






Total-Trak™

PROGRAMMABLE LOGIC CONTROLLER FRONT-END


A Fully Integrated Graphical User Interface
HMI (Human Machine Interface)

- 
- Single Recipe Storage for the entire machine
 - Easy backup of part files on True-Trak 2020™ Network Data Archiver
 - Quick and easy recovery in the event of hard disk drive failure
 - Shot end parameter data and PLC process parameter data in one combined database

- 
- Security levels by operator name
 - Logging of set point changes by security, name, time and date
 - Display of alarms for quick trouble shooting
 - I/O Diagnostics
 - Machine sequence status
 - Setup of core sequences, timers, ejector, and auxiliary devices
 - Set-points and values for the machine
 - Proportional Die Speed and pressure control
 - Tie Bar Strain Gage Monitoring and Display
 - Ladder logic display is optional



Additional set-points and displays can be added as for your application. The Allen Bradley SLC 500 and PLC 5 family of sequential controls are supported. And the latest Allen Bradley controls will be included in the array of sequential controls that can be integrated.



Your existing HMI programs provided by your machine builder or re-manufacturer can be replaced, providing you with the service, support, and on-going development that is the hallmark of Visi-Trak products and systems.

Call us today to discuss your application.

Menu



Exit



Die Set-Points



Shot Profile



Process Values



Auxiliary Equipment



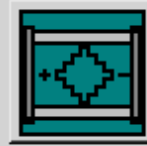
Help



Cores



Part Setup



Tonnage



Inputs



Alarm



Eject Set-Points



Shot Set-Points



Image Viewer



Outputs



Set-Point Log



Power Gate



Analog




Security

Icon Based Menus

ProcessValues File Monitor TotalTrak Help

Current Part: 2/8/2007 3:53:58 PM



Cycle Counters	Setpt.	Actual	
Shift Count	<input type="text" value="1500"/>	<input type="text" value="199"/>	<input type="button" value="Reset"/>
Part Count	<input type="text" value="10000"/>	<input type="text" value="2002"/>	<input type="button" value="Reset"/>

Cycle Timers	Actual	Cycle-1	Cycle-2	Cycle-3	Cycle-4
Total Cycle	<input type="text" value="3276.7"/>	<input type="text" value="50.0"/>	<input type="text" value="50.0"/>	<input type="text" value="51.0"/>	<input type="text" value="50.0"/>
Die Close Fast	<input type="text" value="3276.7"/>	<input type="text" value="4.0"/>	<input type="text" value="3.0"/>	<input type="text" value="4.0"/>	<input type="text" value="3.0"/>
Die Close Slow	<input type="text" value="3276.7"/>	<input type="text" value="7.0"/>	<input type="text" value="6.0"/>	<input type="text" value="7.0"/>	<input type="text" value="7.0"/>
Die Locking	<input type="text" value="3276.7"/>	<input type="text" value="2.0"/>	<input type="text" value="2.0"/>	<input type="text" value="2.0"/>	<input type="text" value="2.0"/>
Shot Sequence	<input type="text" value="3276.7"/>	<input type="text" value="5.0"/>	<input type="text" value="6.0"/>	<input type="text" value="5.0"/>	<input type="text" value="6.0"/>
Part Curing	<input type="text" value="3276.7"/>	<input type="text" value="13.0"/>	<input type="text" value="13.0"/>	<input type="text" value="13.0"/>	<input type="text" value="13.0"/>
Die Open Cushion	<input type="text" value="3276.7"/>	<input type="text" value="3.0"/>	<input type="text" value="3.0"/>	<input type="text" value="3.0"/>	<input type="text" value="3.0"/>
Die Open Fast	<input type="text" value="3276.7"/>	<input type="text" value="5.0"/>	<input type="text" value="5.0"/>	<input type="text" value="5.0"/>	<input type="text" value="5.0"/>
Die Open Slow	<input type="text" value="3276.7"/>	<input type="text" value="2.0"/>	<input type="text" value="2.0"/>	<input type="text" value="2.0"/>	<input type="text" value="2.0"/>
Part Removal	<input type="text" value="3276.7"/>	<input type="text" value="9.0"/>	<input type="text" value="10.0"/>	<input type="text" value="10.0"/>	<input type="text" value="9.0"/>

