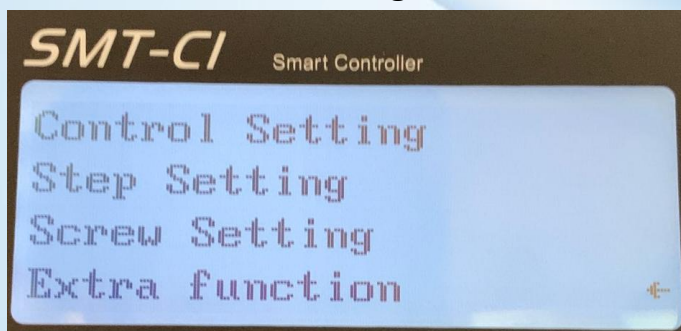


Loading Program Setting

1. Insert Micro SD card



2. Enter controller setting and select "Extra function".



3. Select “Export to SD Card”.



4. After finish loading program, take out the SD card and insert to computer



There are 4 documents in the SD card.

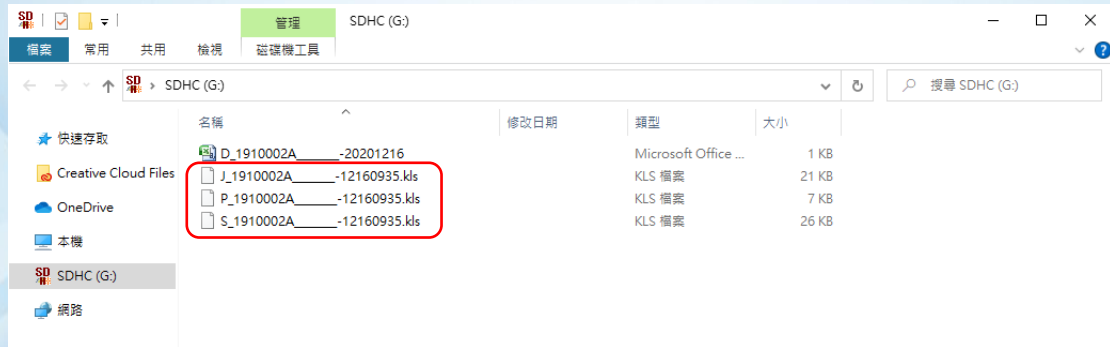
“D_1910002A” is Tightening stats record.

“J_1910002A” is Job sequence setting.

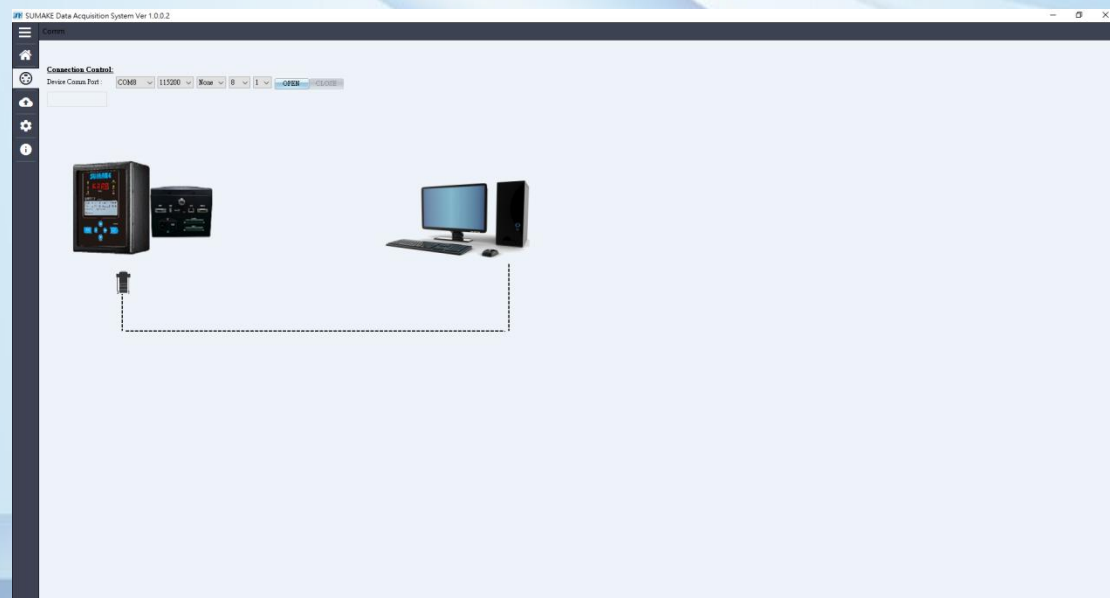
“P_1910002A” is Tightening program setting.

