M40118.V03

M40118.V03 PROCON Measuring Computer

	Content:	Page
1.	Functions	2
2.	Construction	2
3.	Connection elements	3 - 4
4.	Operating mode AUTOMATIC	5
	Single value card and bar chart	7
	Xb-s card	9
	Xb-R card	9
	List display	10
	Automatic zeroing	11
	Display test plan	12 - 13
5.	Selection of operating mode SETUP	14
6.	Operating mode SETUP	15
	Position tracer	15
	Select or delete test plan	16 - 17
	Configuration menu <->	18 - 27
	Import test plans	27 - 28
	Export test plans/measuring values	28 - 29
	Measuring continuously	30
	Diagnostics	31
	Automatic zeroing (cf. operating mode AUTOMATIC)	
_	Display test plan (cf. operating mode AUTOMATIC)	~~ ~~
7.	Entry of job number	32 - 33
8.	l est plan/measuring value files	33 - 34
9.	OPTION: Network connection	35
10.	OPTION: Import of job number and selection of test plan via barcode scanner	36
11.	Connection schematics	36 - 39
	Security instructions according to VDE 0411	40

Please note that some functions and adjustments described in this manual may not be available for every model or in all program releases.

Page 1 of 40

User's manual: M40118.V03

1. Functions

The measuring unit works with externally created test plans in MODAS/Procon NT format. A maximum of 512 test plans may be displayed, but not changed. Out of these 512 test plans, only one may be selected to be active. When selecting another test plan, the measuring results of the previously used test plan remain saved. They will only be deleted after export of the measuring values.

Program functions:

- Max. 8 measurement points, max. 8 measuring inputs (standard setup: 4 measuring inputs)
- 1 start input per measurement point
- Display of measuring values: list, bar chart, single value card
- Monitoring of tolerance limits: for each measurement point LL, LCL, GOOD, UCL UL
- Internal data logger
- Import of test plans in MODAS/ProconNT format from USB storage device
- Export of test plans and measuring values on USB storage device
- AUTOZERO function
- Control interface for tool compensation

2. Construction

The PROCON measuring computer is available with the following computer models:

- Measuring computer A&V 8817.653.0 or A&V 8817.655.0 in table housing with 10.4" colour display and touchscreen
- Measuring computer A&V 8861.600.0 for control cabinet installation on top hat rail with VGA monitor output

Both computer models contain:

at least 512MB RAM, 80GB hard disk,

- USB connection for external storage device
- PLC interface: 16 I/O via optocoupler, 4 measuring value inputs for inductive tracers

OPTIONS:

Extension to 8 measuring value inputs,

connection of external function keys,

control interface 8833.600.0 NEUE MAGDEBURGER / INDEX

3. Connection elements

Front view of case with connection for external USB storage device:



User's manual: M40118.V03

Back of case:



X401	Euro connector
X403	2x 4pol. socket
X405	9pol. plug MIN D
X407	2x 8pol. socket
X408	15pol. plug MIN D
K	6pol. socket MINI DIN
Μ	6pol. socket MINI DIN
X412	4pol. plug
T1-8	8x 5pol. socket 680
X312	37pol. socket MIN D

power supply 115-230V/50-60Hz USB connection Serial interface ETHERNET interface Output VGA monitor PS2 keyboard input PS2 mouse input Internal test socket Inputs for inductive tracers Control inputs/outputs

Option NEUE MAGDEBURGER / INDEX:

X5	37pol. socket MIN D	Control inputs
X12	25pol. plug MIN D	Control outputs
X6	4pol. socket 680	Start input
X10	6pol. socket 680	External function keys

Page 4 of 40

4. Operating mode AUTOMATIC

Switch on the measuring unit. After loading the program, the unit is in the operation mode AUTOMATIC and ready to operate.

By touching the keys or alternatively, with the external function keys, the requested display mode is selected.

Independent of the selected display mode, measurement and saving of the measuring values are carried out as soon as a transfer signal is given at the corresponding control input.

An exception is the function **automatic zeroing**. The unit displays that it is ready for measuring with the output signal **Busy**.

Depending on the test plan, this is either a separate signal for each measurement point or a collective signal for the simultaneous measurement of all measurement points.

Collective start All inputs are measured simultaneously.

Each input has its own start signal. Only inputs with an active start signal will be measured. This function allows measurements without temporal coherence.

Particularities:

Chaotic

Measurements out of range/measurements out of plausibility:

If at least one measurement is out of range, the unit interprets the whole measurement as failure.

The measurement cycle will not be used for statistics and control.

Forced zeroing after n units:

If forced zeroing is included in the test plan, the control signal BUSY as well as a warning message are set after the zero interval was reached.

After having carried out automatic zeroing, measuring may be continued.



40118V3E.DOC 03/2017 Page 5 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

M40118.V03

Operating error:

If a control interface for tool compensation is included in the test plan, in case of an error a warning message is set in the signal exchange with the machine control. Measuring may, however, be continued.

