



ELECTRICAL ASSEMBLY TOOLS
DAI-ICHI DENTSU LTD.

NUTRUNNER / HAND-HELD TOOL / SERVO PRESS



DDK NUTRUNNER SERIES
AFC3000
HIGH SPEED NUTRUNNER



Advanced Precision Technology

FEATURES

Production Process Flexibility

Maximum 32 spindles
multi spindle control

128 Parameters
64 Sequences

Quality and Traceability

ISO5393
compliant

12,000 Stored Data
100 Curve Data

Patented high speed seating mechanism

Cycle time
reduction

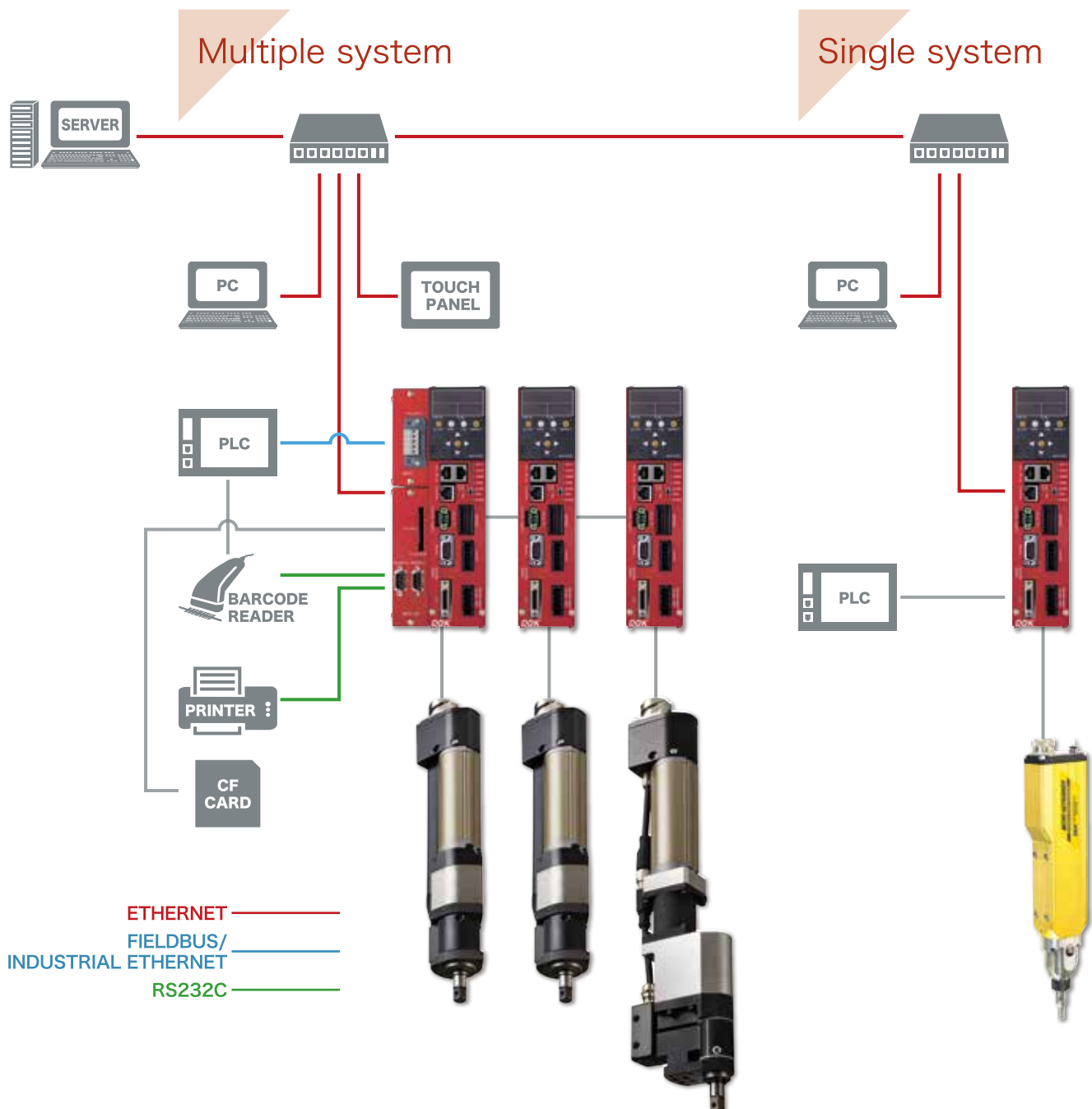
Torque overshoot
reduction

Wide Range of Tools

Minimum
0.2Nm

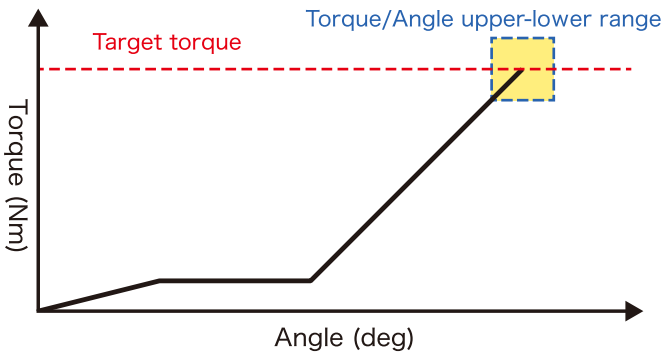
Maximum
5,000Nm

System configuration (Image)

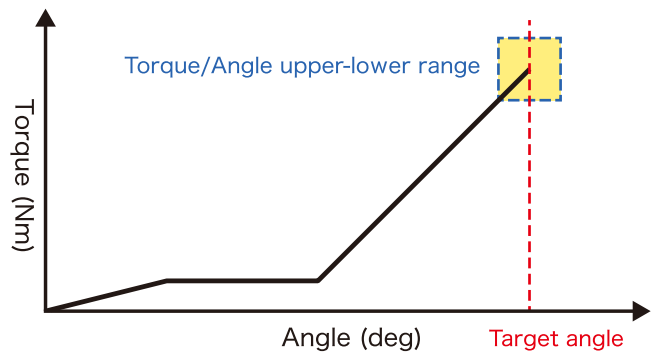


CONTROL AND FEATURES

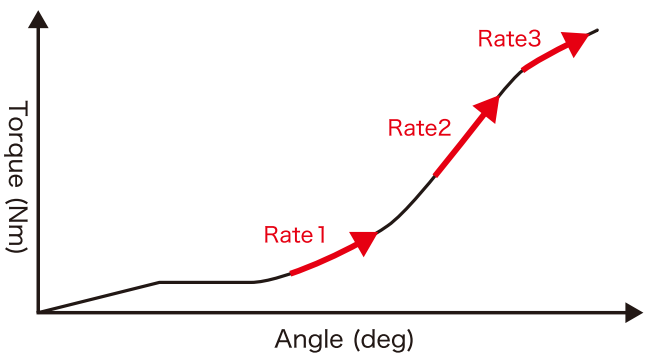
Torque method Tighten to the set target torque value.



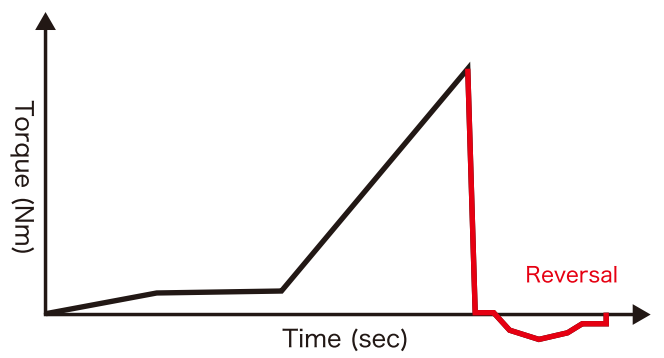
Angle method Tighten to the set target angle value.



