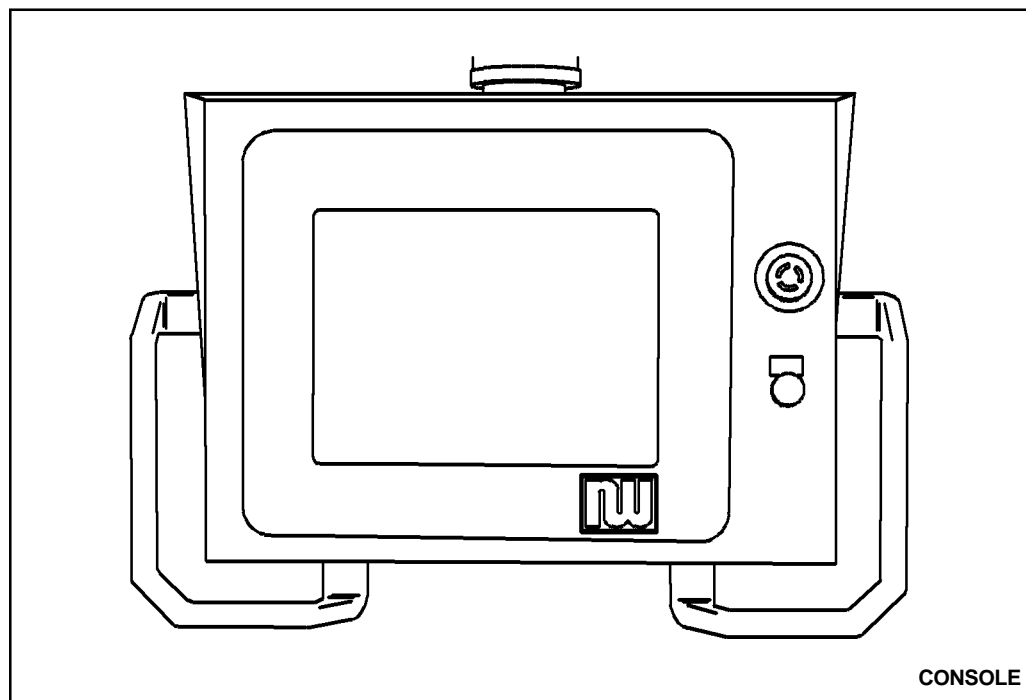