



Maestro active cut

Information to the sales network

Strictly reserved to the sales network of SCM

August, 2019

THE STRONGEST WOOD TECHNOLOGIES ARE IN OUR DNA



TWO HORIZONTAL INNOVATIONS



New horizontal **Human-Machine interface software (HMI)**, which has been unified across all SCM technologies.



IoT platform enabling value-added **services** for the customer.





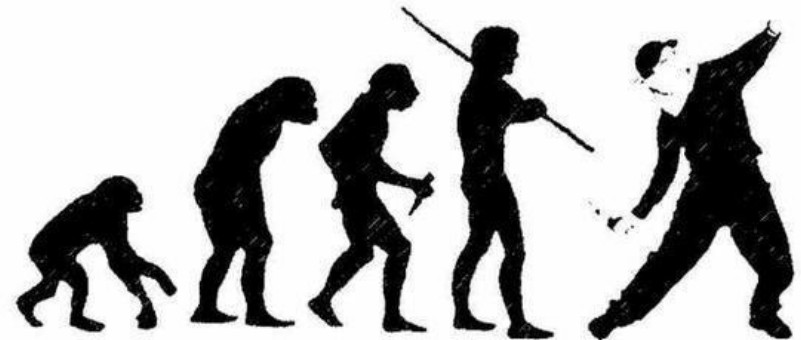
Maestro active is the new horizontal operator interface software which has been unified across all SCM technologies. **A single operator can easily and confidently run multiple machines** due to controller and interface consistency: regardless the machine, **Maestro active** maintains the **same look&feel**, with many **identical icons** and navigation buttons, thus ensuring the **same approach to interaction**.

FROM TODAY ANYONE CAN “DRIVE” A SCM MACHINE!

Maestro active cut – Evolution or Revolution??

Evolution

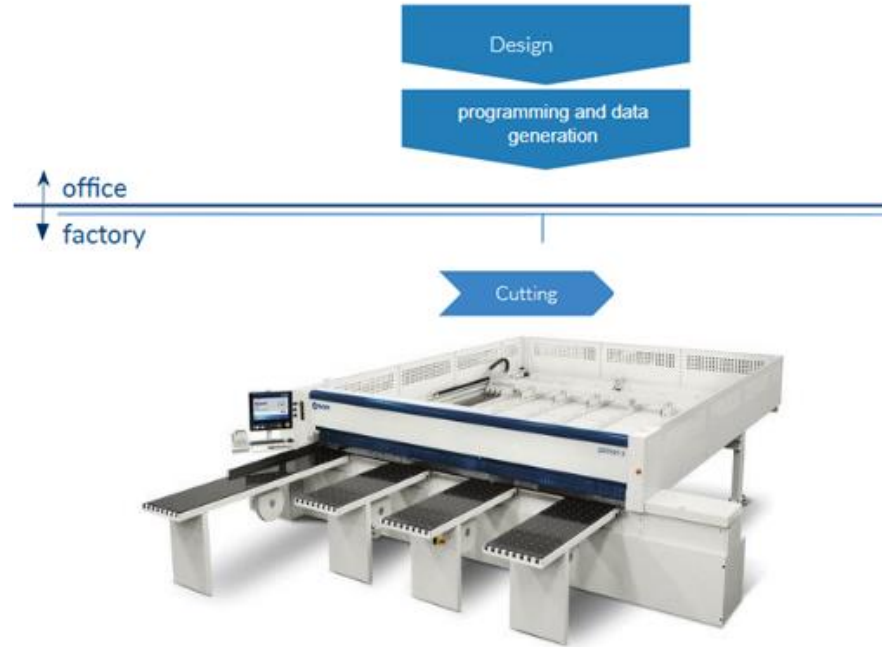
Maestro active in the field of the beam saws represents the point of arrival of a path started 2 years ago with Maestro cut.








REVOLUTION

Maestro active cut

HMI SW POSITIONING



TOP 5 QUALITIES

-  **1** **DEEP.** Lots of features, lots of functionalities
-  **2** **INTELLIGENT.** “Somebody understood my problem”
-  **3** **COMPLETE.** Not just a machine control
-  **4** **EMPOWERING.** Makes customers more productive, it enhances customers
-  **5** **ELEGANT.** Cares about the user interface.

1. Minimal

WHAT WAS WRONG

"They are used so rarely that always displaying them only takes away space."

The old HMI, often too full of components, disoriented and blocked the operators.

1. Minimal
- 2. Readable**

WHAT WAS WRONG

"If they wrote it smaller, not even the screen pixels were enough!"

Features of the old HMI:

- The used font was too small and only visible closely
- Lists and tables were not easily readable
- Alarms and notification were not enough visible

DESIGN PRINCIPLES

1. Minimal
2. Readable
3. Horizontal

WHAT WAS WRONG

"It is not clear what happens by clicking on the tool room button, since it has two different functions"

In the old HMI, similar buttons had different behaviour

DESIGN PRINCIPLES

1. Minimal
2. Readable
- 3. Horizontal**
4. Smart

WHAT WAS WRONG

"You know it by heart or go get the paper."

The old HMI for machining centers required the operator to enter ISO codes and tool codes to complete some procedures and operations.



offline

100%

	Carro Lama	Spintore	Lama
Velocità	0 M/min	0 M/min	0 Rpm
Quota	0 mm	0 mm	0 mm

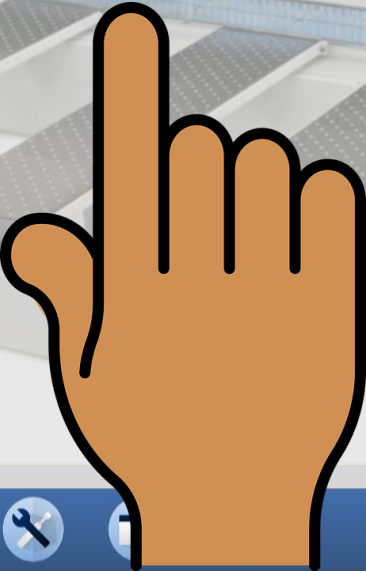
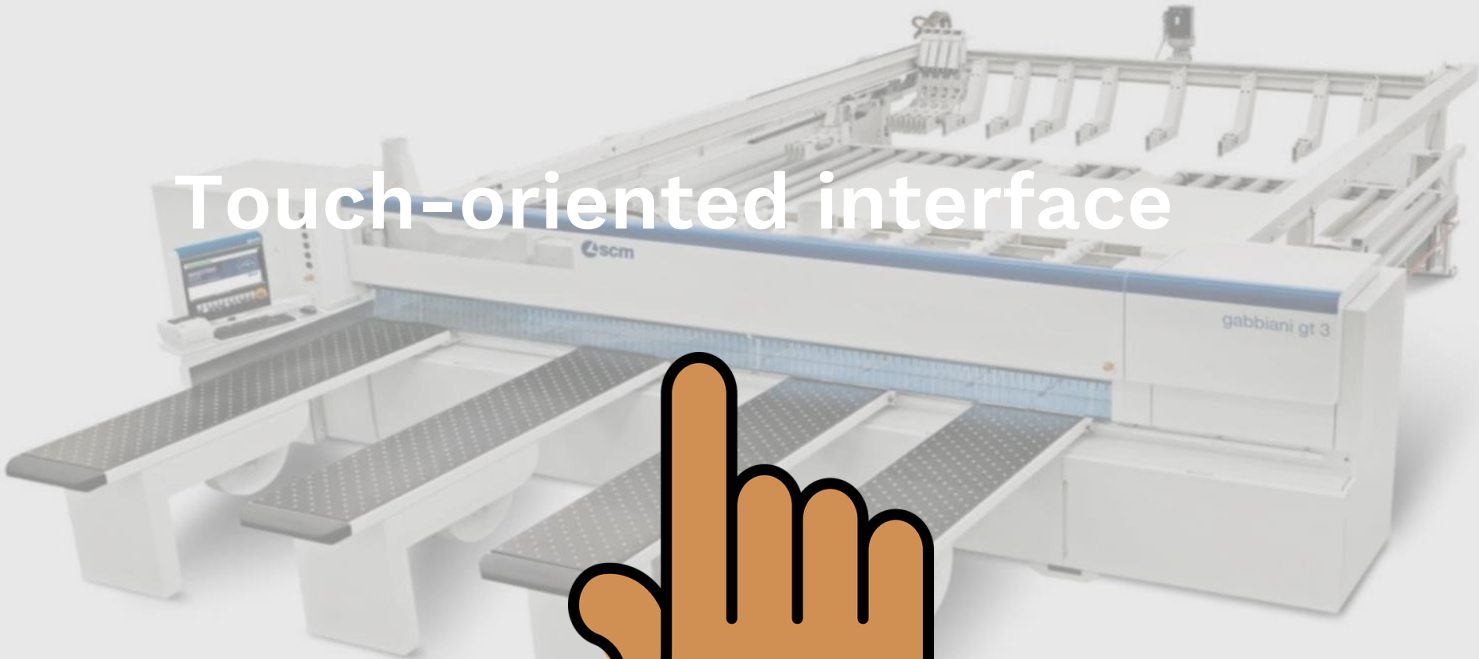


09:57



Saw blade speed

Touch-oriented interface



Editor Programma 

Descrizione	Formato	Tipo	Lunghezza	Larghezza	Spessore	Swap
<input type="text"/>	<input type="text"/> 	<input type="text"/> 	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="checkbox"/> OFF

Maestro active – USER EXPERIENCE

Select a format or create a panel to start

Specific functions (commands, report, etc...)

