PLAST-CONTROL
TOLERANCE CORRECTION PROCEDURE
FOR PROFIL AND PRO-JET/PRO-CON

The purpose of this document is to give a precise procedure to correct the minimum and maximum tolerance range displayed on the PROFIL and PRO-JET/PRO-CON.

Setting the minimum and maximum tolerance range

1) The first step is to record the tolerance range value being displayed by the Plast-Control computer as you finish a roll.
2) The second step is to determine your tolerance range value from your end of roll sample using accurate offline measuring equipment.
3) The third step is to determine the difference between the Plast-control displayed value of the tolerance and the offline value of the range.
4) The formula used to determine this difference is:

    Offline tolerance / Plast-Control tolerance x old Pmboost value

5) The parameter is located by selecting service > password of 1 > parameter service > parameter profile for the correct line > parameter measure > Pmboost
6) After changing the parameter, allow for the next EOS signal for the profile to be updated and show the correct tolerance value. If the results are correct, the parameter must be saved.
7) To save the parameter, you must select service > password of 1 > parameter service > parameter user save and press enter. The computer should say at the top of the screen in a white box "parameters saved ok".

EXAMPLE:

Plast-Control tolerance is 8.2 (2 sigma)
Offline measurement shows the range to be 8.6 (2 sigma)
The Pmboost is set to 125
The difference is calculated out with the formula:
    Offline tolerance / Plast-Control tolerance x Pmboost value

8.6/8.2 = 1.0488 which is 4.9% difference   1.0488 (125) = 131.1

The new value for Pmboost is 131.1 and will increase the min/max tolerance to equal the offline tolerance values. These changes will be reflected in the next profile update.