

Brief instructions



Software IPCS

iret

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1	IPCS – Iret Pipe Cutting Software	5
1.1	Installation and licensing	5
1.1.1	Installation	5
1.1.2	Licensing	5
1.2	Main window	6
1.3	Machine configuration	6
1.4	Select Production Mode	7
1.5	Production Mode “0 List production”	8
1.5.1	Select article list for production	8
1.5.2	Production	9
1.6	Production Mode “1 Spreadsheet production”	9
1.6.1	Using a barcode scanner to load jobs	10
1.7	Create an new or edit an existing material	11
1.8	Inkjet options	12
1.9	Configure inkjet printers	12

Inhaltsverzeichnis

1 IPCS – Iret Pipe Cutting Software

1.1 Installation and licensing

1.1.1 Installation

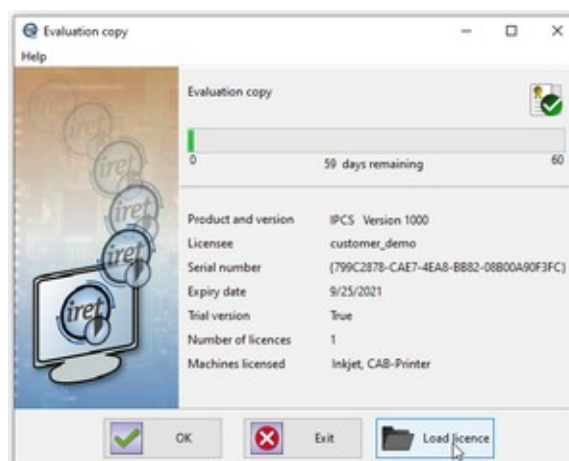
First run the program "IPCS_X_Y_Z_setup.exe" (X_Y_Z represents the version number of the program) and follow the steps of the installation wizard.

- Recommended is the installation to "c:\ipcs\".
- Write permissions are required in the program folder even during operation



1.1.2 Licensing

When the program is installed, a time-limited demo license is automatically activated. When the program is started, the remaining trial period and further license information are displayed.

