



N-DAS FOR KL-CTDS System Operation Manual



Y2F210-3-009
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① User Guide

This manual describes how to quickly operate the “Data Acquisition System” and get started with the KL-CTDS controller.

Diverse and well rounded operation interface, simple and user-friendly design allows users to get quick understanding, and this system can simultaneously work with the four controllers under the **Kilews** brand, and has the functions of report and table printing, data analysis, trend graph, parameter setting, etc. It is very convenient for users.





② System Requirements

- Windows 10, Windows 8, Windows 7, Windows XP or Windows Vista
- Hardware memory at least 768MB/2GBHz processor
- At least 2GB hard disk
- Recommended at least 16-bit color and 1024x768 screen resolution
- .NET Framework 4.0 or above must be installed

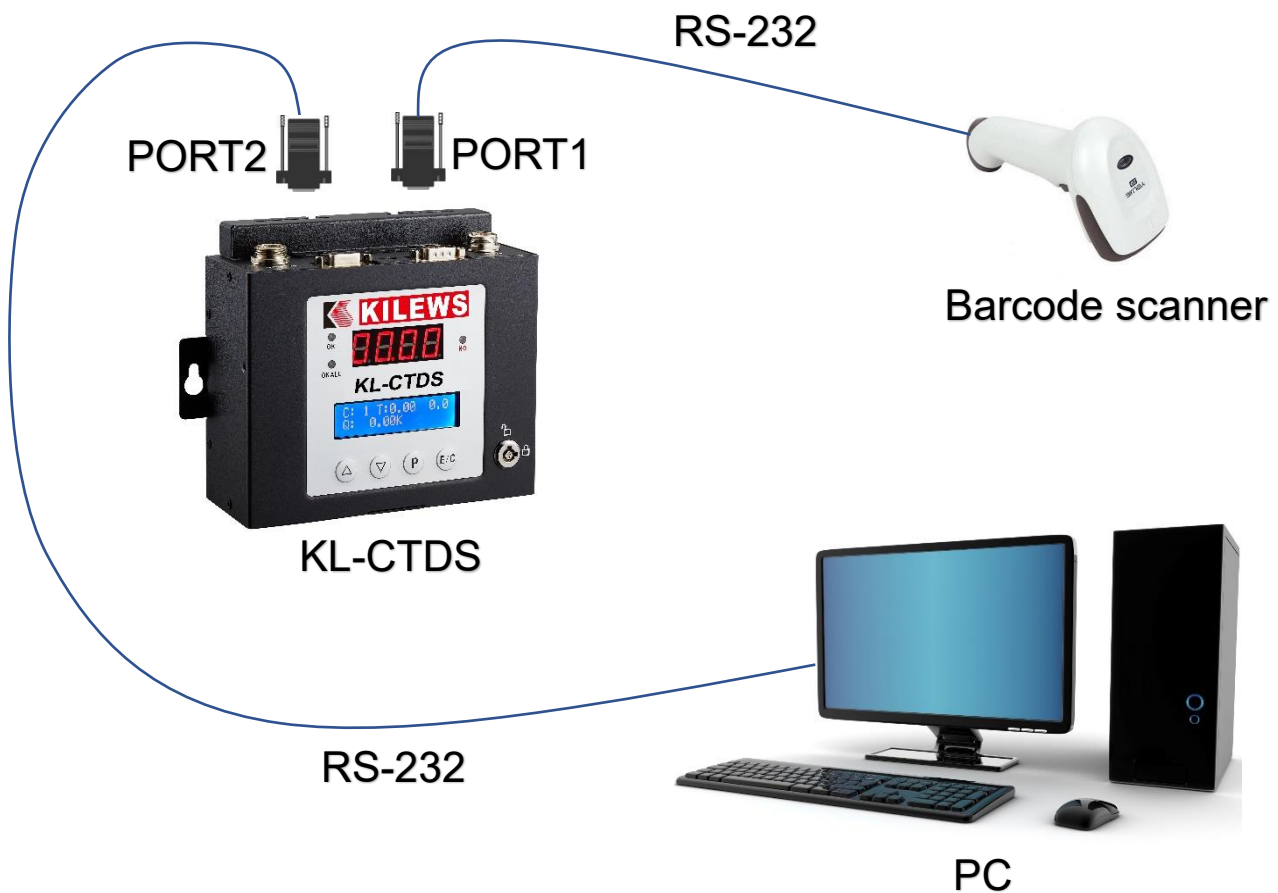


③ Hardware

1. The following must be prepared before operating this system:

- **Kilews** brand controller
(KL-CTDS, KL-MCTDS5, KL-WSCBSN, KL-TCG).
- Executable file for the operating
 Data_Acquisition_System.exe.
- One RS-232 serial port.
- One 1D(Linear) barcode scanner (*not necessary).

2. Device connection as in the following diagram:





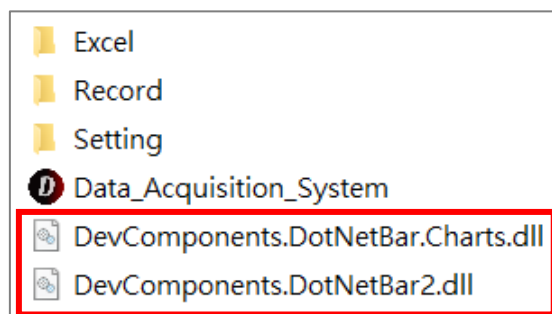
④ System Connection

Step 1: Before log in, it is required to set the date format in the computer system as “YYYY/MM/DD”.

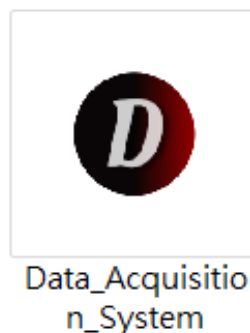
Step 2: Download the compressed software

NOTE:

For the version: 1.0.0.6 and later on, there must have 2 additional dll files in the folder(shown as below picture) after you decompressed the software. These are required files to run the software.

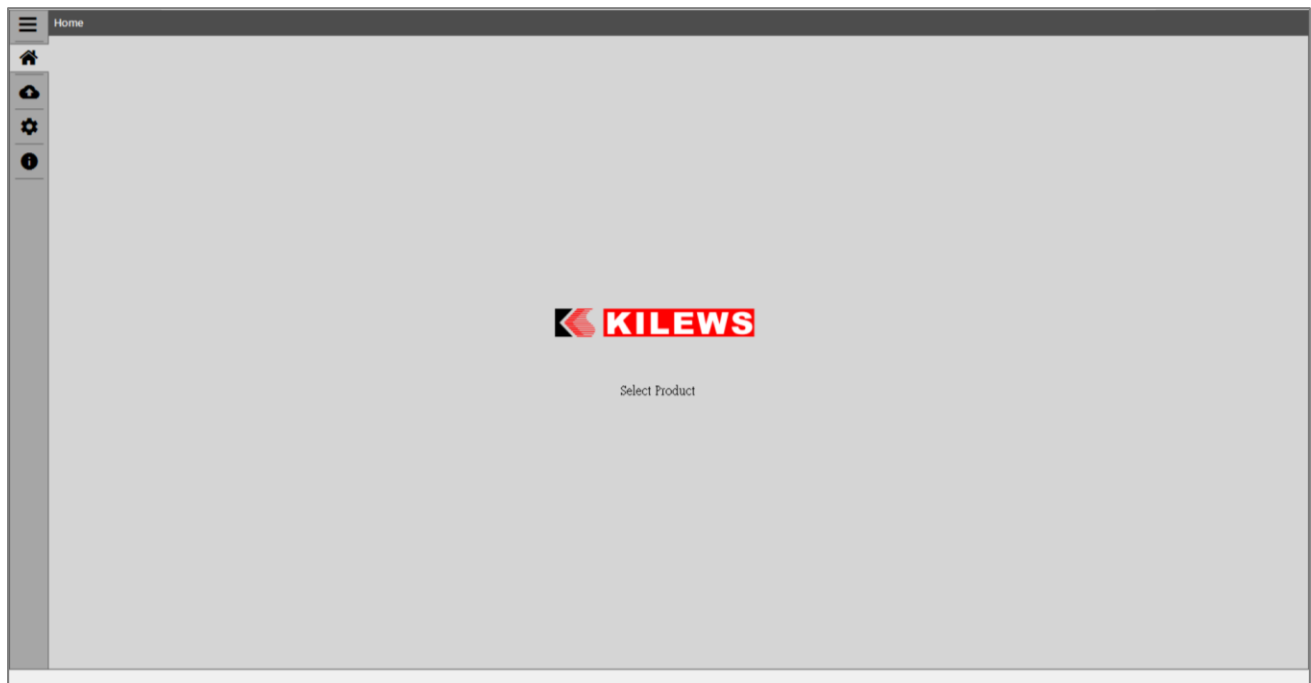


Step 3: Open the executable file  Data_Acquisition_System.exe.





Step 4: Move the mouse cursor to  and display the four controllers.

