

Configuración de sistema

| No. | ATLAS-202 Contents | Description | Explanation | ATLAS-201 | Default | Recommened | Min | Max | Note |
|-----|--------------------|--|---|------------------|---------|------------|-----|------|--|
| 1 | Machine Type | Machine type (L=200, R=201) | | | 201 | | | | Actual setting is to be changed by Dip SW 1-3 (On: L, Off : R) |
| 2 | High Spd Poker | Select use or not use of High Speed Poker | 0: Turn the high speed poker off, 1: Turn the high speed poker on | HIGH SPD POKER | 0 | | 0 | 1 | |
| 3 | Vacuum Detect | Select detect or not detect vaccum error | 0: Turn the vaccum detect off, 1: Turn the vaccum detect on | VACUUM DETECT | 0 | 1 | 0 | 1 | |
| 4 | Metal Mode | Select operation mode when MD signal comes in. | 0: Pause when FMD trip, 1: Stop production when FMD trip | METAL MODE | 0 | 1 | 0 | 1 | Frito-Lay Specification : 0 |
| 5 | Tape Tabs | Not functional | | TAPE TABS | 0 | | 0 | 1 | |
| 6 | Preset Limit | Not functional | | PRESET LIMIT | 0 | | 0 | 1 | Frito-Lay Specification : 1 |
| 7 | Gas Sensor | Select use or not use of Nitrogen Gas Sensor | 0: Not use N2 Gas Sensor, 1: Use N2 Gas Sensor | GAS SENSOR | 0 | | 0 | 1 | |
| 8 | Product Sensor | Select use or not use of Product Sensor | 0: Not use Product Sensor, 1: Use Product Sensor | PRODUCT SENSOR | 0 | | 0 | 1 | |
| 9 | Nitro On/Off | Select use or not use of N2 Gas Flush | 0: Not use N2 Gas flush Controller, 1: Use N2 Gas flush Controller | NITRO ON OFF | 0 | | 0 | 1 | |
| 10 | Nitro Start Dly | Not functional | | NITRO START DLY | 10 | | 10 | 300 | Fix to 5 or 10 sec depending upon bag length |
| 11 | Nitro Stop Dly | N2 Stop Delay from Operation Stop | N2 Gas flush will automatically stop and display the error when ATLAS stops longer than this setting time | NITRO STOP DLY | 120 | | 120 | 1200 | |
| 12 | Nitro Pause Dly | N2 Stop Delay from Operation Pause | Atlas will make high pressure N2 flush when Atlas stops longer than this setting time. If Atlas's stop time is shorter than this setting, Atlas will restart without high pressure N2 flush. | NITRO PAUSE DLY | 0 | | 0 | 300 | |
| 13 | Film Stopper | Select use or not use of Film Stopper | 0: Not use Film stopper, 1: Use Film Stopper | FILM STOPPER | 1 | | 0 | 1 | |
| 14 | Shaker | Select use or not use of Shaker | 0: Not use shaker (Continuous Mode), 1: Use shaker (Intermittent Mode) | SHAKER | 0 | | 0 | 1 | |
| 15 | Knife Dly Offset | Knife Delay offset time during high speed operation | To fire the knife with proper timing in high speed operation, the knife will be fired ahead of seal operation by this setting time. | KNIFE DLY OFFSET | 50 | | 50 | 100 | |
| 16 | Multi Dump | Select use or not use of Intermittent operation w/o Shaker | 0: Not use Multidump with intermittent motion without shaker, 1: Use multidump with intermittent motion without shaker | MULTIDUMP | 0 | | 0 | 1 | |
| 17 | Motion Gain | Speed Gain(Multiply) of Jaw in Intermittent operation w/o shaker | Increase the jaw rotation speed during intermittent & multidump mode. If 14 is entered during 20bpm operation, the jaw rotation speed becomes of 20*1.4 =28bpm jaw operation. | MOTION GAIN | 14 | | 12 | 24 | |