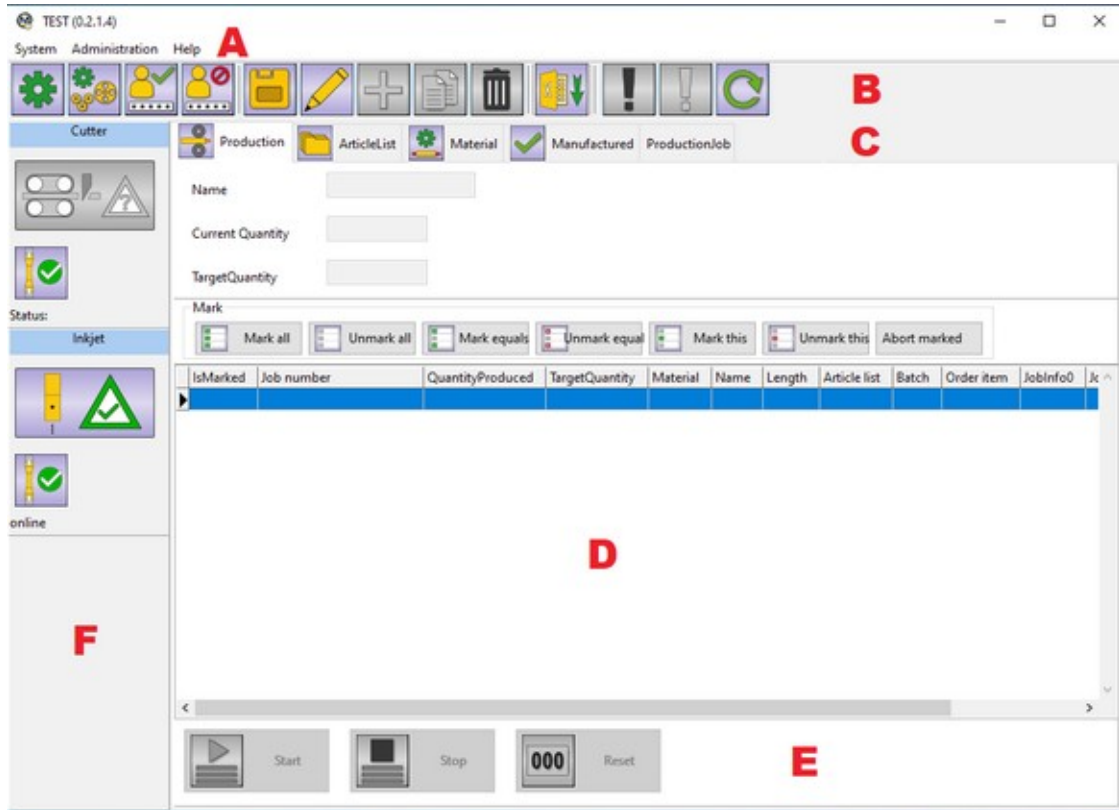


Note: Press the "Load license" button and load the purchased license file ("license_....zip"). You can also activate the license at any later time from the running program.

1 IPCS – Iret Pipe Cutting Software

1.2 Main window

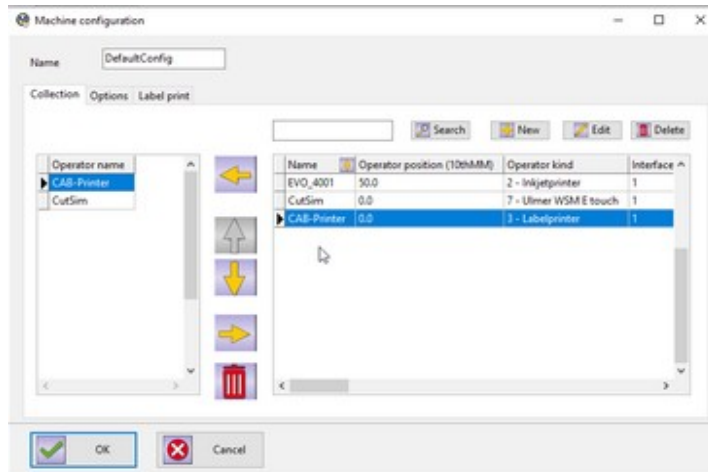
On the main window, the elements for controlling the IPCS software are arranged in groups.







Group	Description
A Main Menu	Setup machine and user configurations. Invoke help and maintenance menu items.
B Toolbar	Buttons for frequently used operations: Edit materials, lists, settings, configurations
C Workflow control	Create / edit production lists, article lists, materials, marking texts, labels
D Detail view and selection	Detailed tabular view of article lists, production lists, materials. Selection of list entries.
E Production control	Start, stop, reset production
F Machine configuration	Shows machines in use (printers, cutting machines etc) and their statuses (ready, not ready ; connected, not connected)

1.3 Machine configuration

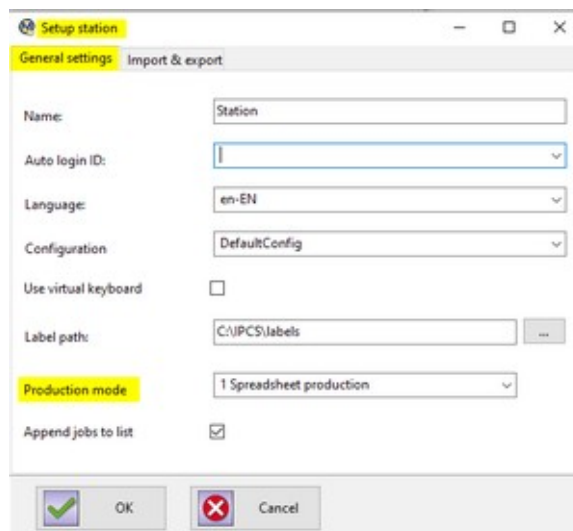
Select “Machine configuration” from main menu or click button “gear wheels” in the toolbar to enter the machine configuration window. Create machines or edit properties of existing machines and add them to the machine collection.



