

## Pallets of Parts in Autorun

If you have lots of parts (the same part) to run, stack them up on the machine in a grid and have the machine do all the work!

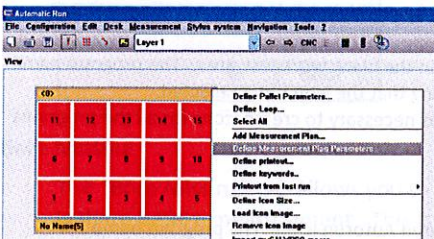
### Before you start:

- Make sure the program you want to “palletize” in Autorun works.
- Make sure all options you want for the run (like ADDITIONAL POSITION RESULT and RESULTS TO FILE) are activated.
- Start a new program and perform an alignment on the Pallet itself. No need to define clearance planes or even run this program.
- Save and Close ALL programs.
  - From a blank Calypso screen, choose PLAN>AUTORUN.

### Pallet Setup:

1. In a blank Autorun “Workdesk”, Right-Click and choose “ADD PALLET”. You can also click the pallet icon in the button bar.
2. You will be asked to select the program that you want to “palletize”. Choose the program folder and open the inspection plan as usual.
3. The Pallet Parameters window will appear.
4. Select your Pallet Alignment Name
5. Select your Part Alignment Name
6. Enter the NUMBER OF COLUMNS
7. Enter the NUMBER OF ROWS
8. Enter the DISTANCE BETWEEN COLUMNS
9. Enter the DISTANCE BETWEEN ROWS
10. OK out of the Pallet Parameters window

11. A Pallet icon will appear on your workdesk



12. Select the new pallet icon that appears by Left-Clicking on it. The program name bar below the icon will turn orange, indicating that the icon is selected.
13. Drag and resize the pallet icon as usual.
14. Right-Click the pallet icon and choose “DEFINE MEASUREMENT PLAN PARAMETERS”
15. Set up the Run Screen as usual and OK out of it.
16. Right-Click the pallet icon and choose “SELECT ALL”. The stations of the pallet all turn green.
17. If necessary, click individual stations in the pallet icon to turn them red, indicating that a part is not loaded.
18. Click the Green RUN button on the lower right of the Autorun Screen. Inspection will immediately begin after ALL necessary header information is entered for ALL parts loaded in the pallet.

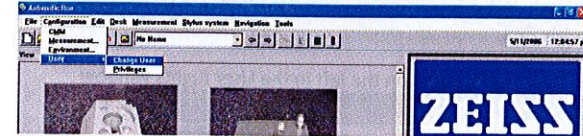
## Autorun Setup for Multiple Users

Now that your Autorun is setup, we need to set up user account, privileges, and then lock the autorun down so these unskilled users can't mess anything up.

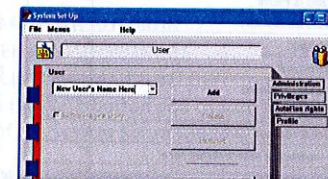
### SETUP OF NEW USERS:

From the Autorun user interface (LOGGED IN AS MASTER):

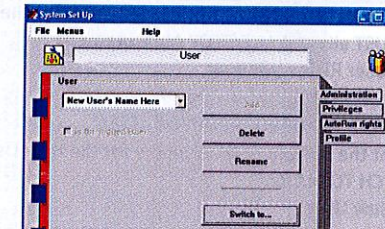
- 1) Choose **CONFIGURATION>USER>CHANGE USER**



- Type the name of the new user in the dropdown menu provided
- Press ENTER key on keyboard
- Click ADD Button in System Setup window
- OK out of the System Setup window



- 2) Choose **CONFIGURATION>USER>CHANGE USER** again.
  - Click the TAB at the bottom of the window for the newly user
  - Click SWITCH TO button



- OK all messages that pop up as you log in the first time as this user.
- OK out of the System Setup window.

- 3) Choose **CONFIGURATION>USER>CHANGE USER** one more time!

- Click the TAB at the bottom of the window for the Master
- Click the SWITCH TO button
- Log in as the Master
- OK out of the System Setup Window

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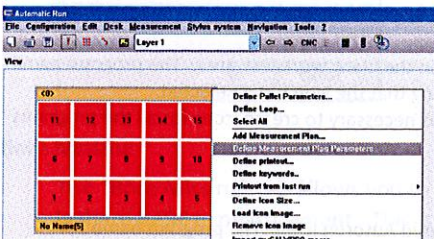
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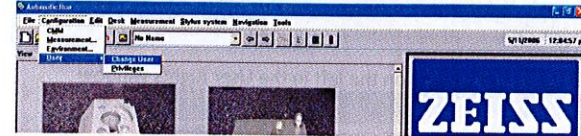
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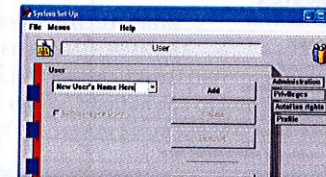
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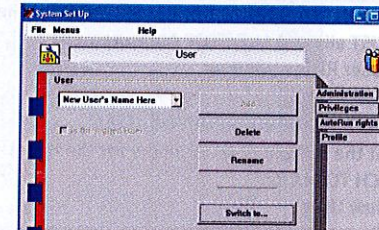
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- 2) Choose **CONFIGURATION>USER>CHANGE USER** again.
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