



N-DAS FOR MY-TR5 System Operation Manual



Y2F210-4-010
2022/01/26



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① User Guide

This manual describes how to quickly operate the “Data Acquisition System” and get started with the MY-TR5 controller.

Diversified operation interface, user-friendly design also system can have functions such as report operation, data analysis, trend graph, parameter setting, etc.






② System Requirements

- Windows 10, Windows 8, Windows 7, Windows XP or Windows Vista
- Hardware memory at least 768MB/2GBHz processor
- At least 2GB hard disk
- Recommended at least 16-bit color and 1024x768 screen resolution
- .NET Framework 4.0 or above must be installed

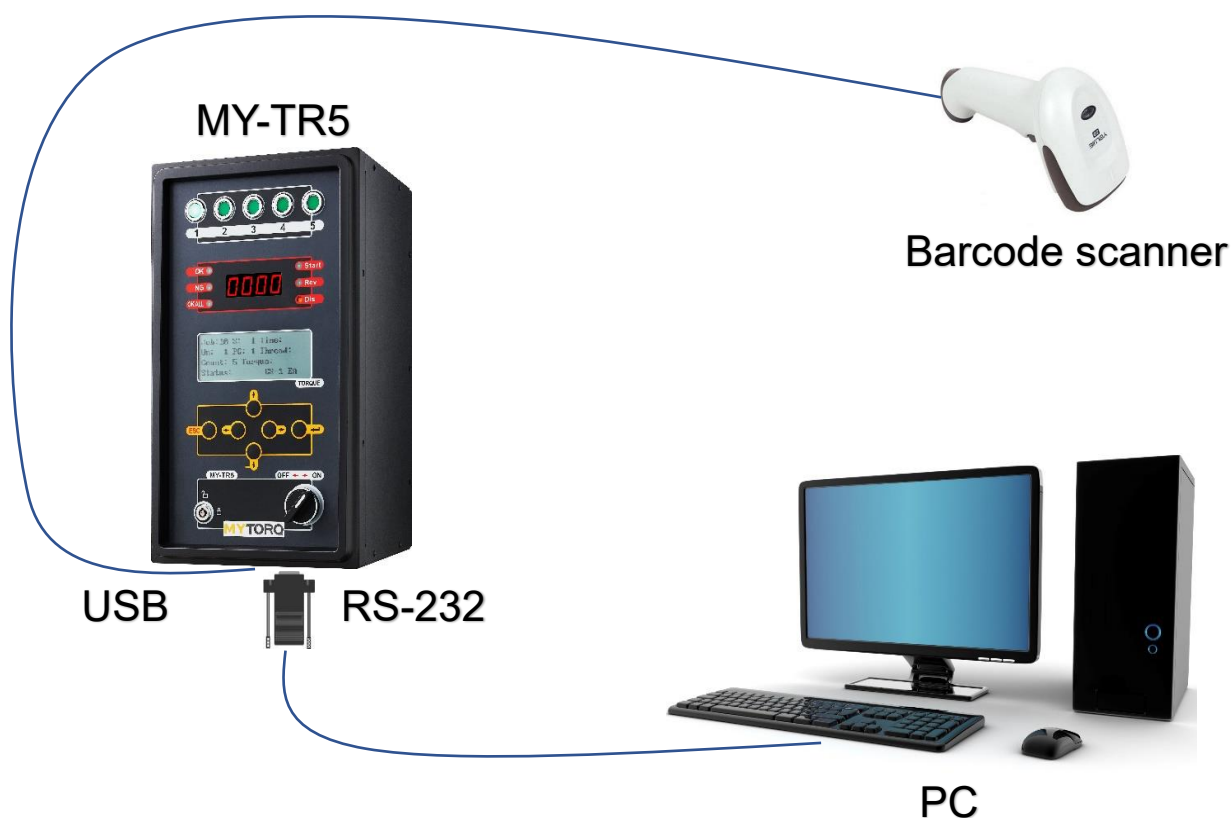
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③ Hardware

1. The following must be prepared before operating this system:

- MY-TR5 Controller
- Executable file for the operating  systemData_Acquisition_System.exe.
- One RS-232 serial port.
- One 1D(Linear) barcode scanner (*not necessary).

2. Device connection as in the following diagram:

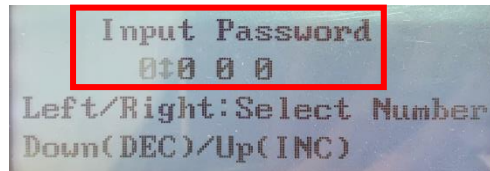


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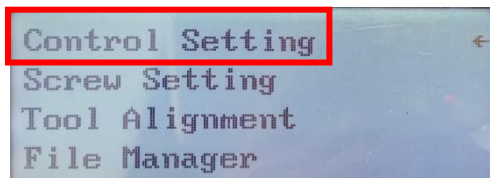
④ Controller Preparation

Step 1: Press and hold ESC for 3 seconds after power is turned on (ON), enter the password (Input Password) XXXX and press Enter to go into setup.

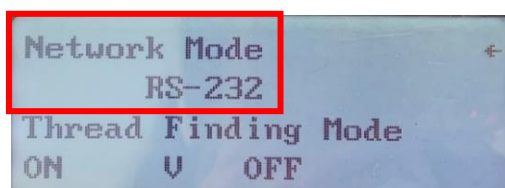
NOTE: 0000 as default password.



Step 2: Press the down arrow key (↓) to find the Control Setting and then press Enter.



Step 3: Find Network Mode and then press Enter. Use the up and down arrow keys (↑↓) to select the RS-232 setting, and then press Enter to exit the network settings, and then press ESC to return to the previous page to complete the setup.



NOTE: This is RS-232 (flashing light indicates successful connection).



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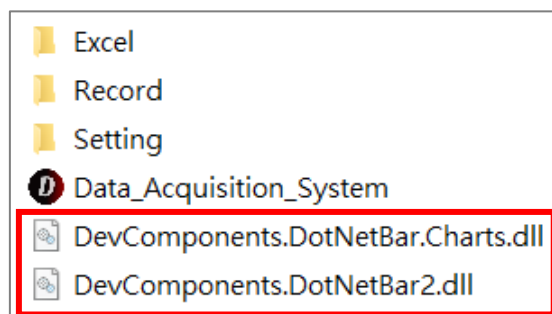
⑤ System Connection

Step 1: Before log in, it is required to set the date format in the computer system as “YYYY/MM/DD”.

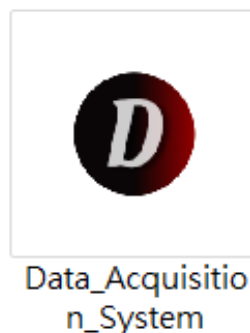
Step 2: Download the compressed software

NOTE:

For the version: 1.0.0.6 and later on, there must have 2 additional dll files in the folder(shown as below picture) after you decompressed the software. These are required files to run the software.



Step 3: Open the executable file  Data_Acquisition_System.exe.



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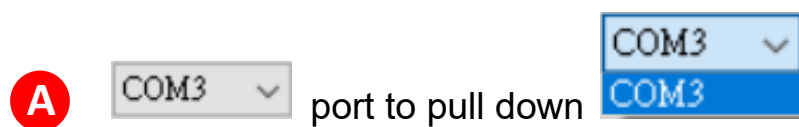
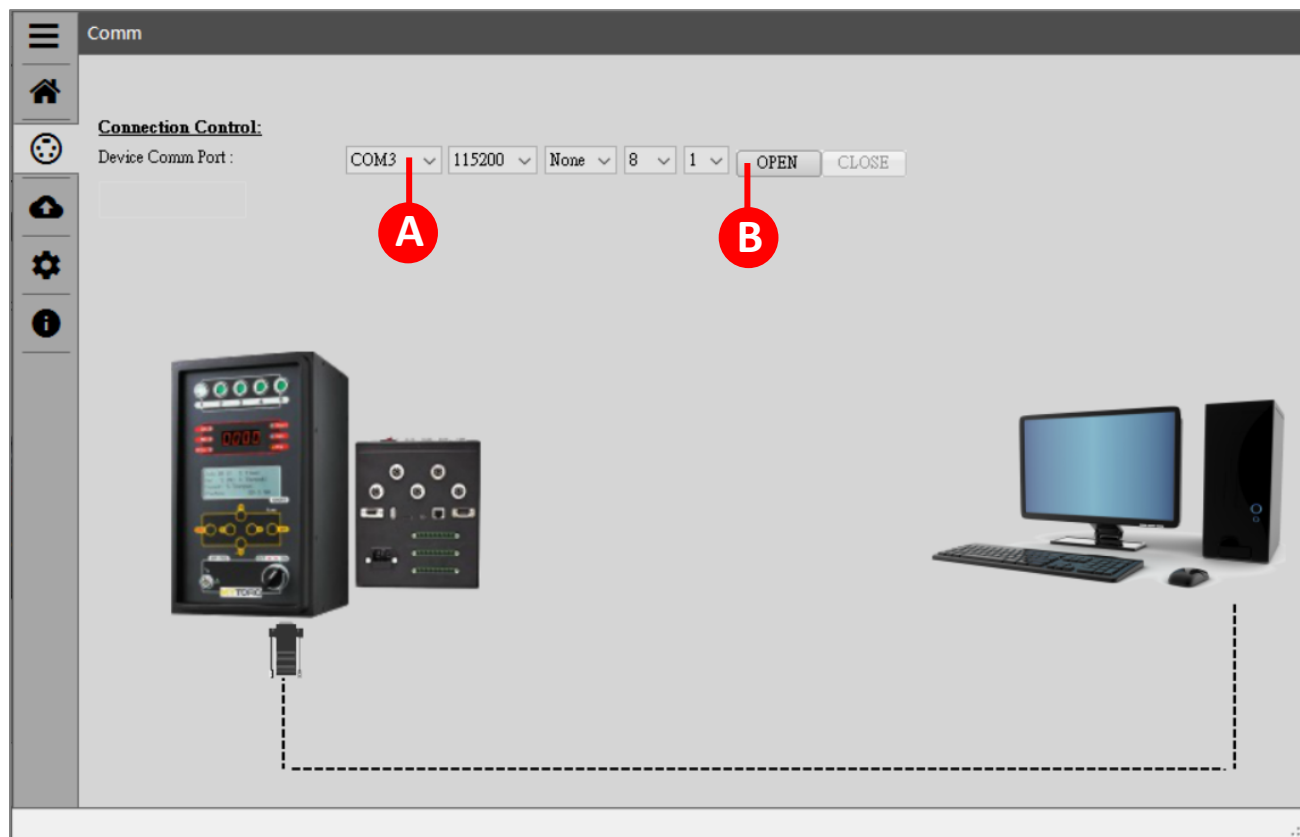
Step 4: Move the mouse cursor to **MYTORQ** and display the four controllers.