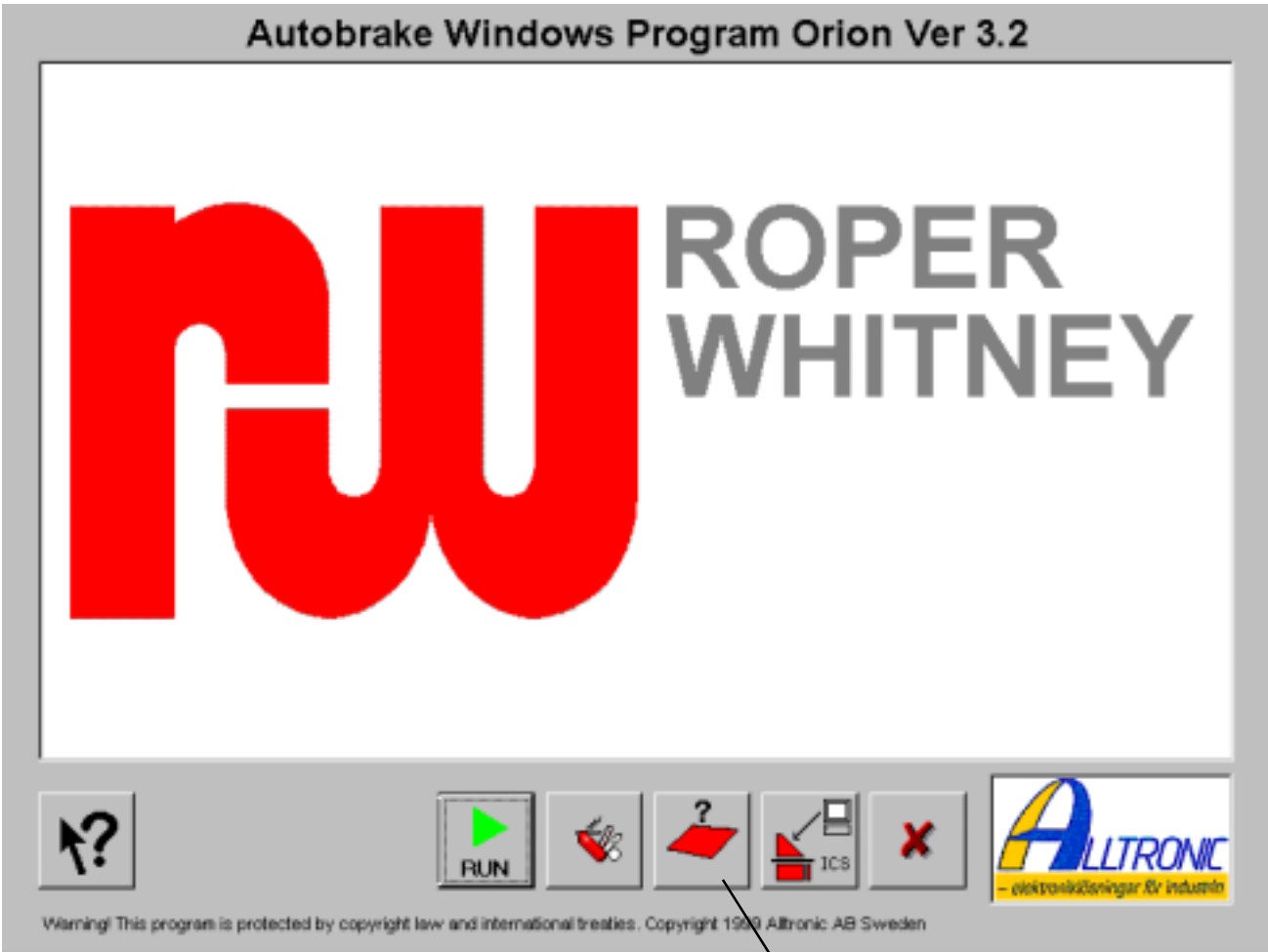ROPER WHITNEY