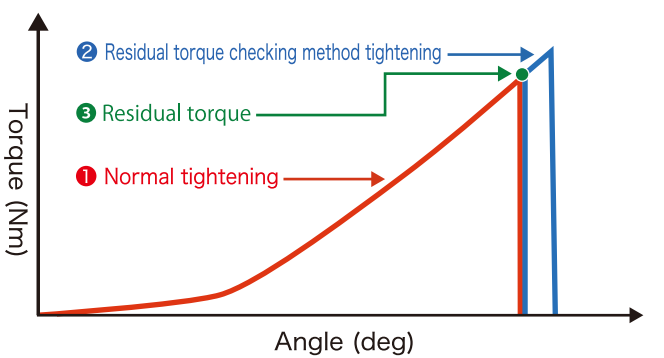
Rate judgement Monitor the torque / angle slope rise and judge if outside of the set limits.



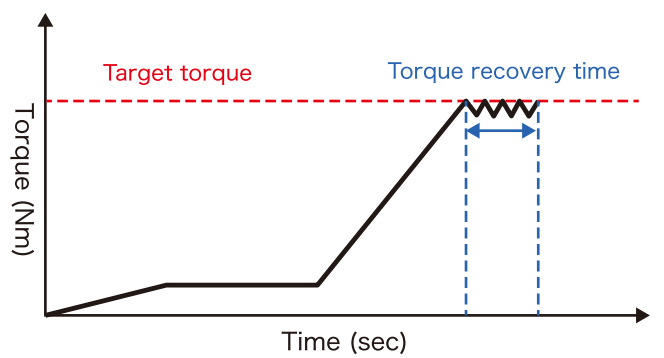
1 Pulse reverse Allows the disengagement of a locked fastener in the socket after tightening.



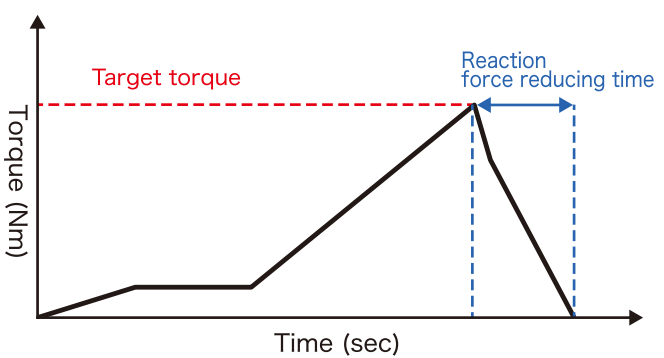
Residual torque checking method Detects residual torque by re-fastening a previously tightened fastener.



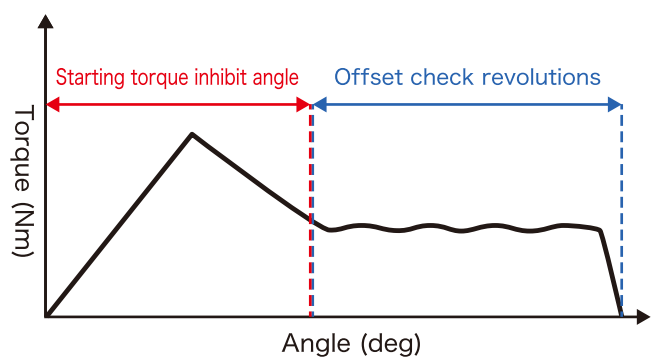
Torque recovery Reduces torque loss after fastening by maintaining torque for a set period of time.



Reduce torque reaction Function to reduce the torque reaction after reaching set torque.



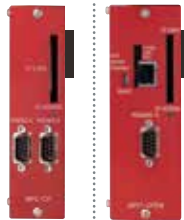
Offset check Function which allows the detection of adverse external torque (ie. external gearing) which could detriment actual dynamic torque applied.



CONTROLLER AND EXPANSION UNIT

BASE UNIT

OPTIONAL UNIT



Display

User Friendly Display

- Displays full content with 6 digit / 2 row LED
- Easily operated cursor keys

Option1

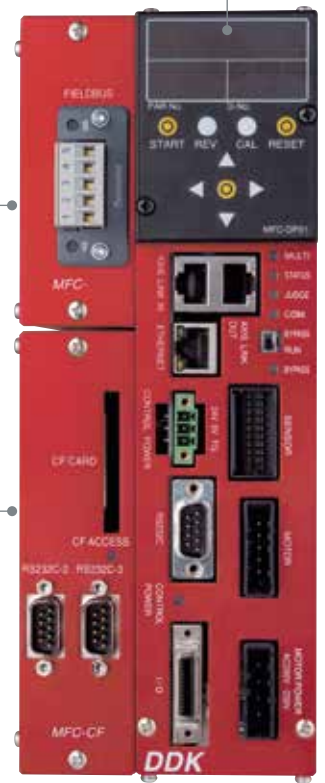
Fieldbus I/O Interfaces

Various interfaces for direct PLC I/O & data connections

Option2

Expansion COM Ports and memory

- Compact Flash (CF) for result data
- Expansion RS232C Input / Output ports



Momentary Max. Peak Current (Arms)

Unit Model	MFC-S008	MFC-S024	MFC-S060	MFC-S120
Momentary Max. Peak Current	5.6Arms	17.0Arms	42.4Arms	84.8Arms
Continuous AC Drive Current	1.1Arms	2.0Arms	4.0Arms	5.2Arms
Transformer Capacity	0.3KVAxspindles	0.3KVAxspindles	0.8KVAxspindles	4.0KVAxspindles
Input power	single phase-AC100V-230V±10%	3-phase AC200~230V±10% 50/60H		
Control Power	DC24V±10% 0.5A		DC24V±10% 1A	
Operating Environment	temperature 0°C~+50°C humidity -below 90%RH			
RS232C communication	38400bps (default)/19200bps/9600bps, 1port			
External analog monitor output	Torque analog voltage, angle pulse, CC/CW pulse etc.			
Axis Link Communication	Spindle Link Communication Port (connect Max. 32 spindles)			
Ethernet	PC communication port in conformity with IEEE802.3(100BASE-T)			
Standard I/O Connector	Input : 12 Output : 12			
Fastening Result Data memory	120,000 Cycles max	500 last REJECT cycles		
TQ. Curve Memory	Last 100 Curves	Last 100 Reject Curves		

Controller	Tool Model Supported	display	option1	option2
MFC-S008	MFT-***M10-*			
MFC-S024	CFT-***RS1-*	MFC-DP01	Fieldbus Industrial Ethernet	CF CFEN
MFC-S060	NFT-***RM1/RM2-*			
MFC-S120	CFT-***RS3-*			
MFC-S120	NFT-***RM3-*			
MFC-S120	CFT-***RM4J-*			
MFC-S120	NFT-***RM4H-*			
MFC-S120	NFT-***RM5-*			

Optional model	Description	Unit Type	
MFC-DT	Expansion Discrete I/O Input : 32 Output : 32	Option1	
MFC-CC	CC-LINK V2		
MFC-DN	DEVICENET		
MFC-PB	PROFIBUS		
MFC-EN	ETHERNET IP		
MFC-PN	PROFINET IO		
MFC-CI	CC-LINK IE		
MFC-EC	ETHER CAT		
MFC-CF	CompactFlash card supported Expansion RS232C(2port)		Option2
MFC-CFEN	Ethernet for Server PC CompactFlash card supported Expansion RS232C(1port)		