Step 5:  Controller selection (MY-TR5).



Step 6: Go to  Comm page.



(Connect according to the port of the computer display device)

- B** And press  and leave controller product testing setup page (communication settings are default, there is no need to modify).

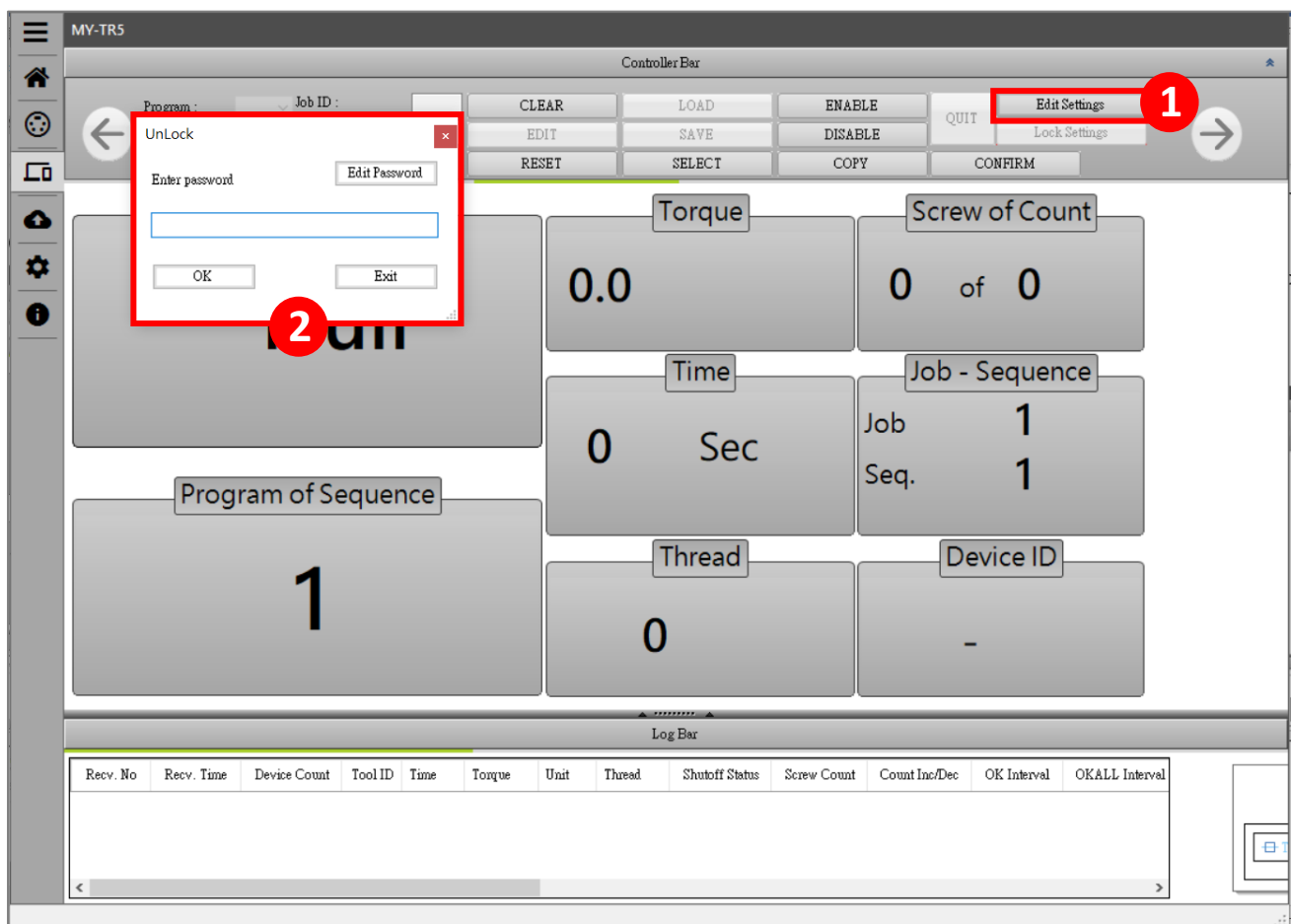
⑥ System Screen Introduction

➤ Unlock Settings

The page displayed is Instant data display after entering the screen. At this time, no operation can be performed due to locked setting. You must enter the password first if need to unlock for operation.

Step 1: After clicking the button of "Edit Settings", the unlock window will pop up.

Step 2: Enter the default password "admin123" and click confirm button.

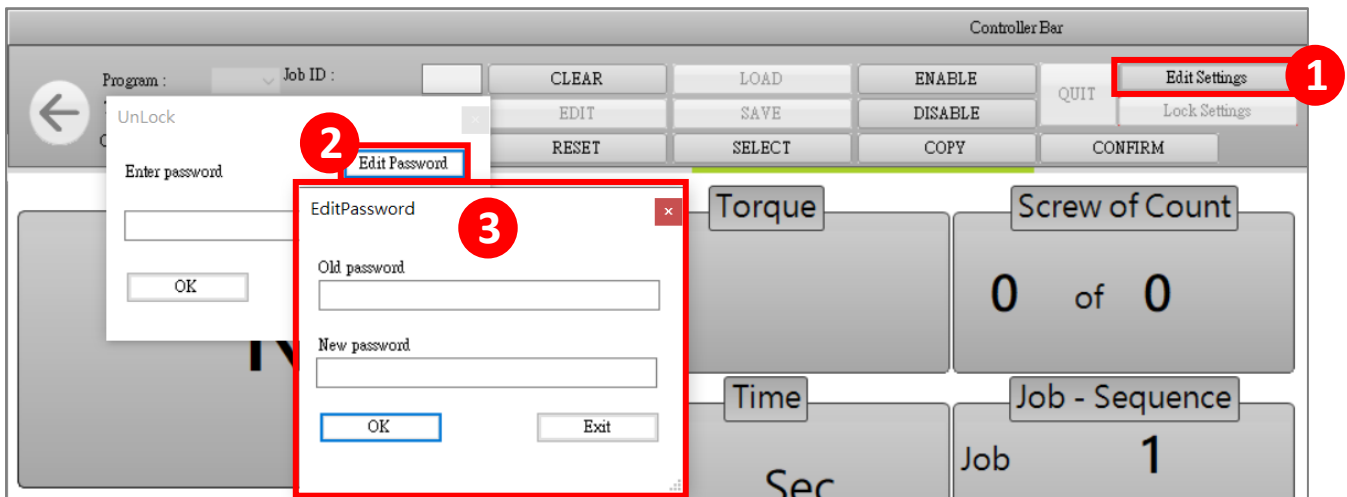


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➤ Password change setting method

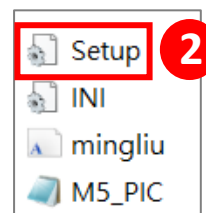
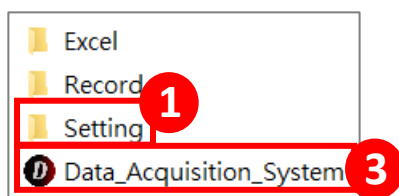
Click "Edit Settings" button → "Edit Password" to enter the old password and the new password, and then click OK button to complete the setting.

NOTE: New password setting: Six to eight characters in length, including English uppercase and lowercase, numbers.




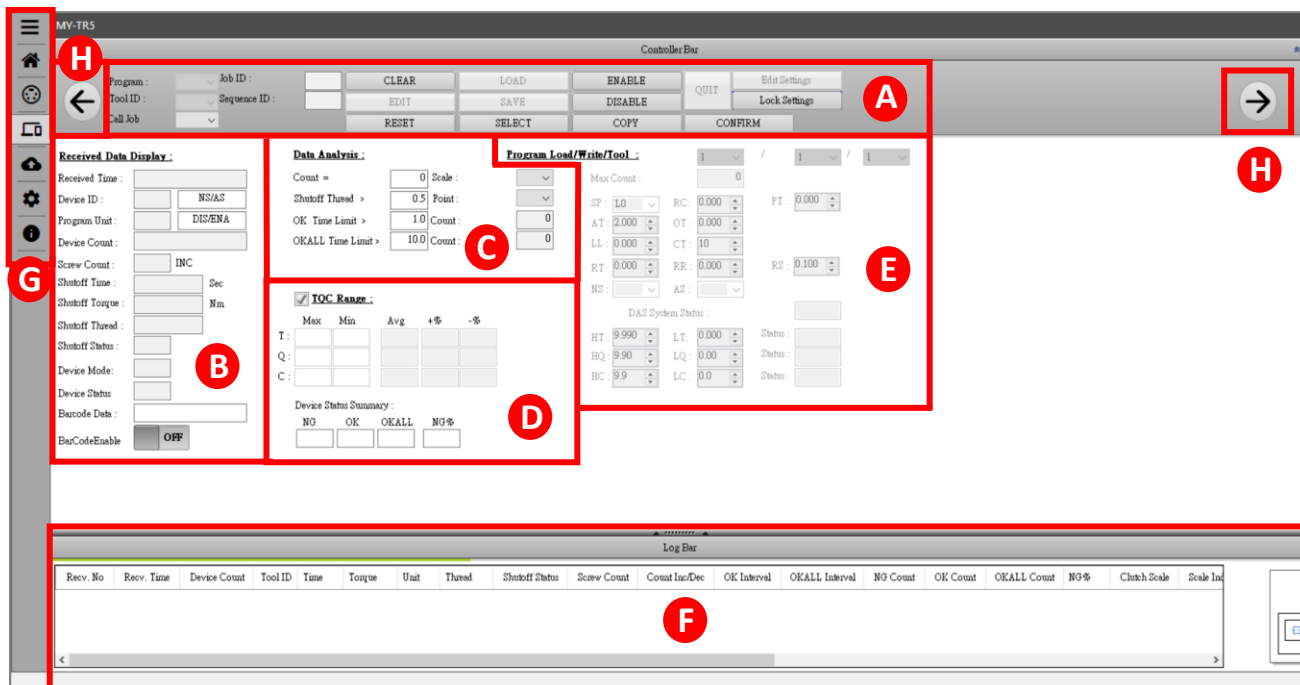
➤ Restore default password

Select to enter the ① Setting folder, delete the file named ② Setup and Reopen it ③ Data_Acquisition_System can restore the default password (admin123)



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1.  Product setup page: divide the setup page into partitions and introduce them in order.



