

User Manual



Datatransfer to PA3100

for PIOS Professional V2.0.0.x

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General

Important hints

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Respect!!!:

It is pointed out that the knowledge of the basic functions of PIOS PROFESSIONAL, the contact with Microsoft Windows® operating system and knowledge of the compartment concepts from the carpenter industry is presupposed. Furthermore, the knowledge of the instruction manual of the PIOS PROFESSIONAL of program is presupposed.

Impressum:



IST ElektronikgesmbH

innovation is our bussines

Marktplatz 40

A-4724 Neukirchen/W./OÖ.

Tel.: +43 (0)7278/3837-0

Fax: +43 (0)7278/3837-50

Email: support@ist.at

Web: www.ist.at

Performance

- * Windows conform construction and service (Windows keyboard, Mouse)
- * Also service by means of Touch Screen is possible.
- * Can also be used in networks (common order and material path)
- * Choose the language

Data transmission:

NC files from PIOS Professional can be transferred to control systems of type PA3100.

System prerequisites

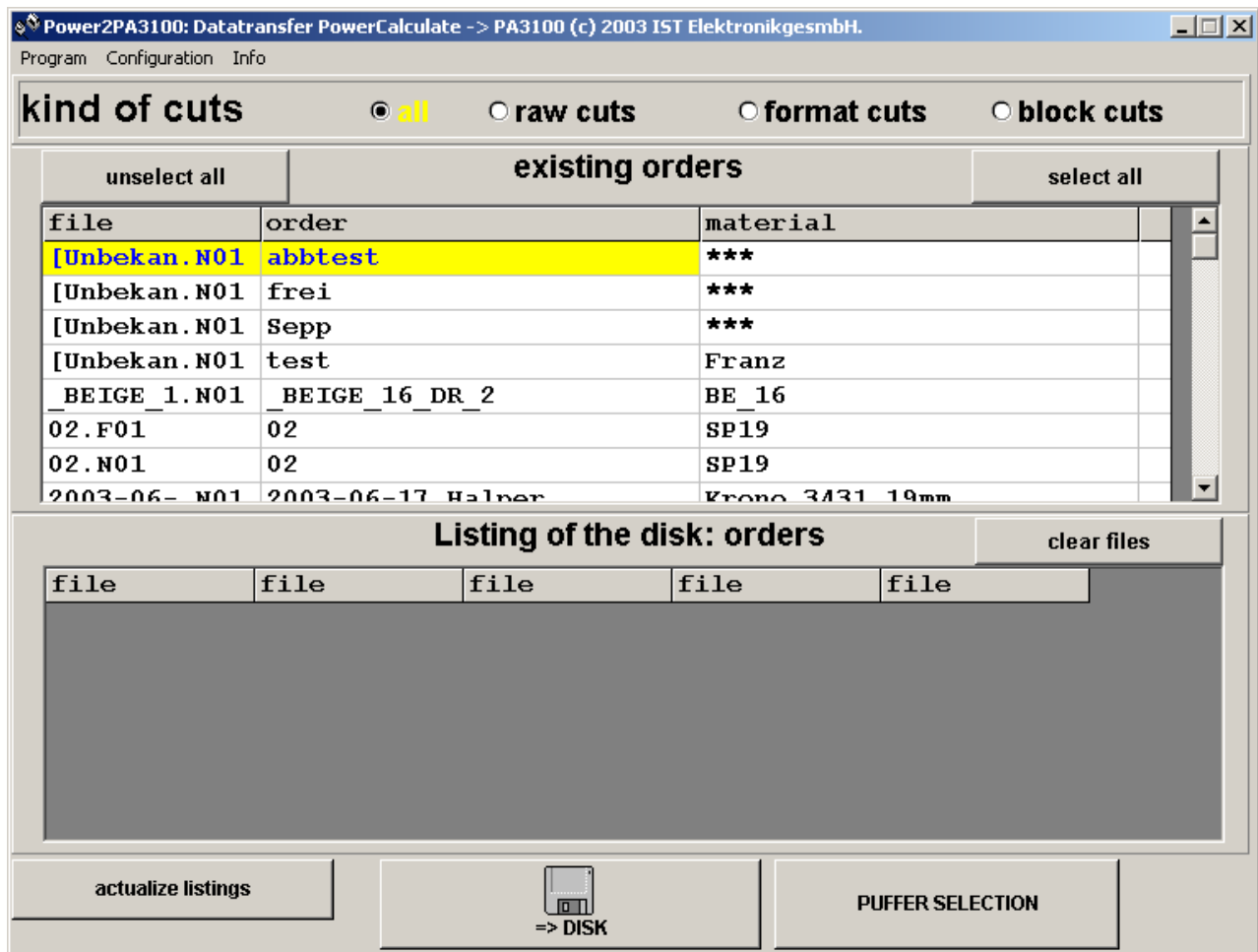
The software program PIOS PROFESSIONAL V1.0 is run-capable only on PC-Systems which fulfill the following minimum requirements.

