

Pressroom Electronics, Inc.

Presscommander Touch Panel PC Remote Display

Configuration and Operations



Access Our Product Mix from your Smart Phone

<p>PressCommander</p> 		<p>SSM-10</p> 	
<p>PCS-05</p> 		<p>SSM-20</p> 	
<p>PCS-08</p> 		<p>1500SS</p> 	
<p>PCS-10</p> 		<p>The Ultimate</p> 	
<p>PCS-20</p> 		<p>BM-1600</p> 	
<p>PCS-4000</p> 		<p>PressCam 8</p> 	
<p>Model 3200SS</p> 		<p>PressCam 8 Junior</p> 	
<p>SSM-05</p> 		<p>Remote Die Box</p> 	
<p>SSM-08</p> 		<p>Pressroom Website</p>  <p>www.pressroomelectronics.com</p>	

**Presscommander Remote Touch Screen Setup and Operation
And
Production Monitoring (or Down-Time Monitoring)
Setup and Operation**

Pressroom Electronics, Inc.

Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

- The Touch Panel PC is 10.1" fully functional Windows 7 computer that is powered by 12vdc (3A) to 24vdc (1.5A).
- Not necessary, but you can add a mouse or keyboard via the 2 USB ports.
- You can use the Presscommander Offline Job programmer (goto <http://pressroomelectronicsupdates.com> user:level2 pass: 9742tri for videos) via either the USB or Serial port on the Touch Panel PC and the software already installed.
- Connection to the Presscommander and/or your network is via the Ethernet port, or wi-fi USB option
- When connected to your network, you can view other computers on your network and they can view you as "HMI000x-PC" on the network. Only the folder c:\pcslogs\ is available to anyone on the network using User Name: hmi719 and Password: hmi719
- Every time you open up Internet Explorer to connect to the Presscommander a new LOG file is created (in a spreadsheet format) and accumulates dates/times of press operations.
- Right Mouse Click: Touch and HOLD until a full circle appears around your finger, then release.


-
- To use the Touch Panel PC as a Remote Display for the Presscommander, the Presscommander must have the Ethernet option installed.
 - The Presscommander Ethernet option must be enabled via the Display Unit menu. Use the Key to put the Display unit in PROG mode. Push the "OPTIONS" button 5 times. Cursor over to the right side of the word "TCP" and press "ENTER"
 - You must find the Internet address of the Ethernet in your Presscommander. You can make this address permanent (recommended) or allow your network to control the address. Use the PCS_FINDER app on your Touch Panel PC Desktop to find this address.
 - Once you have the address, open up Internet Explorer and type in the address and TOUCH ENTER. NOTE: Drag the icon in the address box onto the Desktop (for a future shortcut).
 - The Presscommander Ethernet Remote Display is based on JAVA language. Internet Explorer will warn you when you try to connect to the Presscommander. Touch the CHECK BOX and Touch OK.
 - The following pages will explain the operate of the Remote Display (see also YouTube video. Search Presscommander)
 - **Your Presscommander Ethernet is preprogrammed with a fixed IP address of 169.254.2.x (where x is a value from 1 to 254). A Stand-Alone Java based Remote Display Program has been loaded on your Touch Panel PC. A shortcut for this Program is on the Desktop and will automatically link to the Presscommander it came with. But, you can still use a Browser to Remote to the Presscommander using its IP address**

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Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Fully functioning Windows 7 Industrial fanless multi-touch panel PC with 32GB Solid-State memory, USB, Ethernet, Optional Wi-Fi, Optional Wi-Fi bridge, Internet Explorer 10, Java, Open Office, Adobe Flash, and Adobe reader

You can connect to your company network, just like any other PC. You can see and be seen, just like any other PC (with proper setup)



The image shows a Windows 7 desktop environment with a blue background. The desktop features several icons: 'HM00903', 'OpenOffice Writer', 'OpenOffice Calc', 'pcs remote demo', 'pcs logs folder', 'PCS Files', 'Press:Comm...', 'Computer', 'Network', '115200_USB7', '115200.com', 'Remote_up...', 'pcs ip finder', and 'Recycle Bin'. The taskbar at the bottom shows the Start button, Internet Explorer, and system tray icons including the clock (3:10 PM, 4/30/2014). The center of the desktop displays the 'Pressroom Electronics' logo and the website 'www.pressroomelectronics.com'. Annotations with arrows point to specific icons and folders, providing instructions on their use.

Free OpenOffice version of Excel, called "Calc"

Link to your Presscommander Remote Desktop. (see Pages 5-8)

The Presscommander Offline Job Programmer (see Page 9)

Program to find the Internet Address of your Presscommander (see Pages 10 & 14)

Terminal program if a Firmware update is ever needed

Folder that contains the LOG files. (The .CSV files will open in Excel) (see Page 6)

Tap 1 time to bring up a full keyboard (if it doesn't automatically pop up)

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Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Note: Key on Presscommander must be in RUN position while at this Panel

Note: The LOCK ring and Fault Reset ring must be GREEN before changing most values

LOCK: Enter in 5 digit code to unlock. First 3 digits are the password you assigned at the PCS Display Unit, followed by a special 2 digit code. Example: if your password is 435, you would enter 43512 on the Remote Display for limited access, or enter 43563 for full access. If don't assign a password then enter 00012 or 00063

Touch a White Field & ENTER to change value

Touch a White Field & ENTER to Reset value

Red: Locked password protected. Touch Lock and enter 5 digit password

Green: Unlocked. Touch Lock & ENTER to relock

Black: Waiting for 5 digit code

Red: Fault. Touch button & ENTER to Reset (must be unlocked first)

Grn: No Fault

Touch this button 2 times to see the active FAULT screen

PCS Remote Display

Pressroom Electronics

Operator #: 0 Job #: 1 Job Name: [Field]

Strokes: 50 Parts: 50 /1

Batches: 0 Batch Size: 1000

Quality: 50000 Quantity Left: 49950

Press Status: SINGLE

Brake Monitor (mSec)

