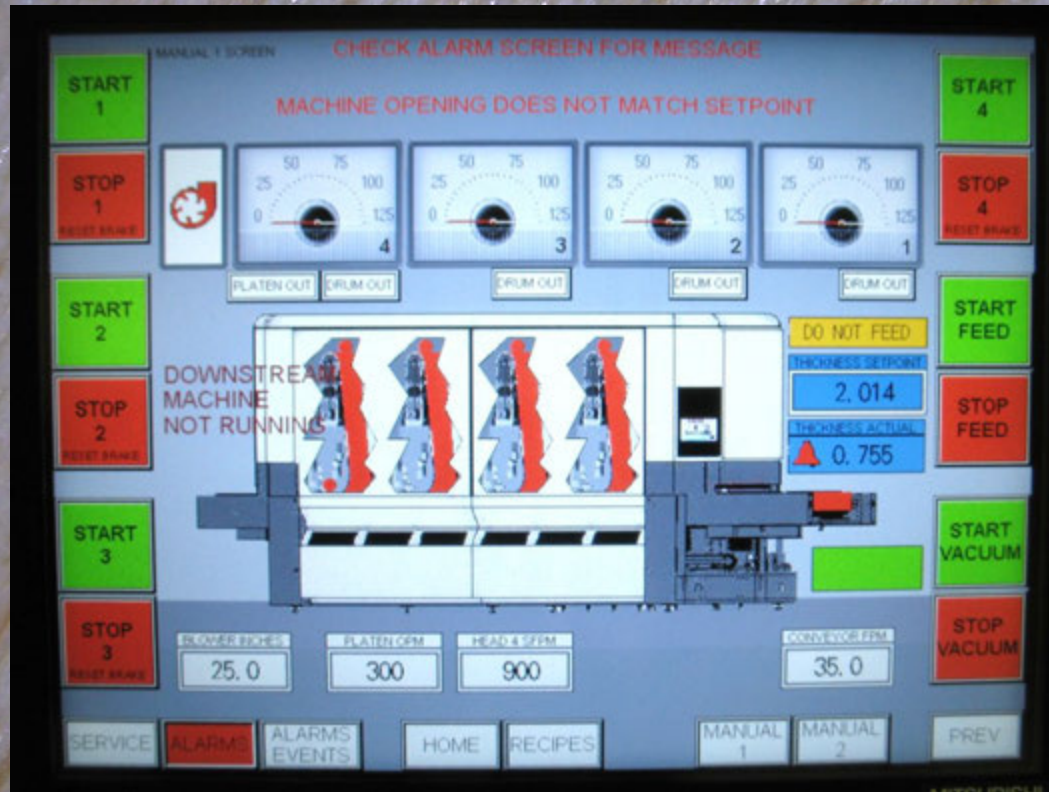


# Timesavers Simple Touch

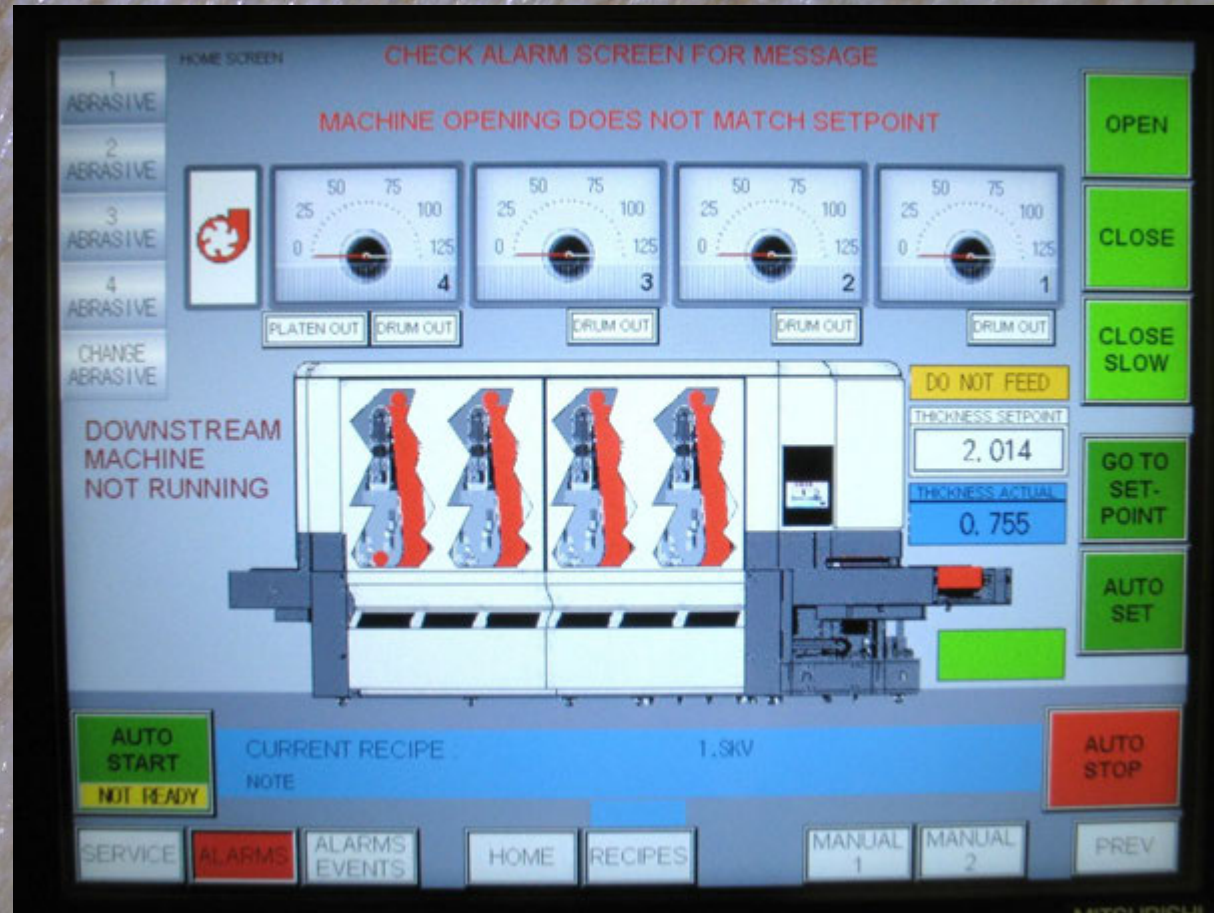


Timesavers New Human Machine Interface System

# Home Screen

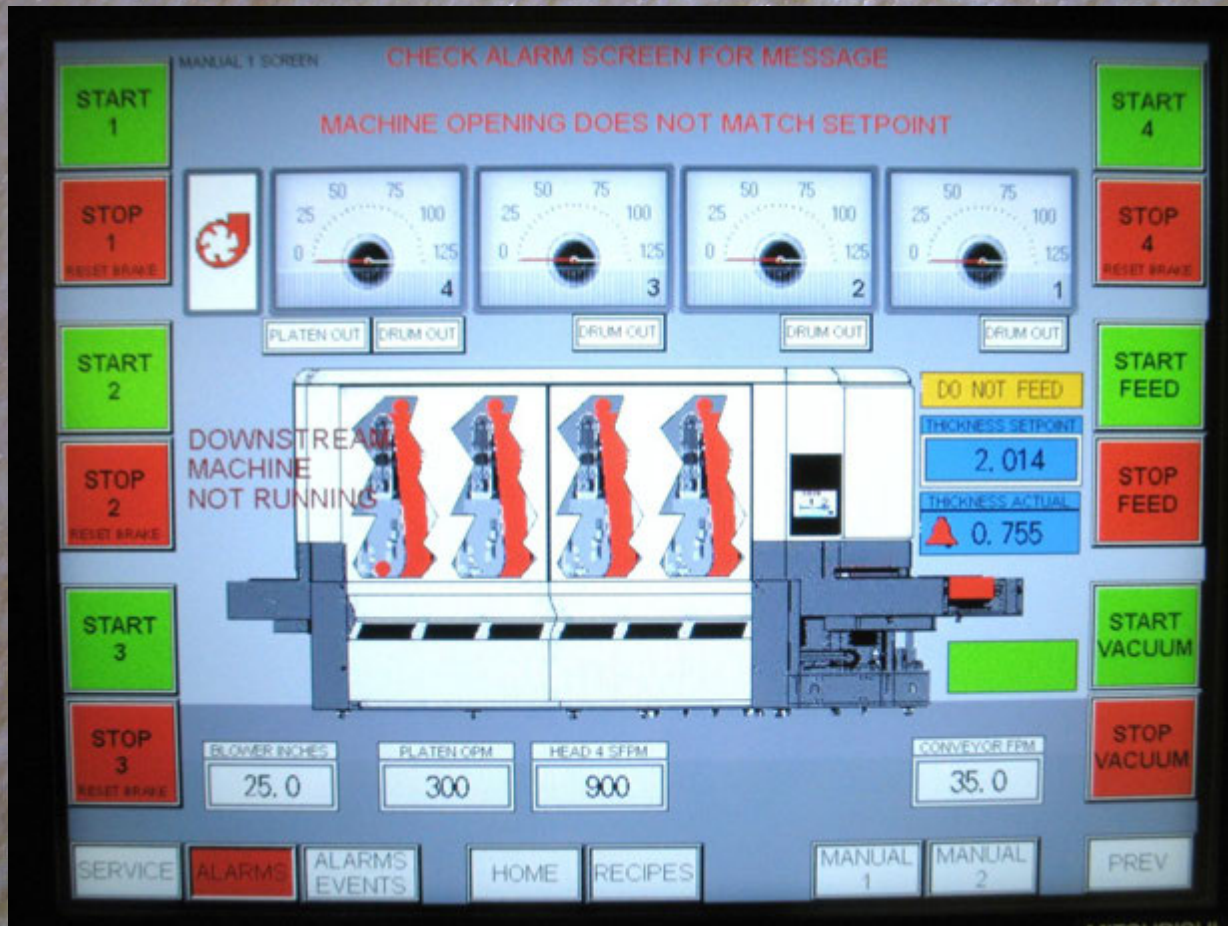
The Home Screen displays all of the overall machine conditions:

- Status of abrasives indicated along left side of screen.
- Motor load on sanding heads. Drums and platen position indicators.
- One button auto start & stop of entire machine.
- Ok to Feed/Do not Feed indicating when the machine is ready to accept product for sanding.
- No Parts in Machine/Parts in Machine indicator to alert when machine is clear of product so adjustments may be made.
- Downstream Machine not Running indicator for machines that are installed in a line of machines.
- Controls for adjusting the thickness setting. Open, Close and Close Slow for manual adjustments.
- Thickness Set Point and Go to Set Point for automatic adjustments.