Meaning of the error message: xH xL

- x = number of control output
- H = timeout error of the signal acknowledge ON (waiting time > 2 s)
- L = timeout error of the signal acknowledge OFF (waiting time > 2 s)



Page 6 of 40

Tool change

During the first 5 measurements after a tool change, a yellow message is displayed showing the number of station times left.

BEBEERSSEED				No.of values	Kugel Ø	Deviation
30.00	100000000000000000000000000000000000000	000000000000000000000000000000000000000	*********	0	20.00	0
29.99-				·	29.90	••
29.98-					1	<mark>29.9</mark> 9
29.97-			0			30
				No.of values	Kegel Ø	Deviation
20.046				0	20.02	5
20.033-				٠	20.02	:0
20.020-						20.02
20.007-						
ool change:	station tim	es left 4			20	20.05
					John H (8	m
12.96-000000000000000		oppecccomposies	CONTRACTOR CONTRACTOR	No.of values	Schart D	Deviatio
12.95				No.of values	12.94	0
12.95- 12.94-				0	12.94	O
12.95- 12.95- 12.94- 12.93-				0	12.94	0
12.96			0	0	12.94	0 12 94 12.95
12.95- 12.94- 12.93- 12.92- 12.92- 21.0025-b0000000000000000000000000000000000			0	No. of values	12.94	0 12 94 12.95 Deviation
12.96				No.of values 0 No.of values 0	12.94 Kegellänge	0 12.94 12.95 Deviation
12.96				No.of values	Kegellange	0 12 94 12.95 Deviation
12.96-000000000000000000000000000000000000			0 0	No.of values 0 No.of values 0	Kegellänge 20.85	0 12.94 12.95 Deviation 1.2.95 0 1.2.95
12.96				No.of values	12.94 Kegellange 20.85	0 12 94 12 95 12 9
12.96	SETUP	Xb-s card	0	No.of values 0 0 Single v	Kegellänge 20.85 20.	0 12.94 12.95 Deviation 1 20.85 8 21

Standard setup in operating mode AUTOMATIC:

Single value card

The single value card shows the process characteristics of a measurement point with the last 125 measuring values. The advantage of the single value card is that it is very easy to read. For process control the Xb-S quality card is recommended because it is more sensitive for changes in location and variance. The tolerance limits are marked as red graph, the control limits as yellow graph and the centre of the tolerance range as blue graph.

Bar chart

The bars show the last measuring values of all measurement points within the tolerance range. This display mode is useful if it is to be checked how the workpieces lie within the tolerance range. For process control the use of quality cards is recommended.

Deviation

The deviation displayed on the right side of the monitor is the difference between the last measured actual value and the nominal value.

If a control interface is used, each correction value put out to the CNC machine is marked with a blue dot. The last issued correction value is displayed at the right side of the diagram as blue numerical value.



M40118.V03

Xb-s card

The Xb-s card shows process characteristics of a measurement point with the last 25 sample results. For process control, the Xb-s quality card display is recommended as it reacts most sensitively to changes in location and variance.



Xb-R card

The Xb-R card shows the course of the process of a measurement point with the last 25 sample results. For process control, the Xb-s quality card display is recommended because it is most sensitive for changes in location and variance.



40118V3E.DOC 03/2017 Page 9 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

M40118.V03

List

The list shows in a detailed numerical overview the last measuring values for all measurement points. This display mode is useful, if one specific measuring value is to be examined.

More frequent are the following output modes:

- quality card for process control
- bar chart for the measuring value display

Deviation Actual value - nominal value

PROCON Measuring Compute	r Material No.: 030 0	60 165 001 Equ	ipm.No.: 56365 :Li	ist		×
meas.point	Nominal	UL	LL	Actual	Deviation	
Kugel Ø	29.985	0.02	-0.02	29.988	0.003	
Kegel Ø	20.026	0.026	-0.026	20.027	0.001	
Schaft Ø	12.94	0.02	-0.02	12.94	0	
Kegellänge	20.845	0.155	-0.155	20.838	-0.007	

Page 10 of 40

User's manual:

M40118.V03

Automatic zeroing (also possible in operating mode SETUP)

Automatic zeroing = offset adjustment

Automatic zeroing is necessary periodically after a fixed time or a number of manufactured units. With this function, the measuring unit determines a correction value and carries out a system check at the same time.

correction value = actual value - setup master

The correction value is used to fine-adjust the tracer position and to compensate changes caused by temperature coefficients. Deviations bigger than the predefined max. correction range indicate failures.

Process:	insert setup master
	set one or all tracers to zero

Set

Yes the measured value lies within the allowed max. correction range.

No the measured value lies outside the allowed max. correction range.
 Please check whether the setup master is inserted correctly.
 If a repeated zeroing does not result in Set = Yes, the corresponding tracer must be adjusted in position tracer.

Correction value = Deviation of the tracer from 0

New Value of the current offset adjustment

Old Value of the previous automatic zeroing" cycle

A comparison between **New** and **Old** shows the changes over time.

