

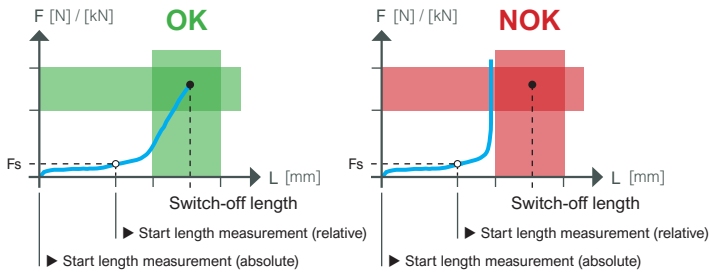
# MultiPro 3G

## Press-In Procedures & Process Functions

The available press-in procedures define the sequence and monitoring of the press-in process. Additional process functions extend the standard functionality and enable application-specific customization.

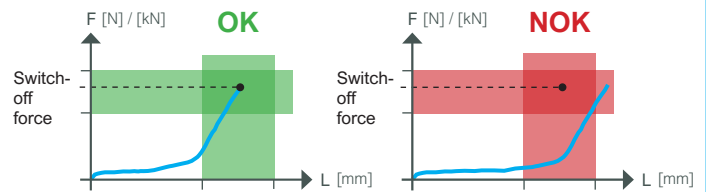
### Move to Length

Press-in until switch-off length is reached. Control of force.



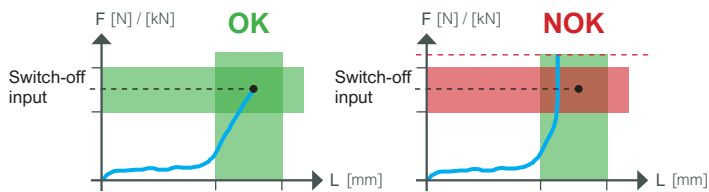
### Move to Force

Press-in until switch-off force is reached. Control of length.



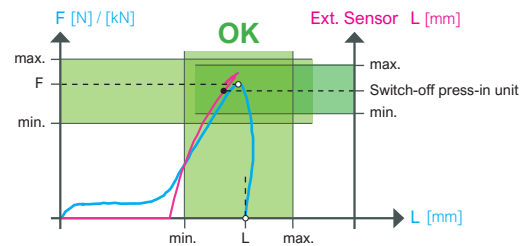
### Move to Initiator

Press-in until a signal is active at the defined switch-off input. Control of force and length.



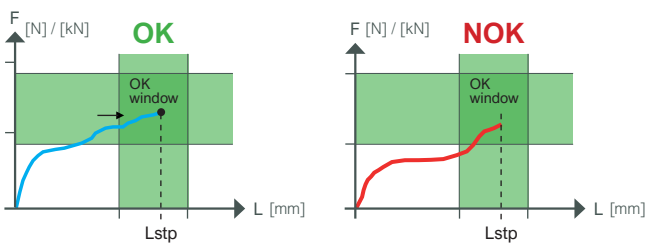
### Move to External Sensor

Press-in until a defined external target position is reached with monitoring of force and length.



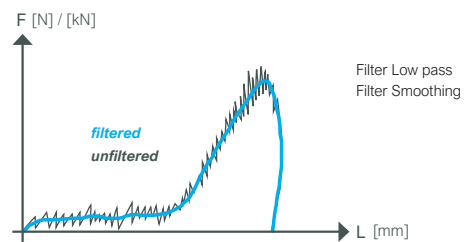
### Force Progression in OK Window

Monitors the entry of the force/length into the OK window. Entry must be from the left and remain within the OK window in the further procedure.



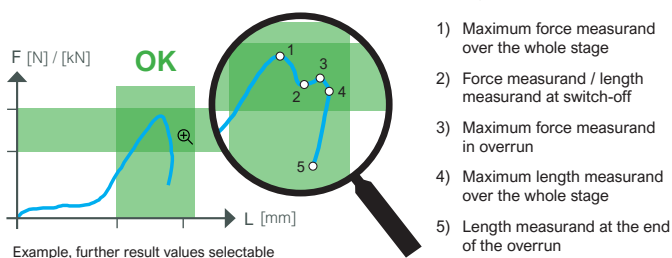
### Filter

With the DSM filter functions it is possible to blend out unwanted interferences of the process sequence.



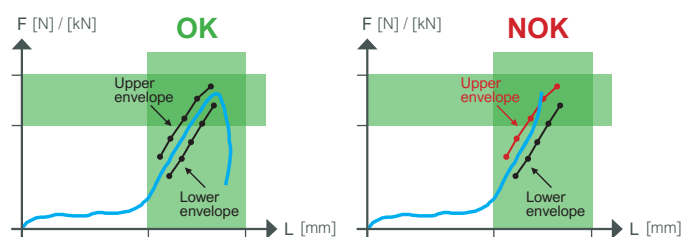
### Result Selection Force / Length / Ext. Sensor

With the result selection you specify the result values for the evaluation of the process. This will evaluate the result relevant to your process.