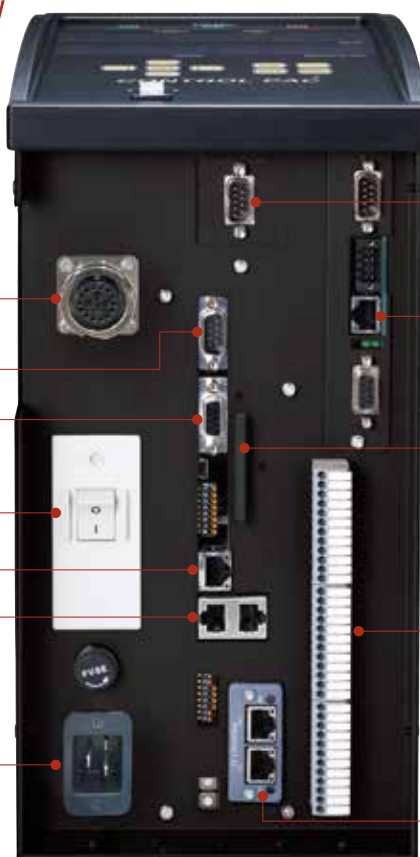


CONTROL PAC

FRONT PANEL



BOTTOM VIEW



Tool cable connector

Connector for RS232C communication(data output)

T/A monitor connector

Power source breaker

Connector for Ethernet communication (PC communication)

Axis Link Communication Connector

Primary power source connector

Option: RS232C-2 communication connector (ID Data Input)

Option: Connector for special ethernet data output protocols

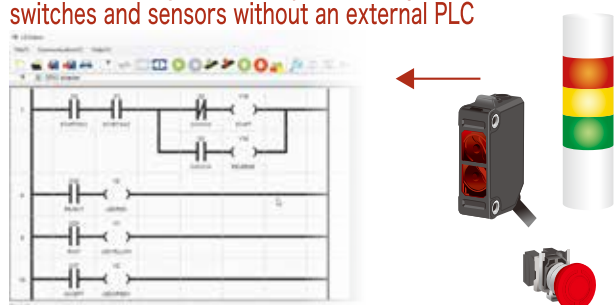
CF card slot

I/O Terminal

Various Fieldbus I/O interfaces

Unit Model	MFC-B060
Settings	Sequence: 64 Parameter: 128
Momentary Max. Peak Current	42.4Arms
Continuous AC Drive Current	5.2Arms
Input power	Single AC200~230V ±10%
Operating Environment	0°C~+45°C humidity below 90%RH
RS232C communication	38400bps (default)/19200bps/9600bps, 1 port
External analog monitor output	Torque analog voltage, angle pulse, CC/CW pulse etc.
Axis Link Communication	Spindle Link Communication Port (connect Max. 32 spindles)
Ethernet	PC communication port in conformity with IEEE802.3(100BASE-T)
Standard I/O Connector	Input : 12 Output : 12
Option	Please refer to the Option1-4 on the left side
Fastening Result Data memory	120,000 Cycles max 500 last Reject cycles
TQ. Curve Memory	Last 100 Curves Last 100 Reject Curves

Internal PLC Logic control option: Ability to control external lights, switches and sensors without an external PLC



Adapted tool model

Standard cable

CFT tool	CFT-***RS1-*	C30-FT-M**
	CFT-***RS3-*	(M=length in meter Std:5, 10, 15 Max 25m)
NFT tool(RM)	NFT-***RM1-*	C30-FM2-M**
	NFT-***RM2-*	(M=length in meter Std:5, 10, 15 Max 25m)
	NFT-***RM3-*	

Control PAC model information

MFC - B060 - CC - IO - CF - EN

series	controller size		
Option1: Fieldbus	Option2: I/O termination	Option3: CF card slot/ Extension RS232C-2 input port	Option4: Optional Ethernet for special data protocols
CC CC-Link	IO With Terminal	CF With CF card slot	EN With data Report Ethernet port
DN DeviceNet	N Without Terminal	N Without CF card slot	N Without data report Ethernet port
PB PROFIBUS			
PI PROFINET I/O			
EI EtherNet IP			
CI CC-Link IE			
EC EtherCat			
N Without Fieldbus			

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the drawings
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MFT & CFT TOOLS

Tool type	Model	Max.Torque [Nm]	Max.Speed [rpm]	Weight [kg]	Length [mm] ※1	Square drive [mm]	Min.Pitch [mm]	Applicable controller
Micro	MFT-080M10-S1	0.8	2220	0.68	206	Hex. 6.35	31	MFC-S008
	MFT-160M10-S	1.6	1250	0.68	206	Hex. 6.35	31	MFC-S008
	MFT-240M10-S	2.4	800	0.68	206	Hex. 6.35	31	MFC-S008
Straight	CFT-051RS1-S/SL	5	1330	1.16	270	9.5	41	MFC-S024
	CFT-101RS1-S/SL (-H)	10	3000	1.26	275	9.5	39	MFC-S024
	CFT-201RS1-S/SL (-H)	20	1293	1.42	290	9.5	39	MFC-S024
	CFT-281RS1-S/SL (-H)	28	992	1.42	293	9.5	39	MFC-S024
	CFT-401RS1-S/SL (-H)	40	712	1.42	293	9.5	39	MFC-S024
	CFT-801RS3-S/SL (-H)	80	1015	3.4	372	12.7	50	MFC-S060
	CFT-132RS3-S1/S1L (-H)	130	574	3.4	372	12.7	50	MFC-S060
	CFT-202RS3-S/SL	200	387	4.3	390	15.9	59	MFC-S060
	CFT-302RS3-S/SL	300	260	5.8	440	19	71	MFC-S060
	CFT-502RM4J-S	500	238	13.5	500	25.4	89	MFC-S120
	CFT-802RM4J-S	800	150	15	566	25.4	96	MFC-S120
	CFT-113RM4J-S	1100	120	22	618	38.1	99	MFC-S120
	CFT-153RM4J-S	1500	88	28.5	633	38.1	115	MFC-S120
Offset	CFT-201RS1-O/OL	20	1221	2	362	9.5	25	MFC-S024
	CFT-401RS1-O/OL	40	712	2.4	368	9.5	29	MFC-S024
	CFT-801RS3-O/OL	80	1015	6	456	12.7	35	MFC-S060
	CFT-132RS3-O1/O1L	130	574	7.5	484	15.9	39	MFC-S060
	CFT-202RS3-O/OL	200	387	8.2	514	15.9	45	MFC-S060
	CFT-302RS3-O/OL	300	260	13	583	19	55	MFC-S060
	CFT-502RM4J-O	500	238	23.5	692	25.4	62	MFC-S120
	CFT-802RM4J-O	800	150	31	788	25.4	71	MFC-S120
Angle head (Straight tool sold separately)	RA025-CFT	25	1941(101)	1.0	104	9.5	29	CFT-101/201RS1-S
	RA040-CFT	40	836(201)	1.3	135	9.5	37	CFT-201/281RS1-S
	RA060-CFT	60	460(401)	1.3	135	12.7	37	CFT-401RS1-S
	RA080-120-CFT	80	656(801)	2.0	157	12.7	42	CFT-801RS3-S
	RA0130-120-CFT	130	656(801)	2.3	169	12.7	46	CFT-801RS3-S
	RA0200-120-CFT	200	371(132)	2.7	196.5	15.9	56	CFT-132RS3-S1
	RA0300-120-CFT	300	250(202)	5.0	248	19	67	CFT-202RS3-S

※Length means the length of standard tool including the square drive, Connector parts are not included, Please refer to the drawings from the above QR code.