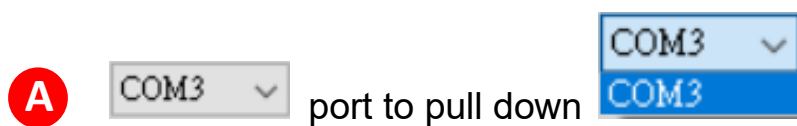
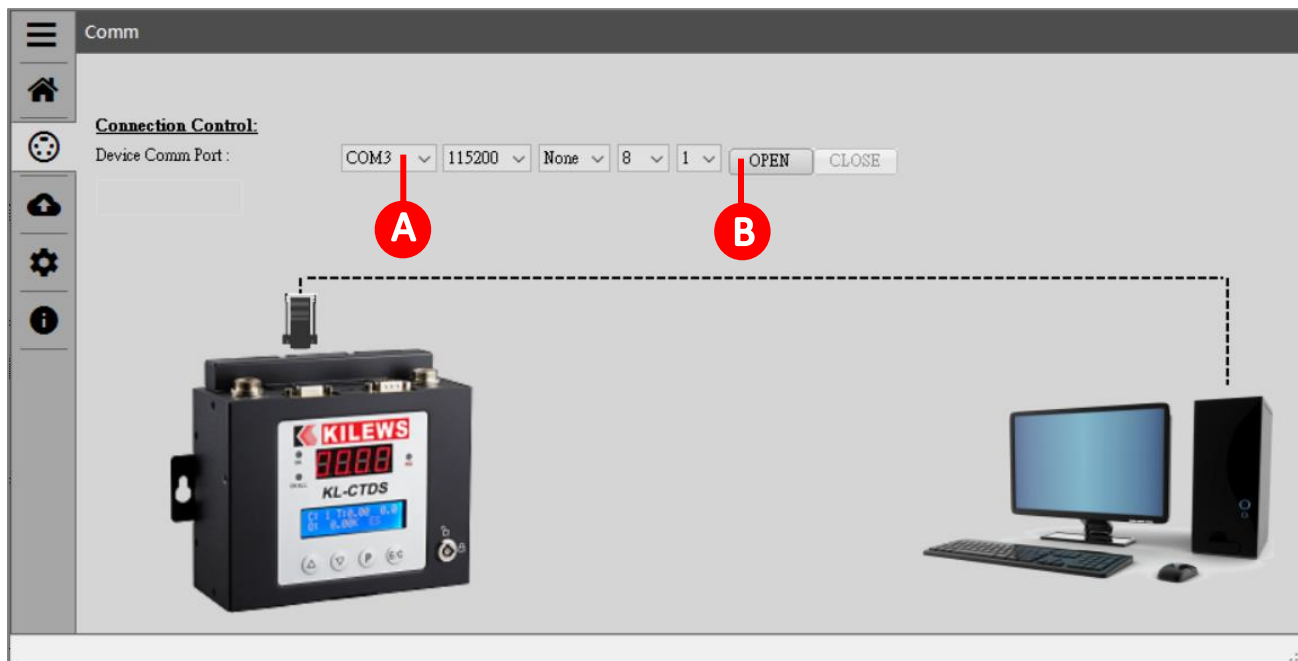


Step 5:  Controller selection (KL-CTDS)

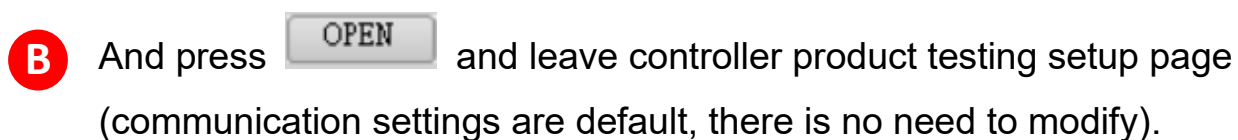




Step 6: Go to  Comm page.



(Connect according to the port of the computer display device)





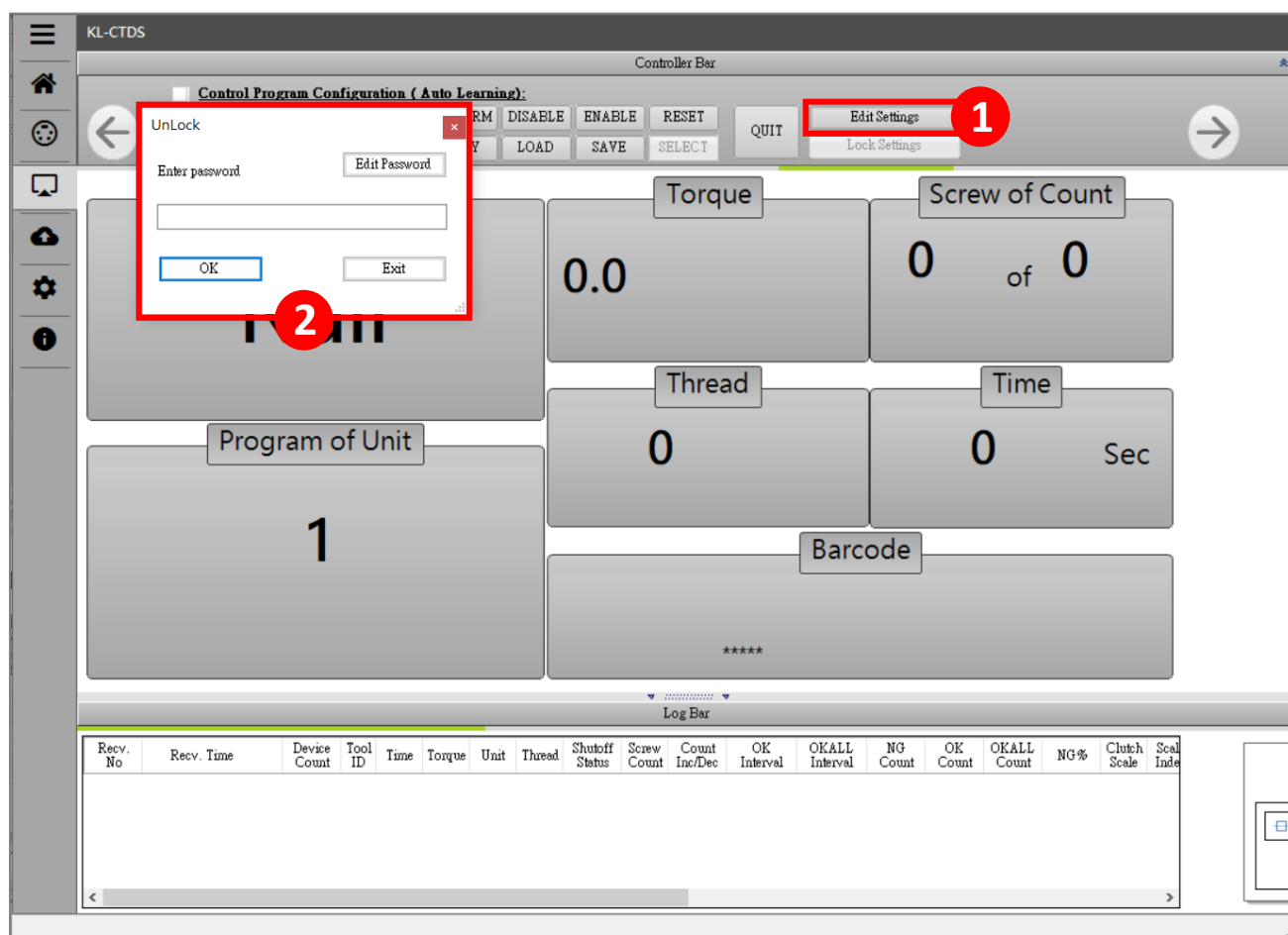
⑤ System Screen Introduction

➤ Unlock Settings

The page displayed is Instant data display after entering the screen. At this time, no operation can be performed due to locked setting. You must enter the password first if need to unlock for operation.

Step 1: After clicking the button of "Edit Settings", the unlock window will pop up.

Step 2: Enter the default password "admin123" and click confirm button.

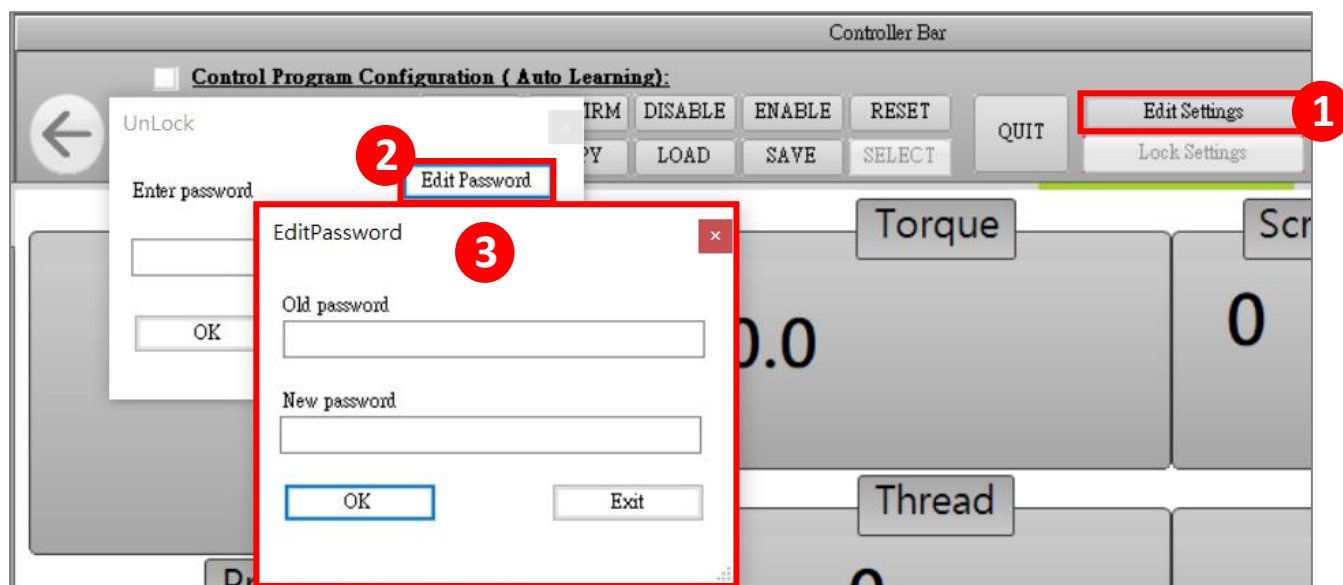




➤ Password change setting method

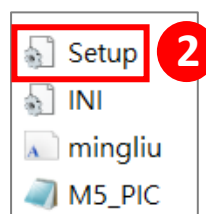
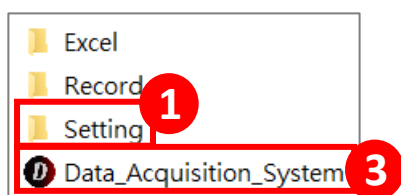
Click "Edit Settings" button → "Edit Password" to enter the old password and the new password, and then click OK button to complete the setting.

