# Koike C press Alteration

Problem: Cannot control the Number of Non spray cycle& water volume tower-wise individually. This problem was found during pop up, where the edges in pop up tower needs different water volume in comparison with another tower running with normal full width reel.

Solution: Alter the number of non-spray cycle values& water volume in Page cut control individually.i.e the values can be altered for different towers by operators.
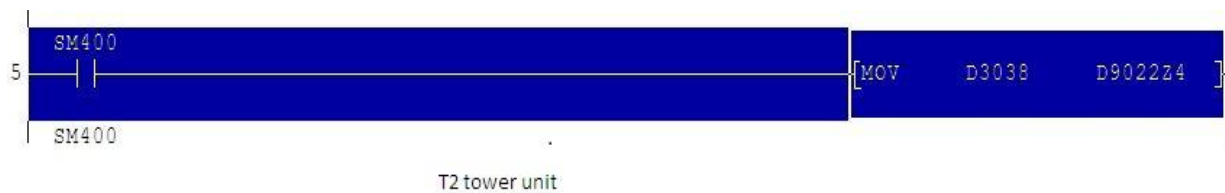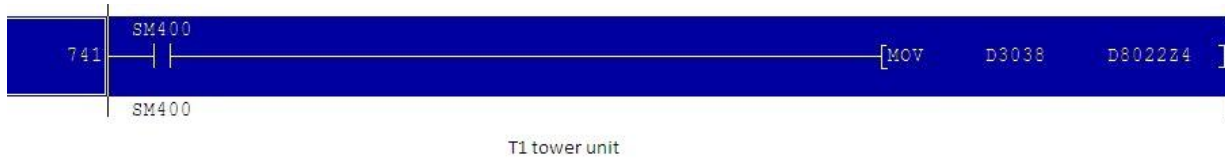
Reference Image:

SCREEN BEFORE EDITING
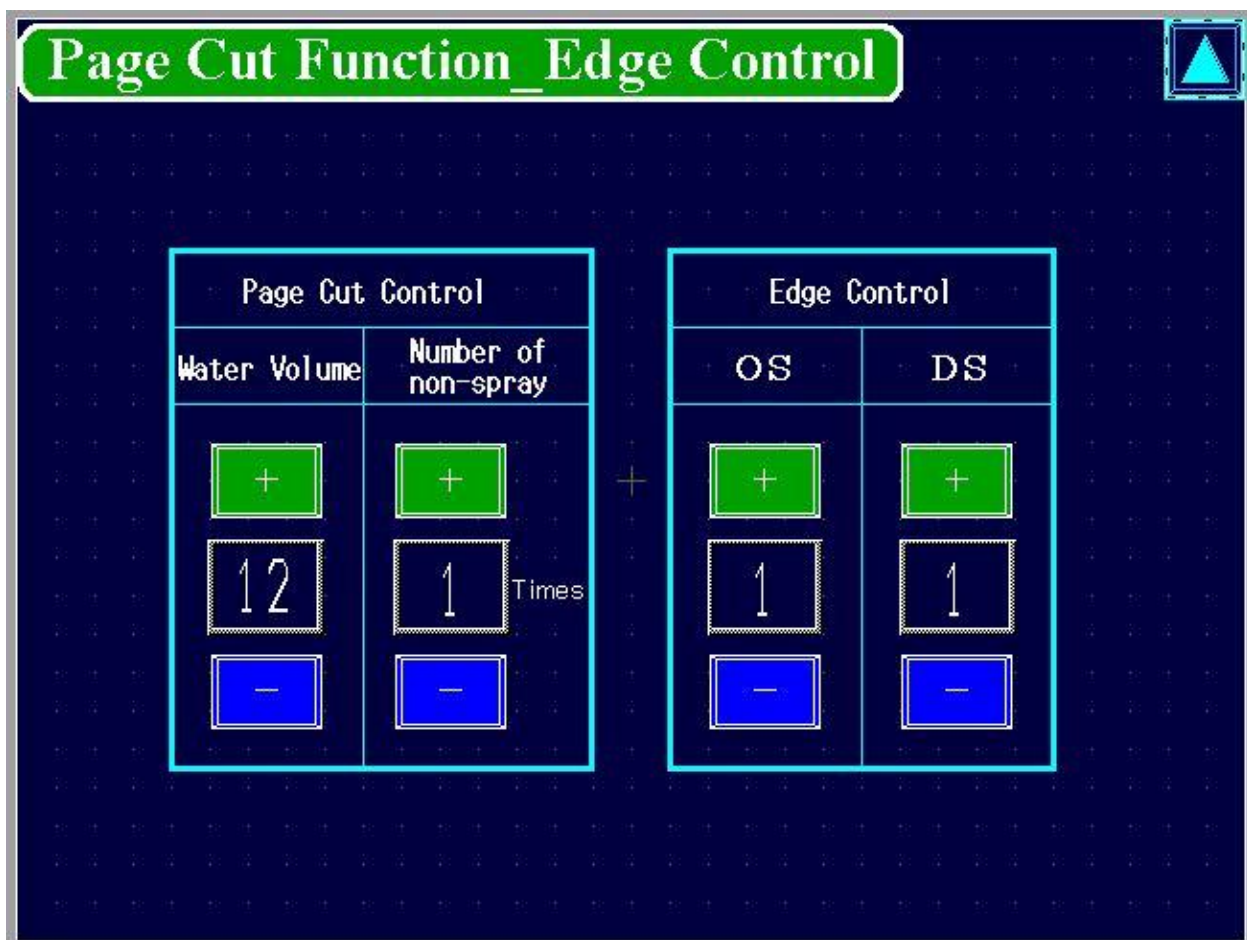
Program Modification steps

