

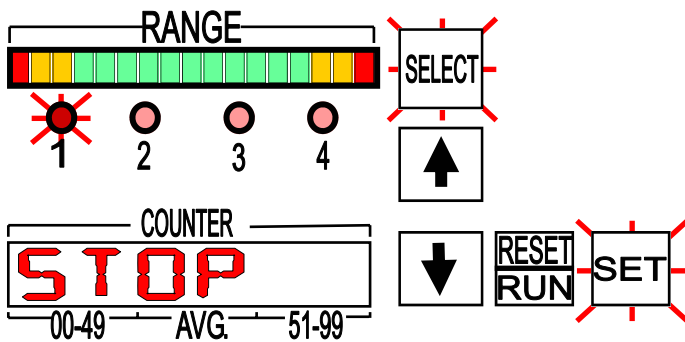
ACE 400 / 600 *plus*

Operator's Guide

Turning on the Machine

On the back of the unit, in the lower left corner, is a circuit breaker switch which turns the monitor on and off. When initially turned on, all LED's will be lit indicating that the unit is functioning properly. The unit retains all counts and limits used during previous use.

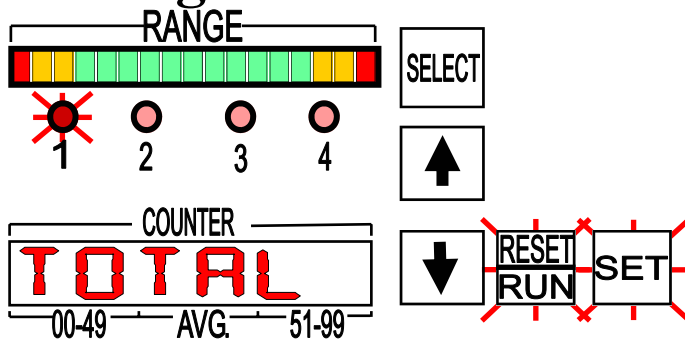
Setting Limits



With **Stop** in the digital display, press SET then SELECT. Flashing display indicates first digit of low limit which may be adjusted by pressing **▲** **▼** SELECT toggles to next digit. After low limit is completed, press SELECT again to adjust the first digit of the high limit. Repeat process above until high limits is complete. Recommended setting is **25 50 75**. Limit values closer to **50** produce greater sensitivity. Pressing SELECT after setting limits will display **TOTAL**.

*Follow the above instructions for each channel.
Limits set at 00 50 99 have no control.*

Setting Total Count

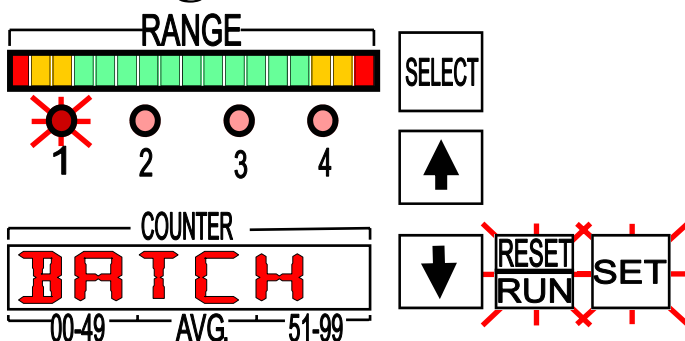


This procedure will establish the maximum amount of parts to be produced. With **total** displayed, press SET then RESET/RUN to enter amount desired using **▲** **▼** to change value. Use SELECT to cycle through each digit as required. When complete, press SET. **BATCH** will be displayed.

Adjustments to counter can only be made while unit is in STOP mode.

NOTE: *If no counts set, unit will not advance into LRN*

Setting the Batch Count



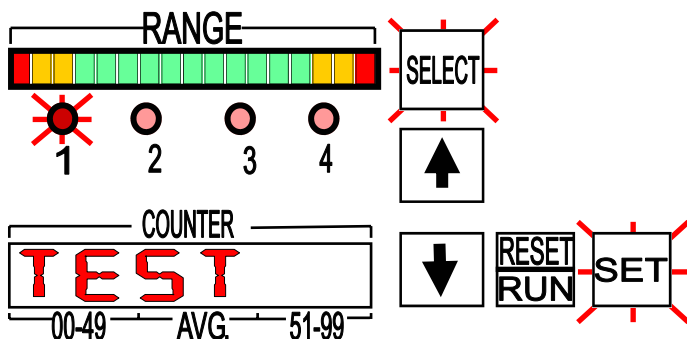
This procedure will establish the maximum amount of batch or inspection parts to be produced. Separate from the **TOTAL** counts.