In case of substantial deviations, zeroing should be repeated in order to prevent that a faulty measurement in automatic zeroing causes mesurement errors.

юсо	N Measuring	Computer	Material No.	: 030 060 165 00	1 Equipm.No.: 56	365 :Automatic z	eroing
	Tracer	Set		NEW readjust valu	OLD readjust value	Ная. соп.	Zero counter
		"NO"		0	-0.001	1	600
		"NO"		0	0.001	1	600
1		"NO"		0	0	1	600
		"NO"		0	0	1	600
5		"NO"		0	0	1	600
5		"NO"		0	-0.001	1	600
<u> </u>		"NO"		0	0	0	0
\$		"NO"		0	0	0	0
					_		_
		2		5 E		A11	
	-		1			201	
_					_		-
	40440\/0				00/0047		Dere 11 of 10

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User's manual:

M40118.V03

Display test plan

_	the second se		Index .		Equipment No.	D4	signation			
	"030 060 16	5 001*			*56365*	• К	ugetzapten"			
	Heas.point		Heas.device		Constant X01	Co	Instant X02		_	
)	"Kugel Ø"		"Procon"		0	0				
	Linkage: Zer	o value +			Start channel					
)	"E01 E02 +"				1					
	Nominal	Zero va	lue Setup maste	r UL	L		Classes	Width		
1	29.985	29.985	29.988	0.0	2 -0.02		8	0.005		
	Collective ar	alysis	UI.		u	Sa	mple		_	
1			"NOT GOOD"		"NOT GOOD"	5				
	Size	Single v	al.ca Avg value ca	a s-c	ard R-card		Unit			
1	"UCL"	0.016	0.008	0.0	07 0.04		"mm"			
	"LCL"	-0.016	-0.008	0	0		"mm"			
2	"Classes"	10	8	5	5		"mm"			
1	"Width"	0.003	0.002	0.0	01 0.008	_	"nn"			
										>

With the UP/DOWN function, all available measurement points as well as the further settings may be displayed one after the other.

Display test plan (2)



User's manual: M40118.V03

Display test plan (3)

meas.point In Inominal vak/Variance Allocation Samsomatic F	
neas.point In Inominal val/Variance Allocation Sansomatic	
meas.point n nominal valv Variance Allocation Samsomatic F	
	aktor
1 1 3 29.985 0.003 0 0 1	
2 3 20.026 0.003 1 0 1	
2 3 3 12.94 0.003 2 0 1	
3 0 0 0 0 0 0)
3 0 0 0 0 0 0)

Display test plan (4)

	Legena	1	12	13	T4	15	16	17	18
	Factor	<u>.</u>	-	1		1	1	0	0
2	"IL MD"	0.000	0.000	0.000	0.990	0.000	0.000	0	0
2	"I MB"	0.333	0.333	0.333	0.333	0.333	0.333	0	0
4	"Zeroing after n units"	0.00	600	600	600	600	0.03	0	0
5	"Zero counter"	600	600	600	600	600	600	0	0

Page 13 of 40

User's manual:

M40118.V03

5. Selection of operating mode SETUP

The password window opens. The unit will only switch into SETUP mode after entering the correct identifier/password. If external function keys with AUTOMATIC-SETUP switch are connected, the external switching and the switching via password work equivalently parallel. The operating mode AUTOMATIC is only selected, if both are set on AUTOMATIC.

PROCOR Measuring Computer Material No.:030.060.165.001 Equipm.No.:56365 5.5.2010 16:13:1denti	fier		×
Please enter identifier:			
	1	2	
	з	4	
	5	6	
	7	8	
	9	0	
		>	

If a wrong password was entered, an error message is displayed.

PROCON Measuring Computer Material No.2030.060.165.001 Equipm.No.256365 5.5.2010 16:13:1dents WRONG identifier !	fier		×
	1	z	
	з	4	
	5	6	
	7	8	
	9	0	
		>	

40118V3E.DOC 03/2017 Page 14 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

6. Operating mode SETUP

Basic settings in operating mode SETUP:

The yellow background indicates the operating mode SETUP. By pressing the buttons, the required display mode is selected.

Position tracer

This display serves for the approximate adjustment of the tracer. It is needed for mechanical changes, a change of tracer or if the tracer is no longer in the adjustment range.

- <u>Process:</u> Insert setup master Carry out adjustment for all tracers. The accuracy of adjustment should be at least 1/2 of the correction range (cf. test plan).
- <u>Tracer No.</u>: No. of the tracer in the measuring unit, corresponding to the label on the back panel.
- <u>Tracer value:</u> Measuring value without consideration of the factor.



Select or delete test plan

The selection window for test plans opens. The available test plan groups are displayed, sorted by the first 3 digits of the drawing number.

