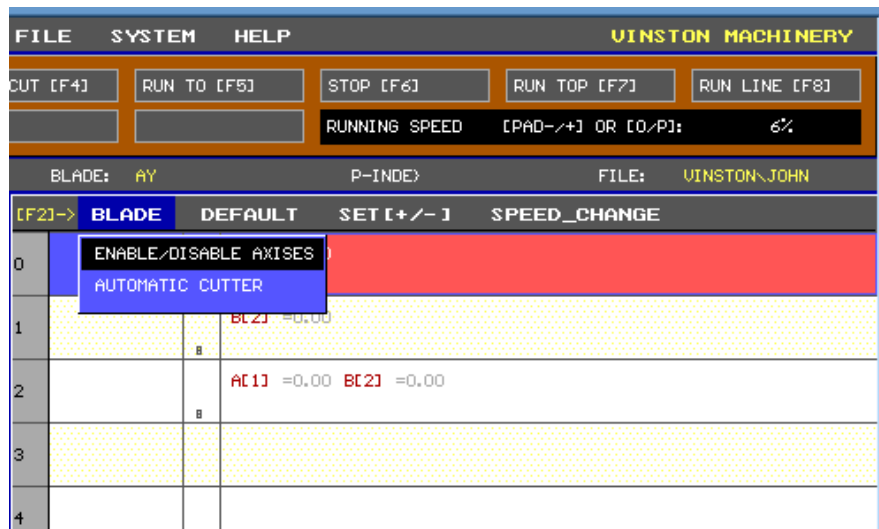


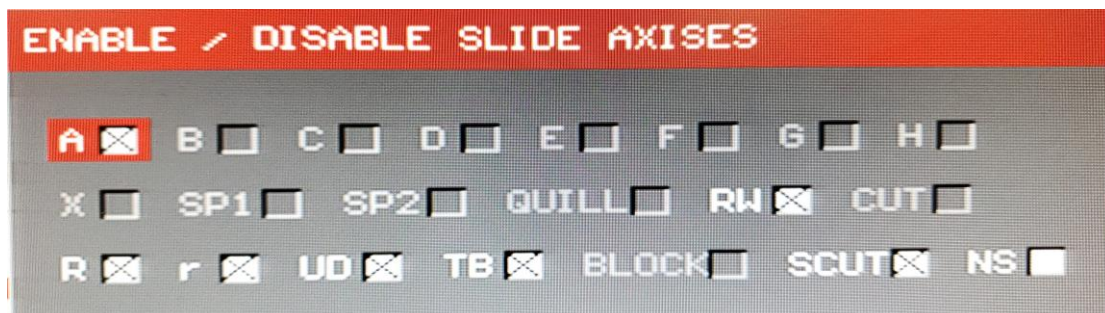
08. SETTINGS FOR THE PART PROGRAM

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

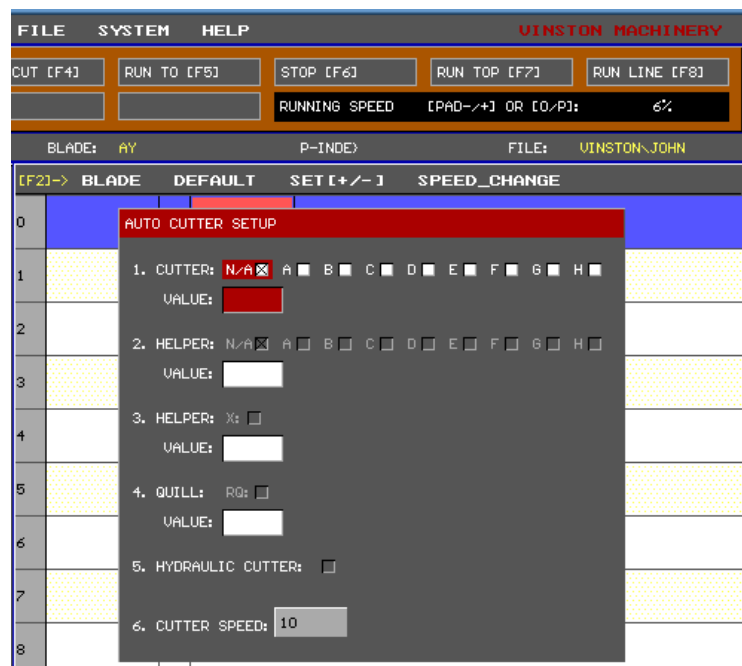
To access the menu, press F2 on your keyboard and press ENTER as the ENABLE/DISABLE AXISES option is the default selection. To exit, press the ESC key.



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) The cutting speed.