Tonnage	Alarm	Actual	Cycle-1	Cycle-2	Cycle-3
Upper Operators Tie Bar	<input type="text" value="230"/>	<input type="text" value="225"/>	<input type="text" value="225"/>	<input type="text" value="225"/>	<input type="text" value="225"/>
Lower Operators Tie Bar	<input type="text" value="230"/>	<input type="text" value="226"/>	<input type="text" value="226"/>	<input type="text" value="226"/>	<input type="text" value="226"/>
Upper Helpers Tie Bar	<input type="text" value="230"/>	<input type="text" value="225"/>	<input type="text" value="225"/>	<input type="text" value="225"/>	<input type="text" value="225"/>
Lower Helpers Tie Bar	<input type="text" value="230"/>	<input type="text" value="227"/>	<input type="text" value="227"/>	<input type="text" value="227"/>	<input type="text" value="227"/>
Unbalance Alarm	<input type="text" value="15"/>				
Total Tonnage	<input type="text" value="920"/>	<input type="text" value="903"/>	<input type="text" value="903"/>	<input type="text" value="903"/>	<input type="text" value="903"/>
Shot Ready					

Ejector Zone 1	Ejector Zone 2	Ejector Zone 3	Ejector Zone 4	Cover Zone 1	Cover Zone 2	Cover Zone 3	Cover Zone 4
Actual Temperature							
<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="1099"/>	<input type="text" value="1099"/>	<input type="text" value="1099"/>
High Temperature Setpoints							
<input type="text" value="1200"/>	<input type="text" value="1200"/>	<input type="text" value="1200"/>	<input type="text" value="1200"/>	<input type="text" value="1200"/>	<input type="text" value="1200"/>	<input type="text" value="1200"/>	<input type="text" value="1200"/>
Low Temperature Setpoints							
<input type="text" value="900"/>	<input type="text" value="900"/>	<input type="text" value="900"/>	<input type="text" value="900"/>	<input type="text" value="900"/>	<input type="text" value="900"/>	<input type="text" value="900"/>	<input type="text" value="900"/>

2/8/2007 3:53:51 PM Gate Not Closed!!!!

Processed Values Display:

PLC parameter data to integrated with shot monitoring related parameter data

Core Selection And Status

File Monitor TotalTrak Help

Current Part: Die3983

3/8/2007 12:58:54 PM



Core Selection

Sequence Select Sequence D

Core Status

Movable Core 1	Movable Core 1	Set Before Close Pull Before Open
Movable Core 1 Retract		
Fixed Core 1 Forward	Fixed Core 1	Set After Close Pull Before Open
Fixed Core 1 Retract		
Movable Core 2	Movable Core 2	Set Before Close Pull Before Open
Movable Core 2 Retract		
Fixed Core 2 Forward	Fixed Core 2	Set After Close During Open
Fixed Core 2 Retract		

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Core Sequence Select Button for standard core sequences

VTWQuickSetup

File Monitor TotalTrak Help

Current Part:

2/8/2007 3:49:52 PM



Die Actual Position (in.)

Die Close Positions		Die Open Positions		Die Velocities (%)		Pressure(PSI)	
Die Full Open	<input type="text" value="62.00"/>	Die Open Cushion	<input type="text" value="3.25"/>	Close Fast	<input type="text" value="100.0"/>	Die Accumulator	<input type="text" value="1549"/> <input type="text" value="0"/>
Die Close Slow	<input type="text" value="10.00"/>	Die Open Core	<input type="text" value="31.51"/>	Close Slow	<input type="text" value="25.0"/>	Die Protection	<input type="text" value="251"/> <input type="text" value="0"/>
Die Close Touch	<input type="text" value="0.25"/>	Mid Die Stop	<input type="text" value="38.25"/>	Open Slow	<input type="text" value="17.0"/>	Shot Accumulator	<input type="text" value="1749"/> <input type="text" value="0"/>
Die Locked	<input type="text"/>	Die Open Eject	<input type="text" value="47.10"/>	Open Fast	<input type="text" value="75.1"/>	Intensifier Accum.	<input type="text" value="1701"/> <input type="text" value="0"/>
		Die Open Slow	<input type="text" value="50.00"/>	Hand (Inch)	<input type="text" value="21.2"/>		

Timer/Counter	Setpt.	Actual
Die Locked Timer	<input type="text" value="0.21"/>	<input type="text" value="0.00"/>
Cycle Alarm Timer	<input type="text" value="37.11"/>	<input type="text" value="0.00"/>
Ejector Fwd Dwell	<input type="text" value="3.00"/>	<input type="text" value="0.00"/>
Lube Duration	<input type="text" value="6.00"/>	<input type="text" value="0.00"/>
Lube Cycle Count	<input type="text" value="9"/>	<input type="text" value="0"/>
Die Open Time	<input type="text" value="5.25"/>	<input type="text" value="0.00"/>
Tip Lube Count	<input type="text" value="6"/>	<input type="text" value="0"/>
Tip Lube Duration	<input type="text" value="1.00"/>	<input type="text" value="0.00"/>

Eject Actual Pos.(in.)

