

Manual



Software CWL-Import

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iret

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1 Overview

1.1 Description

The software CWL-Import realizes the connection of a wire processing machine of the manufacturer Schleuniger to an ERP system. For the operation of CWL-Import, the wire processing software "Cayman" from Schleuniger must be installed on the same PC.

CWL-Import handles the conversion of incoming orders from CSV to Cayman format.

1.2 Data Transfer

The ERP system creates one file per order:

- An order file "<order> .csv", whereby the character string <order> is largely freely selectable.

Restrictions are:

- Only characters allowed by the Windows file system (e.g. no ? question mark)

Valid file names are for example

"2019-06-15 order 001.csv" or "machine27_itemABC.csv".

The files automatically generated by the ERP system are stored in a job directory (transfer directory) provided for the Schleuniger machine.

CWL-Import checks this directory in short time intervals (approx. 1 second) and starts the job conversion or informs about pending new jobs.

The interface format (data transfer) is described in a separately supplied PDF document.

- "td_interface_documentation_accelerator.pdf"

After the program installation, it is located in the "doc" subfolder of the installation directory or can be displayed from within the running program.

2

Installation and commissioning

2.1

Installation

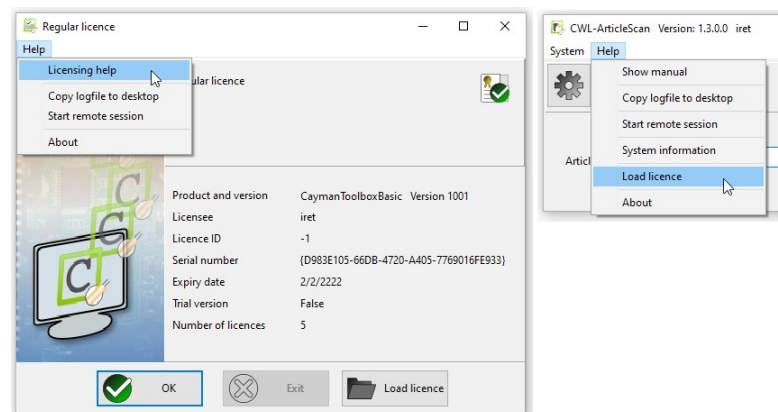
The setup installs all components of the application, the recommended installation location is a directory in the root directory of c:\, e.g. c:\CaymanToolbox\. The installation folder can be created during the installation, write permissions must be granted for this folder. If other iret-CaymanTools are already installed on the PC (e.g. CaymanToolboxBasic), the installation should take place in the same folder, so that saved settings such as the user language are retained.

2.2

Licensing

The licensing of the CaymanToolbox software is described in a separate document. You can display this document in the license dialog (menu 'Help', menu item 'Licensing help').

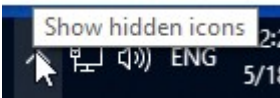
The license dialog is displayed in the demo version of the Toolbox at program start. You can also reach it via the program main menu 'Help', menu item 'Load licence'.



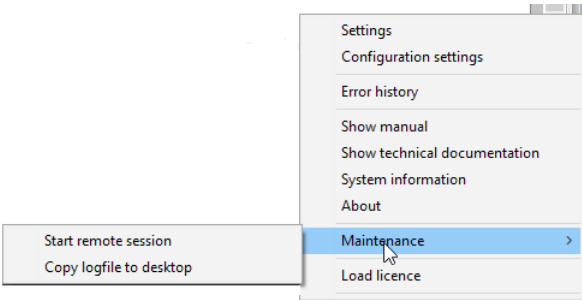
3 Main Menu

The program normally works in the background without visible components. A pop-up menu leads to the operating dialog:

- Click left mouse button on "Show hidden symbols".