Salva Carica

Saw blade speed

Manual

- Beam saw
- Pusher
- Saw carriage
- Grooves
- RegolazioneBatt

- Cerca...
- 3 Accensione Lama
 - 4 Accensione incisore
 - 5 Spintore ABS
 - 6 Spintore ABS + taglio
 - 7 Spintore INC + taglio
 - 11 Apertura/Chiusura pinze
 - 17 Salita/Discesa protezioni
 - 19 Salita/Discesa pressore
 - Salita/Discesa lama

Blade switch on

Machine parameters, manual controls

Saw blade speed

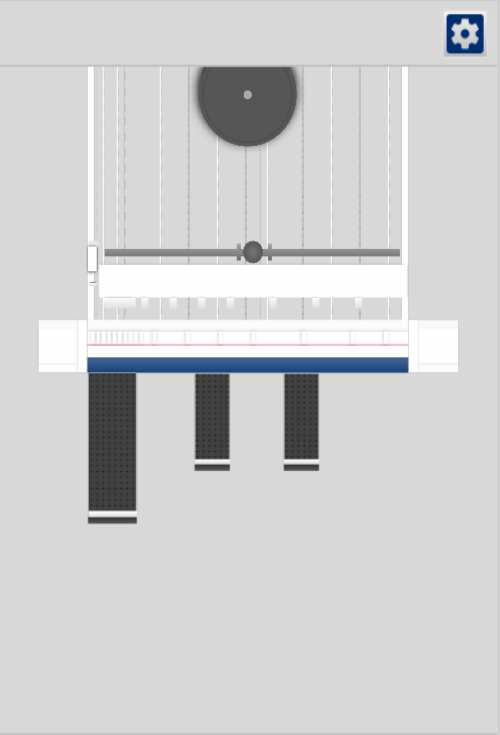
Production



Coda →

Show programs executed

Execution	Finished workpieces	Semi-finished work pieces
-----------	---------------------	---------------------------





offline

100%

Carro Lama Spintore Lama
 Velocità 0 M/min 0 M/min 0 Rpm
 Quota 0 mm 0 mm 0 mm



10:08



Saw blade speed

Paddle

PADDLE

The Paddle allows the commands sending commands to the machine regardless of the machine state and the functionality that is being performed. Inside the paddle there is a set of commands expressed in the form of graphic icons that the user is able to interact and select.

Show programs executed

Execution

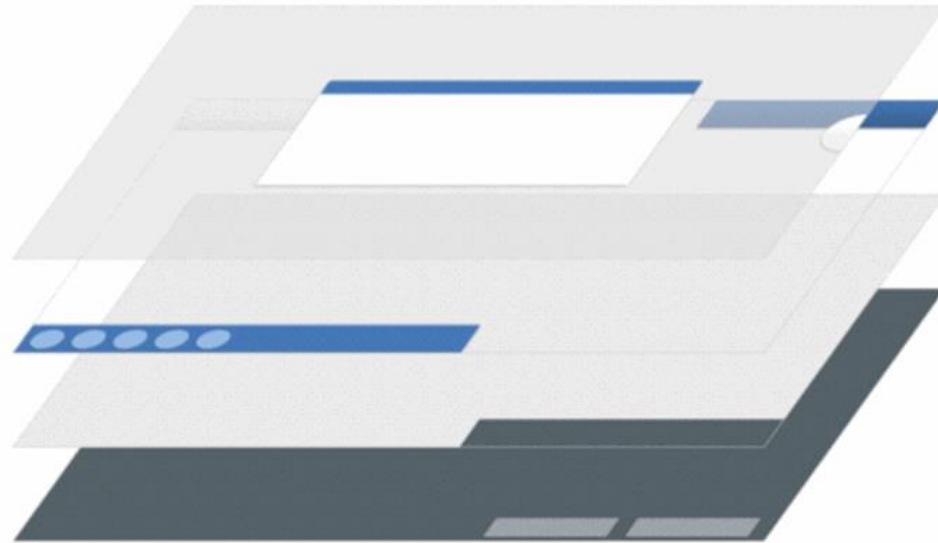
Finished work pieces

Semi-finished work pieces

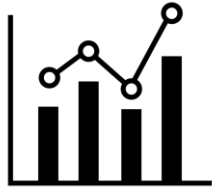
Control panel for the Paddle interface, featuring several interactive elements:

- Two large circular buttons at the top.
- A slider control for "Velocità Carro Lama" (Carriage Speed) set to 100%.
- Buttons for "Clamps opening" and "Clamps closure".
- Buttons for "Scorer enabling" and "air tables".





HORIZONTAL FUNC



Reports



Alarms/warning
signalling



Maintenance
Management



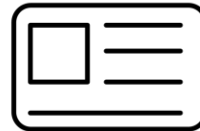
Users and access
management



Shifts
management



Languages
management



Machine master data

History **recording** concerning:

1. Production
2. Events
3. Alarms

Ability of reports **export** in xls format





Production

Events

Timeline

Intervallo di date

Ultimo Mese

Intervallo orario

00 : 00

00 : 00

Programma

Nome del programma

Operatore

Tutti



Reset



ODP	Nome Programma	Info	Dimensioni	Tipologia materiale	Formato materiale	Resto	Q.tà	Ora Inizio	Ora Fine	Data	T Effetti
CATAVORELLO_001.xprg	ant\xPrg\CATAVORELLO_001.xprg		X:2070; Y:2800; Z:22	NERO22	NERO22-01	No	1	13:53:07	14:01:48	19/07/2019	00:08:4
33333333.xPrg	roCut\Client\xPrg\33333333.xPrg		X:2500; Y:1250; Z:18	Truc1	TRUC1	No	1	13:46:27	13:53:02	19/07/2019	00:06:3
	Test11.xPrg						3	12:03:07	12:14:01	18/07/2019	00:01:0
test50.xMix	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	12:00:38	12:01:03	18/07/2019	00:00:2
	Anticipo_Test.xPrg						3	11:52:06	12:00:07	18/07/2019	00:01:5
Test11.xPrg	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:49:08	11:50:31	18/07/2019	00:01:2
Test11.xPrg	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:34:50	11:48:47	18/07/2019	00:03:4
test50.xMix	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:29:45	11:31:31	18/07/2019	00:01:4
Test11.xPrg	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:27:09	11:29:24	18/07/2019	00:02:1
	Anticipo_Test.xPrg						2	11:21:15	11:27:08	18/07/2019	00:02:1

Pezzi lavorati	205
Percentuale di scarto	29
Tempo complessivo (min)	287.48
Pezzi prodotti	1109
M3 totali lavorati	7.04
M3 totali prodotti	1.74



There are 2 active alarms



Saw blade speed

Velocità	0 m/min	0 m/min	0 rpm
Quota	23,5 mm	22,9 mm	1,6 mm

10:22

Production

Events

Timeline

Intervallo di date

Ultimo Mese

Intervallo orario

00 : 00

00 : 00

Tipo

Tutti

Evento

Descrizione dell'evento

Operatore

Tutti

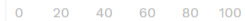


Reset



Tipo	Descrizione	Ora	Data	Nome Operatore
StatusMain_Man	Sezionatrice: Macchina in manuale	10:18:24	23/07/2019	
StatusMain_Ala	Sezionatrice: Macchina in emergenza	10:18:24	23/07/2019	
StatusMain_Man	Sezionatrice: Macchina in manuale	14:22:34	19/07/2019	
StatusMain_Wng	Sezionatrice: Macchina in warning	14:04:55	19/07/2019	
StatusMain_Wng	Sezionatrice: Macchina in warning	14:04:55	19/07/2019	
StatusMain_Man	Sezionatrice: Macchina in manuale	14:04:54	19/07/2019	
StatusMain_Aut	Sezionatrice: Macchina in automatico	14:04:54	19/07/2019	
StatusMain_Semiaut	Sezionatrice: Macchina in semiautomatico	14:03:17	19/07/2019	
StatusMain_Aut	Sezionatrice: Macchina in automatico	14:03:17	19/07/2019	
StatusMain_StartCyc	Sezionatrice: Macchina in start ciclo	14:03:12	19/07/2019	

Percentuale tempo macchina



0%

Tempo HMI (min)

36146

Events

11429





There are 2 active alarms



Saw blade speed

	Carro Lama	Spintore	Lama
Velocità	0 m/min	0 m/min	0 rpm
Quota	23,5 mm	22,9 mm	1,6 mm



10:25



Production

Events

Timeline

Intervallo di date

Ultimo Mese

Intervallo orario

00 : 00

00 : 00

Nome programma

Nome del programma



Reset



Obeject selection

Events

Alarms

Sezionatrice: Alimentazione ausiliaria non inserita. Condizione di emergenza.

Sezionatrice: Verifica pacco non alta

Sezionatrice: Asse lama non tarato

Sezionatrice: Asse incisore non tarato

Sezionatrice: Asse accostatore non tarato

Sezionatrice: Asse GP1 non tarato

Sezionatrice: Asse spintore

17

18

Cursore temporale

18 luglio 2019 - 10:24





There are 2 active alarms



100%

Saw blade speed

Velocità	0 m/min	0 m/min	0 rpm
Quota	23,5 mm	22,9 mm	1,6 mm



10:22



Production

Events

Timeline

Intervallo di date

Ultimo Mese

Intervallo orario

00 : 00

00 : 00

Programma

Nome del programma

Operatore

Tutti



Reset



ODP	Nome Programma	Info	Dimensioni	Tipologia materiale	Formato materiale	Resto	Q.tà	Ora Inizio	Ora Fine	Data	T Effetti
CATAVORELLO_001.xprg	ant\xPrg\CATAVORELLO_001.xprg		X:2070; Y:2800; Z:22	NERO22	NERO22-01	No	1	13:53:07	14:01:48	19/07/2019	00:08:4
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test50.xMix	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	12:00:38	12:01:03	18/07/2019	00:00:2
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Test11.xPrg	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:49:08	11:50:31	18/07/2019	00:01:2
Test11.xPrg	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:34:50	11:48:47	18/07/2019	00:03:4
test50.xMix	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:29:45	11:31:31	18/07/2019	00:01:4
Test11.xPrg	estroCut\Client\xPrg\Test11.xPrg		X:2100; Y:1400; Z:18			No	1	11:27:09	11:29:24	18/07/2019	00:02:1
	Anticipo_Test.xPrg						2	11:21:15	11:27:08	18/07/2019	00:02:1

csv/xls export

Pezzi lavorati 205

Percentuale di scarto 29

Tempo complessivo (min) 287.48

Pezzi prodotti 1109

M3 totali lavorati 7.04

M3 totali prodotti 1.74

23





Selling point

Maximum controls
of production
performance

It allows to monitor, optimize and
improve the production trend.