Eject Forward	<input type="text" value="6.00"/>
Eject Retract	<input type="text" value="1.33"/>
Eject Fwd. Velocity	<input type="text" value="70.1"/>
Eject Ret. Velocity	<input type="text" value="66.6"/>
Eject Fwd. Pressure	<input type="text" value="333"/>
Eject Ret. Pressure	<input type="text" value="450"/>


Auto. Eject

Forward Dwell

2/8/2007 2:26:29 PM Gate Not Closed!!!!

Visi-Trak Worldwide Quick Setup Screen

AlarmSummary File Monitor TotalTrak Help

Current Part:  2/8/2007 3:50:53 PM

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2/8/2007 2:26:29 PM Gate Not Closed!!!!
2/8/2007 2:26:29 PM Ejector Not Retracted!!!
2/8/2007 1:45:14 PM Gate Not Closed!!!!
2/8/2007 1:45:14 PM Ejector Not Retracted!!!
2/8/2007 1:36:45 PM Gate Not Closed!!!!
2/8/2007 1:36:45 PM Ejector Not Retracted!!!
2/8/2007 1:19:13 PM Gate Not Closed!!!!
2/8/2007 1:19:13 PM Ejector Not Retracted!!!
2/8/2007 1:01:23 PM Gate Not Closed!!!!
2/8/2007 1:01:23 PM Ejector Not Retracted!!!
2/8/2007 1:00:38 PM Gate Not Closed!!!!
2/8/2007 1:00:38 PM Ejector Not Retracted!!!
2/8/2007 10:59:43 AM Gate Not Closed!!!!
2/8/2007 10:59:43 AM Ejector Not Retracted!!!
