DONG-DO

Color TFT LCD display

High Precision Air type Electronic micrometer

ML-CP-DA2

User's Guide (Ver. 7.35)

The contents of this manual could be different according to the software version and it can be changed without notice.
Please use this good after reading the manual thoroughly.

Table of Contents

Product features & composition

1. Features (features could be different from pictures without notice.)

Color TFT LCD & Touch pad

I/O port

Air1 in/out

Air2 in/out
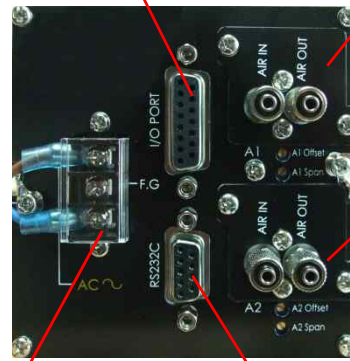
Setup buttons
(up▲, down▼, select▶, mode■
buttons in a row)

Menu

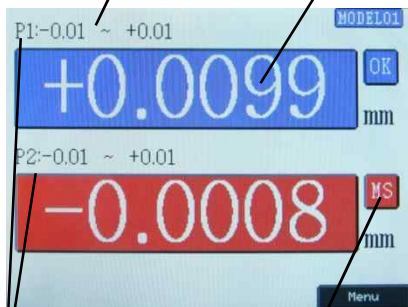AC power input
(100-220V,50/60Hz)

RS232C communication port

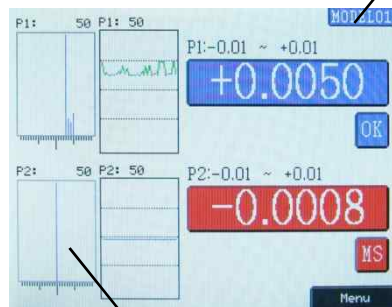## 2. Measuring screen

Tolerance   Measured data

Model number

Result

Measured groups(or points)

Histogram & Flow chart

CP/CPK

\<Normal Text view\>

*A wide digital data is shown in
this mode. Blue & red color make
easy to realize the result.

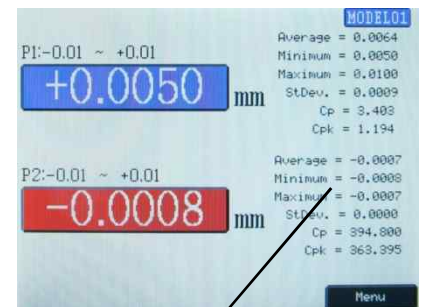**\<Histograms & chart view\>**

*There're number limitations of
displaying histograms and flow
charts.

By 4 groups :
    Max. 9 histograms & charts.

From 5 to 8 groups:
    Max. 3 histograms & charts.

\<Statistics data view\>

*If the statistics data view is on,
the histogram view is off
automatically. And only 2 groups'
statistics data are shown max.

Statistics data is disappeared
from 3 groups.

Functions

**Simple setting orders.

*Air input(2bar) → Group → Dimension → Calibration → Tolerance → Other options

a. **Group** setting to display on the measuring screen. (Doesn't need on the 1ch unit.)
b. Hi/Lo Master Size input(at **Sensor → Dimension** menu).
c. Hi/Lo Master Calibration(at **Sensor → Calibration** menu)
d. Zero Master offset setting(Optional, at **Sensor → Offset** menu)
e. **Tolerance** setting to make the decision of OK or NG.
f. Other settings as like Preset, Display, etc.

Master Size	10.000 [mm] +0.010 [mm] −0.010 [mm]	20.500 [mm] +0.050 [mm] +0.030 [mm]	
Inputting Dimension Value	Preset: +10.000 HI : +10.0(um) LO : −10.0(um)	Preset: +20.500 HI : +50.0(um) LO : +30.0(um)	Preset: +20.530 HI : +20.0(um) LO : +0.0(um)
Note	−	Both of the settings are possible.(HI/LO deviation is the same. 'Preset' is a nominal value but just for display on measuring screen.)	

1. Main menu
- Main menu is entered by hitting the Mode ■ button(4th button from left)
  or touching 'menu' on the measuring screen.

