MANUAL MODE

⬆ CLAMPING ⬇	⬆ SKY / GROUND MOTOR ⬇
⬆ MAIN ASSY ⬇	⬆ EXTERNAL / INTERNAL MOTOR ⬇
⬆ VACUUM CYL ⬇	⬆ VACUUM
⬅ PUNCH CYL ➡	MENU

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

	CYCLE TIME	12.3	Sec.
dd/mm/yy			
	JOB COUNTER	1234	RESET

TEST	OK	NOK
PULL OUT		
SKY		
GROUND		
INTERNAL		
EXTERNAL		

PULL OUT TIME   1234.5   Sec.

STATUS :-   Wait For Cycle Start

| MENU | SETTING | MANUAL |

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

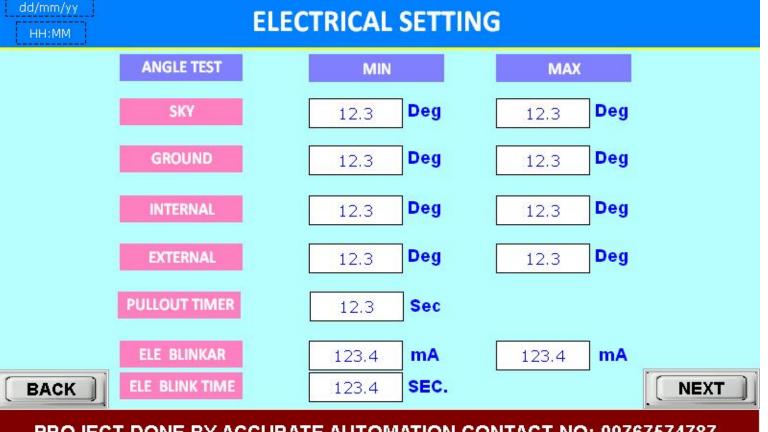| MANUAL	DIGNOSTICS
ELEC SETTING	MECH SETTING
RESULT	TRESEBILITY

BACK

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

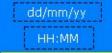H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

ELECTRICAL SETTING

ANGLE TEST	MIN		MAX	
SKY	12.3	Deg	12.3	Deg
GROUND	12.3	Deg	12.3	Deg
INTERNAL	12.3	Deg	12.3	Deg
EXTERNAL	12.3	Deg	12.3	Deg
PULLOUT TIMER	12.3	Sec		
ELE BLINKAR	123.4	mA	123.4	mA
ELE BLINK TIME	123.4	SEC.		

BACK

NEXT

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd/mm/yy

HH:MM

ELE W/O BLINK	MECH + BLINK
FULLY ELE	FULLY MECH
FULLY ELE PF	MENU

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

CYCLE TIME	12.3	Sec.
JOB COUNTER	1234	RESET

	MIN	MAX	ACTUAL	
SKY :-	12.3	12.3	12.3	deg
GROUND :-	12.3	12.3	12.3	deg
INTERNAL :-	12.3	12.3	12.3	deg
EXTERNAL :-	12.3	12.3	12.3	deg
PULL LOAD			12.3	Kg
BLINKAR	123.4	123.4	123.4	mA

TEST	OK	NOK
PULL OUT		
SKY		
GROUND		
INTERNAL		
EXTERNAL		
ELE BLINKAR		

RH PART SELECT   **ELELECTRICAL**   **SPARKING SILVER**

STATUS :- **WAIT FOR CYCIE START**

MENU   **SETTING**   **MANUAL**

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

DIGNOSTICS

INPUT LIST		INPUT LIST		OUT PUT LIST	
E-Stop	X0	SPAIR	X30	DECLAMP	Y0
Cycle Start-1	X1	SPAIR	X31	CLAMP	Y1
Cycle Start-2	X2	SPAIR	X33	MAIN SLIDE UP	Y2
RESET	X3			VACUUM UP	Y3
MAIN AIR PRESS.	X4			PUNCH	Y20
MAIN SLIDE DOWN	X5			VACUUM ON	Y21
Vacuum Down	X6			RED	Y22
Vacuum UP	X7			ORANGE	Y23
VACUUM AIR PRESS.	X20			GREEN	Y24
RH Fixture	X21			BUZZER	Y25
LH Fixture	X22			POLARITY	Y30
CLAMP DOWN	X23			SKY/GND	Y31
PRINTER SENSOR	X24			INT/EXT	Y32
RED BIN	X25				