ORION CONTROL SYSTEM

Appendix B
Creating Angle Compensation Tables

CONSOLE

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MAINSCR

Angle
Compensation
Tables
Touchbutton

Figure B-1. Orion Control System Mainscreen

TABLE OF CONTENTS

APPENDIX B
ANGLE COMPENSATION TABLES

Angle Compensation Tables take the place of general angle compensation values. Like the general angle compensation values, they are added to the programmed value of the specific bend. They are developed by testing various materials, taking into account width and thickness being bent.

Because so many combinations of size and material exist, it is not possible for Roper Whitney to provide Angle Compensation Tables suitable for use by all customers. Therefore, no Angle Compensation Tables are supplied with the machine; it is left to the owner of the equipment to develop these tables.

GETTING STARTED

When Angle Compensation Tables are created, they are stored on the system hard drive. Any number of tables may be stored, thus enabling the machine owner to develop a complete set of tables specifically designed to support the manufacturing processes he uses.

Angle Compensation Tables may also be deleted from the hard drive when they are no longer needed.

To create or remove an Angle Compensation Table, touch the Angle Compensation Tables Touchbutton on the Orion system Main Screen. This will bring up the Angle Compensation Tables Screen shown in Figure B-2.
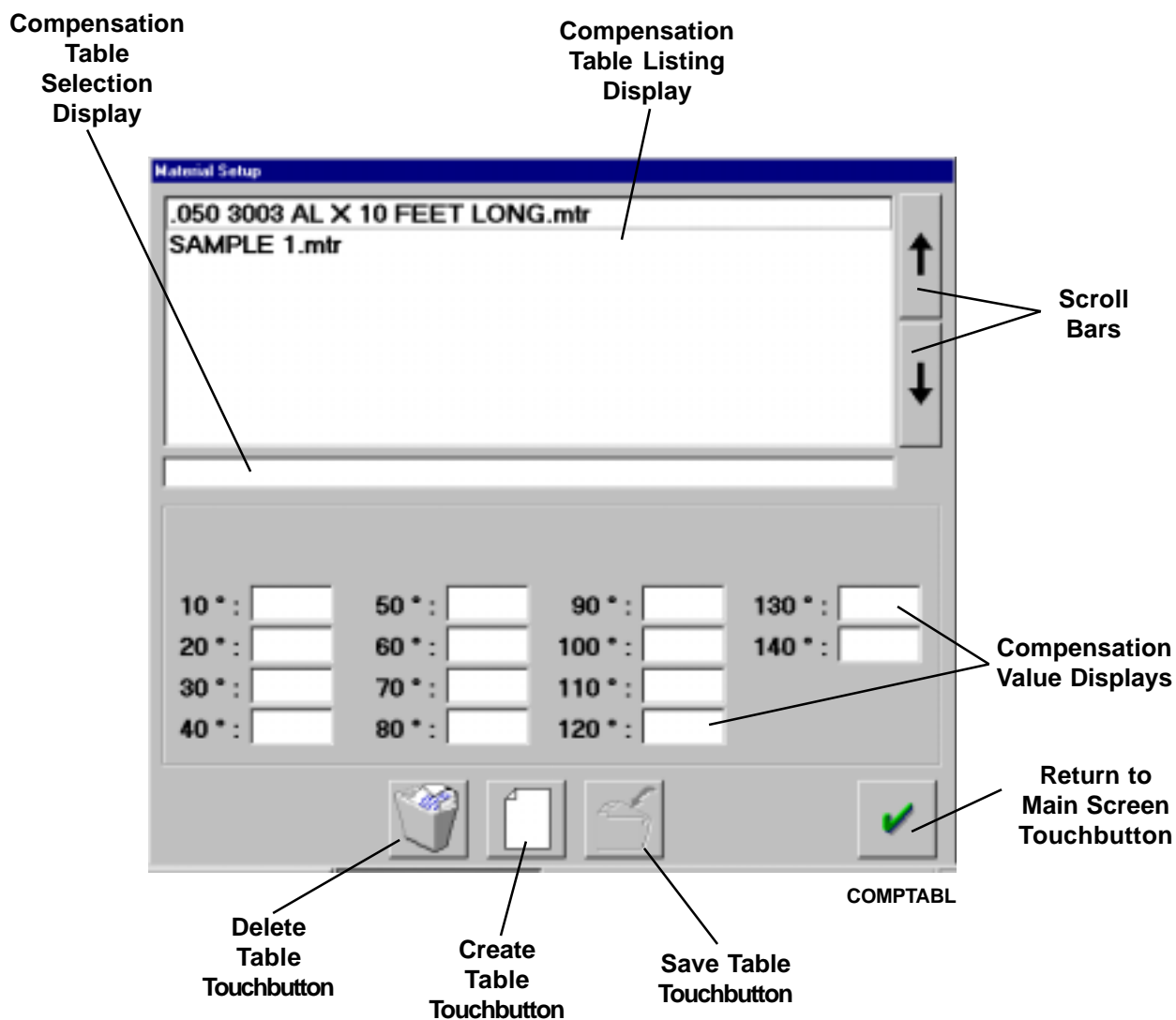
Compensation
Table
Selection
Display

Compensation
Table Listing
Display

Material Setup

.050 3003 AL X 10 FEET LONG.mtr
SAMPLE 1.mtr

Scroll
Bars

10 ° :	50 ° :	90 ° :	130 ° :
20 ° :	60 ° :	100 ° :	140 ° :
30 ° :	70 ° :	110 ° :	
40 ° :	80 ° :	120 ° :	

Compensation
Value Displays

Return to
Main Screen
Touchbutton

COMPTABL

Delete
Table
Touchbutton

Create
Table
Touchbutton

Save Table
Touchbutton

Figure B-2. Angle Compensation Tables Screen

ANGLE COMPENSATION TABLES SCREEN

The Angle Compensation Screen is shown in Figure B-2. Elements comprising the screen are described below.