Alarms and warnings display in **real time**

Ability to add **notes and** customised **enclosures** for every alarm

Maestro active **M**
Advanced Human Machine Interface



There are 2 active alarms



14:55



MACHINE SWITCHED OFF

07/05/2019 - 14:52:13

See

EMERGENCY STOP PUSH-BUTTON PRESSED

07/05/2019 - 14:52:13

See

Type: Date range: User:

Description	Date	Start	Stop	Total T	User	Status
OP PUSH-BUTTON PRESSED	07/05/2019	14:52:13	00:00:00	-	admin	Active
MACHINE SWITCHED OFF	07/05/2019	14:52:13	00:00:00	-	admin	Active
TESTED BY MACHINE SIMULATOR	07/05/2019	14:51:52	14:51:53	00:00:00	admin	Not enabled
MAGAZINE 1 REFERENCE	07/05/2019	14:51:24	14:51:52	00:00:27		Not enabled
MAGAZINE 1 REFERENCE	07/05/2019	14:51:24	14:51:51	00:00:27		Not enabled
MAGAZINE 1 REFERENCE	07/05/2019	14:49:23	00:00:00	-		Active
MACHINE SWITCHED OFF	07/05/2019	14:49:22	14:49:22	00:00:00		Not enabled
MAGAZINE 1 REFERENCE	07/05/2019	14:49:22	00:00:00	-		Active
TESTED BY MACHINE SIMULATOR	07/05/2019	07:39:20	07:39:21	00:00:01	admin	Not enabled
TESTED BY MACHINE SIMULATOR	07/05/2019	07:39:15	07:39:16	00:00:01	admin	Not enabled

MACHINE SWITCHED OFF

07/05/2019 - 14:52:13

Status: Active

See manual

Get help

0 Attachments

0 Notes



MDI



Manual





There are 2 active alarms



14:54



Alarms list

Filter Status Type Date range User

Source	Id	Type	Description	Date	Start	Stop	Total T	User	Status	>>
PLC	app_1,1	Error	EMERGENCY STOP PUSH-BUTTON PRESSED	07/05/2019	14:52:13	00:00:00	-	admin	Active	
PLC	app_1,1	Info	MACHINE SWITCHED OFF	07/05/2019	14:52:13	00:00:00	-	admin	Active	
PLC	app_1,1	Error	COLLISION DETECTED BY MACHINE SIMULATOR	07/05/2019	14:51:52	14:51:53	00:00:00	admin	Not enabled	
PLC	app_1,5	Info	PERFORM EXTERNAL MAGAZINE 1 REFERENCE	07/05/2019	14:51:24	14:51:52	00:00:27		Not enabled	
PLC	app_1,5	Info	PERFORM TOOL MAGAZINE 1 REFERENCE	07/05/2019	14:51:24	14:51:51	00:00:27		Not enabled	
PLC	app_1,5	Info	PERFORM EXTERNAL MAGAZINE 1 REFERENCE	07/05/2019	14:49:23	00:00:00	-		Active	
PLC	app_1,1	Info	MACHINE SWITCHED OFF	07/05/2019	14:49:22	14:49:22	00:00:00		Not enabled	
PLC	app_1,5	Info	PERFORM TOOL MAGAZINE 1 REFERENCE	07/05/2019	14:49:22	00:00:00	-		Active	
PLC	app_1,1	Error	COLLISION DETECTED BY MACHINE SIMULATOR	07/05/2019	07:39:20	07:39:21	00:00:01	admin	Not enabled	
PLC	app_1,1	Error	COLLISION DETECTED BY MACHINE SIMULATOR	07/05/2019	07:39:15	07:39:16	00:00:01	admin	Not enabled	

MACHINE SWITCHED OFF

07/05/2019 - 14:52:13

Status: Active

See manual

Get help



Attachments



Notes



MDI



Manual





Selling point

Decreasing of
technical
downtime

It allows you to display alarm reports and solve them in a short time







Ability of **monitoring** the status and deadlines of the maintenance interventions required by LUM.

Ability of adding new **customized maintenance** interventions by the user





Maintenance

Date range Title Status    

Title	Hours-run meters	Expiry date	Status	>>
Electric spindle: Replace coolant Heat exchanger	2%	1417 days	Not expired	
Electrical cabinet: Clean filters Blade head	0%		Not expired	
Electrical cabinet: Replace battery Absolute encoder	1%	1777 days	Not expired	
Pneumatic system: Check condensation level Filter group	77%	7 days	Expiring	
Pneumatic system: Replace cartridge Filter group	6%	337 days	Not expired	
Tools storage TR12: Lubricate Linear guide	164%	0 days	Expired	
Vacuum system: Check oil level Vacuum pump 1	26%	67 days	Not expired	
Vacuum system: Replace oil Vacuum pump 1	0%		Not expired	

View tool status

Create a maintenance date 

Mark this maintenance as performed.

Maintenance

Date range: Title: Status:

Title	Hours-run meters	Expiry date	Status
Electric spindle: Replace coolant Heat exchanger	2%	1417 days	Not expired
Electrical cabinet: Clean filters Blade head	0%		Not expired
Electrical cabinet: Replace battery Absolute encoder	1%	1777 days	Not expired
Pneumatic system: Check condensation level Filter group	77%	7 days	Expiring
Pneumatic system: Replace cartridge Filter group	6%	337 days	Not expired
Tools storage TR12: Lubricate Linear guide	164%	0 days	Expired
Vacuum system: Check oil level Vacuum pump 1	26%	67 days	Not expired
Vacuum system: Replace oil Vacuum pump 1	0%		Not expired

View tool status

Create a maintenance date

Pneumatic system: Check condensation level Filter group



Estimated Time
7 days

Expires on
06/06/2019 - 16:59

Wizard
Performing maintenance

Attachments

Notes

Mark this maintenance as performed.



Maintenance

Date range: Title: Status:

Title	Hours-run meters	Expiry date	Status
Electric spindle: Replace coolant Heat exchanger	2%	1417 days	Not expired
Electrical cabinet: Clean filters Blade head	0%		Not expired
Electrical cabinet: Replace battery Absolute encoder	1%	1777 days	Not expired
Pneumatic system: Check condensation level Filter group	77%	7 days	Expiring
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Vacuum system: Check oil level Vacuum pump 1	26%	67 days	Not expired
Vacuum system: Replace oil Vacuum pump 1	0%		Not expired

Pneumatic system: Check condensation level Filter group

Estimated Time: **7 days**

Expires on: **06/06/2019 - 16:59**

Wizard
Performing maintenance

- Attachments
- Notes

View tool status

Creation of customized events (in addition to those foreseen by the LUM)





Selling point

**Maintenance
reduction costs**

It allows you to view the
maintenance that is due to be
performed in a short time

Profiling of each user's experience in terms of:

- Access privileges
- Languages
- Unit of measure

Registration of the user's log in reporting for **complete traceability**.

Maestro active **M**
Advanced Human Machine Interface





Settings > User Management

Filter

Filter by ID, Name, Surname



Sorting

Name



Username*	Password	Photo	Name	Surname	Permission levels
admin	*****				Production Setup Report Maintenance MDI, Manual User Management
paolo	*****				Production Report Maintenance

Create a new user




MDI



Manual




User setting ✕



ADMINISTRATORS

[Log out](#) [Termina](#)

Lingua

 Italiano

Unità di misura

Millimetri

[Annulla](#) [Salva](#)



Definition of work shifts on the machine, specifying:

- Coverage time
- Days of the week
- Validity period

The **Reports** are completely filterable by shifts.



Selling point

Advanced
production
organization

It allows the customization of user experience and control of activities, productivity and events occurring in each shift.





Display of texts in the logged
operator language.

Alarm reports translated into the
language of the operator logged at
the moment

Maestro active



Advanced Human Machine Interface

Display of the machine **Info ID**:

- Model
- Serial Number
- HMI version
- Programming software version
- PLC version

Ability to **export backup** of machine information.





offline

100%

	Carro Lama	Spintore	Lama
Velocità	0 M/min	0 M/min	0 Rpm
Quota	0 mm	0 mm	0 mm



12:01



Saw blade speed

Management

Programs management →

Mix management →

Create programs →

Create mix →

Materials management →


Types management →

Shapes management →



Touch-oriented


Machine information ✕



MachName\$\$\$
Matricola nr. **HMI123**

Versione Maestro Active: **1.0.0.0**

Versione PLC:

 **Esporta backup**

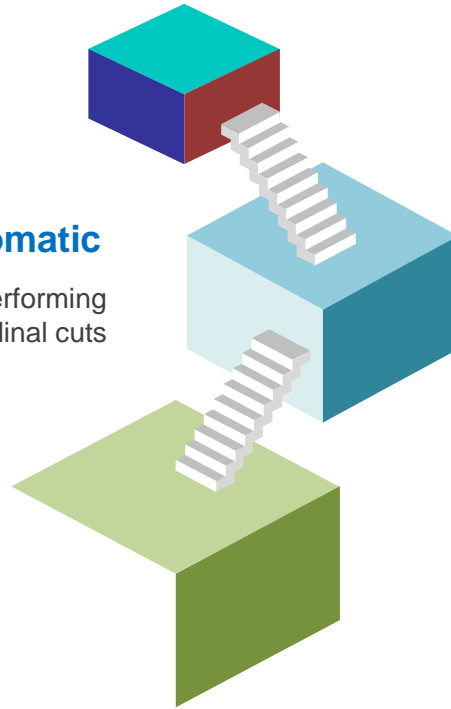
© 2000-2019 SCM Group
Maestro Active

Maestro active cut

BEAM SAWS MODELS

Beam saws	gabbiani	gt3 / g3	S	standard pc
	gabbiani	gt2/g2	S	
	gabbiani	SZ PLAST	S	
	gabbiani	st / s	S	
	gabbiani	pt / p	S	
	gabbiani	cfx	N	
	gabbiani	a3	N	
	gabbiani	cubo	N	
	sag	stc	N	
	sag	st	N	
	sag	sl	N	
	sag	sml	N	

