<center>**U1000 Editor – Marker Setup**</center>

INTRODUCTION

This document describes how to add a Queued Marker with a custom Sub String (i.e. custom date code or part serial number). There are two areas of the U1000 Editor that have to be setup; they are, the Control Interfaces and Data Stores.
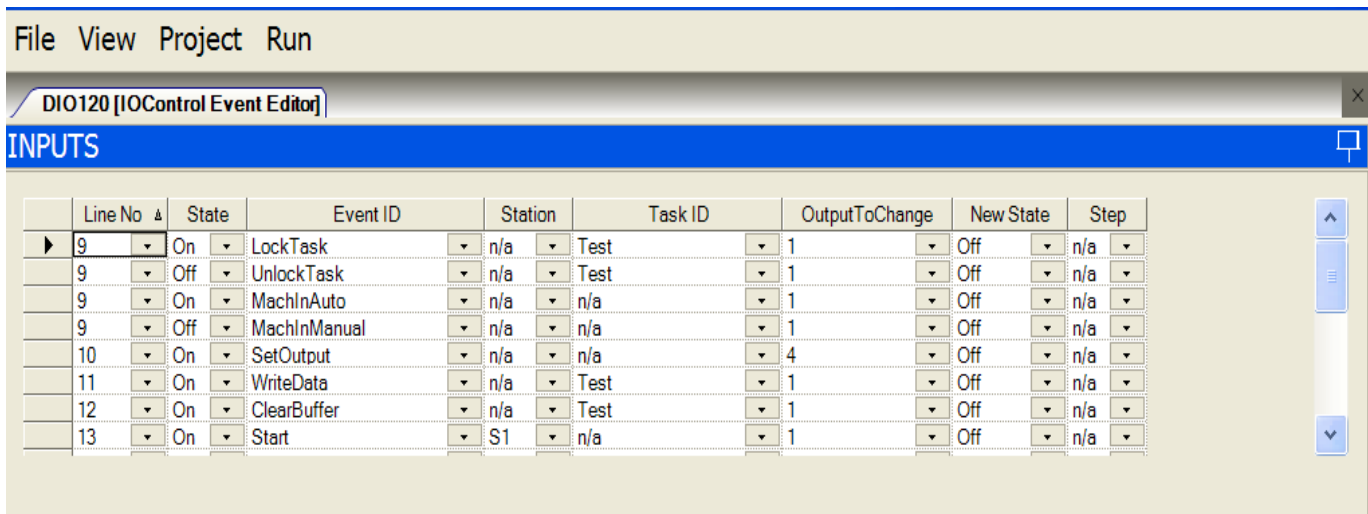
Opening a VMP to Edit

1. Using the Windows Start button, select All Programs
2. Navigate to the VerimetU1000 folder and double click the U1000 Editor Application button.
3. Click the File menu button.
4. Click on "Open" and select the VMP to edit.

Note: It is a good practice to make and save a copy of the VMP prior to editing.

Control Interface

1. Open the Project Explorer if it is not visable (Click View and Project Explorer)
2. Right click on the DIO120 and select Edit.
3. Add Input lines WriteDate Line 11 and ClearBuffer line 12. See below.

File   View   Project   Run

DIO120 [IOControl Event Editor]

INPUTS

	Line No ▲	State	Event ID	Station	Task ID	OutputToChange	New State	Step
▶	9	On	LockTask	n/a	Test	1	Off	n/a
	9	Off	UnlockTask	n/a	Test	1	Off	n/a
	9	On	MachInAuto	n/a	n/a	1	Off	n/a
	9	Off	MachInManual	n/a	n/a	1	Off	n/a
	10	On	SetOutput	n/a	n/a	4	Off	n/a
	11	On	WriteData	n/a	Test	1	Off	n/a
	12	On	ClearBuffer	n/a	Test	1	Off	n/a
	13	On	Start	S1	n/a	1	Off	n/a

Notes: 1.Lines 11 & 12 is the standard lines that Verimation Technology uses, but they could be any input line.
2.Inputs are controlled by others (i.e. PLC, Robot, etc.)
3. WriteData – 1 second pulse to print.
4. ClearBuffer – 1 second pulse to clear buffer, typically at the start of Automatic Cycle.
5. WriteData & ClearBuffer can not be on at the same time or when a Start is on.

Data Stores

1. Click on the Project pull down at the top of the Editor screen.
2. Navigate to Add Date Store and select Queued Marker.
3. A popup block will appear, type in the name for the marker and click OK.
4. The Queued Marker Editor will automatically open. To open the marker editor after it has been closed, use the Project Explorer to navigate to the marker, right click on the marker and click the Edit button.
5. Select the COM Port to be used. Note: COM 1 & 2 are reserved for Temperature Compensation and Touch Screen, respectively.
6. Select the Baud Rate; it must match the Baud Rate of the device you want to communicate with, typically set at 9600.
7. There are four option that you can check, they are:
   a. Write to Debug File And Show Write Button
   b. Queue For Accept Parts Only
   c. Queue in Auto Only
   d. Queue on Result Events Only
8. Set the SendString Delay, typically 100milliseconds.
9. Assign the Sub Strings to print. Each Sub String must have a Type, Value and Format. Use multiple SubStrings to create a custom string.
10. The example below will print the following string "090602135510" if:
    a. Year 2009
    b. Month June
    c. Day 2nd
    d. Hour 1pm
    e. Minute 55
    f. Second 10
    g. CarriageR – carriage returned required by marker

File   View   Project   Run

Queue Marker Editor [Telesis Marker]   ×

COM Port: [COM3 ▼]   Baud Rate: [Baud_9600 ▼]   ☑ Write To Debug File And S

☑ Queue For Accept Parts Only   ☑ Queue In Auto Only   ☐ Queue On Result Events (

SendString Delay: [100]   milliseconds

SubStrings

	Type	Value	Format
▶	Attribute ▼	TimeStam ▼	Year2 ▼
	Attribute ▼	TimeStam ▼	MonthLetterNo1 ▼
	Attribute ▼	TimeStam ▼	Day2 ▼
	Attribute ▼	TimeStam ▼	Hour2 ▼
	Attribute ▼	TimeStam ▼	Minute2 ▼
	Attribute ▼	TimeStam ▼	Second2 ▼
	ControlChar ▼	CarriageR ▼	n/a ▼
		▼	▼

Sub Strings – Type, Value, & Format

Types, the following types are available:
> Text
> Attribute – Typically a Timestam, Lathe, Date, or Time
> Delimeter – Can be a Comma, Tab, Space or None
> ControlChar - Typically a Nul, LineFeed, FormFeed, CarriageReturn, ESC, or
> Ctrl_A - Z
> SendString
> QueueString

Value, the following values are available:

Type	Value	Format
Attribute	Timestam, Lathe, Date, or Time	n/a, LastYearDigit, Year2, Year4, DayofYear, DayofYear3, Month, Month2, MonthLetter, MonthLetterNol, Day, Day2, Hour, Hour2, Minute, Minute2, Second, Secon2
Delimeter	Comma, Tab, Space or None	n/a
ControlChar	Nul, LineFeed, FormFeed, CarriageReturn, ESC, or Ctrl_A, Ctrl_B, Thru Ctrl_Z	n/a
SendString	n/a, LastYearDigit, Year2, Year4, DayofYear, DayofYear3, Month, Month2, MonthLetter, MonthLetterNol, Day, Day2, Hour, Hour2, Minute, Minute2, Second, Secon2	n/a
QueueString	n/a	n/a