

This document will explain how to switch operating units on the Techno HDS system.

The HDS-Osai Techno system will operate in inches or millimeters.

The following files and folders are involved in changing units.

In the upp on "nc001" (Z) : Macros\ folder

-P01M006 -P01M006.mm or -P01M006.inc

-P01M401 -P01M401.mm or -P01M401.mm

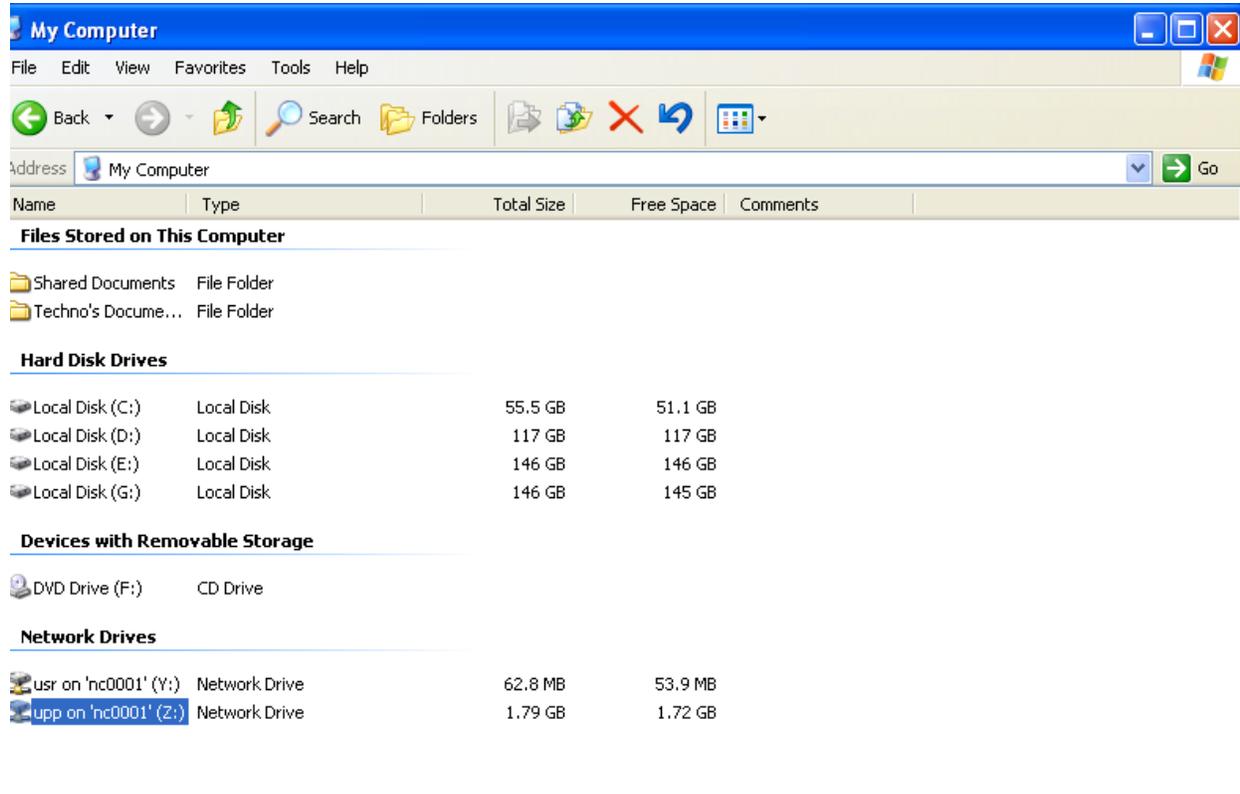
And in the folder location C:\Program Files\osai\WinNBI\Q Video\Techno QV\

The folder MMpp or inchPP

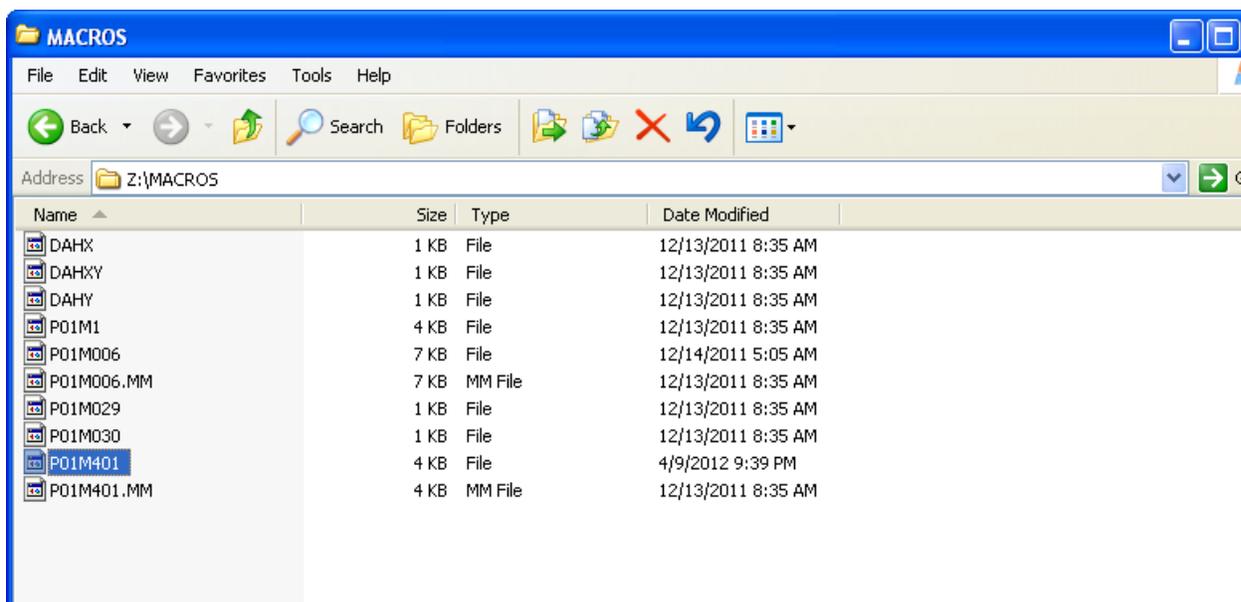
These files are contained with in the TechnoHDSInch2mm.zip file



