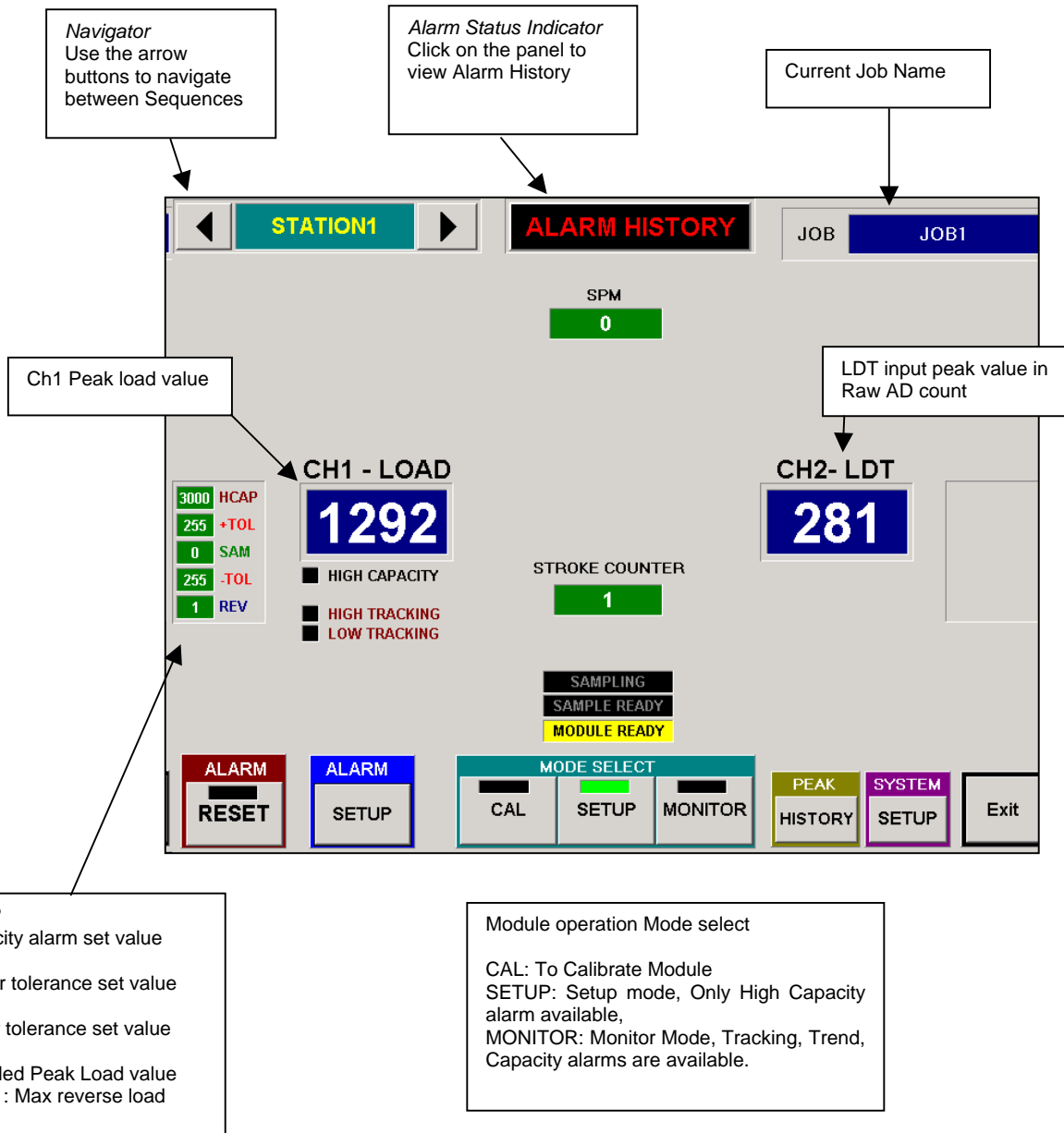


RSTMonLT Software for HM1756 LDT Module Addendum

MAIN TONNAGE SCREEN



ALARM SETUP SCREEN

STATION1 **ALARM HISTORY** **JOB** **JOB1**

CURRENT ALARM SETTING

☐ Group Select **CH 1**

HIGH CAPACITY **1200** **LDT Min Position** **100**

+ TOL **20**

- TOL **20**

ALARM SWITCHES & SETTINGS ☒ Tracking Alarm ☒ AMP Track

LEARNING CYCLE: **0** **2** **4** **8** **16** **TOL. TYPE:** **lb.** **Percent**

