KL-CTDS

DAS (Data Acquisition System) Installation & Operation Manual

Data Acquisition System

- Installation Process:

 Create an AMS file under the C:\ (You may have permissions issue in WIN10 when you do this, please contact with supervisor if when facing with this inquirement)

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- 2. Please copy the software "CTDS_V052.EXE" into AMS file.
- 3. Executive installation file of CTDS_V052.EXE
- 4. Installation program will be under the CTDS subdirectory of AMS file

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5. The driver of "USB TO RS232" must be installed when first time executive

CTDS_Data_Acquisition_System.exe, connect the USB TO RS232 cable for CTDS and PC then executive the DAS software.



2 個項目 已選取 1 個項目 114 KB

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Below window will pop up for remind if USB TO RS232 driver is not installed properly; Once settled, you can adding a software shortcut as a quick link icon and place it in desktop, which is convenient for next time use.

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- Interface Description
- 1. Executive CTDS_Data_Acquisition_System.exe , the COM Port position suppose show automatically as below when COM Port connected.
- 2. Make sure again RS232 TO USB cable connect COM Port is correct 'select "OPEN" to make a link.

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3. Link Setting (Connection Control)

Communication Comm port (Device Comm Port) : This program will executive automatically when COM port connect with PC (COM Port) (Baud Rate 9600) (Parity bit None)

(8 \ 1) Regarding to software programing (Please DO NOT change this setting)(Server Address) : Server IP (This function is under development)

Connection Control :			
Device Comm Port : COM4 v 9600 v None v 8 v 1 v	OPEN	CLOSE	DUTT
Server Address :	CONNECT	DISCONNECT	LAII

4. Display information in real-time(Received Data Display)

(Received Time) : Shows recorder time as computer time

(Device ID) : Indicated equipment ID (1~255)

(Device Count) : Shows how many fastening times has been record after power on,

it will recalculate once if executive power recycle or ID changed during the process.

(Screw Count) : Read and displayed the screw count number

(Shutoff Time) : Read and displayed the screw shutoff time

(Shutoff Torque) : Read and displayed the screw shutoff torque value.

(Shutoff Thread) : Read and displayed the screw shutoff thread number.

(Shutoff Status) : Read and displayed the screw shutoff status.

Note: Below window will pop up when executive first time program connection (OPEN), this is just for reminding, click "確定" button to confirm it. Since the program will search equipment ID automatically therefore it will be occurred every time when equipment ID has been changed.

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intoff Dured :		Warning : Device ID is Please confirm and N	s cheang	ed !! default ID		99 LC	: 0.0	Status :			
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5. Data Analysis

(Enable) : "Enable" check must be selected for turn on Data analysis function

(Count) : Count screw shutoff number (The requirement of this counting must be over than 0.5 thread)

(Shutoff Thread) : Count screw shutoff thread, the requirement of this counting must be over than 0.5 thread, otherwise it does not count.

(OK Time Limit) : The requirement of this counting as fastening time must over than this OK setting time.

(OKALL Time Limit) : The requirement of this counting as fastening time must over than this OKALL setting time.

<u>Data Analysis :</u>				Data Ana	dysis :			
Count =		Enable	e	Count =		7	🖌 Enab	ole
Shutoff Thread >	0.5			Shutoff Th	uread >	0.5		
OK Time Limit :	1.0	Count :	0	OK Time	Limit :	0.1	Count :	б
OKALL Time Limit	: 10.0	Count :	0	OKALL T	ime Limit :	5	Count :	0
Max Min	Avg	+%	- %	Max	Min	Åvg	+%	-%
				0.4	0.3	0.37	7.69	19.23
				5.9	5.7	5.79	1.98	1.48
				8.5	6.2	7.31	16.21	15.23
Device Summary :				Device Su	mmary :			
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Program Unit:	EDIT	C	OPY	Program	Unit: 5	EDIT	C	OPY
Max / Screw Count	: [/	S	AVE	Max / Sci	rew Count :	1/	1	AVE
HT: 99.9 LT	: 0.0	Status :		HT:	0.4 LT:	0.3	Status :	OK
HQ: 99.9 LQ	: 0.0	Status :		HQ :	5.9 LQ	5.7	Status :	OK
HC: 99.9 LC	: 0.0	Status :		HC :	8.5 LC	6.2	Status :	OK

(Device Summary) : The status of statistics result from equipment site

Use this automatic learning function by turn on the "Enable" to learn current fastening object's max, min and average value of time, torque and thread numbers, we also need to press "EDIT" and "COPY" button to completed the learning progress, then learning data will be sent to computer site for next fastening screw status judgment.

