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1 Product Description

**Self-contained Smart Camera with User-Friendly Vision Manager Software**

- Banner’s free and easy-to-use Vision Manager Software provides a number of tools and capabilities that enable VE Series smart cameras to solve a wide range of vision applications, such as item detection, part positioning, feature measurement, and flaw analysis.
- Runtime editing capability reduces costly downtime and the software emulator allows for offline building and troubleshooting of applications.
- Factory communications (EtherNet/IP™, Modbus/TCP, PROFINET®, FTP and Serial RS-232) for integration on the manufacturing floor.
- Six optically isolated I/O and an external light connector on the smart camera.
- Two-line, eight-character onboard display provides smart camera information and focus number and makes it easy to update the smart camera settings, facilitating fast product changeover.
- Robust metal housing with optional sealed lens covers to achieve IP67 rating for use in harsh environments with heat, vibration, or moisture.
- Bright indicator lights for easy viewing of smart camera status.

**WARNING: Not To Be Used for Personnel Protection**

Never use this device as a sensing device for personnel protection. Doing so could lead to serious injury or death. This device does not include the self-checking redundant circuitry necessary to allow its use in personnel safety applications. A sensor failure or malfunction can cause either an energized or de-energized sensor output condition.

**CAUTION: Electrostatic Discharge**

Avoid the damage that electrostatic discharge (ESD) can cause to the Sensor.

Always use a proven method for preventing electrostatic discharge when installing a lens or attaching a cable.

**CAUTION: Hot Surface**

Use caution when handling the camera. The surface of the camera may be hot during operation and immediately after use.

### 1.1 Models

<table>
<thead>
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<th>Model</th>
<th>Resolution</th>
</tr>
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<tbody>
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<td>VE200G1A</td>
<td>WVGA, 752 × 480 pixels grayscale</td>
</tr>
<tr>
<td>VE201G1A</td>
<td>1.3 MP, 1280 × 1024 pixels grayscale</td>
</tr>
<tr>
<td>VE202G1A</td>
<td>2 MP, 1600 × 1200 pixels grayscale</td>
</tr>
<tr>
<td>VE205G1A</td>
<td>5 MP, 2592 × 2048 pixels grayscale</td>
</tr>
</tbody>
</table>

Model VE202G2A, 2 MP, 1600 × 1200 grayscale with 4-pin D-code M12 Ethernet connection is also available.
2 Overview

The VE Series Smart Camera is easy to use and has advanced visual inspection capabilities for automation or control applications. Users can quickly set up the sensor using the Vision Manager software to solve a diverse range of applications on the factory floor.

2.1 Features

![Sensor Features](image)

1. Display
2. Buttons
3. Pass/Fail indicator (green/red)
4. Ready/Trigger indicator (green/amber)
5. Power/Error indicator (green/red)
6. Ethernet indicator (amber), not shown
7. Ethernet connection
8. Light connection
9. Power, Discrete I/O connection

2.1.1 Display

![Display with Home Screen](image)

The display is a 2-line, 8-character LCD. The main screen is the Home Screen, which shows the name of the current inspection and the slot number (inspection location). Use the display to view or change several sensor settings.

2.1.2 Indicators

Four LED indicators provide ongoing indication of the sensing status.

- **Power/Error Indicator**
  - Green = Normal operation
  - Red = System error

- **Ready/Trigger Indicator**
  - Green = Ready for trigger
  - Yellow = Trigger is active
  - OFF = Not ready for a trigger, triggers will be missed

- **Pass/Fail Indicator**
  - Green = Previous inspection passed
  - Red = Previous inspection failed
  - OFF = No trigger since power up

- **Ethernet Indicator**
  - Amber solid = Ethernet connection
  - Amber flashing = Ethernet activity
  - OFF = no connection

2.1.3 Buttons

Use the sensor buttons **Down**, **Up**, **Enter**, and **Escape** to configure several sensor settings and to access sensor information. See **Figure 300** (p. 156) for additional information on using the buttons.
2.2 Vision Manager Software

Set up the VE Series Smart Camera using the free Vision Manager Software, available for download at www.bannerengineering.com.

This easy-to-use image processing software provides a variety of tools and capabilities to solve a wide range of vision applications such as item detection, part positioning, feature measurement and flaw analysis. Run-time editing allows you to make changes to an inspection while the sensor is running, reducing costly downtime. Vision Manager also includes a full software emulator, allowing users to develop or troubleshoot inspections offline, without a sensor.

Password-protected user profiles are also available to enable different levels of access to the tools and data.

Use Vision Manager to configure Banner vision devices including iVu Vision Sensors and VE Smart Cameras.
3 Specifications and Requirements

3.1 Specifications

Power
12 V dc to 30 V dc (24 V dc ± 10% if a Banner light source is powered by the sensor)
Current: 400 mA maximum (exclusive of load and lights)
Use only with a suitable Class 2 power supply, or current limiting power supply rated 12 V dc to 30 V dc, 1 A

Supply Protection Circuitry
Protected against reverse polarity and transient overvoltages

Discrete I/O
1 Trigger IN
5 Programmable I/O

Output Configuration
Optically isolated

Output Rating
Output Resistance: < 2 Ω
Strobe Output Resistance: < 13 Ω
Programmable Output: 100 mA
External Strobe Output: 100 mA
Off-State Leakage Current: < 100 µA

External Light Maximum Current Draw
350 mA

Exposure Time
0.01 ms to 500 ms

Imager
VE200G1A: 6.9 mm × 5.5 mm, 8.7 mm diagonal (1/1.8-inch CMOS)
VE201G1A: 6.9 mm × 5.5 mm, 8.7 mm diagonal (1/1.8-inch CMOS)
VE202G*A: 7.2 mm × 5.4 mm, 9.0 mm diagonal (1/1.8-inch CMOS)
VE205G1A: 12.4 mm × 9.8 mm, 15.9 mm diagonal (1-inch CMOS)

Lens
C-mount

Pixel Size
VE200G1A: 5.3 µm
VE201G1A: 5.3 µm
VE202G*A: 4.5 µm
VE205G1A: 4.8 µm

Communication
10/100/1000 Mbps Ethernet

Communication Protocols
Ethernet/IP®, Modbus/TCP, PCCC, PROFINET®, TCP/IP, FTP, and RS-232

Memory
Device Settings and Inspection Storage Memory: 500 MB
Number of inspection files: 999

Acquisition
256 grayscale levels

Model | Frames Per Second | Image Size
--- | --- | ---
VE200G1A | 60 fps, maximum | 752 × 480 px
VE201G1A | 60 fps, maximum | 1280 × 1024 px
VE202G*A | 50 fps, maximum | 1600 × 1200 px
VE205G1A | 22 fps, maximum | 2592 × 2048 px

Torque—Tapped Holes for Mounting Screws
8 lbf-in (0.9 N·m) maximum torque

Construction
Housing: Aluminum
Display Label: Polyester

Connections
Ethernet: M12, 8-pin or 4-pin D-code Euro-style female
Light Connector: M8, 3-pin Pico-style female
Power, Discrete I/O: M12, 12-pin Euro-style male

Environmental Rating
IEC IP67 with an optional sealed lens cover properly installed

Operating Conditions
Operating Temperature: 0 °C to +50 °C (+32 °F to +122 °F)
95% maximum relative humidity (non-condensing)
Stable Ambient Lighting: No large, quick changes in light level; no direct or reflected sunlight
Storage Temperature: −30 °C to +70 °C (−22 °F to +158 °F)

Vibration and Mechanical Shock
Meets EN 60947-5-2: IEC 60068-2-27 (Shock: 30G); IEC 60068-2-6 (Vibration: 10 Hz to 60 Hz, 1 mm amplitude)

Certifications

3.2 PC Requirements

Operating System
Microsoft® Windows® operating system version 7, 8, or 10®

System Type
32-bit, 64-bit

Hard Drive Space
80 MB (plus up to 280 MB for Microsoft .NET 4.5, if not already installed)

Memory (RAM)
512 MB minimum, 1 GB+ recommended

Processor
1 GHz minimum, 2 GHz+ recommended

Screen Resolution
1024 × 768 full color minimum, 1650 × 1050 full color recommended

Third-Party Software
Microsoft .NET 4.5, PDF Viewer (such as Adobe Acrobat)

USB Port
USB 3.0, recommended if a USB to Ethernet adapter used to communicate with the sensor

---

This value can vary based on inspection settings.
4 1000 Mbps communication speed not available on 4-pin Ethernet models
5 Microsoft and Windows are registered trademarks of Microsoft Corporation in the United States and/or other countries.
3.3 Dimensions

All measurements are listed in millimeters [inches], unless noted otherwise.

* 41.6[1.64] for 5 MP (VE205G1A) models
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4 Installation Instructions

4.1 Install the Accessories

1. VE sensor
2. O-ring (used with the sealed lens cover)
3. C-mount lens (available separately)
4. Filter (optional)
5. Sealed lens cover (optional)

An external light (optional) is not shown.

Note: A sealed lens cover and a ring light cannot be used together.

1. If you are using a sealed lens cover: Remove the black thread protector (not shown) from the sensor (1).
2. If you are using a sealed lens cover: Fit a single o-ring (2) into the undercut area behind the sensor threads.
3. Remove the yellow temporary imager cover (not shown) from the sensor.

CAUTION: Do not remove the imager cover until you are ready to install the lens. Do not touch the imager. Dirt or dust on the imager can affect sensing reliability.

4. Remove any protective covers from the lens. Handle the lens carefully to avoid smudges and dirt on the optical elements.
5. Thread the lens (3) onto the sensor.
6. Make sure that the lens is focused; see Acquire a Good Image (p. 17).
7. Use the thumbscrews on the lens to lock the focus and aperture rings and to prevent movement that can occur during cleaning or accidental contact.
8. If you are using a filter: Thread the filter (4) onto the front of the C-mount lens.
9. If you are using a linear polarization filter: Rotate the outer portion of the filter mount to determine the position where glare is reduced the most, and use the locking thumbscrew to fasten the filter in position.
10. If you are using a sealed lens cover: Thread the sealed lens cover (5) onto the threaded portion of the sensor.
11. Or, if you are using an external light bracket: Attach an external light bracket to the sensor using the provided hardware kit.

Note: For optimal imaging, provide adequate dissipation of heat. A good heat conductor, such as aluminum, may be required.

4.2 Mount the Sensor

1. If a bracket is needed, mount the device onto the bracket.
2. Mount the device (or the device and the bracket) to the machine or equipment at the desired location. Do not tighten the mounting screws at this time.

CAUTION: This device accepts M3×0.5-h6 screws. Engaging the screws more than 3.95 mm will damage the device.

3. Check the device alignment.
4. Tighten the mounting screws to secure the device (or the device and the bracket) in the aligned position.
4.3 Connect the Cables

1. Connect the Ethernet cable to the sensor (3) and to the computer or Ethernet switch.
2. Connect the power, discrete I/O cable to the sensor (1), and the leads to the appropriate locations. See Table 1 (p. 13) for the power, discrete I/O connections.
3. Connect the external light cable (optional) to the light connection (2) if the light is powered by the sensor.

CAUTION: Use Appropriate Power

If the light is powered by the sensor, the sensor power source must be 24 V dc. This connection is for Banner lights only.

Table 1: Power and I/O Pinouts

<table>
<thead>
<tr>
<th>Pin</th>
<th>Wire Color</th>
<th>Description</th>
<th>Direction</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>White</td>
<td>Discrete I/O #3</td>
<td>Input/Output</td>
</tr>
<tr>
<td>2</td>
<td>Brown</td>
<td>12 V dc to 30 V dc</td>
<td>Input</td>
</tr>
<tr>
<td>3</td>
<td>Green</td>
<td>I/O output common</td>
<td>-</td>
</tr>
<tr>
<td>4</td>
<td>Yellow</td>
<td>RS-232 TX (transmit)</td>
<td>Output</td>
</tr>
<tr>
<td>5</td>
<td>Gray</td>
<td>Discrete I/O #5</td>
<td>Input/Output</td>
</tr>
<tr>
<td>6</td>
<td>Pink</td>
<td>Trigger input</td>
<td>Input</td>
</tr>
<tr>
<td>7</td>
<td>Blue</td>
<td>Common</td>
<td>Input</td>
</tr>
<tr>
<td>8</td>
<td>Red</td>
<td>Discrete I/O #2</td>
<td>Input/Output</td>
</tr>
<tr>
<td>9</td>
<td>Orange</td>
<td>I/O input common</td>
<td>-</td>
</tr>
<tr>
<td>10</td>
<td>Light Blue</td>
<td>Discrete I/O #4</td>
<td>Input/Output</td>
</tr>
<tr>
<td>11</td>
<td>Black</td>
<td>Discrete I/O #1</td>
<td>Input/Output</td>
</tr>
<tr>
<td>12</td>
<td>Violet</td>
<td>RS-232 RX (receive)</td>
<td>Input</td>
</tr>
<tr>
<td>Shield</td>
<td>Bare metal</td>
<td>Chassis ground</td>
<td>-</td>
</tr>
</tbody>
</table>
4.3.1 Wiring Diagrams

**Figure 5. PNP Output**

**Figure 6. NPN Output**

**Figure 7. PNP Input**

**Figure 8. NPN Input**

**Figure 9. PNP Inputs and Outputs**

**PNP Inputs & Outputs**

1 = White
2 = Brown
3 = Green
4 = Yellow
5 = Gray
6 = Pink
7 = Blue
8 = Red
9 = Orange
10 = Light Blue
11 = Black
12 = Violet

This is a typical example. Applications may vary.

*Programmable I/O shown set as an output in this example
**Programmable I/O shown set as an input in this example
**NPN Inputs & Outputs**

1 = White  
2 = Brown  
3 = Green  
4 = Yellow  
5 = Gray  
6 = Pink  
7 = Blue  
8 = Red  
9 = Orange  
10 = Light Blue  
11 = Black  
12 = Violet

This is a typical example. Applications may vary.  
* Programmable I/O shown set as an output in this example.  
** Programmable I/O shown set as an input in this example.

![Diagram of NPN Inputs and Outputs](image)

**Figure 10. NPN Inputs and Outputs**

### 4.4 Install the Software

**Important:** Administrative rights are required to install the Vision Manager software.

1. Download the latest version of the software from [www.bannerengineering.com](http://www.bannerengineering.com).
2. Navigate to and open the downloaded file.
3. Click **Next** to begin the installation process.
4. Confirm the software destination and availability for users and click **Next**.
5. Click **Install** to install the software.
6. Depending on your system settings, a popup window may appear prompting to allow Vision Manager to make changes to your computer. Click **Yes**.
7. Click **Close** to exit the installer.
5 Getting Started

Power up the sensor, and verify that the power/error LED is ON green and that the Ethernet indicator is ON amber to verify the Ethernet connection.

5.1 Connect to the Sensor

These instructions use Windows® operating system version 7, 8, or 10.6

1. Confirm the network connections.
   a) Click the Start button, then on the Start menu, click Control Panel.
   b) In Control Panel, click Network and Internet, then click Network and Sharing Center, and then click Change adapter settings.
   c) Right-click on the connection that you want to change, then click Properties.
      If you are prompted for an administrator password or confirmation, enter the password or provide confirmation.
   d) In the connection properties, click Internet Protocol Version 4 (TCP/IPv4), and then click Properties.

   ![Local Area Connection Properties](Figure 11. Local Area Connection Properties)

   e) In the Internet Protocol (TCP/IPv4) Properties, select Use the following IP address.
   f) Make sure that the IP address is 192.168.0.2, and the subnet mask is 255.255.255.0.

2. Open Vision Manager from the desktop or the Start menu.
   The Sensor Neighborhood tab displays and lists the available sensors.

3. From Sensor Neighborhood, click to connect to the desired sensor.
   The status changes from Available to Connected and the Sensor screen displays. Click to disconnect from the sensor.

4. If the desired sensor is not listed, verify that:
   - The network adapter connected to the sensor has the same subnet mask as the sensor (for example, 192.168.0.xxx); view the subnet mask in the Network Adapters list at Home > Sensor Neighborhood > Network Adapters
   - The Ethernet cable is the correct type
   - The TCP/IPv4 settings are correct

Or, manually enter the sensor’s IP address.

