Technical News Bulletin

July 2010

FlexIS Software Release V. 1.07.02.16

FlexIS software version 1.07.02.16 has now been officially released. The new software is a major release, 2\textsuperscript{nd} of 2010, with several new features. Please contact our Technical Service Group through your local sales office for support in installing the new software.

New Features included in the 1.07.02.16 release

Gob Forming and Delivery

Gob Distributor screen:
On the Gob Spray setup there is an additional column “Offset”. It is now possible to trigger to a certain section (‘Offset’) for the gob spray if a multiple of the number of running sections is entered in the ‘cuts’-field. The picture shows that “gob spray 3” is always triggered on section 1 and “gob spray 4” always on section 10. It is now also possible to synchronize all gob spray outputs by pressing the button on the Gob Distributor page.
Mechanical Feeder:
If the proximity switch does not deliver a valuable signal and the “Feeder Sync Supervision” is ON, the GD swings out.

Section Setup

Event Configuration:
Now the Interceptor Event can be configured like another event. If the machine does not have an Emhart Gob Distributor (scoop or different gob distributor) the Interceptor Event must be configured “Angle-Angle” and operator can program the ON and OFF angle of the Interceptor. The duration of the Interceptor movement will be related to the speed of the machine and it will be not necessary to change the duration (msec) on the “Dongle page”.
Special Cycle Configuration:
Now, it can be selected whether the bottles should be rejected or not in the CoMo cycles after manual swab, configuring “Swab Cold Mold” in the Dongle Section Parameter (see Machine Setup / Dongle Configuration):

a) if “no reject” is configured, after Manual Swab the section controller reject the number of bottles programmed on “Reject Cycle Blank” and “Reject Cycle Blow” independently of the number of CoMo cycle.

b) if “rejected” is configured the section controller reject the highest value programmed between CoMo Cycle and reject cycle.

New “on” Section Control

Normal / Alternate stop with non Emhart servo GD:
When stopping the section with delivery on, the section did not clear the remaining glass out of the section but just stopped with the next critical event, this has been changed.

Cold Blank/Mold Reject:
This function has been completely revised and optimized. It should no longer happen that the last good bottles before entering the swab cycle are rejected. It should also no longer happen that the bottles produced during the swab or CoMo cycles are rejected incompletely.

Version settings:

a) New DA file for the 860 pusher with Jet Move 204 (affects TS-E only) has been added, a wrong error was displayed.

b) New DA file for Servo Takeout to Improve motion controller settings.
Machine Setup

Sect Controller Dongle

Swab CoMo:
See Special Cycle above

Plunger Cooling MS:
With this parameter, it can be selected whether the plunger cooling could be activates or not in the MS cycles.
“enabled” only with section in delivery and P&B or NNPB process configured (see Job/ Process screen) pressing MS the plunger cooling event will be activated automatically and the “CoMO blue lights” on BK and BW panels will flash, operator can stop it just pressing the blue pushbutton of CoMo.
“Disabled” plunger cooling will be deactivated in MS.

WHC Dongle

Conveyor Height Adjust:
Both supported motor types can now be selected.
Encoders can also be disabled.
FlexLine & EFRA Parameter Setup

With the existing software Version, as announced with TNB 170, it is possible to load special firing orders calculated with “Firing Order Generator” but, in case of EFRA, all the parameters must be calculated and loaded manually.

With this new V 1.02.07.16 it is possible to calculate and load, also for conveyor and WT with gear ratio not standard EG, the EFRA No, Nb and Nw parameters.

Also for the very slow machine, where it is necessary to duplicate or triplicate all the gear ratio of the cinematic chain to increase the speed of the synchronous motors, it is possible to select this “Slow Machine Factor” and to calculate and load the EFRA parameters.

For Belt Advance higher than 21”, on the Flexline screen, it is indicated the “Number of gap” per machine cycle (virtual bottles = (Belt Adv-21)/21 x # Sect. in operation x # of cavity) and on the EFRA Set UP screen the parameter “Total Belt Advance” indicate the real belt advance in Inch.
**Job**

**Process Type**
As mentioned before “Plunger Cooling in MS” if this function needs to be active it is necessary to program on this page, for each section, the type of process that is running.
As you can see there are four options:
B&B
P&B
NNPB
Unknown
The plunger cooling MS works only with P&B and NNPB.