Button	Function
	Add machine to collection
	Remove machine from collection
	Change machine position (move upwards or downwards)
	Remove all machines from collection

1.4 Select Production Mode

To select the production mode enter the setup by clicking on the leftmost green “gear” symbol in the toolbar or select “Station Settings” under “System” in the main menu. Under “General settings” chose the production mode:



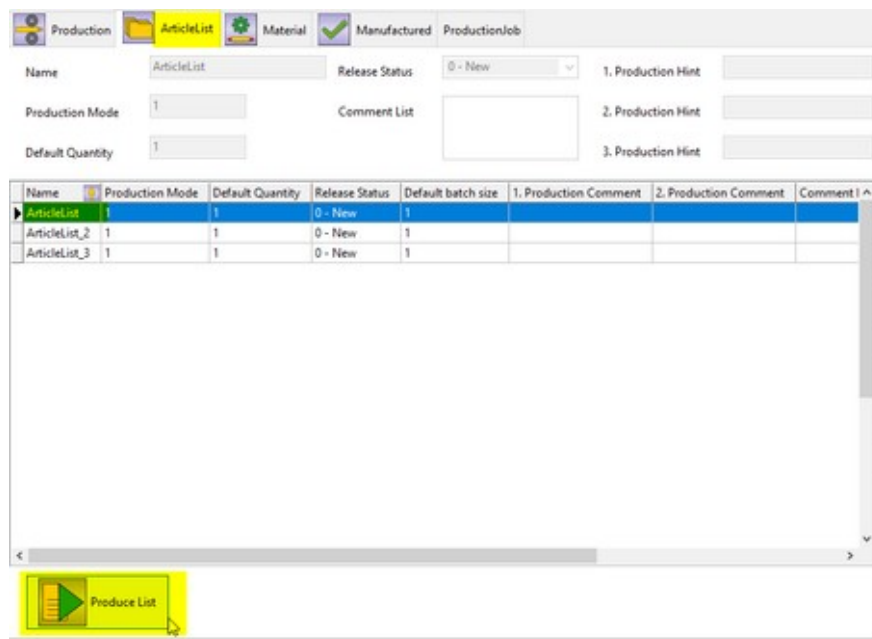
Function	Description
0 List production	Create article lists and bring them into production. Description see Chapter 1.5.
1 Spreadsheet production	Import prefabricated production spreadsheets (Excel format etc.). Import via barcode scanner is supported. Description see Chapter 1.6.
Append jobs to list	This option is only available in Production Mode “1 Spreadsheet production”. If this option is checked, the import will be added to the production list. If this option is unchecked, the list is emptied before a new import.

1.5 Production Mode “0 List production”

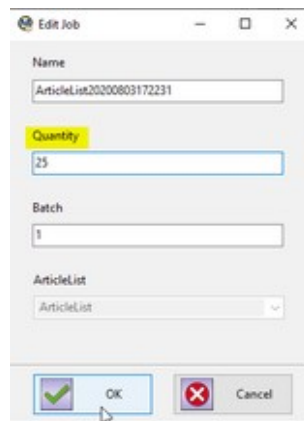
In this mode, articles can be compiled into article lists and these lists can be added to the production queue.

1.5.1 Select article list for production

Here existing article lists can be added to the production queue.