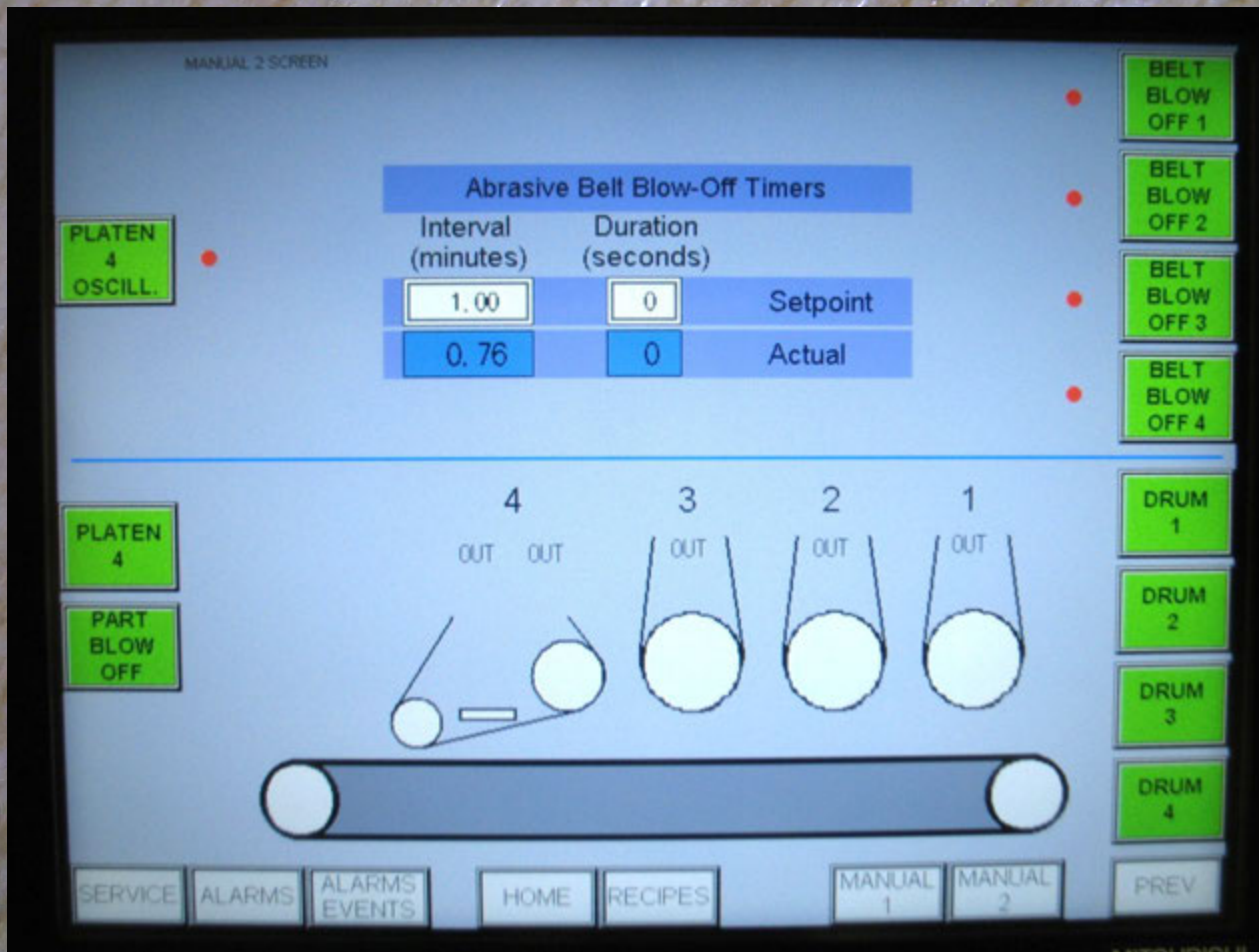
# Manual Screen 1

- This screen contains manual start and stop functions for each head, the feed, and vacuum bed with feedback.
- Also allows for adjustment of all variable speed features.



# Manual Screen 2

Manual control of other machine functions including Platens, Part Blow Off, Belt Blow Off, etc.



# Recipe Screen

- Manage recipes; save, save as, load and delete recipes.
- Displays current recipe detail loaded in the machine.
- These are the settings that the Auto Start function uses.

Current Recipe: 1.SKV

Note:

Parameter	Head 4	Head 3	Head 2	Head 1	Feed	
Motor Speed	On 900	On	On	On	35.0	Save
Conveyor Bed Position Position on/off					2.014 On	Save As
Vacuum Bed Vacuum Level					On 25.0	Load Recipe
Drum Position in/out of Cut Platen Position in/out of Cut	Auto Auto	Auto	Auto	Auto		Delete Recipe
Abrasive Belt Blow-Off Interval (min)/Duration (sec)	On 1.00 0	On 1.00 0	On 1.00 0	On 1.00 0		
Part Blow-Off					On	
Platen Oscillation Speed	On 600					

SERVICE ALARMS ALARMS EVENTS HOME RECIPES MANUAL 1 MANUAL 2 PREV

# Alarm Screen

Records date/time when alarms occur. When alarms are restored they change to green and record the date/time they were restored.