   **Note:** The sensor’s IP address and subnet mask are also available from the sensor display.

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6 Windows is a registered trademark of Microsoft Corporation in the United States and/or other countries.
5.2 Acquire a Good Image

The sensor needs to capture a good image of each part to ensure that it correctly passes good parts and fails bad parts.

1. Make sure that the lighting is appropriate for your target. Use supplementary lighting, such as a ring light, if necessary.
2. Click the 🕵️ Sensor screen.
3. Click the 🕵️ camera tool on Tools and Results.
   The Inputs parameters display.
4. Set the trigger.
   a) Expand the Trigger parameters.
   b) In the Trigger Mode list, click Internal (continuous images).
5. Run Auto Exposure.
   a) Expand the Imager parameters.
   b) Expand the Auto Exposure parameters, and click Start to run.
6. Check the lighting on the part.
   • Make sure that the lighting is constant and consistent (unchanging over time, no shadows or hot spots)
   • Capture the shape and form of the target object with lighting that optimizes its contrast and separates the feature of interest from the background. Depending on the target, consider other Banner lights
   • Adjust the mounting angle to provide the clearest image of the part features you are inspecting
7. After checking and adjusting the lighting, run Auto Exposure a second time or adjust the exposure manually by expanding the Exposure parameters and moving the slider or entering a specific exposure time.
8. Adjust the focus.
   a) Place the part so that the area to be focused appears in the center of the Image pane.
   b) Expand the Focus Info parameters.
   c) Make sure that the Focus Info checkbox is selected.
   d) Adjust the focus of the lens while monitoring the focus number.
      The focus number is a number between 1 and 255. Use the Image pane to determine when the image is sharp enough, or use the focus number as a guide. Turn the focus ring on the lens until the focus number is at the highest possible number between 1 and 255. The focus number is also available on the sensor display.
   e) Tighten the locking thumbscrews to secure the lens at the desired focus.

5.3 Set Up an Inspection

Vision Manager allows you to set up or make changes to an inspection while the sensor is running. Changes are automatically saved as they are made.

1. From the 🕵️ Sensor screen, click 🔍 in the upper right corner to view the inspection list.
2. Click Add New Inspection.
   A new inspection is added to the list, the Image pane updates, and the Tools & Results tab shows only the camera tool.
   Note: The camera tool for the new inspection inherits the parameters of the camera tool for the previous inspection, however the two are not linked together.
3. Add tools and adjust them as needed for the inspection.

5.3.1 Add a Tool

1. Click 💾 on the Tools & Results tab.
   The Add Tool window opens.
2. Click the desired tool.
<table>
<thead>
<tr>
<th>Tool Name</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Average Gray</td>
<td>Evaluates pixel brightness within an ROI and computes the average grayscale value. See Average Gray Tool (p. 59).</td>
</tr>
<tr>
<td>Bead</td>
<td>Inspects parts for uniformity of adhesive or sealant material, or for uniformity of a gap. See Bead Tool (p. 63).</td>
</tr>
<tr>
<td>Blemish</td>
<td>Determines whether flaws are present on a part, or detects whether a feature exists on a part. See Blemish Tool (p. 73).</td>
</tr>
<tr>
<td>Blob</td>
<td>Detects and counts/locates groups of connected light or dark pixels within the ROI and designates them as blobs (Binary Large Objects). After blobs are found, they can be characterized by size and shape. See Blob Tool (p. 78).</td>
</tr>
<tr>
<td>Circle Detect</td>
<td>Detects a single circle or piece of a circle (arc). See Circle Detect Tool (p. 89).</td>
</tr>
<tr>
<td>Edge</td>
<td>Detects and counts transitions between bright and dark pixels (edges). Counts the total number of edges, and determines the position of each edge. See Edge Tool (p. 95).</td>
</tr>
<tr>
<td>Line Detect</td>
<td>Locates a single, straight line segment by finding edge points along bright or dark pixel transitions and fitting a line to those points. See Line Detect Tool (p. 105).</td>
</tr>
<tr>
<td>Locate</td>
<td>Finds the first edge on a part and compensates for translation and rotation of downstream tools (if selected). See Locate Tool (p. 110).</td>
</tr>
<tr>
<td>Match</td>
<td>Verifies that a pattern, shape, or part in any orientation matches a reference pattern. Can also compensate for translation and rotation of downstream tools (if selected). See Match Tool (p. 120).</td>
</tr>
<tr>
<td>Object</td>
<td>Detects the edges of dark and bright segments and locates their midpoints. Counts dark and bright segments, and measures the width of each dark and bright segment. See Object Tool (p. 129).</td>
</tr>
<tr>
<td>Math</td>
<td>Performs mathematical operations using tool data or user-supplied constants. Includes basic arithmetic, inequality expressions, and statistical information. See Math Tool (p. 138).</td>
</tr>
<tr>
<td>Measure</td>
<td>Measures distance, calculates angles, and creates points and lines for use as inputs to other tools. See Measure Tool (p. 142).</td>
</tr>
<tr>
<td>Logic</td>
<td>Uses Boolean logic to combine or convert tool results, or to drive discrete outputs from tool results. Logic tool data can be used to evaluate the results of a single tool or multiple tools. See Logic Tool (p. 149).</td>
</tr>
</tbody>
</table>

The tool is added to Tools & Results and the region of interest (ROI) appears on the Image pane.

3. Configure the tool as needed for your application.
   a) Resize and rotate the ROI around the feature to be analyzed.
   b) Define or view parameters for the tool on the Input tab, such as ROI shape, threshold, or view the histogram.
   c) Define pass or fail criteria on the Test tab, such as the count, size, or match.

5.3.2 Rename a Tool

The default tool name is tool01, tool02, and so on, where the word tool is replaced by the appropriate name (for example, Locate01, Edge02, etc.).

1. On Tools & Results or on Tools Only, click the tool to select it.
2. Highlight the tool name.
3. Enter the desired tool name.

Note: Use only letters, numbers, spaces, and the underscore in the tool name.

5.3.3 Name an Inspection

The default inspection name is Inspection01, Inspection02, and so on. Rename the inspection to something meaningful to the application.

1. Click Inspection Management, then click Manage.
2. Double-click the name of the desired inspection.
3. Enter the new inspection name.

   **Note:** Use only letters, numbers, spaces, and the underscore in the inspection name.

4. Press **Enter** or click off of the name to save the new name.

### 5.3.4 Save an Inspection to a Computer, Network Drive, or Storage Device

Vision Manager automatically saves inspections to the VE as they are created and modified. Save a copy of the inspection to your computer or another network location if you want to be able to go back to previous settings.

Use the following procedure to save a copy of an inspection to your computer or a network location.

1. On the **Inspection Management** screen, click **Transfer**.

2. Change the destination folder, if desired.
   a) Click ![folder icon] above the right column. An explorer window opens.
   b) Navigate to the desired location, network location, or storage device.
   c) Click **Select Folder**. The folder is selected and the window closes.

3. Select the desired inspection from the inspection list in the left column.

4. Click ![transfer icon].

   **Inspection name.idb** displays in the right column and the inspection is transferred (saved) to the selected location.

### 5.3.5 Modify a Currently Running Inspection

1. On the **Sensor** screen, select the desired inspection from the **Inspection** list. The inspection tools and parameters display.
2. Make the desired modifications to the inspection.
Important: Changes are automatically saved as they are made. Save a copy of the inspection if you want to be able to go back to previous settings. Use the Emulator to set up or make changes to an inspection offline.

5.3.6 Copy a Tool
Duplicate (copy) a tool to include more than one of the same tool in an inspection.

1. Click the desired tool to duplicate.
2. Click 
   A duplicate of the tool is created with the same input and test parameters.
3. Set the tool parameters as desired. The two tools are not linked; changes are independent of each other.

5.3.7 Delete a Tool
Use the following procedure to delete a tool from an inspection.

1. Click the tool on Tools & Results or Tools Only to select it.
2. Click 
   The tool is deleted.
   Note: There is no undo option. A deleted tool cannot be recovered.

5.3.8 Delete a Tool and All Tools After It
Use the following procedure to delete a selected tool and all of the tools after it.

1. Click the tool on Tools & Results or on Tools Only to select it.
2. Click 
   The message "Remove selected tool and all tools after it?" displays.
3. Click Continue.
   The tools are deleted.
   Note: There is no undo option. Deleted tools cannot be recovered.

5.3.9 Delete an Inspection

1. Click Inspection Management, then click Manage.
2. Select the inspection to be deleted.
   Note: This inspection cannot be running and it cannot be selected to begin at startup.
3. Click
   The inspection name turns red and "Inspection marked for deletion" displays.
4. Click to another tab to delete the inspection, or click **Undo** to keep the inspection.

### 5.4 Configure the Discrete I/O

From the **System Settings** screen, select **Discrete I/O** to change the discrete I/O settings.

![Image of Discrete I/O settings](image)

For more details, see *Discrete I/O* (p. 37).
6 Vision Manager Workspace

Vision Manager has five main working areas, or screens:

- **Home Screen** (p. 22) — The Home screen provides access to connect to a sensor or emulator, update firmware, and view sensor and Vision Manager software information.
- **Sensor Screen** (p. 27) — The Sensor screen displays the information needed to create or modify an inspection.
- **Inspection Logs Screen** (p. 32) — The Inspection Logs screen displays saved images and inspection information. Inspections logs can be viewed when the camera is offline.
- **Inspection Management Screen** (p. 33) — The Inspection Management screen includes options to add inspections to the currently connected sensor, to rename an inspection, and to transfer inspections between a connected sensor and a network location or storage device.
- **System Settings Screen** (p. 36) — The System Settings screen provides access to view and adjust sensor information, discrete I/O, communications settings, system logs, and units.

6.1 [Home Screen]

The Home screen provides access to connect to a sensor or emulator, update firmware, and view sensor and Vision Manager software information.

The following are available from the Home screen:

- Sensor Neighborhood
- Sensor Maintenance
- Emulators
- About

![Figure 16. Home Screen](image)

Only one sensor can be connected to each instance of the software. Open more than one instance of Vision Manager if you want to connect to more than one sensor at a time. Only one instance of the software can be connected to the Emulator at a time.

6.1.1 Sensor Neighborhood

Use Sensor Neighborhood on the Home screen to connect to active sensors. Sensor Neighborhood opens by default when the software is launched.

**Active Sensors Tab**

Use the Active Sensors tab in Sensor Neighborhood to connect to an active sensor. Available options vary depending on the type of sensor to which Vision Manager is connected.

This tab includes sensor information such as sensor status, sensor name, IP address, MAC address, and model number. Sensors can also be added to Favorites.

To connect to a sensor, click ➔ next to the desired sensor. To disconnect from a sensor, click ☐. To view or change sensor Status, MAC Address, Sensor Name, IP Address, Subnet Mask, and Gateway, click ☐. To add the sensor to a Favorites Group, click ⭐. The icon changes to ⭐.

Favorites Tab

Save sensors to the Favorites tab for easy access to them. Sensors are saved to groups.


Click Add New Group to create a new Favorites Group. To add a sensor to the group, on the Active Sensors tab, click ⭐ or from the Favorites tab, enter the sensor IP address and click ➔ to verify the connection to the sensor and automatically save it to the selected group.

To manually add a sensor with a known IP address to the Favorites tab, enter the IP address in the Enter IP Address field and select the desired group.
To remove a sensor from a group, click the icon across from the sensor name. To move the sensor to another group, click the star and select the desired group.

To remove a group and all the sensors within the group, click the icon across from the group name.

**Network Adapters Tab**

Use the Network Adapters tab on Sensor Neighborhood to view the network adapters that the system searches to find sensors.

Navigate: **Home > Sensor Neighborhood > Network Adapters.**

Network adapter information including Link Status (connected/not connected), Adapter name, IP Address, and Subnet Mask is also available.

### 6.1.2 Sensor Maintenance

Use Sensor Maintenance on the Home screen to update the firmware on a sensor and to backup or restore the sensor.

**Sensor Maintenance** includes sensor information such as sensor Status, Sensor Name, IP address, MAC address, Model number, Firmware Version, and which sensors are tagged as favorites.

Actions include update firmware, view or change some sensor settings, and backup or restore sensor data.

**Update the Firmware**

1. From the Home screen, click Sensor Maintenance.
2. Make sure that the desired sensor is not connected to the Vision Manager software and that the status is Available.
3. Click the star next to the sensor and follow the prompts.

**Note:** During the firmware update process, there are options to restore the sensor to the factory default settings and to create a backup before updating the firmware.
**Important:** All stored inspections are deleted when factory default settings are restored. All user profile information (user names and passwords) is deleted when factory default settings are restored. Ethernet settings and favorites lists are retained.

This process can take several minutes. Do not close the program or remove power from the sensor during the update process.

When the process is complete, the sensor restarts and the status returns to Available. Vision Manager displays the new firmware version in the Firmware Version column.

**Backup or Restore the Sensor**

System settings, inspections, and user profiles can be backed up and restored. Firmware is not included in the backup or restore.

The backup file is saved to the location of your choice.

1. From the **Home** screen, click **Sensor Maintenance**.
2. Make sure that no sensors or emulators are connected to the Vision Manager software and that the desired sensor’s status is Available.
3. Click **Backup**.
4. Follow the prompts to save a backup file.
   A message displays saying that the backup was successful.
5. To restore the sensor data, click **Restore**.
6. Follow the prompts to restore the sensor data. An Emulator backup file can be used to restore the sensor.

   **Note:** This process can take several minutes.

**Important:** Selecting the **Restore User Profiles** checkbox overrides all of the user names and passwords on the sensor that the restore file is being restored to.

A message displays saying that the restore was successful.

### 6.1.3 Emulators

Use **Emulators** on the **Home** screen to connect to the emulator.

![Emulators](image)

Click ➔ to connect to the desired emulator. This tab also displays the Image location on the computer, as well as the emulator version information.

Click ☑️ under Folder Location to change the directory for the reference images. The default directory for images is **C:\Users\Public\Documents\Banner Vision Manager\VE Series\VE xMP\Images**. Both 8-bit monochrome bitmap (BMP) images and inspection logs are supported. Bitmap images should be the same resolution as the VE camera.
If inspection logs are placed in the Images directory, the emulator automatically extracts the image out of the inspection log and uses it to run the currently loaded inspection. Click 🗂️ to open the directory.

The Emulators tab includes all available features and all tools function the same as they do when running on a sensor. On the emulator, execution time is not calculated.

Backup or Restore the Emulator

Emulator settings and inspections can be backed up and restored.

Save the backup file to the location of your choice.

1. From the 🏡 Home screen, click Emulators.
2. Make sure that no sensors or emulators are connected to the Vision Manager software.
3. Click 🌞, then click Backup.
4. Follow the prompts to save a backup file.
   A message displays saying that the backup was successful.
5. To restore the sensor data, click 🌞, then click Restore.
6. Follow the prompts to restore the sensor data. A sensor backup file can be used to restore the emulator.

   **Note:** This process can take several minutes.

   A message displays saying that the restore was successful.

6.1.4 About

Use About to view Vision Manager software information, including the version number.
6.2 Sensor Screen

The **Sensor** screen displays the information needed to create or modify an inspection.

2. Manual Trigger button—Click to manually trigger the sensor
3. Inspection list—Select the desired inspection to start, and to view or modify the inspection
4. Summary pane—Includes the Inspection Summary, the I/O Summary, and the Test Summary
5. Parameters pane—Includes user-adjustable Inputs parameters or Test parameters for the tools in an inspection, depending on what is selected in the Tools and Results pane
6. Tools and Results pane—Includes Tools and Results, Tools Only, and All Results, which display the camera tool, the tools that are included in the current inspection, and the results of the inspection
7. Image Pane Parameters panel—Includes ROI view buttons, zoom, x and y coordinates, grayscale value, settings button, and full image display button, as well as sensor messages
8. Image pane—Displays the current image captured by the sensor; this includes the region of interest (ROI) for the tool for the selected inspection

*Figure 22. Sensor Screen*

6.2.1 Image Pane Parameters

Use the **Image Pane Parameters** to change how the Image pane displays and to view status messages.

*Figure 23. Image Pane Parameters*
**ROI View Buttons**

Click  to view all tool ROIs and annotations.