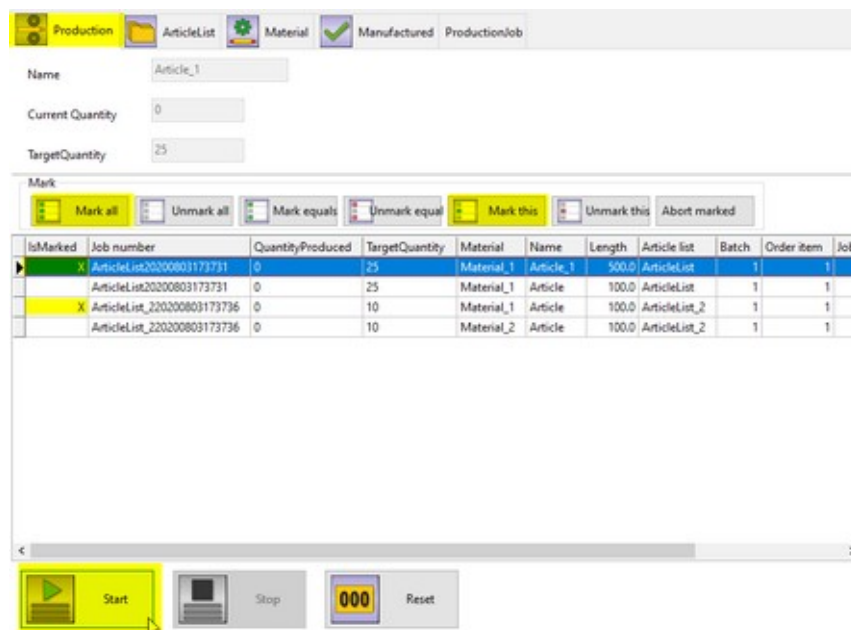
Select tab “**ArticleList**” and select the article list to add to production from the table (mark with mouse). Then click button “**Produce List**” to add the selected list to production.



Select **quantity** to produce and press “OK”.

1.5.2 Production

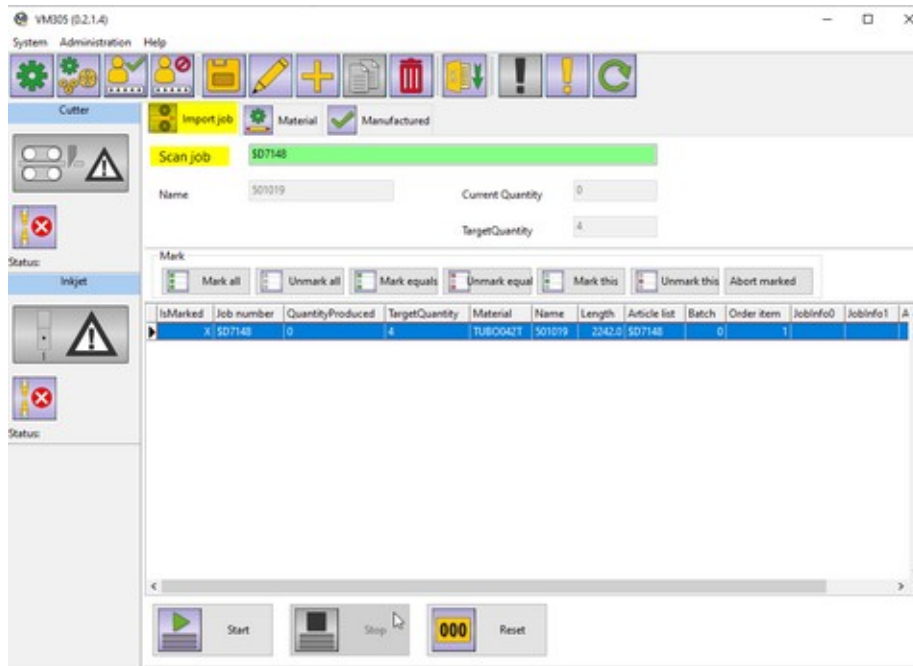
Select tab “**Production**” to show a tabular view of all article lists and all articles ready for production.



Select the articles to be produced (for example use “**Mark all**”, “**Mark this**”, etc.) from the list and click button “**Start**” to start production.

1.6 Production Mode “1 Spreadsheet production”

If this mode is chosen in the station setup, select the “**Import job**” tab to import prefabricated job spreadsheets (Excel format etc.). Enter the job file name in the “**Scan job**” input line or use a barcode scanner.