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

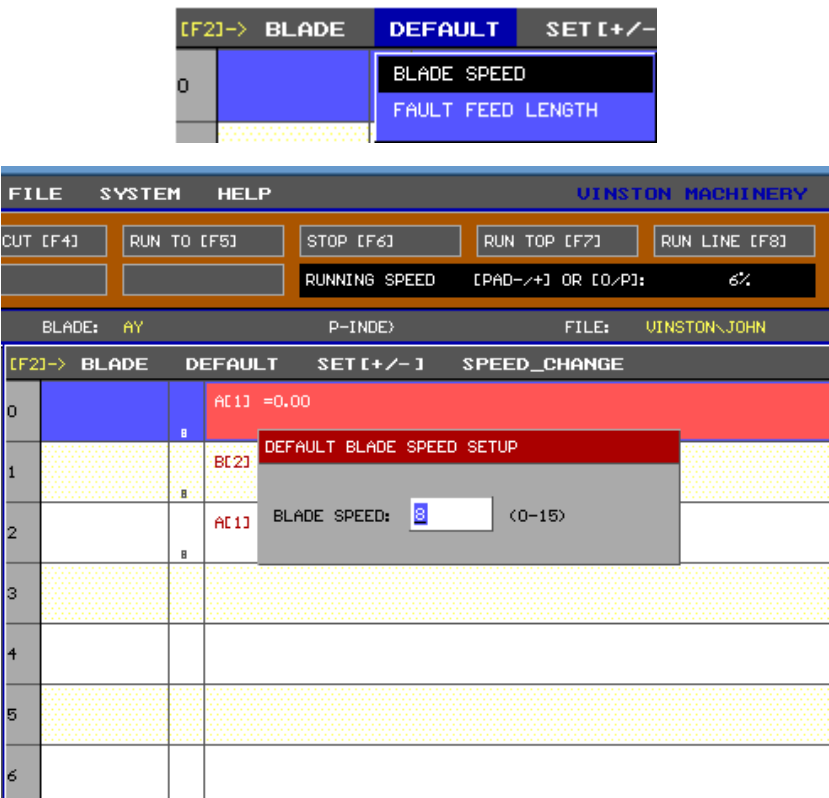
The wire cutter function is executed by pressing the F4 key on your keyboard. The indicator at the top left hand area will change color (green background) and a confirmation window appears.



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

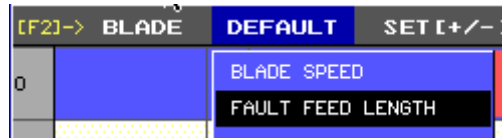
To access the menu, press F2 on your keyboard and navigate with the ►▼ arrow key.
To confirm press the ENTER key or to exit press the ESC key.



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.

08.4 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.

The screenshot displays the WINSTON MACHINERY software interface. At the top, there are menu tabs: FILE, SYSTEM, and HELP. Below these are function buttons: CUT [F4], RUN TO [F5], STOP [F6], RUN TOP [F7], and RUN LINE [F8]. A status bar shows 'RUNNING SPEED [PAD +/-] OR [O/P]: 6%'. Below this, it indicates 'BLADE: AY', 'P-INDE', and 'FILE: WINSTON\JOHN'. The main menu is titled '[F2]-> BLADE DEFAULT SET [+/-] SPEED_CHANGE'. A table lists blades 0 through 8. Blade 0 is selected, and a dropdown menu is open showing options: 20.00mm, 50.00mm, 100.00mm, and 350.00mm. The current value for blade 0 is 0.0. The bottom status bar shows '[FILE]: SAVED', '[POWER]: SERVO ON', '[MODE]: EDITING', '[TIME]: 03/16 11:52:21', and '[PIN]: T1=1 2=1 3=1'.

BLADE	DEFAULT	SET [+/-]	SPEED_CHANGE
0	AC11	0.0	
1	BC21	=0.00	
2	AC11	=0.00	
3			
4			
5			
6			
7			
8			

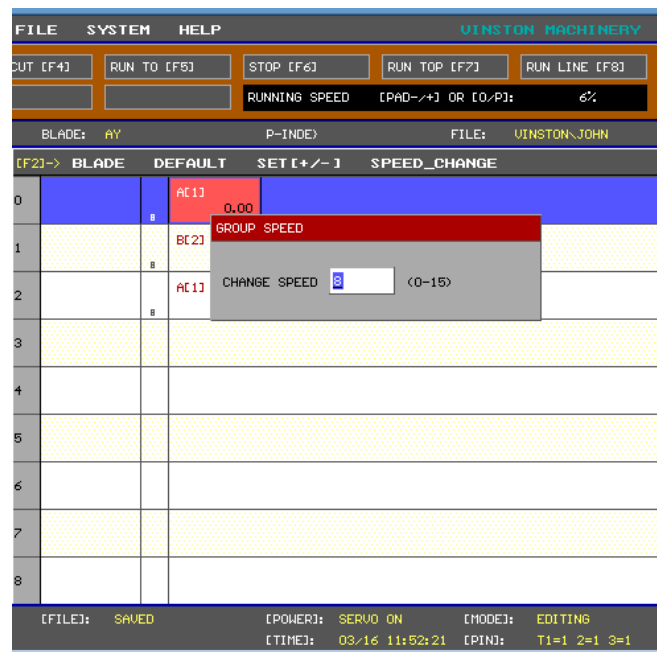
Choose a value of 20/50/100/350 mm for the default feed length using the + and - keys. One common use for these keys (+/-) is during the initial wire straightening process.