1. Go to My computer and locate the Network drive Upp on "nc0001"

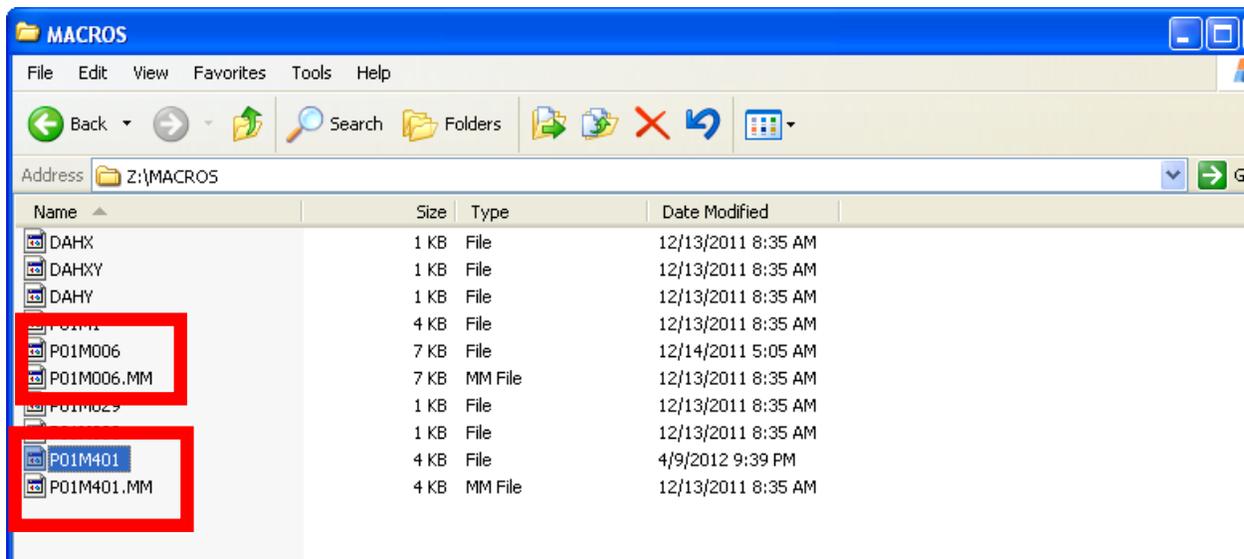


2. On this drive locate the folder MACROS

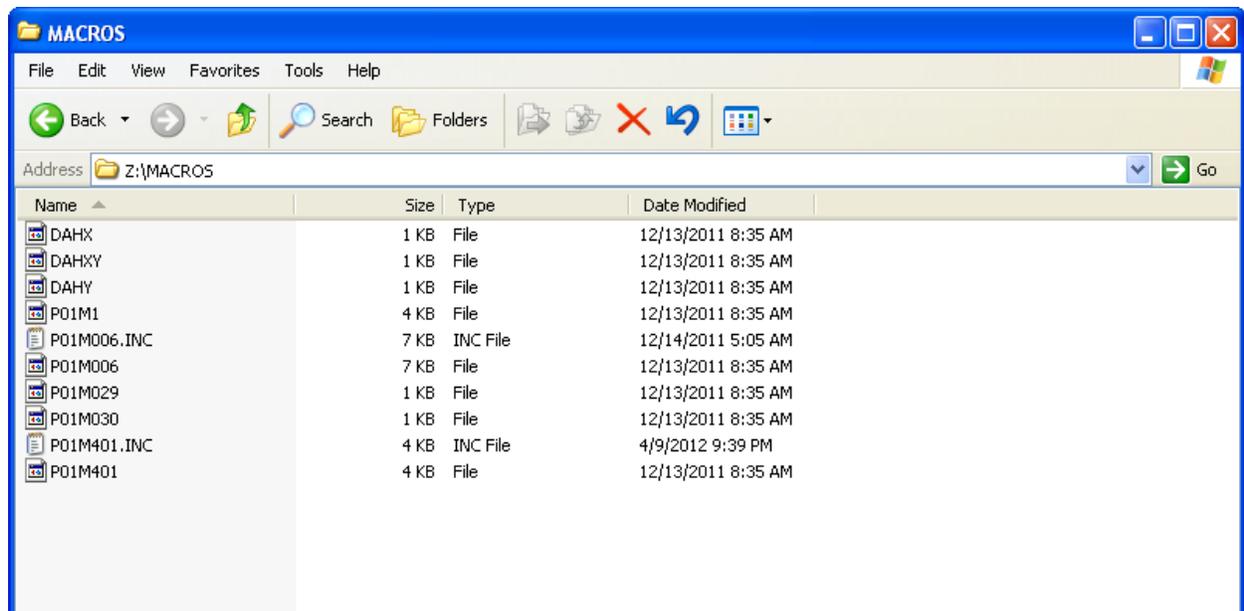


3. In this folder locate the file P01M401 this file will have no extension. If your units are currently inches, rename this file P01M401.inc if current units are mm, rename the file with the extension .mm

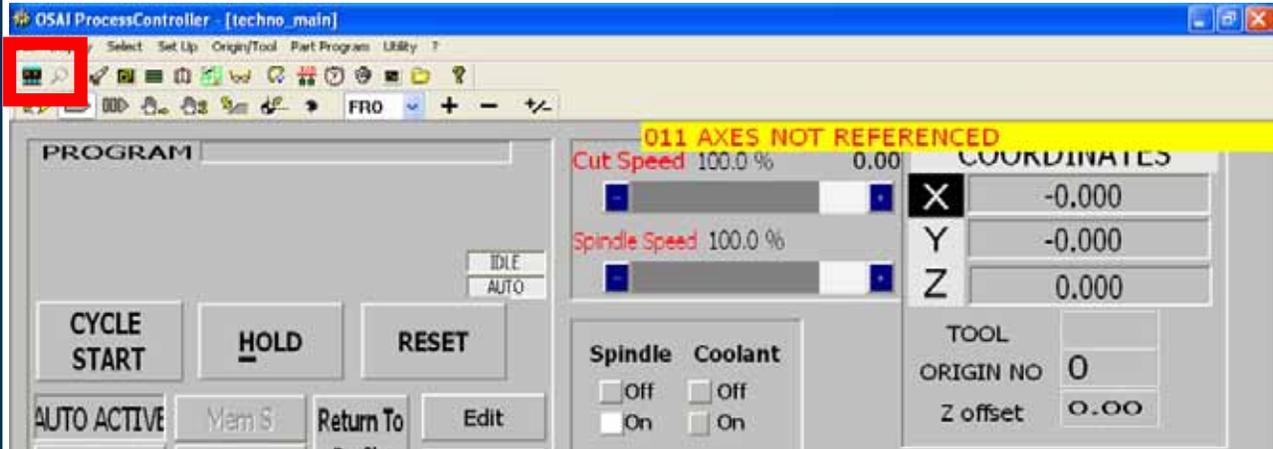
Also locate the file P01M006, and repeat the above. Rename .inc, or .mm.



