AutoTripper™ Start-up Check List

1. Insert a Cam Diskette.
2. Turn the controller switch On (clockwise).
3. Wait for the controller to initialize and the Main Menu to appear, as shown below. This takes up to 40 seconds.

```
Part Cycle Name
>Run Part Cycle
 EDIT Tool AutoAdjs
 LOAD Part Cycle
```

4. Select *RUN Part Cycle*.
5. Locate the turret slide. Press the AUTO key until the yellow light on the front of the controller goes off.
6. Locate the camshaft. Jog or hand-crank the camshaft until the display changes.
7. Locate the spindle clutch.
8. Locate the bar feeder (if in *Chucker Mode*).
9. Locate the tool turret.
10. Put the controller on-cam. Press the AUTO key until the green light illuminates.
11. The screw machine is now ready for normal operation.

Enabling and Disabling AutoTripper™ Trippers

Bar Feeder Tripper

Turning the Bar Feeder AutoTripper™ switch *OFF* disables bar feeding. Turning it to *AUTO* puts feeding under AutoTripper™ control.

All Trippers

1. At the Main Menu, select *DIS/ENABLE Trippers* and press ENTER. The following will be displayed:

```
All Trippers
>    Enable
     Disable
```

2. Select *Enable* or *Disable*, then press ENTER.

Locating the Spindle Clutch

If the spindle clutch is not properly located for the desired speed (as indicated on the ServoCam® controller display), then *manually trip the spindle clutch trip switch and turn the backshaft to reposition the spindle clutch*.

Locating the Bar Feeder (Chucker Mode only)

When the bar feeder is in Chucker Mode, the collet needs to be located to either the open or closed position, as appropriate.

If the bar feed mechanism is not properly located to the desired position (as indicated on the ServoCam® controller display), then *manually trip the bar feeder trip lever and turn the backshaft to reposition it.*

Locating the Tool Turret

If the tool turret is not properly located for the desired tool (as indicated on the ServoCam® controller display), then *manually reposition the tool turret to the correct tool*.

Displaying the Summary Run Screen with AutoTripper™ Option

After selecting *RUN Part Cycle* from the Main Menu, the *Summary Run Screen* will appear on the display:

```
CS 32.4
SS=H FD#O T=1
LOT 10000  200:59:59
BAR    17    0:21:34
```

Line 1: `CS 32.4`

where:

`CS 32.4`	Camshaft position (hundredths)

Line 2: `SS=H FD#O T=1`

where:

`SS=H`	Spindle speed	
	H	High
	L	Low
	2	Speed 2
	3	Speed 3
	4	Speed 4
`FD#O`	Bar Feeder	
	O	Open (Chucker mode)
	C	Closed (Chucker mode)
	F	Feeding (Feeder mode)
	_	Idle (Feeder mode)
`T=1`	Tool turret station	
	1	Tool station #1
and where:	=	Tripper *enabled*
	#	Tripper *disabled*
	?	Tripper changing state (jog to finish) or state unknown (no trips defined).

Line 3: `LOT 10000  200:59:59`

See *"Part Counter Basics"* on ServoCam® Quick Reference Guide for description.

Line 4: `BAR    17    0:21:34`

See *"Part Counter Basics"* on the next page for description.

Part Counter Basics

Part-done detector

See ServoCam® Quick Reference Guide.

Lot counter

See ServoCam® Quick Reference Guide.

Bar-end counter (see "*Setting the Bar-end Counter*")

The ServoCam® system increments the *#Parts Done* (in Bar-end) every time a part is done -- if the Bar Feeder Switch is set to *Auto* and if the bar-end has passed the "bar-end switch".

If the *#Parts/Bar-end* (Bar-end size) is set to UNLIMITED, then the ServoCam® display shows:

```
BAR unlimited
```

If the *#Parts/Bar-end* (Bar-end size) is set to a value other than UNLIMITED, then the ServoCam® display counts *down* the number of parts and time remaining (hh:mm:ss) until the Bar-end is consumed, for example:

```
BAR    17    0:21:34
```

When the Bar-end is consumed (*#Parts Done* equals *#Parts/Bar-end*), then the ServoCam® system will stop the machine, flash the Operator Alert Light, and the display will show "BAR finished". To stop the Operator Alert Light, escape to the Main Menu. The Bar-end counter will reset when the *DRIVESHAFT START* button is next pressed.

If the bar-end has not passed the "bar-end switch", then the bar is *long*, and the ServoCam® display shows, for example:

```
BAR long (20+)
```

If the Bar Feeder Switch is NOT set to *Auto*, then the *#Parts Done* (in Bar-end) is not incremented, and the display will show "NC" on the right-hand side for *not counting*.

Note: The term "bar-end" is used here to mean the portion of the bar remaining after the bar-end switch activates (enough for multiple parts).

Setting the Bar-end Counter

To change the *#Parts/Bar-end* (bar-end size):

1. At the Main Menu, select *Part Counter Menu* and press ENTER .
2. Select *Bar-end Counter* and press ENTER .
3. Select *#Parts/Bar-end:* and press ENTER .
4. Type the number of parts per bar-end and press ENTER , or press ESC to cancel.

To change the *#Parts Done* (number of parts already done out of the bar-end):

1. At the Main Menu, select *Part Counter Menu* and press ENTER .
2. Select *Bar-End Counter* and press ENTER .
3. Select *#Parts Done:* and press ENTER .
4. Type the number of parts already done out of the bar end, and press ENTER , or press ESC to cancel.