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Oversize tools

OVERHAUL OF PROCESS	The oversize is for the ARM type of random tool change, is not for the drum type, because the drum need only taken off the neighbor tools.

From the below procedure search the data:
SYSTEM → PMC → PMCPRM → DATA

D124=0 (no oversize tool function)
D124=3 (the oversize put to the Pot No. 2, but No.1 and No.3 cannot use, or use the small tool that cannot interrupt the moving of oversize tool, but we suggest you don't use the No.1 and No. 3)
D124=5 (the oversize tool put to the Pot No.2 and No.4 and the No.1, 3, 5 cannot use it or use the very small tool.)

The oversize tool function was fix the pot of your set, e.g. D124 =5 in this case the Pot No. 1 to 5 were fixed and cannot change the tool to the other pot, so sometimes the tool change needs long timer, because when the two oversize tools want to change each other, in this moment the oversize should be change one empty tool (POT No.1 or 3 etc.) then call the other oversize tool for change.

If the tool change waiting too long and can't be finished, maybe the alarm occurred, in this case has to modify the timer for the oversize tool change.

The Timer T000 is for magazine running and T002 is for arm swing timer that you can prolong the timer if the timer too short to change the tool.
Timer search procedure as below:
SYSTEM → PMC → PMCPRM → TIMER

The function of oversize tool was supported by the PLC and was not supported by the Macro. It is automatic tool change but when you reset the tools that you have to be careful about the position of oversize tool's position. |