[MAIN]   [ANALOG]

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SETTING

ELE SETTING   MOTOR

MENU

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

MECH SETTING

ANGLE TEST	MIN		MAX	
INTERNAL	12.3	Deg	12.3	Deg
EXTERNAL	12.3	Deg	12.3	Deg
SKY	12.3	Deg	12.3	Deg
GROUND	12.3	Deg	12.3	Deg

BACK

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

MOTOR SETTING

SKY
MOTOR

12.3 **Sec.**

GROUND
MOTOR

12.3 **Sec.**

INTERNAL
MOTOR

12.3 **Sec.**

EXTERNAL
MOTOR

12.3 **Sec.**

BACK

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

ELECTRICAL PART CALIBRATION

LVDT LH	Current Count LH	FACTOR LH	FINAL LH
SKY	12345	12.34	1234
GROUND	12345	12.34	1234
INTERNAL	12345	12.34	1234
EXTERNAL	12345	12.34	1234

LVDT RH	Current Count RH	FACTOR RH	FINAL RH
SKY	12345	12.34	1234
GROUND	12345	12.34	1234
INTERNAL	12345	12.34	1234
EXTERNAL	12345	12.34	1234
ELE BLINKAR	12345	123	

LVDT COUNT RESET

STARTING MIRROR ANGLE

12.34

LOAD CELL COUNT

12345

CALIBRATION FACTOR

12.34

FINAL

1234.5

COUNT RST

L.C. COUNT RESET

BACK

PRINTER SETTING

WITH PRINTER PROGRAM RUNNING

NEXT

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

RESULT

ELE RESULT

MECH RESULT

MENU

MECHANICAL RESULT

CYCLE TIME	12.3	Sec.
JOB COUNTER	1234	RESET

JOYSTICK ANGLE

	OK	NOK
BLINKER		
PULL OUT		
INTERNAL		
EXTERNAL		
SKY		
GROUND		

INTERNAL
12.3 Deg

SKY
12.3 Deg

EXTERNAL
12.3 Deg

GROUND
12.3 Deg

STATUS :- Wait For Cycle Start

MENU	SELECT JOB	SETTING	MANUAL

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd/mm/yy			CYCLE TIME	12.3	Sec.
			JOB COUNTER	1234	RESET

				TEST	OK	NOK
SKY :-	12.3	deg		BLINKER		
GROUND :-	12.3	deg		POWER FOLD		
INTERNAL :-	12.3	deg		PULL OUT		
EXTERNAL :-	12.3	deg		SKY		
BLINKER	12345	ma		GROUND		
PULL LOAD	12.3	Kg		INTERNAL		
PULL OUT TIME	1234	Sec.		EXTERNAL		
STATUS :-	Wait For Cycle Start					

MENU	SELECT JOB	SETTING	MANUAL

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

	CYCLE TIME	12.3	Sec.
dd/mm/yy	JOB COUNTER	1234	RESET

SKY :-	12.3	deg	
GROUND :-	12.3	deg	
INTERNAL :-	12.3	deg	
EXTERNAL :-	12.3	deg	
PULL LOAD	12.3	Kg	
PULL OUT TIME	1234	Sec.	
STATUS :-			

TEST	OK	NOK
PULL OUT		
SKY		
GROUND		
INTERNAL		
EXTERNAL		

MENU   **SETTING**   **MANUAL**

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787
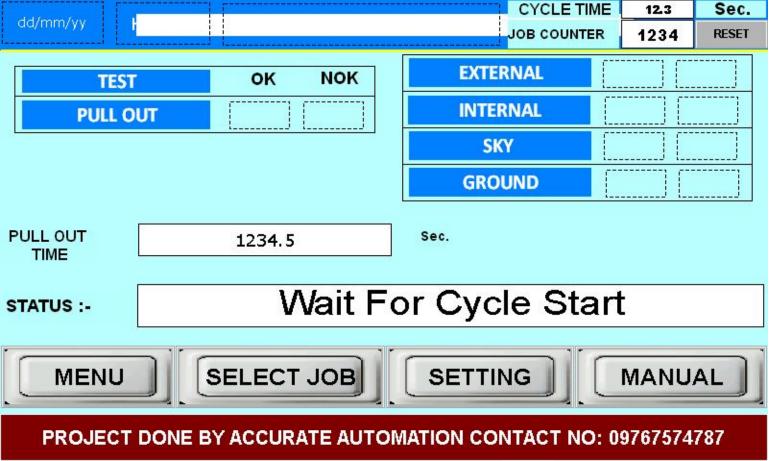
H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

