



Technical Documentation
opti-check

Content

1	Welcome.....	6
2	Imprint	7
3	Safety instructions.....	8
4	Correct Use.....	11
5	Mode of operation.....	12
6	Installation and initial setup.....	14
6.1	Mechanical setup.....	14
6.2	Electrical installation	16
6.3	Wiring.....	17
6.3.1	Notes on using an incremental encoder	18
6.4	Software installation	20
6.5	Initial setup of the Ethernet interface on your computer.....	22
6.6	Notes on using gateways	24
6.7	Important network terms.....	25
6.8	LED panel.....	26
7	Overview of the Application Suite.....	27
7.1	Operating modes of the device	28
7.2	Help, info and support	29
8	Image display options	30
8.1	Images from PC.....	31
8.2	Defect images.....	32
8.3	Loading, saving and recording images.....	33
8.4	Job features	35
9	Creating a job	36
9.1	Adjusting the image (image focus)	36
9.1.1	Adjusting the image (additional parameters)	38
9.1.2	Coordinates (device-dependant).....	43
9.1.3	Focus	46
9.1.4	White balance (device-dependant)	47
9.2	Checking features.....	48
9.3	Configuring interfaces.....	54
9.3.1	Occupancy of digital I/Os	54
9.3.2	Timing digital I/Os	58
9.3.3	Output process interface (device-dependant).....	61
9.3.4	Input process interface (device-dependant)	65
9.3.5	Web interface	68
9.4	Device activation	69
9.4.1	Statistics / Details	70
10	Device menu	71
10.1	Connect to device.....	72
10.2	Device settings... ..	77
10.2.1	Device name	78

10.2.2	Access rights (device-dependant)	79
10.2.2.1	Application Suite	79
10.2.2.2	Web interface	80
10.2.3	Customizing web interface	81
10.2.3.1	Functions	81
10.2.3.2	Design	84
10.2.4	Digital I/Os	85
10.2.5	Alarm signal	87
10.2.6	IP address / Network	88
10.2.7	Process interface (device-dependant)	89
10.2.8	FTP	91
10.2.9	Job management	93
10.2.10	Job selection / Teach	95
10.2.11	Illumination controller (device-dependant)	96
10.2.12	Firmware update	99
10.3	Backup	101
10.3.1	Backup - using the PC	102
10.3.2	Backup – using the FTP server	103
10.3.3	Backup – restoring from the PC	104
10.3.4	Backup - restoring from the FTP server	106
10.4	Digital I/O Assistant	107
10.5	Process interface assistant (device-dependant)	109
10.6	Operating mode display	111
11	Job menu	112
11.1	Create new job	113
11.2	Load job from PC	114
11.3	Load job from device	115
11.4	Save job to PC	116
11.5	Save to the device	117
11.6	Test job	118
11.6.1	Test Protocol – Overview	121
11.6.2	Test Protocol – Statistic	122
11.7	Result and user display	123
12	Feature checks	124
12.1	Part location	125
12.1.1	Part location on contours	125
12.1.2	Part location on edges	128
12.1.3	Part location on circle	130
12.1.4	Part location on text line	132
12.2	Geometry	134
12.2.1	Distance	134
12.2.2	Circle	137
12.2.3	Angle	140
12.2.4	Count edges	143
12.2.5	Point position	146
12.2.6	Edge characteristics	148
12.3	Feature comparison	154
12.3.1	Count contour points	154
12.3.2	Contour comparison	156
12.3.3	Color identification	159

12.3.4	Brightness	164
12.3.5	Contrast.....	166
12.3.6	Area size	168
12.3.7	Area size (color)	171
12.3.8	Color positioning	176
12.3.9	Count areas.....	181
12.3.10	Count areas (color)	184
12.3.11	Pattern comparison.....	189
12.3.12	Pattern comparison (older version).....	192
12.3.13	Pattern comparison (color).....	194
12.4	Identification	197
12.4.1	Barcode.....	197
12.4.2	Barcode (color).....	201
12.4.3	Matrix code.....	205
12.4.4	Matrix code (color)	209
12.4.5	Text.....	214
12.4.6	Text (color)	219
12.4.7	Appendix: Quality characteristics for barcodes and matrix codes	224
13	Digital interfaces	226
13.1	Explanation of terms from the timing diagram.....	226
13.2	Timing when an external trigger is used.....	227
13.3	Timing for continuous image acquisition	228
13.4	External Teach	229
13.5	Job switching	230
13.6	Job selection via digital inputs	231
13.6.1	Binary job selection	232
13.6.2	Bit serial job selection	233
13.7	Alarm signal.....	235
14	Web interface.....	236
14.1	Supported browsers	237
14.2	Connecting to the web interface.....	237
14.3	Device specific functions	240
14.4	Job specific functions	242
14.4.1	Image acquisition	244
14.4.2	Part location	244
14.4.3	Geometry	245
14.4.4	Feature comparison	245
14.4.5	Identification	247
14.5	Functions selectable via the address bar	249
14.5.1	Language selection.....	249
14.5.2	Scaling down the transferred image	249
14.5.3	Live image.....	250
14.5.4	Defect images	251
14.5.5	Static images.....	252
14.5.6	Setting the display screen	254
15	Communication via the process interface (device-dependant)	255
15.1	Process interface via TCP/UDP (device-dependant)	255
15.1.1	Configuration of the Ethernet interface	255
15.1.2	Protocol structure – Ethernet	256

15.2	Process interface via RS485 (device-dependant)	256
15.2.1	Configuration of the RS485 interface	256
15.2.2	Protocol structure – RS485	257
15.3	General Information	260
15.3.1	General description of data formats	260
15.3.1.1	Integer	260
15.3.1.2	Float	260
15.3.1.3	Text	260
15.3.1.4	Composite data type: Integer	261
15.3.1.5	Composite data type: Float-Point	261
15.3.1.6	Composite data type: List	262
15.3.2	Numeric values in commands	262
15.3.3	Conversion Table Decimal ↔ Hexadecimal ↔ Character	263
15.3.4	Receive timeout	264
15.3.5	Response delay	265
15.4	Available commands for TCP / UDP / RS485	266
15.4.1	CS command –reset statistics	266
15.4.2	Command GB – access device backup	267
15.4.3	GD command – retrieve last result	268
15.4.4	GF command – access individual data on the device	271
15.4.5	GI command – access an image (only via Ethernet)	272
15.4.6	GM command – access information about the device	273
15.4.7	GP command – access the current configuration of the SP command	274
15.4.8	GS command – request status	275
15.4.9	SJ command – change to a different job	277
15.4.10	SM command – change operating mode	278
15.4.11	SP command – set parameters for the feature checks	280
15.4.12	TE command – use next image for external teach	283
15.4.13	TR command – request image acquisition and response datagram	285
15.4.14	TI command - trigger immediately	286
15.4.15	TD command – request image acquisition and transfer data	287
15.4.16	UD command – transfer backup data (only for Ethernet)	288
15.4.17	UJ command – transfer a new job	290
15.4.18	VB command – restart device	291
16	Cleaning	292
17	Technical data	293
17.1	Overview of feature checks	293
17.2	Overview Features	294
17.3	Type code	295
17.4	Technical drawing (except OC53962X / OC53972X)	296
17.5	Technical drawing (OC53962X / OC53972X only)	297
17.6	Technical drawing (OC5394V0 only)	298
17.7	Fastening bracket, 90 degree	299
17.8	Fastening bracket, straight	300
17.9	Technical data	301
17.10	Electrical Connection (View on Device)	303
17.11	Power Cable M12 / 12-pin	304

1 Welcome

Welcome to the Help Guide.



Please read these operating instructions carefully and observe the safety instructions!

Target group:

These operating instructions are intended for users that want to perform feature checks with the Vision Sensor.

2 Imprint

ipf electronic gmbh

Kalyer Straße 25-27
58515 Lüdenscheid

Tel: 02351 / 9365-65
E-Mail: hotline@ipf.de

Version 2.6.3

04/2014 Issue

All rights reserved. Reproduction of this document in whole or in part is only permitted with previous written consent from ipf electronic GmbH.

Revisions in the course of technical progress and possible errors reserved.

3 Safety instructions

Explanations of safety instructions

**NOTE**

Gives helpful notes on operation or other general recommendations.

**ATTENTION!**

Indicates a possibly dangerous situation. If this is not avoided, slight or minor injury could result or the device may be damaged.

**WARNING!**

Indicates an immediate imminent danger. If this is not avoided, death or serious injury may occur.

General notes / Safety instructions for the Vision Sensor

**NOTE**

There is a scratch-resistant foil on the glass cover of the tube for devices with interchangeable lenses. Remove the foil before carrying out inspection tasks.

**NOTE**

For optimum electrical noise immunity, the use of shielded cables is recommended.

**NOTE**

Networking problems can occur for a number of different reasons, such as power saving modes on portable computers, defective cables or other defective components, or incorrect settings on the PC. Should an error occur, contact a technician to locate the source of the problem.

NOTE

Characters allowed in file names and job names:



0123456789ABCDEFGHIJKLMNOPQRSTUVWXYZabcdefghijklmnopqrstuvwxyz
 ÀÁÂÃÄÅÈÉÊËÌÍÎ
 àáâãäåèéêëìíî
 ĐÑÓÔÕÖÙÚÛÜÝß
 ðñòóôõöùúûüýÿÇ,
 !"#%&'+-÷×±,.
 i@_`(){}«»~

ATTENTION!



Connection, installation and initial setup may only be carried out by specialized personnel. Protect optical areas from moisture and dirt.

ATTENTION!



The IP protection class is only valid if **all** connectors are connected as described in the technical documentation and, for protection class IP 69K devices, if the sealing screw on the lens setting opening is correctly screwed in.

ATTENTION!



The device may become warm during operation. High temperatures may damage the device. Ensure that any heat generated is dispersed by installing it with the rear to a good heat conductor (metal). The housing temperature must not exceed 50°C.

ATTENTION!



Incorrect supply voltage will destroy the device!

Pin 1: Power (+18...30 VDC)
 Pin 2: Ground

ATTENTION!



The device can become damaged by strong radiation or electrical fields. For this reason, never place the device near strong radiation sources or strong electrical fields. These can occur in close proximity to lasers, for example.

ATTENTION!

The Vision Sensor is a class A device (DIN EN 55022:2011). It can cause radio interference in residential environments. Should this happen, you must take reasonable measures to eliminate the interference.

WARNING!

The device emits bright, pulsed light (Risk group 1, low risk, EN 62471:2008). Bright, pulsed light can cause damage to the eyes and seizures. Never look directly into the pulsed light from the LEDs!

**For devices with infra-red illumination****NOTE**

The device uses LED illumination of the risk group RG 0 (exempt group, no risk) as per IEC/EN 62471.

The radiation of the LEDs does not pose a hazard to the human eye if the device is used for its intended purpose.

Even so, do not look directly into the light source – there is a danger of dazzle and irritation. Mount the device so that it is not possible to look directly into the light source.

4 Correct Use

Depending on the device, the Vision Sensors in combination with the *Application Suite* software are used to monitor and verify:

- Completeness
- Presence
- Position
- Correct position
- Barcode and matrix code
- Numbers and characters
- Color features

e.g. for objects passing the Vision Sensor on conveyor belts.

You can find an overview as to which Vision Sensors check which features under: *Technical Data (Overview of feature checks)*.



NOTE

The color devices are suitable for tasks such as sorting objects by color. They are not suitable for measuring colors or determining color deviations (ΔE).



ATTENTION!

Only use the Vision Sensor for its intended purpose! The guarantee becomes void in the case of any application not described in the technical documentation!

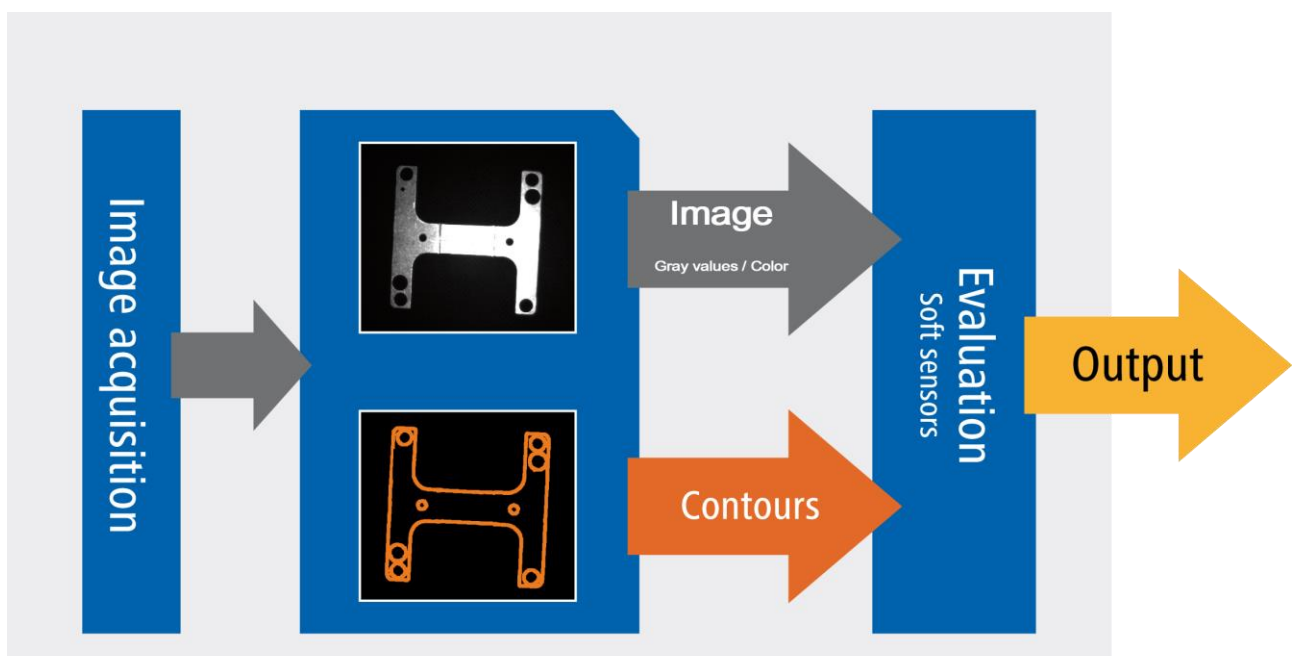
5 Mode of operation

In contrast to conventional optical sensors, this sensor operates with digital images and is capable of conducting several feature checks with parameters set via the software.

The strength of the device lies in the detection of contours. With the procedure, differences in brightness can be optimally tolerated, as contours are usually independent of the absolute brightness (e.g. variations in illumination).

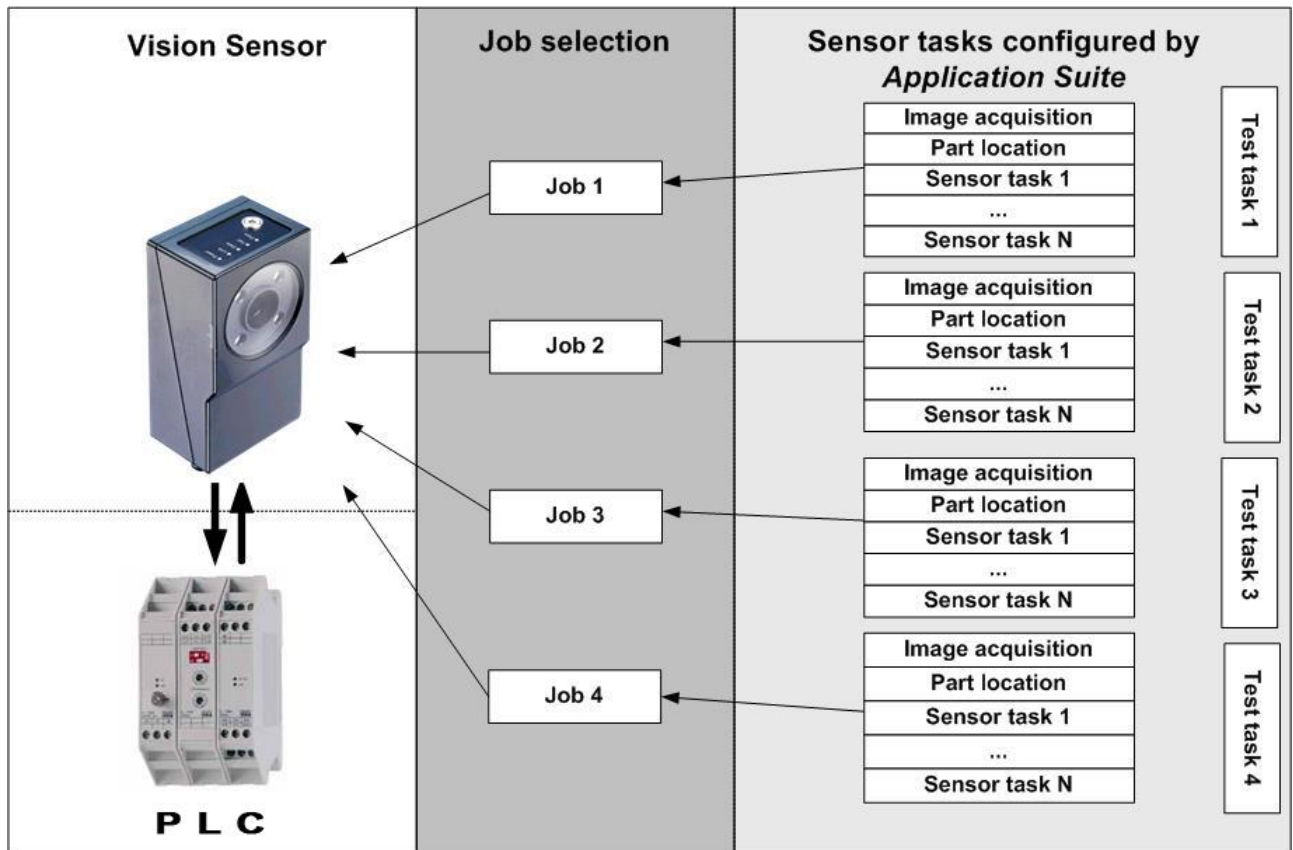
Because a test object can normally be definitively described by its relevant contours, the device provides powerful tools to check their presence, position, completeness or color. The high quality of the method ensures that a reliable result is always achieved even with a rapid sequence of objects.

The diagram shows the schematic mode of operation with the corresponding parts of the sensor.



Here, each inspection task ("job") is divided into several *feature checks*. Each feature check executes one task and returns an associated pass/fail result or the associated measured values. For this purpose, a field of view must be defined that is either circular, an arc, rectangular or polygonal. The contours can be given via search arrows for geometrical feature checks.

Then you can link the results from the feature checks into one result and output it via a digital interface. With the device, the stored jobs can be selected via external switching inputs.



The device has two operating modes:

- *Activated*
- *Configuration*

In *activated* mode, the inspection task is conducted. The device operates autonomously in this mode and can communicate directly with a PLC. The device receives all commands such as trigger or job number from the external control system and mainly returns a pass or fail result. In *Activated* mode, you can also use the *Application Suite* to monitor your inspection tasks.

In *Configuration* mode, you can configure and set the parameters for the jobs and features to be checked. This is conducted using the *Application Suite*.

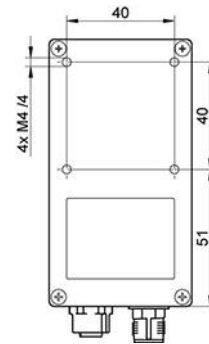
Because a high-quality digital image provides many means of visual inspection, the parameters of the jobs have to be set according to the inspection task and the application. For this purpose, the *Application Suite* provides a pre-configured input mask for each feature to be checked, which helps to identify the optimum settings.

6 Installation and initial setup

6.1 Mechanical setup

You can operate the device in any position.

Attach the device to the M4 screws provided for this purpose.



Align the device so that the image centre indicated below points directly at the object to be inspected.

The device should be installed so that it vibrates as little as possible during operation to avoid negative influences on the image quality (blurred images).

Install the device so that there are no obstacles between the sensor and the object that could block the view or cause reflections. Ensure that the device is protected as well as possible against dust.

The device and its built-in lens can inspect fixed areas at fixed distances. For this purpose, there are two variants with different focal distances of the optical systems ($f = 10 \text{ mm}$ and $f = 16 \text{ mm}$).



NOTE

The field of view for devices with interchangeable lenses depends on the lens used.



ATTENTION!

Devices with protection class IP 69K must be mounted with the rear side against a good conductor of heat (metal) to draw away the warmth created.

Install the device so that water never gets blocked and can drain away.

The tables below contain the maximum fields of view:

Lens	f = 10 mm
Object distance	Max. inspection area
50 mm	26 mm x 17 mm
100 mm	50 mm x 32 mm
200 mm	98 mm x 62 mm
300 mm	145 mm x 93 mm

Lens	f = 16 mm
Object distance	Max. inspection area
70 mm	18 mm x 11 mm
100 mm	26 mm x 17 mm
200 mm	55 mm x 35 mm
300 mm	84 mm x 54 mm



6.2 Electrical installation

For initial setup, you will require:

- the Vision Sensor,
- Installation CD for the *Application Suite*,
- a M12-connecting cable (not supplied)
- an Ethernet cable (not supplied)
- a normal PC with Ethernet interface (not supplied).



NOTE

For optimum electrical noise immunity, the use of shielded cables is recommended.



ATTENTION!

When connecting the power, ensure that all cables are connected correctly according to their color codes!

You will find the voltages necessary, the pin assignment and the corresponding electrical power under *Technical Data*.

Screw the 12-pin power cable with M12 plug onto the power supply connection on the device.

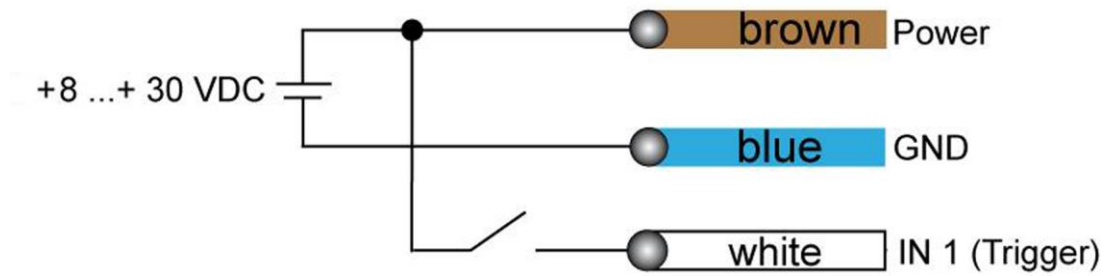


NOTE

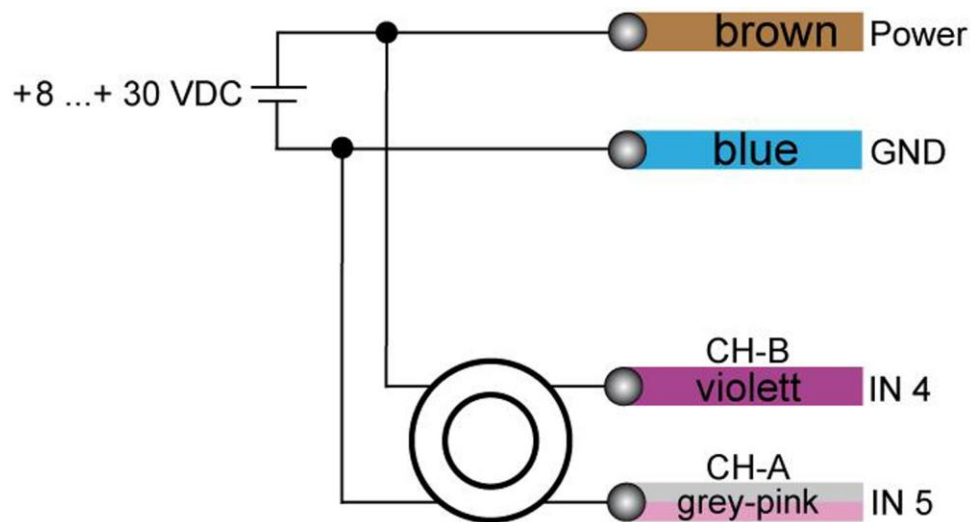
After installing the software, you can check the correct assignment of the digital connections in the menu: *Device* → *Digital I/O-Assistant*.

6.3 Wiring

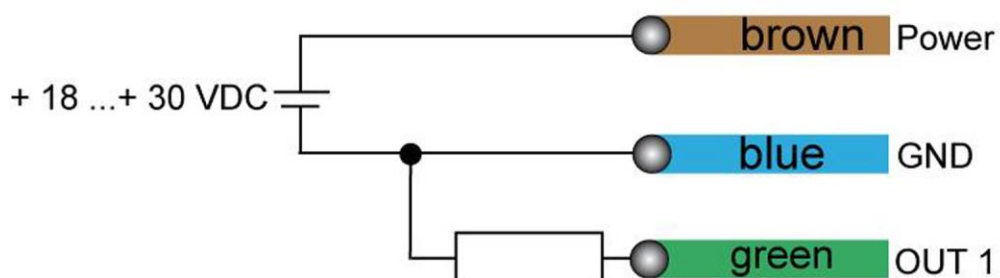
Input



Encoder




Output



6.3.1 Notes on using an incremental encoder

You have two options for operating the device with an encoder:

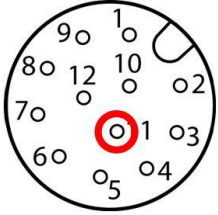
NOTE

 After installation, the inputs must be defined in the software using:
Device → *Device settings* → *Digital I/Os / Inputs* tab

- 1-channel operation (CH-A) In this mode, every **rising edge** of the signal corresponds to one pulse for the timing control of the device.
It is not possible to detect the travel direction of the belt.

The maximum frequency of 500 kHz should not be exceeded for reliable operation.





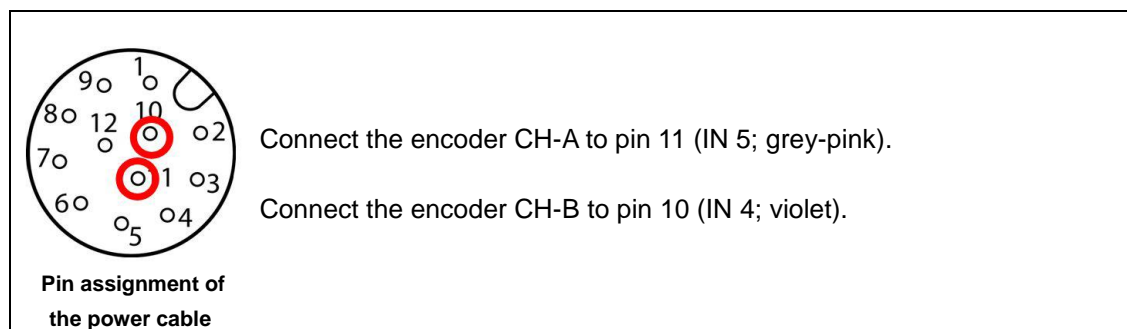
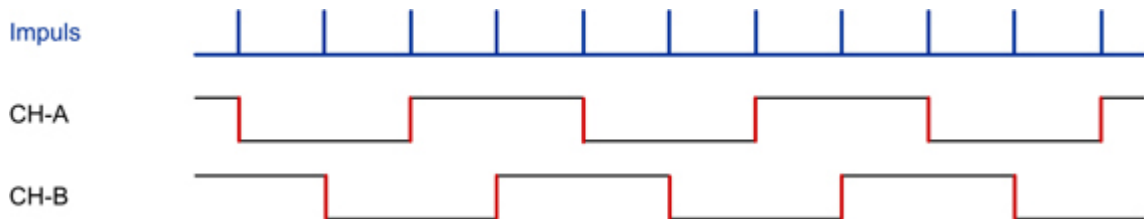
Connect the encoder CH-A to pin 11 (IN 5; grey-pink).

Pin assignment of the power cable

- **2-channel operation (CH-A and CH-B)** In this mode, every **rising and falling edge** of the signal corresponds to one pulse for the timing control of the device. The signals must alternate for the CH-A and CH-B channels.

It is possible to detect the travel direction of the belt.

The maximum frequency of 500 kHz/channel should not be exceeded for reliable operation.



6.4 Software installation

The following is a list of system requirements necessary for a proper operation of the *Application Suite*:

- **Operating system:** Microsoft® Windows® XP SP2, Microsoft® Windows® Vista (32 bit / 64 bit), Microsoft® Windows® 7 (32 bit / 64 bit), Microsoft® Windows® 8 (32 bit / 64 bit), Microsoft® Windows® 10 (32 bit / 64 bit)
- Processor: min. 500 MHz, 2 GHz recommended
- Memory: min. 512 MB RAM, > 1 GB recommended
- Hard disk: min. 150 MB of free disk space; including examples, about 400 MB
- **Display:** Resolution min. 1024 x 768 pixel, true color recommended
- **Network:** Network connection for 10 Base-T / 100 Base-TX or faster

NOTE

Please note that you will require administrator rights to install the *Application Suite* and device drivers; alternatively, you can use the version which does not require installation.



Currently the device officially supports the following browsers:

- Internet Explorer® 8/11 (not under Windows® CE 5.0)
- Firefox 43

Javascript and cookies must be enabled.

ATTENTION!



The IP protection class is only valid if all connectors are connected as described in the technical documentation and, for devices with protection class IP 69K, if the sealing screw on the lens setting opening is correctly screwed in.

Connect the device to the Ethernet interface of your computer or connect the device and your computer in a common network:



1. Start the set-up program from the CD and follow the installation instructions.
2. A link to the Application Suite will be made on your desktop. The software is launched by double clicking on this link.



3. Check the *network settings* to connect to the device.

When the device has been correctly connected and the software is successfully installed, the Vision Sensor can be setup using the software.

NOTE

You can launch the Application Suite using a command line parameter and automatically connect to the device via an IP address.

Example: `appsuite2.exe /ip=192.168.0.250` (default IP address)



There is also the option to launch the *Application Suite* in different languages using a command line parameter.

`/l=de` (German)

`/l=en` (English)

`/l=fr` (French)

Example: `appsuite2.exe /ip=192.168.0.250 /l=en`

(Start the *Application Suite* in English with the default IP address)


6.5 Initial setup of the Ethernet interface on your computer

1. Assigning an IP address

To use the device in your network, you must assign a unique IP address to the device. Below is the default factory configuration:

1. If you have a DHCP server integrated into your network, the IP address is requested from this server. No additional manual actions are necessary on your part.
2. If a valid IP address cannot be obtained within 15 seconds, the default IP address of **192.168.0.250** (subnet mask: 255.255.255.0) is used.

NOTE



To avoid network malfunctions, ensure that each IP address is unique within your network and has not already been assigned!

Now, link your PC into the same network as the device. Under certain circumstances, you may need to configure the IP address of your PC for this purpose. With Microsoft® Windows® XP, proceed as follows:

- 1) Open the "Start" menu and then move to "Settings > Control Panel > Network Connections".



- 2) Select your network (e.g., "Local Area Connection") and then the "Properties" entry in the context menu.
- 3) Select the "Internet Protocol (TCP/IP)" entry in the list of elements and then click the **Properties** button below the selection list. The following dialogue box opens:



Activate the **Use the following IP address** option and select an address in the range 192.168.0.xxx that has not yet been used for the IP address. Enter 255.255.255.0 for the subnet mask and confirm these settings.

NOTE

For device communication via Ethernet, the following ports are used:



- *Application Suite*: 51972 (default setting, programmable)
- Web interface: 80 („HTTP“)
- Process interface: 23 (default setting, programmable)

These ports must not be occupied by other programs or used for communication by the process interface!

Check that these ports are enabled in your firewall! You can find details on this topic in the firewall manufacturer's documentation.

6.6 Notes on using gateways

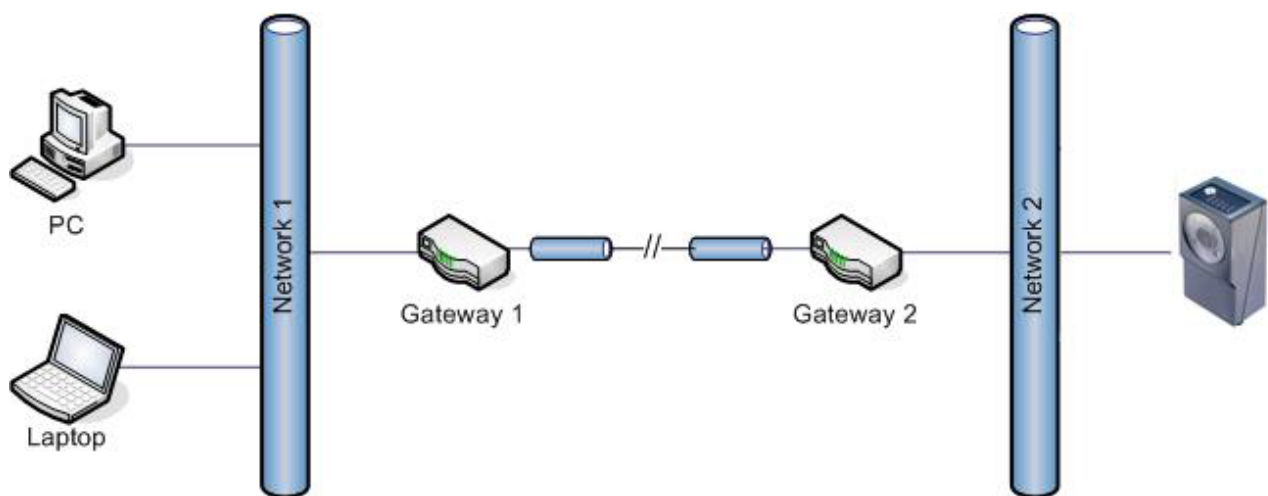
With this device, it is possible to establish a connection and to configure the device by way of a gateway.

NOTE



The public IP address of the device must be known in order to communicate across gateway boundaries. Automatic detection of the device is only possible in the local network.

To establish the connection, use the options in the selection list of available devices.



To do this, set your PC and the *device* as follows:

- **PC:** The gateway of the PC's local network (Gateway 1) must be set in the configuration of the network adapter.
- **Device:** The gateway of the device's local network (Gateway 2) must be set in the network configuration.

The following items must be kept in mind when an address conversion using NAT (Network Address Translation) is being used for at least one of the gateways:

- To connect the device using the *Application Suite*, you must specify the public address and port number of the **gateway** to which the device is connected (Gateway 2).
- A separate port for communications must be used in the device settings. You can find this setting under *Device* → *Device settings* → *IP address / Network*. Change the **Port** setting from *Standard* to the *desired port number*.
- Keep in mind that changes to the network settings of the device are only valid in the local network. If necessary, make sure that the NAT settings of the gateway are also configured to make communication possible.

6.7 Important network terms

ActiveX

Software technology from Microsoft® to extend programs with additional functions

DHCP – (*Dynamic Host Configuration Protocol*)

Protocol for automatic assignment of the ➔ IP addresses

Ethernet

Wired data network technology for local data networks

Firewall

Software that checks and prevents access via the network

HTML – (*Hypertext Mark-up Language*)

Document language describing the formatting of text and graphics

IP Address

"Mailing address" of a device in a network

Assignment of a ➔ MAC address to a specific network

JavaScript

Programming language for websites allowing, among other features, dynamic actions within websites

MAC-address – (*Media Access Control*)

6-byte address, hardware identification number for network devices unique throughout the world

Ping

Program for determining whether a computer is available in a network

Port

(Additional) address of data packets in a network

Describes the Internet services used, e.g., 21 – FTP, 25 – e-mail, 80 – websites (HTTP)

TCP – (*Transmission Control Protocol*)

Reliable protocol for data transfer

All data packets are transferred in the proper sequence

UDP – (*User Datagram Protocol*)

Faster but less reliable protocol for data transfer

Under certain circumstances, data packets may be lost or received in a different sequence

Domain-Name

arbitrary address that you enter into the address line of a browser in place of the IP.

6.8 LED panel



A screw and 5 LEDs are located on the Vision Sensor for displaying the various states.

Image focus setting screw: Used to set the image focus.



NOTE

For devices with interchangeable lenses, the image focus is set on the installed lens.

Power: indicates that the Vision Sensor is being supplied with electricity.

Link: indicates that the Vision Sensor is connected to the network.

Data: indicates that data is being transferred.

Fail: lights up when a feature check has been failed.

Pass: lights up when a feature check has been passed.

Pass/Fail flash quickly and alternately: Vision Sensor starts

Pass/Fail flash simultaneously: Vision Sensor is in Recovery mode

7 Overview of the Application Suite

The *Application Suite* is used for the initial setup, job creation, configuration, service and maintenance of the device. You can monitor the progress of the job in the *Activated* mode.



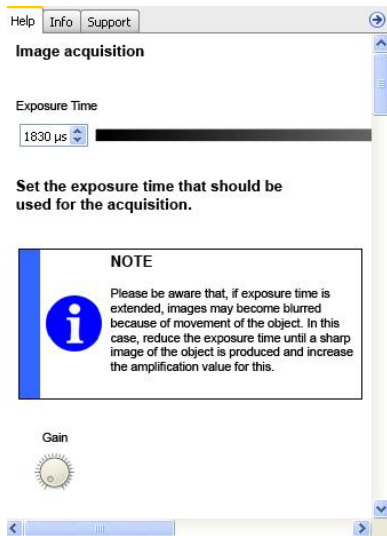
- 1 Image display options
- 2 Display screen
- 3 Help, info and support window
- 4 Job bar
- 5 Device menu / Operating mode display
- 6 Job menu / Result and user display
- 7 Parametrisation area

7.1 Operating modes of the device

The device has two operating modes which differ mainly in the allocation of the priorities:

	Mode	Priority	Job processing	I/Os
1	Activated	Trigger (Image transfer only when permitted by the processing time)	on <i>the</i> Vision Sensor	active
2	Configuration	Image transfer (trigger is ignored if necessary)	to the computer	inactive

7.2 Help, info and support



On the *Help* tab, there is a corresponding online help page for each dialogue.



The *Info* tab displays information about the system.

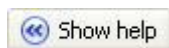
The image is an example and does not correspond to the current version of the software!



On the *Support* tab, there is a form for online support. You can attach images, jobs or log files to your support request.



With this button you have the option to hide the help.



With this button, you can show the hidden Help again.

i

NOTE

To improve clarity, the Help window is shown lightly greyed out when the mouse pointer is not over it.

8 Image display options

The following display options are available:



You can zoom into or out of the displayed image using the magnifier and adjust the image to fit the window.

If the image has been enlarged and can no longer be seen as a whole, you can select another clip by moving the area marked in red. The overview is only displayed if the entire image is not visible.

With these buttons you can switch:



the clockwise rotation of the image by 90° (angle of rotation is displayed in the status bar)



NOTE

The image will not appear rotated in the web interface.



the contour points display



the field of view display



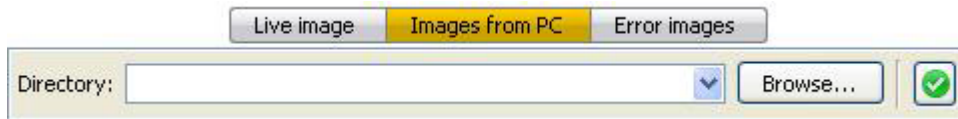
and the model display on and off.

Live image

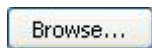
Click on this button to display the current Vision Sensor image.

8.1 Images from PC

Here you can load images for evaluation that you have saved previously from your computer. Click on *Images from PC*.



Click on the green tick to hide the selection.



Click on Browse to select the directory that contains the images.

Choose the directory where the images are located and click *OK*.



You can view the images that you have loaded here.

8.2 Defect images

The device can save up to 32 defect images in *Activated* mode, depending on the device model. The last defect images to occur are stored.

Defect images

Click on defect images to load the fault images.



You can see the last defect images to occur



Use this button to save the single exposure currently being displayed to your PC.



Use this button to save all defect images to your PC.

8.3 Loading, saving and recording images



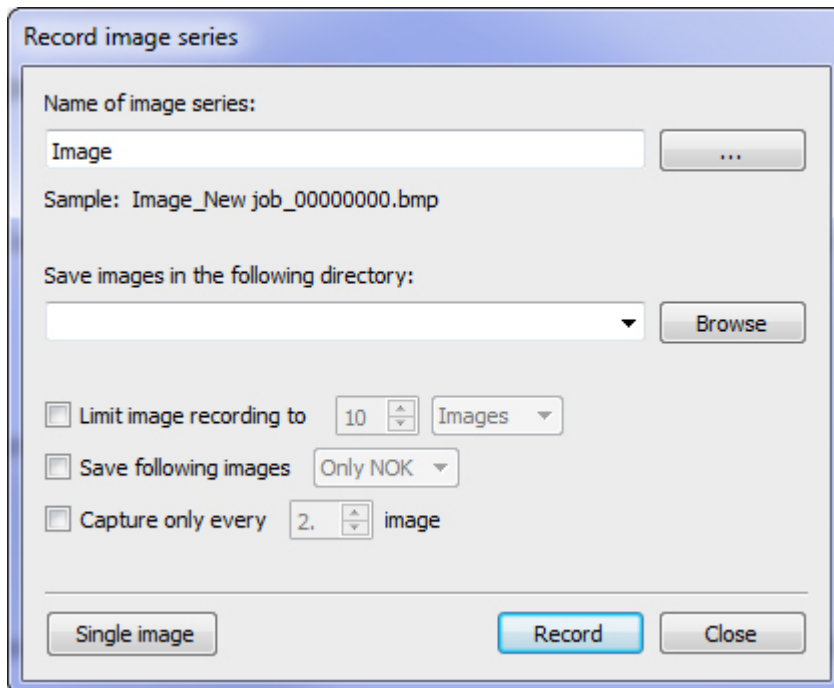
Use this button to load images saved on your computer for further processing.



Use this button to save the image currently being displayed to your PC.



Use this button to record live images. The "Record images" dialogue box opens after clicking.

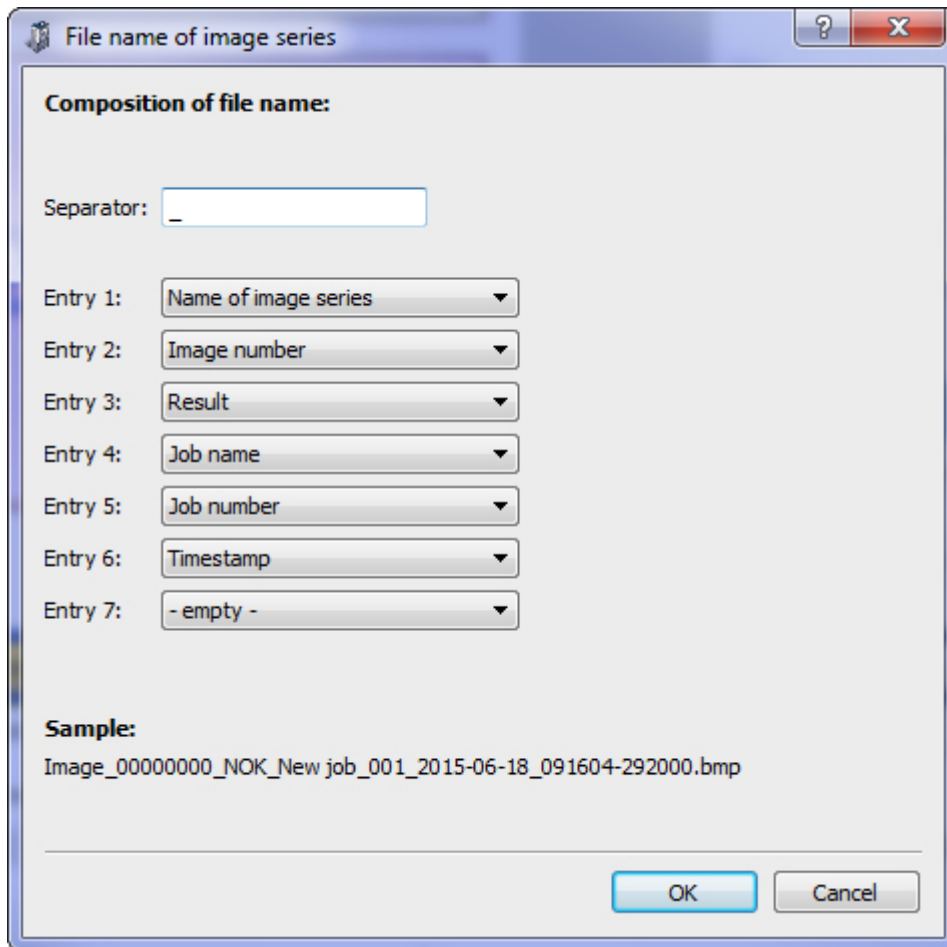


Make the settings required for the image series in this dialogue box.

Use the *Single image* button to save just one image in the selected directory. Use the *Acquisition* button to keep acquiring images until you click on *Stop* or have limited image acquisition.



You can configure the structure of the file name.



The file name configuration gives you the option to freely arrange up to seven entries. You can also define a separation marker.

The entry options for the device are:

- the chosen name of the image series
- sequential numbers generated by the system (00000001 – 99999999)
- the result of the analysis
- the job name
- the job number
- a time stamp (time is taken from the connected PC)

8.4 Job features

The *Application Suite* helps you to create, manage and test jobs and to configure them for operation. Each inspection task is processed by the device in the course of a job. For each job required an image will be acquired in which you mark the features to be checked. A pass/fail result will then be determined.

The following individual steps are used to create a job:



1. Adjust image

1. **Adjusting the image:** Each inspection with the device is based on image data. The image quality depends on the internal camera settings, the illumination settings and lens adjustments. Here, you can set all parameters concerned with the primary image acquisition and its control.



2. Check features

2. **Checking features:** Checking the features is the actual evaluation. Each feature check operates in a field of view, determines one or more values and compares the result with preset switching points. In a second step, you can link the results of the sensor tasks to produce a result.



3. Configure interfaces

3. **Configure Interface I/Os:** This includes settings for digital outputs (output time and duration of output, among other settings) and configuration for datagrams of the process interface.

You can also set which feature checks and their functions can be operated via the web interface. This information is saved separately for each job, while pin assignment for the digital I/Os is set in the device settings.

9 Creating a job

Jobs are created in three main steps, using the *Job bar*. The individual parameters can be set in this bar.



9.1 Adjusting the image (image focus)

To implement reliable inspection with the Vision Sensor, the features to be inspected must be clearly visible.

Set the image focus directly on the Vision Sensor installed at the check location using an Allen key.

ATTENTION!

On devices with protection class IP 69K, the setting screw is protected from moisture by a sealing screw.

Do not remove the sealing screw in damp rooms and only remove it for a short amount of time as there are drying capsules on the inside that absorb moisture and may become saturated.

Reseal the setting screw with the sealing screw once you have configured the image focus!

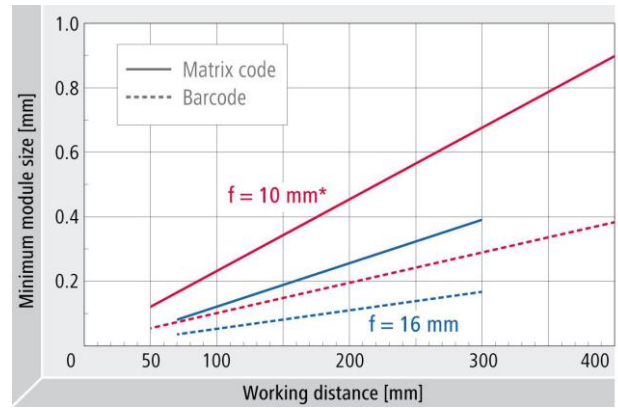
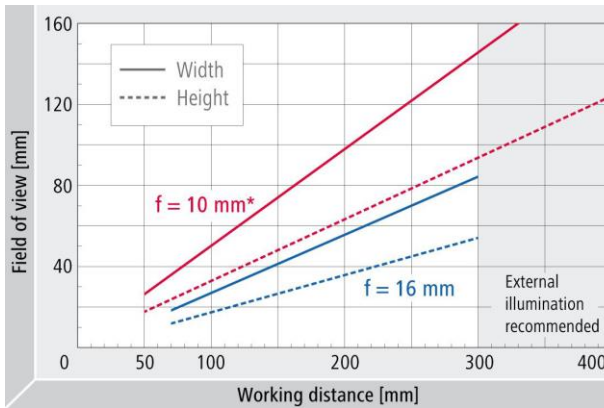


For devices with interchangeable lenses, the image focus is set on the installed lens.



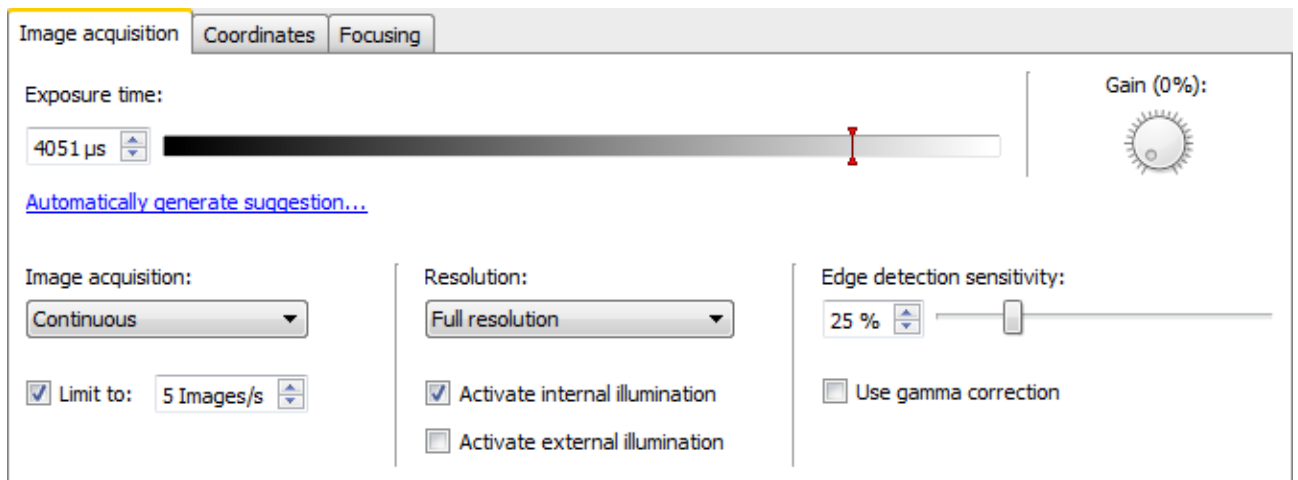
NOTE

The field of view and minimum module size for devices with interchangeable lenses depends on the lens installed.




* Working distances > 400 mm possible

9.1.1 Adjusting the image (additional parameters)




Set the exposure time for image acquisition.

NOTE

 Please be aware that, if exposure time is extended, images may become blurred because of movement of the object. In this case, decrease the exposure time until the object appears sharp, and increase the value for the amplification

(device-dependant)

NOTE


 For technical reasons, if the exposure time is the same, the *Reduced Resolution* (Binning) setting will detect higher grey values than at full resolution.

Gain:



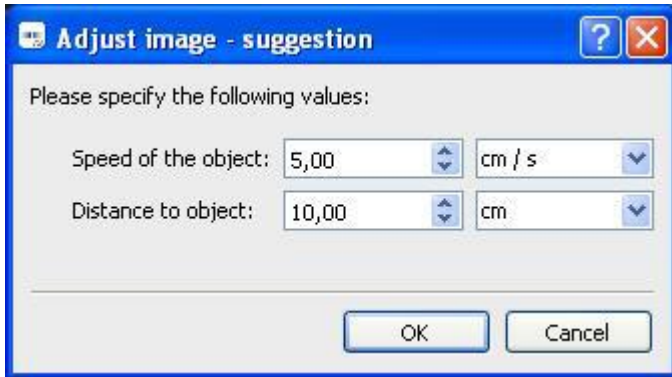
The image can also be brightened using the control gain (*Amplification*).

NOTE

 Higher amplification values result in increased image graininess and make stable analysis more difficult. If sufficient image brightness is not achieved, use external illumination.

[Generating automatic suggestion...](#)

Click on *Generating automatic suggestion ...* to view a suggestion for illumination settings.



Enter the speed of the objects, and their distance from the camera, during inspection. The *Application Suite* automatically calculates the associated parameters. If the image is then still too dark or bright, you can adjust this using the control gain (Amplification).

Image acquisition

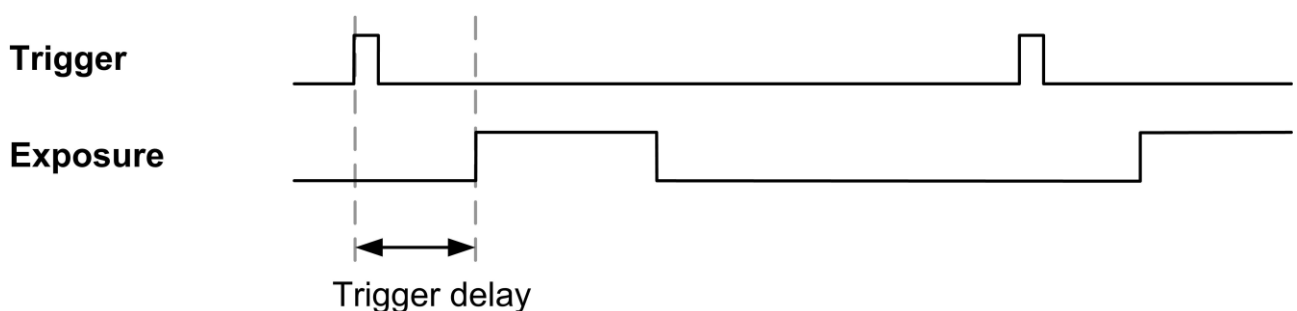
Continuous

Limit to: 1 Images/s

Continuous: A new image acquisition is made as soon as an image analysis is complete. You can also limit the number of images depending on the exposure time.

External trigger: A new image is acquired upon the occurrence of a corresponding external event.

If an encoder is connected, you can also specify the delay time or distance (ft = feet) between the trigger signal and the actual image acquisition. Any other trigger signals received during this period are ignored! If necessary, activate the "invalid trigger" entry (trigger during image acquisition or job switching) in Device settings, so that the alarm output is activated in such cases.



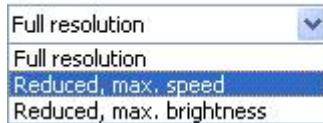
(device-dependant)

[Configure external illumination...](#)

Click on *Configure external illumination...* to make the settings for a connected external illumination system or a flash controller.

(device-dependant)

Resolution:



You can choose between two resolutions for the device, for the reduced resolution, additional profiles optimised for speed or brightness are available:

NOTE



The reduced setting will always detect 2 x 2 pixels and only one in four pixels will be read out. By using the "Reduced, max. speed" setting, the image acquisition time is reduced. By using the "Reduced, max. brightness" setting, a much brighter image can be acquired with the same length of exposure.

This is particularly useful with fast moving objects. Choose the mode in which the feature to be checked appears most clearly. Due to the smaller image size, image processing will generally be faster in both cases.

- Activate internal illumination
- Activate external illumination

With the illumination settings, you can switch off the internal illumination and possibly activate external illumination with the *Flash sync output*. If you wish to use the external *Flash sync output*, this must be chosen accordingly in the *Digital I/O* menu. You can also activate both type of illumination.

The *Flash Sync Signal* is located parallel to the exposure time on the digital I/Os. The exception to this is the 4-pin connection on devices with interchangeable lenses. Here the signal is available at a maximum of 1 metre per second if the operating mode *Activate external flash controller (max. 1 ms)* is selected for the external illumination.

NOTE



Only use contour recognition sensitivity when all of the other image settings have been configured successfully.

(device-dependant)

Edge detection sensitivity:



To ensure consistent evaluation, all contours must be calculated consistently. This means that the image is sharply focused and no over biases occur.

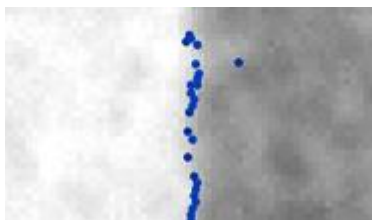
For critical objects, it may be appropriate to adjust the sensitivity of edge detection manually. Set the Edge detection sensitivity to a value where the feature to be inspected is clearly recognizable.

Make sure that the contours of the test object are consistently obtained and that not too many “pseudo-contours” are created.

You can make the contours visible using the following button from the image display options:

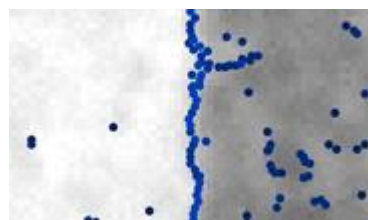


Example images of contours



too few contours

(contour recognition sensitivity must be decreased)



good contours

(optimum contour recognition sensitivity)



too many contours

(contour recognition sensitivity must be increased)

NOTE

Error message: "Too much contour points! Please reduce the number of contour points."

You may avoid this error with the following corrective actions:



- Adjust the application set-up:
 - For example, change the position of the object being examined so that interfering structures that create unnecessary contour points are outside of the image area
 - Cover up the interfering structures.
- Adjust the edge detection sensitivity.
- Reduce the image noise using lower amplification and correspondingly longer exposure or stronger illumination.

(device-dependant)

Use gamma correction

Activate the function “Use gamma correction” if you wish to emphasize contours in dark areas of the image. This option may also be appropriate to reduce the effects of reflections when the image is acquired. This makes the sensitivity of the acquisition non-linear, brightening darker areas of the image and diminishing the contrast of brighter areas of the image.

NOTE



When using gamma correction, the "Reference area" function can only be used to a limited extent for certain feature checks (e.g. Brightness etc.)!

The following value can be set via the process interface:

Entry value	Data type
Exposure time	Integer
Amplification	Integer
Contour recognition sensitivity	Integer

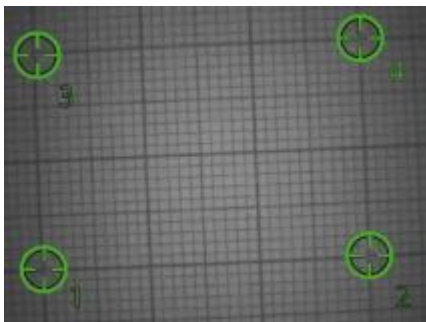
9.1.2 Coordinates (device-dependant)

With the Vision Sensor, there is an option to convert the internal image coordinate system (which uses pixel as its unit) to a user-defined coordinate system (e.g. using millimetres). To do this, it is necessary to specify the real coordinates for a few data points in the image referenced to a world coordinate system in order to teach the Vision Sensor the distance in your unit.



Convert image coordinates to world coordinates

If you want to convert the coordinates, activate this option. Following configuration, the unit you have defined can be selected as the [Units] option for the corresponding feature checks.



Process

1. Place a defined test image of your choice (e.g. graph paper) into the field of view of the sensor.
2. Activate: *Convert image coordinates to world coordinates*.
3. Mark at least four coordinates on the image with defined distances between them. Base this on your defined test image. The order is not important.

To achieve high conversion accuracy, ensure that the marked coordinates:

- are positioned in the image as precisely as possible,
- are uniformly distributed throughout the image,
- do not lie on one line.

	X in [Units]	Y in [Units]	
1	0,00	0,00	+ Add
2	30,00	0,00	- Delete
3	0,00	20,00	
4	30,00	20,00	
			X Delete all

- Enter the values for the marked coordinates. In this example, it is millimetres. Keep in mind that the coordinates must be specified with respect to a right-handed coordinate system (X towards the right, Y towards the top). The *Application Suite* suggests values for you, correct them if necessary.