2/8/2007 10:52:19 AM Gate Not Closed!!!!
2/8/2007 10:52:19 AM Ejector Not Retracted!!!
2/8/2007 10:51:19 AM Gate Not Closed!!!!
2/8/2007 10:51:19 AM Ejector Not Retracted!!!
2/8/2007 8:07:22 AM Gate Not Closed!!!!
2/8/2007 8:07:22 AM Ejector Not Retracted!!!
2/8/2007 7:55:34 AM Gate Not Closed!!!!
2/8/2007 7:55:34 AM Ejector Not Retracted!!!
2/8/2007 7:54:22 AM Gate Not Closed!!!!
2/8/2007 7:54:22 AM Ejector Not Retracted!!!
2/6/2007 4:25:30 PM Gate Not Closed!!!!
2/6/2007 4:25:30 PM Ejector Not Retracted!!!
2/6/2007 4:11:26 PM Gate Not Closed!!!!
2/6/2007 4:11:26 PM Ejector Not Retracted!!!
2/6/2007 8:47:18 AM Gate Not Closed!!!!
2/6/2007 8:47:18 AM Ejector Not Retracted!!!
2/5/2007 3:33:51 PM Gate Not Closed!!!!
2/5/2007 3:33:51 PM Ejector Not Retracted!!!
```

Summary of Active Alarms

InputDisplay

File Monitor TotalTrak Help

Current Part:

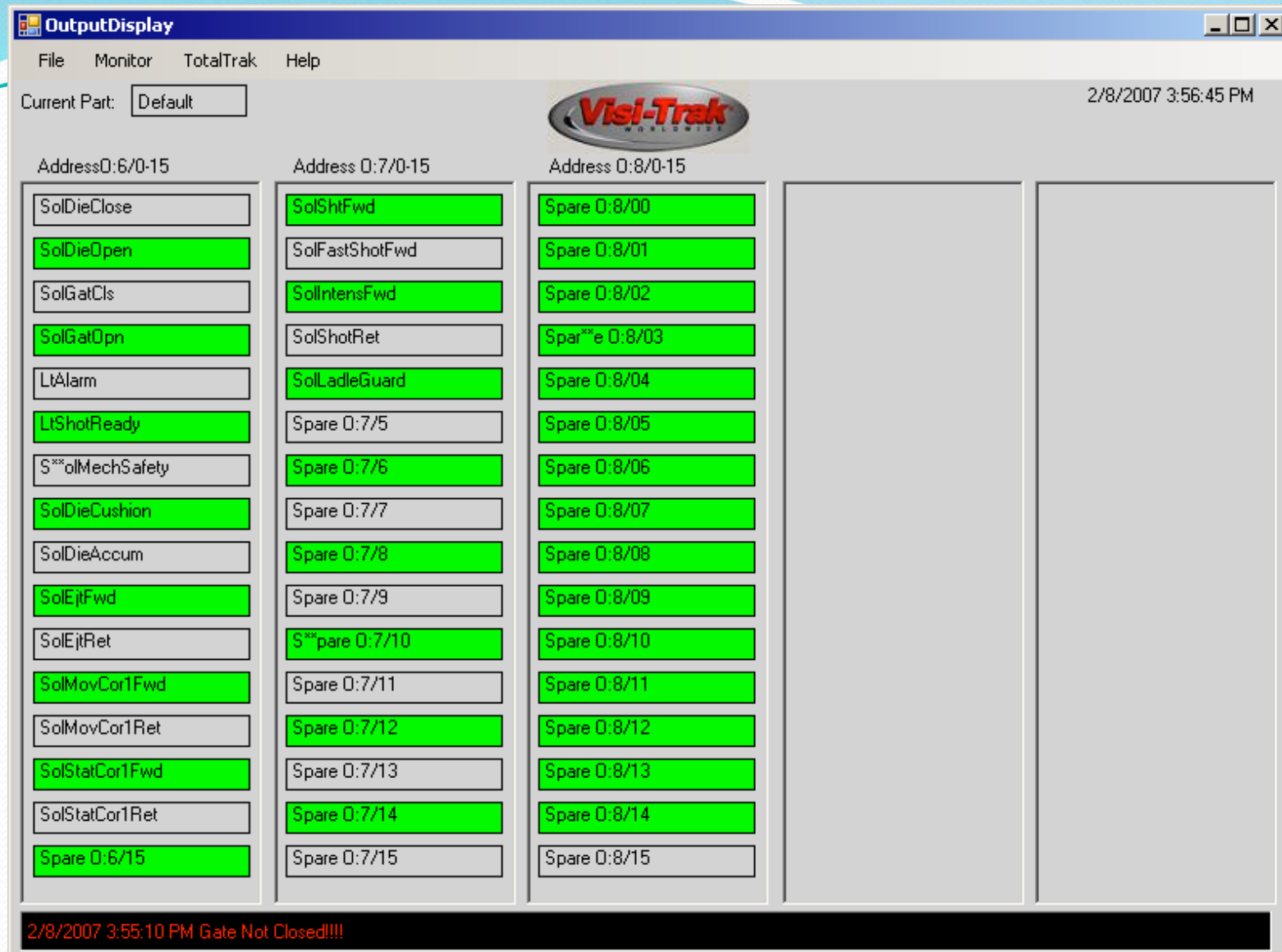
2/8/2007 4:02:23 PM

Visi-Trak

Address I:1/0-15	Address I:2/0-15	Address I:3/0-15		
LSDieLock 1	LSShutOff 1	Spare I:3/00		
LSDieLock 2	LSShutOff 2	Spare I:3/01		
PBCycleStart 1	LSFrontGate 1	Spare I:3/02		