The input line is highlighted:

Color	Meaning
Green	A unique job file was found in the import directory. The job is imported and all job items are marked and ready for production.
Yellow	There are more than one possibly matching job files in the import directory. The selection is not unique.
Red	No possibly matching file was found in the import directory.

If you want to import more than one job, check the option “Append jobs to list” in the station setup, see Chapter 1.4.

1.6.1 Using a barcode scanner to load jobs:

Select “Setup station” / “Import & export” to alter the barcode scanner options.



Scan mode determines how a scanned job name is treated:

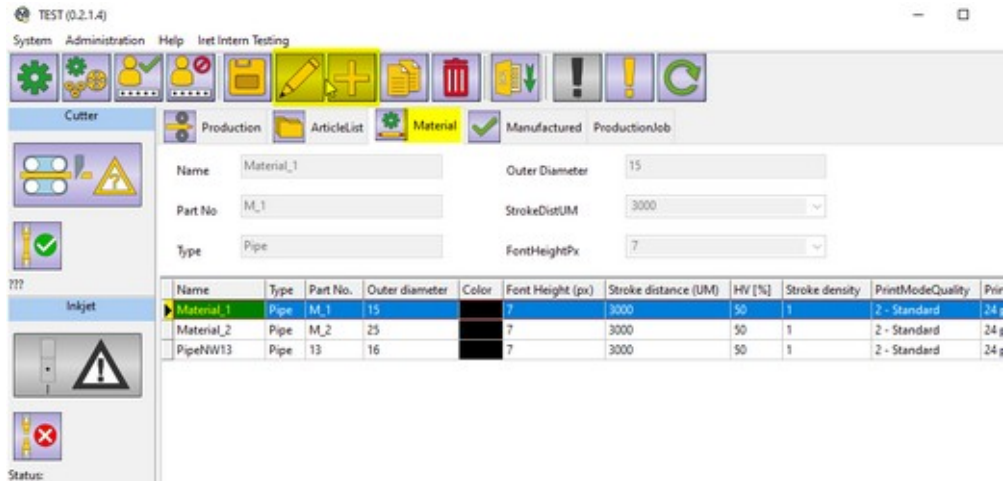
Function	Description
0 Exact match	The job name must match a stored job in the import directory exactly.
1 Filename may be longer	It is sufficient to scan as many characters until the job name is unique.

Scanner operation determines the behavior of the scanner:

Function	Description
0 Load job immediately	A job is automatically loaded as soon as a unique assignment exists. This setting should only be used if the scanner does not generate <CR> characters.
1 Press <ENTER> to load job	The loading of a file must be confirmed with <Enter>. This is the default setting.

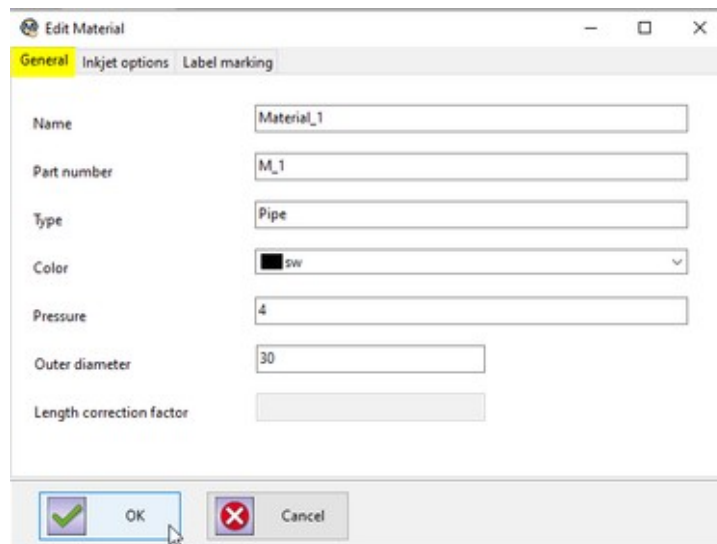
1.7 Create a new or edit an existing material

Regardless of the production mode, material properties can be edited any time.



Select tab “Material”, select an existing material from the table and click “Edit” (pencil symbol) or click “+” (plus symbol) to create a new material.