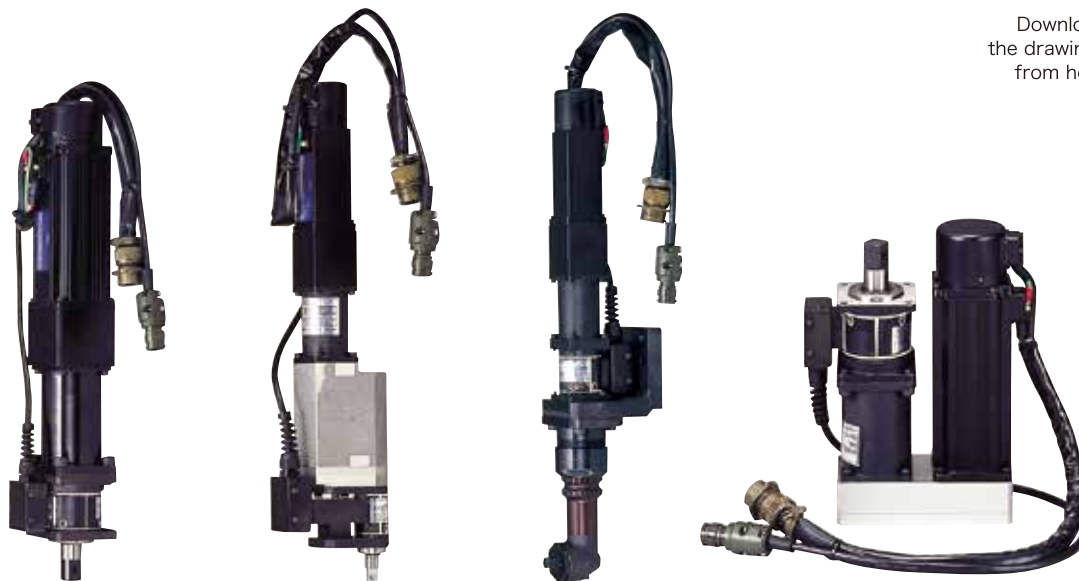
CFT Spindle Adaptor

Model	Max.Torque [Nm]	Length [mm]	Stroke [mm]	Square drive [mm]	Applicable tool
CFT-SP401-40V/H	40	165	40	9.5	CFT-101RS1-S/SL (-H) CFT-201RS1-S/SL (-H) CFT-281RS1-S/SL (-H) CFT-401RS1-S/SL (-H)
CFT-SP801-50V/H	80	217	50	12.7	CFT-801RS3-S/SL (-H)
CFT-SP132-50V/H	130	230	50	15.9	CFT-132RS3-S1/S1L (-H)
CFT-SP202-60V/H	200	253	60	19	CFT-202RS3-S/SL
CFT-SP302-70V/H	300	282	70	19	CFT-302RS3-S/SL
SP502Vertical/Horizontal	500	276	50	25.4	CFT-502RM4J-S



Nutrunner tools

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NFT TOOLS

Tool type	Model	Max.Torque [Nm]	Max.Speed [rpm]	Weight [kg]	Length [mm] ※1	Square drive [mm]	Min.Pitch [mm]	Applicable controller
Straight	NFT-101RM1-S1	10	500	2.1	311	9.5	41	MFC-S024
	NFT-201RM1-S	20	500	2.1	311	9.5	41	MFC-S024
	NFT-301RM2A-S	30	600	2.1	367	9.5	41	MFC-S024
	NFT-401RM1-S	40	250	2.1	311	9.5	41	MFC-S024
	NFT-801RM3-S	80	500	4.5	408	12.7	61	MFC-S060
	NFT-132RM3-S	130	395	5.5	417	15.9	61	MFC-S060
	NFT-202RM3-S	200	220	6	438	15.9	63	MFC-S060
	NFT-302RM3-S	300	150	9	456	19	77	MFC-S060
	NFT-303RM5-S	3000	39	70	946	44.5	172	MFC-S120
NFT-503RM5-S	5000	22	90	930	50.8	207	MFC-S120	
Offset	NFT-201RM1-O	20	500	2.7	388	9.5	25	MFC-S024
	NFT-301RM2A-O	30	600	3	466	9.5	29	MFC-S024
	NFT-401RM1-O	40	250	3	410	9.5	29	MFC-S024
	NFT-801RM3-O	80	500	6.8	497	12.7	35	MFC-S060
	NFT-132RM3-O	130	395	8	537	15.9	39	MFC-S060
	NFT-202RM3-O	200	220	9.5	573	15.9	45	MFC-S060
	NFT-302RM3-O	300	150	13.5	606	19	55	MFC-S060
Angle	NFT-201RM1-A55	31	321	4.2	433.5	12.7	37	MFC-S024
	NFT-401RM1-A55	56	160	4.2	433.5	12.7	37	MFC-S024
	NFT-801RM3-A130	124	321	8.5	551.5	15.9	46	MFC-S060
	NFT-132RM3-A250U	202	250	11.3	580	15.9	57	MFC-S060
	NFT-202RM3-A250U	255	140	11.8	601	15.9	57	MFC-S060
	NFT-202RM3-A380	310	142	16.9	640	19	75	MFC-S060
	NFT-302RM3-A550	466	96	22.2	658	25.4	75	MFC-S060
U type	NFT-101RM1-S1U	10	500	2.5	141(150)	9.5	41	MFC-S024
	NFT-201RM1-SU	20	500	2.5	141(150)	9.5	41	MFC-S024
	NFT-401RM1-SU	40	250	2.5	141(150)	9.5	41	MFC-S024
	NFT-132RM3-SU	130	395	6.5	209(221)	15.9	61	MFC-S060
	NFT-202RM3-SU	200	220	7	230(221)	15.9	63	MFC-S060
	NFT-302RM3-SU	300	150	10	257(221)	19	77	MFC-S060

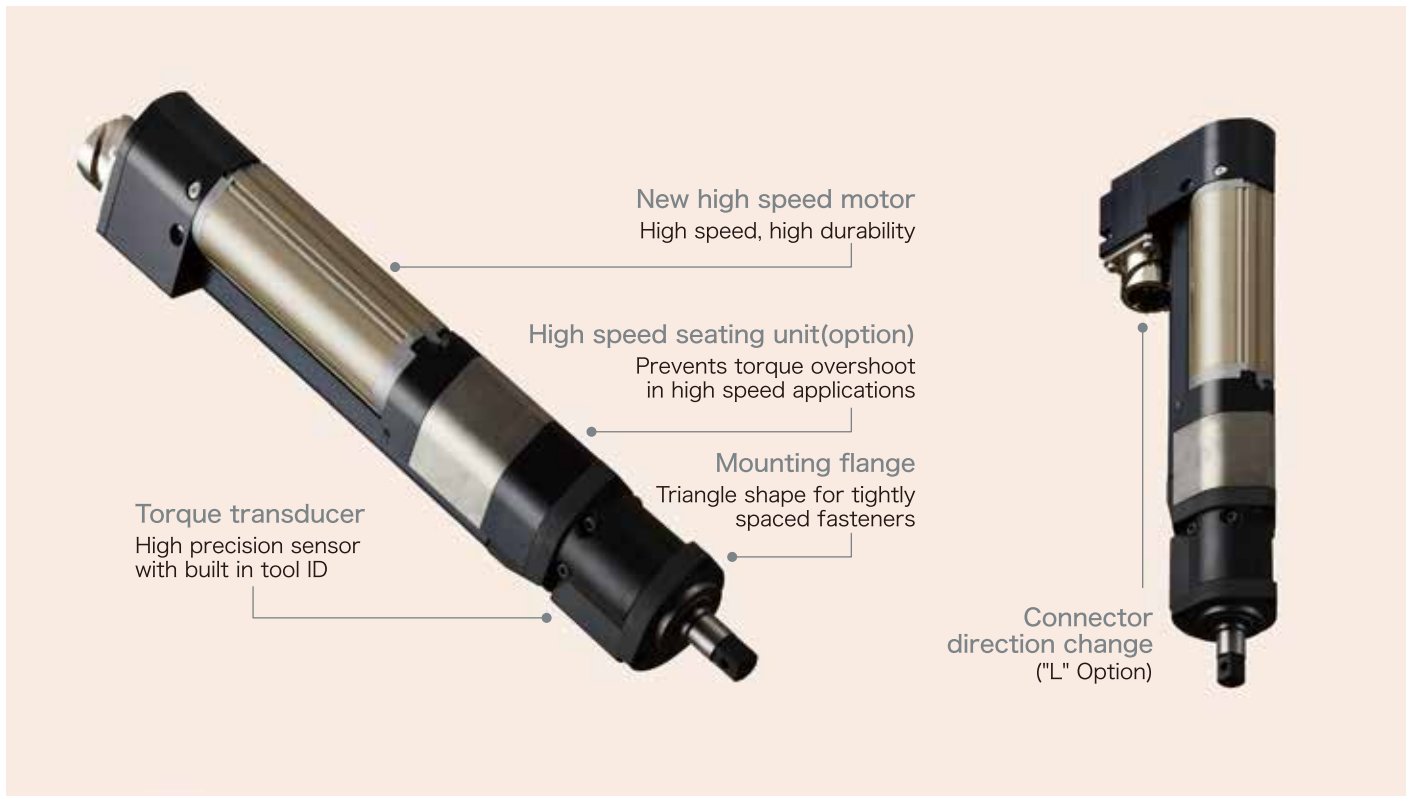
※Length means the length of standard tool including the square drive. Connector parts are not included. Please refer to the drawings from the above QR code.