| 18 | M.D. Return RPS | Minimum Speed of Jaw Return in Intermittent operation w/o shaker | In case the bag length is longer than 600mm, the product cannot be catched with the closed jaw due to slower jaw close speed. By setting this speed, jaw close speed will be increased. | M.D.RETURN RPS | 40 | | 20 | 40 | |
| 19 | Banner On/Off | Select use or not use of Banner | 0: Not use banner, 1: Use banner | BANNER ON/OFF | 0 | | 0 | 1 | |
| 20 | BB Blou On/Off | Select use or not use of big bag blousing | 0: Not use big bag blousing, 2: Use big bag blousing * Turn on/off blousing during big bag production in continuous mode operation. By using the blousing (slow down the film speed relative to jaw rotation speed), the stripping length can be increased and cut position can be stabilized (by moving the jaw a little faster than the film, jaw will pull the film and cut position will not be sifted.) * When this setting is on (2), and bag length is longer than 300mm and setting speed is below BB Blou Spd Limit, machine goes into big bag mode. * In case the bag hangs over the jaw, turn this setting on (2) to slow down the film relative to the jaw rotation speed. * Setting 1 is not used (just for developers trial mode) | BB BLOU ON OFF | 0 | * 2 | 0 | 2 | * This value is to be used when the severe bag hanging happens during big bag run. |
| 21 | BB Blou Spd Limit | Max speed of big bag blousing in effect | Big bag mode (in which BB Blou is active) will active below this speed. | BB BLOU SPD LMT | 0 | * 120 | 0 | 120 | * This value is to be used when the severe bag hanging happens during big bag run. |
| 22 | BB Blou Angle | Jaw angle when big bag blousing starts. | In big bag mode, the film speed begin to slow down from the jaw angle set in this parameter. | BB BLOU ANGLE | 45 | * 55 | 30 | 60 | * This value is to be used when the severe bag hanging happens during big bag run. |

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|----|-----------------------|--|--|--------------------|------|---|------|------|---|
| 23 | BB Dmp Dly Lmt Spd | Big bag dump delay limit speed | In big bag mode, ATLAS will operate the jaw one cycle behind the normal operation to catch the product on the closing jaw below 40 bpm. (Catch the product of next cycle.) In case of the slow falling product, this type of delayed operation is required even if the speed is above 40 bpm. So, when the operation speed is below this setting, and the bag length is longer than the setting of BB Dmp Dly Lmt Len, the delayed operation is active. | BB DMP DLY LMT SPD | 50 | | 40 | 60 | |
| 24 | BB Dmp Dly Lmt Len | Big bag dump delay limit bag length | Minimum bag length for Bib bag mode operation | BB DMP DLY LMT LEN | 400 | | 200 | 600 | |
| 25 | Vacuum Auto Off | Select use or not use of Vacuum pump auto off | 0: Turn off Auto Vacuum Pump off, 1: Turn on Auto Vacuum Pump off | VACUUM AUTO OFF | 0 | 1 | 0 | 1 | |
| 26 | Vacuum Off Time | Vacuum pump auto off time (sec) | Time to activate Auto Vacuum Pump off | VACUUM OFF TIME | 20 | | 20 | 7200 | |
| 27 | Sensor Auto Adj | Select use or not use of Dump Sensor Auto adjust | 0: Turn off product sensor auto adjustment, 1: Turn on product sensor auto adjustment. | SENSOR AUTO ADJ | 0 | | 0 | 1 | Frito-Lay Specification : 1 |