With **BATCH** displayed, press SET then RESET/RUN to enter amount desired using **▲** **▼** to change value. Use SELECT to cycle through each digit as required. When complete, press SET. **STOP** will be displayed.

Note: *It is not necessary to use the BATCH counts.*

ACE 400 / 600^{plus} Operator's Guide

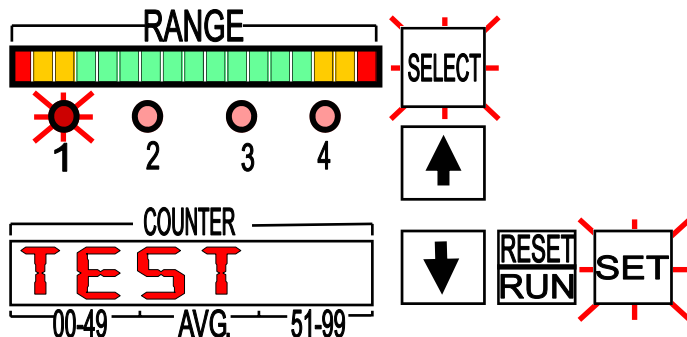
Controlling Production



With **STOP** displayed, pressing RESET/RUN turns off all relays. **TEST** is now displayed. Manually start machine / press. ACE will now monitor up to 100/500 test parts before shutting off for operator input. Operator may press RESET/RUN any time while in **TEST** to enter **LRN** mode. Following an 8 piece learn cycle, the ACE unit begins controlling production (a roaming green light appears in the bar graph). Use ▲ or ▼ to view ascending or descending counts.

Note: Access to **LRN** mode allowed only if an amount was entered in " Total Count" section above.

Altering Limits



Control limit may be changed at anytime while ACE unit is monitoring production. Press SET then SELECT to alter first digit of low limit. (follow procedure as outlined in "Setting Limits" section above). When new limits have been altered, press SET to resume production and control. Min/Max is the lowest and highest force value monitored during control mode. Press SELECT once to view limits then press SELECT again to view Min/Max.

Example: 20 50 80 displays current limits, press again
39 50 59 displays Min/Max

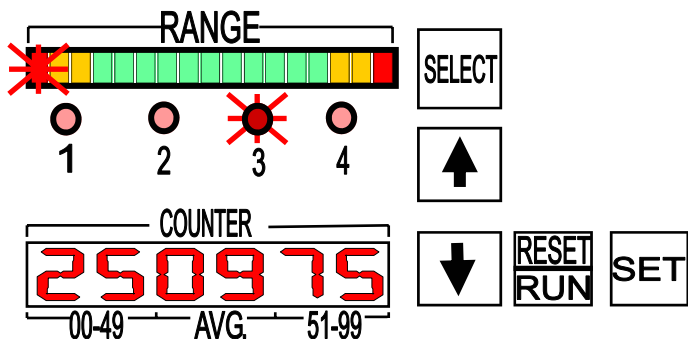
Note: Follow the above instructions for each channel. If in View mode (red LED flashing in lower right side of display) press RESET/RUN before altering limits as described above.

View Sensor Voltage



While unit is monitoring production, press SELECT three times to display PL or PH relative values. PL and PH values can be displayed for each channel. Press RESET/RUN to resume display to production counter.

Errors



When an error occurs the unit stops production then displays the channel and exceeded limit value (bar graph indicates a low limit error when left red light is on, and a high limit error when the right red light is on).

Example: Actual monitored values are displayed (two center display digits) if either.

1. Low force falls below low limit set
- or
2. High force value exceeds high limit set

Pressing the RESET/RUN once will display **TEST** allowing operator to investigate malfunction. When error is corrected, press RESET/RUN to enter **LRN** mode. Monitor will again count 8 parts and resume controlling production.



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