NFT Spindle Adaptor

Model	Max.Torque [Nm]	Length [mm]	Stroke [mm]	Square drive [mm]	Applicable tool
SP201 Vertical/Horizontal	20	156	25	9.5	NFT-201RM1-S/SU
SP401 Vertical/Horizontal	40	180	40	9.5	NFT-401RM1-S/SU
SP801 Vertical/Horizontal	80	218	50	12.7	NFT-801RM3-S/SU
SP202 Vertical/Horizontal	200	237	50	15.9	NFT-132/202RM3-S/SU
SP302 Vertical/Horizontal	300	240	50	19	NFT-302RM3-S/SU



CFT tool features

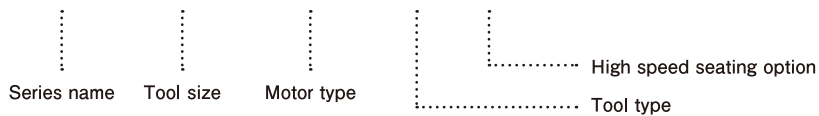


CFT tool

Model information

CFT - 201

RS1 - S - H



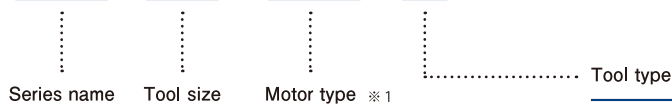
- S** Straight
- SL** Straight Tool Connector "L" Option
- O** Offset
- OL** Offset Tool Connector "L" Option

NFT tool

Model information

NFT - 201

RM1 - S

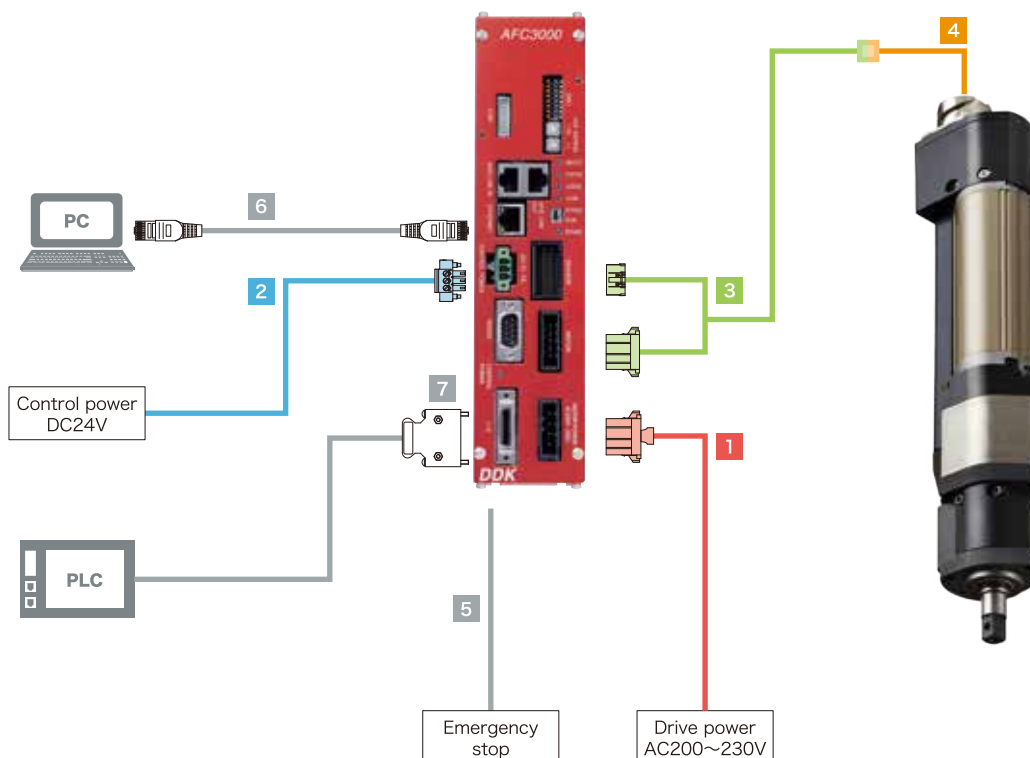


- S** Straight
- O** Offset
- A** Angle
- U** U type

※ 1 Option



RM1A/RM2A/RM3A
 "A" type adds motor connector directly mounted



Cable Applicable Table

No.	Cable name	MFT***M10*	CFT***RS1*	CFT***RS3*	CFT***RM4J*	NFT***RM1*	NFT***RM2*	NFT***RM3*	NFT***RM5*	Model	Standard length	CE <small>※1</small>	Remarks
1	Drive power cable for MFC-S008/S024/S060	■	■	■		■	■	■		C15-D1-M*	2m		Included in controller
	Drive power cable for MFC-S008/S024/S060(CE type)	■	■	■		■	■	■		C15-D1-M*-UC	2m	○	
	Drive power cable for MFC-S120				■					■ C15-D2-M*	2m		Included in controller
	Drive power cable for MFC-S120(CE type)				■					■ C15-D2-M*-UC	2m	○	
2	Control power cable for MFC	■	■	■	■	■	■	■		■ C30-DC1-M*	2m		
	Control power connector for MFC	■	■	■	■	■	■	■		■ MC1.5/3-STF-3.81			Included in controller
3	Tool cable for MFT	■								■ C30-FT2-M*	3m/5m/10m	○	
	Tool cable for CFT-RS1/RS3		■	■						■ C30-FT1-M*	5m/10m/15m	○	
	Tool cable for NFT-RM1/RM2/RM3					■	■	■		■ C30-FM1-M*	5m/10m/15m		For Robot type, please add "-R" to the end of the model
	Tool cable for CFT-RM4J,NFT-RM4H				■					■ C30-FW4-M*	5m/10m/15m		For Robot type, please add "-R" to the end of the model
	Motor cable for NFT-RM5								■	■ C15-M1-M*	5m/10m/15m		For Robot type, please add "-UR" to the end of the model
	Pre-amplifier & Resolver cable for NFT-RM5								■	■ C30-PR5-M*	5m/10m/15m		
4	Extension tool cable for CFT-RS1/RS3		■	■						■ C30-FT1-M*-E	5m/10m/15m	○	
	Extension tool cable for NFT-RM1/RM2/RM3					■	■	■		■ C15-EF1-M*	2m/5m/10m		C15-EF2-M*-LR for robot type.
	Extension tool cable for CFT-RM4J,NFT-RM4H				■					■ C15-EF2-M*	2m/5m/10m		For Robot type, please add "-UR" to the end of the model
	Extension motor cable for NFT-RM5								■	■ C15-EM1-M*	5m		For Robot type, please add "-UR" to the end of the model
	Extension resolver cable for NFT-RM5								■	■ C15-ER1-M*	2m/5m/10m		For Robot type, please add "-UR" to the end of the model
	Extension pre-amplifier cable for all NFT motors				■	■	■	■	■	■ C15-EP1-M*	2m/5m/10m		For Robot type, please add "-UR" to the end of the model
5	Stop signal connector	■	■	■	■	■	■	■		■ MC1.5/2-STF-3.81			Included in expansion unit1
	Stop signal cable	■	■	■	■	■	■	■		■ C30-XA1-M2	2m		
6	Ethernet Crossover	■	■	■	■	■	■	■		■ C30-UL1-M3	3m		For direct connect
	Ethernet Straight	■	■	■	■	■	■	■		■ C30-UL2-M3	3m		For connect through HUB
7	Standard I/O connector	■	■	■	■	■	■	■		■ 10126-3000PE			Included in controller
	Standard I/O cable	■	■	■	■	■	■	■		■ C30-SU1-M3	3m		
8	Axis communication cable	■	■	■	■	■	■	■		■ C15-A3-M03	0.3m		
	Axis communication connector	■	■	■	■	■	■	■		■ C30-AL2			