PROCON Heasuring Computer	Haterial No.:030.060.16	5.001 Equipm3ia:553	5 5.5.2010 16:13		×
PROCON Heasering Competer	Platerial No.030.060.10	5.001 Equipm.No.563	65 5.5.2010 16:L3:T	rst plan	×
<					
	001				
	030				
	035				
				Upload t	est plan
					*
	AUTO	Import	Export	Select test plan	Position tracer
And 5 YoB M 40118 YOB	Meas. continuously	Diagnostics	0	Automatic zeroing	Display test plan
Venior: 363_4048FEVA/WHGU	N1703 NET	VORK CONNECTED PM	Appla/AZAPPEM		

By pressing the button on the left of the respective test plan group, the relevant group may be selected. The drawing number as well as the equipment number of the available test plans are displayed.

	035 063 457 2				
	035 063 457 2	00 04 40TTE	•		
		206-01 13775	8	-	
				-	
				Upload t	est plan
				_	
				-	
				-	
>					*
	AUTO	Import	Export	Select test plan	Position tracer
And 5 Vol N40118 V03	Meas. continuously	Diagnostics	43	Automatic zeroing	Display test plan

40118V3E.DOC 03/2017 Page 16 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

M40118.V03

By selecting the required test plan, the query window Upload test plan/Delete test plan is opened.

Upload test plan: The respective test plan is uploaded and activated.

PROCON Heaturing Compute	o Material No. (010.060.16	5.001 Equipm.No.563	65 5.5.2010 16:13	Select test plan	2
· · · · · · · · · · · · · · · · · · ·	035 063 457 2	06-01 137758	8		
]			Upload	test plan
	i			Delete	est plan
					-8-
	AUTO .	Import	Export	Select test plan	Position tracer

Program option "+V" gives the possibility of selecting test plans by scanning their drawing number from barcodes. Please refer to the description under 10. (page 36).

Delete test plan: This button is marked in yellow. When pressing this button, the colour changes to red. When pressing the button again, the test plan is deleted. NOTE: Only non-active test plans may be deleted.

	063 457 206	3-01 1377 5	8	Upload	test plan
				Upload	i test plan
					_
				Delete	test plan
		_			*
	AUTO	Import	Export	Select test plan	Position tracer
nd & Volt M40118.VE3		Disgnostics	4.9	Automatic peroing	Display test plan

40118V3E.DOC 03/2017 Page 17 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

User's manual: M40118.V03

Configuration menu <- >

The button <- > opens a sub-menu with on-screen keyboard.

			No.of values	Kugel Ø	Devia	tion
			0	29.98	38	
					23.99	
				1000	20	
			lo.of values	Kegel Ø	Devis	tion
			0	20.02	25	
					20.02	
				20	20	05
			No.of values	Schoft Ø	Devia	tion
			0	12.94	10	
					12 94	
				C. La C.	12.95	
			No.of values	Kegellänge	Devia	tion
			0	20.84	9	
					<mark>20.</mark> 85	1
				20	8	21
AUTO	Import	Export	Select	test plan	Position tr	acer
	8					_

When opening this sub-menu for the first time, a new identifier/password for this configuration menu needs to be defined (password prompt marked in yellow).

etsian: 100																ĸ
	Pl	ease (enter	new	iden	tifier	(8-0	ligit)	Ente	er				Now par	roword	
													0	Delete all t	iest plans	
													Now	identifier /	NUTO/SETU	p
Bildech insetan ban ba	tur	_														ناعلم
sc °^	1	2 5	3 5	4 8	5 8	6 /	7	8) ₉	⁻ 0	2.6	1.1	Rü	ick	Pos1	Bid auf
ab q	w	e	r	t	z	u	i i	0	P	T	ü	* +	_		Ende	Bild at
eststell a	s	d	f	9	h	j	T	<	1	ö	ä	1.4	1	-	Einfg	Pause
msch > <	y	x	с	v	b	n	m	1E	. [:	. I		Umsch	1	Entf	Druck	Rollen
100 Av	ΔI+ I			_	_	LA	tar	E.	Enk	e 🖡	Ira	6	14	1 ÷ 1	Optionen	Hilfe

40118V3E.DOC 03/2017 Page 18 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

This new password needs to be confirmed (password prompt marked in green).

ICON Heavoring Computer Haterial No.030.060.165.001 Equipm.No.56365 5.5.2010 1613 2004 Heavoring Computer Haterial No.030.060.165.001 Equipm.No.56365 5.5.2010 1613 merc 100	: Konfiguration
Please confirm new identifier (8-digit)-Enter	New password
	Delote all test plans
	New identifier AUTO/SETUP
Keyboard	

The new identifier must then be entered once more in order to enter into the configuration menu (password prompt without colour).

