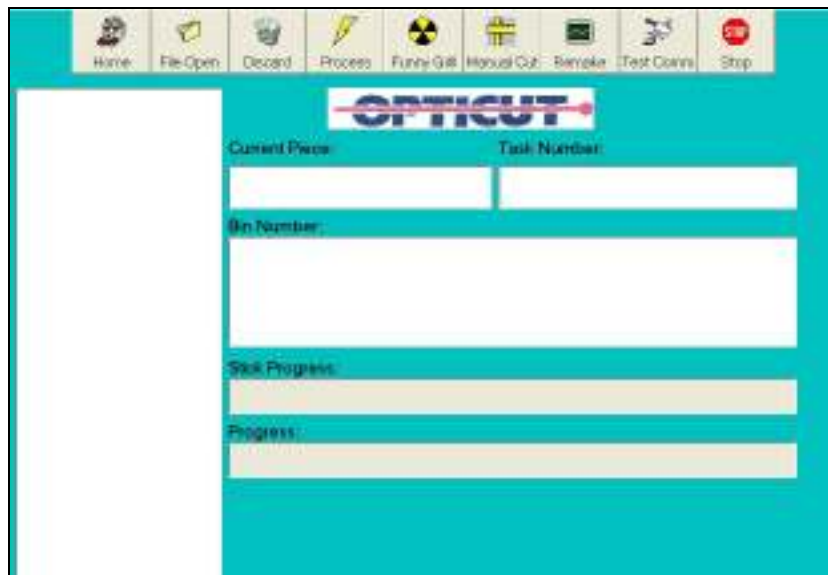


AUTO WINGRID
USERS MANUAL

Introduction

This document describes the basic use and operation of the Auto WinGrid from Opticut Technologies Inc.

In order to "RUN" the machine needs the following external item: Air pressure (100 psi), electric power applied to the controller and air solenoids, electric power and the switch turned on to the saw motor. The electric power is usually all inclusive in the supplied power bar.



Setup

The Auto WinGrid controller application has been designed for computers running Windows 98 SE to Windows XP. The computer must have at least two serial communication ports as well as a keyboard, mouse and monitor. A network connection is desirable but not necessary. One serial port must be connected to the Tigerstop control box with a serial port cable. The other serial port must be connected to the relay controller.

To configure the Auto WinGrid application to communicate with the motor and saw/punch the proper port numbers must be set in the configuration file.

Go to the folder `c:\autostop\`. Inside of the folder there is a file called `autostop.ini`. Open it in a text editor. Modify the entry for "port" to be the port number connecting the Tigerstop. Modify the entry for "relayport" to be the port number connecting the relay controller.

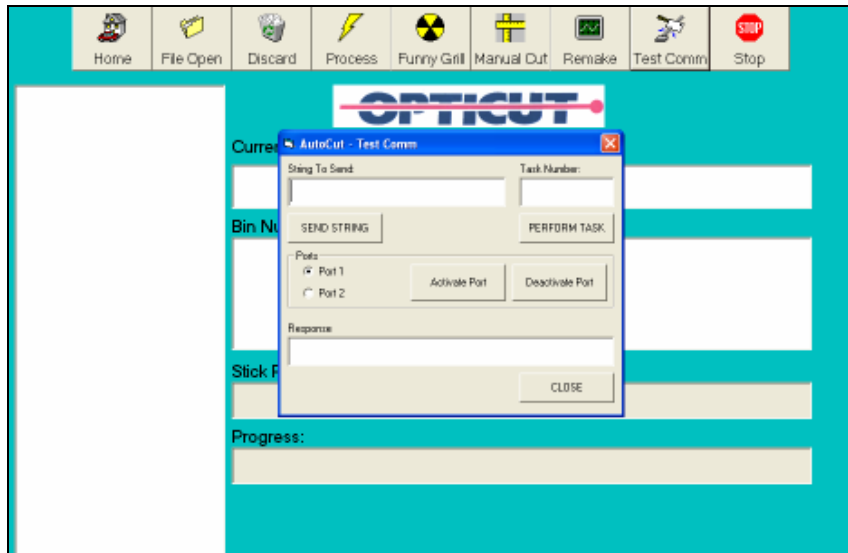


Fig. 2 Comm Port Test

Simple Usage

To process a production run of pre - optimized grills either a floppy disk or a shared network drive must be available. A file with a *.cut extension must be optimized by the production system and opened from the main screen. To open the file, click the File Open button on the main screen. A File Open dialog box will appear. Locate the *.csv file, either on a floppy or on the network, select it and click the Open button. When a file is successfully loaded, the tree on the left hand side of the main screen will be filled with the contents of the file.