- .. Pentium-Processor from 150 MHz
- .. 32 MBS RAM
- .. 10 MBS free hard disk storage + 15MB for manuals
- .. CD-ROM drive
- .. VGA graphics with resolution of 800x600 pixels and 256 colors
- .. Operating system:
 - Microsoft Windows 98 SE
 - Microsoft Windows NT4.0 SP6
 - Microsoft Windows 2000 professional
 - Microsoft Windows XP Home Edition
 - Microsoft Windows XP professional Edition

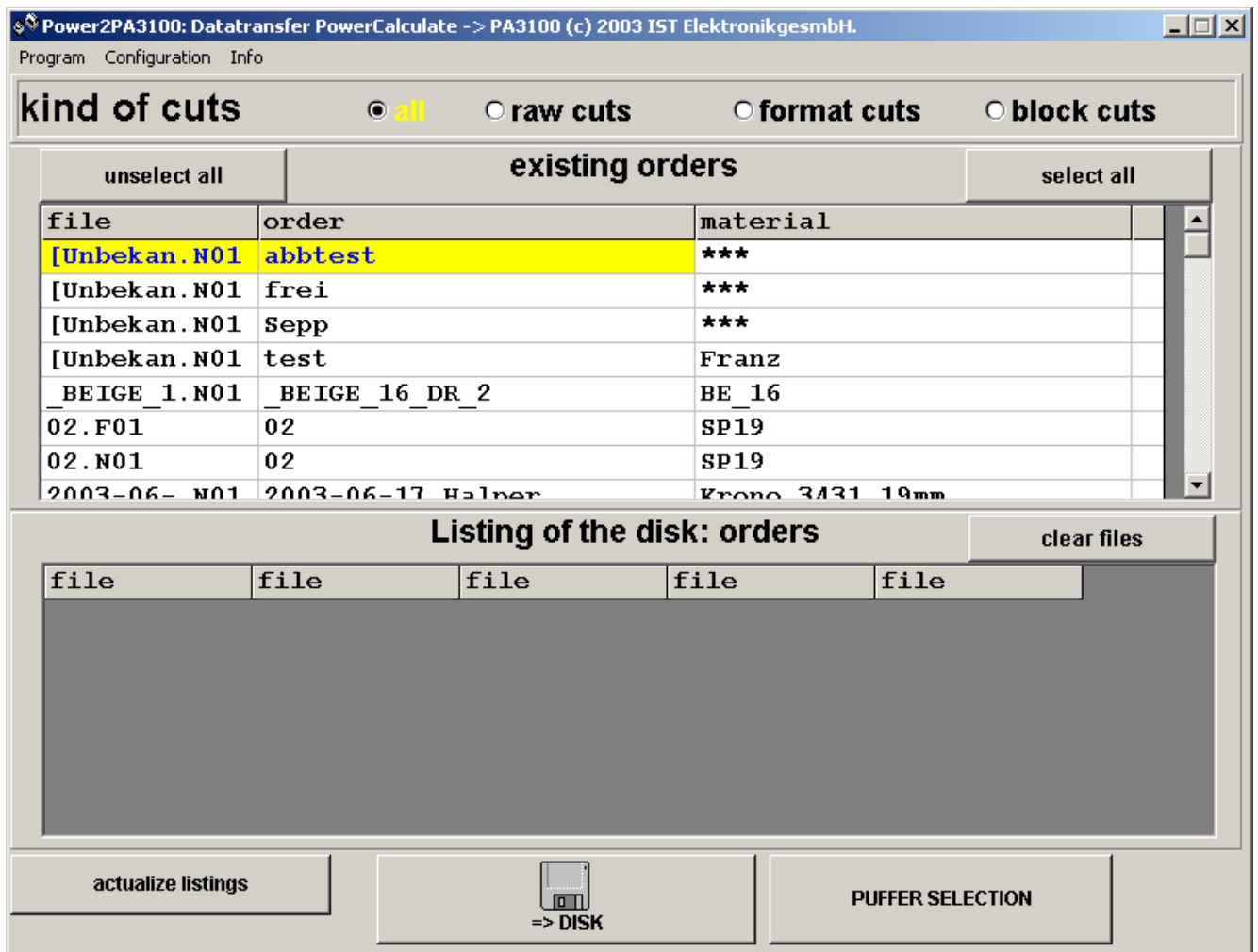
Chapters 1: Start of datatransfer



To start the data transfer, you choose the menu point "Datatransmission -> PA3100" in the menu. Then the program for datatransfer will be started. (Provided the program is already installed, otherwise the installation will be executed!)



Chapters 2: The transfer program



This additional module is used for the data transfer of PIOS Professional NC files to machine controls of the character PA3100.

Several types of the data transfer are supported:

- (a) over diskette: Only possibly with the PA3100 if this is equipped with a disk drive.