Last Stop: 221

Warn Set: 270

Fail Set: 350

Run Time 0000:00:28 PPL 0420

Down Time 0000:00:00 MPR 060

Standby Time 0000:00:21 Avail 99%

Good PR 06409 /hr Perf 176%

OEE 174%

POS. ANGLE 001° SPM 000 Shut-Height +01.145

Operator Downtime Reason Code

service@pressroomelectronics.com • www.pressroomelectronics.com

Logging started: 12/11/15 9:20:59 AM Log Entry # 1

PressCommander RSD

1 2 3

4 5 6

7 8 9

Lock 0 Reset Fault

ENTER Fault Reset

PAGE

PLS/DIE Tonn/Servo Other

V2.8; ...on Stat -> ...X, Write Drive: C

IP address connected to: 192.168.0.141

Touch to Navigate to other screens (note: the button descriptions change depending on the page you are on)

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Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Production & Downtime Monitor with Overall Equipment Effectiveness.

The User must calculate the PPT (Planned Production Time) for the either the Shift, the Job, or the Operator (in Minutes). PPT is the best case scenario production time in MINUTES.

Example: PPT = Shift 480min – normal breaks 30min – normal lunch 60min – maintenance 40min = 350min

The User must calculate the MPR (Maximum Production Rate) for the current Job. This is based on SPM of the Job, wear of the die, material quality. MPR is best case scenario for PARTS / MINUTE

Example: MPR = 100 parts/minute (when press is running)

Run Time: Increments when the Press is cycling in SINGLE or CONT modes (in Hours:Min:Seconds)

Down Time: Increments when either a Down Time Reason Code is active or a Fault has occurred.

Standby Time: Increments when the Press is simply idle.

Touching any timer will allow you to RESET them back to 0:0:0

Good PR: is the Production Rate of parts, based on values found in the Parts, Run, Down, and Standby timers.

Avail: Availability% is based on the Run, Down, and Standby timers vs PPT.

Perf: Performance% is based on the Good PR vs MPR

OEE: Overall Equipment Effectiveness is based on Avail and Perf together.

Operator Downtime Reason Code: Touch to Enter Downtime Reason for a list of Codes. Codes can be customized.

The screenshot displays the 'PressCommander RSD' interface with the following data:

Operator #: 0	Job #: 1	Job Name: ----
Strokes: 50	Parts: 50	/1
Batches: 0	Batch Size: 1000	
Quality: 50000	Quantity Left: 49950	
Press Status: SINGLE		

Brake Monitor (mSec)	Run Time: 0000:00:28	PPT: 0420
Last Stop: 221	Down Time: 0000:00:00	MPR: 060
Warn Set: 270	Standby Time: 0000:00:21	Avail: 99%
Fail Set: 350	Good PR: 06409 /hr	Perf: 176%
		OEE: 174%

POS.	ANGLE: 001°	SPM: 000	Shut-Height: +01.145
------	-------------	----------	----------------------

Operator Downtime Reason Code: [Red Button]

Navigation: [1-9], [Lock], [0], [Reset Fault], [ENTER], [PLS/DIE], [Tonn/Servo], [Other]

Footer: service@pressroomelectronics.com • www.pressroomelectronics.com
 V2.8. Con Stat -> RX, Write Drive: C
 Logging started: 12/11/15 9:20:59 AM Log Entry # 1 IP address connected to: 192.168.0.141

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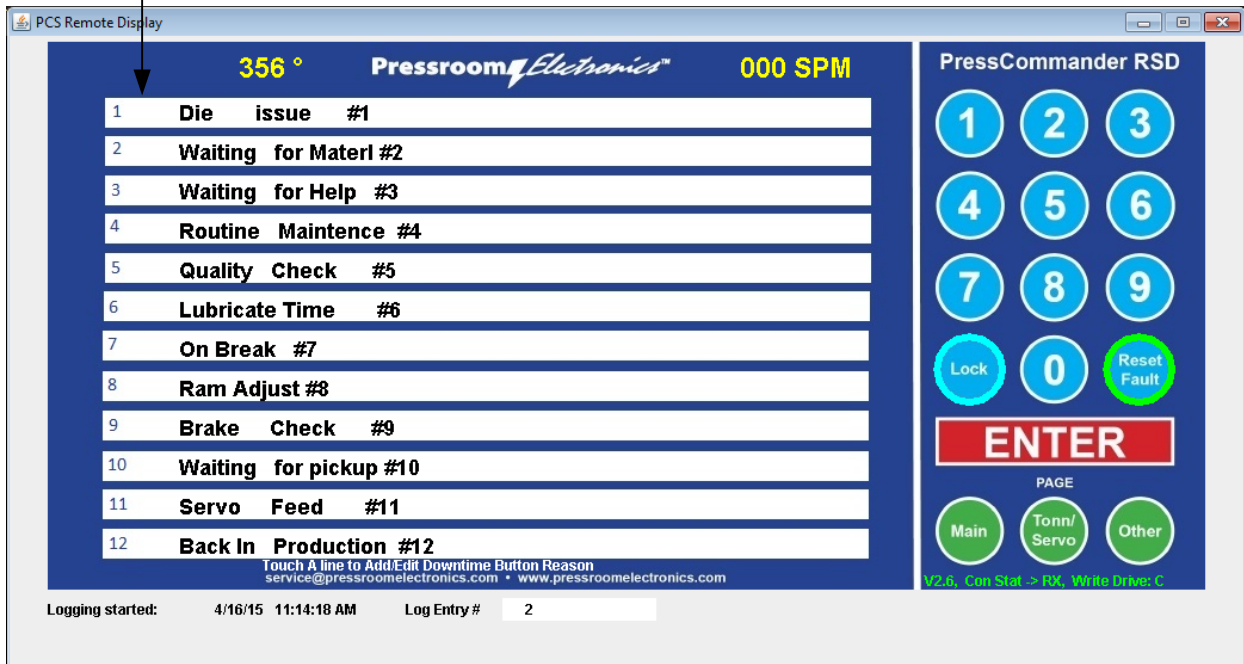
Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Production & Downtime Monitor with Overall Equipment Effectiveness.