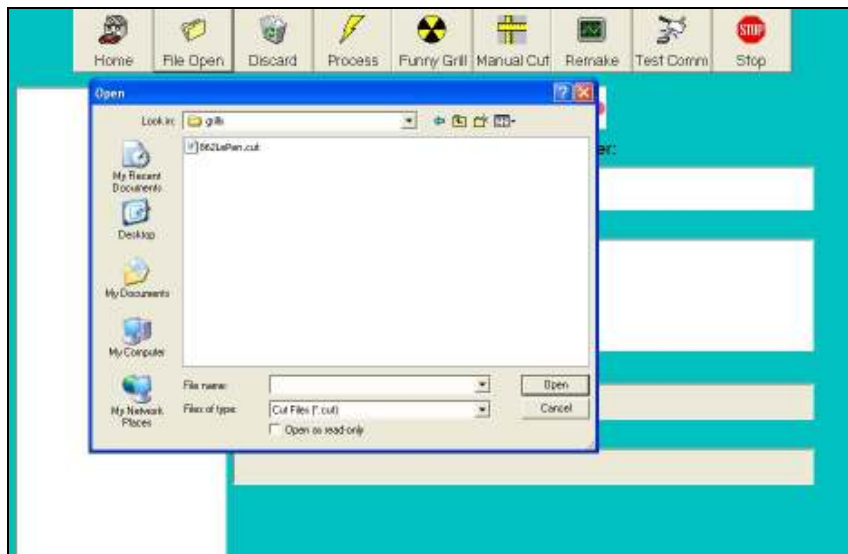


Fig. 3 File Open

In order to start processing the file, open the 'Batch Root' of the tree and select the first stick, usually stick 0. Next, click the Process button. You will be prompted with a message that displays the default stock size. If the stock size displayed is what the batch requires press the OK button and the arm will move to the appropriate position. If the stock size is different enter the new stock size and click the OK button. The arm will move to the appropriate position. If you would like to abort the process click the Cancel button.

After the arm has moved to the start position a message will be displayed prompting the user to load the machine with the grill bar. After loading the Auto WinGrid with stock turn the saw on and click the OK button to start the process.