NOTE: New password setting: Six to eight characters in length, including English uppercase and lowercase, numbers.

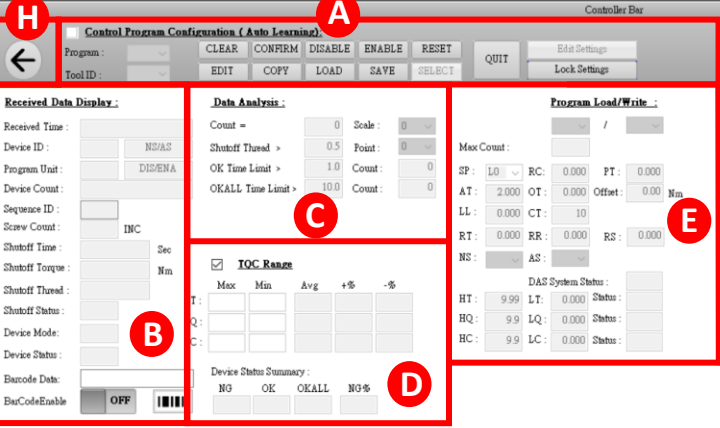


➤ Restore default password

Select to enter the ① Setting folder, delete the file named ② Setup and Reopen it ③ Data_Acquisition_System can restore the default password (admin123)



- 



The pages of the system can be operated by sliding left and right , so the software can be operated on the touch screen.

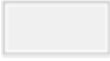


A Controller device setup

Introduce the functions for the two zones from left to right in order:

- Control Program Configuration (Auto Learning) : Press  and check the check box  **Control Program Configuration (Auto Learning):**, then the user could Load or Write the parameters.

➤ When the check box is unchecked

 **Control Program Configuration (Auto Learning):**, all input fields are shown as gray color  which mean the user can't input any parameters.



- When the check box is checked

☒ **Control Program Configuration (Auto Learning):** , all input fields are shown as white color which mean the user can input the parameters.

Program Load/Write :

Max Count :

SP : RC: PT :

AT : OT: Offset: Nm

LL : CT :

RT : RR: RS :

NS : AS :

DAS System Status :

HT : LT: Status :

HQ : LQ: Status :

HC : LC: Status :

- Program: Display the program group currently used (Program).
- Tool ID: Display the current used tool's id.

CLEAR CONFIRM DISABLE ENABLE RESET QUIT Edit Settings

LOCK COPY LOAD SAVE SELECT Lock Settings

- CLEAR: Press to reset counting.
- CONFIRM: Press to dismiss controller C3 status.

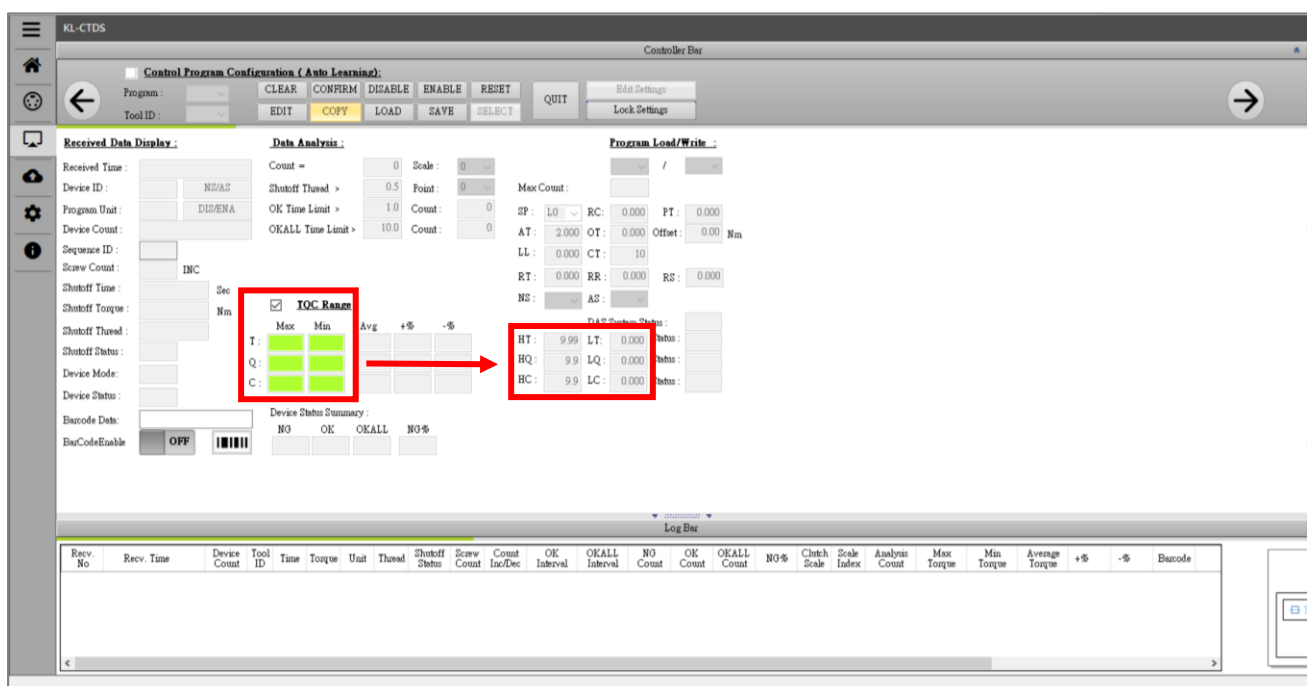
(refer to KL-CTDS User Manual for C3 function introduction).



- DISABLE: Press to immediately stop screwdriver operation.
- ENABLE: Press to immediately allow the screwdriver to run.
- RESET: Press to restart the controller and restore factory parameters.
- EDIT: Press to enter screwdriver condition parameters.
- COPY: Press to copy the TQC condition parameter to Program.

(Procedure: → →

tightening screws → → → , After done this procedure, the system will copy T, Q, C data to HT/ HQ/HC/LT/LQ/LC as limitations.

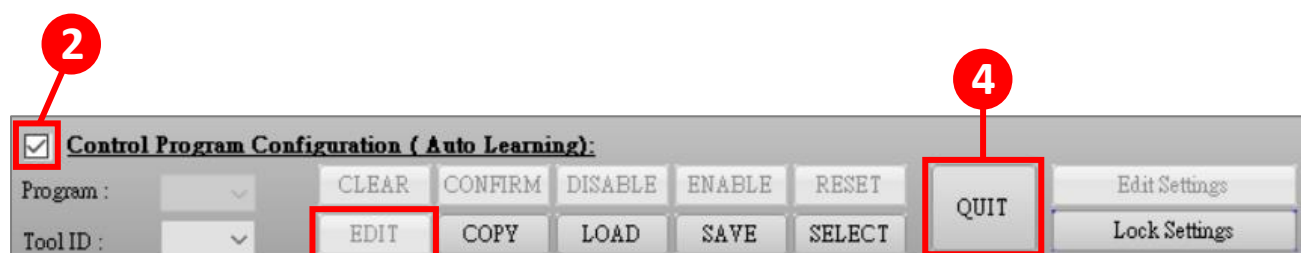




- **LOAD:** To load the parameter settings from the KL-CTDS controller.

Press **EDIT** and check ☒ **Control Program Configuration (Auto Learning):**

and select program **1** . Press **QUIT** to finish this process.



Program Load/Write :

☒ **3** / ☐

Max Count :

SP : RC: PT :

AT : OT: Offset: Nm

LL : CT:

RT : RR : RS :

NS : AS :

DAS System Status :

HT : LT: Status :

HQ : LQ: Status :

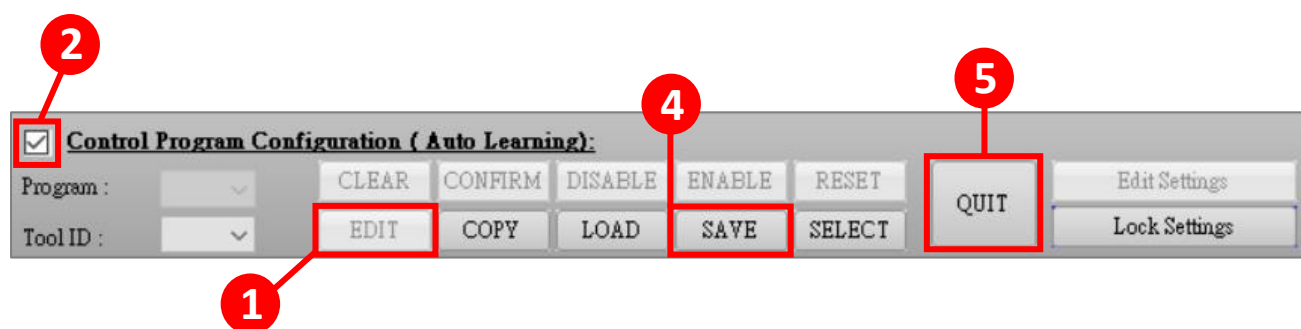
HC : LC: Status :



- SAVE: Save the parameters to KL-CTDS controller.