- (b) foreground mode: the PA3100 access the NC data released by OPAL V2.0 directly.
- (c) background mode: orders are sent by OPAL V2.0 to the PA3100.

Prerequisites for the PA3100:

Diskette: Hardware: Disk drive with FDC-Controller,
Software version: PA3100 V4.00 or higher

Foreground mode: Hardware: Online transfer modules for control and PC,
Software version: PA3100 V2.40 and higher

Background mode: hardware: Online transfer modules for control and PC,
Software version: PA3100 V3.10 and higher.

The settings of the transfer types and transfer parameters takes place for PIOS Professional in the configuration, (see manual PIOS Professional) and for the PA3100 in the parameter lists,

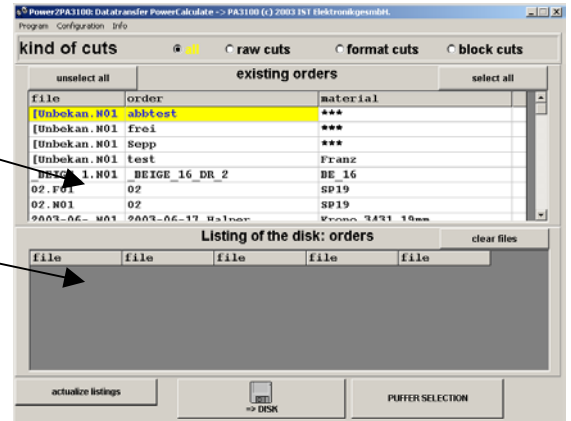
(documentation of the PA3100). Only if PIOS Professional and the machine control run with the same transfer parameters and in the same transfer mode the transfer can take place.

General

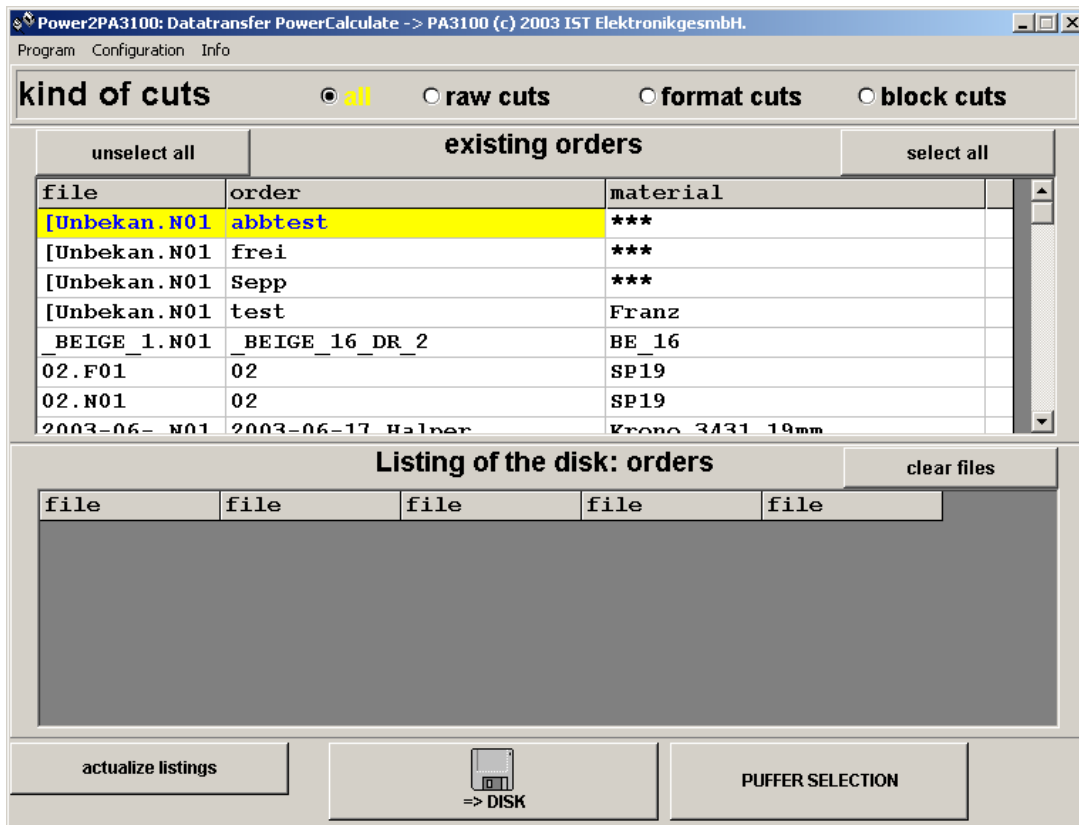
The screen is subdivided into two areas.