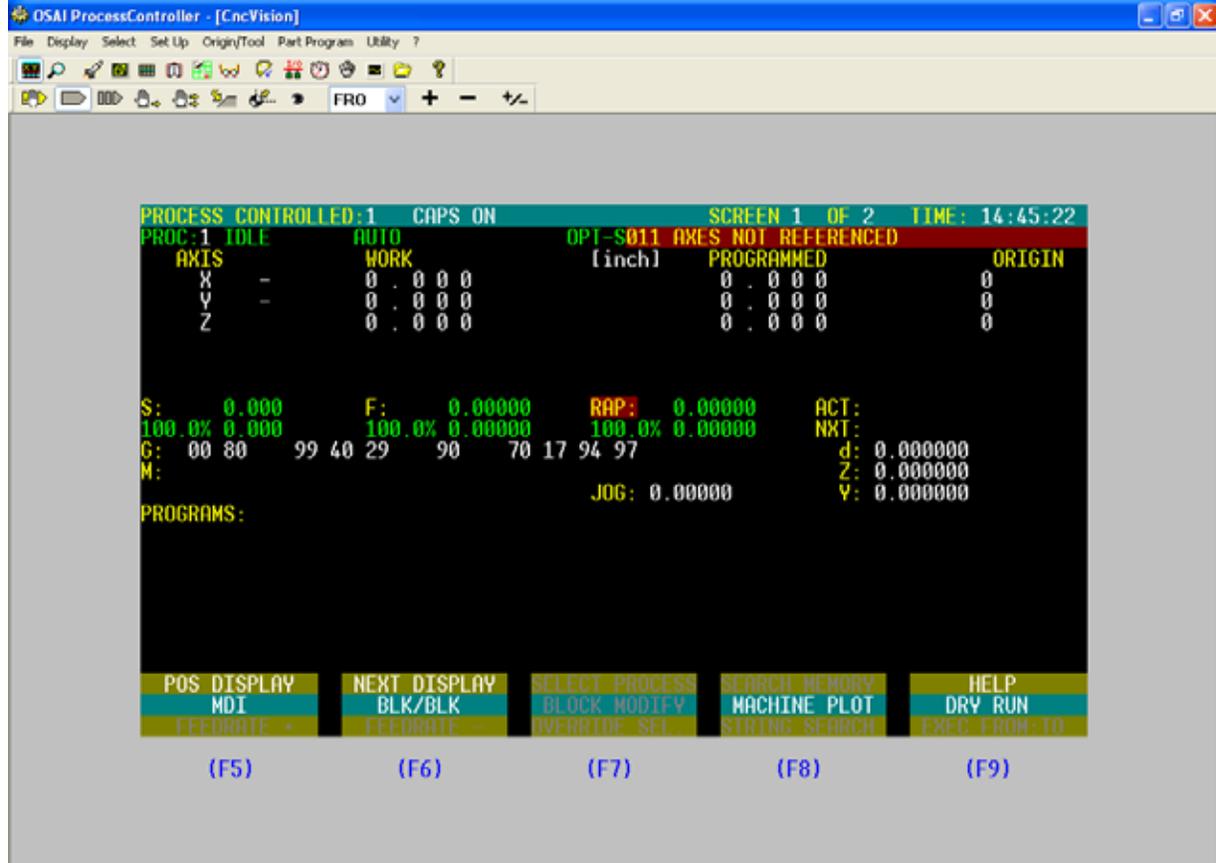
4. In this example we are switching from Inches to metric. Select the file P01M401.MM and remove the .mm extension by renaming the file. Repeat for P01M006.MM



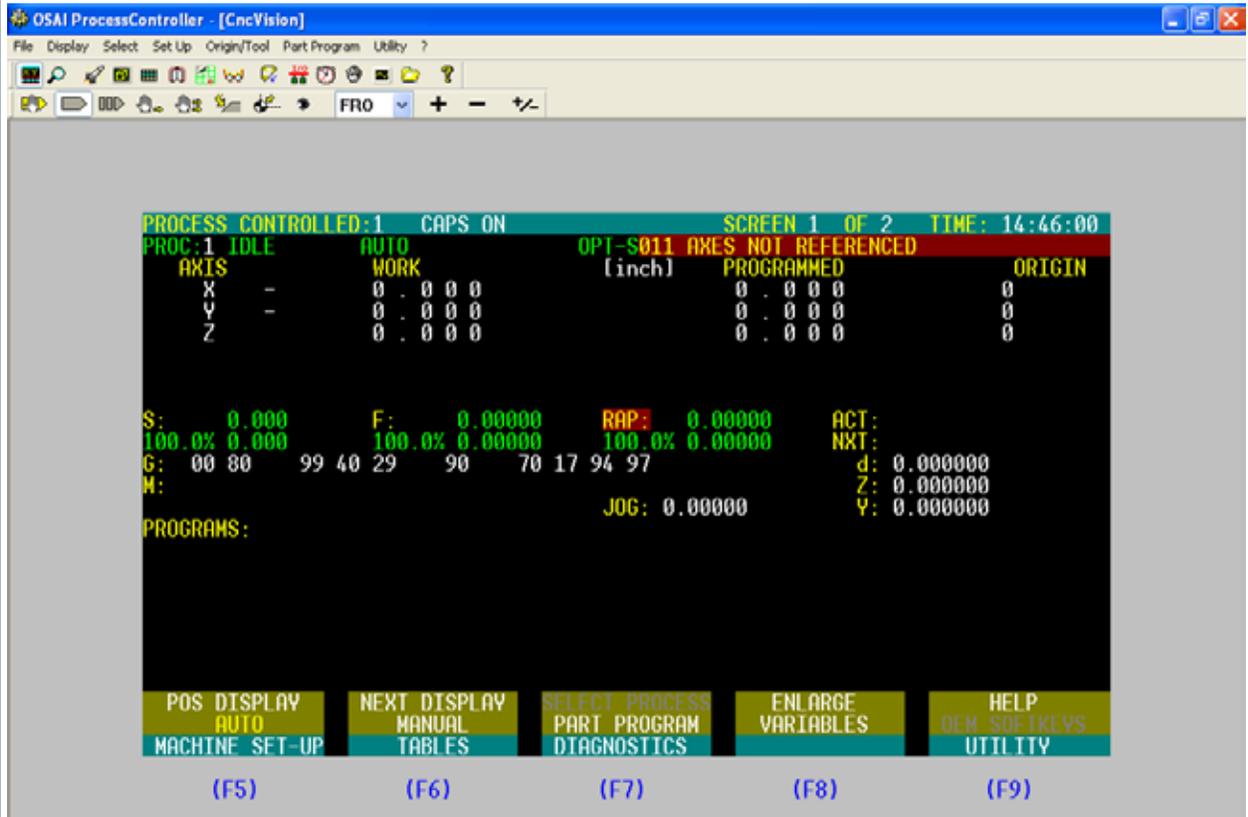
5. Click on the CncVision highlighted in the red square below to access the CNC Vision screen.



6. When the CNCVision screen opens press the F4 key to navigate to the main screen.
 Note: The mouse will not select any options in cnc vision. The F10 key will move the selection bar, and the corresponding F function key below the option will select.