The screenshot shows the MYTORQ product setup page. It is divided into several sections, each labeled with a red circle containing a letter:

- A**: Controller Bar (top right)
- B**: Received Data Display (left side)
- C**: Data Analysis (middle left)
- D**: TOC Range (middle left, below Data Analysis)
- E**: Program Load/Write/Tool (middle right)
- F**: Log Bar (bottom)
- G**: Left sidebar menu
- H**: Right sidebar menu

NOTE:

The pages of the system can be operated by sliding left and right , so the software can be operated on the touch screen.

A Controller device setup


The screenshot shows the Controller device setup section, which includes the following fields and buttons:

Program :	Job ID :		CLEAR	LOAD	ENABLE	QUIT	Edit Settings
Tool ID :	Sequence ID :		EDIT	SAVE	DISABLE		Lock Settings
Call Job			RESET	SELECT	COPY	CONFIRM	







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Introduce the functions for the three zones from left to right in order:

Program :	<input type="text"/>	Job ID :	<input type="text"/>
Tool ID :	<input type="text"/>	Sequence ID :	<input type="text"/>
Call Job	<input type="text"/>		

- Program: Display the program group currently used (Program 1~99).
- Tool ID: Display the current number of screwdriver (Tool 1~5) being used.
- Call Job: The specified Job can be executed immediately.
- Job ID: Display the current number of job (Job 1~20) being used.
- Sequence ID: Display the current number of sequence (Sequence 1~20) being used.



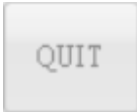
CLEAR	LOAD	ENABLE	QUIT	Edit Settings
EDIT	SAVE	DISABLE		Lock Settings
RESET	SELECT	COPY	CONFIRM	

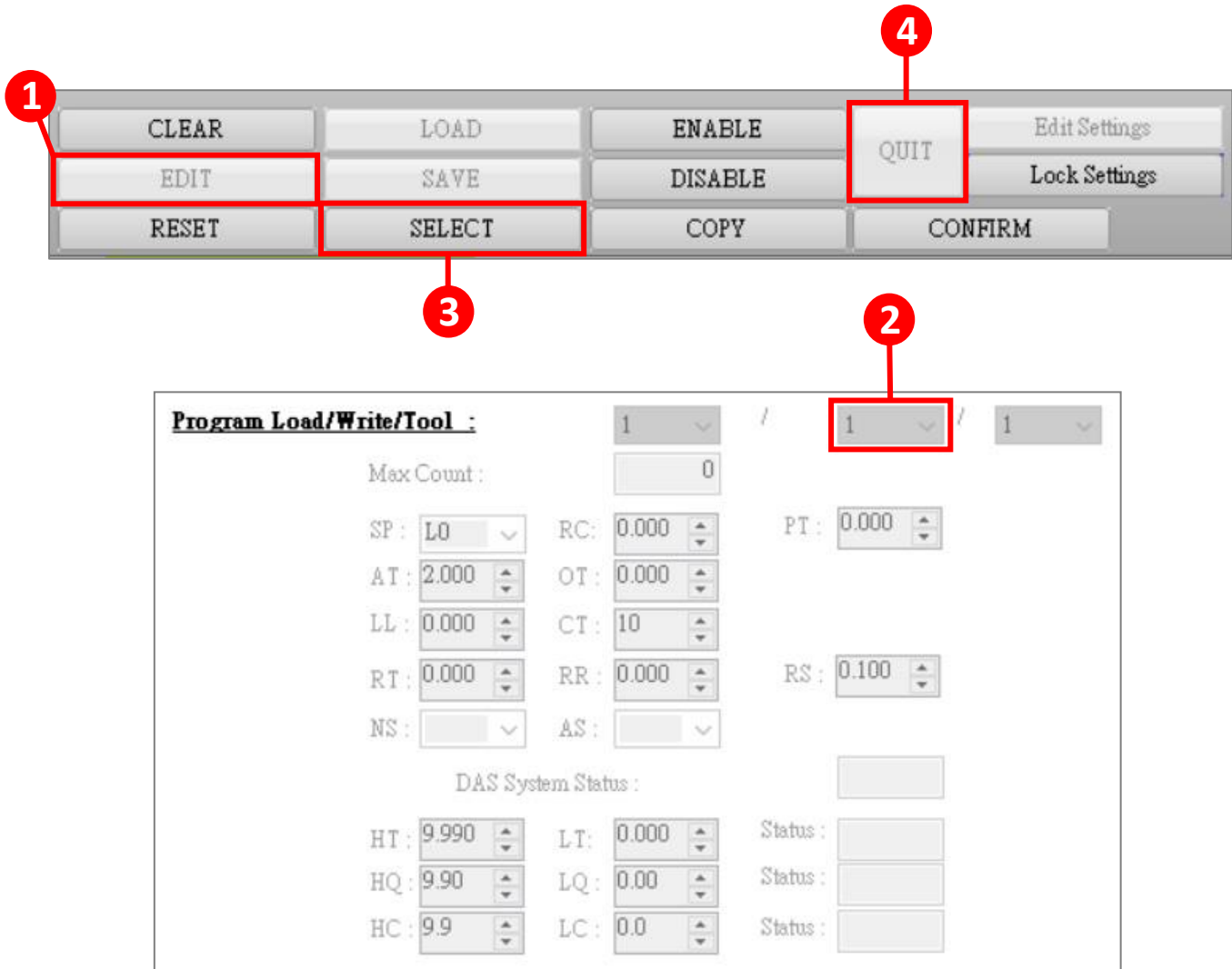
- CLEAR: Click  to reset counting.
- ENABLE: Press  to immediately allow the screwdriver to run.
- EDIT: Press  to enter screwdriver condition parameters.
- DISABLE: Press  to immediately stop screwdriver operation.
- RESET: Press  to restart the controller and restore factory parameters.
- CONFIRM: Click  to dismiss controller C3 status.


(refer to User Manual for C3 function introduction).

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- SELECT: Press  and then input required parameters

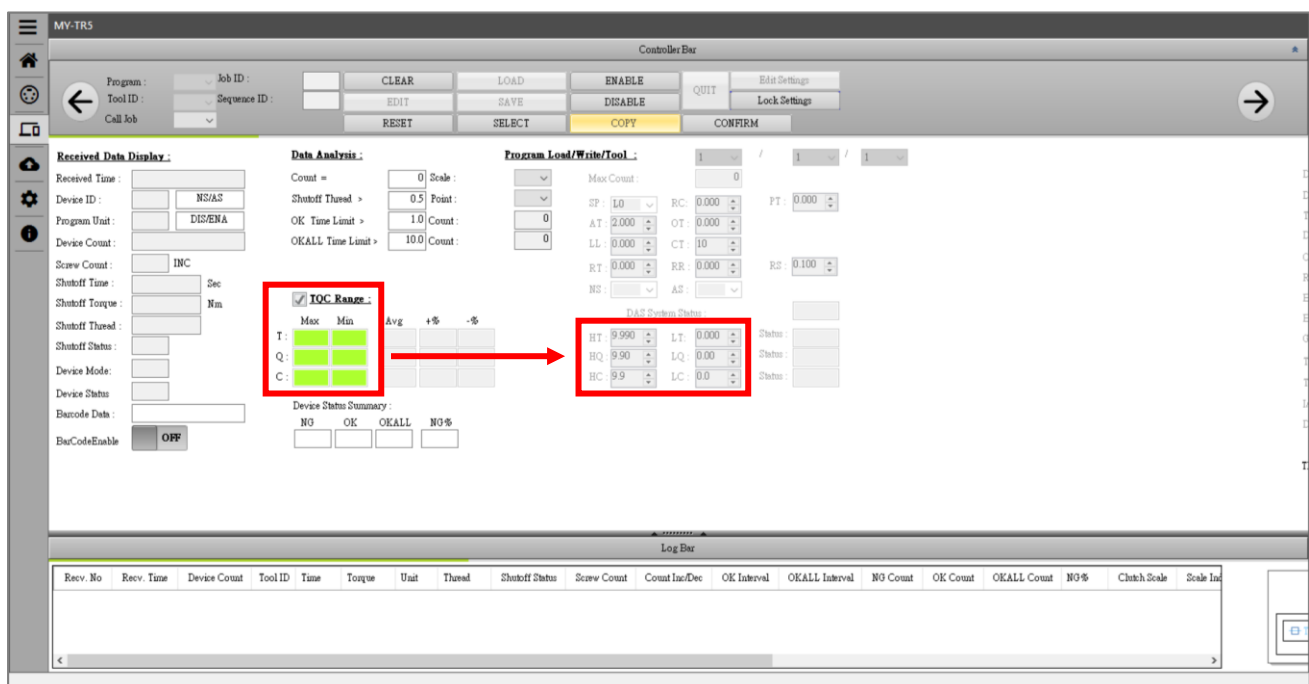
 . Then, press  and  to switch to required program.



- COPY: Press  to copy the TQC condition parameter to Program.

(Procedure:  → tightening screws →  →

 →  . After done this procedure, the system will copy T, Q, C data to HT/ HQ/HC/LT/LQ/LC as limitations.

