# XL200 Series Quick Sheet

***Version 2.X & 3.X Software***

## Program an Order

*Note: If the Use Order Numbers setup parameter is set to NO, skip steps 2 through 6.*

1. Press **[Program]**.
2. Press **[End]**.
3. Press **[F2]** to add an order.
4. Enter the **order number** and press **[Enter]**.
5. *(optional)* Enter the **material number** and press **[Enter]**.
6. *(optional)* Enter the **product code** and press **[Enter]**
7. Enter the **bundle number** and press **[Enter]**.
8. Enter the **quantity** (Qty) and press **[Enter]**.
9. Enter the **part length** and press **[Enter]**.
10. *(punching only)* Enter the **pattern number** and press **[Enter]**.
11. Repeat steps 7 - 10 until the entire cut list is entered.
12. Press **[Status]** to return to the Status Screen.

## Edit an Existing Order or Item

1. Press **[Program]**.
2. Select the **order number** (if used) and press **[Enter]**.
3. Select the **order data** *or* **cut list item** to be edited.
4. Select the **specific data** to be edited
5. Enter the **value** and press **[Enter]**.
6. Press **[Status]** to return to the Status Screen.

## Change the Sequence of Items Within an Order

1. Press **[Program]**.
2. Select the **order number** to be re-sequenced.
3. Select the bundle item to be moved.
4. Press **[Move Up]** or **[Move Down]** to move the item.
5. Repeat for any other items.
6. Press **[Status]** to return to the Status Screen.

## Remake an Item

1. Halt the line.
2. Press **[Status]**.
3. Select the desired done or partially-done **bundle item**.
4. Press **[F4]** to re-make the order. The *Remake Item/Order pop-up window* displays
5. In the **Number of Pieces Field**, enter the quantity of pieces you want to remake (the field pre-fills with the quantity of the selected item already done).
6. Press **[OK]** to save the remake
   *or*
   press **[Cancel]** to stop the remake.

## Delete a New or Done Order or Item

1. Press **[Program]**.
2. Select any **order** or **bundle item** with a status of READY.
3. Press **[F3]**. The selected order or item is deleted.

*Note: All DONE orders/items are erased automatically after the number of days set in* Auto-Delete Done Orders *have elapsed.*

## Set the Next Line to Run

1. Halt the machine.
2. Press **[Status]**.
3. *(punching only)* Cycle the shear twice to clear the target queue.
4. Select the desired **bundle item** to run (the item must have a status of READY or SKIP).
5. Press **[F2]**. The selected bundle item is set to be next.

## Create a Pattern *(Punching Only)*

1. Press **[Program]**.
2. Press **[F6]**. The *Pattern Editing screen* displays.
3. Press **[F2]**. Enter the **pattern number** and press **[Enter]**.
4. Press **[F1]** to toggle from menu window to detail window.
5. In the Tool ID field, enter the **tool number** and press **[Enter]**.
6. From the Reference drop-down, select the **reference** for the tool and press **[Enter]**.
7. Enter the **offset** and press **[Enter]**.
8. Enter the **Y-Reference** and **Y-Offset**, if applicable.
9. Repeat steps 5 - 8 until the pattern is complete.
10. Press **[F1]** to toggle to the main window to enter more patterns.
11. Press **[Status]** to return to order programming.

## Edit a Pattern *(Punching Only)*

1. Press **[Program]**.
2. Press **[F6]**. The *Pattern Editing screen* displays.
3. Select the **pattern** to edit.
4. Select the **data** to edit.
5. Enter the **new value** and press **[Enter]**.
6. Press **[Status]** to return to the Status Screen.

## Delete a Partially Completed Order or Item

1. Halt the machine
2. Press **[Status]**.
3. *(punching only)* Cycle the shear twice to clear the target queue.
4. Select the **bundle Item** to produce next and press **[F2]**. Its status changes to NEXT.
5. Press **[Program]**
6. Select the partially completed order *or* item.
7. Press **[F3]**. The line is deleted.

*Note: Deleting partially completed orders or Items causes them to show as UNSCHEDULED in Eclipse.*

### Increment Quantity During Run Mode

8. Select the bundle Item currently running.
9. Press **[Inc. Qty.]** (Increment Quantity).
10. (*Eclipse users only)* Select **scrap code** from the pop-up menu.
11. Select **[OK]** to accept the scrap code.
12. Press **[Inc. Qty.]** as many times are needed to make the required number of additional parts.

### Decrement Quantity *(Identifying Scrapped Parts as Good Parts)*

1. Halt the line.
2. Highlight the **bundle item** to be decremented.
3. Press **[F5]**. The *Decrease Quantity pop-up window* displays.
4. In the **Number of Pieces** field, enter the number of pieces to decrement. Press **[Enter]**.
5. In the Coil to Adjust Footage field, enter the number of the coil you're adjusting footage for and press **[Enter]**.
6. Press **[OK]**. The pop-up closes and the quantity displayed in the Done field for the selected item is increased.

### Skip an Item to be Run

1. Press **[Status]**.
2. Select an **order** or **item** with a status of READY.
3. Press **[F3]**. The item's status changes to SKIP.

### Load a Coil

1. Press **[Production Data]**.
2. Select **Coil Inventory** from the main menu (left pane).
3. Press **[F2]**.
   - *If a coil is currently loaded,* the *Unload Current Coil pop-up window* displays.
     - Select **Return Coil to Inventory** if material is left on the coil.
       *or*
     - Select **Coil was Completed** if the coil was completely used.

     The *Load New Coil pop-up window* displays.
   - *If no coil is currently loaded,* the *Load New Coil pop-up window* displays.
4. In the **Coil** field, enter the ID of the coil to load.
5. Press **[OK]**. The coil inventory is updated to reflect the changes.

*Note: If the controller features a sheet detect switch, the pop-up window displays automatically, without proceeding through steps 1-2.*

### View Coil Inventory

1. Press **[Production Data]**.
2. Select **Coil Inventory** from the main menu (left pane). Coil information displays in the detail window (right pane).
3. Press **[Status]** to return to the Status Screen.

### Perform a Calibration Trim

1. Press **[Setup]**.
2. From the main menu (left pane), select **Trim Correction**.
3. In the **Last Measured Length** field (right pane), enter the last measured length and press **[Enter]**. The *Update Correction pop-up window* displays.
4. Select **[Yes]** to update the correction, or **[No]** to cancel the correction update.
5. Allow 2-3 parts to run before the change occurs.
   *or*
   *(Punching only)* Halt and cycle the shear twice for the correction factor to take effect immediately.

*Note: Perform this procedure only when part lengths are consistently short or long; otherwise, contact maintenance.*

### View Inputs and Outputs

1. Press **[Diagnostics]**.
2. From the main menu (left pane), select **Input/Output**.
3. Press **[F1]** to toggle the view to the I/O information in the right pane.
   - Use **[Page Down]** and **[Page Up]** to scroll through the list.
4. Press **[Status]** to return to the Status Screen.

### Set the Time Clock

1. Press **[Setup]**.
2. From the main menu (left pane), select **Controller Settings**.
3. Press **[→]** (right arrow) to expand the left pane's view.
4. Select **Clock/Calendar**. The right pane displays only the clock and calendar parameter fields.
5. Select a parameter to edit, enter its new value, and press **[Enter]**.
   - Repeat for each parameter until all are set as required.
6. Press **[Status]** to return to the Status Screen.

*Note: If connected to an Eclipse PC, the controller time is updated to match the Eclipse PC's time.*