In the upper half, there are listed NC files (existing orders) existing in the OPAL V2.0.

In the low half, the listing of NC data situated takes place (diskette, machine or Buffer for prepared NC data).



Transfer mode disk



In the upper half of the screen mask, the NC files of the predialed cutselection (raw- format- or block cuts), existing in the PIOS Professional are shown.

Filename.: determined order name for the PA3100

Order: order name of the optimization

Material: material name of the optimization

Through a click on the button become all marked orders on the diskette (this must be put in previously) into the indicated order mode transfers. The marking is shown by a X in the last column of the existing orders. The marking of the orders takes place through a double-click with the

mouse into the line of the wished order number or through press the ENTER KEY in the line of the wished order numbers. Same is valid if a marking should be canceled. If all orders shall of this cut type should be marked a mouse click on the command button select all, to cancel all selection click on unselect all.

The Del button can be pressed to delete an order.



Through a click on this button you change between orders and programs.

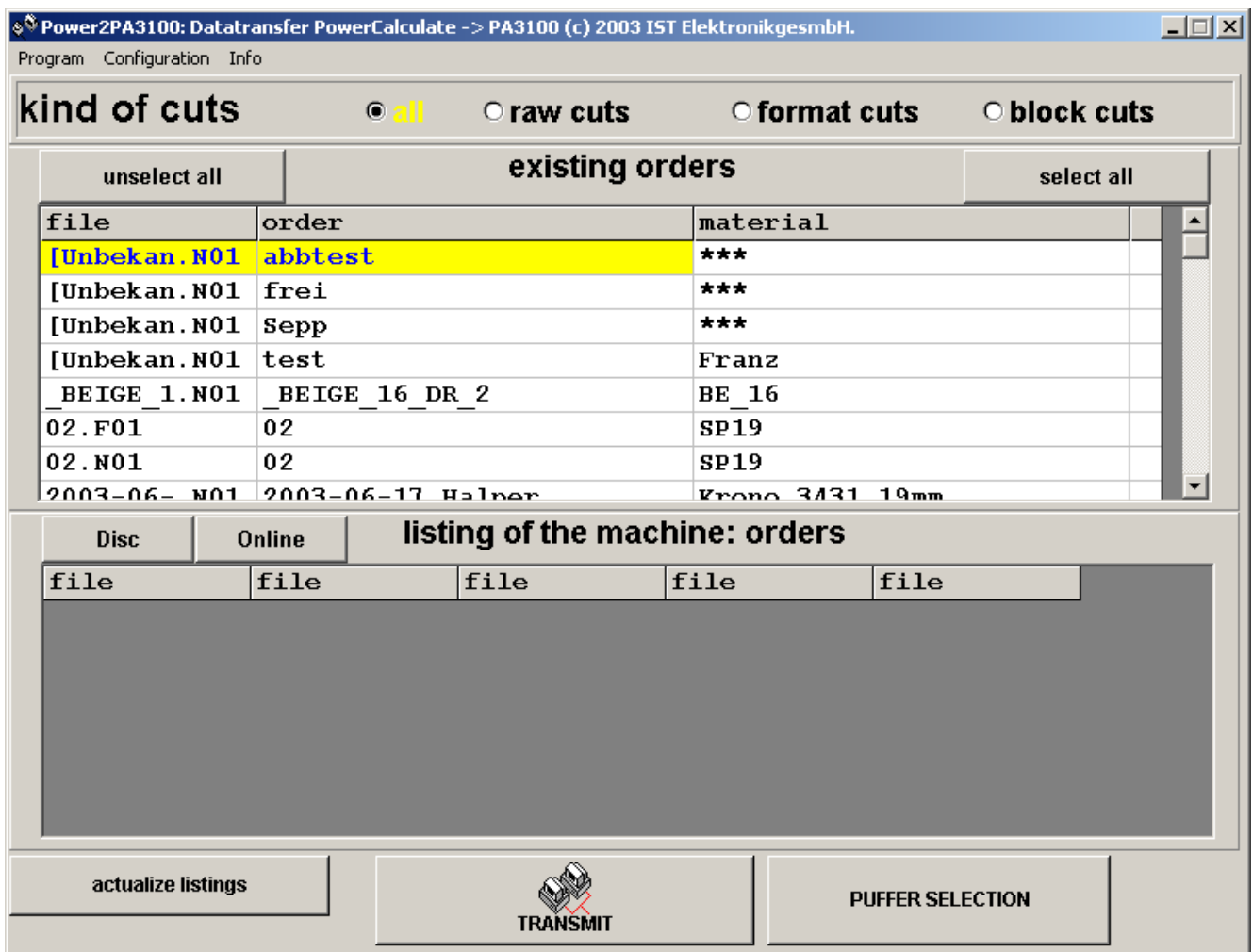
To delete orders as well as programs from the diskette, the relevant order name must be chosen in the disklisting and deleted by a press on the Del button afterwards. Through a mouse click on the command surface clear files all indicated files on the diskette will be deleted.

