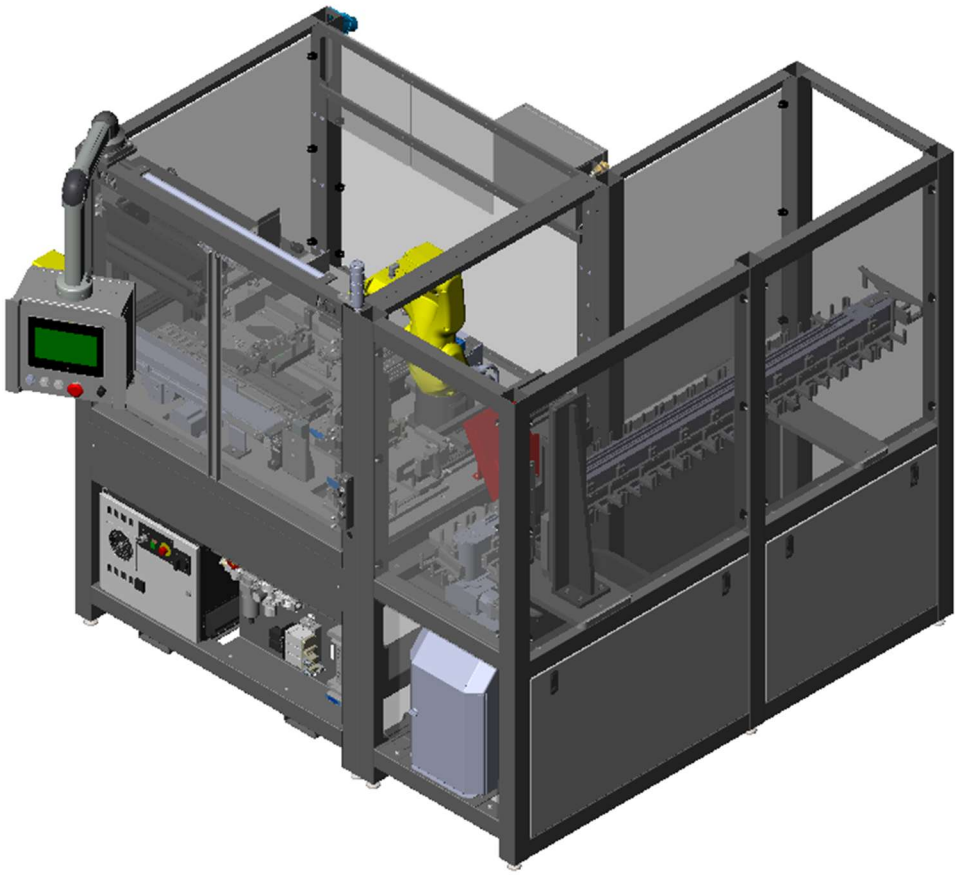
Operations Procedures

Topiderm: B16821



WAUSEON MACHINE

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Navigation Screen

This screen allows the operator to navigate to each of the different elements of the system. Each of them will offer specific options and/or information once the operator has selected a location to navigate to.

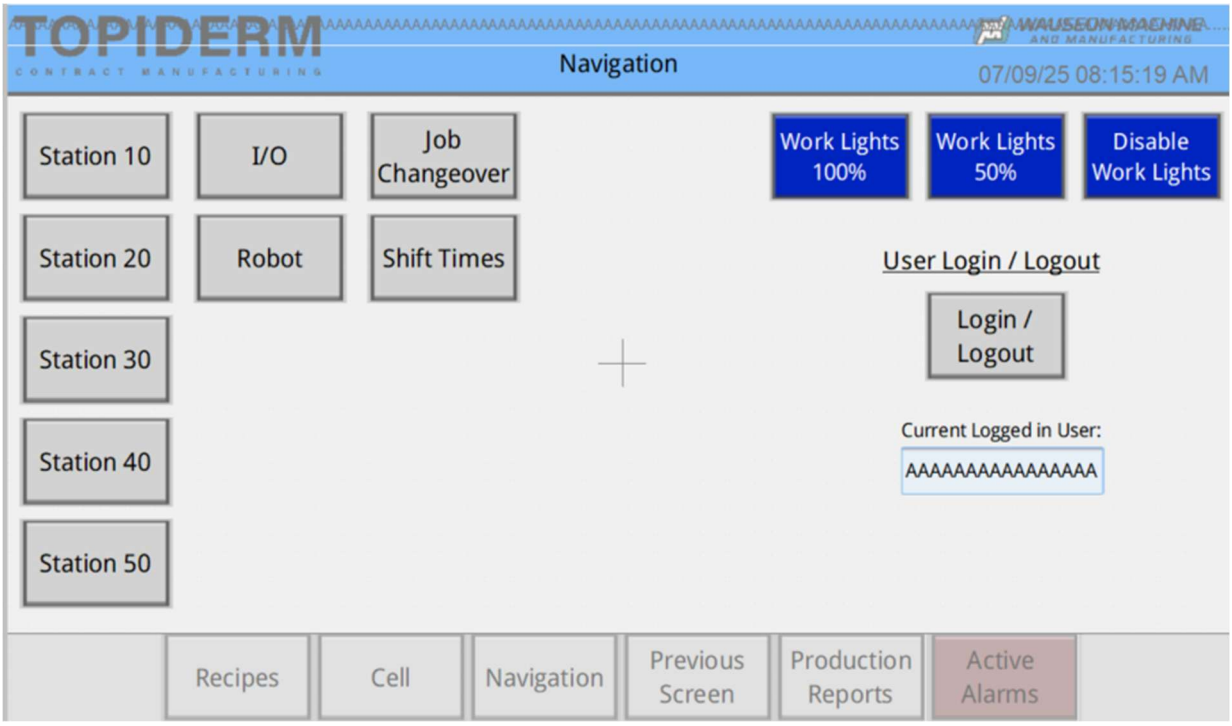

Figure 1: Navigation Screen

Recipes Screen

From this screen, the operator can select and/or view the current recipe. The 30 Box, 35 Box, 50 Box, and 60 Box recipes include the following:

- Box Weight Min. (g)
- Box Weight Max. (g)
- Packs per Nest
- Packs per Stack
- Average Cycle Time
- Target Cycle Time
- Robot Speed

Figure 2: Recipes Screen

Product Changeover Guide Screen

The appropriate station(s) and robot(s) must be selected and deselected on this screen to change the product that is being run. When active, the box next to the station/robot will populate with a green checkmark.

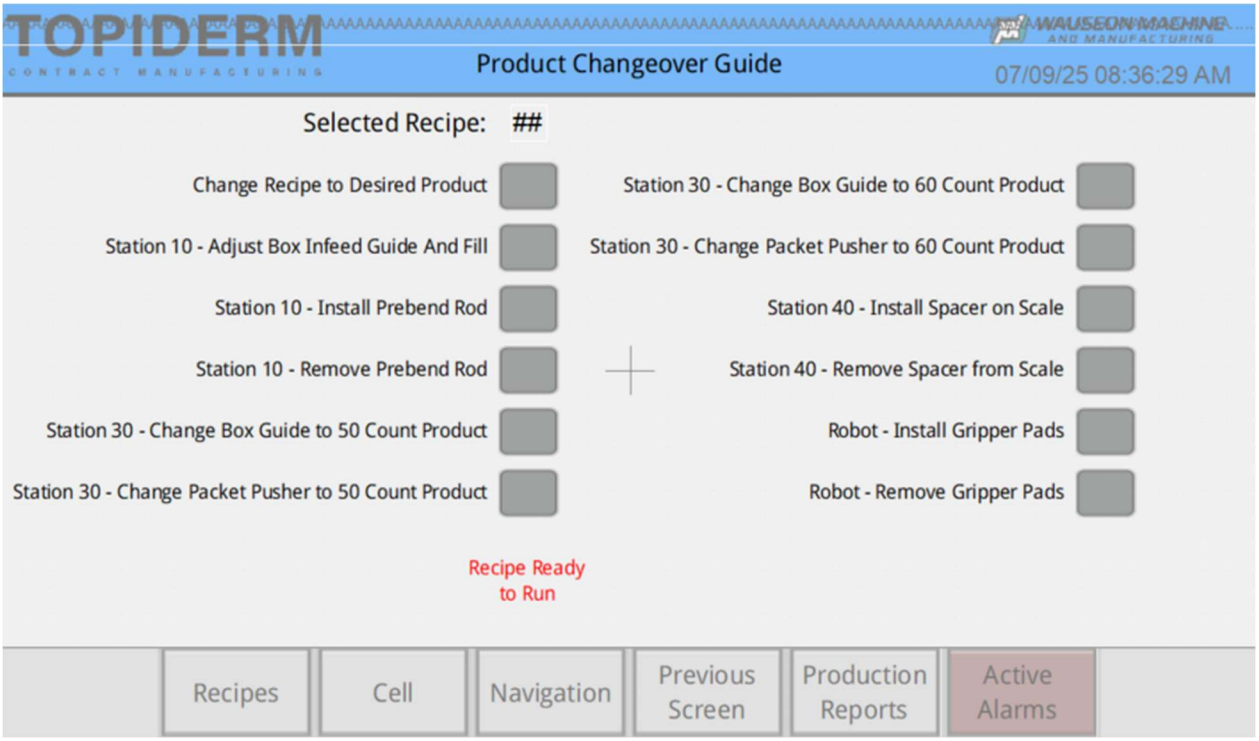

Figure 3: Product Changeover Guide Screen

Production Reports Screen

From this screen, the operator can view the quantity of **Total Parts**, **Good Parts**, and **Reject Parts** for shifts A, B, and C.

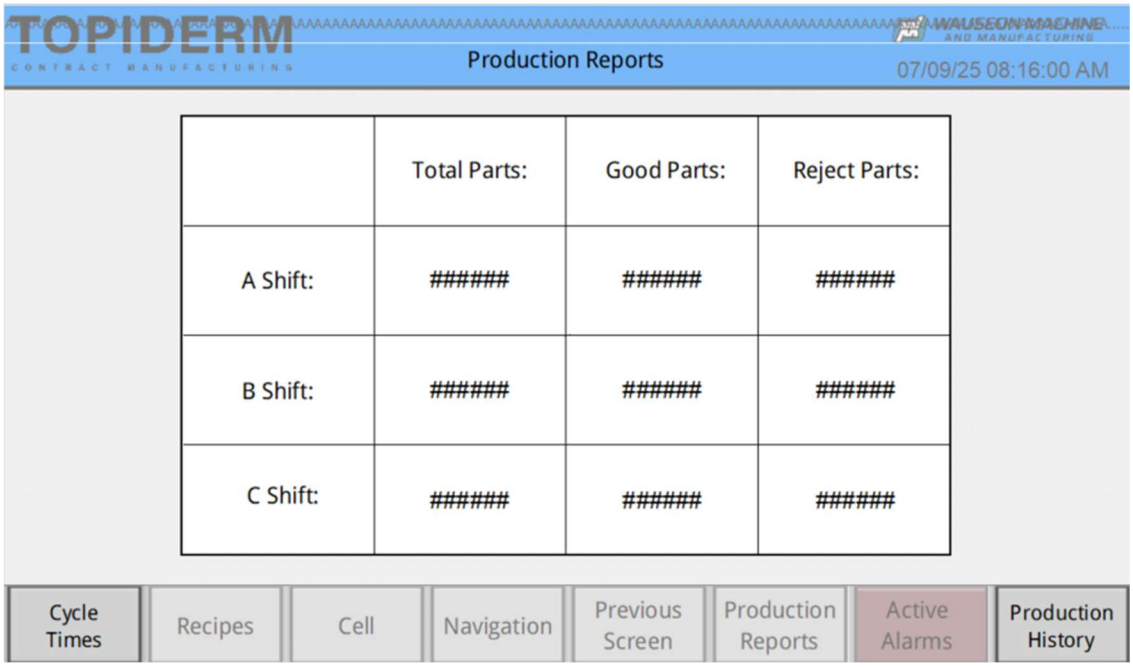

Figure 4: Production Reports Screen

Cycle Times Screen

This screen allows the operator to view recent cycle times and the average cycle time per series of cycles for each package (Pk) type.