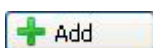


- During the coordinate conversion process, the individual points are checked for validity. Points whose coordinates deviate too greatly from the calculated position following conversion are marked in yellow or red.

In this case, check all points for the correctness of position and of the coordinates. If necessary, shift the points or adjust the entered coordinates. A small line indicates the direction in which the point should be shifted.

If you now allow the results of the corresponding feature checks to be given in [Units], the value produced conforms with your defined coordinates in millimetres.

There is an option to define more than four coordinates. Having more coordinates makes the conversion more precise. To do this, use the following buttons.



Use the *Add* button to add additional coordinates to increase the accuracy of the conversion.



Delete individual points using the *Delete* button.



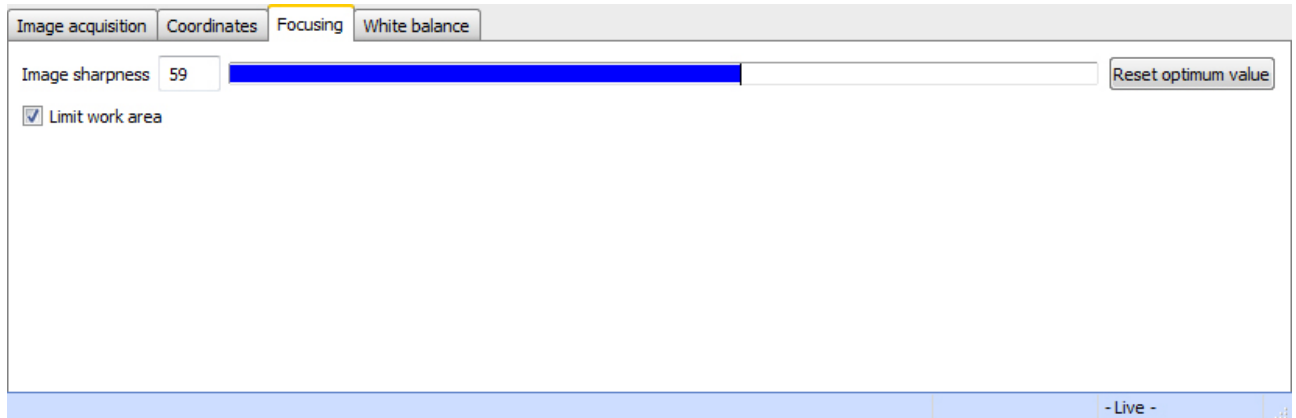
The *Delete all* button deletes all coordinates.

Correct lens distortion

To increase the precision of the calculated coordinates, you can also correct for the distortion of the camera lens. In this case, you will need at least eight coordinates.

9.1.3 Focus

The focus option uses a graphical display to help you focus the Vision Sensor.



Focussing the Vision Sensor

1. Point the device's field of view towards a model piece. Limit the field of view as required.
2. Now adjust the focus on the Vision Sensor. To do this, use the focus setting screw and the installed lens.


→ You will see how the focus changes. The best value may also increase.
3. Adjust the focus until you have achieved the optimum result (highest focus value).

Reset best value: Use this to reset the best value to the current focus value.

Limit field of view: Use this function to limit the field of view, otherwise the entire image area will be used to calculate the focus.

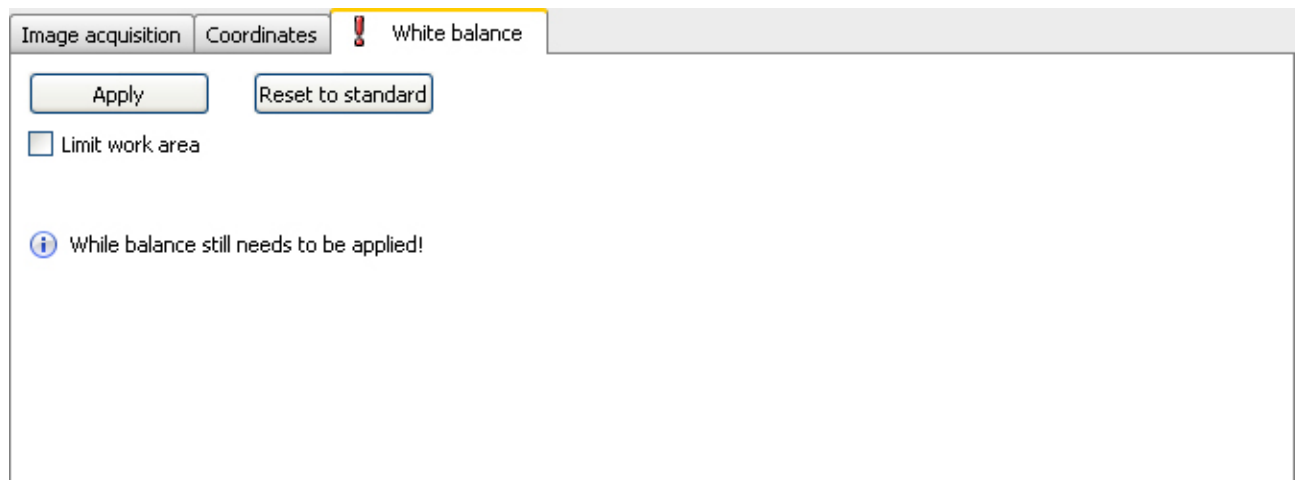
9.1.4 White balance (device-dependant)

The white balance adjusts the color sensitivity of the device to the current lighting situation. The white balance setting is stored in the respective job.



NOTE

If the white balance has not yet been carried out, an exclamation mark is shown on the tab above.



Run white balance

1. Direct the device's field of view onto a white surface (e.g. white paper) or limit the field of view to a white area in the image.
2. Now click on the *Image acquisition* tab and change the exposure time to create an image that is as homogeneous as possible and slightly grey.
3. Click on the *White balance* tab again and then on the *Run* button. The three RGB values should now be similar to one another, see the status bar below.

Once the white balance has been run, you can reconfigure the exposure time on the *Image acquisition* tab to suit your requirements.

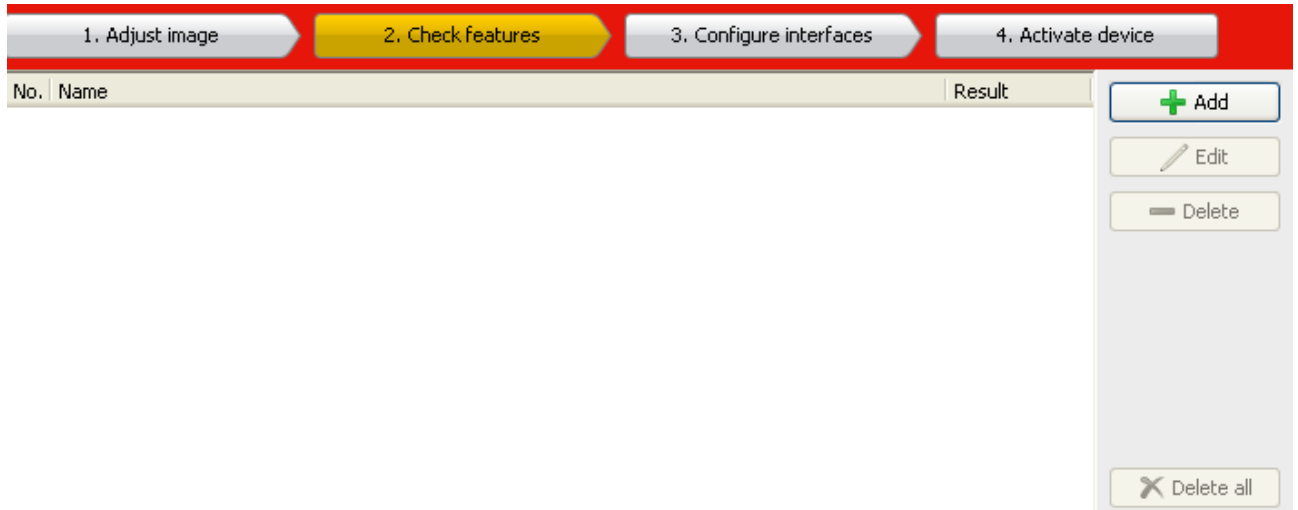
Run: Run white balance with currently displayed image.

Reset to standard: reset to the factory white balance setting.

Limit field of view: Limit the area used for the white balance. This may be necessary if only part of the image is suitable for white balancing.

9.2 Checking features

The features to be checked are composed and their parameters set in this step.



NOTE



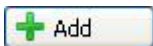
Please note that even the best feature check can only calculate a satisfactory result if the associated feature is clearly visible in the image.

If necessary, check the parameters for the image exposure again to obtain an optimum image quality for your task!

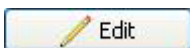
NOTE



As each inspection task has tolerances with regard to the position of the test object, most jobs begin with part location. The part location feature searches for the reference edges of the test object and aligns all subsequent feature checks according to these reference edges.



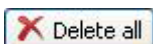
Add opens the New feature check dialogue. In this, a list of all available feature checks is presented. When a feature to be checked has been selected, this appears automatically in the feature list, with its current result and the associated status.



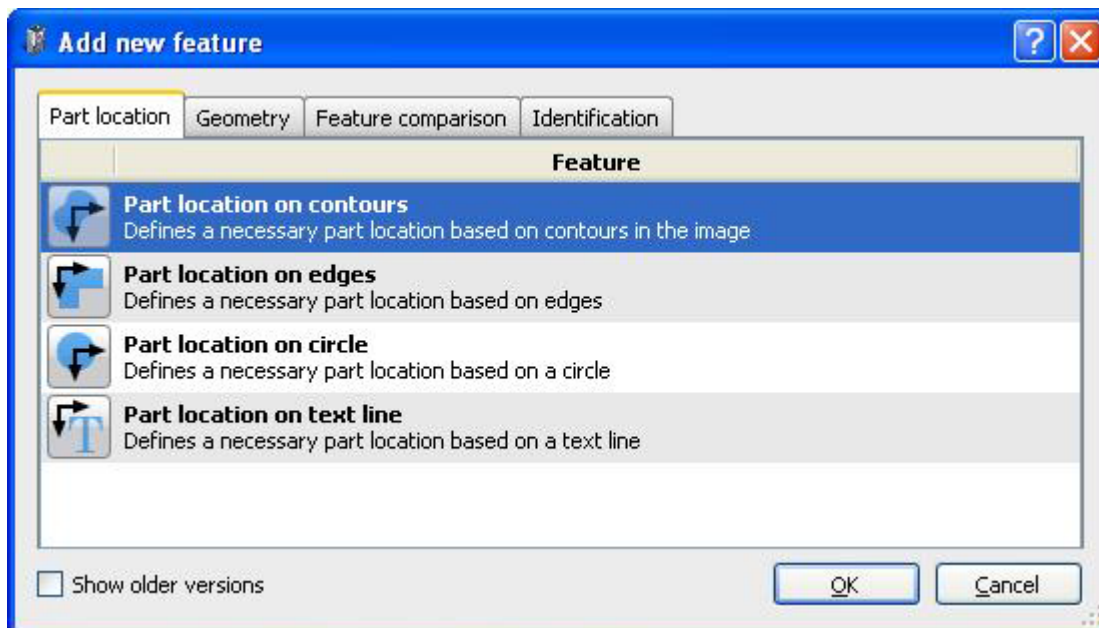
A previously selected feature check is edited here.



Deletes a selected feature check from the list of features.




Deletes all feature checks from the list of features.



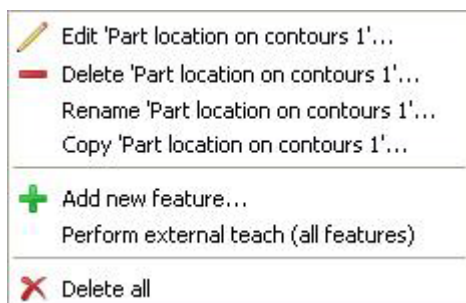
Each feature is optimized for just one inspection task and supplies a Pass or Fail result. Partial results (e.g. brightness - mean brightness) can also be delivered via the process interface.

Show older versions: This function shows you versions of feature checks from earlier releases (labelled accordingly) along with the current ones, e.g. to use in already successfully implemented applications. We recommend that you use the current feature checks. It is not possible to convert from an older to a newer version.



NOTE

The results of the feature checks can be connected at a later stage (device-dependant).

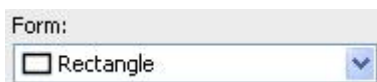
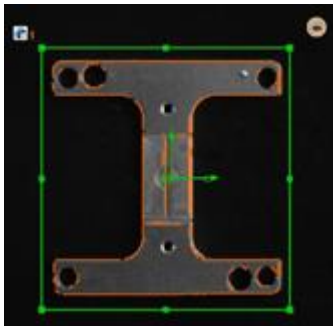
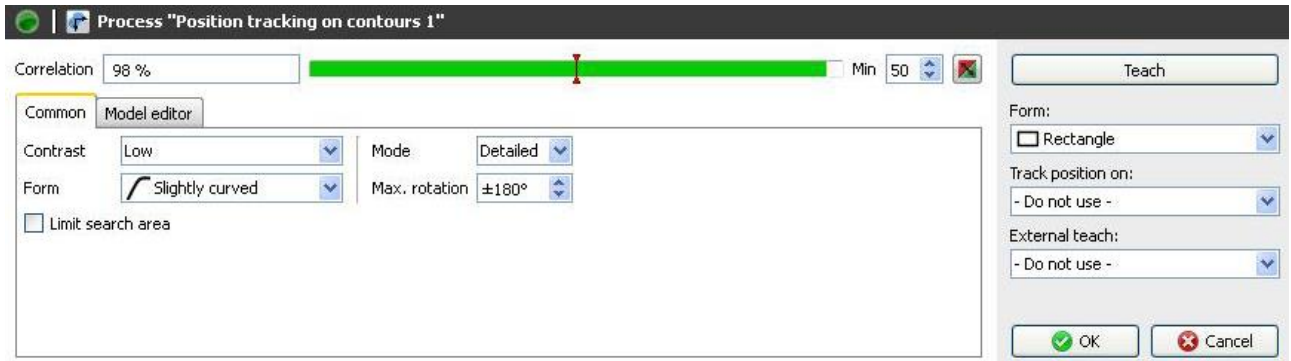


Right click on a configured feature check to access further functions.

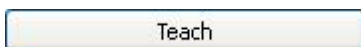
Example: Feature comparison brightness with part location on contours

Part location on contours:

With this feature check, the position of an object is determined using contours.



- Choose the shape of the area from which the contours are adopted.



Adopt the contours by pressing "Teach". A search is then made for the object in the entire image.



- The match of the contours with the found object in the image is displayed here.
- Using the appropriate switching points, set how good the match must be so that the object is found. The button on the extreme right inverts the set point.

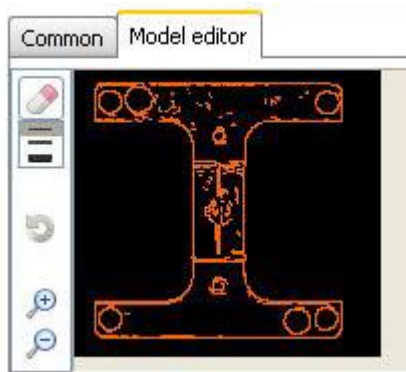


- **Contrast:** Set the minimum contrast of the contours that should be adopted in the model.
- **Form:** Select the shape of the contour that corresponds to the test object and that should be adopted in the model. (Limiting the angular range reduces processing time.)
- **Mode:** Set the amount of detail to be used in the inspection. (The more detailed the mode, the higher the processing time.)
- **Max. rotation:** If you want to find the object only in a limited angular range, you may specify the maximum rotational position here.

Limit search area

- If you do not wish to search for the object in the entire image, set the tick and then limit the search area.

Model editor tab



- With the displayed model, you can now use the mouse to delete contour points which clearly do not belong to the reference object.



- Use this button to restore the model to its original state.



- You can use these two buttons to enlarge or reduce the model.

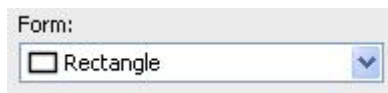
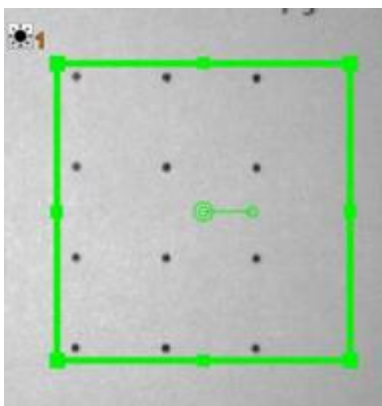
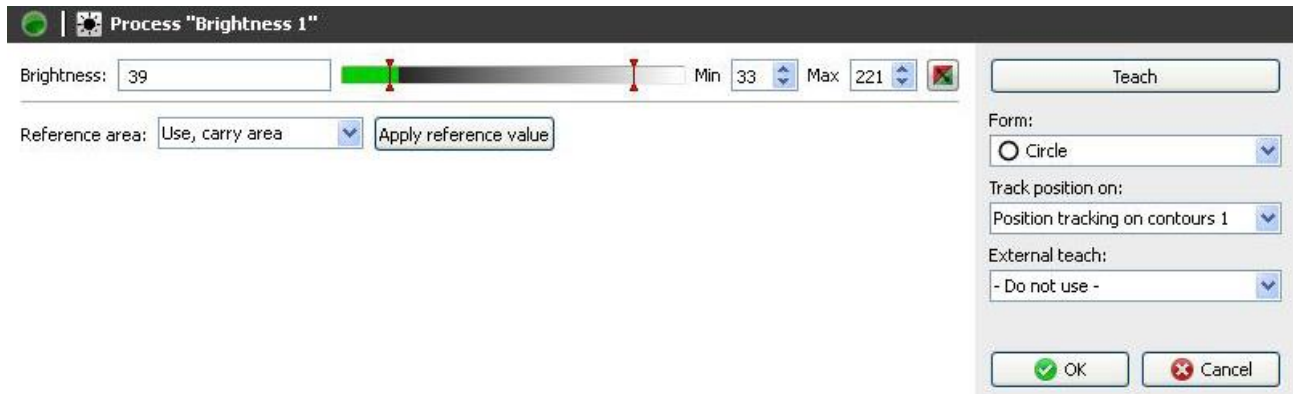


- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

Feature check Brightness

This feature check measures the mean brightness in a field of view and compares the result with the specified switching points.

This feature check supports external Teach. The switching points are adjusted as an absolute to the current measured value.



- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.



- The current result for brightness is shown as a mean grey scale value. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.

Track position on:
 Position tracking on contours 1
 External teach:
 - Do not use -

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.


Reference area:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

- **Use, do not carry reference area:** Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.
- **Use, carry reference area:** This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.


The mean brightness in the field of view of the reference area should exceed a grey scale value of 128 to ensure reliable operation.

NOTE

 If "Use, carry area" cannot be selected, then you have not defined part location.

- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

NOTE

 The *Application Suite* CD features a range of application examples that provide you with typical solutions for various inspection task and the use of the individual feature checks. After successful installation, the examples can be found in the directory

`<installation path>\AppSuite\samples`

on your PC.

9.3 Configuring interfaces

9.3.1 Occupancy of digital I/Os

You can adjust the settings for the digital interface on this dialogue page.

Output	Signal for	Signal for
Output 1:	Total result	Signal for
Output 2:	Partial result 1	Signal for
Output 3:	- not configured -	Signal for
Output 4:	- not configured -	Signal for
Output 5:	- not configured -	Signal for

NOTE



Please keep in mind that, during job switching, the device is not active and the "Camera Ready" output is deactivated. Please wait with the next image analysis operation until the "Active" state is displayed again by this signal. If the switch could not be performed, for example, because the job number was invalid, an alarm signal is also output until the next trigger.

Output 1-5

Enter how the outputs are to be activated here. You can choose between these three options: Total result, Partial result, Alarm. For the results output, you may also choose whether you want a signal to switch for a pass or a fail result.

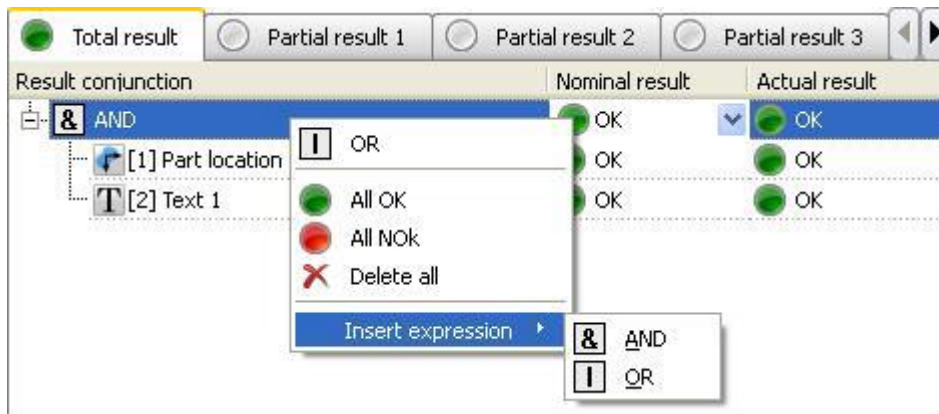
You may output the Total result and the Partial results via the digital interfaces. To do so, configure the required output in *Device menu*.

Flexible result conjunction (device-dependant)

Result conjunction	Nominal result	Actual result
AND	OK	OK
[1] Part location on contours 1	OK	OK
[2] Text 1	OK	OK

In this dialogue, you can specify how the feature check results are to be logically linked together to produce the result of the job.

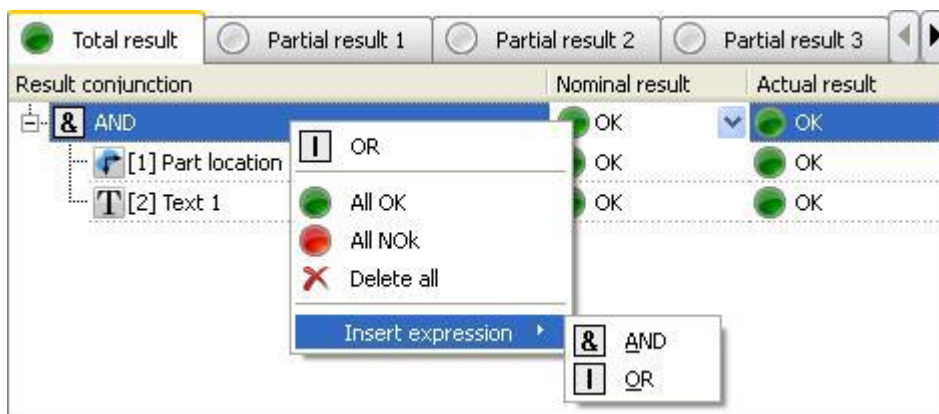
You can specify one Total result and several Partial results for each job. In addition, it is possible to use the Partial results for the configuration of the Total result.



It is possible to link the results with the following operations for configuration:

- AND (“The results of all feature checks are OK.”)
- OR (“The result of at least one feature check is OK.”)

You can also invert and ignore the result of a link by selecting the entry “NOK” or “Ignore” in column “Nominal result”.



It is possible to nest the links to any desired depth to achieve even more complex expressions. You can insert new levels by selecting the “Insert expression” value in the context menu and then the appropriate type of link. For each sub-link, you can now select the corresponding feature checks to be used for the evaluation. Each feature check can appear any number of times in the overall expression, but only once at each level.

Example

(Brightness 1 OR Contrast 1) AND (Brightness 2 OR Contrast 2)

<input checked="" type="radio"/> Total result <input type="radio"/> Partial result 1 <input type="radio"/> Partial result 2 <input type="radio"/> Partial result 3 ◀ ▶		
Result conjunction	Nominal result	Actual result
& AND	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
├─ OR	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [1] Brightness 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [2] Contrast 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
├─ OR	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [3] Brightness 2	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [4] Contrast 2	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK

Part location on edges 1 AND (Contour comparison 1 OR Count contour points OR Brightness 1)

<input checked="" type="radio"/> Total result <input type="radio"/> Partial result 1 <input type="radio"/> Partial result 2 <input type="radio"/> Partial result 3 ◀ ▶		
Result conjunction	Nominal result	Actual result
& AND	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
├─ OR	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [2] Brightness 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [3] Contour comparison 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [4] Count contour points 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
├─ [1] Part location on edges 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK

NOT (Brightness 1 AND Contrast 1) OR (Brightness 1 AND Area size 1 AND Contour comparison 1)

<input checked="" type="radio"/> Total result <input type="radio"/> Partial result 1 <input type="radio"/> Partial result 2 <input type="radio"/> Partial result 3 ◀ ▶		
Result conjunction	Nominal result	Actual result
OR	<input type="radio"/> NOK	<input checked="" type="radio"/> NOK
├─ & AND	<input checked="" type="radio"/> OK	<input type="radio"/> NOK
│ ─ [1] Brightness 1	<input checked="" type="radio"/> OK	<input type="radio"/> NOK
│ ─ [2] Contrast 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
├─ & AND	<input checked="" type="radio"/> OK	<input type="radio"/> NOK
│ ─ [1] Brightness 1	<input checked="" type="radio"/> OK	<input type="radio"/> NOK
│ ─ [3] Contour comparison 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK
│ ─ [4] Area size 1	<input checked="" type="radio"/> OK	<input checked="" type="radio"/> OK

Digital inputs in results conjunction (device-dependant)

You can also include the states of the digital inputs in the total result. They can be nested just like the other feature checks.

The states of the digital inputs are captured at the trigger point or at the start of image acquisition.

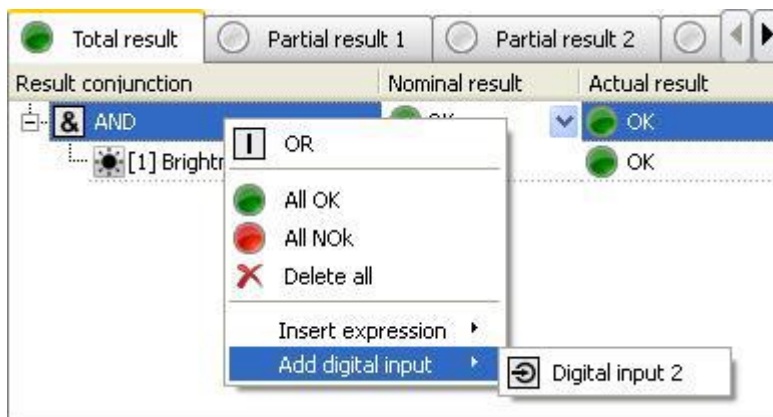
The states of the digital inputs alone cannot be linked; there must be at least one feature check!

NOTE



To use the digital inputs in the result conjunction, you must select *External Sensor* for the relevant input in the device settings.

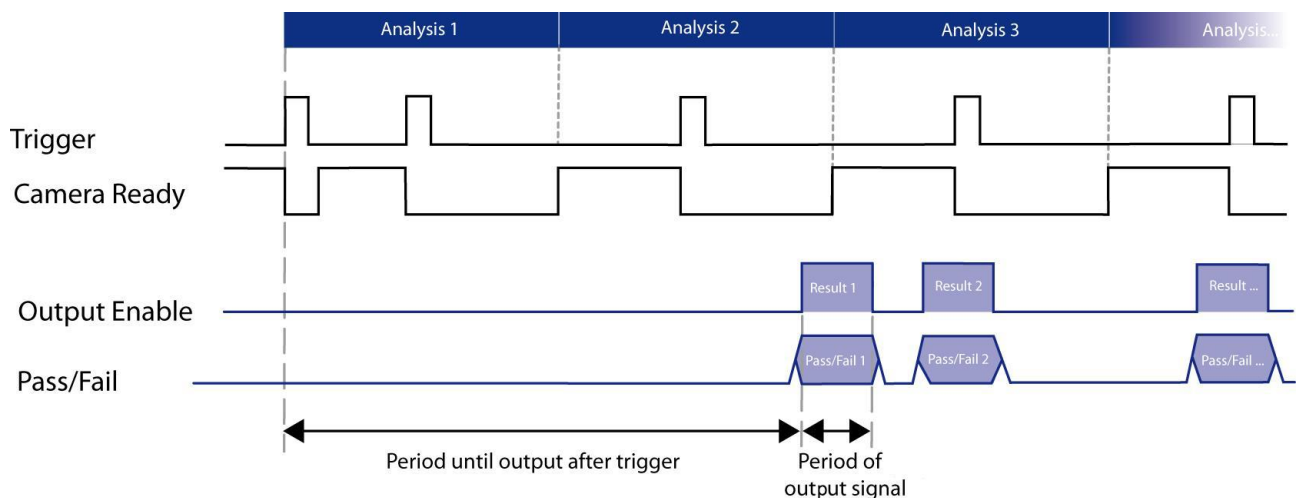
Device → *Device Settings* → *Digital I/Os*



9.3.2 Timing digital I/Os

Occupancy of digital I/Os	Timing digital I/Os	Output process interface	Input process
Processing time			
Duration:	Do not limit	10 ms	
Output			
Time:	Immediately after image evaluation	62 ms	
	Output forerun:	0 ms	
Duration:	Until next result	20 ms	
Configured outputs dissenting...			

In this dialogue, you can define when the output time is reached and how long the output is to be. The timing diagram displays the process visually and you can mouse over various positions to bring up further details.



Following image acquisition, the *Camera Ready* signal is deactivated. The *Camera Ready* signal is activated again at the end of image acquisition and another image acquisition operation is possible immediately.

The *Pass/Fail* signal then switches at the set output time even if additional analyses have already been performed. The *Result valid* signal is active during this time.

A maximum of 64 results can be temporarily saved.

NOTE



If the set output time has been reached prematurely, the calculation in the Vision Sensor is aborted. The result and all partial results are then NOK.

The duration of the output signal is used to specify for how long the output signal (Result valid, Pass/Fail, Alarm) should be produced. Depending on the settings, the signal will either be reset once the set pulse has elapsed, or reset with the next result.

NOTE



If you have connected an encoder, you may set output time and duration as a distance.

In addition, you can specify an "output run-up" in milliseconds to activate the Pass/Fail signal before reaching a specific position.

This option is available if an exact output time has been specified (identical earliest and latest output times) and this is specified as a distance.






Keep in mind that, in this case, the conveyor speed must be constant!

There is also the option to set different times for individual outputs.

[Configured outputs dissenting...](#)

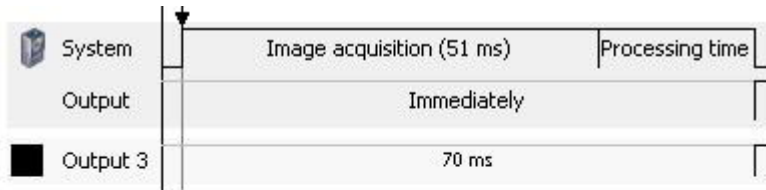
In the drop-down menu, different individual timings can now be set for outputs with a result. These are selected with the check box.

Use dissenting settings for ...

<input type="checkbox"/>		Output 1 (Result : - not configured -)	Time:	<input type="text" value="Immediately"/>	<input type="text" value="62"/>	<input type="text" value="ms"/>	Forerun:	<input type="text" value="0 ms"/>	Duration:	<input type="text" value="Until next result"/>	<input type="text" value="20"/>	<input type="text" value="ms"/>
<input type="checkbox"/>		Output 2 (Result : Partial result 1)	Time:	<input type="text" value="Immediately"/>	<input type="text" value="62"/>	<input type="text" value="ms"/>	Forerun:	<input type="text" value="0 ms"/>	Duration:	<input type="text" value="Until next result"/>	<input type="text" value="20"/>	<input type="text" value="ms"/>
<input checked="" type="checkbox"/>		Output 3 (Result : Partial result 3)	Time:	<input type="text" value="Always after"/>	<input type="text" value="70"/>	<input type="text" value="ms"/>	Forerun:	<input type="text" value="0 ms"/>	Duration:	<input type="text" value="Until next result"/>	<input type="text" value="20"/>	<input type="text" value="ms"/>
<input type="checkbox"/>		Output 4 (Result is valid)	Time:	<input type="text" value="Immediately"/>	<input type="text" value="62"/>	<input type="text" value="ms"/>	Forerun:	<input type="text" value="0 ms"/>	Duration:	<input type="text" value="Until next result"/>	<input type="text" value="20"/>	<input type="text" value="ms"/>
<input type="checkbox"/>		Output 5 (Camera Ready)	Time:	<input type="text" value="Immediately"/>	<input type="text" value="62"/>	<input type="text" value="ms"/>	Forerun:	<input type="text" value="0 ms"/>	Duration:	<input type="text" value="Until next result"/>	<input type="text" value="20"/>	<input type="text" value="ms"/>

In this example, only output 3 has a different output time, although output 2 is also in use. They both follow the general output time.

The different settings can be viewed in the timing diagram once you have left the menu.



System	Image acquisition (51 ms)	Processing time
Output	Immediately	
Output 3	70 ms	

Conveyor speed:

9.3.3 Output process interface (device-dependant)

In this dialogue, you can configure the data outputs via the process interface.

A detailed description of the process interface can be found in the section *Communications via the process interface*.

You can configure the technical parametrisation of this interface in the *Device settings*.



The length of the datagram includes the header and end identifier.

You may select as many entries for the transfer as you wish in the table.

With the **+** and **-** buttons, you may add a new line or erase the currently selected line, respectively. Each line contains one feature to be transferred. Using the arrow keys, the currently selected line can be moved upward or downward thereby changing the data sequence in the data packet.

General settings

Parameters	Meaning
Start	Character string as a start sequence preceding the data block. This character string is freely selectable (e.g. <Start>).
Separator	Character string included as a delimiter between each individual result of the feature check (e.g.)
End	Character string as an end sequence concluding the data block. This character string is freely selectable (e.g. <End>).

NOTE




To enter binary characters, you may use the `\` symbol in the text. The value can then be specified in hexadecimal format. To add a backslash, enter `\\`. The character `\00` cannot be used.

Example:

`\09` corresponds to a tab
`\0D\0A` corresponds to <CR><LF>

Data table settings

The following items are selected in the table:

Column	Meaning
Active	If this entry is marked, the selected value is entered in the datagram.
Feature	The setting or the feature check from which a value is to be transferred is selected here.
Value	The result of the feature check that is to be transferred is selected here. The "Result" option (for the OK/NOK result of the feature check) is always available. All other results depend on the relevant feature check or setting. Should a value consist of multiple components (e.g. a point consists of the X and Y coordinates), these are separated with the separator set within the general configuration.
Start	This character string prefixes the result to be transferred and can make it easier for the receiver to interpret or make the data packet readable for human users.
Format	<p>The format used to represent the data to be transferred is set here. The options provided depend in principal on the values available. Customarily, the following possible options are offered:</p> <ul style="list-style-type: none"> • ASCII (2 decimal places) • ASCII (Exponent) • Decimal • Binary (Little Endian) • Binary (Big Endian) <div style="border: 1px solid black; padding: 10px; margin-top: 10px;"> <p>NOTE</p> <div style="display: flex; align-items: center;">  <p>This means that the data packet can contain characters that are normally used as control characters for serial interfaces or in the protocol. This setting is only recommended if the operating conditions are appropriately secured.</p> </div> </div>
Min. length	<p>The minimum length of the values is adjusted here.</p> <ul style="list-style-type: none"> - Should the value be larger than the set minimum length, the length will be exceeded accordingly - Modifications of the length depend on the data type, for example, a binary value is 4 bytes long - The modification is carried out by prefixing or suffixing with zeros or spaces (depending on the data type)

The following table explains the meaning of various settings for features and values.

Parameters		Meaning
Feature	Value	
Time	Image acquisition	Provides the time of the image acquisition in milliseconds since the device was switched on.
Result	Total result	If this selection is activated, the total result or the partial result of the job is transferred. <ul style="list-style-type: none"> • Result (2 characters): <ol style="list-style-type: none"> 1. Characters: "P" or "F" for a Pass or Fail result 2. Characters: "A" or space for "Alarm triggered" or "No alarm triggered". • Partial result (1 characters): <ul style="list-style-type: none"> "P" or "F" for a Pass or Fail result "I" if the partial result was not output during the job
Result	Partial result	
Statistics	Total result	If this option is activated, the statistics for the result are included. The total number of images, the number of OK images and the number of images for the total result that triggered an alarm are all transferred, with the individual values separated with a separator.
Statistics	Partial result	
Trigger	Additional data trigger	If this selection is activated, the string transferred via the TD command is mirrored back as a control option.
Trigger	Image counter	If this selection is activated, a 16 bit wide counter (0-65535) is used. This increases by 1 with each image acquired and resets to 0 once it reaches 65535.



NOTE

Following the descriptions of the individual feature checks, there is a table containing the values which can be output via the process interface.

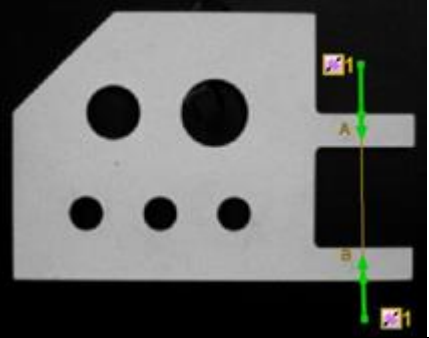
Example

Output of read data for the *Distance* feature check via the process interface.

i

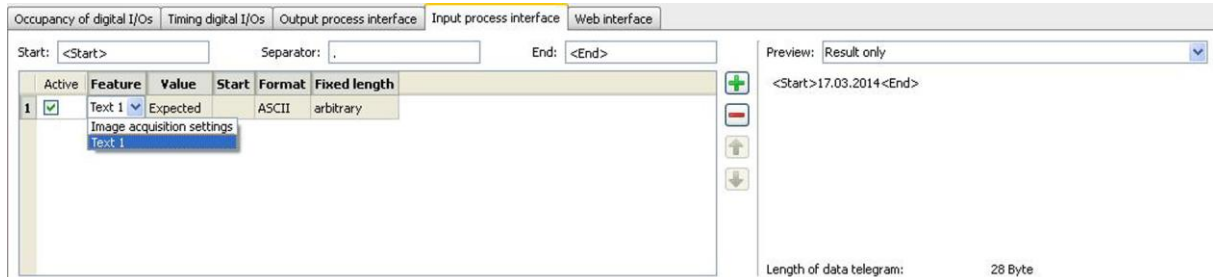
NOTE

The preview window on the right shows you in real time how your settings affect the data to be transferred.

1.	Configure the <i>Distance</i> feature check.													
2.	Go to the <i>Configure interface</i> → <i>Output process interface</i> step.													
3.	Configure all of the settings in the overview for the data output (see Data table settings). <ol style="list-style-type: none"> (1) Select the feature check / setting to be output. (2) Select the value to be output. (3) Set the start character, separator and end character for the datagram. 													
<div style="border: 1px solid gray; padding: 5px;"> <div style="display: flex; justify-content: space-between; font-size: small; border-bottom: 1px solid gray;"> Occupancy of digital I/Os Timing digital I/Os Output process interface Input process interface </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> Start: <Start> Separator: End: <End> </div> <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 5px;"> <thead> <tr> <th style="width: 5%;">Active</th> <th style="width: 15%;">Feature</th> <th style="width: 15%;">Value</th> <th style="width: 10%;">Start</th> <th style="width: 40%;">Format</th> <th style="width: 15%;">Min. length</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1 <input checked="" type="checkbox"/></td> <td>Distance 1</td> <td>Distance</td> <td></td> <td>ASCII (2 decimal places)</td> <td style="text-align: center;">0</td> </tr> </tbody> </table> </div>			Active	Feature	Value	Start	Format	Min. length	1 <input checked="" type="checkbox"/>	Distance 1	Distance		ASCII (2 decimal places)	0
Active	Feature	Value	Start	Format	Min. length									
1 <input checked="" type="checkbox"/>	Distance 1	Distance		ASCII (2 decimal places)	0									
4.	You will see how the data will be output via the process interface in the preview window on the right. The RD (R esponse D ata) and the number of characters (4 byte ASCII-Hex) will also be prefixed (see RD response).	<pre><Start>186.00<End></pre>												
5.	In this case, the device will send to the controller:	<pre>RD0013<Start>186.00<End></pre> <p style="font-size: small;">(Note: 0013_{HEX} = 19_{DEC}, length is therefore 19 characters)</p>												

9.3.4 Input process interface (device-dependant)

Via the process interface it is possible to set, for example, the expected values of the feature check of the identification (barcode, matrix code, text) sensors using the SP ("Set Parameter") command. You can also set parameters for image acquisition.



The length of the datagram includes the header and end identifier.

You may select as many entries for the transfer as you wish in the table.

With the + and - buttons, you may add a new line or erase the currently selected line, respectively. Each line contains one feature to be transferred. Using the arrow keys, the currently selected line can be moved upward or downward thereby changing the data sequence in the data packet.

General settings

Parameters	Meaning
Start	Character string as a start sequence preceding the data block. This character string is freely selectable (e.g. <Start>).
Separator	Character string included as a delimiter between each individual result of the feature check (e.g.)
End	Character string as an end sequence concluding the data block. This character string is freely selectable (e.g. <End>).

NOTE




To enter binary characters, you may use the \ symbol in the text. The value can then be specified in hexadecimal format. To add a backslash, enter \\ . The character \00 cannot be used.


Example:

\09 corresponds to a tab
 \0D\0A corresponds to <CR><LF>

Data table settings

The following items are selected in the table:

Column	Meaning
Active	If this entry is marked, the desired value is entered in the datagram.
Feature	The setting or the feature check from which a value is to be transferred is selected here.
Value	The result of the feature check that is to be transferred is selected here. The results depend on the relevant feature check.
Start	This character string prefixes the result to be transferred and can make it easier for the receiver to interpret or make the data packet readable for human users.
Format	<p>The format used to represent the data to be transferred is set here. The options provided depend in principal on the values available. Customarily, the following possible options are offered:</p> <ul style="list-style-type: none"> • ASCII (2 decimal places) • ASCII (Exponent) • Decimal • Binary (Little Endian) • Binary (Big Endian) <div data-bbox="379 1003 1310 1245" style="border: 1px solid black; padding: 10px; margin-top: 10px;"> <p style="text-align: center;">NOTE</p> <div style="display: flex; align-items: center;">  <p>This means that the data packet can contain characters that are normally used as control characters for serial interfaces or in the protocol. This setting is only recommended if the operating conditions are appropriately secured.</p> </div> </div>
Fixed length	The length of the expected values is adjusted here. Missing characters are filled with zeros (numbers) or spaces (text).




NOTE


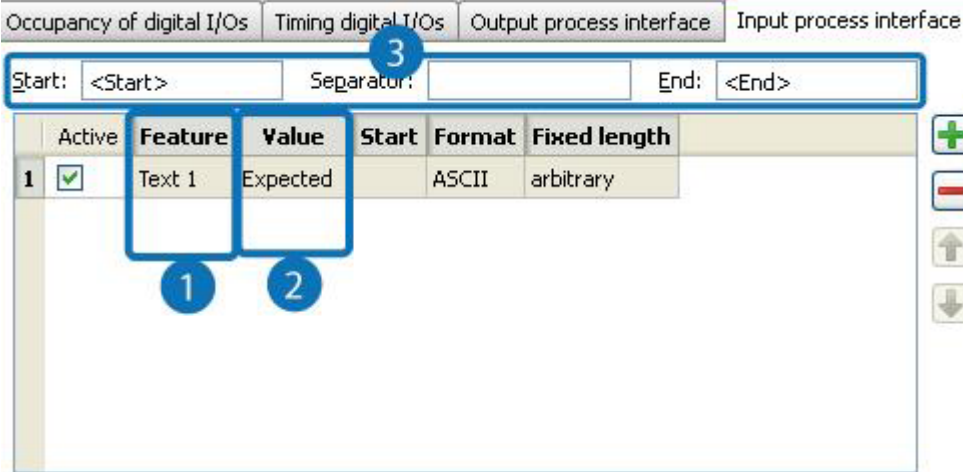
Following the descriptions of the individual feature checks, there is a table containing the values which can be input via the process interface.

Example

Setting an expected value for the *Text* feature check via the process interface and determining the required command.

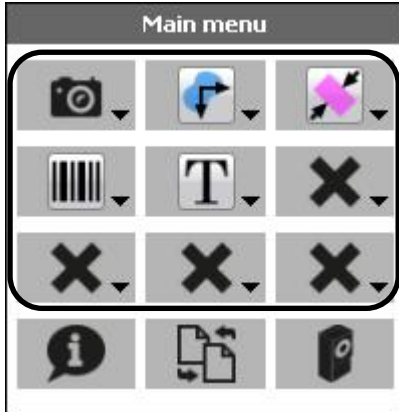
NOTE

 The preview window on the right shows you in real time how your settings affect the data to be sent.

1.	Configure the <i>Text</i> feature check.	
2. Go to the <i>Configure interface</i> → <i>Input process interface</i> step.		
3. Configure all of the settings in the overview for the data input (see Data table settings). (1) Select the feature check / setting to be set. (2) Select the value to be output. (3) Set the start character, separator and end character for the datagram.		
		
4.	You will now see the current set value in the preview window on the right. The SP (Set Parameter) and the number of characters (4 byte ASCII-Hex) will also be prefixed (see SP command)	<p style="text-align: center;"><Start>17.03.2014<End></p> <p>NOTE</p> <p>If no value is set as "expected" during configuration of the feature check, no value will be shown in the preview window!</p>
5.	The command to set the expected value for the device to this date is therefore:	<p style="text-align: center;">SP0017<Start>17.03.2014<End></p> <p>(Note: 0017_{HEX} = 23_{DEZ}, length is therefore 23 characters)</p>

9.3.5 Web interface

In this step, there is the option to assign functions to the upper 9 buttons of the web interface view.



You can assign configured feature checks and the *Parameters for image acquisition* button to the 9 buttons.

Configurable parameters for 'Distance 1':

	User	<input checked="" type="checkbox"/> Profi
Working area edge/circle A	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Working area edge/circle B	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Distance	<input type="checkbox"/>	<input checked="" type="checkbox"/>

Once a button has been assigned a function, you can set which parameters for these functions can be configured in the web interface by which user profiles.

If no user profile is used, only the "Expert" column will be used and the "Operator" column will be greyed out.



If you assign this function to a button, you can set parameters for image acquisition (exposure time, amplification, edge sharpness, gamma correction) via the web interface.

9.4 Device activation




Click on *Activate device*.

Confirm the question with *Yes*.

The Vision Sensor is now in *Activated* mode and processes the created job. The *Statistics / Details* are shown on the right of the parametrisation area.

NOTE

 While the Vision Sensor is processing the job, you may continue to retrieve defect images and to save images.

There is also the option to save the current job and all jobs to the PC via the Job menu

Switch job...
Configure device
Reset statistics

No	Name	Result	Number OK / NOK	Processing time
1	Part location on contours 1	OK	250 / 0 (100.00 %)	28.71 ms
2	Distance 1	OK	250 / 0 (100.00 %)	1.38 ms

Statistics Alarms

Current job:
8: New job 1.app

Number of parts: 250 19.7 parts/s

Number of OK: 250 100.00%

Number of NOK: 0 0.00%

Number of alarms: 0 0.00%

Image acquisition: 35.3 ms

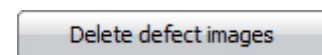
Processing time: 50.4 ms



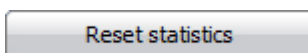
Click on *Switch job...*, to change to a different job stored in the Vision Sensor.



Click on *Configure Device* to return to *Configuration* mode and to make new settings.



Click on *Delete defect images* to delete stored defect images (button only appears when you click on *Defect images* in the display options).



Click on *Reset statistics* to reset the statistics values (number of parts, number OK, NOK, number of alarms).

9.4.1 Statistics / Details

Statistics	Details
Current job:	
1: Neuer Job.app	
<hr/>	
Number of parts:	663 50,6 parts/s
Number of OK:	663 100,00%
Number of NOK:	0 0,00%
Number of alarms:	1 0,15%
<hr/>	
Bilddaufnahme:	18,5 ms
Calculation time:	0,5 ms

The statistics window displays the following values:

- Name of job currently processing
- Total number of parts tested; part per second
- Number of passed parts (OK) (number/percent)
- Number of failed parts (NOK) (number/percent)
- Number of alarms (number/percent)
- Device's processing time in ms (per image, incl. acquisition)

Click on *Reset statistics* to reset the statistics values (number of parts, number OK, NOK, number of alarms).

Statistics	Alarms
Current job:	
2: New job.app	
<hr/>	
Alarm details:	
Invalid trigger:	0 0.00%
Evaluation cancelled:	0 0.00%
Job selection error:	0 0.00%
Error on process interface:	0 0.00%
FTP error:	0 0.00%

The details window displays the following values:

- Name of job currently processing
- Invalid trigger: Alarms due to mistimed triggering (number/percent)
- Analysis aborted: Aborted operations due to processing timeout (number/percent)
- Error in job selection: Alarm during job selection (number/percent)
- Errors at process interface: Errors at process interface (number/percent)
- FTP error: Error during transfer via FTP (number / percent)

10 Device menu

In the device menu, the basic parameters are set which apply equally to all jobs.

You can find the device menu when you click on *Device*.



NOTE

Please observe that it may be necessary to configure the stored jobs if you change these settings.

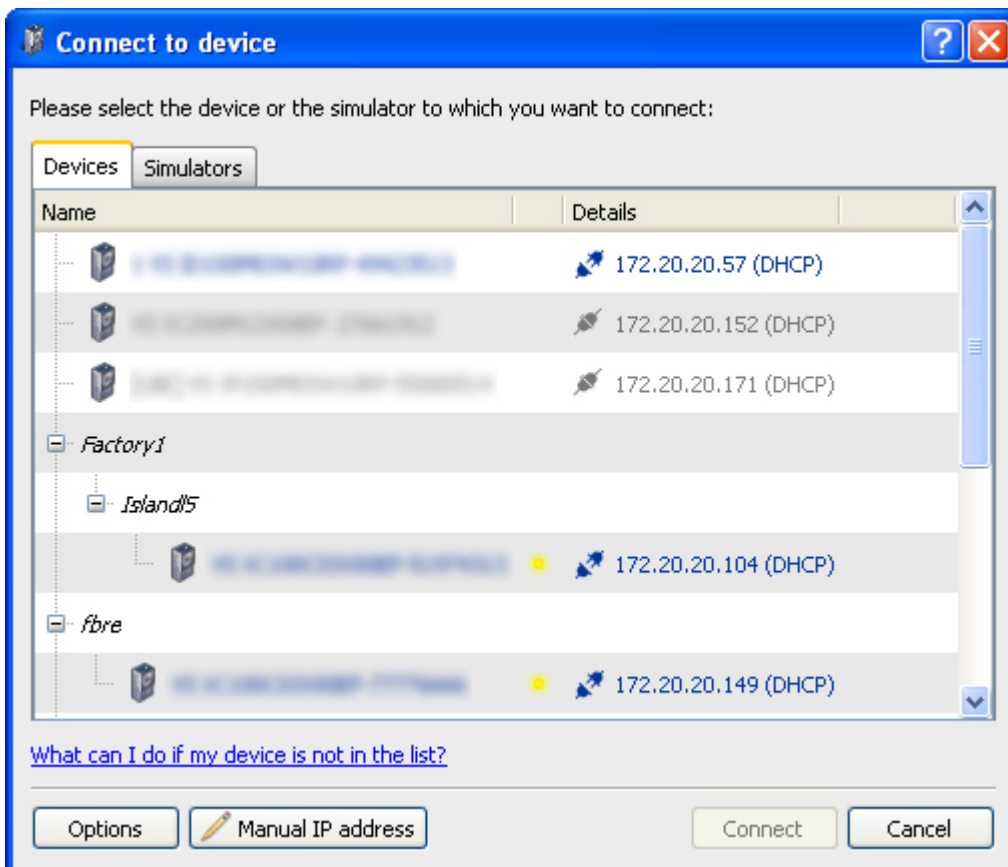
10.1 Connect to device...



Click on *Connect to the device*. Now you can see a list of all located devices on the Devices tab. If a device's device settings contain the location, the corresponding devices will be displayed as a topology ("device tree"). This makes it easier to manage even larger installation bases.

The operating mode and connection status to an *Application Suite* are displayed with a pictogram.

If you move your cursor over the respective device, you will see a tool tip with further information.



Options: Here you have the option of limiting the address area in which devices are searched for and of selecting an alternative port for communication. You can also activate the *User-defined list of known devices*.

User-defined list of known devices

The *User-defined list of known devices* allows you to manage devices from one central location. Different users thus have easy access to the same pool of recorded devices or can view their status (e.g. all those in the same plant) without a device disappearing from view or from the access bar due to an amended IP address or a power failure, for instance.

All devices saved here correspond to the devices with bookmarks. If a bookmark is placed against a device, it is automatically adopted into the list and if the bookmark is deleted it is removed from the list.



NOTE

Make security copies of this list on a regular basis.

Process

1. Save a file ending in .txt (e.g. *knownDevices.txt*) on a drive to which all required users have access.
2. Place a check against *Options* → *User-defined list of known devices*
3. Use *Search* to select the .txt file saved as per 1. above.
4. Confirm the entries made with *OK*.

→ All bookmarked devices will now be listed by name and serial number in the saved file and be displayed in the connection dialogue.

Manual IP address: This is where you can call up a device directly via its known IP address or place a bookmark.










NOTE

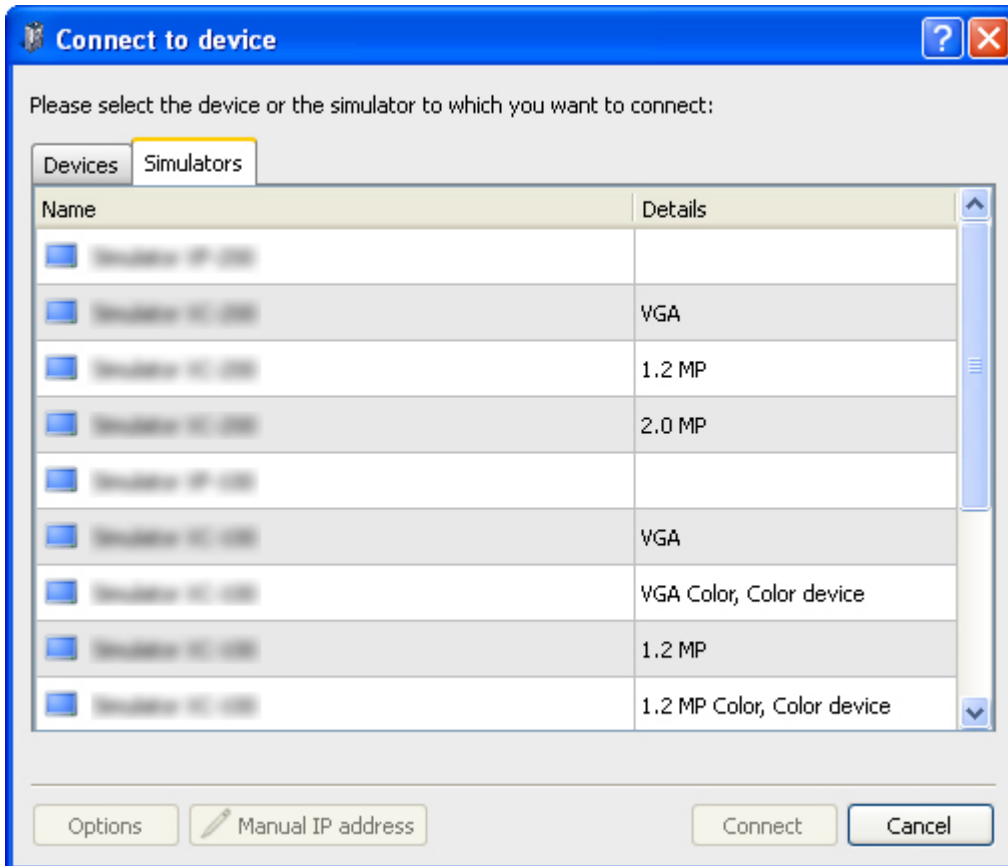
Once a device is installed in a machine it is typically assigned an IP address. In the event of temporary access via an external PC from another sub-network (e.g. for resetting parameters) the IP address is temporarily amended when connection is established.

In order for the machine to be able to access the device as usual again after the temporary amendment in IP address, it needs to recognise the previous IP address again.

This occurs by means of a device restart. Please therefore confirm the corresponding question with *Yes*.

Connection: Create a connection to the selected device.

	<p>The Vision Sensor is in the <i>Activated</i> operating mode.</p>
	<p>The Vision Sensor is in the <i>Configuration</i> operating mode.</p>
	<p>The Vision Sensor is in <i>Recovery mode</i>.</p>
	<p>The Vision Sensor is not connected to an <i>Application Suite</i>.</p>
	<p>The Vision Sensor is connected to an <i>Application Suite</i>.</p>
	<p>Mark the Vision Sensor as a favourite. Now it will remain in the list even if it is temporarily unavailable.</p>
	<p>Here you have the option to hide devices. You can reveal hidden devices with the <i>Display hidden devices</i> function.</p>



On the *Simulators* tab, you can connect with one of the simulators to simulate a device and modify job settings without having to connect to an actual device. Select the desired simulator and click on *Connect*.



NOTE

The device names and device location can be edited under *Device* → *Device settings* → *Device name*.



NOTE

You can launch the *Application Suite* using a command line parameter and automatically connect to the device via an IP address.

Example: `appsuite2.exe /ip=192.168.0.250` (default IP address)

There is also the option to launch the *Application Suite* in different languages using a command line parameter.

`/l=de` (German)

`/l=en` (English)

`/l=fr` (French)

Example: `appsuite2.exe /ip=192.168.0.250 /l=en`
(Start the *Application Suite* in English with the default IP address)



NOTE

Should the device no longer be reachable due to adverse factors (e.g. corrupt job data), and cannot be rebooted into Recovery mode independently, it can normally be forced to start in Recovery mode by starting the *Application Suite* with the following command line parameters:

`appsuite2.exe /ip=<device IP address> /rebootrecovery`

This process normally takes a little over a minute. Once complete, the device will be in Recovery mode and jobs can be deleted, device settings can be changed or new firmware can be loaded.

10.2 Device settings...



The following generally applicable settings are made under the menu option *Device settings*.

10.2.1 Device name

Device name

Device type:

Serial number: 51974313


Device name:

User-defined topology

Device location:

Example: /Factory1/Hall2/Island5

Preview:

- [-] Factory1
 - [-] Island5
 -  IP-CAM-SENSOR 5MP 30x 30 ●

Domain name

Name:

Domain: my-device.local

Device type: The device type is permanently stored in the device and is only displayed.

Serial number: The serial number is permanently stored in the device and is only displayed.

Device name: You can assign a name to the device. This is then shown in the device status.


User-defined topology

Device location: You can enter the device location here. The preview changes as you enter the details.

Domain name: Activate this function if you wish to enter a device domain name for your Vision Sensor. This means that you will not only be able to enter the device's IP address to access it via the browser, but also be able to use a preset domain name (e.g. <http://my-device.local>), which has the advantage of being a fixed URL.

10.2.2 Access rights (device-dependant)

10.2.2.1 Application Suite



ATTENTION!

An assigned password cannot be reset without providing the assigned password.