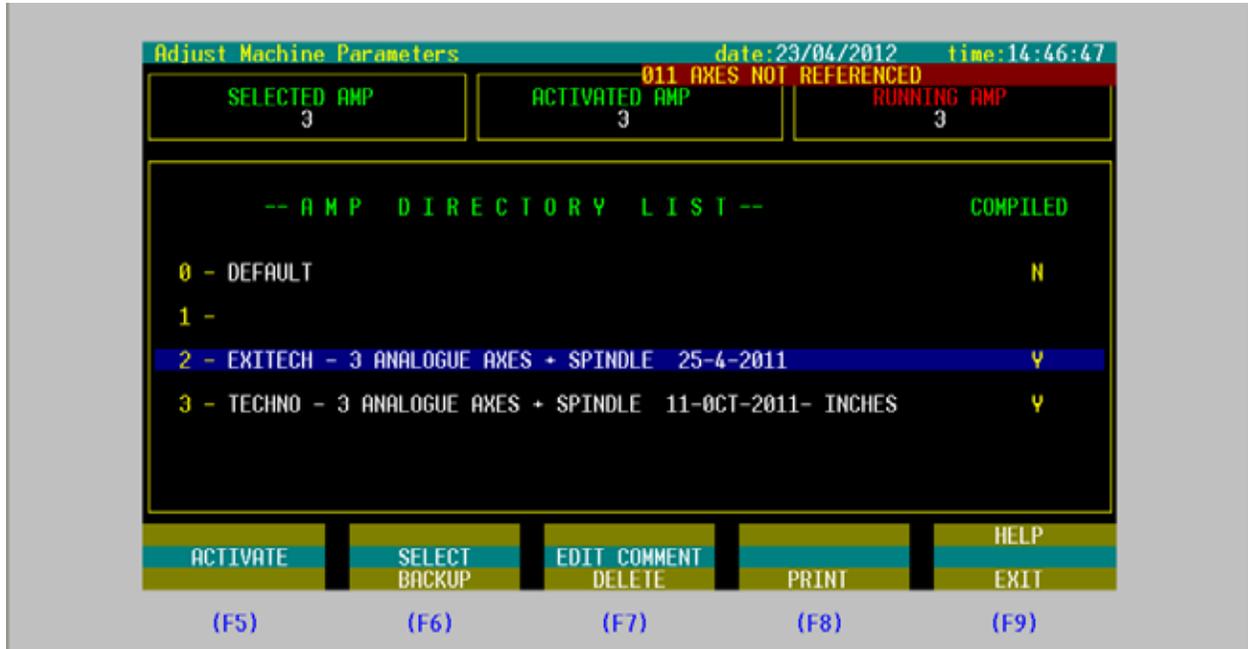
7. Press F10 until Utility is highlighted and press F9



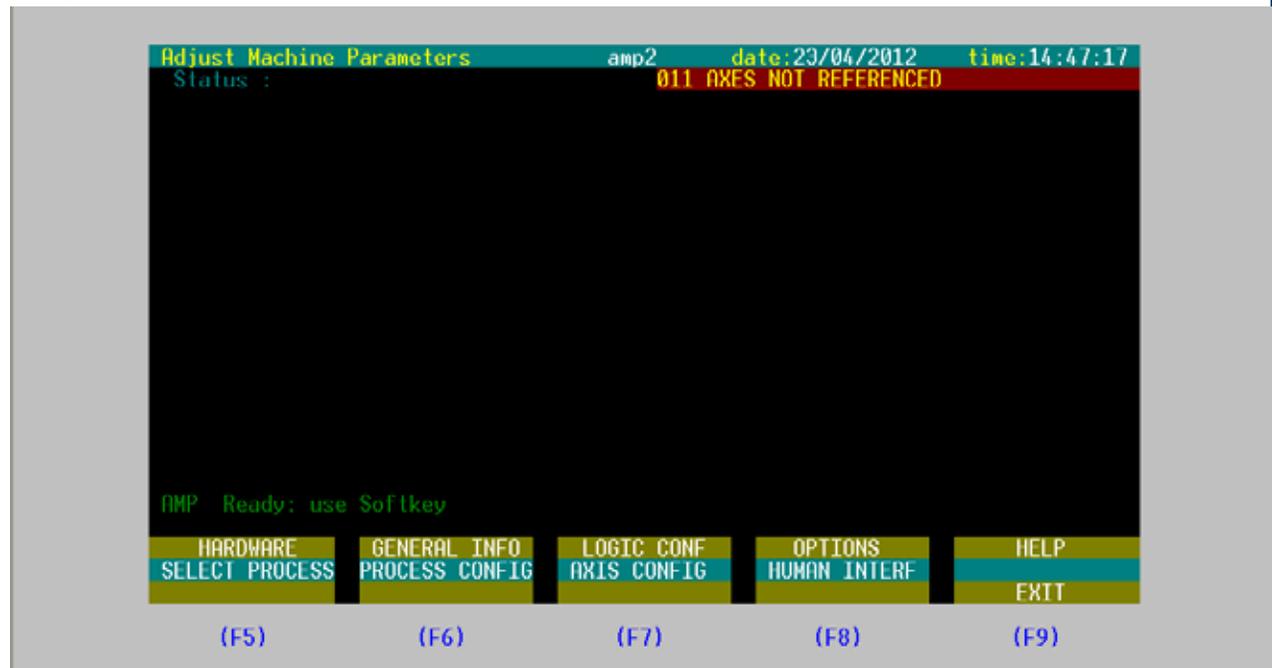
8. Press F5 to select AMP.



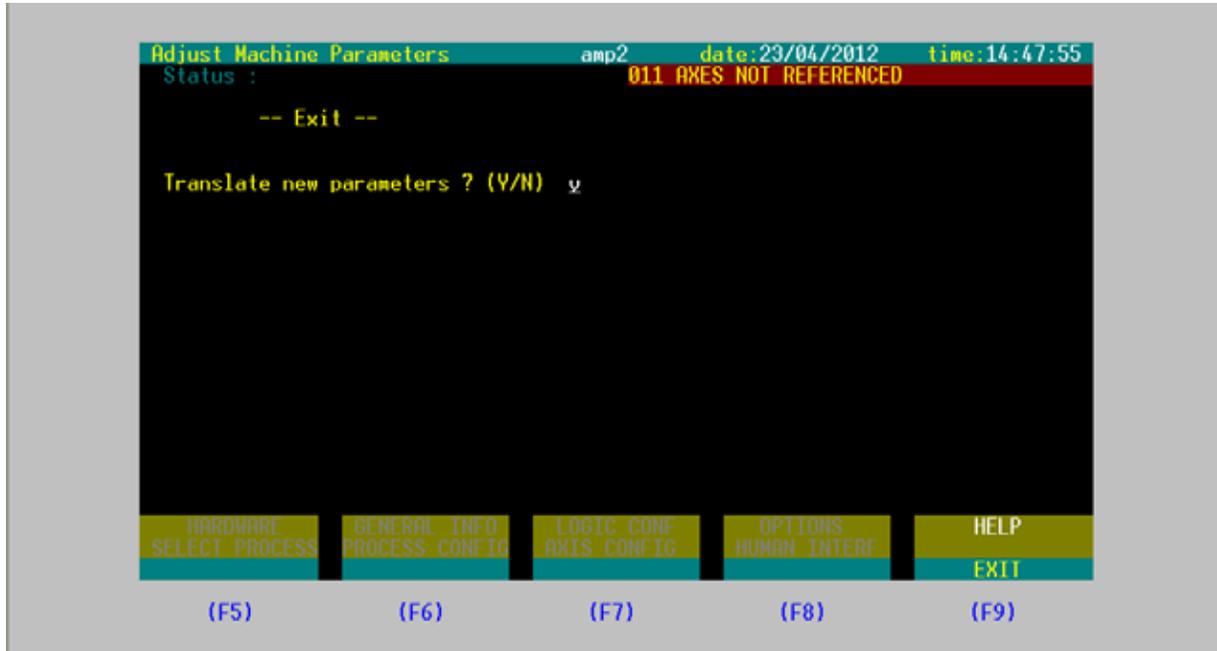
9. Use the arrow keys to move the Dark Blue bar to highlight option 2 in the Amp directory list. Press F5 to Activate.