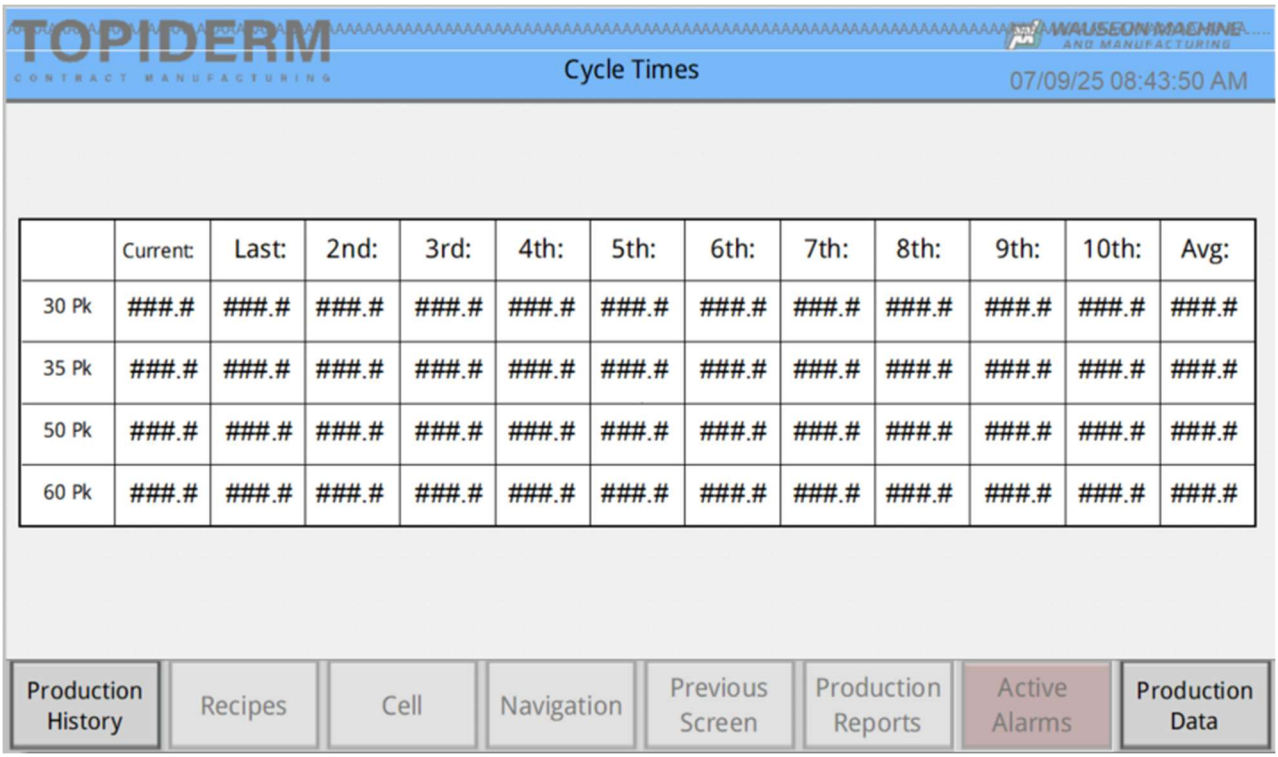

Figure 5: Cycle Times Screen

Cell Screen

From this screen, the operator is able to view the active/inactive status of each component of the system, in addition to the:

- Active Recipe
- Infeed Setpoint
- Nest at Infeed
- Current Step
- Sta10 Step
- Box Close Step
- Cycle Time (Current)
- Cycle Time (Last)
- Last Box Weight (g)

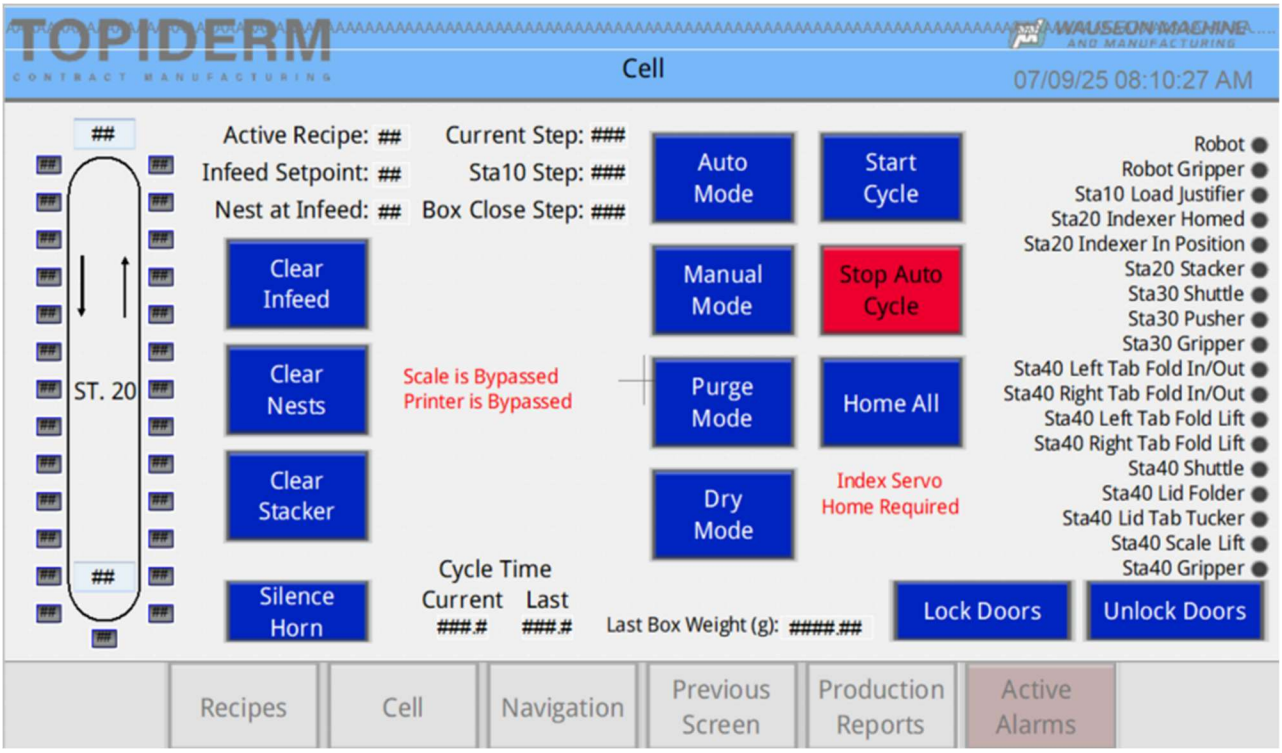

Figure 6: Cell Screen

Cell Screen (Continued)

From the Cell screen the operator can also perform any of the following:

- Clear Infeed
- Clear Nests
- Clear Stacker
- Silence Horn
- Auto Mode
- Manual Mode
- Purge Mode
- Dry Mode
- Start Cycle
- Stop Auto Cycle
- Home All

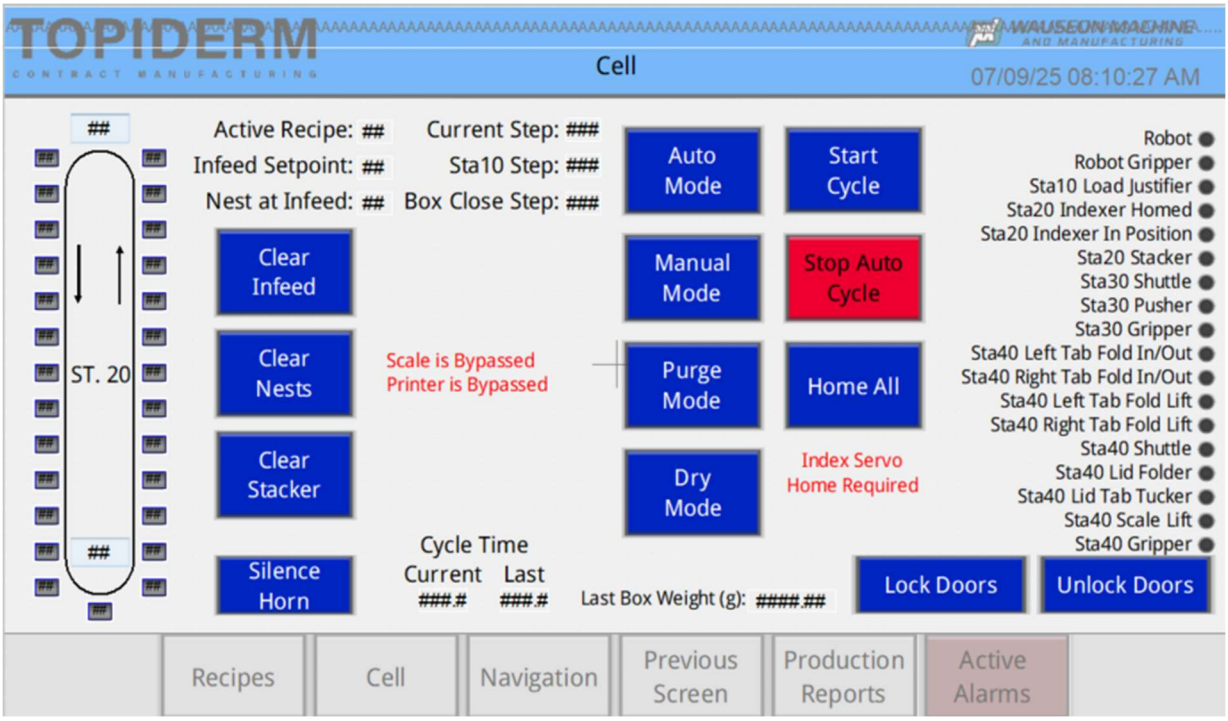

Figure 7: Cell Screen

Robot Manual Control Screen

This screen allows the operator to select an individual robot by clicking the **Mission Select** dropdown box and choosing the desired element. On the right side of the screen the active/inactive statuses can be seen. Once a robot has been selected, the operator can manually perform the following:

- Close (Robot Gripper)
- Open (Robot Gripper)
- Move to Home (Robot Control)
- Move to Maintenance (Robot Control)
- Stop (Robot Control)
- Request Speed (Robot Speed(%))
- Run Mission

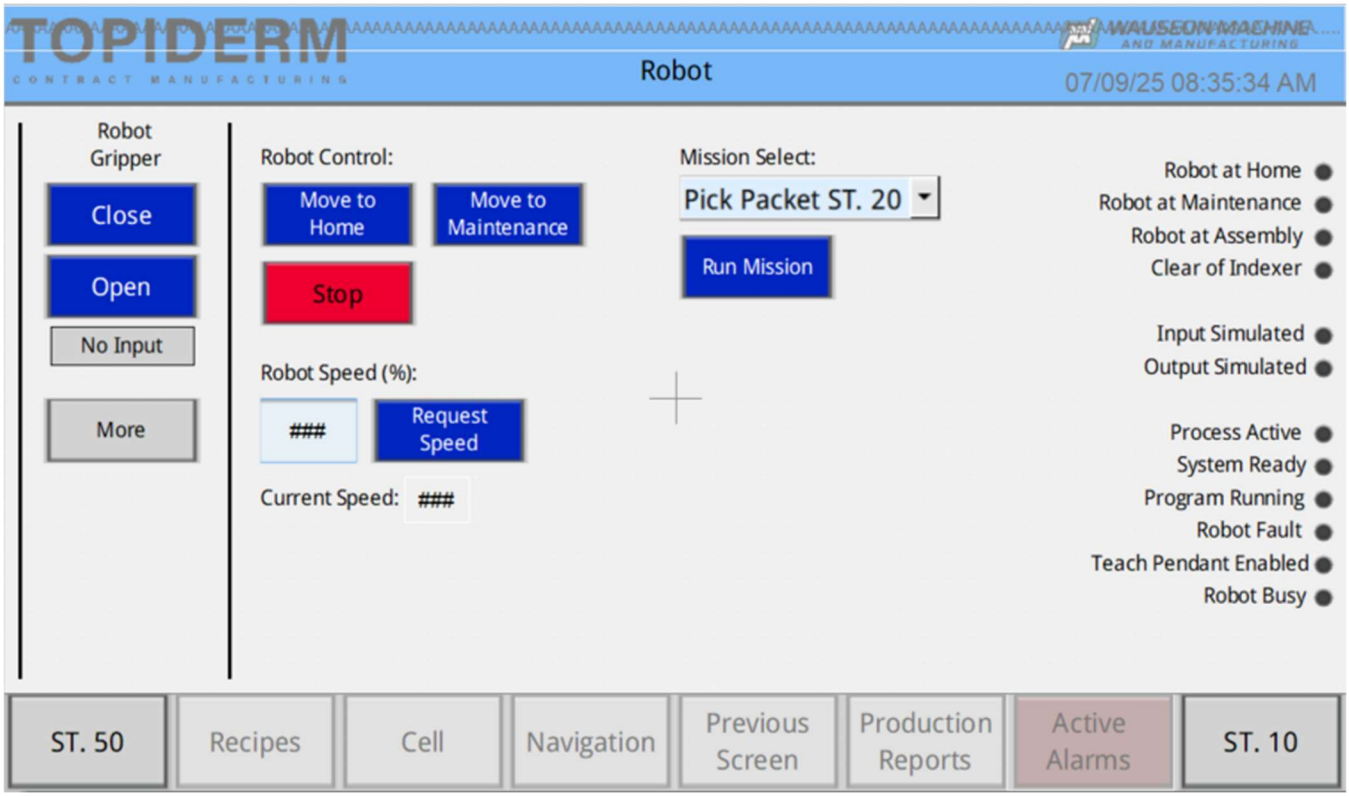

Figure 8: Robot Manual Control Screen

Robot Servo Gripper Screen

From this screen, the operator can view the following statuses of the robot servo gripper:

- Open Position
- Close Position
- Velocity (%)
- Force (%)

They can also manually command the robot servo gripper to:

