

ACE INSIGHT *plus*

Operator's Guide

TURNING ON THE MONITOR

On the back of the unit, in the lower right corner, is a switch which turns the monitor on and off.

SETTING & CLEARING COUNT

Total	15000000
Made	107
Shift	107
Tool	107
RPM	***

1	2	3
4	5	6
7	8	9
C	0	E

Press Count then press "C". This will make the number flash, press "C" again to erase the current count settings. Then, with the numeric keypad enter the new counts.

Entering 0 in TOTAL will not stop the machine.

press "E", to advance to "MADE",
press "C", Press "E" to advance to "SHIFT"
press "C", Press "E" to advance to "TOOL"

To exit the count, press "COUNT" "C" CLEAR
"E" ENTER

SETTING LIMITS

CH	LL	MIN	AVG	MAX	HL	PEAK
1		450	504	546	600	2.29
2	350	426	505	574	595	7.82
3	225	215	215	514	550	13.3
4	450	490	498	509	525	3.69

1	2	3
4	5	6
7	8	9
C	0	E

Limits can be set anytime.

Press LIMITS to activate the channel adjustment display.

The first channel will highlight.

Pressing "C" will now flash the Low Limit (LL)

indicating it can be changed,

press "E" to advance and change the High Limit (HL).

press "E" will advance to the next enabled channel,

press "C" and repeat steps as listed above.

To exit the Limits display, press LIMITS.

Limits set at 000 AVG 999 will have no control.

NO-FEEDS *Thread Rollers Only*

No-Feed Limit: 150
No-Feed Count Limit: 100 No-Feeds Seen: ***

No-Feed limit is a second low limit, force below this limit is not counted or measured by the process monitor.

No-Feed Count Limit stops the machine when the limit of parts is reached.

No-Feeds Seen shows how many consecutive no feeds have occurred.

When the AVG force goes below the No-Feed Limit a red light will flash. The unit will no longer count production parts and the No-Feeds Seen will start to count up to the No-Feed Count Limit.



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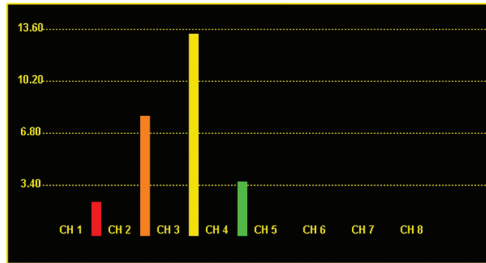
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ACE INSIGHT *plus* Operator's Guide Continued...

VIEW PEAK

Not available on the ACE / INSIGHT *plus*



Press PEAK to view the work load for each channel enabled.

The work load may range from .200 millivolts to 400 volts.

To exit Peak display, press PEAK.

ERRORS

CH	LL	MIN	AVG	MAX	HL	PEAK
1	400	450	503	546	600	2.17
2	350	426	508	574	595	7.73
3	225	215	215	514	550	1.03
4	450	490	500	509	525	3.62

Mode: **STOP**
Low limit exceeded
on Ch: 3

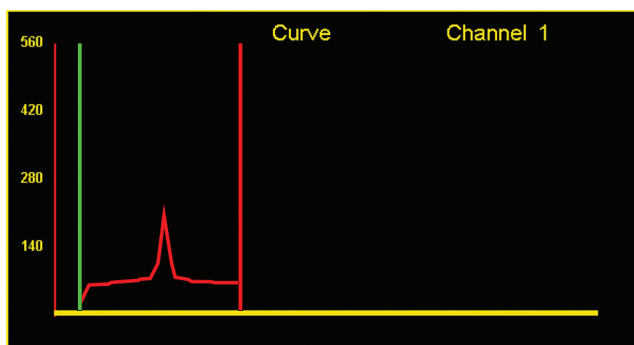
Errors will occur when the forming force is outside the limits.

When the AVG force goes below or above the limit in any station, the unit will stop the machine and display the error detected.

To clear the error hit RESET button to the right of the screen.

CURVE DISPLAY

Not available on the ACE / INSIGHT *plus*



Press CURVE to view the incoming signal.

You will see a curve per activated channel. Press next to view each next channel.

To exit Curve display, press CURVE.

Note: This is an example for cursors enabled. A CAM setting will not show the lines.



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