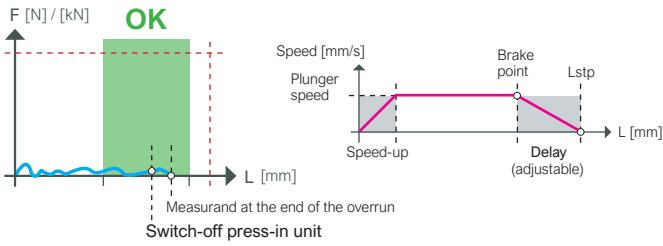
### Envelope Monitoring

Additional evaluation element for control of the press-in process. The measuring curve may not break the upper and/or lower envelope.



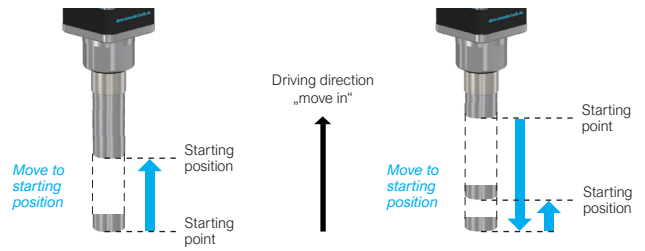
### Move Empty

The plunger of the press-in unit is moved without a defined force until it reaches a defined target position (switch-off length).



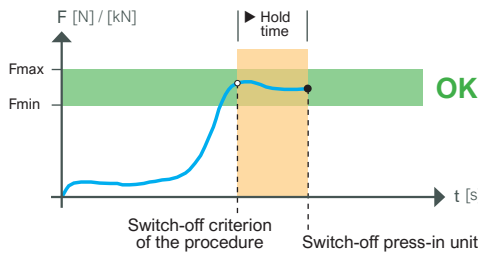
### Move to Starting Position

Moves the plunger of the press-in unit to the user defined starting position – to avoid long strokes.



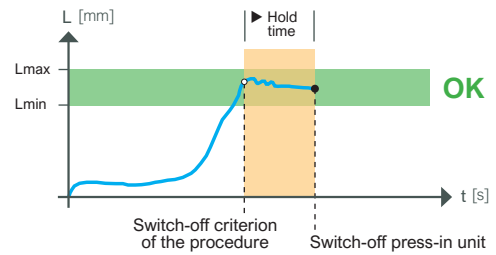
### Hold Mode Force

After reaching the switch-off criterion, the force measured at this time is held for a defined period of time.



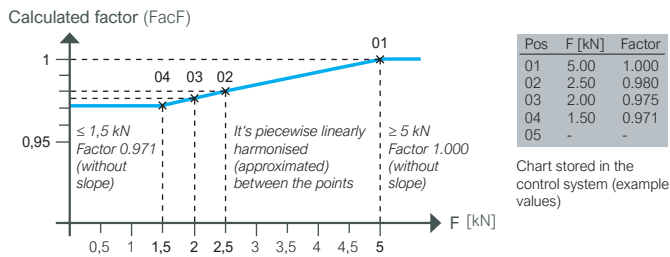
### Hold Mode Position

After reaching the switch-off criterion, the position (length) measured at this time is held for a defined period of time.



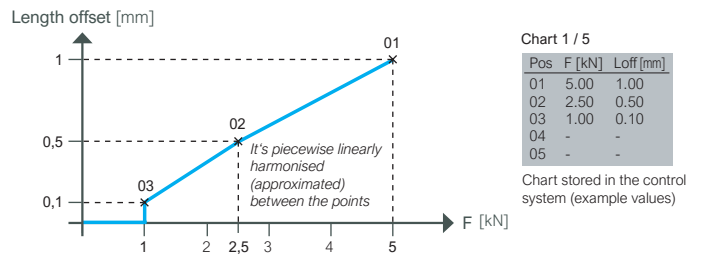
### Linearisation Force

Non-linearities of the characteristic curve between reference value and displayed value are piecewise linearly approximated with the force linearisation.



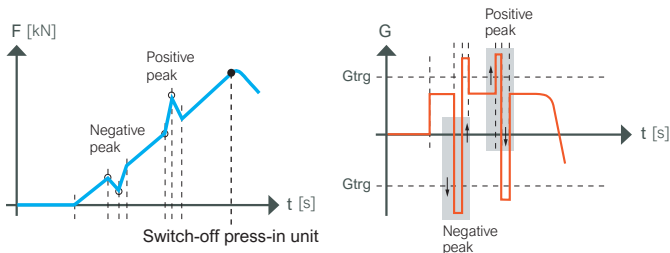
### Linearisation Length

The physically caused elastic fractions (bending up, setting, etc.) in the assembly process can be compensated with the length linearisation.



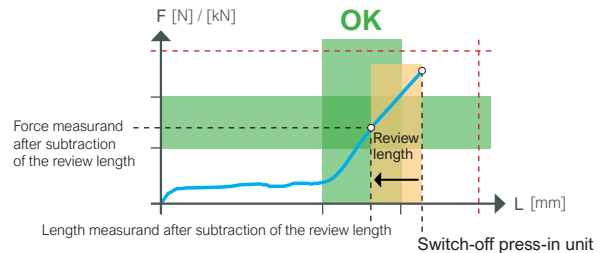
### Gradient Detection

Function for detection of a defined gradient – detects positive as well as negative peaks and their quantity.



### Review Length

The evaluation of the procedure is done at the position resulting after subtracting the defined review stroke.



#### Document Information

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