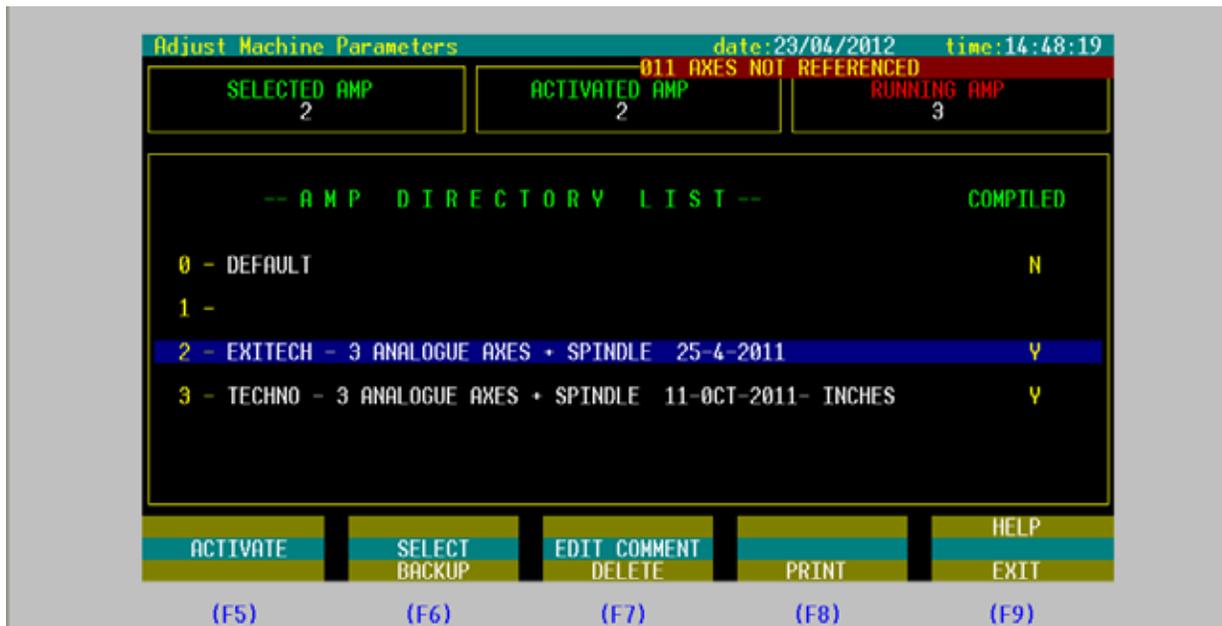
10. Press F6 to SELECT. When the parameter screen opens, press F10 to move the highlight bar, and F9 to Select EXIT.



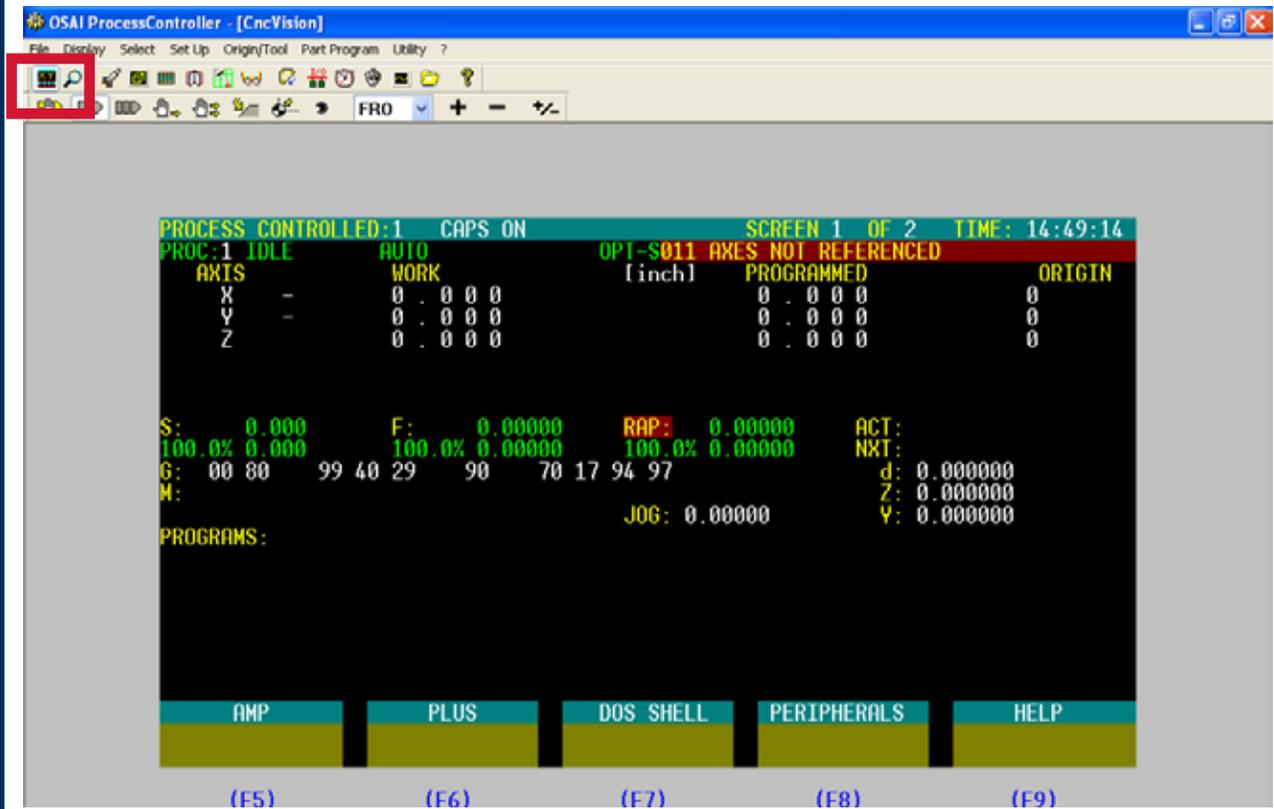
11. When you exit press y and then hit the Enter key. Note, use the enter key on the Number pad on the far right of the keyboard. The retrun carriage/enter key will not be accepted.