PBCycleStart 2	LSFrontGate 2	Spare I:3/03		
PBHand	LSFrontGate 3	Spare I:3/04		
PBShotJog	LSRear Guard 1	Spare I:3/05		
PBManualEjectFwd	LSRear Guard 2	Spare I:3/06		
PBManualEjectRet	LSRear Guard 3	Spare I:3/07		
PBMovCore1Fwd	LSLadle Guard	Spare I:3/08		
PBMovCore1Ret	LS Ldl Guard Lck	Spare I:3/09		
PBStatCore1Fwd	LS Front Gate Open	Spare I:3/10		
PBStatCore1Ret	LS Rear Guard Open	Spare I:3/11		
LSMovCore1Fwd	LS Shot Retracted	Spare I:3/12		
LSMovCore1Ret	Spare I:2/13	Spare I:3/13		
LSStatCore1Fwd	Spare I:2/14	Spare I:3/14		
LSStatCore1Ret	Spare I:2/15	Spare I:3/15		

2/8/2007 4:02:13 PM Gate Not Closed!!!!

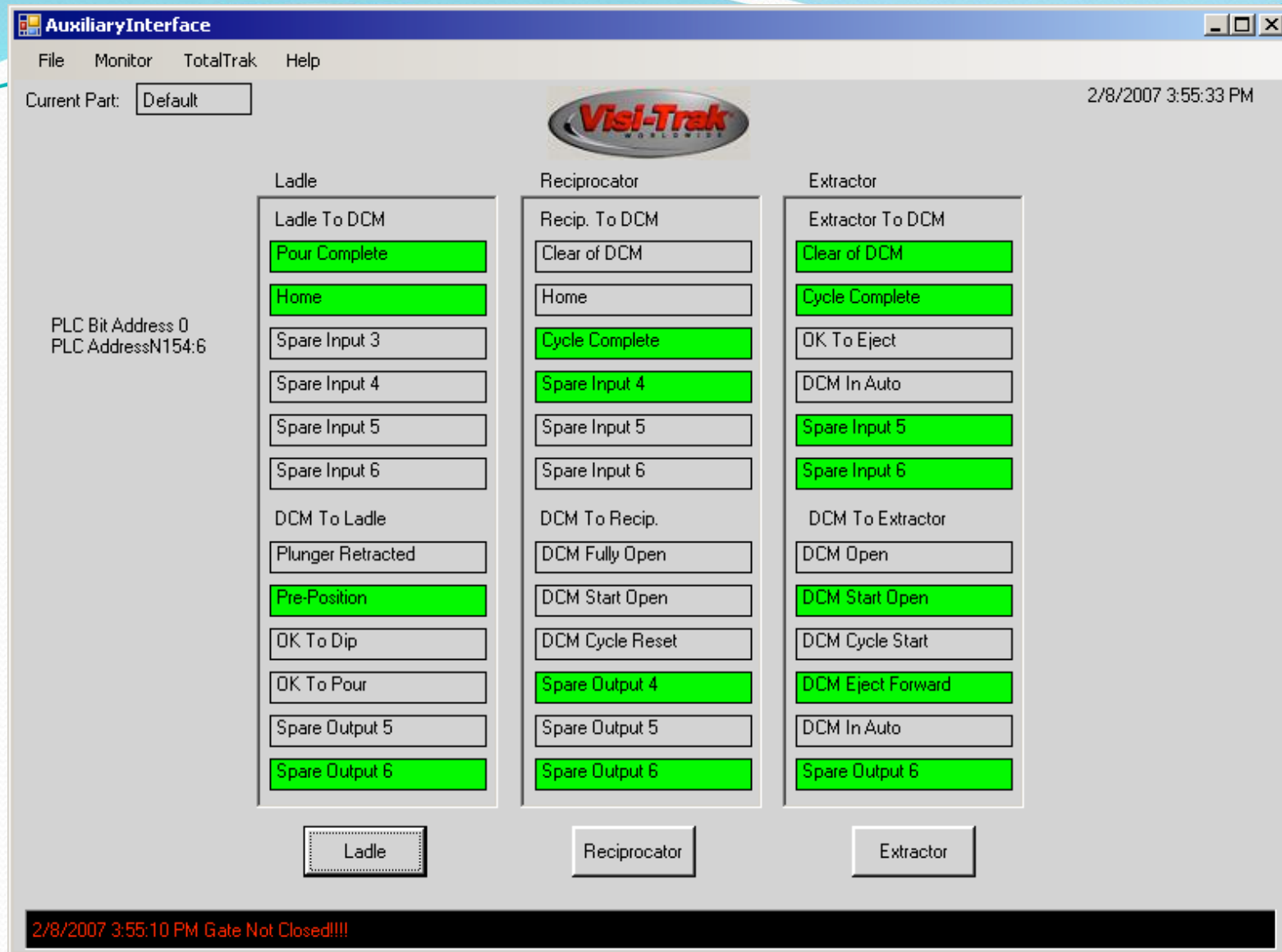
Input Display Screen: Up to 5 columns of 16 digital values



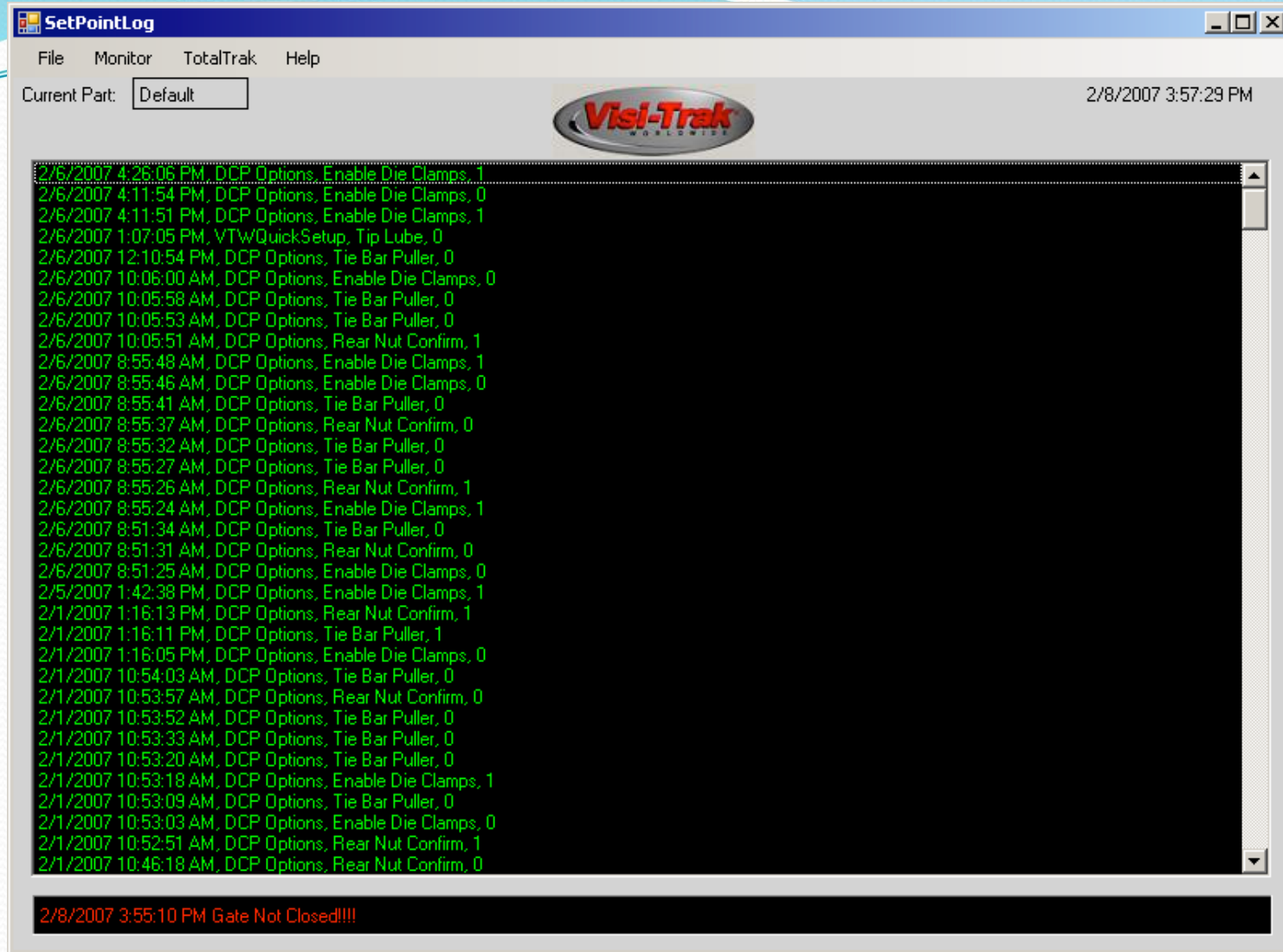
Output Display Screen: Up to 5 columns of 16 digital values



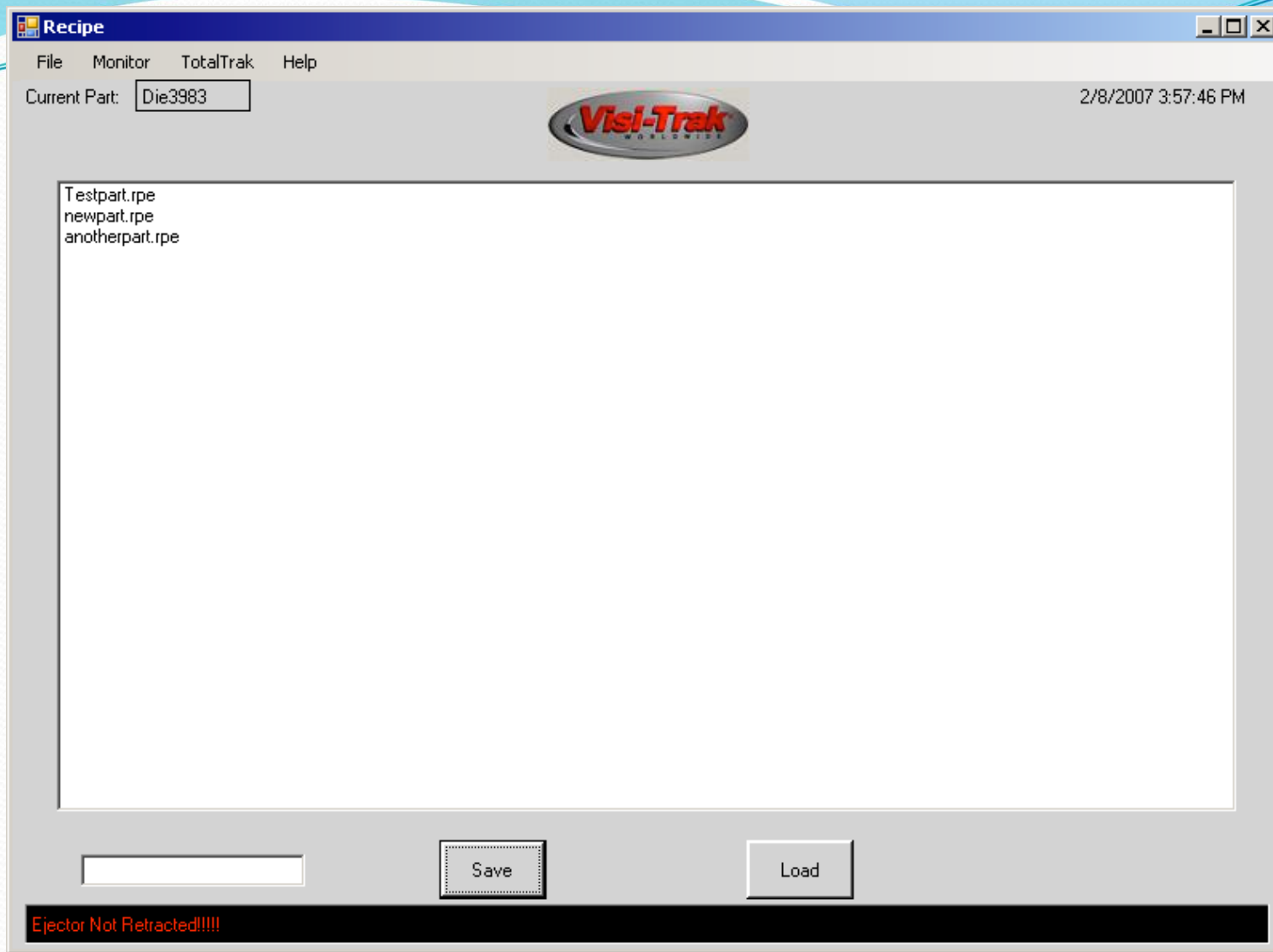
Image Viewer Display: Supports .jpg, .gif. and .bmp. images



Auxiliary Interface Display: ON/OFF Selection for individual devices- up to 12 signals available for each device



Set-Point Log Display: Displays the date, time, display name, description of the Set-Point that was changed and the new value of the Set-Point