Press **EDIT** and check ☒ **Control Program Configuration (Auto Learning):**

then input required parameters. Press **SAVE** and **QUIT** to finish this process.



3

Program Load/Write :

Program : /

Max Count :

SP : LO RC : 0.000 PT : 0.000

AT : 2.000 OT : 0.000 Offset : 0.00 Nm

LL : 0.000 CT : 10

RT : 0.000 RR : 0.000 RS : 0.000

NS : AS :

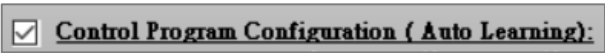
DAS System Status :

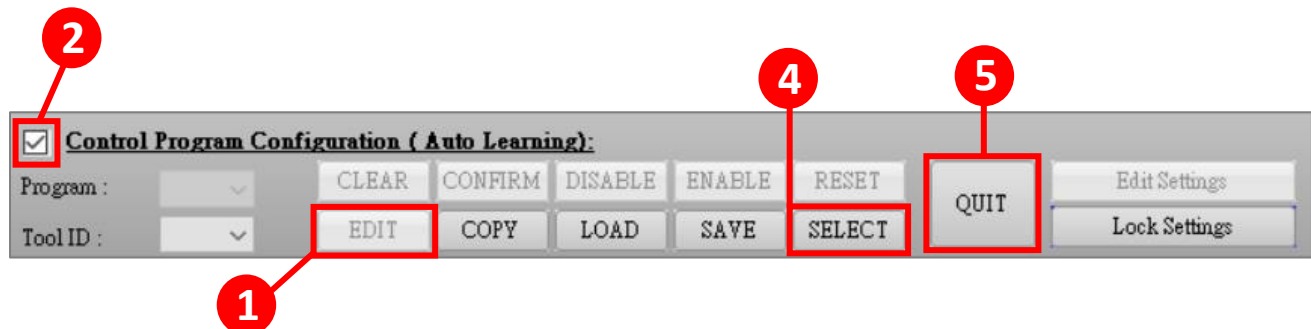
HT : 9.99 LT : 0.000 Status :

HQ : 9.9 LQ : 0.000 Status :

HC : 9.9 LC : 0.000 Status :



- SELECT: Press  and check  then input required parameters . Press  and  to switch to required program.



Program Load/Write :

1 / 1

Max Count :

SP : RC : PT :

AT : OT : Offset : Nm

LL : CT :

RT : RR : RS :

NS : AS :

DAS System Status :

HT : LT : Status :

HQ : LQ : Status :

HC : LC : Status :

- QUIT: Press  to end after pressing .



- Edit Settings : After entering the system, you must click  and enter the password to unlock the screen and switch to other pages.
(Please refer to ["Password Change Setting Method"](#))
- Lock Settings : Click  to automatically jump to the "Instant data display" screen, and no operation can be performed. The lock settings must be unlocked.
(Please refer to ["Instant data display"](#) , ["Unlock Settings"](#))



- B** Received Data Display: All fastened data can be displayed instantly.

Received Data Display :

Received Time :		
Device ID :		NS/AS
Program Unit :		DIS/ENA
Device Count :		
Sequence ID :		
Screw Count :		INC
Shutoff Time :		Sec
Shutoff Torque :		Nm
Shutoff Thread :		
Shutoff Status :		
Device Mode:		
Device Status :		
Barcode Data:		
BarCodeEnable	☐ OFF	

- Received Time: The time to fasten the data.
- Device ID: Device ID (1~255).
- Program Unit: This fastened program group (Program).
- Device Count: The total number of times the device is fastened.
- Sequence ID: Shows current sequence unit ID (1~8).
- Screw Count: The number of fastened units.



- Shutoff Time: How long driver ran before clutch tripped. (Sec)
- Shutoff Torque: the torque for the fastening.
- Shutoff Thread: Number of rotations at output shaft.
- Shutoff Status: shut off status (OK, NG, OK ALL, REV).
- Device Mode: STD mode, ADV mode (**please refer to KL-CTDS manual**).
- Device Status: (**Refer to the “Display Status Code Description” in KL-CTDS User Manual**).
- Barcode Data: barcode data.
- BarCodeEnable: The C3 function will be dismissed when the barcode is scanned (**refer to KL-CTDS User Manual for C3 function introduction**).



- C** Data Analysis: the number of times, the number of shut off, OK and OKALL interval time can be set. The data which meet the conditions will be shown.

NOTE: Data Analysis will be activated when the TQC Range is enable.

<u>Data Analysis :</u>			
Count =	0	Scale :	0 ▾
Shutoff Thread >	0.5	Point :	0 ▾
OK Time Limit >	1.0	Count :	0 1
OKALL Time Limit >	10.0	Count :	0 2

- Count: the number of shutoff Thread greater than its setting and also the torque value is greater than 0.
- Scale: 0~8 scale.
- Shutoff Thread: Output shaft must rotate more than displayed value or result will be ignored.
- Point: Clutch scale (1~15).
- OK Time Limit: Set the maximum duration between each OK1 signal. Once the time over this setting, it will count 1.
- 1** Count: the number of times greater than OK interval.
- OKALL Time Limit: Set the maximum duration between each OKALL signal. Once the time over this setting, it will count 1.
- 2** Count: the number of times greater than OKALL interval.



- D** TQC Range: Analyze the average error value.

	Max	Min	Avg	+%	-%
T :					
Q :					
C :					

Device Status Summary :

NG	OK	OKALL	NG%

- E** Program parameter setup
(refer to KL-CTDS manual for condition parameters)

<u>Program Load/Write :</u>					
Max Count :					
SP :	LO	RC :	0.000	PT :	0.000
AT :	2.000	OT :	0.000	Offset :	0.00 Nm
LL :	0.000	CT :	10		
RT :	0.000	RR :	0.000	RS :	0.000
NS :		AS :			
DAS System Status :					
HT :	9.99	LT :	0.000	Status :	
HQ :	9.9	LQ :	0.000	Status :	
HC :	9.9	LC :	0.000	Status :	



- Program Load/Write:

Program Load/Write :			
v		/	v
Max Count :			
SP :	LO v	RC :	0.000
PT :	0.000		
AT :	2.000	OT :	0.000
Offset :	0.00 Nm		
LL :	0.000	CT :	10
RT :	0.000	RR :	0.000
RS :	0.000		
NS :	v	AS :	v
DAS System Status :			
HT :	9.99	LT :	0.000
Status :			
HQ :	9.9	LQ :	0.000
Status :			
HC :	9.9	LC :	0.000
Status :			

- For the “Load” field, please refer to [“ROAD”](#)
- For the “Write” field, please refer to [“SAVE”](#)



- Max Count:

Program Load/Write :					
Max Count :					
SP :	LO ▾	RC :	0.000	PT :	0.000
AT :	2.000	OT :	0.000	Offset :	0.00 Nm
LL :	0.000	CT :	10		
RT :	0.000	RR :	0.000	RS :	0.000
NS :	▾	AS :	▾		
DAS System Status :					
HT :	9.99	LT :	0.000	Status :	
HQ :	9.9	LQ :	0.000	Status :	
HC :	9.9	LC :	0.000	Status :	

The field indicate program “required total screw numbers”

- Program parameter setup

(refer to KL-CTDS Manual for Condition Parameters)

Program Load/Write :					
Max Count :					
SP :	LO ▾	RC :	0.000	PT :	0.000
AT :	2.000	OT :	0.000	Offset :	0.00 Nm
LL :	0.000	CT :	10		
RT :	0.000	RR :	0.000	RS :	0.000
NS :	▾	AS :	▾		
DAS System Status :					
HT :	9.99	LT :	0.000	Status :	
HQ :	9.9	LQ :	0.000	Status :	
HC :	9.9	LC :	0.000	Status :	



- F** Data collection: When the fasten tool is started, the data will be displayed in the Log Bar field at the bottom of the page.

(Fasten data sheet, TQC Trend Setting)

- Fasten data sheet (If you need to hide or display the received data, please refer to [“Item selection”](#)).