The screenshot shows an alarm screen with the following information:

- Alarms** (Title)
- Number of Alarms 12** (Status)
- 14.09.23 08:43:48** (Date and Time)

Occured	Message	REST.
14/09/22 13:03:40	4th Head Abrasive Belt Mistrack Outboard (LS-4B)	-
14/09/22 13:03:40	3rd Head Abrasive Belt Mistrack Outboard (LS-3B)	-
14/09/22 13:03:40	2nd Head Abrasive Belt Mistrack Outboard (LS-2B)	-
14/09/22 13:03:40	1st Head Abrasive Belt Mistrack Outboard (LS-1B)	-
14/09/22 13:03:40	3rd Head Abrasive Belt Mistrack Inboard (LS-3A)	-
14/09/22 13:03:40	2nd Head Abrasive Belt Mistrack Inboard (LS-2A)	-
14/09/22 13:03:40	1st Head Abrasive Belt Mistrack Inboard (LS-1A)	-
14/09/22 13:03:40	Master Control Power Off (CR-M)	-
14/09/22 13:03:40	4th Head Abrasive Belt Not Tensioned (LS-4D)	-
14/09/22 13:03:40	Outfeed Belt Load Door Open (LS-21C)	-
14/09/22 13:03:40	Infeed Belt Load Door Open (LS-21B)	-
14/09/22 10:49:42	HMI Low Battery	-

Navigation buttons: Page Up, Page Down, SERVICE, ALARMS, ALARMS EVENTS, HOME, RECIPES, MANUAL 1, MANUAL 2, PREV.

# Alarm & Event History Screen

- Records date/time when alarms occur and when they are restored.
- Records date/time when events occur and where they are.
- Events include all functions on the machine such as starting and stopping of motors.

Alarm & Event History 14.09.22 14:58:46

Occured	Message	REST.
14/09/22 13:03:40	Stop Panel Brush	-
14/09/22 13:03:40	Stop 3rd Head Abrasive Belt Blow-Off	-
14/09/22 13:03:40	Stop 2nd Head Abrasive Belt Blow-Off	-
14/09/22 13:03:40	Stop 1st Head Abrasive Belt Blow-Off	-
14/09/22 13:03:40	Downstream Machine Not Running	-
14/09/22 13:03:40	Apply 3rd Head Brake	-
14/09/22 13:03:40	Apply 2nd Head Brake	-
14/09/22 13:03:40	Apply 1st Head Brake	-
14/09/22 13:03:40	End Auto-Start Mode	-
14/09/22 13:03:40	End Auto-Stop Mode	-
14/09/22 13:03:40	Stop Motorized Lift Close	-
14/09/22 13:03:40	Do Not Feed Parts	-
14/09/22 13:03:40	Stop Vacuum	-
14/09/22 13:03:40	Stop Motorized Lift Open	-
14/09/22 13:03:40	Stop Feed Conveyor	-
14/09/22 13:03:40	Stop 3rd Head	-
14/09/22 13:03:40	Stop 2nd Head	-
14/09/22 13:03:40	Stop 1st Head	-
14/09/22 13:03:40	End Bed Go To Position	-
14/09/22 13:03:40	Move 3rd Head Drum Out Of Cut	-
14/09/22 13:03:40	Move 2nd Head Drum Out Of Cut	-
14/09/22 13:03:40	Move 1st Head Drum Out Of Cut	-
14/09/22 13:03:40	4th Head Abrasive Belt Mistrack Outboard (LS-4B)	-