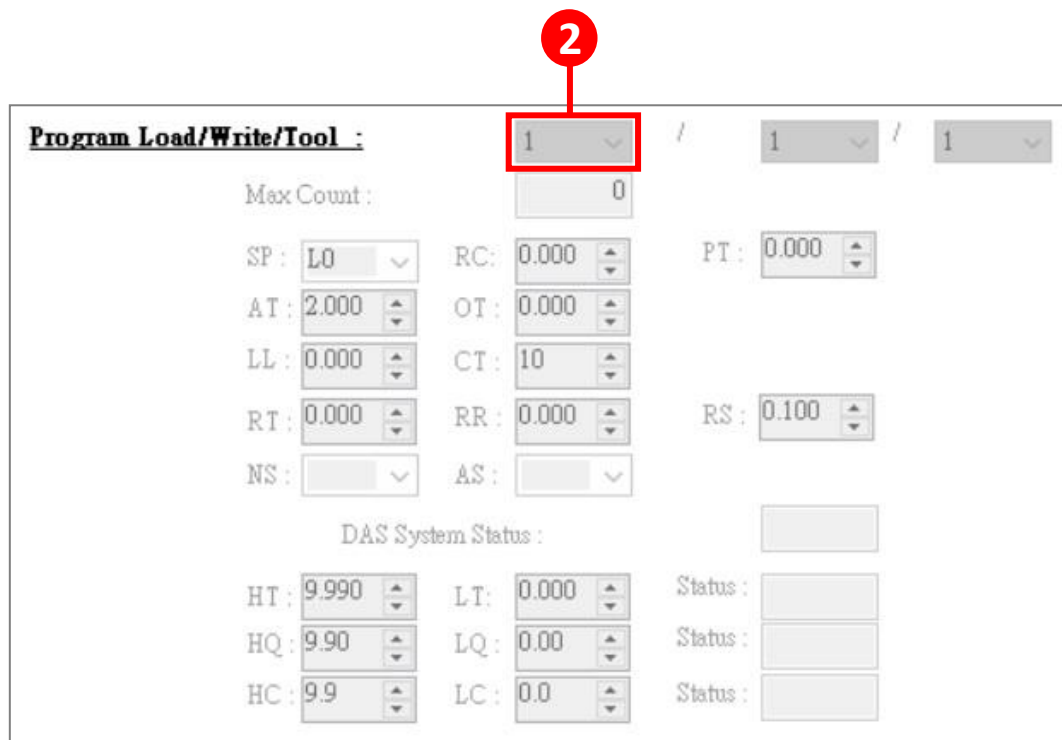


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- **LOAD:** To load the parameter settings from the KL-MCTDS5 controller.


Press and then select program .

Press to finish this process.

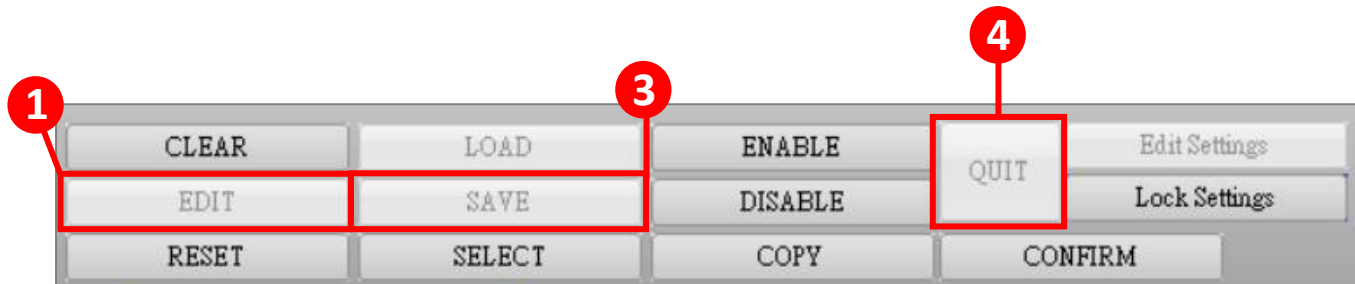


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- **SAVE:** Save the parameters to KL-MCTDS5 controller.

Press  and then input required parameters.

Then, press  and  to finish this process.




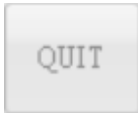


2 Program Load/Write/Tool :

Max Count :	1	/	1	/	1
SP : LO	RC : 0.000	PT : 0.000			
AT : 2.000	OT : 0.000				
LL : 0.000	CT : 10				
RT : 0.000	RR : 0.000	RS : 0.100			
NS :	AS :				
DAS System Status :					
HT : 9.990	LT : 0.000	Status :			
HQ : 9.90	LQ : 0.00	Status :			
HC : 9.9	LC : 0.0	Status :			

NOTE: Program Load/Write/Tool : 1 / 1 / **1**

Program Tool: Normally, this function is used to test specific tool No. with specific program No. flexibility. You could assign which tool to run the program No. you load.

* Available only when the Sequence settings is set to OFF.

- QUIT: Press  to end after pressing .
- Edit Settings : After entering the system, you must click 
and enter the password to unlock the screen and switch to other pages.
(Please refer to ["Password Change Setting Method"](#))
- Lock Settings : Click  to automatically jump to the
"Instant data display" screen, and no operation can be performed. The lock
settings must be unlocked.
(Please refer to ["Instant data display"](#) , ["Unlock Settings"](#))

B Received Data Display: All fastened data can be displayed instantly.

Received Data Display :

Received Time :	<input type="text"/>	
Device ID :	<input type="text"/>	NS/AS
Program Unit :	<input type="text"/>	DIS/ENA
Device Count :	<input type="text"/>	
Screw Count :	<input type="text"/>	INC
Shutoff Time :	<input type="text"/>	Sec
Shutoff Torque :	<input type="text"/>	Nm
Shutoff Thread :	<input type="text"/>	
Shutoff Status :	<input type="text"/>	
Device Mode:	<input type="text"/>	
Device Status	<input type="text"/>	
Barcode Data :	<input type="text"/>	
BarCodeEnable	<input type="checkbox"/> OFF	



- Received Time: The time to fasten the data.
- Device ID: Device ID (1~99).
- Program Unit: This fastened program group (Program).
- Device Count: The total number of times the device is fastened.
- Screw Count: The number of fastened units.
- Shutoff Time: How long driver ran before clutch tripped. (Sec)
- Shutoff Torque: the torque for the fastening.
- Shutoff Thread: Number of rotations at output shaft.
- Shutoff Status: shut off status (OK, NG, OK ALL, REV).
- Device Mode: STD mode, ADV mode. **(please refer to manual)**
- Device Status: **(Refer to the “Display Status Code Description” in User Manual).**
- Barcode Data: barcode data.
- BarCodeEnable: The C3 function will be dismissed when the barcode is scanned. **(refer to User Manual for C3 function introduction)**

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- C** Data Analysis: the number of times, the number of shut off, OK and OKALL interval time can be set. The data which meet the conditions will be shown.

NOTE: Data Analysis will be activated when the TQC Range is enable.

<u>Data Analysis :</u>			
Count =	<input type="text" value="0"/>	Scale :	<input type="text" value="v"/>
Shutoff Thread >	<input type="text" value="0.5"/>	Point :	<input type="text" value="v"/>
OK Time Limit >	<input type="text" value="1.0"/>	Count : — 1	<input type="text" value="0"/>
OKALL Time Limit >	<input type="text" value="10.0"/>	Count : — 2	<input type="text" value="0"/>

- Count: the number of shutoff Thread greater than its setting and also the torque value is greater than 0.
- Scale: 0~8 scale.
- Shutoff Thread: Output shaft must rotate more than displayed value or result will be ignored.
- Point: Clutch scale (1~15).
- OK Time Limit: Set the maximum duration between each OK signal. Once the time over this setting, it will count 1.
- 1** Count: the number of times greater than OK interval.
- OKALL Time Limit: Set the maximum duration between each OKALL signal. Once the time over this setting, it will count 1.
- 2** Count: the number of times greater than OKALL interval.

- D** TQC Range: Analyze the average error value

☒ **TQC Range :**

	Max	Min	Avg	+%	-%
T :					
Q :					
C :					

Device Status Summary :

NG	OK	OKALL	NG%

- E** Program parameter setup

(refer to manual for condition parameters)

Program Load/Write/Tool :

1 / 1 / 1

Max Count : 0

SP : L0 RC: 0.000 PT: 0.000

AT: 2.000 OT: 0.000

LL: 0.000 CT: 10

RT: 0.000 RR: 0.000 RS: 0.100

NS: AS:

DAS System Status :

HT: 9.990	LT: 0.000	Status:
HQ: 9.90	LQ: 0.00	Status:
HC: 9.9	LC: 0.0	Status:

- Program Load/Write/Tool:

Program Load/Write/Tool :			1	/	1	/	1
Max Count :			0				
SP :	L0	RC :	0.000	PT :	0.000		
AT :	2.000	OT :	0.000				
LL :	0.000	CT :	10				
RT :	0.000	RR :	0.000	RS :	0.100		
NS :		AS :					
DAS System Status :							
HT :	9.990	LT :	0.000	Status :			
HQ :	9.90	LQ :	0.00	Status :			
HC :	9.9	LC :	0.0	Status :			

- For the “Load” field, please refer to [“ROAD”](#) .
- For the “Write” field, please refer to [“SAVE”](#) .

