



CE
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**HOFFMANN
Machine
Company, Inc.**

Touchscreen and Scanner Manual
MS-40-SF-NC Double Miter Saw with
Dovetail Routing Stations

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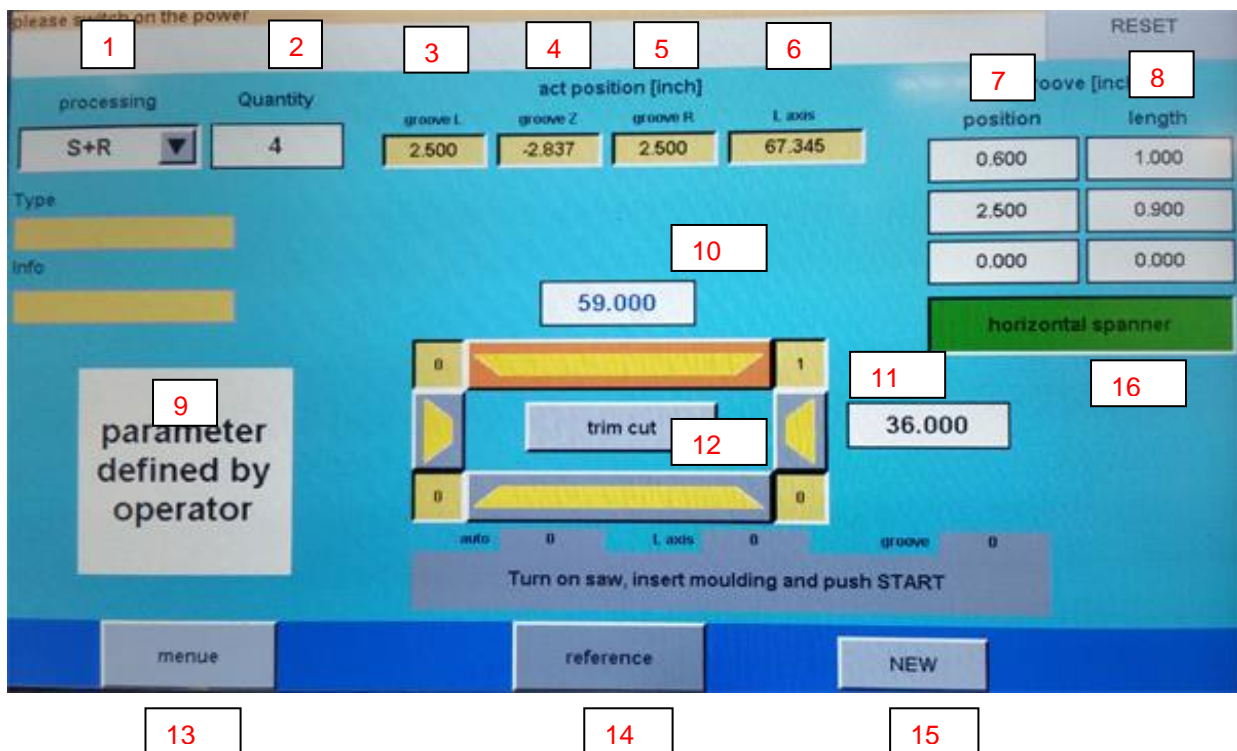
IMPORTANT:

THIS MANUAL ONLY COVERS DATA ENTRY, I/O AND ERROR MESSAGES AND QR CODE DETAILS FOR MS40SF

OPERATOR MUST HAVE ACCESS TO AND BE THOROUGHLY FAMILIAR WITH THE MAIN OPERATING AND MAINTENANCE MANUAL FOR THIS MACHINE AS WELL AS THE SEPARATE MANUAL FOR THE ELA-2 POSITIONING SYSTEM.

ALL THREE MANUALS MUST BE KEPT WITH MACHINE AT ALL TIMES.

2 Main Menu





1	Processing	To manually select “sawing only” or “sawing and routing”
2	Quantity	Displays number of completed work pieces
3	Groove - L	Displays current position of left hand router motor
4	Groove - Z	Displays current vertical position of router motors
5	Groove - R	Displays current position of right hand router motor
6	L axis	Displays current position of automated length stop
7	Groove position	Displays selected positions for three different keyway locations (grooves). Positions are entered either via QR code scan or manually via touch screen. Measurement is in decimal inches, measured from tip of miter to center of keyway.
8	Groove length	Displays selected routing length (routing height) for three different keyway locations (grooves). Positions are entered either via QR code scan or manually via touch screen. Measurement is in decimal inches, measured from top of machine table to end of keyway.
9	Image display field	Displays color image of current moulding type – only active if data is entered by scanning QR code. Note: Image files are stored on removable USB stick in .png format.
10	Frame Width	Displays frame width when data is entered by scanning QR code. Frame width may also be manually entered in this field.
11	Frame Height	Displays frame height when data is entered by scanning QR code. Frame height may also be manually entered in this field.
12	Trim Cut	Used to disable automatic work piece counter when making initial cut on new length of raw material.
13	Navigation	Push to select sub-menu Navigation
14	Reference	Used to start reference sequence on all axes. Reference sequence is required upon initial start-up of machine.
15	New	Push to reset frame dimensions
16	Horizontal Spanner	Allows operator to manually active or de-activate horizontal material clamps Note; Vertical clamps are always activated and cannot be switched doff for safety.

3 Sub Menu NAVIGATION

Sub Menu NAVIGATION is selected to adjust servo drives, axis parameters and to reach other machine specific menus.

