

Applications

Manufacturing with Electric Clutch, Pneumatic Clutch with Signal Ports and DC Control Tools

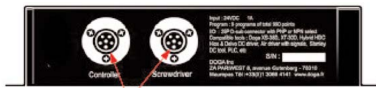
Key Features

Error Proof Assembly Process	99 Programable Points w/ 9 Sequence Programs
Programmable Sequence Operation	Prevent RMI and CTS
Detect cross threading, omissions, unfinished fasteners and cycle complete	Operates with most DC Control System, Electric and Pneumatic Clutch Tools
Quick and Easy setup with Self Teach Mode	Customize programmable parameters
Available up to 100 Nm	25 pin Sub-D Input / Output for PLC communication

Modes

Operation	Working mode
Login	Allow access to Program, Parameter and Edit Modes
Program	Automatic and Manual programming on sequence programs
Parameter	Customize programmable parameter settings
Edit	Edit points and values in a sequence program

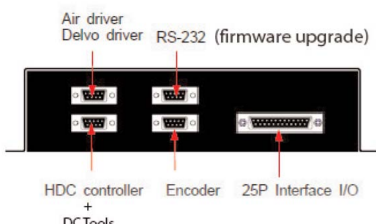
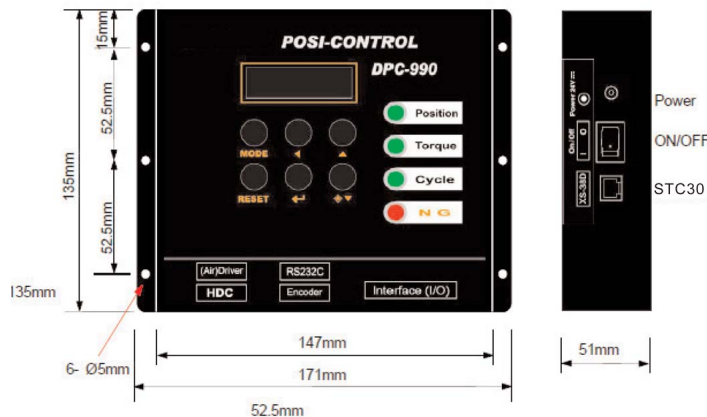
Control Unit



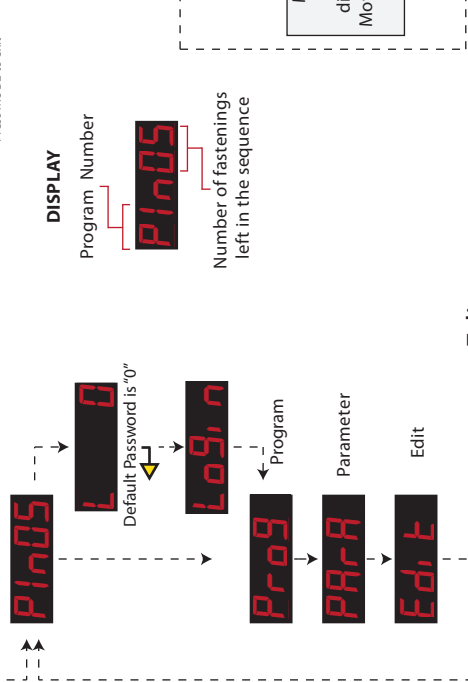
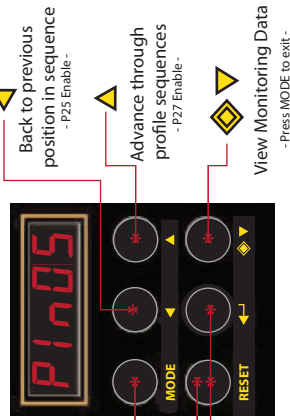
Hiros controller & driver

Important Notes

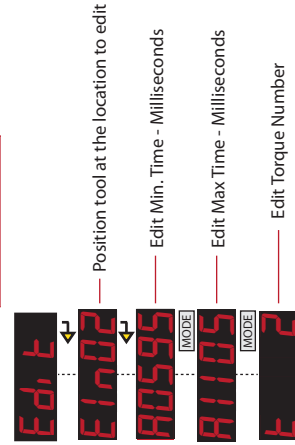
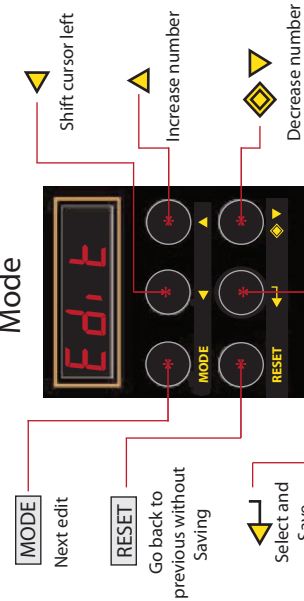
- Parameter 16 must be set to the tool type used for proper communication - see parameter settings.
- Auto Program Mode measures the fastening time per sequence location to set timing parameters to determine an acceptable rundown. This is for non-DC controlled tools. Parameters are editable
- DC Controlled tools including the Hybrid Tools are set up using the Manual Program function which utilizes the digital I/O communication to determine an acceptable rundown. Torque strategies are selected during the programing process.
- Password protected with programmable number of attempts to refasten a NG rundown.
- Audio and visual alerts are fully programmable.