- Home
- Jog to Close
- Close
- Open

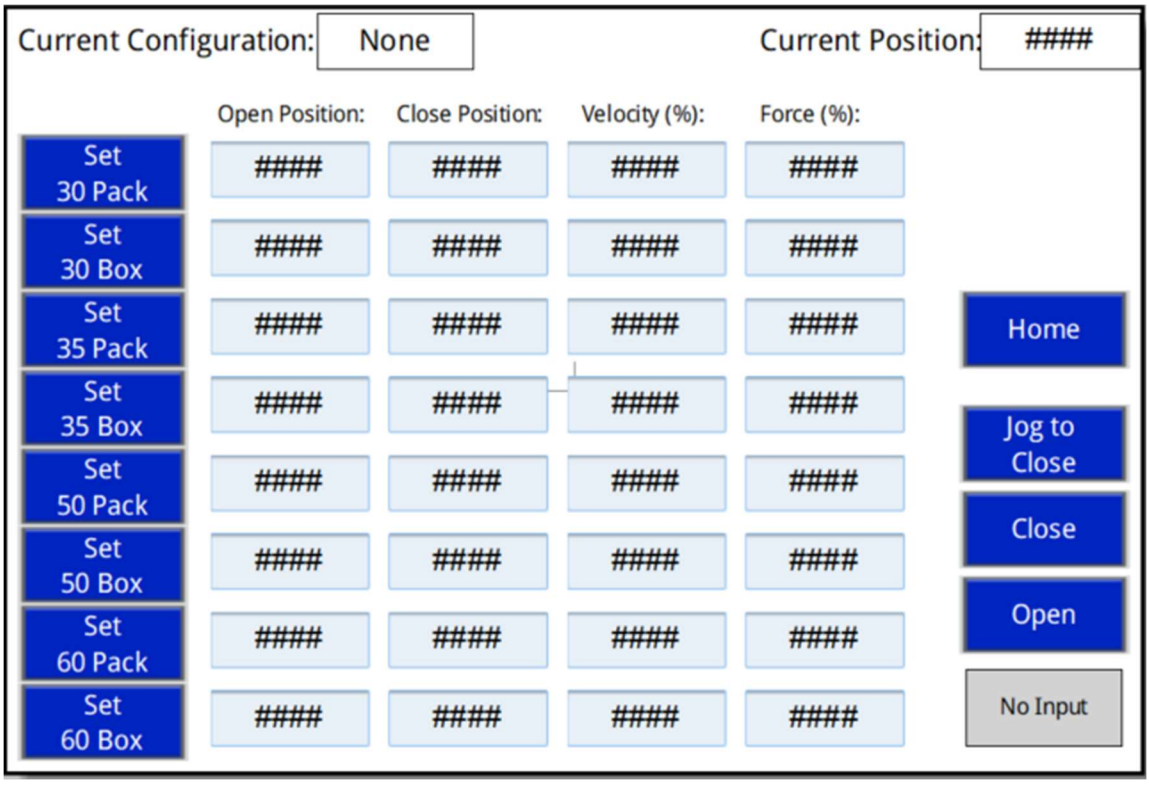

Figure 9: Robot Servo Gripper Screen

St.10 Infeed and Justifier Data Screen

This screen allows the operator to view the following:

- Cycles (Extend/Return)
- Last Time (Extend/Return)
- Avg. Time (Extend/Return)

To clear the current values and begin recording new, the operator must select the **Reset Statistics** button.

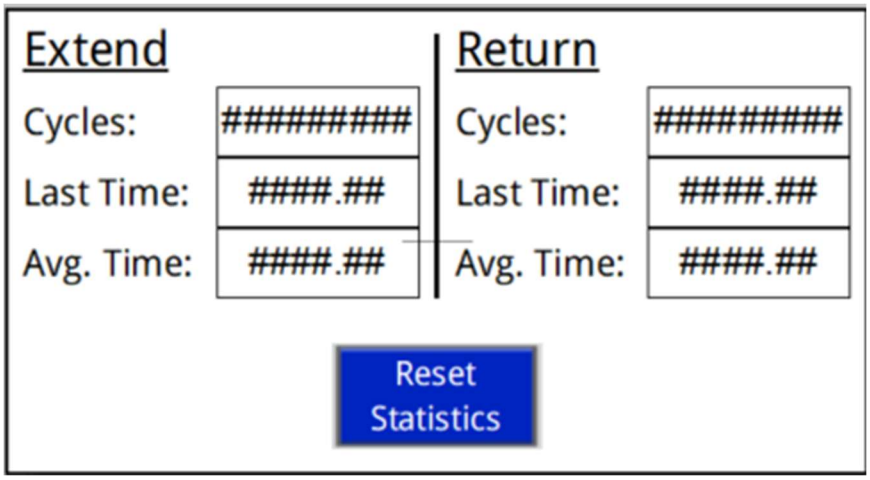

Figure 10: St.10 Infeed and Justifier Data Screen

St.10 Manual Control Screen

From this screen, the operator can manually perform the following:

- Extend (Infeed Pick Cylinder)
- Retract (Infeed Pick Cylinder)
- Vacuum (Infeed Pick)
- Blowoff (Infeed Pick)
- Disable Vacuum (Infeed Pick)
- Extend (Justifier Cylinder)
- Retract (Justifier Cylinder)
- Vacuum (Infeed Justifier)
- Blowoff (Infeed Justifier)
- Disable Vacuum (Infeed Justifier)

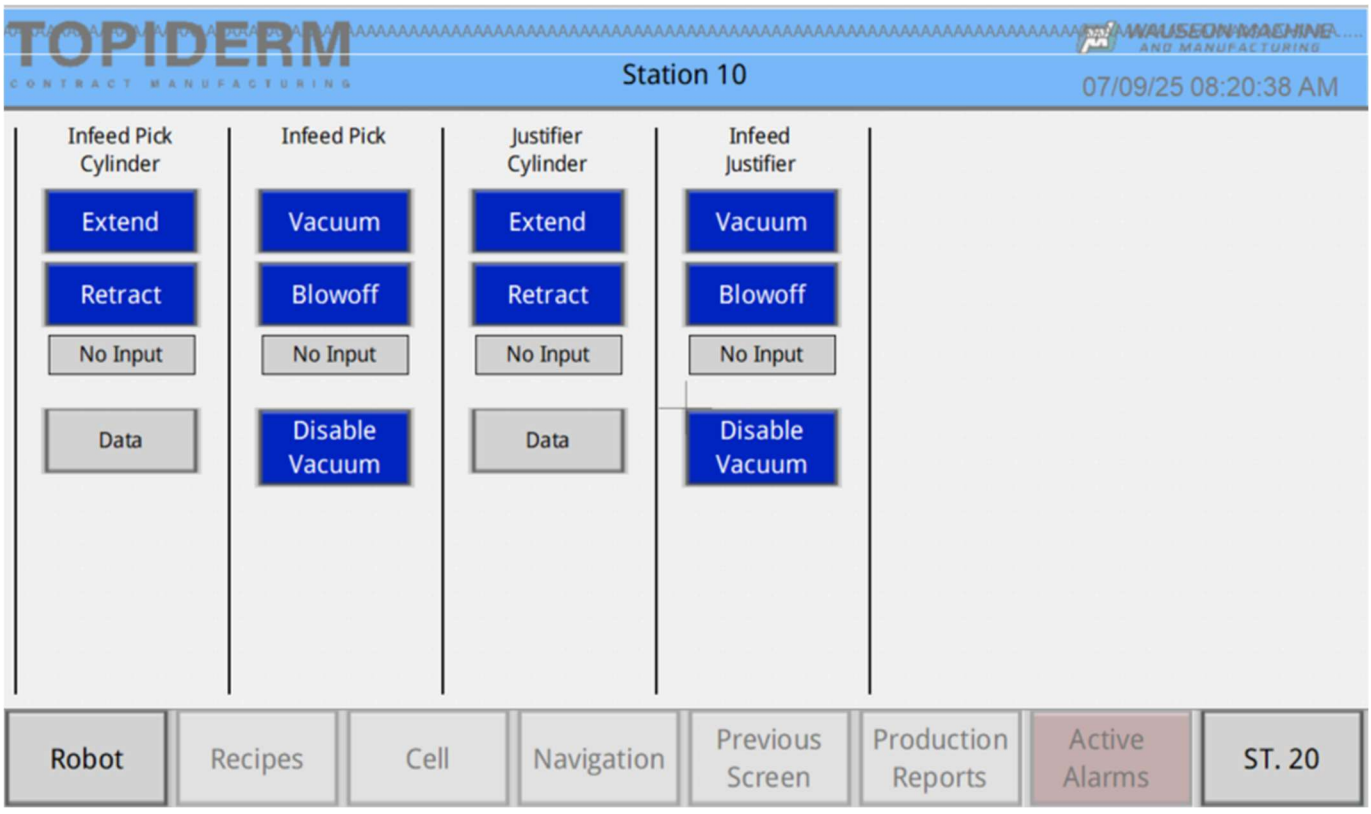

Figure 11: St.10 Manual Control Screen

St.20 Manual Control Screen

From this screen, the operator can manually perform the following:

- Raise (Packet Stack Cylinder)
- Lower (Packet Stack Cylinder)
- Extend (Packet Support Cylinder)
- Retract (Packet Support Cylinder)
- Jog + (Infeed Index Control)
- Jog – (Infeed Index Control)
- Home (Infeed Index Control)
- Index 1 Pocket (Infeed Index Control)
- Nest Enable/Disable

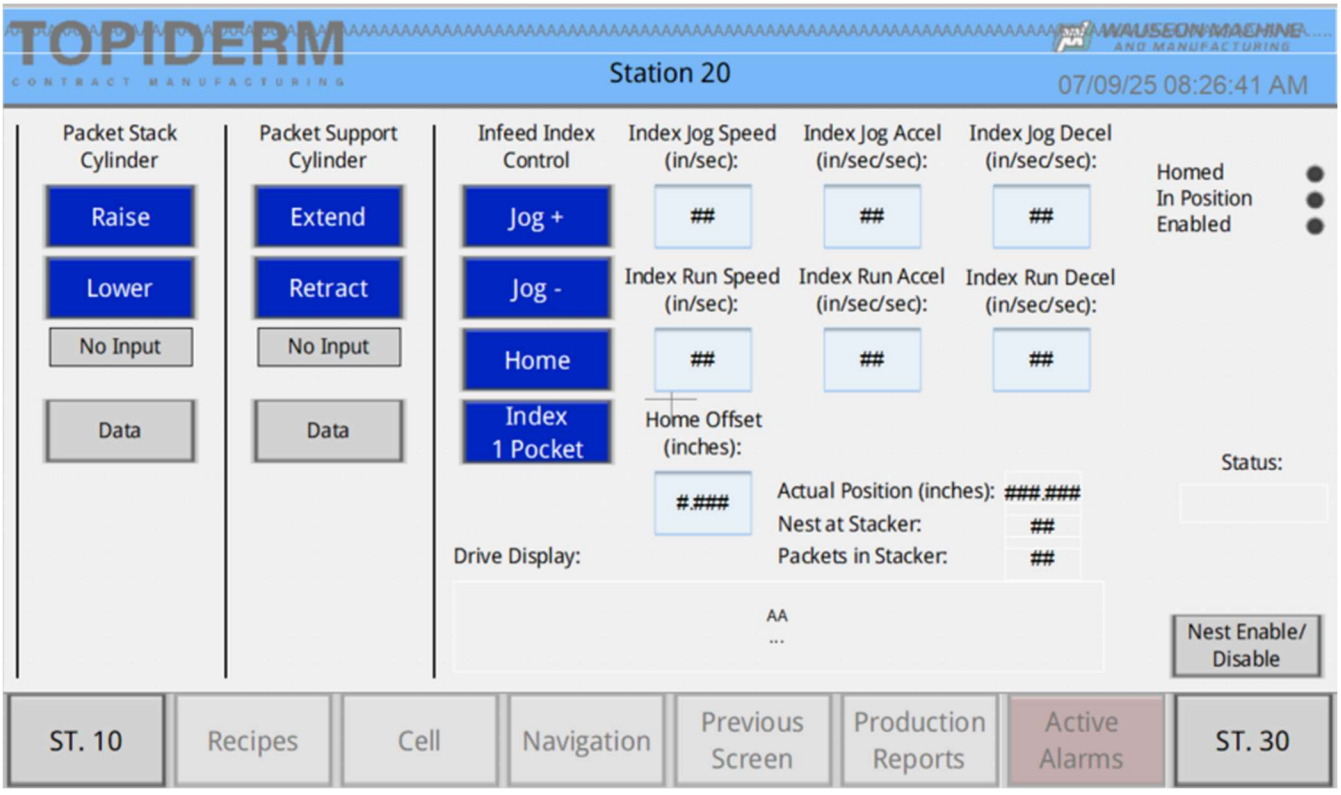

Figure 12: St.20 Manual Control Screen

St.20 Nest Enable/Disable Screen

This screen allows the operator to **view** and **select** which nests are currently enabled and disabled. If **enabled**, the nest will be green.

