

Conveyor QuickStart Guide

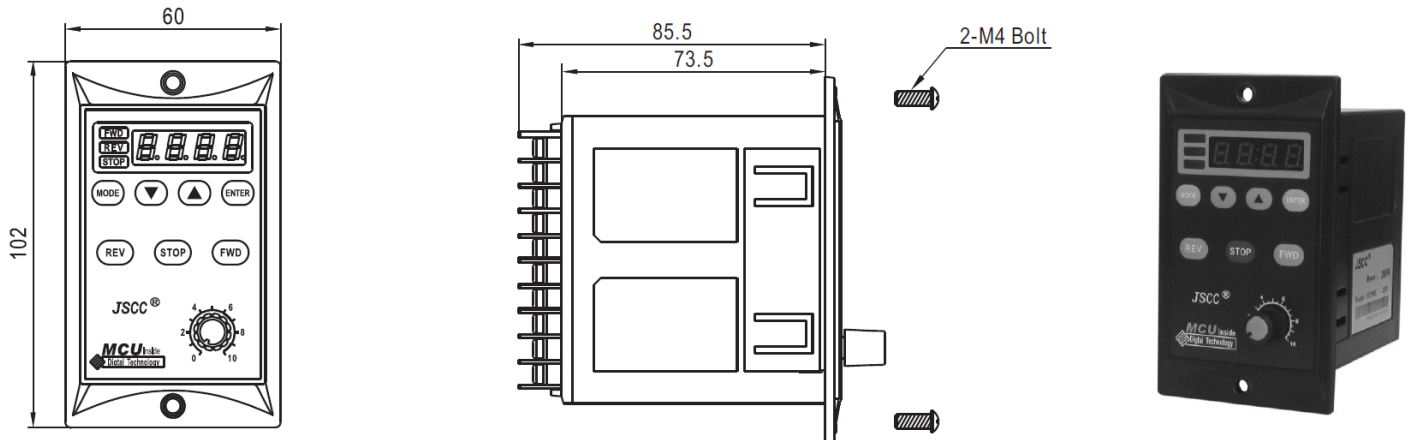
All of this information can be found under Production Set (Section 5.6, pg: 36) of the ARI Manual. The Production Set Tab allows the robot user to control the conveyor output signal when a conveyor is interfaced with the robot.

When the Production Set Tab is selected, the following display will appear on the HMI:



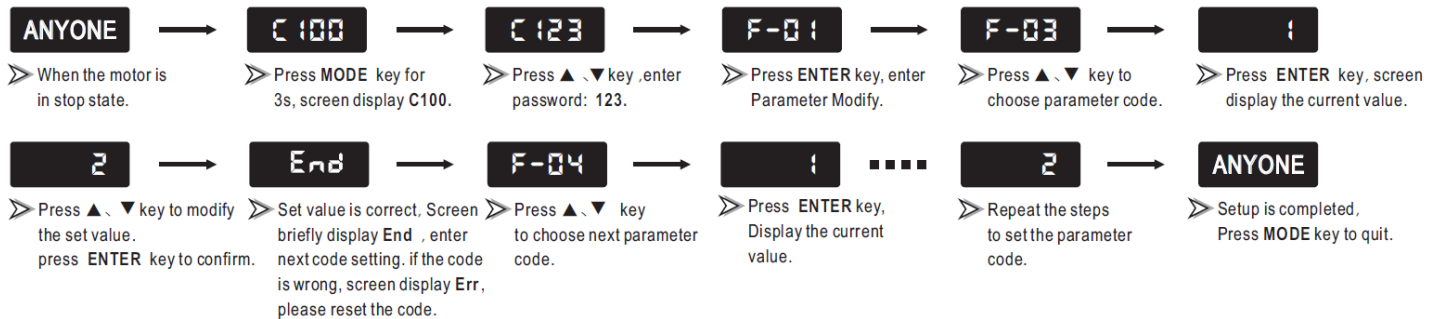
- 1. Product Output:** Input a value to control the number of products being extracted. When the limit has been reached, the robot will alarm
- 2. Transfer Qty:** The conveyor will index once the transfer quantity value has been met. If you are stacking parts on a conveyor, it is important to make sure the transfer quantity matches the amount of parts in that stack.
- 3. Transfer Time:** This is how long the conveyor output will remain "On".
- 4. Samplings:** If set as a given number, system will take out a sample to setting position every cycle.
- 5. Defectives:** If the amount of defective parts has reached the set point, the system will alarm and stop. You can set the placed position of defective parts. (Note: You should open the check of defective signal in Special Set.
- 6. Tests:** In Autorun, the test cycle number and put the product to setting position. To manually turn on the conveyor select CNV Conveyor and the conveyor will move until the transfer time has been met.

