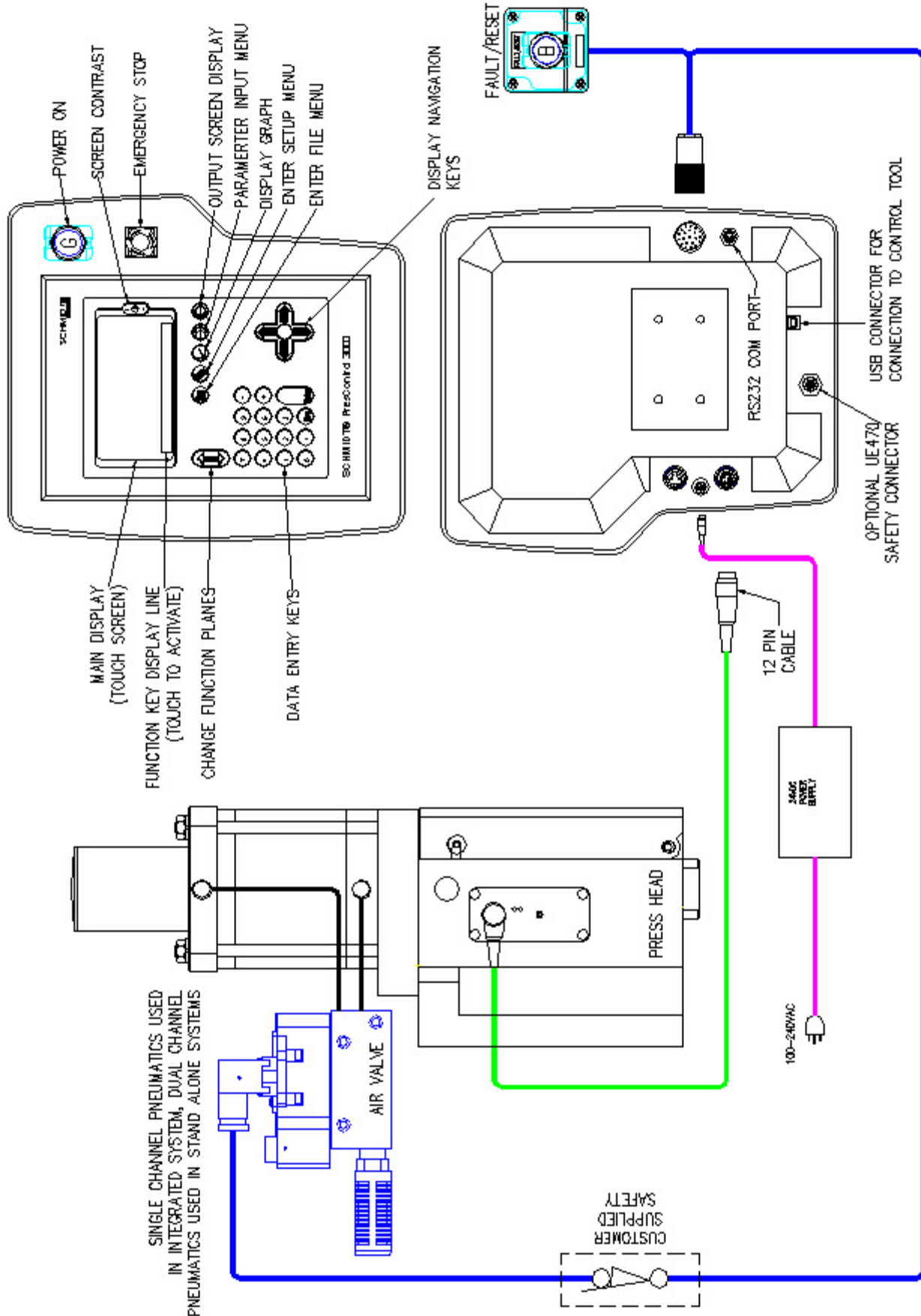


Quick Start Guide – Press Control 3000 – 300 Series Manual Press



Quick Start Guide – Press Control 3000 – 300 Series Manual Press

Power up & initialize press

1. Turn control on using green power button.
2. Operate press for “reference stroke”.

Parameter Input Screen

0 Mode: F=0, s=1, m=2	1	
1 Unlock at target force	100	N
2 Unlock at target stroke	20	mm
3 Unlock target time	0.5	sec
4 Start/Stop PDA	5	mm
5 Counter access	1	
6 Target count	10	pcs
7 Alarmtime quan. Reached	3	sec
8 Alarmtime press error	3	sec
9		

F – Force S – Stroke M- Manual



↑
D-In Key

Parameter Input Screen Information (D-In)