08.5 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.

FILE			SYSTEM			HELP			WINSTON MACHINERY		
CUT [F4]		RUN TO [F5]		STOP [F6]		RUN TOP [F7]		RUN LINE [F8]			
				RUNNING SPEED		[PAD-/+]		OR [O/P]:		6%	
BLADE: AY			P-INDE)			FILE: WINSTON\JOHN					
[F2]->		BLADE		DEFAULT		SET [+/-]		SPEED_CHANGE			
0			AC11	0.00				GROUP SPEED			
1			BC21	=0.00				FEED SPEED ONLY			
2			AC11	=0.00	BC21	=0.00		BLADE SPEED ONLY			
3								RW SPEED			
4								RQ SPEED			
5											
6											
7											
8											
[FILE]: SAVED			[POWER]: SERVO ON			[MODE]: EDITING					
[TIME]: 03/16 11:52:21			[PIN]: T1=1 2=1 3=1								

08.6.1 GROUP SPEED



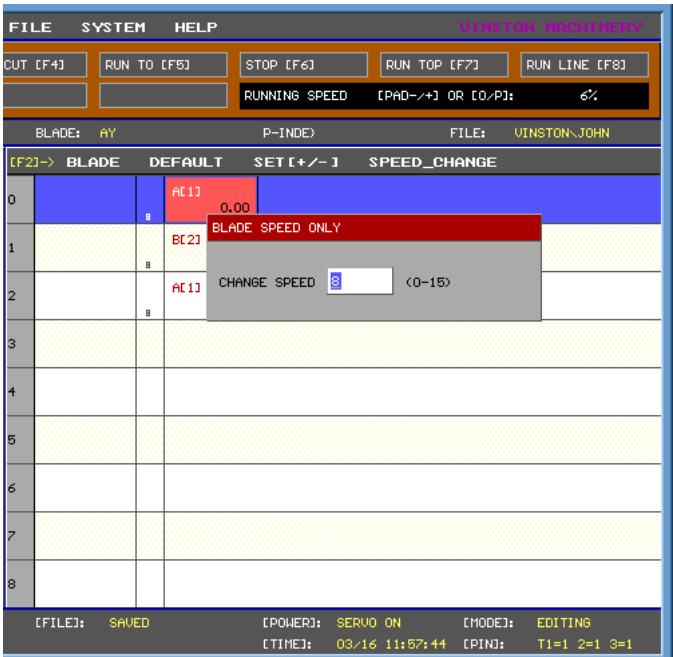
GROUP SPEED: Change the speed of all axes on the selected line of code. The operator can set a value between 0 and 15.

08.6.2 FEED SPEED ONLY

FILE			SYSTEM			HELP			WINSTON MACHINERY								
CUT [F4]			RUN TO [F5]			STOP [F6]			RUN TOP [F7]			RUN LINE [F8]					
						RUNNING SPEED			[PAD-/+] OR [O/P]:			6%					
BLADE: AY			P-INDE			FILE:			WINSTON.JOHN								
[F2]->			BLADE			DEFAULT			SET [+/-]			SPEED_CHANGE					
0					AC13	0.00	FEED SPEED ONLY										
1					BC23												
2					AC13	CHANGE SPEED	8	<0-15>									
3																	
4																	
5																	
6																	
7																	
8																	
[FILE]:			SAVED			[POWER]:			SERVO ON			[MODE]:			EDITING		
						[TIME]:			03/16 11:56:35			[PIN]:			T1=1 2=1 3=1		

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

FILE			SYSTEM			HELP			WINSTON MACHINERY					
CUT [F4]			RUN TO [F5]			STOP [F6]			RUN TOP [F7]			RUN LINE [F8]		
						RUNNING SPEED			[PAD-/+] OR [O/P]:			6%		
BLADE: AY			P-INDE)			FILE: WINSTON\JOHN								
[F2]-> BLADE			DEFAULT			SET [+/-]			SPEED_CHANGE					
0					AC11	0.00								
1					BC21	RW SPEED								
2					AC11	CHANGE SPEED 8 (0-15)								
3														
4														
5														
6														
7														
8														
[FILE]: CHANGED			[POWER]: SERVO ON			[MODE]: EDITING								
[TIME]: 03/16 11:59:38			[PIN]: T1=1 2=1 3=1											

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