PROCOV Heavaring Competer Haberial No. 030.060.165.001. Equipm.No.56345.5.5.2010. 10: 2007/011 Heavaring Competer Haberial No. 030.060.165.001. Equipm.No.56345.5.5.2010. 16:	13 Definition
Venior: 100	x
Please enter identifier (8-digit)-Enter	Now password
	Delete all test plans
	New identifier AUTO/SETUP
Keyboard	

M40118.V03

If a wrong password is entered, the password prompt is marked in red. It is possible to enter the password a second time. After input of the correct password, the configuration menu with the following options is opened:

New password

Delete all test plans New password AUTO/SETUP Further settings Test plan group / ("Prüfplangruppe") (with OPTION "N")

PROCON Measuring Computer Material No.3001.045.950.001 Equipm.No.Hand 26.2.2015 13:1 PROCON Measuring Computer Material No.3001.045.950.001 Equipm.No.Hand 26.2.2015 13:	IS
Version: 100	New password
	Delete all test plans
	New identifier AUTO/SETUP
	Further settings
Prüfplangruppe (max. 8 Zeichen) ZAPFEN Keyboard	x

New password

This option makes it possible to change the password for the configuration menu. A new identifier/password may be entered (password prompt marked in yellow).

PROCON Heavaring Computer Natural No.2012.045.650.001 Equipm.No.Hand 26.2.2015 13:13 PROCON Heavaring Computer Natural No.2012.045.950.001 Equipm.No.24and 26.2.2015 13:1	Sufconfiguration
Vetor: 100	New password
Please enter new identifier (8-digit)-Enter	Delote all test plans
	New identifier AUTO/SETUP
	Further settings
Philplangrappe (max. B.Zeichen) ZAPVIN Keyboard	×

The new password must be confirmed (password prompt marked in green).

RECOVE Heavaring Computer Natural No.501.045.950.001 Equipm.No.51and 26.2.2015 13:1 PROCOM Heavaring Computer Natural No.501.045.950.001 Equipm.No.51and 26.2.2015 13: Numer. 201	s j IS:Konfiguration
	New password
Please confirm new identifier (8-digit)-Enter	Delete all test plans
	New identifier AUT0/SETUP
	Further settings
Philiplangrappe (max. B.Zeichen) ZAPETN Kayboard	×

40118V3E.DOC 03/2017 Page 21 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

M40118.V03

Delete all test plans

The button "Delete all test plans" makes it possible to delete all test plans available in the PROCON measuring computer, except for the currently active test plan.

•
ETUP
×

After selection of this option, the button is marked in red.

PROCON Heavuring Computer Naterial No.201.045.950.001 Equipm.No.Hand 26.2.2015 12:1	5 X
PEOCON Heavaring Computer Haterial No.2011.045.950.001 Equipm.No.3Nand 25.2.2015 13:1 Venior: 100	S:Xenfiguration
	New password
	Delete al test plane
	New identifier AUTO/SETUP
	Further settings
Philplangruppe (max. B Zeichen) ZAPVIN Keyboard	×

40118V3E.DOC 03/2017 Page 22 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

By pressing the red button again, the test plans are **irrevocably** deleted. The green colour of the button shows that the test plans have been deleted successfully.

New paraword
Dollates off-treat planes
Now identifies AUTO/SETUP
Further settings
×

New password AUTO/SETUP:

This option makes it possible to change the password for switiching into SETUP mode from AUTOMATIC mode. The newly created identifier/password must be entered (password prompt marked in yellow).

PROCON Heavaring Computer Haterial No.:001.045.950.001 Equipm.No.:Hand 26.2.2015 13:13 PROCON Heavaring Computer Haterial No.:001.045.950.001 Equipm.No.:Hand 26.2.2015 13:1 Vision 100	St. Konfiguration
Please enter new identifier (8-digit)-Enter	Delete all test plans
	New identifier AUTO/SETUP
Pridplangruppe (max. # Zoichen) 2AITEN Keyboard	Futher settings X

40118V3E.DOC 03/2017 Page 23 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

The new password must be confirmed (password prompt marked in green).

PROCON Heasuring Computer Historial Rec001.045.950.001 EquipmUkschool 26.2.2015 13:15 PROCON Heasuring Computer Haterial Rec001.045.350.001 EquipmUkschool 26.2.2015 13:15	Excelligeration
10001 100	New paraword
Please confirm new identifier (8-digit)-Enter	Dulete all text plane
	New identifier AUTO/SETUP
	Futher settings
Prülplangruppe (max. 8 Zaichen) ZAPVEN Keyboard	×

Page 24 of 40

User's manual: M40118.V03

Further settings



Settings for Cp/Cpk values:

The display of Cp and Cpk values may be switched on or off for operating mode AUTOMATIC.

With the 3 coloured buttons

Cpk >= 1.33 Cpk < 1.33 Cpk < 1.00the colour mark for the display of the Cpk values may be changed.

With the 8 buttons "Cp/Cpk: ON" bzw. "Cp/Cpk: OFF", the display of Cp/Cpk values may be switched on or off.

Interlock tracer error:

A tracer control is constantly running in the background. The batch size for the recognition of a tracer error is set to 5. This means that in case an error is found after 5 measuring cycles, a corresponding message is put out. If the setting "Interlock tracer error: YES" is activated, the machine will also be stopped in case of an error.