TEST		OK	NOK
BLINKER			
PULL OUT			

SKY		
GROUND		
INTERNAL		
EXTERNAL		

PULL OUT TIME   1234.5   Sec.

STATUS :-   Wait For Cycle Start

MENU   **SELECT JOB**   **SETTING**   **MANUAL**

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

| dd/mm/yy | | | CYCLE TIME | 12.3 | Sec. |
| | | | JOB COUNTER | 1234 | RESET |

TEST	OK	NOK
PULL OUT		

SKY		
GROUND		
INTERNAL		
EXTERNAL		

PULL OUT TIME   1234.5   Sec.

STATUS :-   **Wait For Cycle Start**

MENU	SELECT JOB	SETTING	MANUAL

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

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	CYCLE TIME	12.3	Sec.
dd/mm/yy	JOB COUNTER	1234	RESET

TEST	OK	NOK
BLINKER		
PULL OUT		

EXTERNAL		
INTERNAL		
SKY		
GROUND		

PULL OUT TIME   1234.5   Sec.

STATUS :-   Wait For Cycle Start

MENU	SELECT JOB	SETTING	MANUAL

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

| dd/mm/yy | H: | CYCLE TIME | 12.3 | Sec. |
| | | JOB COUNTER | 1234 | RESET |

TEST	OK	NOK
PULL OUT		

EXTERNAL		
INTERNAL		
SKY		
GROUND		

PULL OUT TIME 　　　1234.5　　　Sec.

STATUS :- Wait For Cycle Start

| MENU | SELECT JOB | SETTING | MANUAL |

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

ARE YOU SURE
YOU WANT TO RESET
LVDT COUNTS

YES   BACK

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

ARE YOU SURE
YOU WANT TO RESET
LOADCELL COUNTS

YES   BACK

SETTING

SR NO.	PART DESCRIPTION OF MIRROR	TORISHI CODE	PART NO.
1	ORVM LH ELEC ORANGE	ABCDEFGHIJ…	ABCDEFGHIJ…
2	ORVM LH ELEC DARK METALLIC GT	ABCDEFGHIJ…	ABCDEFGHIJ…
3	ORVM LH ELEC GRAINED	ABCDEFGHIJ…	ABCDEFGHIJ…
4	ORVM RH ELEC ORANGE	ABCDEFGHIJ…	ABCDEFGHIJ…
5	ORVM RH ELEC DARK METALLIC GT	ABCDEFGHIJ…	ABCDEFGHIJ…
6	ORVM RH ELEC GRAINED	ABCDEFGHIJ…	ABCDEFGHIJ…
7	ORVM LH MECH ORANGE	ABCDEFGHIJ…	ABCDEFGHIJ…
8	ORVM LH MECH DARK METALLIC GT	ABCDEFGHIJ…	ABCDEFGHIJ…
9	ORVM LH ELEC GRAINED	ABCDEFGHIJ…	ABCDEFGHIJ…
10	ORVM RH MECH ORANGE	ABCDEFGHIJ…	ABCDEFGHIJ…
11	ORVM RH MECH DARK METALLIC GT	ABCDEFGHIJ…	ABCDEFGHIJ…
12	ORVM RH ELEC GRAINED	ABCDEFGHIJ…	ABCDEFGHIJ…
13	ORVM LH ELEC WHITE	ABCDEFGHIJ	ABCDEFGHIJ…
14	ORVM RH ELEC WHITE	ABCDEFGHIJ…	ABCDEFGHIJ…
15	ORVM LH ELEC BLACK (shine black)	ABCDEFGHIJ…	ABCDEFGHIJ…
16	ORVM RH ELEC BLACK (shine black)	ABCDEFGHIJ…	ABCDEFGHIJ…

BACK   NEXT

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

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| dd.mm.yy | HH:MM:SS | A |

ABCDE ABCDEFGHIJ...