COMPENSATION TABLE LISTING DISPLAY

The Compensation Table Listing Display lists all the angle compensation tables contained on the system hard drive. Compensation table files are designated by the **.mtr** extension.

COMPENSATION TABLE SELECTION DISPLAY

The Compensation Table Selection Display will show the name of a compensation table being prepared, or the name of a compensation table selected for deletion.

SCROLL BARS

The Scroll Bars enable the operator to scroll backward and forward through the list of compensation tables shown in the Compensation Table Listing Display when the number of tables contained on the hard drive is too large to fit entirely in the display.

COMPENSATION VALUE DISPLAYS

The Compensation Value Displays contain the compensation values entered for the designated angles. The values are effective over a range of +/- 4 degrees from the designated angle, except for the value entered for 10 degrees, which is effective from 1 degree through 14 degrees.

CREATE TABLE TOUCHBUTTON

The Create Table Touchbutton initiates table creation. See the instructions beginning with Figure B-3.

SAVE TABLE TOUCHBUTTON

The Save Table Touchbutton saves a newly created table. See the instructions beginning with Figure B-5.

DELETE TABLE TOUCHBUTTON

The Delete Table Touchbutton initiates the deletion of a table. See the instructions beginning with Figure B-6.

RETURN TO MAIN SCREEN TOUCHBUTTON

The Return To Main Screen Touchbutton returns you to the Main Screen.
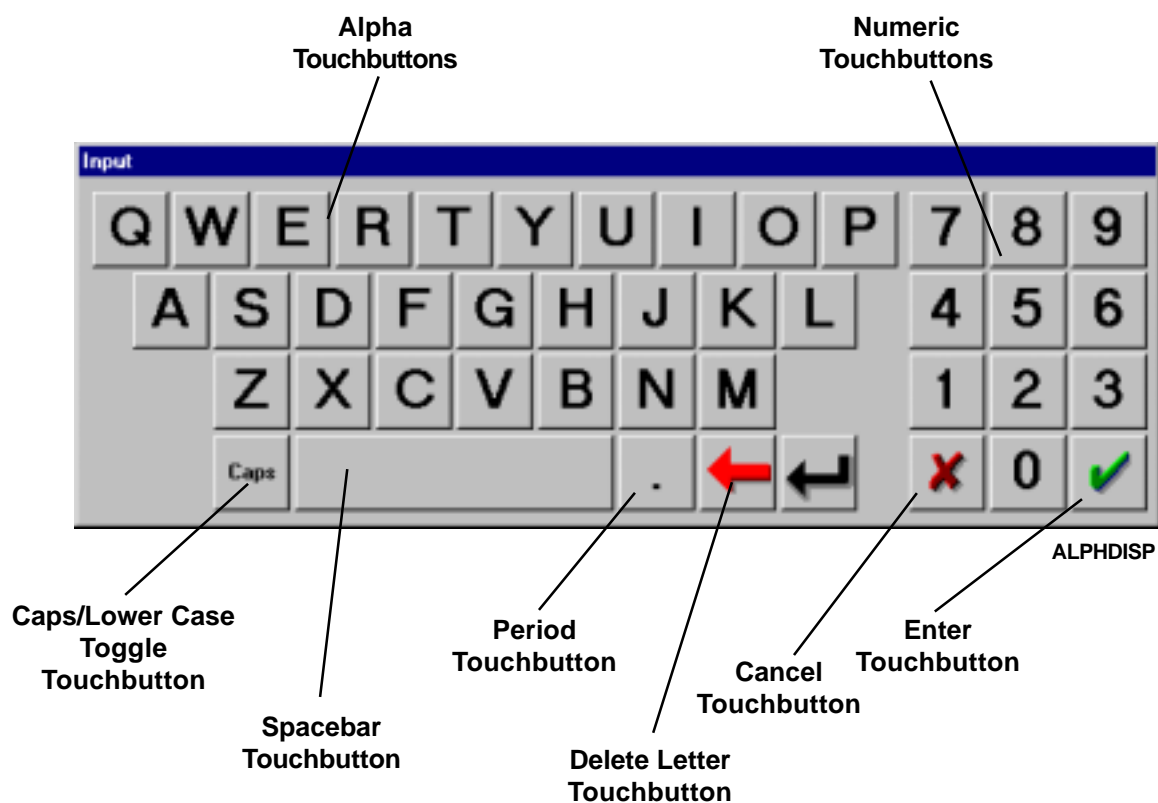
Alpha Touchbuttons