※MFT,CFT tools are only compatible to CE.Please change to the control power cable to CE compatible model.
 ※You need to change the Control power cable model to "-UC" but you don't need to change any other cables.

Applications

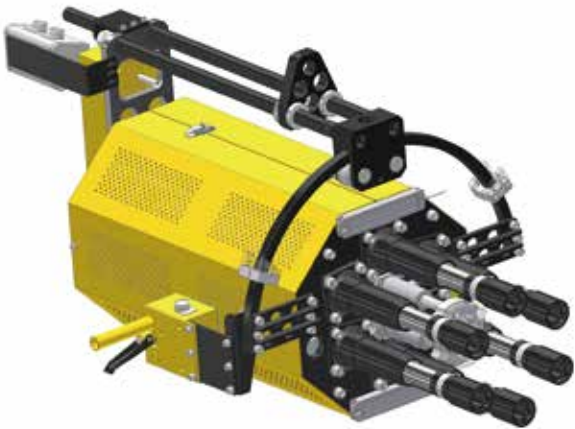
Sliding arm for manual production



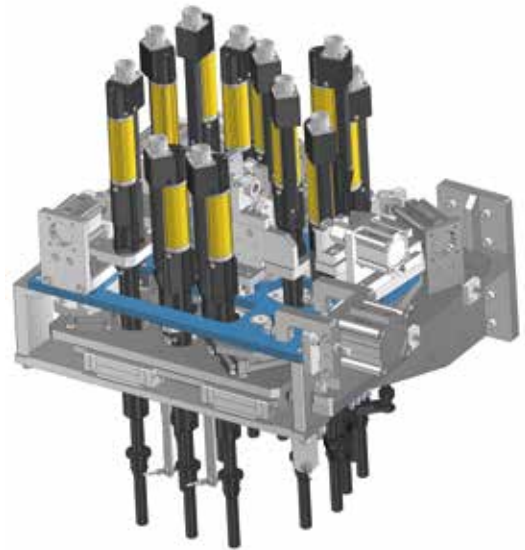
Multi-spindle manually-operated hanging head



Tire fastening systems



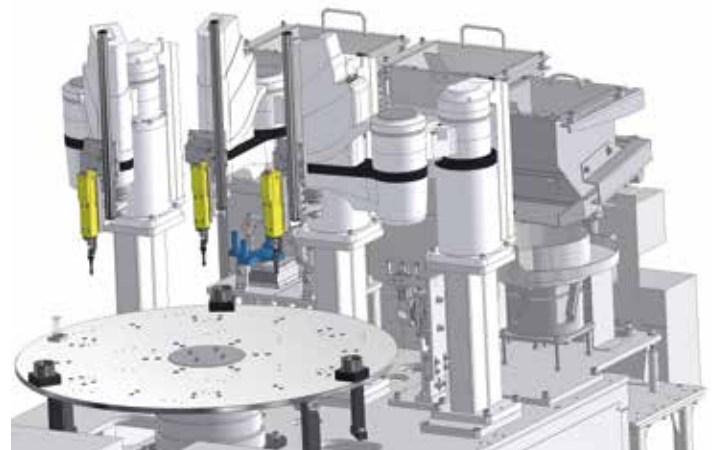
Open type, machine mount - variable pitch systems



Robotic systems (with tool change function)



Dial table type Micro-nutrunner systems

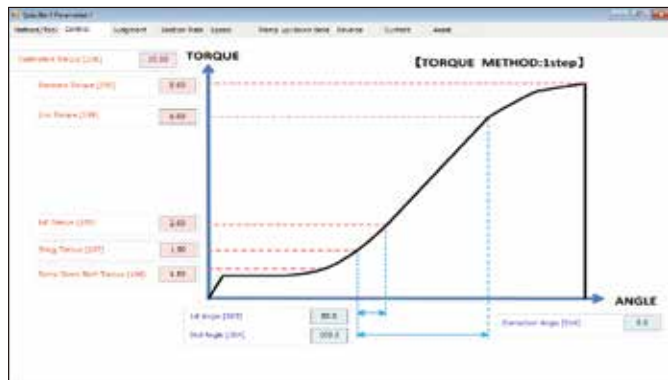


User Software

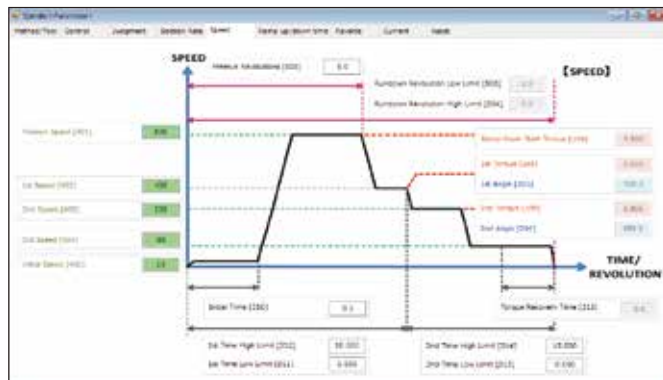
Setup / Monitor Software for Windows (MFC-UC-N)

- Simple graphic settings
 - Result data Collection & Storage
 - Fastening curve display and Excel format storage
 - Fastening Sequence function
- *Supported language: Japanese/English/Chinese/Korean/Indonesian

Control setting display



Speed setting display



Sequence setting display

Step	Command	Date 1	Date 2	Comment
1	Line Report	Revolution 1	0%	
2	Report Jump	0		
3	Set Stop	Revolution 2	0%	
4	Data Report			
5	Report Jump	0		
6	Set Stop	Revolution 3	0%	
7	Data Report			
8	Set Stop (Data Report)			