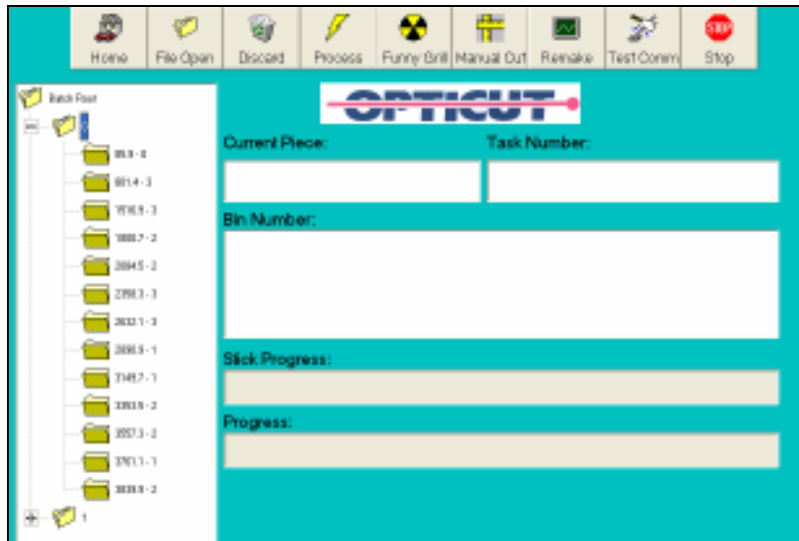


Fig. 4 File tree

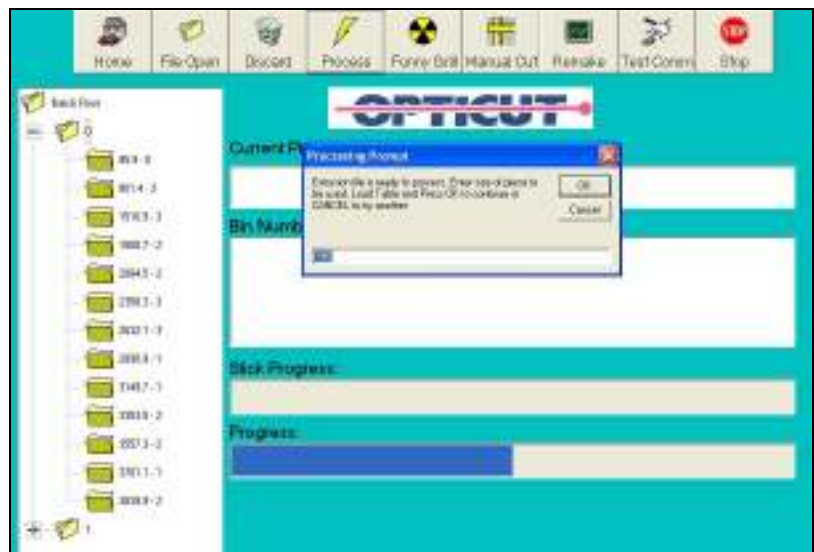


Fig. 5 Processing Screen

The machine will push the grill bar and make the cuts and punches. When a piece of grill bar is cut, the bin number that the piece belongs to will be displayed in the large text box. When a stick is finished, the arm will travel back to the home position and the user will again be prompted to verify the stock size for the next stick and the above process is repeated. When there are no more sticks to be processed the arm will move to the home position and the process will be complete.

Manual Cut

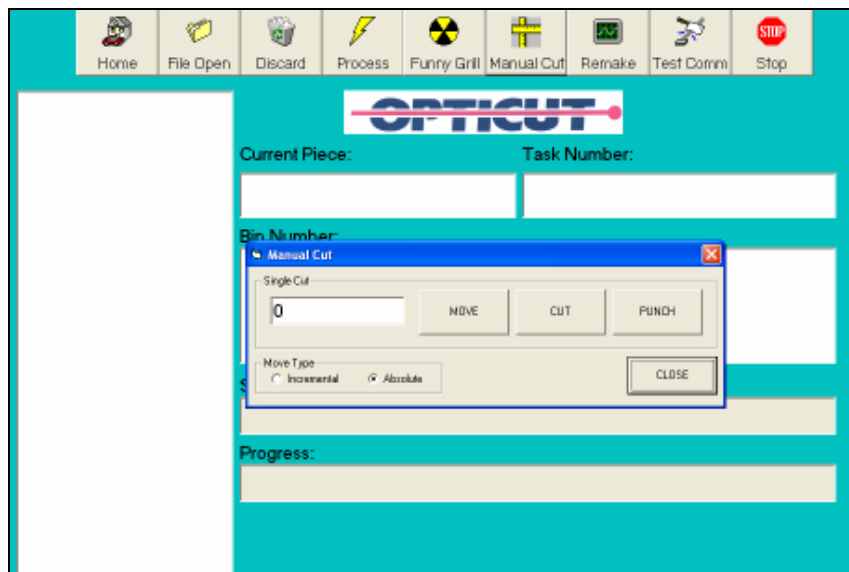


Fig. 6 Manual Cut

In order to perform a manual cut operation, click the Manual Cut button. Enter the length that you want the arm to move to and click the Move button. Clicking the Cut button will perform the cut operation and clicking the Punch button will perform the Punch operation.

Grill Remake

Instances may arise when the operator may have to reprocess some of the sticks in a production run but not all of them. The Grill Remake screen is used for this situation.

To use the Grill Remake feature click the 'Remake' button on the main screen, the Grill Remake dialog box will open. Clicking the Browse button will open the File Open dialog box. Search for the corresponding production run's csv file. The csv file contains the data before being optimized and indexed. After selecting the file and clicking the Open button the file will be loaded and displayed in the tree structure in the Grill Remake dialog box. A new filename will be generated and put into the Output File text box. Each stick in the production run is displayed with a corresponding bin/glass slot number. Open the tree up and click the check boxes of the sticks that need to be reprocessed. Make sure that all the values down the right hand side of the dialog are correct for the type of grills that you are processing and click the Optimize button. This will generate a new index file specified by the Output File text box. Close the Grill Remake dialog box, use the File Open feature to find and open the newly created file and process the file like any other production run file.