“S_1910002A” is Tightening step setting.

Save “J_1910002A”, “P_1910002A” and “S_1910002A” to your computer.



5. Open Das system



Click



SUMAKE Data Acquisition System Ver 1.0.0.2

Control Program Configuration:

Job: 5 Sequence: 1
Tool ID: 1 Program: 21

CLEAR CONFIRM EDITABLE SAVE Call Job Select Seq
RESET ENABLE LOAD

Tightening Status

Null

Torque: 0.0 Kgf.cm
Screw of Count: 0 of 0
Time: 0 Sec
Program of Seq: P 21
Thread: 0
Device ID: 001

Status Count (Reset)

	Job - Seq
OK	14
NG	3
OKALL	7

Job Seq: 5 1

Log File

Exec No	Exec Time	Device Count	Tool ID	Time	Torque	Unit	Thread	Tightening Status	Status Count	Count Inc/Dec	Barcode	Job	Sequence	Tightening Program
---------	-----------	--------------	---------	------	--------	------	--------	-------------------	--------------	---------------	---------	-----	----------	--------------------

SUMAKE Data Acquisition System Ver 1.0.0.2

Control Program Configuration:

Job: 5 Sequence: 1
Tool ID: 1 Program: 21

CLEAR CONFIRM EDITABLE SAVE Call Job Select Seq
RESET ENABLE LOAD

Tightening Step (1)

Tightening Program (1)