Control Program Configuration (Auto Learning)

Program: [] CLEAR CONFIRM DISABLE ENABLE RESET QUIT Edit Settings
Tool ID: [] EDIT COPY LOAD SAVE SELECT Lock Settings

Received Data Display:
Received Time: []
Device ID: [] NS/AS
Program Unit: [] DIS/ENA
Device Count: []
Sequence ID: []
Screw Count: [] INC
Shotoff Time: [] Sec
Shotoff Torque: [] Nm
Shotoff Thread: []
Shotoff Status: []
Device Mode: []
Device Status: []
Barcode Data: []
BarCodeEnable: [OFF] []

Data Analysis:
Count = [0] Scale: [0]
Shotoff Thread > [0.5] Point: [0]
OK Time Limit > [1.0] Count: [0]
OKALL Time Limit > [10.0] Count: [0]
TQC Range: []
T: [] Max Min Avg +% -%
Q: []
C: []

Program Load/Write:
Max Count: [] / []
SP: [LO] RC: [0.000] PT: [0.000]
AT: [2.000] OT: [0.000] Offset: [0.00] Nm
LL: [0.000] CT: [10]
RT: [0.000] RR: [0.000] RS: [0.000]
NS: [] AS: []
DAS System Status:
HT: [9.99] LT: [0.000] Status: []
HQ: [9.9] LQ: [0.000] Status: []
HC: [9.9] LC: [0.000] Status: []

Log Bar

Recv No	Recv Time	Device Count	Tool ID	Time	Torque	Unit	Thread	Shotoff Status	Screw Count	Count Inc/Dec	OK Interval	OKALL Interval	NG Count	OK Count	OKALL Count	NG%	Chitch Scale	Scale Index	Analysis Count	Max Torque	Min Torque	Average Torque	+%	-%	Barcode

- Depress the scroll bar and swipe to the next page to display TQC Trend Setting (Please refer to [“Trend Setting”](#) for the TQC setting)

Control Program Configuration (Auto Learning)

Program: [] CLEAR CONFIRM DISABLE ENABLE RESET QUIT Edit Settings
Tool ID: [] EDIT COPY LOAD SAVE SELECT Lock Settings

Received Data Display:
Received Time: []
Device ID: [] NS/AS
Program Unit: [] DIS/ENA
Device Count: []
Sequence ID: []
Screw Count: [] INC
Shotoff Time: [] Sec
Shotoff Torque: [] Nm
Shotoff Thread: []
Shotoff Status: []
Device Mode: []
Device Status: []
Barcode Data: []
BarCodeEnable: [OFF] []

Data Analysis:
Count = [0] Scale: [0]
Shotoff Thread > [0.5] Point: [0]
OK Time Limit > [1.0] Count: [0]
OKALL Time Limit > [10.0] Count: [0]
TQC Range: []
T: [] Max Min Avg +% -%
Q: []
C: []

Program Load/Write:
Max Count: [] / []
SP: [LO] RC: [0.000] PT: [0.000]
AT: [2.000] OT: [0.000] Offset: [0.00] Nm
LL: [0.000] CT: [10]
RT: [0.000] RR: [0.000] RS: [0.000]
NS: [] AS: []
DAS System Status:
HT: [9.99] LT: [0.000] Status: []
HQ: [9.9] LQ: [0.000] Status: []
HC: [9.9] LC: [0.000] Status: []

Log Bar

Recv No	Recv Time	Device Count	Tool ID	Time	Torque	Unit	Thread	Shotoff Status	Screw Count	Count Inc/Dec	OK Interval	OKALL Interval	NG Count	OK Count	OKALL Count	NG%	Chitch Scale	Scale Index	Analysis Count	Max Torque	Min Torque	Average Torque	+%	-%	Barcode

**NOTE:**

Touch the red box area and swipe to the next page to display a trend graph.

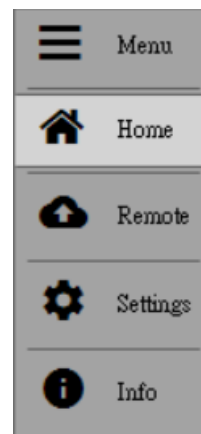
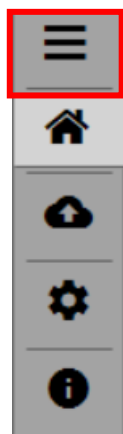
The screenshot shows the 'Control Program Configuration (Auto Learning)' screen. It includes sections for 'Received Data Display', 'Data Analysis', and 'Program Load/Write'. A red arrow points to a red box in the 'Data Log Chart' area at the bottom right, which is used to access the trend graph.



Main menu: click

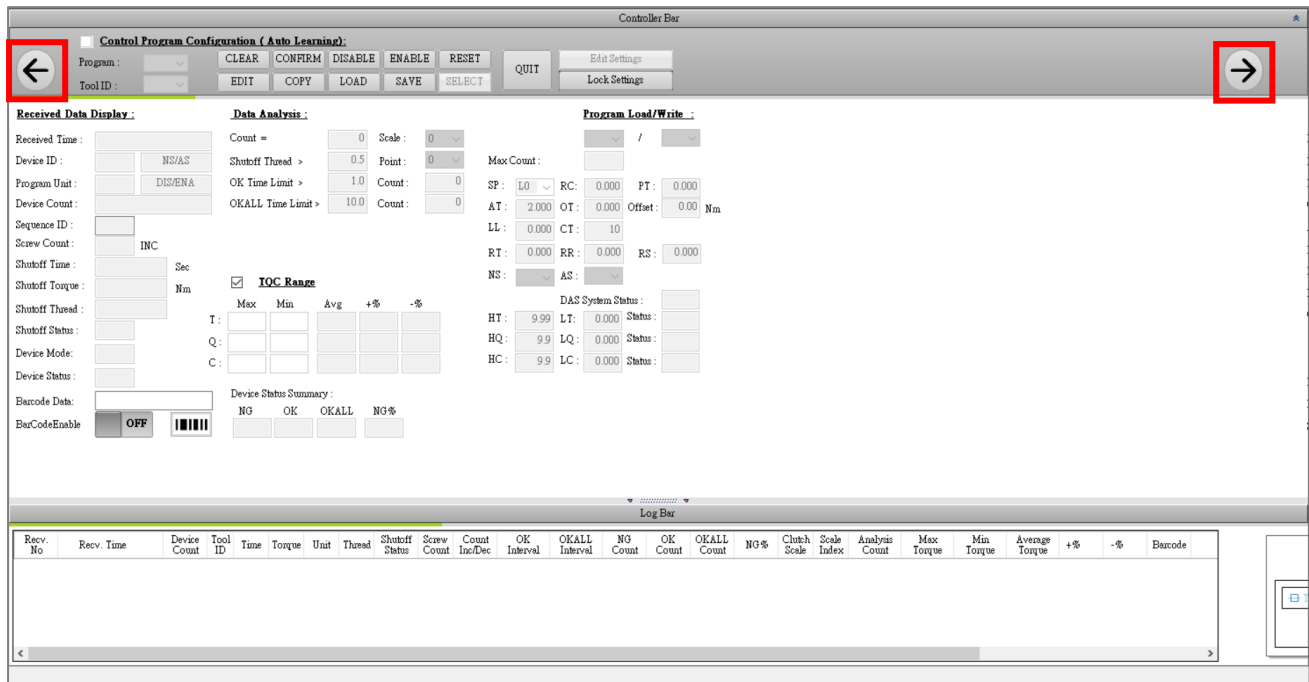


to hide or display English title.





H Go to previous page by pressing  button, next page by pressing  button.

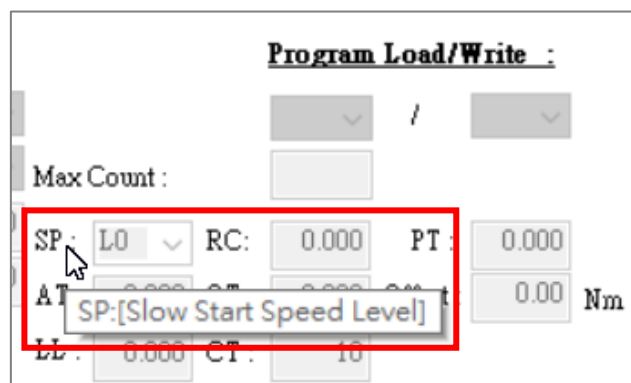


NOTE:

Full description will be displayed when the mouse moves to the setting parameter (please refer to KL-CTDS manual for details).

Example:

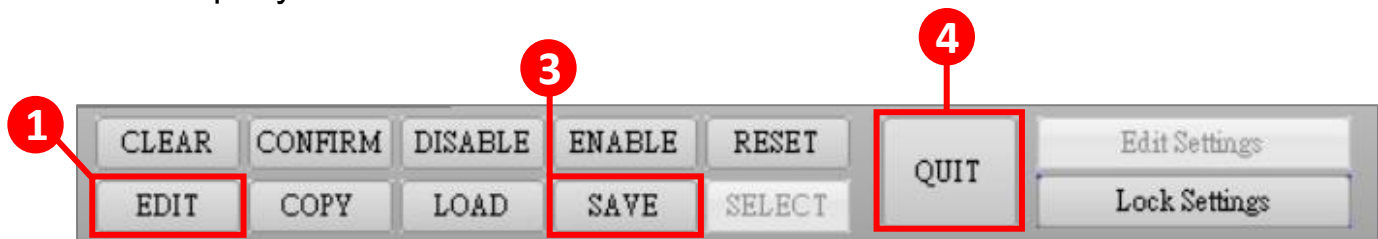
When the mouse moves to “SP”, “SP: [Slow Start Speed Level]” is displayed.



[illegible]



A Controller Configuration: After pressing , you can modify the controller status set by the device (RED rectangle area). After the setup is completed, press the  button and press  to complete the query.



Controller Configuration : 2

Device Time:

Device Sn:

Device ID/Type: /

Operation Mode : ADV Seq.: Seq.

