08. SETTINGS FOR THE PART PROGRAM

As indicated in Section 3, every program in SPRING has default settings for the current program and is dependent on the tooling of the machine. These settings are accessed by pressing the F2 key.

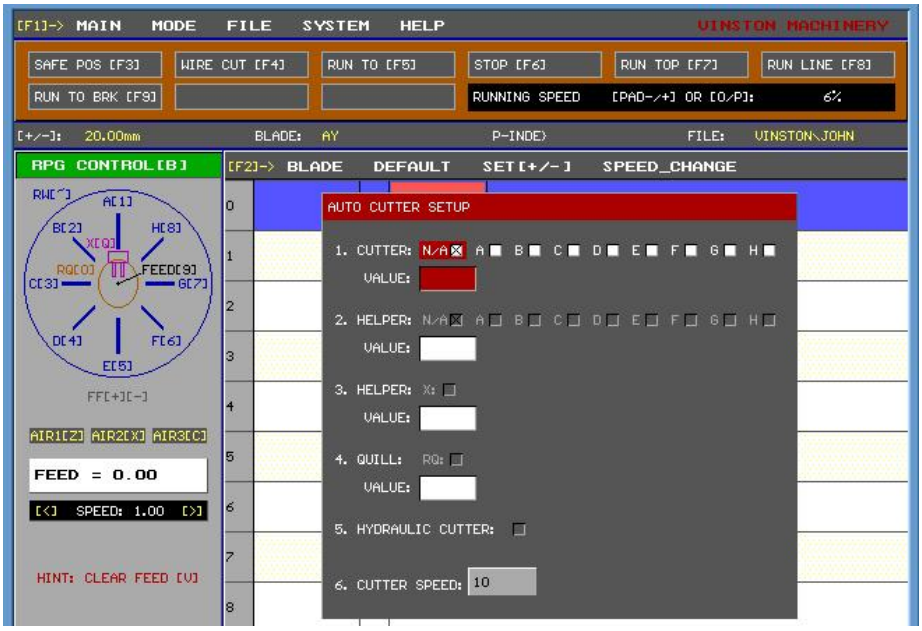
08.1 ENABLE/DISABLE AXES

To access the menu, press F2 on your keyboard and and press ENTER as the ENABLE/DISABLE AXISES option is the default selection. To exit, press the ESC key.

Use the SPACE BAR to enable/disable the highlighted axis. Press the ENTER key to exit and confirm the current settings.

08.2 AUTOMATIC CUTTER

To access the menu, press F2 on your keyboard and navigate with the ▼ arrow key. Press the ENTER key to confirm your selection. To exit, press the ESC key.



Set the following values:

1) Select the axis with the mounted blade designated for the wire cutter.
2) Designate any additional axes to help with the wire cutting process.
3) Designate the X-Y Blade to help with the wire cutting process.
4) Specify the position of the Quill when the cutter moves in on the wire.
6) The cutting speed.

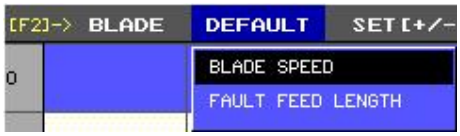
Press ENTER to confirm the settings and exit. After setting the values for the auto cutter setup, perform a system reset.

The wire cutter function is executed by pressing the F4 key on your keyboard. The indicator at the top left hand area will change color (green background) and a confirmation window appears.

After confirming the command, the designated wire cutter blade will move to its zero (reset) position. The machine will feed 20 mm of wire (this is the default feed length) and the Quill will move into the cutting position. The slide with the mounted blade will move into the cut position and return to its previous position after the cut.

08.3 SLIDE SPEED

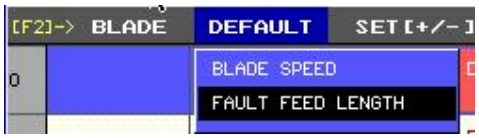
To access the menu, press F2 on your keyboard and navigate with the ►▼ arrow key. To confirm press the ENTER key or to exit press the ESC key.



Enter a value between 0 and 15 for the speed of all blades. It is highly recommended to initially start with a low value until the operator becomes more familiar with the machine.