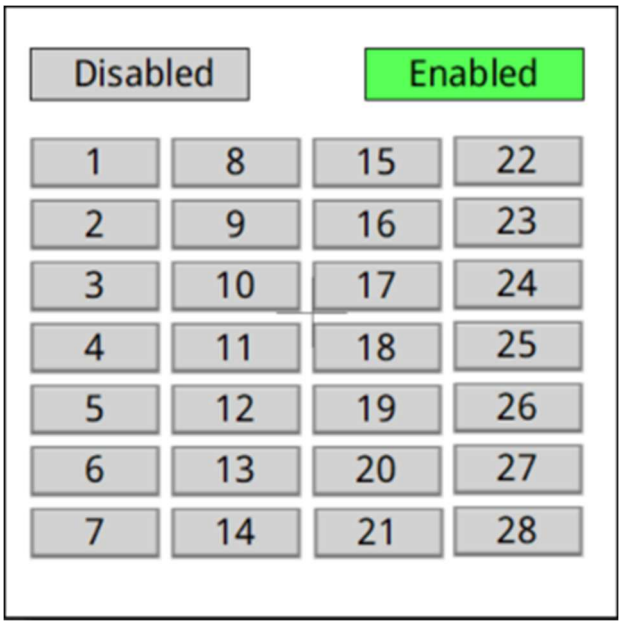

Figure 13: St. 20 Nest Enable/Disable Screen

St.30 Manual Control Screen

From this screen, the operator can manually perform the following:

- Close (Packet Gripper)
- Open (Packet Gripper)
- Extend (Packet Shuttle Cylinder)
- Retract (Packet Shuttle Cylinder)
- Extend (Packet Pusher Cylinder)
- Retract (Packet Pusher Cylinder)
- Vacuum (Box Holder Vacuum)
- Blowoff (Box Holder Vacuum)
- Disable Vacuum (Box Holder Vacuum)

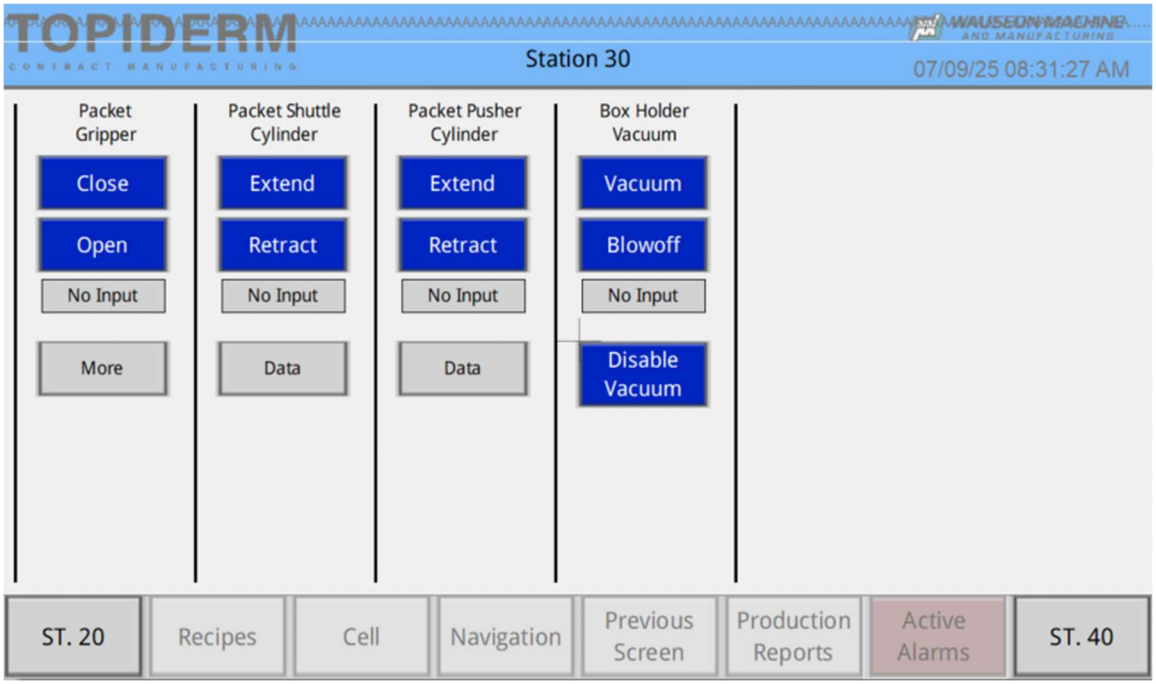

Figure 14: St.30 Manual Control Screen

St.30 Servo Gripper Screen

From this screen, the operator is able to view the following:

- Current Configuration
- Current Position
- Open Position (Set 50 Pack, Set 60 Pack)
- Close Position (Set 50 Pack, Set 60 Pack)
- Velocity (%) (Set 50 Pack, Set 60 Pack)
- Force (%) (Set 50 Pack, Set 60 Pack)

They can also perform the following manual commands:

- Jog to Close
- Close
- Open
- Home

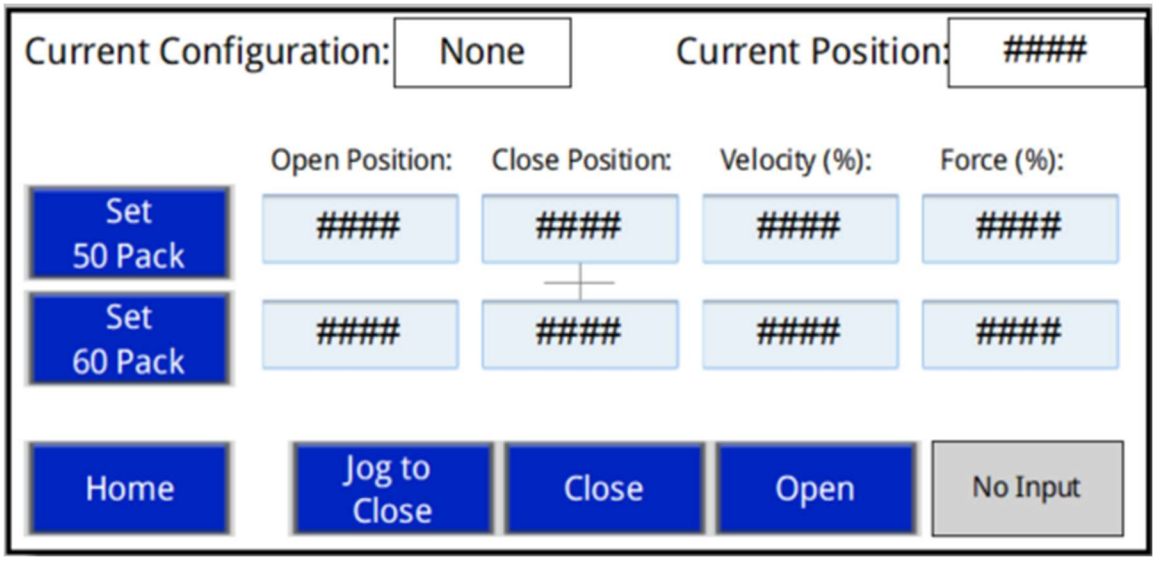

Figure 15: St.30 Servo Gripper Screen

St.40 Manual Control Screen Page 1

From this screen, the operator is able to manually perform the following:

- Close (Box Gripper)
- Open (Box Gripper)
- Vacuum (Box Holding Vacuum)
- Blowoff (Box Holding Vacuum)
- Disable Vacuum (Box Holding Vacuum)
- Raise (Weight Scale Cylinder)
- Lower (Weight Scale Cylinder)
- Box Close Advance
- Calibrate Scale (Last Box Weight (g))
- Next (Last Box Weight (g))
- Cancel (Last Box Weight(g))
- Reset (hold 3 sec) (Product Counts)

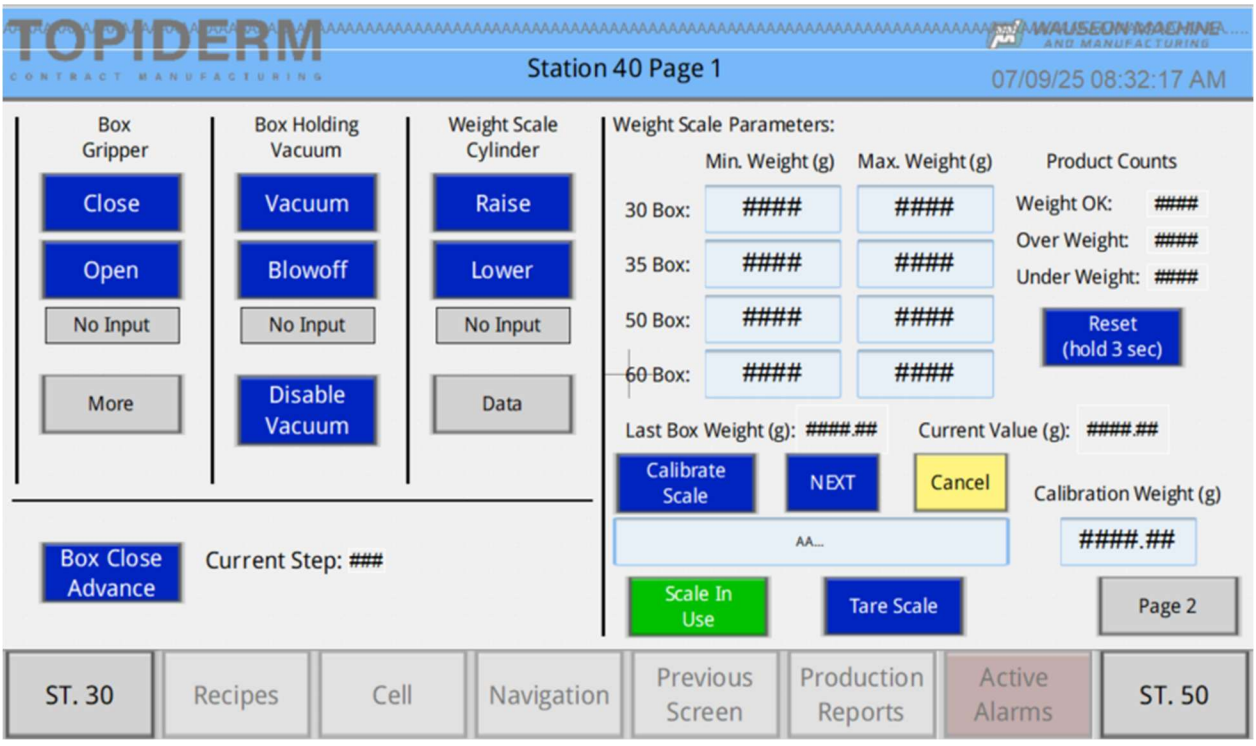

Figure 16: St.40 Manual Control Screen Page 1

St.40 Manual Control Screen Page 2

From this screen, the operator can manually control the following:

- Up (Tab Cylinders)
- Down (Tab Cylinders)
- In (Tab Cylinders)
- Out (Tab Cylinders)
- Extend (Lid Fold Shuttle Cylinder)
- Retract (Lip Fold Shuttle Cylinder)
- Extend (Lip Fold Cylinder)
- Retract (Lip Fold Cylinder)
- Vacuum (Lip Fold Vacuum)
- Blowoff (Lip Fold Vacuum)
- Disable Vacuum (Lip Fold Vacuum)
- Vacuum (Lip Fold 50/60 Vacuum)
- Blowoff (Lip Fold 50/60 Vacuum)
- Disable Vacuum (Lip Fold 50/60 Vacuum)
- Extend (Lid Tab Tuck Cylinder)
- Retract (Lid Tab Tuck Cylinder)

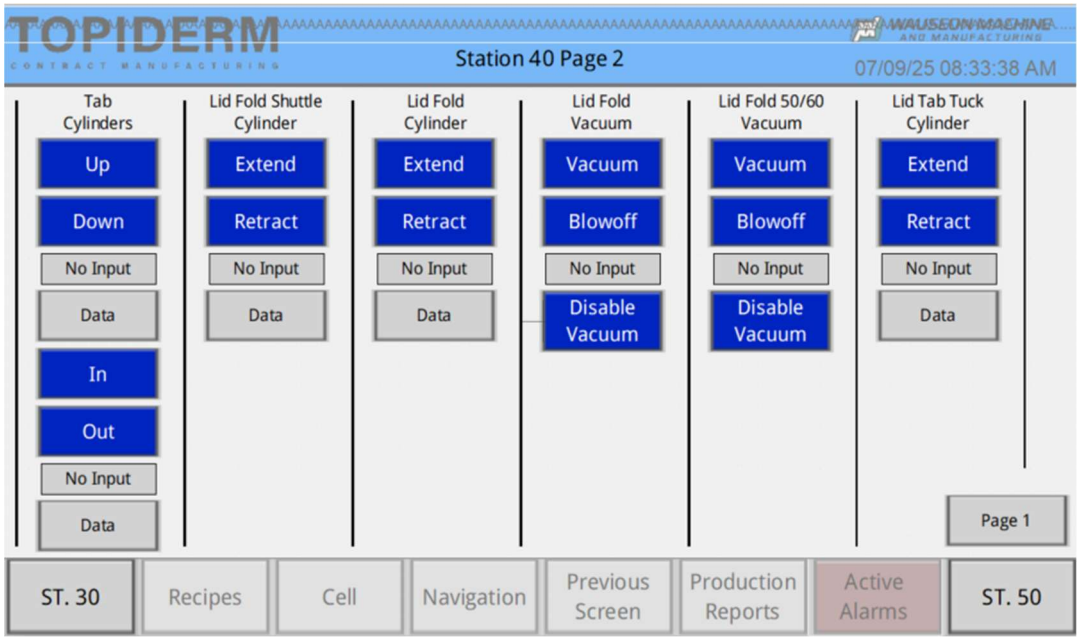

Figure 17: St.40 Manual Control Screen Page 2

St.40 Servo Gripper Screen

From this screen, the operator is able to view the following:

- Current Configuration
- Current Position
- Open Position (Set 30 Box, Set 35, Set 50 Box, Set 60 Box)
- Close Position (Set 30 Box, Set 35, Set 50 Box, Set 60 Box)
- Velocity (%) (Set 30 Box, Set 35, Set 50 Box, Set 60 Box)
- Force (%) (Set 30 Box, Set 35, Set 50 Box, Set 60 Box)
- Open Position (Set 30 Box, Set 35, Set 50 Box, Set 60 Box)
- Velocity (%) (Set 30 Box, Set 35, Set 50 Box, Set 60 Box)
- Force (%)(Set 30 Box, Set 35, Set 50 Box, Set 60 Box)

