxes

Two possible scenarios will show the yellow warning box on startup.



Open Sensor Locations and set up a sorting output.



Open Sensor Locations and define the Cycles Counted output.

Note that after fixing the problem the warnings only disappear at the end of the next cycle with a "Good" output on.

Security

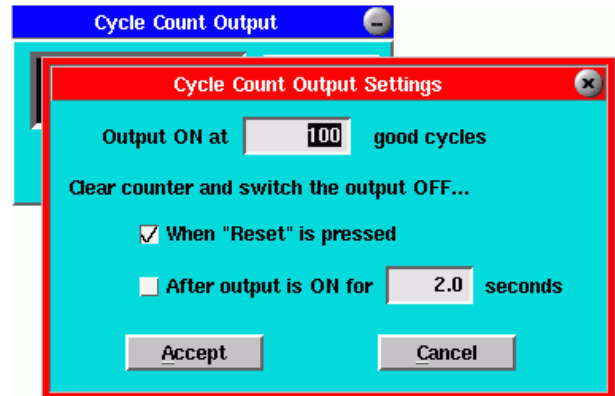
When first installed the Cycle Count Output has security enabled for the "Settings" controls but none for the "Reset" button. The Reset button cannot be secured. If you wish to un-secure the settings you can log in and open Security (main menu). In the "Secured functions" turn off security on the Cycle Count Output.

Setting for Manual Part Handling

In manual part handling the Cycle Count Output counts up to the selected value and turns the output on. The output stays on until someone presses the Reset button. It then clears both the count and the output.

While good cycles continue to be made after reaching the count and output the Cycle Count Output tool continues to count up.

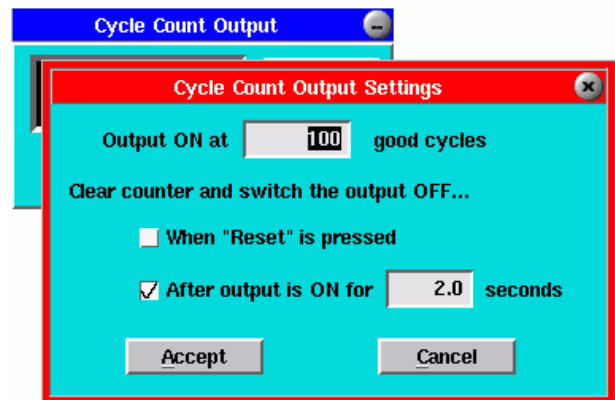
To set up for manual part handling open the "Settings" by clicking the "Settings..." button and select..."When Reset is pressed" shown here. You can also enter the count value on this window.



Setting for Automatic Part Handling

In automatic part handling the Cycle Count Output counts up to the selected value and turns the output on. At the same time the count is reset to zero. The output stays for a selected time period and then turns itself off.

To set up for automatic part handling open the "Settings" by clicking the "Settings..." button and select..."After output is ON" shown here. You can then tell the software how many seconds you want the output on before it goes off automatically. Again, you can also choose the count value on this page.



If you want to prevent anyone from resetting the counts early you can turn off the “When Reset is pressed” switch as is shown above. This hides the Reset button on the main screen.

Active-X Control Third-Party Network Data

If you are using the eDART’s third party “back door” access you can find a new data value named “*Status / Cycle Count Output Value*”. This is the value on the counter on the display at any time. It could be used for a supervisory warning to send an operator to a press before the counter reaches its limit.

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