Program: 1

Program Name: *****

The First Step: 1

The Second Step: 0

The Third Step: 0

The Fourth Step: 0

The Fifth Step: 0

OK ALL Alarm Tone: 2.0

OK One Alarm Tone: 0.0

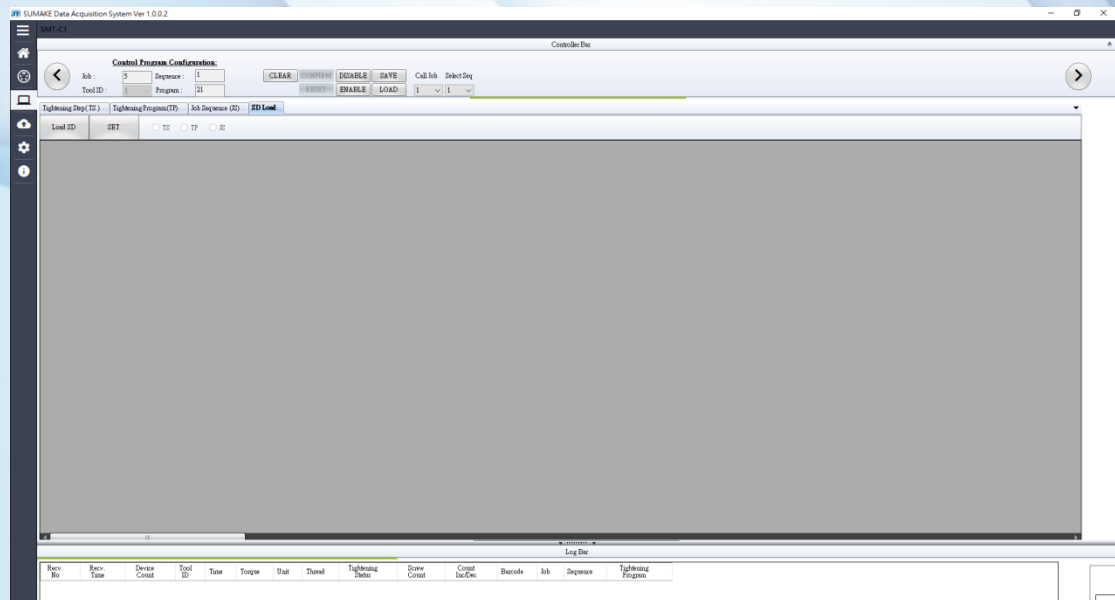
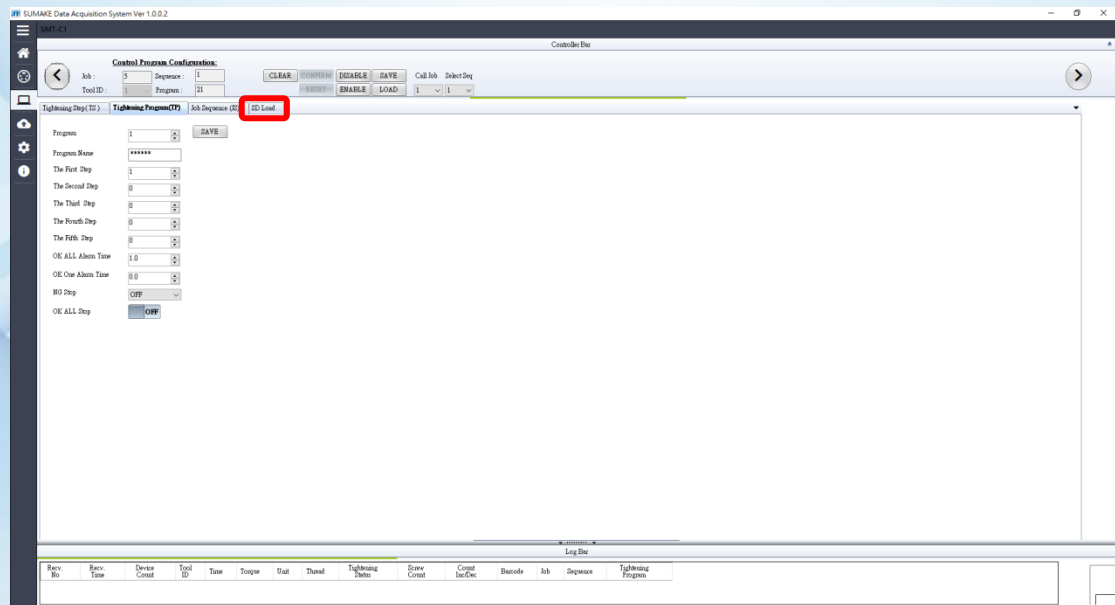
NG Step: OFF