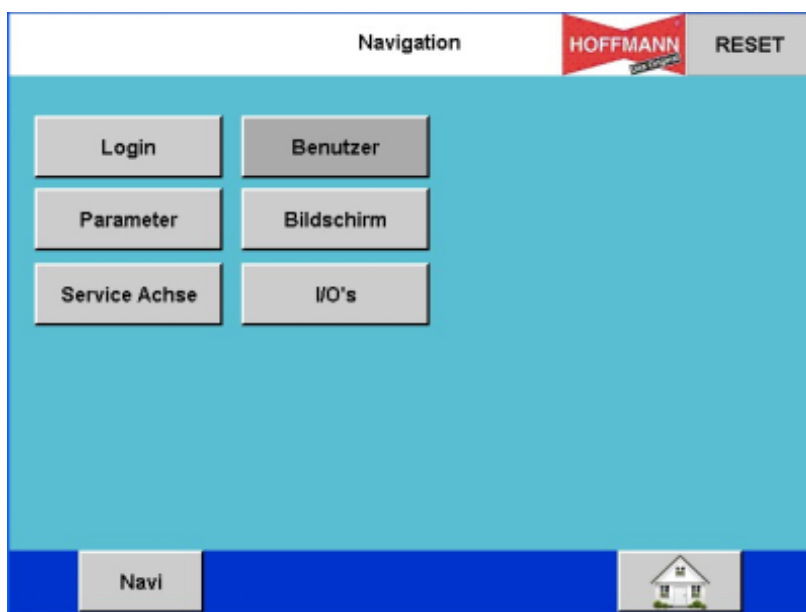
Generally, these settings are adjusted during the installation of the machine and changes are rarely, if ever, necessary.

Any adjustments should be performed carefully and in small, incremental steps to avoid damage to machine components.

It is advisable to record the factory setting prior to making any changes.

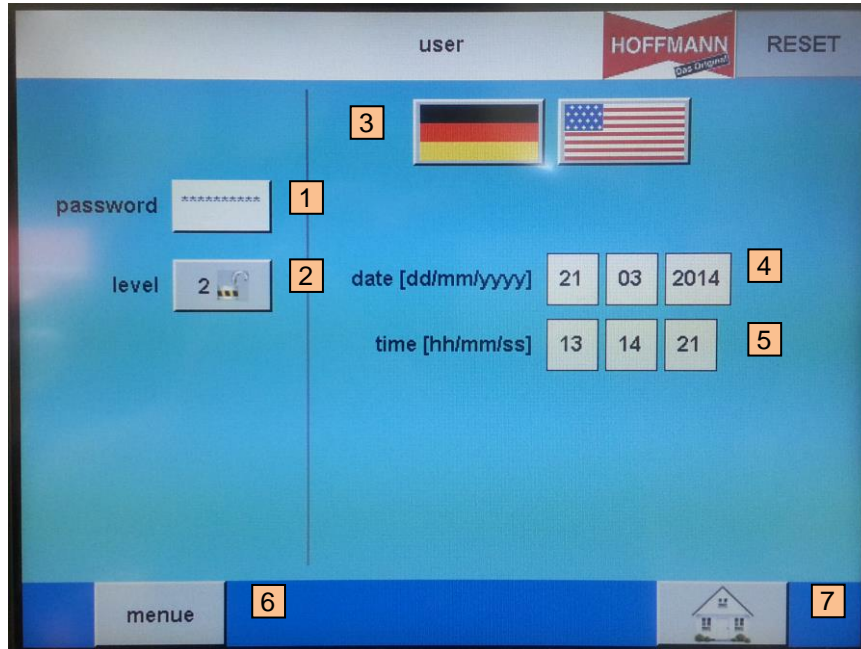
If you have questions regarding the factory settings, please contact Hoffmann Machine company, Inc. toll-free at (866) 248 – 0100.

This sub menu section is password protected (1961) to avoid unintentional changes.



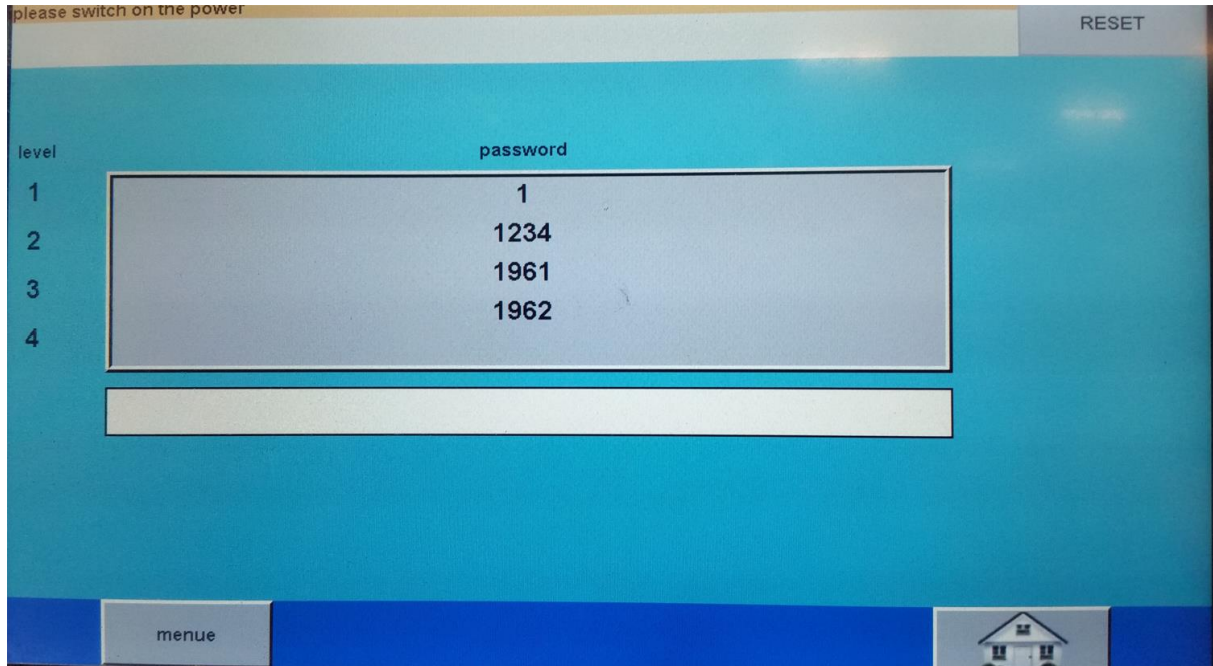
1	Login	Press to select submenu LOGIN
2	User	Press to select submenu USER
3	Parameter	Press to select submenu PARAMETER
4	Touch	Press to select submenu TOUCHSCREEN
5	Service Axis	Press to select submenu Axis
6	I/O	Press to select submenu I/O (input – output)

3.1 Sub Menu USER



1	Password	Field to enter required password
2	Level	Displays current user level. Level 3 and 4 can be used to change passwords.
3	Language	To select between English and German display language.
4	Date	To set current date.
5	Time	To set current time.
6	Menu	To return the previous menu level.
7	Home	To return to main (home) screen