Numeric Touchbuttons

ALPHDISP

Caps/Lower Case Toggle Touchbutton

Period Touchbutton

Enter Touchbutton

Cancel Touchbutton

Spacebar Touchbutton

Delete Letter Touchbutton

Figure B-3. The Alpha-Numeric Pop-Up Keypad

CREATING AND ANGLE COMPENSATION TABLE

To create an Angle Compensation Table, press the Create Table Touchbutton on the Angle Compensation Table Screen shown in Figure B-2.

The Alpha/Numeric Pop-Up Keypad, shown in Figure B-3, will appear. This keypad is used to enter a file name for the Angle Compensation Table. The file name must be entered before the table can be created.

ENTERING THE TABLE NAME

As the table name is entered, it appears in the Compensation Table Selection Display. shown in Figure B-2.

Textual data is entered by using the Alpha Touchbuttons. Numbers are entered by using the Numeric Touchbuttons. The Period Touchbutton is used to enter a period in the text. Spaces between words are added by using the Spacebar Touchbutton. Use the Upper/Lower Case Toggle Touchbutton to change from upper to lower case and back again. When this toggle is used, it automatically changes the Alpha-Touchbuttons from one case to the other. As the data is entered, it appears in the Program Title Area of the Program Selection display.

A character or space can be removed by touching the Delete Letter Touchbutton. When this touchbutton is used, it removes one character at a time, starting from the right.

The entry can be cleared completely by touching the Cancel Touchbutton.

When the entry shown is that desired, touch the Enter Touchbutton on the Alpha/Numeric Pop-Up Keypad. The keypad will disaappear, and the name shown in the Compensation Table Selection Display will be followed by the **.mtr** extension. Compensation values may now be entered in the Compensation Value Displays.

ENTERING COMPENSATION VALUES

Touch the first Compensation Table Selection Display for which a value is to be entered. The Numeric Keypad shown in Figure B-4 will appear.
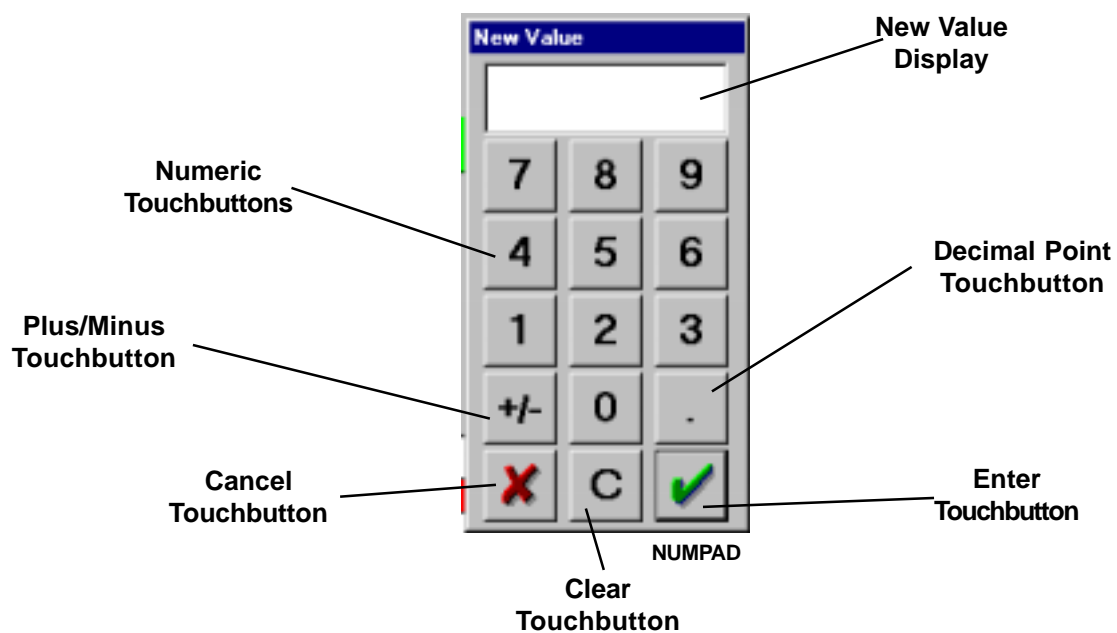
**New Value
Display**