OK ALL Step: OFF

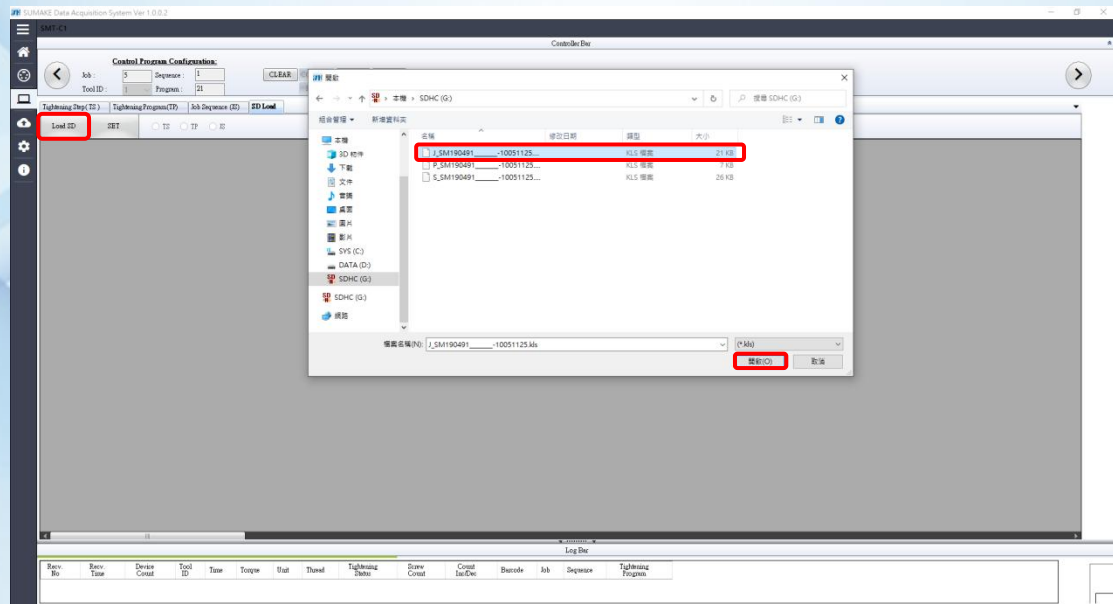
Log File

Exec No	Exec Time	Device Count	Tool ID	Time	Torque	Unit	Thread	Tightening Status	Status Count	Count Inc/Dec	Barcode	Job	Sequence	Tightening Program
---------	-----------	--------------	---------	------	--------	------	--------	-------------------	--------------	---------------	---------	-----	----------	--------------------

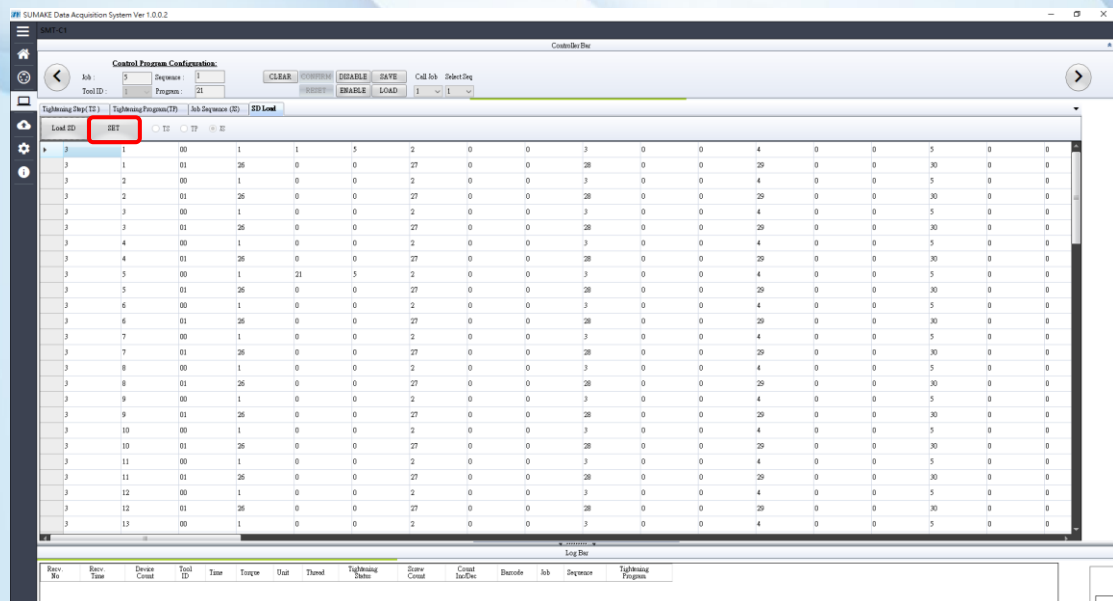
6. Click “SD Load”

