MiTek Service Bulletin

Document ID:

Install Moxa UPort to Replace *Teguar*® Splitter

Affected machinery: Cyber® A/T Component Saw

Distribution: All customers with affected machinery

Applies to: *Cyber A/T* machines with a printer- Frames 743 and up, or older frames if replacing the PC

CAUTION: MiTek recommends printing	Part # and Rev.	SB267 rev. A
this document in high resolution using color ink.	Print Date	7 May 2024
Many of the graphics may be	Effectivity	See above
unsafe condition if this	Revision Date	7 May 2024
followed.	Revised By	M. Farmer
MiTek Automation	Orig. Release Date	25 April 2024
Phone: 800-523-3380	Created By	M. Farmer
Fax: 636-328-9218 www.mitek-us.com	Approved By	R. Tucker

Copyright © 2024 MiTek[®]. All rights reserved.

Purpose and Scope

This service bulletin instructs how to replace the serial port splitter on a Teguar touch screen computer with a Moxa UPort used in the equipment referenced on the title page.

Overview

Parts Included

The parts included in this kit are shown in Table 1. Please make sure all parts and supplies are present before starting the procedure.

Table 1:	Parts in S	SB267

Quantity	Description	Part #
1	USB Drive with Moxa Drivers	92355
1	Moxa UPort 1250	005-06180
6	Cable Ties 7.25"	508704
1	Service bulletin document	SB267

If you have any questions, call MiTek Automation Support at 1-800-523-3380.



Supplies Needed

- Small Phillips head screwdriver
- Small slotted screwdriver

Procedure

	ELECTROCUTION HAZARD.
	All electrical work must be performed by a qualified electrician.
<u>_</u>	If it is absolutely necessary to troubleshoot an energized machine, follow NFPA 70E for proper procedures and personal protective equipment.
	Pneumatic and hydraulic components may move unexpectedly if not de-energized. Physically restrain any components capable of movement when working on or near those components.



Upon receiving this kit

 Open the supplied Moxa UPort by using a small Phillips head screwdriver to unscrew the two screws on the sides of the box, shown in Figure 1. Figure 1: Moxa UPort Screw Locations



2. Locate the DIP switches and slide them away from the ON position. Figure 2: DIP Switches



3. Replace the cover on the Moxa UPort.

Removing the *Teguar* Splitter

- 1. Close the *Cimplicity*® program on the touch screen.
- 2. Open the PC enclosure and locate the splitter shown in Figure 3. Figure 3: *Teguar* Splitter



- 3. Using a small flat head screwdriver, unscrew and unplug the splitter from the back of the touch screen computer, then unscrew and unplug all connections to the splitter.
 - The splitter is yours to keep.
- 4. Plug in the supplied USB Drive with Moxa Drivers to any USB port located on the back of the touch screen computer.
- 5. Go to the touch screen.

Re-Assigning the Ports

1. Navigate to the device manager by typing "Device Manager" into the search bar.

Figure 4: Search for Device Manager on Windows 10





- Open the Ports (COM & LPT) drop-down and look for COM3. If COM3 is not assigned to any communications port, go to Installing the Moxa on page 9. If COM3 is assigned to anything, continue to Step 3.
- 3. Right-click on Communications Port (COM3).

Figure 5: COM3 in the Ports Drop-Down Menu in Device Manager



4. Select Properties.

Figure 6: Select Properties



5. In the Communications Port (COM3) Properties window, select **Port Settings**.

Figure 7: Select Port Settings

Commun	nications Port	t (COM3)	Propert	ies		×	
General	Port Settings	Driver	Details	Events	Resources		
	C/ icat	ions Port	(COM3)				
	De type	: Po	orts (COM	& LPT)			
	Ma cture	er: (S	tandard p	ort types)			
	Loc 1:	or	I/O LPC	Controller set Family	r - 9D84 for Inte	I(R) 300	
Devic	e sta						
)This	device is work	ing prope	rty.			 	
						~	
					OK	Cancel]

6. Select Advanced.

Figure 8: Select Advanced

Communi	cations Port	(COM3)	Properti	ies		×
General	Port Settings	Driver	Details	Events	Resources	
		Bits pe	er second Data bits Parity Stop bits	: 9600 : 8 : None : 1		> >
		Flo	w control	None		\sim
			Ac	Ivanced	. Restore D	lefaults
					ОК	Cancel

 Click the drop-down menu for COM Port Number and select the next unused COM port. This will most likely be COM8.
 Figure 9: Go to COM Port Number Drop-Down Menu

Communications Port	t (COM3) P	roperties			×			
Advanced Settings fo	or COM3							×
Use FIFO by Select lower Select highe Receive Buffer: Transmit Buffer:	uffers (requir r settings to er settings fo Low (1) Low (1)	es 16550 co correct conr r faster perfo	ection problem mance.	T) 18.	•	High (14) High (16)	(14) (16)	OK Cancel Defaults
COM Port Number:	COM3	~						
			ОК	Cancel				





8. Click **OK** on the Advanced Settings for COM3 window and on the Communications Port (COM3) Properties window.

9. Repeat Step 2 through Step 8 to reassign COM4 to the next unused port. Figure 11: COM4 in the Ports Drop-Down Menu in Device Manager



10. Do not exit the Device Manager.

Installing the Moxa

- 1. In the file manager of your touch screen computer, navigate to the USB drive.
- 2. Double click on the Moxa driver file located on the USB drive.
- 3. Complete the installation using the Windows Install Wizard.
 - No settings will need to be changed during the install.
- 4. When the *Install Wizard* has finished, return to the PC enclosure.
- Plug the serial connection for the inker into the Moxa UPort Port 1. If applicable, plug the serial connection for the catcher into Moxa UPort Port 2.

