STOLL

1 What Is New?

Operating system of the machine: V_OKC_006.005.000_STOLL

| **?** ? | When a stop motion occurs, the help button flashes (a big and a small question mark in turns). With it, you can call up information for remedying the problem. |

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1.1 Specification "MSECK" - Carriage speed with small knots

Carriage speed for small knots over m rows, default: 1 row.

The value range for the number of rows has been modified.

- Up to now: 1…12 rows
- New: 1…99 rows

ⓘ Entry in the Setup Editor of the "Speed"menu.

1.2 New command "Y-RALL(n)" - Do not open the clamp of the yarn carrier

Y-RALL	The clamps of all yarn carriers are opened.
Y-RALL(n, m)	This command is used when not all of the clamps are to be opened, as the threads of individual yarn carriers will be winded around the take-down roller otherwise.
	Example: Y-RALL(1A,2A) All the clamps of the yarn carriers are opened, with the exception of the clamps of the yarn carriers 1A and 2A.
	Only when the fabric is below the take-down roller, open the clamp with the command "Y-1A:R" and "Y-2A:R" (entry in the knitting program).

1.3 EFS Feed Wheels

The electronic feed wheels EFS 820 and EFS 920 of the company Memminger-IRO are supported in the Setup Editor.

You have two options to connect the feed wheels:

- serial, connected via EFS kit (ID 268 338)

- CAN, connected via CAN-Gateway

	Serial	CAN
Quantity of feed wheel groups	6	64
Connection type Machine - Feed Wheel	unidirectional Machine -> Feed Wheel	bidirectional Machine <-> Feed Wheel
Mode 8 (Yarn tension return correction factor)	no	yes
Mode 12 (permanent take-up function)	no	yes* * Firmware update from Memminger-IRO required
Data transfer rate	4800 B/s	1 MB/s

ⓘ If the machine is equipped with EFS-Kit (ID 268 338) or the CAN-Gateway, then the "Feed Wheels" menu will be displayed in the Setup Editor.

Changes for "Mode 8" (Yarn tension return correction factor)

Up to now	Up to now, only one value could be set for "Mode 8" ("SFOINIT" tab)
New	The value for "Mode 8" can individually be adapted to the knitting situation at the "SFOI" tab.

1.4 APM Mode - Re-knitting an Already Done Ticket

You can knit an already finished ticket again, e.g. in case of a defective fabric piece.

The state of the ticket changes from "Done" to "Todo".
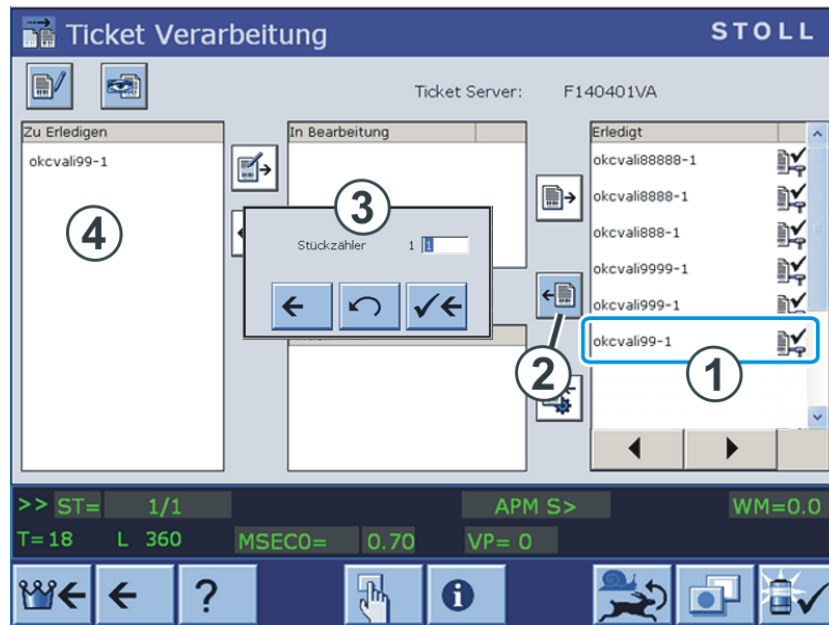
For doing this, proceed as follows:

1. Select the desired ticket (1) in the "Done" field.

2. Tap the button (2) .

    ▷ The (3) entry window is displayed.
       Enter the desired quantity and confirm the entry.

▶ The ticket is returned to the "Todo" field (4).

1.5 PPS - Extended Knit Report

We split up the comprehensive PPS package into individual packages because we want to give you the possibility of controlling and monitoring even better your machine pool.

The packages build on each other and have different priorities. An extension is possible at any time.

■ You can use the first package, Extended Knit Report, for free (without EVP)

■ The other packages are chargeable. For each of them you need a separate EVP.