<Main Menu>
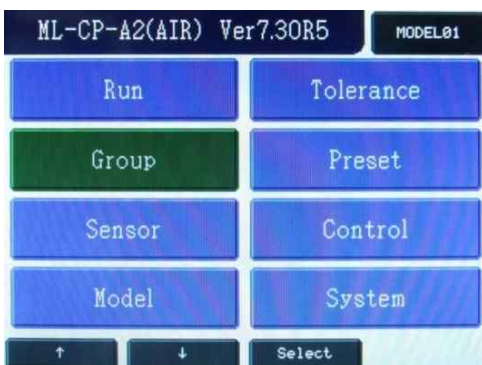
-The main menu is composed as like the picture at the left.
 -Each functions can be chosen by touching screen or ▶ button after cursor is moved by ▲▼buttons.

1. Run: To go to the measuring screen.
2. Group: To set the items to display on the measuring screen.
3. Sensor: Calibration sensors by Hi/Low masters.
4. Model :Memory space to save the current settings.
       There are 16 spaces, 0 to 15, and external memory selection by input signal is possible if the model is set to 99.
5. Tolerance: To input the tolerance of the measuring part.
6. Preset: Preset(nominal) value for the measuring data on the LCD display.
7. Control: To set up the display, input/output, serial communication, etc.
8. System : To setup the unit, language, password, etc.

2. Run
-To enter the measuring screen.

Functions

3. Group (2ch differential type only.)

- To set the item to display on the measuring screen. Only 3 kind of group can be selected.
- User can select one from P1 + P2, P1 – P2, P2 – P1.
- If "Group" is selected on the main menu, the Group setup screen is come out.

Group	MODEL01
P1+P2	
P1-P2	
P2-P1	
↑ ↓ Select Return	

①Group menu

The group calibration should be done on 'Sensor' menu.

4. Sensor

- Calibration sensors by Hi/Low masters and sensor's direction setting.

1) Direction:
- Sensor direction setting menu. IN-DIA ←→ OUT-DIA
• IN DIA : to measure inner diameter. So, the value is increased as the hole size is bigger.
• OUT DIA : to measure outer diameter. So, the value is increased as the part size is bigger.

2) Offset:
 - A offset value is set on this menu. The offset value would be added on the real measured data. For example, 110um would be displayed if the real measured data is 100um and the offset value is 10um.
- Usually set up to 0.
• Measured(displayed) data = Real measured data + Offset value.

3) Dimension:
- Hi/Low masters' dimension setting before doing master calibration.

4) Calibration:
- Hi/Low masters setting menu.

①Red color is shown without Master setting

②Blue color is shown at the High value with Hi master setting.

③All blue color is shown if the master setting is done well.

5. Model

- Memory space to save the current settings. And the setting can be recalled.
  There're 16 memory spaces in ML-CP. If the model is set by 99 or External, the model can be changed by external I/O input.

6. Tolerance
- Tolerance to make the decision of OK/NG is put in this menu.

Low limit   High limit   Group Offset

Factor(digital gain)

Group name

Return

①Group name: No changeable.
②Hi/Low tolerance: Hi and Low tolerance to make the OK/NG decision. If the tolerance to change is selected, the number entering menu is come out.
③Offset: Offset values for groups. Normally set by 0.000.
④Factor: Digital gain for groups. Normally set by 1.000.
　　Final value = raw value * Factor(at 'Tolerance' menu).
⑥Return: To return to the main menu with saving the setting.

7. Preset
- Preset(nominal) value for the measuring data on the LCD display. Preset is useful to display the real dimension number.

※ The value on the Preset does not effect to the result of the decision. It is just added when the measuring data is displayed.
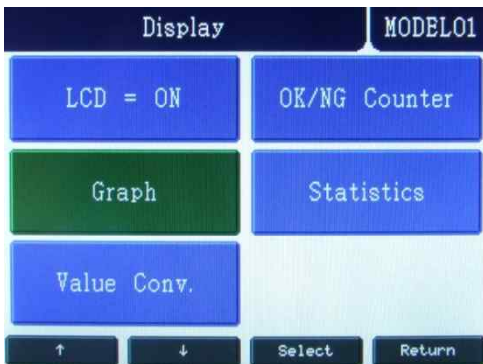
8. Control
- To set up the input/output methods, serial communication, etc.
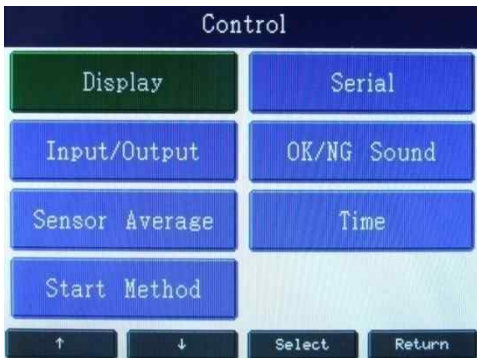
1) Display:
- To set up display items on the measuring screen .