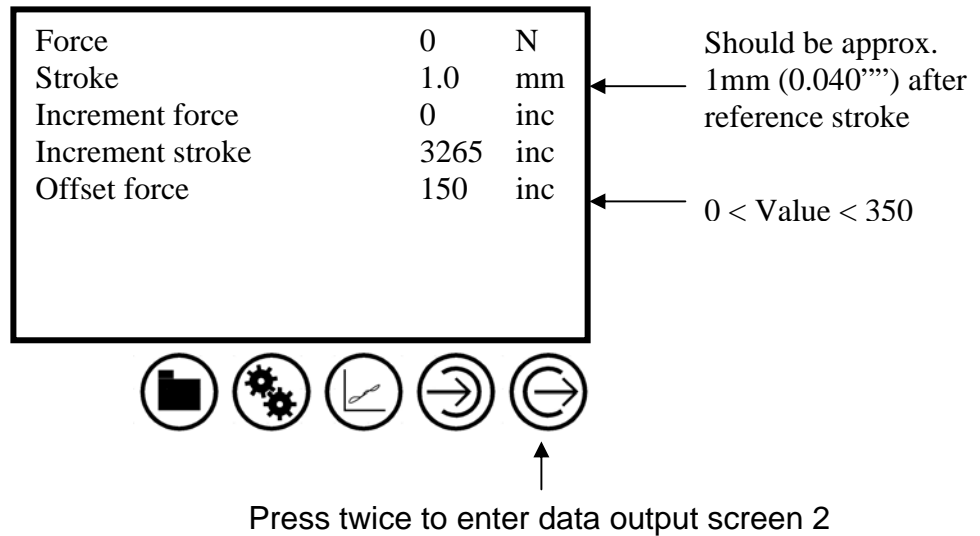
- Press Parameter Input Key (D-In)
- Use arrow keys to highlight parameter to change.
- Press enter to change highlighted parameter.
- Use keypad to change value.
- Press enter to accept and esc to abort change.
- Reference Section 5 of Operators manual for details.



Parameter Definitions

- Parameter 0 – Select press mode, 0 for force, 1 for stroke and 2 for manual.
- Parameter 1 – Target force if force is selected.
- Parameter 2 – Target stroke if stroke is selected.
- Parameter 3 – Time delay before ram retracts after target is reached.
- Parameter 4 – Start & stop position for recording force curve. 5mm is min.
- Parameter 5 – Enables/Disables access to change and zero counters.
- Parameter 6 – Target count for preset counter.
- Parameter 7 – Time alarm sounds for when target quantity is reached.
- Parameter 8 – Time alarm sounds for when press error occurs.

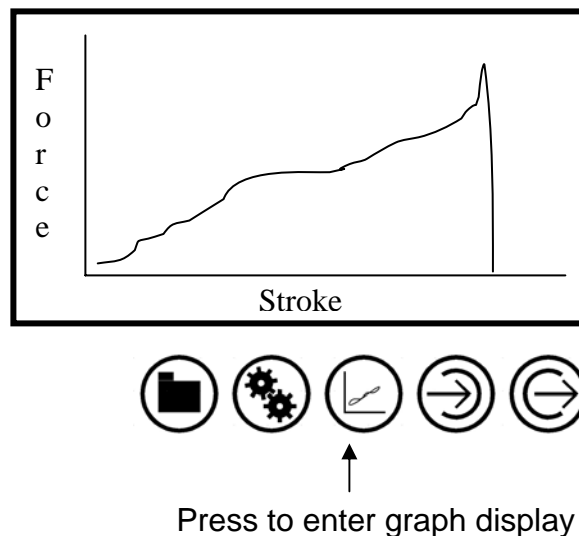
Quick Start Guide – Press Control 3000 – 300 Series Manual Press Data Output Screen 2



Data Output Screen 2 Information:

- Displays current force
- Displays current stroke
- Displays current force in system increments
- Displays current stroke in system increments
- Force offset value, if 0 or greater than 350, system needs to be calibrated

Graph Display



Graph Screen

- Once graph screen is displayed, pressing enter will enter the monitoring and zoom function screen.
- Refer to section 10 of the Operators Manual for information on Zoom and Monitoring functions.

Quick Start Guide – Press Control 3000 – 300 Series Manual Press

Sample setup parameters:

Press to a distance

1. Press D-In Key
2. Line 0 – set to 1 (for stroke – mode)
3. Line 1 – set to 100 N
4. Line 2 – set to 30 mm (press ENTER, enter value, press ENTER)
5. Cycle press without a part in fixture

Press to a force

1. Press D-In Key
2. Line 0 – set to 0 (for force – mode)
3. Line 1 – set to desired press force. Once reached, ram will return
4. Line 2 – enter value greater than required ram travel
5. Cycle press with a part in fixture or something to press against