Please remember your passwords.

Three user levels are available for you to avoid unauthorized changes on the device. The individual privileges for these levels are set as follows:


Function	Operator	Expert	Administrator
Activate / deactivate device	+	+	+
Change the active job	+	+	+
Save and transfer the job to the device		+	+
Process interface assistant		+	+
Change device settings		+	+
Firmware update			+
Backup / restore device			+
Password management / encryption			+

Access rights

Application Suite


Web interface

Restrict access rights for certain user profiles




User

May change jobs and activate or deactivate the device respectively, but may not transfer any new jobs.



Profi

May transfer jobs to the device, but may not make any device-related changes.



Administrator

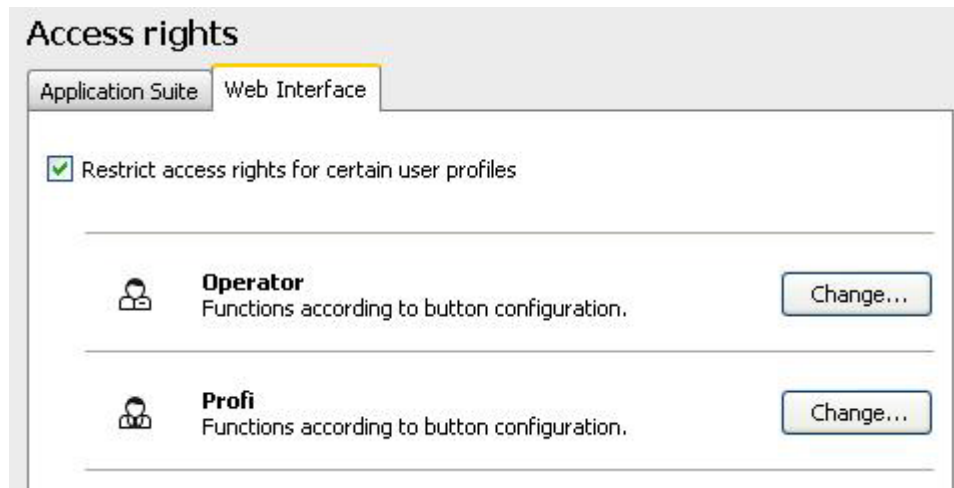
Has full access to all device functions.

Activate the option *Restrict access rights for certain user profiles* for using user profiles.

10.2.2.2 Web interface

Two user levels are available for you to use to avoid unauthorized changes being made via the web interface.

The user levels for the web interface can be configured independently and differently to the *Application Suite* user levels. All functions of the web interface are therefore deactivated under factory settings.



Activate the option *Restrict access rights for certain user profiles* for using user profiles.

NOTE



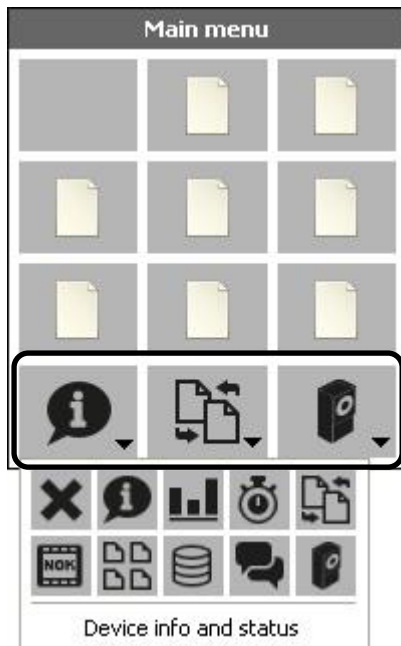
The rights to change individual functions relating to a job can be set during job creation as part of the *Configure interface* → *Web interface* step.











Rights for device-specific functions are set under *Device* → *Device settings* → *Configure web interface*.

10.2.3 Customizing web interface

10.2.3.1 Functions

In this dialogue, you have the option to assign device-specific functions to the three lower buttons in the web interface view.



Icon	Description
	Button has not been assigned a function
	Device info and status
	Statistics
	Processing time
	Change job
	Defect images
	Job management
	Backup
	Language
	Device-specific functions (provides access to all device-specific functions via an additional menu level.)

Configuration of device specific functions:

	User	<input checked="" type="checkbox"/> Profi
Device info and status	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Statistics	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Processing time	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Switch job	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Defect images	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Job management	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Backup	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Language	<input type="checkbox"/>	<input checked="" type="checkbox"/>



NOTE

Setting web interface access rights: *Device* → *Device settings* → *Access rights / Web interface*

Furthermore, you can define the rights for the different user groups for selected device-specific functions under "*Device-specific function configuration*".

Language settings

Language:  German

Save selection by web interface

Language: Select the language for the web interface here

Save the selection via the web interface: Activate this function if you wish to save the changes you have made to the language via the web interface. It will then be active immediately when you next start the web interface. You can only save this setting if a language has been set.

Offer continuous image acquisition 

For User

For Profi

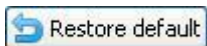


ATTENTION!

The live image function puts the device into "free running" mode, i.e. it runs without the external trigger signal. Please be aware of the effects this may have on later processes.

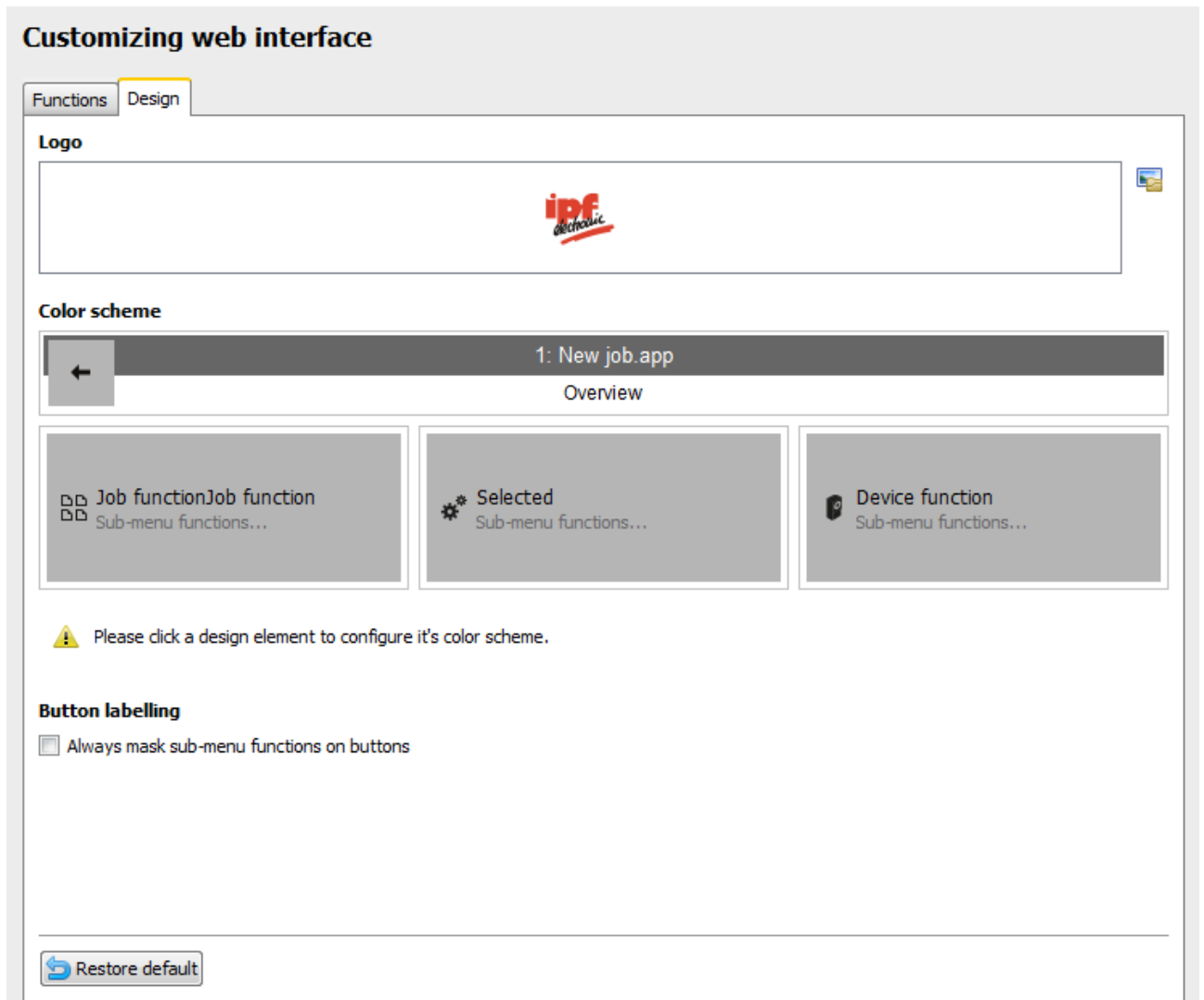
No live image will be available in the web interface when reconfiguring feature checks in the web interface for trigger-controlled image acquisition and stationary analysis.

Here, you can set the user level that has the access rights to temporarily set image acquisition to continuous rather than trigger-controlled using the *Live image* button.



Using this button, you can restore the original settings.

10.2.3.2 Design

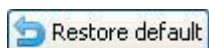


In this dialogue, you have the option to adjust the color representation of the web interface to suit you, and to integrate your own logo (max. 184 x 23 pixels) into the interface.

Click on the design element you wish to adjust and use the controls to adjust the color.

In Expert mode, you have the option to enter color values using hex format (RGB).

Button labels: Activate this function if you do not wish the second row of the buttons to be displayed in the web interface. This is particularly useful for smaller monitors.



Using this button, you can restore the original settings.

10.2.4 Digital I/Os

You can make the settings for the digital interface in this dialogue page. You can also configure an incremental encoder and specify the polarity of the digital inputs and outputs.


Inputs



Input	Configuration	Polarity
Input 1	Trigger	Rising edge
Input 2	Binary job selection - Bit 0	High active
Input 3	Binary job selection - Bit 1	High active
Input 4	Binary job selection - Bit 2	High active
Input 5	Binary job selection - Bit 3	High active

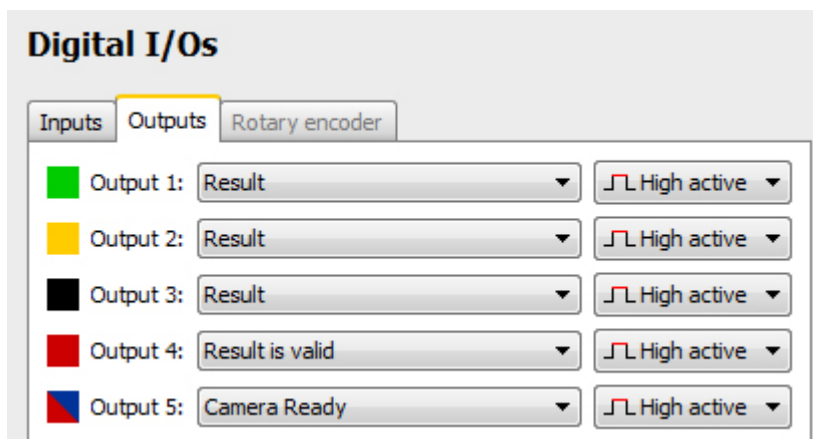
Input 1 is reserved for the trigger. For other inputs you can specify how you want to switch the active job. It is also possible to connect an incremental encoder to the Inputs 5 (CH-A) and 4 (CH-B).

Outputs



NOTE

The number of configurable outputs is device-dependant.



Output	Configuration	Polarity
Output 1	Result	High active
Output 2	Result	High active
Output 3	Result	High active
Output 4	Result is valid	High active
Output 5	Camera Ready	High active

Enter how the outputs are to be activated here. You can output hardware signals (Flash Sync, Alarm, Camera Ready, Result is valid, device activated) for each output or configure the output for outputting job results.

Encoder

Digital I/Os

Inputs
Outputs
Rotary encoder

Conversion impulses to distance

Number of impulses:

Distance:

Invert rotating direction

Calculate values

Select the size known in advance to calculate the values for conversion automatically.

Known size:

Value:

If an incremental encoder is connected, you must also set the factor between the distance travelled and the number of pulses from the encoder.

To determine this factor, either you must know the conveyor speed or you must move the conveyor belt over a defined distance.

Determine the conversion factor as follows:

- Select the known quantity and set the corresponding value.
- Activate pulse measurement by pressing the *Start* button.
- Move the conveyor belt by the set value.
- Terminate the measurement using the *Stop* button.

Press the Test configuration button to check the current setting.

NOTE



All specifications during configuration refer to the forward motion of the conveyor belt. If necessary, reverse the direction of rotation to allow the device to function correctly.

Make sure that Inputs 4 and 5 are set up correctly if you are using an encoder. If not, the functionality of the device may be impaired.

10.2.5 Alarm signal

Alarm signal

Alarm, if...

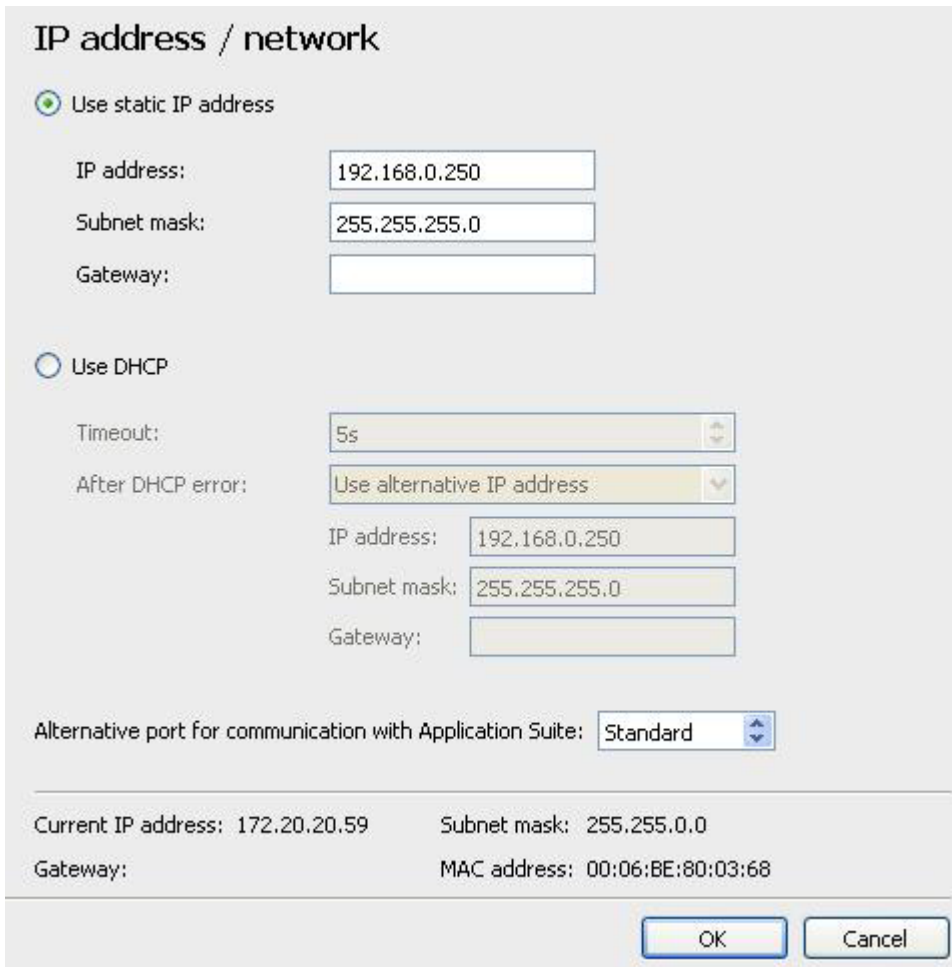
- invalid trigger (trigger during image capture or job change)
- Evaluation cancelled prematurely (output time exceeded)
- Job selection error (invalid job number)
- Error on process interface
- FTP client could not send all files

You can define the conditions which cause an alarm to be initiated here. Alarm signals indicate that an irregularity has occurred in the sensor.

The following causes may trigger the alarm:

Invalid trigger	Trigger during image acquisition, job switching or during parameter setting via the process interface ("SP"-Datagram)
Evaluation cancelled prematurely	The result of computing was not present at the latest output time.
Error in job selection	Invalid job number or job could not be loaded, e.g. because it is not correctly configured.
Error at process interface	An error occurred during data transfer to the process interface, e.g. an invalid command is received.
FTP client could not send all files	An error occurred while transferring the images via the FTP client. Possible causes could include: Device or server overloaded, incorrect access details or server cannot be reached.

10.2.6 IP address / Network



Set the IP address of the device here. There are two choices for this.

- **Static IP address**

The device uses a set IP address.

- **DHCP (Dynamic Host Configuration Protocol)**

If you have integrated a DHCP server in your network, the IP address is obtained there. If this does not happen within a specific time and a timeout occurs, you can choose whether:

- the last IP address obtained via DHCP is used
- another fixed IP address is set

If the port 51.972 (standard) is already being used in your network, you may specify a different port for communication between the connection of the device and the Application Suite.



NOTE

This port must also be set in the dialogue *Connect to device - Options*, in order to create a connection.

10.2.7 Process interface (device-dependant)

Process interface

Data telegram (RD)

Time: Automatically after image evaluation
 GD command via process interface

Structure: send with command identifier (RD) and length
 send result data only (i)

Protocol

Type:

Port:

End identifier:

Receive timeout:

Connection timeout:

Here, you will find all parameters which can be used to configure data exchange via the interfaces.

Datagram (RD)

Time:

Automatically following image analysis: the device sends the datagram independently

GD command via process interface: the device's result is requested with the GD command

Structure:

Send with command designator (RD) and length: the device also sends the RD command designator and the length of the result data (prefixed as a header)

Send result data only: the device only sends the result with no additional information. One suitable use for this would be if the application only requires the result data from the device (without header information).

Protocol

Type: Set the protocol here (TCP / UDP / RS485).

Port: Set the port for the device's Ethernet interface here.

End identifier: Shows which control character is expected or sent at the end of each datagram.

Receive timeout: Here, you can set the time after which receipt is stopped.

Connection timeout: The connection is closed if no contact is received within a given time.

NOTE



A TCP/IP connection can be monitored, for example for when the PLC cyclically sends the "GS" command. If the connection is broken, this is shown on the Vision Sensor page and the connection is reset.

Protocol (RS485) (device-dependant)

Here, you will find all parameters which can be used to configure data exchange via the RS485 interface. Select device number 1 and the "Bus (without checksum)" protocol type and adjust the other parameters as necessary.

Baud rate: Speed of data transfer (bit/s)

Data bits: Number of bits per character

Device number: If you have multiple devices on one RS485 bus, each device must be assigned a number. (1-254)

Receive timeout: Here, you can set the time after which receipt is stopped.

Response delay: Duration between reception of a command and transmission of the response

RS485 terminating resistor: Deactivate the terminating resistor if more than 6 devices are being operated on one RS485 bus.

Parity: Control of the parity bit

Stop bits: Number of stop bits as end code (1)

Protocol: Protocol type (point-to-point, bus without checksum, bus with checksum)

10.2.8 FTP

Using the FTP function, you can save selected images on an FTP server during production. It is also possible to save backups of the device to FTP servers and to access them up from there.

FTP

FTP server

IP address: Port:

User name: Password:

Save images on FTP server

Save images: Number limitation:

Image directory on FTP server:

Name of image series:

Sample: Image_00000000_NOK.bmp, ... , Image_00000999_NOK.bmp

Backup by FTP

Directory for Backup:

FTP Server

IP address: IP address of the FTP server

Port: Port number for the FTP server

Username: Enter the username for FTP access.

Password: Enter the password for FTP access.

NOTE



To use the FTP server successfully, the device requires read, write and delete access. The device and the FTP server must also be located in the same sub-network.

Do not save the images and backup file to the same directory on the FTP server. This can lead to long load times.

Saving images to the FTP server

Saving images: Select the images to be stored on the FTP server.

(NOK only = all images with the total result of "Fail", OK only = all images with the total result of "Pass")

Number limit: Use this function to limit the number of images stored. If the limit is reached, the older images will be overwritten.

Image directory on the server: Select a directory on the FTP server where images are to be stored.

Name of image series: Provide a name for the image series.



You can configure the structure of the file name.

Composition of file name:

Separator:

Entry 1:

Entry 2:

Entry 3:

Entry 4:

Entry 5:

Entry 6:

Entry 7:

Sample:
Image_00000001_NOK_[TD]_New job_001_06-10_103307-501000.bmp

The file name configuration gives you the option to freely arrange up to seven entries. You can also define a separation marker.

The entry options for the device are:

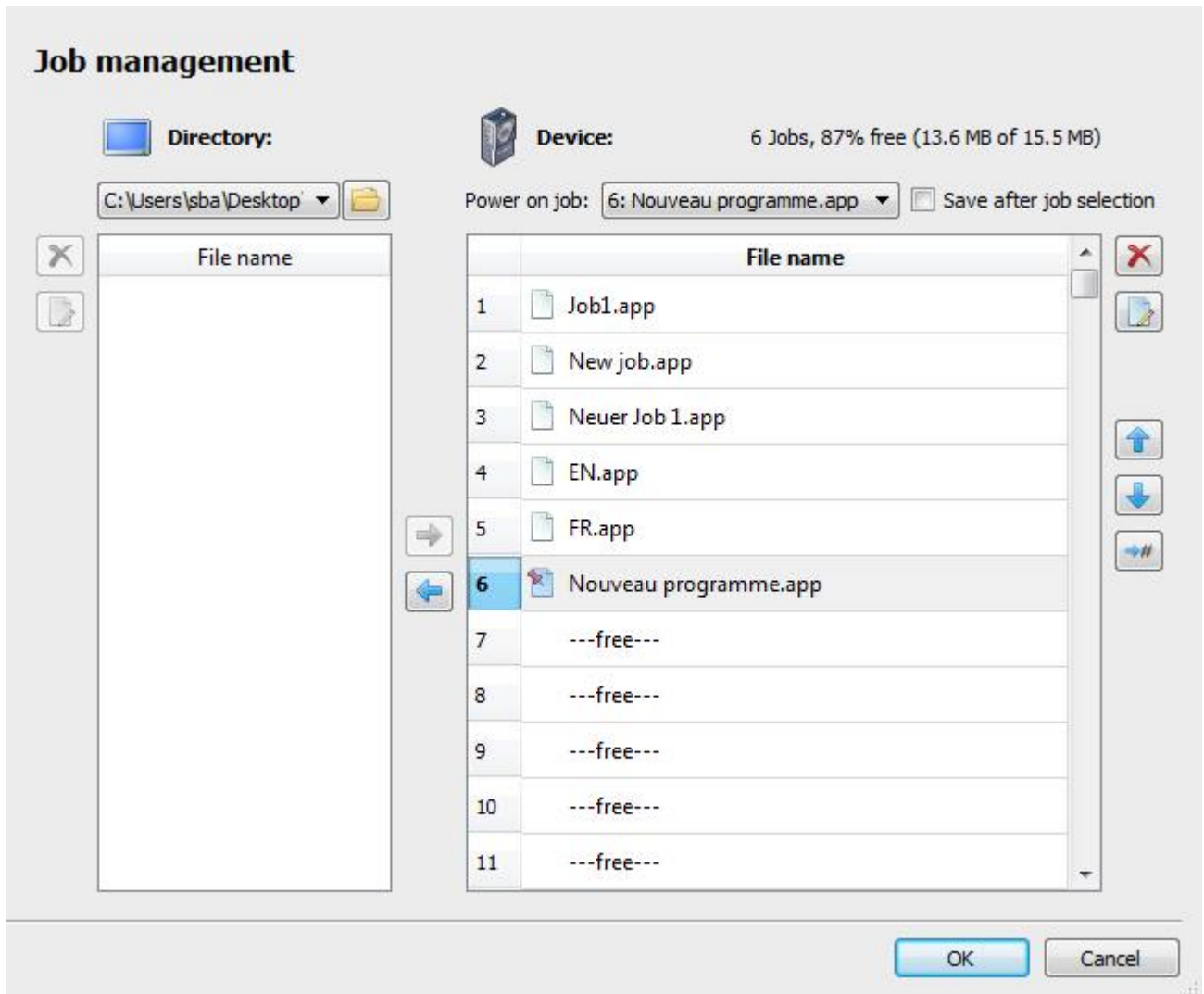
- the chosen name of the image series
- sequential numbers generated by the system (00000001 – 99999999)
- the result of the analysis
- the additional data applied to the image using the TD command
- the job name
- the job number
- a time stamp (when saving images to the PC and backups from the PC: PC time; backup from the browser: browser time (i.e. PC or plant computer; saving images to FTP: time from FTP server (the Vision Sensor time is synchronised with the FTP server every time it is restarted).

Backup via FTP

Directory for backup: Select a directory on the FTP server where the backups are to be stored.

10.2.9 Job management

With this dialogue, you can easily and conveniently copy your jobs between a folder on your computer and the Vision Sensor.




Choose the folder on your computer with: off. The jobs available in this folder are then displayed on the left hand side.

On the right hand side you will see the jobs on the device and their job numbers, as well as remaining storage space available for jobs on the device.

NOTE

Even if no job is available, part of the storage space is occupied by internal files.

Observe that the job number directly corresponds to the binary code with which the jobs are selected in Real time mode via the Job selection via digital inputs.

Power on job: Here you can also choose which job will be loaded when the Vision Sensor is switched on. This job is then marked with this symbol. 

When jobs are switched by the binary method via the digital inputs, no job is active when the device is switched on. In this case, the desired job is selected using the levels present at the inputs.

Save after job selection: Activate this function if you would like the most recently active job to be activated the next time the device is started.

Transfer the jobs using the horizontal arrows and move jobs to the corresponding storage locations in the device with the vertical arrows. You can also use the bottom button to enter the target position for the job directly.


Use the cross to delete jobs.

10.2.10 Job selection / Teach

Job selection / Teach

Job selection via: Application Suite / web interface
 Digital inputs
 SJ command via process interface

Parameters after external teach / SP command

save to device  Changes made via the web interface will always be saved

Here you can basically set how you want to make the job selection.

Job selection via:

Application Suite / Web interface: The job can only be changed manually via the *Application Suite* or via the web interface.

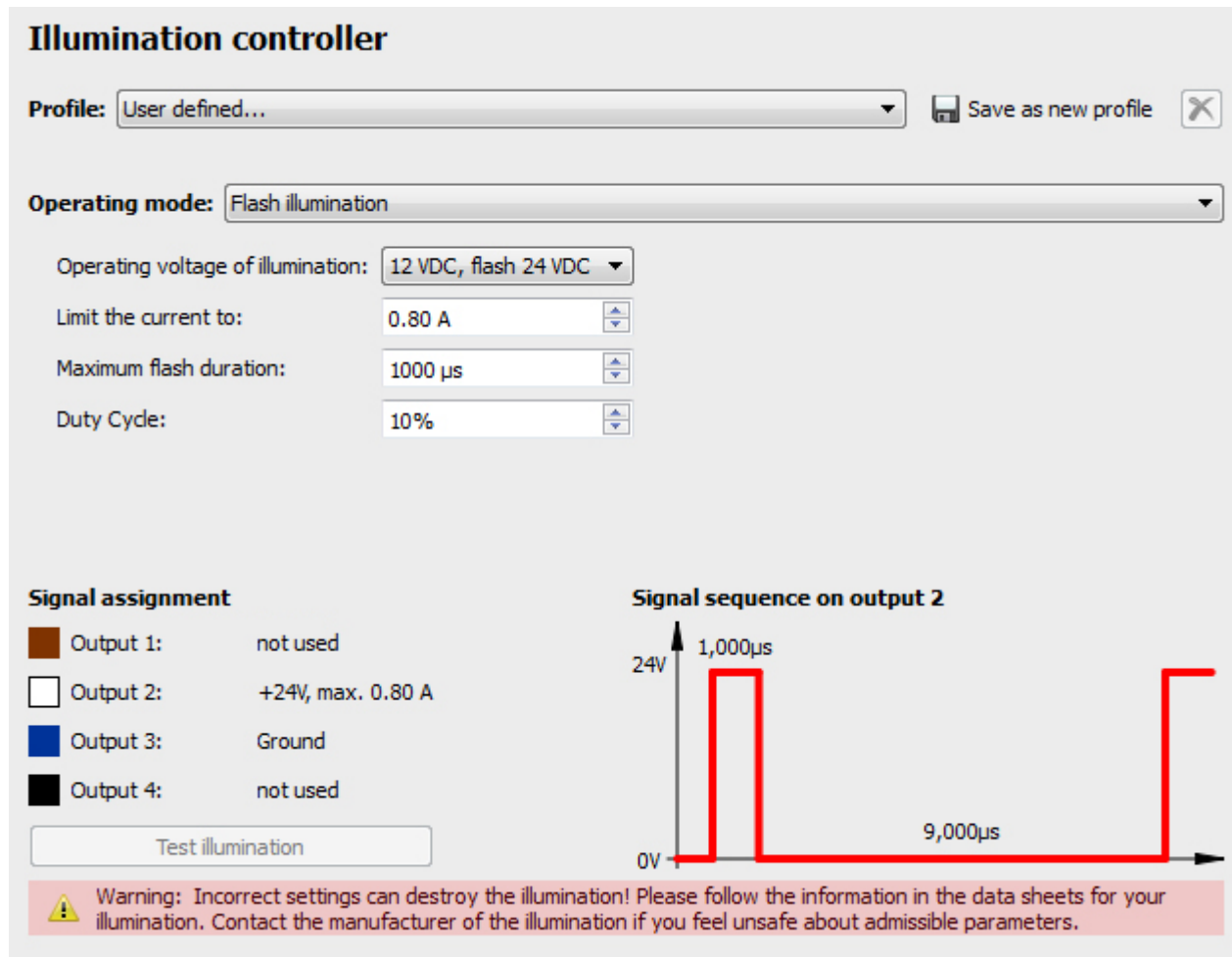
Digital inputs: Jobs are selected via the digital inputs.

Command SJ via process interface: Jobs are selected via the process interface.

Parameters following external teach / SP command

If the “save to device” option is activated, changes resulting from external teach-in or process interface commands in the job are saved to the device. If this option is not activated, changes are discarded when the device is rebooted. In this case, the originally saved job is executed.

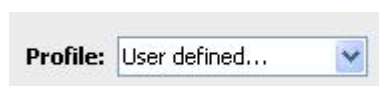
10.2.11 Illumination controller (device-dependant)



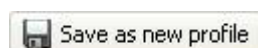
Using the illumination controller, you can make the settings at the outputs of the illumination port.

You can also use a direct "flash" (flash controller function) alongside directly controlling external illumination. Alternatively, an unamplified signal can be output to an external flash controller.

To use the illumination controller, the device must be in *Configuration* mode. If the menu item is not visible, your device does not support this function.



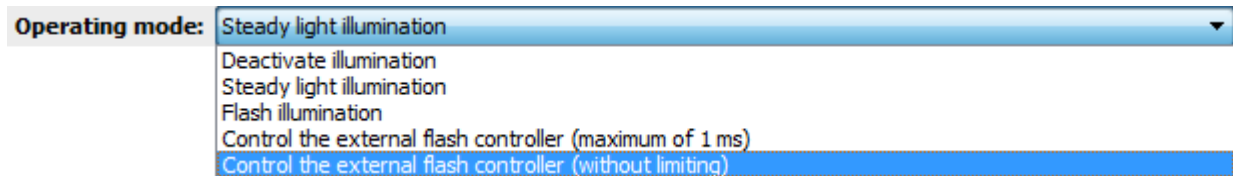
As soon as you have saved a profile that you created, it is available here.



If you have made your own settings, you may save them as a new profile.

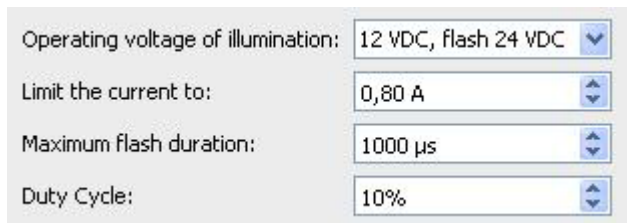


Using this function, you can delete a profile that you created.



You have various operating modes available.





Operating Mode	Description
Deactivate illumination	No settings possible / illumination port deactivated
Steady light illumination	Settings possible (limit operating voltage/current)
Flash illumination	All settings possible
Control the external flash controller	No settings possible, flash sync active
Control the external flash controller (max. 1 ms)	No settings possible, flash sync active (max. 1 ms)
Control the external flash controller (without limit)	No settings possible, flash sync synchronous to exposure active



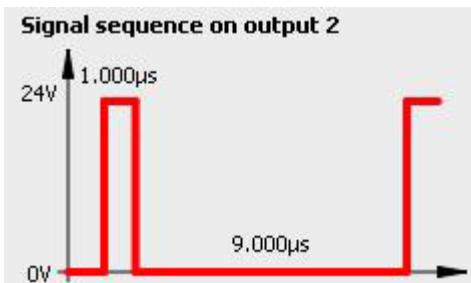
Here, you can define settings in the current operating mode.

Function	Setting Possibilities
Operating voltage of illumination:	12VDC/24VDC
Limit the current to:	<u>Steady light illumination</u> 0.1A...0.8A (increments of 0.1A) <u>Flash illumination</u> 0.1A...4.0A (increments of 0.1A)
Maximum flash duration:	1µs...1000µs
Duty Cycle:	1%...10%

Signal assignment

-  Output 1: not used
-  Output 2: +24V, max. 0.80 A
-  Output 3: Ground
-  Output 4: not used

This view shows how the signals at the 4 outputs of the illumination port are connected for the current settings.



This diagram shows the current waveform at output 1 and output 2.



ATTENTION!

Erroneous settings can destroy the illumination! Please follow the information in the data sheets for your illumination. Contact the manufacturer of the illumination if you are unsure about admissible parameters.

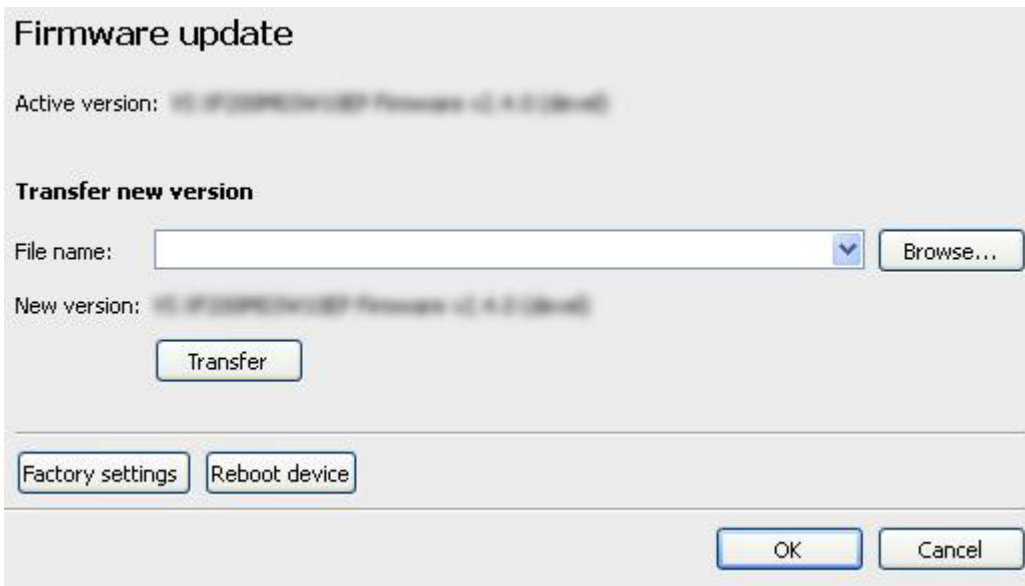
10.2.12 Firmware update

NOTE



During restoration of a backup or firmware, the operation of the device by uninvolved programme components (web interface, *Application Suite* or process interface) is not blocked. This means it is possible to interrupt these during the restoration process.

Do not undertake any other actions during the restoration process!



The screenshot shows a dialog box titled "Firmware update". It displays the "Active version" and "New version" as "V2.6.3 (2024-01-10) (IPF Firmware v2.6.3 (2024-01-10))". Under the "Transfer new version" section, there is a "File name:" field with a dropdown arrow and a "Browse..." button. Below this is a "Transfer" button. At the bottom of the dialog, there are buttons for "Factory settings", "Reboot device", "OK", and "Cancel".

This dialogue provides support in the installation of new firmware.

ATTENTION!



Only use the most recently released version of the firmware for updating. You may wish to ask the Support before updating firmware. Create a device backup of your Vision Sensors before updating firmware!

Browse...


Click on the button *Browse* and select the firmware file to be transferred.
(File extension *.vsf).

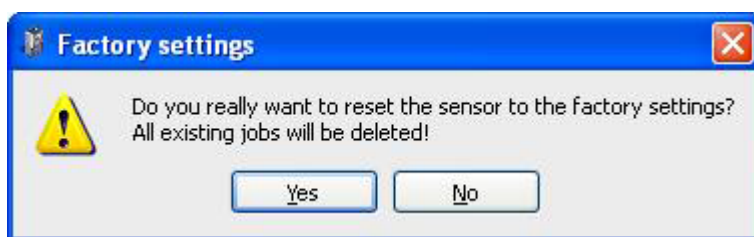
Transfer

Click on the button *Transfer* to carry out the update.

Factory settings

The *Factory settings* button permits the factory settings to be restored. The current firmware will be retained.

 **NOTE**
Restoring the factory settings deletes all of your previous settings and jobs.



Confirm the request with *Yes* to restore the sensor to the factory settings.

Reboot device

Use the *Restart device* button to restart the device. The functionality is equivalent to switching the power supply off and back on.

Confirm the request with *Yes* to restart the sensor.

10.3 Backup

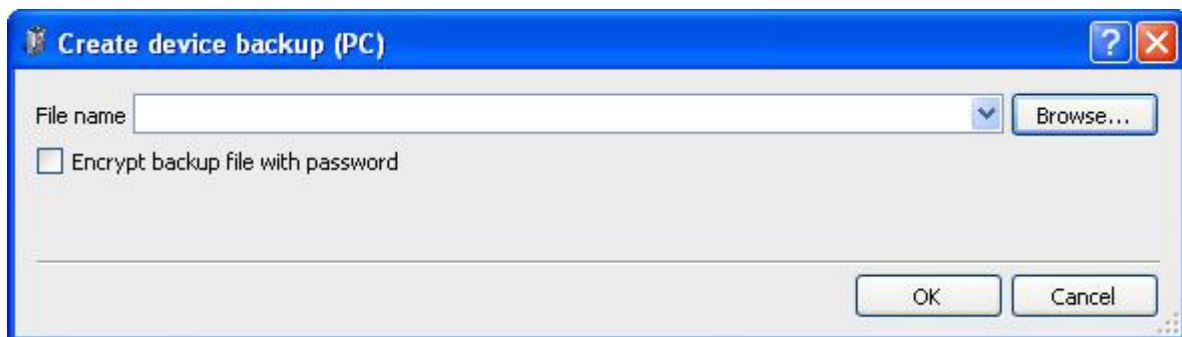
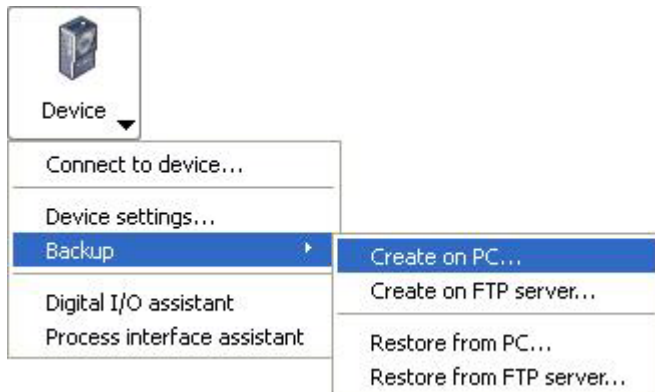
NOTE



During the creation and restoration of a backup or firmware, the operation of the device by uninvolved programme components (web interface, *Application Suite* or process interface) is not blocked. This means it is possible to interrupt these during the restoration process.


Do not undertake any other actions during the creation and restoration process!

10.3.1 Backup - using the PC...

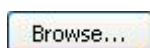


This dialogue page supports you in making a complete device backup of your device on the PC. Here device settings, jobs and firmware are saved in a file. Activate the option “Encrypt backup file with a password” if the backup file is to be stored in protected mode.

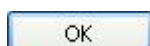
NOTE



The device backup cannot be reloaded without knowing the password!

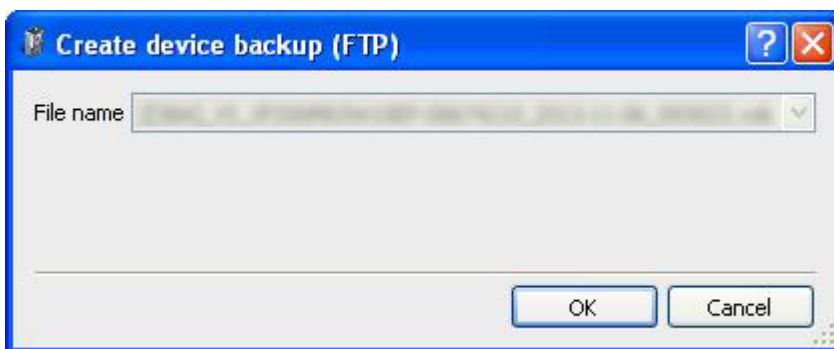
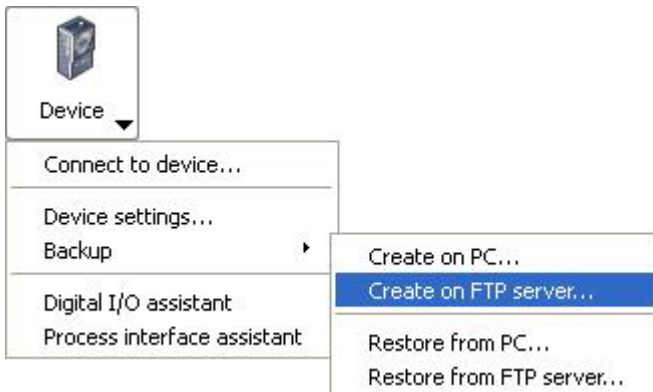


Specify a storage path and a file name for the backup file or click on *Search*. The file extension must be *.vsb.



Click on *OK*. The required file is created. During this process, all device settings and jobs are transferred. This process may take a few minutes.


10.3.2 Backup – using the FTP server...



This dialogue page allows you to create a complete device backup of your device on the FTP. Here device settings, jobs and firmware are saved in a file.

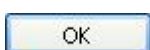
The backup file cannot be protected with a password, and a file name for it cannot be assigned manually.

NOTE



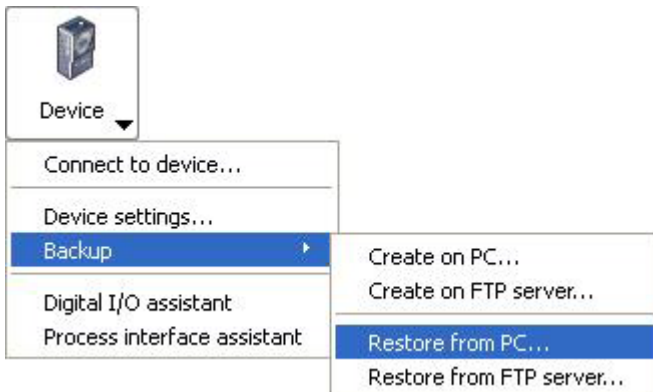
Do not save the images and backup file to the same folder on the FTP server. This can lead to long load times.

FTP settings: *Device* → *Device settings* → *FTP*

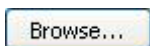
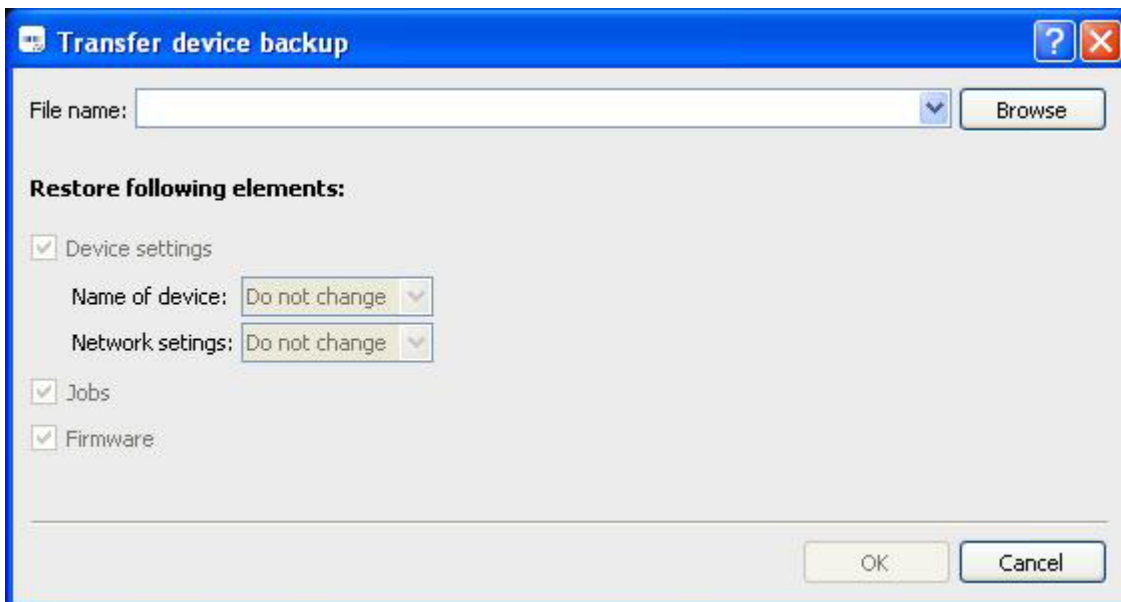


Click on **OK**. The required file is created. During this process, all device settings and jobs are transferred. This process may take a few minutes.

10.3.3 Backup – restoring from the PC...





Use this dialogue to transfer a device backup file from the PC to the device.



Specify the storage path of the backup file or click on *Browse*. The file extension must be *.vsb.


If this is a protected backup file, you must then enter the password.

Restore following elements:

Device settings
Name of device: 
Network settings: 

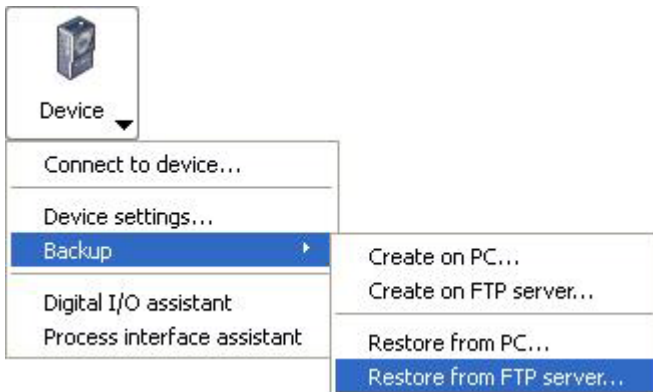
Jobs
 Firmware

Here you select what components are to be transferred during the restore process.

	<p>NOTE</p> <p>If you restore the factory settings of the Vision Sensor, all unsaved files will be lost!</p>
---	---

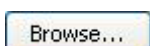
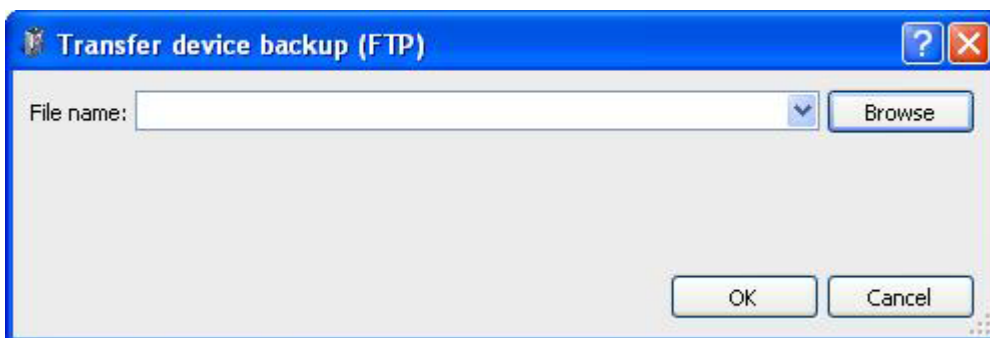
Now transfer the selected settings and jobs to the device with *OK*. This process may take a few minutes.

10.3.4 Backup - restoring from the FTP server




Use this dialogue to transfer a device backup file from the FTP server to the device.

With this dialogue, you can transfer a complete device backup from the FTP server to the device. Device settings, jobs and firmware are all restored.



Specify the storage path of the backup file or click on *Browse*. The file extension must be *.vsb.



NOTE

If you restore the factory settings of the Vision Sensor, all unsaved files will be lost!

Now transfer the selected settings and jobs to the device with *OK*. This process may take a few minutes.

10.4 Digital I/O Assistant



With the Digital I/Os assistant, you can test whether all cables are connected correctly to the digital inputs and outputs. To use the assistant, the device must be in Set-up mode. If the menu option is still greyed, your device may have the wrong firmware version.

ATTENTION!



If your Vision Sensor has already been permanently integrated into your system, it is advisable during initial testing to check the outputs with a meter. Keep in mind that switching of the outputs will be transmitted to any connected controllers!

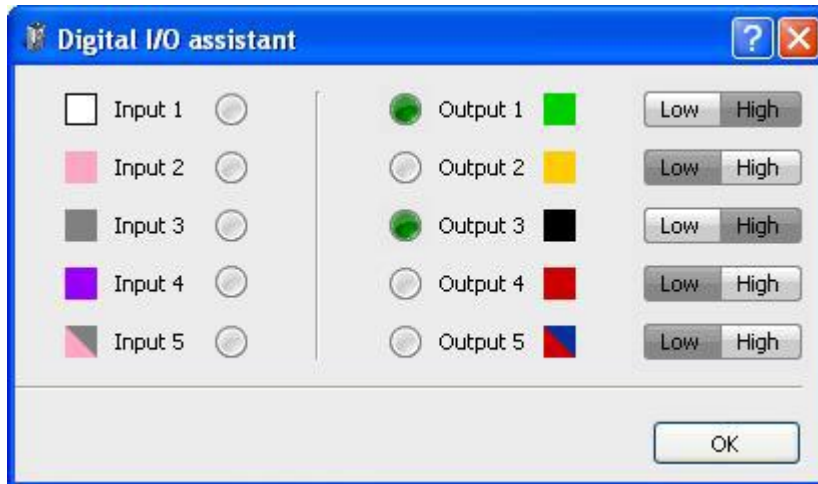
NOTE



If encoders are defined for the inputs 4 and 5, you cannot test these using this assistant! You can change the settings under:

Device → *Device settings* → *Digital I/Os*.

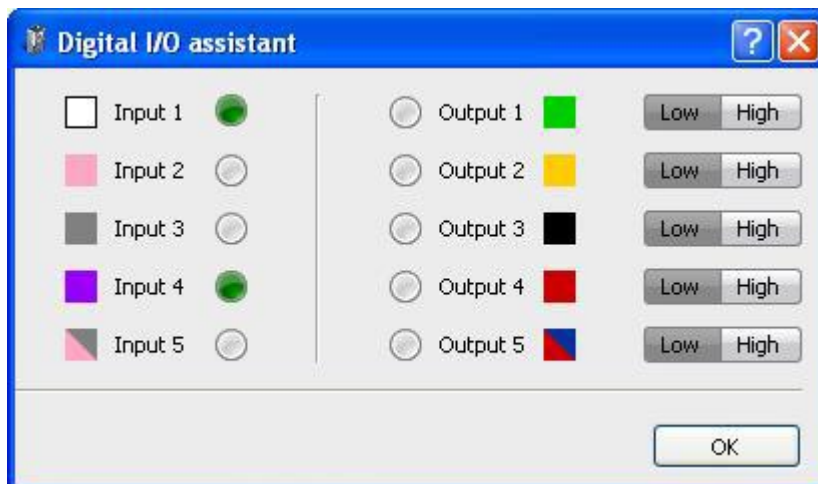
Example using outputs



Set the appropriate output on or off using the Low/High button.

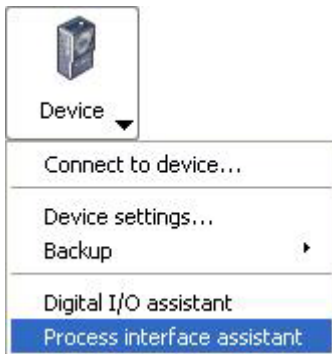
In the example, Output 1 and Output 3 are set. This means that power is now applied to Output 1 and Output 3.

Example using inputs



In the example, applied power is registered on Input 1 and Input 4.

10.5 Process interface assistant (device-dependant)



You can use the process interface assistant to check what data is being sent and received via the device process interface. It appears in chronological order in the *Device communication* field.

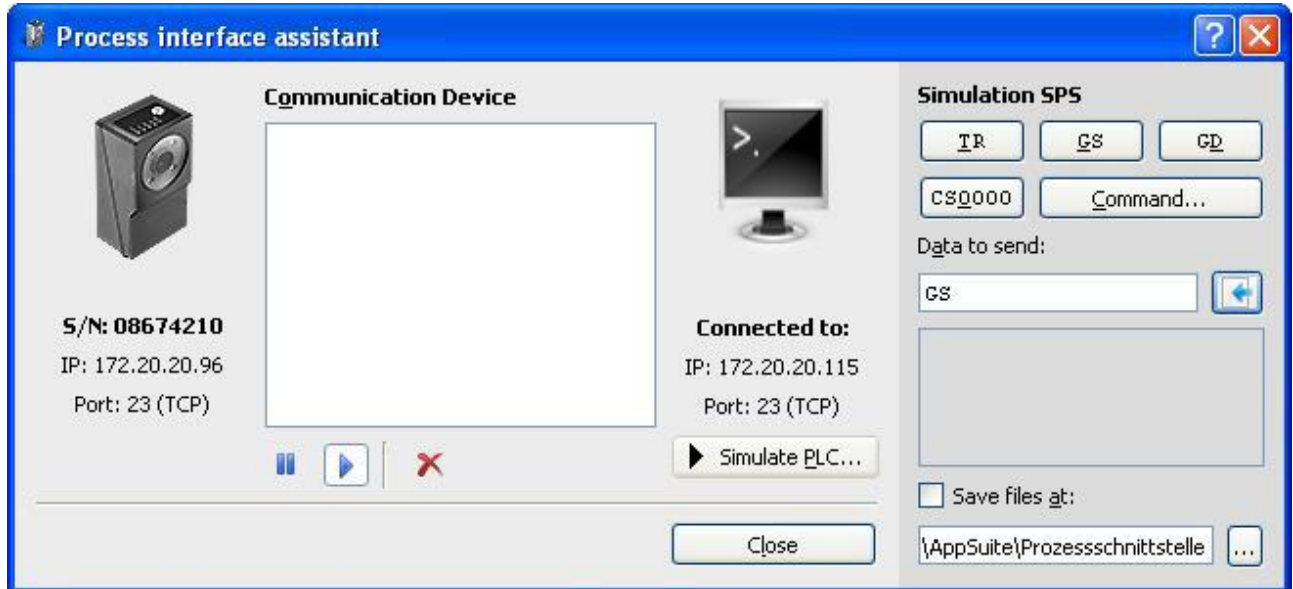
This window is updated immediately when a datagram is transferred through the process interface, regardless of whether it was sent from your PLC or PC.

You can use the corresponding buttons to pause the window, resume a paused image and delete.



You can also use this dialogue page to send commands without connecting a physical PLC.

To do this, click the *Simulate PLC* button....



On the right, you will now see buttons to select common commands, a field to amend the commands or enter your own, and a protocol field showing the data transfer for the simulation.

You can use the *Command...* button to select your chosen command from a list, and then add arguments before using the Send button to transfer it to the connected device.

You can also access data (images, jobs, backups) and select where they should be stored. To do this, activate the option *Store files under:*

10.6 Operating mode display



The current operating data of your Vision Sensor are displayed here:

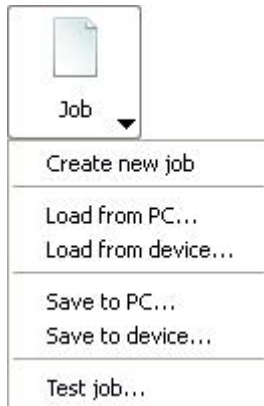
- Device name
- Operating mode (*Configuration, Activated*)



NOTE

Clicking on the relevant displays allows you to change operating modes in the same way as the buttons.

11 Job menu



Actions are performed in this menu that affect jobs. Here you can create new jobs and load and save jobs from different sources. You can also test jobs.

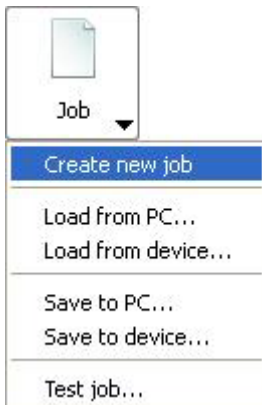
NOTE



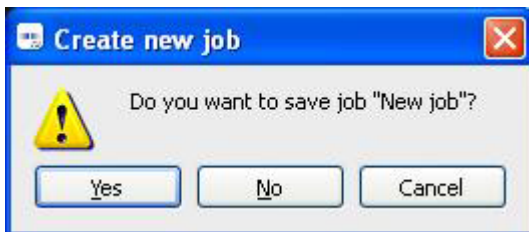
Use job management to copy jobs between your computer and the *device*. This is found under

Device menu → *Device settings* → *Job management*.

11.1 Create new job

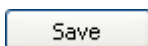


This menu option is used for creating a new job.



Decide whether you want to save the current job.

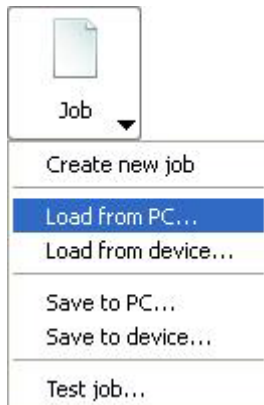
Select a new name of the job and save it.



Click on Save.


You can now configure the job.

11.2 Load job from PC...



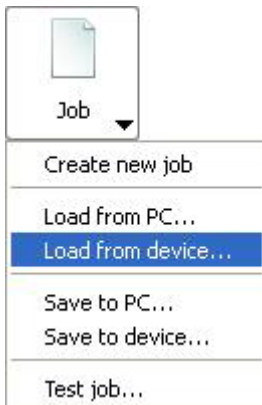
This menu option is used for loading jobs that have already been saved from the PC for processing.

Select the saved file and click on *Open*.