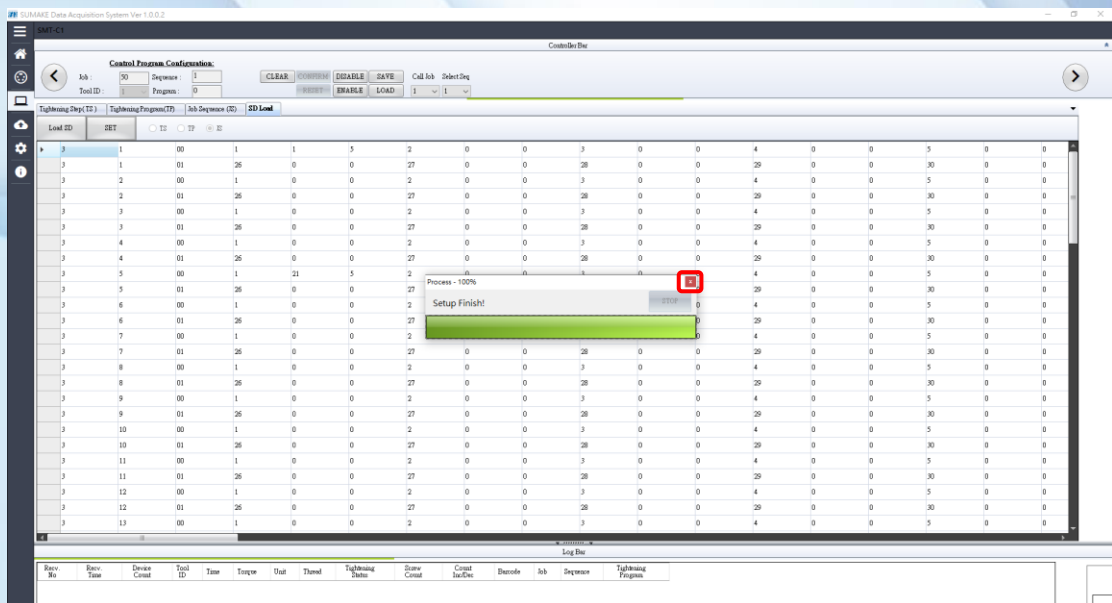


7. Click “Load SD” and select J_xxxxxxxx

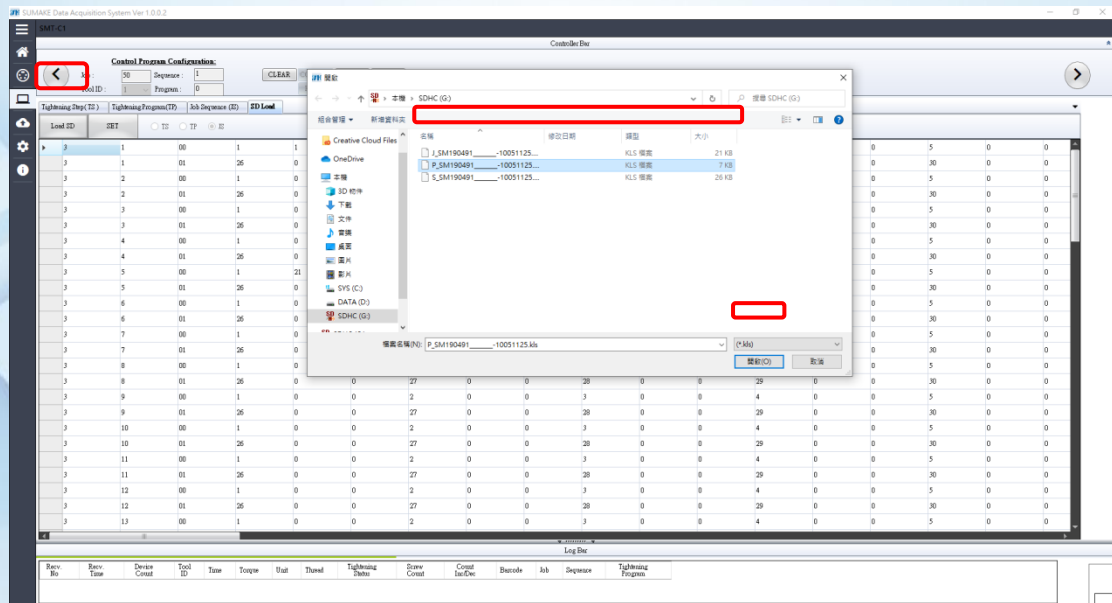


Click “SET”

