Appendix for LEISTER automatic welding machines with Memory Card

Please read the operating instructions carefully before use and keep for further reference.

APPLICATION

Depending upon the automatic welding tool in question, the welding parameters can be stored longer term in an electronic data store (MC). These data can be further processed and displayed with a PC/laptop, in an appropriate program such as Excel.

- The MC must be formatted (DOS-format FAT → PC, or laptop)
- The record is stored in ASCII-format
- Memory cards supported (MC): Type SRAM

Customary memory cards have various storage capacities. The table shows the storage capacity in metres and in feet.

Capacity of the MC	[m]	[ft]
512K	350	1150
1M	700	2300
2M	1400	4600
4M	2800	9200

DESCRIPTION OF FUNCTIONS — Memory Card

- When starting the recording, a filename is generated automatically, which consists of the current date in front of and a serial number after the decimal point.
- The current filename can be interrogated when the MC is fitted.
- The recording can be started automatically or manually.

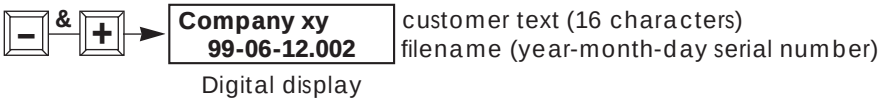
Meaning of the light displays

	Green light	Red light
MC not fitted / MC not detected	○ OFF	–
MC fitted, ready for recording	◍ ON	○ OFF
Data are being recorded and stored	◍ ON	◍ Flashing
MC storage space 0%	◍ ON	◍ ON

Warning

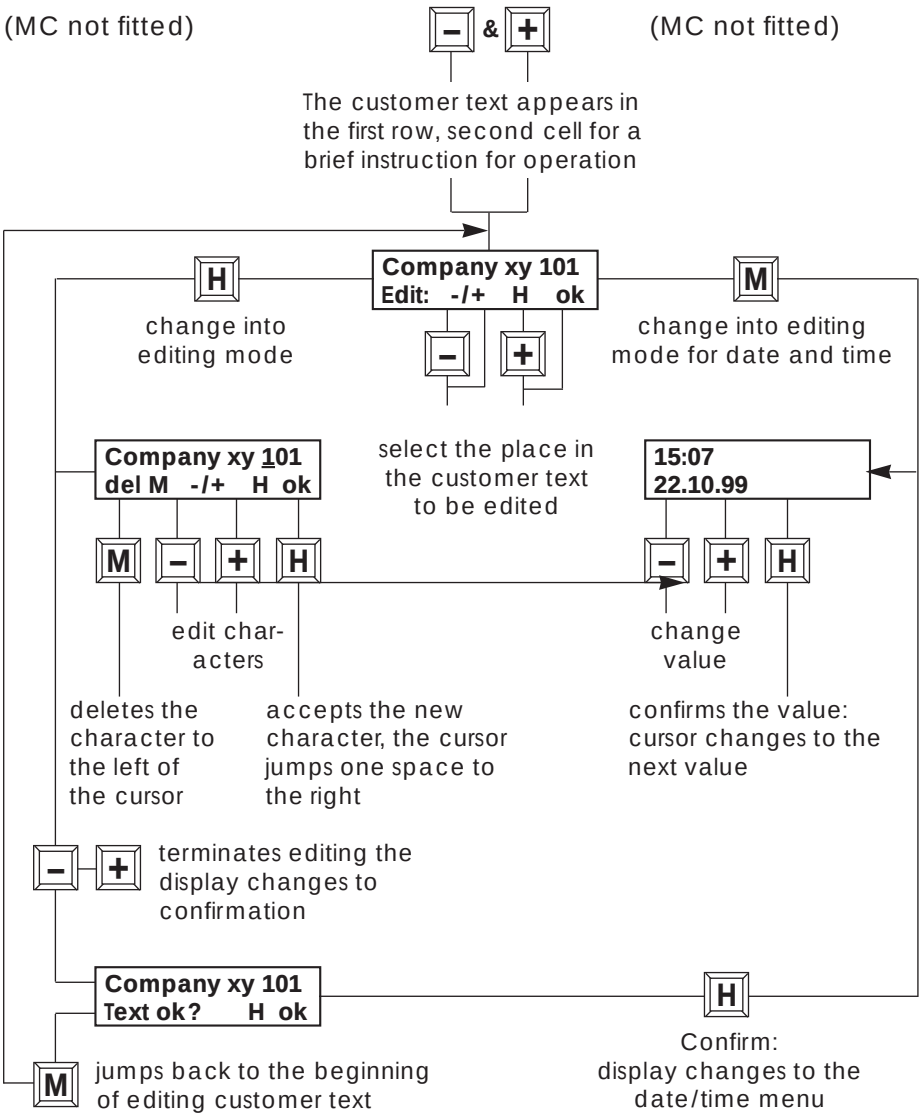
- When the MC is inserted the green light must light up.
- During recording onto the MC, the MC must not be removed! The recording must first be stopped.
- If during recording the data store of the MC is filled up to 100%, the controller terminates the recording and writes MCF (memory card full) at the end of the record.