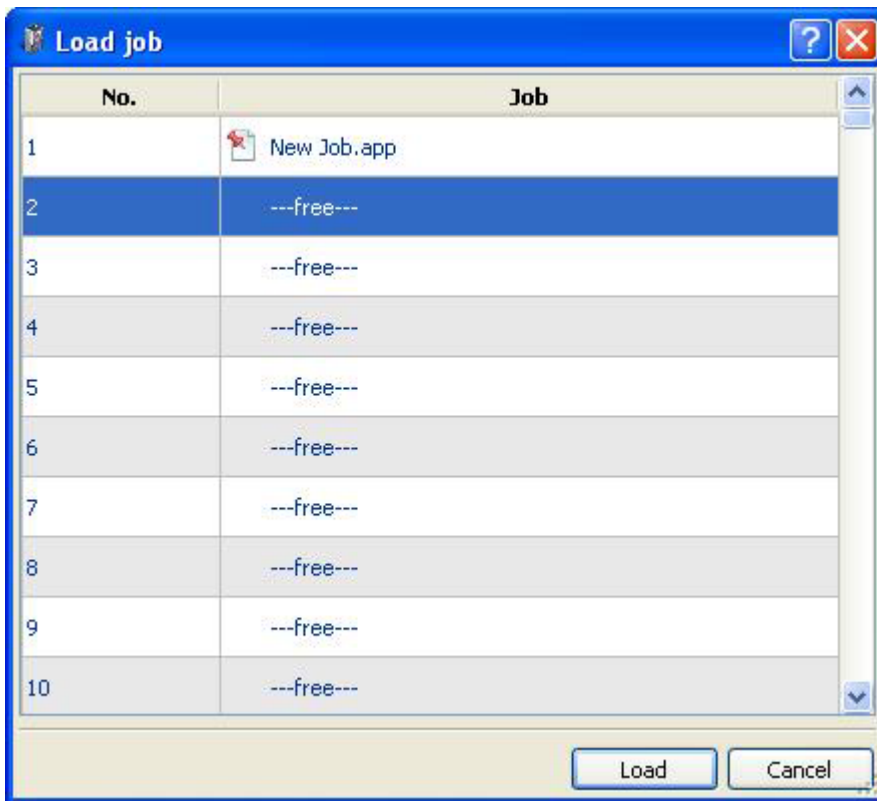
	NOTE
Password-protected files cannot be loaded if the password is not known!	


You can now process the loaded job.

11.3 Load job from device...




This menu option is used to load a job that has already been saved on the device for processing in the *Application Suite*.



 This pin shows that the job is active at power on.

Select the job and click on *Load*.



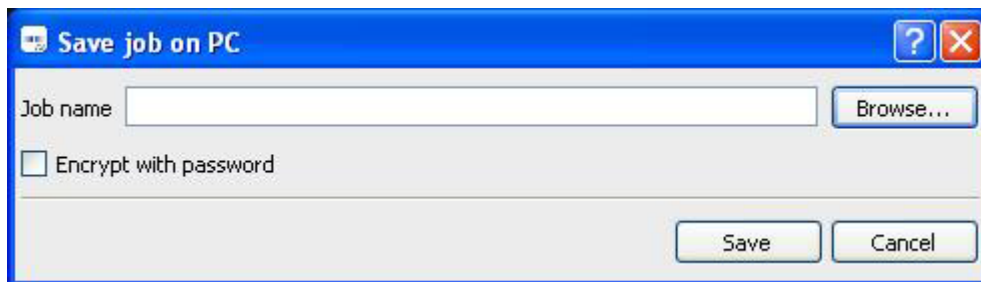
NOTE

Password-protected files cannot be loaded if the password is not known!

11.4 Save job to PC...




This menu option is used to save a job created with the *Application Suite* to the PC.



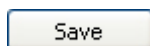
Use *Browse* to select a directory where you would like to save the job.

Activate the option *Encrypt with password* if the file is to be saved in protected mode.

NOTE

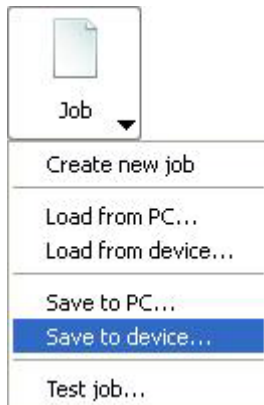


The file cannot be reloaded afterwards without knowing the password!



Click on *Save* to create the file.

11.5 Save to the device...




This menu option is used for save a job created with the *Application Suite* to the Vision Sensor.



Enter a name for the job into the Job Name field and click on Save.

Encrypt with password: Activate this option if the file is to be saved in protected mode.

Activate when switching the device on: Activate this option if you want to activate the saved job when you switch on the Vision Sensor.

 This pin shows that the job is active at power on.

11.6 Test job...



Here, you can test your job using live images or images from one or more sample directories.



If you wish to use images from a folder for the test, you must select the appropriate folder with *Browse*.

Using *Add an additional directory...* you may add additional directories containing images to be tested. You may remove the added directories again by clicking on the X icon.



During the test you have the option of saving only certain images. This is related to the results of the feature check. Choose between "NOK only, OK only and All".

Specify the directory where the pre-selected images will be saved by using *Browse*.

Give a name to the image series to be recorded.

Record process interface

File name:

Record results only

Record total actual data traffic

You have the option of recording the output of the process interface. Select a directory using Browse to determine where the file will be saved.

Record results only: If you only want to save the actual result data, select this option.


Record all actual data traffic: check this option if you want to record all data traffic. Here all data that is actually transferred is recorded and the file will remain empty if no data is transferred!

Limit test to


Activate outputs

You can limit the duration of the test. Select a value and choose between seconds and images. You can also activate or deactivate the outputs.



NOTE

 If you do not limit the test sequence you may terminate the test at any time using the *Finish* button.

ATTENTION!

 If your Vision Sensor is already integrated in your machine, it is often advisable to deactivate the outputs during the first tests to avoid incorrect behaviour of your machine.

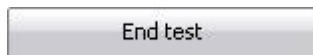
The test is activated with the "Start test" button. In the list of features you will see the current results of the feature checks and the statistics window will give an overview of the results.

No.	Name	Result	Numberl OK / NOK
1	 Position tracking on contours 1	● OK	4 / 0 (100,00 %)
2	 Area size 1	● OK	4 / 0 (100,00 %)

Statistics

Current job:
Lebkuchenjob.app

Number of parts:	4	--
Number of OK:	4	100,00%
Number of NOK:	0	0,00%
Number of alarms:	0	0,00%

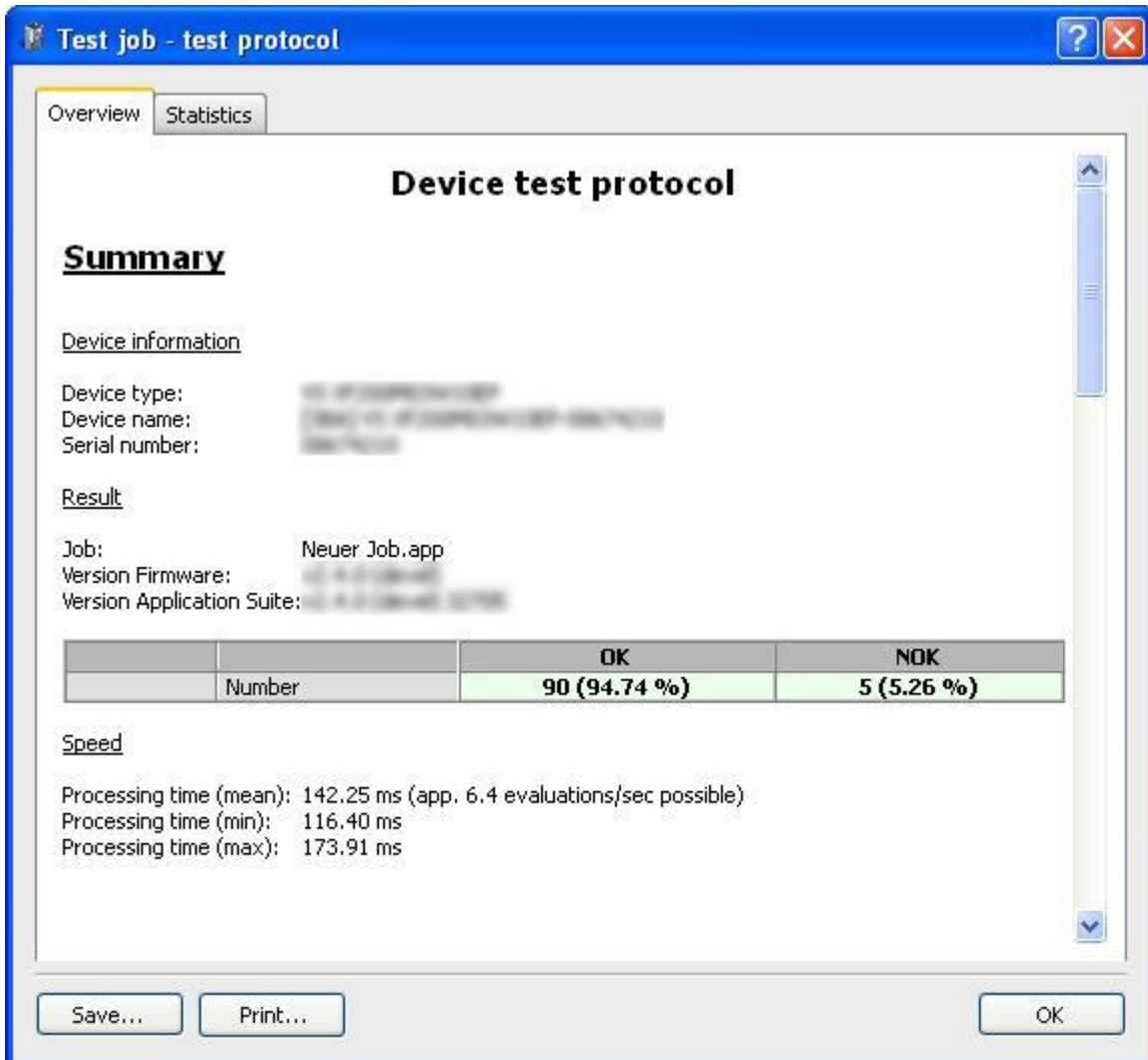


Click on "End test" when you want to end the test.

11.6.1 Test Protocol – Overview

When the test has been completed, the results are displayed in a test protocol, which you can save and print.

When you have completed the test with pictures from different directories, in the test protocol are indicated in different colors.



The screenshot shows a software window titled "Test job - test protocol" with two tabs: "Overview" (selected) and "Statistics". The main content area is titled "Device test protocol" and contains a "Summary" section. Under "Device information", fields for Device type, Device name, and Serial number are shown with blurred values. Under "Result", fields for Job (Neuer Job.app), Version Firmware, and Version Application Suite are shown with blurred values. A table displays the test results:

	OK	NOK
Number	90 (94.74 %)	5 (5.26 %)

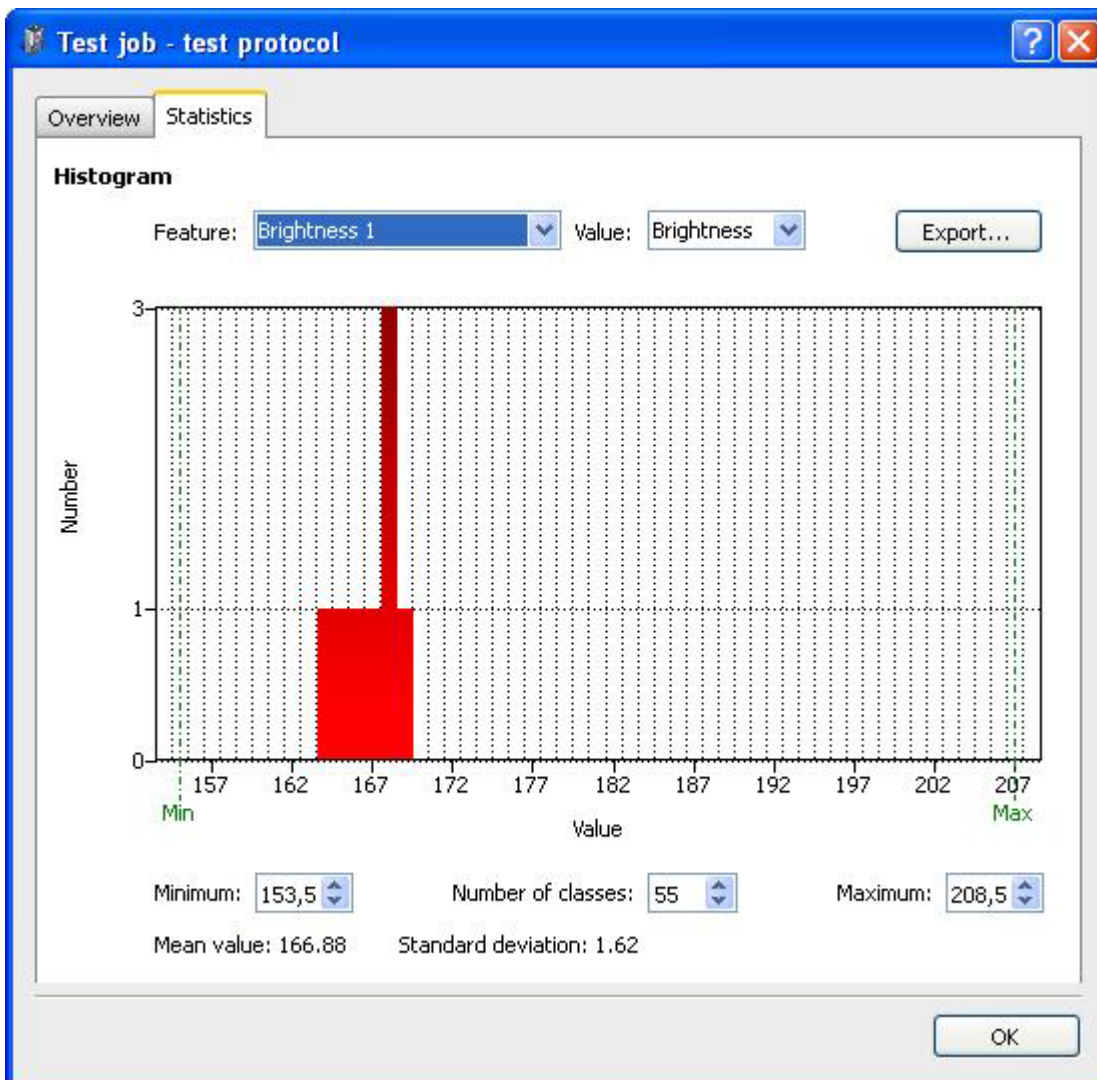
Below the table, the "Speed" section lists processing times: mean (142.25 ms), min (116.40 ms), and max (173.91 ms). At the bottom of the window, there are buttons for "Save...", "Print...", and "OK".

11.6.2 Test Protocol – Statistic

On the Statistics tab, you can even evaluate the job just tested using its individual feature checks according to various criteria. The results are displayed graphically using a histogram.

The currently displayed result can be exported as a *.csv or *.txt file.

Under *Feature*, select the feature of the tested job or the entire job (number of OK/NOK) to be evaluated. Under *Value*, you may evaluate the numerical results of the feature check (the angle of the object's rotation in the event of a part location).



Minimum: Set the minimum of the range of values here.

Number of classes: You can set the scaling between the Minimum and Maximum here.

Maximum: Set the maximum of the range of values here.

If you move the mouse pointer over the histogram, a tool tip appears containing the values of the current mouse pointer position.

The average and the standard deviation of the evaluation are displayed in the lower region.

11.7 Result and user display



The current job information for your Vision Sensor is displayed here. The information consists of:

- Job name
- OK, NOK or Alarm
- Current user (device-dependant)

12 Feature checks

All feature checks are described below. Note that not all feature checks are supported by all devices.

Please see the *Correct use* section for information as to which devices support which feature checks.

NOTE



The *Application Suite* CD features a range of application examples that provide you with typical solutions for various inspection tasks and for the use of the individual feature checks. After successful installation, the examples can be found in the subdirectory:

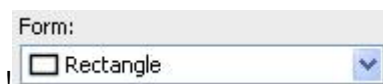
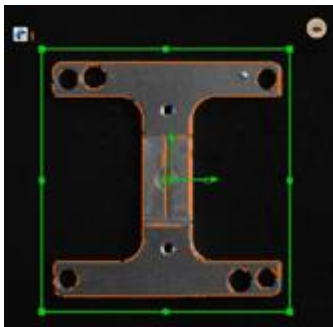
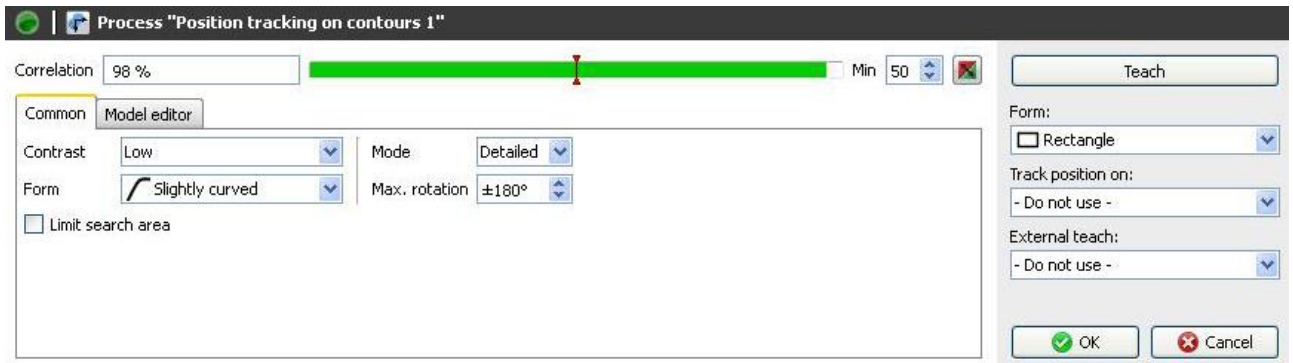
`<installation path>\AppSuite\Samples`

on your PC.

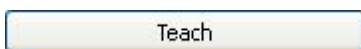
12.1 Part location

12.1.1 Part location on contours

With this feature check, the position of an object is determined using contours.



- Choose the shape of the area from which the contours are adopted.



Adopt the contours by pressing "Teach". A search is then made for the object in the entire image.



- The match of the contours with the found object in the image is displayed here.
- Using the appropriate switching points, set how good the match must be so that the object is found. The button on the extreme right inverts the set point.

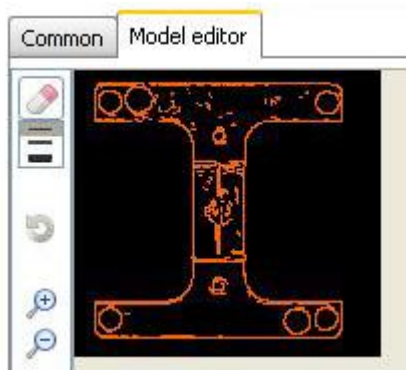
Common		Model editor	
Contrast	Low	Mode	Detailed
Form	Slightly curved	Max. rotation	±180°

- **Contrast:** Set the minimum contrast of the contours that should be adopted in the model.
- **Form:** Select the shape of the contour that corresponds to the test object and that should be adopted in the model.
- **Mode:** Set the amount of detail to be used in the inspection. (The more detailed the mode, the higher the processing time.)
- **Max. rotation:** If you want to find the object only in a limited angular range, you may specify the maximum rotational position here. (Limiting the angular range reduces processing time.)

Limit search area

- If you do not wish to search for the object in the entire image, set the tick and then limit the search area.

Model editor tab



- With the displayed model, you can now use the mouse to delete contours which clearly do not belong to the reference object.



- Use this button to restore the model to its original state.



- You can use these two buttons to enlarge or reduce the model.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

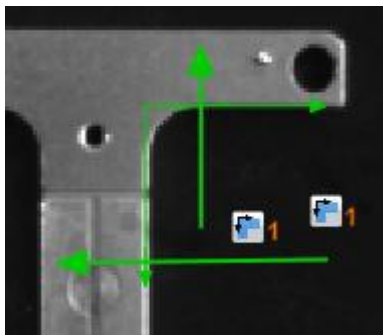
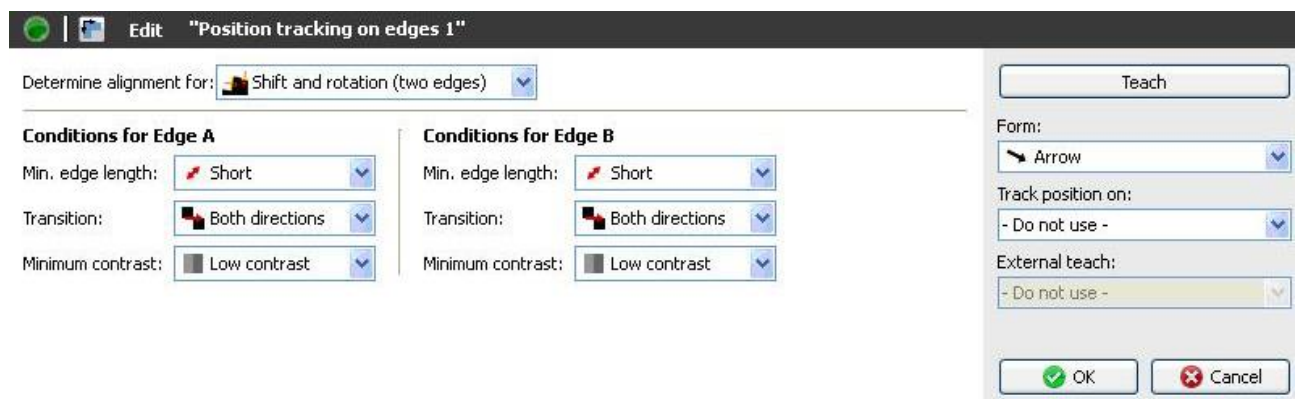
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Conformity	Integer	Match of the model (%)
Centre of object	Float-Point	Position of the object in the image (px)
Angle of object's rotation	Float	Angle of the object (degrees)

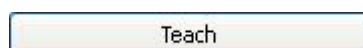
12.1.2 Part location on edges

This feature check localizes an object using edges. The detected position is used as a reference for the subsequent feature checks. In this way, tilted or displaced objects can also be examined. All fields of view and search beams for which part location is activated are corrected according to the current position of the test object.

This feature check does not support external teach-in. If a teach-in procedure is still executed, the parameters set will be maintained.

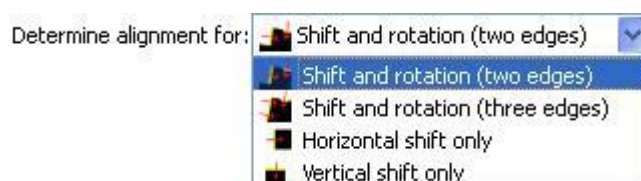


In this example, two edges of a test object are found, with a horizontal and a vertical search line, and the reference point for part location is determined at the intersection of the detected edges.



- If you wish to change the reference position of the part location, press the *Teach* button and the new position will be adopted.

Configuring of the part location as follows:



- **Determine alignment for:** Select the type of part location. You can determine either offset and rotation on two edges, offset and rotation on three edges, only horizontal or only vertical offset. A shorter processing time is required with fewer edges.
- Depending on whether you wish to align to one or two edges, you must then draw the search lines directly in the image using the mouse. Hold the left mouse button depressed during this.
- Position the search lines such that the sought contour is intersected as closely as possible to the middle. The first contour is detected which intersects the search line along the search axis. You can correct the positioning at any time.
- With long edges it is advisable to search the main reference edge with two search lines.

Conditions for Edge A		Conditions for Edge B	
Min. edge length:	 Short	Min. edge length:	 Short
Transition:	 Both directions	Transition:	 Both directions
Minimum contrast:	 Low contrast	Minimum contrast:	 Low contrast

Enter the criteria:

- **Min. edge length:** You must also specify whether a short, medium or long edge is to be sought. Using User defined, you may manually enter the length of an edge (5-1000 pixels).
- **Transition:** You must specify whether each edge can progress from bright to dark or from dark to bright (device-dependant).
- **Minimum contrast:** Specify whether you are searching for an edge with sharp or weak contrast.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

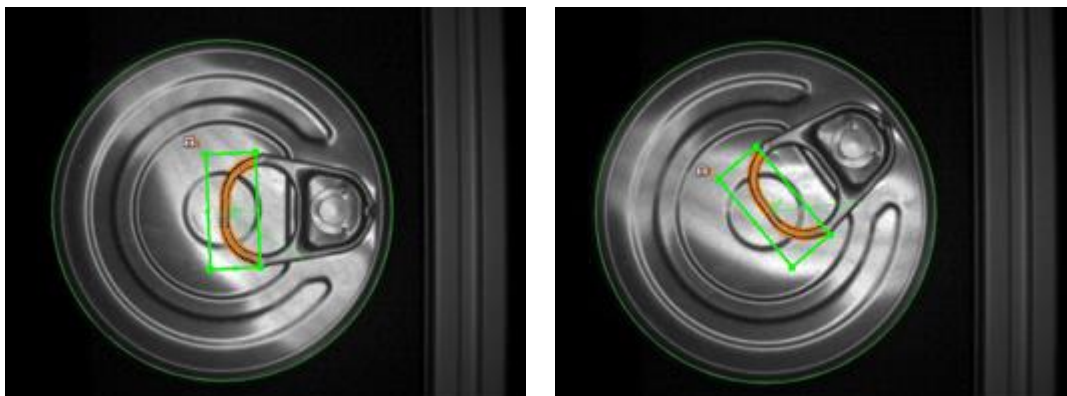
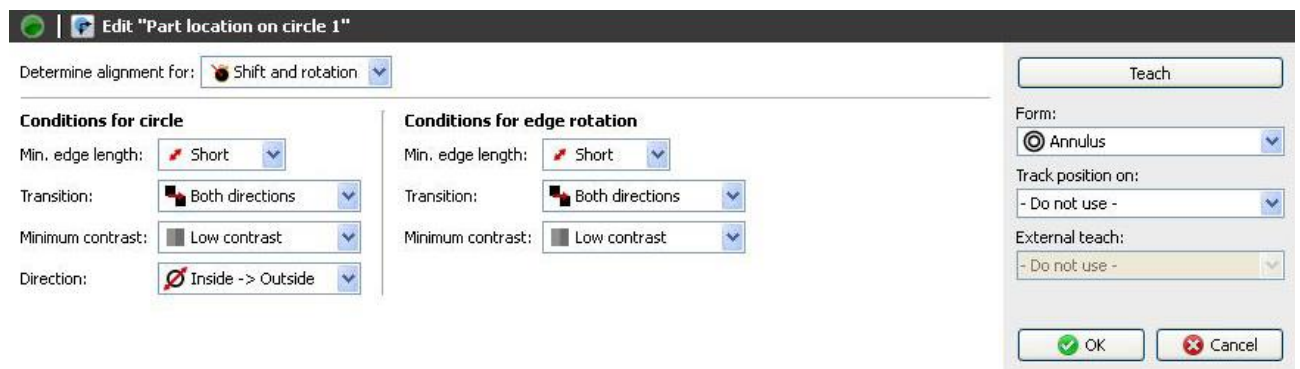
Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Centre of object	Float-Point	Position of the object in the image (px)
Angle of object's rotation	Float	Angle of the object (degrees)
Edge A	Float	Coordinates of the found edge A: Start point X – separator Start point Y – separator Rising of edge Δx – separator Rising of edge Δy – separator
Edge B	Float	Coordinates of the found edge B: Start point X – separator Start point Y – separator Rising of edge Δx – separator Rising of edge Δy – separator

12.1.3 Part location on circle

With this feature check, you can align a round object with regard to its centre. It is also possible to correct the angle of rotation on the basis of an edge along the object.

In this example, the shape of the ring-pull on a drinks can is examined. The angle of rotation is determined and corrected by the feature check "Part location on circle".

This feature check does not support external teach-in. If a teach-in procedure is still executed, the parameters set will be maintained.



Configuration for part location on a circle as follows:



- Select the shape of the field of view. A circular ring and a circular ring sector can be chosen.
- Draw the inner and outer reference circles with the mouse.
- The inspection of a circle is always conducted along the individual segments from circle A to circle B and in the direction indicated by the blue arrows.
- Adjust the edge length, transition type and contrast until the circle is reliably detected.

Determine alignment for: Translation only

- Select the type of part location. You can either search for a circle and thereby compensate displacement or also detect rotation of the object by an edge in close proximity.
- Draw the arc with the mouse to search for the associated edge.

Conditions for circle

Min. edge length: Short

Transition: Both directions

Minimum contrast: Low contrast

Direction: Inside -> Outside

Conditions for edge rotation

Min. edge length: Short

Transition: Both directions

Minimum contrast: Low contrast

Enter the criteria:

- **Min. edge length:** You must also specify whether a short, medium or long edge is to be sought. Using User defined, you may manually enter the length of an edge (5-1000 pixels).
- **Transition:** You must specify whether each edge can progress from bright to dark or from dark to bright or in both directions (device-dependant).
- **Minimum contrast:** Specify whether you are searching for an edge with sharp or weak contrast.
- **Direction:** Select the direction of the search

- If you wish to change the reference position of the part location, press the *Teach* button and the new position will be adopted.

- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

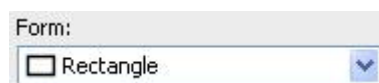
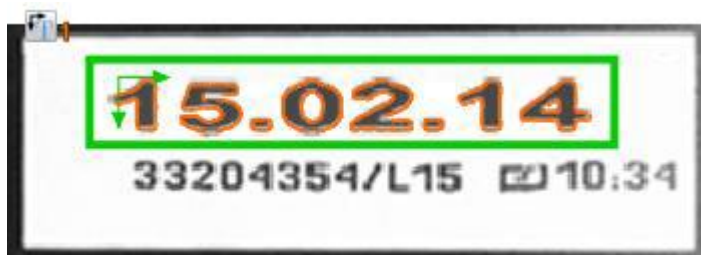
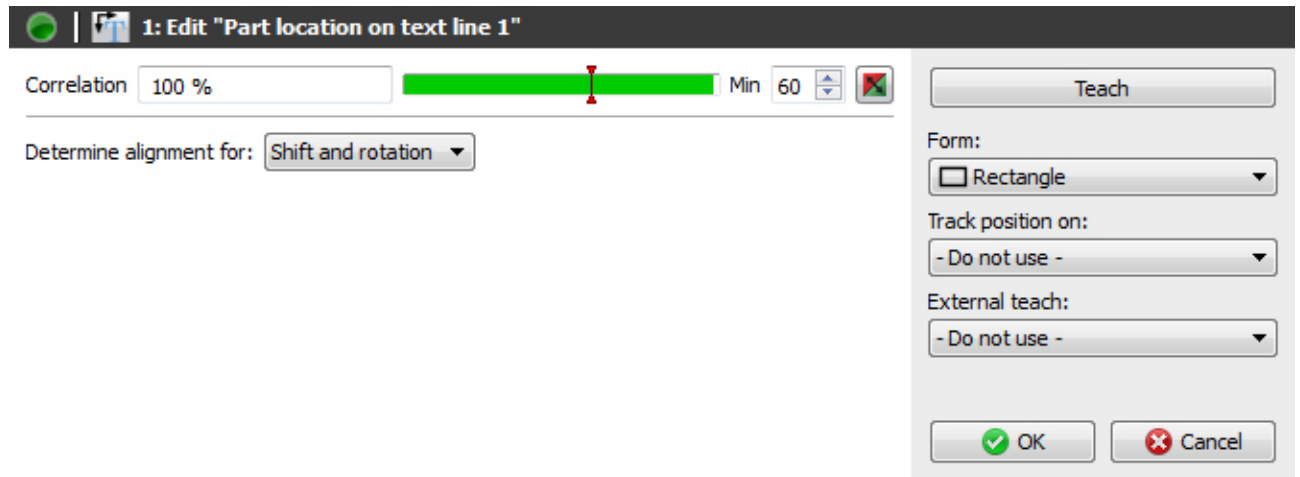
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Circle centre	Float-Point	X – Separator – Y
Circle diameter	Integer	
Edge (for rotation correction)	Integer	Coordinates of the found edge for rotation correction: Start point X – Separator Start point Y – Separator Rising of edge Δx – Separator Rising of edge Δy – Separator

12.1.4 Part location on text line

With this feature check, the position of the text within a field of view can be determined. To do this, the field of view must be positioned roughly parallel to the text with deviations of +/- 15 degrees being tolerated. The background of the text should be homogeneous to achieve a stable analysis. The position found can then be used to align other feature checks, for example, the "Text" feature check.

This feature check supports external Teach. The position of the text line will be re-taught.



- The conformance of the current object with the taught-in model is displayed directly. You can set the associated switching point in the graphic display.
- The button on the extreme right inverts the set point.
- The switching point *Min* can also be edited manually.

Determine alignment for:

Select which alignment should be determined:

- Offset and rotation
- Offset only



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

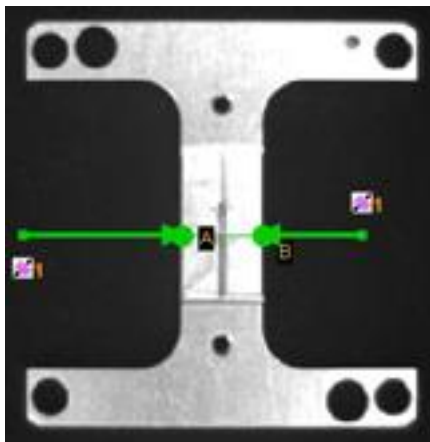
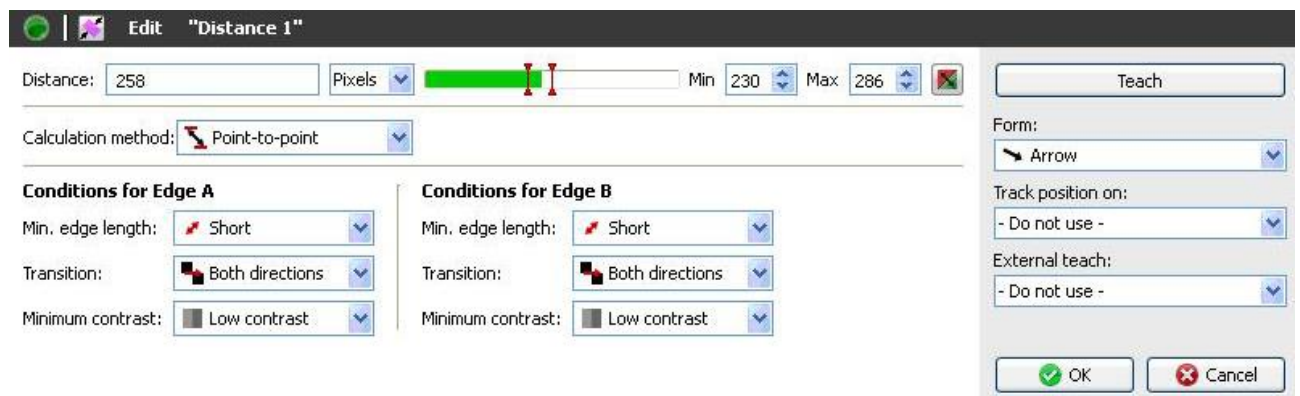
Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Conformity	Integer	Match between the current object and the taught-in model (%)
Text position	Float-Point	X – <i>Separator</i> – Y
Text angle	Float	

12.2 Geometry

12.2.1 Distance

This feature check determines the distance between two points, the right angular distance between two points and the distance of an edge in relation to a reference edge (a taught-in edge) and compares the distance found with the associated switching points.

This feature check supports external Teach. The switching points are adjusted as a percentage to the current measured value.




- Select the shape of the field of view. A search line and an arc can be chosen.
- Adjust the field of view by holding the left mouse button depressed.

In this example, two points on a test object are detected with one search line each. The distance between the intersections is indicated directly in the display:



- The current result is displayed directly in the dialogue as the distance. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.

Calculation method:  Point-to-point

Select the computation method.

- **Point-to-point:** Distance between two points
- **Rectangular distance:** Right angular distance between two points
- **To reference:** Distance to a reference edge
- **Edge to circle:** Distance from one edge to the centre of a circle
- **Circle to circle:** Distance between the centres of two circles

Teach

- Click on Teach to retrain a new reference.

Conditions for Edge A

Min. edge length:  Short

Transition:  Both directions

Minimum contrast:  Low contrast

Conditions for Edge B

Min. edge length:  Short

Transition:  Both directions

Minimum contrast:  Low contrast

- **Min. edge length:** With short, medium or long, select the anticipated length of the sought contour to achieve a consistent result. Using User defined, you may manually enter the length of an edge (5-1000 pixels).
- **Transition:** You must specify whether each edge can progress from bright to dark or from dark to bright (device-dependant).
- **Minimum contrast:** Specify whether you are searching for an edge with sharp or weak contrast.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

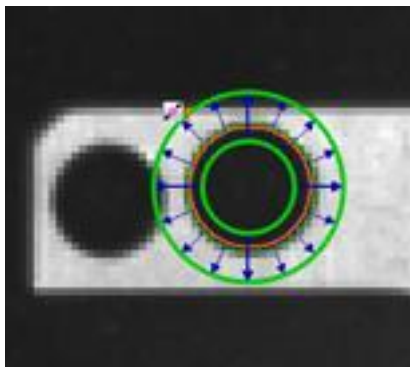
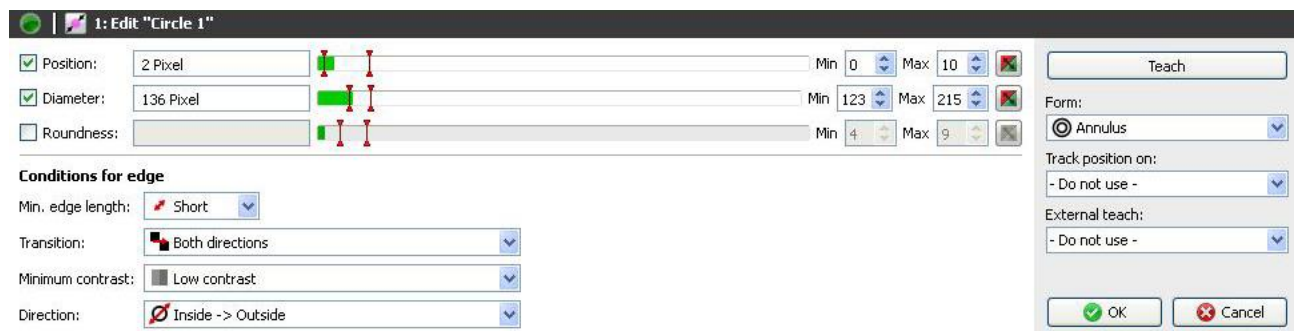
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Distance	Float	

12.2.2 Circle



This feature check determines the position, the diameter and the roundness of a circle in comparison to a reference circle that is taught in. The search area for a circle is defined by selecting a minimum inner circle and a maximum outer circle. Both the position and the diameter of the detected circle are compared with switching points.



This feature check supports external Teach. The switching points for the diameter are adjusted as a percentage to the current measured value. The thresholds for the distance remain unchanged as the newly programmed circle is adopted as a reference and the distance reverts to zero.






- Select the shape of the field of view. A circular ring and a circular ring sector can be chosen.
- Adjust the field of view by holding the left mouse button depressed.

In this example, the diameter, position and roundness of a hole are determined by measuring from the outer circle towards the inner circle. Both results appear directly on the display:

Position:  Min Max 

Diameter:  Min Max 

Roundness:  Min Max 


Fail Pass Fail



- **Position:** Determine the switching points of the position.
- **Diameter:** Determine the switching points for the diameter.
- **Roundness :** Determine the switching points of the roundness.


The right button is used to invert the result of the feature check.


- If you wish to change the reference position of the centre of the circle, simply press the *Teach* button and the new position will be adopted.

Conditions for edge

Min. edge length:  Short

Transition:  Both directions

Minimum contrast:  Low contrast

Direction:  Inside -> Outside

- **Min. edge length:** With short, medium long or user defined, select the anticipated length of the sought contour to achieve a consistent result. Using User defined, you may manually enter the length of an edge (5-1000 pixels).
- **Transition:** You must specify whether each edge can progress from bright to dark or from dark to bright (device-dependant).
- **Minimum contrast:** You can also specify whether you are searching for an edge with sharp or weak contrast.
- **Direction:** Select the direction of the search.

Track position on:
 - Do not use -

External teach:
 - Do not use -

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

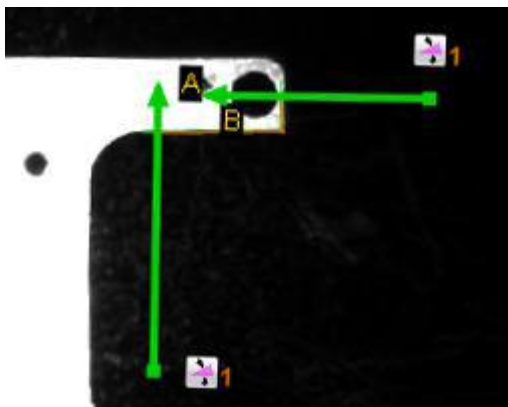
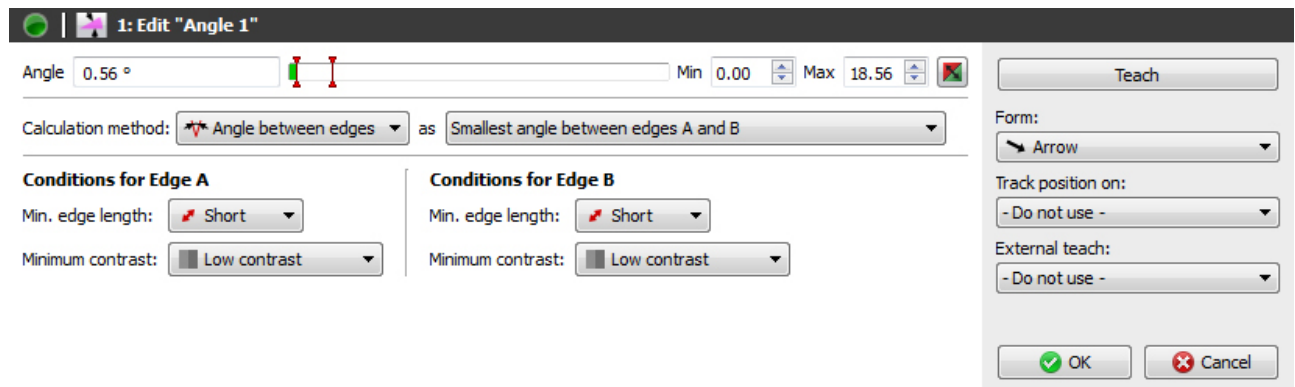
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Circle centre	Float-Point	
Circle diameter	Float	
Distance of the centre to the reference	Float	
Difference of the diameter to the reference	Float	
Roundness	Integer	

12.2.3 Angle

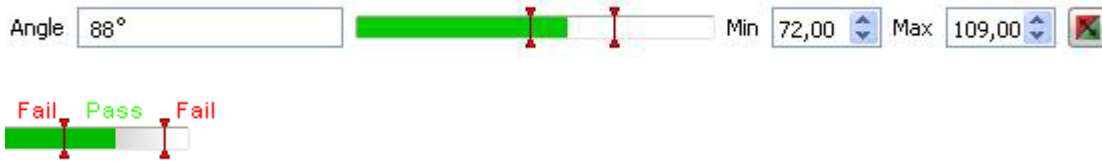
This feature check determines the angle between two edges or to a reference. The angle is compared with the associated switching points.

This feature check supports external Teach. The switching points are adjusted as an absolute to the current measured value.

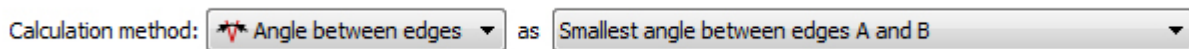


- Select the shape of the field of view. A search line and an arc (radial search for edges) can be chosen.
- Adjust the field of view by holding the left mouse button depressed.

In this example, the angle between a vertical edge and a horizontal edge on a test object is determined by one horizontal and one vertical search line. The angle between the detected edges is indicated directly in the display:

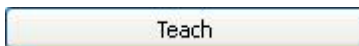


- The current result is displayed directly in the dialogue as the angle. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.



Select the calculation method and orientation of the angle.

- **Calculation method:**
Angle between edges: Angle between two edges
Angle to reference: Angle to a reference edge
- **Orientation of the angle:**
Smallest angle between edge A and B
Angle between edge A and B, clockwise
Angle between edge A and B, anticlockwise



- You can teach in a new reference with this button.

Configure of the sensor as follows:



- **Min. edge length:** With short, medium or long, select the anticipated length of the sought contour to achieve a consistent result. Using User defined, you may manually enter the length of an edge (5-1000 pixels).
- **Transition:** You must specify whether each edge can progress from bright to dark or from dark to bright (device-dependant).
- **Minimum contrast:** You can also specify whether you are searching for an edge with sharp or weak contrast.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.

- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

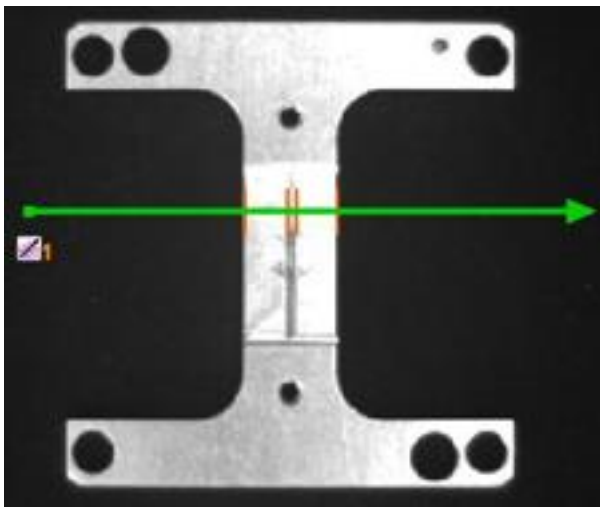
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Corner position	Float-Point	Coordinates of where the edges intersect
Angle of the corner	Float	Size of the angle between the edges (in degrees)
Position of corner	Float	Rotational position of edge 1 (in degrees, 0° == horizontal, 90° == vertical)
Distance	Float	Distance between the current corner position and the corner position of the reference angle
Angle difference	Float	Difference between the current angle and the reference angle (in degrees)
Deviation of position	Float	Difference between the current rotational position and that of the reference angle (in degrees)

12.2.4 Count edges

This feature check inspects the number of edges along a search beam.

This feature check supports external Teach. The switching points are adjusted as an absolute to the current measured value.



- Select the shape of the field of view. A search line and an arc can be chosen.
- Adjust the field of view by holding the left mouse button depressed.

In this example, the edges of a test object are detected at both the bright/dark and the dark/bright transitions. The number of detected edges is indicated directly in the display in *Number*.

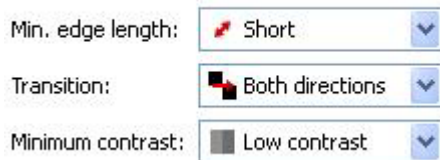


- The current result is displayed directly in the dialogue as the *Number*. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.

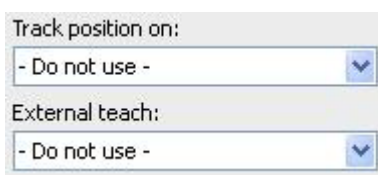
Configure of the sensor as follows:

- Position the search line by holding the left mouse button depressed in the image.

Conditions for edge



- **Min. edge length:** With short, medium or long, select the anticipated length of the sought contour to achieve a consistent result. Using User defined, you may manually enter the length of an edge (5-1000 pixels).
- **Transition:** You must specify whether each edge can progress from bright to dark or from dark to bright (device-dependant).
- **Minimum contrast:** You can also specify whether you are searching for an edge with sharp or weak contrast.



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

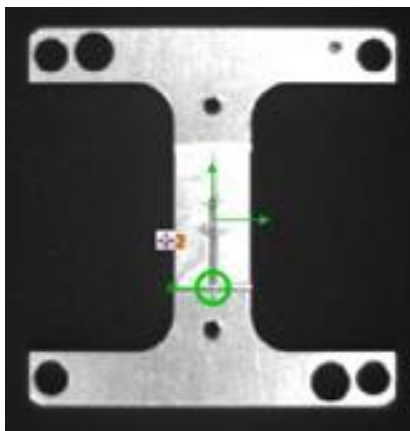
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Number of edges	Integer	

12.2.5 Point position

This feature check determines the position and rotational position of a point, as an absolute in the picture or relative to a reference. It is therefore advisable that it is only used with part location. This feature check can, e.g. be used to determine the grasp position for robots (pick and place).

This feature check supports external Teach. The switching points are adjusted as an absolute to the current measured value.



- Set the point on the position to be determined. You may need to rotate it with the lever.

Select the features that should be checked.

- **Rotation:** Determine the switching points of the rotation.
- **Position X:** Determine the switching points of the X position.
- **Position Y:** Determine the switching points of the Y position.

The right button is used to invert the result of the feature check.

Calculation method: Absolute position in image

- **Calculation method:** Absolute position in image (If you set this, you will get the coordinates of this point.) Relative to reference (show the deviations to the taught point.)



The reference point set using Teach-in is identified with a cross.

Track position on:

 External teach:

- Here, select the part location with which the feature check should be corrected.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

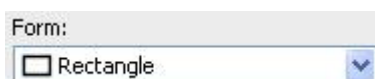
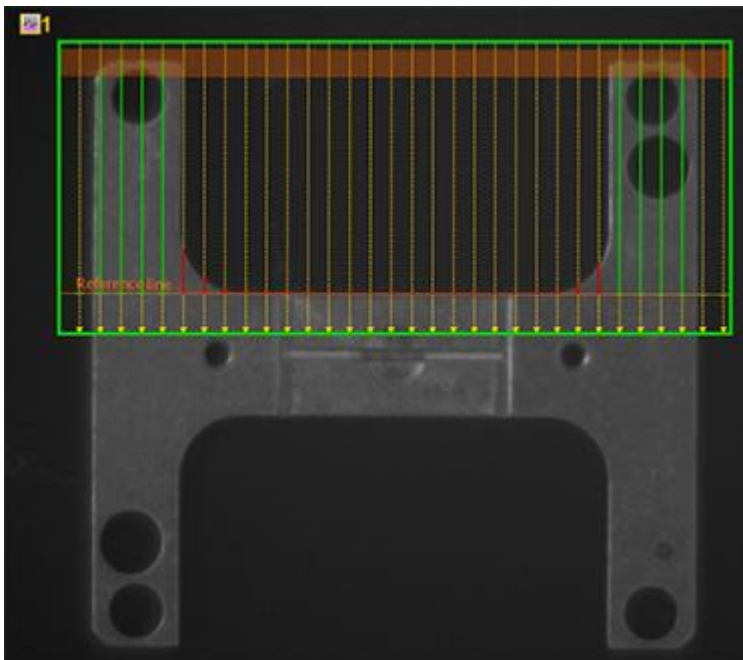
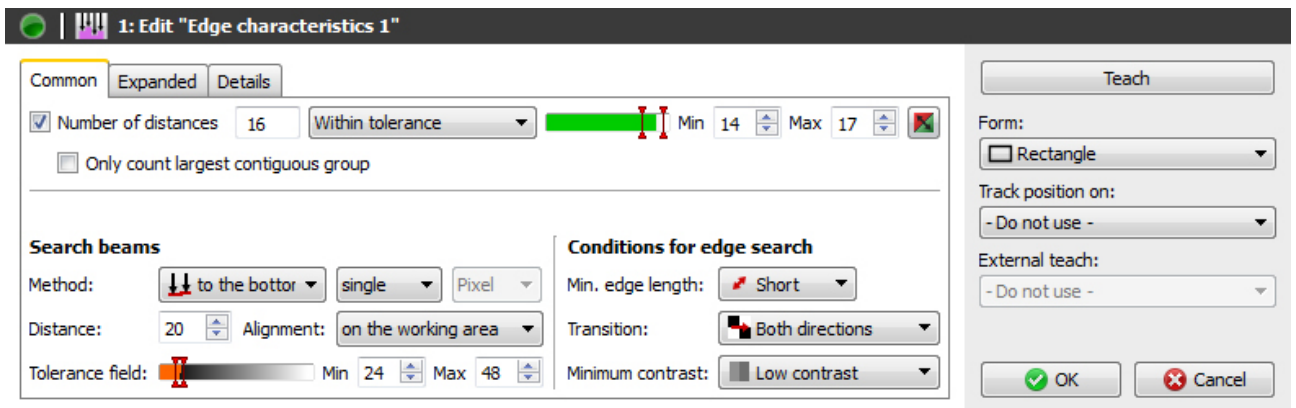
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Rotation	Float	
Position X	Float	
Position Y	Float	

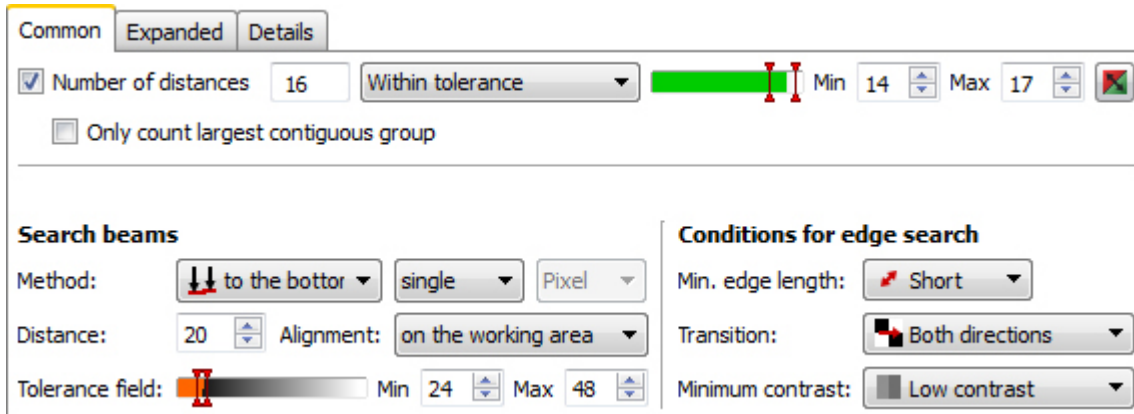
12.2.6 Edge characteristics

This feature check scans an edge with search beams and compares the distances detected with the defined conditions.

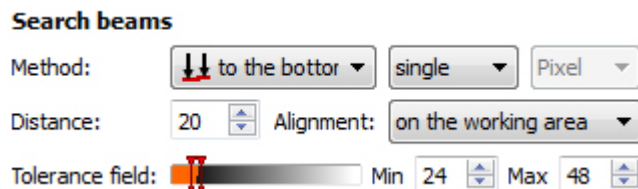
This feature check does not support external teach-in.



- Select the shape of the field of view. A rectangle, a circular ring and a circular ring sector can be chosen.



- The current number of distances calculated is displayed as *Number of distances* in the dialogue by default.
- You can also select which located distances should be counted. You can select whether to count the number of distances within or outside of the tolerance range.
- The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The button on the right inverts the result of the *Number of distances* partial check.
- If you activate *Only count largest related group*, only the number of distances located within the largest group will be counted – i.e. the distances which fulfil the set criteria and appear directly next to one another.



- **Methods:** Here you can define the methods the search beams should use to search for edges. The search direction is indicated by a yellow arrow in the field of view. The methods available depend upon the shape of the field of view.



NOTE

For horizontal edge searches, you must rotate the field of view.

single: The system searches for an edge in a single direction from each search beam position. The reference point used to calculate the distance is the edge of the field of view (field of view alignment) or the located reference line (object alignment).

double: The system searches for an edge in two directions from each search beam position. The distance between the two located edges on the search beam is calculated.

- downwards (single):** The search for edges starts at the top edge of the field of view.
- upwards (single):** The search for edges starts at the bottom edge of the field of view.
- inwards (single):** The search for edges starts at the outer edge of the circle.
- outwards (single):** The search for edges starts at the inner edge of the circle.
- to the centre line (double):** The search for edges begins from both sides.
- outwards (double):** The search for edges begins from the centre line.

The following table provides an overview of which methods are available for which types of field of view.

	Rectangle		Circle / sector	
	single	double	single	double
downwards	x			
upwards	x			
inwards			x	
outwards			x	
to the centre line		x		x
outwards		x		x

Pixel: Pixels are used as the default preset value if you have not defined your own unit.

[Units]: If you have defined your own unit (*Adjust image* → *Coordinates*), you can select it here.

- **Distance:** Here, you can set the distance between the search beams.
- **Alignment:** Define how the search beams are to be aligned.

to the field of view: The search beams are aligned according to the orientation of the field of view.

to the object: The system searches for a straight (rectangular field of view) or circular (circular or sector field of view) reference line. The search beams are aligned perpendicular to the reference line.

- **Tolerance field:** Here, you have the option to configure the size of the tolerance range. The tolerance range is the range between the set minimum and maximum values. The system will test whether each distance located falls within or outside of this range. It is shown as a transparent orange area in the field of view.

Conditions for edge search

Min. edge length:

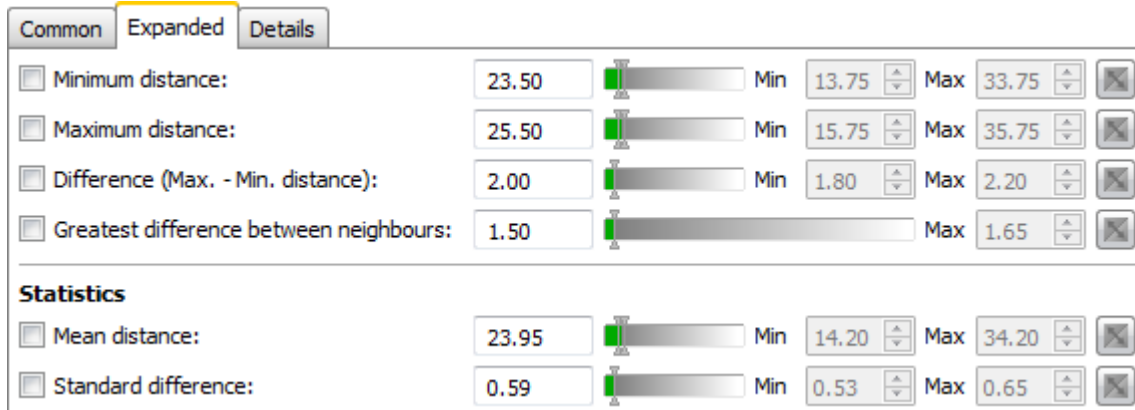
Transition:

Minimum contrast:

Specifications for the edge search

Define the specifications for the edge search.

- **Min. edge length:** You must also specify whether a short, medium or long edge is to be sought. Using User defined, you may manually enter the length of an edge (5-1000 pixels).
- **Transition:** For each edge, you must specify whether the edge progresses from bright to dark or from dark to bright.
- **Minimum contrast:** Specify whether you are searching for an edge with sharp or weak contrast.



The screenshot shows the 'Expanded' tab of a software interface. It contains two main sections: 'Distance' and 'Statistics'. Each section has four rows of controls, each with a checkbox, a text input field, a slider, and two numeric input fields (Min and Max) with up/down arrows and a reset button.