The Operator can Touch any Red Button to select the current Down Time Reason. Once a Reason Code is touched, you will go back to the MAIN screen and the STATUS line will reflect the Code. The Last Red Button will release the Press back into Production, or Cycling the Press with the KEY in RUN mode. Cycling the Press with the KEY in PROG mode will not remove the Reason Code.



This list can be customized by Touching the Square Green button, while the Remote is UNLOCKED. A virtual keyboard will appear and you can alter 1 – 11 (12 cannot be altered)



Pressroom Electronics, Inc. Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Double Tapping the pcslogs folder icon on the desktop brings you here.

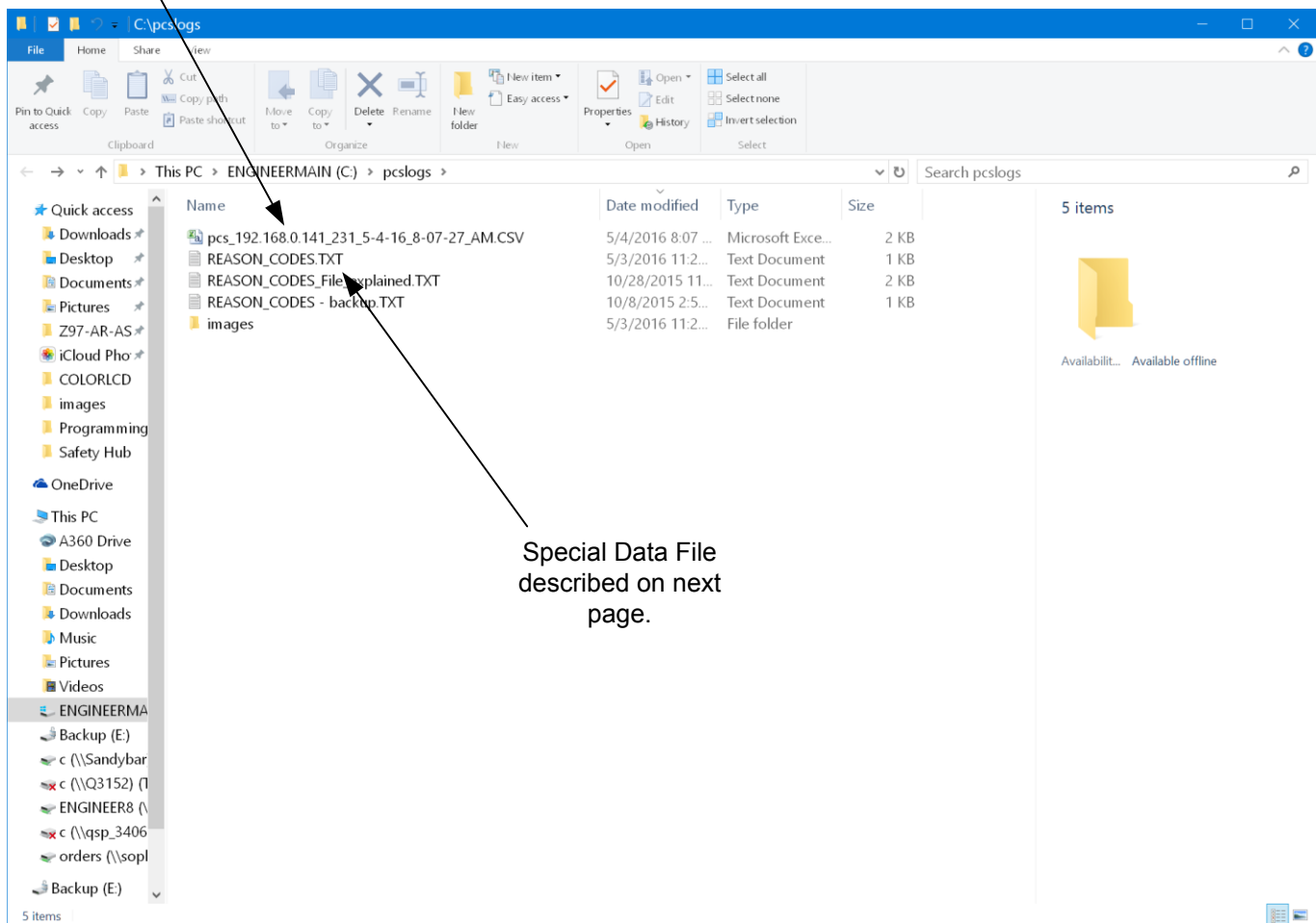
Do not attempt to open any of these files while the Internet Connection to the Presscommander is open and running.

The best way to view the file with an OPEN connection, is to make a copy of the file

COPY/PASTE on a Touch Screen:

Double Tap the .CSV file to open the file in OpenOffice Calc or Excel

HOLD your finder on the File (until a full circle appears around your finger) and the pop up menu appears. Select either COPY or PASTE



Special Data File described on next page.

Like any Windows PC, you can setup Windows to allow Outside access to this folder. See your IT person to help set this up for you.

OR

You can Map a Network Hard Drive (NAS) and have the Logs directly written to your Mapped Drive instead of locally on the Touch Screen Drive. The next page describes this.

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Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

“REASON_CODES.TXT” file contains all your downtime reason codes and various other information described below:

Line 1: Downtime reason code #1

.
.