- Max Count:

Program Load/Write/Tool :			1	/	1	/	1
Max Count :			0				
SP :	L0	RC :	0.000	PT :	0.000		
AT :	2.000	OT :	0.000				
LL :	0.000	CT :	10				
RT :	0.000	RR :	0.000	RS :	0.100		
NS :		AS :					
DAS System Status :							
HT :	9.990	LT :	0.000	Status :			
HQ :	9.90	LQ :	0.00	Status :			
HC :	9.9	LC :	0.0	Status :			

The field indicates the “required total screw numbers”

- Program parameter setup

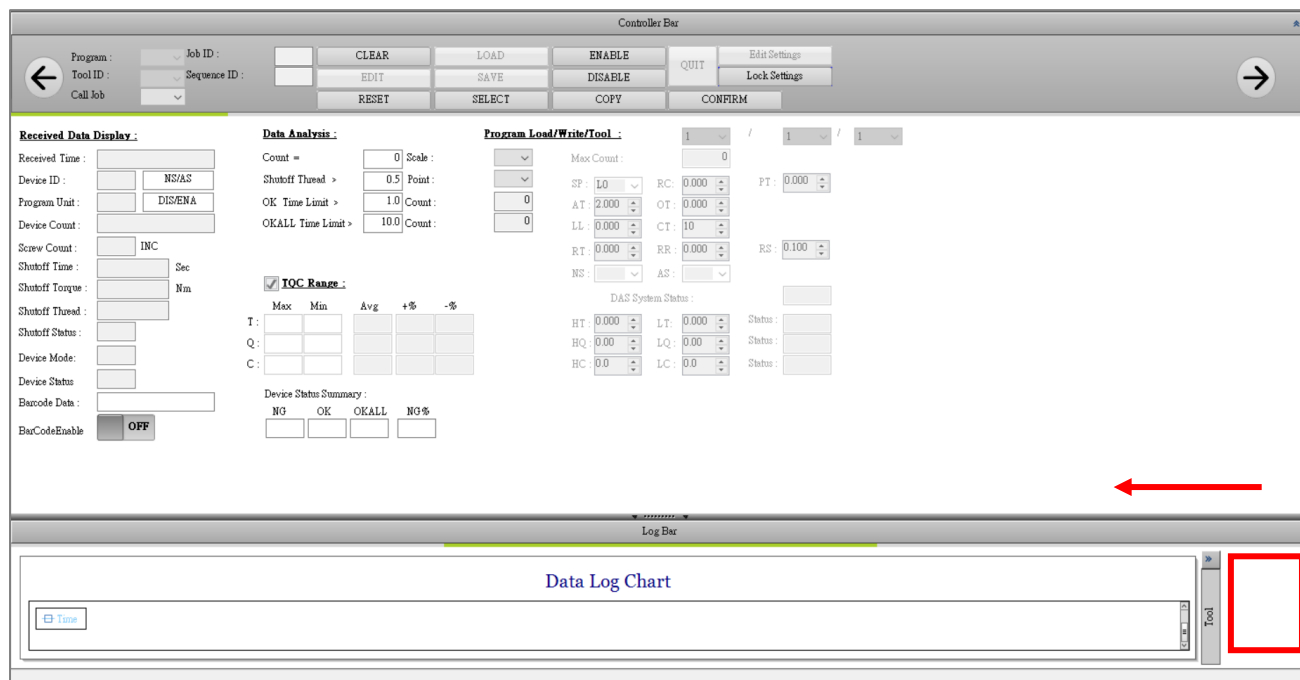
(refer to Manual for Condition Parameters)

Program Load/Write/Tool :			1	/	1	/	1
Max Count :			0				
SP :	L0	RC :	0.000	PT :	0.000		
AT :	2.000	OT :	0.000				
LL :	0.000	CT :	10				
RT :	0.000	RR :	0.000	RS :	0.100		
NS :		AS :					
DAS System Status :							
HT :	9.990	LT :	0.000	Status :			
HQ :	9.90	LQ :	0.00	Status :			
HC :	9.9	LC :	0.0	Status :			

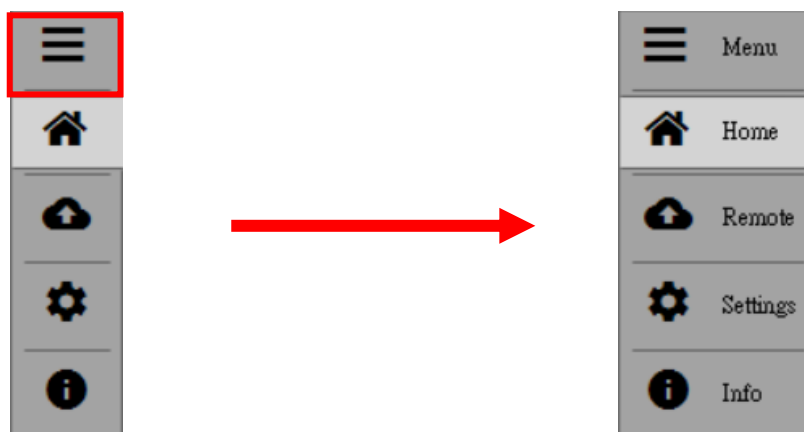
- [illegible]

-
- The screenshot shows the 'Controller Bar' interface. At the top, there are buttons for 'CLEAR', 'LOAD', 'ENABLE', 'QUIT', 'EDIT', 'SAVE', 'DISABLE', 'RESET', 'SELECT', 'COPY', and 'CONFIRM'. Below these are input fields for 'Program ID', 'Job ID', 'Tool ID', and 'Sequence ID'. A red arrow points to the 'Job ID' field. The main area is divided into several sections: 'Received Data Display' with fields for 'Received Time', 'Device ID', 'Program Unit', 'Device Count', 'Screw Count', 'Shutoff Time', 'Shutoff Torque', 'Shutoff Thresh', 'Shutoff Status', 'Device Mode', 'Device Status', 'Barcode Data', and 'BarCodeEnable'; 'Data Analysis' with fields for 'Count', 'Scale', 'Shutoff Thresh', 'OK Time Limit', 'OKALL Time Limit', and 'IOC Range'; 'Program Load/Write/Tool' with fields for 'Max Count', 'SP', 'AT', 'LL', 'RT', 'NG', 'RC', 'OT', 'CT', 'RR', 'RS', 'AS', 'LT', 'LQ', 'LC', and 'Status'; and 'Device Status Summary' with fields for 'NG', 'OK', 'OKALL', and 'NG%'. A 'Log Bar' is at the bottom.

NOTE: Touch the red box area and swipe to the next page to display a trend graph.



G Main menu: click  to hide or display English title.





Go to previous page by pressing



button, next page by pressing



button.

NOTE:

Full description will be displayed when the mouse moves to the setting parameter (please refer to manual for details).

Example:

When the mouse moves to “SP”, “SP: [Slow Start Speed Level]” is displayed.

2. Controller and Job setup page

Controller Bar

Program : Job ID : CLEAR LOAD ENABLE QUIT Edit Settings
 Tool ID : Sequence ID : EDIT SAVE DISABLE Lock Settings
 Call Job : RESET SELECT COPY CONFIRM

Controller Configuration :

Device Time :
 Device Sn :
 Tool Sn :
 Device ID : 1
 Operation Mode : Seq
 Reverse Mode :
 Batch Mode :
 Brake Signal :
 Gate Mode :
 Torque Unit :
 Tool Status :
 I/O Status :
 Device/Tool Ver :
 TF:

Job No. : Sequence Numbers :



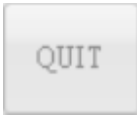
Sequence 1	Sequence 6	Sequence 11	Sequence 16
1 0.00	1 0.00	1 0.00	1 0.00
Sequence 2	Sequence 7	Sequence 12	Sequence 17
1 0.00	1 0.00	1 0.00	1 0.00
Sequence 3	Sequence 8	Sequence 13	Sequence 18
1 0.00	1 0.00	1 0.00	1 0.00
Sequence 4	Sequence 9	Sequence 14	Sequence 19
1 0.00	1 0.00	1 0.00	1 0.00
Sequence 5	Sequence 10	Sequence 15	Sequence 20
1 0.00	1 0.00	1 0.00	1 0.00

A **B**

Log Bar

Recv. No	Recv. Time	Device Count	Tool ID	Time	Torque	Unit	Thresh	Shutoff Status	Screw Count	Count Inc/Dec	OK Interval	OKALL Interval	NG Count	OK Count	OKALL Count	NG%	Clutch Scale	Scale I

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A Controller Configuration: After pressing , you can modify and query the controller status set by the device (RED rectangle area). After the setup is completed, press the  button and press  to complete the query.



Controller Configuration : 2

Device Time :

Device Sn :

Tool Sn :

Device ID:

Operation Mode : Seq :

Reverse Mode :

Batch Mode :

Brake Signal :

Gate Mode :

Torque Unit :

Tool Status :

I/O Status :

Device/Tool Ver: /

TF :

NOTE: To query the Controller Configuration ,

press  →  →  .

NOTE: Refer to instruction manual for device setup conditions.

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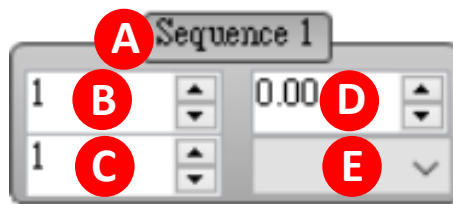
B Work Sequence:

You can set up twenty Job. No. : and twenty Sequence Numbers :.

The screenshot displays the 'Work Sequence' setup screen. At the top, there are two dropdown menus: 'Job. No. :' and 'Sequence Numbers :', both set to '20'. Below these, there is a grid of 20 sequence settings, labeled 'Sequence 1' through 'Sequence 20'. Each sequence setting consists of a small box with '1' and a larger box with '0.00' and a dropdown arrow. The 'Job. No. :' and 'Sequence Numbers :' dropdowns are highlighted with a red rectangle.

- When Job. No. : selects the first set, after Sequence Numbers : has set up three, you will see the following screen.

The screenshot displays the 'Work Sequence' setup screen after selecting 'Job. No. : 1' and 'Sequence Numbers : 3'. The 'Job. No. :' dropdown is set to '1' and the 'Sequence Numbers :' dropdown is set to '3'. Below these, there are three sequence settings, labeled 'Sequence 1', 'Sequence 2', and 'Sequence 3'. Each sequence setting consists of a small box with '1' and a larger box with '0.00' and a dropdown arrow.

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NOTE:

- A** Sequence (Sequence No. 1 ~ No. 20)
- B** Unit (Unit No.1 ~ No. 99) = Program No. + Tool No.
- C** Program (Program No.1 ~ No. 99)
- D** Offset (Offset +99.99 ~ -99.99)
- E** Tool (Tool NO. 1 ~ Tool NO. 5)

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3. Instant data display

The screenshot displays the MYTORQ Controller Bar interface. At the top, there is a 'Controller Bar' header. Below it, a navigation bar includes buttons for CLEAR, LOAD, ENABLE, EDIT, SAVE, DISABLE, RESET, SELECT, COPY, CONFIRM, QUIT, Edit Settings, and Lock Settings. The main display area is divided into several sections: 'Shutoff Status' (Null), 'Torque' (0.0), 'Screw of Count' (0 of 0), 'Time' (0 Sec), 'Job - Sequence' (Job 1, Seq. 1), 'Program of Sequence' (1), 'Thread' (0), and 'Device ID' (-). At the bottom, a 'Log Bar' contains a table with columns for Recv. No, Recv. Time, Device Count, Tool ID, Time, Torque, Unit, Thread, Shutoff Status, Screw Count, Count Inc/Dec, OK Interval, OKALL Interval, NG Count, OK Count, OKALL Count, NG%, Clutch Scale, and Scale Inc.