Click  to view the ROI and annotations for the selected tool only.

Click  to hide all ROIs annotations and view the image only.

*Note: The Image Overlays parameter for each tool also control which ROI is shown and this parameter overrides the ROI view buttons.*

**Zoom**

Slide to zoom the Image pane in and out.

**Status Messages**

View status messages such as "Applying Changes" and "Waiting for Trigger". Some messages, such as "Applying Changes," display only momentarily while a parameter change is serviced by the sensor. Other messages, such as "Waiting for Trigger", require an action to be completed.

**X and Y Coordinates and Grayscale Value**

Displays the current x and y coordinates and grayscale value for the location the pointer is at in the Image pane.

**Settings Button**

Click  to change some ROI settings.

- Change the size of the ROI labels
- Change the opacity of the background of the ROI labels
- Show or hide controls (change ROI shape, add a mask) in the labels, where applicable
- Change the size of the sizing handles

**Full Image Display Mode Button**

Click  to expand the image to fill the screen. The image pane, image pane parameters, as well as passed, failed, and missed counts are shown. Click  to return to the standard view.

When in Full Image Display Mode, click  to view the Test Summary Results and click  to hide the Test Summary Results.

### 6.2.2 Summary Pane

The Summary pane includes the **Inspection Summary**, the I/O Summary, and the Test Summary.

**Inspection Summary**

When expanded, the **Inspection Summary** displays inspection pass, fail, and missed trigger statistics since the last time the inspection summary results were reset.

A green checkmark indicates that an inspection passed, and a red X indicates that an inspection failed. A dash indicates that there is no information to display.

![Inspection Summary](image)

*Figure 24. Inspection Summary*

The History Trend below the pass/fail statistics provides another visual indication of whether or not an inspection passed, as well as an indication of when changes are made.
• Green indicates that an inspection passed
• Red indicates that an inspection failed
• Blue indicates that a change was made to the inspection
• Pink indicates that a product change was made—either a new inspection was added or the inspection was changed to a different one

The History Trend holds up to 400 entries and updates after an inspection is completed. The entries are recorded first in, first out, with the newest entry displayed on the left of the History Trend. Point to an entry on the History Trend for information about the entry. For example, pointing to a green entry displays the frame number.

Click Reset to clear the Inspection Summary statistics. The History Trend does not reset.

When collapsed, the Inspection Summary displays only pass and fail information. The green number on the left represents the number of inspections that passed. The red number on the right represents the number of inspections that failed since the last reset.

I/O Summary

When expanded, the I/O Summary displays input and output status information and system errors, if present.

When collapsed, no I/O Summary information is visible.

![Figure 25. I/O Summary](image)

Inputs and outputs display on the I/O Summary after they are configured from the System Settings screen (see Configure the Discrete I/O (p. 21)). Green indicates that the I/O is active. Light gray indicates that the I/O is inactive.

The System Error indicator flashes red when an error is present. View and clear the error from the System Settings screen (see Logs (p. 44)).

![Figure 26. I/O Summary with Error](image)

Test Summary

When expanded, the Test Summary shows results from the enabled Test parameters for each tool in the current inspection. Failures are highlighted in red.

When collapsed, no Test Summary information is visible.
6.2.3 Tools & Results

Tools & Results shows the camera tool and the inspection tools that are included in the current inspection, as well as the results for the currently selected tool.

Use Tool & Results to add and configure tools in an inspection and to view results. Click a camera tool or inspection tool on Tools & Results to access the Parameters pane for that camera or tool. Click in the empty area below the tools to view information about the inspection, such as Inspection Name and Execution Time. If Data export is enabled, the available data also displays.

See Using the Camera Tool (p. 55), Using the Inspection Tools: Vision Tools (p. 59), and Using the Inspection Tools: Analysis Tools (p. 138) for additional tools information. See also Data Export Tab (p. 42).

6.2.4 Tools Only

Tools Only shows the camera tool and the inspection tools that are included in the current inspection.

Use Tools Only to add and configure tools in an inspection. Click a camera tool or inspection tool on Tools Only to access the Parameters pane for that camera or tool.
See *Using the Camera Tool* (p. 55), *Using the Inspection Tools: Vision Tools* (p. 59), and *Using the Inspection Tools: Analysis Tools* (p. 138) for additional tools information.

### 6.2.5 All Results

**All Results** lists the results for the current inspection, camera tool, and inspection tools.

![Figure 31: All Results](image)

At a glance, view the Result (pass/fail/status), execution Time (in milliseconds), Pass Count, and Fail Count for each item. Expand each item for additional details.
6.3 Inspection Logs Screen

The Inspection Logs screen displays saved images and inspection information. Inspections logs can be viewed when the camera is offline.

1. Log Sources pane—Choose the source for the inspections logs to view, and set the criteria for collecting logs
2. Loaded Logs pane—View and filter the inspection logs
3. Image pane—Displays the saved inspection image captured by the sensor. This includes the tools that were used in that inspection
4. Summary pane—Displays saved information from a specific inspection and frame number
5. Parameters pane—Displays the logged Input or Test parameters, depending on what is selected in the Tools & Results pane
6. Tools and Results pane—Includes the Tools & Results tab, the Tools Only tab, and the All Results tab, which display the camera tool, the tools that are included in the logged frame, and the results of the inspection
7. Image Pane Parameters panel—Includes ROI view buttons, zoom, x and y coordinates, grayscale value, and the ROI label settings button, as well as sensor messages

Figure 32. Inspection Logs Screen

6.3.1 Log Sources

View logs from either the sensor or a network folder or storage device.

Click to move the inspection logs from the sensor to the computer. Click to navigate to saved inspection logs. Thumbnail views of the images display in the Loaded Logs pane. While inspection logs are loading, the Percent Bar displays and shows the percentage of inspection logs that have loaded; it is removed when all inspection logs have finished loading.

Expand Sensor to set the criteria for what is collected in the inspection logs. Set the Log Criteria:

- All
• Pass Only
• Fail Only
• By Slot Number
• Remote Teach All
• Remote Teach Pass
• Remote Teach Fail

Set the **Strategy**:  
• First N Logs
• Last N Logs

Set the **Capture Limit** (limits the number of inspection logs the sensor holds in internal memory):  
• Low Count
• Medium Count
• High Count

Filter logs to be viewed by pass ✓, fail ✗, remote teach RT, or inspection number using the buttons to the left of the inspection previews. Click ✗ to clear all filters.

### 6.3.2 Loaded Logs

After log information is loaded from the Log Sources pane, click on a thumbnail to view the full frame in the Image pane.

The Inspection Summary shows whether or not the inspection passed, which inspection was being used, which frame number you are viewing, and the system and inspection CRCs. Click the camera tool or an inspection tool in the Tools and Results pane to view additional logged information in the Parameters pane, such as camera exposure, the reference pattern, or the filters used during the inspection, as well as to view specific results for the frame.

**Note:** Some parameters are disabled in the Inspection Logs. For example, if histogram information was not collected during the inspection, it cannot be viewed from the log.

### 6.4 Inspection Management Screen

The Inspection Management screen includes options to add inspections to the currently connected sensor, to rename an inspection, and to transfer inspections between a connected sensor and a network location or storage device.

The following are available from the Inspection Management screen:  
• Manage
• Transfer

The inspection CRC is listed for each inspection on both the Manage and Transfer screens. When an inspection is created, it is assigned a Cyclic Redundancy Check code, or CRC. The CRC is generated by considering each setting within the inspection (this includes the input parameters of all tools). When a change is made to the input parameters of any tool within the inspection, a new CRC is generated. Because of this, CRC becomes a very simple yet powerful way to determine if a change was made to the inspection since the last time it was modified.

**Note:** Changing an inspection’s name and slot number does not modify its CRC.

The system CRC is available on the System Settings tab.
6.4.1 Manage

Use **Manage** to add new inspections, delete existing inspections, rename inspections, set an inspection to run at startup, or copy an inspection.

![Figure 33. Manage](image)

Also displayed are the sensor name, inspection name, and whether the inspection is running.

**Copy an Inspection**

Duplicate (copy) an inspection to use as a starting point for a new inspection.

1. On the **Inspection Management** screen, click **Manage**.
2. Locate the inspection to copy and click **Duplicate**. A duplicate of the inspection is created with the same tools and parameters and is added to the inspection list as **Inspection (#)**.
3. Adjust the inspection as desired. The two inspections are not linked; changes are independent of each other.

**Delete an Inspection**

1. Click **Inspection Management**, then click **Manage**.
2. Select the inspection to be deleted.
   
   **Note:** This inspection cannot be running and it cannot be selected to begin at startup.
3. Click **Delete**. The inspection name turns red and "Inspection marked for deletion" displays.

![Figure 34. Inspection Marked for Deletion](image)

4. Click to another tab to delete the inspection, or click **Undo** to keep the inspection.
Set an Inspection to Begin at Startup

1. On the **Inspection Management** screen, click **Manage**.
2. Locate the desired inspection and click **on**.
   The **on** turns green and the inspection will begin at the next startup.

6.4.2 Transfer

Use **Transfer** to transfer inspections between a connected sensor and a computer, network drive, or storage device.

Save an Inspection to a Computer, Network Drive, or Storage Device

Vision Manager automatically saves inspections to the VE as they are created and modified. Save a copy of the inspection to your computer or another network location if you want to be able to go back to previous settings. Use the following procedure to save a copy of an inspection to your computer or a network location.

1. On the **Inspection Management** screen, click **Transfer**.
2. Change the destination folder, if desired.
   a) Click **on** above the right column. An explorer window opens.
   b) Navigate to the desired location, network location, or storage device.
   c) Click **Select Folder**.
      The folder is selected and the window closes.
      The path to the location displays above the right column.
3. Select the desired inspection from the inspection list in the left column.
4. Click **on**.
   *Inspection name.idb* displays in the right column and the inspection is transferred (saved) to the selected location.
Save Inspections to a VE Sensor

Inspections stored on a computer or network drive or created in the emulator can be saved to the connected VE sensor.

1. On the Inspection Management screen, click Transfer.
2. Select the desired location.
   a) Click above the right column.
   b) Navigate to the desired folder.
      The path to the location displays above the right column.
3. In the list on the left, select (Next Empty Slot) to add the inspection to the list or select an existing inspection to replace.
4. Select the desired inspection from the list on the right.
5. Click .
   Inspection name displays in the left column and the inspection is transferred to the sensor.

6.5 System Settings Screen

The System Settings screen provides access to view and adjust sensor information, discrete I/O, communications settings, system logs, and units.

The following are available from the System Settings screen:
- Sensor Info
- Discrete I/O
- Communications
- Logs
- Units
- User Profiles
- System Reset

6.5.1 Sensor Info

Use Sensor Info to view or change sensor information, including sensor name, IP address, subnet mask, and gateway.

Click to access the sensor properties editing window. Click to refresh the information.
- Sensor Name—View or change the sensor name
- Model—View the model number of the sensor
- Serial Number—View the serial number of the sensor
- Firmware Version—View the current firmware version of the sensor
- Up Time—View the amount of time the sensor has been running since it was last powered on
- Hour Count—View the number of hours the sensor has been powered on over its lifetime
- Boot Count—View the number of times the sensor has been powered on over its lifetime
- System CRC—View the current system CRC number
The system Cyclic Redundancy Check code, or CRC is listed on the System Settings > System Info tab. The CRC is generated by considering each setting within the system. When a change is made to the system parameters (including a change to the inspection CRC) a new CRC is generated. Because of this, CRC becomes a very simple yet powerful way to determine if a change was made to the system since the last time it was modified.

**Note:** Changing the following sensor features and information does not modify the system CRC:
- Sensor IP address
- Sensor subnet mask
- Sensor gateway
- Sensor name
- Sensor Serial Number
- Sensor Mac Address
- User Profile changes
- Updated pattern in match tool if remote teach feature was used to change it.

The inspection logs show which CRC an image was acquired under. The system CRC is available to a PLC and can be sent using Data Export on all protocols.

The inspection CRC is available on the Inspection Management tab.

### 6.5.2 Discrete I/O

Use **Discrete I/O** to view the I/O and pin numbers; view the status; and set the function, active level, output delay, latch type, and output duration for each pin.

From the System Settings screen, select **Discrete I/O** to change the discrete I/O settings.

**Figure 38. Discrete I/O**

#### I/O
The VE has five configurable I/O. These are pins 1, 5, 8, 10, and 11.

#### Pin 
The pin number on the cable connection. See Table 1 (p. 13).

#### Wire Color
The corresponding wire color for each pin. See Table 1 (p. 13).

#### Status
Indicates whether or not the I/O is active.
- **Green** = active
- **Gray** = inactive
Function

The following input and output options are available:

- **Disabled**—The pin is not configured
- **General Output**—Used in conjunction with the Logic Tool to configure individual discrete outputs based on specific tool results
- **Pass**—Active when the inspection passes
- **Fail**—Active when the inspection fails
- **Ready**—Active when the sensor is ready to accept another trigger
- **System Error**—Active when a system error occurs
- **Online**—Active when the Camera is connected
- **Missed Trigger**—Active when a trigger is missed
- **Product Change**—The input is used in conjunction with one of the four I/O points programmed as Product Select lines. The inspection loaded will be executed following a valid trigger. See Function: Product Change (p. 38) for additional details on Product Change
- **Product Select Bit 0/1/2/3**—Available when Product Change is selected on another I/O; used in conjunction with Product Change to select inspection locations at which to begin execution. See Function: Product Change (p. 38)
- **Remote Teach**—Sets the pin to accept input pulses for remote teaching the sensor

Invert

Select to switch when the I/O is active or inactive.

Output Delay (ms)

The time from when a trigger starts an inspection until the sensor output turns on. It is available for the General Output, Pass, Fail, and Missed Trigger functions of the selected pin.

**Note:** If the inspection execution time is longer than the output delay, the output becomes active immediately after the processing is finished.

Latch Type

Select the behavior of the I/O pin when in the active state; available when the I/O is configured as an output.

- **Latched**—Maintains state until the condition of the associated function changes; available for the following functions: General Output, Pass, Fail, Ready, System Error, Online, and Missed Trigger
- **Pulsed**—Maintains active state for a selected period of time, then returns to the inactive state; available for the following functions: General Output, Pass, Fail, System Error, and Missed Trigger
- **Trigger Gated**—Output signal is only active upon trigger signal being active
- **Latched Until Trigger**—Maintains state until a new trigger is received; available for the following functions: General Output, Pass, Fail, and Missed Trigger

Output Duration (ms)

The length of time the output is active.

This option is available for the Latch Type = Pulsed.

Minimum Hold READY Time

When checked, this option holds the READY signal inactive for at least this minimum duration after receiving a valid trigger.

Function: Product Change

The sensor can be commanded to load inspections from slots 1 to 15 using the combination of Product Change and Product Select functions of the discrete I/O pins.

Set the state of the Product Select pins as described in Product Select Inputs (p. 38). Then set the state of the Product Change pin to Active when the sensor is in the Ready state. The sensor immediately loads the selected inspection and is ready to execute when it receives a trigger. For Product Change to be successful, select at least one of the I/O pins to function as Product Select.

Product Select Inputs

The VE has four dedicated Product Select lines that can be thought of as making a Binary Code Decimal (BCD) table. Access inspections 0 through 15 using the following pin combinations:
### 6.5.3 Communications

Use **Communications** to view or change communication information, to set the industrial protocol, and to set image export, data export, and serial connection settings.

#### Ethernet Settings Tab

Use the **Ethernet Settings** tab to view or change some Ethernet settings.

**Navigate:** System Settings > Communications > Ethernet Settings.

![Figure 39. Ethernet Settings Tab](image)

On the **Ethernet Settings** tab, click ![icon] to access the sensor properties editing window and view or change the following:

- **IP Address**—View or change the IP address of the sensor
- **Subnet Mask**—View or change the subnet address of the sensor
- **Gateway**—View or change the gateway address of the sensor
- **MAC Address**—View the MAC address of the sensor

To change the **Max Speed**, the maximum negotiation speed with the network, select the desired speed from the list:

- 1000 Full Duplex
- 100 Full Duplex (default)
- 100 Half Duplex
Serial Tab

Use the Serial tab to configure the serial connection.

Navigate: System Settings > Communications > Serial.