Inker Serial Connection Port 1 (Inker) Port 2 (Catcher)

Figure 12: Inker Serial Connection Plugged into Moxa

- 6. Plug the Moxa UPort into any USB port on the back of the touch screen computer.
- Connect two of the provided cable ties together to create one long cable tie. Secure the Moxa UPort using two long cable ties, as shown below in Figure 13.

Figure 13: Moxa UPort in Place

- 8. Navigate to the Device Manager on the touch screen. Ensure that Moxa Port 1 is assigned to COM3 and Moxa Port 2 is assigned to COM4.
- 9. If the Moxa ports are <u>not</u> assigned to COM3 and COM4, follow the instructions on page 4 to open the COM3 and COM4 ports. Then, using those instructions, assign Moxa Port 1 to COM3 and Moxa Port 2 to COM4.
- Once the ports are correctly assigned, close the Device Manager. Safely eject the USB Drive, then shut down the touch screen computer.
 Figure 14: Safely Eject USB Drive



- 11. Unplug the USB drive from the back of the touch screen computer.
 - The USB drive is yours to keep.
- 12. Restart the entire machine and any auxiliary components.

Adjusting the Cimplicity® Software

- 1. Open the Cimplicity® program.
- 2. Click the **Automatic** button on the screen. Figure 15: Automatic Button



3. Click the **Inker** button. Figure 16: Inker Button

ew H	lelp											
				ENCODERS	E ME	RGENCY 2		VFD POS		STATUS	-	ALARMS
	Cuantity Set SET 1	Job # 3844431-JI Size 2 x 4 Filename: 38444	31-Jig01	Truss F03L Stock 6	ARE IN	POSITION	lember ength	T2 5 - 10 - 00)	MAIN	MENU	
	DONE In 0 Out 0	Set Point	4				A	Set Point		ST	OP	
	View Saw	Biade 1	90.0	2.12	•	3.00 2.12	90.0 90.0	Blade 5		Mor	e	
		Blade 2	90.0	3.08		0,12	90.0	Blade 3				
	Infeed Speed 65 % 100 80 60 60 40	6	Lumb	er Grade: A S	NO.28	P			5	Initiate	Setup	
	20 0	2 Current Cut #:	6				Total C	suts: 6	4 3	STA	ART	
	Mode: 0			AUT	OM/	ATIC			Inker	BL OU	ADE RUN T OF CUT	

4. Click **Setup** and select **Port**.

Figure 17: Inker Setup

Port		Stage
Printer		Start
<length></length>		Clear - Pause
<qty></qty>		Restore - Continue
Current Queue:	Next Queue:	Manual
	1:T2 :F03L	Send
		CIr In Buffer
		Flush
		Minimize
Port Settings:	Status:	
Port=3 19200,n,8,1	Ready	ShutDown

5. Click the drop down menu for **Comm Port** and select **3**. Then click **Done**. Figure 18: Comm Port Drop Down Menu

Baud Rate	
Data Bits	
Parity None	
Stop Bits 1	

6. Click Minimize.

Figure 19: Minimize Button Location

Tour		Stage
Printer		Start
<length></length>		Clear - Pause
Qty>		Restore - Continue
urrent Queue:	Next Queue:	Manual
	1:T2 :F03L	Send
		CIr In Buffer
		Flush
		Minimize
at Catting and	Status:	L
ant Catting and	Status:	L

7. If applicable, click the **Catcher** button. Figure 20: Catcher Button Location



8. Click **File** and select **Setup Comm Port**. Figure 21: Catcher Display

ile <u>H</u> elp		
Setup Display Setup <u>C</u> omm Port		Stage
End	Next Queue	Start
		Clear
		Minimize

9. Click the drop down menu for **Comm Port** and select **3**. Then click **Done**. Figure 22: Comm Port Drop Down Menu

Hardware	Flow Control	Flow Control Hardwa	are Options	
Red Lion	F Hardware (RTS/CTS)	F Set DTR High		
C Vorne M1000	■ Software (XON/XOFF)	₽ SetRTS High		
Communications Settings		Protoce: settings		
Comm Port	<u>4</u>	Sync String		□ Enabled
Baud Rate	1 2 3	LineFeed String	^ +	✓ Enabled
Data Bits	4 5	End String	*	
Parity	67	Line Length	20	I Enabled
Stop Bits		-Signal Options		
		500 U Limit	t Switch Debounce	Time (milliseconds)
		L		Ĩ
			Help	Done

10. Click Minimize.

Figure 23: Minimize Button Location