Recv. No	Recv. Time	Device Count	Tool ID	Time	Torque	Unit	Thread	Shutoff Status	Screw Count	Count Inc/Dec	OK Interval	OKALL Interval	NG Count	OK Count	OKALL Count	NG%	Clutch Scale	Scale Inc

- Shutoff Status: Display current complete status of fasten process.
- Program of Sequence: Indicate the current Program of the Sequence.
- Torque: Display fastening torque.
- Time: Display screw fastening time.
- Thread: Display the number of turning screwdriver.
- Screw of Count: Display the number of current screw count status.
- Job-Sequence: Display current fastened tasks and work sequence.
- Device ID: Display controller device number.

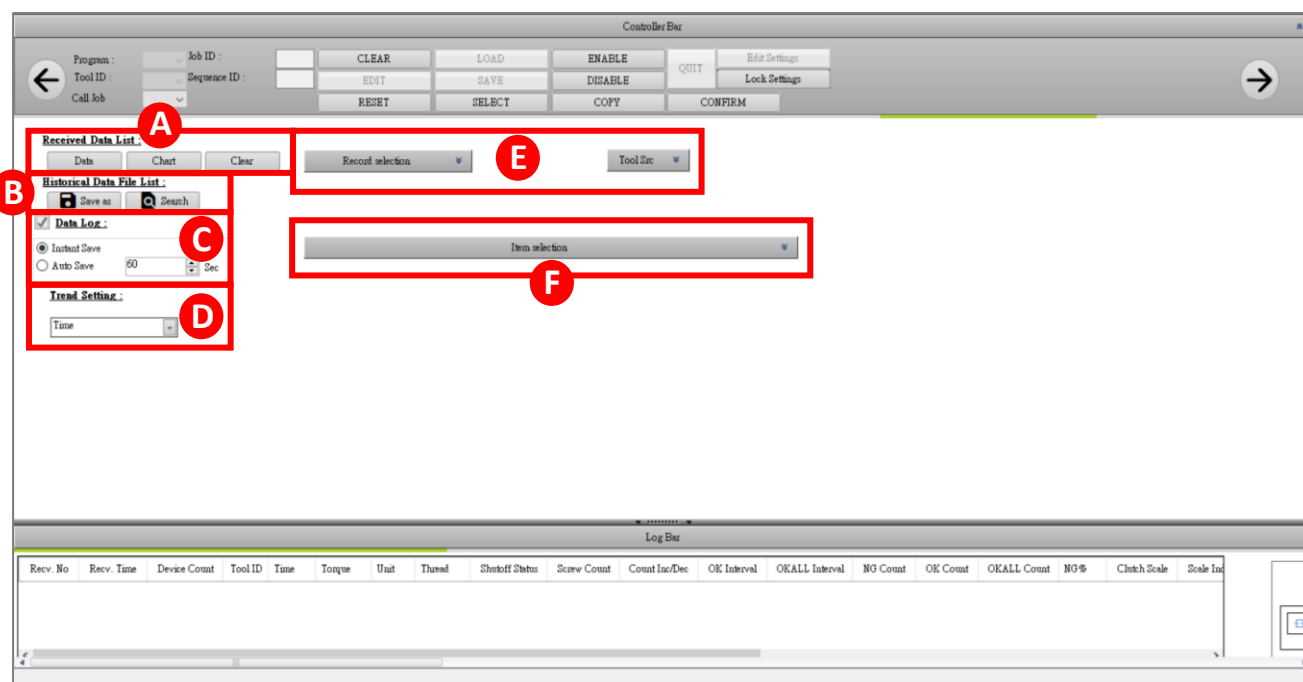


4. Electric screwdriver serial number calibration time page

This page shows the status of the electric screwdriver connection status, tool items, and number of torque filters.






5. Report and trend graph setup page



A Received Data List



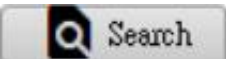
There are two types of display data   . If you need to clear it, press the  button to clear all the data immediately.

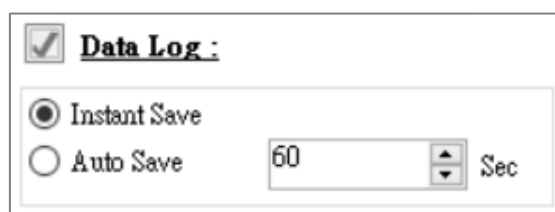
B Historical Data File List



- Excel export: When swiping the Controller Bar to page 4,

press  to export the Excel report to the specified location.

- Excel import: When swiping the Controller Bar to page 4,

press  and then click the Excel file to import it.

C Data Log

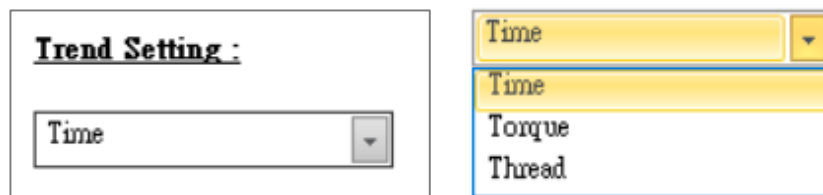
- Data Log: When ☒ **Data Log :** is checked, there are two ways to automatically export Excel reports (instant archive, automatic archive).
 - When ☒ **Instant Save** is selected, any data fastened will be automatically exported to the bottom of  **Excel** . When the system passes the integral time point, the form will be cleared to ensure sufficient memory space.
 - When ☐ **Auto Save** is selected, the data will be recorded in “seconds” as set in and the report will be exported below  **Excel** .

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D Trend Setting: Time, Torque, Thread

Select one of the Time, Torque, and Thread from the pull-down menu.

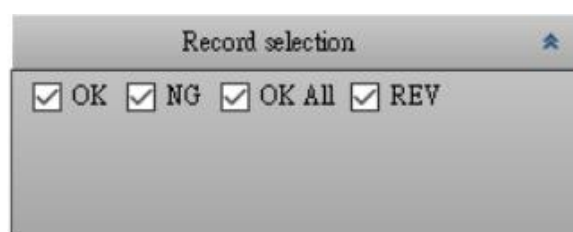
It will show the graphic trend chart. (Refer to ["TQC Trend Setting"](#))



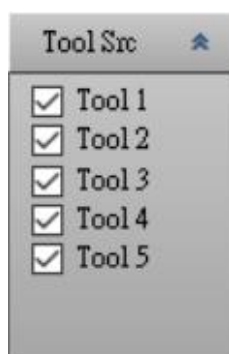
NOTE: When changing the “Trend Setting”(T/Q/C) setting, the screen of the chart will be clear and then display again after finished a new tighten.

E

- Record selection: Checked items will affect the data recorded in the form. When REV selection is cancelled, the inverted data will no longer be received.



- Tool Src: The selected items will affect the data recorded in the form. When the item is checked, the display data will be displayed; otherwise, it will not be displayed.



- Item selection: The selected items will affect the data recorded in the form. When the item is checked, the display data will be displayed; otherwise, it will not be displayed.

Item selection

☒ All Checked/Cancel

<input checked="" type="checkbox"/> Recv.No	<input checked="" type="checkbox"/> Recv.Time	<input checked="" type="checkbox"/> Device Count	<input checked="" type="checkbox"/> Tool ID	<input checked="" type="checkbox"/> Time
<input checked="" type="checkbox"/> Torque	<input checked="" type="checkbox"/> Unit	<input checked="" type="checkbox"/> Thread	<input checked="" type="checkbox"/> Shutoff Status	<input checked="" type="checkbox"/> Screw Count
<input checked="" type="checkbox"/> Count Inc/Dec	<input checked="" type="checkbox"/> OK Interval	<input checked="" type="checkbox"/> OKALL Interval	<input checked="" type="checkbox"/> NG Count	<input checked="" type="checkbox"/> OK Count
<input checked="" type="checkbox"/> OKALL Count	<input checked="" type="checkbox"/> NG Percentage	<input checked="" type="checkbox"/> Clutch Scale	<input checked="" type="checkbox"/> Scale Index	<input checked="" type="checkbox"/> Analysis Count
<input checked="" type="checkbox"/> Max Torque	<input checked="" type="checkbox"/> Min Torque	<input checked="" type="checkbox"/> Average Torque	<input checked="" type="checkbox"/> UpPercentage	<input checked="" type="checkbox"/> LowPercentage
<input checked="" type="checkbox"/> BarcodeData	<input checked="" type="checkbox"/> RawData	<input checked="" type="checkbox"/> ProgramUnit	<input checked="" type="checkbox"/> Torque Filter	

[Example]

If you only want to display the “received serial number”, “torque”, and “increase/decrease” for the “second screwdriver”, check “Tool2” in “Tool Source”, and check “Receive Serial Number”, “Torque”, “increment/decrease” in “Record selection”.

The screenshot displays the 'Controller Bar' software interface. At the top, there's a 'Controller Bar' title bar. Below it, a 'Program' section contains fields for 'Job ID', 'Tool ID', and 'Call Job', along with buttons for 'CLEAR', 'LOAD', 'ENABLE', 'QUIT', 'EDIT', 'SAVE', 'DISABLE', 'Edit Settings', 'Lock Settings', 'RESET', 'SELECT', 'COPY', and 'CONFIRM'. The main area is divided into two sections: 'Received Data List' and 'Historical Data File List'. The 'Received Data List' section has a 'Data Log' checkbox and a 'Trend Setting' dropdown. The 'Historical Data File List' section shows a list of tools (Tool 1 to Tool 5) and a 'Data Log' checkbox. The 'Data Log' checkbox is highlighted with a red box. Below the 'Received Data List' section, there's a 'Trend Setting' dropdown. At the bottom, there's a 'Log Bar' section with a 'Log' button and a 'Log Bar' label.