Standard job number:

If "Standard job No.: YES" is defined, the job number only needs to be entered once. If "Standard job No.: NO" is active, a job number needs to be entered every time when selecting a new test plan (cf. 7. on page 32).

40118V3E.DOC	03/2017	Page 25 of 40
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User's manual:

M40118.V03

Max. tracer deviation (only with OPTION "K"):

Tracer control during calibration (automatic zeroing):

Prerequesite for the control is that the defined measurement point measures diameters with the linkage tracer A + tracer B. These two tracers must be arranged counter-directionally. It is checked that the deviation of the tracer sums of the current calibration cycle in comparison with the previous calibration cycle do not exceed a predefined limit value. Thus, problems in the mechanical parts or tracer errors will be discovered.

Configuration settings for monitoring the AUTOZERO plausibility:

YES/ON: limit > 0,003 μ m and < 0,030 μ m means control is active. NO/OFF: limit = 0,030 μ m means control is inactive. The limit value may be changed through the buttons "+" and "-".

Obligatory prerequesite is the paired allocation of the tracers to one measurement point:

Measurement point 1 = tracer 1 and 2 Measurement point 2 = tracer 3 and 4 Measurement point 3 = tracer 5 and 6 Measurement point 4 = tracer 7 and 8

If this option is installed and the control has been activated, the deviation is displayed as numeric value as well as coloured mark after automatic zeroing: green = GOOD, red = NOT GOOD.

PROCON	Measuring	Computer	Haterial No.:001.	045.950.001	EquipmJlo.:	Hand 26.2.201	5 13:15			<u>×</u>
PROCOM	(Measuring	g Computer	Material No.:001	.045.950.001	L Equipm.No.	Hand 26.2.20	15 13:15:	Automa		
	Tracer	Set	NEW value	OLD value	Max. con.	Zero count	NEU-ALT	Abw.		
		WEC*	0.0015	0.0015	0.1000	0.0000	0.0000	_		
1		"NO"	0.0000	0.0015	0.0000	0.0000	0.0000	0.0000		
- 3		"NO"	0.0000	0.0007	0.0000	0.0000	0.0000	0.0000		
4		"NO"	0.0000	-0.0713	0.0000	0.0000	0.0000	0.0000		
5		"NO"	0.0000	-0.0013	0.0000	0.0000	0.0000	0.0000		
6		"NO"	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000		
7		"NO"	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000		
8		"NO"	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000		
_										
1										
_	_					_				
0							All			
0						_				
<u> </u>	7 1.1 11			_		-				
	7 J00 N0	λ.	AUTO		import	EX	port	Select t	est plan	Position tracer
And: 5 V	/a8 M40118.	V03	Meas. continue	ously D	agnostics		.>	Automati	c zeroing	Display test plan
Version:	364-DABFEV	WWHEU-K1	1703							

40118V3E.DOC 03/2017 Page 26 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

User's manual:

M40118.V03

Test plan group / ("Prüfplangruppe") (with OPTION "N")

This function is relevant for the program option with automatic network mode. Into this field, the test plan group (max. 8 letters) may be entered. Test plans will then be imported from the respective folder of that test plan group from the defined network (e.g. network path/prplan/[test plan group]). This folder is displayed in the network path as described on page 35.

If the on-screen keyboard was closed manually, it may be re-opened by pressing the button "keyboard".

Exit the configuration menu by pressing the button "X".

Import test plans

A security query is displayed:

PROCON Measuring Computy	r Material No.: 030	060 165 001 Equip	um.No.: 56365		×		
PROCON Measuring Comput	RDCON Measuring Computer Material No.: 030 060 165 001 Equipm.No.: 56365 :Copy 🕺						
Import test plan							
CONTINU	e Y	'ES - Co	ntinue				
Abort NO - Abort							
	MUTO	Import	Export	Select text plan	Peatien tracer		
And: 5 Volt M40118 V03	entering continues.	Diagnostics		Automatic zeroing	Display levil plan		

Return into the main menu by selecting "ABORT".

By pressing CONTINUE, all test plans available on the external storage device will be imported.

Page 27 of 40

User's manual: M40118.V03

If no test plan is found, an error message is displayed.

PRDCON Measuring Computer Material No.: 030 060 165 001 Equipm.No.: 56365							
PROCON Measuring Comput	er Material No.: 030	0 060 165 001 Equi	am.No.: 56365 :Cop		×		
Import test plan Please wait ERROR !							
No test plan available !							
Jab No.: 80124609	AUTO	Import	Experi	Select test plan	Position tracer		
And & Vo8 M40118.V03	Meas, continuously	Diagnostics		Automatic zeroing	Display test plan		

Export test plans/measuring values

All available test plans or all measuring values may be exported.