4 Sub Menu USER (access levels)



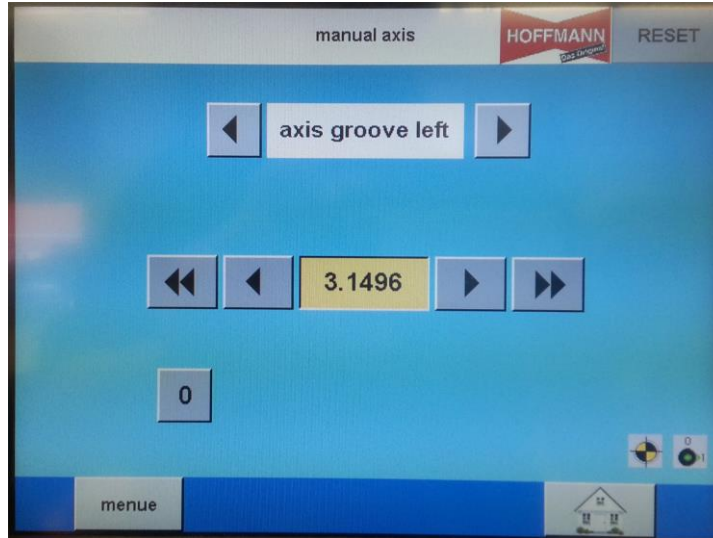
LEVEL	ACCESS	PASSWORD
1	Manual data entry and machine operation	1
2	Allows changes to parameters	1234
3	Full access except password changes for level 4	1961
4	Full access (mfg. access only to this level)	1962

5 Sub Menu MANUAL AXIS

Sample factory setting
– groove left

Maintenance Staff:
Enter actual number
from display for
future reference:

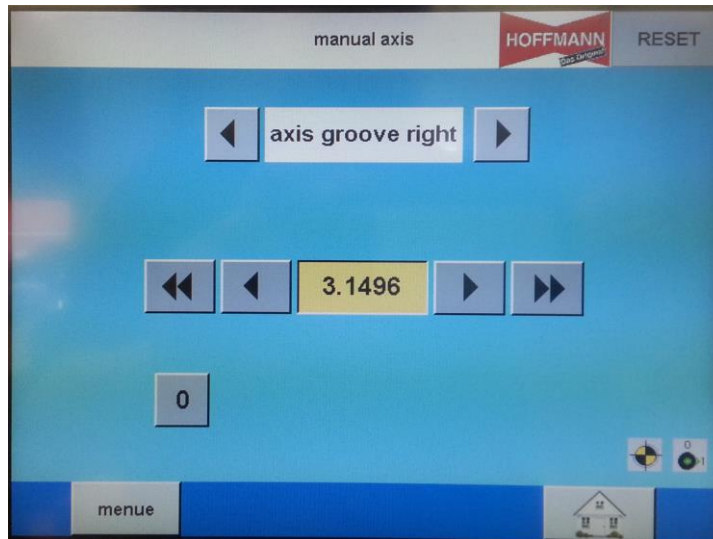
.....



Sample factory setting
– groove right

Maintenance Staff:
Enter actual number
from display for
future reference:

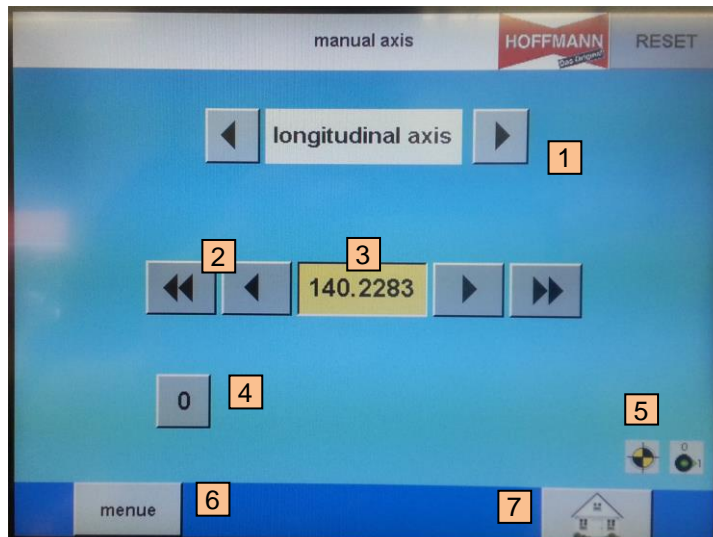
.....



Sample factory setting
– length axis

Maintenance Staff:
Enter actual number
from display for
future reference:

.....



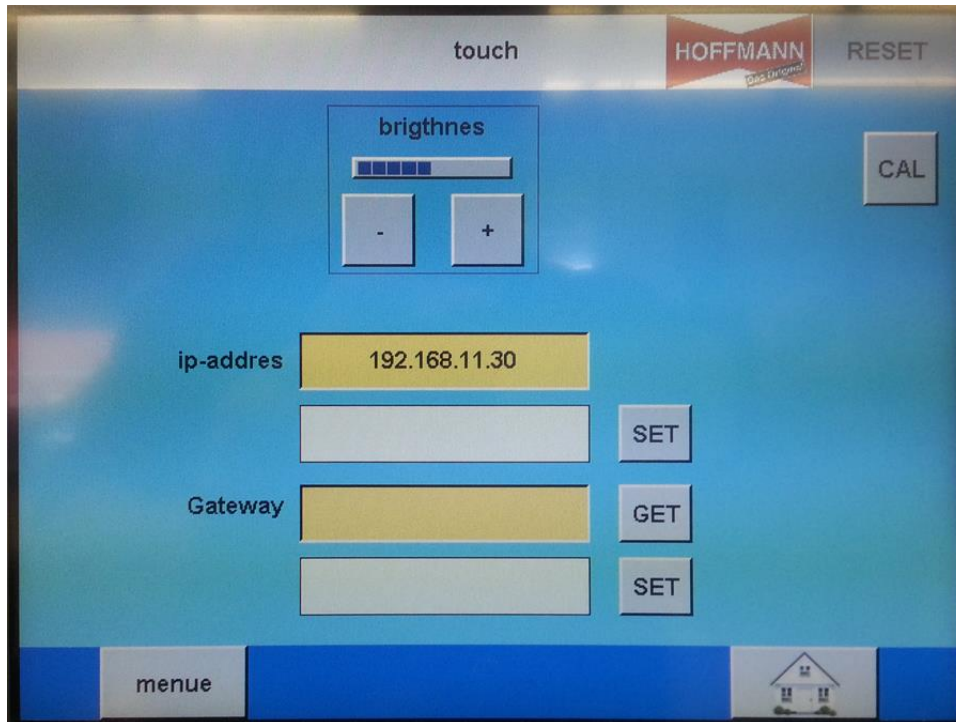
1	Axis selection	Use left and right arrows to select different axis.
2	L - R arrows	Use left and right hand arrows to advance and reduce settings. Press double arrows for fast forward/reverse.
3	Display	Displays current position
4	Button "0" Press to reset axis fault.	Machine requires recalibration (reference sequence) after axis fault or error message. Background color will change from red to green when reference sequence is completed.
5	RESET-Button	Press to reset.
6	Menu	Press to return to previous screen / menu
7	Home	Press to return to home screen