| 28 | Sensor Adjust Cnt | Cycle of Dump Sensor Auto Adjust | Operation cycle of product sensor automatic adjustment | SENSOR ADJUST CNT | 10 | | 10 | 9000 | Only available for Frito-Lay Specification |
| 29 | Full Auto Dump | Dump Delay Auto Adjust | 0: Turn off full auto dump, 1: Turn on full auto dump | FULL AUTO DUMP | 0 | | 0 | 1 | Frito-Lay Specification : 1 |
| 30 | Air Jet Delay | Not functional | | | 0 | | 0 | 200 | APEX |
| 31 | Shutter1 Start | Not functional | | | 0 | | 0 | 1200 | |
| 32 | Shutter1 End | Not functional | | | 0 | | 0 | 1200 | |
| 33 | Shutter2 End | Not functional | | | 0 | | 0 | 1200 | |
| 34 | Charge Separation | Not functional | | | 0 | | 100 | 1000 | Only available for Frito-Lay Specification APEX |
| 35 | Dancer Upr Lmt | Dancer roller upper limit | Maximum load cell count for Dancer Roller Film End detection | DANCER UPR LMT | 4000 | | 2000 | 5000 | |
| 36 | Roll Dir Detect | Film Roll Winding direction auto detect | 0: Not use Film Roll winding auto detection, 1: Use film roll winding auto detection | ROLL DIR DETECT | 0 | | 0 | 1 | |
| 37 | FilmEnd Low Lmt | Film End (Lower side) Detect width | Detection width of Dancer roller lower position at film end | FILMEND LOW | 200 | | 100 | 500 | |
| 38 | Prod Drop Time | Product Drop time in Multidump without shaker | Dump request interval in multi dump mode (intermittent mode without shaker) * Dump Request interval = Cycle time - setting value of this parameter | PROD DROP TIME | 1000 | | 1000 | 2000 | |
| 39 | Dump Time Max | Product Drop Time | With standard Atlas's software, if "0" is set to dump delay, the interlock signal output and jaw close is same timing, and larger positive number is set, the jaw close will be delayed from interlock signal output from the bagmaker. However, if we set some value here, setting procedure will be changed as follows: If we set "0" on the screen, the jaw close will be delayed to the time as set in this parameter. If we set the same value as set in this parameter, the interlock signal will be sent when the jaw starts. As Frito-Lay machine's default is 950msec, if we set "0" in this parameter, the jaw will be closed 950msec after the interlock signal. The standard product drop time from WH to Jaw is 950msec, the product will be just caught with the closed jaw with this setting. | | 950 | | 0 | 3000 | |
| 40 | FMD RS232C I/F | Not functional | | FMD RS232C I/F | 0 | | 0 | 1 | |
| 41 | PRN RS232C I/F | Not functional | | PRN RS232C I/F | 0 | | 0 | 2 | |
| 42 | MD Test Probe | Not functional | | MD TEST PROBE | 0 | | 0 | 1 | |
| 43 | BigBag Blou Max Speed | Changed only in Developer mode | | BB MAX SPEED | 650 | | 600 | 1100 | |
| 44 | BigBag Blou Min Speed | Changed only in Developer mode | | BB MIN SPEED | 0 | | 0 | 400 | |
| 45 | BigBag Blou Acc Time | Changed only in Developer mode | | BB ACC TIME | 50 | | 30 | 100 | |
| 46 | M2 Cam Version | Changed only in Developer mode | | CAM VERSION | 1 | | 0 | 1 | |
| 47 | Product End | Changed only in Developer mode | | | 0 | | 0 | 500 | |
| 48 | HighSpeed Poker Speed | Changed only in Developer mode | | | 250 | | 200 | 300 | |