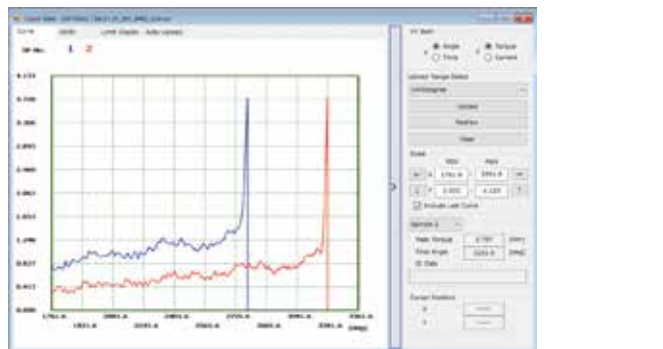
I/O monitor

Input Signal	Output Signal	Output Signal 2	Output Signal 3	Output Signal 4
1. Emergency Stop	Multi	Stop	Stop	Stop
2. Start	Multi	Start	Start	Start
3. Sequence Start Bit 1	Multi	Sequence Start Bit 1	Sequence Start Bit 2	Sequence Start Bit 3
4. Sequence Start Bit 2	Multi	Sequence Start Bit 2	Sequence Start Bit 3	Sequence Start Bit 4
5. Sequence Start Bit 3	Multi	Sequence Start Bit 3	Sequence Start Bit 4	Sequence Start Bit 5
6. Sequence Start Bit 4	Multi	Sequence Start Bit 4	Sequence Start Bit 5	Sequence Start Bit 6
7. Cycle Count Up	Multi	Sequence Start Bit 5	Sequence Start Bit 6	Sequence Start Bit 7
8. Cycle Count Down	Multi	Sequence Start Bit 6	Sequence Start Bit 7	Sequence Start Bit 8
9. Input Start Port 1	Multi	Sequence Start Bit 7	Sequence Start Bit 8	Sequence Start Bit 9
10. Input Start Port 2	Multi	Sequence Start Bit 8	Sequence Start Bit 9	Sequence Start Bit 10
11. Input Start Port 3	Multi	Output Port 1	Output Port 2	Output Port 3
12. Input Start Port 4	Multi	Output Port 3	Output Port 4	Output Port 5
13. Input Start Port 5	Multi	Output Port 4	Output Port 5	Output Port 6
14. Input Start Port 6	Multi	Output Port 5	Output Port 6	Output Port 7
15. Sequence 1 BIT/FAULT	Multi	Sequence Start Bit 9	Sequence Start Bit 10	Sequence Start Bit 11
16. Sequence 2 BIT/FAULT	Multi	Sequence Start Bit 10	Sequence Start Bit 11	Sequence Start Bit 12
17. Sequence 3 BIT/FAULT	Multi	Sequence Start Bit 11	Sequence Start Bit 12	Sequence Start Bit 13
18. Sequence 4 BIT/FAULT	Multi	Sequence Start Bit 12	Sequence Start Bit 13	Sequence Start Bit 14
19. Sequence 5 BIT/FAULT	Multi	Sequence Start Bit 13	Sequence Start Bit 14	Sequence Start Bit 15
20. Sequence 6 BIT/FAULT	Multi	Sequence Start Bit 14	Sequence Start Bit 15	Sequence Start Bit 16
21. Sequence 7 BIT/FAULT	Multi	Sequence Start Bit 15	Sequence Start Bit 16	Sequence Start Bit 17
22. Sequence 8 BIT/FAULT	Multi	Sequence Start Bit 16	Sequence Start Bit 17	Sequence Start Bit 18
23. Sequence 9 BIT/FAULT	Multi	Sequence Start Bit 17	Sequence Start Bit 18	Sequence Start Bit 19
24. Sequence 10 BIT/FAULT	Multi	Sequence Start Bit 18	Sequence Start Bit 19	Sequence Start Bit 20
25. Sequence 11 BIT/FAULT	Multi	Sequence Start Bit 19	Sequence Start Bit 20	Sequence Start Bit 21
26. Sequence 12 BIT/FAULT	Multi	Sequence Start Bit 20	Sequence Start Bit 21	Sequence Start Bit 22
27. Sequence 13 BIT/FAULT	Multi	Sequence Start Bit 21	Sequence Start Bit 22	Sequence Start Bit 23
28. Sequence 14 BIT/FAULT	Multi	Sequence Start Bit 22	Sequence Start Bit 23	Sequence Start Bit 24
29. Sequence 15 BIT/FAULT	Multi	Sequence Start Bit 23	Sequence Start Bit 24	Sequence Start Bit 25
30. Sequence 16 BIT/FAULT	Multi	Sequence Start Bit 24	Sequence Start Bit 25	Sequence Start Bit 26
31. Sequence 17 BIT/FAULT	Multi	Sequence Start Bit 25	Sequence Start Bit 26	Sequence Start Bit 27
32. Sequence 18 BIT/FAULT	Multi	Sequence Start Bit 26	Sequence Start Bit 27	Sequence Start Bit 28
33. Sequence 19 BIT/FAULT	Multi	Sequence Start Bit 27	Sequence Start Bit 28	Sequence Start Bit 29
34. Sequence 20 BIT/FAULT	Multi	Sequence Start Bit 28	Sequence Start Bit 29	Sequence Start Bit 30
35. Sequence 21 BIT/FAULT	Multi	Sequence Start Bit 29	Sequence Start Bit 30	Sequence Start Bit 31
36. Sequence 22 BIT/FAULT	Multi	Sequence Start Bit 30	Sequence Start Bit 31	Sequence Start Bit 32
37. Sequence 23 BIT/FAULT	Multi	Sequence Start Bit 31	Sequence Start Bit 32	Sequence Start Bit 33
38. Sequence 24 BIT/FAULT	Multi	Sequence Start Bit 32	Sequence Start Bit 33	Sequence Start Bit 34
39. Sequence 25 BIT/FAULT	Multi	Sequence Start Bit 33	Sequence Start Bit 34	Sequence Start Bit 35
40. Sequence 26 BIT/FAULT	Multi	Sequence Start Bit 34	Sequence Start Bit 35	Sequence Start Bit 36
41. Sequence 27 BIT/FAULT	Multi	Sequence Start Bit 35	Sequence Start Bit 36	Sequence Start Bit 37
42. Sequence 28 BIT/FAULT	Multi	Sequence Start Bit 36	Sequence Start Bit 37	Sequence Start Bit 38
43. Sequence 29 BIT/FAULT	Multi	Sequence Start Bit 37	Sequence Start Bit 38	Sequence Start Bit 39
44. Sequence 30 BIT/FAULT	Multi	Sequence Start Bit 38	Sequence Start Bit 39	Sequence Start Bit 40
45. Sequence 31 BIT/FAULT	Multi	Sequence Start Bit 39	Sequence Start Bit 40	Sequence Start Bit 41
46. Sequence 32 BIT/FAULT	Multi	Sequence Start Bit 40	Sequence Start Bit 41	Sequence Start Bit 42
47. Sequence 33 BIT/FAULT	Multi	Sequence Start Bit 41	Sequence Start Bit 42	Sequence Start Bit 43
48. Sequence 34 BIT/FAULT	Multi	Sequence Start Bit 42	Sequence Start Bit 43	Sequence Start Bit 44
49. Sequence 35 BIT/FAULT	Multi	Sequence Start Bit 43	Sequence Start Bit 44	Sequence Start Bit 45
50. Sequence 36 BIT/FAULT	Multi	Sequence Start Bit 44	Sequence Start Bit 45	Sequence Start Bit 46
51. Sequence 37 BIT/FAULT	Multi	Sequence Start Bit 45	Sequence Start Bit 46	Sequence Start Bit 47
52. Sequence 38 BIT/FAULT	Multi	Sequence Start Bit 46	Sequence Start Bit 47	Sequence Start Bit 48
53. Sequence 39 BIT/FAULT	Multi	Sequence Start Bit 47	Sequence Start Bit 48	Sequence Start Bit 49
54. Sequence 40 BIT/FAULT	Multi	Sequence Start Bit 48	Sequence Start Bit 49	Sequence Start Bit 50
55. Sequence 41 BIT/FAULT	Multi	Sequence Start Bit 49	Sequence Start Bit 50	Sequence Start Bit 51