Important note for Maintenance Staff:

Numbers shown in screen images are samples only, they are not necessarily the same numbers as on actual machine.

Please take a moment to enter actual numbers from display for future reference!

6 Sub Menu TOUCH (screen)



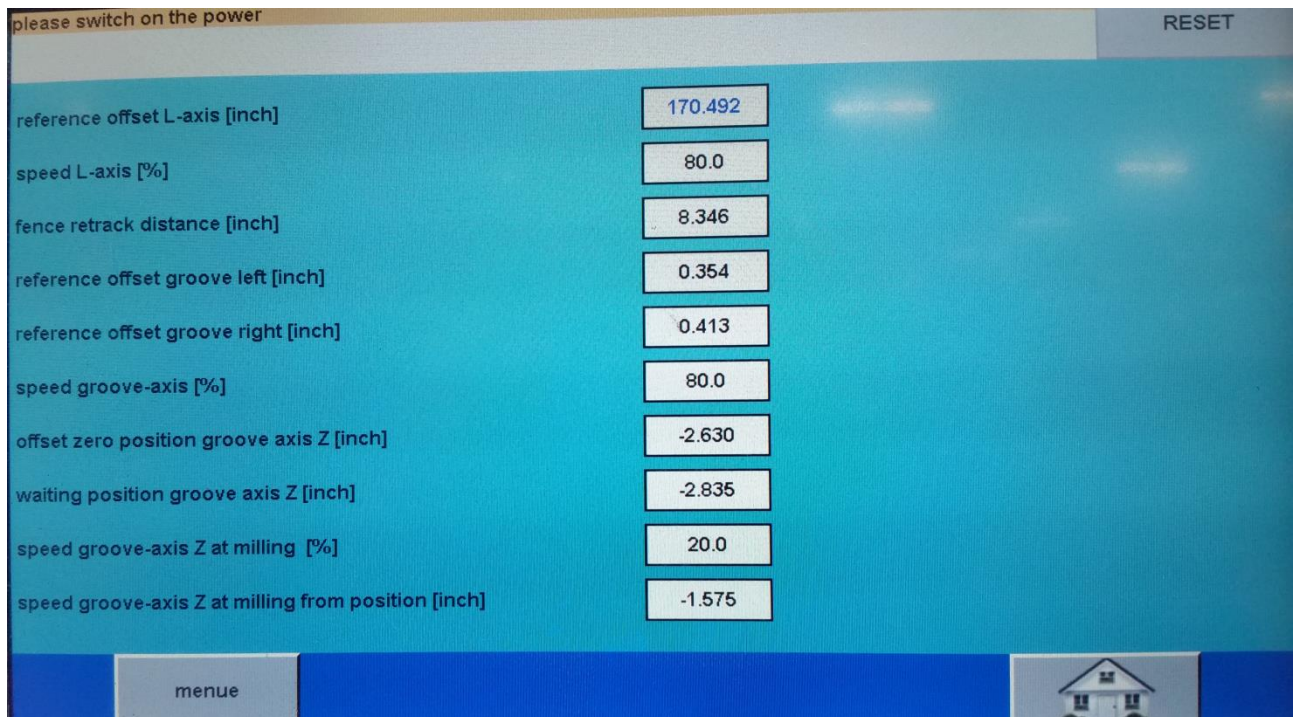
Press +/- to adjust screen brightness.

For service technician only:

Use displayed IP address to connect to external PC for software maintenance.

7 Sub Menu PARAMETER

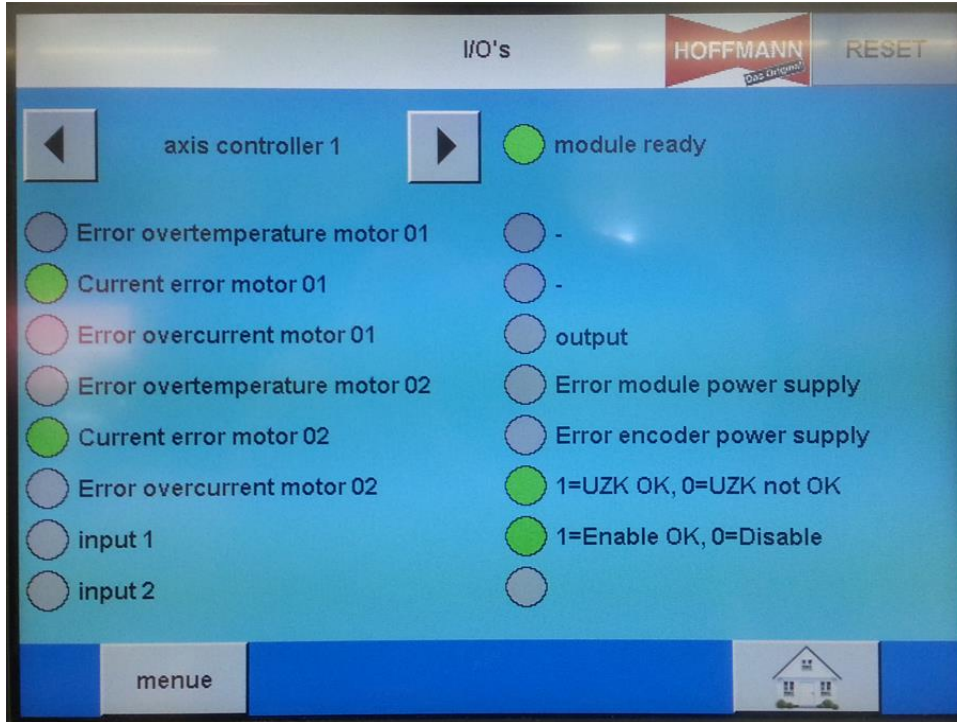
Displays all factory settings – adjustments and changes should only be made if authorized by Hoffmann Service Department.