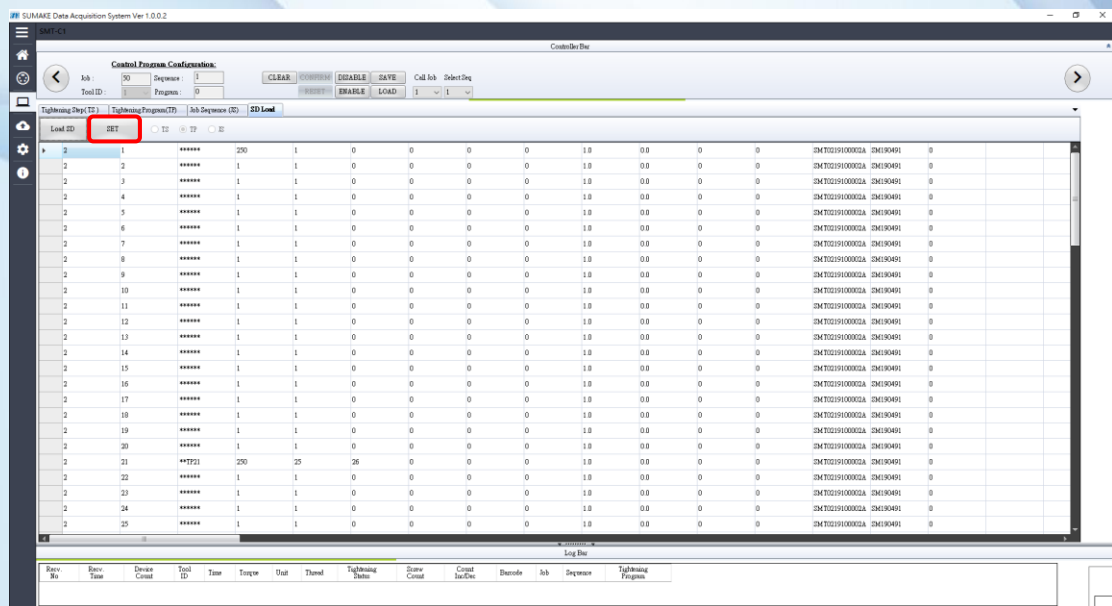


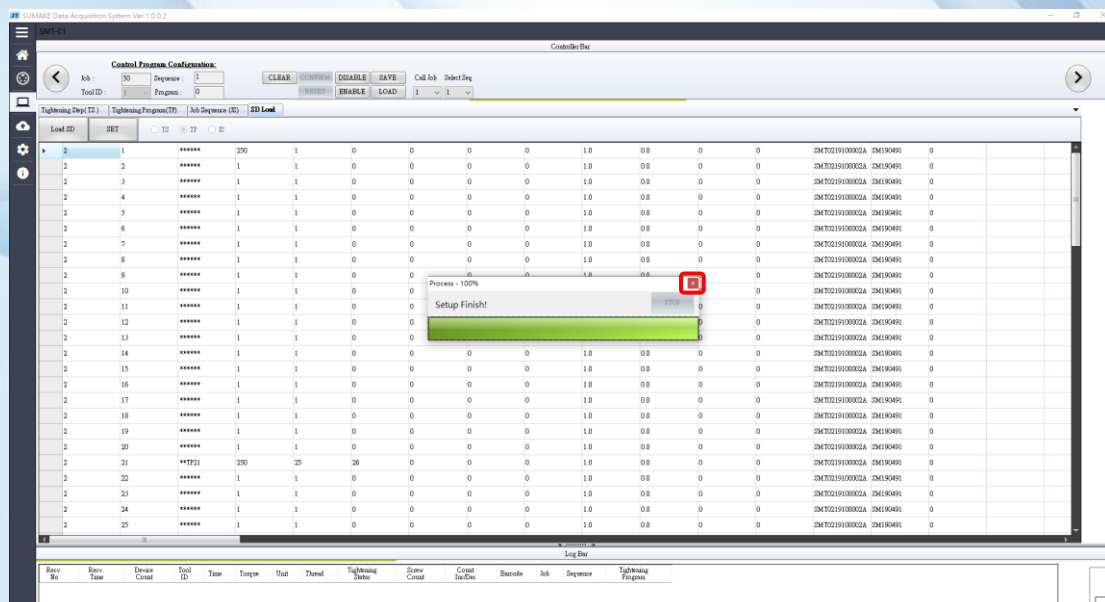