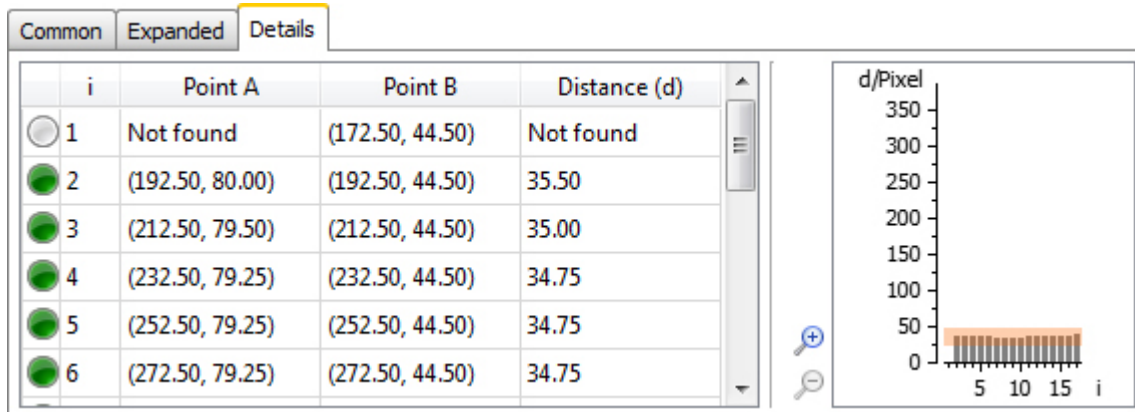
Section	Parameter	Value	Min	Max
Distance	Minimum distance:	23.50	13.75	33.75
	Maximum distance:	25.50	15.75	35.75
	Difference (Max. - Min. distance):	2.00	1.80	2.20
	Greatest difference between neighbours:	1.50		1.65
Statistics	Mean distance:	23.95	14.20	34.20
	Standard difference:	0.59	0.53	0.65

On the *Extended* tab, there are further options for influencing the result of the feature check.

- The switching points designated **Min** and **Max** are adjusted on the right hand side. To do this, the corresponding criterion must be activated. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The button on the right inverts the result of the respective partial check for this feature check.
- **Minimum distance:** Define the criteria for the smallest distance value located.
- **Maximum distance:** Define the criteria for the largest distance value located.
- **Difference (max. - min. distance):** Define the criteria for the difference between the smallest and largest distance values located.
- **Greatest difference between adjacent distances:** Determine the criteria for the greatest difference between directly adjacent distances.

Statistics

- **Mean distance:** Define the criteria for the average of all distance values located.
- **Standard difference:** Define the criteria for the standard difference for all distance values located.



On the *Details* tab, there is a table showing the results for the individual search beams and a bar chart. This tab is only used to display the values. You can zoom into the bar chart with the magnifying glass.

If you hover your cursor over one of the values in the table or a bar in the bar chart, the corresponding search line, point or distance will be highlighted in the field of view.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

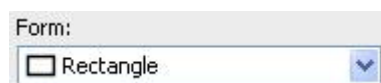
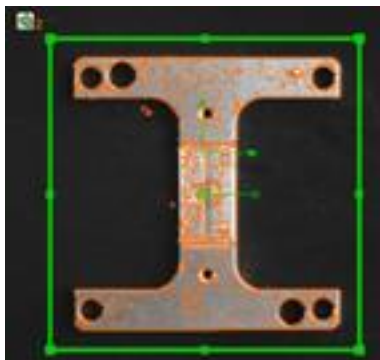
Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Number of distances	Float	
Minimum distance	Float	
Maximum distance	Float	
Difference max-min	Float	
Greatest difference between adjacent distances	Float	
Mean distance	Float	
Standard difference	Float	
Distance list	Float list	
Edge point A list	Float-Point list	Intersection between search beam and located edge $X - separator - Y$, "NaN" if point is not found
Edge point B list	Float-Point list	Intersection between search beam and located edge $X - separator - Y$, "NaN" if point is not found

12.3 Feature comparison

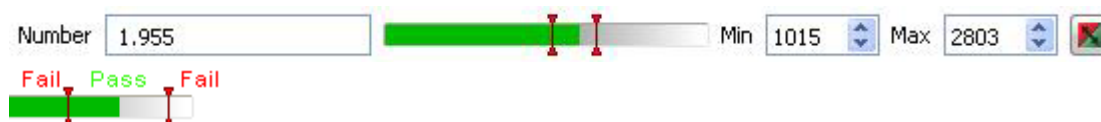
12.3.1 Count contour points

This feature check examines the number of contour points within the field of view.

This feature check supports external Teach. The switching points are adjusted as a percentage to the current measured value.

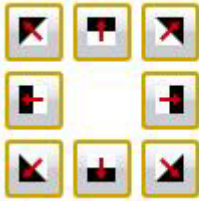


- Choose the shape of the field of view in this menu.



- The current result is displayed directly in the dialogue as the *Number*. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.

Only count following directions:



- Determine the direction of the contour points that should be taken into consideration (device-dependant).

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

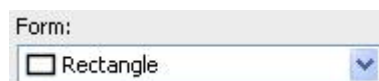
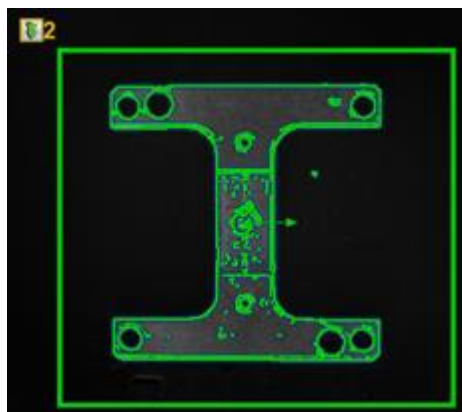
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Number of contour points	Integer	

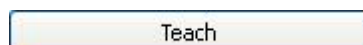
12.3.2 Contour comparison

This feature check compares the contour of a taught-in object with the contour of the current object. In the comparison, adjacent pixels are counted and correspondence is determined on the basis of switching points. To use this feature check to its best effect, it is highly advisable to combine it with part location.

This feature check supports external Teach. Here all of the contours will be adopted in the model, but the switching points remain unchanged.



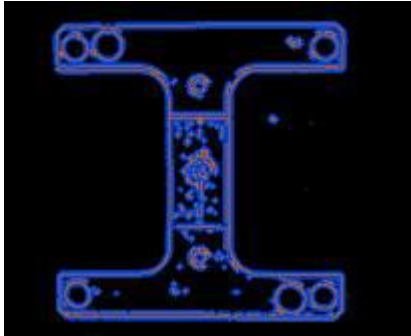
- The field of view must firstly be defined.



- The corresponding object is then taught in.

Tolerance: 3 px
 Observe edge direction

- **Tolerance:** Now adjust the size of the pixel field in which a pixel-by-pixel search is conducted for adjacent pixels. *Distance* specifies the search area size in each direction up/down and right/left.
- **Observe edge direction:** Mark this option to increase accuracy during the examination.



- With the displayed model, you can then use the mouse to delete pixels that clearly do not belong to the reference object or to supplement missing contour areas.



- This button resets the model to its default state.

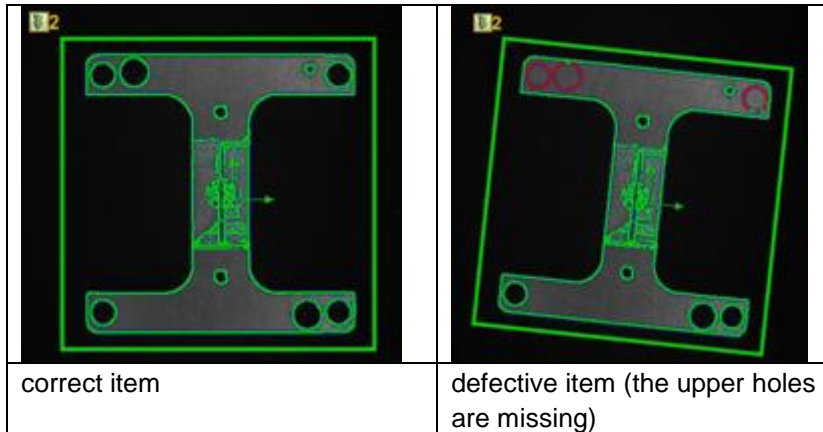


- You can use these two buttons to enlarge or reduce the model.

Correlation: 100 %  Min 90

- The current result is displayed directly in the dialogue as the *Match*. The switching point designated **Min** is adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.

The differences between the inspected items are marked in red following comparison between correct and defective items.



Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

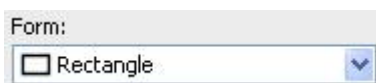
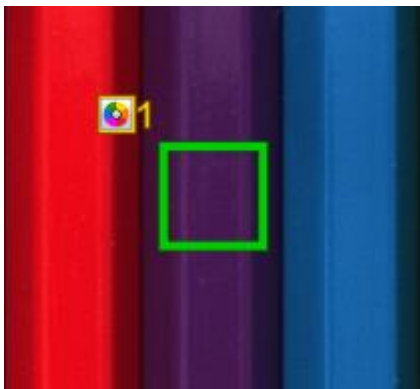
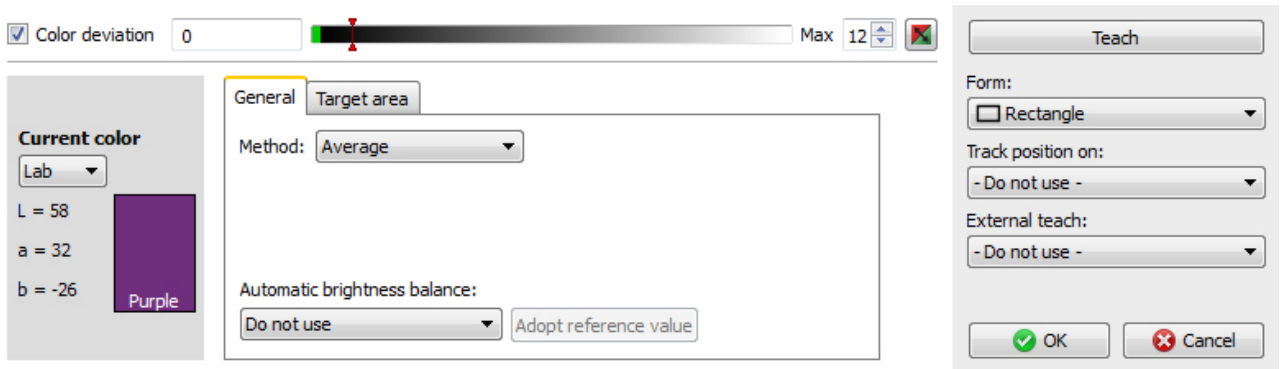
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Conformity	Integer	

12.3.3 Color identification

This feature check identifies the color in a field of view and checks whether the result is within a preset tolerance.

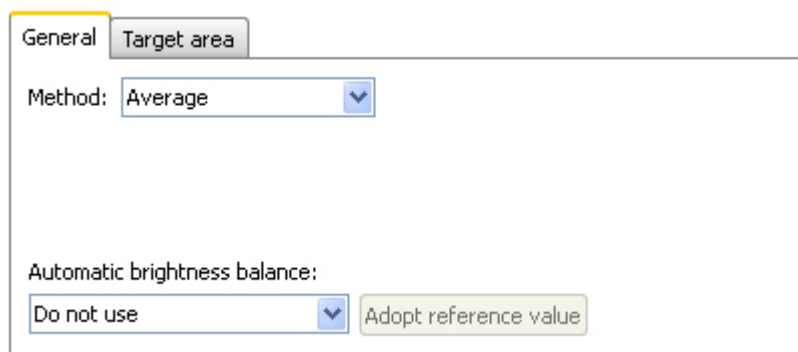
This feature check supports external Teach. The current color is taught as the target color.



- Select the shape of the field of view.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.



- Tick here if you want to calculate the color deviation, otherwise it will produce the current color of the field of view rather than the result (OK, NOK).
- The current result (in ΔE - distance between two color coordinates in the CIELab color coordinate system) is displayed under *Color deviation*. The switching point designated **Max** (max. 50) is adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.
- Activate



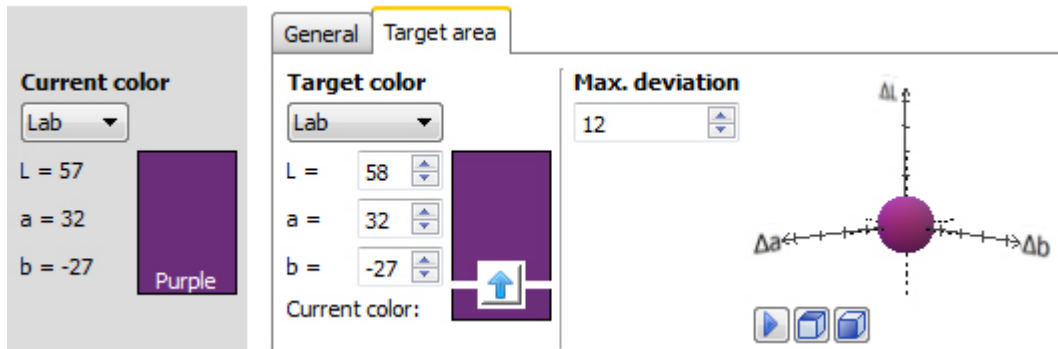
- **Methods: Average value:** The average value of all the pixels in the marked area is used.
- **Methods: Dominant single color:** The dominant color in the spectrum in the marked field of view is calculated and used. This means that any small errors such as dirt or reflections can be ignored.

Automatic brightness correction:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

Use, do not carry reference area: Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.

Use, carry reference area: This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.



- **Current color:** The color currently detected is displayed here. You can view the values for the color currently detected in various color spaces (RGB, Lab, LCh, HSV).



- **Target color:** In this area, you can set the color that should be searched for in each field of view. Use the arrow to accept the color currently detected as the target color.



NOTE

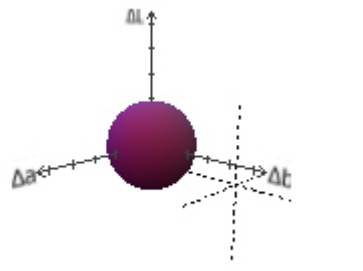
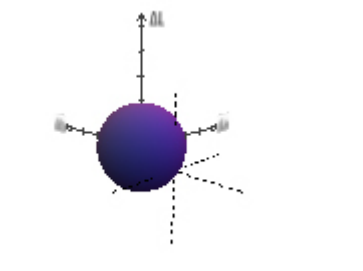
We recommend that you calculate the target color with a correct model piece. Entered values may deviate from the model piece.

- **Max. deviation:** Here, you can set the maximum permissible color deviation (in ΔE - distance between two color coordinates in the CIE Lab color coordinate system). This change is displayed to you in the CIE Lab color coordinate system. The cover of the sphere represents the maximum deviation.

CIELab color coordinate system

The cover of the sphere represents the maximum permissible color deviation (ΔE) from the target color and changes as you make entries. This means that all color values for the current color, which are inside the sphere, are assessed as *OK*.

The current color is represented by a coordinate cross with dotted lines.

	
<p>Current color outside of the target color - Result: <i>NOK</i></p>	<p>Current color inside of the target color - Result: <i>OK</i></p>



NOTE

The scales of the CIELab color coordinate system are divided into increments of 10 and show up to 50.

CIELab color coordinate system scale

ΔL = brightness (difference from target color)

Δa = red / green parts (difference from target color)

Δb = blue / yellow parts (difference from target color)

Control buttons

You can move the CIELab coordinate system freely with the mouse and zoom with mouse wheel. There are also buttons to stop the animation and tilt the CIELab color coordinate system.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

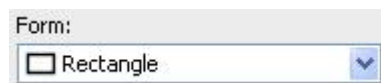
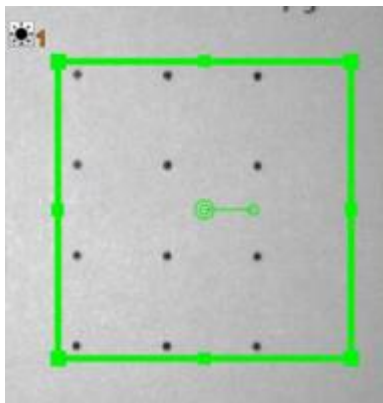
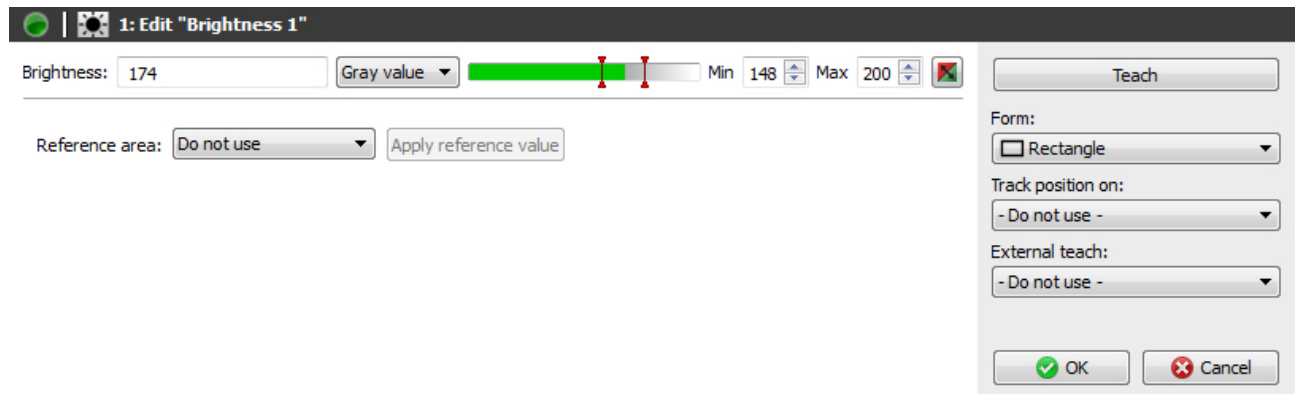
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Reference area brightness	Integer	
Color deviation (ΔE)	Integer	
Color (Lab)	Integer-Triple	
Color (RGB)	Integer-Triple	
Color (HSV)	Integer-Triple	
Color (LCh)	Integer-Triple	

12.3.4 Brightness

This feature check measures the mean brightness in a field of view and compares the result with the specified switching points.

This feature check supports external Teach. The switching points are adjusted as an absolute to the current measured value.



- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.



- The current result for brightness is shown as an average grey scale value or as a percentage. The lightness value calculated during the teach process is 100%. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.

- The right button is used to invert the result of the feature check.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.

Reference area:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

The mean brightness in the field of view of the reference area should exceed a grey scale value of 128 to ensure reliable operation.

- **Use, do not carry reference area:** Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.
- **Use, carry reference area:** This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.

- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

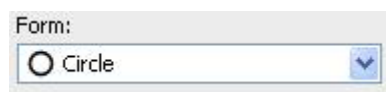
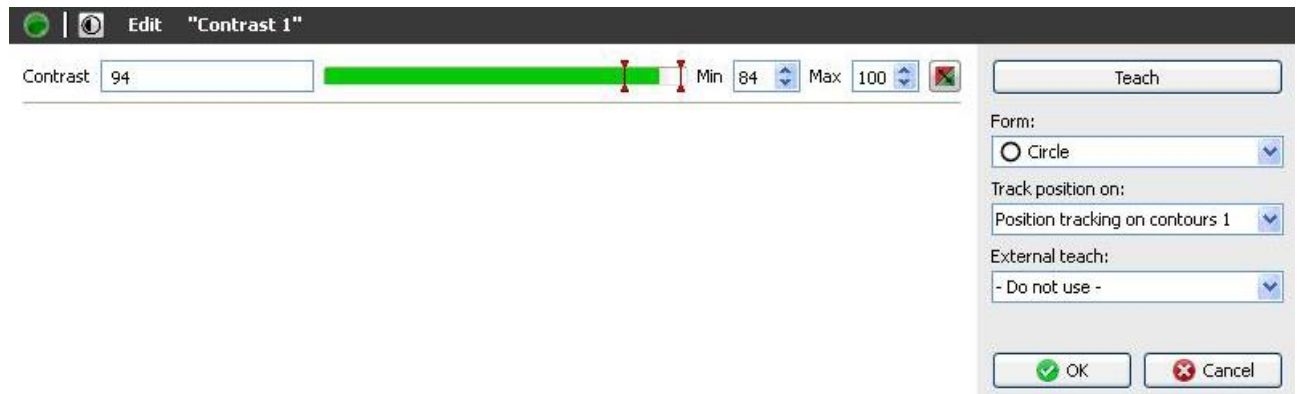
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Brightness	Integer	
Reference area brightness	Integer	

12.3.5 Contrast

The feature check measures the contrast in a field of view and compares the result with the specified switching points.

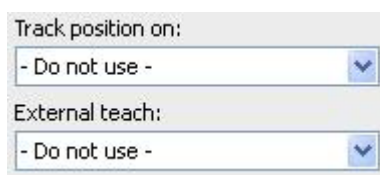
This feature check supports external Teach. The switching points are adjusted as an absolute to the current measured value.



- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.



- The current result of the contrast feature check is displayed directly in the dialogue as the *Contrast*. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

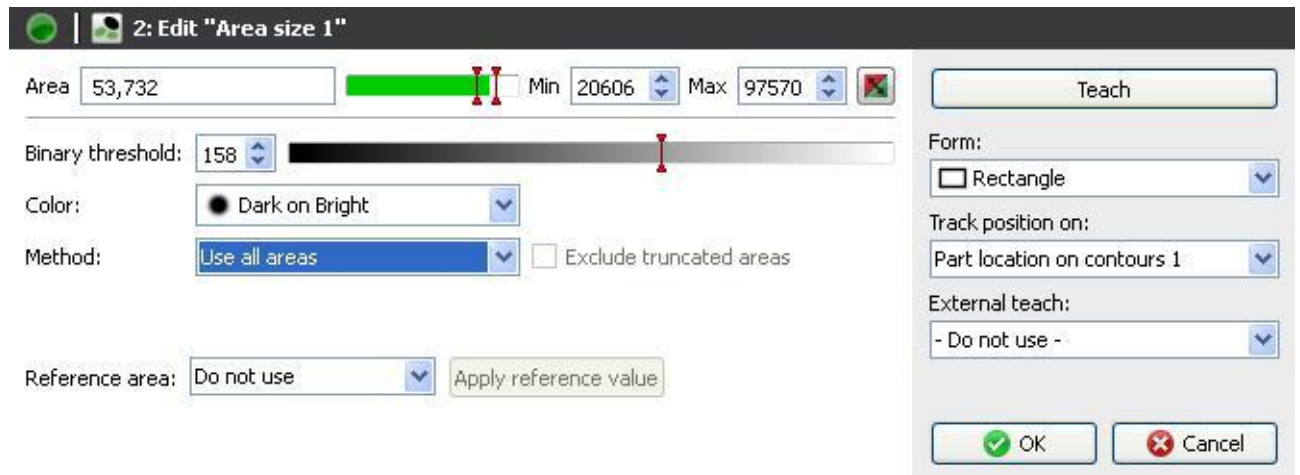
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Contrast	Integer	
Reference area brightness	Integer	

12.3.6 Area size

The feature check calculates the number of bright or dark pixels in a field of view and compares the result with specified switching points.

This feature check supports external Teach. The switching points are adjusted as a percentage to the current measured value.



2: Edit "Area size 1"

Area: 53,732 | Min: 20606 | Max: 97570

Binary threshold: 158

Color: Dark on Bright

Method: Use all areas Exclude truncated areas

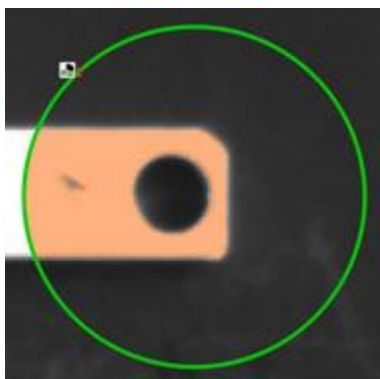
Reference area: Do not use

Teach

Form: Rectangle

Track position on: Part location on contours 1

External teach: - Do not use -

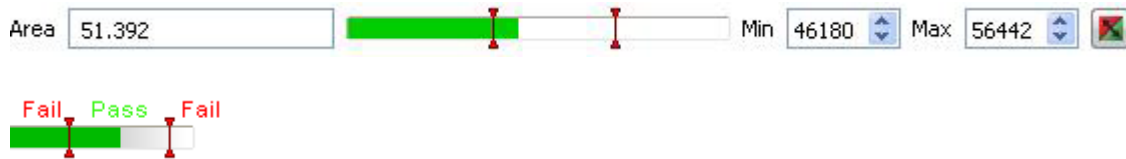


Proceed as follows for configuration:



Form: Circle

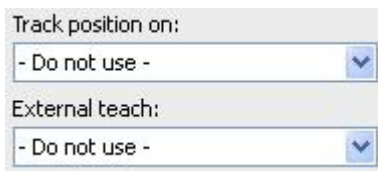
- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.



- The current result of the feature check is displayed directly in the dialogue as the *Area*. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.



- **Binary switching point:** Set the switching point between 0 and 255, from which bright or dark pixels will be counted.
- **Color:** You can also decide whether the *dark* or the *bright* pixels in a field of view are to be counted.
- **Methods:** Choose whether you want to count all areas or just the largest related areas.
- **Exclude cropped areas:** Areas which touch the edge of the field of view are excluded from the analysis. (only available for the *largest related areas*).



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.

Reference area:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

The mean brightness in the field of view of the reference area should exceed a grey scale value of 128 to ensure reliable operation.

- **Use current field of view:** The current defined field of view is used as a reference. It should only be used if the pattern being checked is very similar.
- **Use, do not carry reference area:** Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.
- **Use, carry reference area:** This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

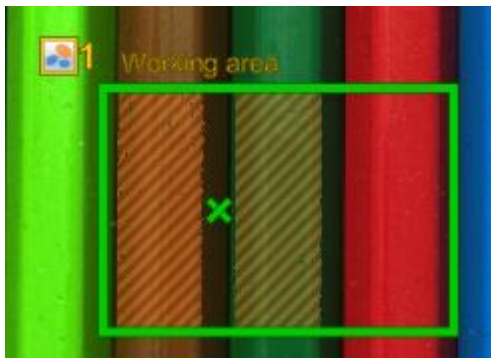
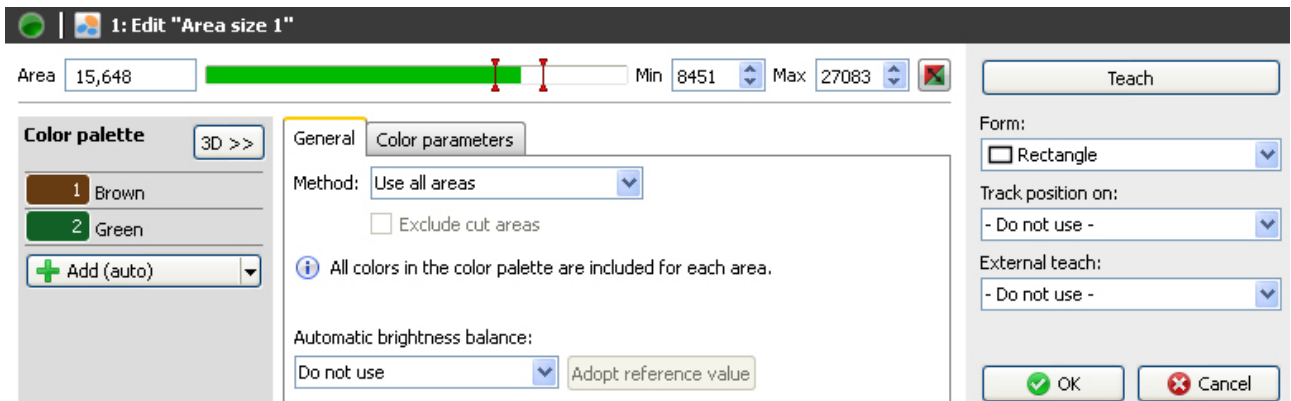
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Area	Integer	
Reference area brightness	Integer	
Centre	Integer	

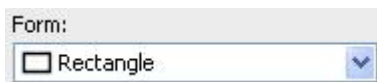
12.3.7 Area size (color)

This feature check calculates the number of pixels of particular colors in a field of view and compares the result with specified switching points.

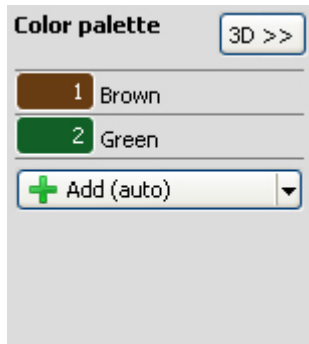
This feature check supports external Teach. The switching points are adjusted for the current calculated value.



Proceed as follows for configuration:

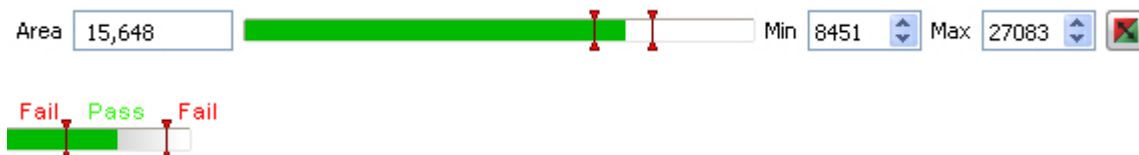


- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.

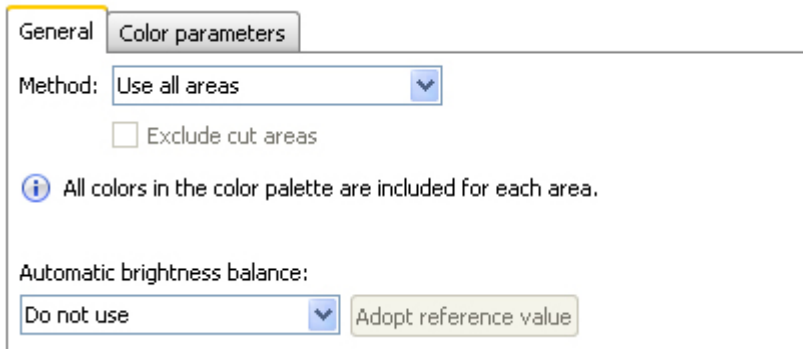


- Now select *Add* on the color palette to teach in the first target color.
- In the next step, mark the first target color to be added on the image. This target color can be located in any part of the image area and does not have to be in the field of view. However, only target colors in the defined field of view are assessed as *OK / NOK*. The marked target colors are displayed with a hatched pattern in the field of view.
- You can add up to 8 target colors to the color palette. With *Add (auto)*, an area is automatically suggested for you to add as a new color. Move the suggested area to the desired area and adjust its size if necessary.

3D>>: Here you can see where the defined colors are in a CIELab color coordinate system. Unlike the CIELab color coordinate system on the *Color parameters* tab, the complete color space is displayed and is not limited to 50 values per axis. The current target color is marked with a grid.



- The current result of the feature check is displayed directly in the dialogue as the *Area*. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.



General Color parameters

Method: Use all areas

Exclude cut areas

i All colors in the color palette are included for each area.

Automatic brightness balance:

Do not use Adopt reference value

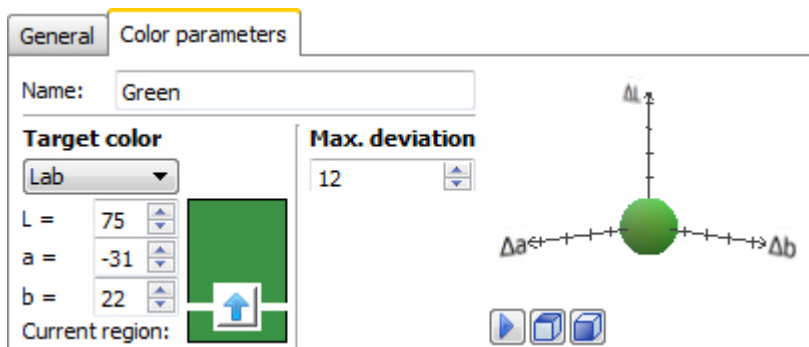
- **Methods:** Choose whether you want to count all areas or just the largest related areas.
- **Exclude cropped areas:** Areas which touch the edge of the field of view are excluded from the analysis. (only available for *only the largest related areas*).

Automatic brightness correction:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

Use, do not carry reference area: Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.

Use, carry reference area: This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.



General Color parameters

Name: Green


Target color

Lab

L = 75

a = -31

b = 22

Current region: 

Max. deviation

12

Δa Δb ΔL



- **Target color:** In this area, you can set the color that should be searched for in each field of view. Use the arrow to accept the color currently detected as the target color.

NOTE



We recommend that you calculate the target color with a correct model piece. Entered values may deviate from the model piece.

- **Max. deviation:** Set the maximum permissible color deviation (in ΔE - distance between two color coordinates in the CIELab color coordinate system) (max. 50) here. This change is displayed to you in the CIELab color coordinate system. The cover of the sphere represents the maximum deviation. Only the current target color is displayed as a colored sphere, the other target colors are displayed as abstract spheres.

CIELab color coordinate system scale

NOTE



The scales of the CIELab color coordinate system are divided into increments of 10 and show up to 50.

ΔL = brightness (difference from target color)

Δa = red / green parts (difference from target color)

Δb = blue / yellow parts (difference from target color)

Control buttons

You can move the CIELab coordinate system freely with the mouse and zoom with mouse wheel. There are also buttons to stop the animation and tilt the CIELab color coordinate system.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.

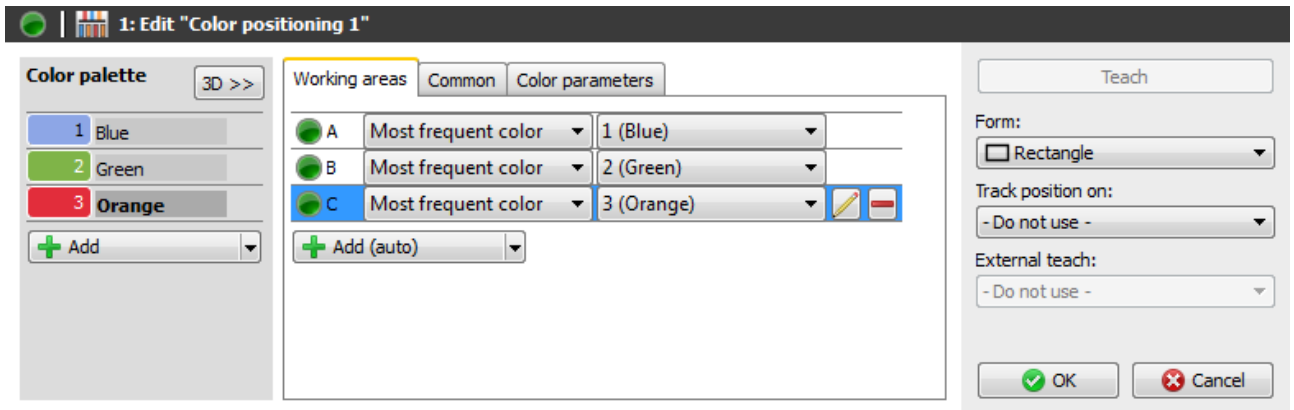
- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

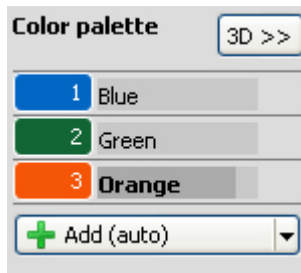
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Area	Integer	
Centre	Integer	
Reference area brightness	Integer	
Structure	Integer	Number of contour points on hatched areas

12.3.8 Color positioning

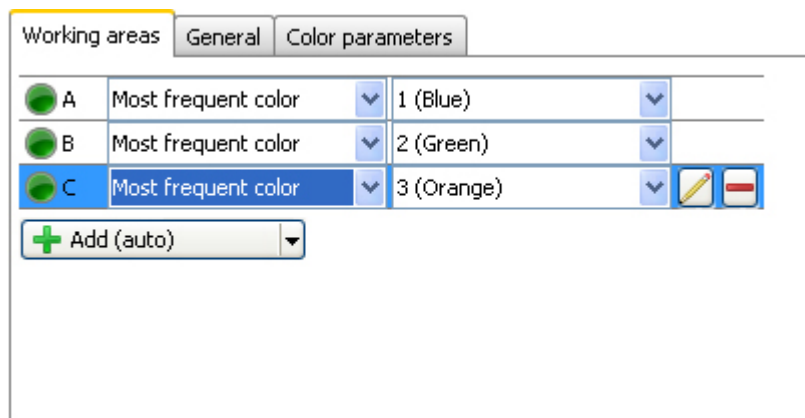
This feature check checks the dominant color or the presence of individual colors in one or more fields of view. This can be used to classify colors, for example.





- Select *Add* on the color palette to teach in the first target color.
- In the next step, mark the first target color to be added on the image. This target color can be found anywhere across the entire image area. The marked target color in the image is displayed with a hatched pattern. If the target colors touch each other (spheres on the Color parameters tab), this is indicated with a warning triangle. A tool tip gives you information as to which other target color it is touching.
- You can add up to 24 target colors to the color palette. With *Add (auto)*, an area is automatically suggested for you to add as a new color.
- Move the suggested area to the desired area and adjust its size if necessary.

3D>>: Here you can see where the defined colors are in a CIELab color coordinate system. Unlike the CIELab color coordinate system on the *Color parameters* tab, the complete color space is displayed and is not limited to 50 values per axis. The current target color is marked with a grid. Only color areas that do not overlap can be definitively detected.



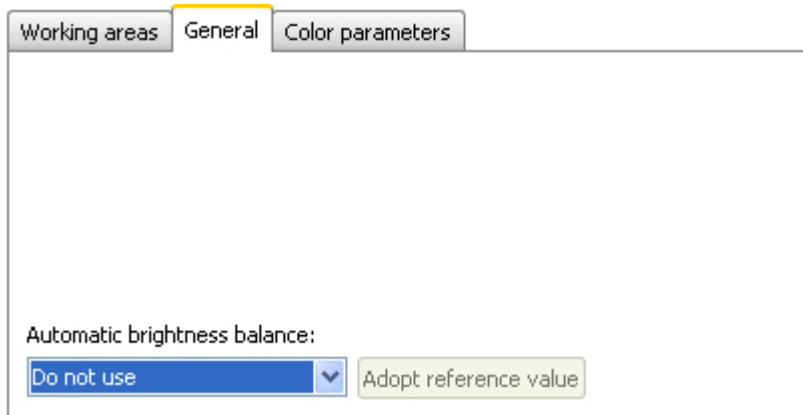
- Select *Add* on the Fields of view tab and mark the first field of view in the image. You can define up to 32 fields of view.
- Now select the method according to which the field of view should be analysed. The entire feature check will only be assessed as OK if all of the individual fields of view are OK, i.e. meet the defined criteria.

Most frequent color: the selected color must be the most frequently occurring color in the field of view. This method is automatically selected if one color in the color palette is dominant in the field of view.

Contains a color from: the field of view must contain one of the selected colors, the minimum color proportion (in %) that must be present can also be adjusted.

Contains all colors from: the field of view must contain all of the selected colors

- You can use the buttons on the right to edit the minimum areas of the colors for the respective field of view, or to delete the entire field of view.

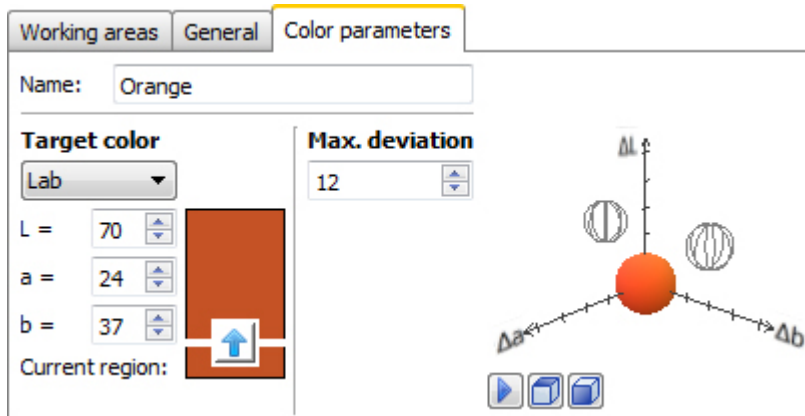


Automatic brightness correction:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.


Use, do not carry reference area: Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.

Use, carry reference area: This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.



- **Target color:** In this area, you can set the color that should be searched for in each field of view. Use the arrow to accept the color currently detected as the target color.


NOTE

 We recommend that you calculate the target color with a correct model piece. Entered values may deviate from the model piece.

- **Max. deviation:** Set the maximum permissible color deviation (in ΔE - distance between two color coordinates in the CIE Lab color coordinate system) (max. 50) here. This change is displayed to you in the CIE Lab color coordinate system. The cover of the sphere represents the maximum deviation. Only the current target color is displayed as a colored sphere, the other target colors are displayed as abstract spheres.

CIE Lab color coordinate system scale

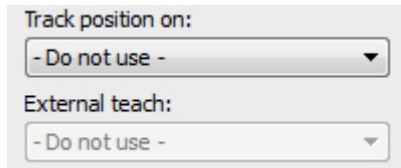
NOTE

 The scales of the CIE Lab color coordinate system are divided into increments of 10 and show up to 50.

ΔL = brightness (difference from target color)
 Δa = red / green parts (difference from target color)
 Δb = blue / yellow parts (difference from target color)

Control buttons

You can move the CIELab coordinate system freely with the mouse and zoom with mouse wheel. There are also buttons to stop the animation and tilt the CIELab color coordinate system.



- If the feature check is to be corrected by the result of the part location, you can choose this option here.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

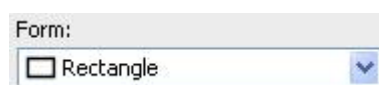
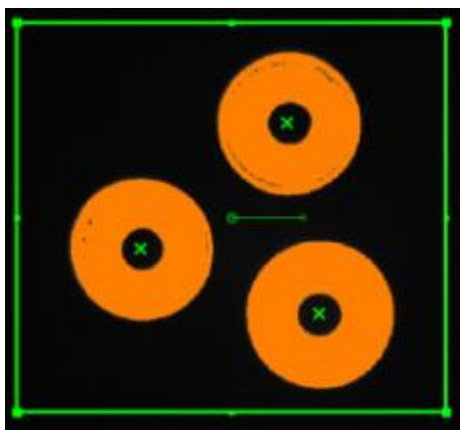
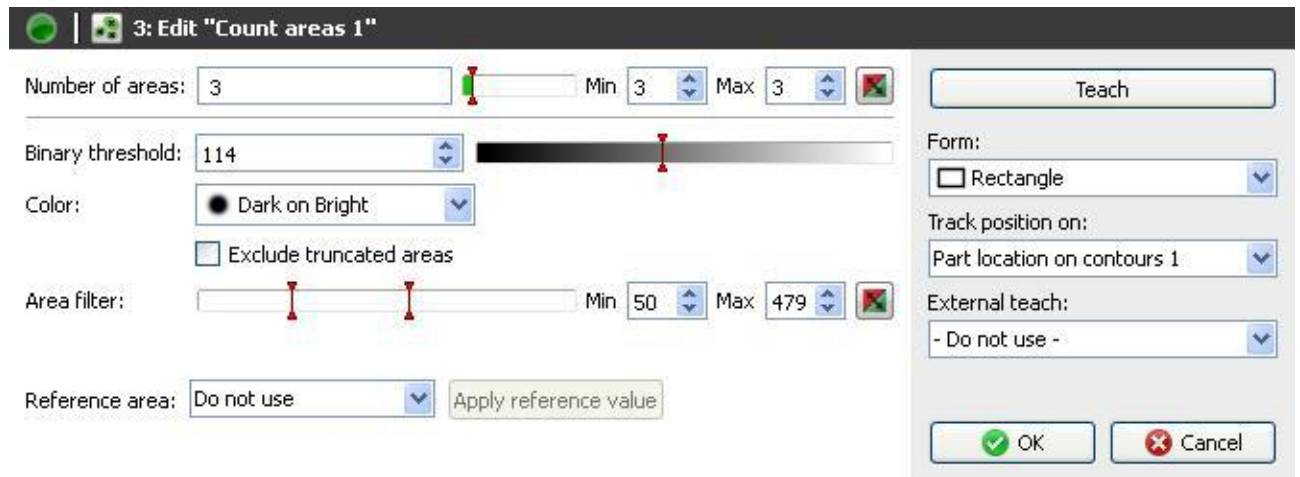
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Reference area brightness	Integer	
Field of view, color, area	Integer list	Three values are listed for each combination of a field of view and a color (field of view, color, area). Field of view: Number, starting with 1 (not as letters) Color: Number, starting with 1 Area: Proportion (in percent) of the field of view occupied by the color
Dominant color	Integer list	Number of the dominant color for each field of view, or 0 if no color is found
Pass/Fail	Text	Results for the individual fields of view as "P" (Pass) or "F" (Fail)

12.3.9 Count areas

With this feature check, related areas in the field of view are counted.

This feature check supports external Teach. The switching points are adjusted as an absolute to the current measured value.



- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.



- The current result is displayed directly in the dialogue as the *Number of areas*. The switching points designated **Min** and **Max** are adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.

Binary threshold: 

Color: Dark on Bright Light on Dark

Exclude truncated areas

Area filter:  Min Max 

- **Binary switching point:** Set the binary switching point at a value between 0 and 255.
- **Color:** Choose whether bright or dark objects are to be counted.
- **Exclude cropped areas:** Areas which touch the edge of the field of view are excluded from the analysis.
- **Areas filter:** Adjust the minimum and maximum number of pixels of the counted areas. You can invert the result using the right button.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.

Reference area:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

The mean brightness in the field of view of the reference area should exceed a grey scale value of 128 to ensure reliable operation.

- **Use, do not carry reference area:** Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.
- **Use, carry reference area:** This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.



This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Number of objects	Integer	
Reference area brightness	Integer	
List of centres	Float-Point list	
List of areas	Float-Point list	
List of structure values	Integer list	Number of contour points within the respective area (BLOB).
List of lightness values	Integer list	Average grey value within the respective area.

12.3.10 Count areas (color)

This feature check is used to count related areas of a particular color or color selection in the field of view.

This feature check supports external Teach. The switching points are adjusted as an absolute to the current calculated value.


Number of areas  Min Max 


Color palette 3D >>

- 1 Purple
- 2 Blue
- 3 Green

+ Add (auto)

General Color parameters

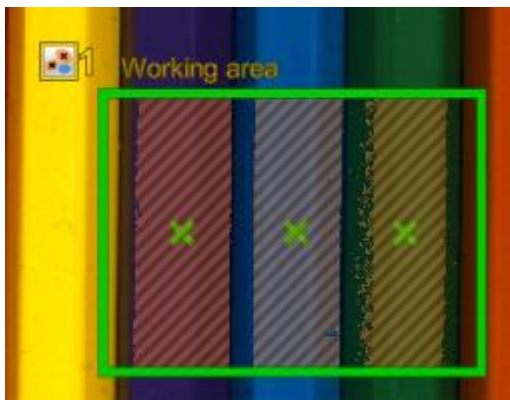
Area filter: Min 

Max 

Exclude cut areas

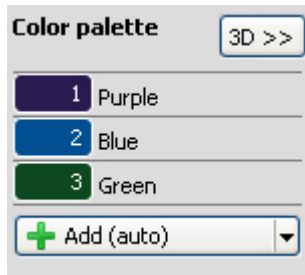
i All colors in the color palette are included for each area.

Automatic brightness balance:
 Adopt reference value



Form:

- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.

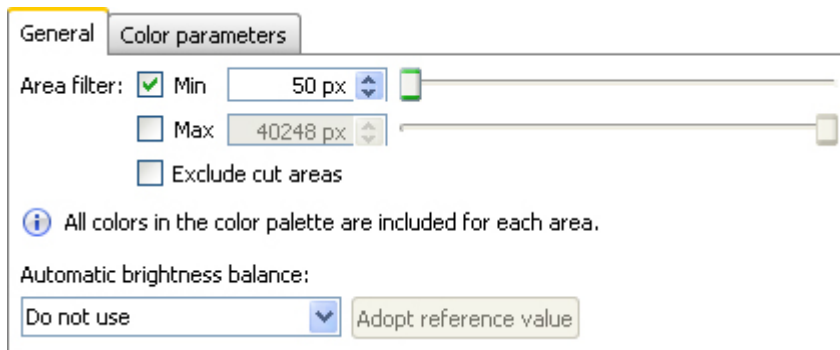


- Now select *Add* on the color palette to teach in the first target color to be counted.
- In the next step, mark the first target color to be added on the image. This target color can be located in any part of the image area and does not have to be in the detection area. However, only target colors in the defined detection area are counted. The marked target colors are displayed with a hatched pattern in the detection area.
- You can add up to 8 target colors to the color palette. With *Add (auto)*, an area is automatically suggested for you to add as a new color. Move the suggested area to the desired area and adjust its size if necessary.

3D>>: Here you can see where the defined colors are in a CIELab color coordinate system. Unlike the CIELab color coordinate system on the *Color parameters* tab, the complete color space is displayed and is not limited to 50 values per axis. The current target color is marked with a grid. Only color areas that do not overlap can be definitively detected.



▪

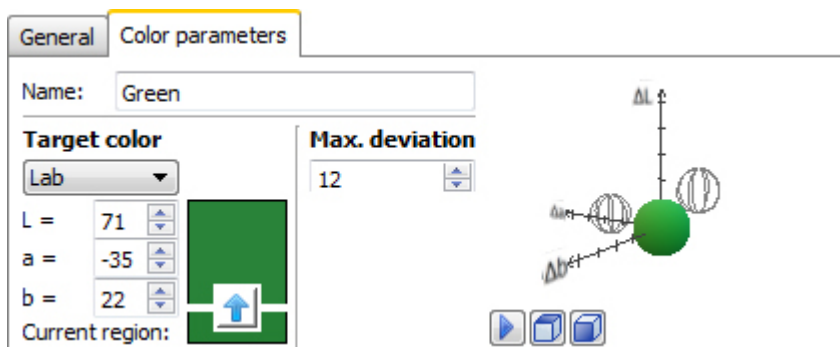


- **Areas filter:** Set the minimum and maximum size of the areas that are to be counted. These settings refer to all areas and not to an individual color. If you hover the cursor over this area, you will see the size of the detected area in the detection area in the image.
- **Exclude cropped areas:** Areas which touch the edge of the field of view are excluded from the analysis.

Automatic brightness correction:

In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

- **Use, do not carry reference area:** Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.
- **Use, carry reference area:** This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.





- **Target color:** In this area, you can set the color that should be searched for in each field of view. Use the arrow to accept the color currently detected as the target color.



NOTE

We recommend that you calculate the target color with a correct model piece. Entered values may deviate from the model piece.

- **Max. deviation:** Set the maximum permissible color deviation (in ΔE - distance between two color coordinates in the CIELab color coordinate system) (max. 50) here. This change is displayed to you in the CIELab color coordinate system. The cover of the sphere represents the maximum deviation. Only the current target color is displayed as a colored sphere, the other target colors are displayed as abstract spheres.

CIELab color coordinate system scale



NOTE

The scales of the CIELab color coordinate system are divided into increments of 10 and show up to 50.

ΔL = brightness (difference from target color)

Δa = red / green parts (difference from target color)

Δb = blue / yellow parts (difference from target color)

Control buttons

You can move the CIELab coordinate system freely with the mouse and zoom with mouse wheel. There are also buttons to stop the animation and tilt the CIELab color coordinate system.

Track position on:

External teach:

- If the feature check is to be corrected by the result of a part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

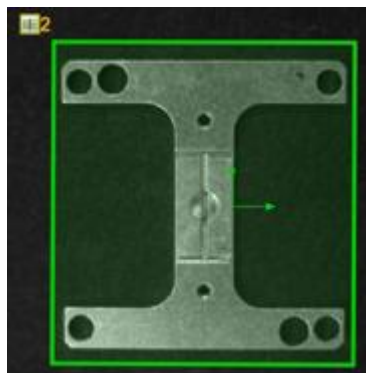
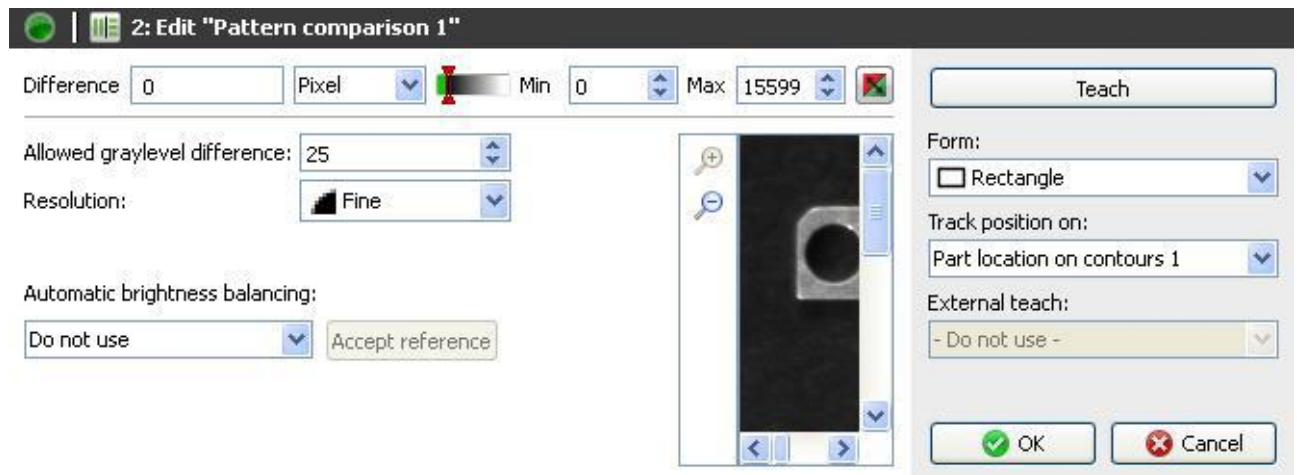
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Number of objects	Integer	
Reference area brightness	Integer	
List of centres	Float-Point list	
List of areas	Float-Point list	
List of structure values	Integer list	Number of contour points within the respective area (BLOB).

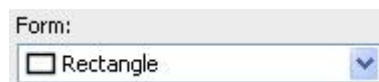
12.3.11 Pattern comparison

This feature check verifies the presence of a taught-in pattern.

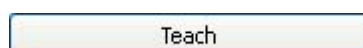
It supports external teach-in. The current image area is adopted in the model, but the switching points remain unchanged.



Proceed as follows for configuration:



- The field of view must firstly be defined.



- Teach in a new pattern using this button.



- The current result is displayed directly in the dialogue as the *Deviation*. You can also select whether the value should be displayed in *pixels* or in *percent*.
- A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.



- **Permissible grey scale variation:** Select the permissible grey scale variation. This corresponds with the absolute grey scale variation in the image.
- **Resolution:** You can choose the calculation accuracy and thereby the required processing time.

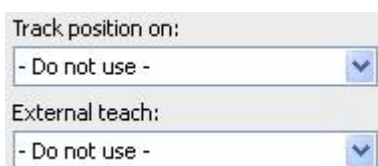
Automatic brightness balancing:



In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

The mean brightness in the field of view of the reference area should exceed a grey scale value of 128 to ensure reliable operation.

- **Use current field of view:** The current defined field of view is used as a reference. It should only be used if the pattern being checked is very similar.
- **Use, do not carry reference area:** Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.
- **Use, carry reference area:** This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.




- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Deviation	Integer	
Reference area brightness	Integer	

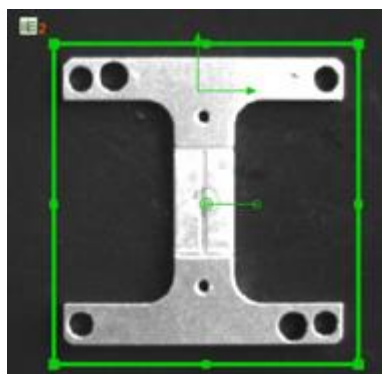
12.3.12 Pattern comparison (older version)

NOTE

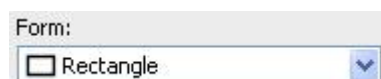
 The older version of the feature check is still available due to reasons of compatibility. It is strongly recommended that you use the newer, more powerful version. It is not possible to convert to the newer version.

This feature check verifies the presence of a taught-in pattern.

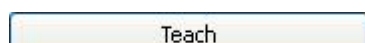
This feature check supports external Teach. The current image area is adopted in the model, but the switching points remain unchanged.



Proceed as follows for configuration:



- The field of view must firstly be defined.



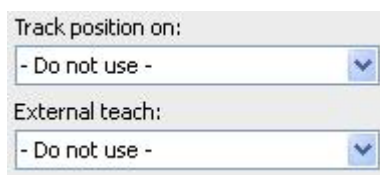
- Teach in a new pattern using this button.



- The current result is displayed directly in the dialogue as the *Match*. The switching point designated **Min** is adjusted on the right hand side. A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.



- **Resolution:** You can choose the calculation accuracy and thereby the required processing time.
- **Automatic brightness correction:** You can choose an automatic brightness correction to increase the stability of the feature check under ambient conditions. Brightness correction corrects the brightest and darkest grey scale values in the image and thereby adjusts all other grey scale values to the corresponding level.



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

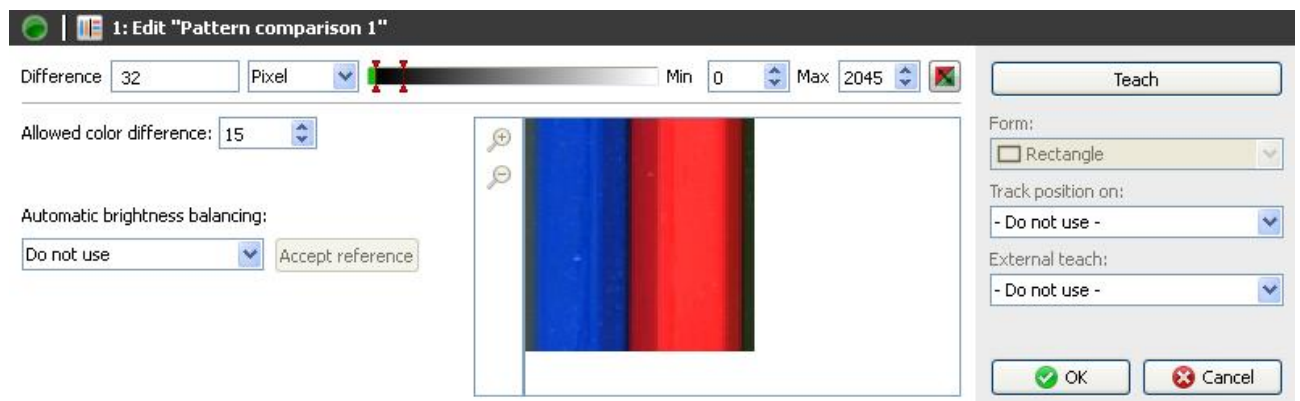
This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Conformity	Integer	

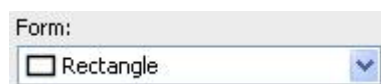
12.3.13 Pattern comparison (color)

This feature check verifies the presence of a taught-in color pattern.

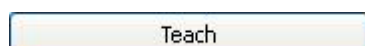
It supports external teach-in. The current image area is adopted in the model, but the switching points remain unchanged.



Proceed as follows for configuration:



- Select the shape of the field of view. A circle, a rectangle and a freely definable polygon, a circular ring and a circular ring sector are available.
- Adjust the field of view by holding the left mouse button depressed. You can rotate the rectangle by dragging with the mouse on the lever at the centre.



- Teach in a new pattern using *Teach*.