ABCDEFGHIJ... **ABCDE** 123

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MECHANICAL SETTING

ANGLE TEST	MIN		MAX	
SKY	12.3	Deg	12.3	Deg
GROUND	12.3	Deg	12.3	Deg
INTERNAL	12.3	Deg	12.3	Deg
EXTERNAL	12.3	Deg	12.3	Deg
PULLOUT TIMER	12.3	Sec		

BACK

PROJECT DONE BY ACCURATE AUTOMATION CONTACT NO: 09767574787

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy | HH:MM:SS | A

ABCDE | ABCDEFGHIJ...

ABCDEFGHIJ... | **ABCDE** | 123

dd.mm.yy	HH:MM:SS	A

ABCDE	ABCDEFGHIJ...

ABCDEFGHIJ...	**ABCDE**	123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

MECHNICAL PART CALIBRATION

LVDT LH	Current Count LH	FACTOR LH	FINAL LH
SKY	12345	12.34	1234
GROUND	12345	12.34	1234
INTERNAL	12345	12.34	1234
EXTERNAL	12345	12.34	1234

LVDT COUNT RESET

LOAD CELL COUNT

12345

CALIBRATION FACTOR

12.34

LVDT RH	Current Count RH	FACTOR RH	FINAL RH
SKY	12345	12.34	1234
GROUND	12345	12.34	1234
INTERNAL	12345	12.34	1234
EXTERNAL	12345	12.34	1234

STARTING MIRROR ANGLE

12.34

FINAL

1234.5

COUNT RST

L.C. COUNT RESET

BACK

PRINTER SETTING

WITH PRINTER PROGRAM RUNNING

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A

ABCDE ABCDEFGHIJ...

ABCDEFGHIJ... **ABCDE** 123

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	

ABCDEFGHIJ...	**ABCDE**	123

dd.mm.yy	HH:MM:SS	A

PART NO. ABCDEFGHI

TORSHI CODE **ABCDE** 123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

dd.mm.yy	HH:MM:SS	A

ABCDE ABCDEFGHIJ...

ABCDEFGHIJ...	**ABCDE**	123

dd.mm.yy	HH:MM:SS	A
ABCDE	ABCDEFGHIJ...	
ABCDEFGHIJ...	**ABCDE**	123

dd.mm.yy HH:MM:SS A

ABCDE ABCDEFGHIJ...

ABCDEFGHIJ... **ABCDE** 123

SETTING

SR NO.	PART DESCRIPTION OF MIRROR	TORISHI CODE	PART NO.
17	ORVM LH MECH BLACK (sparking silver)	ABCDEFGHIJ…	ABCDEFGHIJ…
18	ORVM RH MECH BLACK (sparking silver)	ABCDEF	ABCDEFGHIJ
19	ORVM LH ELEC BLINKAR (white)	ABCDEFGHIJ…	ABCDEFGHIJ…
20	ORVM RH ELEC BLINKAR (white)	ABCDEFGHIJ…	ABCDEFGHIJ…
21	ORVM LH ELEC BLINKAR (Black)	ABCDEFGHIJ…	ABCDEFGHIJ…
22	ORVM RH ELEC BLINKAR (Black)	ABCDEFGHIJ…	ABCDEFGHIJ…
23	ORVM LH ELEC BLINKAR (Spare)	ABCDEFGHIJ…	ABCDEFGHIJ…
24	ORVM RH ELEC BLINKAR (Spare)	ABCDEFGHIJ…	ABCDEFGHIJ…

BACK

H:\TATA TRAABILITY\TRACEABILITY DATA\XBA ORVM\XBA ORVM\XBA ORVM\XBA ORVM 080823\XBA ORVM MY19 EOL UPLOAD 080823.dpa 8/26/2023

TRESEBILITY

TRESEBILITY ON / OFF		CAMERA ON / OFF

UNIK CODE JOB COUNTER   **1234**   RESET

BACK