Semi-automatic
Priority over all others modes , performing longitudinal cuts



Manual

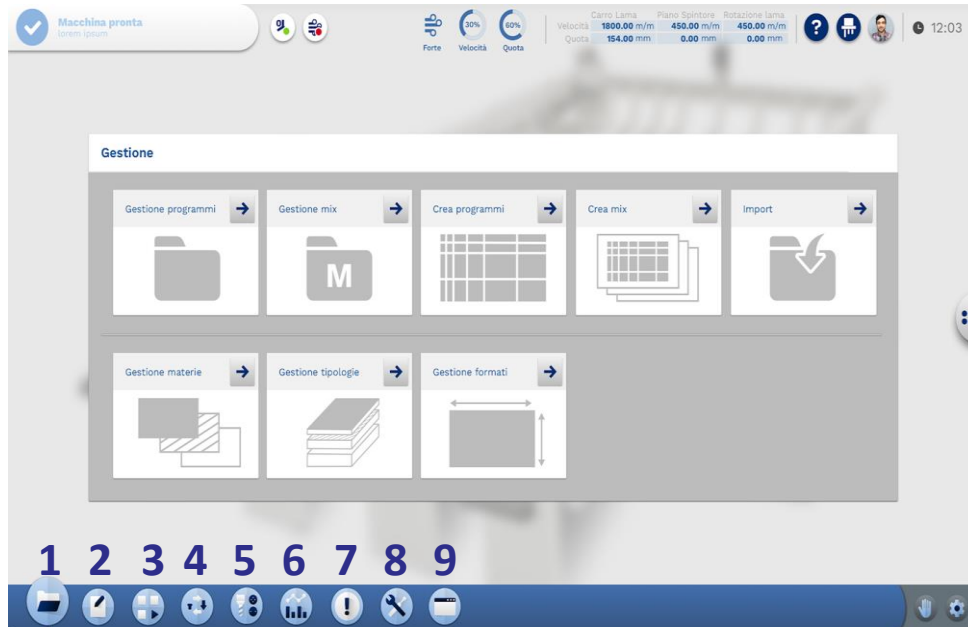
It allows manual commands to be sent to the PLC.

Production

The production function allows the execution of cutting and/or mix patterns in the beam saw

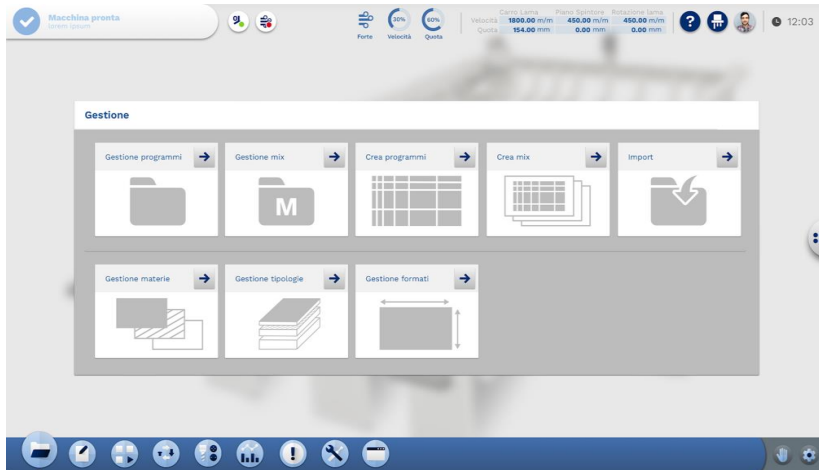
SURFING

A series of pages that allow you to access a set of features collected in them

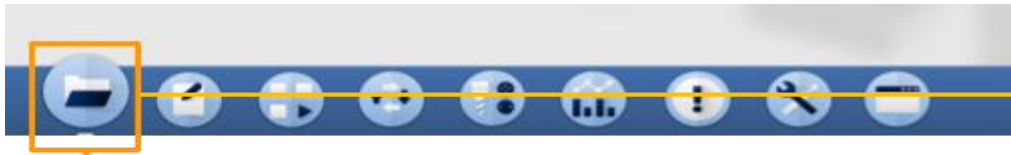


1. Management
2. Editor
3. Production
4. Semi-Automatic
5. Tool
6. Report
7. Alarm
8. Maintenance
9. Utilities
10. Settings

Management



- **Program management:** it allows to browse the file system in search of programs
- **Mix management:** it allows to browse the file system in search of mix
- **XPRG Editor:** XPRG program editor
- **XMIX Editor:** XMIX editor
- **Import :** import functions
- **Matters:** magazine materials editor
- **Types:** magazine materials editor
- **Formats:** magazine materials editor



Maestro active cut – ADVANCED BROWSING

Browsing

Browser folder pages include all those pages that allow navigation through the file system in order to search and manage all cutting patterns

The screenshot shows the 'Gestione programmi' (Program Management) interface. The breadcrumb path is 'MaestroCut_3 > MaestroCut3.0 > MaestroCut > bin > Debug > xPrg'. The search bar contains 'anticipo2'. The left sidebar shows a file tree with 'Programmi' selected, containing files like 'anticipo2.xPrg', 'anticipo33.xPrg', 'AutoFiller.tmp_001.xprg', 'AutoFiller_t01.xPrg', 'CATAVORELLO_001.xprg', and 'CATAVORELLO_002.xprg'. The main area displays a preview of the 'anticipo2' file, showing a 3D visualization of a cutting pattern. The dimensions are listed as X: 2000 mm, Y: 1500 mm, and Z: 18 mm. Below the preview, there is a table for 'Pannelli richiesti' (Required Panels) with one entry: 'generico' with dimensions '2000x1500x18' and quantity 'x1'. At the bottom right, there are buttons for 'Pianifica' and 'Carica'.

Preview tools for XPrg and XMix

The screenshot shows the 'aaaaasad' preview tool interface. The breadcrumb path is 'aaaaasad'. The main area displays a table for 'Pannelli richiesti' (Required Panels) with the following data:

Pannelli richiesti		Tot: 3
CODICE 1440.60x1000.00	1440.599975585	x1
Formato		
CODICE BARRA_FRAS	3130x390x40	x1
Formato		
CODICE Generico-3000-2000-18	3000x2000x18	x1
generico		

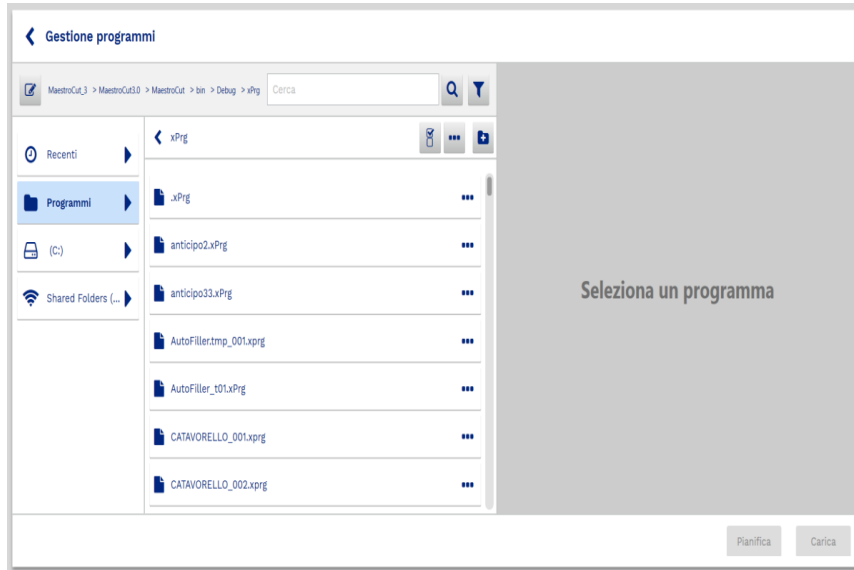
Below the table, there is a section for 'Resti' (Remnants) with a total of 0.

- Preview
- Description
- Size

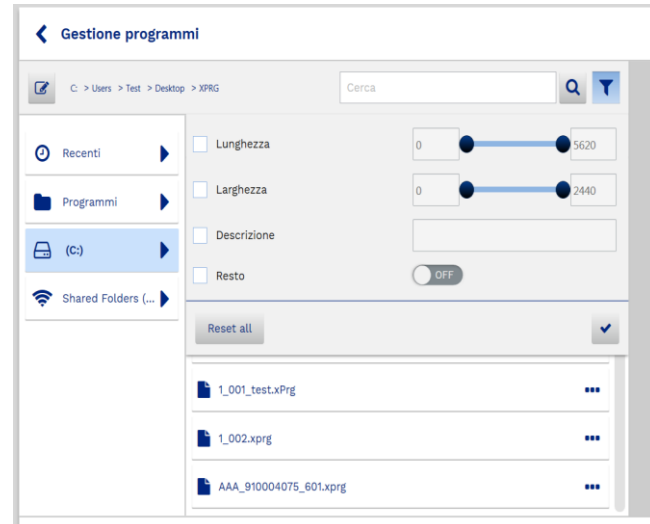
Maestro active cut – ADVANCED BROWSING

Browsing

Browser folder pages include all those pages that allow navigation through the file system in order to search and manage all cutting patterns