Temporary Recipe Display:

Create new recipes and update existing recipes

Analog

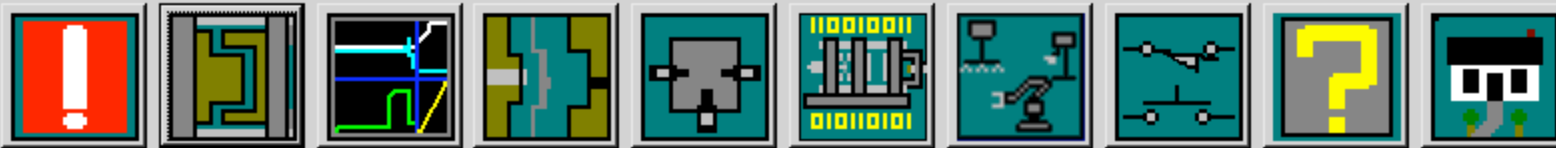
Current Part:

3/8/2007 12:58:31 PM



Analog Inputs		Volts	Analog Inputs		Volts	Analog Outputs		Volts
Die Position		10.000	Spare 09		10.000	Die Velocity		2.500
Crosshead Position		5.000	Spare 10		1.250	Gate Velocity		5.000
Ejector Position		10.000	Spare 11		2.500	Spare 02		10.000
Gate Position		1.250	Spare 12		5.000	Spare 03		1.250
Die Accumulator Pressure		1.250	Spare 13		5.000	Spare 04		2.441
Shot Accumulator Pressure		2.500	Spare 14		10.000	Spare 05		2.500
Intensifier Accum. Pressure		5.000	Spare 15		1.250	Spare 06		3276.7
Spare 08		10.000	Spare 16		2.500	Spare 07		3276.7

3/8/2007 12:57:32 PM Gate Not Closed!!!!



Analog Input Screen/ Analog Output Screen

Tonnage

Current Part: Die3983

3/8/2007 1:03:53 PM



Upper Operators Tie Bar

225
230
212
225

Actual
Alarm High
Alarm Low
Calibrate

Upper Helpers Tie Bar

225
230
209
225

Total Tonnage

Actual	Alarm High	Alarm Low	Unbalance Alarm	Scale
903	910	880	15	600

Shot Ready