If an on-line transfer to the PA3100 still is possibly two other command surfaces are available.

Disk: shifts to disklisting

On-line: shifts to online listing

Transfer mode on-line background




In the upper half of the screen mask, the NC files of the predialed cutselection (raw- format- or block cuts), existing in the PIOS Professional are shown.


Filename.: determined order name for the PA3100

Order: order name of the optimization

Material: material name of the optimization

Through a click on the button  become all marked orders transferred online into the indicated order mode to PA3100. The marking is shown by a X in the last column of the existing orders. The marking of the orders takes place through a double-click with the mouse into the line of the wished order number or through press the ENTER KEY in the line of the wished order numbers. Same is valid if a marking should be canceled. If all orders shall of this cut type should be marked a mouse click on the command button select all, to cancel all selection click on unselect all. The Del button can be pressed to delete an order.

RESPECT: After the transfer of the NC data to the order storage of the machine, the NC data are deleted at the PC so that orders are not worked several times off.

Through a click on this button  you change between orders and programs. To delete orders as well as programs, the relevant order name must be chosen in the listing and deleted by a press on the Del button afterwards.

If this mode two other command surfaces are available.

Disk: shifts to disklisting

On-line: shifts to online listing


Transfer mode online foreground

In the upper half of the screen mask, the NC files of the predialed cutselection (raw- format- or block cuts), existing in the PIOS Professional are shown.

Filename.: determined order name for the PA3100

Order: order name of the optimization

Material: material name of the optimization

Through a click on the button  become all marked orders transferred into the transferbuffer in the indicated order mode to PA3100. The marking is shown by a X in the last column of the existing orders. The marking of the orders takes place through a double-click with the mouse into the line of the wished order number or through press the ENTER KEY in the line of the wished order numbers. Same is valid if a marking should be canceled. If all orders shall of this cut type should be marked a mouse click on the command button select all, to cancel all selection click on unselect all. The Del button can be pressed to delete an order.

Data of the transferbuffer:

Filename.: determined order name for the PA3100

Order: order name of the optimization

Material: material name of the optimization

PUFFER SELECTION

Through a click on this button you change between orders and programs.

To delete orders as well as programs from the transferbuffer, the relevant order name must be chosen in the transferbuffer and deleted by a press on the Del button afterwards. Through a mouse click on the command surface clear files all indicated files on the transferbuffer will be deleted.

If this mode two other command surfaces are available.

Disk: shifts to disklisting

On-line: shifts to online listing

Connectors to the transfer modules

The plug at the COM - interface to the transfer module must be connected with a 3 wire. See here:

