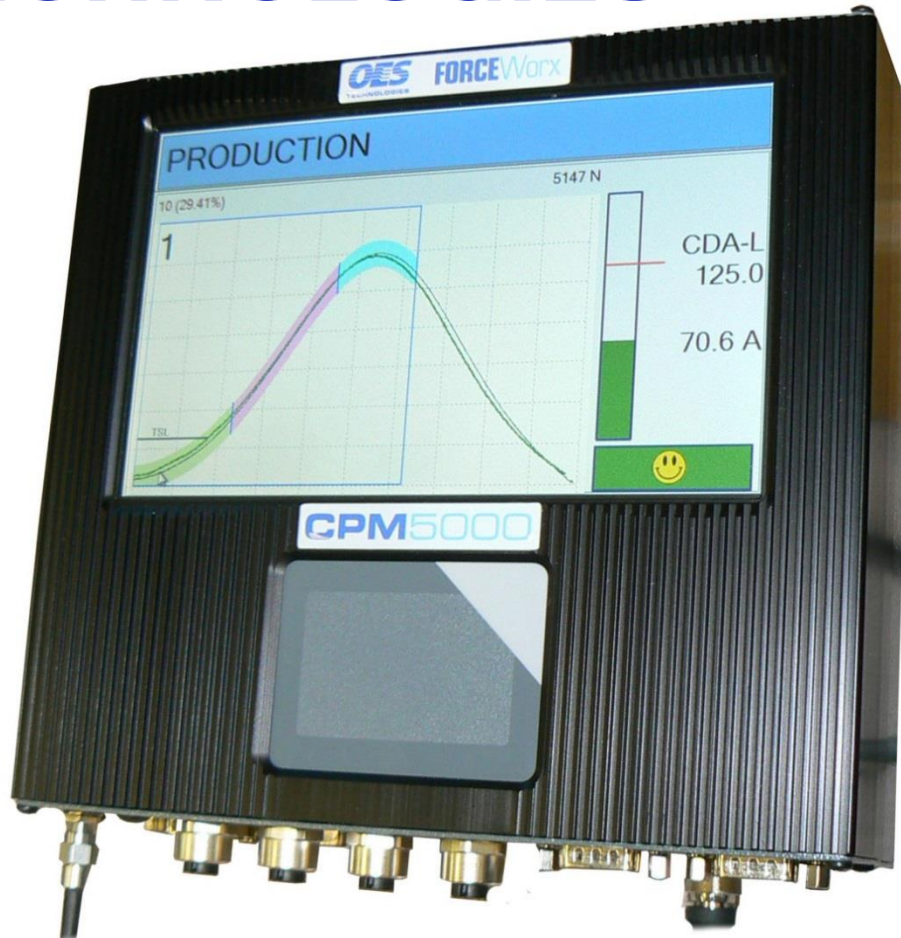


# OES

Quality  
Without  
Question

## TECHNOLOGIES



### CPM5000™

### CRIMP Process Monitor

### Appendix: Part Profile



FM 64157

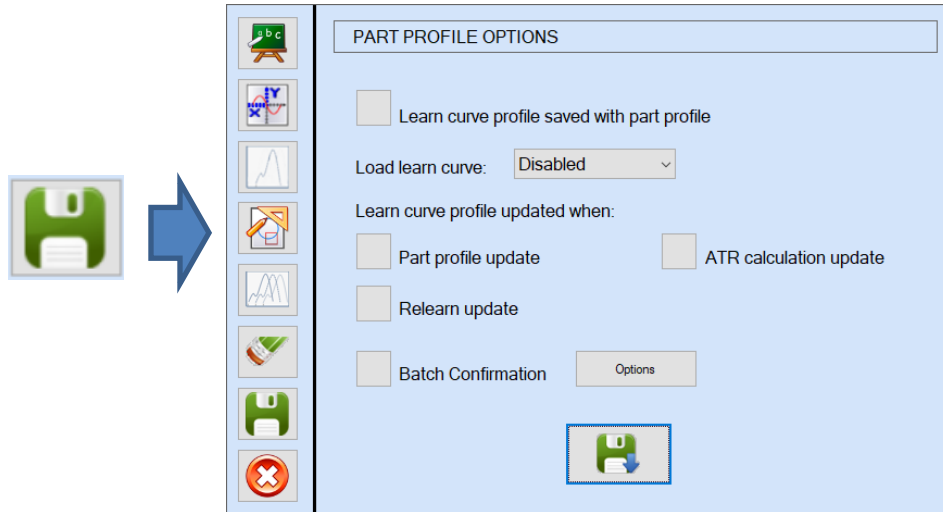
OES US Patent #'s: 5,841,675, 7,333,906

## Contents

PART PROFILE OPTION SETTINGS	3
SETTINGS SAVED WITH THE PART PROFILE	4
BATCH CONFIRMATION	6
– Batch Confirmation Options	6
– Batch Barcodes	8

## Part Profile Option Settings

Creating and saving a Part Number / Part Profile. This will save all the settings as is in the configuration and then allow you to save the learn curve.