Lower Operators Tie Bar

226
230
211
226

Actual
Alarm High
Alarm Low
Calibrate

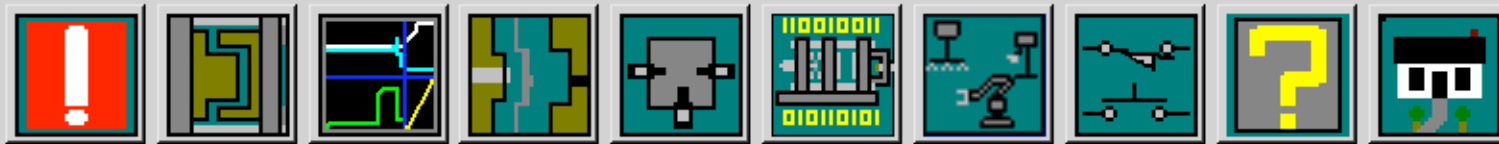
Lower Helpers Tie Bar

227
230
210
227

Peak Mode On

Reset

3/8/2007 1:03:52 PM Gate Not Closed!!!!



Tie Bar Tonnage Display Screen

Microsoft Excel - ProcessValues.csv

File Edit View Insert Format Tools Data Window Help

Type a question for help

C2 1

	A	B	C	D	E	F	G	H	I	J	K	L
1	VB Name	Text	LblVisible	TxtVisible	ActualVis	Value-1	Value-2	Value-3	Value-4	Address		
2	LblPartDescr	Current Part:	1	0	0	0	0	0	0	0 NA		
3	LblPartName	Default	1	0	0	0	0	0	0	0 NA		
4	LblCounters	Cycle Counters	1	0	0	0	0	0	0	0 NA		
5	LblCntrSetpt	Setpt.	1	0	0	0	0	0	0	0 NA		
6	LblCntAct	Actual	1	0	0	0	0	0	0	0 NA		
7	LblShiftCnt	Shift Count	1	0	0	0	0	0	0	0 N153:0		
8	BtnShftRst	Reset	1	0	0	0	0	0	0	0 B3/10		
9	LblPartCnt	Part Count	1	0	0	0	0	0	0	0 N153:1		
10	BtnPrtRst	Reset	1	0	0	0	0	0	0	0 B3/11		
11	LblCycleTmrs	Cycle Timers	1	0	0	0	0	0	0	0 NA		
12	LblActTim	Actual	1	0	0	0	0	0	0	0 NA		
13	LblPwTim1	Cycle-1	1	0	0	0	0	0	0	0 NA		
14	LblPwTim2	Cycle-2	1	0	0	0	0	0	0	0 NA		
15	LblPwTim3	Cycle-3	1	0	0	0	0	0	0	0 NA		