They can also perform the following manual commands:

- Jog to Close
- Close
- Open
- Home

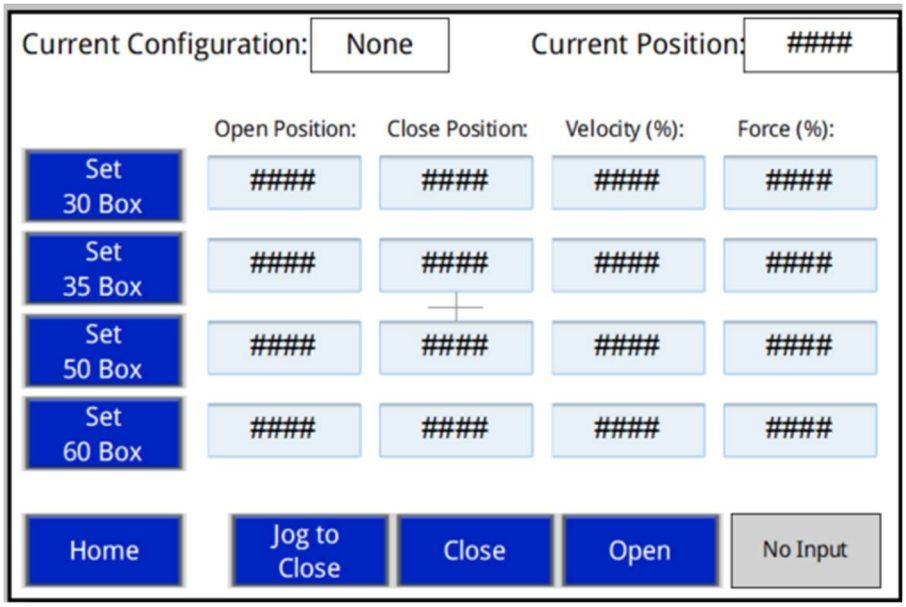

Figure 18: St. 40 Servo Gripper Screen

St.50 Screen

This screen lets the operator perform the following:

- FWD (Outfeed Control)
- Start (Outfeed Control)
- Stop (Outfeed Control)

They can also view the following via the indicators:

- Running
- Faulted
- Box on Conveyor
- Printer in Use

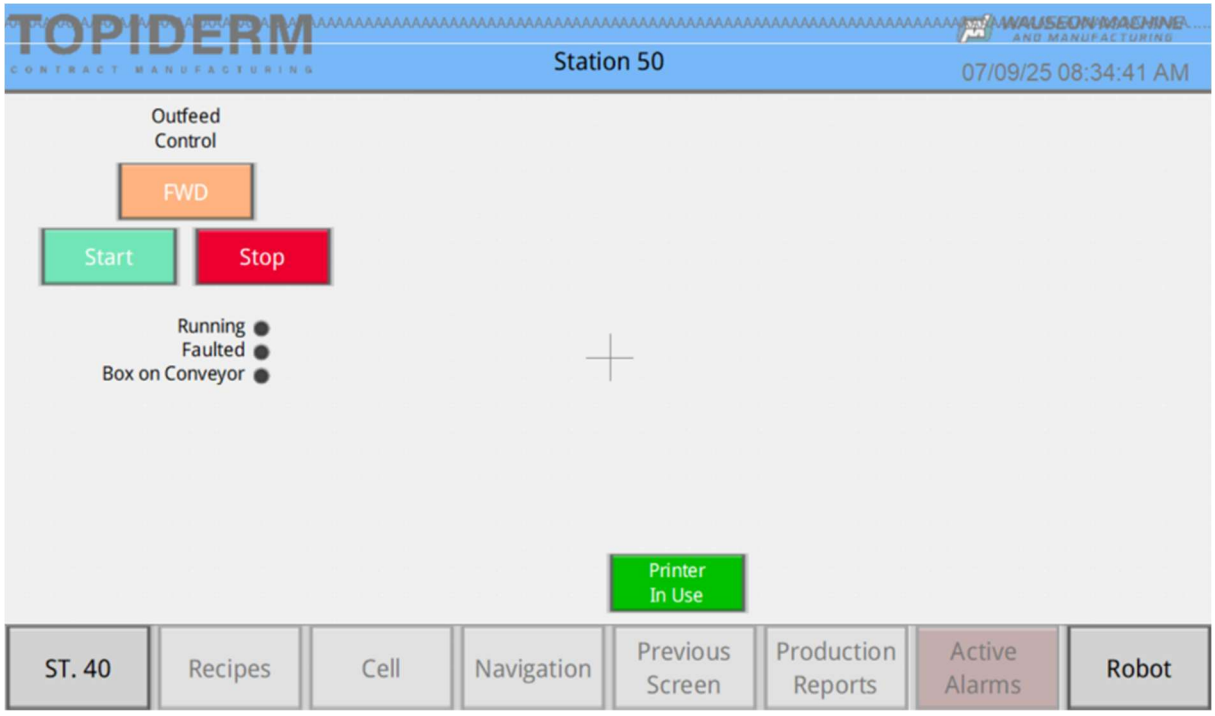

Figure 19: St. 50 Screen

Active Alarms Screen

From this screen, the operator is able to view any alarms that are currently active. The following information is provided:

- **Trigger Date** – reflects the date that the alarm activated
- **Trigger Time** – reflects the precise time the alarm activated
- **Message** – describes the reason the alarm was activated

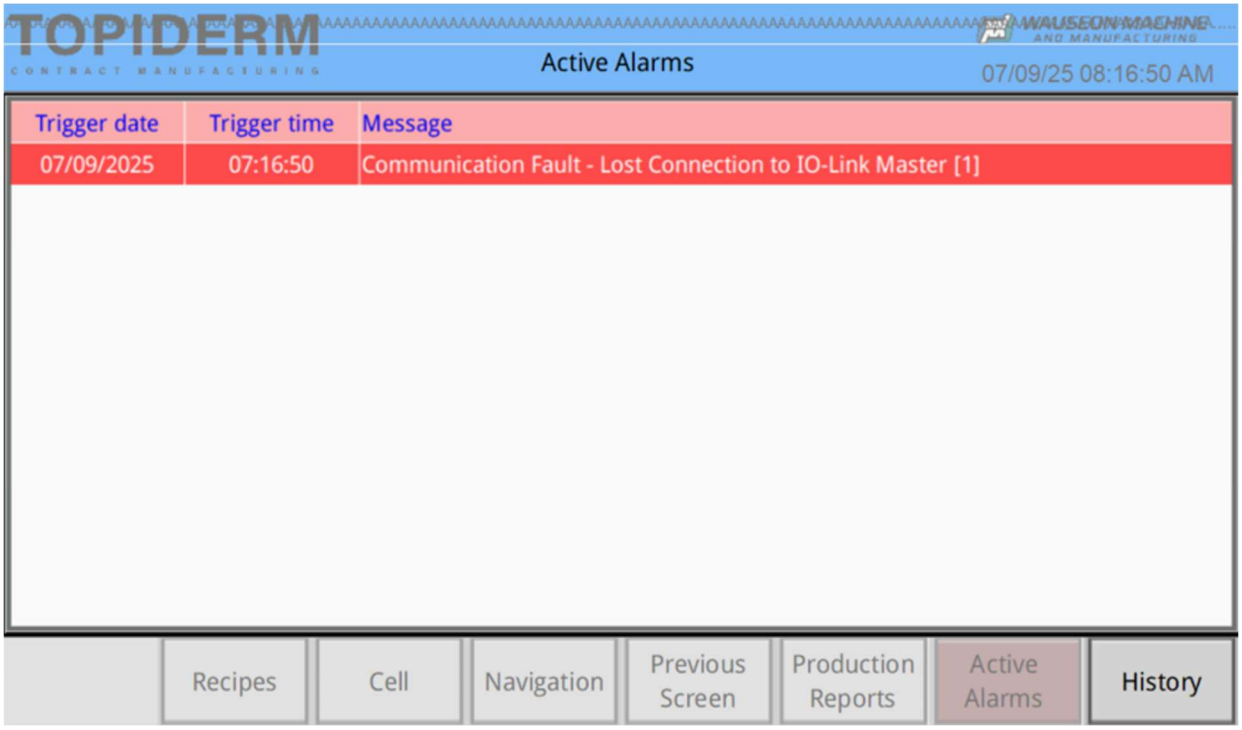

Figure 20: Active Alarms Screen

Alarm History Screen

From this screen, the operator is able to view any previous alarms which were activated. The following information is provided:

- **Trigger Date** – reflects the date that the alarm activated
- **Trigger Time** – reflects the precise time the alarm activated
- **Message** – describes the reason the alarm was activated

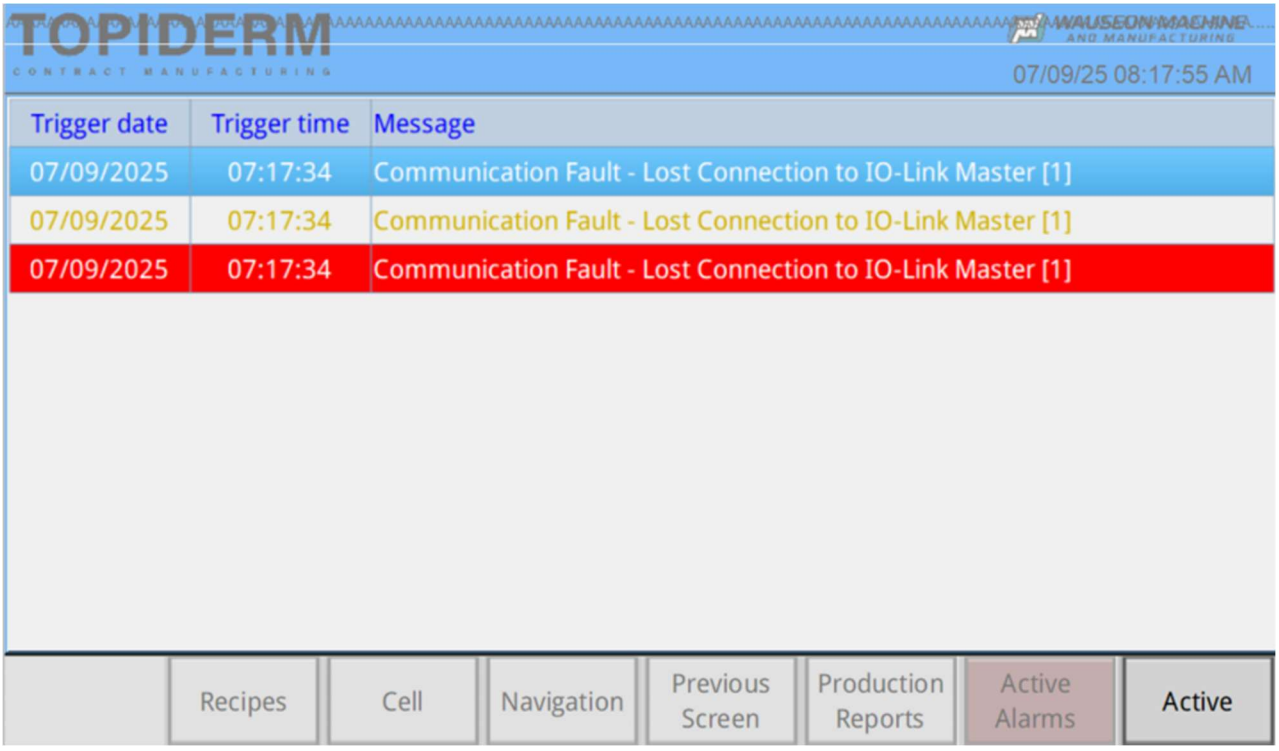

Figure 21: Alarm History Screen

Enter Shift Start Times Screen

From this screen, the operator can enter the start times for shifts A,B, and C.