![Figure 40. Serial Tab]

The serial connection is used with the Data Export function. It uses pins 4 and 12. Pin 4 is RS-232 TX (transmit) and pin 12 is RS232 RX (receive). On the Serial tab, set the following parameters to match the receiving device:

**Baud Rate**
- 115200 (default)
- 57600
- 38400
- 28800
- 19200
- 9600

**Data Bits**
- 8 bits (default)
- 7 bits

**Parity Control**
- None (default)
- Even
- Odd

**Stop Bits**
- 1 Bits (default)
- 2 Bits

*Note:* Because there is no flow control for the serial connections, the sensor will not detect or log a lost or broken connection.

Industrial Protocols Tab

Use the Industrial Protocols tab to set the protocol the sensor uses to communicate and to select output data (map) to send to a PLC.

Navigate: System Settings > Communications > Industrial Protocols.

![Figure 41. Industrial Protocols Tab]

On the Industrial Protocols tab, select the desired protocol to enable it.
- Disabled (default)
- EtherNet/IP
- PROFINET
- Modbus/TCP
- PCCC

A 32 Bit Format setting displays if Ethernet/IP, Modbus/TCP, or PCCC is chosen. Select LSW-MSW or MSW-LSW from the list.

A customizable map to output camera or inspection tool-specific results also displays. The map includes the following:
- Register/Byte/Word (depending on the protocol selected)
- Inspection #
- Tool Type
- Tool Name
- Result
- Type
- Actions

**Note:**
- Inspection # changes automatically depending on which inspection includes the tool.
- Type changes automatically depending on how much space is available.
- Data in registers 1–16 are fixed and contained in the PLC input assemblies (EtherNet/IP, Modbus/TCP, and PCCC).

Click **Apply Changes** to send the current map to the camera.

Click **Print** to print and save a PDF of the current map. The PDF includes all data, whether system-defined or user-defined.

Click **Reset** above the map to return the map to the default settings. All user-defined output data is deleted. Click **Delete** in the Actions column to delete an individual result.

For additional information see:
- **Set the Industrial Ethernet Protocol (EtherNet/IP, PROFINET, Modbus/TCP, PCCC)** (p. 167)
- **Tool-Specific Results: EtherNet/IP** (p. 175)
Data Export Tab

Use the **Data Export** tab to set the parameters used to export inspection results.

**Navigate:** ⚒️ System Settings > Communications > Data Export.

![Figure 43. Data Export Tab](image)

On the **Data Export** tab, set the data export parameters, including which results to export, which channel to use, and the port number to use. Note that the port number cannot be the same as any other port in use.

Use the data export map to select the results to publish. Use ▲ to add additional entries at the end of the list. Click ▲ or ▼ to add additional entries above or below the currently selected entry. Use ▲ and ▼ to move an entry to either up or down in the map.

Click ▲ above the map to return the map to the default settings. All user-defined output data is deleted. Click ❌ in the **Actions** column to delete an individual entry.

Shown below the map is the data that is currently available to be exported.

The Frame Format settings are located to the right of the map and include the desired delimiter, start string, and end string.

The Missing Data Format settings are also located to the right of the map. These settings include the option to publish filler characters in place of data that is missing in the current inspection. If **Fill String** is selected, enter the desired filler characters in the **Fill String** field.

For additional information, see *Data Export* (p. 159).

Image Export Tab

Use the **Image Export** tab to set the parameters used to export images.

**Navigate:** ⚒️ System Settings > Communications > Image Export.

Image Export is disabled by default. On the **Image Export** tab, set which images to export, then select the method.

- **Export**
  - Set which images to export:
    - **Disabled** (default)
    - All
    - Pass only
    - Fail only
Choose which protocol to use to export images:
- TCP/IP
- FTP

See Image Export: TCP/IP (p. 161) and Image Export: FTP (p. 163) for more information.

Input String Tab

Use the Input String tab to set the parameters used to send information to the sensor from an external Ethernet source. If desired, export the data using Data Export.

Navigate: System Settings > Communications > Input String.

Input String is disabled by default. On the Input String tab, configure the Port Number, String Header, and String Footer to enable the sensor to receive an input string. For example, a VIN number supplied by a PLC to the sensor. This aids in traceability. The string value is set only through the Ethernet source, not in Vision Manager. The maximum size, including the header, content, and footer, is 50 bytes.

For additional information, see Input String (p. 165).
6.5.4 Logs

The Logs default view is the System tab. Use the System Tab to view, export, or clear system logs and communication logs. Select or clear the Display checkboxes to customize which events are shown.

Navigate: System Settings > Logs > System.

To clear a system error flag (or state), click Clear System Error.

**Note:** The system error log entry will not be cleared from the log.

To export system logs, click Export Log and follow the prompts. Logs are exported as a .slog file.

To clear the log, click Clear Log.

View a system log exported from another sensor using the View Exported Logs tab.

Navigate: System Settings > Logs > View Exported Log. Click Load Log and navigate to the desired log file to view it.
6.5.5 Units

Use Units to select a unit to display, to adjust the precision, or to perform a perspective correction.

The VE Series Smart Camera computes tool distance and area values in units of pixels. The Scaling mode allows users to convert pixels to user defined measurements units (for example, millimeters).

When the camera is not perpendicular to the part being inspected there is a natural perspective distortion, causing tool distance and area values to vary across the image. The Perspective Correction mode addresses this situation. Perspective Correction can also be used to adjust the camera's native coordinate system, for example matching the coordinate system of a robot interfacing with the camera.

Use Precision to set the number of decimal places used in Distance and Area tool results.

Units and Calibration

Use Units and Calibration to select a unit to display, to adjust the precision, or to correct for perspective distortion.

Select either Scaling or Perspective Correction from the Mode list.
Scaling

Use the Scaling mode to select a unit to display and to publish results that represent distance, size, and location calculations.

Navigate: System Settings > Units > Units and Calibration, then select Scaling from the Mode list.

By default, distance, size, and location calculations are shown in pixels. To change the displayed units, select the desired measurement unit and parameters. The following Measurement Units are available:

- Microns (µm)
- Millimeters (mm)
- Centimeters (cm)
- Meters (m)
- Mils (mil)
- Inches (in)
- Feet (ft)
- Yard (yd)

Click Apply Changes to save the changes. Applying a scaling factor changes the measurements listed in the Tools and Results to the selected unit and applies the scale to all inspections.

Scale Units Using a Known Measurement

Use a known measurement, such as ruler, to configure the scaling factor for converting pixels to the desired unit.

The conversion factor for using scaled units can be determined using any object of a known size. For illustration purposes, this example uses a ruler as the object.

Note: This procedure is an example only.

- Make sure the camera focus is as sharp as possible
- Span more pixels for increased accuracy
- Use objects closer to the center of the FOV to limit the distortion that naturally occurs closer to the edges of the FOV

1. Place the ruler in the FOV.
2. Add a Measure tool.
3. Point to the 0 line on the ruler and write down the x and y coordinates shown in the Image Parameters pane.
4. Expand Measure from... and select Constant.
5. In the Point (X, Y) field, enter the x and y coordinates from step 3.
6. Point to the 10 mm (1 cm) line on the ruler and write down the x coordinate shown in the Image Parameters pane.
7. Expand Measure to... and select Constant.
8. In the Point (X, Y) field, enter the x you wrote down in step 6 and y coordinate from step 3. (The y coordinates must be the same.)
   The Measure tool measures between the two points.
9. Write down the Distance (px) show in Tools & Results.
   In this example, the distance is 101.00 px.
10. On the System Settings screen, click Units.
11. From the Mode list, select Scaling.
   The scaling parameters display.
12. Select the desired Measurement Unit. For this example, the unit is Millimeters.
13. In the Measurement in Pixels field, enter the distance from step 9.
14. In the Measurement in Millimeters field, enter 10 because the known distance was 10 mm.

15. Click Apply Changes.
   Applying a scaling factor affects all existing inspections. The currently running inspection is immediately modified on
   the next trigger and other inspections are modified when they are loaded.

Perspective Correction

Use the Perspective Correction mode to enter real world coordinates, select a unit to display, and publish results which
represent locations and angles (except Blob Major Axis Angle).

Navigate: **System Settings > Units > Units and Calibration**, then select Perspective correction from the Mode list. While
configuring the perspective correction, inspections are suspended.
The **Inspection** list changes to a **Calibration** list. Up to five perspective corrections (calibrations) can be stored. Select the appropriate **Calibration #** from the **Inputs** parameters on the **Camera** tool found on the **Sensors** tab. By default, the first calibration created is applied to all inspections (this does not apply to the Emulator).

When **Perspective Correction** is used, **All Results** includes information about the **Units**.
Using Perspective Correction

Follow these steps for an example use of Perspective Correction mode.

Cancel the process at any time by clicking Abort.

**Note:** This procedure is an example only.

1. Go to System Settings > Units > Units and Calibration, then select Perspective Correction from the Mode list. **Important:** Inspections are suspended during this time.

2. If needed, set the Exposure, Gain, or Auto Exposure on the Inputs parameters pane. These settings are saved with the Calibration.

3. Select the desired measurement unit from the Real World Unit list. This example uses millimeters.

4. If desired, click to add additional calibration points. This example uses a fifth point. Up to 20 points can be added.

5. Move the P1, P2, P3, P4, and P5 calibration points to the desired location on the image. The points should be spread out and accurately placed in the desired region of measurement. When a calibration point is selected, the corresponding row in the Real World Coordinates table is highlighted.
6. In the Real World Coordinates table, enter the corresponding actual coordinates for each calibration point.

![Real World Coordinates](image)

Figure 59. Real World Coordinates

7. Click **Apply Changes**.

The Calibration Summary pane updates to show the status, scaling factor, and other information, including the Computed Fit Error.

![Calibration Summary](image)

Figure 60. Calibration Summary

The Computed Fit Error is the distance between a user-defined point in the real world coordinate space and the computed point, based on the fit of all points in the real world coordinate space. Vision Manager displays the minimum and maximum computed fit errors for all user-defined points when five or more points are used. If only four points are used, there is no Computed Fit Error.

The Inputs parameters pane for the Camera tool (on the Sensor tab) now includes a Calibration dropdown.

![Camera Calibration Parameter](image)

Figure 61. Perspective Correction Calibration Parameter

8. If needed, select and add additional Perspective Correction Calibrations from the Calibration list at the top right of the screen.

9. Select the desired Perspective Correction calibration for your inspection from the Calibration parameter list on the Inputs parameters pane for the Camera tool.

Only one Perspective Correction Calibration can be associated with each inspection.
Precision

Use **Precision** to set the number of decimal places shown and exported.

Navigate: **System Settings > Units > Precision.**

![Image of Precision settings](image)

**Figure 62. Precision**

Select the desired number of decimal places, from 1 to 6, that display throughout the software and in exported data. In general, the number of decimal places chosen is the number used, however, there are a few exceptions. See the following descriptions:

**Floating Point Representation**

All input values represented as decimals are single 32-bit floating point values. The precision varies based on the range; the bigger the floating number, the less precision it may have. As a result, the values entered manually may be automatically adjusted to the closest floating point value.

For example, if the precision is set at 6 decimal digits and the number 123.456789 is entered, this is not a valid floating point number. However the closest floating point number is 123.456787109375, so the value is approximated to 123.456787.

**Camera Exposure**

Camera exposure time is restricted by the minimum change the imager can perform. As a result, the values entered manually may be automatically adjusted to the next value accepted by the imager.

Imager exposure precision:
- WVGA: 14 µs
- 1.3 MP: 14 µs
- 2 MP: 15 µs
- 5 MP: 10 µs

**External Strobe**

The external strobe duration and the external strobe exposure delay are restricted to 1 µs resolution. As a result, the values entered by the user may be automatically adjusted to the next µs value.

6.5.6 User Profiles

Use **User Profiles** to prevent users from accessing specific features or making changes to the system. When User Profiles is enabled users are required to enter a user name and password to access the sensor. Users cannot access the system without a valid login.

User Profiles are specific to each sensor. Enable User Profiles on each sensor that requires extra security.

Note that when User Profiles are enabled, the sensor display is available as read-only. No editing can be done directly from the sensor until User Profiles are disabled for that sensor.

**Users**

Use the **Users** tab to manage the use of user names and passwords and to view or change the type of user, user name, and password for each user. Passwords are not required.

Navigate: **System Settings > User Profiles > Users.**
User Profiles are disabled by default. To enable User Profiles, select **Enabled** from the **User Profiles** list. This enables User Profiles for the sensor you are currently connect to. The next time you connect to the sensor, you must enter a user name and password to access the sensor, inspections, and other information.

**Add a User**

Use this procedure to add a new user to the system. Only an Administrator can add new users.

1. Click **+**.
   A new user is added and the **Username** field is active.
2. Enter the user name in the **Username** field.

   **Note:** Use only letters, numbers, spaces, and the underscore in your user name.

3. Click **Set Password** to add a password, if desired.
   The **Change Password** screen displays.
4. Enter and confirm the desired password.
5. Click **Continue**.
6. Select the type of user from the **Profile** list.
   The type of user determines the level of access the user has. The level of access can be changed from the **Profiles** tab. See **Profiles** (p. 54).
7. Click **Apply Changes**.

**Change a Password**

Use this procedure to change a password. Users can change their own password. An Administrator can change any password.

**Note:** If you are a non-Administrator user and you lose your password, an Administrator can change your password to a new one. If you are an Administrator and you lose your password, contact Banner Engineering.

1. Click **System Settings > User Profiles**.
   An Administrator sees all available user names. Any other user sees only their own name.
2. Click inside the Password field next to the desired user.
   The **Change Password** window displays.
3. Enter and confirm the new password, then click **Continue**.
4. Click **Apply Changes**.
Change a User Name

Use this procedure to change a user name. Only an Administrator can change a user name.

1. Click **System Settings > User Profiles**.
2. Click inside the **Username** field for the desired user.
   The field becomes active.
3. Enter the desired user name.
4. Click **Apply Changes**.

Profiles

Use the **Profiles** tab to determine the level of access given to each type of user (user profile).

Navigate: **System Settings > User Profiles > Profiles**.

![Profiles Tab](image)

The **Profiles** tab shows the functions that are enabled or disabled for each user profile. Only an Administrator can change the functions or the profile names. Select and clear the check boxes to enable or disable the desired functions for each user profile. The selected functions apply to every user of that user profile. Click **** to return this screen to the default functions for each user profile.

When an unauthorized user attempts to access a restricted feature, a warning displays that the user is not authorized. In many cases, a **lock** displays next to items in the software to indicate that the item is not available for the current user.

An Administrator user has all available functions, and this column is not editable. Using the default selections, a Monitor user has the fewest available functions.

### 6.5.7 System Reset

Use **System Reset** to reboot the sensor or to restore the sensor to the factory default settings.

Click **Reboot Sensor** to stop, shutdown, and restart the sensor. The start-up inspection is loaded after the sensor reboot.

Click **Reset to Factory Defaults** to restore the sensor to the factory default settings.

**Important:** All stored inspections are deleted when factory default settings are restored. All user profile information (user names and passwords) is deleted when factory default settings are restored. Ethernet settings and favorites lists are retained.
7 Using the Camera Tool

The camera tool controls the sensor’s camera function during an inspection. Configure the camera tool using the parameters in the **Parameters** pane:

- Imager
- Focus Info
- Trigger
- External Strobe
- Image Histogram

![Camera Tool Input Parameters](image)

When the camera tool is selected, it is highlighted orange in **Tools & Results** and in **Tools Only**, the **Inputs** tab displays on the **Parameters** pane, and the camera tool results are highlighted in **All Results**.

7.1 Imager

Use the **imager** parameters to adjust the exposure and gain.

![Imager](image)

**Exposure**

Exposure time is the amount of time the camera allows light to energize the imager chip. Increasing the exposure time allows more light to energize the imager chip, which brightens the picture. Use the slider or enter the desired exposure time in milliseconds.
Gain

Gain is an electronic boost to the image signal. Increasing gain increases image brightness without increasing exposure time. Use the slider or enter the desired gain number.

Note: Gain brightens both the light pixels and the dark pixels. High gain values will make the image appear grainy.

Auto Exposure

During Auto Exposure, the exposure time and gain are optimized for the current inspection. Click Start to begin Auto Exposure.