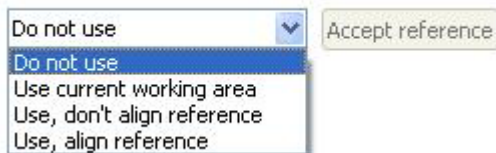


- The current result is displayed directly in the dialogue as the *Deviation*. You can also select whether the value should be displayed in *pixels* or in *percent*.
- A graphic display is located in the middle, in which the positions of the switching points are displayed and where they can be changed.
- The right button is used to invert the result of the feature check.

Allowed color difference:

- **Permissible color deviation:** Set the maximum permissible color deviation (in ΔE - distance between two color coordinates in the CIELab color coordinate system).

Automatic brightness balancing:



In order to be independent of fluctuations in the ambient light, the device offers a means of automatically correcting the brightness.

The mean brightness in the field of view of the reference area should exceed a grey scale value of 128 to ensure reliable operation.

- **Use current field of view:** The current defined field of view is used as a reference. It should only be used if the pattern being checked is very similar. However, we recommend that you choose a separate field of view.
- **Use, do not carry reference area:** Here, a field of view is defined as a reference area, for example by attaching a white label to the edge of the conveyor belt (static). The brightness correction is now guided by the brightness of this area.
- **Use, carry reference area:** This function is only available in connection with part location. A field of view is still used as the reference area. However, this is carried with the position correction. The brightness correction is now guided by the brightness of this carried area.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.

- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Deviation	Integer	
Reference area brightness	Integer	

12.4 Identification

12.4.1 Barcode

With this feature check barcodes can be read. In addition, the quality of the barcode can be determined according to ISO/IEC 15416.

This feature check supports external Teach. Here the parameters are adjusted for the identification and the expected value adopted.



Form:
 Rectangle

- Choose the search area.

Read Expected Text

- **Read:** The read result is displayed here.
- **Arrow:** Using the arrow, you can accept the current result as the new expected value.
- **Expected:** In addition, you may specify an expected value.
- **Text/binary:** Change the display between Text (ASCII) and Binary (hexadecimal).

Common	Appearance	Code parameters
Code type	EAN-13	<input checked="" type="checkbox"/> Detect on teach
Parameters	Fast	<input type="checkbox"/> Optimize on teach
	<input type="checkbox"/> Abort read attempt after around	50ms
Quality	Don't calculate	Not calculated
	<input type="checkbox"/> Minimum quality	D

- **Code type:** Select the type of barcode in the image.
- **Detect on teach:** Using the *Detection on teach* option, you can have the code type automatically determined during external teach-in.
- **Parameters:** Select the search parameters used to search for the code. *Fast*, *Robust* and *User defined* are available. In the case of the user-defined search, you can manually set the parameters for the display and the code.
- **Optimize on teach:** Using the *Optimize on teach* option, you can have the parameters automatically adjusted for the code search during the external teach-in. This is only necessary if you have set the search parameters in the User-defined option.
- **Abort read attempt after circa:** Use this function to limit processing time for code determination.

NOTE



If processing time for code determination is limited and code quality is also to be determined, you need to be aware that limiting processing time only applies to code determination. If necessary, the extra time required for determining code quality should be established empirically and planned in addition – so deducted from the maximum permitted processing time, for example.

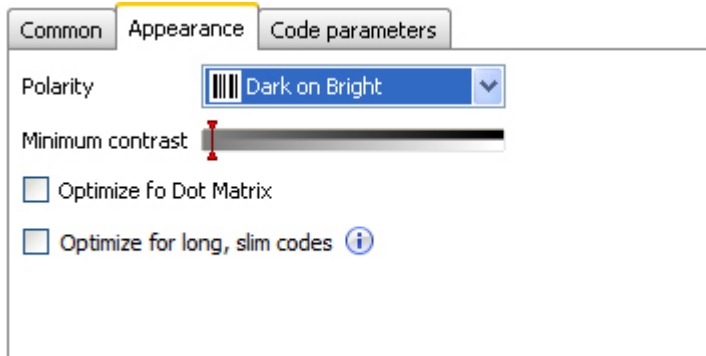
The limit on processing time may potentially vary between device and PC as they each have a different computing performance.

- **Quality:** If you also wish to check the code quality, you may activate the Calculate per *ISO/IEC 15416* option. However, this also increases the processing time!
- **Minimum quality:** Activate this box if you want to specify a minimum quality.
- The code quality is specified as follows:
A - F (A = High quality ; F = Poor quality)
- The first parameter corresponds to the overall code quality.
- A total of 8 features are specified:
Legibility, symbol contrast, minimal reflectance, edge contrast, modulation, defects, decodability, additional code-specific parameters.
- You can find more details on the quality characteristics in appendix: Quality characteristics for barcodes and matrix codes

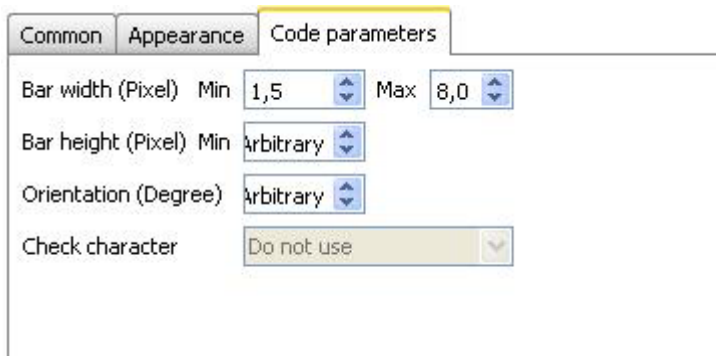


NOTE

In order to be able to make the settings "Appearance" and "Code parameters" on the tabs, you must set the Parameters on the "Common" tab to *User defined*.



- **Polarity:** Specify whether the code is brighter or darker than the background.
- **Minimum contrast:** Specify the minimum contrast of the barcode.
- **Optimise for dot matrix:** Activate this function if the barcode consists of a dot matrix.
- **Optimise for long, slim codes:** Activate this function if the height of the code is less than 15% of its width.



- **Bar width (pixel):** Specify the minimum width of one bar of the barcode.
- **Bar height (pixel):** Specify the height of one bar of the barcode.
- **Orientation (Degree):** To reduce processing time, you may restrict the barcode orientation. To do this, specify the maximum deviation with respect to the position of the field of view.
- **Check character:** Specify whether you want to use a check digit.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Read code	Text	Read result
Quality	Text	Overall quality
Quality (details)	Text	Individual quality characteristics
Output of position	Float-Point	Centre of the code

The following value can be set via the process interface. Please note that an expected value must be provided during parametrisation of the feature check.

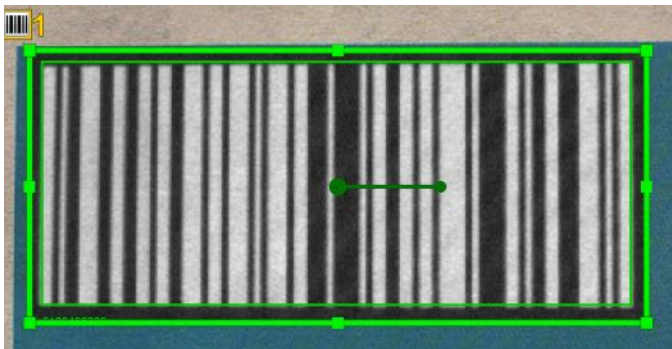
Input value	Data type	Description
to expected code	Text	expected code

12.4.2 Barcode (color)

This feature check enables colored barcodes with colored backgrounds to be read. The field of view is first converted into a black and white image. In addition, the quality of the barcode can be determined according to ISO/IEC 15416.

The quality is determined once the image has been converted to black and white. You cannot, therefore, observe any influence the color has on the quality.

This feature check supports external Teach. Here the parameters are adjusted for the identification and the expected value adopted.



Form:
 Rectangle

- Choose the search area.

Read Expected

- **Read:** The read result is displayed here.
- **Arrow:** Using the arrow, you can accept the current result as the new expected value.
- **Expected:** In addition, you may specify an expected value.
- **Text/binary:** Change the display between Text (ASCII) and Binary (hexadecimal).

Common	Appearance	Code parameters
Code type	Code 128	<input checked="" type="checkbox"/> Detect on teach
Parameters	Robust	<input type="checkbox"/> Optimize on teach
	<input type="checkbox"/> Abort read attempt after around	50ms
Quality	Don't calculate	Not calculated
	<input type="checkbox"/> Minimum quality	D

- **Code type:** Select the type of barcode in the image.
- **Detect on teach:** Using the *Detection on teach* option, you can have the code type automatically determined during external teach-in.
- **Parameters:** Select the search parameters used to search for the code. *Robust* and *User defined* are available. In the case of the user-defined search, you can manually set the parameters for the display and the code.
- **Optimize on teach:** Using the *Optimize on teach* option, you can have the parameters automatically adjusted for the code search during the external teach-in. This is only necessary if you have set the search parameters in the User-defined option.
- **Abort read attempt after circa:** Use this function to limit processing time for code determination.

NOTE




If processing time for code determination is limited and code quality is also to be determined, you need to be aware that limiting processing time only applies to code determination. If necessary, the extra time required for determining code quality should be established empirically and planned in addition – so deducted from the maximum permitted processing time, for example.

The limit on processing time may potentially vary between device and PC as they each have a different computing performance.

- **Quality:** If you also wish to check the code quality, you may activate the Calculate per *ISO/IEC 15416* option. However, this also increases the processing time!
- **Minimum quality:** Activate this box if you want to specify a minimum quality.
- The code quality is specified as follows:
A - F (A = High quality ; F = Poor quality)
- The first parameter corresponds to the overall code quality.
- A total of 8 features are specified:
Legibility, symbol contrast, minimal reflectance, edge contrast, modulation, defects, decodability, additional code-specific parameters.
- You can find more details on the quality characteristics in appendix: Quality characteristics for barcodes and matrix codes

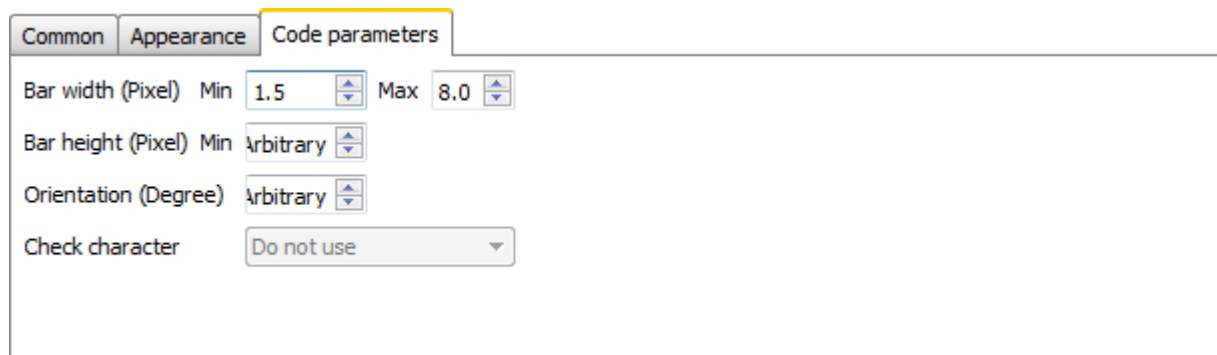
NOTE



In order to be able to make the settings "Appearance" and "Code parameters" on the tabs, you must set the Parameters on the "Common" tab to *User defined*.



- **Color conversion:** Enter the method you wish to use to convert the field of view into a black and white image here. Select *Gray value*, if the black and white version of the field of view contrasts well. Select *Two color optimization* if the barcode and background appear in similarly light colors.
- **Polarity:** Specify whether the code is brighter or darker than the background. The *Arbitrary* option doubles the processing time.
- **Minimum contrast:** Specify the minimum contrast of the barcode.
- **Noise suppression:** Activate this function if you want to minimize noise.



- **Bar width (pixel):** Specify the minimum width of one bar of the barcode.
- **Bar height (pixel):** Specify the height of one bar of the barcode.
- **Orientation (Degree):** To reduce processing time, you may restrict the barcode orientation. To do this, specify the maximum deviation with respect to the position of the field of view.
- **Check character:** Specify whether you want to use a check digit.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Read code	Text	Read result
Quality	Text	Overall quality
Quality (details)	Text	Individual quality characteristics
Output of position	Float-Point	Centre of the code

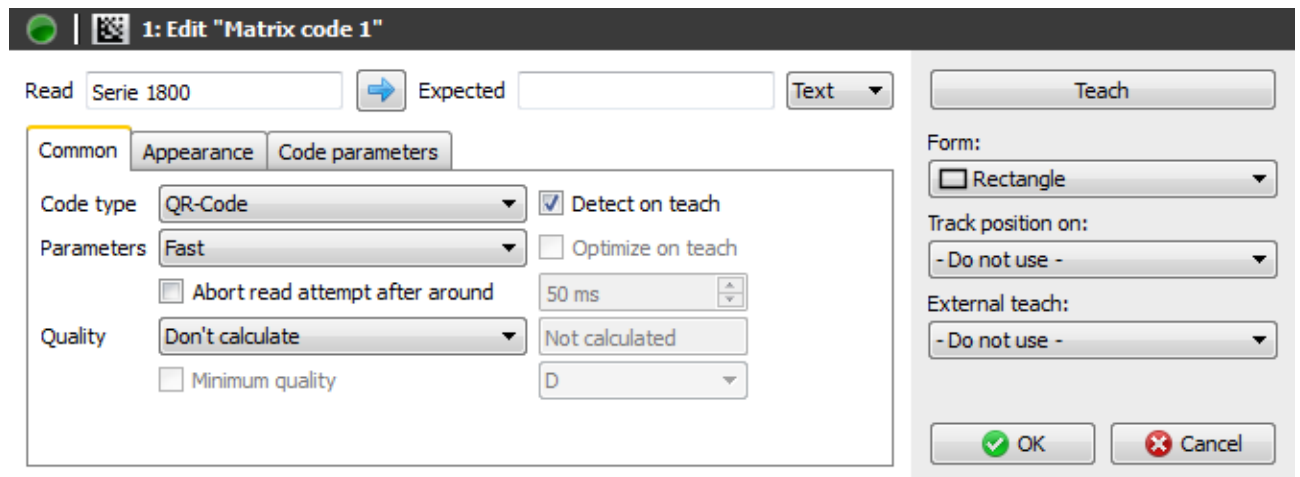
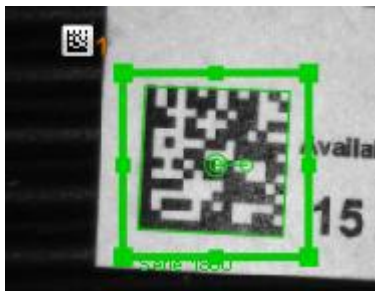
The following value can be set via the process interface. Please note that an expected value must be provided during parametrisation of the feature check.

Input value	Data type	Description
to expected code	Text	expected code

12.4.3 Matrix code

Matrix codes (ECC 200, QR, PDF417) can be read using this feature check. In addition, the quality of the barcode can be determined according to ISO/IEC 15415 or AIM DPM-1-2006.

This feature check supports external Teach. In this process, the parameters for identification are adjusted and the expected value is accepted if an expected value has already been set.

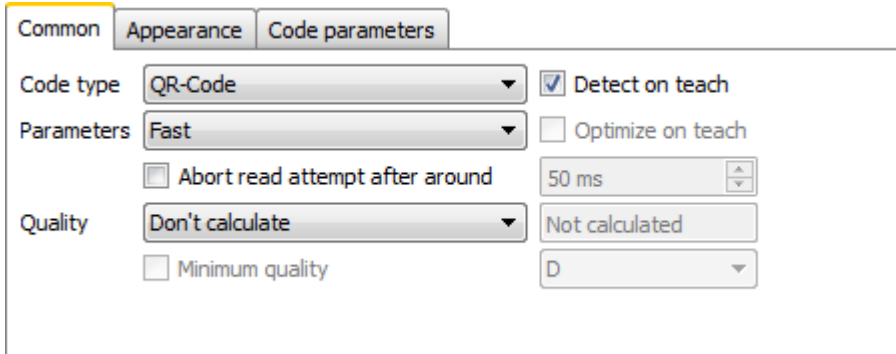



Form:
 Rectangle

- Choose the search area.

Read Expected Text

- Read:** The read result is displayed here.
- Arrow:** Using the arrow, you can accept the current result as the new expected value.
- Expected:** In addition, you may specify an expected value.
- Text/binary:** Change the display between Text (ASCII) and Binary (hexadecimal).



- **Code type:** Select the type of matrix code in the image.
- **Detect on teach:** Using the *Detection on teach* option, you can have the code type automatically determined during external teach-in.
- **Parameters:** Select the search parameters used to search for the code. *Fast*, *Robust*, *Maximum* and *User defined* are available. In the *Robust* or *Maximum* modes, codes are found even with more demanding backgrounds. However, this places a burden on the processing time. In the case of the user-defined search, you can manually set the parameters for the display and the code.
- **Optimize on teach:** Using the *Optimize on teach* option, you can have the parameters automatically adjusted for the code search during the external teach-in. This is only necessary if you have set the search parameters in the User-defined option.
- **Abort read attempt after circa:** Use this function to limit processing time for code determination.

NOTE



If processing time for code determination is limited and code quality is also to be determined, you need to be aware that limiting processing time only applies to code determination. If necessary, the extra time required for determining code quality should be established empirically and planned in addition – so deducted from the maximum permitted processing time, for example.

The limit on processing time may potentially vary between device and PC as they each have a different computing performance.

- **Quality:** If you also wish to check the code quality, you may activate the *Calculate* based on *ISO/IEC 15415* or *Calculate* based on *AIM DPM-1-2006* option. However, this also increases the processing time!
- **Minimum quality:** Activate this box if you want to specify a minimum quality.

The code quality is specified as follows:

A - F (A = High quality ; F = Poor quality)

The first parameter corresponds to the overall code quality.

In the *ISO/IEC 15415* mode, various characteristics are determined:


- ECC200 / QR code:
 - Contrast, modulation, pattern damage, decodability, axial non-uniformity (evaluation of width and height), grid non-uniformity (evaluation of slope angle), unused error correction

- PDF417:
Reflection properties of the start/stop pattern, decoded codeword yield, unused error correction, modulation, decodability, defects

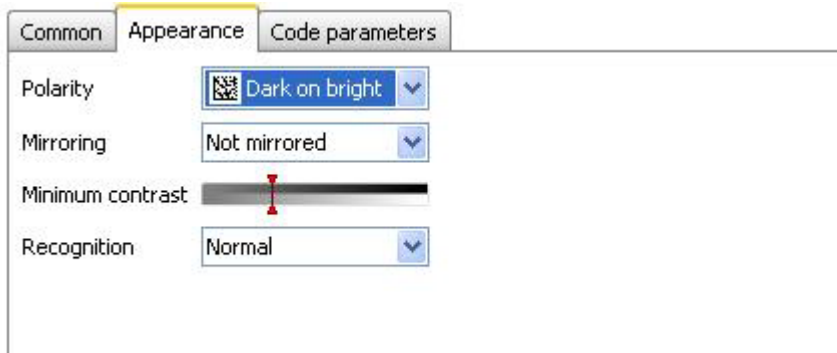
In the *AIM DPM-1-2006* mode, a total of 8 characteristics are determined (for ECC200 / QR code only):

Cell contrast, cell modulation, fixed pattern damage, decodability, axial non-uniformity (evaluation of the width and height), grid non-uniformity (evaluation of the slope angle), unused error correction, mean grey value of the light modules.

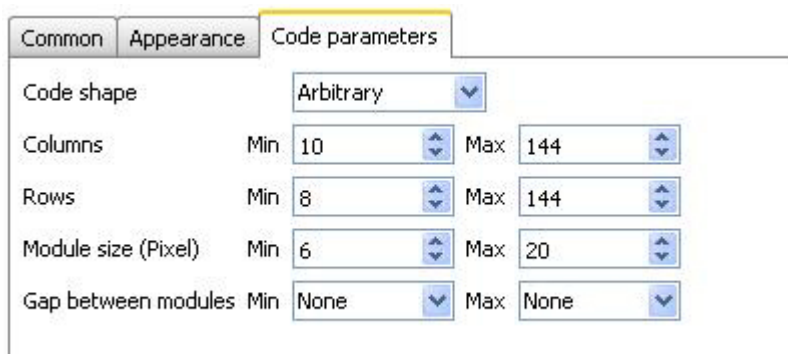
NOTE



In order to be able to make the settings "Appearance" and "Code parameters" on the tabs, you must set the Parameters on the "Common" tab to *User defined*.



- **Polarity:** Specify whether the code is brighter or darker than the background.
- **Mirroring:** Specify whether the code is mirrored.
- **Minimum contrast:** Specify the minimum contrast of the matrix code.
- **Recognition:** If the outer contour of the code exhibits disturbances, you should activate "Tolerant" recognition. Otherwise, "Normal" recognition is sufficient.



- **Code shape:** Specify the shape of the code to be found. For code type Data Matrix: (rectangular, square, arbitrary). For code type QR code: (Model 1, Model 2, arbitrary).
- **Columns:** Specify the number of columns of the module.
- **Rows:** Specify the number of lines of the module.
- **Module size (Pixel):** Specify the size of a module.

- **Gap between the modules:** Specify whether gaps may occur between the modules.

Track position on:

External teach:

- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Read code	Text	Read result
Quality	Text	Overall quality
Quality (details)	Text	Individual quality characteristics
Output of position	Float-Point	Centre of the code

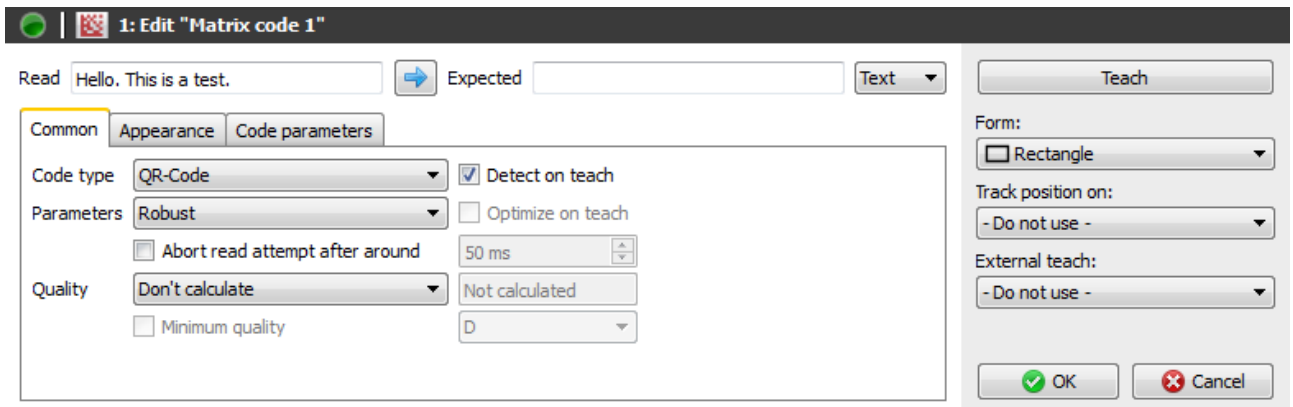
The following value can be set via the process interface. Please note that an expected value must be provided during parametrisation of the feature check.

Input value	Data type	Description
to expected code	Text	expected code

12.4.4 Matrix code (color)

Colored matrix codes (ECC 200, QR, PDF417) with colored backgrounds can be read using this feature check. The field of view is first converted into a black and white image. In addition, the quality of the barcode can be determined according to ISO/IEC 15415 or AIM DPM-1-2006.

This feature check supports external Teach. In this process, the parameters for identification are adjusted and the expected value is accepted if an expected value has already been set.



1: Edit "Matrix code 1"

Read: Hello. This is a test. [Arrow] Expected: [Text]

Code type: QR-Code [Detect on teach checked]

Parameters: Robust [Optimize on teach unchecked]

Quality: Don't calculate [Minimum quality unchecked]

Form: Rectangle

Track position on: - Do not use -

External teach: - Do not use -

[OK] [Cancel]



Form:

Rectangle

- Choose the search area.

Read: Hello. This is a test. [Arrow] Expected: [Text]

- Read:** The read result is displayed here.
- Arrow:** Using the arrow, you can accept the current result as the new expected value.
- Expected:** In addition, you may specify an expected value.
- Text/binary:** Change the display between Text (ASCII) and Binary (hexadecimal).

Common	Appearance	Code parameters
Code type	QR-Code	<input checked="" type="checkbox"/> Detect on teach
Parameters	Robust	<input type="checkbox"/> Optimize on teach
	<input type="checkbox"/> Abort read attempt after around	50 ms
Quality	Don't calculate	Not calculated
	<input type="checkbox"/> Minimum quality	D

- **Code type:** Select the type of matrix code in the image.
- **Detect on teach:** Using the *Detection on teach* option, you can have the code type automatically determined during external teach-in.
- **Parameters:** Select the search parameters used to search for the code. *Robust*, *Maximum* and *User defined* are available. In the *Robust* or *Maximum* modes, codes are found even with more demanding backgrounds. However, this places a burden on the processing time. In the case of the user-defined search, you can manually set the parameters for the display and the code.
- **Optimize on teach:** Using the *Optimize on teach* option, you can have the parameters automatically adjusted for the code search during the external teach-in. This is only necessary if you have set the search parameters in the User-defined option.
- **Abort read attempt after circa:** Use this function to limit processing time for code determination.

NOTE



If processing time for code determination is limited and code quality is also to be determined, you need to be aware that limiting processing time only applies to code determination. If necessary, the extra time required for determining code quality should be established empirically and planned in addition – so deducted from the maximum permitted processing time, for example.

The limit on processing time may potentially vary between device and PC as they each have a different computing performance.

- **Quality:** If you also wish to check the code quality, you may activate the *Calculate* based on *ISO/IEC 15415* or *Calculate* based on *AIM DPM-1-2006* option. However, this also increases the processing time!
- **Minimum quality:** Activate this box if you want to specify a minimum quality.

The code quality is specified as follows:

A - F (A = High quality ; F = Poor quality)

The first parameter corresponds to the overall code quality.

In the *ISO/IEC 15415* mode, various characteristics are determined:

- ECC200 / QR code:
Contrast, modulation, pattern damage, decodability, axial non-uniformity (evaluation of width and height), grid non-uniformity (evaluation of slope angle), unused error correction
- PDF417:
Reflection properties of the start/stop pattern, decoded codeword yield, unused error correction, modulation, decodability, defects


In the *AIM DPM-1-2006* mode, a total of 8 characteristics are determined (for ECC200 / QR code only):

Cell contrast, cell modulation, fixed pattern damage, decodability, axial non-uniformity (evaluation of the width and height), grid non-uniformity (evaluation of the slope angle), unused error correction, mean grey value of the light modules.



NOTE

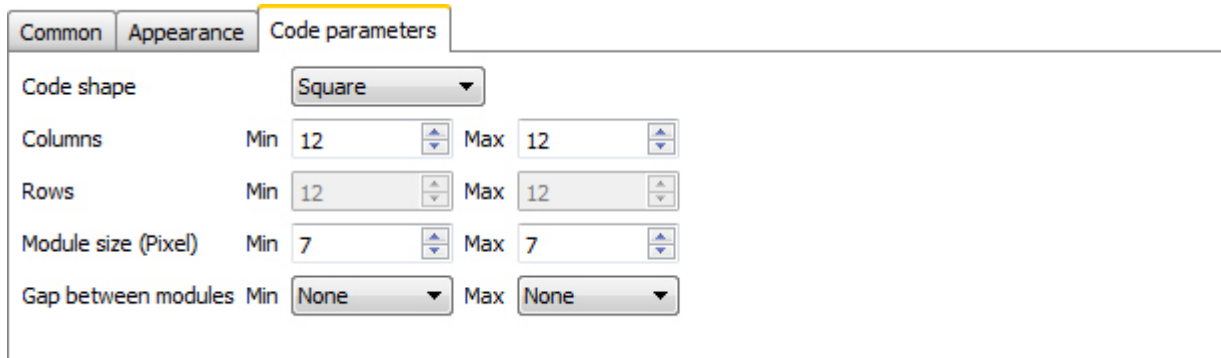
In order to be able to make the settings "Appearance" and "Code parameters" on the tabs, you must set the Parameters on the "Common" tab to *User defined*.



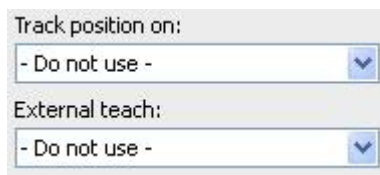
The screenshot shows a software interface with three tabs: 'Common', 'Appearance', and 'Code parameters'. The 'Common' tab is active. Under the 'Appearance' section, there are four settings:

- Color conversion: Two color optimization (dropdown)
- Polarity: Arbitrary (dropdown)
- Mirroring: Not mirrored (dropdown)
- Minimum contrast: A slider control with a red vertical marker.

- **Color conversion:** Enter the method you wish to use to convert the field of view into a black and white image here. Select *Gray value*, if the black and white version of the field of view contrasts well. Select *Two color optimization* if the barcode and background appear in similarly light colors.
- **Polarity:** Specify whether the code is brighter or darker than the background.
- **Mirroring:** Specify whether the code is mirrored.
- **Minimum contrast:** Specify the minimum contrast of the matrix code.



- **Code shape:** Specify the shape of the code to be found. For code type Data Matrix: (rectangular, square, arbitrary). For code type QR code: (Model 1, Model 2, arbitrary).
- **Columns:** Specify the number of columns of the module.
- **Rows:** Specify the number of lines of the module.
- **Module size (Pixel):** Specify the size of a module.
- **Gap between the modules:** Specify whether gaps may occur between the modules.



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the feature check. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Read code	Text	Read result
Quality	Text	Overall quality
Quality (details)	Text	Individual quality characteristics
Output of position	Float-Point	Centre of the code

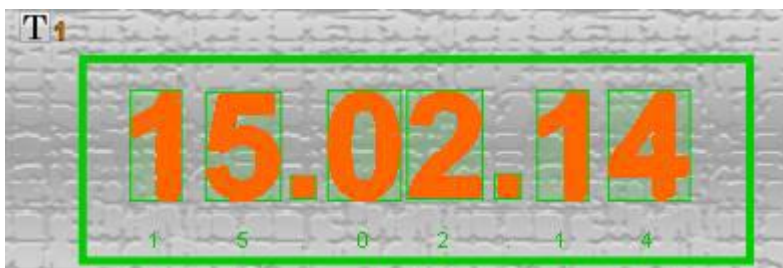
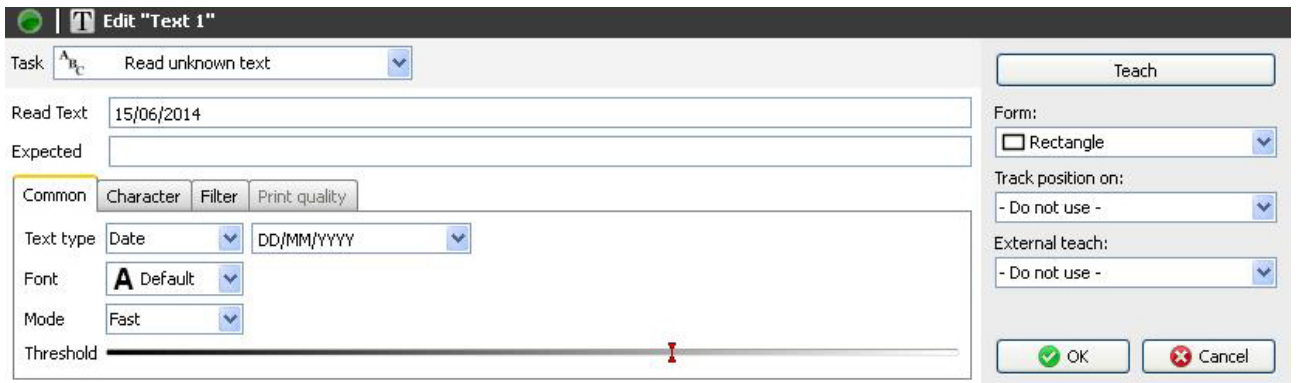
The following value can be set via the process interface. Please note that an expected value must be provided during parametrisation of the feature check.

Input value	Data type	Description
to expected code	Text	expected code

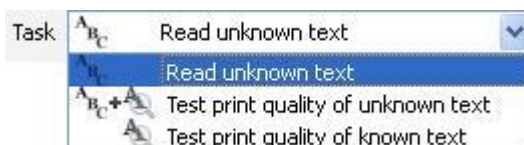
12.4.5 Text

You can read date specifications, numbers and words using this feature check. In addition, it is possible to compare the result to an expected value. You can also check the print quality of text.

This feature check supports external Teach. Here, the value actually read is adopted as a new expectation value.



- Select the area containing the text.
- Always mark only one line. If the text covers multiple lines, you must use several feature checks. Make sure that the text is marked as precisely as possible.
- If the text fluctuates in its location in the image, you can use the “Part location on text line” feature check for part location.



- **Read unknown text:** Select this option if you want to read unknown text.
- **Test print quality of unknown text:** Select this option if you want to check the print quality of unknown text.
- **Test print quality of known text:** With this function, you can compare the print quality to a taught value.

Read unknown text


If you have selected Read unknown text, the read text is displayed. You can also enter the text expected into the Expected field. You can configure settings on the Common, Characters and Filter tabs. Using the arrow, you can accept the current result as the new expected value.

Check the print quality of unknown text

If you have selected Check the *print quality of unknown text*, you can compare the print quality of unknown text to previously taught reference characters. To use this function, you have to teach in the reference characters on the *Print quality* tab. You can also make settings on the Common, Characters and Filter tabs.

Check the print quality of known text

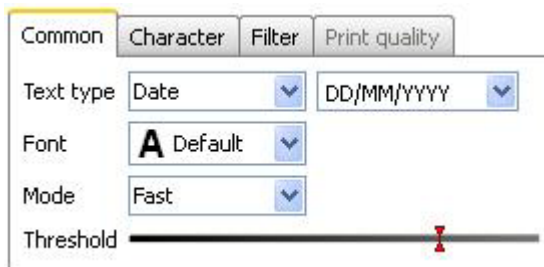
If you have selected Check the print quality of known text, you can compare the read text to previously taught characters and set it as a reference using external teach-in.



NOTE

Using teach-in, only the text contents are read and not the text format (e.g., date)!
All characters to be read must be taught in advance using the Print quality tab!


You can teach in the reference characters on the Print quality tab. You can also make settings on the Common, Characters and Filter tabs.



The screenshot shows the 'Print quality' tab selected. The settings are as follows:

- Text type:** Date (dropdown), DD/MM/YYYY (dropdown)
- Font:** A Default (dropdown)
- Mode:** Fast (dropdown)
- Threshold:** A horizontal slider bar with a red vertical marker.

- **Text type:** Set the type of the text. You may select *Date*, *Numbers*, *Hexadecimal characters*, *Letters*, *Mask* and *Time*. You can describe the text type exactly on the right side, which is then displayed in accordance with the selected type.
- **Font:** Select the *Standard* font if you want to recognize Sans-serif writing (e.g., Arial, Verdana, Univers and OCR-B). Select the *Dot-Print* font if you want to recognize dot-matrix fonts.



NOTE

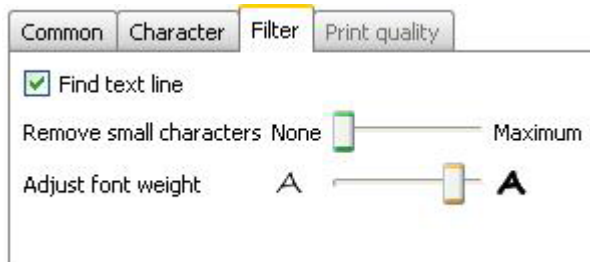
With the Dot-Print font, lower case letters cannot be read.

- **Mode:** The selected mode determines the processing time required to process the feature check. The *Robust* mode requires the longest processing time but makes more stable read results possible if the print format is not optimal.

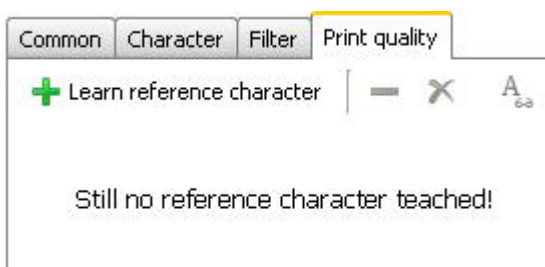
- **Threshold:** Set the threshold for the separation of background and characters. For optimal recognition, the background should have as little structure as possible!



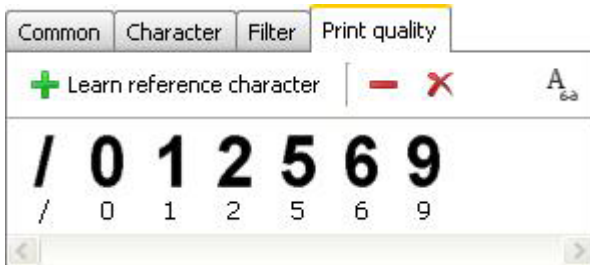
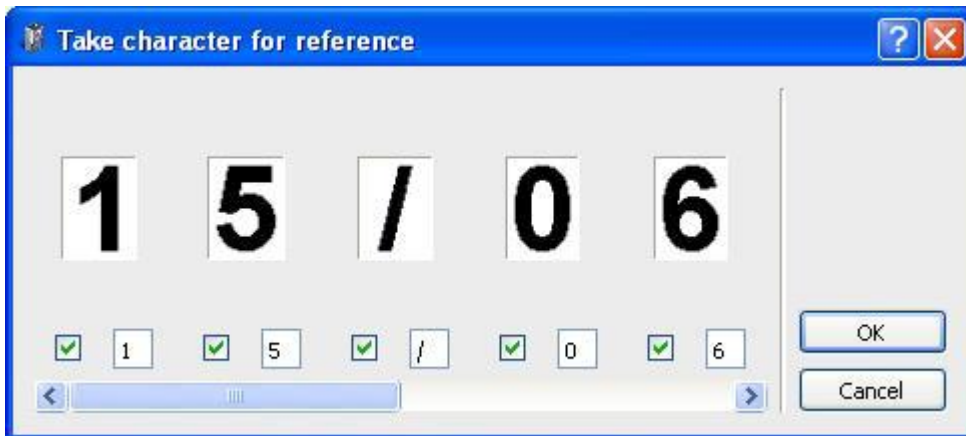
- **Polarity:** Specify whether the text is brighter or darker than the background.
- **Mirroring:** Specify whether the text is mirrored.
- **Font height:** Choose whether the character size is automatically recognized or whether it should be entered manually. With manual entry, you may enter this value or draw a frame in the image around one individual character.



- **Find text line:** Activate the *Find text line* option if structures are present below or above the text and these structures are to be automatically masked.
- **Remove small characters:** In addition, you can set a minimum size for the characters to remove very small characters.
- **Adjust font weight:** It is also possible to reduce or increase the line thickness of the characters found.



- **Learn reference character:** Click on the + to teach in reference characters. The window below opens where you can assign values to the characters read.



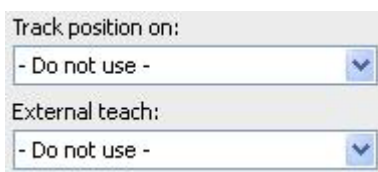
Delete the individually marked reference character



Delete all reference characters



Show/hide characters that have not been taught in



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the sensor. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Read text	Text	Read result

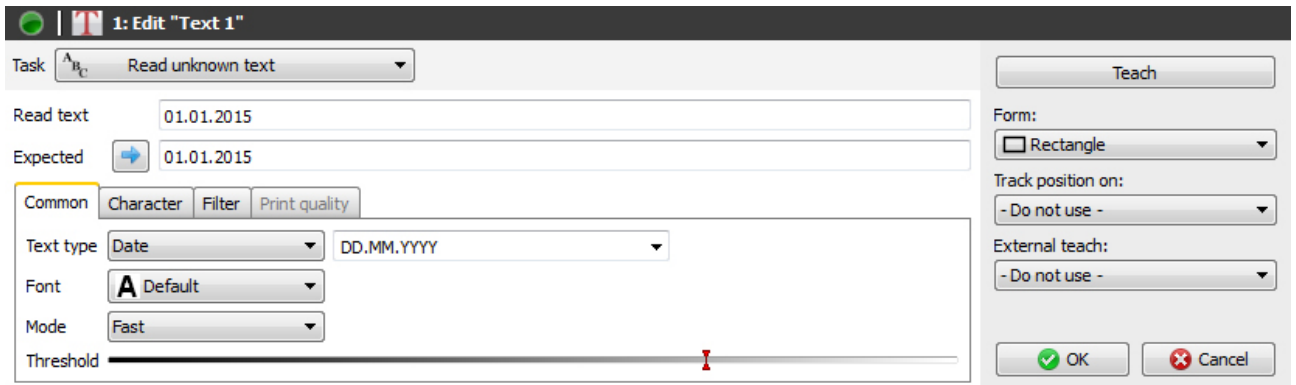
The following values can be set via the process interface. Please note that an expected value must be provided during parametrisation of the feature check.

Input value	Data type	Description
Mask	Text	Masking of the expected text
Expected	Text	expected text

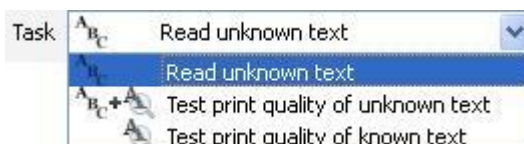
12.4.6 Text (color)

You can read colored dates, numbers and words on colored backgrounds using this feature check. The field of view is first converted into a black and white image. It also gives you the option to compare the result to an expected value. You can also check the print quality of text.

This feature check supports external Teach. Here, the value actually read is adopted as a new expectation value.



- Select the area containing the text.
- Always mark only one line. If the text covers multiple lines, you must use several feature checks. Make sure that the text is marked as precisely as possible.
- If the text fluctuates in its location in the image, you can use the “Part location on text line” feature check for part location.



- **Read unknown text:** Select this option if you want to read unknown text.
- **Test print quality of unknown text:** Select this option if you want to check the print quality of unknown text.
- **Test print quality of known text:** With this function, you can compare the print quality to a taught value.

Read unknown text

If you have selected Read unknown text, the read text is displayed. You can also enter the text expected into the Expected field. You can configure settings on the Common, Characters and Filter tabs. Using the arrow, you can accept the current result as the new expected value.


Check the print quality of unknown text

If you have selected Check the *print quality of unknown text*, you can compare the print quality of unknown text to previously taught reference characters. To use this function, you have to teach in the reference characters on the *Print quality* tab. You can also make settings on the Common, Characters and Filter tabs.

Check the print quality of known text

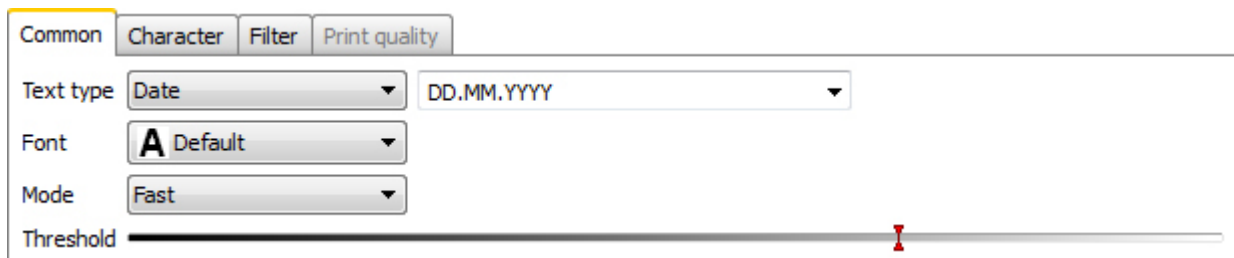
If you have selected Check the print quality of known text, you can compare the read text to previously taught characters and set it as a reference using external teach-in.

NOTE



Using teach-in, only the text contents are read and not the text format (e.g., date)!
All characters to be read must be taught in advance using the Print quality tab!

You can teach in the reference characters on the Print quality tab. You can also make settings on the Common, Characters and Filter tabs.




The screenshot shows the 'Print quality' tab with the following settings:

- Text type: Date (DD.MM.YYYY)
- Font: A Default
- Mode: Fast
- Threshold: A slider bar with a red vertical marker.

- **Text type:** Set the type of the text. You may select *Date*, *Numbers*, *Hexadecimal characters*, *Letters*, *Mask* and *Time*. You can describe the text type exactly on the right side, which is then displayed in accordance with the selected type.
- **Font:** Select the *Standard* font if you want to recognize Sans-serif writing (e.g., Arial, Verdana, Univers and OCR-B). Select the *Dot-Print* font if you want to recognize dot-matrix fonts.

NOTE

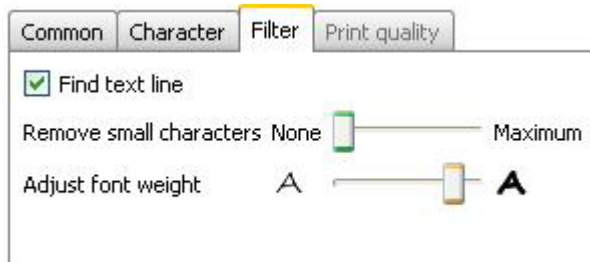


With the Dot-Print font, lower case letters cannot be read.

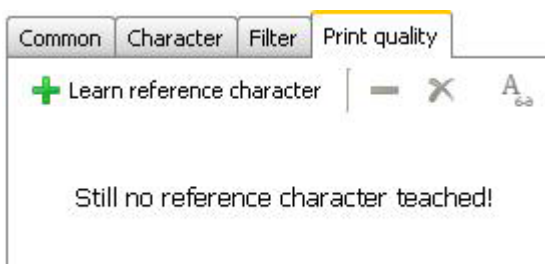
- **Mode:** The selected mode determines the processing time required to process the feature check. The *Robust* mode requires the longest processing time but makes more stable read results possible if the print format is not optimal.
- **Threshold:** Set the threshold for the separation of background and characters. For optimal recognition, the background should have as little structure as possible!



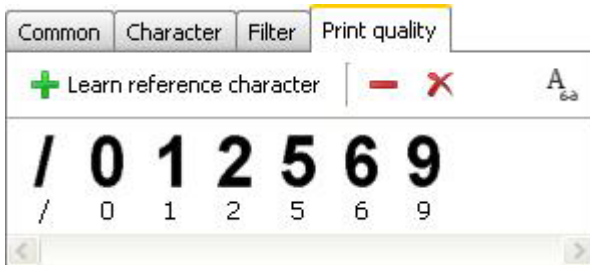
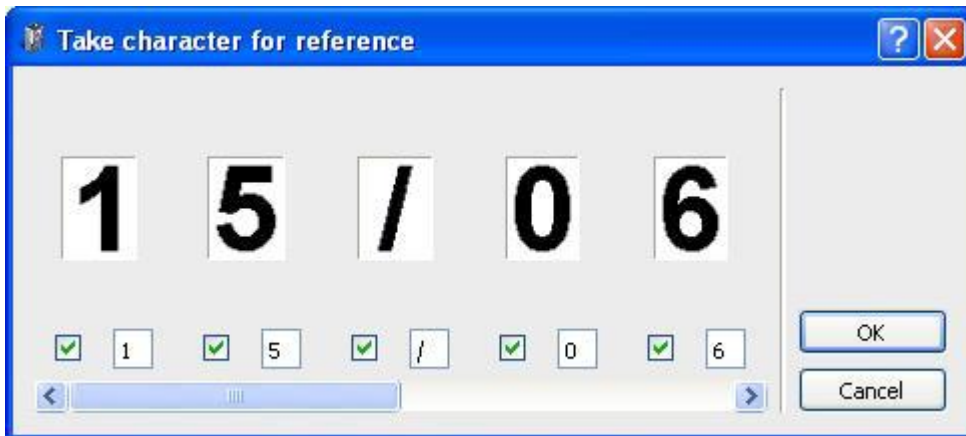
- **Polarity:** Specify whether the text is brighter or darker than the background.
- **Mirroring:** Specify whether the text is mirrored.
- **Font height:** Choose whether the character size is automatically recognized or whether it should be entered manually. With manual entry, you may enter this value or draw a frame in the image around one individual character.
- **Color conversion:** Enter the method you wish to use to convert the field of view into a black and white image here. Select *Gray value*, if the black and white version of the field of view contrasts well. Select *Two color optimization* if the barcode and background appear in similarly light colors.
- **Re-learn text color:** Use this function to optimize the way the field of view is converted into a black and white image. This is useful if the colors in the field of view have changed.



- **Find text line:** Activate the *Find text line* option if structures are present below or above the text and these structures are to be automatically masked.
- **Remove small characters:** In addition, you can set a minimum size for the characters to remove very small characters.
- **Adjust font weight:** It is also possible to reduce or increase the line thickness of the characters found.




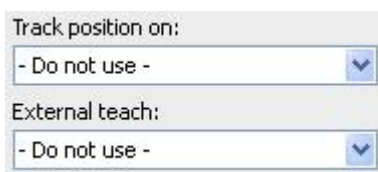
- **Learn reference character:** Click on the + to teach in reference characters. The window below opens where you can assign values to the characters read.



 Delete the individually marked reference character

 Delete all reference characters

 Show/hide characters that have not been taught in



- If the feature check is to be corrected by the result of the part location, you can choose this option here. External teach-in also makes it possible to retrain the sensor. Select the appropriate option for this purpose.



- Confirm your settings and return to the feature list with *OK*. Return to the feature list without making any changes with *Cancel*.

This feature check has the following output values for the datagram at the process interface:

Output value	Data type	Description
Result		Result of the feature check: "P" (Pass); "F" (Fail)
Read text	Text	Read result

The following values can be set via the process interface. Please note that an expected value must be provided during parametrisation of the feature check.

Input value	Data type	Description
Mask	Text	Masking of the expected text
Expected	Text	expected text





12.4.7 Appendix: Quality characteristics for barcodes and matrix codes





Numerous quality characteristics are defined for the various code types, these characteristics are described in more detail in the following. Keep in mind that illumination arrangements and quality requirements are defined on the image for these standards so that the values determined cannot be directly mapped to your installation situation!

Barcode quality characteristics (ISO/IEC 15416)

Designation	Description
Legibility	A = Code legible F = Code not read
Symbol contrast	Difference between the maximum and minimum grey scale value of the symbols
Minimum reflection	A = Minimum grey scale value $\leq 0.5 \cdot$ maximum grey scale value F = Other
Edge contrast	Minimum contrast between two symbol elements
Modulation	Amplitude between symbol elements
Defects	Irregularities in the grey scale profile of a symbol
Decodability	Deviations in the width of symbol elements
Additional code-specific parameters	Depending on code type, for example, evaluation of the width of the quiet zones or ratio of symbol widths.

Quality characteristics DataMatrix (ECC200) and QR code (ISO/IEC 15415 + AIM DPM-1-2006)

Designation	Example	Description
Contrast		Difference between the maximum and minimum grey scale value of the modules
Modulation		Amplitude between data code modules (dependent on error correction!)
Pattern damage		Disturbances in the frame pattern (finder pattern)
Legibility		A = Code legible F = Code not read

Designation	Example	Description
Axial non-uniformity		Evaluation of the width and height of the modules
Grid non-uniformity		Evaluation of the incline angle (perspective distortion)
Unused error correction		Proportion of the unused error redundancy
Gray scale value of the light modules		Average grey scale value of all light modules of the DataMatrix or QR code

Quality characteristics PDF 417 (ISO/IEC 15415)

Designation	Description
Reflection properties Start/stop pattern	Analysis of reflection properties and bar width of the start/stop pattern
Proportion of decoded code words	Relative proportion of decoded code words
Unused error correction	Proportion of the unused error redundancy
Modulation	Amplitude between symbol modules
Decodability	Deviations in the width of symbol elements
Defects	Irregularities in the scanning profile within the module

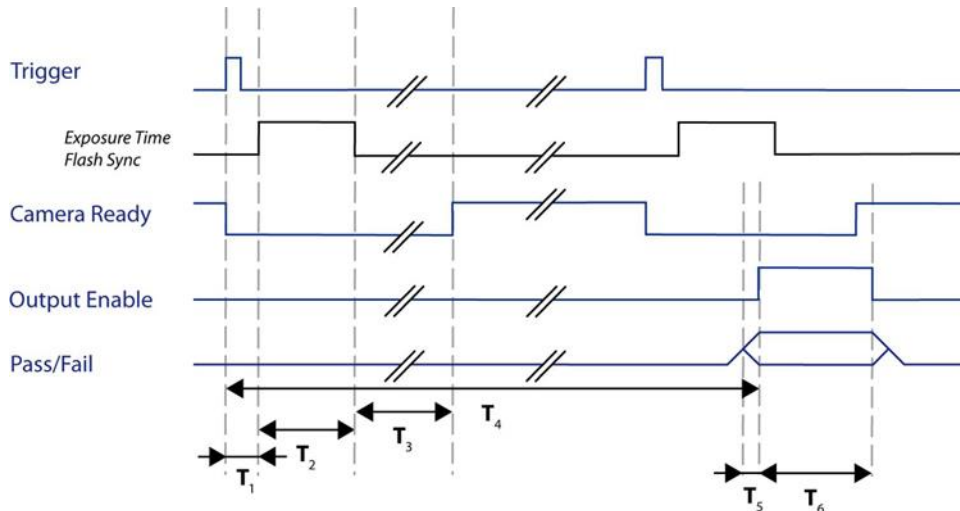
13 Digital interfaces

13.1 Explanation of terms from the timing diagram

Alarm	Indicates that an irregularity has occurred that should be investigated more closely by an expert.
Trigger	Input signal that triggers image acquisition
Flash Sync exposure time	Output signal for triggering external illumination
Camera ready	Shows that the result is at one of the outputs (pass/fail) and can, for example, be read by an PLC (not for varied output times). With the device, a new image can be recorded before the current analysis is completed. There is internal storage for two images for this reason.
Result invalid	Indicates that the result can be read at the outputs (pass/fail).
Pass	Feature check passed
Fail	Feature check failed
T	Time
Device activated	Shows that the device is activated and ready to run inspection task ("Run Mode").

13.2 Timing when an external trigger is used

The sequence of the individual signals and their designation are indicated in the diagram below:



Signal	Full resolution		Reduced resolution (device-dependant)		
	min.	max.	min.	max.	
Trigger-exposure time delay T_1	20 μ s plus preset trigger delay				
Exposure time T_2	Internal illumination ¹	35 μ s	10 ms	35 μ s	5 ms
	External illumination	35 μ s ¹ / 10 μ s ²	65.5 ms	35 μ s ¹ / 10 μ s ²	65.5 ms
	Flash controller ²	10 μ s	1 ms / 65.5 ms	10 μ s	1 ms
Image acquisition T_3	16 ms	20 ms	8 ms	11 ms	
Output time (min / max) T_4	20 ms		11 ms		
Run-up output T_5	50 μ s	2 ms	50 μ s	2 ms	
Result retention time T_6	1 ms	1 s or next result	1 ms	1 s or next result	

)¹ Devices with integrated lenses)² Devices with interchangeable lenses

Following image acquisition, the *Camera Ready* signal is deactivated. The *Camera Ready* signal is activated again at the end of image acquisition and another image acquisition operation is possible immediately.

The *Pass/Fail* signal then switches at the set output time even if additional analyses have already been performed. The *Result valid* signal is active during this time.

NOTE



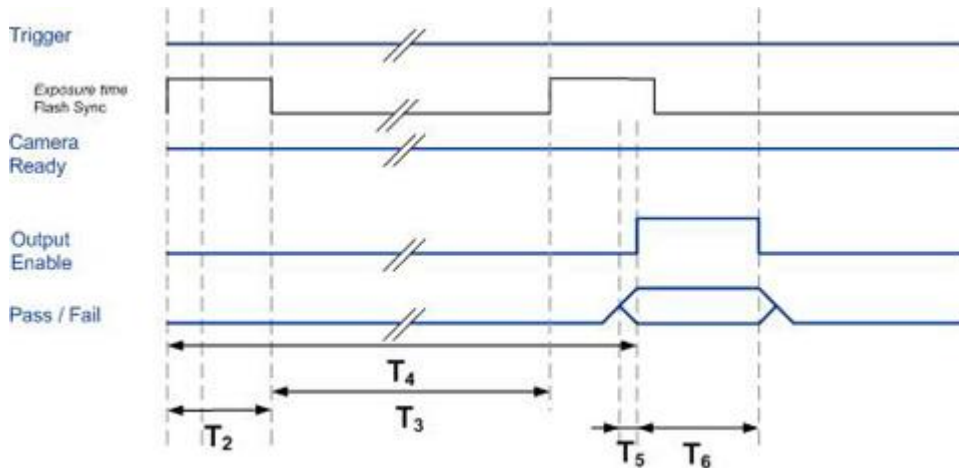
If you have connected an encoder, you may set the output time and duration as a distance.

In addition, you can specify an "output run-up" in milliseconds to activate the *Pass/Fail* signal before reaching a specific position. This option is available if an exact output time has been specified and this is specified as a distance.

Keep in mind that, in this case, the conveyor speed must be constant!

13.3 Timing for continuous image acquisition

The sequence of the individual signals and their designation are indicated in the diagram below:



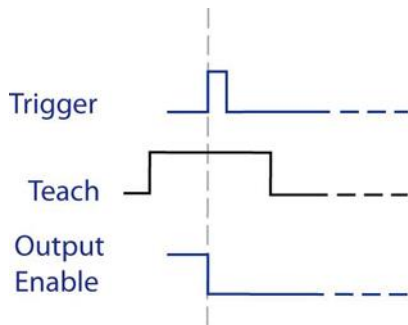
Signal		Full resolution		Reduced resolution (device-dependant)	
		min.	max.	min.	max.
Exposure time T_2	Internal illumination ¹	35 μ s	10 ms	35 μ s	5 ms
	External illumination	35 μ s ¹ / 10 μ s ²	65.5 ms	35 μ s ¹ / 10 μ s ²	65.5 ms
	Flash controller ²	10 μ s	1 ms / 65.5 ms	10 μ s	1 ms
Image acquisition T_3		16 ms	20 ms	8 ms	11 ms
Output time (min / max) T_4		20 ms		11 ms	
Run-up output T_5		50 μ s	2 ms	50 μ s	2 ms
Result retention time T_6		1 ms	1 s or next result	1 ms	1 s or next result

)¹ Devices with integrated lenses)² Devices with interchangeable lenses

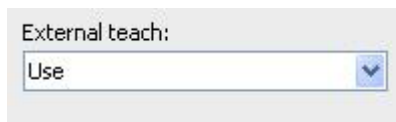
If continuous image acquisition is set in the job, the image acquisition operation occurs as soon as the previous image acquisition is complete. The *Camera Ready* signal is continuously activated during this time. The Pass/Fail signal is switched at the end of image analysis but no earlier than the set output time. You can recognize this time by a rising edge of the *Result valid* signal.

13.4 External Teach

External Teach adjusts the switching thresholds and models in the feature checks so that the evaluations have OK as the result. External Teach is used if the product changes or there are new product versions.



The digital input "Teach-in" must be in the "active high" state at the trigger point.



To use external Teach, **Use External Teach:** must be activated for the corresponding feature checks. External Teach-in is then triggered simultaneously for all appropriate feature checks.

Save changed parameters for external teach or process interface command SP on device
(Changes by web interface will always be saved)

Job changes are only stored temporarily until the device is deactivated. If you want to retain the settings, you must activate the option "Save changed parameters from External Teach-in or process SP interface command to the device".