## Settings Saved with the Part Profile

These are the settings saved with each profile. When the profile is loaded it will place all settings to saved profile. \*\*\***Sensor Configuration** and **Counter settings** are not saved with each profile as it is machine dependant.

### 1. Signature Learn settings:

**SIGNATURE LEARN**

MAX. LEARN VARIATION 3.0%

MINIMUM SAMPLES 5 MAXIMUM SAMPLES 16

STOP AFTER LEARN ☐

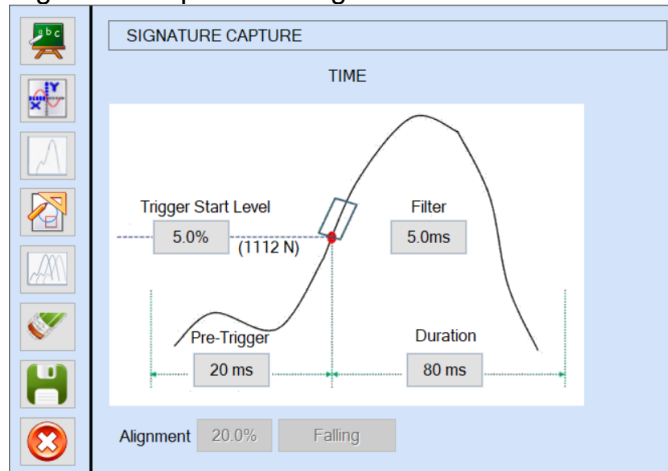
☒ LEARN TIMEOUT (seconds) 300

TARGET RECALCULATION 5 SAMPLES

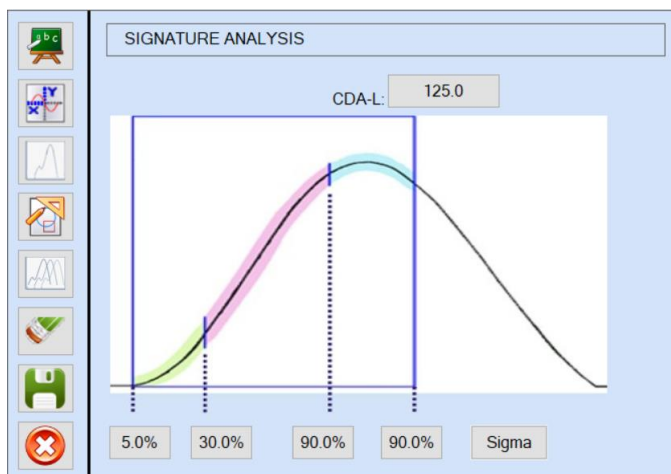
RECALCULATION LIMIT 75%

PROCESS DEVIATION 2.0% (444.8 N)

### 2. Signature Capture Settings:



### 3. Signature Analysis



#### 4. Advanced settings

The 'SIGNATURE ANALYSIS' window shows advanced settings for CDA and Curve Mismatch.