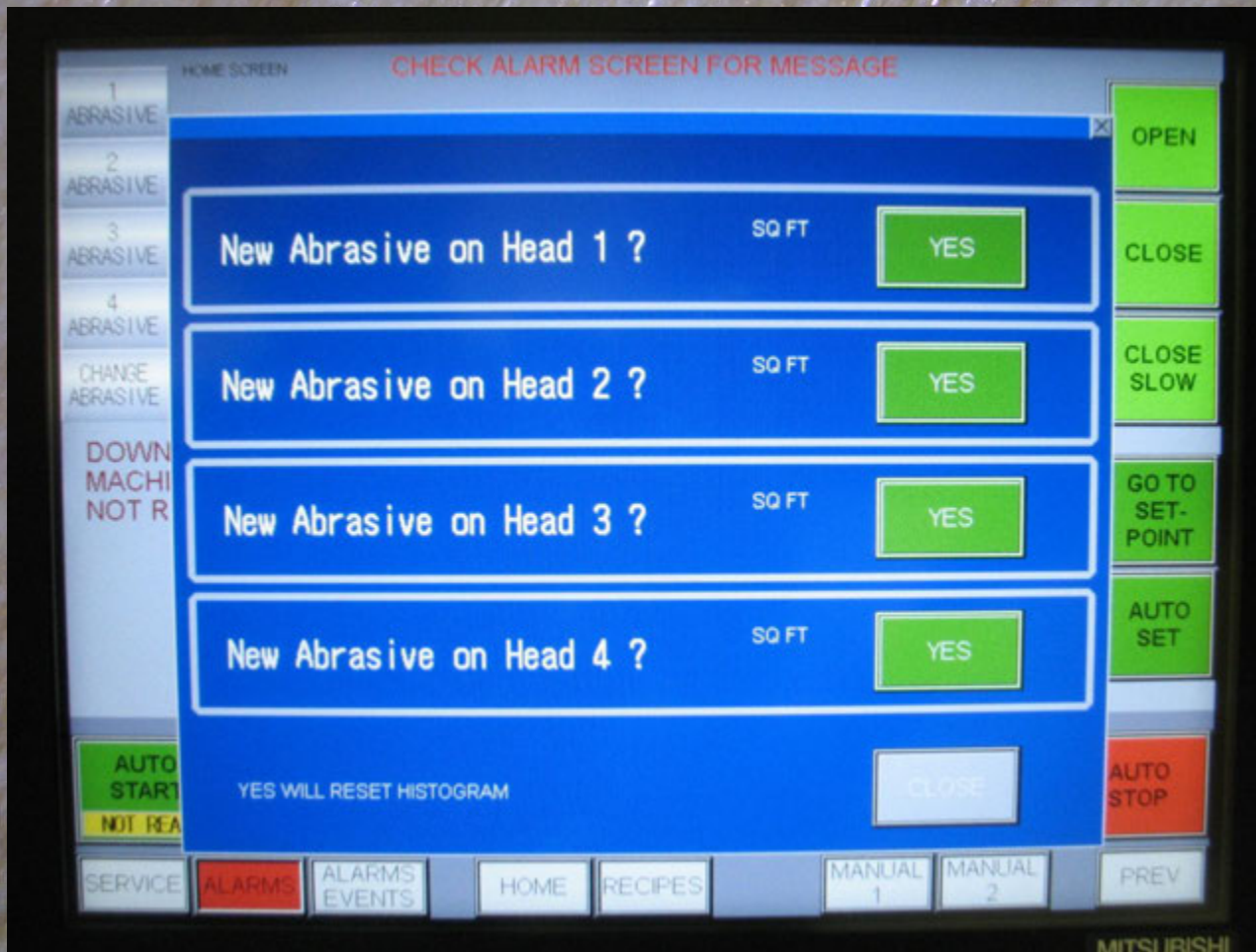
Page Up Page Down

SERVICE ALARMS ALARMS EVENTS HOME RECIPES MANUAL 1 MANUAL 2 PREV

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# Change Abrasive Screen

