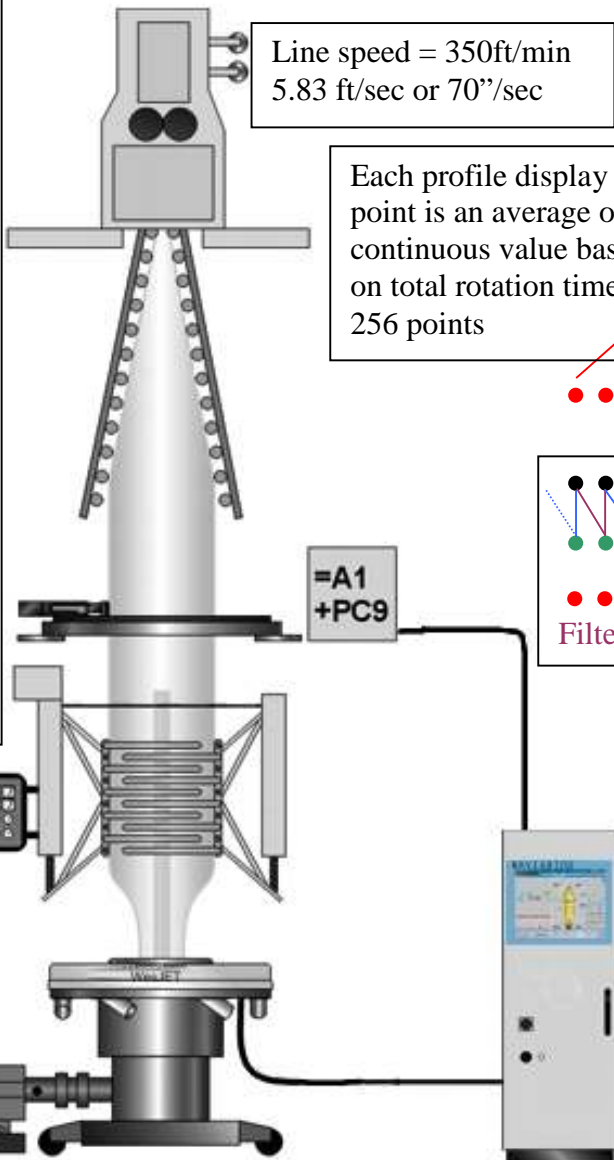


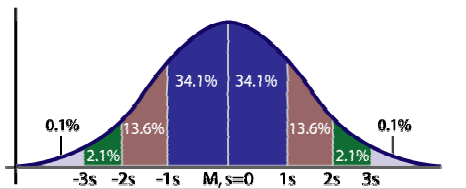
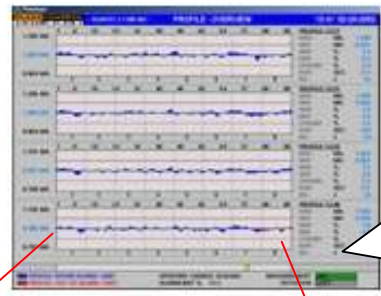
# PROFILE MEASUREMENT FILTERING

**Example**  
 6 samples per second  
 16 min/rotation  
 960 sec/rotation  
 5,600' film/rotation  
 5,760 average measurements/rotation  
 256 display points / rotation  
 1 display point/3.75 sec  
 1 display point/262.5" in machine direction (21.875')

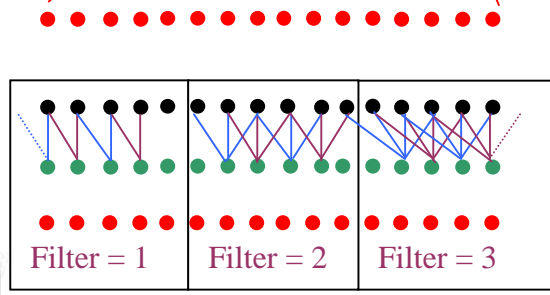


Line speed = 350ft/min  
 5.83 ft/sec or 70"/sec

Each profile display point is an average of a continuous value based on total rotation time / 256 points