Line 24: Last reason Code #24

Line 25: The Drive Letter to locate the LOG files:

C indicates the files will be written to C:\pcslogs

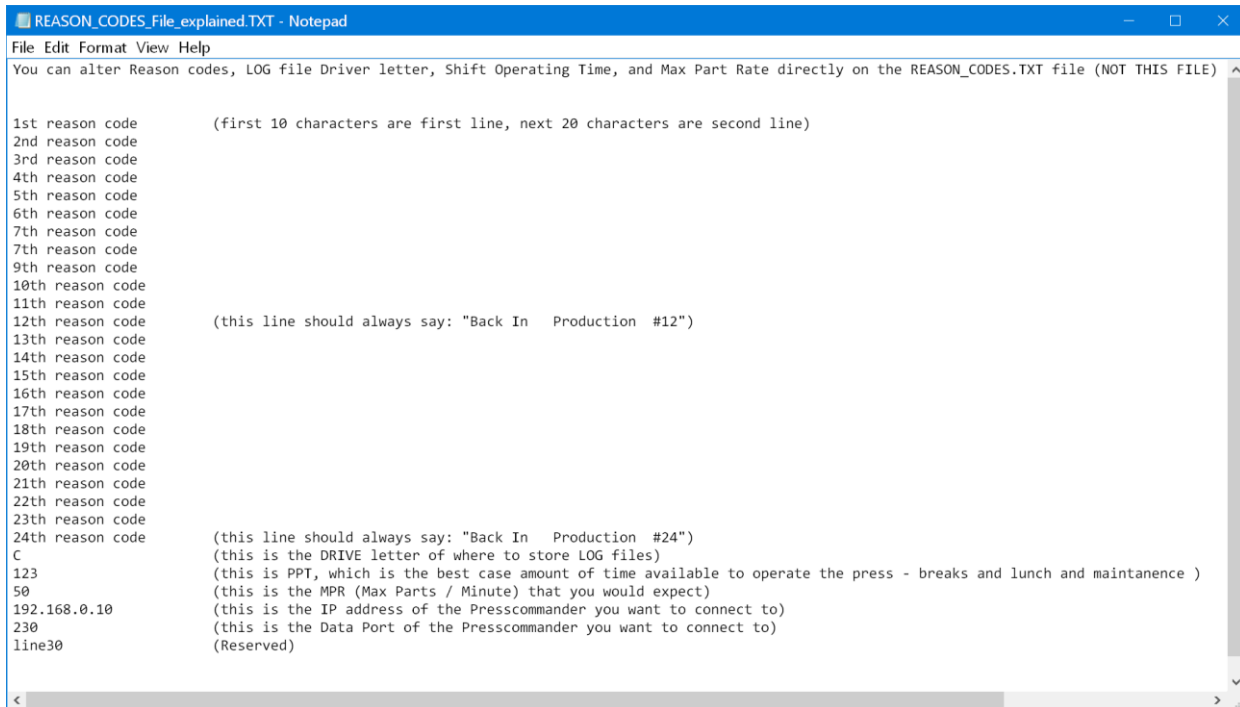
Z indicates the log files will be written to Z:\pcslogs

Line 26: PPT value for production monitoring

Line 27: MPR value for production monitoring

Line 28: IP address of your PressCommander

Line 29: IP Data Port# of your PressCommander



```
REASON_CODES_File_explained.TXT - Notepad
File Edit Format View Help
You can alter Reason codes, LOG file Driver letter, Shift Operating Time, and Max Part Rate directly on the REASON_CODES.TXT file (NOT THIS FILE)

1st reason code      (first 10 characters are first line, next 20 characters are second line)
2nd reason code
3rd reason code
4th reason code
5th reason code
6th reason code
7th reason code
9th reason code
10th reason code
11th reason code
12th reason code    (this line should always say: "Back In  Production #12")
13th reason code
14th reason code
15th reason code
16th reason code
17th reason code
18th reason code
19th reason code
20th reason code
21th reason code
22th reason code
23th reason code
24th reason code    (this line should always say: "Back In  Production #24")
C                   (this is the DRIVE letter of where to store LOG files)
123                 (this is PPT, which is the best case amount of time available to operate the press - breaks and lunch and maintenance )
50                  (this is the MPR (Max Parts / Minute) that you would expect)
192.168.0.10       (this is the IP address of the Presscommander you want to connect to)
230                 (this is the Data Port of the Presscommander you want to connect to)
line30             (Reserved)
```

Only Lines 25, 28,29 need to be directly modified by text editor. The other lines are modified from within the Remote Touch Screen program

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Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

After making a copy of the .CSV file and then Double Tapping on the file copy, you will open up "Calc" automatically and this is something like what you will see

The size of the spreadsheet depends on how many Operator#/Job# changes are made and how many faults are recorded

The screenshot shows a Microsoft Excel spreadsheet with the following data:

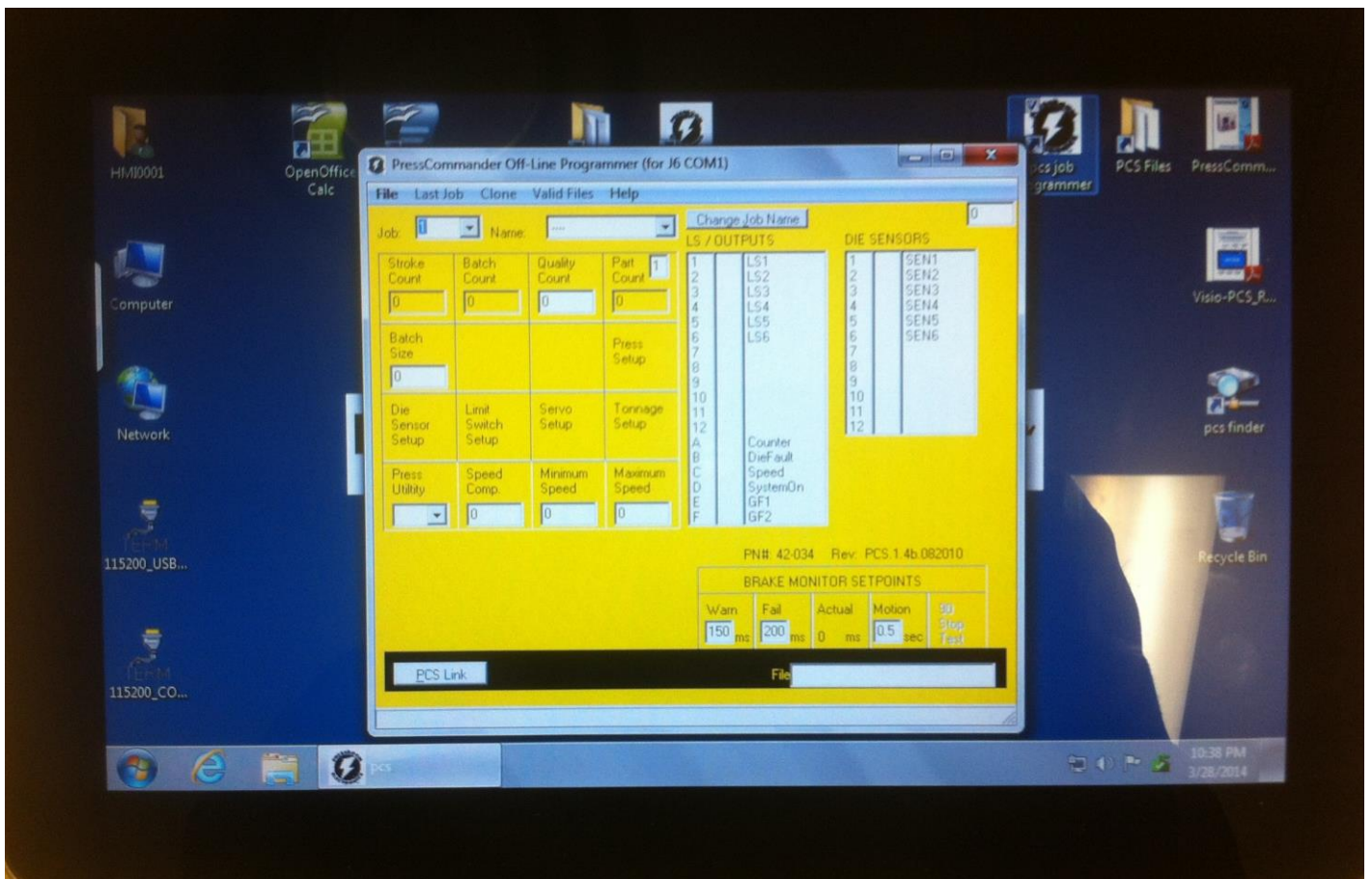
1	Logging Started: 4/25/14 2:38:38 PM																												
2	MESSAGES and FAULTS:																												
3	Operator Change																												
4	4/25/2014 14:38 4/25/14 2:38 4/25/14 2:38 4/25/14 2:38 4/25/14 2:38																												
11	Entry Log	DATE of	TIME of	Operator#	Job#	Job Name	Stroke#	Part#	Batch#	Batch Size	Batch	Running T	Down Tim	Down Time	Stroke#	Part#	Batch#	Running T	Down Tim	Down Time	Tonn Low	Tonn Low	Tonn Low	Tonn Low	Tonn High	Tonn High	Tonn High	Tonn High	
12	Reason	Entry	Entry	this->new	this->new	this->new	Total	Total	Total	Current	How far	Total	FAULT Tot	IDLE Total	by this Oj	by this Oj	by this Oj	by this Oj	by this Oj	FAULT by 1	IDLE by th	LR	RR	LF	RF	LR	RR	LF	RF
16	Initial Log	4/25/2014	2:38:40 PM	0	2	----	90	0	0	0	0	0:00:49	0:00:00	0:00:00	0	0	0	0:00:00	0:00:00	0:00:00	0	0	0	0	0	0	0	0	0
17	Unlock some Fields	4/25/2014	2:38:47 PM	0	2	----	90	0	0	0	0	0:00:49	0:00:00	0:00:06	0	0	0	0:00:00	0:00:00	0:00:06	0	0	0	0	0	0	0	0	
18	Op# Change	4/25/2014	2:38:50 PM	0->10	2	----	90	0	0	0	0	0:00:49	0:00:00	0:00:09	0	0	0	0:00:00	0:00:00	0:00:03	0	0	0	0	0	0	0	0	
19	job# Change Req	4/25/2014	2:38:54 PM	10	2	----	90	0	0	0	0	0:00:49	0:00:00	0:00:12	0	0	0	0:00:00	0:00:00	0:00:03	0	0	0	0	0	0	0	0	
20	New job#	4/25/2014	2:38:58 PM	10	2->1	----	90	3	0	0	0	0:00:49	0:00:00	0:00:16	0	0	0	0:00:00	0:00:00	0:00:04	0	0	0	0	0	0	0	0	
24	Current	4/25/2014	2:39:02 PM	10	1	----	90	3	0	0	0	0:00:49	0:00:00	0:00:20	0	0	0	0:00:00	0:00:00	0:00:04	0	0	0	0	0	0	0	0	

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Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

The Presscommander OFFLINE Job(s) Programmer connects to the Presscommander via either USB or Serial COM port.
Go into the PCS FILES folder for documentation

This Job Programmer allows for backup storage of the Jobs that are contained in the Presscommander (PCS) DISPLAY UNIT.