56. Sequence 42 BIT/FAULT	Multi	Sequence Start Bit 50	Sequence Start Bit 51	Sequence Start Bit 52
57. Sequence 43 BIT/FAULT	Multi	Sequence Start Bit 51	Sequence Start Bit 52	Sequence Start Bit 53
58. Sequence 44 BIT/FAULT	Multi	Sequence Start Bit 52	Sequence Start Bit 53	Sequence Start Bit 54
59. Sequence 45 BIT/FAULT	Multi	Sequence Start Bit 53	Sequence Start Bit 54	Sequence Start Bit 55
60. Sequence 46 BIT/FAULT	Multi	Sequence Start Bit 54	Sequence Start Bit 55	Sequence Start Bit 56
61. Sequence 47 BIT/FAULT	Multi	Sequence Start Bit 55	Sequence Start Bit 56	Sequence Start Bit 57
62. Sequence 48 BIT/FAULT	Multi	Sequence Start Bit 56	Sequence Start Bit 57	Sequence Start Bit 58
63. Sequence 49 BIT/FAULT	Multi	Sequence Start Bit 57	Sequence Start Bit 58	Sequence Start Bit 59
64. Sequence 50 BIT/FAULT	Multi	Sequence Start Bit 58	Sequence Start Bit 59	Sequence Start Bit 60
65. Sequence 51 BIT/FAULT	Multi	Sequence Start Bit 59	Sequence Start Bit 60	Sequence Start Bit 61
66. Sequence 52 BIT/FAULT	Multi	Sequence Start Bit 60	Sequence Start Bit 61	Sequence Start Bit 62
67. Sequence 53 BIT/FAULT	Multi	Sequence Start Bit 61	Sequence Start Bit 62	Sequence Start Bit 63
68. Sequence 54 BIT/FAULT	Multi	Sequence Start Bit 62	Sequence Start Bit 63	Sequence Start Bit 64
69. Sequence 55 BIT/FAULT	Multi	Sequence Start Bit 63	Sequence Start Bit 64	Sequence Start Bit 65
70. Sequence 56 BIT/FAULT	Multi	Sequence Start Bit 64	Sequence Start Bit 65	Sequence Start Bit 66
71. Sequence 57 BIT/FAULT	Multi	Sequence Start Bit 65	Sequence Start Bit 66	Sequence Start Bit 67
72. Sequence 58 BIT/FAULT	Multi	Sequence Start Bit 66	Sequence Start Bit 67	Sequence Start Bit 68
73. Sequence 59 BIT/FAULT	Multi	Sequence Start Bit 67	Sequence Start Bit 68	Sequence Start Bit 69
74. Sequence 60 BIT/FAULT	Multi	Sequence Start Bit 68	Sequence Start Bit 69	Sequence Start Bit 70
75. Sequence 61 BIT/FAULT	Multi	Sequence Start Bit 69	Sequence Start Bit 70	Sequence Start Bit 71
76. Sequence 62 BIT/FAULT	Multi	Sequence Start Bit 70	Sequence Start Bit 71	Sequence Start Bit 72
77. Sequence 63 BIT/FAULT	Multi	Sequence Start Bit 71	Sequence Start Bit 72	Sequence Start Bit 73
78. Sequence 64 BIT/FAULT	Multi	Sequence Start Bit 72	Sequence Start Bit 73	Sequence Start Bit 74
79. Sequence 65 BIT/FAULT	Multi	Sequence Start Bit 73	Sequence Start Bit 74	Sequence Start Bit 75
80. Sequence 66 BIT/FAULT	Multi	Sequence Start Bit 74	Sequence Start Bit 75	Sequence Start Bit 76
81. Sequence 67 BIT/FAULT	Multi	Sequence Start Bit 75	Sequence Start Bit 76	Sequence Start Bit 77
82. Sequence 68 BIT/FAULT	Multi	Sequence Start Bit 76	Sequence Start Bit 77	Sequence Start Bit 78
83. Sequence 69 BIT/FAULT	Multi	Sequence Start Bit 77	Sequence Start Bit 78	Sequence Start Bit 79
84. Sequence 70 BIT/FAULT	Multi	Sequence Start Bit 78	Sequence Start Bit 79	Sequence Start Bit 80
85. Sequence 71 BIT/FAULT	Multi	Sequence Start Bit 79	Sequence Start Bit 80	Sequence Start Bit 81
86. Sequence 72 BIT/FAULT	Multi	Sequence Start Bit 80	Sequence Start Bit 81	Sequence Start Bit 82
87. Sequence 73 BIT/FAULT	Multi	Sequence Start Bit 81	Sequence Start Bit 82	Sequence Start Bit 83
88. Sequence 74 BIT/FAULT	Multi	Sequence Start Bit 82	Sequence Start Bit 83	Sequence Start Bit 84
89. Sequence 75 BIT/FAULT	Multi	Sequence Start Bit 83	Sequence Start Bit 84	Sequence Start Bit 85
90. Sequence 76 BIT/FAULT	Multi	Sequence Start Bit 84	Sequence Start Bit 85	Sequence Start Bit 86
91. Sequence 77 BIT/FAULT	Multi	Sequence Start Bit 85	Sequence Start Bit 86	Sequence Start Bit 87
92. Sequence 78 BIT/FAULT	Multi	Sequence Start Bit 86	Sequence Start Bit 87	Sequence Start Bit 88
93. Sequence 79 BIT/FAULT	Multi	Sequence Start Bit 87	Sequence Start Bit 88	Sequence Start Bit 89
94. Sequence 80 BIT/FAULT	Multi	Sequence Start Bit 88	Sequence Start Bit 89	Sequence Start Bit 90
95. Sequence 81 BIT/FAULT	Multi	Sequence Start Bit 89	Sequence Start Bit 90	Sequence Start Bit 91
96. Sequence 82 BIT/FAULT	Multi	Sequence Start Bit 90	Sequence Start Bit 91	Sequence Start Bit 92
97. Sequence 83 BIT/FAULT	Multi	Sequence Start Bit 91	Sequence Start Bit 92	Sequence Start Bit 93
98. Sequence 84 BIT/FAULT	Multi	Sequence Start Bit 92	Sequence Start Bit 93	Sequence Start Bit 94
99. Sequence 85 BIT/FAULT	Multi	Sequence Start Bit 93	Sequence Start Bit 94	Sequence Start Bit 95
100. Sequence 86 BIT/FAULT	Multi	Sequence Start Bit 94	Sequence Start Bit 95	Sequence Start Bit 96

Fastening result monitor

Sample No.	Start Date	End Date	Display Range	Display Filter
80	2023-08-01 13:47:18	0	0	0
81	2023-08-01 13:48:39	0	0	0
82	2023-08-01 13:49:57	0	0	0
83	2023-08-01 13:51:15	0	0	0
84	2023-08-01 13:52:33	0	0	0
85	2023-08-01 13:53:51	0	0	0
86	2023-08-01 13:55:09	0	0	0
87	2023-08-01 13:56:27	0	0	0
88	2023-08-01 13:57:45	0	0	0
89	2023-08-01 13:59:03	0	0	0
90	2023-08-01 14:00:21	0	0	0
91	2023-08-01 14:01:39	0	0	0
92	2023-08-01 14:02:57	0	0	0
93	2023-08-01 14:04:15	0	0	0
94	2023-08-01 14:05:33	0	0	0
95	2023-08-01 14:06:51	0	0	0
96	2023-08-01 14:08:09	0	0	0
97	2023-08-01 14:09:27	0	0	0
98	2023-08-01 14:10:45	0	0	0
99	2023-08-01 14:12:03	0	0	0
100	2023-08-01 14:13:21	0	0	0

Fastening curve monitor





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