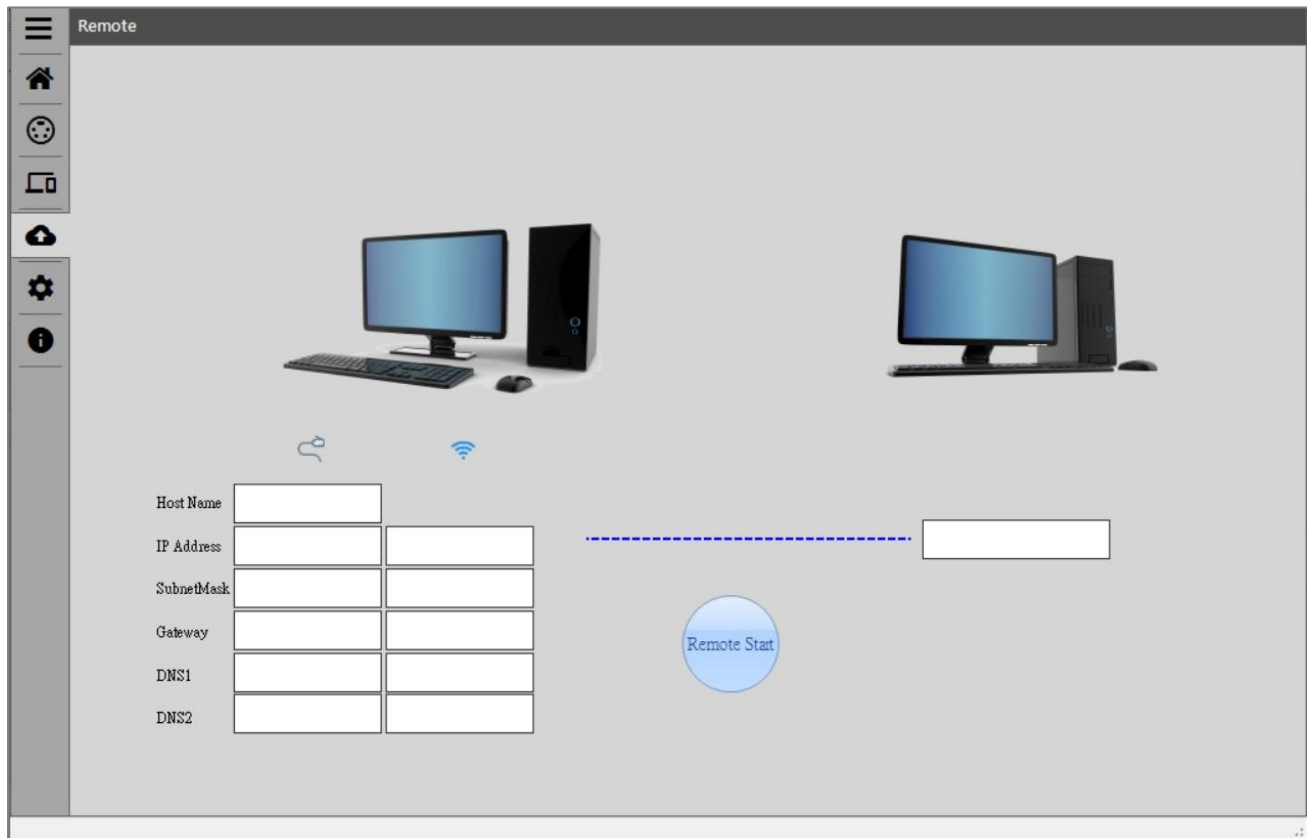
MYTORQ

⑦ Remote Screen




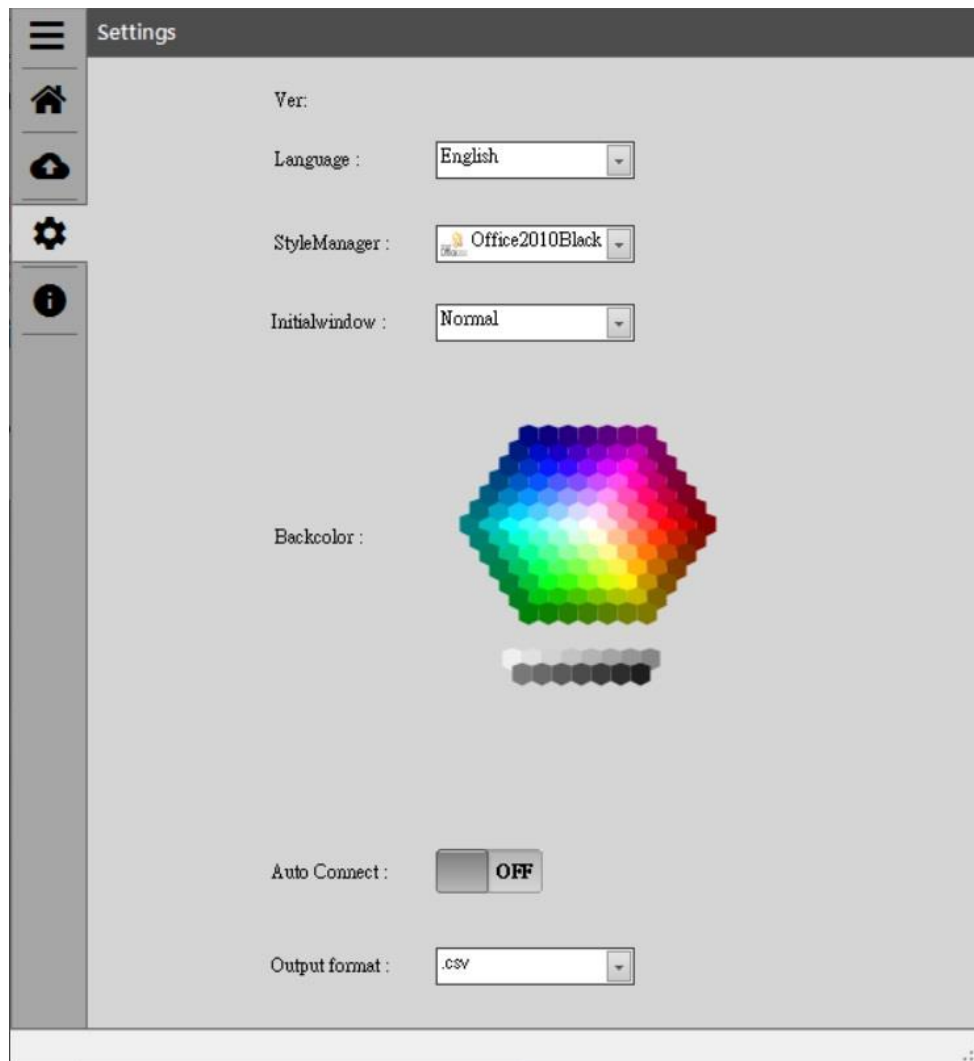
The screen image by remote monitoring.

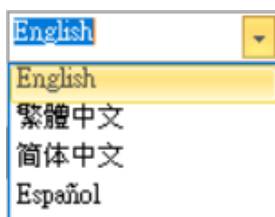
NOTE: Please contact with local distributors for the detail information.



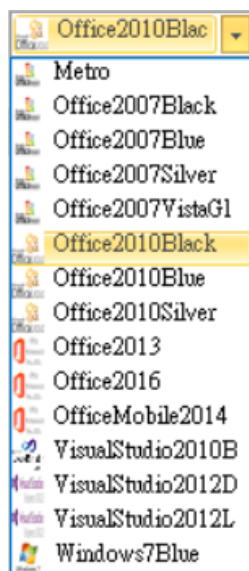
⑧ System Function Setup

Switch to  Settings page to operate system functions.

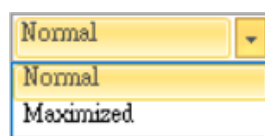




1. Language: three language options are available.




2. Style: system operating style can be changed.



3. Initialwindow: To set the initial windows setting.




4. Background color: system background color can be selected.

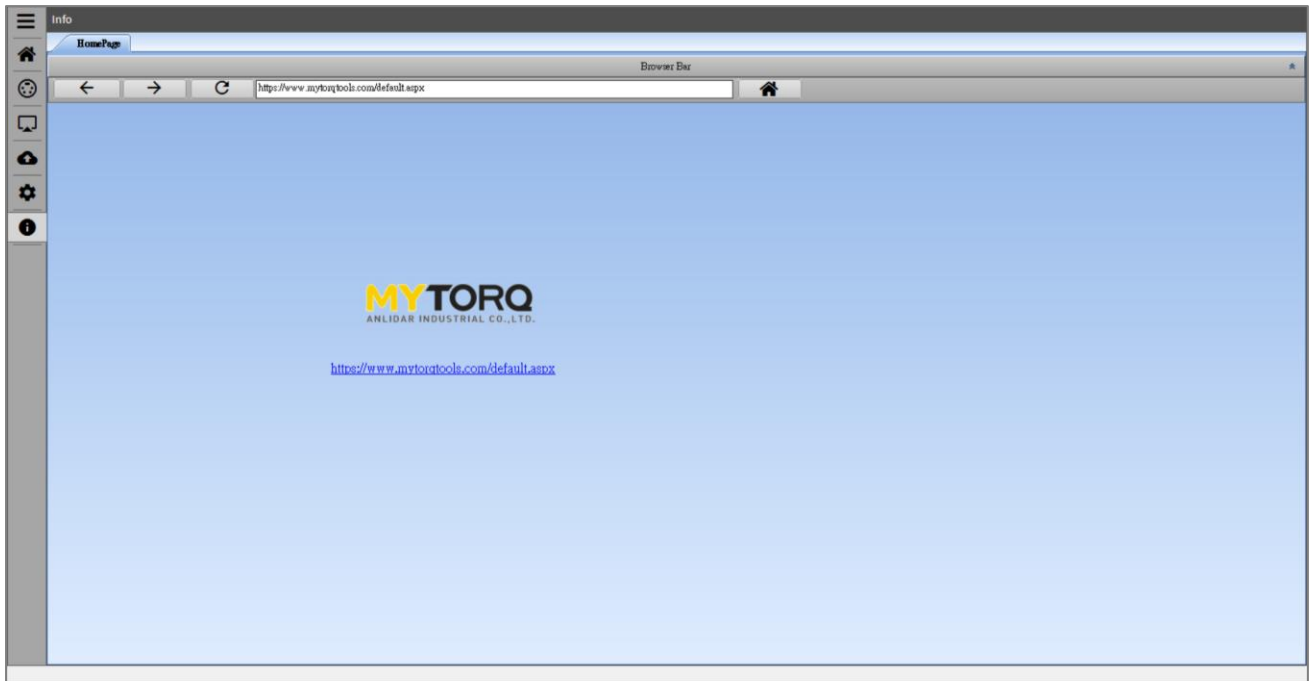
5. Auto connection: When switching  , the serial port (COM) will automatically connect to the device the next time you start the software.