| 49 | Twin Film Feed Gain | Changed only in Developer mode | | FF GAIN | 100 | | 30 | 130 | |
| | | | | | 1000 | | 500 | 1500 | |

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| 51 | M3DU Acc Coeff | Changed only in Developer mode | | | 7 | | 3 | 20 | |
| 52 | M3Trq First Stage | Changed only in Developer mode | | LOW PRESSUER ? | 20 | | 20 | 80 | |
| 53 | M3DU Debug | Changed only in Developer mode | | | 1 | | 0 | 255 | |
| 54 | M3Trq Prestart Time | Changed only in Developer mode | | | 9 | | 3 | 20 | |
| 55 | M4 Acc Limit | Changed only in Developer mode | | ACC LIMIT | 2000 | | 0 | 9980 | |
| 56 | M4 Init Speed | Changed only in Developer mode | | INIT SPEED | 0 | | 0 | 9980 | |
| 57 | Developers Mode | Changed only in Developer mode | | WIDE BAG MODE | 0 | 1 | 0 | 7fffff | |
| 58 | CNT WideBag MaxSpe | Changed only in Developer mode | | WIDE MAX SPD | 30 | 35X41 | 0 | 250 | |
| 59 | HighSpeed Mode Spee | Changed only in Developer mode | | HIGH SPEED | 120 | 20 | 0 | 200 | |
| 60 | Blou Min Speed | Changed only in Developer mode | | | 50 | | 0 | 100 | |
| 61 | Blou Max Speed | Changed only in Developer mode | | | 650 | | 440 | 650 | |
| 62 | Blou Acc Time | Changed only in Developer mode | | | 50 | | 10 | 50 | |
| 63 | Film Feed Gain | Changed only in Developer mode | | | 0 | | 0 | 15 | |
| 64 | AutoDump Mode | Changed only in Developer mode | | | 1 | | 0 | 1 | Adjust in case of APEX at Ishida mode, bu t now it is completely fixed. |
| 65 | Jaw Close Offset Time | Changed only in Developer mode | | JAW CLOSE OFFSET TIME | 0 | | 0 | 300 | |
| 66 | INT Dump Time Max | Changed only in Developer mode | | | 500 | | 0 | 3000 | |
| 67 | TwinSeal Start Point | Changed only in Developer mode | | | 15 | | 5 | 40 | |
| 68 | M3 Max Torque | Changed only in Developer mode | | M3 MAX TRQ | 0 | | 0 | 1 | |
| 69 | Strip Limit Bag Len Min | Changed only in Developer mode | | STRIP LOW LMT | 100 | * 711 | 100 | 711 | * These are the value for Software stripping is off (Dip SW 1-5 is off) |
| 70 | Strip Limit Bag Len Max | Changed only in Developer mode | | STRIP UPR LMT | 711 | * 100 | 100 | 711 | * These are the value for Software stripping is off (Dip SW 1-5 is off) |
| 71 | Strip Limit Speed Max | Changed only in Developer mode | | STRIP SPD LMT | 150 | | 10 | 250 | |
| 72 | Poker Off Width | Changed only in Developer mode | | POKER OFF WIDTH | 0 | | 0 | 13*25.4 | |
| 73 | Closer On/Off | Changed only in Developer mode | | TUBE CLOSER | 0 | | 0 | 1 | |
| 74 | M3 Acc Time | Changed only in Developer mode | | M3UD TIME ? | 0 | | 0 | 200 | |
| 75 | M2 Acc Time 1 | Changed only in Developer mode | | M2UD TIME A ? | 0 | | 0 | BmSetup.M3UpDownTime | |
| 76 | M2 Acc Time 2 | Changed only in Developer mode | | M2UD TIME B ? | 0 | | 0 | 200 | |
| 77 | Strip Speed Gain | Changed only in Developer mode | | STRIP GAIN | 20 | | 10 | 20 | |
| 78 | Strip Seal Start Limit | Changed only in Developer mode | | SEAL DOWN LMT | 5 | | 1 | 40 | |
| 79 | HolePunch On/Off | Hole Punch | 0: Not use hole punch, 1: Use hole punch | HOLE PUNCH | 0 | | 0 | 1 | |
| 80 | CCW Master Flag | Not functional | | CCW MASTER | 0 | | 0 | 1 | |
