

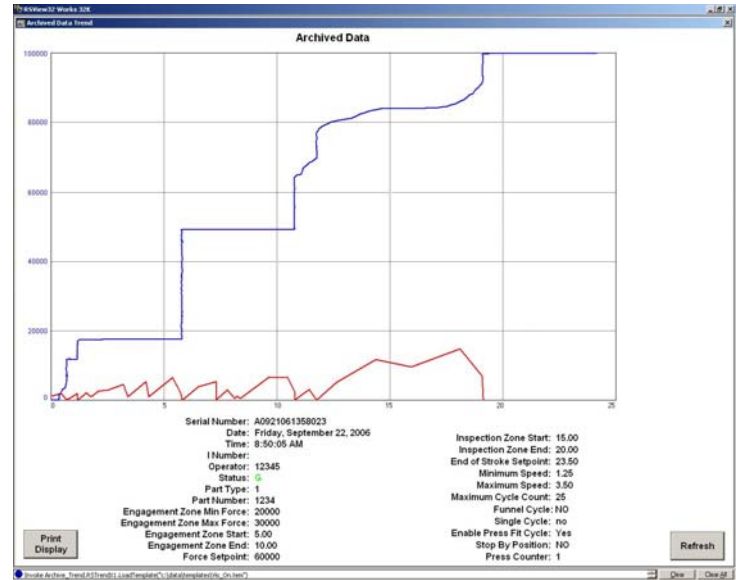
# Press Force Monitoring Quality Control System



Fenton Systems hydraulic press quality monitoring system records process data for historical parts tracking purposes. The data recorded is shown on the screen at the right. This data is shown in real time as the process proceeds and can be retrieved in the future to view the process history for a particular serial number or key parameter pertinent to your process.

The information is retrieved base on serial number that can be entered via the keyboard or by scanning the bar code using the scanner supplied.

A means is provided to calibrate transducers. In the case of force, a screen similar to the one below is used to setup and calibrate the force load cell interface.



For each part number the press can run, a set of parameters can be supplied. The parameters are shown on the screen below. These parameters define force limits and velocity limits based on test zones along the force signature.

Scale Parameters	
<b>Force:</b> 11548	
<b>Read Parameters:</b>	<b>Write Parameters:</b>
Channel Active: 1	Channel Active: 1
Metric: 0	Metric: 0
Waversaver: 2	Waversaver: 2
NumAverages: 20	NumAverages: 20
ZeroTrackEnable: 0	ZeroTrackEnable: 0
Unused0: 0	Unused0: 0
AutoZeroTol: 10	AutoZeroTol: 10
MotionTol: 5	MotionTol: 5
Zero Tol: 10	Zero Tol: 10
Unused1: 0	Unused1: 0
Unused2: 0	Unused2: 0
TareWeight: 25	TareWeight: 25
SpanWeight: 100000	SpanWeight: 100000
CalLowWeight: 0	CalLowWeight: 0
ZeroCount: 1072607	ZeroCount: 0
CalZeroCount: 1072607	CalZeroCount: 0
CalHighCount: 1072607	CalHighCount: 0
CalLowCount: 2548813	CalLowCount: 0

The system prints bar codes for each part processed containing a serial number and part number and good/bad status of the part.

Part Number Maintenance	
Part Type:	1
Part Number:	1234
Engagement Zone Min Force:	20000
Engagement Zone Max Force:	30000
Engagement Zone Start:	5.00
Engagement Zone End:	10.00
Force Setpoint:	60000
Inspection Zone Start:	15.00
Inspection Zone End:	20.00
End of Stroke Setpoint:	23.50
Minimum Speed:	1.25
Maximum Speed:	3.50
Maximum Cycle Count:	25
Funnel Cycle:	NO
Single Cycle:	Yes
Enable Press Fit Cycle:	No
Stop By Position:	NO
Press Counter:	1