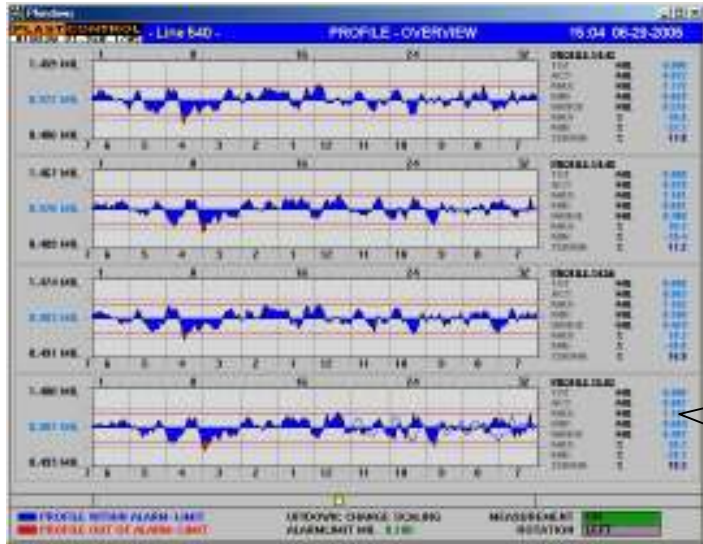
0 Sigma = 100% of points used  
 1 Sigma = 68.28% of points used  
 2 Sigma = 95.46% of points used  
 3 Sigma = 99.73% of points used



256 profile display points  
 Filter value = 0  
 256 raw measurement point  
 256 filtered values  
 256 profile display points  
 Filter selection 0 to 20

Filter = 0 – each individual point is displayed directly  
 Filter = 1 – each point plus 1 point to the left is averaged together  
 Filter = 2 – each point plus 1 point to the left & right are averaged together  
 Filter = 3 – each point plus 2 points to the left & 1 point to the right are averaged together  
 Filter = 4 - each point plus 2 points to the left & right are averaged together  
 Filter = 5 – each point plus 3 points to the left & 2 point to the right are averaged together  
 :  
 Filter = 20 – each point plus 10 points to the left & right are averaged together  
 Filter range is 0 to 20

## PROFILE MEASUREMENT FILTERING



Parameter	Unit	Value
TGT	MIL	0.900
ACT	MIL	0.987
MAX	MIL	1.191
MIN	MIL	0.694
RANGE	MIL	0.497
MAX	%	20.7
MIN	%	-29.7
2SIGMA	%	18.2

- Changing the filter value will effect the thickness MAX / MIN / RANGE and the percentage MAX /MIN values along with the actual profile being displayed.
- Changing the filter value generally requires adjusting the PMBOOST parameter to calibrate to off-line value.
- Changing the Sigma selection will only change the Sigma displayed % value and leave all other values unchanged.

# PROFILE MEASUREMENT FILTERING

Phindows		PLAST CONTROL - Line 539 -		PARAMETER PROFILE DISPLAY		14:07 05-09-2005	
		EXIT					
PDSCREWS	12		(0/128)	[ 4]	number of screws xx.x (0=disable)		
PDZONES	32		(0/128)	[48]	number of zones xx.x (0=disable)		
PDSCALE0	10.00		(0/200)	[ 5]	scaling factor 0		
PDSCALE1	20.00		(0/200)	[10]	scaling factor 1		
PDSCALE2	30.00		(0/200)	[20]	scaling factor 2		
PDSCALE3	50.00		(0/200)	[30]	scaling factor 3		
PDALARM	0.00		(0/200)	[ 0]	alarm limit (ref. OK14)		
PDFILT	2		(0/20)	[ 2]	filter grade (0=no filter) (ref. OK02)		Filter selection parameter
PDFLSCR	1		(0/1)	[ 0]	flip screws (mirror)		0 = no filter 1 = 2 points averaged 2 = 3 points averaged 3 = 4 points averaged 20 = 21 points averaged
PDSTSCR	66.00		(0/96)	[ 0]	start screws xx.x {screws}		
PDFLCIRC	0		(0/1)	[ 0]	flip circle graphic (mirror)		
PDSTCIRC	192		(0/255)	[ 0]	start circle graphic (rotation)		
PDTEMP	0		(0/999)	[ 0]	1'=display film-temp 10'=disable Temp in STATUS		
PDABSVAL	13		(0/999)	[ 1]	1'=abs prof. (0=off/1=act/2=tgt/3=chd) 2'=tgt+act4STS		
PDSIGMA	0		(0/5)	[ 2]	# sigma for display (0=2sigma, 4=100%, 5=off)		Sigma calculation parameter
PDSETUP	1111		(0/9999)	[ 0]	1'=MCMnAbs 10'=AbsMyTgt/TptHi 100'=sigma4tnd 1000'=Mue		0 = 2 Sigma 1 = 1 Sigma 2 = 2 Sigma 3 = 3 Sigma 4 = 0 Sigma 5 = off
PDSCAFFT0	2.00		(0/200)	[ 2]	scaling factor 1 for profile analyse		
PDSCAFFT1	4.00		(0/200)	[ 4]	scaling factor 2 for profile analyse		
PDSCAFFT2	6.00		(0/200)	[ 6]	scaling factor 3 for profile analyse		
PDSCAFFT3	8.00		(0/200)	[ 8]	scaling factor 4 for profile analyse		