Ink Jet Printing on Artos machines.

REV 3 10/28/2016

Restrictions for Ink Jet marking.

1. DIN style marking cannot be used:
    a. With two label end marking style on MTX or CR11
    b. With two label end marking style on CS326 or CS327 with software older than 6/9/2014
    c. On wires that are doubled (MTX or Cr.11 if doubles are ever implemented there.)
    d. In Jobs
2. In Jobs you should:
    a. Not have parts that have ink jet marking mixed with parts that have no ink jet marking. If you must, put a blank ink jet label on wires that don't need a label.
    b. None of the parts can use DIN mode two label end marking style, ink jet printing.
    c. Not mix Fonts and font sizes.
    d. Try to minimize master stop, wire change and E-stops. Group parts with same wire to minimize wire changes.   Master stop, wire change and E-stop will cause a lead in sequence which creates scrap wire on Cr.11, CS326 and CS327. Not so bad, only 36mm, on MTX.
3. The maximum message length
    a. For MTX and CR11 the maximum length is 35 characters. In end marking you can have a different 35 character message at each end of the wire. In continuous marking you can have one 35 character message.
    In End Double + Continuous Simple (3 labels) the maximum length is 35 characters for all messages.
    b. For CS326 and CS327 software version prior to 6/1/2014 the maximum length is 35 characters. In end marking you can have a different 35 character message at each end of the wire. In continuous marking you can have one 35 character message.
    c. For CS326 and CS327 software version after 6/9/2014 the maximum length is 62 characters. In end marking you can have a different 62 character message at each end of the wire. In continuous marking you can have one 62 character message.

CS326 and CS327 Software version numbers released on 6/9/2014
GUI version for both with 62 character printing is 4.70
Controller Exec:
CS327 – 4.01
CS326 – 4.42