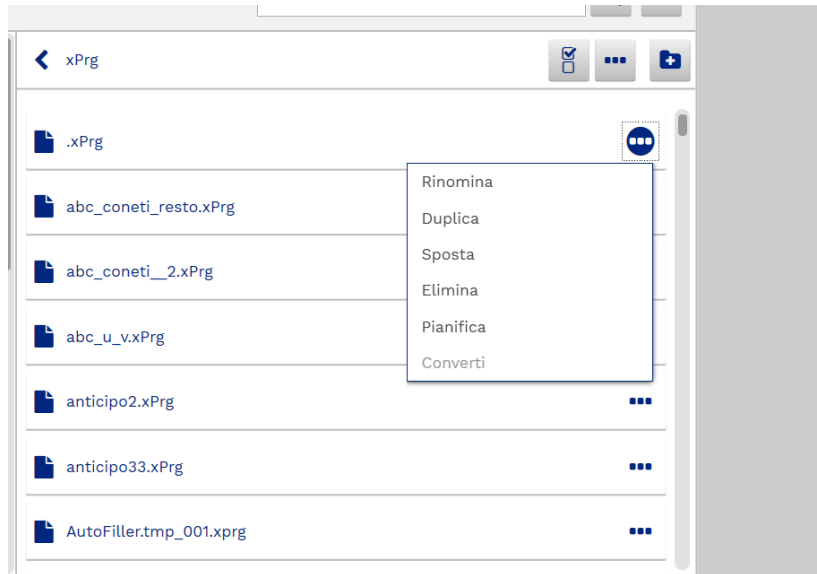
Advanced filter to search program



Maestro active cut – ADVANCED BROWSING

Browsing

Browser folder pages include all those pages that allow navigation through the file system in order to search and manage all cutting patterns



Integrated file system
management environment



Maestro active cut

EDITOR XPRG

XMix editing tools, XPrG programs guided intuitive and fast

Carro Lama: Velocità 1800.00 m/m, Quota 154.00 mm, Piano Spessore 450.00 m/m, Spessore 0.00 mm

Crea programma: **Tavolo Rosso**

#	Tipologia	Quota	Rip.	Resto	Opzioni
01	P	246.00	3	277.00	
02	Y	540.00	3	151.00	
03	X	565.00	1	90.00	
04	X	526.00	1	60.00	
05	X	780.00	2	63.00	
06	X	260.00	2	697.00	
07	X	400.00	3	296.00	

(P, Y, X, U, V, F, RY, RX, RU, RV)

- Input validation
- Guided editing

Aggiungi un taglio

E3.1

E3.2

E3.3

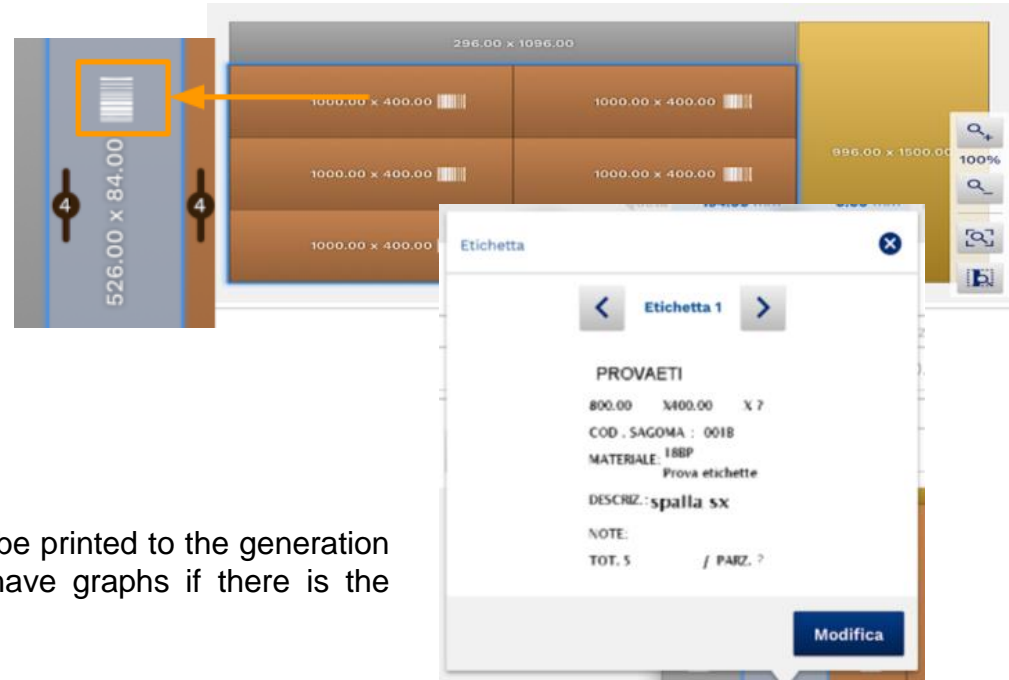
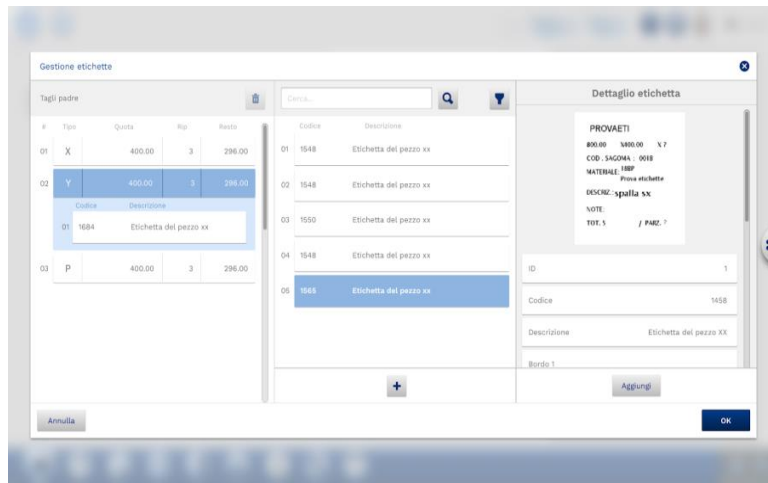
- (E3.1): List of cuts
- (E3.2): Advanced cutting pattern editing commands
- (E3.3): Graphic area (Preview)



Maestro active cut – LABELS

LABEL

Advanced functionality for editing, templating and previewing.

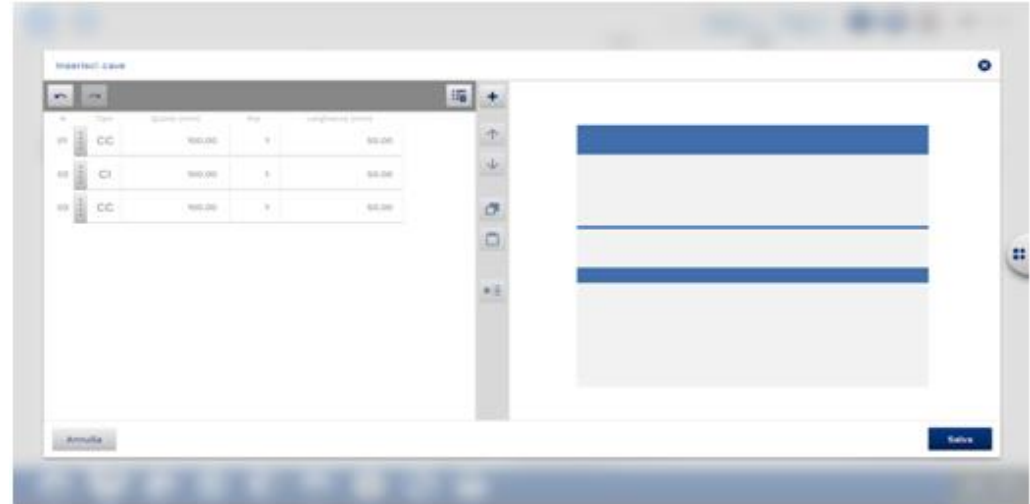
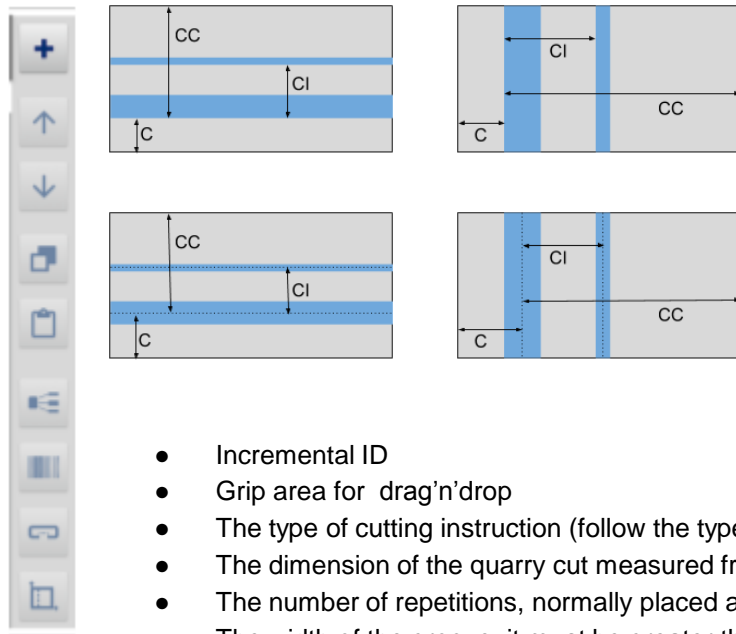


At each cut it is possible to associate a label that can be printed to the generation of the shape generated with that cut and you will have graphs if there is the information of edging.