Note: Several triggers may be required to calculate the optimized values for exposure and gain.

7.2 Trigger

Use the Trigger parameters to set the method and rate at which the sensor captures images. Trigger parameters are stored in the inspection file and can be different for each inspection.

Figure 67. Trigger

Internal (default)

The sensor triggers itself at a user-defined rate. Use the slider or enter the desired rate, from 10 ms to 10,000 ms. The default rate is 100 ms.

External

The sensor is triggered either manually using the trigger button in the Vision Manager software or it is triggered by an external source (via the trigger pin), such as a photoelectric sensor. The external trigger option has the following parameters:

- **Trigger Polarity**—Sets when the image is captured compared to the trigger signal. Choose Leading Edge to capture images at the leading edge of a trigger signal. Choose Trailing Edge to capture images at the trailing edge of the trigger signal. The default is Leading Edge.
- **Trigger Delay**—Sets the fixed time from the instant the sensor receives a valid trigger to the instant the sensor captures the image. Use the slider or enter the desired time in milliseconds, from 0 ms to 10,000 ms. The default is 0 ms.
- **Minimum Trigger Width**—Eliminates unwanted triggers by accepting triggers only if they last for a specified duration. Use the slider or enter the desired minimum trigger width in milliseconds, from 1 ms to 5,000 ms. The default is 1 ms.
- **Trigger Divide**—Sets the logic for how valid trigger inputs are related to actual images taken. If the Trigger Divide is set to 1, an image is captured in response to every valid trigger. If it is set to 2, an image is captured in response to every second valid trigger, and so on. Use the slider or enter the desired trigger divide, from 1 to 1,000. The default is 1.
Free Run
The sensor immediately issues a new trigger at the end of an inspection.

Industrial Ethernet
The Industrial Ethernet communications channel controls the trigger. A PLC or HMI triggers the camera tool over an Industrial Ethernet protocol such as EtherNet/IP or PROFINET.

7.3 Focus Information
Select the Focus Info checkbox and expand the parameter to view the current focus number for the installed lens.

The focus number is a number between 1 and 255. Use the Image pane to determine when the image is sharp enough, or use the focus number as a guide. Turn the focus ring on the lens until the focus number is at the highest possible number between 1 and 255. The focus number is also available on the sensor display.

Note: There is no optimal value for this number, but it can be used as a guide if you are setting up more than one sensor that are focused on the same target.

7.4 External Strobe
Use External Strobe to control an external light connected to the sensor.

Strobe Type
The strobe type of the VE Series camera should match the style of external light used, otherwise the ON/OFF behavior of the light will be inverted.
- Active Low—A 0 V dc external strobe signal is provided by the VE Series camera when the external light should be ON. A +5 V dc external strobe signal is provided by the VE Series camera when the external light should be OFF. This is the default strobe type setting for the VE Series camera and many of the external vision lights Banner offers.
- Active High—A +5 V dc external strobe signal is provided by the VE Series camera when the external light should be ON. A 0 V dc external strobe signal is provided by the VE Series camera when the external light should be OFF.

Mode
- Always Off—The external light is always OFF
- Always On—The external light is always ON
- Exposure Based—The external light is ON for the duration of the camera exposure time
- Time Based—The external light is ON for the duration of a user-defined time period
Exposure Delay
The external light turns ON after a user-defined time delay, in milliseconds, after a valid trigger. Available only when the Mode is Exposure Based or Time Based.

Duration
The external light is ON for a user-defined amount of time, in milliseconds. Available only when the Mode is Time Based.

7.5 Camera Tool: Results
Click the camera tool on Tools & Results or expand the camera tool on All Results to view camera information.

**Focus Number**
The focus number for the frame being viewed, if the Focus Number parameter is enabled in the Camera tool. See Focus Information (p. 57) for more information on the Focus Number.

**Execution Time**
The execution time for the camera tool. This is the total time required to capture an image.
Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.

**Status**
Status and error messages display as appropriate.
8 Using the Inspection Tools: Vision Tools

Vision sensor tools include Average Gray, Bead, Blemish, Blob, Edge, Locate, Match, and Object.

Click a tool on Tools & Results or on Tools Only to access the Parameters pane for that tool. The Parameters pane contains both an Inputs tab and a Test tab. Define parameters for the tool itself on the Inputs tab. Define pass or fail criteria for the tool on the Test tab. When a tool is selected, the tool is highlighted orange in Tools & Results and in Tools Only, the tool ROI is selected in the Image pane, and the tool results are highlighted in All Results.

For many of the parameters, move the slider to set the desired number, or move both sliders to set minimum and maximum limits, where applicable. Numbers and limits can also be entered manually.

In parameters with colors in the sliders, vertical green bars represent current image information. Light gray backgrounds indicate the range over which a value has varied over time.

8.1 Average Gray Tool

Use the Average Gray tool to determine the brightness levels of pixels found within the ROI.

Each pixel has a grayscale intensity value from 0 to 255, where 0 is black and 255 is white. The tool records the grayscale value of each pixel in an ROI and averages them. With this information, the tool can detect changes in intensity that can indicate several conditions, such as missing objects, holes, texture changes, and possible color changes.

Example applications:
- Spot-check for holes
- Check for a change in surface texture
- Check for presence/absence of a label or other objects

8.1.1 Average Gray Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.

ROI

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

Resize and rotate the ROI around the feature to be analyzed. Change the shape of the ROI to a square, ellipse, or circle as needed by expanding ROI on the Parameters pane and selecting the desired shape. An ROI can be as large as the entire Field of View (FOV). The ROI automatically displays on the Image pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.
Masks

Add and define a mask to exclude a group of pixels from the tool analysis.

![Masks Parameters](image)

A mask created for a tool will not apply to any other tool in the inspection. Up to 10 masks can be added to a tool.

1. Expand **Masks** on the **Inputs** tab.
2. Click ![Add Mask Button](image). The mask ROI automatically displays on the **Image** pane.
3. Select the mask shape. The mask ROI can be rectangular, elliptical, or circular.
4. Resize 📊 and rotate 👉 the mask ROI around the pixels to be excluded.
5. To delete a mask, click 🗑️.

Pixel Intensity Range

Set the intensity range of pixels to analyze. Pixels with brightness values outside of this range are ignored.

![Pixel Intensity Range Parameters](image)

The default settings of 0 to 255 allow all pixels to be included in the average calculation.

- **Note:** An average grayscale result of – indicates that all pixels in the ROI have been excluded by the pixel intensity range parameter.

Image Overlays

Choose whether to display or hide the ROI or masks.

![Image Overlays – Default](image)

These options override the ROI view buttons 📚 🗑️ 🗑️ on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

- **Hide ROI**
  - Hides the ROI when the tool is **not** selected.
- **Hide Masks**
  - Hides the Mask ROI when the tool is **not** selected.
Tool Histogram

The Tool Histogram graphically displays pixel intensity information within the current ROI.

Select the Tool Histogram checkbox to enable the histogram. The default is enabled. Expand the Tool Histogram parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.

Inspection Pass/Fail

Select the Contribute to Inspection Pass/Fail check box (default) if the tool will influence the Pass/Fail status of the inspection.

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

8.1.2 Average Gray Tool: Test Parameters

Use the Test parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable Test parameters. The historical data begins from the last reset.

Average Grayscale
The grayscale value range.

Standard Deviation
The standard deviation range.
8.1.3 Average Gray Tool: Results

Tools & Results and All Results list information from the current and previous inspections. A red box around a tool indicates that the tool failed. Status provides information about the specific failure.

All Results displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

**Average Grayscale**
- The average grayscale value of the pixels in the ROI.

**Standard Deviation**
- The standard deviation of the average grayscale value for the pixels in the ROI.

**Execution Time**
- The execution time, in milliseconds, for the currently selected tool in the current inspection.
- Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.
- Use the reset button in the Inspection Summary to reset these historical values.

**Status**
- Status and error messages display as appropriate.

8.1.4 Using the Average Gray Tool

Follow these steps for a typical presence/absence Average Gray inspection.

- **Note:** This procedure is an example only.

1. Add an Average Gray tool to the inspection.
2. Adjust the ROI to frame the desired feature.
3. Set the Test parameters to set the pass/fail criteria.
   - a) On the Test tab, select the Average Grayscale checkbox.
     - This option sets the grayscale range that must be present in the ROI so that a part passes.
   - b) Move the sliders or enter the minimum and maximum grayscale. Inspections outside of this range will fail. For this example, the minimum is 56.12 and the maximum is 74.83.
     - The green bar indicates the current grayscale and the light gray background indicates the grayscale over time since the last reset.
4. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

![Figure 79. Average Gray—Pass](image1)
![Figure 80. Average Gray—Fail](image2)
8.2 Bead Tool

Use the Bead tool to inspect parts for uniformity of adhesive or sealant material, or for uniformity of a gap. In an industrial setting, this "bead" of material is commonly applied in a strip along a known path. The Bead tool looks at this pre-defined path and verifies whether the adhesive or sealant has been correctly applied.

For the purposes of this tool, a bead is any long, narrow strip of approximately consistent width and approximately consistent color. The bead must have sufficient contrast with the background so that a simple grayscale threshold scheme can separate the two. Background clutter and optical noise, such as shiny spots or holes in the bead, are permitted, but their presence may degrade the robustness of a bead inspection.

The Bead tool assumes that the bead material has been applied by a mechanized system and is consistent in location and direction. The tool does not attempt to detect, follow, or account for variations in bead location.

Example applications:
- Detect uniformity of a bead of adhesive
- Detect uniformity of a gap between two adjacent materials

8.2.1 Bead Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.

**ROI**

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

The ROI is configurable to follow the desired path of the adhesive or sealant being analyzed. Adjust the width of the ROI and set the sample rate. From the list select the frequency of bead width measurements: Every Pixel, Every 2nd Pixel, or Every 4th Pixel. See Bead Tool: Adjust the ROI (p. 69).
Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

Masks

Add and define a mask to exclude a group of pixels from the tool analysis.

A mask created for a tool will not apply to any other tool in the inspection. Up to 10 masks can be added to a tool.

1. Expand **Masks** on the **Inputs** tab.
2. Click ![icon](image). The mask ROI automatically displays on the **Image** pane.
3. Select the mask shape. The mask ROI can be rectangular, elliptical, or circular.
4. Resize ![icon](image) and rotate ![icon](image) the mask ROI around the pixels to be excluded.
5. To delete a mask, click ![icon](image).

Threshold

The threshold parameter separates the bead from the background, in terms of contrast.

Threshold Type: Adaptive

Select Adaptive when there are lighting changes that cause the acquired image to change.

An adaptive threshold is a technique that adjusts the threshold for the tool based upon lighting changes and image content within the ROI. It performs best if used with bi-modal images, which have a clear contrast in the ROI. Adaptive threshold chooses the current threshold value by converging to a value based on the average value of the pixels above and below the previous threshold value; it will not move the value of the threshold above or below the minimum and maximum limits.

Adaptive Threshold: Bead/Blob Type

Defines whether the bead/blob is dark against a relatively brighter background or bright against a darker background.

This parameter defines the appearance of the feature of interest. For example, if you have a dark adhesive or part on a bright background, choose **Dark**.

Choosing **Dark** with an adaptive threshold type causes the tool to limit the threshold to the range specified by the threshold level minimum and maximum limits. The tool identifies all grouped pixels below the threshold chosen as dark beads/blobs.

Choosing **Bright** with an adaptive threshold type causes the tool to limit the threshold to the range specified by the threshold level minimum and maximum limits. The tool identifies all grouped pixels above the specified minimum limit and less than or equal to the maximum limit as bright beads/blobs.
**Adaptive Threshold: Threshold**

Use the sliders or enter the desired minimum and maximum possible grayscale threshold.

The green line is the current threshold value, chosen by the tool, and the sliders represent boundaries beyond which you do not want the tool to move the threshold settings.

**Reject Level**

When the Bead/Blob Type is set to Bright, use the **Reject Level** to narrow the range of pixel intensities to be considered in an inspection.

Leaving the defaults at 0 for low and 255 for high means that the tool takes into consideration all grayscale levels in the ROI from 0 (black) to 255 (white).

**Reject Level Example**

Consider setting up an inspection for a relatively bright object that ranges from 180 to 200 in pixel intensity and takes up 15 percent of the FOV. The remaining 85 percent of the FOV ranges from 230 to 255 in pixel intensity. Setting a Reject Level of 220 allows the tool to pay attention to only the bright object being inspected. Masking the bright parts of the FOV is not necessary because only pixels whose intensity is less than the Reject Level will contribute to bright beads/blobs.

**Threshold Type: Fixed**

Select **Fixed** when the lighting and image content remain relatively constant for all inspections.

**Fixed Threshold: Bead/Blob Type**

Defines whether the bead/blob is dark against a relatively brighter background or bright against a darker background.

This parameter defines the appearance of the feature of interest. For example, if you have a dark adhesive or part on a bright background, choose **Dark**.

Choosing **Dark** with a fixed threshold type causes the tool to fix the threshold at the level specified by the Threshold level parameter. The tool identifies all grouped pixels below the specified threshold as dark beads/blobs.

Choosing **Bright** with a fixed threshold type causes the tool to fix the threshold at the Bright level specified by the Threshold level parameter. The tool identifies all grouped pixels above the specified Bright threshold and less than or equal to the Reject level as bright beads/blobs.

**Fixed Threshold: Threshold**

Use the slider to define the dark/bright cutoff point.

Any pixels brighter than this point define the bright bead while those darker than this point define the dark bead.

**Reject Level**

When the Bead/Blob Type is set to Bright, use the **Reject Level** to narrow the range of pixel intensities to be considered in an inspection.

Leaving the defaults at 0 for low and 255 for high means that the tool takes into consideration all grayscale levels in the ROI from 0 (black) to 255 (white).
Reject Level Example
Consider setting up an inspection for a relatively bright object that ranges from 180 to 200 in pixel intensity and takes up 15 percent of the FOV. The remaining 85 percent of the FOV ranges from 230 to 255 in pixel intensity. Setting a Reject Level of 220 allows the tool to pay attention to only the bright object being inspected. Masking the bright parts of the FOV is not necessary because only pixels whose intensity is less than the Reject Level will contribute to bright beads/blobs.

Good Bead Width
Move the sliders or enter the desired minimum and maximum bead width.
The red section is bead that is too narrow or is a gap. The green section is good bead width. The blue section is bead that is too wide.

Filters
Select the checkbox to ignore boundary pixels.

Boundary pixels are bead pixels that touch the ROI. If boundary pixels are ignored, one or more segments may also be ignored.

Image Overlays
Choose whether to display or hide the annotations, ROI, or masks when this tool is not selected. Masks are hidden by default.

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.
Hide Annotations
Hides the annotations on the live image for the tool, even when the tool is selected.

Hide ROI
Hides the ROI when the tool is not selected.

Hide Masks
Hides the Mask ROI when the tool is not selected.

Tool Histogram
The Tool Histogram graphically displays pixel intensity information within the current ROI.

Select the Tool Histogram checkbox to enable the histogram. The default is enabled. Expand the Tool Histogram parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.

Inspection Pass/Fail
Select the Contribute to Inspection Pass/Fail check box (default) if the tool will influence the Pass/Fail status of the inspection.

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.
8.2.2 Bead Tool: Test Parameters

Use the Test parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable Test parameters. The historical data begins from the last reset.

![Image of Test Parameters]

**Figure 93. Test Parameters**

- **Count - Good**: The number of good beads.
- **Count - Narrow/Gap**: The number of narrow beads.
- **Count - Wide**: The number of wide beads.
- **Largest Width**: The maximum width found.
- **Smallest Width**: The minimum width found.
- **Average Width**: The average width found.
- **Total Length - Good**: The total length of good beads.
- **Total Length - Narrow/Gap**: The total length of narrow beads.
- **Total Length - Wide**: The total length of wide beads.
- **Longest Length - Good**: The longest good bead length.
- **Longest Length - Narrow/Gap**: The longest narrow bead length.
- **Longest Length - Wide**: The longest length of wide beads.

8.2.3 Bead Tool: Results

**Tools & Results** and **All Results** list information from the current and previous inspections.

A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.

**All Results** displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

- **Count - Good**: The number of beads that fall within the user-defined good bead width.
  