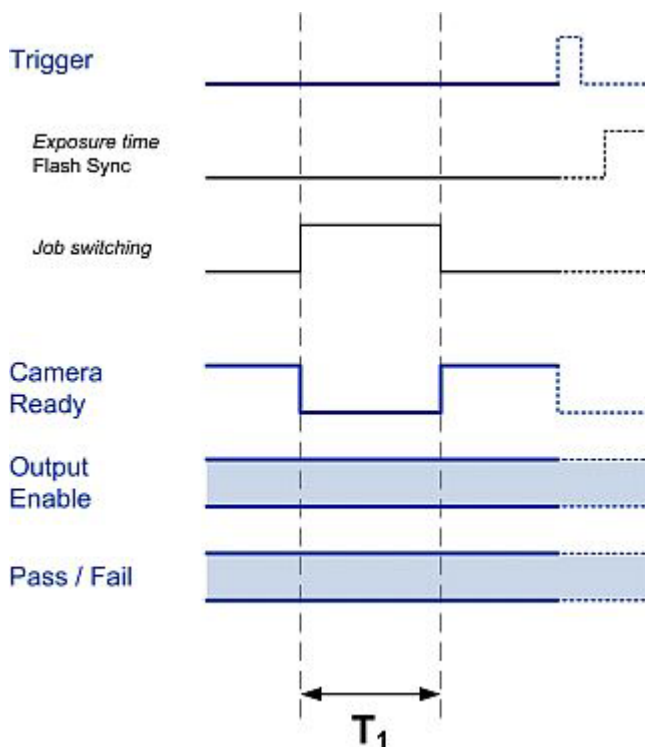
(Device → Device settings → Job selection/Teach)

13.5 Job switching

The jobs saved in the device can be activated by the corresponding switching signals with the digital inputs or individually via the process interface.

They are activated as soon as the command is received, however evaluations that are already running will be completed before the job is switched over. How long it takes to switch the job over depends mainly on its content (exposure time, number and type of feature checks, job position).

New images cannot be triggered during the switch-over.



Signal	Switch-over times
Run-up program selection T_{1^*}	Jobs 1-16: 5 ms Jobs 17-255: typically < 1 s (plus the set exposure time)

During program selection (T_1), the device is not active and the signal. *Camera ready* is deactivated. Please wait with the next image analysis operation until the "Active" state is displayed again by the corresponding signal.

If the switch could not be performed, for example because the job number was invalid, an alarm signal is also output until the next trigger.

i

NOTE

If a job is selected again by way of Job switching, and this job is already active, the *Camera Ready* signal is not deactivated!

13.6 Job selection via digital inputs

There are two ways of switching the active job of the device via the digital inputs:

- **Binary:** Bit serial: The stored jobs can be selected directly using a clock and data line.
- **Bit serial:** The stored jobs can be selected directly using a clock and data line.

Switching between jobs is only possible when the current mode is set to Activated. Switching between jobs is not possible in any other modes. Note that you must activate the option *Job selection via digital inputs* under Job Management in order to execute job selection in this way.

You can also switch the active job by sending corresponding commands via the process interface.

13.6.1 Binary job selection

For the device a maximum of four digital inputs are available for job selection.

It is possible to quickly switch between jobs 1 to 16 in this way.

The allocation of the levels to the selected job is as follows:

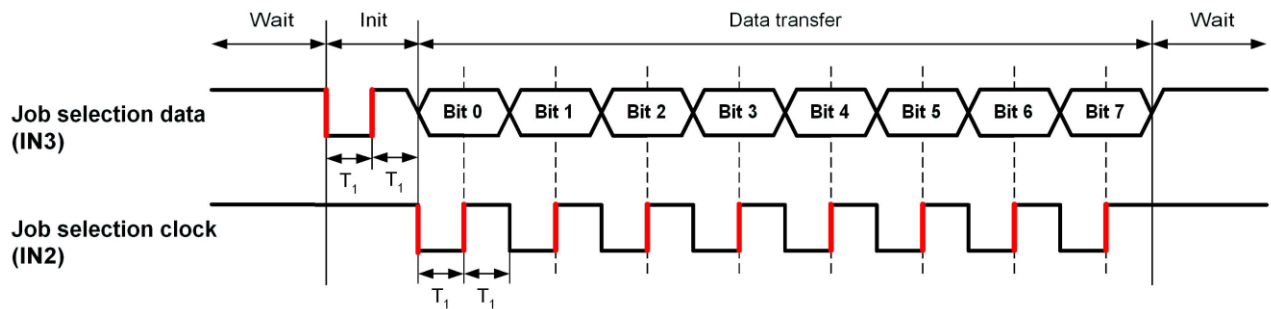
	Binary job selection – Bit 0	Binary job selection – Bit 1	Binary job selection – Bit 2	Binary job selection – Bit 3
Job 1	Low	Low	Low	Low
Job 2	High	Low	Low	Low
Job 3	Low	High	Low	Low
Job 4	High	High	Low	Low
Job 5	Low	Low	High	Low
Job 6	High	Low	High	Low
Job 7	Low	High	High	Low
Job 8	High	High	High	Low
...				
Job 16	High	High	High	High

NOTE



Please observe that this table relates to the configuration of the inputs as “active high”. If you have configured an input as “active low”, you must invert the specified levels for this input in the overview.

13.6.2 Bit serial job selection



	Signal applied to the input	
	min.	max.
Result retention time T_1	10 ms	1,000 ms

For bit serial job switching, two digital inputs are required: digital inputs IN2 ("Bit serial job selection – Clock") and IN3 ("Bit serial job selection – Data"). When inactive, high levels are applied to both lines. The levels of the data line are set briefly to low and then returned to high to start the transfer.

The desired job number can then be transferred as a series of bits. The respective bits must be transferred with the following levels on the data line:

Value	Level on the data line
0	High
1	Low

As soon as a rising edge is detected on the clock line, the corresponding bit is read on the data line. The status of the data line must be held constant for the result retention time T_1 and may only change when a low level is set on the clock line.

When all 8 bits have been transferred in this way, the inactive state is restored.

We recommend that switching to the next bit on the data line should be done simultaneously with activation of the falling edge on the clock line.

NOTE

This description applies when the parameters of the inputs are set to "active high". If you have configured an input as "active low", you must invert the specified levels for these inputs in the description.



You should also make sure that you have made the following settings for bit-serial job selection:

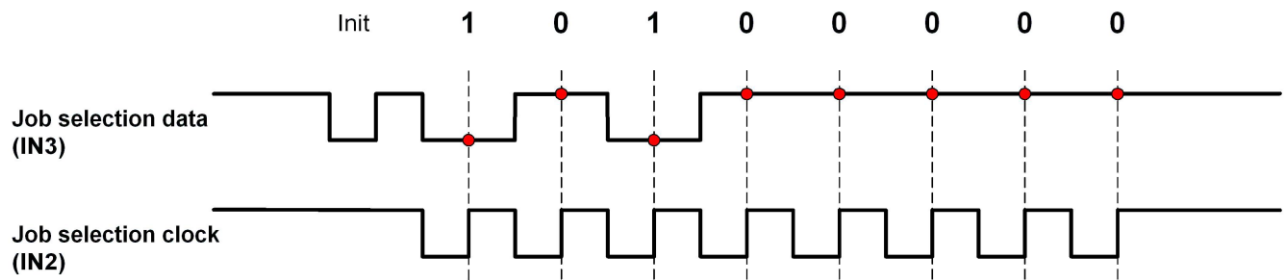
- In Job selection you must set the source "Digital inputs".
- For digital I/Os, the parameters for digital inputs 2 and 3 must be set as "Bit serial job selection – Clock" or "Bit serial job selection – Data".

Transfer the desired job number in this manner.

	Data to be transferred
Job 1	10000000
Job 2	01000000
Job 3	11000000
	...
Job 8	00010000
	...
Job 255	11111111

Example: Activation of job 5

You must switch the two digital inputs as follows to activate job 5:



13.7 Alarm signal

The alarm signal is activated under the following conditions in **parallel with the Pass/Fail signal** of the **current image acquisition/analysis operation**:

- Invalid trigger (trigger during image acquisition or job switching)
- Analysis aborted prematurely (output time exceeded)
- Error in job selection (invalid job number)
- Error at process interface
- FTP Alarm (An error occurred while transferring the images via the FTP client.)

If image analysis is not being performed at this time, the alarm signal is activated in parallel with the Pass/Fail signal of the **next image acquisition/analysis operation** if an error occurs.



NOTE

This output time for the alarm signal is not necessarily the next (seen chronologically) Pass/Fail signal if you are using the *Camera Ready* or *Result valid* signals.

The alarm signal is activated immediately under the following circumstances and maintained **until the next trigger or until a successful job switch**:

- Job switching
 - if a job is selected that is not completely configured
 - if a job is selected that is not present
- Device activation
 - if an active job was not selected at Power On

14 Web interface

The device includes an integrated web server. This enables operation and reconfiguration (e.g. of machine control) via the web browser. The web interface can be adapted to suit the application by configuring the 9 buttons for the main menu. Sub-functions and access rights for up to two user profiles can also be set.

In the web interface, you will be able to access the functions you have configured during job creation (*Configure interface* → *Web interface*) and in the device menu (*Device* → *Device settings* → *Configure web interface / Functions*).



NOTE

It is possible, but not essential, to use the web interface at the same time as the *Application Suite*.

14.1 Supported browsers

Due to differences in browser technology, there may be some differences in appearance between browsers and browser versions or even incompatibilities with the device. In our experience, these incompatibilities increase with the age of the browser due to a lack of standardisation, for instance Internet Explorer® 7 and lower is not compatible with the device. We cannot test all browsers and their various releases, so untested browsers may also function with the device.

Currently the device officially supports the following browsers:

- Internet Explorer® 8/11 (not under Windows® CE 5.0)
- Firefox 43

Cookies must be permitted.

NOTE



Information for users operating the web interface from WinCCflexible 2008 SP3 on Windows 7 Embedded (Siemens panel): Customers report requests for Internet Explorer 7, even though Internet Explorer 9 is installed on Windows 7. The web interface requires at least Internet Explorer 8 (see supported web browsers). If this happens, please contact Siemens Support.

NOTE



When using the web interface, ensure that security measures are in place to ensure that unauthorised persons do not have access.

This could include restricting access from outside sources or using VPN connections.

Only connect the Vision Sensor to a maximum of two browsers at any one time. Otherwise the web interface may not be displayed in its entirety.

NOTE



To use the web interface, you must activate JavaScript and Cookies!

Using pop-up blocker tools may result in the web interface not being correctly displayed. In this case, deactivate the pop-up blocker!

Users of Windows Internet Explorers® must also activate the use of ActiveX. You will find this setting under *Tools > Internet Options > Security > Security level for this zone > Run ActiveX controls and plug-ins*.

If necessary, add the IP address of the device to the “Local Intranet” zone. You can find this setting under *Tools → Internet Options → Security → Local Intranet → Sites → Extended*.

14.2 Connecting to the web interface

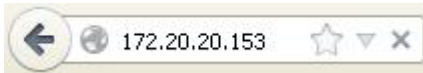
Launch a supported browser and enter the IP address of the *device* or the defined domain name into the address bar.

NOTE



You can find the current IP address for your device on the *Info* tab next the *Help* tab in the *Application Suite*.

You can set the domain name under: *Device* → *Device settings* → *Device name*.



You have the option to log into the device as an operator or expert via the address line in your browser (password assignment for user profiles: *Device* → *Device settings* → *Access rights / Web interface*).

NOTE



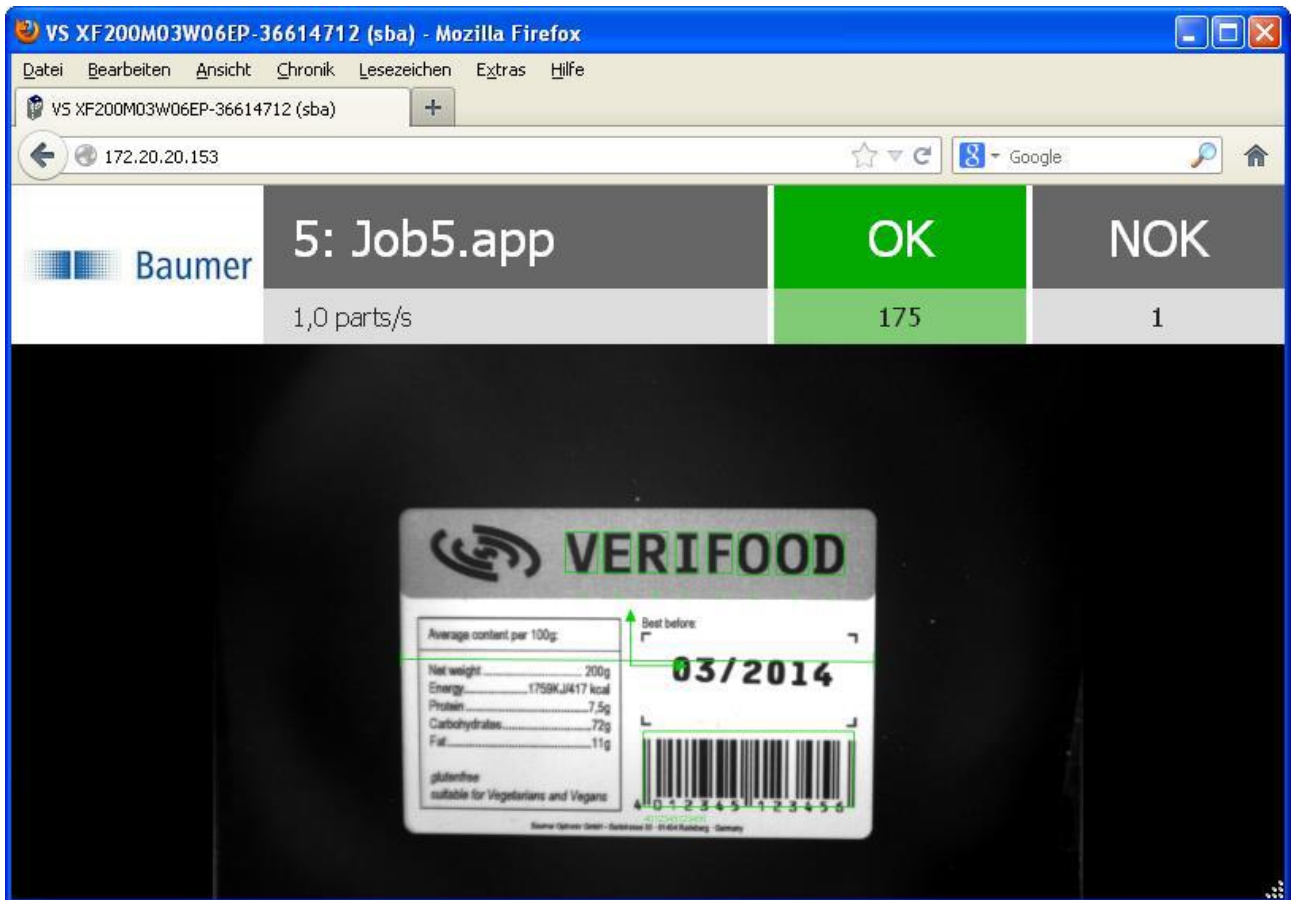
Please ensure the URL is encoded correctly when entering your password via the browser!

`http://[IP-address]/?user=[Profi|Operator]&password=[password]`

e.g.

`http://173.194.35.23/?user=Profi&password=goodPassword`

The following screen is displayed when the device is activated:




Click on the value to change the unit.

- Parts/ s → Parts/min → Parts/h
- OK (Parts → Percentage)
- NOK (Parts → Percentage)




Click on the picture to access the *Settings*.

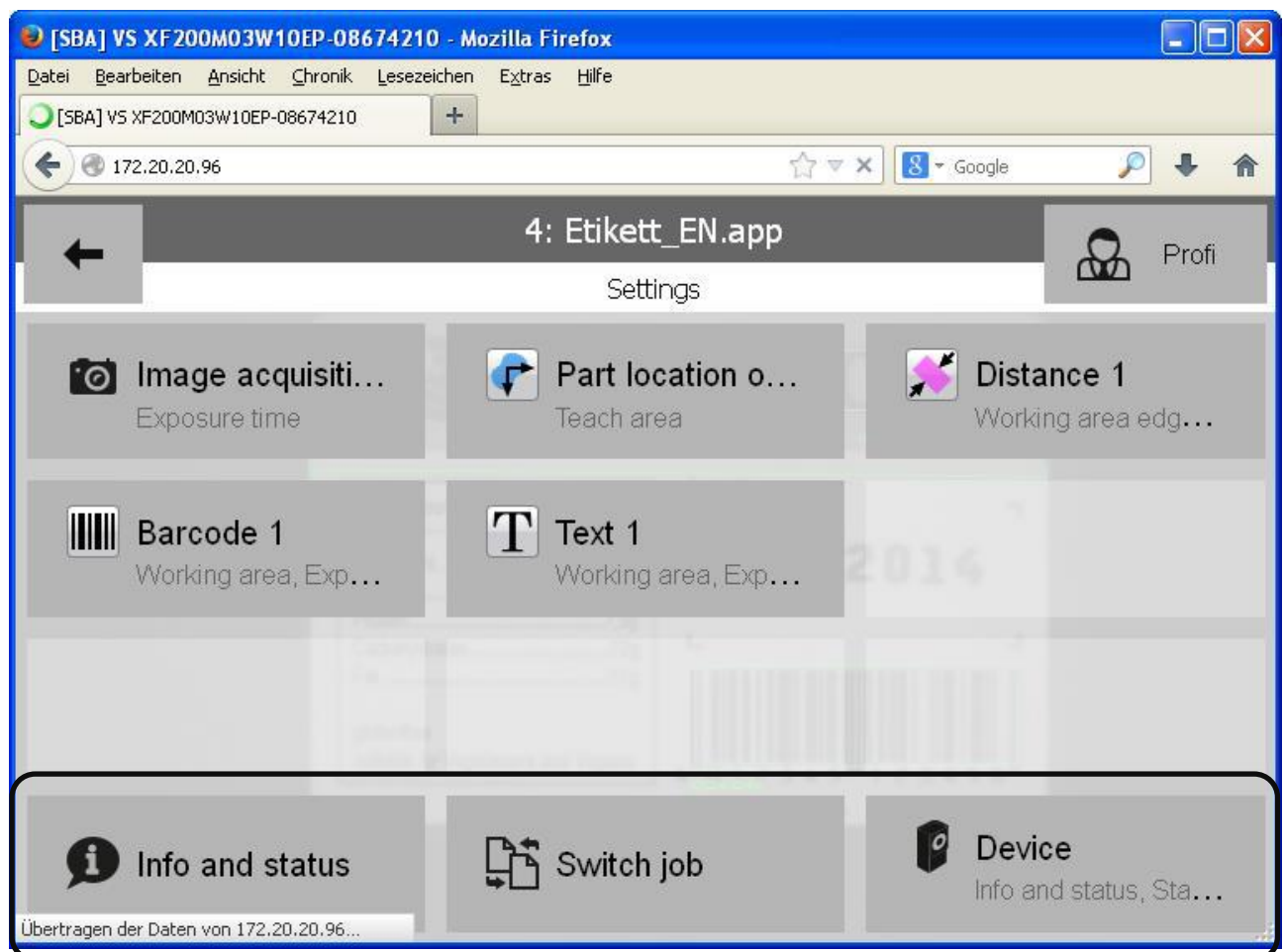
14.3 Device specific functions

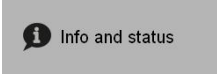




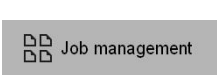


The device specific functions that can be operated via the web interface are described below.


	<p>NOTE</p> <p>You can set the availability of settings options and the corresponding rights through: <i>Device</i> → <i>Device settings</i> → <i>Configure web interface</i>.</p>
---	---

Navigation

		
Back to start view	User profile (Only shown when user profiles are activated)	



Icon	Content
	<ul style="list-style-type: none"> • Device name • Device state • Device type • Firmware version • Serial number of the device
	<ul style="list-style-type: none"> • Name of job currently processing • Total number of checked parts • Number of parts marked good (OK) • Number of parts marked bad (NOK) • Number of alarms • All feature checks for the job with results (Number of OK/NOK)
	<ul style="list-style-type: none"> • <i>Device</i> processing time in ms (Parts/s) • Processing time and results for current feature check
	<p>In this menu, you can change the active job. You can select any job on the device.</p> <p>The chosen job will activate immediately once selected.</p>
	<p>In this dialogue, you will see the currently saved defect images. You can save defect images in full resolution using your browser's context menu.</p>
	<p>Under job management you have the following options:</p> <ul style="list-style-type: none"> ▪ Copy job (Copy the job from one save location on the device to another) ▪ Delete job (Delete job from the <i>device</i>) ▪ Access job (Download a job from the device to your computer) ▪ Transfer job (Transfer a job from your computer to the device) ▪ Job on Power on (Set which job should be active when the <i>device</i> is switched on) ▪ Change job name (Change the name of a job on the <i>device</i>) ▪ Change job location (Save the job to a different location)
	<ul style="list-style-type: none"> ▪ Create backup on the PC ▪ Restore from the PC ▪ Create on the FTP server ▪ Restore from the FTP server
	<p>You can change the language here.</p> <p>Once the language is selected, you can make sure this language is always used by ensuring Device → Device settings → <i>Configuration</i> → <i>Web interface / Language settings functions / Save selection via web interface</i> is ticked.</p>

 Device	Device-specific functions (provides access to all device-specific functions via an additional menu level.)
--	--

14.4 Job specific functions

The job specific functions that can be used via the web interface are described below. Corresponding changes to the job are adopted and effective immediately.

The majority of feature checks support external teach-in, which can be triggered in the web interface by reconfiguring using the *Teach* button.

External teach-in must be activated during configuration of the relevant feature check in the *Application Suite*.

NOTE




You can set the availability of settings options and the corresponding rights for the feature check under:

Configure interface → *Web interface* tab

Navigation


Back	Apply settings and go back	Cancel	Display the live image if image acquisition is controlled via triggers	Trigger external teach-in

NOTE



The external teach-in triggered using the *Teach* button can also no longer be cancelled using the *Cancel* button!

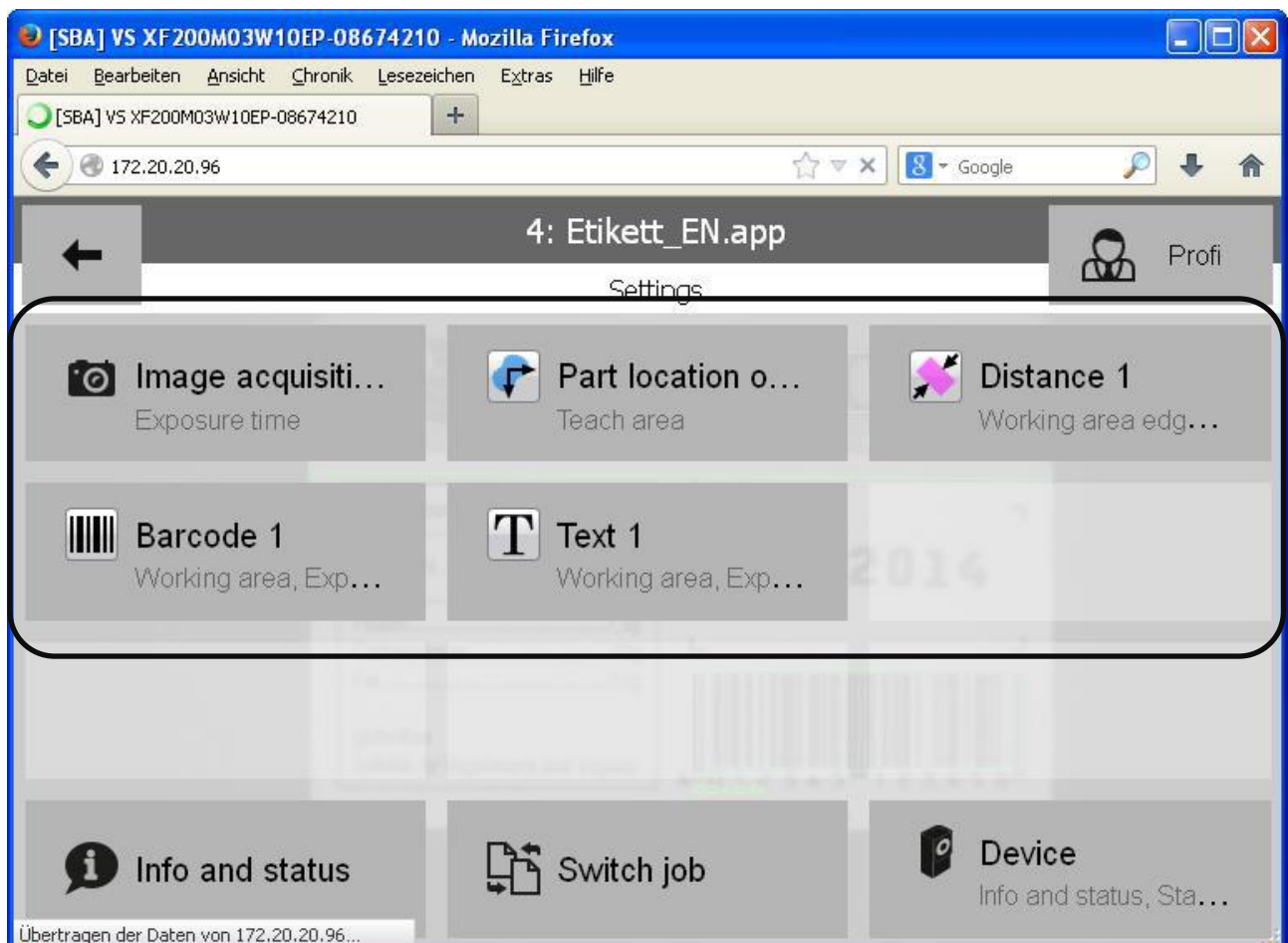
ATTENTION!




The live image function puts the device into "free running" mode, i.e. it runs without the external trigger signal. Please be aware of the effects this may have on later processes.

The user level required to access the live image display can be configured under:


Device settings → *Configuration* → *Web interface/Functions*







14.4.1 Image acquisition







Function	Icon	Adjustable parameters
Image acquisition		<ul style="list-style-type: none"> • Exposure time • Amplification • Edge sharpness • Gamma correction

14.4.2 Part location




	<p>NOTE</p> <p>The web interface does not support chained position tracking.</p>
---	---










Function	Icon	Adjustable parameters
Part location on contours		<ul style="list-style-type: none"> • Teach area • Search area • Conformity • Contrast • Maximum rotation • External Teach
Part location on edges		<ul style="list-style-type: none"> • Field of view edge A • Field of view edge A2 • Field of view of edge B
Part location on circle		<ul style="list-style-type: none"> • Field of view circle • Field of view edge for rotation
Part location on text line		<ul style="list-style-type: none"> • Field of view • Conformity

14.4.3 Geometry






Function	Icon	Adjustable parameters
Distance		<ul style="list-style-type: none"> • Field of view edge/circle A • Field of view edge/circle B • Distance • External Teach
Circle		<ul style="list-style-type: none"> • Field of view circle • Distance to the centre • Circle diameter • Roundness • External Teach
Angle		<ul style="list-style-type: none"> • Field of view edge A • Field of view edge B • Angle of the corner • External Teach
Count edges		<ul style="list-style-type: none"> • Field of view edges • Number of edges • External Teach
Point position		<ul style="list-style-type: none"> • Field of view • Rotation • Position X • Position Y • External Teach
Edge characteristics		<ul style="list-style-type: none"> • Field of view • Number of distances


14.4.4 Feature comparison

Function	Icon	Adjustable parameters
Count contour points		<ul style="list-style-type: none"> • Field of view • Number of contour points • External Teach
Contour comparison		<ul style="list-style-type: none"> • Field of view • Conformity • Tolerance • External Teach
Color identification		<ul style="list-style-type: none"> • Field of view • Color deviation (in ΔE)

Brightness		<ul style="list-style-type: none"> • Field of view • Brightness • External Teach
Contrast		<ul style="list-style-type: none"> • Field of view • Contrast • External Teach
Area size		<ul style="list-style-type: none"> • Field of view • Area • Color • Binary threshold • External Teach
Area size (color)		<ul style="list-style-type: none"> • Field of view • Area • Target color
Color positioning		<ul style="list-style-type: none"> • Fields of view • Target color
Count areas		<ul style="list-style-type: none"> • Field of view • Number of areas • Color • Binary threshold • Areas filter: Minimum • Areas filter: Maximum • External Teach
Count areas (color)		<ul style="list-style-type: none"> • Field of view • Number of areas • Areas filter: Minimum • Areas filter: Maximum • Target color
Pattern comparison		<ul style="list-style-type: none"> • Field of view • Deviation
Pattern comparison (color)		<ul style="list-style-type: none"> • Field of view • Deviation

14.4.5 Identification

Function	Icon	Adjustable parameters
Barcode		<ul style="list-style-type: none"> • Field of view • Expected code • Type of code • Parameter set • Bar width: Minimum • Bar width Maximum • Bar height: Minimum • Polarity • Minimum contrast • Rotation tolerance • External Teach
Barcode (color)		<ul style="list-style-type: none"> • Field of view • Expected code • Type of code • Parameter set • Bar width: Minimum • Bar height: Minimum • Polarity • Minimum contrast • Rotation tolerance
Matrix code		<ul style="list-style-type: none"> • Field of view • Expected code • Type of code • Parameter set • Polarity • Minimum contrast • Recognition • External Teach
Matrix code (color)		<ul style="list-style-type: none"> • Field of view • Expected code • Type of code • Parameter set • Polarity • Minimum contrast • Recognition
Text		<ul style="list-style-type: none"> • Field of view • Expected • Mode • Color • Threshold • Change character density • External Teach

Text (color)		<ul style="list-style-type: none">• Field of view• Expected code• Type of code• Parameter set• Polarity• Minimum contrast• Recognition
--------------	---	--

14.5 Functions selectable via the address bar

14.5.1 Language selection

The web interface will automatically launch in the same language as your operating system. However, you can change the language via the address bar of the browser.

Web interface in German:

```
http://[IP-address]/?lang=de
```

Web interface in English:

```
http://[IP-address]/?lang=en
```

Web interface in French:

```
http://[IP-address]/?lang=fr
```

Web interface in Spanish:

```
http://[IP address]/?lang=es
```

Web interface in Chinese:

```
http://[IP-address]/?lang=zh
```

14.5.2 Scaling down the transferred image

To increase the image refresh rate in the web interface, you can scale down the image before transferring it (binning). The binning parameter can be combined with all of the other access options for the web interface.

Image in its original size

```
http://[IP-address]/?binning=none
```

Image scaled down to half of its original height and width (default setting)

```
http://[IP-address]/?binning=2x2
```

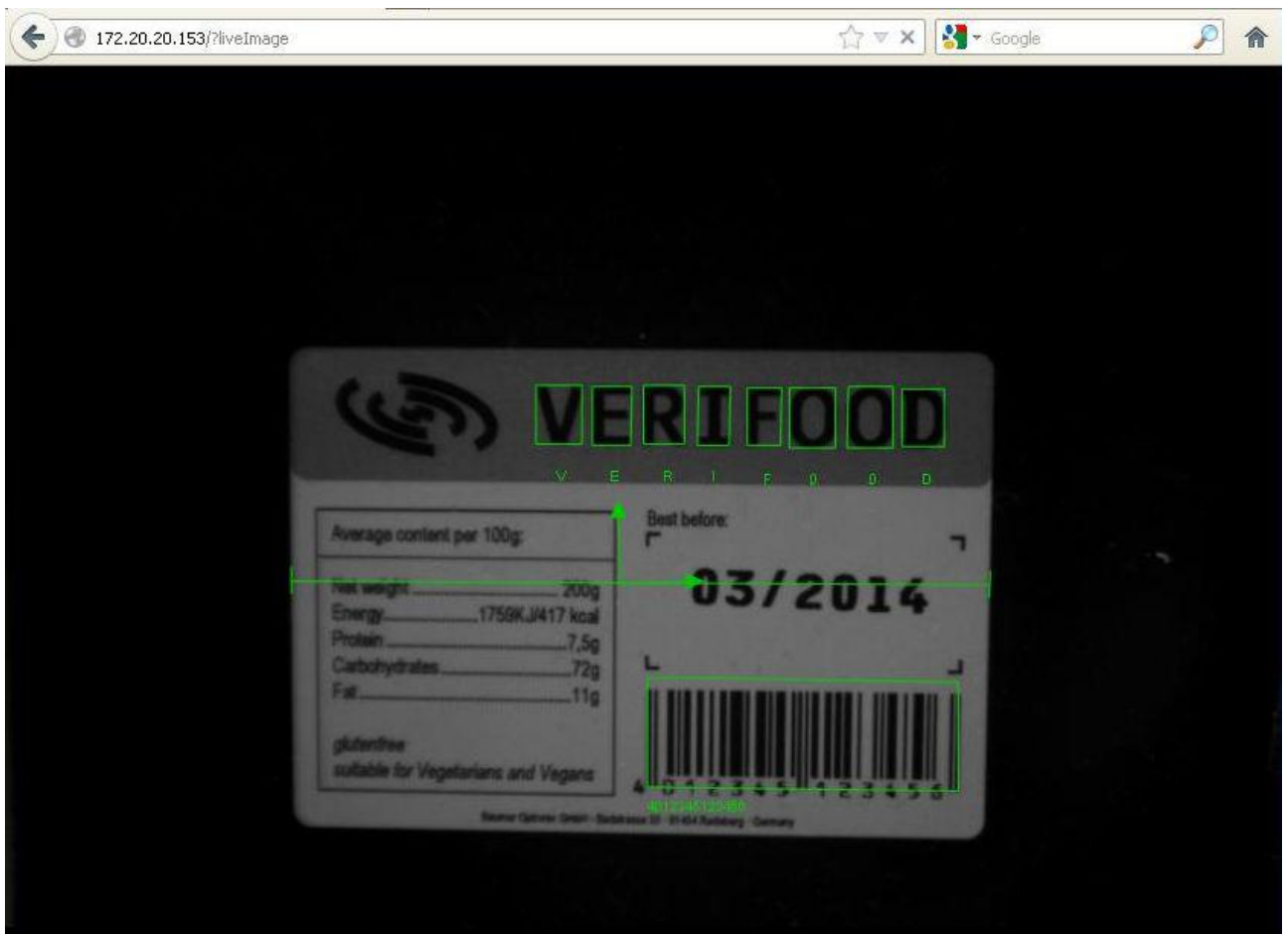
Image scaled down to quarter of its original height and width

```
http://[IP-address]/?binning=4x4
```

14.5.3 Live image

View the live image in the full browser window via the browser's address field. If the device is activated, graphical primitives will be displayed.

`http://[IP-Address]/?liveImage`



14.5.4 Defect images

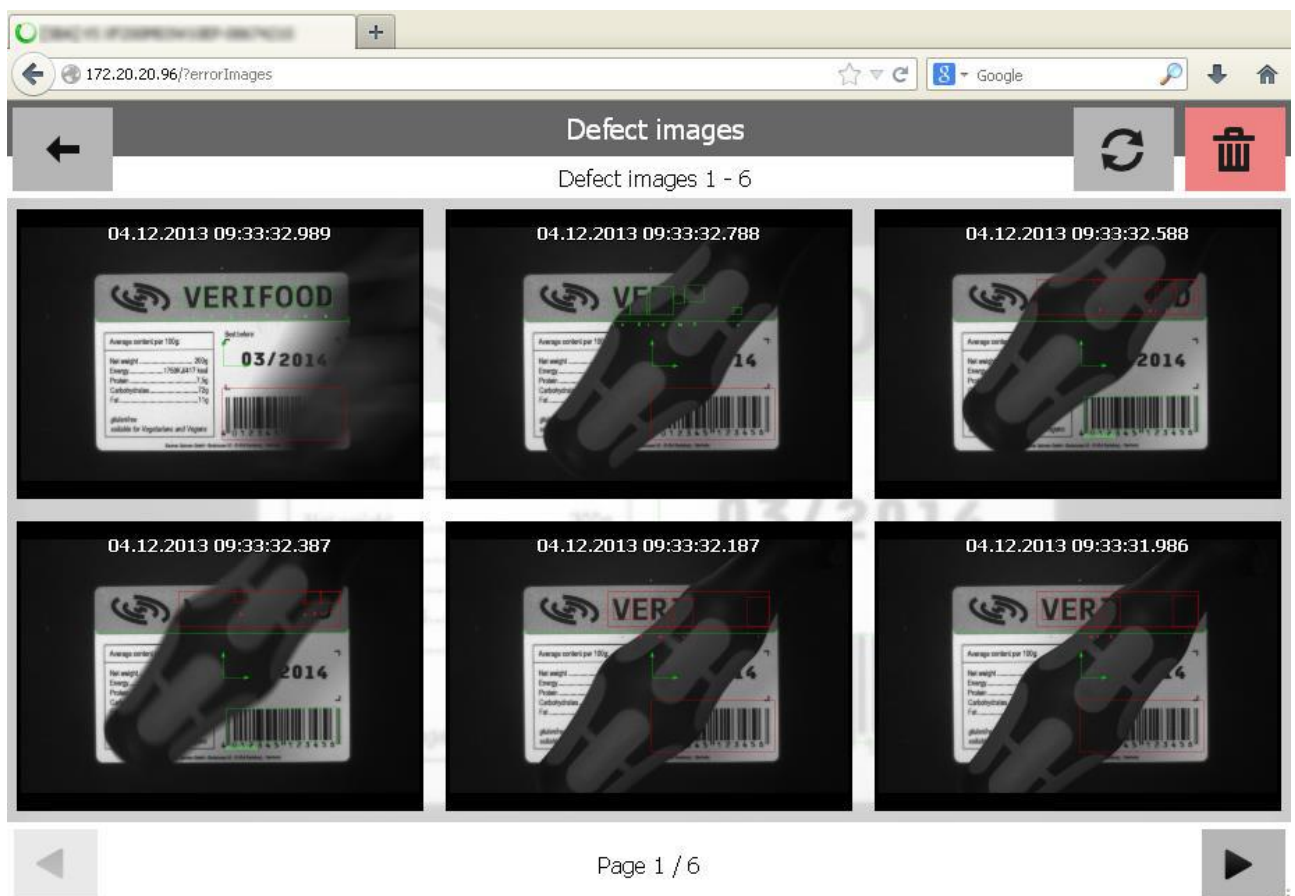
Access defect images via the browser's address field. You can save defect images in full resolution using your browser's context menu.

[http://\[IP-Address\]/?defectImages](http://[IP-Address]/?defectImages)

other access options:

[http://\[IP-Address\]/?errorImages](http://[IP-Address]/?errorImages)

	
update defect images	delete defect images



14.5.5 Static images

You can access a single image without displaying the feature checks using the address field of the browser:

`http://[IP-Address]/live_image.bmp`



You can also display a single image showing the feature checks using the address field of the browser:

`http://[IP-Address]/live_image.bmp?results=1`



14.5.6 Setting the display screen

By default, the current image is refreshed as quickly as possible. If you want a constant image refresh rate, say to reduce network traffic, you can change this rate using a parameter on opening the web interface:

```
http://[IP-address]/?refreshTime=t
```

The cycle time t is specified in milliseconds. A value of 0 means that the images are to be transferred as quickly as possible.

If display errors result when using a fixed image refresh rate, please increase the cycle time value.

NOTE



It is possible that the device is transferring image data via the web interface while simultaneously being linked to an *Application Suite*. In this case, the image data are preferably transferred to the *Application Suite* with the image frequency on the web interface being correspondingly reduced.

You can check in the *Status* area whether the device is linked to an *Application Suite*.

15 Communication via the process interface (device-dependant)

This chapter provides an overview of the process interface of the device.

15.1 Process interface via TCP/UDP (device-dependant)

15.1.1 Configuration of the Ethernet interface

The device is integrated via the process interface using an Ethernet connection and pre-configured port 23 ("Telnet"). For this purpose, connect the device with your machine and set the parameters, in particular the configuration of the IP address, using the *Application Suite*.

You can change the parameters under: *Device* → *Device settings* → *Process interface*.

The following parameters are also required to control the logical transfer of the process data:

Parameters	Description	Values
Result	Time of result transfer	On request Continuous
Receive timeout	Maximum duration between two characters	10 – 2,000 ms
Connection timeout	Maximum time between two received commands	Deactivated 1 – 3,600s

The transfer of the datagrams can occur at two different times:

- The Vision Sensor transfers the datagrams *on request*, i.e. as a response to the command "GD". This mode is designated "*Polling mode*".
- The Vision Sensor transfers data *continuously* after each image has been transferred. This mode is designated "Continuous mode".

NOTE



The connection timeout will in principal (depending on the duration of the process) not be reset, or not be reset at the correct time, for the following commands:

- Command GB (backup of the device)
- Command GF (retrieve individual pieces of data from the device)
- Command GI (retrieve an image)

15.1.2 Protocol structure – Ethernet



After you have established a connection with the device via the set port, you can request data from the device or transfer commands. To do this, you may use the device protocol. This consists of a 2-byte command code followed by the parameters and the actual data.

The datagrams may also be terminated with the following control characters:

- <CR> (Hex: 0D, Escape sequence: \r)
- <LF> (Hex: 0A, Escape sequence: \n)
- <CR><LF> (Hex: 0D 0A, Escape-Sequence: \r\n)
- without

15.2 Process interface via RS485 (device-dependant)

You can communicate directly with the device via an RS485 connection.

15.2.1 Configuration of the RS485 interface

The integration of the device via the process interface is made with an RS485 connection. To do this, connect the device to your machine using the pins provided and configure the RS485 parameters using the *Application Suite*.

The following parameters are available with which the physical transfer is controlled:

Parameters	Description	Values
Baud rate	Transfer speed	9600, 38400, 57600, 115200, 230400 bps
Parity	Control of the parity bit	none, even, odd
Data bits	Number of bits per character	8
Stop bits	Number of stop bits as end code	1

The following parameters are also required to control the logical transfer of the process data:

Parameters	Description	Values
Device number	Address in the bus protocol	1 – 254
Protocol	Protocol type	Point-to-point Bus without checksum Bus with checksum
Result	Time of result transfer	On request Continuous
Receive timeout	Maximum duration between two characters	10 – 2,000 ms
Response delay	Duration between reception of a command and transmission of the response	Min: 0 – 2,000 ms Max: 500 – 10,000 ms

The transfer of the datagrams can occur at two different times:

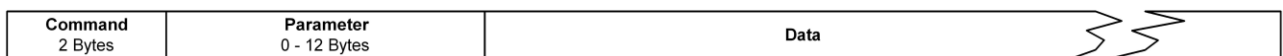
- The Vision Sensor transfers the datagrams on *request*, i.e. as a response to the command “GD”. This mode is designated “*Polling mode*”.
- The Vision Sensor transfers data *continuously* after each image has been transferred. This mode is designated “*Continuous mode*”.

15.2.2 Protocol structure – RS485

Two means of data transfer are available for the operation of the process interface:

- **Point-to-point protocol** This protocol is a shortened form of the bus protocol. It provides no means of addressing or verification with a checksum. This protocol is suitable when fast reaction times and low data volumes are concerned and transfers are verified by other means.
- **Bus-Protocol**
This protocol permits up to 254 devices to be accessed on one RS485 bus. Communication security is ensured by the use of synchronization signals and an optional checksum. The formatting of the data is so more strictly defined in this protocol, simplifying further processing.

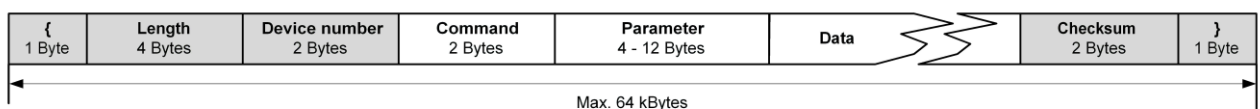
Point-to-point protocol:



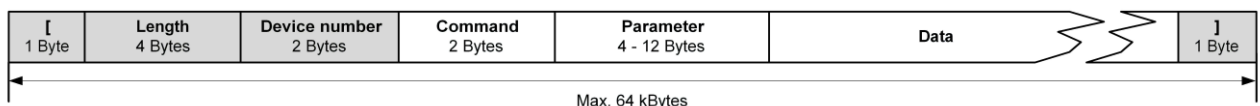
The point-to-point protocol consists of a 2-byte command designator followed by the parameters and the actual data. No control codes are used. Synchronization can be achieved using receive timeout.

Bus protocol:

With checksum

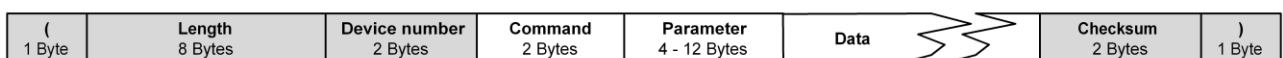


Without checksum

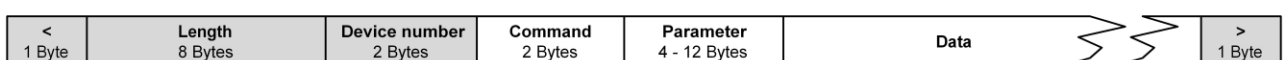


If you wish to transfer more than 65,535 bytes, e.g. jobs, you can extend the length to 8 bytes (sufficient for 2^{32} bytes). This changes the start and end codes:

With checksum



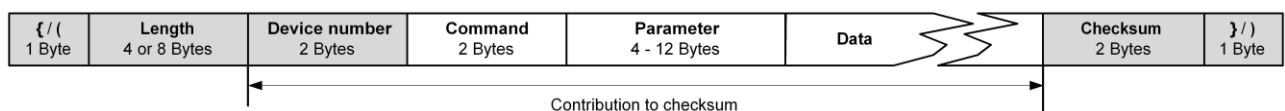
Without checksum



This protocol has a defined format:


Element	Size	Meaning
{ / [(/ <	1 byte	These codes are used for synchronization of the transfer. If you specify the length in 4 bytes, use the code "{“ (datagram with checksum) or “[“ (datagram without checksum). If you specify the length in 8 bytes, use the code "(“ (datagram with checksum) or ">“ (datagram without checksum).
Length	4 or 8 bytes ASCII-Hex	The length is equivalent to the number of transferred bytes from the device number (inclusive) to the end of the data, i.e. without any checksum. If the datagram exceeds a length of 65,535 bytes and you require 8 bytes for the length, you must use the start code “(“ or “<“.
Device number	2-byte ASCII hex	Each connected device has its own device number in a range from 1 („01“)-254 („FE“). Number 0 is reserved to address the bus master (PLC, PC ...). Device number 255 (“FF”) can be used to send commands to all connected devices simultaneously.
Command	2 byte	Command designation
Parameters	4-12 bytes	Each command has a parameter block at least 4 bytes in length, some of which remain unused.
data	variable	Optional data section, which may contain result or job data.
Checksum	2-byte ASCII hex	The checksum is produced by linking all characters beginning with the device number to the end of the data byte for byte with XOR. The checksum must only be specified if the start code “{“ or “(“ is used, otherwise this entry is omitted.
} /]) / >	1 byte	These codes are used as the end codes of the command blocks. If you specify the length in 4 bytes, use the code "}“ (datagram with checksum) or “]“ (datagram without checksum). If you specify the length in 8 bytes, use the code ")“ (datagram with checksum) or ">“ (datagram without checksum).

The following section is used to calculate the checksum:



If you use the RS485 bus protocol (device number: 6), the formats change as follows:

Example (Retrieve the last feature check)

	NOTE
	You can set the structure of datagrams for input and output via the process interface during job creation under <i>Configure interface</i> .

{	0	0	0	8	0	6	G	D	0	0	0	0	0	5	}
Start	Length	Device	Comman	unused	Checks	End									
	8 byte	No.	d		m										

Retrieve a result

{	0	0	1	6	0	6	R	D	0	0	0	E	S	T	P	,	P	,	0	1	2	5	E	T	7	5	}
Start	Length	Device	Respon	Length	Start	Result		Result	Brightnes	End	Checks	End															
	22 byte	No.	se	14 byte	data		Intensity 1		s	data	m																
									Intensity																		
									1																		

Response datagram

15.3 General Information

15.3.1 General description of data formats

It is important to distinguish between primitive data types (integers, floats, text) and composite data types (integer points, float points, lists) as well as the format of the corresponding data type (ASCII-dec, binary, ASCII-2 decimal places).

15.3.1.1 Integer

This data type is a whole number value and can also be negative.

Example: 234

Format	Text representation	Transferred value (process interface)
ASCII-Hex	"EA"	\45 \41
ASCII-Dec	„234“	\32 \33 \34
Binary	cannot be represented	\00 \00 \00 \EA

15.3.1.2 Float

This data type is a floating value and can also be negative.

Example: 10.02

Format	Text representation	Transferred value (process interface)
ASCII (2 decimal places)	„10.02“	\31 \30 \2E \30 \32
ASCII (Exponent)	„+1.002E+01“	\2B \31 \30 \30 \32 \45 \2B \30 \30 \31
Decimal	„10“	\31 \30
Binary (Little Endian)	cannot be represented	\EC \51 \20 \41
Binary (Big Endian)	cannot be represented	\41 \20 \51 \EC

15.3.1.3 Text

This data type can contain both printable and non-printable characters.

Example: "MHD"

Format	Text representation	Transferred value (process interface)
ASCII	"MHD"	\4D \48 \44
Binary	"MHD"	\4D \48 \44

15.3.1.4 Composite data type: Integer

This composite data type is formed of two integer values, the x-coordinate and the y-coordinate.

Available format: Analogue integer

Display: x-coordinate <separator> y-coordinate

Example: Value: (234, 123), Separator: „;“

Format	Text representation	Transferred value (process interface)
ASCII-Hex	“EA;7B“	\45 \41 \3B \37 \42
ASCII-Dec	„234;123“	\32 \33 \34 \3B \31 \32 \33
Binary	cannot be represented	\00 \ 00 \00 \EA \3B \00 \ 00 \00 \7B

15.3.1.5 Composite data type: Float-Point

This composite data type is formed of two float values, the x-coordinate and y-coordinate.

Available format: Analogue float

Display: x-coordinate <separator> y-coordinate

Example: Value: (234.02, 123.03), Separator: „;“

Format	Text representation	Transferred value (process interface)
ASCII (2 decimal places)	„234.02;123.03“	\32 \33 \34 \2E \30 \32 \3B \31 \32 \33 \2E \30 \33
ASCII (Exponent)	“+2.3402E+02;1.2303E+02“	\2B \31 \30 \30 \32 \45 \2B \30 \30 \31
Decimal	„234;123“	\31 \30
Binary (Little Endian)	cannot be represented	\1F \05 \6A \43 \3B \5C \0F \F6 \42
Binary (Big Endian)	cannot be represented	\43 \6A \05 \1F \3B \42 \F6 \0F \5C

15.3.1.6 Composite data type: List

This composite data type is a list of values of arbitrary type.

Available format: analogue used data type

Represented as: number <separator> <1. value corresponding data type> <separator><2. Value corresponding data type><separator>...<separator><last value corresponding data type>


Example: (data type integer):

Values: (123,234,245), Separator: „,“

Format	Text representation	Transferred value (process interface)
ASCII-Hex	„03;7B;EA;F5“	\30 \33 \3B \37 \42 \3B \45 \41 \3B \46 \35
ASCII-Dec	„3;123;234;245“	\33 \3B \31 \32 \33 \3B \32 \33 \34 \3B \32 \34 \35
Binary	cannot be represented	\00 \00 \00 \03 \3B \00 \00 \00 \7B \3B \00 \00 \00 \EA \3B \00 \00 \00 \F5

15.3.2 Numeric values in commands

Various commands require numeric values as parameters or return numeric values. For example, when switching the current job, the corresponding job number must be specified and the new job number is returned in the status datagram.



NOTE

Numerals are always entered as ASCII Hex information in the command data. Observe that the Hex values must be specified in upper case letters!

For example, the Hex numbers below result from the following values:

Value	2-byte ASCII hex	4-byte ASCII hex
1	01	0001
10	0A	000A
100	64	0064
255	FF	00FF
1000	-	03E8

15.3.3 Conversion Table Decimal ↔ Hexadecimal ↔ Character

Dec	Hex	Char	Dec	Hex	Char	Dec	Hex	Char	Dec	Hex	Char
00	00	NUL	32	20	SP	64	40	@	96	60	`
01	01	SOH	33	21	!	65	41	A	97	61	a
02	02	STX	34	22	"	66	42	B	98	62	b
03	03	ETX	35	23	#	67	43	C	99	63	c
04	04	EOT	36	24	\$	68	44	D	100	64	d
05	05	ENQ	37	25	%	69	45	E	101	65	e
06	06	ACK	38	26	&	70	46	F	102	66	f
07	07	BEL	39	27	'	71	47	G	103	67	g
08	08	BS	40	28	(72	48	H	104	68	h
09	09	HT	41	29)	73	49	I	105	69	i
10	0A	LF	42	2A	*	74	4A	J	106	6A	j
11	0B	VT	43	2B	+	75	4B	K	107	6B	k
12	0C	FF	44	2C	,	76	4C	L	108	6C	l
13	0D	CR	45	2D	-	77	4D	M	109	6D	m
14	0E	SO	46	2E	.	78	4E	N	110	6E	n
15	0F	SI	47	2F	/	79	4F	O	111	6F	o
16	10	DLE	48	30	0	80	50	P	112	70	p
17	11	DC1	49	31	1	81	51	Q	113	71	q
18	12	DC2	50	32	2	82	52	R	114	72	r
19	13	DC3	51	33	3	83	53	S	115	73	s
20	14	DC4	52	34	4	84	54	T	116	74	t
21	15	NAK	53	35	5	85	55	U	117	75	u
22	16	SYN	54	36	6	86	56	V	118	76	v
23	17	ETB	55	37	7	87	57	W	119	77	w
24	18	CAN	56	38	8	88	58	X	120	78	x
25	19	EM	57	39	9	89	59	Y	121	79	y
26	1A	SUB	58	3A	:	90	5A	Z	122	7A	z
27	1B	ESC	59	3B	;	91	5B	[123	7B	{
28	1C	FS	60	3C	<	92	5C	\	124	7C	
29	1D	GS	61	3D	=	93	5D]	125	7D	}
30	1E	RS	62	3E	>	94	5E	^	126	7E	~
31	1F	US	63	3F	?	95	5F	_	127	7F	DEL

Example: Command GB – access device backup

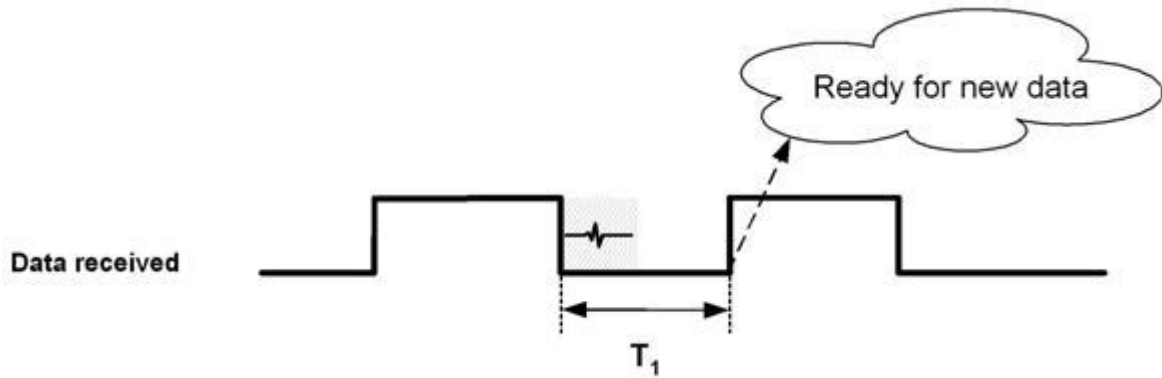
Command

Char	G	B	0	0	0	0
Dec	71	66	48	48	48	48
Hex	0x47	0x42	0x30	0x30	0x30	0x30

Response

Char	R	B	0	0	0	0	0	0	0	4	F	6	1	6	...
Dec	82	66	48	48	48	48	48	48	48	52	70	54	49	54	data
Hex	0x52	0x42	0x30	0x30	0x30	0x30	0x30	0x30	0x30	0x34	0x46	0x36	0x31	0x36	

15.3.4 Receive timeout

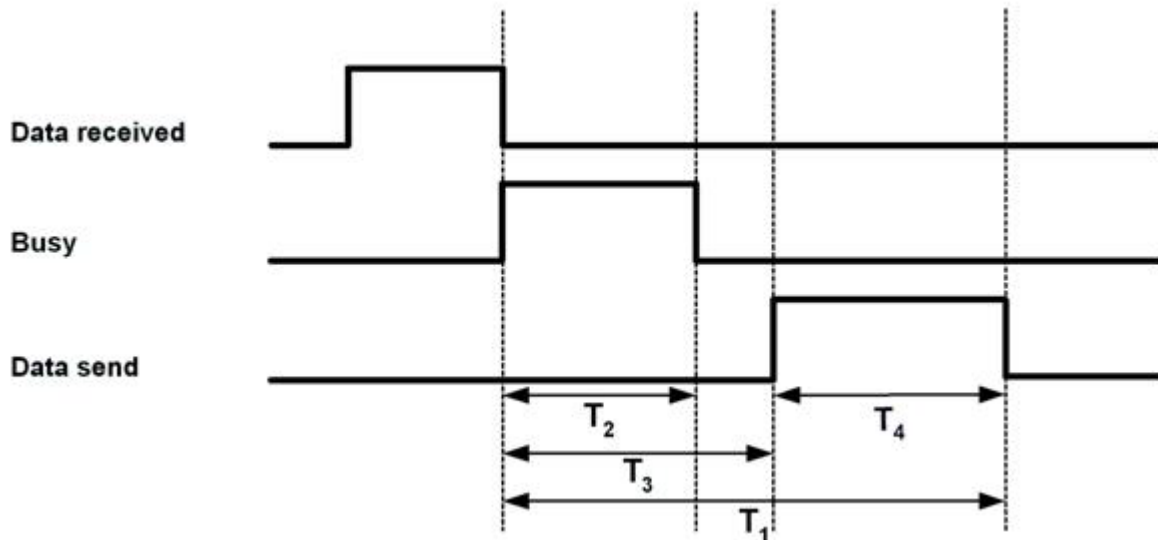


Signal	Duration	
	min.	max.
Receive timeout T_1	10 ms	2000 ms

If errors occur in the communication, receiving is terminated after a defined time. The data received to this point is then discarded. The possible error causes may be:

- The cable was unplugged or mechanically damaged during the transfer.
- Transmission of the data was prematurely terminated due to a technical fault.
- An error occurred in the transfer of the length information, so that the information is incorrectly transferred. The device then presumes an incorrect overall length of the data.

15.3.5 Response delay



Signal		Duration	
		min.	max.
Response time T_1 No further commands must be transferred during this time!		0 ms	max. $\{ T_2, T_3 \} + T_4$
Reaction time T_2	Ethernet	1 ms	5 ms
	RS485 (device-dependant)	1 ms	5 ms + 2.5 ms per 128 bytes of data
Response delay T_3		T_2	10,000 ms
Transfer time T_4		Dependent on the transfer parameters and the length of the data	

The transfer of the data begins not before time T_2 or the value set by the user.

