



Quick Start for TM-45 and TM-65 Fastener Counter

1. Attach black power cord to rear of Electra TM box.
2. Plug into 110VAC power.
3. Plug WORK I/P Plug (plastic stem with connector) into “Work I/P” receptacle on back of Electra TM system.
4. On front of TM box, attach Electra Screwdriver power cord into receptacle on lower-right side.
5. Turn power on to TM system (will also power Electra Screwdriver).
6. Press “Set” button on front of the Electra TM system.
7. Password will be requested. Press keys in this combination “+ + - - SET DETECTOR”.
8. Press “SET” three (3) times.
9. On screen **3-1.SAMPLE TIMES**, use “+” or “-” keys to scroll up or down to desired number of sample runs that will be used to set up the system. The larger the number, the more accurate the sampling will be and the tighter the tolerance on the box can be set. Twelve (12) is a good place to start. Press “SET” when the desired number is on the screen.



On screen **3-2.SAMPLES**, it will display 0/xx with ‘xx’ being the number of samples from the previous screen.

Begin the sample gathering by running the Electra Screwdriver exactly as the operator will on a production quality application. At the end of each rundown, the Electra TM system will request an entry of the “+” key if the sample ran as expected with no known problems or an entry of the “-” key if the sample run had an operator error or some other difficulty. Repeat this process until ‘xx’ number of good samples has been recorded based on ‘xx’ being the number of samples desired (xx/xx). Hit “SET” to complete.

10. On screen **4-1.RANGE RATE**, use the “+” or “-” keys to adjust the value to the + tolerance of the assembly task. Be sure to take the application dynamics into account as the material variances will contribute to how accurate the assembly job can be performed. A good strategy is to start at +10% and then adjust as the product quality sampling dictates. Hit “SET” to complete.
11. On screen **4-2.RANGE RATE**, use the “+” or “-” keys to adjust the value to the - tolerance of the assembly task. Be sure to take the application dynamics into account as the material variances will contribute to how accurate the assembly job can be performed. A good strategy is to start at +10% and then adjust as the product quality sampling dictates. Hit “SET” to complete.
12. On screen **5.PCS/UNIT**, use the “+” or “-” to select how many screws per work piece are to be monitored. If the operator is installing four (4) screws into a phone, for example, then this screen should be set at four (4). The unit will then count how many good phones pass through the station. Hit “SET” to complete.
13. Press “DETECTOR” and the system will be ready to run and monitor fastening.
14. For additional options and detailed descriptions of each menu screen, please see the Electra TM Instruction Sheet packaged with the Electra TM system.