

MC Pro 2400 System Check Setup

This test should be set up after the system lug pulse is timed properly

1. Locate a suitable Calibration Test piece, preferably the piece the mill uses to calibrate their scanners. 2x4 aluminum tubing is perfect.
2. With the sensors empty, go into the diagnostic static test screen. Set the Burst Length to 2 then force the background.
3. Place the test piece centered over the sensors. Observe the Delta reading. You are looking for a Delta value of about 150. If the delta is too high, remove the piece then set the burst length to 1 and take a background and test again. Once you find the optimum Burst Length for that piece you can remove it and set the burst length back to its original value and take a background.
4. Open the System Check page in the software. then open the Standard tab
5. Set the burst length to the value discovered in the static screen
6. If the system uses a photoeye for board present then select "use infeed PC" if an input from the PLC is used for board present then leave it deselected.
7. set the high and low range for the temperature. this will be the temperature of the test piece, so typically the values will be between +5 for a low and +30 for the high
8. Save the values
9. Press the start tab, then yes to confirm
10. Run the line empty until the display at the bottom says "waiting for Standard Piece"
11. Pass the piece through the sensors then run empty lugs until the display at the bottom says "System Check Complete"
 - Min lug count should say Pass
 - Temp sensor cycle should say Pass
 - Temp sensor should say Pass
 - Infeed PC should either Pass if it is present, or say not tested
 - PC 1-5 should pass if they are enabled
12. Open the standard window so that the values can be adjusted while you are looking at the results
 - Note: Ideally you will be able to use just the default settings but if you have one of the sensors that is reading significantly different than the others you can check the override for that sensor to adjust its parameters separately.
 - Ticks between PE and lug should be between 10 and 20 if the line has been timed properly the min - max for the standard board should be set to +5 from this value
 - Sensor Distance 1-5 set the min distance to .100 lower than the lowest distance reading and the max to .100 higher than the greatest distance.
 - Sensor 1 - 5 Delta set the min max to + - 15 from this value
 - Sensor 1 - 5 Read count set the min max to + - 3 from this value