**CDA**

- CDA-E Region 1: 10%
- CDA-E Region 2: 50%
- CDA-E Region 3: 50%

Region	Pos Error Compensation	Neg Error Compensation
R1	1.0	1.0
R2	1.0	1.4
R3	1.0	1.2

**Advance**

- R1 Pos Error: - Neg Error
- R2 Pos Error: - Neg Error
- R3 Pos Error: - Neg Error

**Curve Mismatch: Disabled**

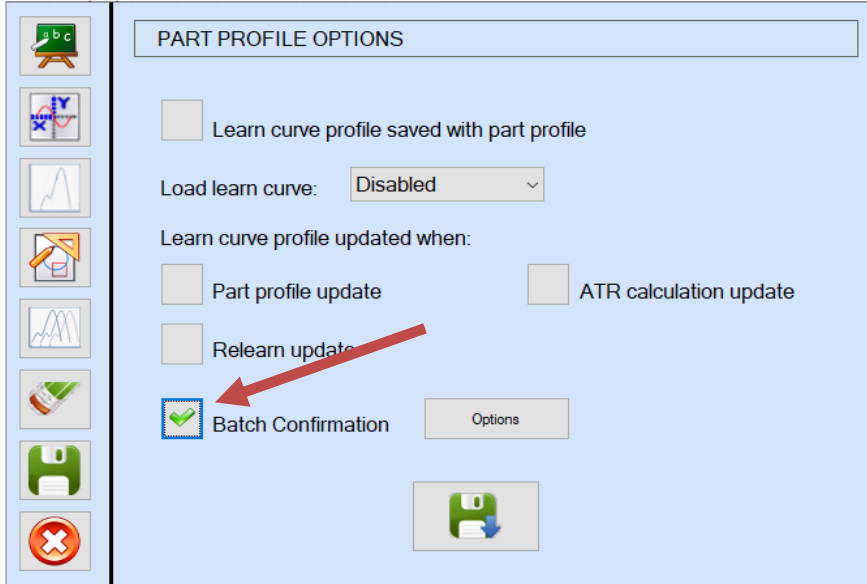
Region	Pos Error Compensation	Neg Error Compensation
CDA-E Region 1	50%	
CDA-E Region 2	25%	
CDA-E Region 3	20%	

**BASIC**

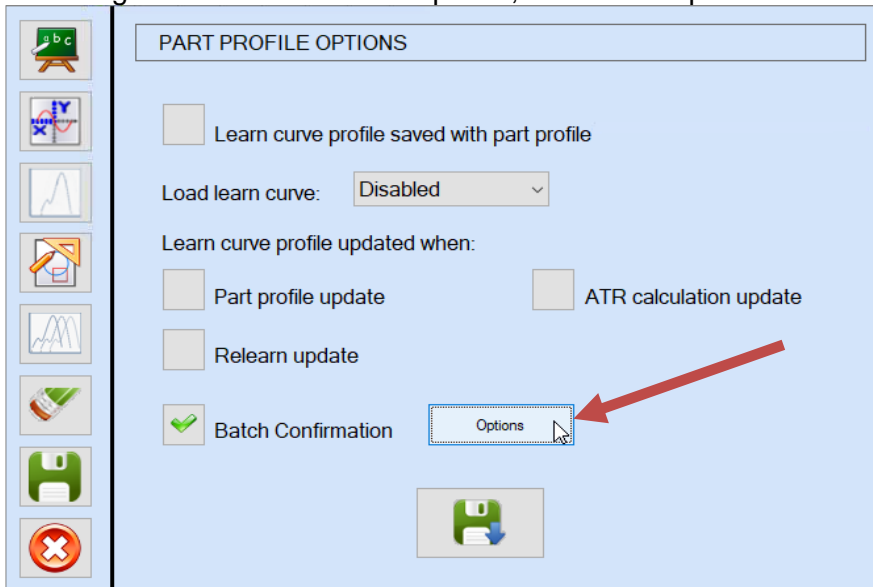
## Batch Confirmation

### Batch Confirmation Options

To Enable Batch Confirmation, select the checkbox for Batch Confirmation in the Save dialog



