

ACE 200-400-600^{plus}

Channel Setup

Only use this procedure if you are changing machines or adding or removing sensors.

Step 1. Turn off the unit using the switch on the rear of the unit.

Step 2. Press and hold any two buttons on the front of the keypad (**▲ ▼**) and turn on the unit using the switch on the rear of the unit.

*Note: Using the **▲ ▼** you can disable the desired channels. When the LED is ON, the channel is on, when the LED is OFF that channel is off.*

Step 3. The display will show **CH 1**, the first LED, Input 1 will be on.

Step 4. Press SELECT, the display will show **CH 2**, and the second LED, input will be on.

Step 5. Press SELECT, the display will show **CH 3**, and the third LED, input will be on.

Step 6. Press SELECT, the display will show **CH 4**, and the fourth LED, input will be on. This will continue for the ACE 600plus, 2 more channels.

Step 7. Press SELECT and the display will show **SP 100**. The first digit will flash, press SELECT again which will move from the first digit to the second.

*Note: With this feature, we allow you to set the amount of strokes to occur before stopping the machine after the monitor sees a speed change. If this is set to **100**, the relays will not turn off the machine until 100 strokes after the speed change. If this is set to **001**, the machine will stop 1 part after the speed change.*

Step 8. Press SELECT and the display will show **TST LO** for the number of strokes the unit will stay in test mode. Press **▲ ▼** to change to **TST HI**. (**TST LO** is for 100 strokes, and **TST HI** is for 500 (strokes))

Step 9. Press SELECT and the display will show **LRN LO**. Press **▲ ▼** to change to **LRN HI**. **LRN LO** is set for 8 strokes, **LRN HI** is set for 32 strokes.

Step 10. Press SELECT and the display will show **REJ OF**. Press **▲ ▼** to turn on or off the reject feature. **REJ OF** is Reject off, **REJ ON** is reject on. Reject will allow the machine to run when defective parts are made.

If **REJ** is OFF go to step 12.

If **REJ** is ON go to step 11.

Step 11. Press SELECT and the display will show **ECP LH**, which will allow you to reject low only, high only, or low and high parts. Press **▲ ▼** to change from **ECP LH**, low and high bad parts, to **ECP LO**, low only bad parts, to **ECP HI** high only bad parts.

Step 12. Press SELECT and the display will show **CH 1** again, now turn off and on the unit to save the changed set up. Continue to set the limit and the counts as described in the Operators Guide.

Note: Should you have any questions, please contact our service department.

ACE products are manufactured and serviced by:

