



The Way

Corporation

P.O. Box 12 Fowlerville, MI 48836

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Siemens 840D Double Disk Grinder Win CC Flexible Screens

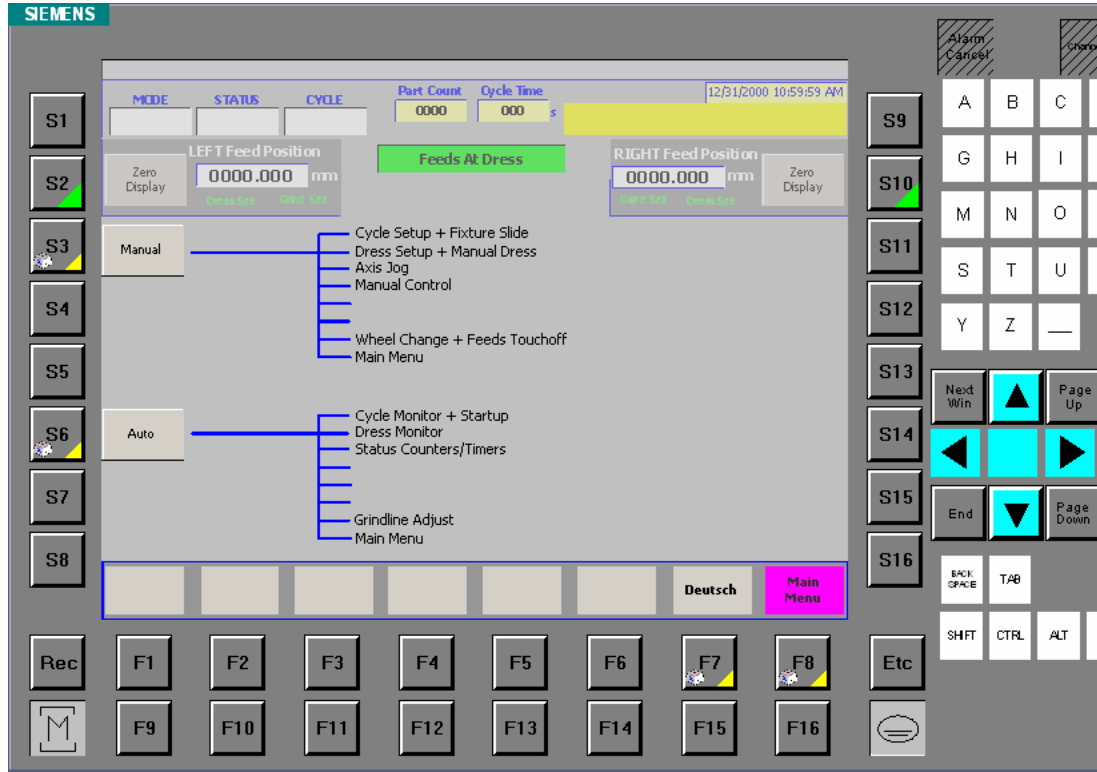
The following pages contain screen shots of a Double Disk Grinder Project design with WinCC Flexible. Using WinCC Flexible Software, The Way Corporation is able to design Operator Screens which display process parameters that make sense to the Operator. The key to developing great custom operator screens is to understand the machining process, understand the machine, and then understand the operator needs. Once we understand the needs and process, screens can be design to improve productivity.

The end user of this Double Disk Grinder Project is in Germany, so a pushbutton was added to the main menu to select the screen language. Note the screen shots below.