6. Output format: Different formats for record storage can be select.

MYTORQ

⑨ Info Company Website

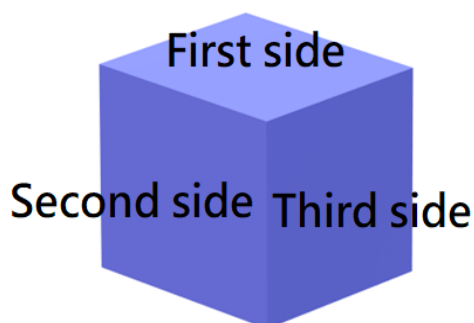
Switch to  Info page to browse official website.



MYTORQ**⑩ Example Description****NOTE:**

1. 1 Job (Job No.1 ~ Job No.20) = Sequence (Sequence *20)
2. 1 Sequence (Sequence No. 1 ~ No. 20) = Unit No. + offset
3. 1 Unit (Unit No.1~ No. 99) = Program No. + Tool No.
4. 1 Program (Program No.1 ~ No. 99) : 99 programs could be set
5. 1 Tool (Tool NO. 1 ~ Tool NO. 5) : Tool NO.1 ~ Tool No.5 could be selected.

When screws are fastened on 3 sides of a product, the condition is as follows:

**Job**

Fastened (Sequence)	Maximum count value	Condition (kgf.cm)	Tool
First Side (Sequence 1)	4 pcs	HQ 15, LQ 1	Tool 1
Second Side (Sequence 2)	3 pcs	HQ 20, LQ 5	Tool 2
Third Side (Sequence 3)	2 pcs	HQ 18, LQ 3	Tool 3

MYTORQ**Step 1:** Set the Unit 1 ~ Unit 3 condition

(refer to [“Save”](#) for setting up the parameter condition)

1. Set to Unit 1 when the first side is fastened

Program1 condition = maximum count as 4, maximum fastening torque (HQ) 15 kgf.cm, minimum fastening torque (LQ) 1 kgf.cm, and tool 1.

2. Set to Unit 2 when the second side is fastened

Program2 condition = maximum count as 3, maximum fastening torque (HQ) 20 kgf.cm, minimum fastening torque (LQ) 5 kgf.cm, and tool 2.

3. Set to Unit 3 when the third side is locked

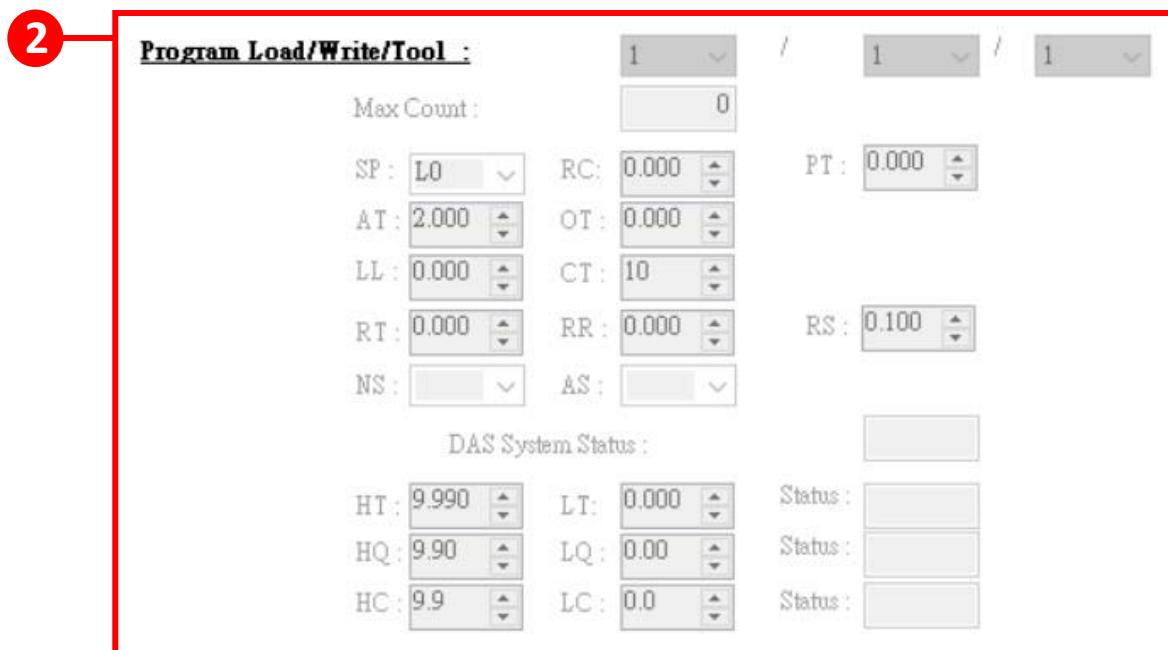
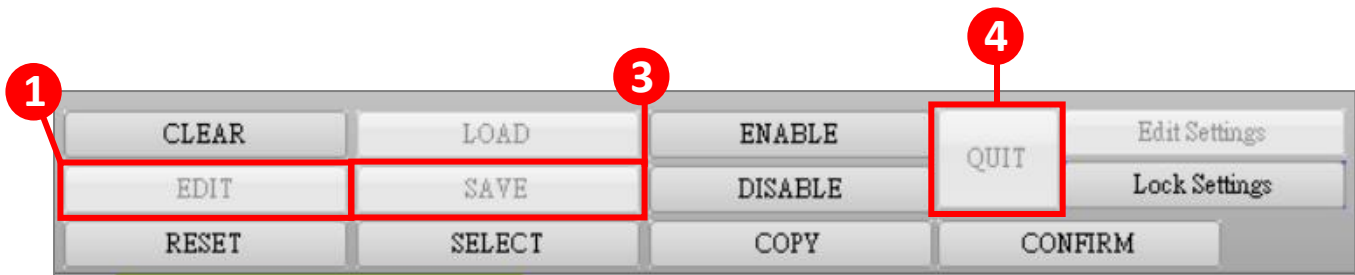
Program3 condition = maximum count as 2, maximum fastening torque (HQ) 18 kgf.cm, minimum fastening torque (LQ) 3 kgf.cm, and tool 3.

4. After complete setting parameters, press  to save data.

Press  to enter the “Controller and Job setup page”

MYTORQ

- Set condition parameter steps (Unit 1 ~ Unit 3 settings are the same):



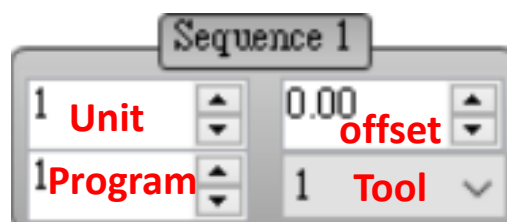
Job. No. :

1

Step 2: There is only one product 1 and three processes

Sequence Numbers :

3



Job. No. : 1

Sequence Numbers : 3

Sequence 1

1	0.00
1	1

Sequence 2

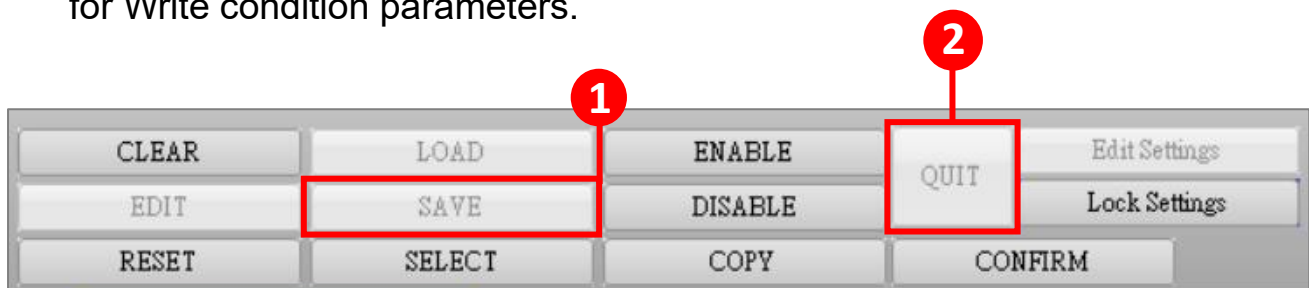
2	0.00
2	2

Sequence 3

3	0.00
3	3

1. Fasten the first side (Sequence 1) to set Unit 1, Program 1, Tool 1
2. Fasten the second side (Sequence 2) to set Unit 2, Program 2, Tool 2
3. Fasten the third side (Sequence 3) to set Unit 3, Program 3, Tool 3
4. After it is set from the first side Sequence 1 to the third side Sequence 3,

press  and then press  to complete the setup for Write condition parameters.





⑪ Statement

Reminder again, please follow the relevant regulations and the international practice of the Internet. Never do anything illegal or harm to the company in any illegal way. You may not use this service to engage in violations of other's rights or illegal activities: Please acknowledge you have ownership for all your photos and texts. Do not post or transmit any files that are defamatory, insulting, threatening, offensive, indecent, defamatory, false, in violation of public order or good customs or other unlawful words, pictures or files in any form, nor infringe on the reputation or privacy of others, business secrets, trademarks, copyrights, patents, other intellectual property rights and other rights, and other acts that are deemed improper.