| 81 | FilmSplice Width | Changed only in Developer mode | | | 15 | | 5 | 50 | Splicing Detection width |
| 82 | Current threshold DA | Changed only in Developer mode | | | 0 | | 0 | 4095 | Current Sensor Threshold |
| 83 | JawCatch On/Off | Not functional | For box motion machine. | JAW CATCH | 0 | | 0 | 1 | |
| 84 | Strip Blou Priority | Changed only in Developer mode | | BLOU PRI | 0 | | 0 | 100 | |
| 85 | Strip Plate Gap | Changed only in Developer mode | | PLATE GAP | 0 | | 0 | 100 | |
| 86 | Auto Restart | Auto Restart | 0: When the machine stop film low, need to push restart key to restart ATLAS. 1: When Atlas stop due to film low, Atlas automatically restart without pressing restart key. | AUTO RESTART | 0 | | 0 | 1 | |
| 87 | Small Former | Small Former | 0: Use the former larger than 4" 1: Use the former smaller than 4" | SMALL FORMER | 0 | | 0 | 1 | |
| 88 | Strip Lead Agnle | Changed only in Developer mode | | STR LEAD ANGLE | 0 | | 0 | 20 | |
| 89 | Long Back Seal | Changed only in Developer mode | | LONG BACK SEAL | 0 | | 0 | 1 | |
| 90 | Temp Step | Burn Through | 0: Not use burn through type heater 1: Use burn through type heater | TEMP STEP | 0 | | 0 | 1 | |
| 91 | Temp Step Max | Upper Limit of Burn Through | Heater on ratio of burn through heater | TEMP STEP MAX[V] | 0 | | 0 | 100 | |
| 92 | Upper Limit Speed | Changed only in Developer mode | | | 250 | | 0 | 250 | |

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|-----|----------------------|-----------------------------------|--|--------------|-----|------|-----|-----|---|
| 93 | Jaw Motion Type | Changed only in Developer mode | | | 0 | | 0 | 1 | |
| 94 | Jaw Arm Diameter | Changed only in Developer mode | | | 170 | | 100 | 500 | |
| 95 | Minimum Seal Time | Changed only in Developer mode | | | 50 | | 5 | 100 | |
| 96 | Film Feed Acc Ticks | Changed only in Developer mode | | | 40 | | 20 | 100 | |
| 97 | Film Feed Drive Mode | Changed only in Developer mode | | | 0 | | 0 | 3 | |
| 98 | Print Miss Detect | Print Verification Device Install | 0: Not use print verification, 1: Use print verification | PRINT CAMERA | 0 | | 0 | 5 | Print Verification |
| 99 | Knife Solenoid Type | Double Action Type knife cylinder | 0: Use single action knife cylinder, 1: Use Double action type knife cylinder (for perforation) | KNIFE TYPE | 0 | | 0 | 1 | |
| 100 | Dev. Reserve 1 | Changed only in Developer mode | | P Gain | 90 | | 10 | 200 | |
| 101 | Dev. Reserve 2 | Changed only in Developer mode | | P Gain 1 | 20 | | 1 | 100 | |
| 102 | Dev. Reserve 3 | Changed only in Developer mode | | | 0 | | 0 | 6 | |
| 103 | Dev. Reserve 4 | Changed only in Developer mode | | | 53 | * 80 | 40 | 80 | * These are the value for Software stripping is off (Dip SW 1-5 is off) |
| 104 | Dev. Reserve 5 | Changed only in Developer mode | | | 0 | | | | |
| 105 | Dev. Reserve 6 | Changed only in Developer mode | | | 0 | | | | |
| 106 | Dev. Reserve 7 | Changed only in Developer mode | | | 0 | | | | |
| 107 | Dev. Reserve 8 | Changed only in Developer mode | | | 0 | | | | |
| 108 | Dev. Reserve 9 | Changed only in Developer mode | | | 0 | | | | |
| 109 | Dev. Reserve 10 | Changed only in Developer mode | | | 0 | | | | |