To change Batch Confirmation Options, Select the Options button



Select the options for each barcode

On/Off Enable/Disable barcode

Text field      Barcode type

(Terminal, Seal, Wire, Die or Other (Allows you enter custom type))

No of digits      Length of barcode

Type      Characters allowed in barcode

Numbers only (0-9)

Numbers and letters (0-9, A-Z)

Letters only (A-Z)

All (0-9, A-Z, space, #, @.....)

Rescan barcode after every ? pcs – This option will cause the CPM5000 to prompt the user to rescan the barcodes after every so many pieces. 0 means this option is disabled.

Batch Confirmation Options

	On/Off	Text field	No of digits	Type
1	<input checked="" type="checkbox"/>	Terminal	6	Numbers and letters (0-9, A-Z)
2	<input type="checkbox"/>		0	
3	<input type="checkbox"/>		0	
4	<input type="checkbox"/>		0	
5	<input type="checkbox"/>		0	

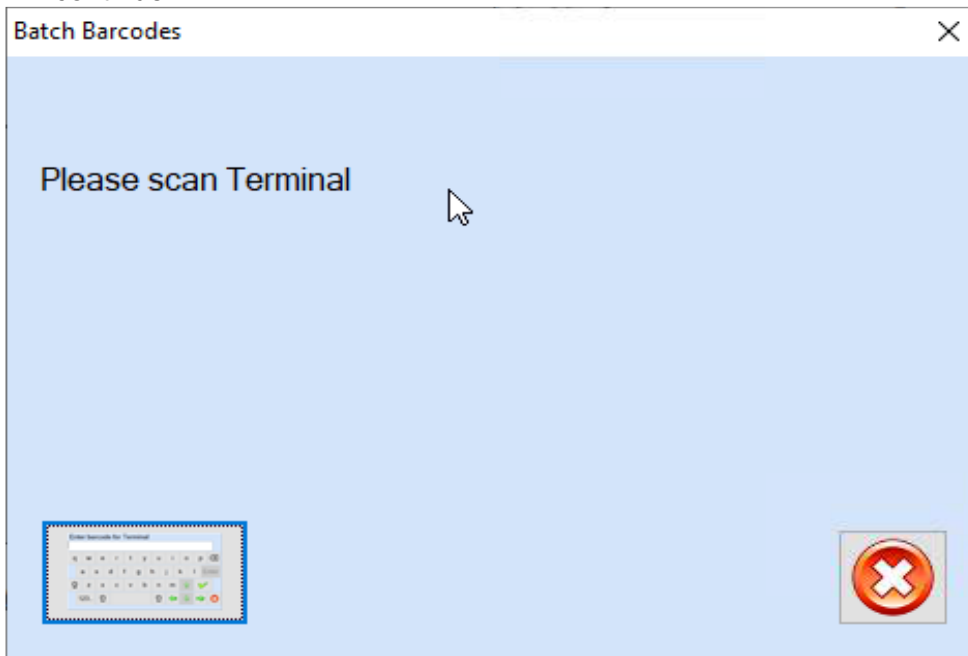
Rescan barcode after every  pcs ☒ ☐

## Batch Barcodes

When Batch confirmation is enabled the Batch Barcodes dialog will appear when

- Unit is put into learn
- After x cycles if Rescan barcode after every ? pcs is enabled

Scan or manually enter each barcode. After all barcodes are entered and verified, the unit will continue.







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FM 64157