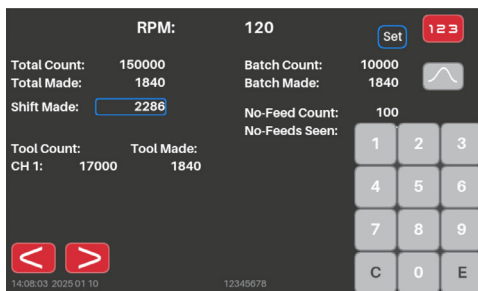# T3 MODEL OPERATOR'S GUIDE

Machine/Tool Protection

The primary function of this monitor is to reliably measure speed and force.

SETTING & CLEARING COUNT (123 BUTTON)

Press the **123 Button** to bring up the count view/adjustment display.

Press the number you wish to modify. Using the keypad, type in the desired number and press "**E**" to confirm the changes.

Entering "**0**" in the Count field will maintain the count but won't shut the machine off.

Count can both be set and cleared, while Made can only be cleared.

Press "**Set**" to disable the keyboard.

SETTING LIMITS (CURVE BUTTON)

Limits set at 000 AVG 999 will have no control.
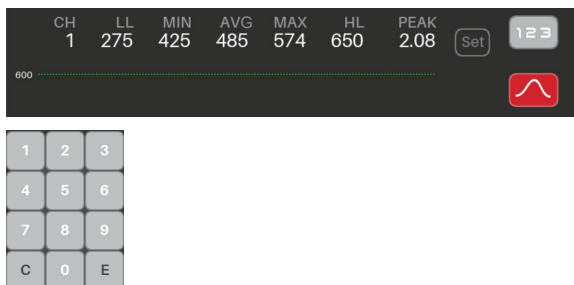
Press the **Curve Button** to activate the channel adjustment display.

Press the number below **LL** or **HL**, and it will begin to flash. Using the keypad, input the desired number for this limit. Press "**E**" to modify the **HL** Limit. Press "**E**" to confirm the changes.

In Auto Limit Mode, the "**Set**" tab will appear in red. Limits will be set by the monitor.

To leave the set Limits option, press "**Set**."

NO-FEED (CURVE BUTTON)

Thread Rollers Only

To find the no-feed limit, run the roller with parts and hold them back in the rail to simulate a no-feed. With parts, the average is 498; holding them can gives an average of 4. Set the no-feed limit to 8; if it drops below 8, the die area is empty.

Select the **No-Feed Button**, and the **AVG** will switch to the No-Feed Limit setting. Then, using the keypad, type in the desired number and press "**E**" to confirm the changes.

T3 MODEL OPERATOR'S GUIDE

This monitor has two input types. The first connects to the Force Sensor, a device that gives a precise analog signal based on the applied force, enabling real-time monitoring within defined limits. The second input is from the Cam Sensor, which acts like a trigger to determine the position of the ram on the machine. The placement of these sensors is important for the functioning of the monitor, as it ensures safety by stopping the machine if the force exceeds the set limits to prevent further damage or faulty parts.