FAULT FEED LENGTH

To access the menu, press F2 on your keyboard and navigate with the ►▼ arrow key. To confirm press the ENTER key and to exit press the ESC key. When the probe sensor cannot touch the wire at the designated time interval during normal operations, the program will do a wire feed. This will help the operator to identify possible issues within the program.



When the probe sensor triggers a fault event, the machine move the slides to their corresponding zero (reset) positions and feeds wire designated by the Fault Feed Length. At this time, a GO command can be triggered to jump to another line of code within the program. For further details, refer to the section on probe sensor settings.

08.5 SET DEFAULT WIRE FEED/DETRACT LENGTH

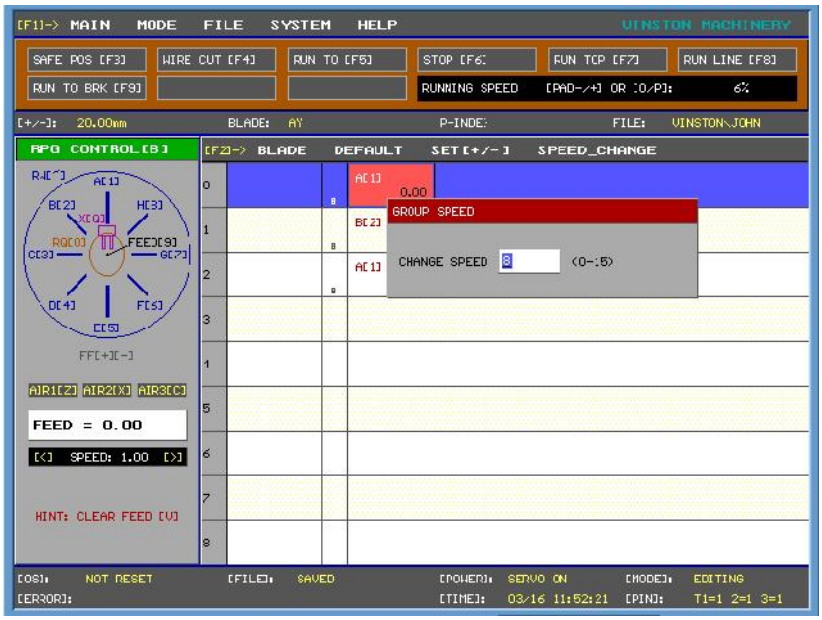
To access the menu, press F2 on your keyboard and navigate with the ►▼ arrow key. To confirm press the ENTER key or to exit press the ESC key.

Choose a value of 20/50/100/350 mm for the default feed length using the + and - keys. One common use for these keys (+/-) is during the initial wire straightening process.

08.6 SPEED DEFAULTS

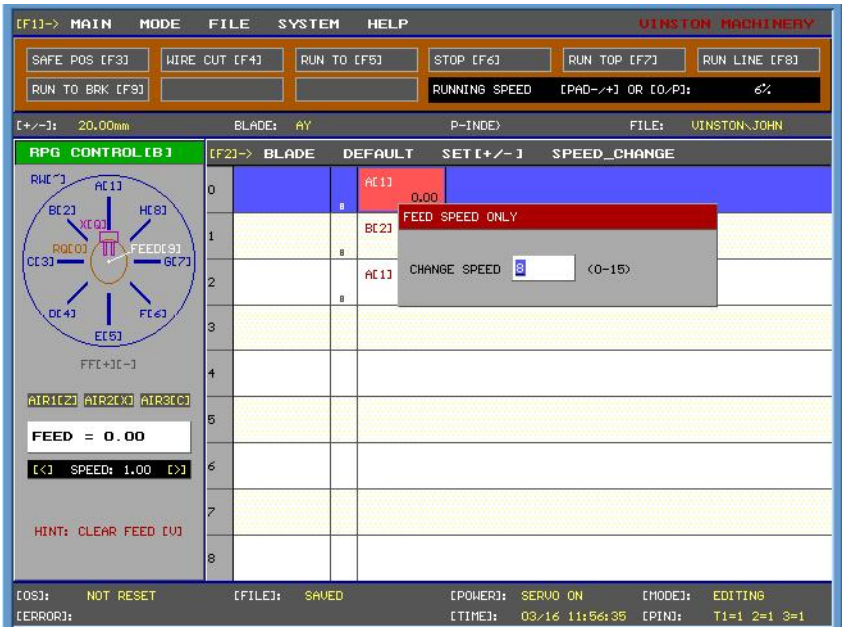
To access the menu, press F2 on your keyboard and navigate with the ►▼ arrow key. To confirm press the ENTER key or to exit press the ESC key.