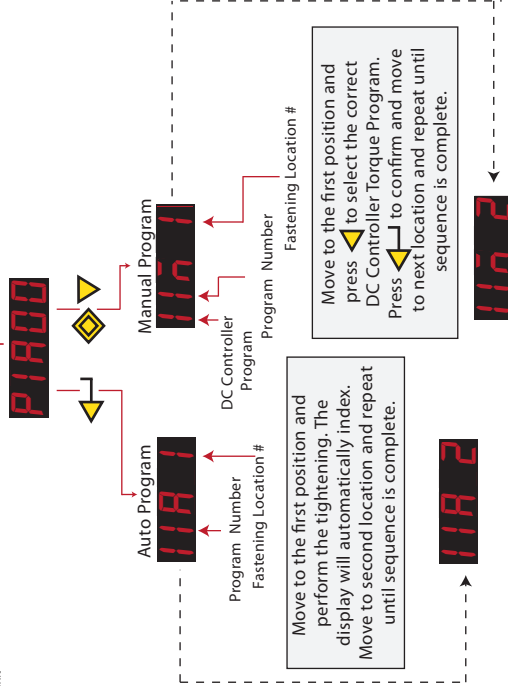
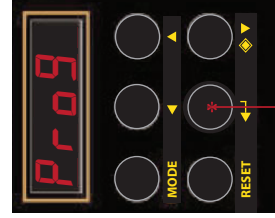
Operation Mode



Edit Mode

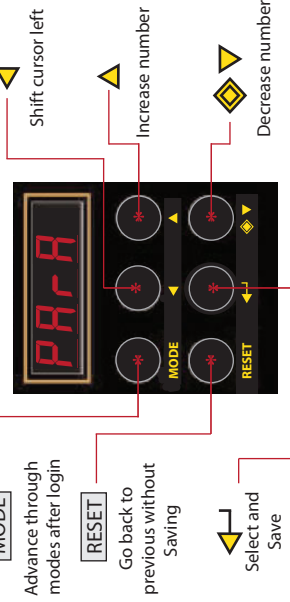


Program Mode



SAVE

Parameter Mode



P #	Name	Specification	Default
P16	Tool select	Select the connected tool 1 : Hybrid HDC controller 2 : Stanley & Other DC Tools 3 : STC30 (4.2 or prior) signal port 4 : Hfos 5 : Air driver with Start trigger signal + motor RUN signal 6 : Delvo & Other low voltage Electric Tools 7 : STC30 v4.3 or STC40	1
P19	MIN fastening time percentage	Percentage (%) from fastening time for Auto programming 0 - 100 (%) "0": No use	50
P20	MAX fastening time	Percentage (%) from fastening time for Auto programming 100 -200 (%) "0": No use	130
P21	Cycle reset by I/O	Cycle reset by I/O Disable : 0 Enable : 1	1
P22	Number of refastening	Number of refastening on a position 1 - 9	1
P23	Refastening Enable	Refastening enable Disable : 0 Enable : 1	1
P24	Skip a position	Skip one position declared NG to the next one without refastening Disable : 0 Enable : 1	0
P25	Back to previous	Back to previous position by < button Disable : 0 Enable : 1 Note : P23 must be 0 (disable)	1
P26	Reset button on front panel	Reset button front panel for (J) Reset 2) Cycle reset (Reset + Enter) Disable : 0 Enable : 1	1
P27	Program select on front panel	Program select by < button Disable : 0 Enable : 1	1
P28	NG signal output time duration	Time duration setting of NG output signal. 0.1 - 2.0 seconds Input to Controller	1
P51	Password	Pin # Configuration Password for Log in can be Changed 0 - 9999	0
P52	Parameter Initialize	Every parameter change to the factory initial setting Key in "77" and press Enter for initializing .	0
Error	Error Description	Solution	
101	Fastening time is lower than Min. Value	Pattern error / Reset	
102	Fastening time is over than Max. Value	Pattern error / Reset	
103	Error signal from external tool	Auto Reset without signal	
200	Parameter Read Error	System error / Reset	
201	Check sum error	Com error / Reset	