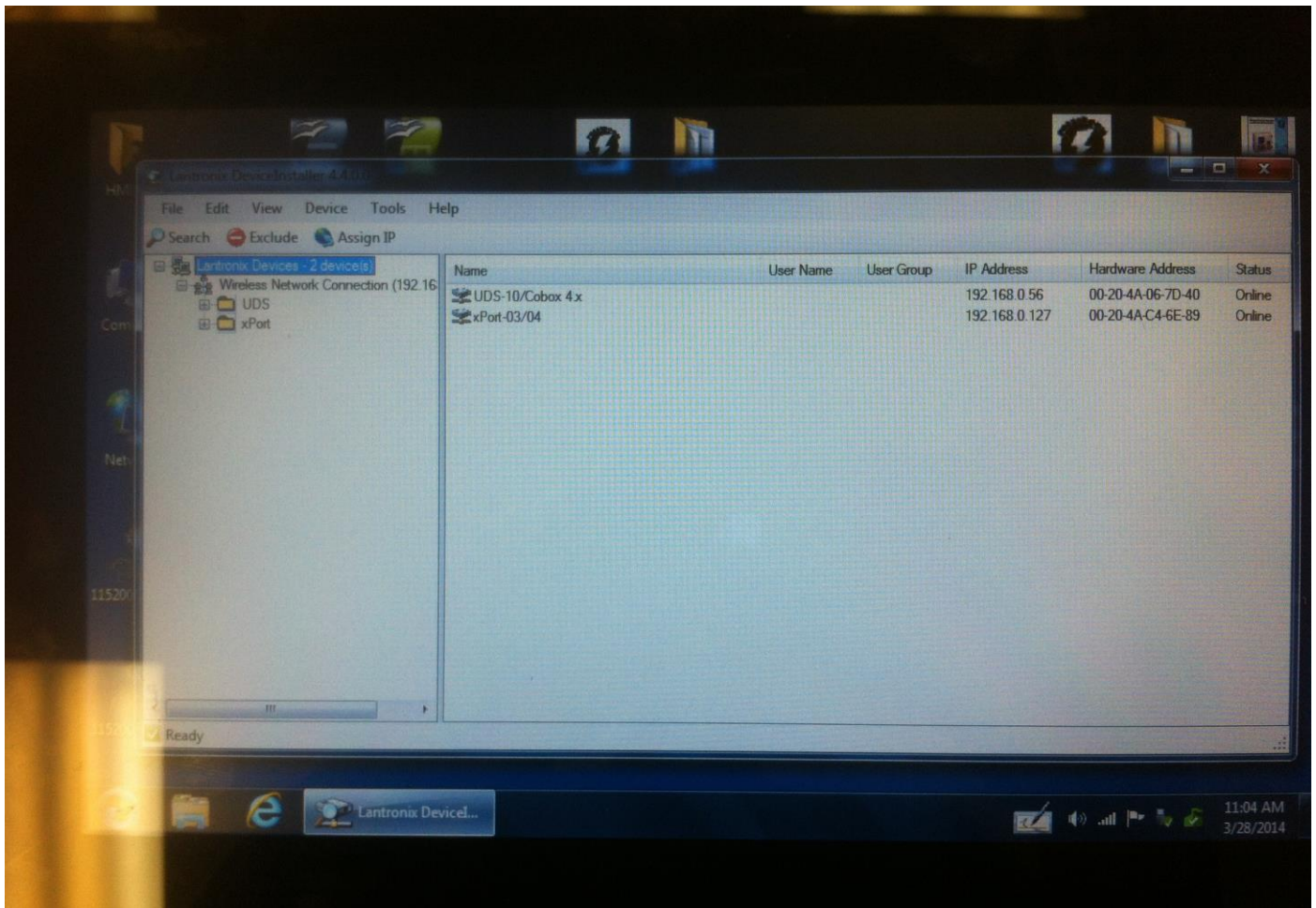


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Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

The Presscommander (PCS) finder searches your network to find the Internet address (IP) of all your Presscommanders that are connected to the same network.

It is possible to SET an IP address permanently if you don't have a DHCP server on the network

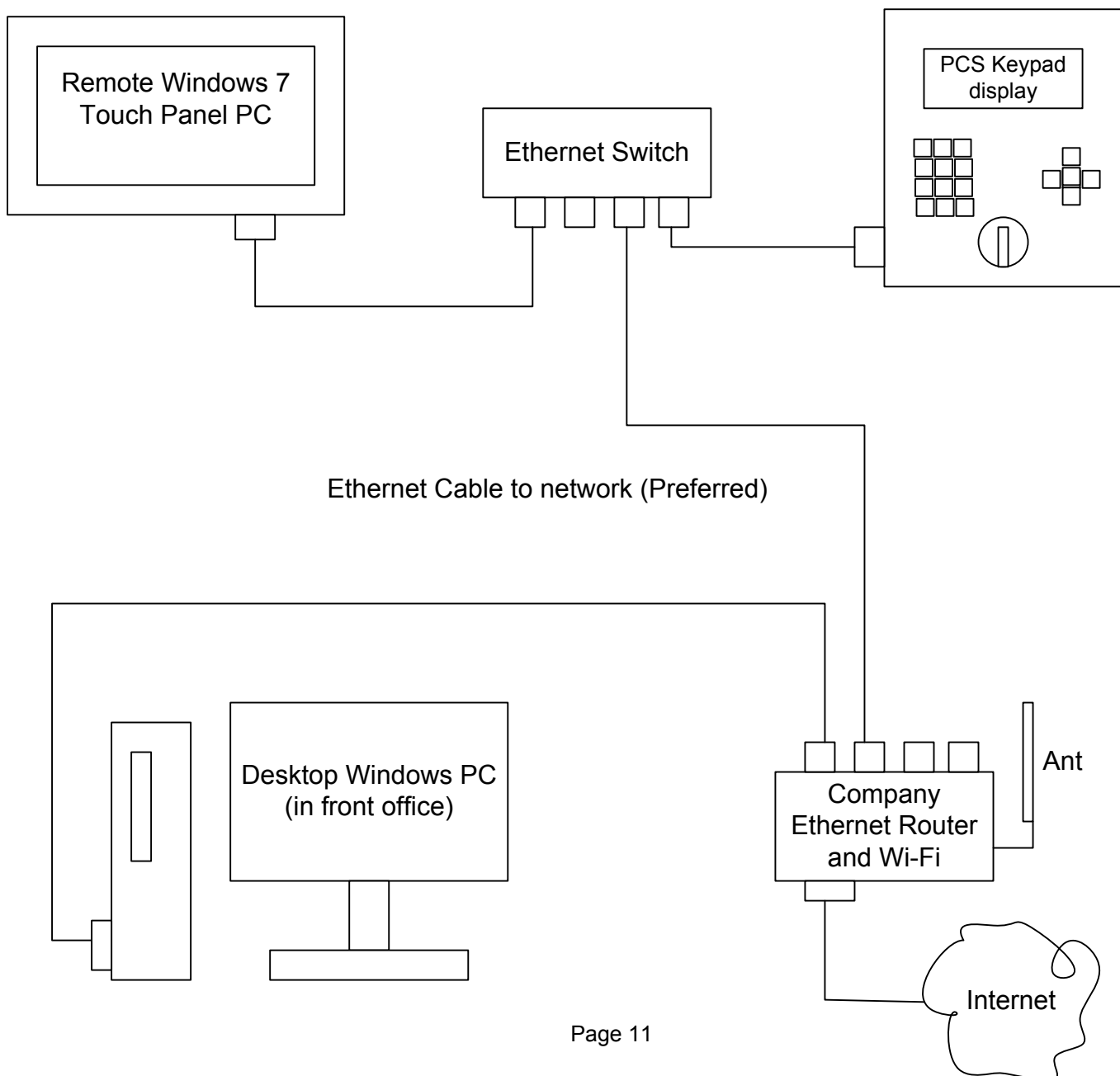


Pressroom Electronics, Inc.
Presscommander Ethernet/Wi-Fi Remote operator station and Down-Time Monitor