***Note: Times should be entered in 24 hour clock format. (e.g. 5:00PM should be entered as 1700)**

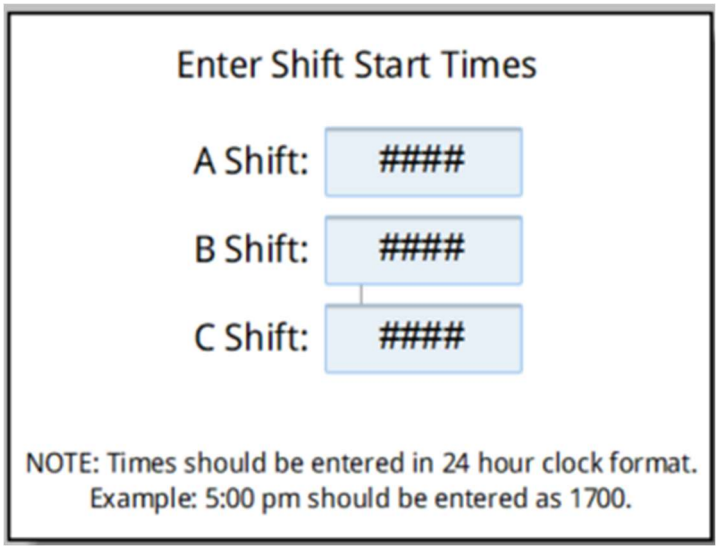

Figure 22: Enter Shift Start Times Screen

IO Screen Page 1

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

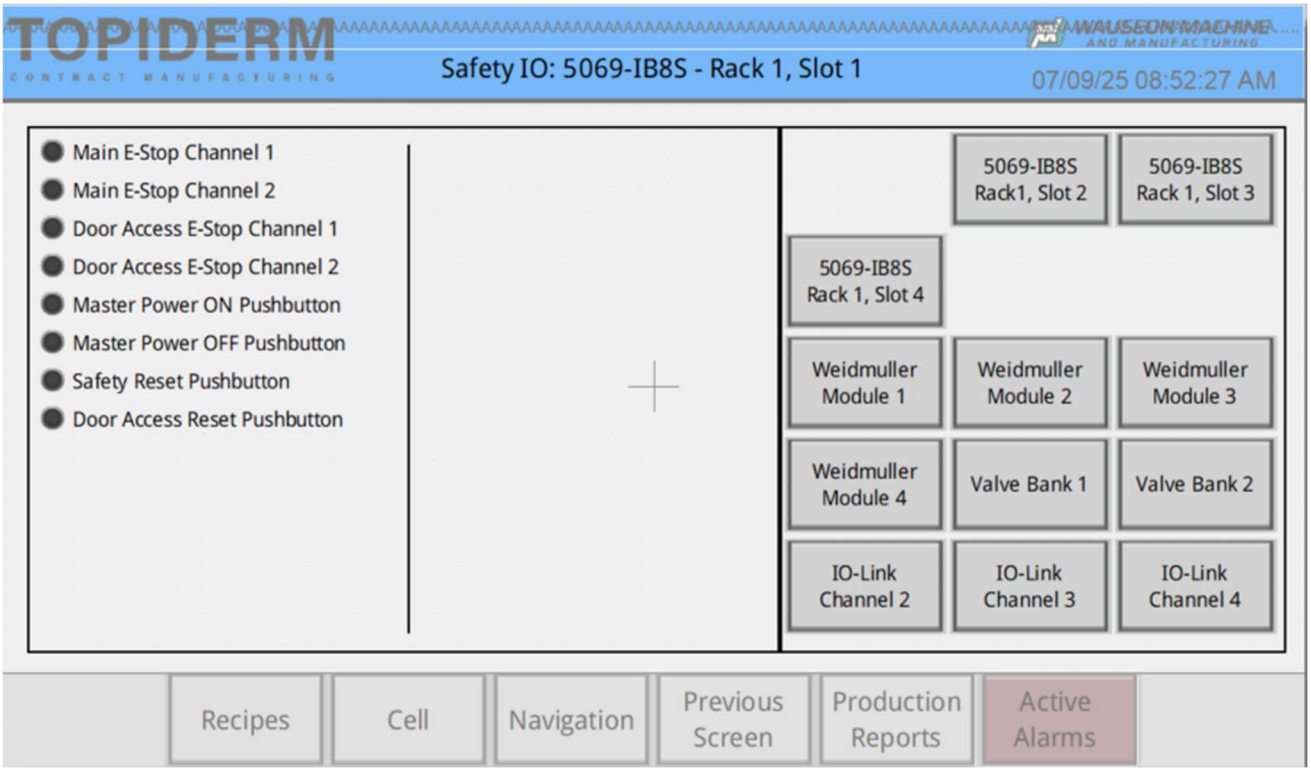

Figure 23: IO Screen Page 1

IO Screen Page 2

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

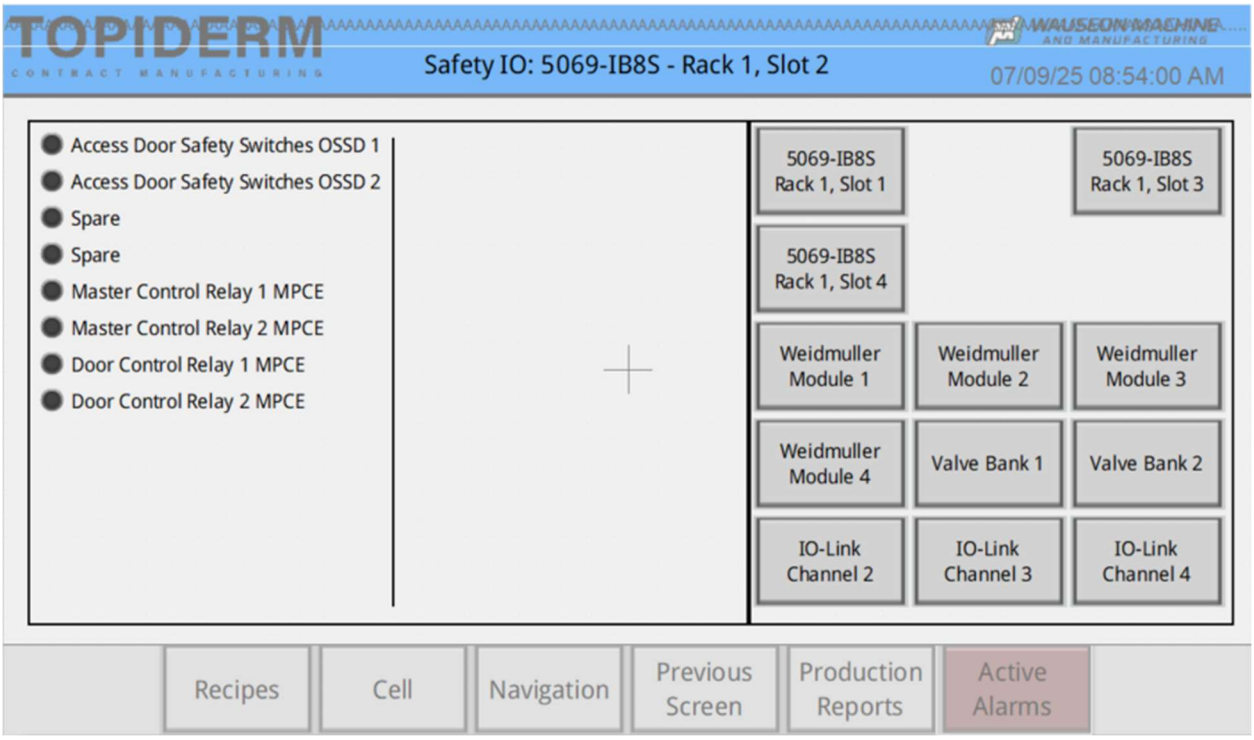

Figure 24: IO Screen Page 2

IO Screen Page 3

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

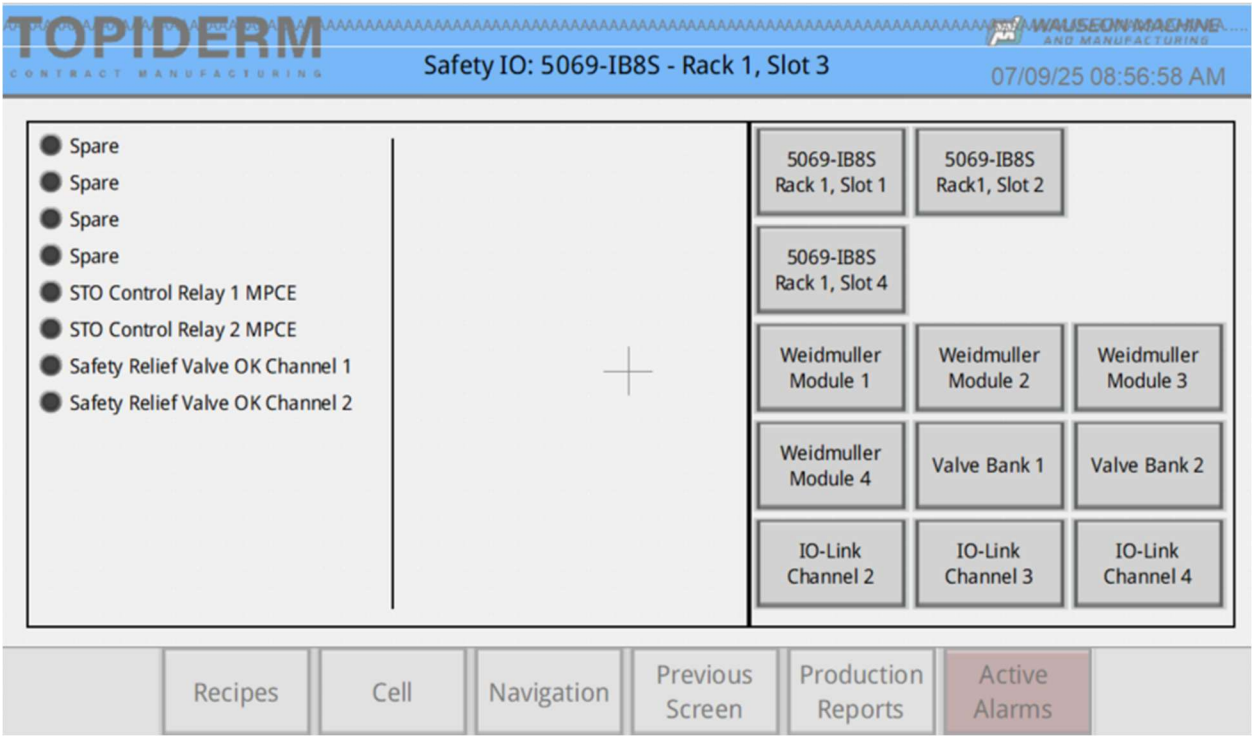

Figure 25: IO Screen Page 3

IO Screen Page 4

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

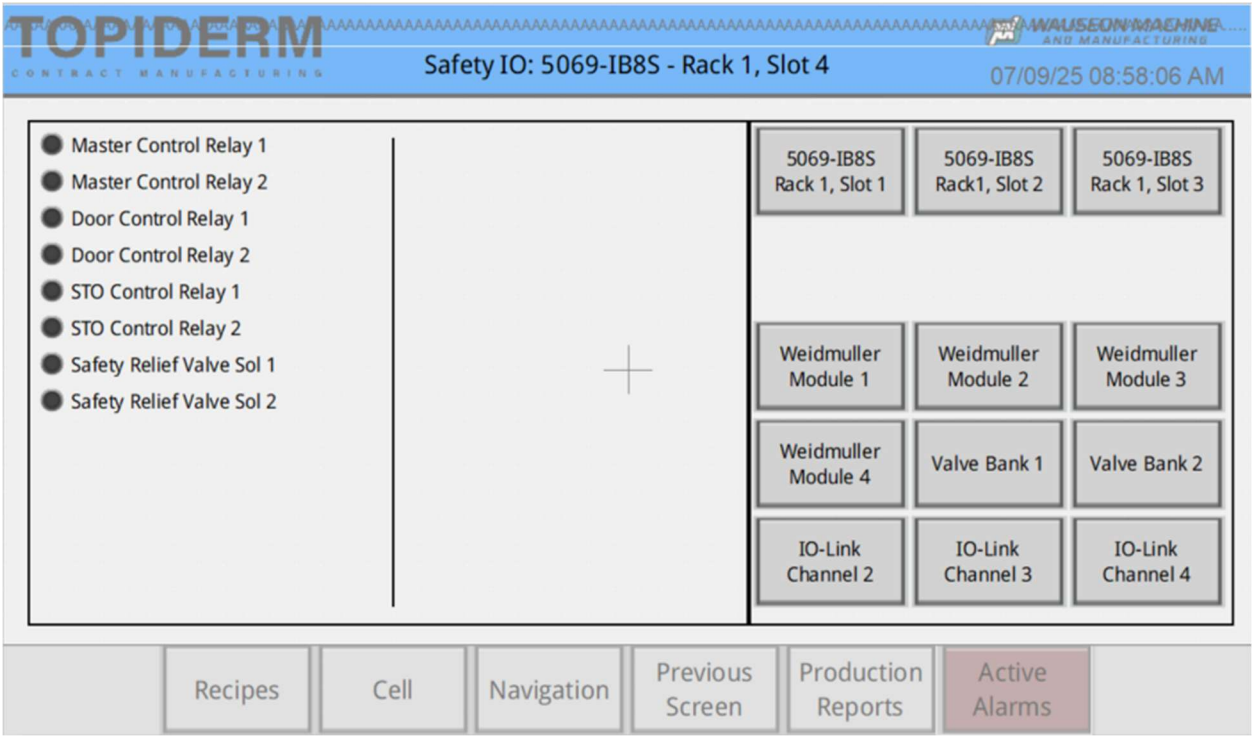