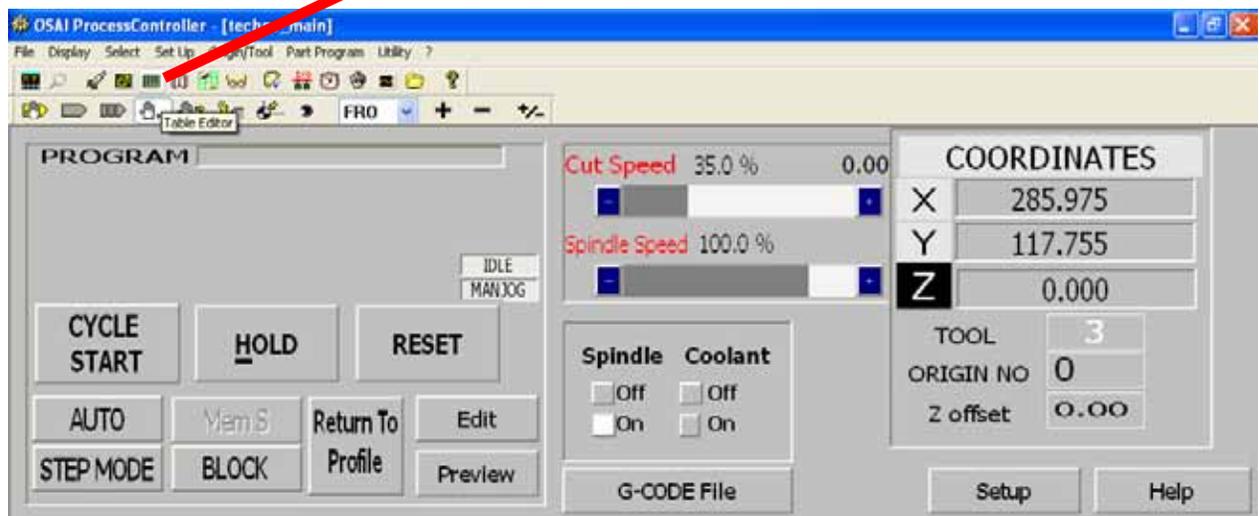
12. The Amp selection screen will appear again. Press F10 to highlight and F9 to Exit.



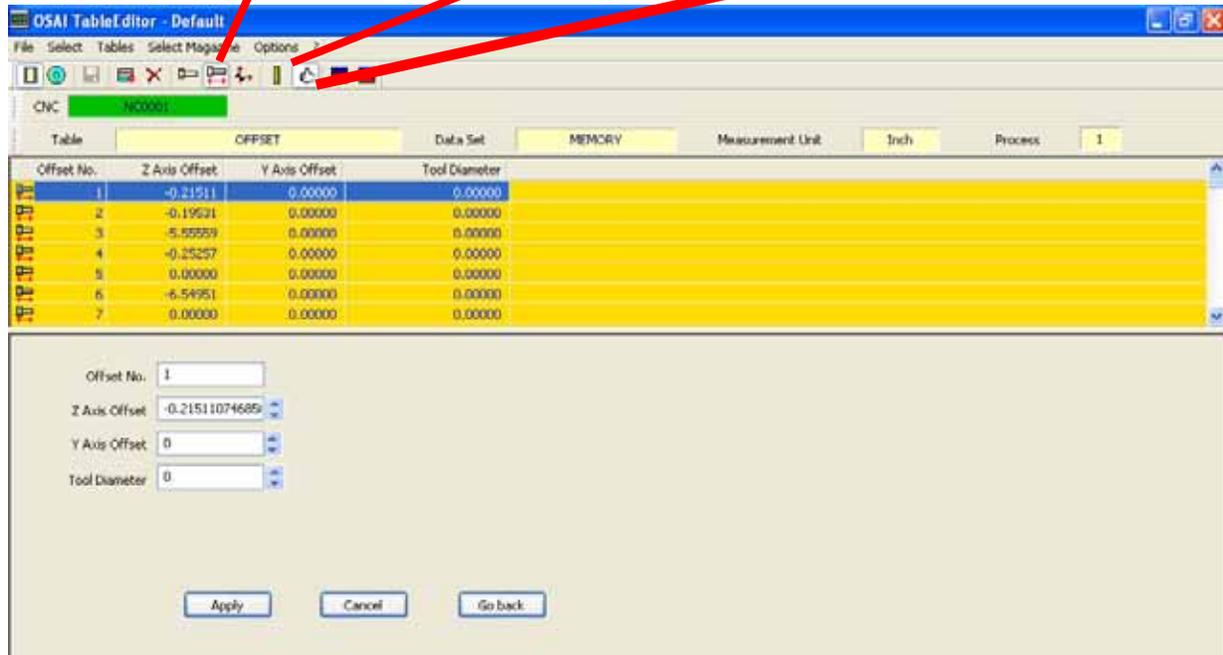
13. Press the CNCVision icon again to exit the Cnc Vision screen.



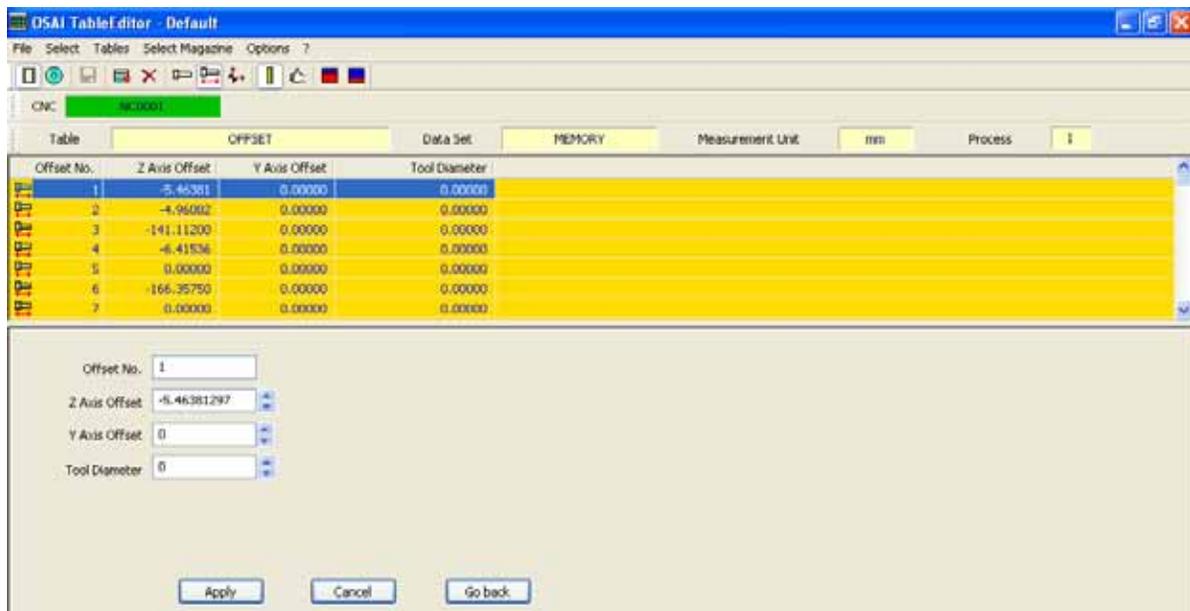
14. In the main Techno screen, select the Table Editor icon to open the Table screen.