ALARM WINDOW: **500** — **950** ms

LOOK WINDOW START: **250** LDT Position **TRACKING TRESHOLD SET:** **10** %

LOOK WINDOW TIME: **2000** ms **SCALE VALUE:** **1200** lb.

EDIT ON **EDIT** **DOWNLOAD** **SAVE TO RECIPE&PLC** **JOB RECIPE** **RETURN**

This is the module's trigger position for monitoring tonnage signal. In reference to our PLM module, LDT position area above the set value becomes the tonnage look window area where High Capacity alarm is being monitored in real time.

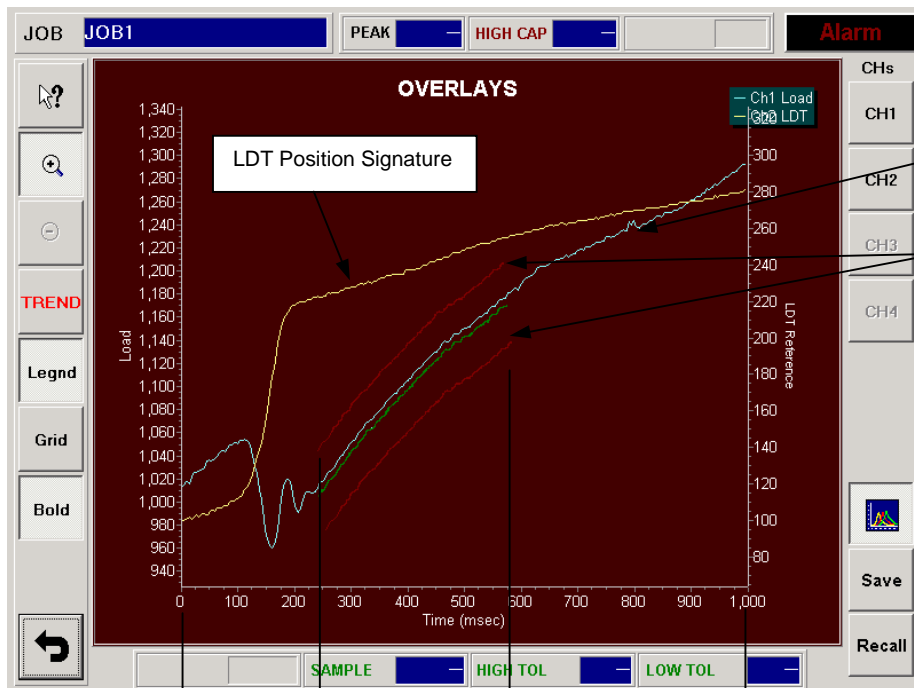
Use MODULE SETUP & CALIBRATION screen to find the optimal position.

You can always adjust LDT Min Position setting to find the optimal trigger position for your application.

Look Window Start position is the raw AD count of LDT position where the module starts to capture signatures for the duration of Look Window Time setting.

The Look Window Start must be set larger than LDT Min Position set .