6. (Counting Control Setting /Learning)

(Tool Sn) : Tool serious number (This function is under development)
(Tool ID) : Tool ID number (This function is under development)
(Program Unit) : Program Unit number (This function is under development)
(Max/Screw Count) : Max batch of screw number /Current screw count number
(System Summary) : The status of statistics result as calculated from computer site

<u>Count</u>	ting Co	ontrol	Setting	(Learning):
Tool S	n :	00000-	000000	
Tool II	D :	1	GET	SET
Progra	m Unit:	1	EDIT	COPY
Max/S	Screw C	ount :	/	SAVE
HT:	99.9	LT:	0.0	Status :
HQ :	99.9	LQ :	0.0	Status :
HC :	99.9	LC :	0.0	Status :
System NG	Summa Ok	ny: ((OKALL	NG%

Note: Please be noted that KL-CTDS Program has one-way (V1.X) and two-ways (V2.X) transformation method, currently version of KL-CTDS is using one-way (V1.X) for data transformation method, therefore we can use automatically learning function to learn Time, Torque and thread numbers then press COPY to save it to DAS, we also can modify the setting values by KL-CTDS itself if we are not using auto learn function here.

7. Received Data saved and export

7.1 Received Data save

Received Data List :				
File Name :	SAVE	•	EXPORT To :	notepad.exe

The program will generate the File-name automatically when if this is the first time use software, in additional, the remind window will pop up when executive leave/close the program without saved.

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				Max	Min	A	lvg	+%	-%						
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Shutoff Thread :	9.9									HC	: 99.9	LC :	0.0	Status :	OK
Shutoff Status :	OK														OK
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C																>

File-name format specification : CTDS_1_1_20160930_101321.DAT

CTDS_(Device ID)_(Tool ID)_Date_Time.DAT

7.2 Data Export

Method 1 : Use EXCLE to open DAS export file(*.DAT) , please select "All file" to open this file

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Step 1: Select "spacing symbol" and enter for next step

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15	預覽檔案 C:\AMS\CTDS\CTDS_1_1_	20160830_102235.DAT •	
16	I Recy. No Recy. Time Device C	ount ID Time Torque Unit Thread	Device Status Screw Count C ^
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18	3 2,2016/08/30 10:22:36,12,1,0 4 3,2016/08/30 10:22:37 13,1,0	.2,4.4,KGF,4.0,0K,3,INC,0K,0K,0	(,0K,1.00, (.0K.0.50)
19	54,2016/08/30 10:22:37,14,1,0	.0,6.7,KGF,0.5,0K,5,INC,0K,0K,0	K,OK,O.00,
20	In 15,2016/08/30 10:22:37,15,1,0	.0,6.7,KGF.0.5,OKALL.1,INC.OKAL	.,0K,0K,0K,0.50,2.00
22			
23		取消 < 上一步(B) 下一步(N) > 完成(E)
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28 工作表1 0			· · · · · · · · · · · · · · · · · · ·
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Step 2: Checked "commas" option as shows in below and then go for next step

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檔案 常用 插入 反面面	22国 公式 資料 校開 檢視 🕻 告訴我您想要執行的動作 🛛 🔒 共用
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Step 3: Select "do not Import this column" then go for next step



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Method 2: Data file format output to EXCEL directly

- Saved the data and leave the executive page, then change the path of export format to EXCEL

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🕼 Wei_Lee (wei_lee-nb	🚰 Outlook 201	目標(T):	m Files\Microsoft Office\root\Office16\EXCEL.EXE" 3 KB	
📜 下載	🛃 Photos		3 КВ	
🜙 公司共用區 (kilews2)	👔 PowerPoint 2		3 КВ	
📗 文件	🚮 Publisher 20	開始位置(S):	3 КВ	
🔰 音樂	👧 TeamViewer	快速鏈(K)·	無 1 KB	
💺 圏片	👔 Word 2016	17.22.0E(14).	3 КВ	
● 影片	🏚 市集	執行(R):	標準視窗	
🤩 Acer (C:)	📄 桌面		1 KB	
International and a second sec	鵚 商務用 OneD	註解(O):	輕鬆採案、顯規及共用芯質科的詳測資訊。 3 KB	
	🔊 商務用 Skype	盟政構	変位置(F) 様軍圏示(C) 準防(D) 3 KB	
🥨 網路	₽ 授尋	010/164 164	2 KB	
	🔅 電腦設定		3 KB	~
48 個項目 已選取 1 個項	目 2.22 КВ			
			確定 取消 套用(A)	