a. LCD on/off:
 To set if the LCD display is used during running or not. If the LCD does not used, other processes are faster. The text of <<LCD DISPLAY IS OFF>> is displayed on the screen if it is set 'Off'.

b. Graph:
To set which the histograms & charts are on the measuring screen.

- Graph On/Off : To select if the graph function is used or not.
- Sample Count : This is for 'Latest histogram' & 'Flow chart'.
                 It's about how many latest data is used for them.
- Clear Data : To clear the graphs on the measuring screen.
- Selection : To choose which graphs are displayed on the measuring screen.

**There're 3 kinds of display output in the 'Graph' selection menu.
- Total histogram(T.Histo) : Histogram by total data but they're not saved in the memory,
                 but only updated from last histogram.
- Latest histogram(L.Histo) : Histogram by a number of latest data, 1 to 50, and they're saved
                 in the memory.
- Flow chart(F.Chart) : Flow chart by a number of latest data, 1 to 50.

Functions

c. Value conversion:
To setup the end figure of the measured value. There are the options of 'none' (Don't do anything.), 'round', 'raise', and 'cut'.

d. OK/NG counter:
To choose the ok/ng counter on the measuring screen or not.

e. Statistics:
To display statistics data on the measuring screen. Average/Min/Max/Standard Deviation/Cp/Cpk are shown.
*If the statistics data view is on, the histogram view is off automatically. And only 2 groups' statistics data are shown max. Statistics data is disappeared from 3 groups.

2) Input/output:
- To set input / output pins' purpose. (Check page 13).

3) Sensor Average:
-To set how many raw data is used to average them for one measuring sequence.
- The one measuring sequence time could be different by this setting.

4) Start Method:
 - Auto : Start the measuring continuously.
 - Semi-Auto : Data is updated continuously on the screen.
              But the measured data is gotten when 'start' signal is inputted.
 - Manual : give the start signal from outside(▶button or from I/O port).
 - Wait Start Off : If this is 'ON', starting the measuring sequence is waited until the 'Start' signal is off.
              If this is 'Off', the measuring sequence is continued until the 'Start' signal is on.
              Work with the 'Start Method' is 'Manual' or 'Semi-auto'.

5) Serial:
-To set the RS232C data(Check page 11).

6) OK/NG sound:
-To set if a beep is used at the decision of the OK or NG.

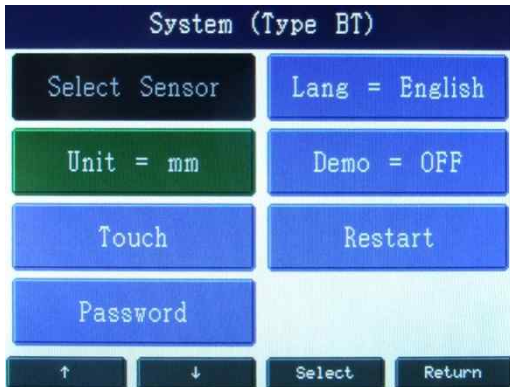**7) Time:**
- To set the probe stable time and output signal hold time.

9. System

- To setup the unit, language, password, etc.

1) Select Sensor : Only Air type fixed. (Doesn't work on ML-CP-Ax model.)

2) Unit: unit is changed mm → inch → mil(1/1000 inch).

3) Touch :
   a. Touch Calibration: To check or calibrate the touch pad. To calibrate it, just follow
     the 5 cross in order. You should press it until a beep is on.
   b. Touch on Run: if 'Off', no touch is worked on the measuring screen. Use mode(■) button
     to enter the main menu.
   c. Test touch: To check the touch pad is working well. A blue cross will be marked at the
     touched point. To end of it, press the mode(■) button.

4) Password : To set the password to enter main menu. At the first, password is null, no set.

5) Lang : Menu language selection. English / Korean / Chinese.