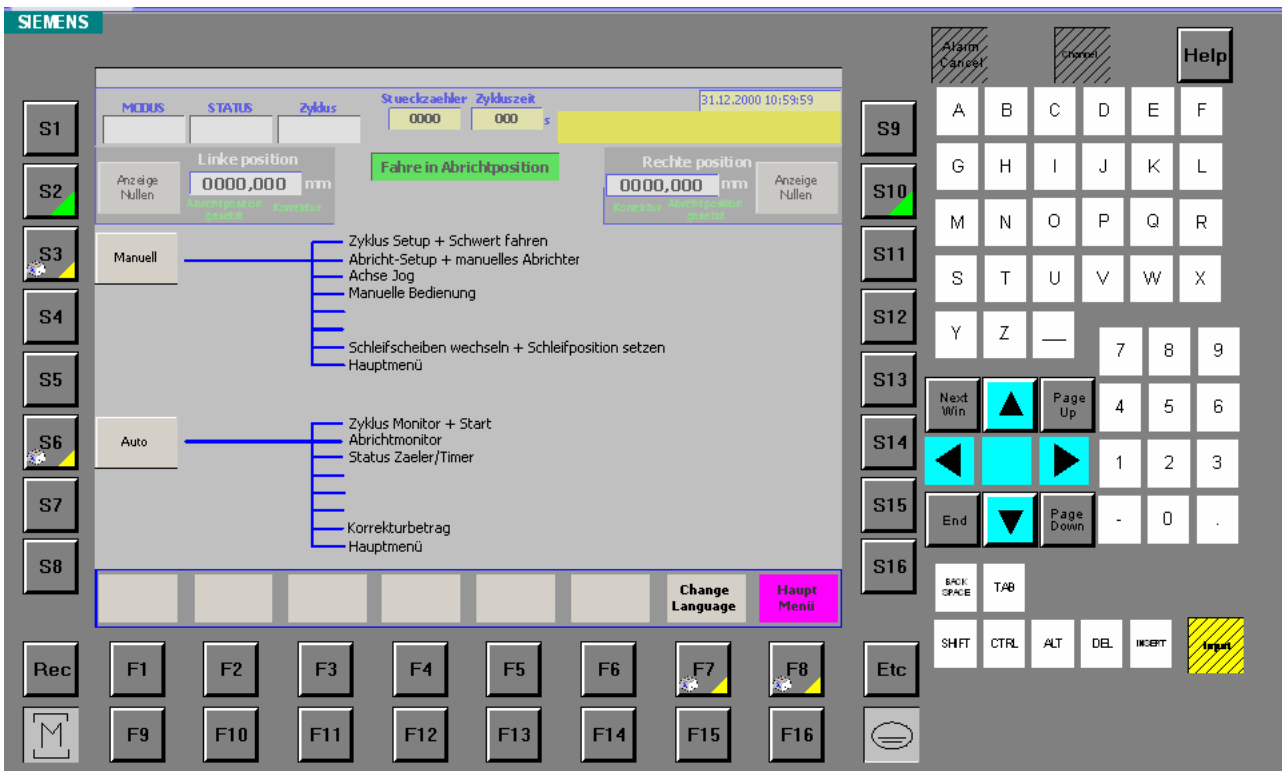


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Main Menu Screen which shows the screen navigation. This machine had English and German languages and changed between the two languages at a push of the button.



Main Menu Screen in German Language which shows the screen navigation.



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Manual Control Screen gives the operator the ability to manually jog auxiliary functions.

Manual Control Screen in German Language.



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Axis Jog Screen enables the operator to jog the axis in incremental or continues mode.

Axis Jog Screen in German Language.



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The screenshot shows the Siemens Dress Setup Screen in English. At the top, it displays 'MODE', 'STATUS', and 'CYCLE' information, along with 'Part Count' (0000) and 'Cycle Time' (000 s). The date and time are shown as 12/31/2000 10:59:59 AM. The 'LEFT Feed Position' and 'RIGHT Feed Position' are both set to 0000.000 mm. The 'Feeds At Dress' indicator is green. The 'Manual Dress' section includes 'Passes' (00), 'Comp Amount' (0.000), 'Free Passes' (00), and 'Wheel Speed' (Left: 000, Right: 000). The 'Auto Dress' section is 'Enabled' and includes 'Cycles' (000), 'Passes' (00), 'Comp Amount' (0.000), 'Free Passes' (00), and 'Wheel Speed' (Left: 000, Right: 000). The interface also features a numeric keypad (S9-S12), a numeric keypad (S13-S16), and function keys (F1-F16). The 'Dress Setup' button is highlighted in pink.