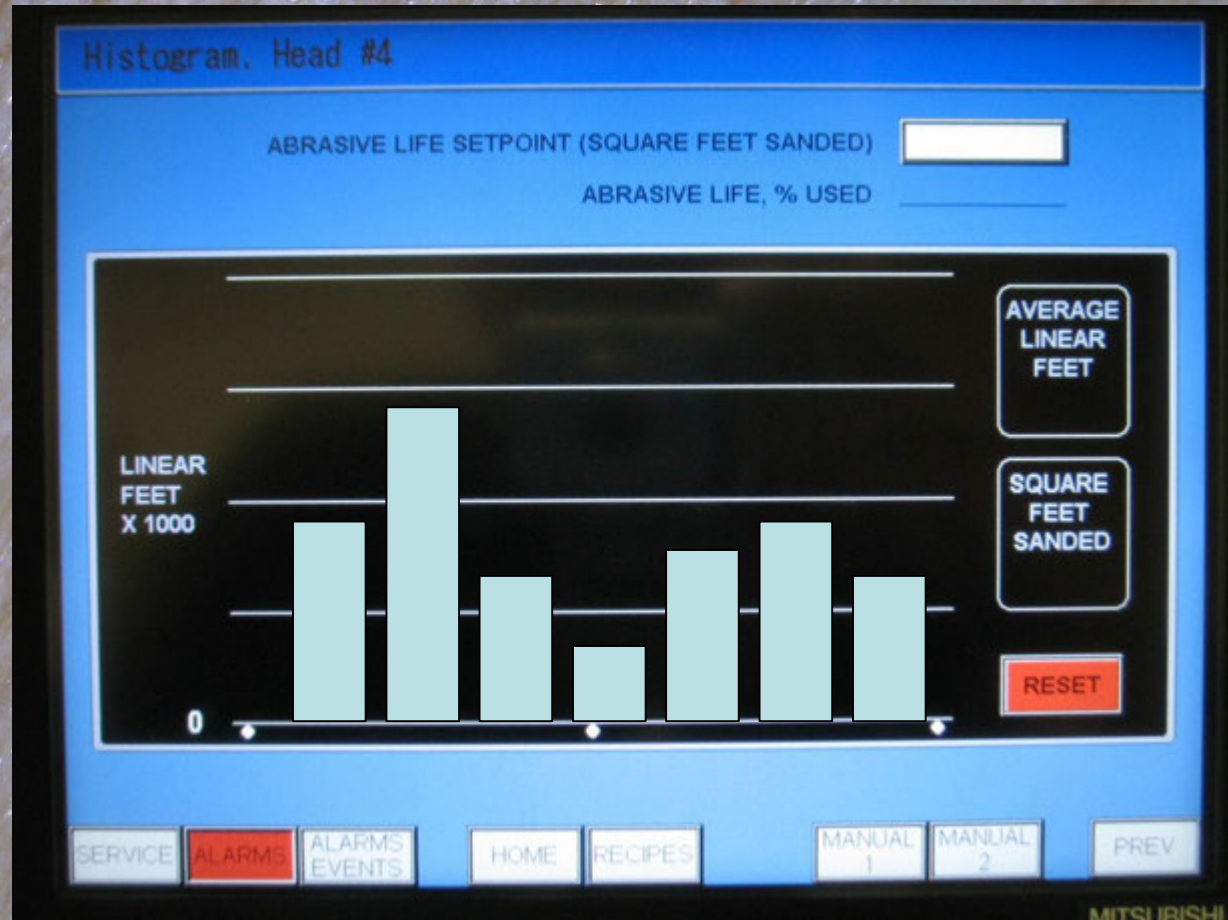
This screen pops up when abrasive belts are tensioned. Press "YES" button when installing a new abrasive belt to reset the Histogram.