6) Demo : To make a random data for a show.

7) Restart : To restart the system(Turn off the power and on again).

Serial communications
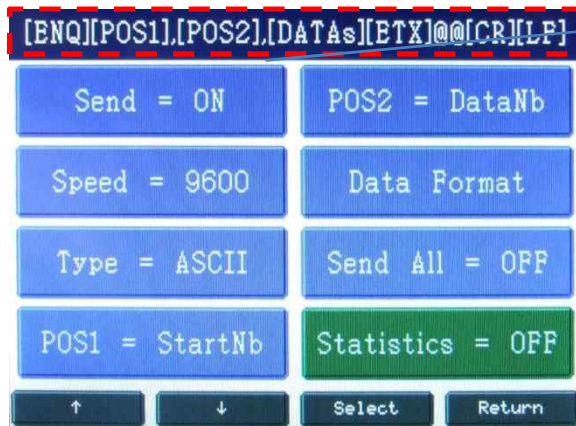
Serial format viewer :
Whenever the settings are changed, the serial format is shown on this viewer.

① Items (At the Main menu → Setup → Input/Output → Serial)
- Use : To set the use of the RS232C serial output or not.
- Speed : Communication speed from 9600 bps to 115200 bps.
- Type : ASCII or HEX
- POS1, POS2 : User can choose one.
  a start number(StartNb), result(OK/NG), a number of data(DataNb),
  model number(Mdl.Nb), or model name(Mdl.name).
- Data Format :
    1)Point On/Off : To put the decimal point on the data or not.
    2)Preset On/Off : To add the 'preset' values for the serial data or not.
    3)Int.Length : To set how many digits are at the front of the decimal point.
     (Only used if 'Point' = ON)   ex) In.Length = 4 / Point On/Off = On → +0000.000
    4)OK/NG : To send individual OK/NG result on each data.
-Send All : To send all groups' data even if user doesn't set some groups. i.e. max data output.
-Statistics On/Off : If this is on, the statisitics data, Average/Minimum/Maximum/Standard Deviation/
                Cp/Cpk, are out with other data. Only worked if user set statistics view is on.

② Cable setting

Elec' micrometer		Direction of signal	Computer	
Signal	Pin No.		Pin No.	Signal
N.C	1		1	DC
RD	2		2	RD
TD	3		3	TD
N.C	4		4	DTR
SG	5		5	SG
N.C	6		6	DSR
N.C	7		7	RTS
N.C	8		8	CTS
N.C	9		9	RI

 - Cable of computer serial working terminal - Connect 4Pin and 6Pin / Connect 7Pin and 8Pin

Serial communications

③ Examples of the serial communication

- Hex Format

STX (1 Byte)	STATUS (1 Byte)	MEASURING DATA (n Byte)	ETX (1 Byte)

(n = Transmit Data Q'ty x 2)

- ASCII Format

Byte	1	2	1	2	1	-	1	1	2	1	1
Char	ENQ (0x05)	Start Point	,	End Point	,	Data	,	ETX (0x03)	@@	CR	LF

Ex) In case of No. of Data is 2.

1	2	1	2	1	5	1	5	1	1	2	1	1
ENQ	01	,	02	,	+0043	,	-0025	,	ETX	@@	CR	LF

- ASCII Format with Statistic

Byte	1	2	1	2	1	-	-	1	1	2	1	1
Char	ENQ (0x05)	Start Point	,	End Point	,	Data	Statistic Data	,	ETX (0x03)	@@	CR	LF

