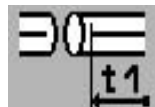
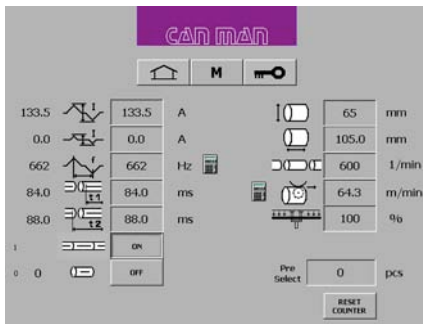


FAQ_X1_013 Qualimaker (QM) does not show a graph, after "Start scope" has been activated!
The reject does not memorize the canbodies and all cans are rejected.

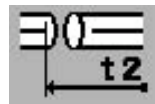
Cause 1:

The setting of $t1$ and $t2$ is wrong. If the timing is wrong the PM cannot execute the signal, which is necessary to memorize the canbodies in the reject unit and to start the record of the graph.

Setting of $t1$ and $t2$:



$t1$ defines the starting point for the reduced current time window.



$t2$ is the time, where the reduced current window ends.

$t2 - t1$ is thus the time span for the reduced current, therefore $t2 > t1$!



NOTE:

The value of $t2$ and $t1$ need to be smaller as the cycle of one single can.

For example:

A production of 300/min. corresponds to a cycle time of 200 ms/can. Production of 600/min. corresponds to 100ms/can.



NOTE:

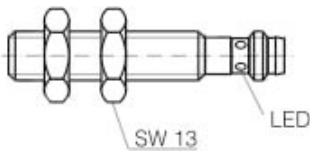
For a more detailed explanation of timing $t1$ and $t2$, consult your manual book 2, chapter 5.6.5. "Setting of Parameter $t1$ & $t2$ for recuded Current and Overlap Check".

Cause 2:

Check the inductive proximity switch B64 at the final pusher unit for function, operating distance and defect.

**B64**

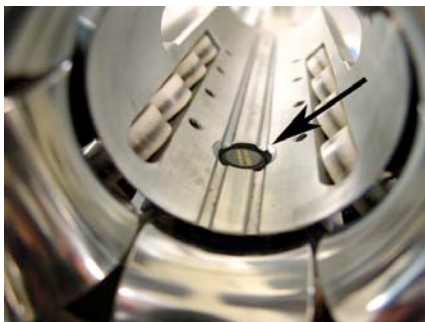
Final pusher (Synchrostar II):
Sensor B64.



Description:
Inductive proximity sensor for embeddable
mounting.
Polarity: PNP
Output: NO. or NC.
Operating distance: 2mm

Cause 3:

Check the tool switch B6 in the calibration tool for function, operating distance and defect.

**B6**

The position of the welding sensor B6, can
be almost flush. Just make sure that you
don't get scratches on the canbodies.



The height of the sensor can be adjusted here (arrow).



Inductive Sensor (magnetic field resistant)

Mounting mode: flush

Function principle: inductive/normally open

Rated operating distance: 3 mm