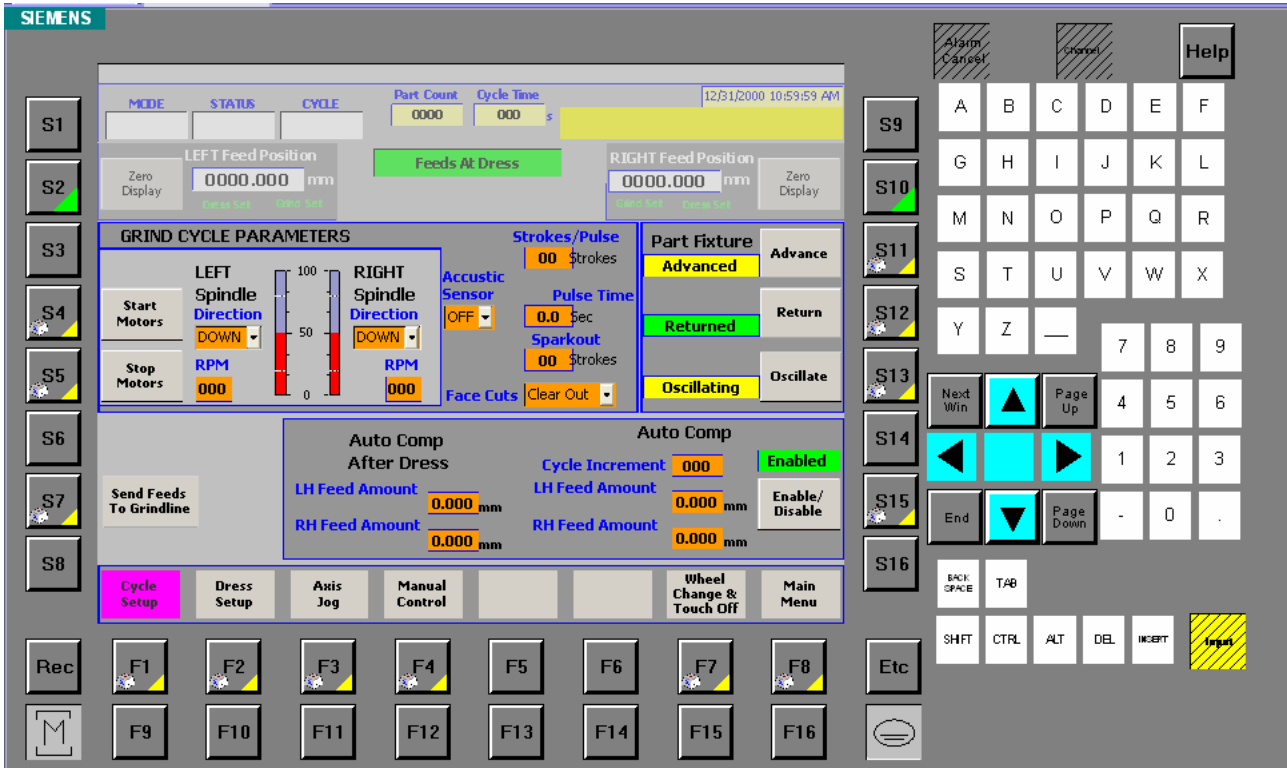
Dress Setup Screen lets the operator Manually Dress the Wheels in preparation for automatic operation.

The screenshot shows the Siemens Dress Setup Screen in German. At the top, it displays 'MODUS', 'STATUS', and 'Zyklus' information, along with 'Stueckzaehler' (0000) and 'Zykluszeit' (000 s). The date and time are shown as 31.12.2000 10:59:59. The 'Linke position' and 'Rechte position' are both set to 0000,000 mm. The 'Fahre in Abrichtposition' indicator is green. The 'Manuelles Abrichten' section includes 'Hübe pro Vorschub' (00), 'Betrag Kompensation' (0,000), 'Leerhübe' (00), and 'Drehgeschwindigkeit' (Links: 000, Rechts: 000). The 'Auto Abrichten' section is 'Ein' and includes 'Zyklen' (000), 'Hübe pro Vorschub' (00), 'Betrag Kompensation' (0,000), 'Leerhübe' (00), and 'Drehgeschwindigkeit' (Links: 000, Rechts: 000). The interface also features a numeric keypad (S9-S12), a numeric keypad (S13-S16), and function keys (F1-F16). The 'Abricht Setup' button is highlighted in pink.