**Numeric
Touchbuttons**

**Decimal Point
Touchbutton**

**Plus/Minus
Touchbutton**

**Cancel
Touchbutton**

NUMPAD

**Enter
Touchbutton**

**Clear
Touchbutton**

Figure B-4. The Numeric Pop-Up Keypad

ENTERING ANGLE COMPENSATION DATA

Angle compensation data is entered by using the Numeric Touchbuttons. As the data is entered, it appears in the New Value Display at the top of the keypad. A decimal point is entered by using the Decimal Point Touchbutton.

Numeric values can be made positive or negative by using the Plus/Minus Touchbutton, which can be used at the beginning of an entry, or at any point after numeric data is entered.

A numeral can be removed from the New Value Display by touching the Clear Touchbutton. When this touchbutton is used, it removes one number at a time, starting from the right.

The New Value Display can be cleared completely by touching the Cancel Touchbutton.

The values are effective over a range of +/- 4 degrees from the designated angle, except for the value entered for 10 degrees, which is effective from 1 degree through 14 degrees.

When the value shown in the New Value Display is the value desired, touch the Enter Touchbutton to enter the number into the Compensation Value Display. The Numeric Pop-Up Keypad disappears from the screen.

COMPTAB2

Save Table
Touchbutton

Figure B-5. A Completed Angle Compensation Table

The process is repeated for each compensation value to be entered. Values need not be entered in all the Compensation Value Displays.