Figure 26: IO Screen Page 4

IO Screen Page 5

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

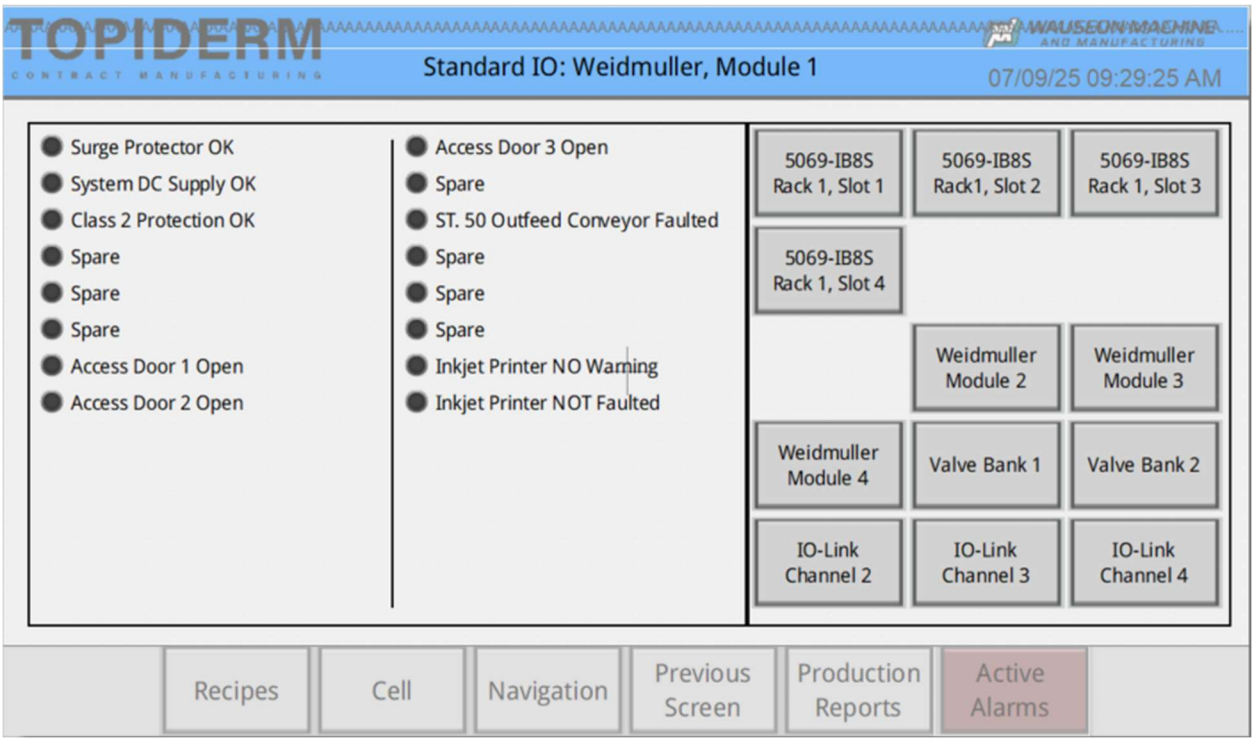

Figure 27: IO Screen Page 5

IO Screen Page 6

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

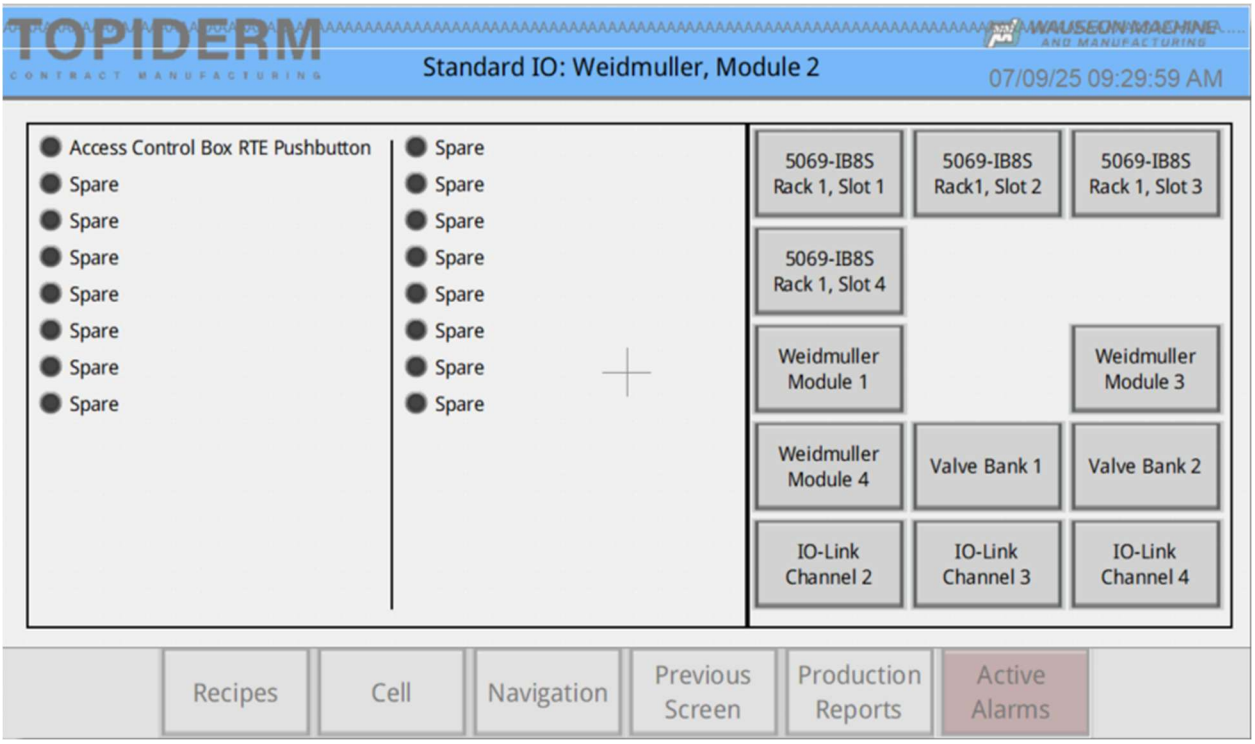

Figure 28: IO Screen Page 6

IO Screen Page 7

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

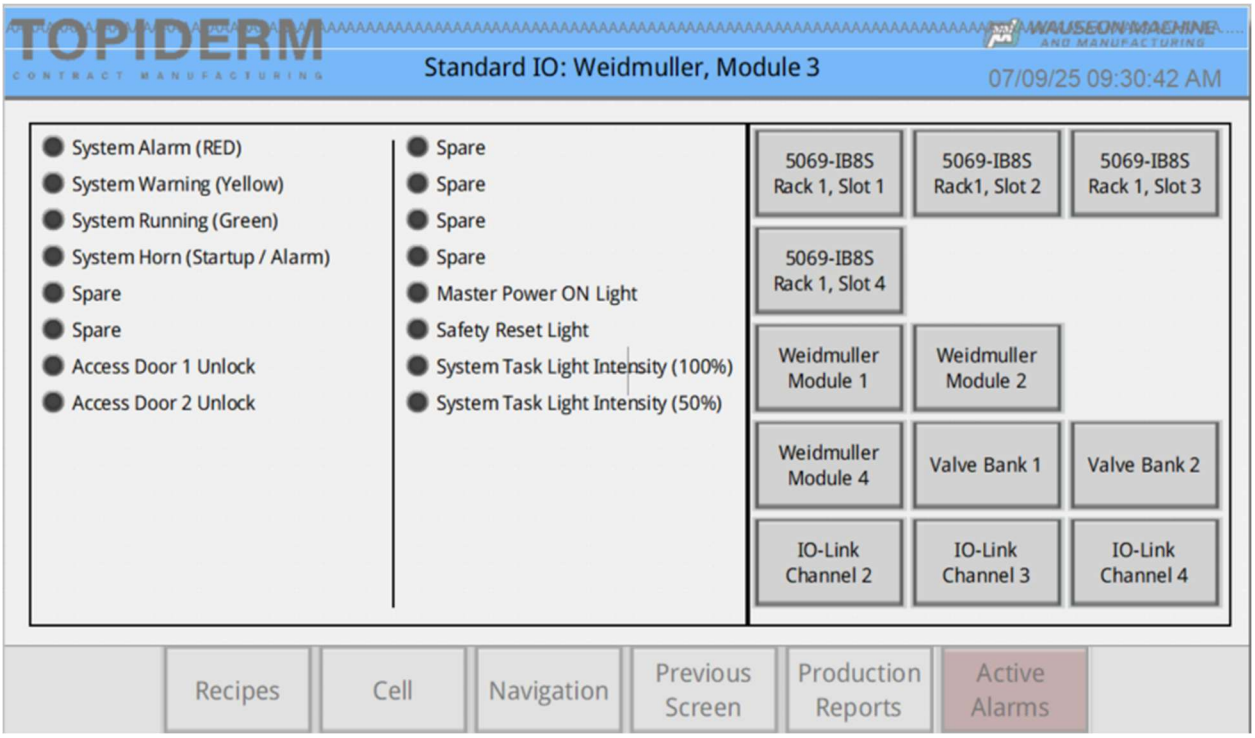

Figure 29: IO Screen Page 7

IO Screen Page 8

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

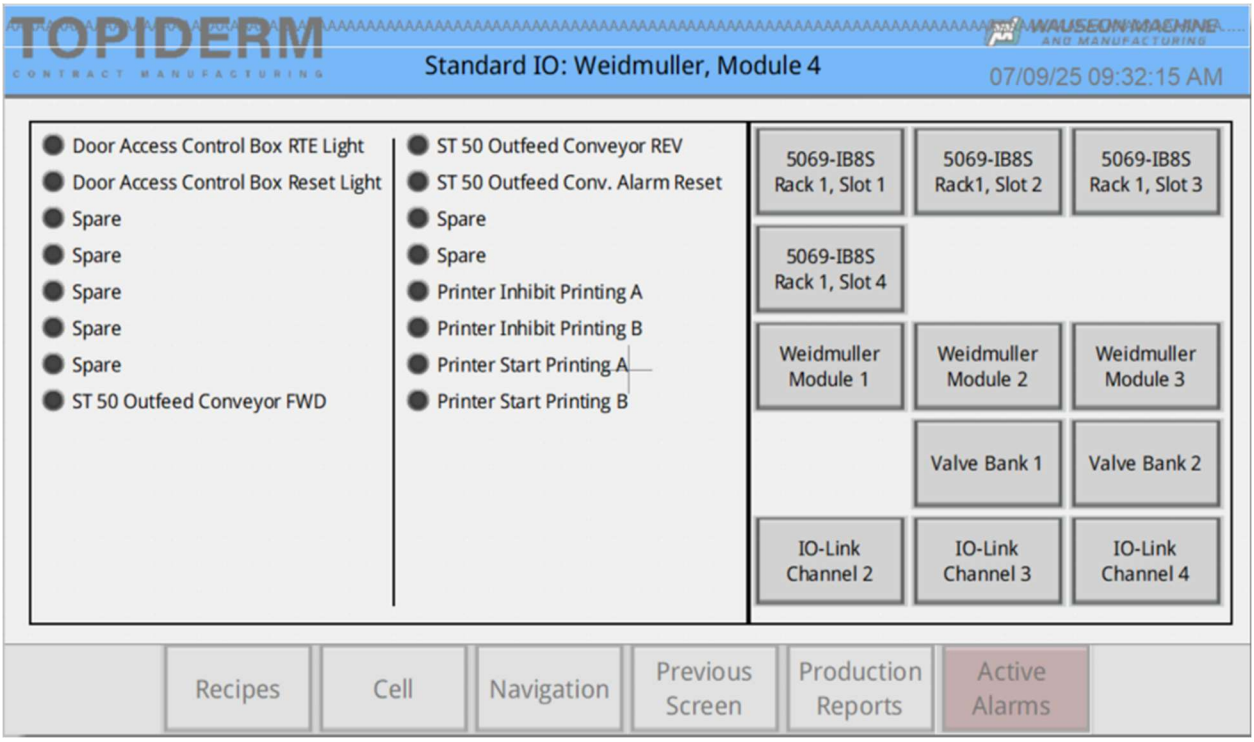

Figure 30: IO Screen Page 8

IO Screen Page 9

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

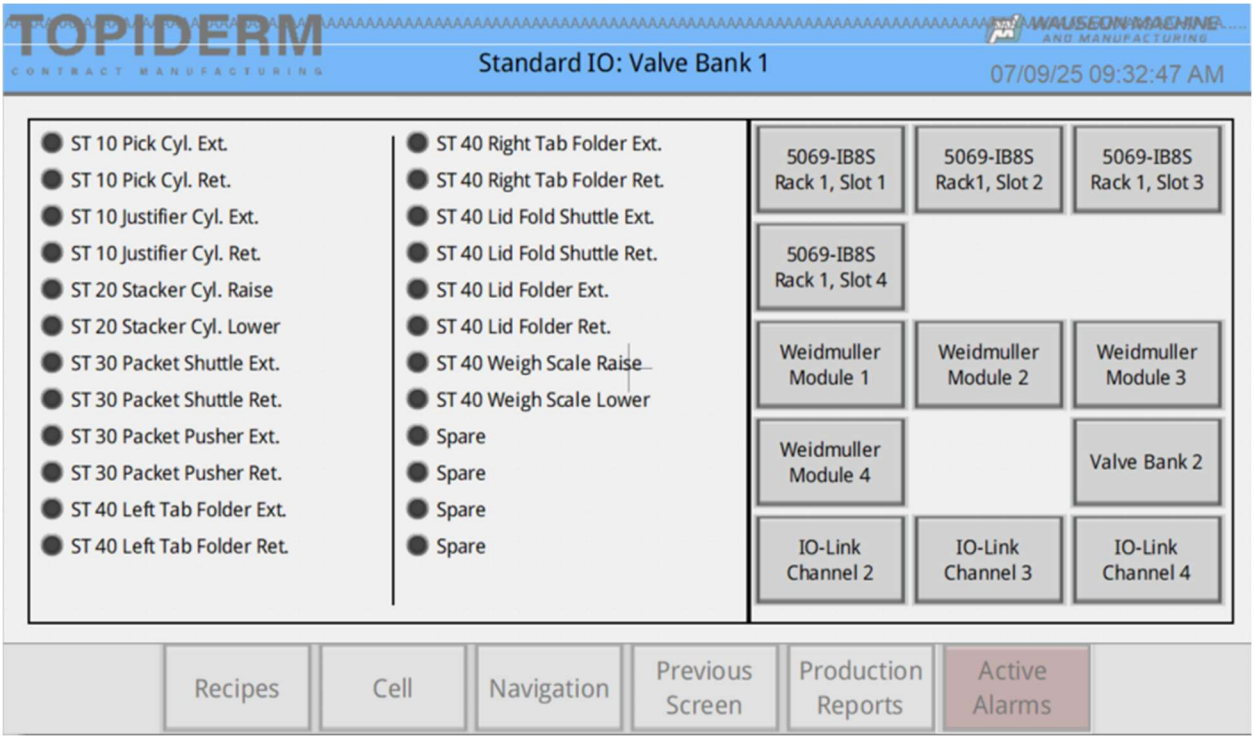

Figure 31: IO Screen Page 9