- Right mouse click on the "CWL Import"

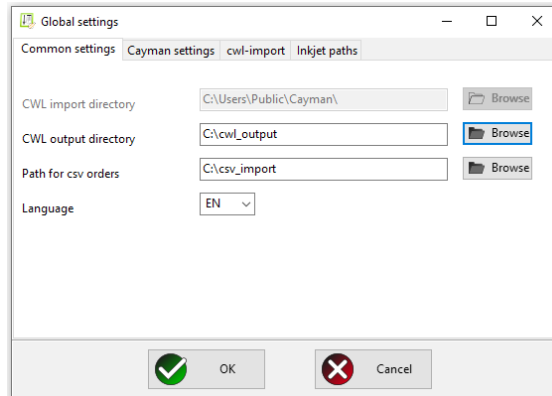


The popup menu contains the following items:

Function	Description
Settings	Opens the settings menu.
Configuration settings	Opens the printing settings menu.
Error history	Shows errors that have occurred in the program flow.
Show manual	Shows this document. A PDF viewer must be installed.
Show technical documentation	Shows the installed PDF document for interface description (data transfer).
System information	Shows information (e.g. paths) to required system files.
About	Shows program and licensing information.
Maintenance	Start remote session. Copy logfile to desktop: Copies a log file of the previous program run to the computer desktop. There the file is easy to find and can be sent for diagnostic purposes e.g. as email.
Load licence	Opens the dialog window for loading a licence.

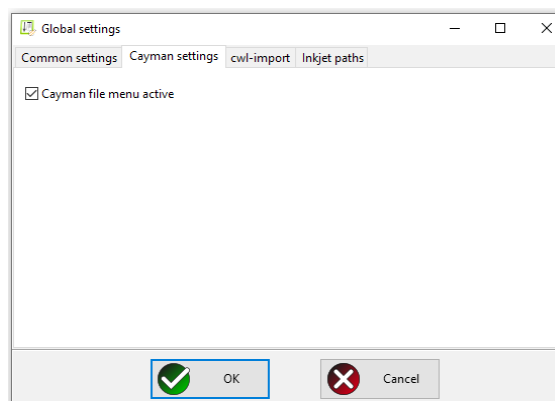
3.1 Menu „Settings“

3.1.1 Common settings



Function	Description
CWL Output directory	The generated Cayman files (.cwl) are stored in this directory. <ul style="list-style-type: none"> The program needs write permission here Tip: UNC paths are possible
Path for csv orders	Also called the transfer directory. Here the incoming orders (jobs) are searched for in CSV format. Two subdirectories are also created here (see , into which processed CSV files are moved. <ul style="list-style-type: none"> The program needs write permission here Tip: UNC paths are possible
Language	Here the user language is selected, so far German (DE) and English (EN) are supported. After changing the language, the program must be restarted to activate the change.
(Further directories)	These settings have no function in CWL Import and are therefore grayed out.

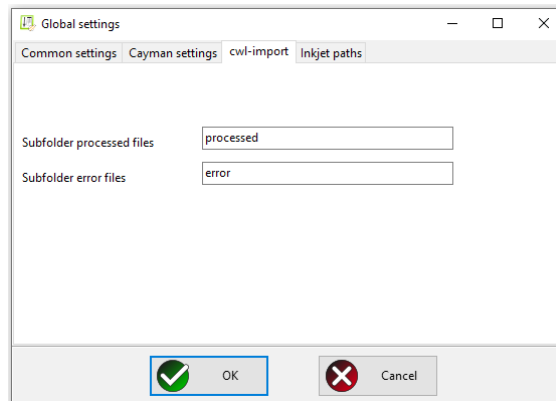
3.1.2 Cayman settings



Function	Description
Cayman file menu active	This option enables / disables the Cayman file menu. It must be activated (check mark set) if article lists are to be saved from Cayman.

3.1.3 CWL-Import settings

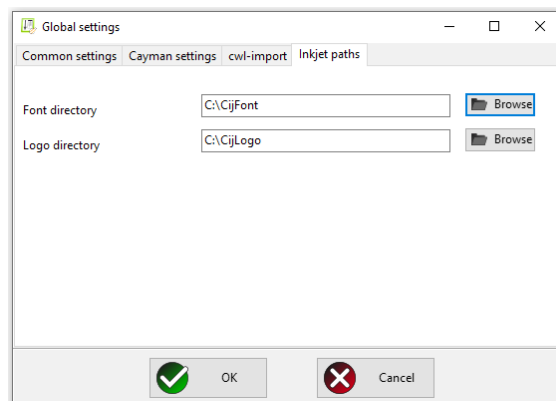
In the transfer directory (see 3.1.1) CWL Import creates two subfolders for processed CSV files. Jobs for which a Cayman file could be created will be moved to the "processed" subdirectory, jobs for which the conversion to Cayman format failed will be moved to the "error" subdirectory. The default directory names are "processed" or "error", but they can be changed here.