  Expand **Count - Good** to see the length of each bead, the total length of all beads, and the longest length.

- **Count - Narrow/Gap**: The number of narrow beads or gaps that qualify as having a narrow bead width.
  
  Expand **Count - Narrow/Gap** to see the length of each bead, the total length of all beads, and the longest length.

- **Count - Wide**: The number of wide beads that qualify as having a wide bead width.
  
  Expand **Count - Wide** to see the length of each bead, the total length of all beads, and the longest length.
**Average Width**

The average width of all beads.

Expand **Average Width** to see the largest width and the smallest width.

**Adaptive Threshold**

The grayscale value used to detect the bead when the Threshold Type is Adaptive. If the tool cannot calculate this value, or if the Threshold Type is Fixed, this value displays as --.

**Execution Time**

The execution time, in milliseconds, for the currently selected tool in the current inspection.

Expand **Execution Time** to see the historical minimum and maximum execution times up to this point for the selected tool.

Use the reset button in the Inspection Summary to reset these historical values.

**Status**

Status and error messages display as appropriate.

### 8.2.4 Bead Tool: Adjust the ROI

Follow these steps to adjust the Bead tool ROI.

**Note:** This procedure is an example only. Use the appropriate steps to adjust the Bead tool ROI for your application.

1. Add a Bead tool to the inspection.

![Figure 94. Add a Bead Tool](image)

2. Move the ROI over the bead to be inspected.

3. Move an anchor point to a new position by clicking on the anchor point when the **Hand** icon displays.

![Figure 95. Click to Move Anchor Point](image)

4. Click the **+** sign on either end of the bead ROI to add more anchor points.
5. Click on a line to add an inline anchor point.
   a) Point to the ROI line; the pointer changes to a +.

   ![Figure 96. Add Anchor Point](image)

   ![Figure 97. Add Inline Anchor Point](image)

   ![Figure 98. Inline Anchor Point Location Selected](image)

   ![Figure 99. Inline Anchor Point Set](image)

   b) Click to select the location for the new anchor point; + is added on the line.

   c) Click the point again to set the location on the line. The + changes to ◦.

6. Click on an ◦ anchor point and the Trash icon displays above it; click the Trash to delete the point.

   ![Figure 100. Click to Delete Anchor Point](image)

7. Use the ROI sliders in the Input tab to change the ROI width.

   ![Figure 101. Bead Tool ROI Width](image)

8. Use the Good Bead Width parameter under Characteristics to define the good bead width.
Green indicates that the bead width is acceptable. Red indicates that the bead width is too narrow or that a gap exists. Blue indicates that the bead width is too wide.

Figure 102. Good, Narrow, and Wide Adhesive Widths

8.2.5 Using the Bead Tool

Follow these steps to configure a Bead tool for a dark adhesive on a bright background.

**Note:** This procedure is an example only.

In this example, scaling is on (System Settings > Units > Scaling) with the Measurement Unit set at Millimeters, the Measurement in Pixels set at 810, and the Measurement in Millimeters set at 70.

1. Add a Bead tool to the inspection.
2. Adjust the ROI path and width to match the adhesive bead.
   See Bead Tool: Adjust the ROI (p. 69).

3. Set the threshold.
4. Set the bead width.
   a) Expand the Good Bead Width parameter.
   b) Move the sliders to define the minimum and maximum acceptable bead width. In this example, the minimum bead width is 1.72 mm and the maximum bead width is 4.83 mm.

5. Set the test parameters to set the pass/fail criteria.
   a) On the Test tab, select the Count - Good checkbox to enable the test parameter. This option sets the number of good beads that must be present with the tool parameters so that a part passes.
   b) Expand Count - Good and move the sliders or enter the minimum and maximum as 1 and 1. This means that the inspection must find one and only one bead within the ROI that meets the Good Bead Width definition.
   c) Select the Count - Narrow/Gap checkbox to enable the test parameter. This option sets the allowable number of gaps in the bead.
   d) Move the sliders or enter the minimum and maximum as 0 and 0. This means that no gaps are allowed. If gaps are found, the inspection fails.
6. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

8.3 Blemish Tool

Use the Blemish tool to determine whether flaws are present on a part (for example, scratches on a disc), or to make sure that a feature exists on a part.

Although finding features is more commonly an application for a Blob tool, the Blemish tool may be a better option to find a feature when dealing with variable materials or inconsistent lighting.

Example applications:
- Check for scratches on a part, and reject parts where the scratches are too numerous or larger than acceptable
- Check for the presence of a label or marking on a part that may vary in brightness level
8.3.1 Blemish Tool: Input Parameters

Use the **Input** parameters to configure how the tool analyzes an image.

![Blemish Tool—Input Parameters](image)

**ROI**

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

![ROI Shape Selection](image)

Resize 📉 and rotate 🍂 the ROI around the feature to be analyzed. Change the shape of the ROI to a square, ellipse, or circle as needed by expanding **ROI** on the **Parameters** pane and selecting the desired shape. An ROI can be as large as the entire Field of View (FOV). The ROI automatically displays on the **Image** pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

**Masks**

Add and define a mask to exclude a group of pixels from the tool analysis.

![Masks Parameters](image)

A mask created for a tool will not apply to any other tool in the inspection. Up to 10 masks can be added to a tool.

1. Expand **Masks** on the **Inputs** tab.
2. Click 📊. The mask ROI automatically displays on the **Image** pane.
3. Select the mask shape. The mask ROI can be rectangular, elliptical, or circular.
4. Resize 📉 and rotate 🍂 the mask ROI around the pixels to be excluded.
5. To delete a mask, click 🗑️.
Sensitivity

Set the **Sensitivity** to define how sensitive the sensor is to finding blemish or other edges within the ROI. The sensitivity value helps account for light variations that can affect how well the sensor detects edges on inspected parts.

![Figure 112. Sensitivity](image)

The Sensitivity scale is from 0 to 100 where 0 means least sensitive and 100 means most sensitive. If set near 0, the sensor finds very sharp edges with strong contrast. If set near 100, the sensor finds very dim or blurry edges, and may be unstable. The default is 80.

Edge Length Range

Shows the different contiguous edge segments found.

![Figure 113. Edge Length Range](image)

Use the sliders to specify the edge length range in pixels. Edges found within this range will be considered when calculating the Pass Count. Green represents lengths within the specified range and yellow represents lengths outside of the specified range.

Image Overlays

Choose whether to display or hide the annotations, ROI, or masks when this tool is **not** selected. Masks are hidden by default.

![Figure 114. Image Overlays—Default](image)

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

- **Hide Annotations**
  - Hides the annotations on the live image for the tool, even when the tool is selected.

![Figure 115. Show Blemish Tool Annotations](image)  ![Figure 116. Hide Blemish Tool Annotations](image)

- **Hide ROI**
  - Hides the ROI when the tool is **not** selected.
**Hide Masks**

Hides the Mask ROI when the tool is **not** selected.

**Tool Histogram**

The Tool Histogram graphically displays pixel intensity information within the current ROI.

![Example Histogram](image)

Select the **Tool Histogram** checkbox to enable the histogram. The default is enabled. Expand the **Tool Histogram** parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.

**Inspection Pass/Fail**

Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

![Inspection Pass/Fail](image)

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

### 8.3.2 Blemish Tool: Test Parameters

Use the **Test** parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable **Test** parameters. The historical data begins from the last reset.

![Blemish Tool—Test Parameters](image)

**Count**

The total number of edge pixels.
8.3.3 Blemish Tool: Results

Tools & Results and All Results list information from the current and previous inspections. A red box around a tool indicates that the tool failed. Status provides information about the specific failure.

All Results displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

- **Count**
  The total number of edge pixels counted.

- **Length Range**
  The minimum and maximum edge lengths found.
  Expand Length Range to see the minimum and maximum edge pixels counted, and the total edge pixels for each blemish.

- **Execution Time**
  The execution time, in milliseconds, for the currently selected tool in the current inspection.
  Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.
  Use the reset button in the Inspection Summary to reset these historical values.

- **Status**
  Status and error messages display as appropriate.

8.3.4 Using the Blemish Tool

Follow these steps for an example Blemish inspection to check for a date/lot code on a product.

- **Note:** This procedure is an example only.

1. Add a Blemish tool to the inspection.
2. Adjust the ROI to frame the date/lot code.
3. Set the sensitivity.
   a) Expand the Sensitivity parameters.
   b) Move the slider or enter 75 for this example.
      A low sensitivity setting finds only high contrast edges, while a high sensitivity setting finds lower contrast edges as well. Note that the color does not matter; the tool will still find the edges of the date/lot code.

4. Leave the default minimum and maximum edge length range (100 px and 165000 px).
   This defines how long the edge has to be before it is counted and how small it can be before it is ignored. Green means that the edge is within the criteria to be counted and yellow means it is outside of the criteria and is being ignored.
5. Set the Test parameters to set the pass/fail criteria.
   a) On the Test tab, select the Count checkbox.
      This option sets the number of edges that must be present within the ROI that match the inspection parameters so that the tool passes.
   b) Move the sliders or enter the minimum count at 242 and the maximum count at 233230.
      For example, a minimum and maximum count of 0 and 0 means that the part must have zero edges within the ROI that match the inspection parameters. In this case, the part must be blemish-free.
6. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

![Figure 122. Bad Part—Missing Date/Lot Code](image)

8.4 **Blob Tool**

Use the Blob tool to detect and count groups of like-colored pixels within the ROI.

A user-selected range of brightness levels defines the pixels of interest. Then, the Blob tool merges pixels of interest that touch each other into groups, called blobs. The Blob tool then counts the number of blobs in the ROI, calculates their size in pixel area, and defines each blob’s center of mass location.

Example applications:
- Count pills
- Measure hole size
- Verify the number of characters in a date/lot code
- Detect LCD segments
- Detect missing products during packaging

8.4.1 **Blob Tool: Input Parameters**

Use the **Input** parameters to configure how the tool analyzes an image.

![Figure 123. Blob Tool—Input Parameters](image)
ROI
The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

Resize and rotate the ROI around the feature to be analyzed. Change the shape of the ROI to a square, ellipse, or circle as needed by expanding ROI on the Parameters pane and selecting the desired shape. An ROI can be as large as the entire Field of View (FOV). The ROI automatically displays on the image pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

Masks
Add and define a mask to exclude a group of pixels from the tool analysis.

A mask created for a tool will not apply to any other tool in the inspection. Up to 10 masks can be added to a tool.

1. Expand Masks on the Inputs tab.
2. Click . The mask ROI automatically displays on the image pane.
3. Select the mask shape. The mask ROI can be rectangular, elliptical, or circular.
4. Resize and rotate the mask ROI around the pixels to be excluded.
5. To delete a mask, click .

Threshold
The threshold parameter is used to mark a transition point.

Threshold Type: Adaptive
Select Adaptive when there are lighting changes that cause the acquired image to change.

An adaptive threshold is a technique that adjusts the threshold for the tool based upon lighting changes and image content within the ROI. It performs best if used with bi-modal images, which have a clear contrast in the ROI. Adaptive threshold chooses the current threshold value by converging to a value based on the average value of the pixels above and below the previous threshold value; it will not move the value of the threshold above or below the minimum and maximum limits.
Adaptive Threshold: Bead/Blob Type

Defines whether the bead/blob is dark against a relatively brighter background or bright against a darker background.

This parameter defines the appearance of the feature of interest. For example, if you have a dark adhesive or part on a bright background, choose Dark.

Choosing Dark with an adaptive threshold type causes the tool to limit the threshold to the range specified by the threshold level minimum and maximum limits. The tool identifies all grouped pixels below the threshold chosen as dark beads/blobs.

Choosing Bright with an adaptive threshold type causes the tool to limit the threshold to the range specified by the threshold level minimum and maximum limits. The tool identifies all grouped pixels above the specified minimum limit and less than or equal to the maximum limit as bright beads/blobs.

Adaptive Threshold: Threshold

Use the sliders or enter the desired minimum and maximum possible grayscale threshold.

The green line is the current threshold value, chosen by the tool, and the sliders represent boundaries beyond which you do not want the tool to move the threshold settings.

Reject Level

When the Bead/Blob Type is set to Bright, use the Reject Level to narrow the range of pixel intensities to be considered in an inspection.

Leaving the defaults at 0 for low and 255 for high means that the tool takes into consideration all grayscale levels in the ROI from 0 (black) to 255 (white).

Reject Level Example

Consider setting up an inspection for a relatively bright object that ranges from 180 to 200 in pixel intensity and takes up 15 percent of the FOV. The remaining 85 percent of the FOV ranges from 230 to 255 in pixel intensity. Setting a Reject Level of 220 allows the tool to pay attention to only the bright object being inspected. Masking the bright parts of the FOV is not necessary because only pixels whose intensity is less than the Reject Level will contribute to bright beads/blobs.

Threshold Type: Fixed

Select Fixed when the lighting and image content remain relatively constant for all inspections.

Fixed Threshold: Threshold

Use the sliders to define the range of brightness values of interest.

Area Range

Set the size range of blobs that the tool will count.

Green represents blobs that are within the set range, and yellow represents blobs that are outside of the set range.
Blob Statistics

Select to calculate and display advanced results on **Tools & Results** and **All Results**.

![Blob Statistics](image1)


Filters

Set filters for tool analysis.

![Filters](image2)

**Discard Blobs that Touch ROI**

Select to exclude blobs that touch the perimeter of the ROI.

**Fill Holes within Blob**

Select to ignore (by filling) small features such as scratches and glare that might otherwise appear as small imperfections or non-blobs within a larger blob. After selecting this option, use the slider or enter the size of the largest hole to fill.

Image Overlays

Choose whether to display or hide the annotations, ROI, or masks when this tool is not selected. Masks are hidden by default.

![Image Overlays](image3)

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

**Hide Annotations**

Hides the annotations on the live image for the tool, even when the tool is selected.

![Hide Annotations](image4)

**Hide ROI**

Hides the ROI when the tool is not selected.
**Hide Masks**

Hides the Mask ROI when the tool is **not** selected.

**Tool Histogram**

The Tool Histogram graphically displays pixel intensity information within the current ROI.

Select the **Tool Histogram** checkbox to enable the histogram. The default is enabled. Expand the **Tool Histogram** parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.

**Inspection Pass/Fail**

Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

**8.4.2 Blob Tool: Test Parameters**

Use the **Test** parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable **Test** parameters. The historical data begins from the last reset.
8.4.3 Blob Tool: Results

Tools & Results and All Results list information from the current and previous inspections. A red box around a tool indicates that the tool failed. Status provides information about the specific failure.

All Results displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

**Count**
- The number of blobs found.

**Total Area**
- The total area of all of the blobs found.

**Individual Blobs**
- From the Blob(s) to test dropdown list, select All Blobs, First Blob, or Specific Blob, to view area and centroid information about the blobs.
- When Specific Blob is selected, choose the specific blob using the Blob Index.
- To verify if blobs within the ROI are of a specific area, select the Area checkbox and use the sliders or enter the minimum and maximum blob size.
- When Calculate Blob Statistics is enabled, additional parameters for the selected blob become available. These include Perimeter, Compactness, Major Axis Length, Minor Axis Length, Eccentricity, Minimum Radius, Maximum Radius, Major Axis Angle, Top Left Position X, Top Left Position Y, Bottom Right Position X, and Bottom Right Position Y.

**Area Range**
- The minimum and maximum areas of the blobs found.
- Expand Area Range to see the area and centroid (center point) for each blob.
- Click a blob’s area range to highlight that blob on the Image pane.

**Statistics**
- Advanced statistical information about each blob.
- Available when Calculate Blob Statistics is checked. See the following sections for more details.

**Adaptive Threshold**
- The grayscale value for the software-selected threshold value used to generate the blobs.
- This result is blank if the threshold type is set to Fixed.

**Execution Time**
- The execution time, in milliseconds, for the currently selected tool in the current inspection.
- Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.
- Use the reset button in the Inspection Summary to reset these historical values.

**Status**
- Status and error messages display as appropriate.
Area
The area (A) is a count of the total number of pixels that belong to the blob.

Centroid
The centroid \((x_c, y_c)\) is the point at the center of mass of the blob.

