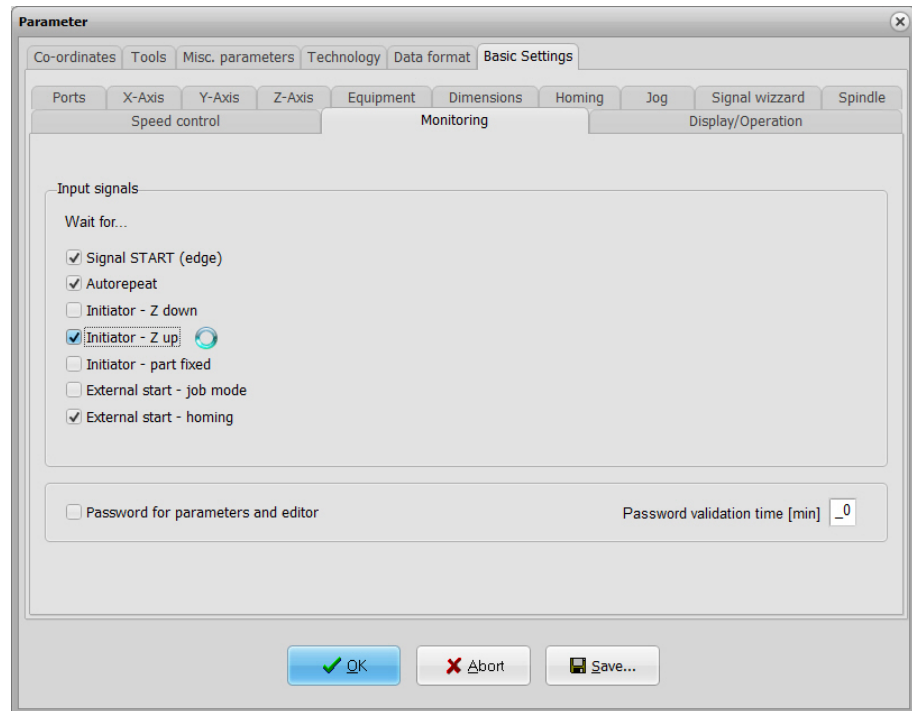


Basic settings-monitoring

All input signals and relevant parameters which can be synchronized are grouped in a specific dialog box.



Monitoring input signals

Input signals

Synchronization with various sensor signals signalen

WinPC-NC can synchronize the job sequence with various input signals. The option of activating these signals depends on definition and assignment of the signal transmissions and inputs.

The various signals and what they mean :

Start signal

Following activation of the job process, **WinPC-NC** waits always for a positive edge on this signal and does not start processing the NC data until the signal changes from LOW to HIGH.

Sensor Z down

WinPC-NC can wait for this signal after the Z-axis is lowered. The movements are not continued until the signal is active. This signal is particularly useful with pneumatic Z-axes

Sensor Z up	WinPC-NC can wait for this signal after the Z-axis is raised. Movements to the next insertion point are not continued until the signal is active
Spindle speed	It is possible to use this signal after the drilling speed starts to indicate when the required speed has been reached. WinPC-NC waits until this signal goes to HIGH before continuing the process
Clampin	This signal can be used to indicate when the workpiece clamping is activated. The working process cannot be started until this signal is active.

Automatic repeat

*Perform
the process
repeatedly*

When the start signal is active, it is possible to use this parameter to make **WinPC-NC** wait for the next start signal as soon as it finishes a working process. This means no input from the keyboard or mouse is required.

Password and period of validity

This parameter activates a password which must be entered prior to change the parameters or a loaded program. The password is fixed.

The period of validity stipulates the term how long the password is valid and how long it is not interrogated again.