Maestro active cut – SPECIAL MACHININGS

SPECIAL PROCESS

Grooving (OPTION)



- Incremental ID
- Grip area for drag'n'drop
- The type of cutting instruction (follow the types of instructions available and their use)
- The dimension of the quarry cut measured from the edge (or from the tail): must be greater than or equal to zero
- The number of repetitions, normally placed at 1, can be greater than 1 only for the instructions CI (Incremental groove)
- The width of the groove: it must be greater than or equal to the thickness of the blade
- The depth of the groove (option): numerical value greater than zero. This field is present only in the presence of dedicated mechanical options

Maestro active cut – SPECIAL MACHININGS

SPECIAL PROCESS

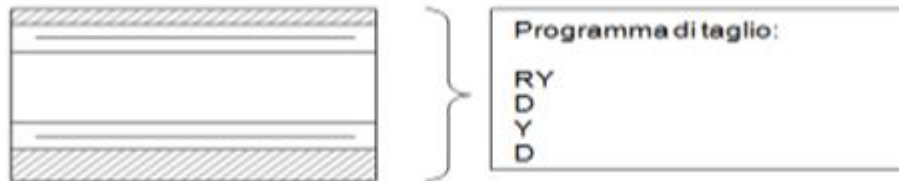
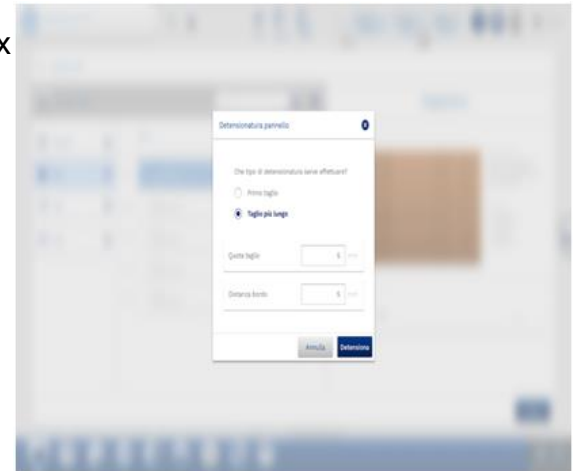
De-tensioning cuts (OPTIONAL)

E3.3.1.7

De-tensioning cuts are special processes, i.e. they are passive cuts that have the purpose of eliminating the internal ribs and tensions that occur through the processes of veneering and/or pressing.



A short tap on the icon (E3.3.1.7) shows the dialog box for inserting the de-tensioning cuts.



Maestro active cut – SPECIAL MACHININGS

SPECIAL PROCESS

Insertion of windows, are internal workings of the panel. They can only be programmed according to YXUV instructions and can be rotated or not rotated. (OPTION)



Crea Sfinestra

Punto di origine

X (mm)	Y (mm)	X (mm)	Y (mm)
<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>	<input type="text" value="0"/>

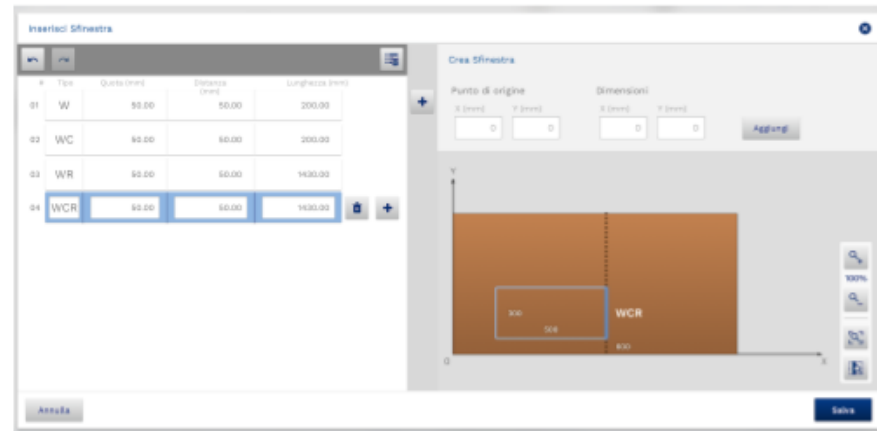
ES2.3.1

ES2.3.2

ES2.3.3

ES2.3.4

ES2.3.5



WIZARD

(ES2.3.1): Coordinates of the point of origin X

(ES2.3.2): Coordinates of the point of origin Y

(ES2.3.3): Dimension along the X axis

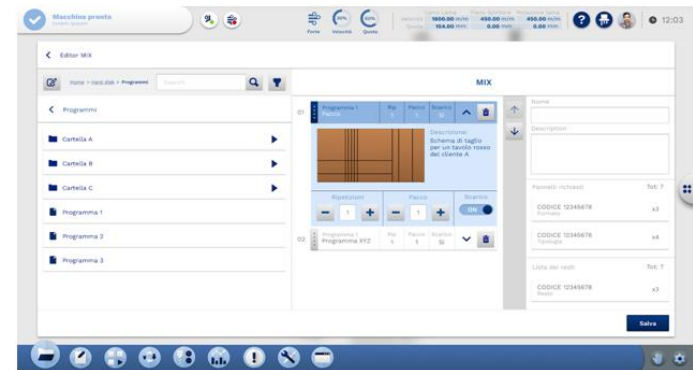
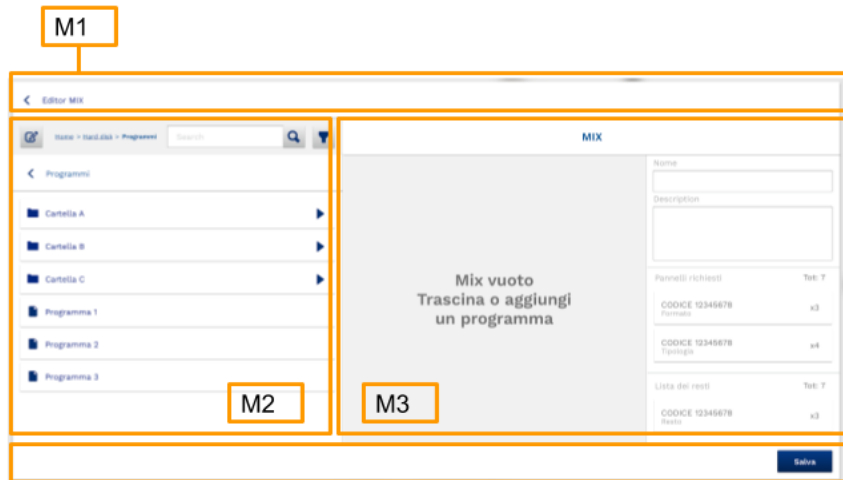
(ES2.3.4): Dimension along the Y axis

(ES2.3.5): Command 'Apply'

Maestro active cut – EDITOR

EDITOR XMix

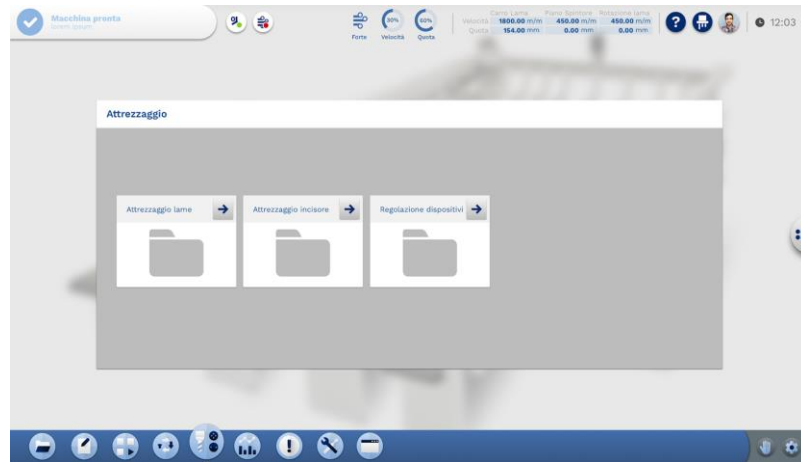
Smart and fast editing tool for XMix, XPrG and semi automatic program



M4

- M1: header (caption)
- M2: Folder browser section
- M3: Preview section
- M4: footer (command and button section).

TOOLS STOCK



- Main blades management:
- Score blades management
- Devices settings: (SAW HI SET)



Gestione lame

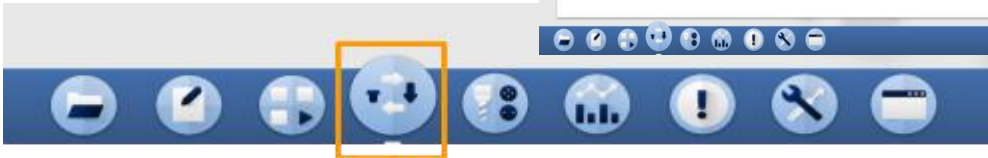
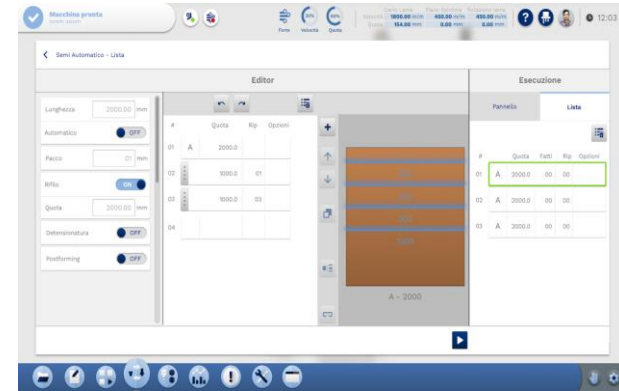
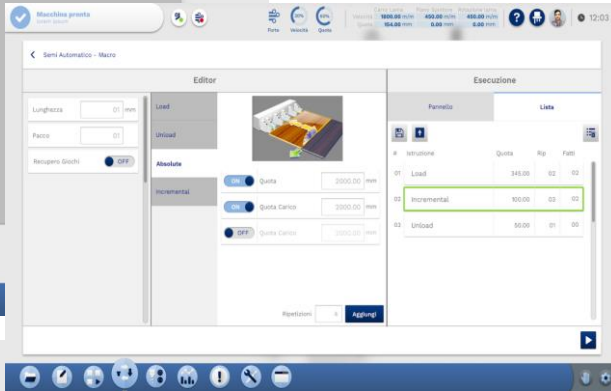
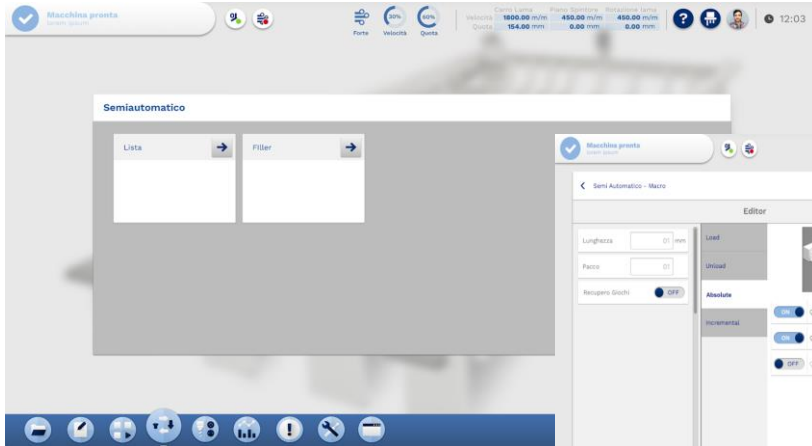
Cerca