8. Click "Load SD" and select P_xxxxxxx

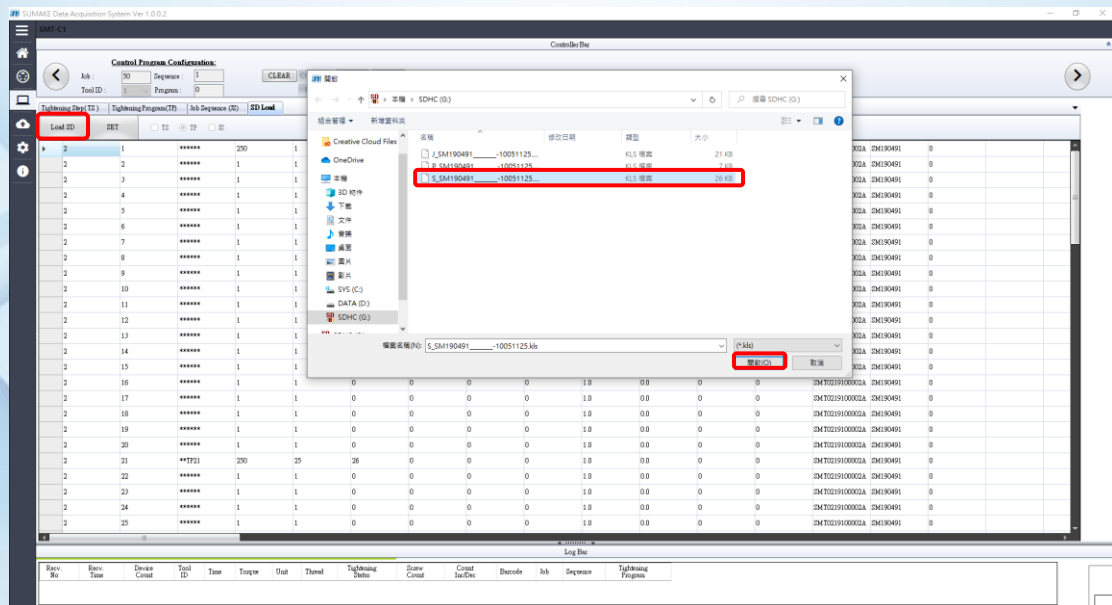


Click "SET"