PROCON Measuring Computer Material No.	: 030 060 165 001 Equip	um.No.: 56365		×
PROCON Measuring Computer Material No	.: 030 060 165 001 Equi	pm.No.: 56365 :Cop	π	×
Export test p	olans/meas	values		
CONTINUE: test plans	YES - Co	ntinue		
Abort	NO - Abo	rt		
NUTO	Import	Export	Select test plan	Position tracer
And: E Vol: N40118-V03	Diagnostics		Automatic zeroing	Display test plan
Versiev: 336W1701 NET2WERK, VERBUNDEN	1			

40118V3E.DOC 03/2017 Page 28 of 40 Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany Phone: +49 4182-289 760 Fax -289 761 email: info@arndtundvoss.de http://www.arndtundvoss.de

The measuring unit checks if a USB storage device is connected. If none is connected, an error message is displayed.

ROCON Measuring Computer Material No.: 030 060 165 001 Equipm.No.: 56365							
Export test plans/meas.values							
Please wait							
ERROR ! Data device missing !							
	AUTO	Import	Expert	Select test plan	Position tracer		
And 5 Vol M4018/03 Varian: 295N1201	Meas, continuously	Disprestics		Automatic zeroing	Display test plan		

If a USB storage device is connected, the measuring values are saved in the root directory on the USB storage device. Test plans are being exported into the folder \prplan on the USB storage device. If there is no such folder on the device yet, it will be created automatically.

If the unit contains option "N" (automatic network mode), measuring value files are automatically saved into the folder "mwerte" in the defined network (cf. page 35).

After the files have successfully been saved on the external storage device or network, all measuring value files will be deleted from the measuring unit. Test plans will not be deleted.

Page 29 of 40

User's manual: M40118.V03

Measuring continuously

Measuring continuously = system check

To check the measuring device or to examine the shape of a workpiece, a measurement without signal exchange with the machine is frequently required. **Measuring continuously** provides the measurement with all combinations and consideration of the correction value of the function automatic zeroing. The result is the same as in the main function in AUTOMATIC mode.



Diagnostics

The status of the control input is displayed (1= ON, 0 = OFF). Left: Bit 10, Right: Bit 0

The control output may be switched bit by bit with the UP/DOWN function. Left: Bit 15, Right: Bit 0

The unscaled values of the measuring inputs 1-8 are continuously being displayed.

The program version as well as the name of the measuring computer are being displayed.



Meaning of the diagnostics bits:

Control input: 18: start inputs SINGLE S: collective start b: not used U: acknowledge Index/Neue Magd Control output: 1,2,4,8: binary correction value uni 10,20,40,80: binary correction value -: algebraic sign of the correction v C0,C1: code bits 0,1 N0,N1: number of control interface M: values for Index/Neue Magdebu S: control bit Samsomatic is ready B: Procon BUSY	eburger ts digit e tens digit alue Bit 0,1 ırger are ready	
40118V3E.DOC	03/2017	Page 31 of 40
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7. Entry of job number

By pressing the button "Job No." in the bottom left corner of the screen, the window for entry of the job number is opened. After entering and confirming the job number, it is saved and allocated to the subsequent measuring results.

Entering the job number is possible in the operating modes SETUP and AUTOMATIC.



Program option "V" offers the possibility of importing the job number from barcodes via barcode scanner. Please refer to the description under 10. (page 36).

Page 32 of 40

If no job number has been entered yet for the active test plan, the red message "Job No." appears.

PROCON Measuring Computer	Material No.:001.025.8	170.001 Equipm.No.:Try	Out 26.2.2015 13	15		2
25.890-00000000000000		ODDECCCOMODDECCS		No.of values	Bohrungs Ø	Deviation
25.885-		000000000000000000000000000000000000000		0		
25.880-						
25.875-					-11	000
25.870			0		25	88
	Job No.					
Job No.:	SETUP	Xb-s card	Xb-R card	Single v	alue card	
Arndt & Voß M40118.V03		List		Automat	ic zeroing	Display test plan
Version: 363 4-DABFEV/W/WHGU	N1703 NE	TWORK CONNECTED Pa	th \piplan\ZAPFEN\			

8. Test plan/measuring value files

Import test plans:

The test plan created in MODAS/ProconNT format has to be in the root directory of the USB storage device. In the measuring computer, the files will be renamed according to the following pattern:

drawing/material number + index/equipment number.

Example:

drawing No./material No.: 039.543.123.678; index No./equipment No.: NU132 The file name will be: 339 543 123 678 NU132 (cf. page 16-17, test plan selection).

Export test plans:

All test plan files available on the measuring computer will be transferred into the sub-folder "prplan" on the storage device.

40118V3E.DOC	03/2017	Page 33 of 40
Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany		
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User's manual:

M40118.V03

Export measuring value files:

All measuring value files available on the measuring computer will be transferred into the root directory of the storage device. With option "N" (automatic network mode), the files are transferred automatically into the folder "mwerte" on the defined network when selecting a new test plan. In case a file with an identical name is already available, an error message is displayed and the file will not be overwritten. After a successful data transfer, the measuring value files will be deleted from the measuring computer and the measuring value counter will be set to zero.