Ex) In case of No. of Data is 2 / Statistics data is 2.
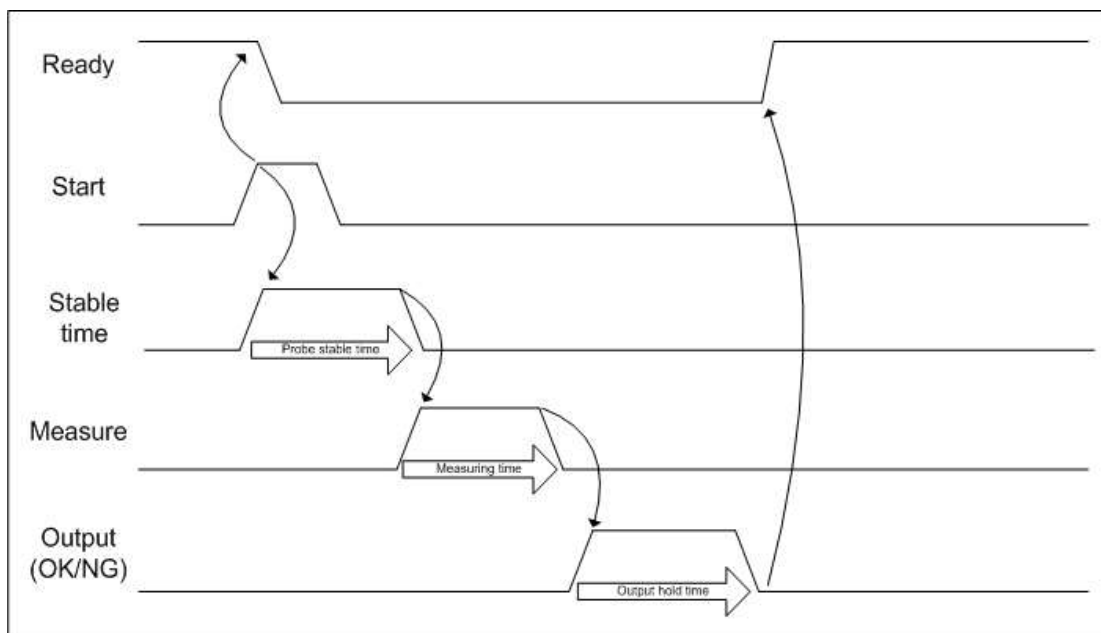
POS1(start num.)

POS2(Data num.)

Statistic Data 1   Statistic Data 2

01,02,-0007,+0779,-0.007,-0.007,-0.007,+0.000,+10.000,+10.000,+0.779,+0.779,+0.779,+0.000,+10.000,+10.000@@
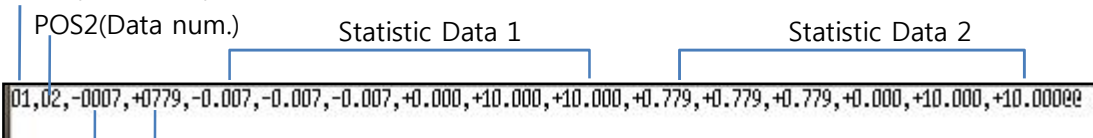
Data 2

Data 1

I/O port & operating sequence

1) I/O pin description

Pin	Name	In/Out		Description	Circuit
1	NCOMMON		0 V	GROUND	
2	PCOMMON		+24V		
3	IN6	in	H/L		
4	IN5	in	H/L		
5	IN4	in	H/L		
6	IN3	in	H/L		
7	IN2	in	H/L		
8	IN1	in	H/L		
9	OUT6	out	H/L		
10	OUT5	out	H/L		
11	OUT4	out	H/L		
12	OUT3	out	H/L		
13	OUT2	out	H/L		
14	OUT1	out	H/L		

INPUT (START)
+24V
INPUT CURRENT:MAX 10mA

OUTPUT (OK, NG, READY)
LOAD
com   POWER
VOLTAGE:MAX 30V
CURRENT:MAX 300mA

* User should set how to use the IN/OUT pins at the 'Setup' → 'Input/output'.

2) Timing diagram

Ready

Start

Stable time
Probe stable time

Measure
Measuring time

Output (OK/NG)
Output hold time

Specifications

1. General Specifications

DIVISION	GENERAL
MAIN SUPPLY	AC100-220V~ 50/60Hz
OPERATING TEMPERATURE	5 ~ 40℃
RELATIVE HUMIDITY	Up To 70%
INPUT AIR PRESSURE	2 BAR
OPERATING CONDITION	NO CORROSIVE GAS AND DUST
SUPPORTING OUTAGE	DATA BACK UP BY INNER FLASH MEMORY

2. Specifications

DIVISION		SPECIFICATION
AIR SENSOR	CHANNELS	1~2ch
	RESOLUTION	0.1um
DISPLAY	LCD	3.5" TFT COLOR GRAPHIC LCD
DIMENSION		W100×H100×D160(㎜)
WEIGHT		1.0kg
OUTER INTERFACE		RS232C, 9600N81
		I/O port (IN:6, OUT:6)

High Precision Air Type Micrometer

DONG-DO