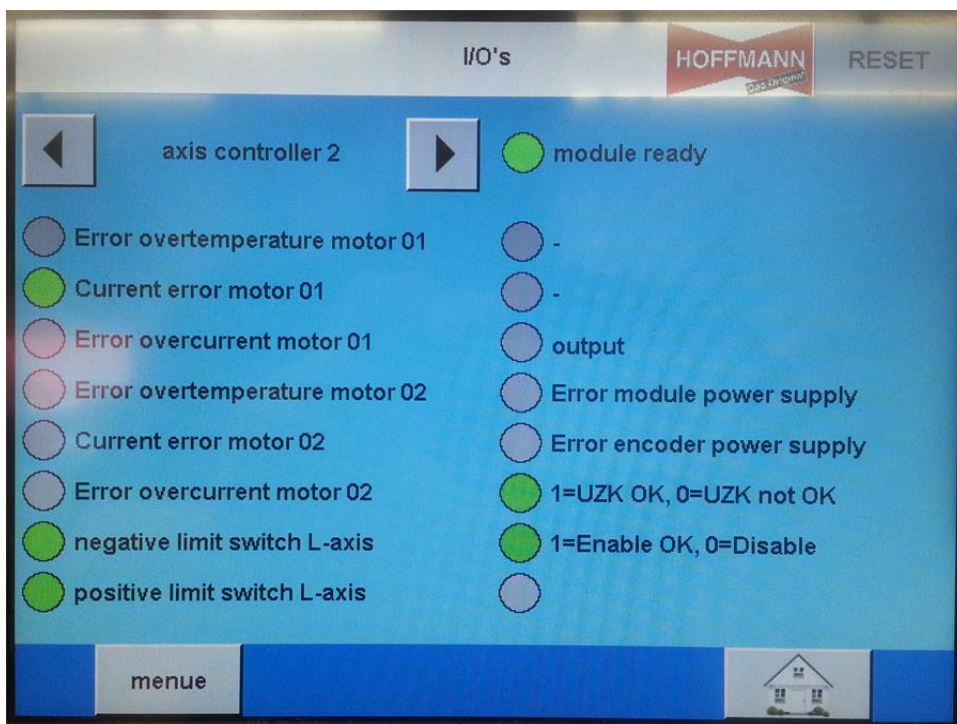


8 Sub Menu DIGITAL INPUTS AND OUTPUTS (I/Os)

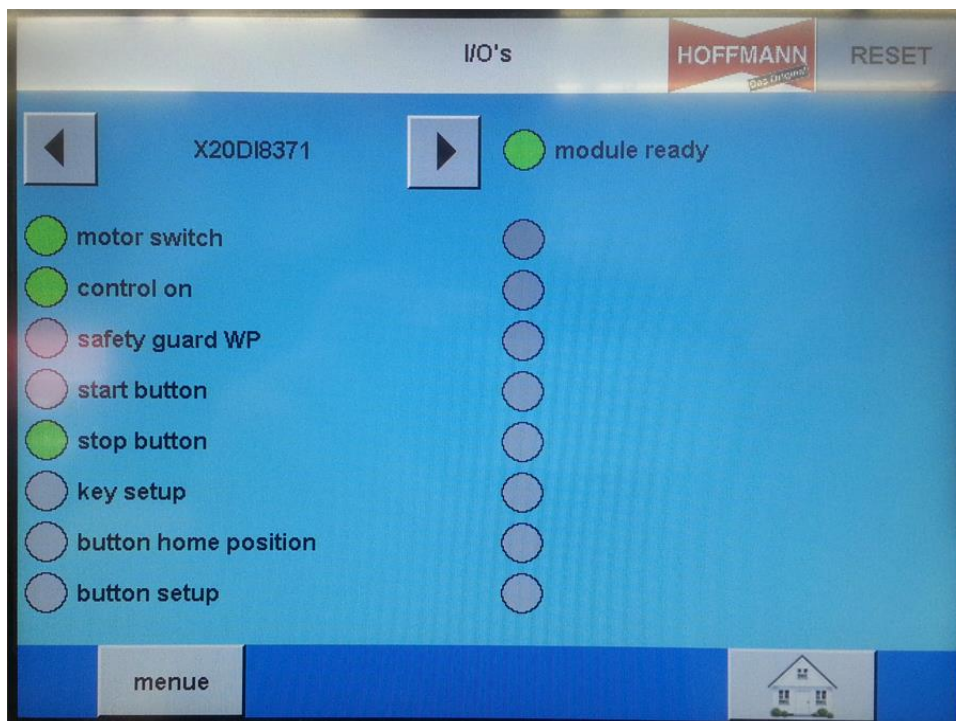
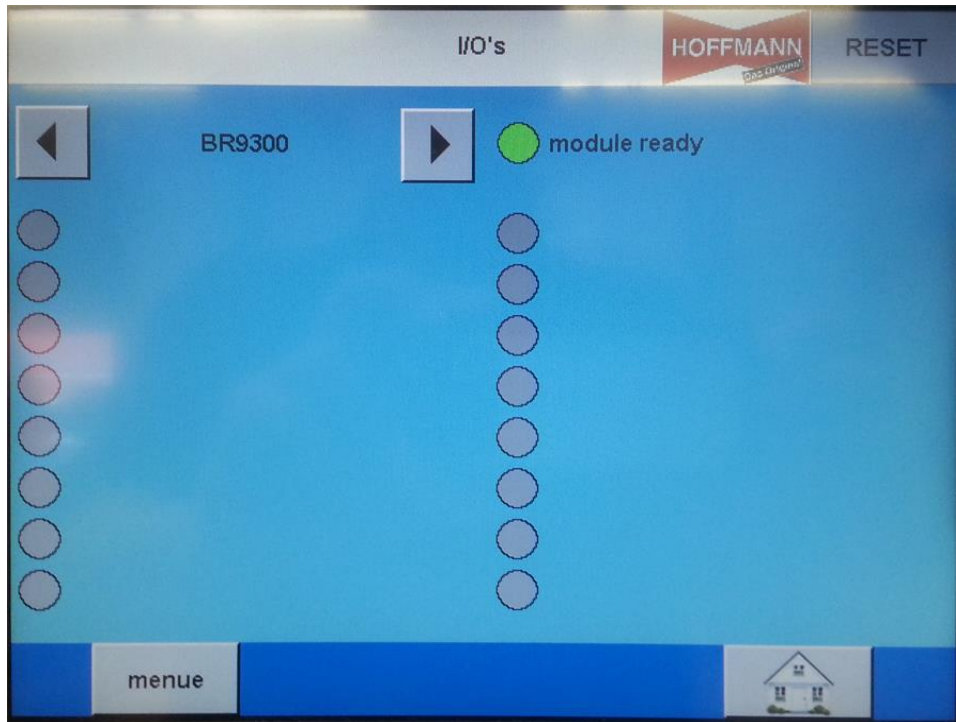
These screen shots display status of input and outputs when machine is in operating mode and no errors are being reported.