16	LblPwTim4	Cycle-4	1	0	0	0	0	0	0	0 NA		
17	LblTotalCycle	Total Cycle	1	1	1	1	1	1	1	1 N153:5		
18	LblDiClsFstTim	Die Close Fast	1	1	1	1	1	1	1	1 N153:6		
19	LblDiClsSlo	Die Close Slow	1	1	1	1	1	1	1	1 N153:7		
20	LblDiLckg	Die Locking	1	1	1	1	1	1	1	1 N153:8		
21	LblInjSeq	Shot Sequence	1	1	1	1	1	1	1	1 N153:9		
22	LblPrtCur	Part Curing	1	1	1	1	1	1	1	1 N153:10		
23	LblDiOpnCshn	Die Open Cushion	1	1	1	1	1	1	1	1 N153:11		
24	LblDiOpnFst	Die Open Fast	1	1	1	1	1	1	1	1 N153:12		
25	LblDiOpnSlo	Die Open Slow	1	1	1	1	1	1	1	1 N153:13		
26	LblPrtRmvl	Part Removal	1	1	1	1	1	1	1	1 N153:14		
27	LblITon	Tonnage	1	0	0	0	0	0	0	0 NA		
28	LblITonAlrm	Alarm	1	0	0	0	0	0	0	0 NA		
29	LblITonAct	Actual	1	0	0	0	0	0	0	0 NA		
30	LblITonPw1	Cycle-1	1	0	0	0	0	0	0	0 NA		
31	LblITonPw2	Cycle-2	1	0	0	0	0	0	0	0 NA		
32	LblITonPw3	Cycle-3	1	0	0	0	0	0	0	0 NA		
33	LblUprOprTiBar	Upper Operators Tie Bar	1	1	1	1	1	1	1	0 N153:21		
34	LblLwrOprTiBar	Lower Operators Tie Bar	1	1	1	1	1	1	1	0 N153:22		
35	LblUprHlprTiBar	Upper Helpers Tie Bar	1	1	1	1	1	1	1	0 N153:23		
36	LblLwrHlprTiBar	Lower Helpers Tie Bar	1	1	1	1	1	1	1	0 N153:24		

ProcessValues /

Ready

Configuration File