IO Screen Page 10

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

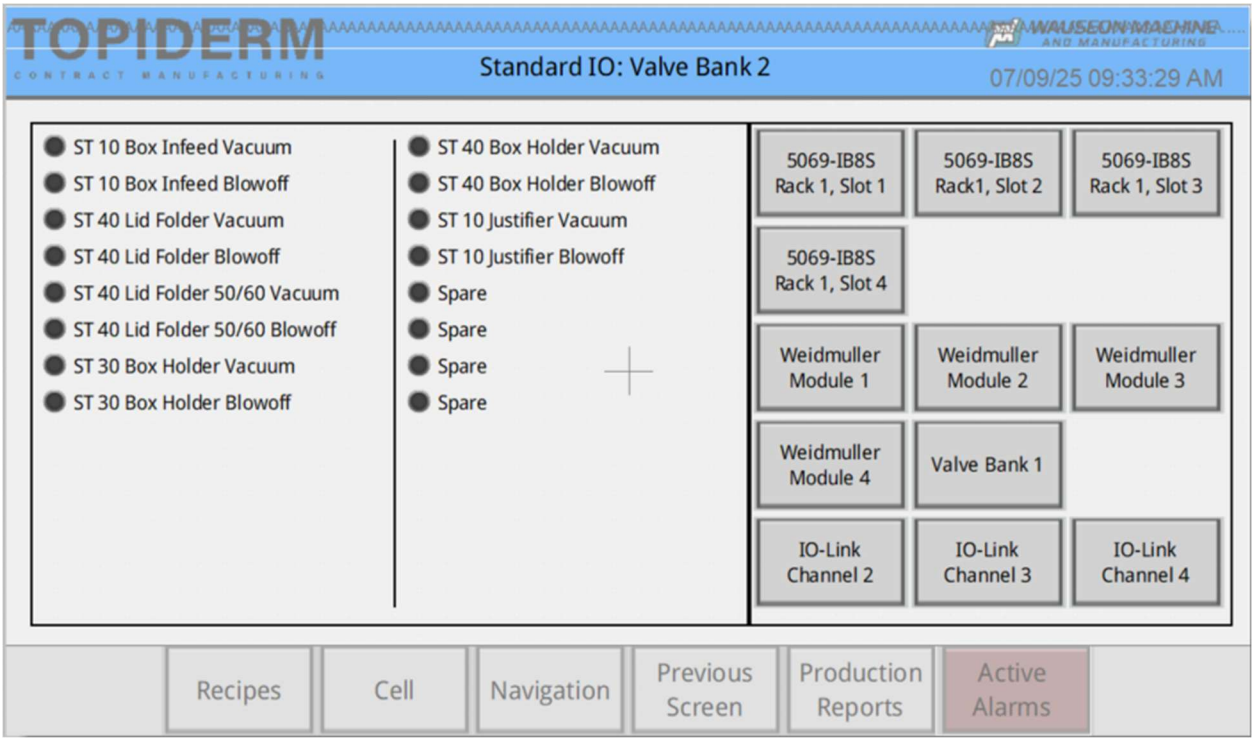

Figure 32: IO Screen Page 10

IO Screen Page 11

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

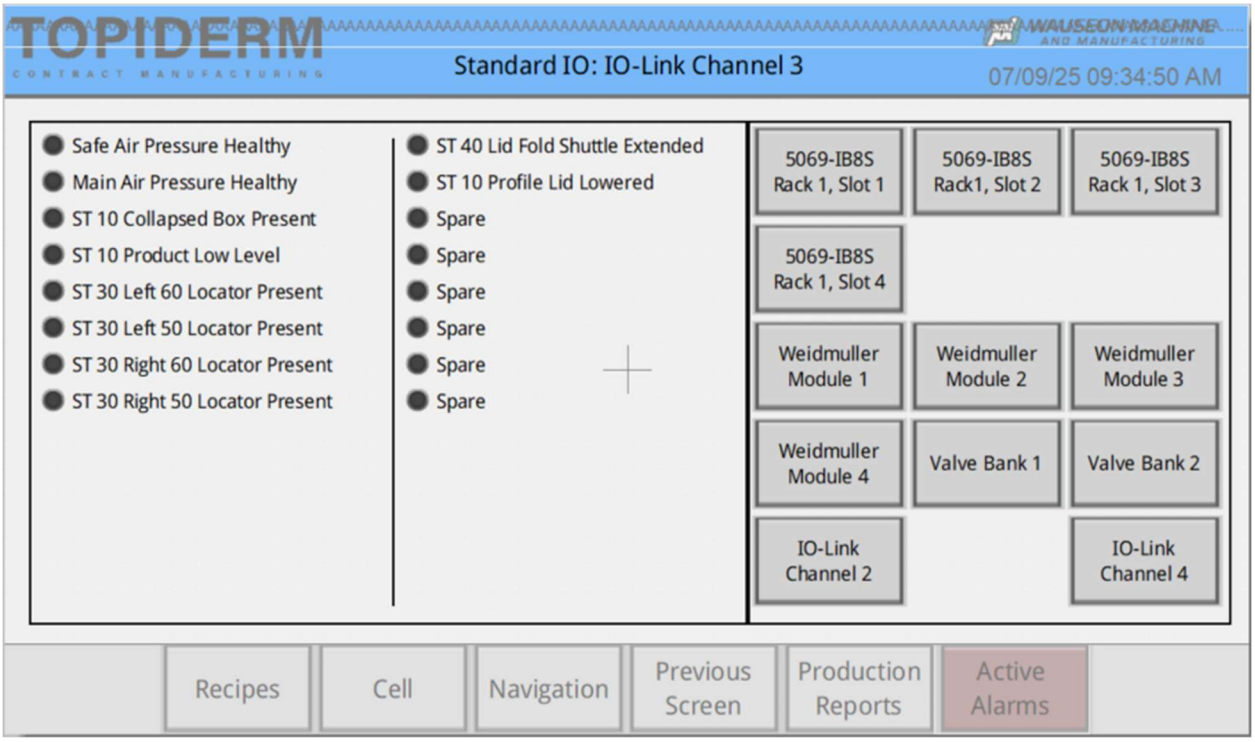

Figure 33: IO Screen Page 11

IO Screen Page 12

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

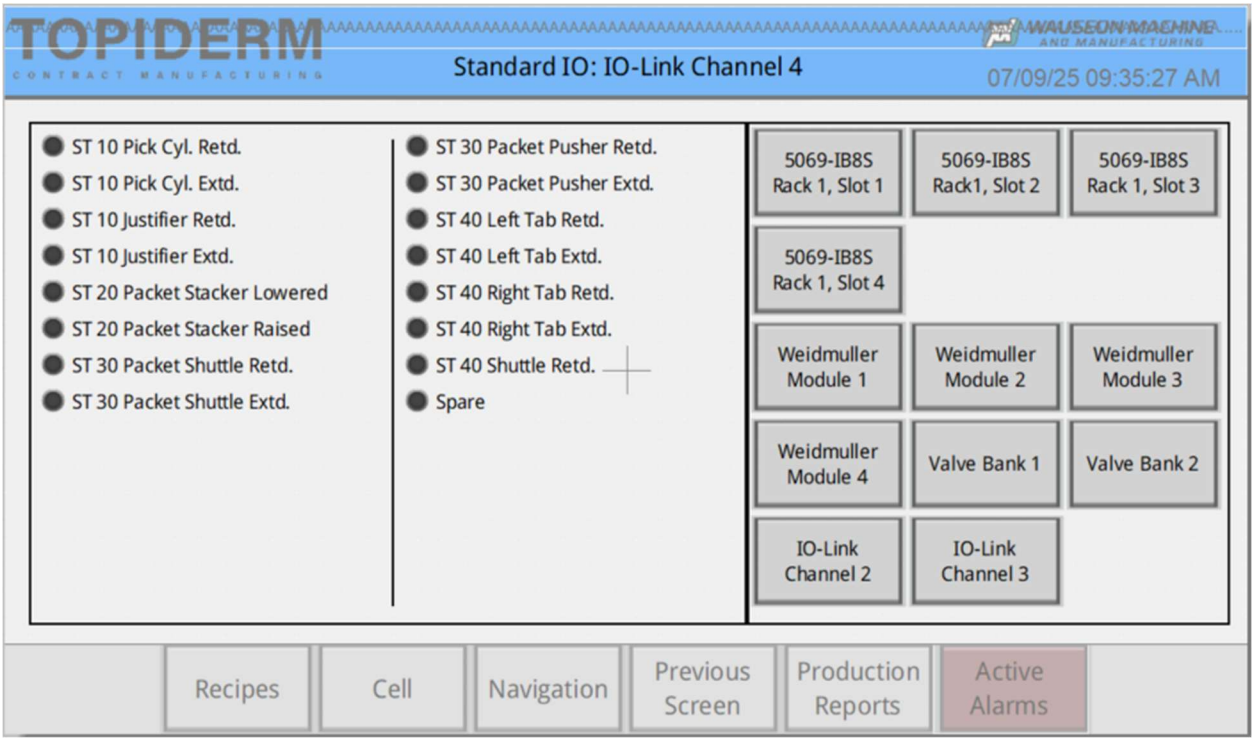

Figure 34: IO Screen Page 12

IO Screen Page 13

From this screen, the operator can view which items are **active/inactive** in each area by selecting one of the icons on the right side of the screen. If an item is **active**, the circle next to it will become green.

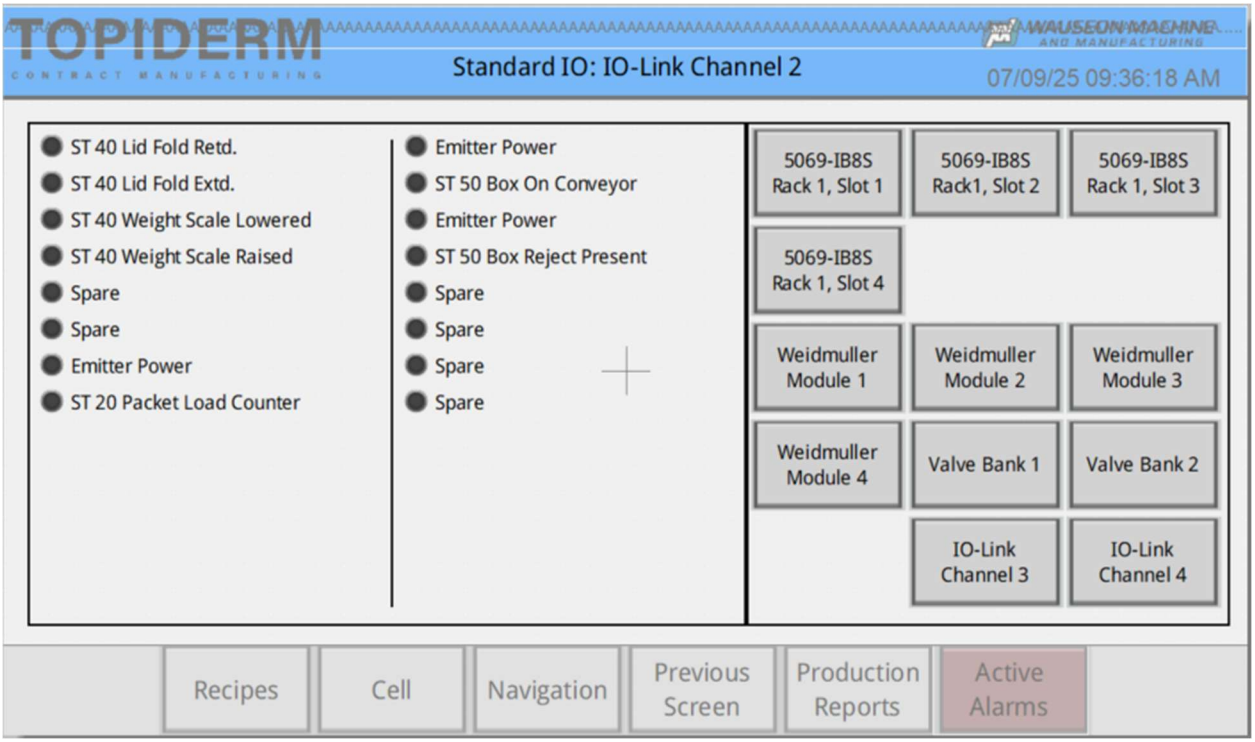

Figure 35: IO Screen Page 13