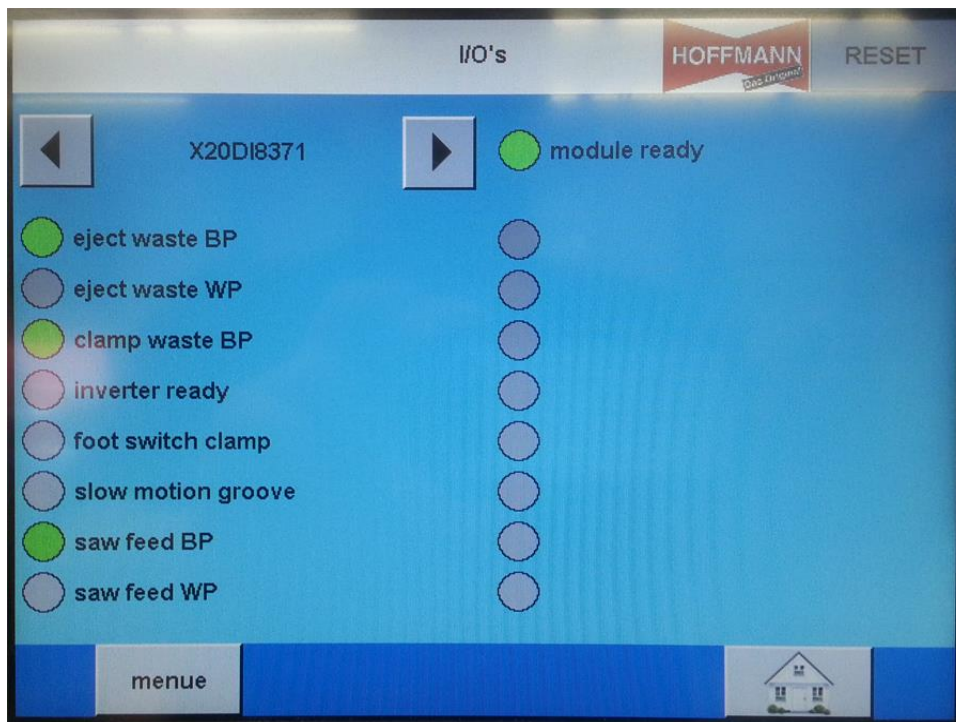


NOTE:
Current Error Motor 01 and/or **Current Error Motor 02** may be ON (green) during normal operating mode and can therefore be disregarded!

