**XL200 SERIES QUICK SHEET**

**PROGRAM AN ORDER**
1. Press [Program].
2. Press [End].
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.

**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].

**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.
5. Repeat for any other items.

**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].

**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.

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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
1. Select the bundle item currently running.
2. Press [Inc. Qty.] (Increment Quantity).
3. (Eclipse users only) Select scrap code from the pop-up menu.
4. Select [OK] to accept the scrap code.
5. 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.

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