Nome Diametro Spessore Distanza (km)

02	Lama_T_4_4	400	4,4	0,23	✓
01	Def	400	4,6	0,03	
03	prova	30000	300	0	

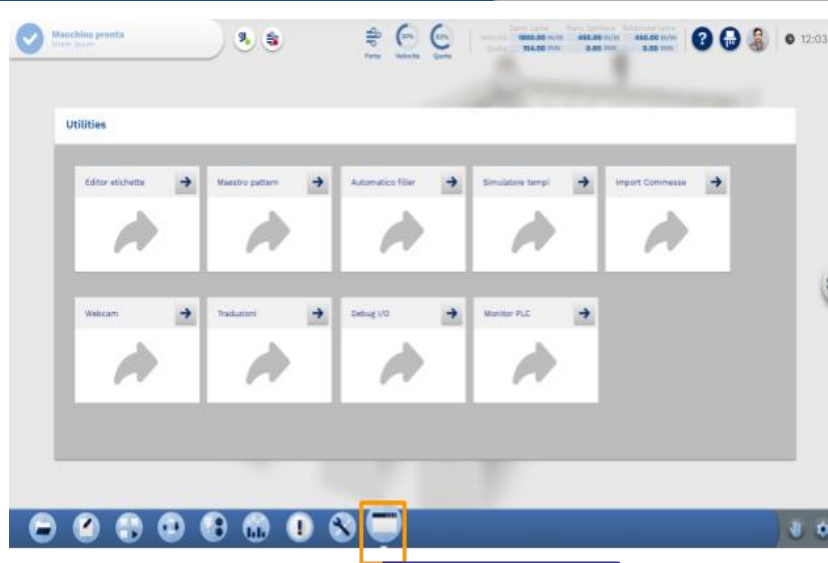
Semi-automatic

- **Semi-automatic list:** standard
- **Semi-automatic filler:** standard
- **Semi-automatic macro:** option



Maestro active cut – UTILITIES

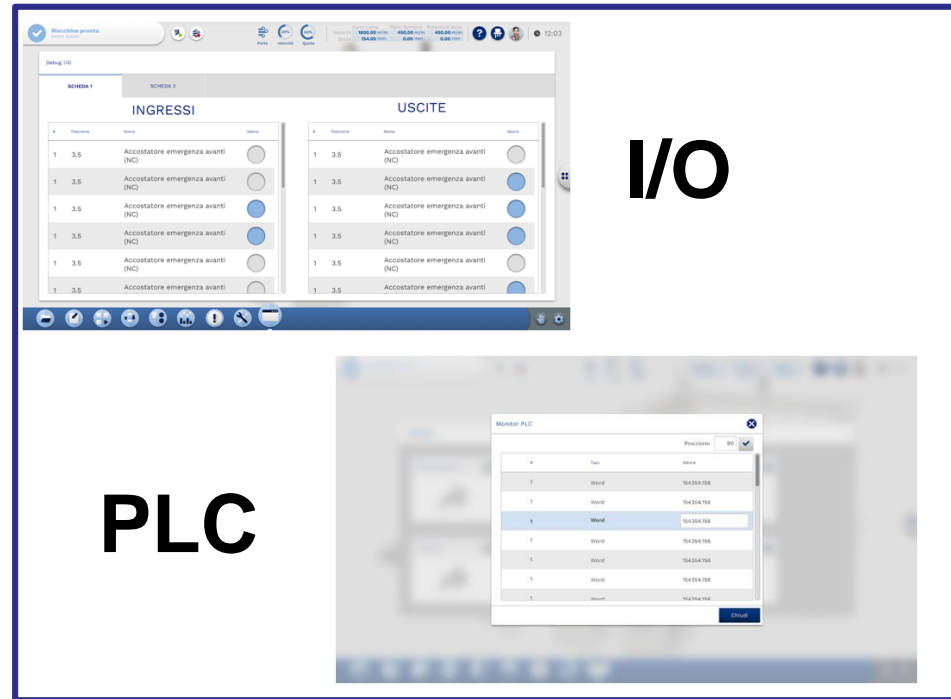
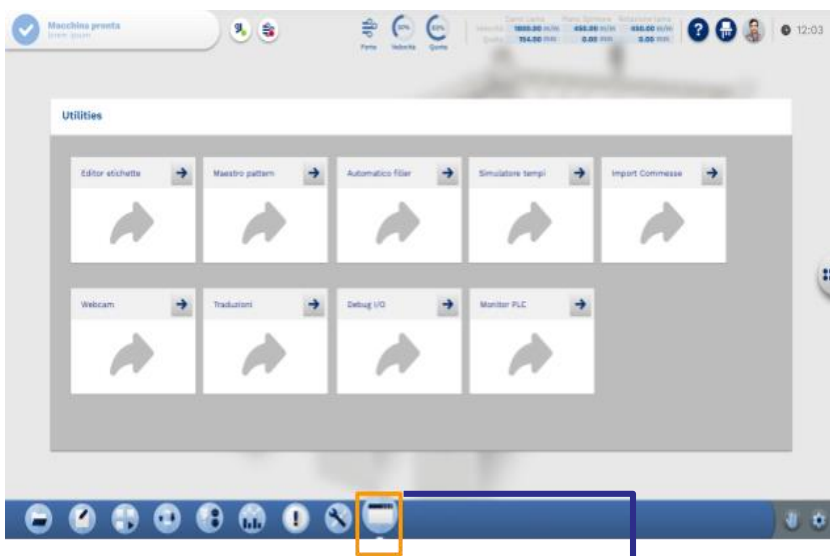
Utilities



- **Label editor:** external program for editing the label layout
- **Maestro pattern**
- **Automatic Filler:** optimizer on panel
- **ETA**
- **Import**
- **WebCam**
- **Tranlsation**
- **Debug I/O:** Display of PLC inputs and outputs
- **Monitor PLC:** allows access to PLC memory areas

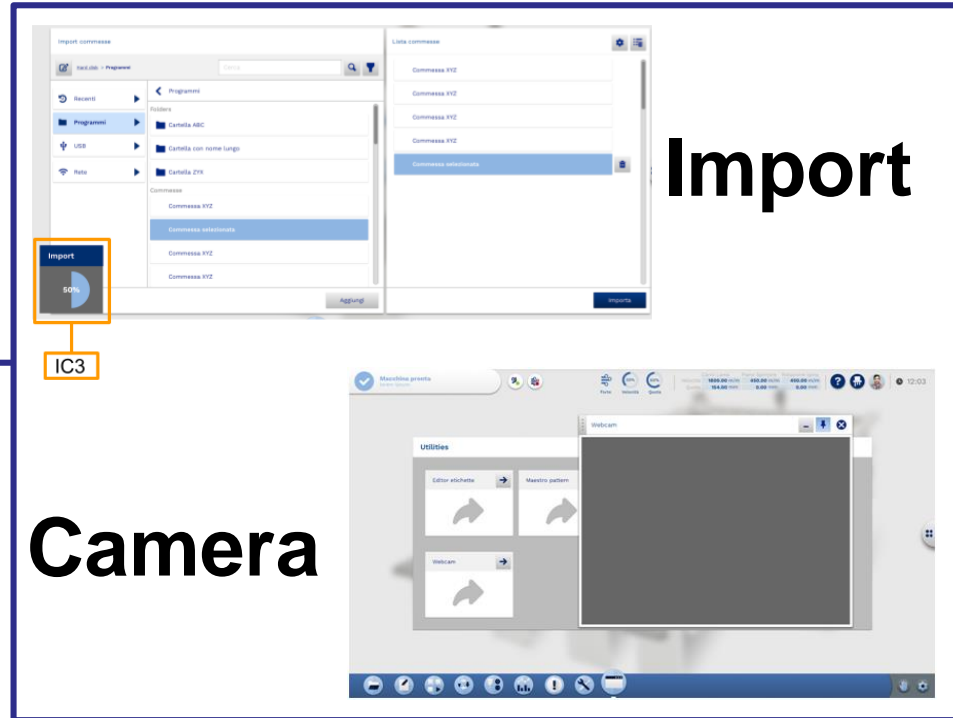
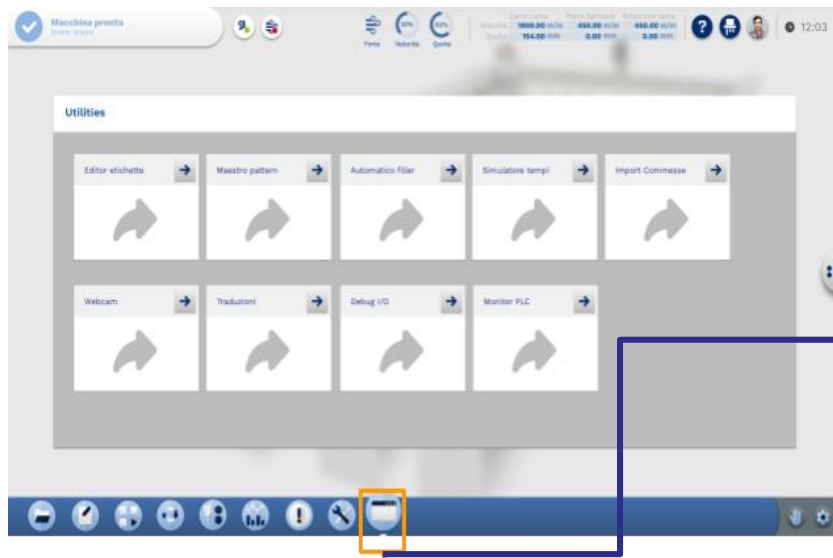
Maestro active cut – UTILITIES