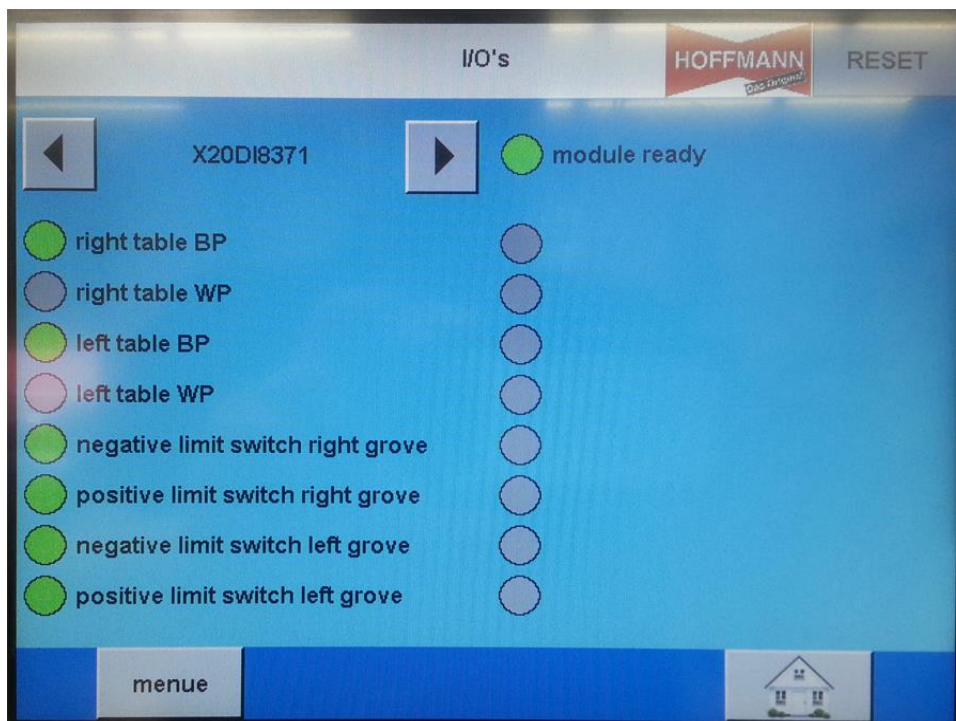


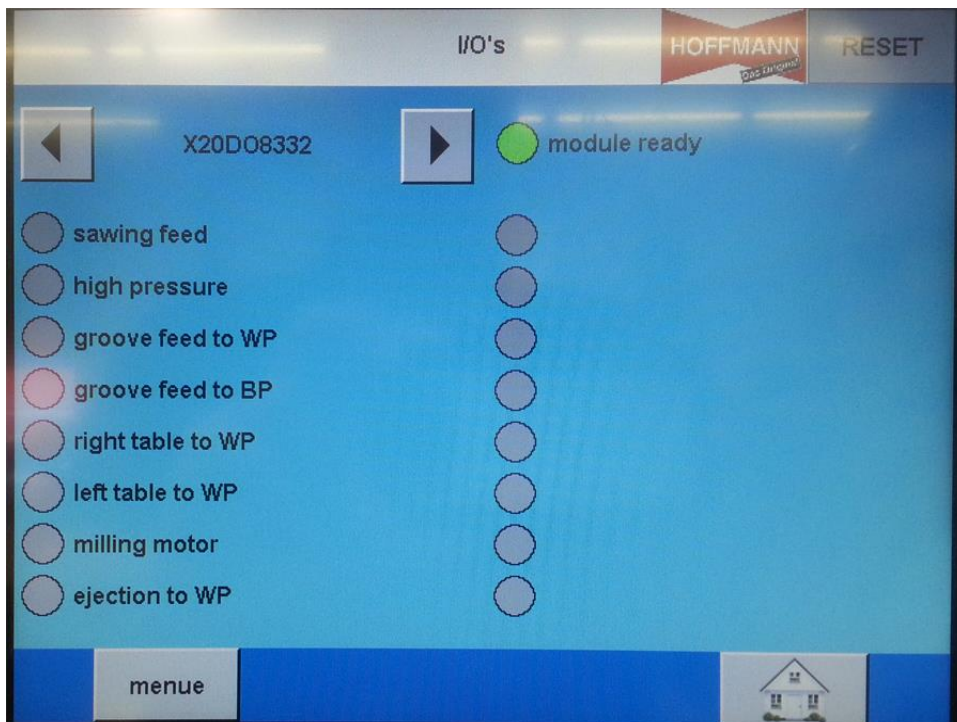
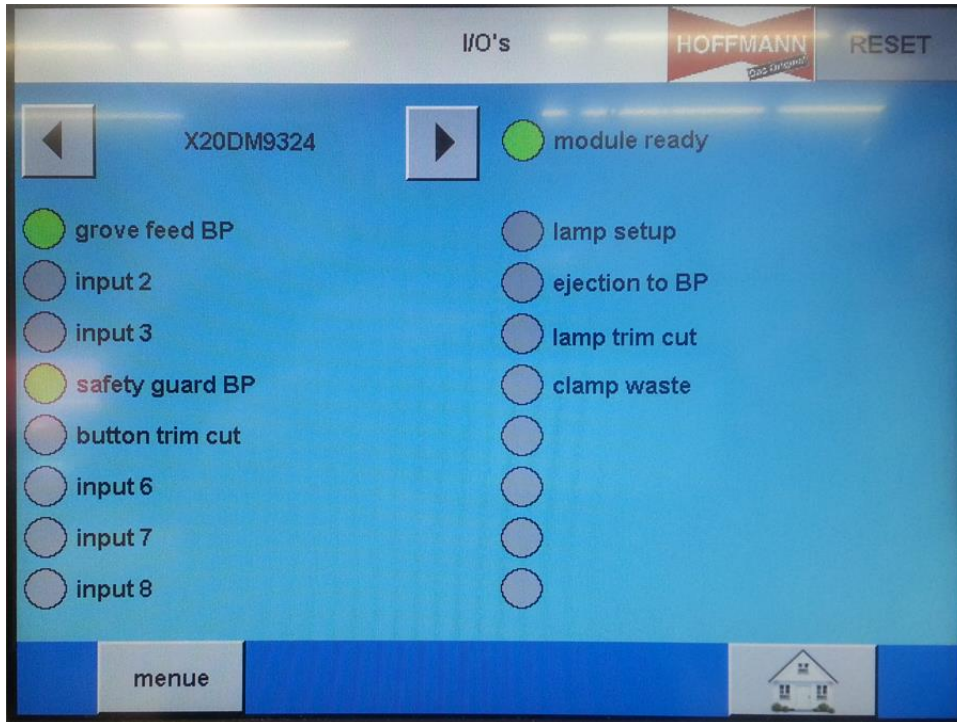
This screen (BR9300) is not used in this machine and can be disregarded!