Function	Description
Subfolder processed files	CSV order files are moved here if a Cayman file (.cwl) could be created.
Subfolder error files	Order files are moved here if the creation of the cayman file failed.

3.1.4 Injket paths

Here you specify the directories in which CWL-Import searches for the printer fonts and logos to prepare the print texts.



Function	Description
Font directory	Font directory for print preview
Logo directory	Logo directory for print preview

3.2 Configuration settings

This configuration data is sent to the printer before production; it defines the appearance of the marking texts (maximum height, width, drop density, quality).

The screenshot shows a 'Configuration settings' window with the following fields and values:

- Name: *
- Default font height: 7
- Barcode height [pixel]: 15
- Stroke distance [mm]: 0.3000
- Printing quality: 2 - Standard
- Print height: 16
- High voltage [%]: 50

At the bottom, there are 'OK' and 'Cancel' buttons. The 'OK' button is highlighted with a green checkmark icon.

Funktion	Beschreibung
Name	(Without meaning, because at present only one configuration can be stored.)
Default font height	Internal value for calculating actual marking text widths. If a font of a different size is used, this value must be adjusted accordingly in order to print marking texts with the correct distance to the left end of the cable.
Barcode height [pixel]	Print height for barcodes.
Stroke distance	This value affects the length of the printout. Note: <ul style="list-style-type: none"> This is the desired value; the resulting value depends on the resolution of the shaft encoder.
Printing quality	<ul style="list-style-type: none"> Hi-speed: for maximum printing speed. Low: better quality but still a high printing speed (with emphasis on speed). Standard: for normal operation. High: highest quality but low printing speed.
Print height	<ul style="list-style-type: none"> 0 – automatically: CWL-Import determines the height of the printout automatically. other values: the height of the printout is limited to the number of pixels. When the print text is higher than specified you will miss some of the upper pixels in the printout.
High voltage [%]	(The default value 50 cannot be modified here.)

3.3 Error history

Errors, warnings and notes are logged in an error history. It can be called up from the main menu via the menu item "Error history". This window opens automatically when a serious error occurs and closes when a job is loaded successfully.

Errors:				
No:	Type	Message	Details	Date / Time
32003	WW	The logo directory does not exist,	C:\logos\	5/14/2020 10:52:49
32004	WW	No fonts loaded, marking text can		5/14/2020 10:52:49
Click on table to show details: No fonts loaded, marking text can not be displayed!				

Column	Description
No.	Internal error number, used for error diagnosis.
Kind	Type of message: <ul style="list-style-type: none">• II: Information (green background)• WW: Warning (yellow background)• EE: Error (red background)
Message	The message text.
Details	Further explanations, e.g. job or file where the error occurred.
Time	Time of message event.

Note: A mouse click on a table entry displays the complete cell text in the footer of the table.

4

Handling of incoming jobs

As soon as CWL-Import detects a job file (.csv) in the transfer directory, two cases are distinguished for further processing:

Case 1: The software "Cayman" is *not running* **or** Cayman's article list is *empty*:

Cayman is started automatically if necessary, the incoming job is processed and loaded into Cayman. Production can start immediately.

Case 2: Cayman is running, the article list is *not empty*:

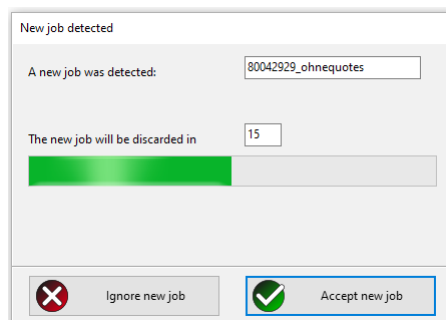
A distinction is made as to whether the job loaded into Cayman is currently being produced or is paused.

Case 2a: An existing job is being produced (machine is running):

The current production is not interrupted. The new job remains in the transfer directory until production is finished or paused.

Case 2b: Existing job is paused / is finished:

In this case, a dialog appears and the user is asked how to proceed:



- The user can **accept** the new job: The new job is loaded, all items previously loaded into Cayman are discarded.
- The user can **ignore** the new job: The Cayman article list is kept, the new job is moved unprocessed to the error directory. This is logged in the error history.
- If the user does not react within 30 seconds, the dialog disappears and the new order is **ignored**.