PPQ5 measuring value format:

File name: contains machine identification, date/time, material/drawing No. and machine No. (cf. example) CSV

File ending:

File layout:

File name:

Example: ABx1y2nr_1507270815_006_003_002_001_151617.csv

Data from the file C:\daten\station.tol" in the measuring computer: ABx1y2nr AB: machine identification

- machine No. x1:
- No. of measuring location at the machine v2:
- model No. = 01 (constant value) nr:

Date/time: YYMMDDHHMM: 1507270815

12-digit drawing/material No. in groups of 3 taken from the test plan: 006_003_002_001 The format with number of digits as well as the separation with points or underscores is required.

Machine/equipment No. taken from the test plan: 151617

File content:

(Column separatior: semicolon) one row per measuring value

material/drawing No. (OPTION "Q": drawing No. + index) (taken from the Column 1: test plan)

- Column 2: job No. (entry in the measuring computer; 12 digits)
- workstation (taken from the test plan; 10 digits) Column 3:
- Column 4: measuring device No. (deposited in the measuring computer.
 - Text file "pmnr.tol")

date/time Column 5:

Columns 6 - 45: max. 8 measurement points with 5 columns each. In case of less than 8 measurement points, the column separators (semicolon) are still set for 8 measurement points.

1. UL = upper limit (taken from the test plan)

- 2. LL = lower limit (taken from the test plan)
- 3. UCL = upper control limit (taken from the test plan)
- 4. LCL = lower control limit (taken from the test plan)
- 5. measuring value

Example:

Material/drawing No.;job No.;workstation;measuring device No.;date/time;MP1 UL;MP1 001.045.950.001-Hand;1234;Hand;33003;26.09.2016 *MP* = *measurement point*

40118V3E.DOC	03/2017	Page 34 of 40
Arndt & Voß GmbH - Eichhofstr. 7 - D-21255 Tostedt/Germany		
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User's manual: M40118.V03

9. **OPTION:** network connection

If the PROCON measuring computer contains option "N" (automatic network mode), the status "network connected" or "network missing" is shown at the bottom of the display. If the network is connected, the defined network path is displayed as well.

The defined network path must lead to a location in the network which contains the two folders "prplan" and "mwerte". The folder "prplan" may contain sub-folders for different test plan groups. In the example photo below, the test plan group and its respective sub-folder are called "ZAPFEN". The test plan group may be defined as described on page 27. Test plans will then be imported from the respective sub-folder of that test plan group from the network. Via the "Export" function in SETUP mode, measuring value files are directly saved onto the network, namely into the folder "mwerte" (cf. page 27).

Network functions

- Automatic query and transfer of new or changed test plans from the QS server when starting the program or when selecting "Automatic zeroing".
- Automatic saving of measuring values on the QS server under "Upload test plan".



Status: "network connected"

Page 35 of 40

10. OPTION: Import of job number and selection of test plans via barcode scanner

This program option makes it possible to import job numbers from barcodes via barcode scanner. The barcode scanner is connected to the PROCON measuring computer via USB interface. The barcode information is read and imported by the measuring program.

Apart from importing the job number, the enhanced option "+V" makes it possible to select a test plan by scanning its drawing number from a barcode. As several test plans may be available for one material number which are only distinguished by the equipment number, an unambiguous assignment is necessary. This is achieved by storing the equipment number in the PROCON measuring computer. A plausibility check of the scanned data is carried out.

11. Connection schematics

Arndt & Voß GmbH Elektronik - Meßtechnik

User's manual:

M40118.V03



User's manual:

M40118.V03



Page 38 of 40



Page 39 of 40

User's manual: M40118.V03

Security instructions according to VDE 0411

time for warming up		
temperature		
atmospheric humidity		
frequency		
power supply voltage		
security		

20 minutes 0...+40 degrees C up to 75% rel. 50/60 Hz 115-230V +10%, -15% according to VDE 0411, protection class 1

This unit was built and checked under DIN 57411 part 1/VDE 0411 part 1 and left the factory in a safe and perfect condition. To preserve this condition and to guarantee a safe working the user has to follow the comments and warnings which are given in these instructions. Before turning on the power, you have to make sure that the voltage of operation and the mains voltage correspond. The mains plug may only be inserted into a socket with ground contact. The safety effect may not be abolished by an extension lead without ground connection. The opening of covers or removing of components, except if it is possible to do by hand, might uncover parts or connections under dangerous voltage. Racks may only be used inside a cover. If an adjustment, a maintenance or a repair at the opened unit under voltage is unavoidable, it may only be done by a qualified employee, who is well acquainted with the dangers involved.

ATTENTION:

After the end of those works, the unit has to be checked according to VDE 0411, part 1. You have to make sure, that only fuses of the given type and values are taken for replacement. The use of mended fuses or short-circuiting them is inadmissible. If it is presumed, that a safe working is not possible, you have to take this unit out of work. Safe work may not be possible, if

- there are visible damages at the unit.
- the unit does not work.
- after longer storage under unfavourable circumstances.
- after heavy stress of transport.