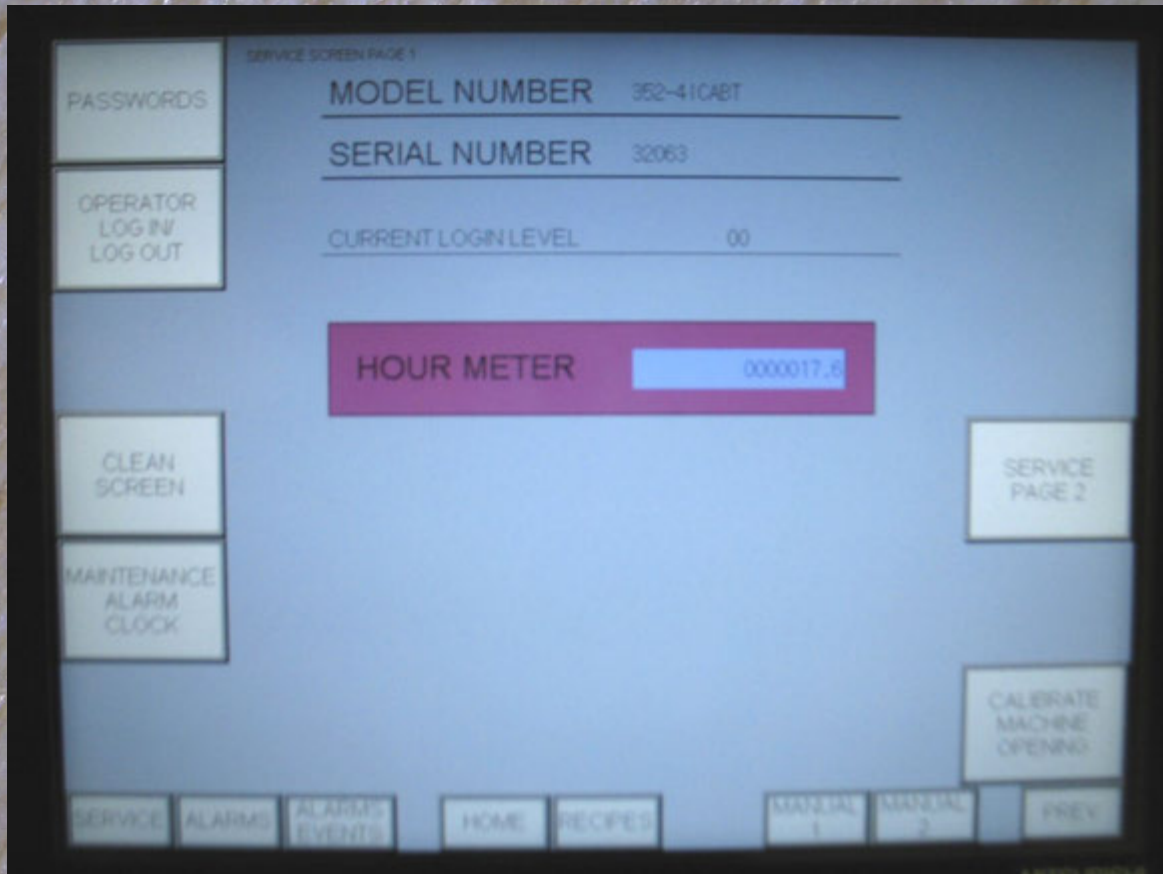
# Histogram Screen

- There is one Histogram for each head.
- Linear feet of material sanded is tracked, square feet is calculated and displayed.
- Belt life set point triggers alarms when 80% and 100% abrasive usage is achieved.



# Service Screen 1

- Machine model, serial number, and hour meter are displayed.
- Operator & Maintenance log-in for access to password protected screens.
- Access to calibrate machine thickness display, password management, preventive maintenance alarm clocks, screen cleaning screen and service screen 2.



# Service Screen 2

- Less used maintenance activities.
- Access to calibrate sanding head motor, load meters, monitor digital and analog PLC I/O, & set time and date
- Also allows adjustment of machine parameters such as time between motor starting, wye-delta starter time, etc.