08.6.1 GROUP SPEED



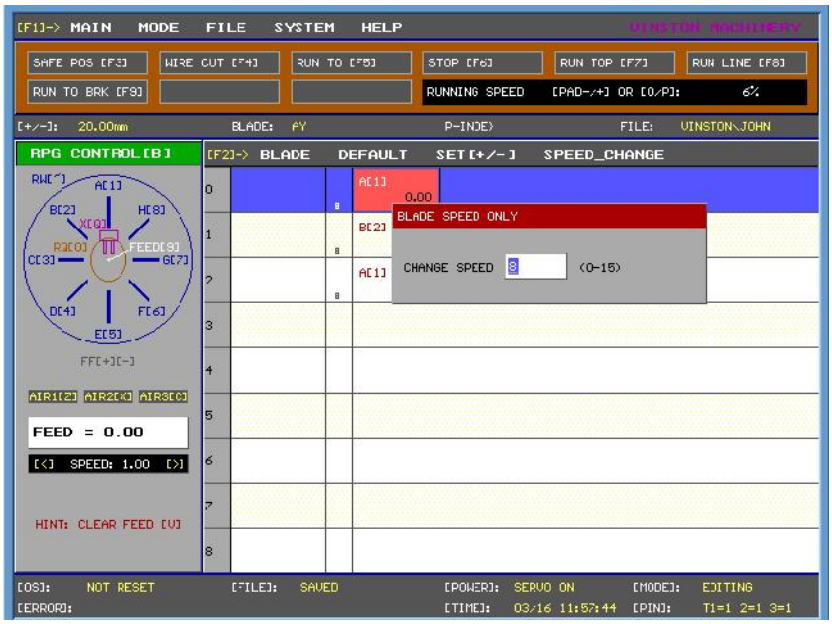
GROUP SPEED: Change the speed of all axes on the selected line of code. The operator can set a value between 0 and 15.

08.6.2 FEED SPEED ONLY



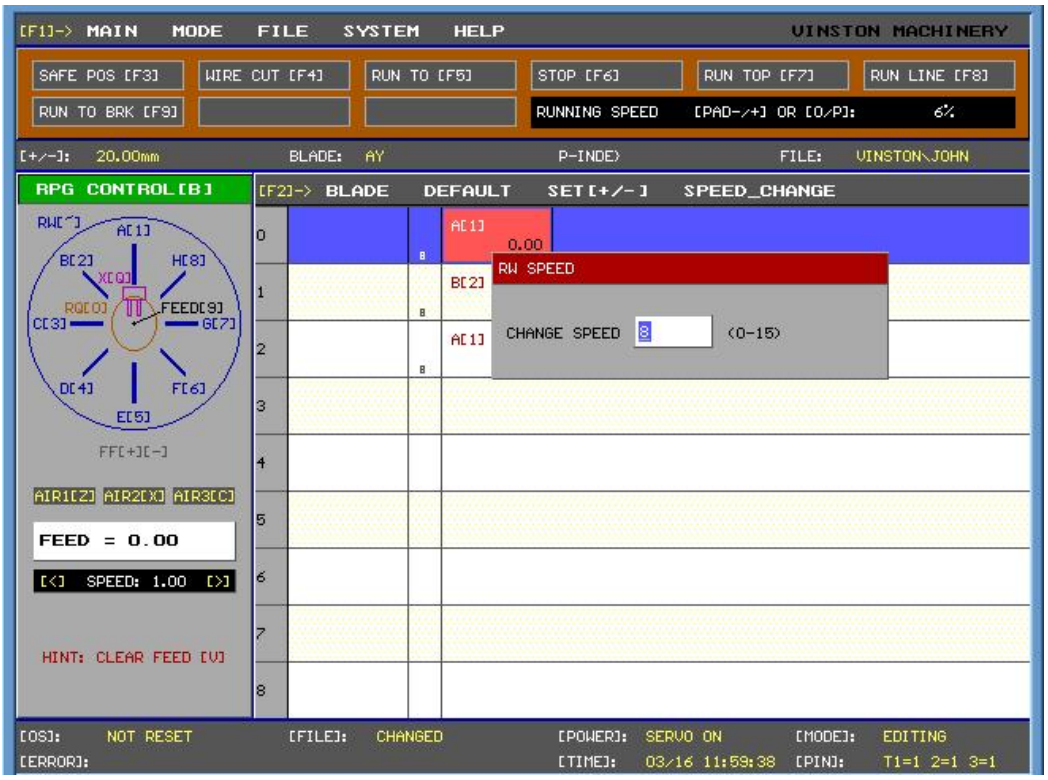
FEED SPEED ONLY: Change the wire speed on the selected line of code. The operator can set a value between 0 and 15.