For simple blobs such as solid circles, ellipses, or rectangles, this is the center of the shape. For more complicated shapes it is helpful to imagine a piece of cardboard cut in the shape of the blob. The centroid is the point where you could balance the cardboard on the tip of a pencil. For complicated shapes—especially shapes with unfilled holes—the centroid might lie outside of the shape.

The x coordinate of the centroid is calculated by adding the x coordinates of each pixel in the blob and dividing by the area. The y coordinate is similar:

\[
x_c = \frac{\sum_{i=1}^{A} x_i}{A}
\]
\[
y_c = \frac{\sum_{i=1}^{A} y_i}{A}
\]

Perimeter
The perimeter (P) gives an approximate measurement of the length of the circumference of the blob.

Because blobs are built from individual pixels, it is most practical to estimate the perimeter by counting the contributions of individual pixels on the blob’s boundary. The following describes the exact values that are added to the perimeter for each possible pixel configuration. In each example, the description refers to the center pixel in the corresponding pictures.

A pixel with no neighbors that belong to the same blob contributes 3.14 linear pixels to the perimeter of the blob. This can happen only in a blob that has an area of one. Since such small blobs are usually ignored, this circumstance is rare.

A pixel with one neighbor that belongs to the same blob contributes 2.571 linear pixels to the perimeter of the blob.

A pixel with two neighbors that belong to the same blob, forming a straight line, contributes exactly 2 linear pixels to the perimeter of the blob.

A pixel with two neighbors that belong to the same blob, forming a corner, contributes 1.414 linear pixels to the perimeter of the blob.

A pixel with three neighbors that belong to the same blob contributes exactly 1 linear pixel to the perimeter of the blob.
A pixel with four neighbors that belong to the same blob contributes nothing to the perimeter of the blob.

This method of counting slightly overestimates the "true" perimeter. For example, a circle with a radius of 100 pixels has a computed perimeter of approximately 660 pixels, compared with the expected value of 628 pixels.

If the sensor is configured to convert pixel distances to other units, (for example, millimeters), the perimeter is given in those units. If the blob contains holes that have not been filled, the length of the perimeter includes the points on the perimeters of these holes.

**Compactness**

Compactness is a measurement of the space a blob occupies.

The compactness is high for blobs that are nearly circular and low for blobs that are elongated or complicated.

\[
\text{compactness} = \frac{400 \pi A}{P^2}
\]

Where \( A \) is the area and \( P \) is the perimeter of the Blob in question. An idealized circle would have a compactness of 100, but because the perimeter is approximated (see above), the highest realistic value for most blobs is roughly 90. Very small blobs with just a handful of pixels may reach or even exceed the theoretical maximum of 100, again because of the approximations in the perimeter calculation.

**Major Axis Length, Minor Axis Length, and Major Axis Angle**

Major Axis Length, Minor Axis Length, and Major Axis Angle are determined using a best fit ellipse.

To understand Major Axis Length, Minor Axis Length, and Major Axis Angle, it is important to note that these are not measurements of the blob itself because the blob may be an irregular shape. Rather, these measurements are determined by a well-defined shape, a "best fit ellipse".

These three results combine to give information about the elongation and orientation of a blob. The equations used to compute these statistics are complicated, but the results usually have an intuitively useful meaning, described below. The first step in computing these results is to compute the \( M_{2,0} \), \( M_{0,2} \) and \( M_{1,1} \) statistical moments:

\[
M_{2,0} = \frac{\sum_{i=1}^{A} (x_i - x_c)^2}{A}
\]

\[
M_{0,2} = \frac{\sum_{i=1}^{A} (y_i - y_c)^2}{A}
\]

\[
M_{1,1} = \frac{\sum_{i=1}^{A} ((x_i - x_c)(y_i - y_c))}{A}
\]
where $A$ is the area, $(x_c, y_c)$ are the coordinates of the centroid, and $(x_i, y_i)$ are the coordinates of pixel $i$. These values represent the variance with respect to $x$, the variance with respect to $y$, and the covariance, respectively. The final results can be calculated as follows:

$$\text{Major Axis Length} = 2\sqrt{2\left(\frac{M_{2,0} + M_{0,2} + \sqrt{4M_{1,1} (M_{2,0} - M_{0,2})^2}}{1 + 2M_{1,1}}\right)}$$

$$\text{Minor Axis Length} = 2\sqrt{2\left(\frac{M_{2,0} + M_{0,2} - \sqrt{4M_{1,1} (M_{2,0} - M_{0,2})^2}}{1 + 2M_{1,1}}\right)}$$

$$\text{Major Axis Angle} = \tan^{-1}\left(\frac{2M_{1,1}}{M_{2,0} - M_{0,2}}\right)$$

The following table gives a more practical perspective on how to interpret these results. If the sensor is configured to convert pixels to other units, the major and minor axis lengths are given in those units. The major axis angle is always given in degrees.

<table>
<thead>
<tr>
<th>Blob Shape</th>
<th>Meaning of Major Axis Length</th>
<th>Meaning of Minor Axis Length</th>
<th>Meaning of Major Axis angle</th>
</tr>
</thead>
<tbody>
<tr>
<td>Circular, no holes</td>
<td>Diameter of the circle</td>
<td>Equal to the major axis length</td>
<td>Unstable</td>
</tr>
<tr>
<td>Elliptical, no holes</td>
<td>Length of the ellipse</td>
<td>Width of the ellipse</td>
<td>Orientation of the ellipse</td>
</tr>
<tr>
<td>Square, no holes</td>
<td>Diameter of a circle that best approximates the square</td>
<td>Equal to the major axis length</td>
<td>Unstable</td>
</tr>
<tr>
<td>Rectangular, no holes</td>
<td>Length of an ellipse that best approximates the rectangle</td>
<td>Width of an ellipse that best approximates the rectangle</td>
<td>Orientation of the rectangle</td>
</tr>
<tr>
<td>Complicated shape, no holes</td>
<td>Length of an ellipse that best approximates the shape</td>
<td>Width of an ellipse that best approximates the shape</td>
<td>Orientation of the shape—unstable if length and width are nearly equal</td>
</tr>
<tr>
<td>Any shape with holes</td>
<td>Results vary depending on exact shape—experiment on your particular shape</td>
<td>Results vary depending on exact shape—experiment on your particular shape</td>
<td>Results vary depending on exact shape—experiment on your particular shape</td>
</tr>
</tbody>
</table>

**Eccentricity**

The eccentricity of a blob is the length of the major axis divided by the length of the minor axis.

For circular regions and other regions with radial symmetry (such as a square), the value will be very close to 1. For elongated regions, the value will increase.

**Max Radius and Max Radius Position**

The Maximum Radius of a blob is the distance from the centroid of the blob to the farthest pixel on that blob’s perimeter. The Maximum Radius Position gives the pixel coordinates of that farthest perimeter point.

If the sensor is configured to convert pixels to other units, the maximum radius will be given in those units.

**Min Radius and Min Radius Position**

The Minimum Radius of a blob is the distance from the centroid of the blob to the closest pixel on that blob’s perimeter. The Minimum Radius Position gives the pixel coordinates of that closest perimeter point.

If the blob contains unfilled holes, the minimum radius position may be on the perimeter of a hole. If the sensor is configured to convert pixels to other units, the minimum radius will be given in those units.
Top Left Position X, Top Left Position Y, Bottom Right Position X, and Bottom Right Position Y

The top left and bottom right coordinates are determined using a bounding box around each blob. These positions represent the maximum and minimum coordinates of each blob.

![Blob Bounding Box](image)

8.4.4 Using the Blob Tool

Follow these steps for an example blob inspection in a pill counting application.

**Note:** This procedure is an example only.

1. Add a Blob tool to the inspection.
2. Adjust the ROI to frame the first set of pills in the blister pack.

![Adjusted ROI](image)

3. Set the threshold.
   a) Expand the **Threshold** parameters.
   b) From the **Threshold Type** list, select **Fixed**. Select Fixed when the lighting and image content remain relatively constant for all inspections.
   c) Expand the second **Threshold** parameters.
   d) Move the sliders to define the minimum and maximum threshold. This sets a minimum and maximum brightness within the ROI to include or exclude.
4. Set the area range.
   This defines the size range of pixel groups to include or exclude.
   a) Expand the **Area Range** parameters.
   b) Move the sliders to define the minimum and maximum size of pixel groups.
      Yellow indicates that a group of pixels is outside of the set range.

5. Set the Test parameters to set the pass/fail criteria.
   a) On the **Test** tab, select the **Count** checkbox to enable the test parameter.
      This option sets the number of blobs that must be present within the ROI that match the inspection parameters so that the tool passes.
   b) Expand **Count** and move the sliders or enter the minimum and maximum count as 10 and 10.

   **Note:** The green bar indicates the current count and the light gray background indicates the count over time.

6. Copy the Blob tool.
   a) With the Blob tool selected, click 📐.
      The tool and all of the settings are duplicated (copied) and all of the tools are deselected.
   b) Select one of the Blob tools and click 📐 a second time.
      There are now three Blob tools with the same settings.

7. Click Blob02 (the second Blob tool) and move the ROI over the second blister pack.
8. Click Blob03 (the third Blob tool) and move the ROI over the third blister pack.
9. Click to show all three ROI at the same time.
10. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

Figure 142. Bad Part—Missing Pill

Figure 143. Bad Part—Broken Pill

8.5 Circle Detect Tool

Use the Circle Detect tool to find a single circle or a piece of a circle (arc).

The Circle Detect tool finds many edge points along the transitions between bright and dark pixels and then fits a circular shape to some or all of these points. The tool can determine a bend radius and the circumference of a circular part. The tool finds only one circle within the ROI—either the best circle (using the Best Points option) or the average circle (using the All Points option).

Example applications:
- Find flaws such as chips or metal spurs along a punched or drilled hole
- Measure hole size
- Measure the size of a disk
- Verify that the neck on a vial or bottle is the correct size
- Measure the bend radius of an electronic component
- Find the radius of a circle that is too big to fit in the image

8.5.1 Circle Detect Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.

Figure 144. Circle Detect Tool—Input Parameters
ROI

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

Figure 145. Circle Detect Tool ROI

The ROI is two concentric circles that can also be configured as an arc. Resize or reshape the ROI around the feature to be analyzed. Tool analysis follows the direction of the arrow. The ROI automatically displays on the Image pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

Use the two circles to surround the specific circle of interest and avoid other edges, and to improve the execution time by reducing the number of pixels that are analyzed.

ROI Width

Larger ROIs find more edges, however if too many edges are outliers, the desired circle may not be found. Smaller ROIs execute faster.

The tool works best when the inner ring of the ROI is completely inside the circle being detected, and when the ROI and the circle being detected are concentric.

Sample Rate

The sample rate sets the spacing between scan lines along the width of the ROI (one sample for every pixel, one sample every second pixel, etc.). When the sample rate includes more pixels, more edges, more precise results, and small flaws are found. The highest sample rate is Every Pixel. When the sample rate includes fewer pixels, fewer, more widely spaced edges are found. The lowest sample rate is Every 64th Pixel. This creates a trade-off between speed and precision. Lower sample rates execute faster, and higher sample rates find more precise results and are capable of detecting smaller flaws.

Threshold

Indicates the rate of change of grayscale values that is needed to detect an edge.

Figure 146. Threshold Parameters

Edges are detected by measuring transitions from bright to dark or dark to bright. Enter a threshold in the range from 1 to 255. The default value is 20. As this value is reduced, the tool finds weak, blurry, or more gradual lines or edges. At lower thresholds, unwanted transitions such as background noise may become edges. Detected edges are combined to find potential circles.

Edge Polarity

Edge Polarity defines the type of edges that the tool finds.

- Dark to Bright—Finds edges where pixel intensities start below the threshold value and cross above the threshold value
- Bright to Dark—Finds edges where pixel intensities start above the threshold value and cross below the threshold value
- Bright or Dark—Finds any edge
Search For

Set the type of object that the Line Detect tool searches for.

Circle, Best Points
Automatically determines which edge points make the best circle and ignores the rest of the points. The points that are included are shown on the image in orange, while the points that are ignored are in yellow. Best Points is tolerant of noise or extra edges in the ROI, but under some circumstances, it may ignore edges that should be included.

Circle, All Points
Finds a circle that explains all of the edges as well as possible; all found points are included in the analysis. Found points are shown on the image in orange. All Points is faster than Best Points, but works poorly if there are extra edges or noise within the ROI. All Points is useful if if the circle being examined is irregular or elliptical.

Circular Arc
Finds a piece of a circle. Use this setting to find the start or end angle of an arc or bend or to measure the angle subtended by a bend. Circular Arc mode operates on best points.

Image Overlays

Choose whether to display or hide the annotations or the ROI when this tool is **not** selected.

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

Hide Annotations
Hides the annotations on the live image for the tool, even when the tool is selected.

Hide ROI
Hides the ROI when the tool is **not** selected.

Tool Histogram

The Tool Histogram graphically displays pixel intensity information within the current ROI.
Select the **Tool Histogram** checkbox to enable the histogram. The default is enabled. Expand the **Tool Histogram** parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.

**Inspection Pass/Fail**

Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

![Figure 151. Inspection Pass/Fail](image)

The Pass/Fail contribution influences the following:

- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

**8.5.2 Circle Detect Tool: Test Parameters**

Use the **Test** parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable **Test** parameters. The historical data begins from the last reset.
8.5.3 Circle Detect Tool: Results

**Tools & Results** and **All Results** list information from the current and previous inspections. A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.

**All Results** displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

- **Center**
  - The x and y coordinates of the center of the found circle. This point can be used as inputs to other tools.

- **Radius**
  - The distance from the center of the detected circle to its edges.

- **Min Radius**
  - The distance from the center of the circle to the closest included edge point.

- **Max Radius**
  - The distance from the center of the circle to the farthest included edge point.

- **Min Radius Point**
  - The x and y coordinates of the include edge point located closest to the center of the circle or arc.

- **Max Radius Point**
  - The x and y coordinates of the included edge point located farthest from the center of the circle or arc.

- **Circumference**
  - The distance around the circle.
  - **Available when Search For is set to Circle, Best Points or Circle, All Points.**

- **Arc Length**
  - The distance along the arc.
  - **Available when Search For is set to Circular Arc.**

- **Arc Angle**
  - The angle between the start and the end of the arc.
  - **Available when Search For is set to Circular Arc.**

- **Average Error**
  - The average distance between included edge points and the circle found.
  - Use this value to determine if a circle is squished (elliptical), poorly formed, or irregular.
Arc Length
The distance along the arc.
Available when Search For is set to Circular Arc.

Arc Angle
The angle between the start and the end of the arc.
Available when Search For is set to Circular Arc.

Arc Start
The angle between the x-axis and the beginning of the arc. This is between -180 and +180 degrees.
Available when Search For is set to Circular Arc.

Arc End
The angle between the x-axis and the end of the arc. This is between -180 and +180 degrees.
Available when Search For is set to Circular Arc.

Average Error
The average distance between included edge points and the circle found.

Execution Time
The execution time, in milliseconds, for the currently selected tool in the current inspection.
Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.
Use the reset button in the Inspection Summary to reset these historical values.

Status
Status and error messages display as appropriate.

8.5.4 Using the Circle Detect Tool

Follow these steps for a typical Circle Detect inspection to check for flashing, spurs, or cracks in a disk.

Note: This procedure is an example only.

1. Add a Circle Detect tool to the inspection to check the outer edge of the disk.
2. Adjust the ROI to frame the outside edge of the disk.
   a) Move the ROI so that it is concentric with the disk.
   b) Expand the outer ring of the ROI to frame the disk. Leave some space around the disk to ensure that flashing or spurs are found.
   c) Adjust the inner ring of the ROI so that the hole in the disk is exclude from the inspection.

3. Set the Input parameters.
   a) Expand the Search For parameter.
   b) Select Circle, All Points from the list.
4. Set the **Test** parameters to set the pass/fail criteria.
   a) Select the **Average Error** checkbox.
      This option looks at the average distance between included edge points and the circle found.
   b) Set the range from 0 px to 3 px.
5. Add a Circle Detect tool to the inspection to check the hole in the disk.
6. Adjust the ROI to frame the hole in the disk.
   a) Move the ROI so that it is concentric with the disk.
   b) Reduce the outer ring of the ROI to frame the hole.
   c) Adjust the inner ring of the ROI so that the entire hole is included in the inspection.