Utilities



Maestro active cut – UTILITIES

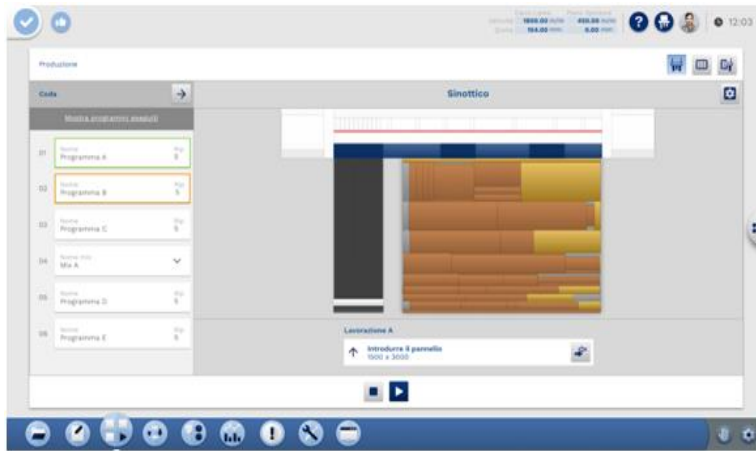
Utilities



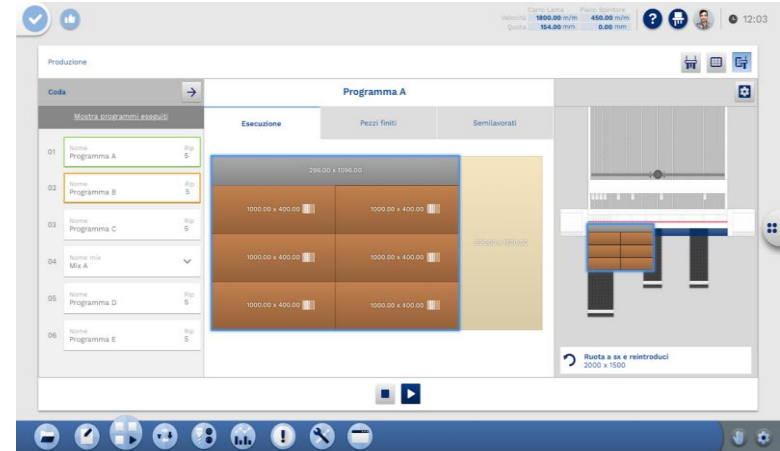
Maestro active cut – PRODUCTION

PRODUCTION

This is the mode in which the machine executes the cutting diagrams elaborated by the optimizer or edited through the tools made available by the HMI.



Fullscreen view of running scheme



1. Preview of the running scheme
2. Preview of finished parts
3. Preview of semi-finished products

Maestro active – COMPETITION COMPARISON

			
Cutting			
Edge banding			Sintra 
Machining Centers + Drilling Solutions			Control panel 

Maestro active cut – MANUAL CONTROLS

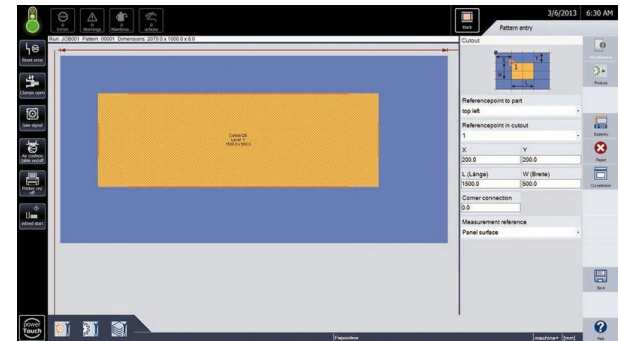
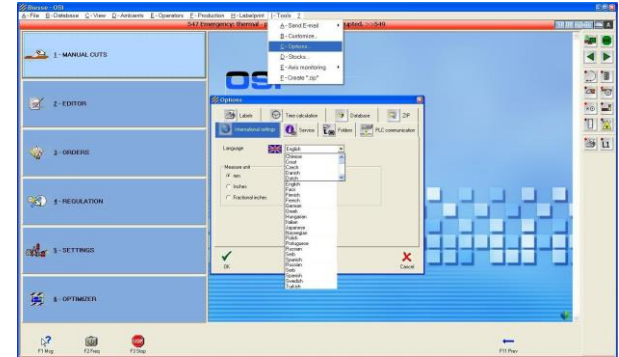
Benchmark

in line with the latest technological innovations in the field of HMI

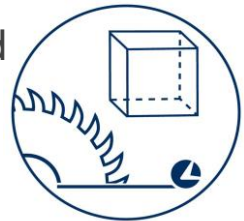


 **BIESSE**

 **HOMAG**



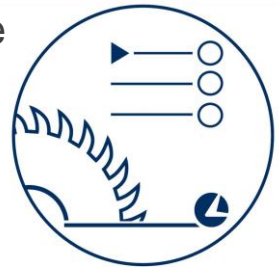
- **Graphic editor** - Additional modes for editing programs
- **Label** - Software operating on the machine board for the production of labels by means of graphic editor. Possibility to insert logos (black and white bitmap format), descriptive fields and bar codes for panel identification and subsequent processing.
- **Panel editor** - Software integrated in the machine management program for manual filling of the cutting pattern. Insertion of the pieces from database and from external files with information for flame cuts.



Maestro cut 3d editor

- **De-tensioning cuts** - In Semi-automatic and automatic mode it is possible to apply between 2 longitudinal cuts a sequence of de-tensioning cuts, which allow to reduce the tensions inside the panel.
- **Dynamic editor for editing cutting patterns and trimmings** - All cutting patterns and their trimmings can be modified runtime before execution.
- **Automatic Filler** - Optimisation of a cutting list starting from the manual selection of the panels and the remains inside the Maestro active warehouse
- **Offcuts management** – It allows the management and automatic conversion of waste into off-cuts,

Detension



- **ETA (Estimated time of action)-** Simulated execution of job/multi-job cutting diagrams to check the machine time required
- **Job scheduling by date and priority -** Functionality that allows the operator to assign priority or date to propose them automatically
- **Advanced report -** Cross functionality for simple and intuitive visualization of event sequencing

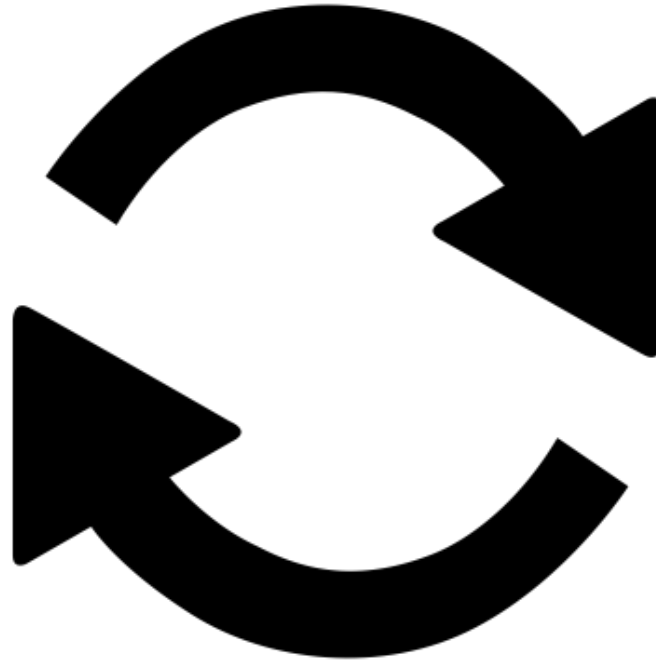


Maestro cut manager

CONVERSION

All transfers to SCM saws by 3rd Party Optimization Software should go through the PTX file format.

PTX
Rel 1.14



XMix
Lst
XPrg
Prg

Maestro ottimo import

IMPORT

Old Easy Cut

Maestro ottimo import is a software tool that runs in MS EXCEL environment and eases operators when using the optimisation cutting programme for saving data related to all pieces to cut in one or more excel worksheets.

Just a simple click to export and consequently optimizing in a very rapid time without errors, that may occur when copy the selected pieces list, independently from the way they are organized in the worksheet.



Maestro ottimo import - Software eemo

Maestro ottimo cut

Demonstration of the cutting plans optimisation program with reference to one or more panels or sub format lists to produce, raw material stock management and the conversion of the optimised cutting patterns into programs for the beam saw control.

CONFIGURATION

OPTIMISATION PARAMETER, SETTING/UP AND TIME CONFIGURATION

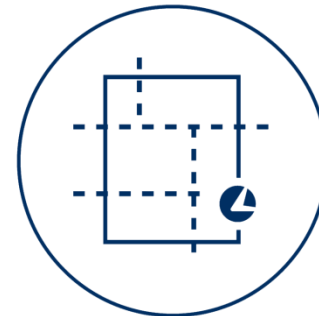
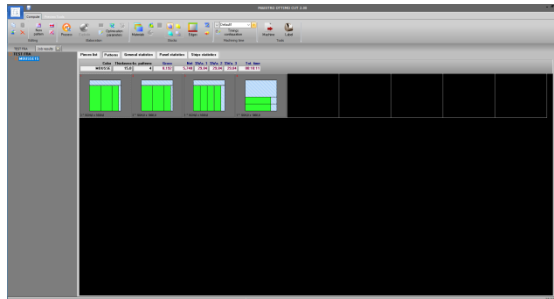
MATERIALS MANAGEMENT

TYPE, FORMAT, EDGE AND OFF-CUTS

ORDER MANAGEMENT

SINGLE OR MULTI-ORDERS EDITING, MATERIALS ASSOCIATION, PROCESSING, ANALYSIS AND PATTERNS EDITOR

IMPORT/EXPORT/PRINTING



Maestro ottimo cut



**Many thanks
For your kind attention!**