1	Extended Knit Report (Extended Knit Report)	without EVP	◆ STOLL Nameserver (SNS) ◆ STOLL – knit report (SKR) ◆ Infrastructure Management
2	STOLL Production Planning System (PPS)	by EVP (PPS Connector)	◆ Production Management ◆ Ticket Management
3	Auto Production Mode (APM)	by EVP (PPS Connector, APM extension)	◆ Auto Production Mode (Safety switches needed)

How can you use the different packages?

■ Download the entire PPS software from the STOLL homepage.

■ Without EVP you can use the feature of the Extended Knit Report.

■ For the other packages you have to order a EVP at STOLL.
   After having received the EVP you can use the corresponding package.
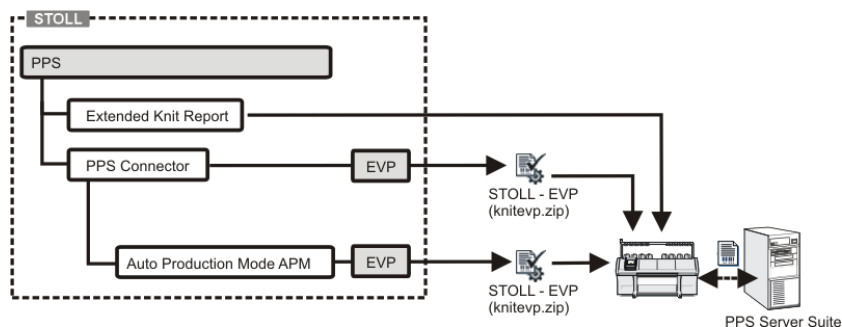
1.6 Adapters for switchable outputs and inputs
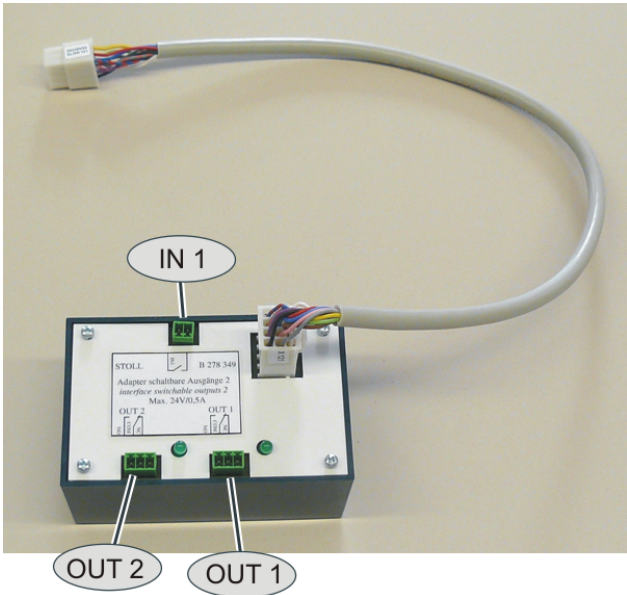
Up to now	Adapter for switchable outputs (ID 253 291)
	Two potential-free relay outputs which enable external devices to be switched on and off (a maximum of 24V/0.5A) are available.
	OUT 1 OUT 2
New	Adapters for switchable outputs and inputs 2 (ID 278 349)
	2 outputs and 1 input
	OUT 1 OUT 2 IN 1

Example for using the input "IN1"

The elastic thread is to be monitored for knots. For monitoring the elastic yarn, an additional external knot detector is used.

A knot appears for example during a bobbin change. The knot leads to a quality defect, the fabric is unusable. The fabric does not need to be completed and is to be started again automatically.

Use the new adapter and complete the knitting program so that the machine quickly terminates the faulty fabric and starts a new one.

- The knot is detected

- The knot is knitted-in
  You specify the number of knitting rows in the knitting program.

- The fabric is aborted
  In the knitting program you specify the behavior of the machine.

■ A new fabric is started.

In the knitting program you specify, how the machine should behave:

CTRLZ(x)	The machine automatically begins with a new fabric if the following conditions are met: ◆ Racking located on home position ◆ Yarn carriers located at starting position ◆ Carriage direction allows new start x = Number of rows until the execution of the action
NEWSP(x,y)	Cancel the current fabric and start it again. x = Number of rows until the execution of the action y = Line number to start the knitting program with

Example with "CTRLZ":

30 START : 35 DO CTRLZ(6), #IN1=1; : 70 IF #IN1=1 DO CTRLZ(6), #IN1=1; : 200 IF #IN1=1 DO CTRLZ(6), #IN1=1; : 400 DO NONE, #IN1=1; : 500 END	Line 35 - Activate automatic CTRLZ with #IN1 Line 70 - If a knot is detected, the command "CTRLZ" is executed after 6 rows. ◆ The second "#IN1=1" specification is necessary to activate again "#IN1=1" ◆ You can also expand the specification with a function created by you. 70 IF #IN1=1 F:CANCEL-PROCEDURE; DO CTRLZ(6), #IN1=1; Line 200 - The knot monitoring is to be active in an additional area in the knitting program. Line 400 - Deactivate #IN1

ⓘ If you work with "NEWSP", replace the above mentioned specifications for "CTRLZ(x)" with "NEWSP(x,y)".