Select tab “General” to enter general material settings



Function	Description
Name	Enter a material name
Part No	(x)
Type	So far only "pipe" is supported (x)

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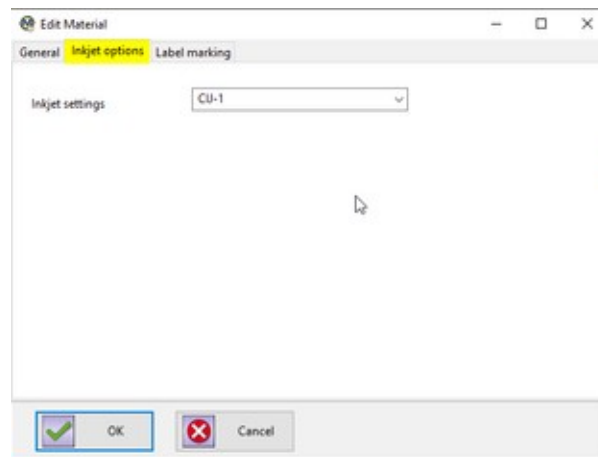
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Function	Description
Color	(x)
Pressure	(x)
Outer diameter	(x)
(Length correction factor)	(In this program version without meaning)

(x): This value is for user information only, but has no further significance for the program flow.

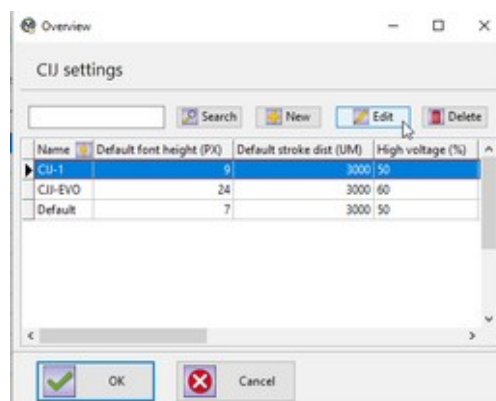
1.8 Inkjet options

Select tab “**Inkjet options**” to chose one of the configured inkjet printers from the list (see chapter 1.9).



1.9 Configure inkjet printers

From the main manu chose “Administration” / “CIJ settings” to create or alter a CIJ printer.

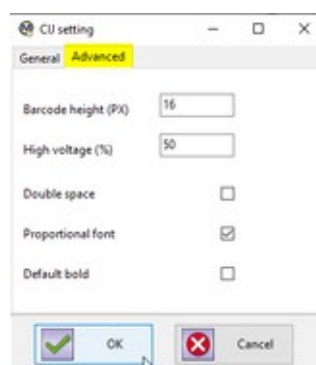


On the “General” tab enter the base inkjet settings.



Function	Description
Name	Enter an arbitrary printer name (see chapter 1.8).
Default stroke dist (UM)	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.
Default font height (PX)	The height of the default marking font in pixels. This value is included in the calculation of the marking text <i>width</i> . If a font other than the default font is used, this value must be adjusted accordingly.
Print mode 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. Printing quality
Print mode height	<ul style="list-style-type: none"> 0 – automatically: IPCS 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.
Stroke density	The stroke density specifies how black the printout will be. The larger the value the more times a row of ink is repeated. <ul style="list-style-type: none"> Default value is 1 The higher the stroke density the lower the maximum production speed. 1 : Normal, 2 = Bold (double width)

On the “Advanced” tab enter additional settings.



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Function	Description
Barcode height (PX)	Barcode height in pixels, must not be larger than Print mode height
High voltage (%)	This value affects the height of the printout. <ul style="list-style-type: none">• Default value is 50%• < 50%: the distance between two ink drops is decreased, resulting in reduced height of the printout.• > 50%: the distance between two ink drops is increased; the printout will be higher.
Double space	Determines whether spaces are printed twice.
Proportional font	Use proportional font (on selected printers only).
Default bold	Print all texts bold (results in double printing width).