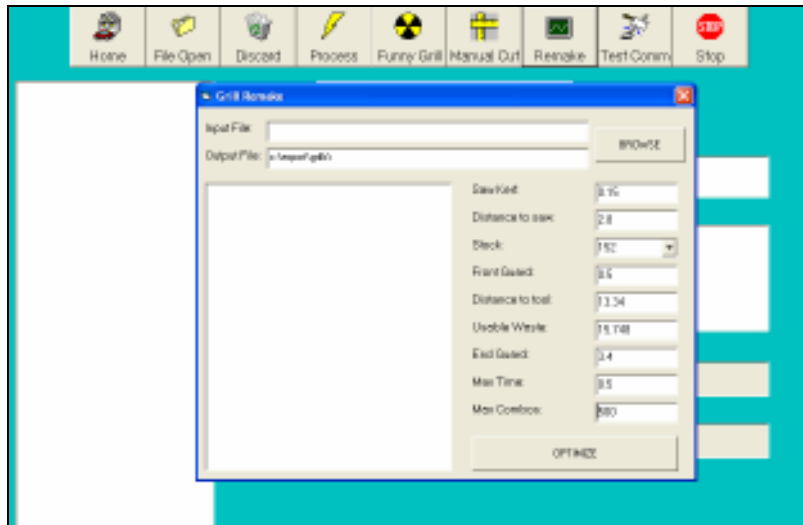


Fig. 7 Grill Remake

Funny Grills

The “Funny Grill” feature is used to generate a cut file of grills without utilizing the DaVinci production software.

This feature enables the operator to specify the size, type, color and number of grills, number and placement of notches. This will then generate a “cut” file, which is then processed through the “Simple Usage” stage discussed above.

You can also add pieces to a pre-existing “.csv” file by clicking the “Open File” button and importing the contents of the selected file. Performing this step will create a new Output File name at the bottom of the dialog box.

The Funny Grill feature also allows you to select or change the grill type (e.g. Colonial, Georgian, Pencil, etc.) by selecting from the Bar Type drop down list. The Grill Color is chosen similarly in the Bar Color box.

Enter the length of the grill in the Length text box and the number of grills of this length you want to process in this run. Enter the number of spaces, which is the number of notches plus 1, in the Num Spaces box. When you exit the Num Spaces box, a picture representing the grill will appear as well as text boxes with the length of each space. You can modify the values in the text boxes and a running sum of the bar length will be displayed in the Actual Length box. Clicking the Add To List button will add the piece to the production run.

Clicking the Optimize List button will generate an index file at the location specified in the Output File box. Once the file is generated, close the Funny Grills dialog and open the file using the Simple Usage process discussed above.

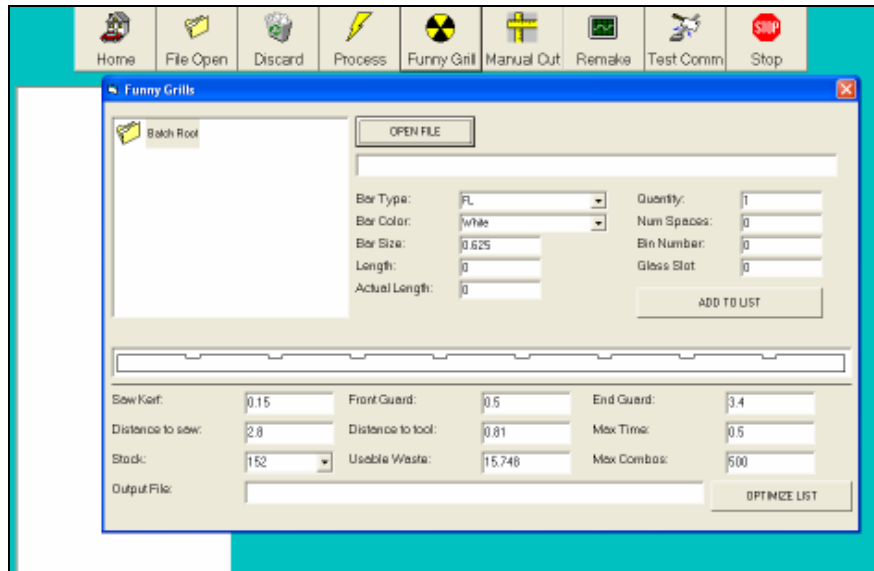


Fig. 8 Funny Grills

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