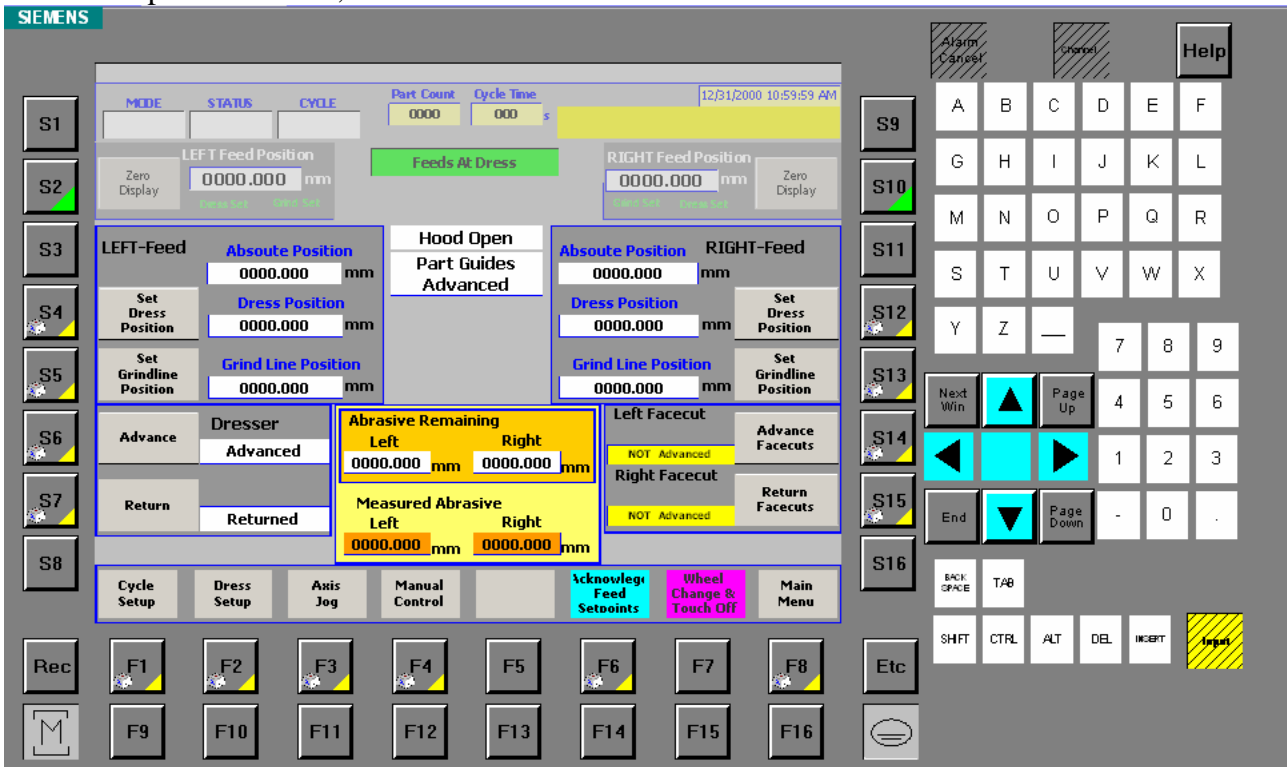
Dress Setup Screen in German Language.

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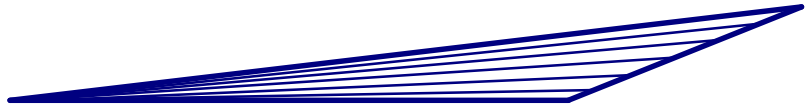
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Cycle Setup Screen the operator uses this screen to setup the process parameters such as when to dress, how much to compensate after the dress, which direction the wheels are to rotate, number of strokes between the wheels the part is to make, ect...



Wheel Change Screen is used to setup the machine after the Grinding Wheels had been changed.



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Cycle Monitor Screen Operator will use while in Automatic Mode to monitor the process and make small process changes to bring the part within part tolerance.

Dress Monitor Screen Is used in Automatic Mode the dress parameters.