When all desired values have been entered, touch the Save Table Touchbutton, the Table name shown in the Compensation Table Selection Display will move to the Compensation Table Listing Display, and the Compensation Table will be saved to the system hard drive.
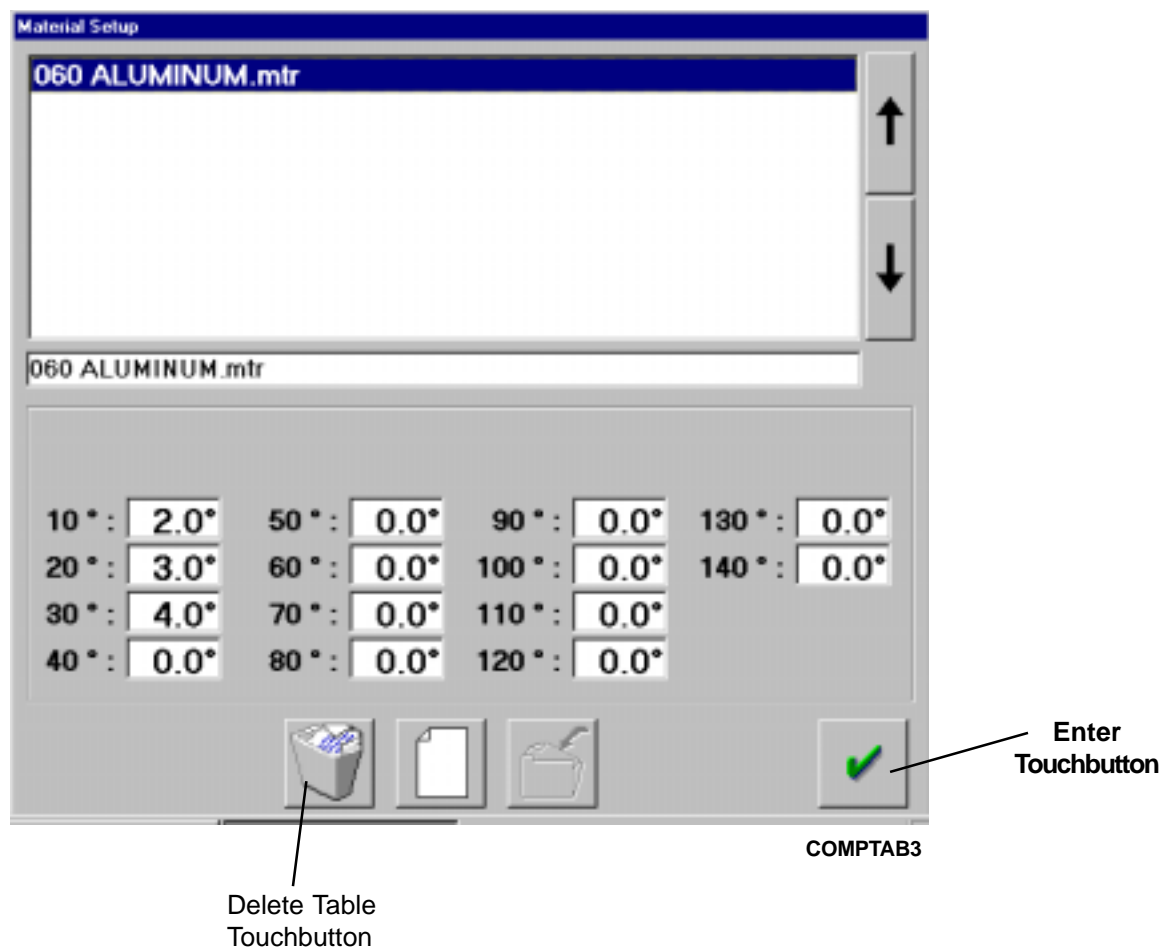
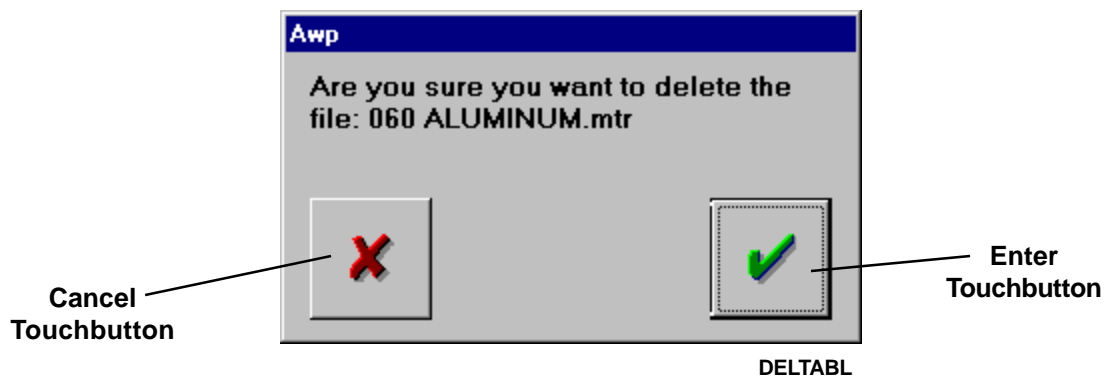**Figure B-6. Selecting a Compensation Table to be Deleted**

Figure B-7. Delete Table Confirmation Display

DELETING AN ANGLE COMENSATION TABLE

If it is desired to delete an Angle Compensation Table, use the following procedure.

Bring up the Angle Compensation Table Screen shown in Figure B-6. The list of Angle Compensation Tables will appear in the Compensation Table Listing Display.

Touch the file name of the Compensation Table to be removed. The file name will appear in the Compensation Table Selection Display. Touch the Delete Table Touchbutton and the Delete Table Confirmation Display shown in Figure B-7 will appear.

At this point, the delete operation can be halted by touching the Cancel Touchbutton in the Delete Table Confirmation Display.

If the correct table to be removed appears in the Compensation Table Selection Display, touch the Enter Touchbutton in the Delete Table Confirmation Display. The Confirmation display will disappear and the Compensation Table will be removed from the system hard drive.

Touch the Enter Touchbutton in the Angle Compensation Table Screen shown in Figure C-6 to return to the system Main Screen.

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