1. The number of non spray value are stored in D3038 register. These values get transferred to tower spray control board with address for T1-D8022, T2-D9022, T3-D10022, T4-D11022, T5-D12022.

T1 tower unit

T2 tower unit

2. So instead of using same D3038 register, we used separate registers for all towers. Separate register are chosen based on the free registers in the program.

3. An input for tower section is given on screen, so that these spray cycle can be varied for each tower. An ALL Input is given for transferring same values to all towers as per previous function.
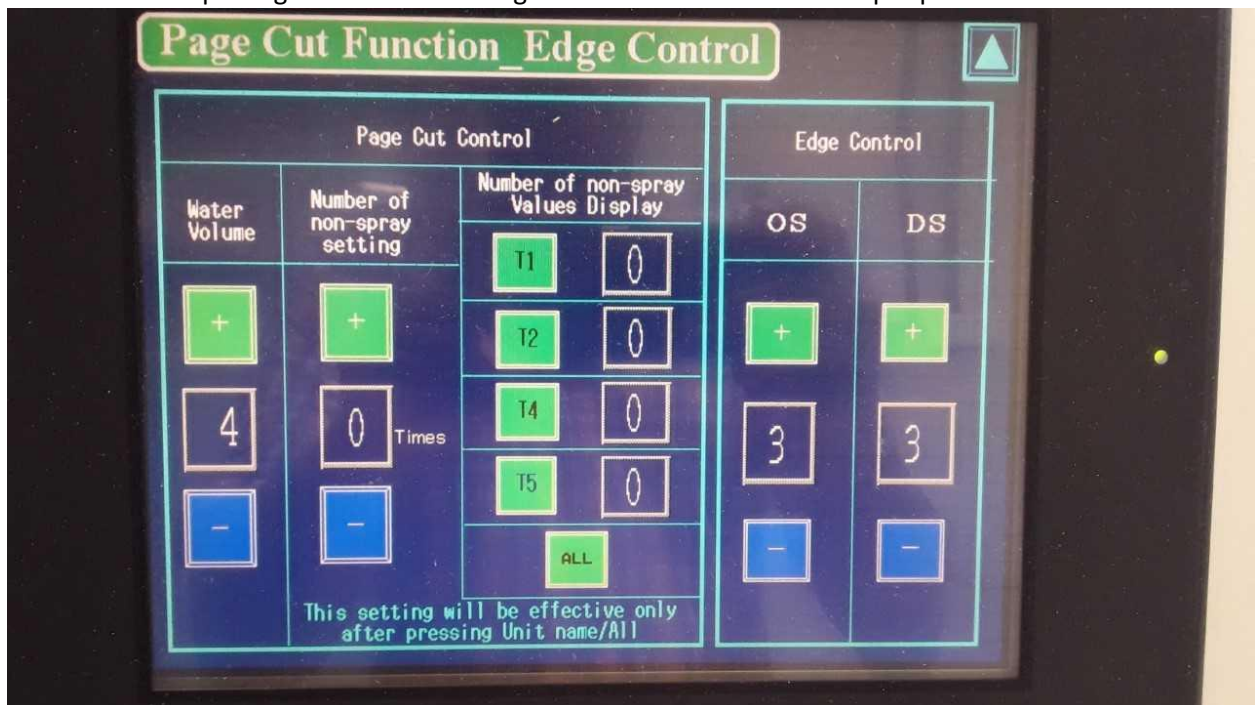
4. Only Koike board PLC is altered. So these values has to be transferred to Koike Panel PLC. So, D8022 in board gets transferred to D 2100 in Panel for T1, D9022 to D2101 in T2, D11022 to D2102 for T4, D12022 to D2103.
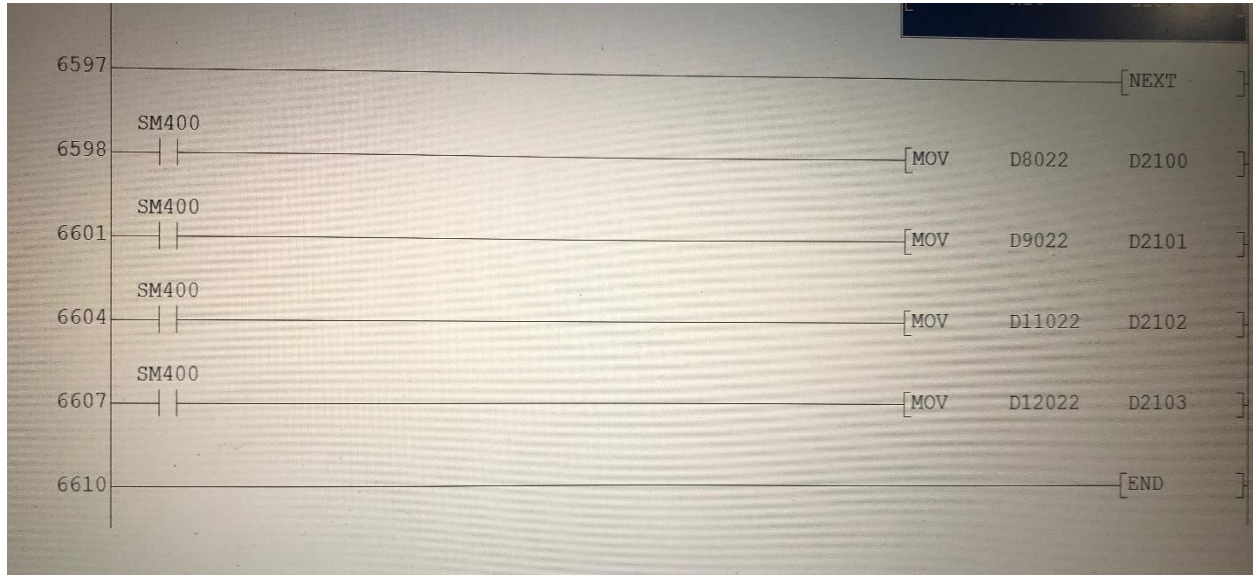
5. These registers D2100, D2101, D2102, and D2103 are configured in the proface touch panel software.

SCREEN AFTER EDITING