Reversing Direction for an ARI Branded Conveyor:



Menu Settings:

Safety Notice: Only modify the parameter F-05, F-29 when the motor is in stop state. Otherwise the parameter cannot be set, and the screen display 'Err'.



Reverse Direction:

1. Enter C100
2. Enter Password 123
3. Press Enter to go into Parameter Modify
4. Scroll to F-05, Press Enter
5. Select value 1, Press Enter
6. If value is correct screen will display End.
 - a. If the screen displays Err, please repeat and try again
7. If this does not successfully change the direction of the conveyor, please set it back and try a different value from: **List of SF Series Panel Speed Controller** on page 3.



Conveyor Reference Guide

Menu list of SF Series Panel Speed Controller:

Parameter code	Parameter function	Setting range	Function description	Factory set value	User set value
F-01	Display content	1. Motor speed setting value 2. Range speed setting value	Range speed setting value = Motor speed setting value / range	1	
F-02	Set range	1.0 ~ 999.9	According to the intuitive requirement to display target value.	1.0	
F-03	Operation control mode	1. operation panel control, without memory. 2. external switch, STOP key on panel is invalid. 3. external switch, STOP key on panel is valid. 4. operation panel control, with memory.	Choose "1", operation panel control, the Speed Controller can not record the station before the power was off. when the Speed Controller shut on again, the motor is STOP station. Choose "4", operation panel control, the Speed Controller can record the station before the power was off. when the Speed Controller shut on again, the motor is last station before power off. E. G. the motor is FWD station before power off, after power on, the motor is still FWD station. Choose external switch control, the FWD, REV external switch K1, K2 control motor.	1	
F-04	Rotate mode	1. Allow Forward & Reversal 2. Allow Forward, Prohibit Reversal 3. Allow Reversal, Prohibit Forward	To limit motor rotation direction, prevent equipment failure or accident.	1	
F-05	Direction of Rotation	1. not to change to opposite direction 2. change to opposite direction	Easy to change the motor rotation direction, not to change the motor's wiring, make it consistent with the habits or requirements	1	
F-06	Speed adjust mode	1. Panel ▲ ▼ key 2. Panel knob	Press ▲ ▼ key to adjust the motor speed during Min. to Max. speed, the panel knob automatically match 0~Max. speed.	1	
F-07	Max. speed	500 ~ 3000	Limit the maximum speed of motor to prevent speeding, damage or accident occurs.	1400	
F-08	Min. speed	90 ~ 1000	Limit the minimum speed of motor to prevent overheated and overload, because of the speed instability by the motor running at low speed.	90	
F-09	Forward-start Acceleration time	0.1~10.0s	For a long time, the motor starts slowly, starting time is long. For a short time, the motor starts fast, starting time is short.	1.0	
F-10	Forward stop mode	1. Free deceleration stop 2. Slow deceleration stop	When choosing free deceleration stop, motor stop faster. When choosing slow deceleration stop, change F - 11 set value to affect the speed of slow deceleration stop.	1	
F-11	Forward stop, slow deceleration time	0.1~10.0s	F-10 choose 2, menu is valid.	1.0	
F-12	Reversal-start Acceleration time	0.1~10.0s	For a long time, the motor starts slowly, starting time is long. For a short time, the motor starts fast, starting time is short.	1.0	
F-13	Reversal stop mode	1. Free deceleration stop 2. Slow deceleration stop	When choosing free deceleration stop, motor stop faster. When choosing slow deceleration stop, change F - 14 set value to affect the speed of slow deceleration stop.	1	
F-14	Reversal stop, slow deceleration time	0.1~10.0s	F-13 choose 2, menu is valid.	1.0	
F-29	To recover factory set	1. no recovery 2. to recover factory set		1	
F-30	Program version	Code +Version		01.**	
Fault alarm Er-1: 1) Overload locked-rotor 2) the connection of the speed controller with the motor is abnormal.			Fault processing method: 1) check and debugging. 2) To power on remove alarm.		