Job Status:

Reverse Mode: Each

Batch Mode: Decrease

Brake Signal: Release

Gate Mode: OFF

Torque Unit: N-m

Tool Status:

I/O Status:

Device Ver:

Screwdriver Ver:

TF : OFF

NOTE: To query the Controller Configuration ,

press  →  →  .

NOTE: Refer to KL-CTDS instruction manual for device setup conditions.



B Tool Configuration

Tool Configuration:

Tool Sn :

Gear Ratio:

Cal. Time:

Torque Filter :

- Tool Sn: Tool's serial number.
- Gear ratio: Based on driver model.
- Cal. Time: Date stamp when driver was last calibrated.
- Torque Filter function: set 0 to disable the filter function, 1-250 to set the numbers of filter time, set & to always enable filter function.

(This setting not supports the BNK TOOL version before VER:2.16)

C All Sequences List

All Sequences List:

Program Unit:

1	2	3	4
5	6	7	8

The diagram shows a sequence of 8 units arranged in two rows. The first row contains units 1, 2, 3, and 4. The second row contains units 5, 6, 7, and 8. A dashed line connects the end of the first row to the start of the second row, indicating a continuous sequence.

- Pick up a program from 1 ~ 99 programs, the program could be set more than once, setting "0" will be ignored and then execute the next unit.
- Tightening cycle will follow the "All Sequences List" below. After finish a cycle, it will be repeated automatically.

To take below case for example, it will be 12345678, 12345678, ...etc.



- Load All Sequences List:

Press  →  →  to finish loading.



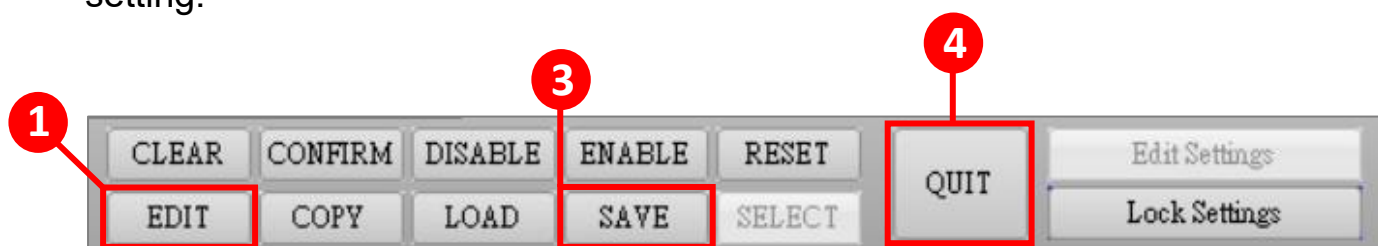
All Sequences List:

Program Unit:

1	2	3	4
5	6	7	8

- Setting All Sequences List:

Press  → setting Program Unit →  →  to finish setting.



All Sequences List:

Program Unit:

1	2	3	4
5	6	7	8



3. Barcode Manager

The screenshot shows the 'Barcode Manager' window within the 'Controller Bar' application. It contains two sub-windows, A and B, both outlined in red.

Sub-window A: BarCode Controller

Barcode Data	Text Data	Program
		=
		=
		=
		=
		=

Buttons: Load, Save

Sub-window B: BarCode DAS

Barcode Data	Text Data	Program
		=
		=
		=
		=
		=

Buttons: OF, Save

Below the sub-windows is a 'Log Bar' table with the following columns: Recv. No, Recv. Time, Device Count, Tool ID, Time, Torque, Unit, Thru, Shutoff Status, Screw Count, Count Inc/Dec, OK Interval, OKALL Interval, NG Count, OK Count, OKALL Count, NG%, Clutch Scale, Scale Index, Analysis Count, Max Torque, Min Torque, Average Torque, +%, -%, Barcode.

A Set / Read Barcode data to / from KL-CTDS

This is a detailed view of the 'BarCode Controller' sub-window. It shows the following layout:

Barcode Data	Text Data	Program
		=
		=
		=
		=
		=

Buttons: Load, Save

NOTE: Refer to the “BARCODE LEARNING” in KL-CTDS User Manual.

**B** Turn ON / OFF DAS's Barcode function

Only when the specific barcode data hasn't been stored in KL-CTDS will be applied to DAS's barcode function.

The procedure to set DAS's barcode data.

Step 1: Turn ON DAS's barcode function.

Step 2: Scan the barcode.

NOTE: The data will be shown on the "Barcode Data".

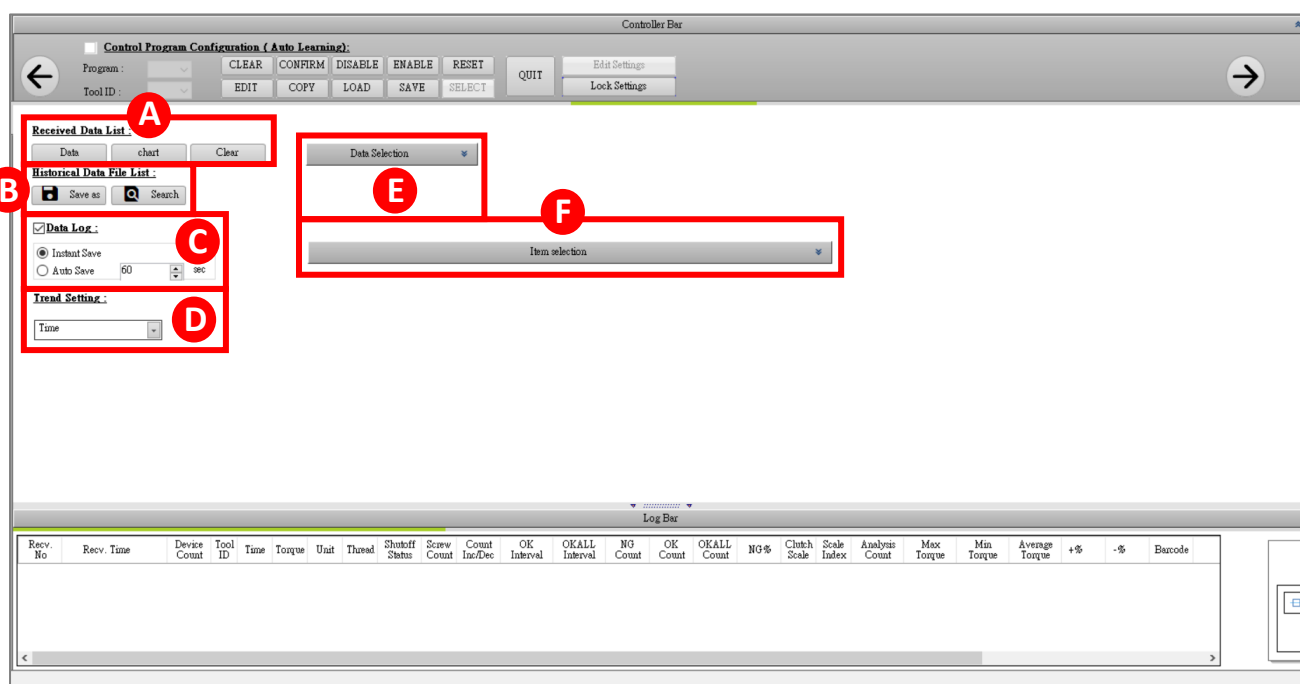
Step 3: You could input whole or partial barcode data in one of the "Text Data" and then assign this data to which Program No.

Step 4: Press .

NOTE: **A** and **B** couldn't be used at the same time.



4. Report and trend graph setup page



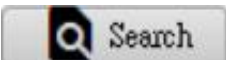
A Received Data List



There are two types of display data  . If you need to clear it, press the  button to clear all the data immediately.

B Historical Data File List



- Excel export: When swiping the Controller Bar to page 4, press  to export the Excel report to the specified location.
- Excel import: When swiping the Controller Bar to page 4, press  and then click the Excel file to import it.



C Data Log

➤ Data Log: When ☒ **Data Log :** is checked, there are two ways to automatically export Excel reports (instant archive, automatic archive).

- When ☒ **Instant Save** is selected, any data fastened will be automatically exported to the bottom of **Excel** . When the system passes the integral time point, the form will be cleared to ensure sufficient memory space.
- When ☐ **Auto Save** is selected, the data will be recorded in “seconds” as set in and the report will be exported below **Excel** .

D Trend Setting: Time, Torque, Thread

Select one of the Time, Torque, and Thread from the pull-down menu.

It will show the graphic trend chart. (Refer to [“TQC Trend Setting”](#))

NOTE: When changing the “Trend Setting”(T/Q/C) setting, the screen of the chart will be clear and then display again after finished a new tighten.

**E**

- Record selection: Checked items will affect the data recorded in the form.
When REV selection is cancelled, the inverted data will no longer be received.

Data Selection

☒ OK ☒ NG ☒ OK All ☒ REV

F

- Item selection: The selected items will affect the data recorded in the form.
When the item is checked, the display data will be displayed; otherwise, it will not be displayed.

Item selection

☒ All Checked/Cancel

☒ Recv.No	☒ Recv.Time	☒ Device Count	☒ Tool ID	☒ Time
☒ Torque	☒ Unit	☒ Thread	☒ Shutoff Status	☒ Screw Count
☒ Count Inc/Dec	☒ OK Interval	☒ OKALL Interval	☒ NG Count	☒ OK Count
☒ OKALL Count	☒ NG Percentage	☒ Clutch Scale	☒ Scale Index	☒ Analysis Count
☒ Max Torque	☒ Min Torque	☒ Average Torque	☒ UpPercentage	☒ LowPercentage
☒ BarcodeData	☒ RawData	☒ ProgramUnit	☒ Torque Filter	

[Example]

If you only want to display the “received serial number”, “torque”, and “increase/decrease” from the tool, check “Receive Serial Number”, “Torque”, “increment/decrease” in “Record selection.

