



How to change the cut length scale factor using the EasyRider software:

Note: this only works on machines without a PLC.

First start up EasyRider software and plug into a powered **631 or 637** cutter drive with the programming lead provided with the EasyRider software (serial on computer; Com1 on drive).

If you do not have the original BIAS program on disc, you will have to read the BIAS on the drive and upload it to the computer you are using. To do this:

Go to 'File' top left of the screen and left click to open a pull down menu, Highlight 'BIAS Program' within the menu and a second menu will open, Move the mouse pointer to highlight 'Read BIAS Program' and left click.

Or;

Use the keyboard short-cut Ctrl+F4.

At this stage you may be asked to enter a password, the password is 'level2'.

Note: by uploading a BIAS program from the drive, you will not have any program comments to help you.

If you have the Original BIAS program on disc, then open this file instead by using the option above 'Read BIAS Program' which is 'Open BIAS File'.

OR;

Use the keyboard short cut Ctrl+O.

Then select the file location and open it.



Note: you cannot open a BIAS file outside of Easyrider.

Should you open a BIAS program this way you will have program comments within the program. You will also have to enter the password when you try and download the program to the drive.

Once you have the BIAS program open within Easyrider, you only have to alter ONE variable and this will depend on the program you have.

If you have program comments, (normally shown in green) you will be able to fine the variable from these. The one you would be looking for is called **scale factor for BCD length**. This is normally variable 5 on 631 drives and variable 12 on 637 drives. The value will either be a 3 or 4 digit number. Common values are 396 and 1450.

Once you have altered the scale factor (it is suggested to make an alteration of about +- 100 to determine a rough amount of change required.) you have to download the software to the drive, to do this;

Go to 'File' top left of the screen and left click to open a pull down menu, Highlight 'BIAS Program' within the menu and a second menu will open. Move the mouse pointer to highlight 'Transmit BIAS Program' and left click.

Or:

Use the keyboard short cut F4.

If the password has not already been entered you will be asked here. Next be sure to left click 'yes' at every screen option until load is complete.

It will take trial and error to reach the correct scale factor for the machine, but once the machine has been scaled correctly make a note of the value entered and send the information to Gillard so that the company has an up to date database for future reference. Also be sure to save the altered BIAS program to disc, but comments will only be saved if they are already in the program.



IMPORTANT NOTE:

To be certain you have the correct variables, in the case were you do not have any BIAS comments (you uploaded the program from the drive itself) then you **MUST** contact Gillard with the **SERIAL NUMBER** of the machine in question (XXXX).

Making any other changes may cause the machine to stop functioning OR cause damage to the machine or operator.

ANY changes must be made by a skilled person and with the consent of Gillard.