Retrieve filename (MC fitted), is possible also during recording. By pressing the [–] and [+] keys simultaneously the filename and customer text appears. The display changes back to a normal view after approx one second.

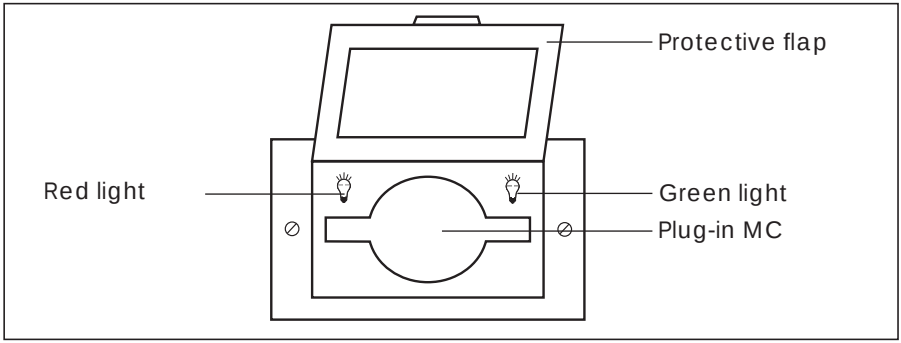


Enter customer text
(MC not fitted)

Set date and time
(MC not fitted)



Plug-in memory-Card



Recording (formatted MC fitted)

Automatically **Started**	**Manually**
Drive ON, tensioning lever tensioned → recording starts when a preset contact pressure is exceeded (works setting).	Switch drive on, within one second press key [H] twice. Recording starts.
Automatically **Terminating**	**Manually**
Release tensioning lever → recording is terminated.	Within one second press key [H] twice. Recording is terminated.

Example of file contents

Record head	Twinny_T 0032054 CONTEC TWINNY_T Date: 23.08.00 Time: 16:15 v=1.70m/min T= 560°C Intervall: 0010			
Headings of columns		v[m/min]	T[°C]	F[N]
1st data record	1.70	384	875	
2nd data record	1.70	384	870	
3rd data record	1.70	384	875	
4th data record	1.70	384	870	
105 data record	2.00	561	395	Set:v=2.00m/min
Data record	2.00	561	395	
Data record	2.00	561	395	
Last data record	END			

Data Evaluation

The record can be prepared and evaluated graphically with various programs for table processing. The procedure when using Microsoft® Excel® is shown in the text that follows.

Importing the welding record into Excel®

1. Insert the memory card into the drive
2. Start the Excel® program
3. *[Opening file]* → select file **(Search pattern *.*)**
4. *[Opening]* → the text conversion assistant appears
5. Set checkbox to **separately.**
6. *[Continue)*
7. Set separator sign to **space.**
8. *[Completion]* or *[ending]*
9. Store file under a new name.

Example: evaluation in Excel®