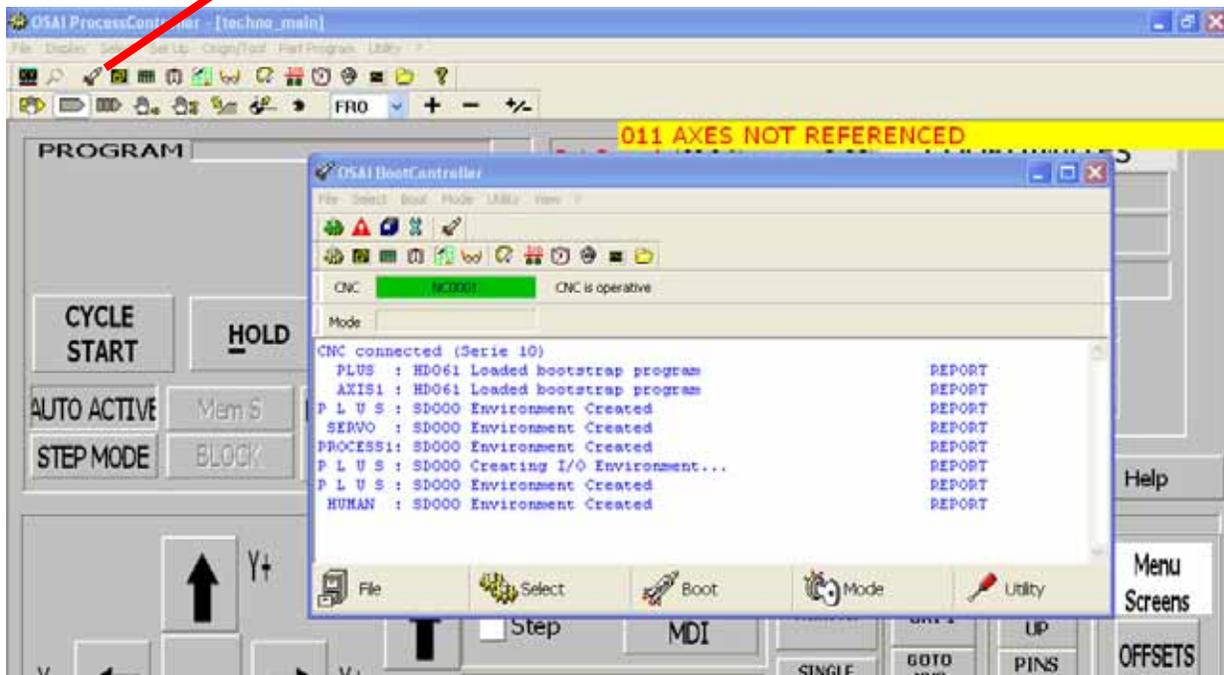
15. Click on the Tool lengths, and select the Ruler Icon for mm, and the Thumbs up icon for inches.



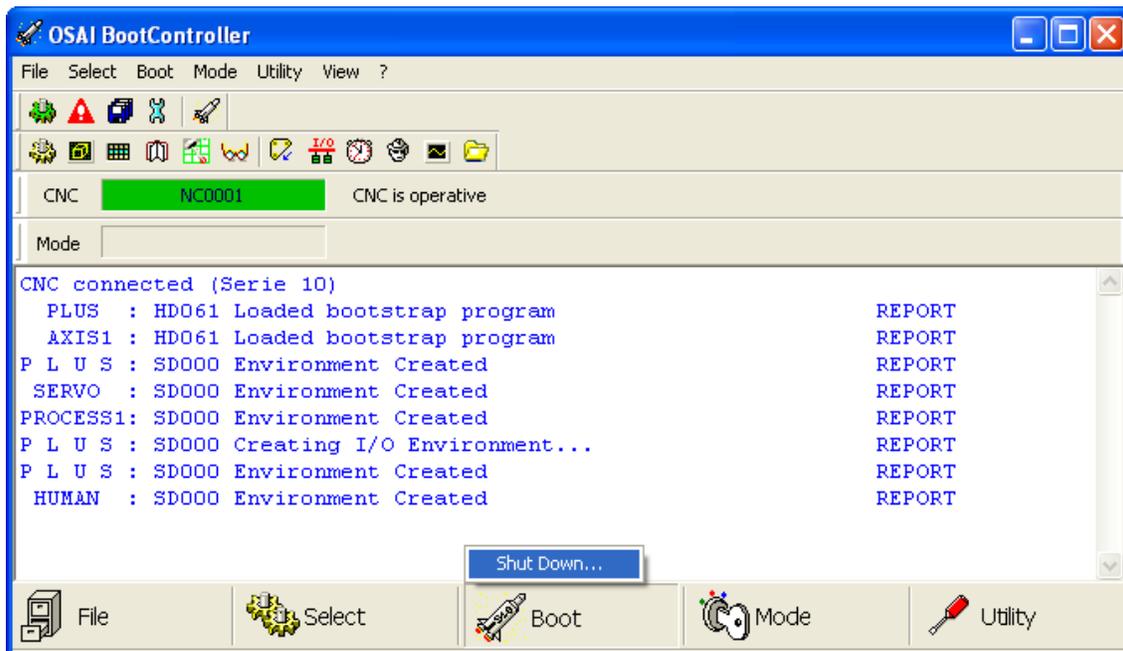
16. When the required unit is selected, exit out of the screen by closing (X-ing) the window.



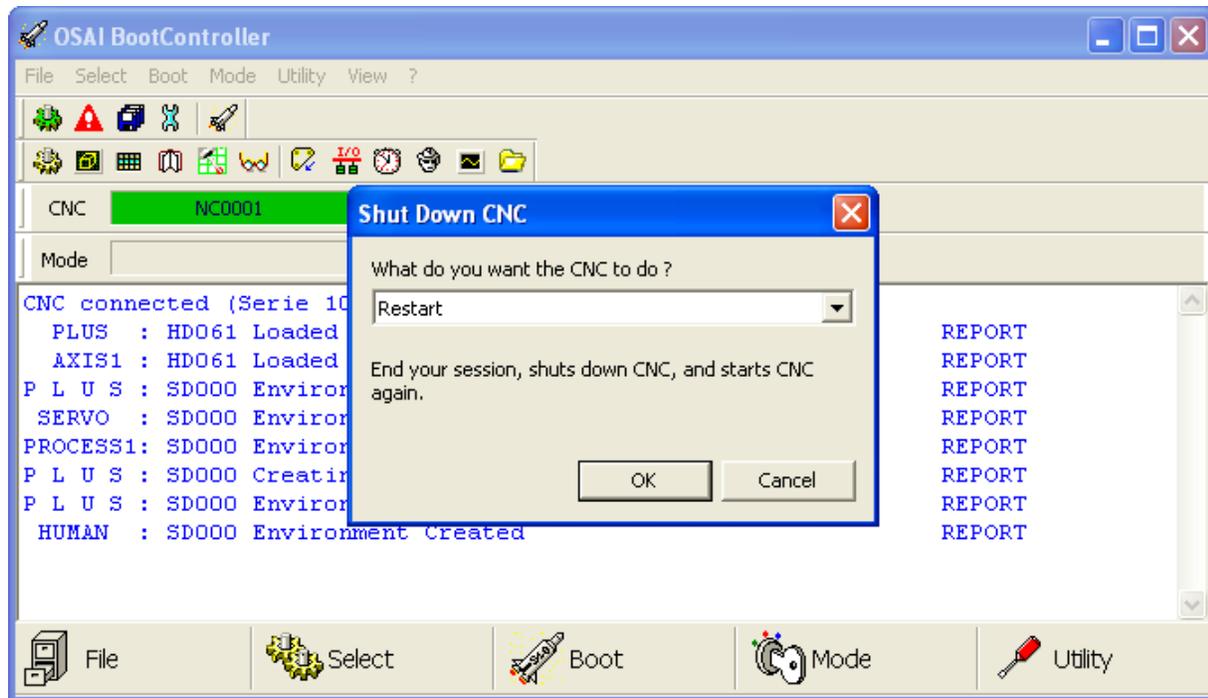
17. Select the Boot Icon (Rocket,) to open the Boot Controller screen.