Controller Bar

Control Program Configuration (Auto Learning):

Program: [] CLEAR CONFIRM DISABLE ENABLE RESET QUIT Edit Settings

Tool ID: [] EDIT COPY LOAD SAVE SELECT Lock Settings

Received Data List:

Data chart Clear Data Selection

Historical Data File List:

Save as Search

Data Log:

☒ Instant Save ☐ Auto Save 60 sec

Trend Setting:

Time

Item selection

☒ All Checked/Cancel

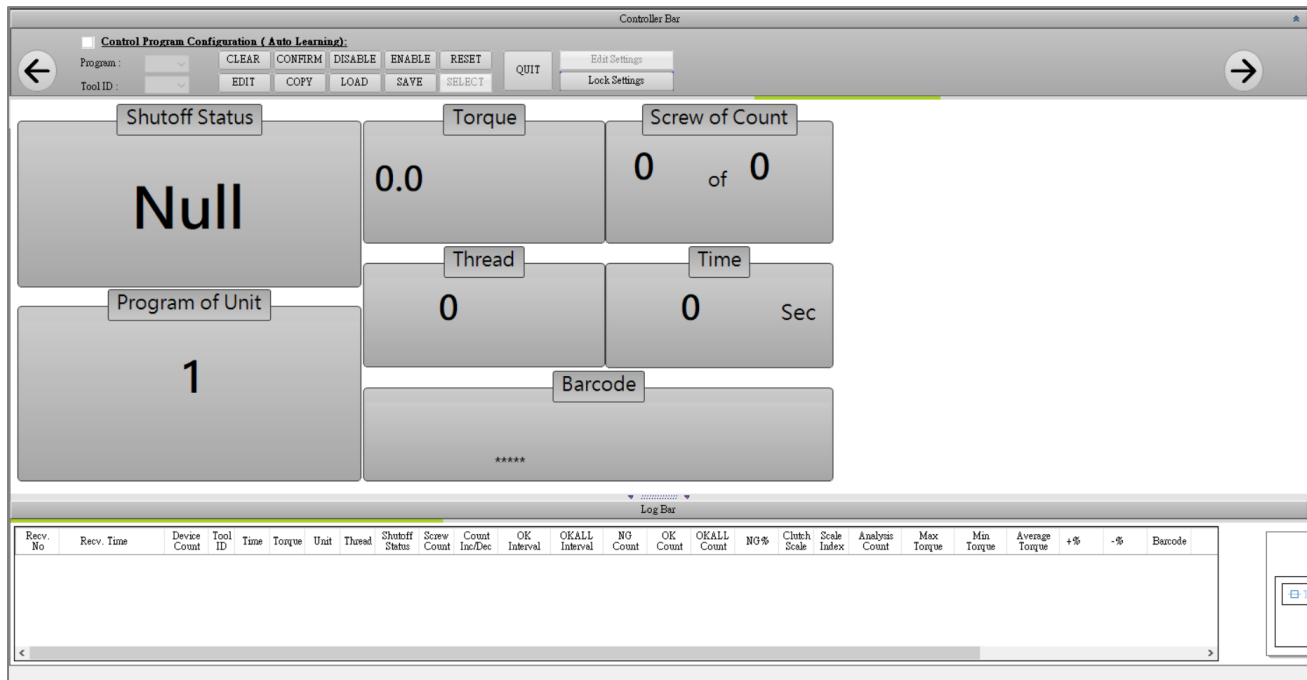
☒ Recv.No	☒ Recv.Time	☒ Device Count	☒ Tool ID	☒ Time
☒ Torque	☒ Unit	☒ Thread	☒ Shutoff Status	☒ Screw Count
☒ Count Inc/Dec	☒ OK Interval	☒ OKALL Interval	☒ NG Count	☒ OK Count
☒ OKALL Count	☒ NG Percentage	☒ Clutch Scale	☒ Scale Index	☒ Analysis Count
☒ Max Torque	☒ Min Torque	☒ Average Torque	☒ UpPercentage	☒ LowPercentage
☒ BarcodeData	☒ RawData	☒ ProgramUnit	☒ Torque Filter	

Log Bar

Recv. No	Torque	Count Inc/Dec	N/A



5. Instant data display



- Shutoff Status: Display current complete status of fasten process.
- Program of Unit: Indicate the current Program of the Unit.
- Torque: Display fastening torque.
- Thread: Display the number of turning screwdriver.
- Screw of Count: Display the number of current screw count status.
- Time: Display screw fastening time.
- Barcode: Display current Barcode data.

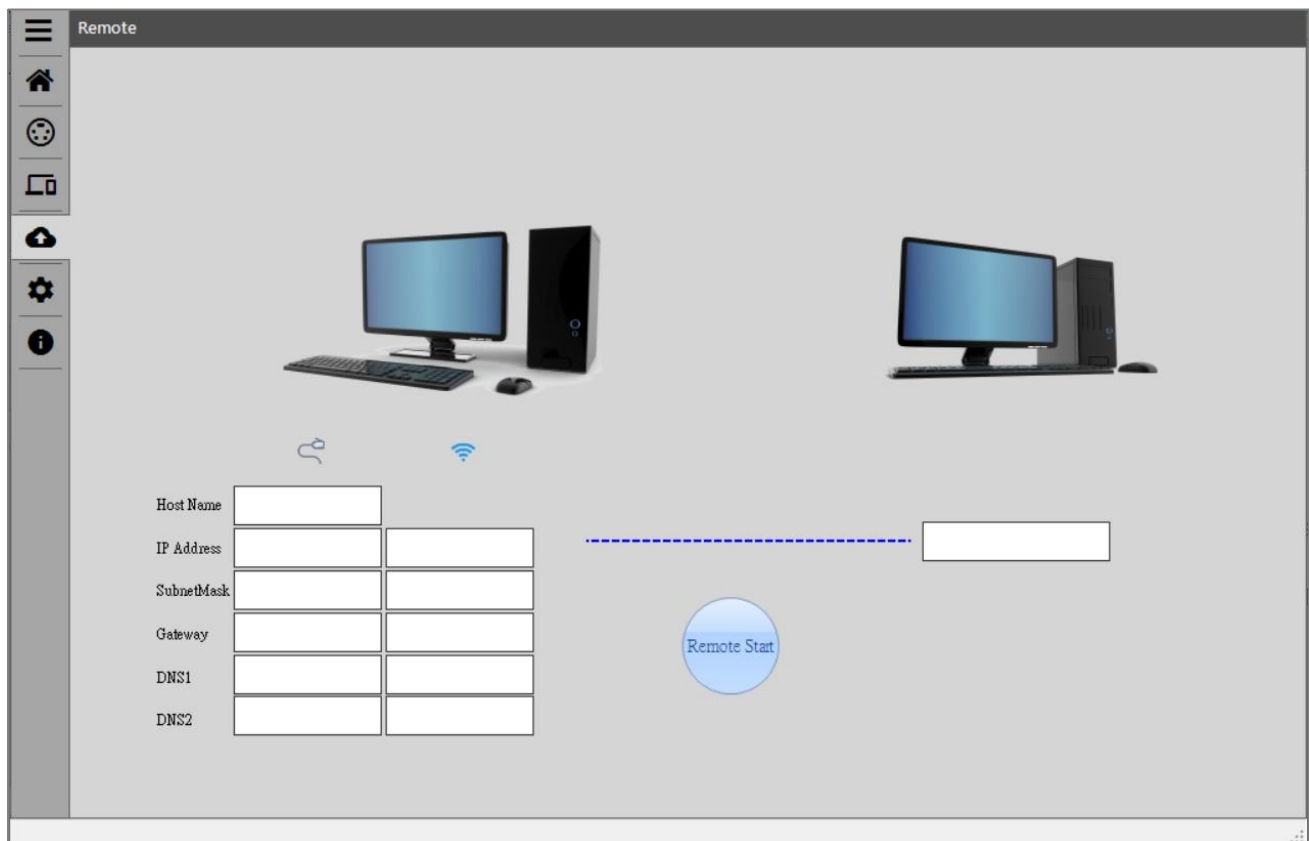


⑥ Remote Screen



The screen image by remote monitoring.