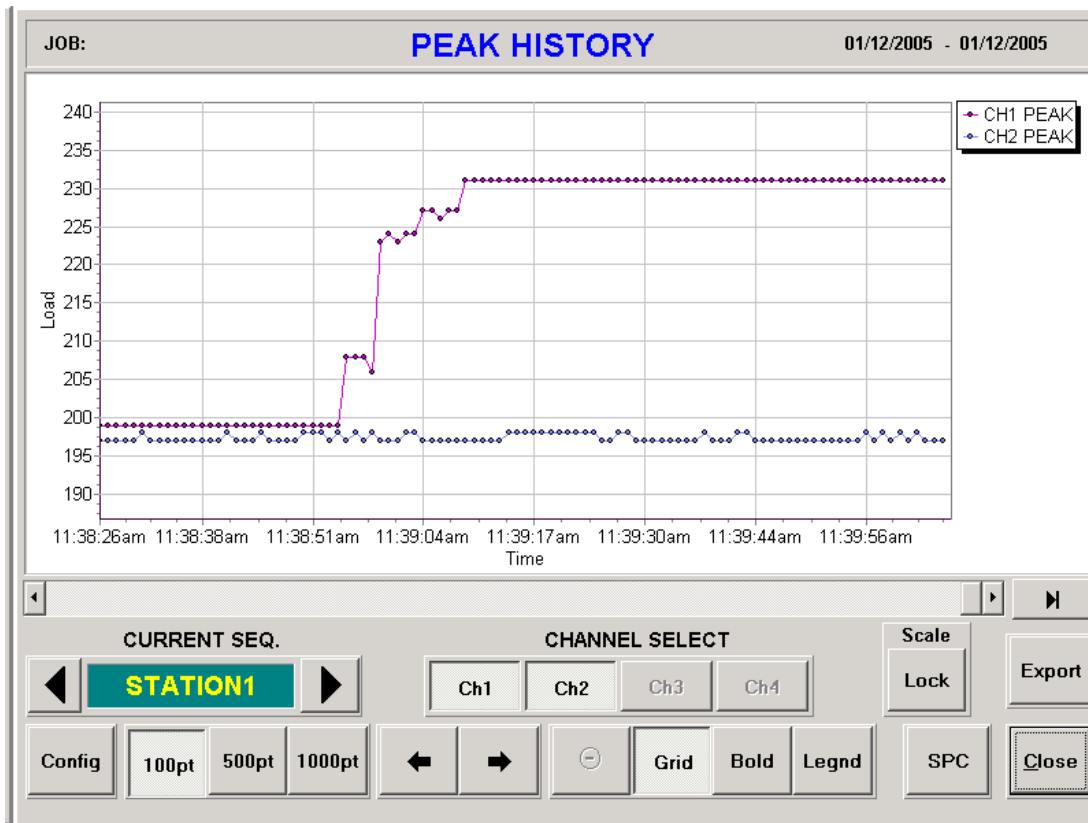
SIGNATURE ANALYSIS SCREEN



ALARM WINDOW Where Tracking alarm is monitored in real time

LOOK WINDOW in msecond when the signatures are captured triggered by LDT set position

PEAK HISTORY SCREEN



MODULE SETUP & CALIBRATION

The screenshot shows a control panel interface for 'MODULE SETUP & CALIBRATION'. At the top, there is a navigation bar with a left arrow, a green button labeled 'STATION1', a right arrow, and the title 'MODULE SETUP & CALIBRATION' in blue. Below this, the main display area is divided into sections. The top section shows 'PEAK TONNAGE' with two blue digital displays for 'CH 1' and 'CH 2', both showing '0'. The bottom section is titled '* Calibration Mode Only' and 'LDT INPUT CALIBRATION' in green. It shows 'CURRENT COUNT' on the left and 'TONNAGE MODULE 1' on the right, with a blue digital display showing '0'. At the bottom of the screen, there are three buttons: a green 'EDIT ON' button, a 'MODE SELECT' button with two sub-buttons 'CAL' and 'Setup', and a 'RETURN' button.

1. Turn EDIT ON using Master Password "4356" as default
2. Change to CAL mode.
In Calibration Mode, You can see the raw LDT input count on TONNAGE MODULE 1 display. Move the press slide to the top positions (rest position) to read the Rest Position LDT input count and record it. This is the reference value that is required to find the optimal LDT Min Position setting.

Normally Add 10% of the full stroke LDT count to the recorded Rest Position LDT input count for the value to LDT Min Position from Current Alarm Setting screen. This is the reference trigger position where the module starts to monitor the tonnage from Ch1 internally. You can always adjust LDT Min Position setting to find the optimal trigger position for your application. Entering proper LDT Min Position value is very important for the module to work properly.