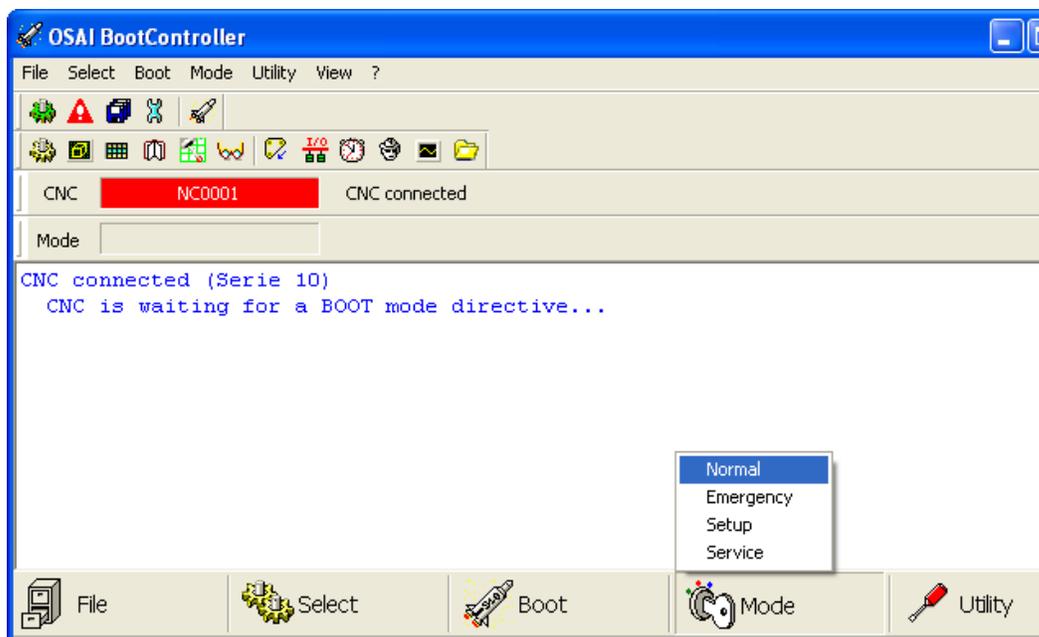
18. Click on Boot on the bottom of the window and select Shut Down...



19. Select Restart to reboot the controller. Click OK.



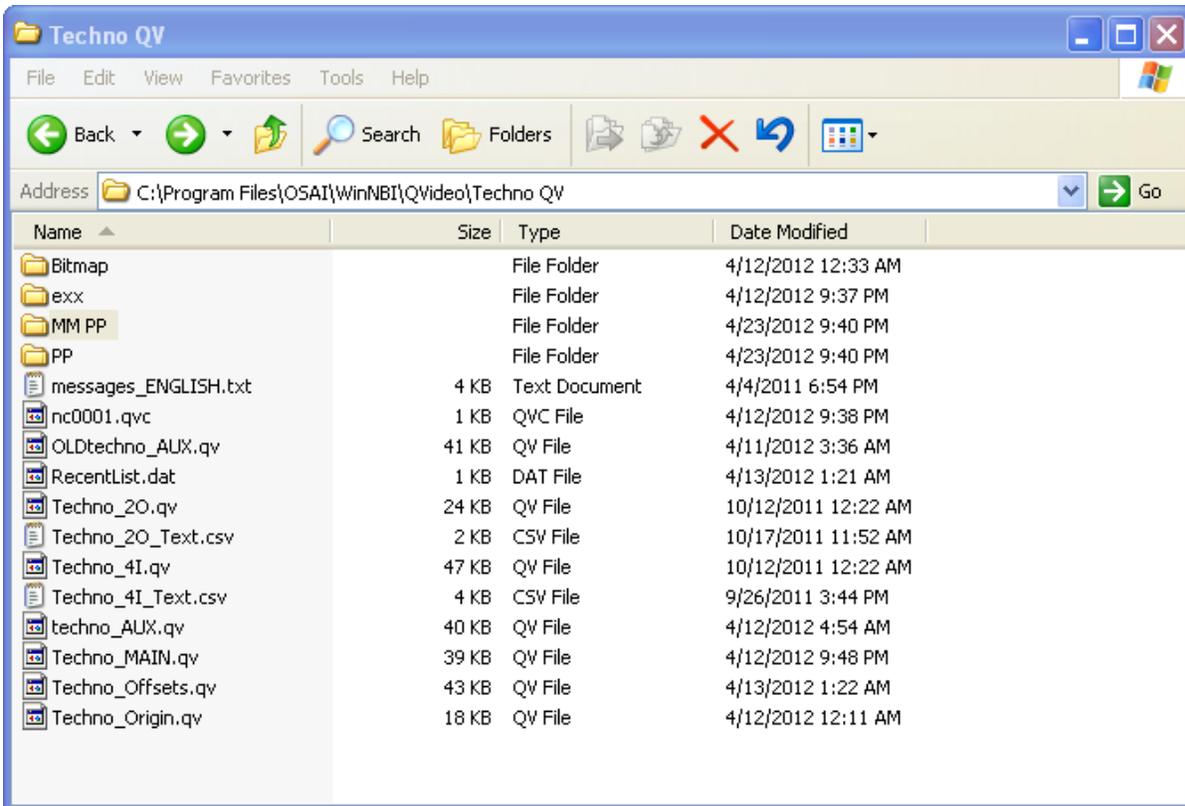
20. The controller will start to reboot, click on Mode and select normal to boot in Normal mode.



21. The controller will now boot in your selected units.

22. Go into the folder

C:\Program Files\OSAI\WinNBI\QVideo\Techno QV\



Rename the folder "PP" to "Inch PP"

If the folder "MM PP" is not present copy it into this location and rename it "PP"

Everything is now set for metric units.

NOTE: Perform tool changes on all locations at a slow speed to see that they function correctly. Also perform the Z tool length/Tool Offset functions slowly at first.

If they do not function correctly, copy the macros from the Zip folder into Upp\MACROS\ network drive.

P01M401 is for Tool Lengths.

P01M006 is for Tool locations.