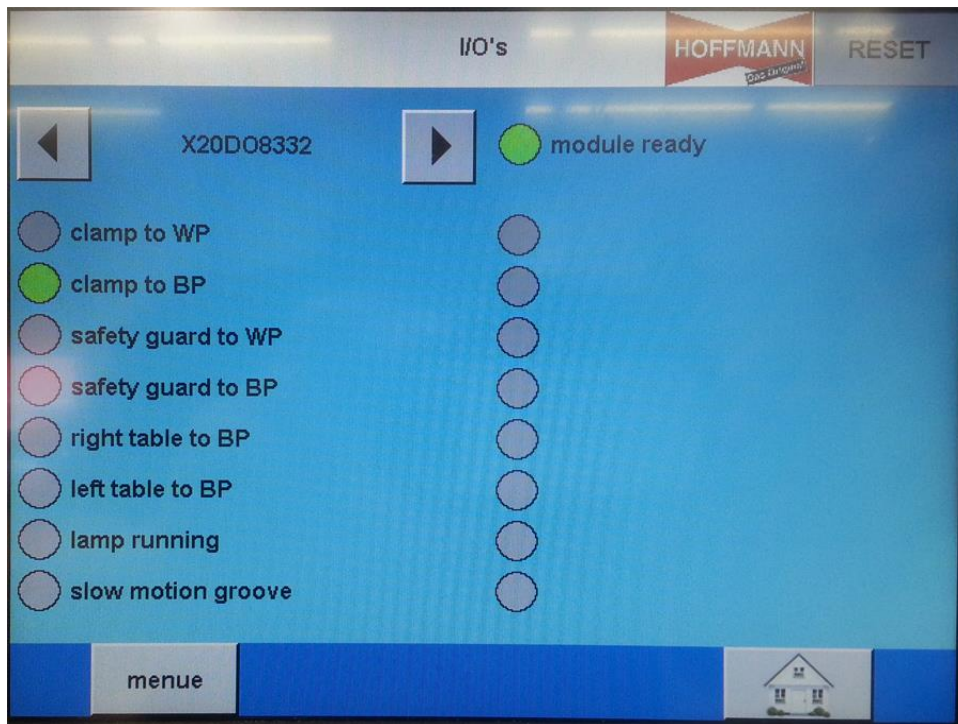




BP = base (home) position
WP = working position







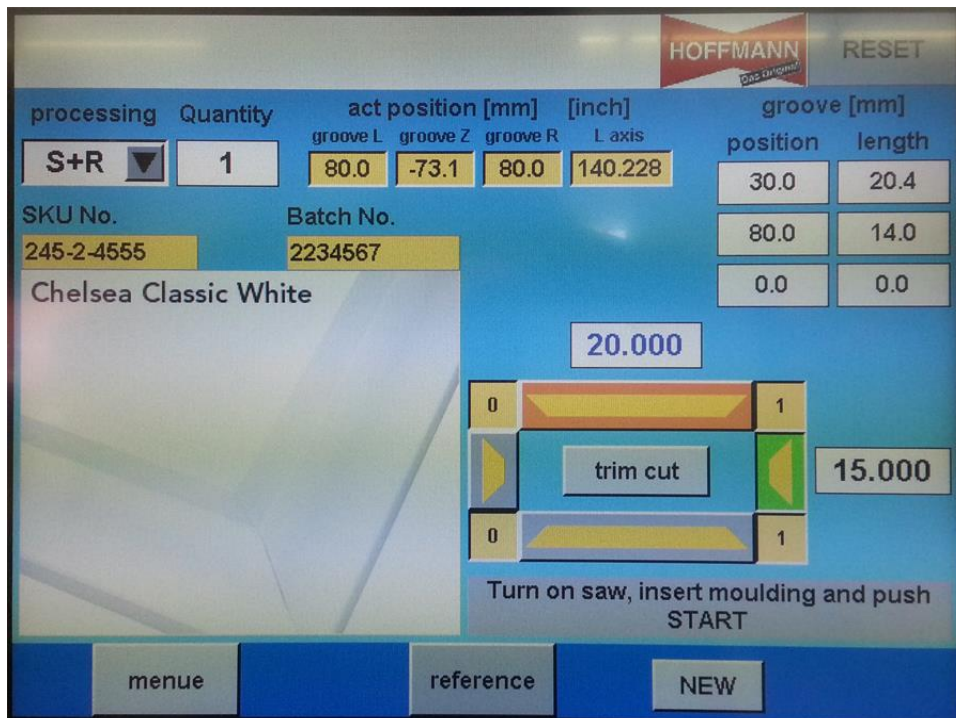
9 MANUAL ENTRY OF FRAME DIMENSIONS

The touch screen allows the operator to enter frame dimensions, keyway locations and routing heights without the need to scan the information with a QR code.



- ⇒ Press the NEW button
- ⇒ Touch the entry field for frame width or frame height.
- ⇒ Enter the desired length on the pop-up keypad and confirm dimension by pressing ENTER.
- ⇒ Select groove position and routing height and enter desired dimensions.
- ⇒ Push START to move automatic length stop to selected position.

Note: A frame corner image will not be displayed when manually entering data.



10 SCANNING QR CODES

Remove hand-held scanner from its holder and aim it at the desired QR code on worksheet.

Press scanner trigger and use the laser crosshairs to properly center the code for scanning.

Once read, the code is automatically transferred to machine's computer.

The computer uses the assigned SKU to select and display the corresponding image on the screen so operator can visually confirm correct moulding style and moulding color.

The image files are stored on a USP memory stick, located on the back of the touchscreen (open electrical enclosure for access).

Handheld Scanner by Datalogic, model Powerscan D9500 – see attached data sheet and detailed manual on CD ROM

Never aim scanner at any person or animal –
LASER light can cause eye damage!
Read all relevant safety warnings and instructions in scanner manual before use.



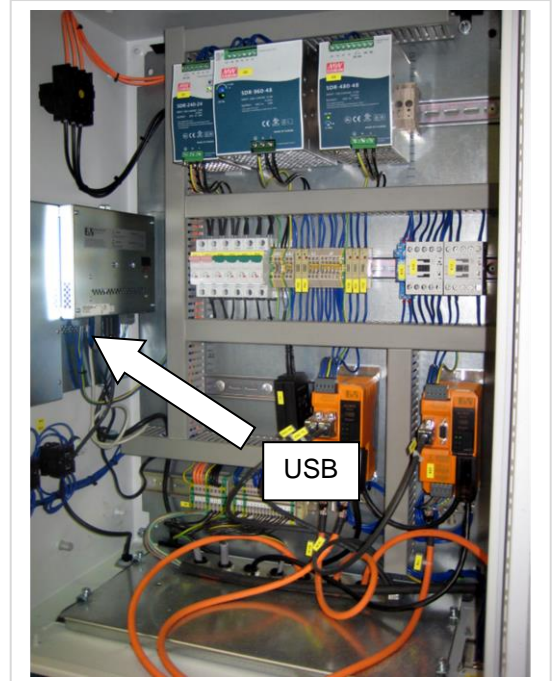
11 ADDING AND DELETING IMAGES

The software is designed to display an image of moulding being processed to allow for visual verification.

All image files are stored on a USB memory stick, connected to a USB port on the back of the touchscreen unit – see arrow.

To add or delete image files, remove the USB stick and insert it into a USB port on a desktop or laptop PC.

- All image files must be in *.png format.
- All image files must be sized to 300 x 250 pixels.
- All file names must match exactly the file name used in the QR codes.



Example

12 QR- CODE STRUCTURE

The QR (quick response) Codes must be created in this exact sequence, with all field semicolon delimited.

Order number;
SKU number;
Frame width;
Frame height;
Keyway 1 P (position);
Keyway 1 D (depth);
Keyway 2 P;
Keyway 2 D;Keyway 3 P;
Keyway 3 D;
Number of frames