MORNING CHECKLIST

PLEASE ANSWER ALL QUESTIONS   **CIRCLE ONE**

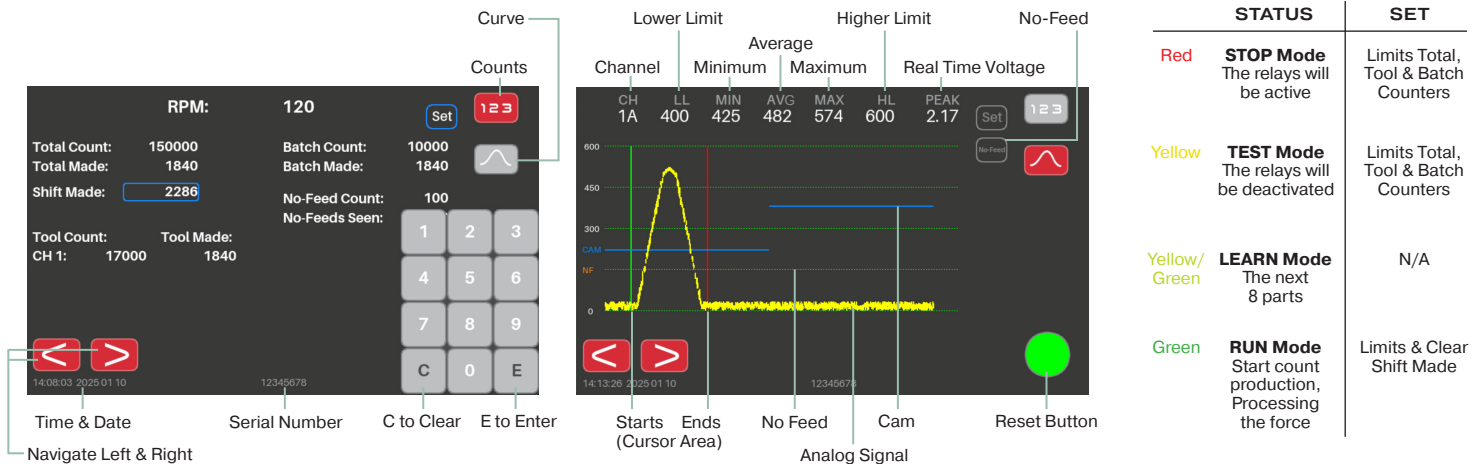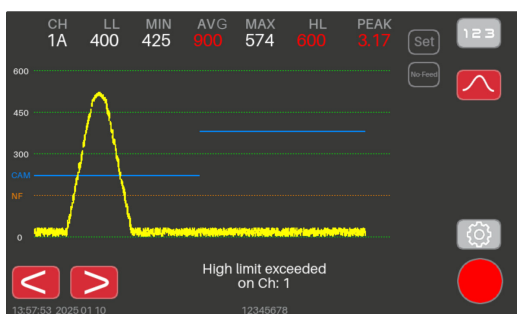|	
Does the monitor turn on?	**YES / NO**
Is the monitor accurately counting?	**YES / NO**
Does the monitor maintain an average limit of around 500?	**YES / NO**
Does the monitor power off the machine when an error occurs?	**YES / NO**
Do you have any questions how the monitor works?	**YES / NO**

*If you answer **NO** to any questions, contact maintenance or consult your ACI technician.*

OVERVIEW

Curve
Counts

Lower Limit
Average
Higher Limit
No-Feed
Channel
Minimum
Maximum
Real Time Voltage

RPM: **120**

Total Count: 150000	Batch Count: 10000
Total Made: 1840	Batch Made: 1840
Shift Made: 2286	No-Feed Count: 100
	No-Feeds Seen:
Tool Count:	Tool Made:
CH 1: 17000	1840

Set

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

14:08:03 2025 01 10   12345678

Time & Date
Serial Number
C to Clear
E to Enter
Navigate Left & Right

CH	LL	MIN	AVG	MAX	HL	PEAK
1A	400	425	482	574	600	2.17

Set
No-Feed

600
450
300
CAM
NF
0

14:13:26 2025 01 10   12345678

Starts   Ends
(Cursor Area)
No Feed
Cam
Reset Button
Analog Signal

	STATUS	SET
Red	**STOP Mode** The relays will be active	Limits Total, Tool & Batch Counters
Yellow	**TEST Mode** The relays will be deactivated	Limits Total, Tool & Batch Counters
Yellow/ Green	**LEARN Mode** The next 8 parts	N/A
Green	**RUN Mode** Start count production, Processing the force	Limits & Clear Shift Made

ERRORS (CURVE BUTTON)

CH	LL	MIN	AVG	MAX	HL	PEAK
1A	400	425	900	574	600	3.17

Set
No-Feed

600
450
300
CAM
NF
0

High limit exceeded on Ch: 1

13:57:53 2025 01 10   12345678

When the **AVG** number falls below the **LL** or rises above the **HL** limits at any station, the machine will stop, and the status will indicate which channel has gone beyond the limit.

To return the monitor to **Test Mode**, press the **RESET Button**.