When EXCEL software location has been found, then check the content of EXCEL for path information, please copy this path and paste it to export format (Please remember to cancel the "Quotation Marks" of the path)

K		Kilews (CTDS Da	ta Acqu	uisitior	n Syster	m Ver 0.	.52			- 1	
Connection Contr	rol :											
Device Comm Port :	сом4 🖌 9600	v None	v 8 v	1 🖌			OPEN	CLO	SE		-	
Server Address :							CONNECT	DISCON	NECT		EXII	
Received Data Di	splay :	Data J	Analysis :				Cou	nting Co	ontrol	Setting (Learni	<u>1g):</u>
Received Time :		Count	=		Enal	ble	Tool	Sn :	00000-	000000		
Device ID :	1	Shutof	f Thread >	0.5			Tool	ID :	1	GET		SET
Device Count :		OK Ti	me Limit :	5.0	Count :	0	Progr	am Unit:	1	EDIT		COPY
Screw Count :	INC	OKAL	L Time Limit	30.0	Count :	0	Max	/Screw C	ount :	51	5	SAVE
		Max	t Min	Avg	+%	-%						
Shutoff Time :	Sec						HT:	99.9	LT:	0.0	Status :	
Shutoff Torque :	KGF						HQ :	99.9	LQ :	4.0	Status :	
Shutoff Thread :							HC :	99.9	LC :	0.0	Status :	
Shutoff Status :												
		Device	Summary :				Syster	n Summ	ary :			
		NG	OK	OKALL	NG%		NG	F 01	K (OKALL	NG%	
Received Data Lis	t:				0.0						0.0	
File Name :			SAVE	CTDS	1_1_2016	50830_1041	41.DAT	÷ EX	PORT T	o: C:\P	rogram	Files\Mic
Recv. Recv.	Time Device Count	ID Time	e Torque U	Jnit Thre	ad Devic Statu	e Screw s Count	Count Inc/Dec	System Status	Torque St.	Time St.	Thread St.	OK Interval
<												>

8. Received Data List, please refer comment in below

(Reve No) : Received number
(Reve Time) : Received time
(Device Count) : Device count times
(ID) : Equipment ID number
(Shutoff Status) : Equipment site Shutoff Status
(Time) : Equipment site Shutoff Time
(Torque) : Equipment site Shutoff Torque
(Unit) : Torque unit selection
(Thread) : Equipment site Shutoff Thread number
(Device Status) : Equipment site shutoff status
(Screw Count) : Screw Count Number
(Count Inc/Dec) : Screw count way (Increase / Decrease)
(System Status) : Computer site Shutoff torque
(Time St.) : Computer site Shutoff time

(Thread St.) : Computer site Shutoff thread

3

1 0.4

2016/08/24 11:42:34

(OK interval) : Interval time (Sec.) between current OK and last OK

5.9

KGF

(OKALL interval) : Interval time (Sec.) between current OKALL and last OKALL.

Recv. No	Recv. Time	Device Count	ID	Time	Torque	Unit	Thread	Device Status	Screw Count	Count Inc/Dec	System Status	Torque St.	Time St.	Thread St.	OK Interval
						_	_		_		_	_			
Recv. No	Recv. Time	Device Count	ID	Time	Torque	Unit	Thread	Device Status	Screw Count	Count Inc/Dec	System Status	Torque St.	e Time St.	Thread St.	O] ^ Intei
Recv. No	Recv. Time 2016/08/24 11:42:30	Device Count 1	ID 1	Time 0.4	Torque	Unit KGF	Thread 7.8	Device Status NGTQ	Screw Count	Count Inc/Dec INC	System Status OKALL	Torque St.	e Time St. OK	Thread St. OK	O] ^ Inter

6.8

NGTQ

1

INC

OKALL

OK

OK

OK

1.8