Please note that some knowledge of Ethernet and Router configuration is required.

There are many possible configurations of the Presscommander with the Remote Touch Panel PC Display.

Below is the **preferred configuration**: Hard wired Ethernet cable between all devices with inexpensive Ethernet Switches and routers. Access to the PCS can be obtained from the Touch Panel, Office PC, and over the Internet

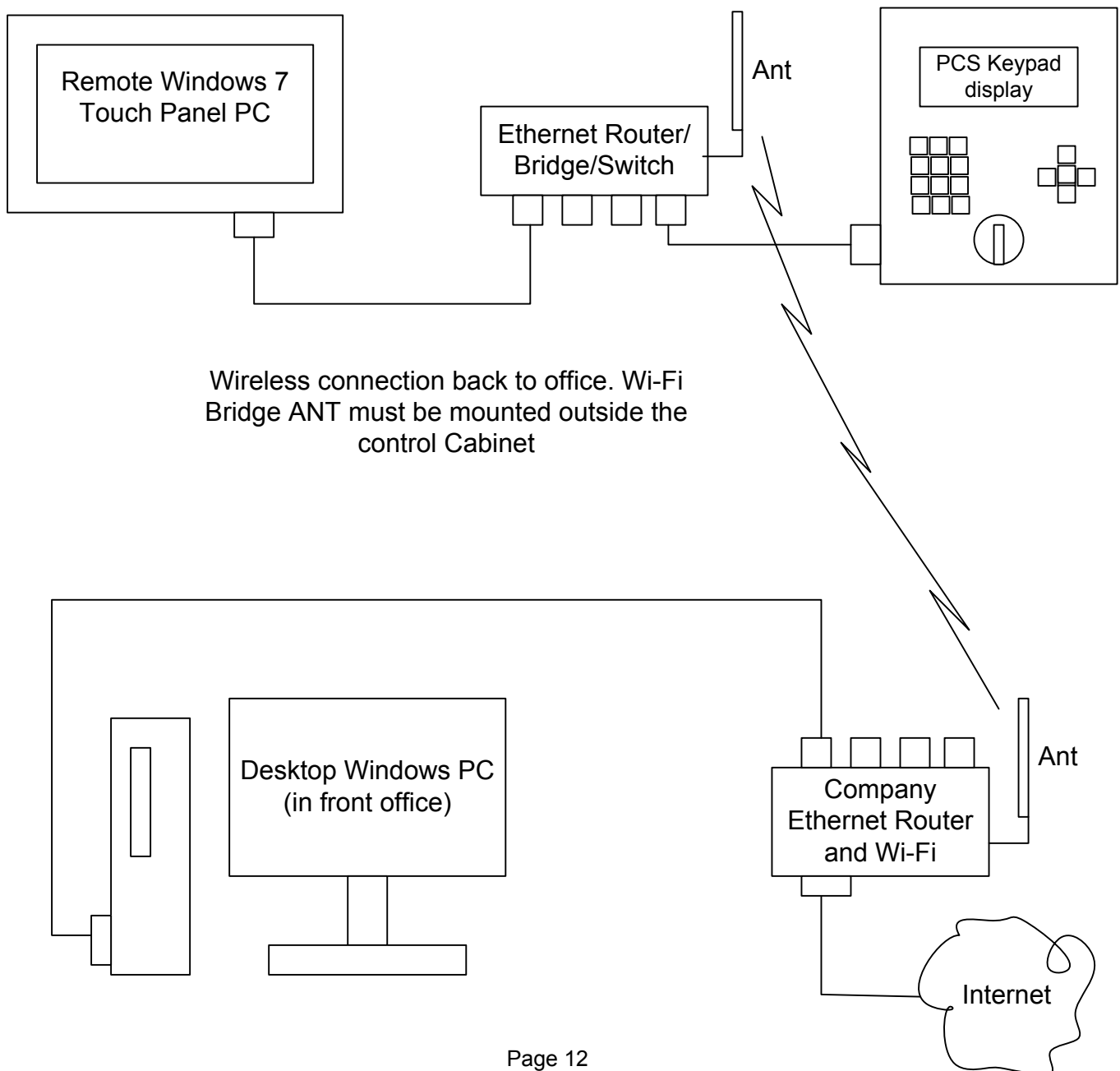


Pressroom Electronics, Inc.
Presscommander Ethernet/WI-FI Remote operator station and Down-Time Monitor

Please note that some knowledge of Ethernet and Router configuration is required.

There are many possible configurations of the Presscommander with the Remote Touch Panel PC Display.

Below is much less preferred configuration: Hard wired Ethernet cable between the Touch PC and PCS, but Wi-Fi back to the front office. Wi-Fi performance and connection issues.