08.6.3 BLADE SPEED ONLY



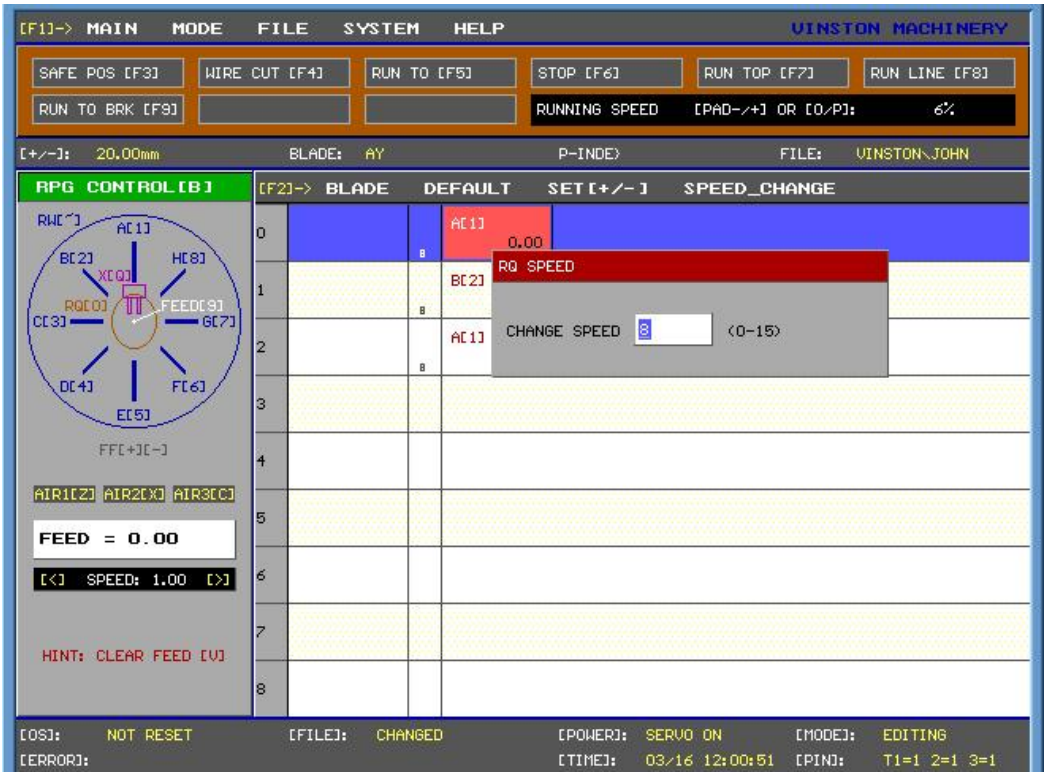
BLADE SPEED ONLY: changes the speed of the slides on the selected row. The operator can set a value between 0 and 15.

ROTARY WIRE SPEED



ROTATION WIRE SPEED: change the speed of the wire rotation on the selected row. The operator can set a value between 0 and 15.

ROTARY QUILL SPEED



ROTATION QUILL SPEED: changing the speed of the quill rotation on the selected row. The operator can set a value between 0 and 15.