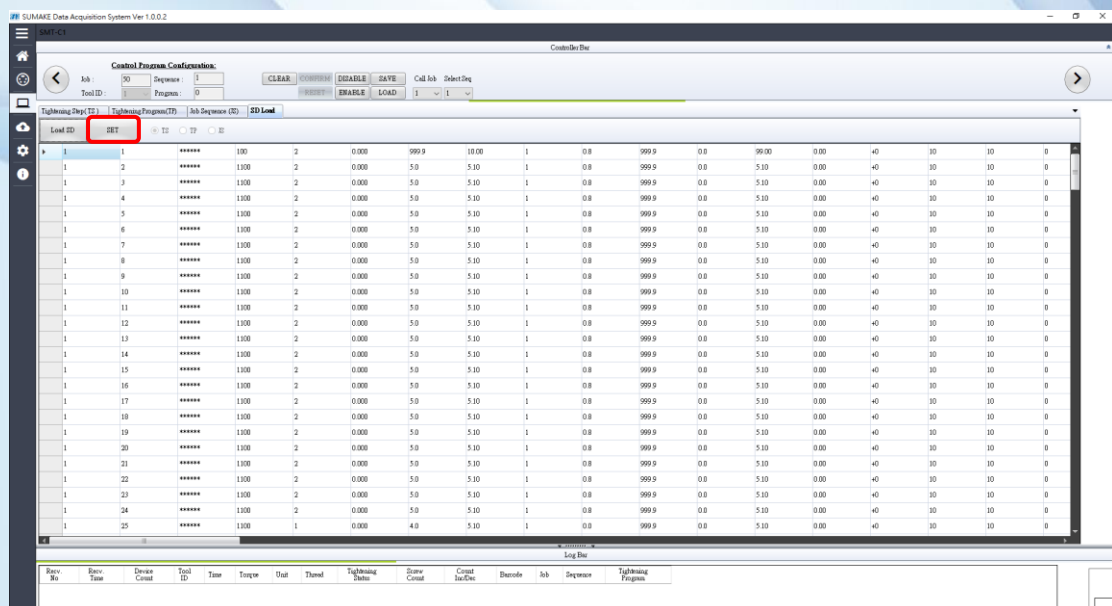


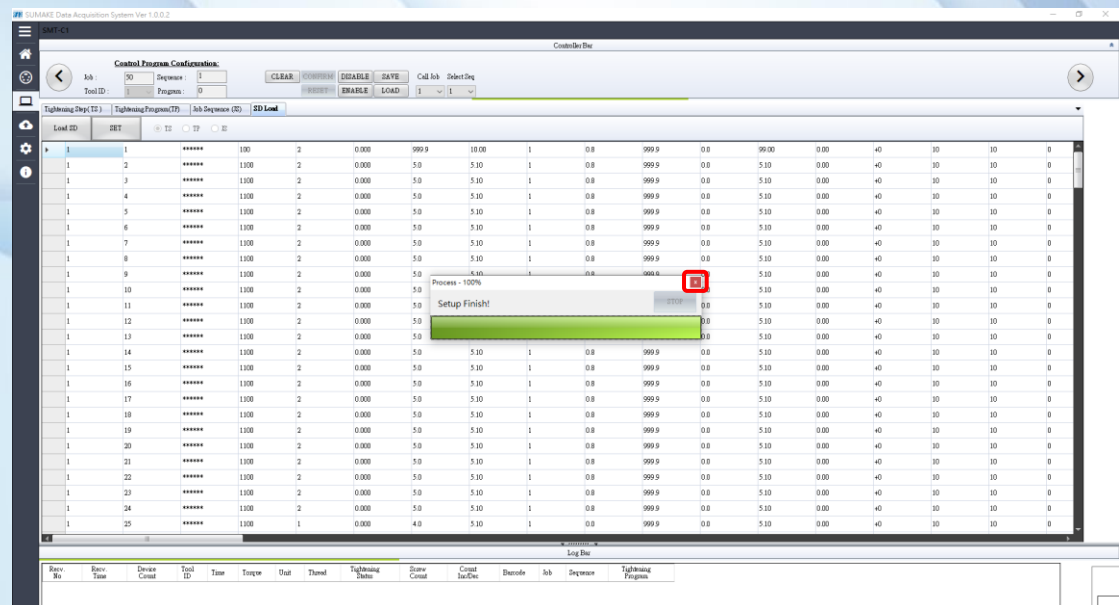


9. Click "Load SD" and select S_xxxxxxxx



Click “SET”





After complete above process, please test the programs.