If the time of the maximum response delay is exceeded without data being transferred, the possible response is discarded and you can transfer further commands.

Please observe that the received command will be processed in any case, even if no response datagram has been transferred due to the elapse of the maximum response time! For example, it is possible that this time could be exceeded when switching the active job. In this case, you will receive no confirmation, although the active job has been changed. If necessary, query the device status if you have received no confirmation.

15.4 Available commands for TCP / UDP / RS485

15.4.1 CS command –reset statistics

This function enables you to reset the statistics for individual jobs.

Example

Structure of the command PLC → device						
Command		Parameters				
C	S	0	0	0	0	
Clear Statistics		4-byte ASCII hex Job number 0000 = active job 0001 – 0010 = Job number 1-16 0011 – 00FF = invalid				

Structure of the Response PLC ← device						
Response						
R	C	0	0	0	0	
Response Statistics Cleared		4-byte ASCII hex Job number 0000 = active job 0001 – 0010 job number 1-16 0011 – 00FF = invalid				

15.4.2 Command GB – access device backup

This function enables you to access a backup of the device with firmware or the job as well as the device settings.


Example

Structure of the command PLC → device					
Command		Parameters			
G	B	0	0	0	0
Get Backup		0000 = Backup with firmware 0001 = Only jobs and device settings			

Structure of the Response PLC ← device														
Response														
R	B	0	0	0	0	0	0	0	4	F	6	1	6	...
Response Backup		4-byte ASCII hex Parameters of the GB-command				8 Byte ASCII-Hex data length (32bit) For errors, the length is 0						data		
		Error messages:												
		F001 = Device is not deactivated												
		F004 = Backup has already been called												
		F008 = Password protection activated												

15.4.3 GD command – retrieve last result

This function enables you to retrieve the result of the last feature check.

	<p>NOTE</p> <p>You can set the content of the datagram for output via the process interface during job creation under <i>Configure interface</i> → <i>Output process interface</i>.</p>
---	--

Example

Structure of the command PLC → device		
Command		Parameters
G	D	
Get Data		none

Structure of the Response PLC ← device						
Response						
R	D	0	0	0	0	...
Response Data		4-byte ASCII hex Length of the result data			data	

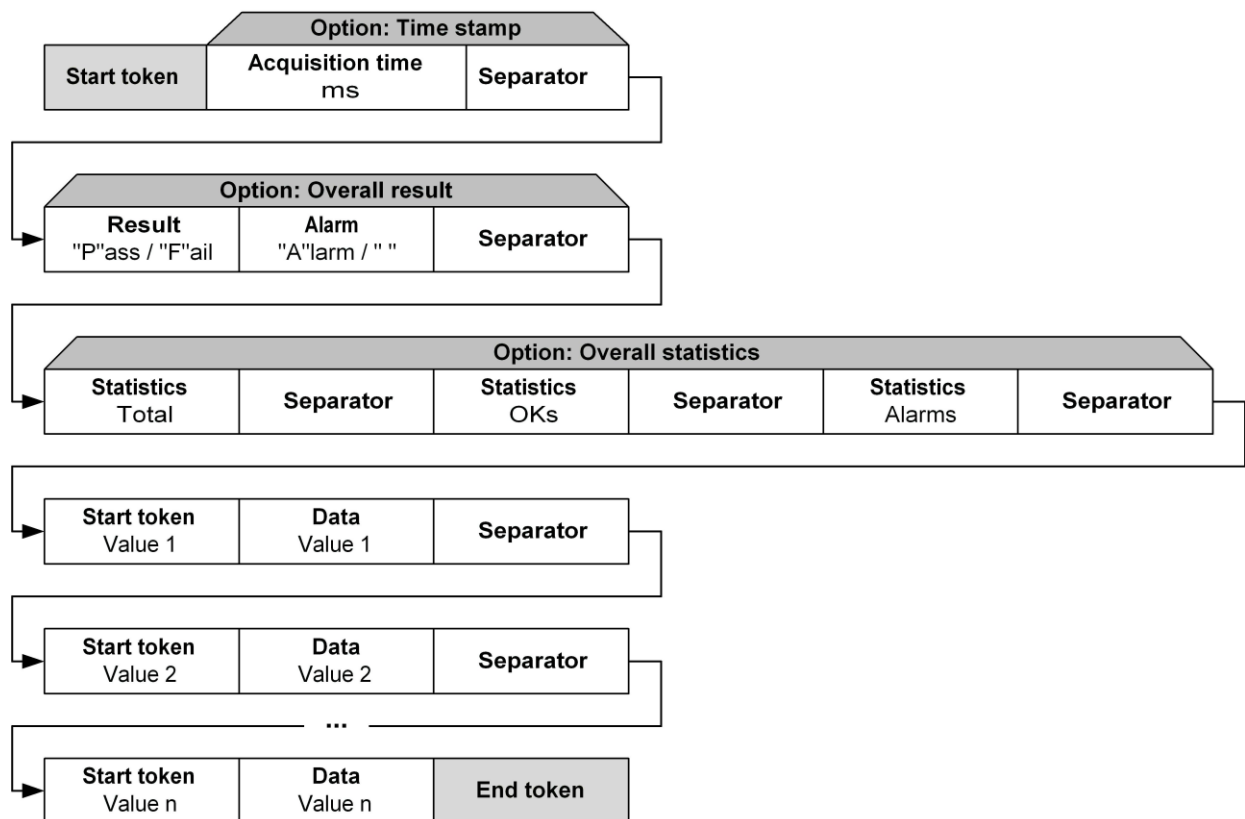
Parameters of the “RD” datagram response

The datagram contains the results of the last image analysis.

i

NOTE

You can set the content of the datagram for output via the process interface during job creation under *Configure interface* → *Output process interface*.



The time stamp in the datagram consists of 8 ASCII characters which specify the number of milliseconds since the system start of the device as a hexadecimal number. This value reverts from 4,294,967,295 ms to the value 0 ms after about 49.7 days.

Numbers in datagrams can be represented in different ways:

Representation	Description
ASCII decimal	Decimal notation of the number. Negative numbers are represented with "-". „123“, „78“, „89“, „-123“
ASCII hexadecimal	Hexadecimal notation of the number. Negative numbers are represented as a complement. “7B”, “4E”, “59”, FF85
Binary	Binary output of the number. Measured value 123: Characters output 0x00, 0x00, 0x00, 0x7B

i

NOTE

In ASCII decimal, the sign is included in the length. For example, if a length with the value of 4 is set, this results in a range of values from –999 to 9999.

Example for the transfer of result data

The configuration of the datagram is set as shown in the illustrations:

Active	Feature	Value	Start	Format	Min. length
<input checked="" type="checkbox"/>	Ergebnis	Total result			
<input checked="" type="checkbox"/>	Brightness 1	Result			0
<input checked="" type="checkbox"/>	Brightness 1	Brightness		ASCII Deci	0

The response from the device would be:

Structure of the Response PLC ← device													
Response													
R	D	0	0	0	E	S	T	P	,	P	,	0125	ET
Response Data		4-byte ASCII hex Length of the result data				Start data		Result		Result Brightness		Brightness End data	

Each feature check's result is represented within 1 Byte. The inspection result is described by "P" (result OK) or "F" (result NOK).

An interpretation of this datagram produces:

The overall result of the last image analysis was OK. In the field of view for the "brightness" feature check, the measured value is defined as 125. The individual result for this feature check was also OK.

Each feature check can produce a range of parameters, which you can find in the description of the current feature check.

15.4.4 GF command – access individual data on the device

This function enables you to access individual data on the device.

Example

Structure of the command PLC → device						
Command		Parameters				
G	F	0	0	0	0	
Get File		0000 = List of all jobs 01nn = Retrieve job (nn 2 byte ASCII-Hex Job number) 02nn = Call a job using the job name (nn:2-byte ASCII hex length of the file name + file name) 0300 = Access Logging				

Structure of the Response PLC ← device																
Response																
R	F	0	0	0	0	0	0	0	0	0	0	F	1	2	3	...
Response File		4 bytes ASCII-hex, mirrored parameters of the GF request		2 bytes ASCII hex: Error code 00 = no error occurred 01 = is not in Set-up- or IDLE- mode 02 = File not found 04 = last file still being retrieved FF = internal error			2 bytes ASCII hex Reserved		8 bytes ASCII hex Length of the following data				data			

15.4.5 GI command – access an image (only via Ethernet)

This function enables you to access live images and defect images with and without the field of view.

Example

Structure of the command PLC → device					
Command		Parameters			
G	I	0	0	0	0
Get Image	2-byte ASCII hex 00 = Live image 01 = Live image with field of view 80 = Fault image 81 = Fault image with field of view	2 byte ASCII hex image number 00 = Last image, 01 = penultimate image, 02 = ...			

Structure of the Response PLC ← device														
Response														
R	I	0	0	0	0	0	0	0	4	F	6	1	6	...
Response Image	2-byte ASCII hex 00 = Live image 01 = Live image with field of view 80 = Fault image 81 = Fault image with field of view	2-byte ASCII hex Image number		8-byte ASCII hex Length of the image data				Image data in the format BMP						

15.4.6 GM command – access information about the device

This function enables you to access information about the connected device.

Example

Structure of the command PLC → device										
Command		Parameters								
G	M	0	0	4	0					
Get Model Information		4 byte-ASCII hex Access single elements 0001 = Device type 0002 = MAC address 0004 = Serial number 0008 = Firmware version 0010 = Hardware version 0020 = Device name 0040 = Manufacturer 0000 = All (in the order given above)								

Structure of the Response PLC ← device										
Response										
R	M	0	0	4	0	0	0	1	4	ipf electronic gmbh
Response Model Information		4-byte ASCII hex mirrored parameters of the GM request				4 byte-ASCII hex For each element: Length of the result data				data

15.4.7 GP command – access the current configuration of the SP command


This function allows you to read out the current values that can be changed using the SP command (set parameters for feature checks).

This is useful, for example, if you wish to read out the expected value for the "Barcode" / "Matrix code" via the controller.

Example

Structure of the command PLC → device		
Command		Parameters
G	P	
Get Parameter		none

Structure of the Response PLC ← device														
Response														
R	G	0	0	0	8	1	5	.	0	2	.	1	4	
Response Get Parameter		4-byte ASCII hex Length of the result data				data The content of the data corresponds with the expected values currently set for the feature check e.g. a date, or a combination of expected values for different feature checks								

	<p>NOTE</p> <p>You can set the content of the datagram for output via the process interface during job creation under <i>Configure interfaces</i> → <i>Output process interface</i>.</p>
---	---

15.4.8 GS command – request status

This function enables you to access current status information for the device.

Example

Structure of the command PLC → device		
Command		Parameters
G	S	
Get State		none

Structure of the Response PLC ← device										
Response										
R	S	0	0	8	5	0	0	1	A	
Response State		4-byte ASCII hex Status				4-byte ASCII hex Number of the active job				

Parameters of the “RS” command – Current status information

The current status information consists of 8 characters, of which the first 4 characters describe various states in a bit mask and the other 4 characters contain the current job number.

Bits							
3	2	1	0	3	2	1	0
1. Status (ASCII)				2. Status (ASCII)			
Internal error	Backup OK	Backup Error	Backup Active	Acquisition Trigger possible	Job Update OK	Job Update Error	Job Update Active
3. Status (ASCII)				4. Status (ASCII)			
Mode Run Mode	Mode Test Mode	Mode Setup	Mode Recovery	Acquisition continuously	Acquisition External trigger	Protocol Continuous Mode	Protocol Polling Mode
1. Job number (ASCII)				2. Job number (ASCII)			
Number of active job							
3. Job number (ASCII)				4. Job number (ASCII)			
Number of active job							

When a job is being transferred via the process interface, the current status of this action can be queried by the PLC. The corresponding bit “Job update active” is set during the data transfer period. This bit remains set until the job has been completely transferred and stored or an error has occurred. The success of the action can then be assessed by the corresponding bits “Job update – OK” and “Job update – error”. These flags are retained until the next transfer of a job.

If the sensor is in *Activated* mode, the current job number is entered in the datagram. 0000 is entered here in all other operating modes.

Here are two examples of possible states of the device:

Character string	Meaning									
0 0 8 5 0 0 1 A	<table border="1"> <tr> <td>0</td> <td>0</td> <td>8</td> <td>5</td> </tr> <tr> <td>0 0 0 0 0 0 0 0 1 0 0 0 0 1 0 1</td> <td></td> <td></td> <td></td> </tr> </table>	0	0	8	5	0 0 0 0 0 0 0 0 1 0 0 0 0 1 0 1				Current inspection mode: <i>Activated</i> Acquisition: External trigger Protocol: Polling mode Active job: 26 (Hex: 1A)
0	0	8	5							
0 0 0 0 0 0 0 0 1 0 0 0 0 1 0 1										
0 0 2 9 0 0 0 0	<table border="1"> <tr> <td>0</td> <td>0</td> <td>2</td> <td>9</td> </tr> <tr> <td>0 0 0 0 0 0 0 0 0 0 1 0 1 0 0 1</td> <td></td> <td></td> <td></td> </tr> </table>	0	0	2	9	0 0 0 0 0 0 0 0 0 0 1 0 1 0 0 1				Current inspection mode: <i>Configuration</i> Acquisition: Continuous Protocol: Polling mode Active job: -
0	0	2	9							
0 0 0 0 0 0 0 0 0 0 1 0 1 0 0 1										

15.4.9 SJ command – change to a different job

This function enables you to change to a different job.

To use this function, you must first activate the option Command SJ via process interface in the device settings.

Example

Structure of the command PLC → device						
Command		Parameters				
S	J	0	0	1	A	
Switch Job	4-byte ASCII hex desired job number					

Structure of the Response PLC ← device										
Response										
R	S	0	0	8	5	0	0	1	A	
Response State	4-byte ASCII hex Status				4-byte ASCII hex Number of the active job					



NOTE

Further explanation of the parameters of the RS response can be found under “Request status (GS / RS)”.

15.4.10 SM command – change operating mode

This command enables you to change the operating mode for the device as well as the parameters for data exchange.

Example

Structure of the command PLC → device				
Command		Parameters		
S	M	M	R	
Switch Mode		2 byte-ASCII hex		
		Mode		
		<p>DC = Data transfer – Continuous Mode The result data is autonomously transferred via the process interface after each analysis in Activated mode. You must also set the "Activate outputs" parameter during job testing.</p> <p>DP = Data transfer – Polling Mode In <i>Activated</i> mode and in Configuration mode, the result data is only transferred after the GD command has been received.</p> <p>MR = Mode switch – <i>Modus Run</i> The device is activated. Data is only transferred autonomously if the Continuous mode is activated as described above.</p> <p>MS = Mode switch – <i>Configuration</i> mode The device is switched to Configuration No result data is transferred.</p>		
		For Ethernet only		
		<p>CC = Command delimiter – Carriage return Data packets from the process interface are terminated using <CR> (Hex: 0D, Escape sequence: \r)</p> <p>CL = Command delimiter – Line feed Data packets from the process interface are terminated using <LF> (Hex: 0A, Escape sequence: \n)</p> <p>CB = Command delimiter – Both carriage return + line feed Data packets from the process interface are terminated using <CR><LF></p> <p>CN = Command delimiter – No sequence Data packets from the process interface are not terminated using a sequence</p>		

Structure of the command PLC → device				
Command		Parameters		
S	M	M	R	
Switch Mode	2 byte-ASCII hex			
	Mode			
	For RS485 only			
	Point-to-point protocol	Bus protocol		
	PP	PP	Protocol mode – Point-To-Point Changes the employed protocol to point-to-point protocol	
PB	PB	Protocol mode – Bus without checksum Changes the used protocol to bus protocol without checksum		
PC	PC	Protocol mode – Bus with Checksum Changes the used protocol to bus protocol with checksum		

Structure of the Response PLC ← device										
Response										
R	S	0	0	8	5	0	0	1	A	
Response State	4-byte ASCII hex Status					4-byte ASCII hex Number of the active job				



NOTE

Further explanation of the parameters of the RS response can be found under “Request status (GS / RS)”.


15.4.11 SP command – set parameters for the feature checks

This function enables you to set the expected values for the feature checks.

The expected values are set temporarily and remain valid until the device is restarted or switches to configuration mode.


To save it long term, activate: *Device* → *Device settings* → *Job selection / Teach* → *Save changed parameters from external Teach or process interface command XX to device...*

NOTE

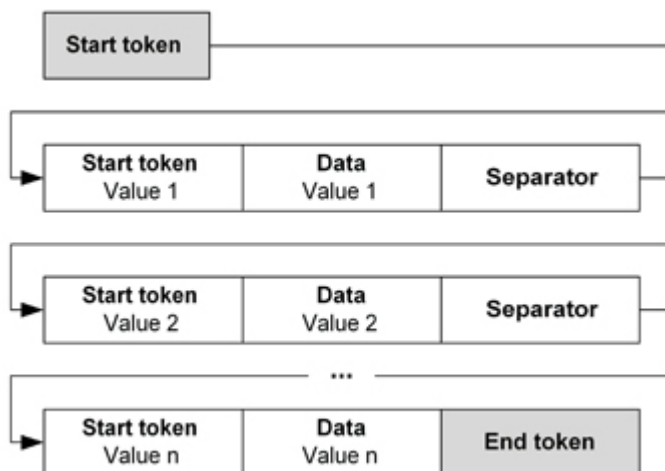


You can set the content of the datagram for output via the process interface during job creation under *Configure interface* → *Output process interface*.

NOTE



When setting the exposure time for the job, the "Camera ready" signal must be active before the next image can be acquired.



Example

Structure of the command PLC → device															
Command		Parameters													
S	P	0	0	0	8	1	7	.	0	3	.	2	0	1	4
Set Parameter		4-byte ASCII hex Length of the result data				data e.g. a date, or a combination of expected values for different feature checks									

Structure of the Response PLC ← device															
Response															
R	P	0	0	0	0	0	0	0	0	0	0	0	0	0	
Response Parameter		4-byte ASCII hex Status 0000 = OK 0001 = defective data in data packet 0002 = device not in RUN mode 0003 = value range exceeded 0004 = no datagram defined in job other = internal fault				4-byte ASCII hex Error position									

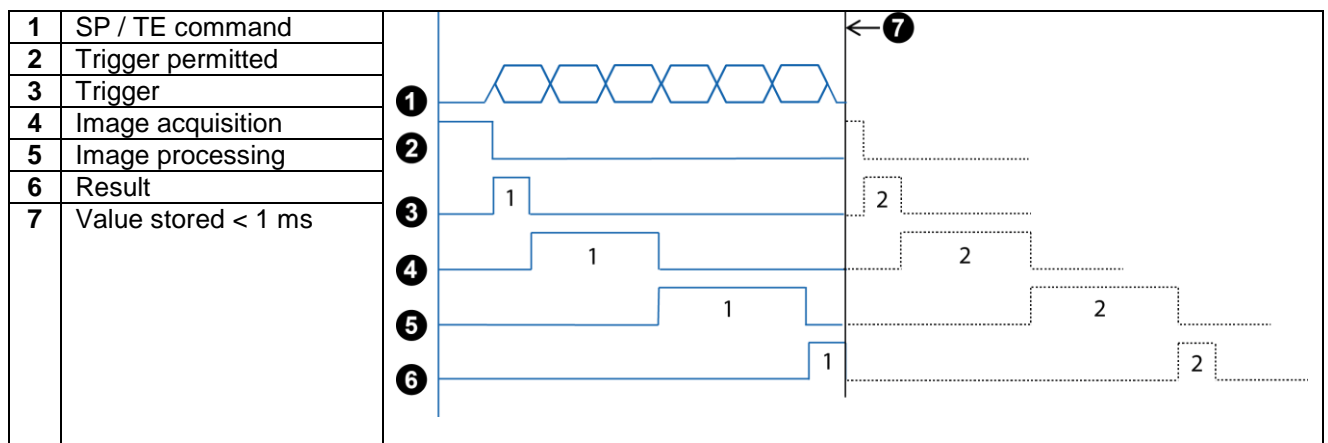
Timing diagram for SP and TE commands

The SP and TE commands can be sent at any time and are buffered. The system simultaneously sets a flag to prevent further images from being acquired.

This means that all processes currently running are completed before a new one is triggered.

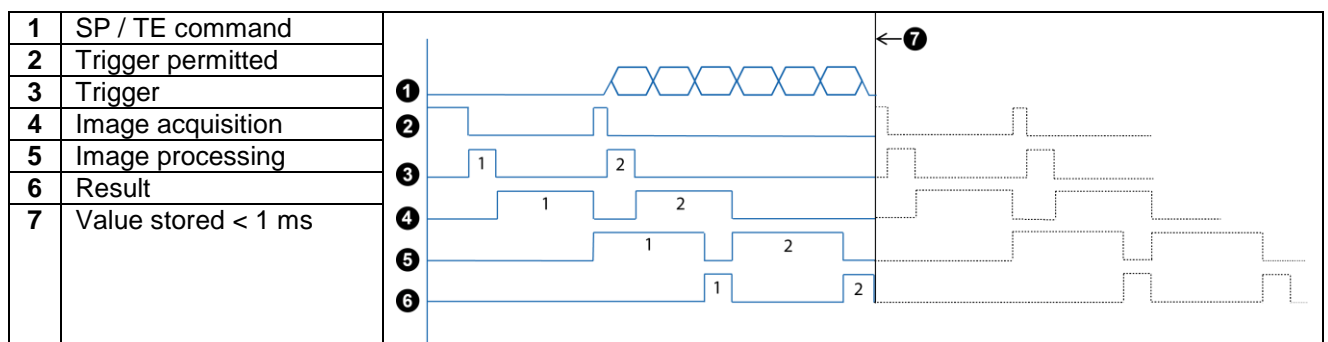
Example 1 (sequential processing)

All processes are completed up to result output 1. SP/TE then becomes effective.



Example 2 (overlapped, clocked processing)

The command comes after the second trigger → all processes up to trigger 1 and trigger 2 are completed, SP/TE become effective after result 2.



15.4.12 TE command – use next image for external teach

This function enables you to use the next image for an external teach-in. However, image acquisition will not be triggered.

The function is set temporarily and remains valid until the device is restarted or switches to configuration mode.

To save it long term, activate: *Device* → *Device settings* → *Job selection / Teach* → *Save changed parameters from external Teach or process interface command XX to device...*

Structure of the command PLC → device		
Command		Parameters
T	E	
TEach Image		none

Structure of the Response PLC ← device		
Response		
R	T	
Response Teach		

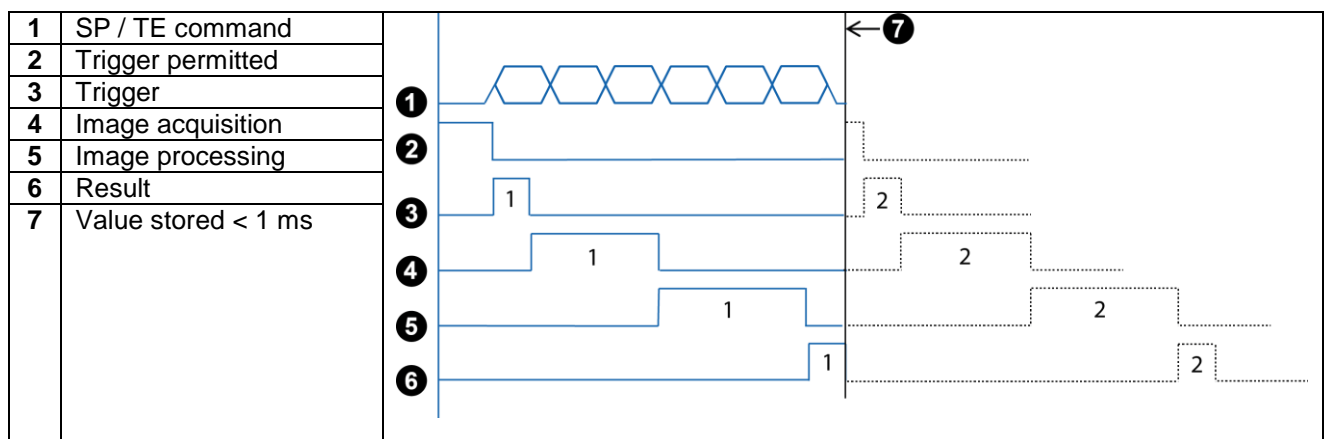
Timing diagram for SP and TE commands

The SP and TE commands can be sent at any time and are buffered. The system simultaneously sets a flag to prevent further images from being acquired.

This means that all processes currently running are completed before a new one is triggered.

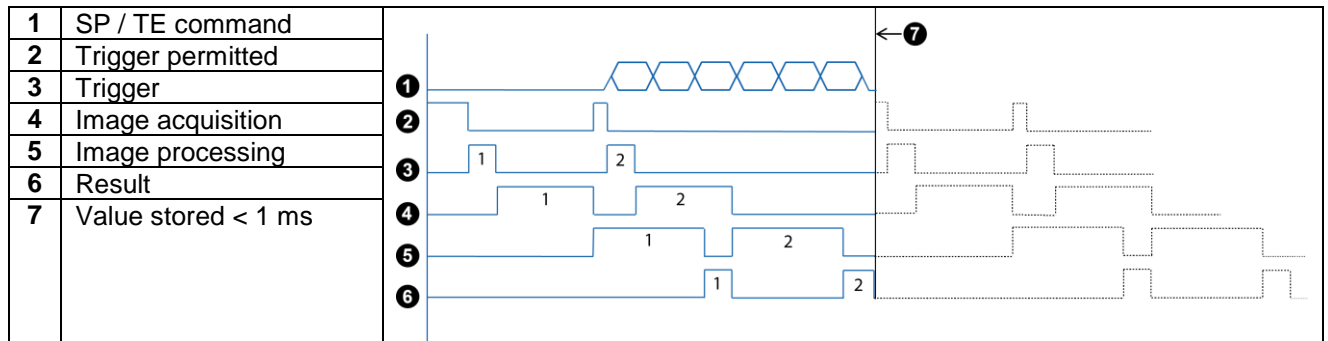
Example 1 (sequential processing)

All processes are completed up to result output 1. SP/TE then becomes effective.



Example 2 (overlapped, clocked processing)

The command comes after the second trigger → all processes up to trigger 1 and trigger 2 are completed, SP/TE become effective after result 2.



15.4.13 TR command – request image acquisition and response datagram

This function enables you to immediately trigger image acquisition and request a response datagram if required (the trigger delay remains in effect). The response datagram will only be sent if the result is automatically sent following image evaluation and if the data is defined.

Example

Structure of the command PLC → device		
Command		Parameters
T	R	
TRigger Image		none

Structure of the Response PLC ← device						
Response						
R	D	0	0	0	E	...
Response Data		4-byte ASCII hex Length of the result data			data	



NOTE

Further information on the composition of the datagram can be found using the command "Retrieve last result (GD / RD)".

15.4.14 TI command - trigger immediately

This function enables you to immediately trigger image acquisition and request a response datagram if required (any configured trigger delay is ignored). The response datagram will only be sent if the result is automatically sent following image evaluation and if the data is defined.

Example

Structure of the command PLC → device		
Command		Parameters
T	I	
Trigger Immediately		none

Structure of the Response PLC ← device						
Response						
R	D	0	0	0	E	...
Response Data		4-byte ASCII hex			data	
		Length of the result data				



NOTE

Further information on the composition of the datagram can be found using the command "Retrieve last result (GD / RD)".

15.4.15 TD command – request image acquisition and transfer data

This function enables you to immediately acquire an image and response datagram. The response datagram will only be sent if the result is automatically sent following image evaluation and if the data is defined.

Unlike with command TR, this function can be used to transfer a string with the trigger, for example the part number of the current item being checked. The device allows you to use this string in the file name for the image when saving it to an FTP server. This is an easy way to establish a connection between images and objects.

Example

Structure of the command PLC → device						
Command		Parameters				
T	D	0	0	0	0	...
Trigger Data		4-byte ASCII hex Length of the transferred string			Characters (0-255)	


Structure of the Response PLC ← device						
Response						
R	D	0	0	0	0	...
Response Data		4-byte ASCII hex Length of the result data			data	

A maximum of 156 characters is permitted in the data string (0-255).

15.4.16 UD command – transfer backup data (only for Ethernet)

This function enables you to transfer backup data to the device.

NOTE



The device must be restarted following use of the UD command and successful transfer of a backup, for example via the *VB0000* command.

Example

Structure of the command PLC → device	
Command	Parameters
U D	S 1 9 2 . 1 6 8 . 0 0 0 . 2 5 0
Update Device	IP Address S = static D = DHCP
	15 characters ASCII IP Address
	→

Parameters	
2 5 5 . 2 5 5 . 2 5 5 . 0 0 0	
15 characters ASCII	
Subnet mask	→

Parameters	
0 0 0 . 0 0 0 . 0 0 0 . 0 0 0	
15 characters ASCII	
Gateway	→

Parameters	
1 1	V S X F 2 0 0 M 1 0 W E - T E S T
2-Byte ASCII Hex Length of device name	Device name
	→

Parameters									
0	0	B	6	B	B	4	6	...	
8 byte ASCII hex Length of the following data								Data of the backup device	

NOTE

If using DHCP, you can set what happens following a DHCP timeout as follows:




- Use DHCP and in case of DHCP failure, use the last IP address
UDD000.000.000.000000.000.000000.000.000...
- or
UDD255.255.255.255000.000.000000.000.000...
- Use DHCP, set an alternative IP address
e.g. UDD192.168.000.250255.255.255.000000.000.000.000...
(In this case, the alternative IP address is 192.168.0.250)

The response datagram is only sent once the backup has been transferred and stored in full or an error occurs.

Structure of the Response PLC ← device				
Response				
R	U	0	0	
Response Update	2-byte ASCII hex 00 = received OK 01 = device not in SETUP mode 02 = invalid job number 03 = job could not be loaded 04 = job update still active 05 = invalid network settings 06 = invalid device name 07 = backup file device type not identical to the device 08 = user management is active 09 = device file is password protected 10 = file could not be opened for writing 11 = file write error 12 = incompatible backup 13 = only the firmware cannot be imported other = internal fault			

15.4.17 UJ command – transfer a new job

This function enables you to transfer a new job to the device.

	<p>NOTE</p> <p>Jobs cannot be renamed on the PC when using the UJ command for job transfers.</p>
---	---

Example

Structure of the command PLC → device															
Command		Parameters													
U	J	0	0	0	3	0	0	0	4	F	9	E	2	...	
Update Job		4 byte ASCII hex job number				8-byte ASCII hex Job size								Job as binary data	

Structure of the Response PLC ← device				
Response				
R	U	0	0	
Response Update	00 = received OK 01 = device not in SETUP mode 02 = invalid job number 03 = job could not be loaded 04 = job update still active 05 = invalid network settings 06 = invalid device name 07 = backup file device type not identical to the device 08 = user management is active 09 = device file is password protected 10 = file could not be opened for writing 11 = file write error 12 = incompatible backup 13 = only the firmware cannot be imported other = internal fault			

15.4.18 VB command – restart device

This function enables you to restart the device or put it into recovery mode. This command does not send a response.

Example

Structure of the command PLC → device					
Command		Parameters			
V	B	0	0	0	0
Vision Sensor ReBoot		4 byte ASCII hex 0000 = Restart FFFF = Recovery mode			

16 Cleaning

Due to its compact design, the device is characterized by almost maintenance-free operation.

When used for the intended purpose, it is possible that the device may need to be cleaned from time to time. Very clean optical surfaces (cover glass) are required for the consistent and reproducible operation of the device.

For cleaning, use a soft, lint-free cloth to clean the surface of the cover glass with a gentle pressure, without scratching.

To clean stubborn dirt, commonly available window cleaning agent is recommended.



ATTENTION!

Ensure that no residues of the cleaning agent or scratches remain on the glass. These can permanently damage the reproducibility of the results from the device.



ATTENTION!

As so many cleaning agents are available, we hope you understand that we cannot test every single one. Resistance to cleaning agents and areas of use depends upon the specific application.

Cleaning agents must be tested on a discreet area of the device under application conditions to evaluate if they are suitable.

Materials within the device with protection class IP 69K

Component, part	Material	Classification
Housing	Stainless steel 1.4404 (316L)	
Seal (housing)	polymerized silicone rubber (CAF)	FDA, BfR
Seal bonding agent (primer)	Silquest VS-142 (Silquest is a trademark of Momentive Performance Materials Inc.)	
Cover glass	PMMA	FDA, UL
Seal / adhesive (cover glass)	Silicone adhesive	FDA
Seals (O-rings)	Fluororubber (FPM)	FDA
Press-fitted optical fibre	Polycarbonate	
Sealing collar optical fibre	Epoxy resin	
Screw cover (rear side)	Silicone	FDA
Connector M12 / 12 pin	Stainless steel 1.4404 (316L)	

17 Technical data

17.1 Overview of feature checks

Feature checks	OC53922X	OC539320	OC53912X	OC53942X OC5394V0 OC53962X	OC53952X OC53972X	OC53962X color
Part location						
Part location on contours			360°	360°	360°	360°
Part location on edges				+	+	+
Part location on circle				+	+	+
Part location on text lines		+		+	+	+
Geometry						
Distance			+	+	+	+
Circle			+	+	+	+
Angle				+	+	+
Count edges				+	+	+
Point position				+	+	+
Edge characteristics				+	+	
Feature comparison						
Count contour points			+	+	+	
Count contour points (color)						+
Contour comparison		+	+	+	+	
Contour comparison (color)						+
Color identification						+
Brightness			+	+	+	
Contrast				+	+	
Area size				+	+	
Area size (color)						+
Color positioning						+
Count areas				+	+	
Count areas (color)						+
Pattern comparison				+	+	
Pattern comparison (color)						+
Identification						
Barcode	+	+			+	
Matrix code	+	+			+	
Text		+			+	

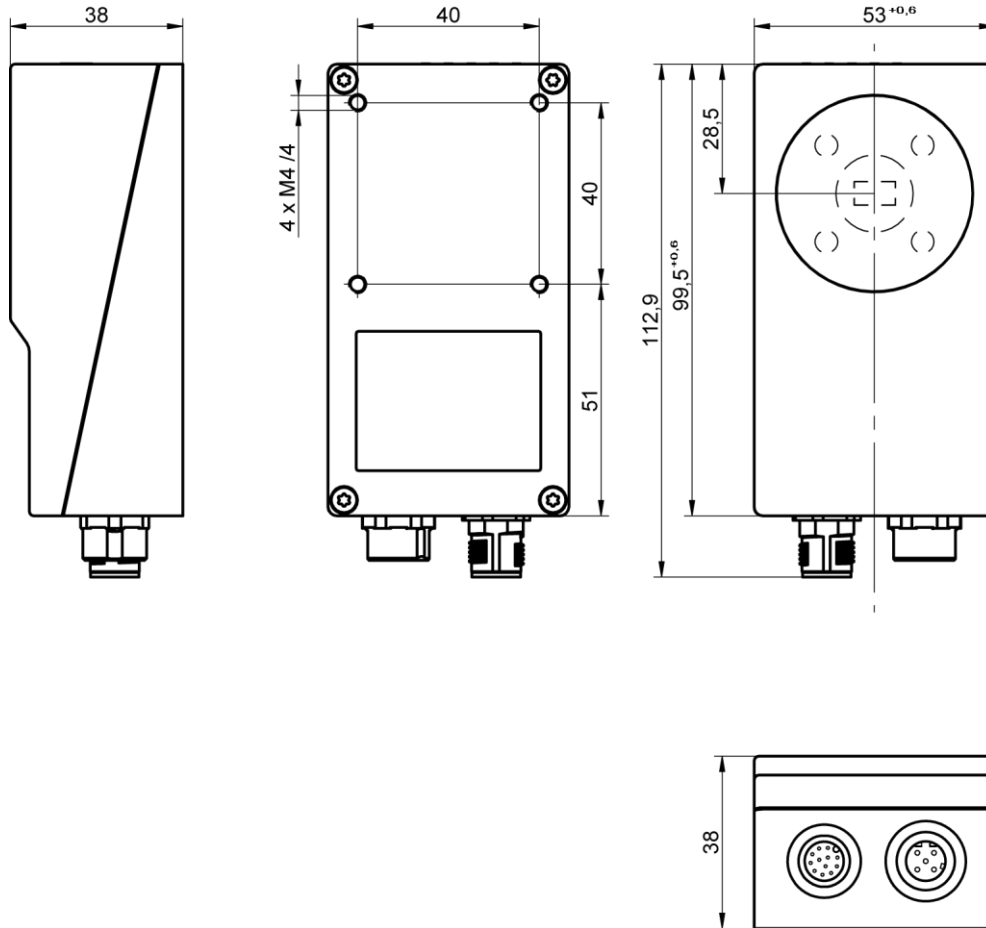
17.2 Overview Features

Features	OC53962X	OC53972X	OC53942X OC5394V0	OC53952X	OC53912X	OC539320	OC53922X
Optics: 10 mm 16 mm C-mount	- -●	- -●	● ● -	● ● -	● ● -	● - -	● ● -
Illumination: White Infra-red (daylight filter integrated) Integrated flash controller for external illumination	- -●	- -●	● ● -	● ● -	● ● -	● ● -	● - -
Configurable web interface (live image, job switching, retrieving defect images)	●	●	●	●	●	●	●
Save images via FTP	●	●	●	●	●	●	●
Configuration via Ethernet	●	●	●	●	●	●	●
Process linkage: Digital I/Os	5 5	5 5	5 5	5 5	5 5	5 5	5 3
Produce partial results via digital I/Os at different times	●	●	●	●			
Process interface: Ethernet RS485 (device-dependant)	● -	● -	● -	● -	- -	● -	● ●
Gonloc Image processor	●	●	●	●	●	●	●
360° Posfix (360° part location)	●	●	●	●	●		
User administration / Password protection	●	●	●	●		●	●
Coordinate conversion	●	●	●	●			
Flexible result conjunction	●	●	●	●			
Integrate digital inputs into results conjunction	●	●	●	●			
Identification functions: Code Text	- -	● ●	- -	● ●	- -	● ●	● -
Job test function	●	●	●	●	●	●	●
High speed mode (monochrome only)	●	●	●	●			
Gamma correction	●	●	●	●			

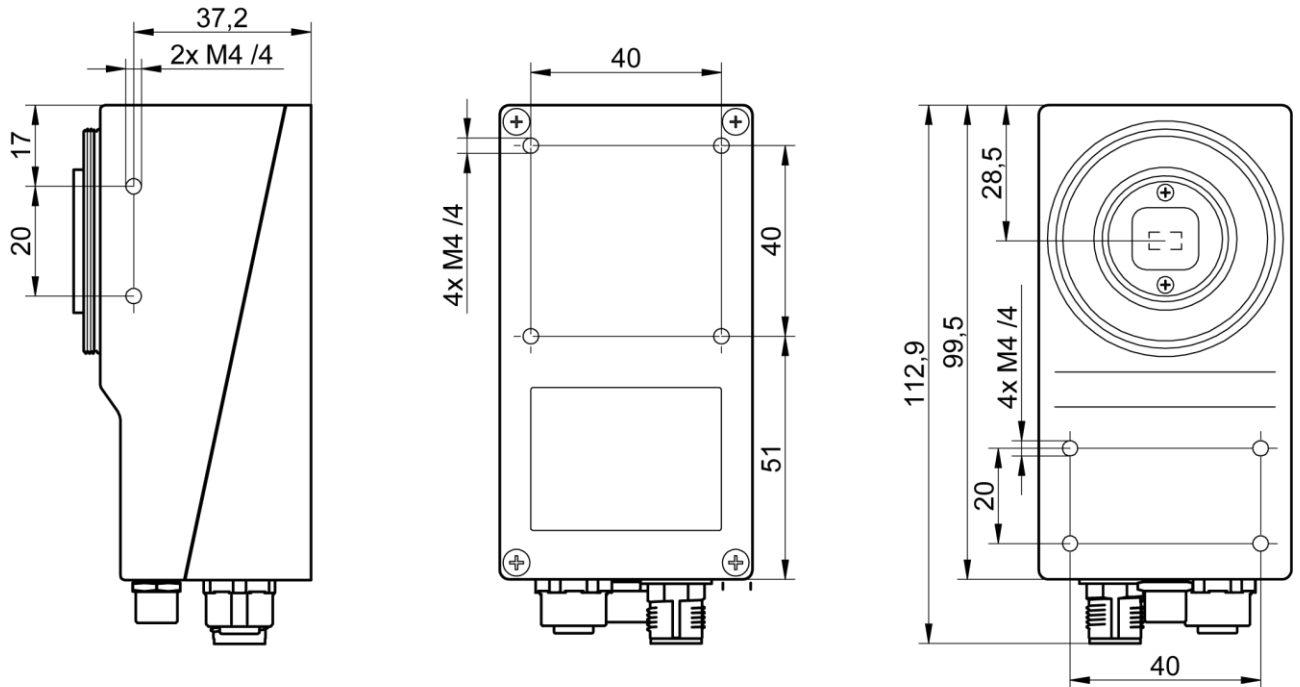
17.3 Type code

			OC	53	95	20
opti-check						
Design						
Product	91	white light, monochrome, CS				
	92	white light, monochrome, ID				
	93	white light, monochrome, ID, OCR				
	94	white light, monochrome, VS				
	95	white light, monochrome, VS, ID, OCR				
	81	IR, monochrome				
	83	IR, monochrome				
	84	IR, monochrome				
Optic	85	IR, monochrome				
	20	focal length 10mm				
	21	focal length 16mm				
	V0	IP69K/10mm,				
	V1	IP69K/16mm				

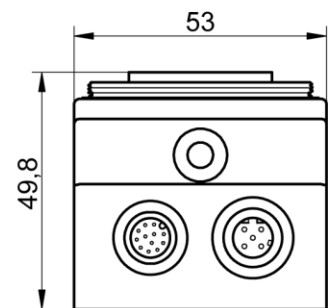
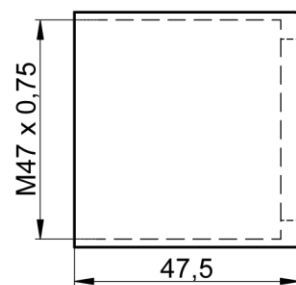
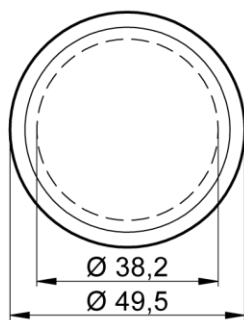
17.4 Technical drawing (except OC53962X / OC53972X)



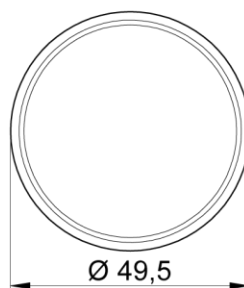
17.5 Technical drawing (OC53962X / OC53972X only)



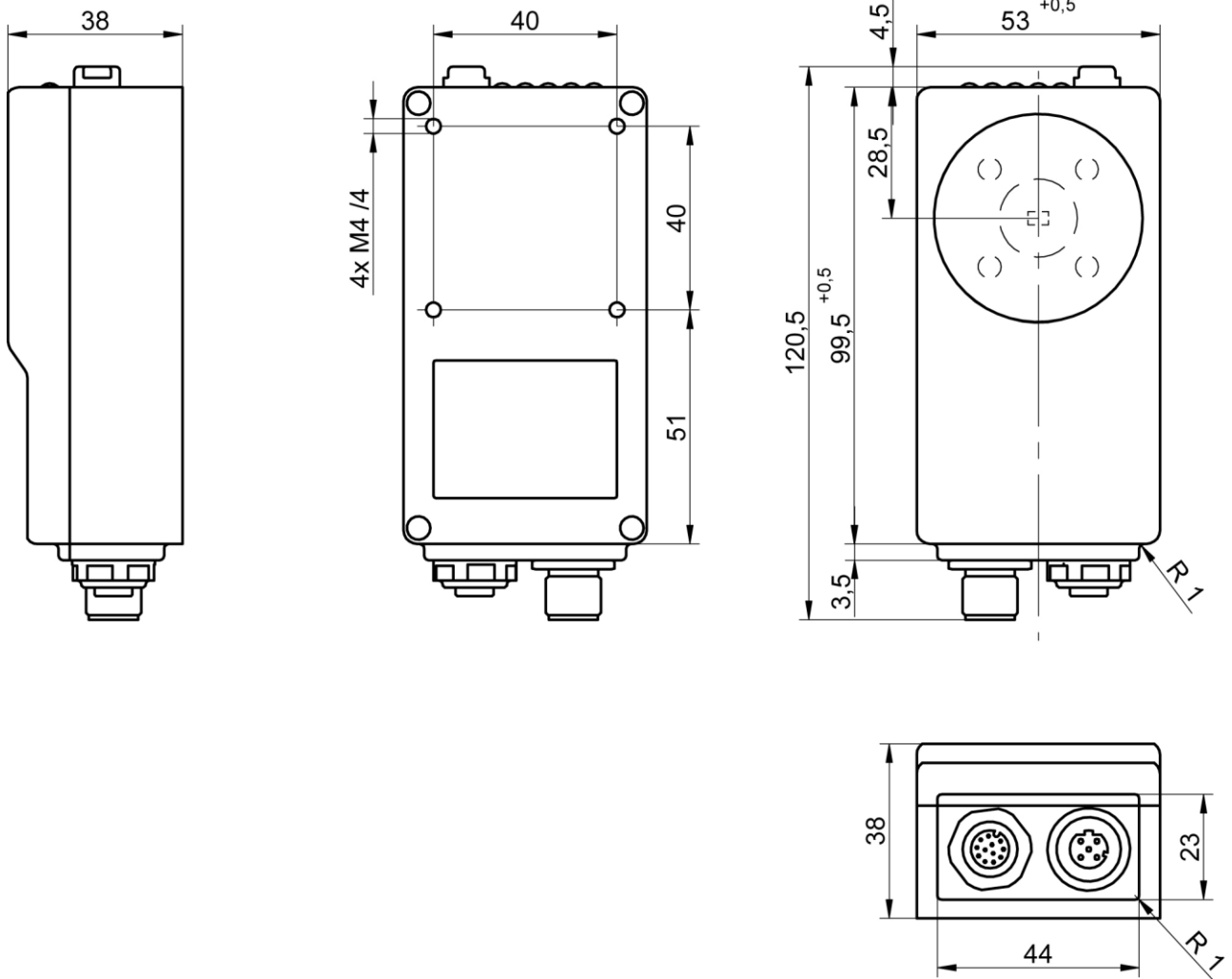
Tube



Tube Modul

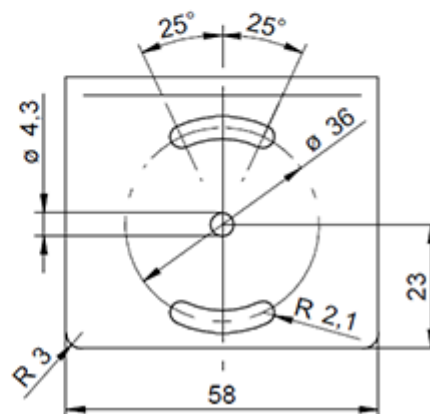
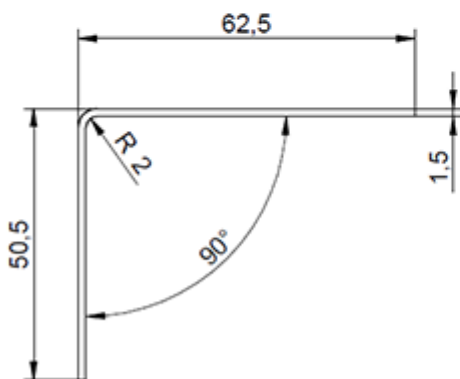
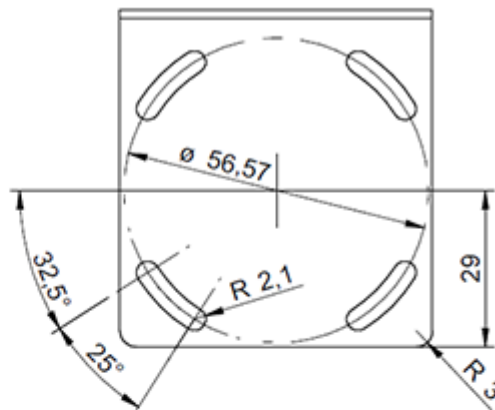


17.6 Technical drawing (OC5394V0 only)



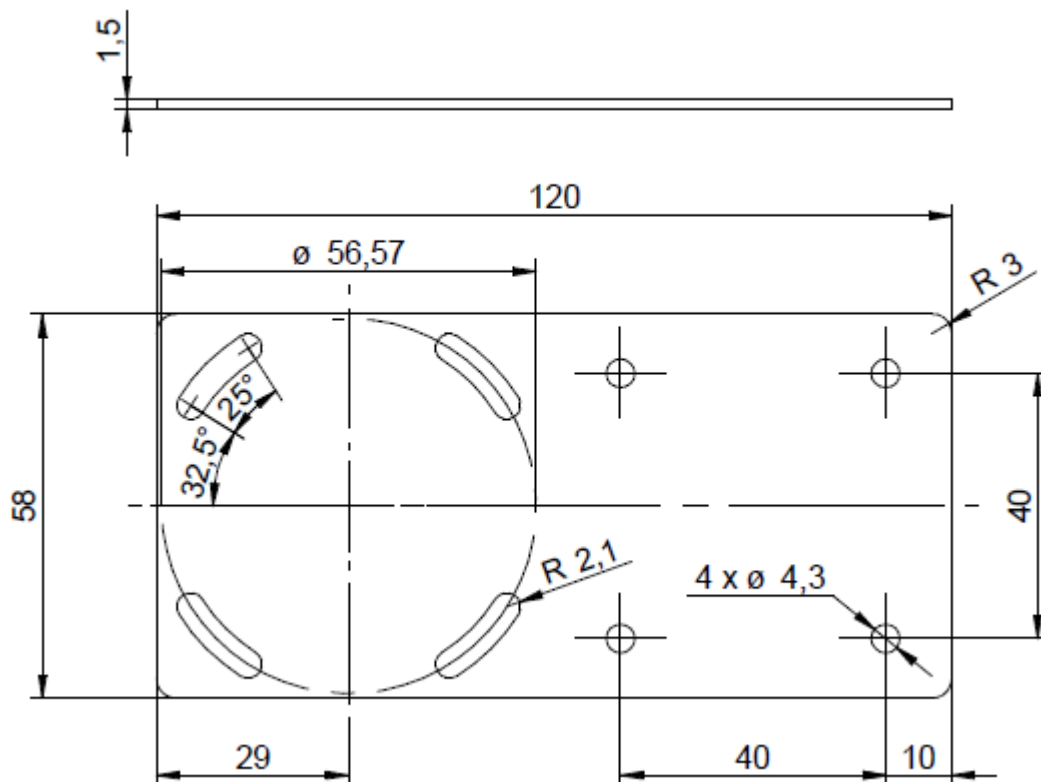
17.7 Fastening bracket, 90 degree

- Color: Black
- Material: powder coated steel



17.8 Fastening bracket, straight

- Color: Black
- Material: powder coated steel



17.9 Technical data

General data	OC53962x OC53972x OC53982x			OC53942x OC53952x OC53842x OC538520 OC53912x OC53812x OC53922x OC539320 OC538320
Resolution	640 × 480 px	1280 × 960 px	1600 × 1200 px	752 × 480 px
Sensor (monochrome)	1/4" CCD (monochrome, color)	1/3" CCD (monochrome, color)	1/1.8" CCD (monochrome)	1/3" (monochrome)
LED illumination	Integrated flash controller for external illumination			White (LED class: Risk group 1, low risk, EN 62471:2008) Infra-red (LED class: free group risk free, EN 62471:2008) (860 nm)
Lens	Changeable lens (C-mount)			f = 10 mm (integrated) f = 16 mm (integrated)
Min. object distance	Depending on changeable lens			50 mm 70 mm
Max. object distance	Depending on changeable lens			∞ 300 mm
Speed High-resolution mode High-speed mode (Binning 2 × 2 monochrome)	Max. 50 insp. / sec. Max. 100 insp. / sec.	Max. 12 insp. / sec. Max. 25 insp. / sec.	Max. 7 insp. / sec. Max. 15 insp. / sec.	Max. 50 insp. / sec. Max. 100 insp. / sec. (OC53942x OC53952x OC53842x OC538520 only)
Defect image memory	32	8	4	32
Number of jobs	Up to 255 on the device (can be exchanged via process interface)			
Features per job	32			

Electrical data	OC53962x OC53972x OC53982x		OC53942x OC53952x OC53842x OC538520 OC53912x OC53812x OC53922x OC539320 OC538320
Power supply	≡ +18 ... 30 VDC		
Power consumption	Type 5 W (I _{max} = 1.5 A at 24 V)	Type 5 W (I _{max} = 1 A at 24 V)	
Inputs	8 ... 30 VDC		
Outputs	PNP 100 mA		
Digital input	Trigger, Job selection, External teach-in, Encoders (CH-A, CH-B) 500 kHz		
Digital output	Pass / Fail 1-5 ¹⁾ , flash sync, alarm, image trigger permitted, result valid ¹⁾ VS XXXXXXXXXXXXR: 1-3		
Communication Initial set-up Process interface	Ethernet (10BASE-T / 100BASE-TX) TCP UDP (Ethernet) ²⁾ , RS485 ³⁾		²⁾ except OC53912X

Integr. Flash controller	OC53962x OC53972x OC53982x		OC53942x OC53952x OC53842x OC538520 OC53912x OC53812x OC53922x OC539320 OC538320
Voltage (permanent) Voltage (pulsed)	≡ 12 VDC or ≡ 24 VDC ⌋ 24 VDC or ⌋ 48 VDC		–
Current (permanent)	I _{max} = 800 mA at ≡ 24 VDC (+/-10 %, at least +/- 100 mA, at 25 °C)		–
Current (pulsed)	I _{max} = 4 A at ⌋ 48 VDC (+10/-20 %, at least +/- 100 mA, at 25 °C)		–
Flash time	Max. 1 ms (Duty Cycle max. 1:10)		–

Operating conditions	OC53962x OC53972x OC53982x	OC53942x OC53952x OC53842x OC538520 OC53912x OC53812x OC53922x OC539320 OC538320
Operating temperature	+5 ... +50 °C / Storage temperature: -20 ... +70 °C / Housing temperature max. +50 °C	
Humidity	0 ... 90 % (non-condensing)	
Protection class	IP 67 (OC53962x OC53972x OC53982x: with tube)	IP 67, IP 69K (only OC53942x OC53952x OC53842x OC538520 in IP 69K)
Vibration load	IEC 60068-2-6, IEC 60068-2-64	
Mech. shock resistance	EN 60068-2-27	

Mechanical data	OC53962x OC53972x OC53982x	OC53942x OC53952x OC53842x OC538520(OC53942x OC53952x OC53842x OC538520in IP 69K) OC53912x OC53812x OC53922x OC539320 OC538320
Width x Height x Depth	53 mm x 99.5 mm x 49.8 mm (without lens / tube)	53 mm x 107.5 mm x 38 mm
Material	Housing: Aluminium, cover glass tube: PMMA	Housing: Aluminium (IP 69K: Stainless steel 1.4404) Cover glass: PMMA ⁴⁾
Weight	300 g (without lens / tube)	250 g (640 g)

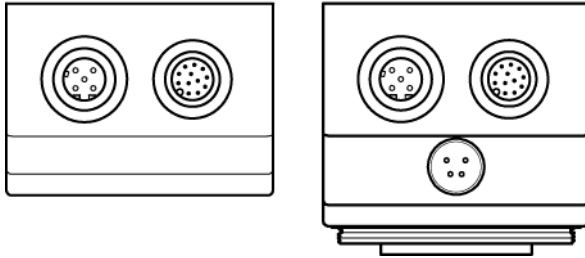
Code types / OCR	Model: OC53972X	Models: OC53952X / OC539320 OC53922X
Barcode ⁵⁾	2/5 Industrial, 2/5 Interleaved, Codabar, Code 39, Code 93, Code 128, PharmaCode EAN 8, EAN 13, UPC-A, UPC-E: Base code + variants Add-On 2, Add-On 5 GS1 DataBar (RSS): Limited, Expanded, Expanded Stacked GS1 DataBar (RSS-14): Base code + variants Truncated, Stacked, Stacked Omnidir GS1 128	
Matrix code ⁵⁾	DataMatrix (ECC 200), GS1-DataMatrix, QR, PDF417	
Font ⁶⁾	Optional fonts (recommended: sans serif, proportional), dot matrix, characters: A-Z a-z 0-9 + - . : / ()	

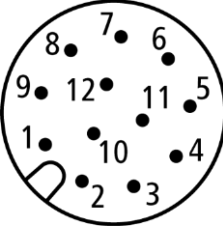
⁴⁾ for OC53942X / OC5394V0 / OC53952X / / OC53912X / OC539320 with infra-red illumination: Daylight filter integrated

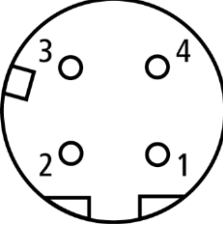
⁵⁾ incl. quality rating of all barcodes according to ISO / IEC 15416 as well as all matrix codes according to ISO / IEC 15415 or AIM DPM-1-2006

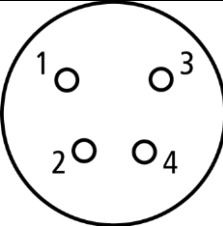
⁶⁾ OC53952X / XC-205 / OC53972X / OC539320 only

17.10 Electrical Connection (View on Device)



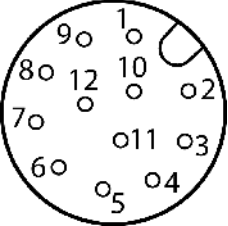
 Pin Assignment(M12)	Pin	Designation
	1	Power (≡+ 18 - 30 VDC)
	2	Ground
	3	IN1 (Trigger)
	4	OUT 1 (PTC-protected)
	5	IN 2
	6	OUT 2 (PTC-protected)
	7	OUT 3 (PTC-protected)
	8	IN 3
	9	OUT 4 / (RS 485+, OC53922X only) (PTC-protected)
	10	IN 4
	11	IN 5
	12	OUT 5 / (RS 485-, OC53922X only), (PTC-protected)

 Pin assignment of the Ethernet interface (M12)	Pin	Designation
	1	TD+
	2	RD+
	3	TD-
	4	RD-

 Supply for external illumination (M8) (XC only)	Pin	Designation
	1	≡ +24V or ⏏+48V Flash
	2	≡ +12V or ⏏+24V Flash
	3	Ground
	4	Flash Sync ¹⁾ , (100 mA PNP)
		¹⁾ voltage according to power supply Voltage outputs configurable by software



17.11 Power Cable M12 / 12-pin

 <p>Pin assignment of the connecting cable (M12)</p>	Pin	Designation	Color code
	1	Power (===+ 18 - 30 VDC)	brown
2	Ground	blue	
3	IN1 (Trigger)	white	
4	OUT 1 (PTC-protected)	green	
5	IN 2	pink	
6	OUT 2 (PTC-protected)	yellow	
7	OUT 3 (PTC-protected)	black	
8	IN 3	grey	
9	OUT 4 / RS 485+ (PTC-protected)	red	
10	IN 4	violet	
11	IN 5	grey-pink	
12	OUT 5 / RS 485- (PTC-protected)	red-blue	