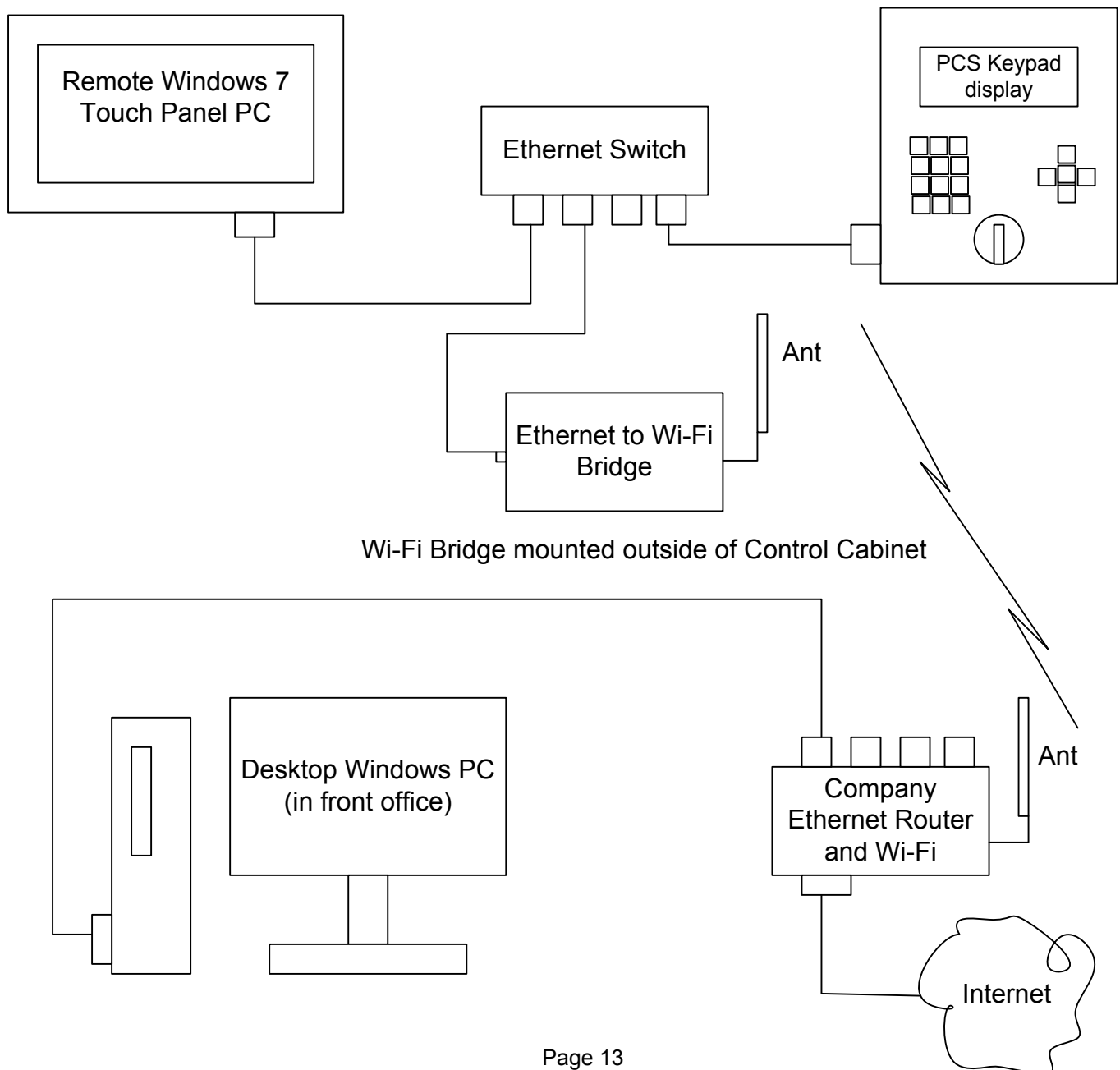


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Presscommander Ethernet/Wi-Fi Remote operator station and Down-Time Monitor

Connecting the Presscommander to your Network

- A) Touch Panel PC Remote Display and Ethernet Enabled Presscommander
- B) Ethernet Enabled Presscommander ONLY

Wired Setup (standard hardware):

Simply connect your networks CAT 5e Ethernet Cable to: an open port on the Ethernet Switch provided with option A) or the Ethernet Jack on the side of the Presscommander Display Unit with option B)

Wi-Fi Bridge Setup (this is OPTIONAL hardware):

Follow the instructions that come with the Bridge before plugging it into anything.

You will need to plug the Bridge into your laptop to set it up to automatically connect to your networks Wi-Fi. This requires you to know the SSID of the Wi-Fi network and its password.

You will then need to pick a location to install the Bridge device. Avoid high power or high voltage devices (i.e. motors, starters, drives, high voltage lines).

Connect the Wi-Fi Bridge Ethernet jack to any open port on the Ethernet Switch with option A) with Cat5e cable, or the Ethernet Jack on the side of the Presscommander Display Unit with option B)

Presscommander Ethernet IP Address:

NO NETWORK: If you have option A) Touch Panel PC with the Presscommander, but do not connect it to your network, your Presscommander will be assigned an IP automatically (i.e. 169.xxx.xxx.xxx). You will not be able to connect to the Internet itself, but the Touch Panel PC will be able to Remote Display the Presscommander.

NETWORK: Whether you have Option A) or B), once connected to your Network, your Networks Router will supply an Internet IP address to your Presscommander.

Finding the Presscommander Ethernet IP Address:

On the Touch Panel PC Click to Run “tcp ip finder” app from the Desktop

On a laptop PC you must download and install DeviceInstaller.exe from Lantronix

Either program will allow you to find the IP address of the Presscommander based on the MAC ID. The MAC ID is written on a label on the backside of the Presscommander Display unit and on the Ethernet Jack of the Presscommander itself (with aluminum cover removed).

You can keep the IP address from changing by going to your network router and assigning the IP address as STATIC

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WARNING

The entire machine safety system must be tested at the start of every shift. Machine testing should include: (1) proper machine operation and stopping capability; and (2) verification of proper installation and settings of all point of operation guards and devices before the operation is released for production.

CHANGE IN SPECIFICATIONS

Product specifications and accessories may be changed at any time based on improvements and other reasons. It is our practice to change part numbers when published ratings or features are changed, or when significant construction changes are made. However, some specifications of the Product may be changed without any notice. When in doubt, special part numbers may be reassigned to fix or establish key specifications for your application. Please consult the factory.

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