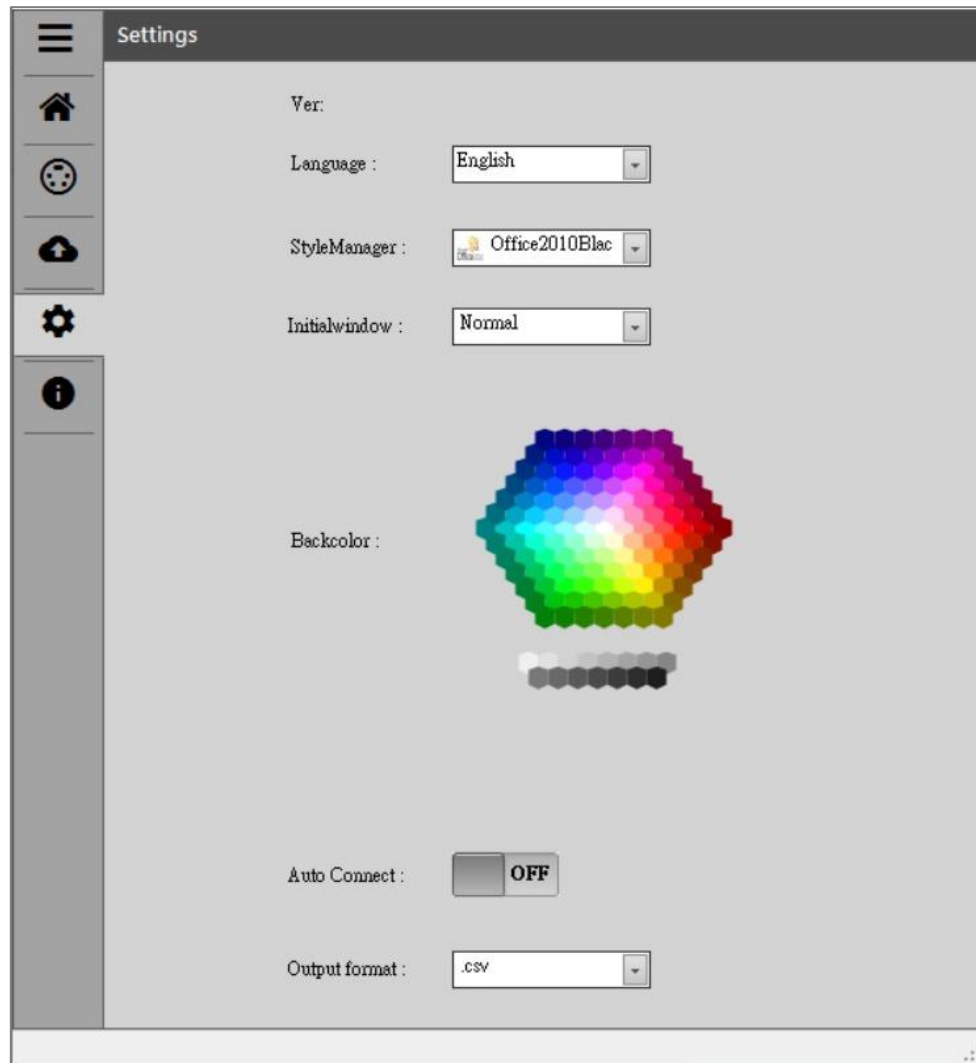
NOTE: Please contact with local distributors for the detail information.

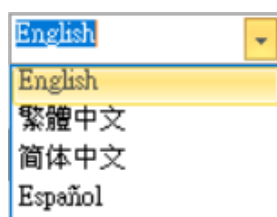




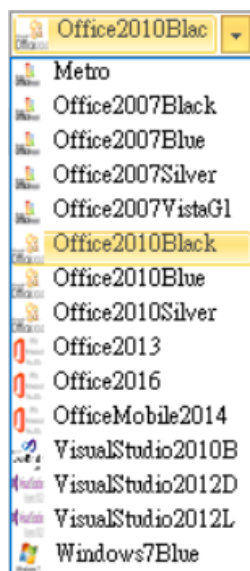
⑦ System Function Setup

Switch to  Settings page to operate system functions.

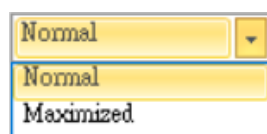




1. Language: three language options are available.



2. Style: system operating style can be changed.



3. Initialwindow: To set the initial windows setting.



4. Background color: system background color can be selected.



5. Auto connection: When switching , the serial port (COM) will automatically connect to the device the next time you start the software.

6. Output format: Different formats for record storage can be select.



⑧ Info Company Website

Switch to  Info page to browse  Kilews official website.



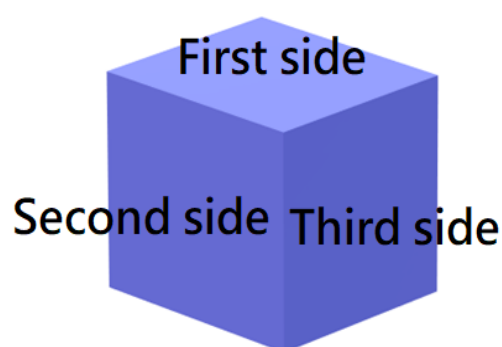


⑨ Example Description

NOTE:

1. 1 Unit (Unit No.1 ~ No. 8) = Program
2. 1 Program (Program No.1 ~ No. 99) : 99 programs could be set
3. Tool: always Tool1

When screws are fastened on 3 sides of a product, the condition is as follows:



Job

Unit	Program	Tool1
First Side (Unit1)	Program 1= Maximum count value: 4, HQ: 15 kgf.cm, LQ: 1 kgf.cm	Tool 1
Second Side (Unit2)	Program 2= Maximum count value : 3, HQ: 20 kgf.cm, LQ: 5 kgf.cm	Tool 1
Third Side (Unit3)	Program 3= Maximum count value : 2, HQ: 18 kgf.cm, LQ: 3 kgf.cm	Tool 1



Step 1: Set the Unit 1 ~ Unit 3 condition (refer to [“SAVE”](#) for setting up the parameter condition)

1. Set to Unit 1 when the first side is fastened

Program5 condition = maximum count as 4, maximum fastening torque (HQ) 15 kgf.cm, minimum fastening torque (LQ) 1 kgf.cm, and tool 1.

2. Set to Unit 2 when the second side is fastened

Program8 condition = maximum count as 3, maximum fastening torque (HQ) 20 kgf.cm, minimum fastening torque (LQ) 5 kgf.cm, and tool 1.

3. Set to Unit 3 when the third side is locked

Program10 condition = maximum count as 2, maximum fastening torque (HQ) 18 kgf.cm, minimum fastening torque (LQ) 3 kgf.cm, and tool 1.

4. After complete setting parameters, press  to save data.

Press  to enter the “Controller and Job setup page”.



- Set condition parameter steps (Program 5、Program 8、Program 10 settings are the same):

2

4

5

1

☒ **Control Program Configuration (Auto Learning):**

Program : CLEAR CONFIRM DISABLE ENABLE RESET

ToolID : EDIT COPY LOAD SAVE SELECT QUIT

Edit Settings

Lock Settings

3

Program Load/Write :

1 / 1

Max Count :

SP : LO RC: 0.000 PT : 0.000

AT : 2.000 OT : 0.000 Offset : 0.00 Nm

LL : 0.000 CT : 10

RT : 0.000 RR : 0.000 RS : 0.000

NS : AS :

DAS System Status :

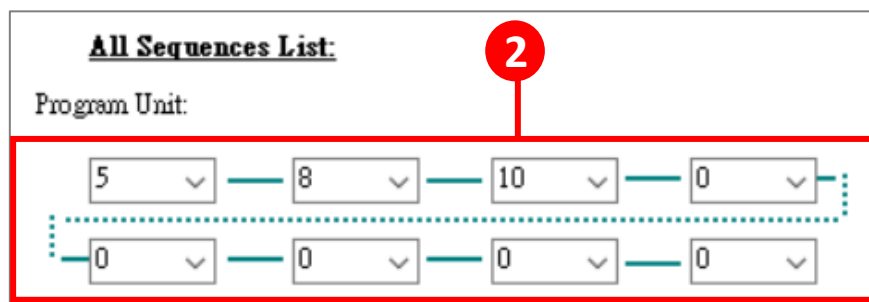
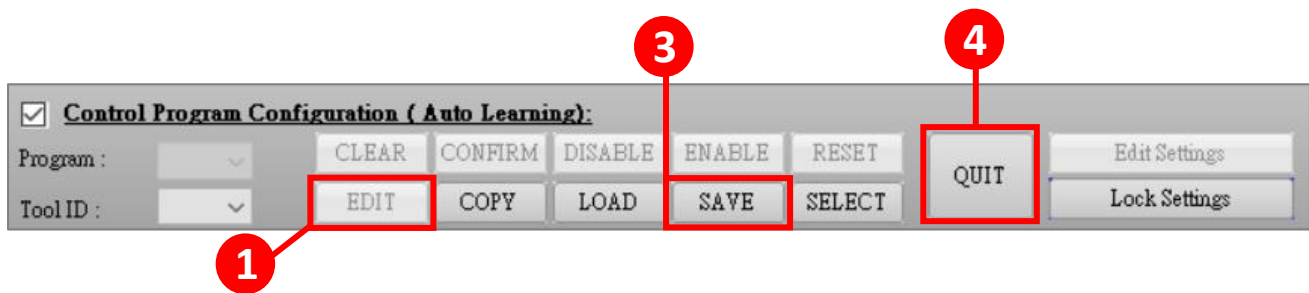
HT : 9.990 LT: 0.000 Status :

HQ : 9.9 LQ: 0.000 Status :

HC : 9.9 LC : 0.000 Status :

**Step 2:**

Press  to modify the program Unit. Press  to then  to store the parameters.





⑩ Statement

Reminder again, please follow the relevant regulations and the international practice of the Internet. Never do anything illegal or harm to the company in any illegal way. You may not use this service to engage in violations of other's rights or illegal activities: Please acknowledge you have ownership for all your photos and texts. Do not post or transmit any files that are defamatory, insulting, threatening, offensive, indecent, defamatory, false, in violation of public order or good customs or other unlawful words, pictures or files in any form, nor infringe on the reputation or privacy of others, business secrets, trademarks, copyrights, patents, other intellectual property rights and other rights, and other acts that are deemed improper.