7. Set the **Input** parameters.
   a) Expand the **Search For** parameter.
   b) Select **Circle, All Points** from the list.
8. Set the **Test** parameters to set the pass/fail criteria.
   a) Select the **Average Error** checkbox.
   b) Set the range from 0 px to 3 px.
9. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

---

**Figure 154. Circle Detect ROI—Hole Edge Detection**

**Figure 155. Bad Part—Flashing**

**Note:** The flashing on the outer edge fails only the first Circle Detect tool in this example.

**Figure 156. Bad Part—Crack**

**Note:** This crack fails both of the Circle Detect tools in this example.

---

### 8.6 Edge Tool

Use the Edge tool to detect and count transitions between bright and dark pixels (edges).

The Edge tool counts the total number of edges, and determines the position of each edge. Edge position information can be used for distance or angle measurements when used with a Measure tool.
Example applications:
• Measure the height and width of a part
• Count the pins on an integrated circuit
• Measure the height of a needle
• Measure the deflection of an automotive gauge
• Detect the edge of a web
• Verify that a bottle cap is on completely

8.6.1 Edge Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.

**ROI**

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

The ROI is a line of pixels that can be shortened, lengthened, or widened as needed for the inspection. Tool analysis follows the direction of the arrow. Set the width and the sample rate for the region of interest. The ROI automatically displays on the Image pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

**ROI Width**

An ROI can be as large as the entire Field of View (FOV).

Note that:
• Narrow ROIs execute faster but could miss the edge
• Wide ROIs are more consistent but don’t execute as fast
• A wide ROI provides an average value/location, which results in improved repeatability
• The ROI must be 13 pixels or wider to calculate the rotation of a part (Locate tool only)

**Sample Rate**

The sample rate sets the number of samples per pixels (one sample per pixel, two samples per pixel, etc.). The sample rate determines the sub-pixel resolution, which increases the resolution of the tool, and increases the inspection time.
Threshold

The Threshold parameter marks the grayscale transition point. The tool marks the edge where the pixel intensity crosses the threshold level. From the **Threshold Type** list, select one of the following:

- Absolute
- Relative (default)
- Edge Strength

**Threshold Type: Absolute**

Finds an edge at a specific grayscale level.

![Absolute Threshold Parameters](image)

While Absolute threshold is less likely to find a false edge than Relative threshold, it may miss edges if the light level changes between inspections.

**Absolute Threshold: Value**

Enter a specific grayscale value from 0 to 255.

**Edge Polarity**

Edge Polarity defines the type of edges that the tool finds.

- Dark to Bright—Finds edges where pixel intensities start below the threshold value and cross above the threshold value
- Bright to Dark—Finds edges where pixel intensities start above the threshold value and cross below the threshold value
- Bright or Dark—Finds any edge
Absolute Threshold: Edge Profile Graph

For absolute threshold, the x axis is the length of the ROI. The y axis is the actual grayscale value from 0 to 255. The light blue line shows the absolute pixel intensity. The horizontal gray threshold line moves up or down with the threshold value. Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

Threshold Type: Relative
Finds an edge at a relative pixel intensity. This is the default threshold setting.

The brightest grayscale level found along the ROI is 100% and the darkest is 0%. While Relative threshold is more tolerant of light fluctuations between inspections than other transition types, it may find false edges.

Relative Threshold: Percent
Choose the percentage value at which the edge should be marked.

Edge Polarity
Edge Polarity defines the type of edges that the tool finds.

- Dark to Bright—Finds edges where pixel intensities start below the threshold value and cross above the threshold value
- Bright to Dark—Finds edges where pixel intensities start above the threshold value and cross below the threshold value
- Bright or Dark—Finds any edge
Relative Threshold: Edge Profile Graph

For relative threshold, the x axis is the length of the ROI. The y axis is the pixel intensity along the ROI, with 0% as the darkest pixel in the ROI and 100% as the lightest pixel in the ROI. The light blue line shows the percentage pixel intensity relative to the horizontal gray threshold line. The threshold line moves up or down with the percent value.

Note: Because the pixel intensity is relative to what is seen in the ROI, this does not necessarily mean that 0% = pure black or that 100% = pure white.

Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

Threshold Type: Edge Strength
Measures the rate of change of grayscale values and needs sharply-defined transitions to find edges.

Edge strength ignores gradual changes in light levels across the tool better than other threshold types and it filters out weak or gradual edges.

Edge Strength Threshold: Edge Strength
Enter an edge strength value from 1 to 255.
Edges are selected by the edge strength method, which measures the rate of change from bright to dark or dark to bright. Enter an edge strength threshold in the range from 1 to 255. The default value is 20. As this value is reduced, the tool finds weak, blurry, or more gradual edges.

Edge Polarity
Edge Polarity defines the type of edges that the tool finds.
- Dark to Bright—Finds edges where pixel intensities start below the threshold value and cross above the threshold value
- Bright to Dark—Finds edges where pixel intensities start above the threshold value and cross below the threshold value
• Bright or Dark—Finds any edge

**Edge Strength Threshold: Edge Profile Graph**

For edge strength threshold, the x axis is the length of the ROI. The y axis has two measurements. The first is the light blue axis. It represents Edge Strength, a measure of the rate of change of pixel grayscale values. The second is the dark gray axis. It represents Edge Profile, which gives the absolute grayscale level across the tool ROI. The blue line is the rate of change of the grayscale value along the ROI. The two horizontal gray lines are the edge strength threshold plus and minus.

Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

**Filters**

Set filters for tool analysis.

**Smoothing**

Runs a rolling average along the ROI length. Smoothing filters out sharp changes in the edge profile.

*Note:* A high filter number may miss the edge of a narrow line.

**Minimum Edge Width**

Filters out small spike-of-intensity changes, and narrow dark or bright bands. It determines the distance before and after an edge that must be free from additional transitions or the end of the ROI before the edge is recognized as valid.

*Note:* A high filter number may miss the edge of a narrow line.
Edge Profile

The Edge Profile graph changes depending on which threshold type is selected. Refer to the Threshold section and the specific threshold types for details on the Edge Profile graph.

Image Overlays

Choose whether to display or hide the annotations or the ROI when this tool is not selected.

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

**Hide Annotations**

Hides the annotations on the live image for the tool, even when the tool is selected.

**Hide ROI**

Hides the ROI when the tool is not selected.

Tool Histogram

The Tool Histogram graphically displays pixel intensity information within the current ROI.

Select the Tool Histogram checkbox to enable the histogram. The default is enabled. Expand the Tool Histogram parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.
Inspection Pass/Fail

Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

![Figure 172. Inspection Pass/Fail](image)

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

### 8.6.2 Edge Tool: Test Parameters

Use the **Test** parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable **Test** parameters. The historical data begins from the last reset.

![Figure 173. Edge Tool—Test Parameters](image)

#### Total Count
The total number of edges.

#### Dark to Bright Count
The total number of edges that start below the threshold value and cross above the threshold value.

#### Bright to Dark Count
The total number of edges that start above the threshold value and cross below the threshold value.

#### Maximum Edge Strength
The greatest rate of change value observed by the tool.
Available when the Threshold Type is set to Edge Strength.

### 8.6.3 Edge Tool: Results

**Tools & Results** and **All Results** list information from the current and previous inspections.

A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.

**All Results** displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

**Total Count**
The total number of edges.
Expand **Total Count** to see the location of each edge.
Click an edge number/location to highlight that edge in the **Image** pane.

**Dark to Bright Count**
The total number of edges that start below the threshold value and cross above the threshold value.
Expand **Dark to Bright Count** to see the location of each edge.

**Bright to Dark Count**
The total number of edges that start above the threshold value and cross below the threshold value.
Expand **Bright to Dark Count** to see the location of each edge.
**Maximum Edge Strength**

The greatest rate of change value observed by the tool.
Available when the Threshold Type is set to Edge Strength.

**Execution Time**

The execution time, in milliseconds, for the currently selected tool in the current inspection.
Expand **Execution Time** to see the historical minimum and maximum execution times up to this point for the selected tool.
Use the reset button in the Inspection Summary to reset these historical values.

**Status**

Status and error messages display as appropriate.

### 8.6.4 Using the Edge and Measure Tools

Follow these steps for an example Edge inspection to check the position of a plunger in a syringe.
This procedure uses two Edge tools and a Measure tool to determine the position of the plunger in the barrel.

![Note: This procedure is an example only.]

1. Add an Edge tool to the inspection.
2. Adjust the ROI position, length, and width.
   a) Position the ROI vertically over the top of the plunger.
   b) Expand ROI, then expand ROI Width.
   c) Set the ROI width to 161 px.

![Figure 174. ROI Over the Top of the Plunger](image)

3. Set the threshold.
   a) Expand the Threshold parameters.
   b) Set the Threshold Type to Edge Strength.
   c) Leave Edge Strength at the default (20).
   d) Select Bright to Dark from the Edge Polarity list.
   The tool finds the top of the plunger.
4. Add a second Edge tool.
5. Adjust the ROI position, length, and width.
   a) Position the ROI vertically over the top of the barrel.
   b) Expand ROI, then expand ROI Width.
   c) Set the ROI width to 97 px.
6. Set the threshold.
   a) Expand the **Threshold** parameters.
   b) Set the **Threshold Type** to **Edge Strength**.
   c) Expand **Edge Strength** and set it to 21.
   d) Select **Dark to Bright** from the **Edge Polarity** list.

   The tool finds the lower edge of the barrel.

7. Add a Measure tool.
   a) Expand **Measure From...** and select **Edge02** from the **Tool** list.
   b) Expand **Measure To...** and select **Edge01** from the **Tool** list.

8. Set the **Test** parameters to set the pass/fail criteria.
   a) On the **Test** tab, select the **Distance Y** checkbox to enable the test parameter.
   b) Move the sliders slightly above and below the green line to allow for very slight variations in the distance.

   **Note:** The green bar indicates the current distance and the light gray background indicates the distance over time.

9. Click to show all ROIs at the same time.

10. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.
8.7 Line Detect Tool

Use the Line Detect tool to find single, straight line segments.

The Line Detect tool finds many edge points along the transitions between bright and dark pixels and then fits a line to some or all of those points. It can measure the length of a straight edge and find damage or flaws along an edge. In conjunction with a Measure tool, it can help measure between a straight line and other points or lines in the image.

Example applications:
- Measure the height and width of a part
- Measure the height of a needle
- Measure the deflection of an automotive gauge
- Detect the edge of a web
- Verify that a bottle cap is on completely
- Find chips, spurs, or other flaws along a straight edge
- Measure the angle between two lines

8.7.1 Line Detect Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.

![Line Detect Tool—Input Parameters](image)
ROI

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

The ROI is a line of pixels that can be shortened, lengthened, or widened as needed for the inspection. Tool analysis follows the direction of the arrow. Set the width and the sample rate for the region of interest. The analysis functions best when the ROI is positioned perpendicular to the feature to be analyzed. The ROI automatically displays on the Image pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

ROI Width

An ROI can be as large as the entire Field of View (FOV). An ROI that captures as much of the line feature to be analyzed while minimizing other image content may improve consistency. Note that:

- Narrow ROIs execute faster but could miss the edge
- Wide ROIs are more consistent but don’t execute as fast
- A wide ROI provides an average value/location, which results in improved repeatability

Sample Rate

The sample rate sets the spacing between scan lines along the width of the ROI (one sample for every pixel, one sample every second pixel, etc.). When the sample rate includes more pixels, more edges, more precise results, and small flaws are found. The highest sample rate is Every Pixel. When the sample rate includes fewer pixels, fewer, more widely spaced edges are found. The lowest sample rate is Every 64th Pixel. This creates a trade-off between speed and precision. Lower sample rates execute faster, and higher sample rates find more precise results and are capable of detecting smaller flaws.

Threshold

Indicates the rate of change of grayscale values that is needed to detect an edge.

Edges are detected by measuring transitions from bright to dark or dark to bright. Enter a threshold in the range from 1 to 255. The default value is 20. As this value is reduced, the tool finds weak, blurry, or more gradual lines or edges. At lower thresholds, unwanted transitions such as background noise may become edges. Detected edges are combined to find potential line segments.
Edge Polarity

Edge Polarity defines the type of edges that the tool finds.

- Dark to Bright—Finds edges where pixel intensities start below the threshold value and cross above the threshold value
- Bright to Dark—Finds edges where pixel intensities start above the threshold value and cross below the threshold value
- Bright or Dark—Finds any edge

Search For

Set the type of points the Line Detect tool searches for.

Best Points

Automatically figures which edge points make the best line and ignores the rest. Points that are included are shown on the image in orange, while the points that are ignored are yellow. Best Points is tolerant of noise or extra edges in the ROI, but under some circumstances, it may ignore edges that should be included. If the line in the image has gaps in it, Best Points may produce lines that are shorter than desired.

All Points

Finds a line that explains all of the edges as well as possible; all found points are included in the analysis. Found points are shown on the image in orange. All Points is faster than Best Points, but works poorly if there are extra edges or noise within the ROI. All Points is useful if the line being examined is jagged, irregular, or curved.

Image Overlays

Choose whether to display or hide the ROI.

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

Hide Annotations

Hides the annotations on the live image for the tool, even when the tool is selected.

Hide ROI

Hides the ROI when the tool is not selected.

Tool Histogram

The Tool Histogram graphically displays pixel intensity information within the current ROI.

Select the Tool Histogram checkbox to enable the histogram. The default is enabled. Expand the Tool Histogram parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.
Inspection Pass/Fail

Select the Contribute to Inspection Pass/Fail check box (default) if the tool will influence the Pass/Fail status of the inspection.

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

8.7.2 Line Detect Tool: Test Parameters

Use the Test parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable Test parameters. The historical data begins from the last reset.

8.7.3 Line Detect Tool: Results

Tools & Results and All Results list information from the current and previous inspections.

A red box around a tool indicates that the tool failed. Status provides information about the specific failure.

All Results displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

Midpoint
- The x and y coordinates of the middle point of the found line segment.

Start Point
- The x and y coordinates of the start point of the found line segment. The start point is on the end of the line segment that is closer to the top of the ROI, when viewed in the direction of the arrows.

End Point
- The x and y coordinates of the end point of the found line segment.
Worst Distance Point
The x and y coordinates of the farthest included point for the found line.

Worst Distance
The distance from the line to the farthest included edge point.

Length
The distance from the start point of the line segment to the end point.

Angle
The angle between the x-axis and the found line. The range is \(-180^\circ\) to \(+180^\circ\).

Average Error
The average distance between the included edge points and the found line.

Execution Time
The execution time, in milliseconds, for the currently selected tool in the current inspection.
Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.
Use the reset button in the Inspection Summary to reset these historical values.

Status
Status and error messages display as appropriate.
Line detect may also show another status: "Edge data may not have given a conclusive line fit." It is not an error and will not directly cause the tool to fail. If this status displays and the desired line is not consistently found, adjust the tool so that fewer edges that are not part of the desired line are found. For example, adjust the ROI to remove any unnecessary area, raise the threshold value to find fewer edges, or use a specific edge polarity rather than the generic Bright Or Dark.

8.7.4 Using the Line Detect Tool
Follow these steps for a typical Line Detect inspection.

This example inspection checks whether a syringe needle is straight, bent, deformed, too short, or too long.

Note: This procedure is an example only.

1. Add a Line Detect tool to the inspection.
2. Adjust and rotate the ROI to frame the needle. The analysis functions best when the ROI is positioned perpendicular to the feature to be analyzed.
3. Set the threshold.
   a) Expand the Threshold parameters.
   b) Move the sliders until the edge of the needle is found with few extra points included.

![Figure 189. Good Part]

4. Set the edge polarity.
   a) Expand the Edge Polarity parameters.
   b) Select Bright to Dark because the needle is dark against a light background.
5. Set the Test parameters to set the pass/fail criteria.
   a) On the Test tab, select the Length checkbox to enable the test parameter.
      This option sets the minimum and maximum length so that a part passes.
b) Expand **Length** and move the sliders to set the acceptable length range.

c) Select the **Angle** checkbox to enable the test parameter.

This option sets the minimum and maximum angle of the part.

d) Move the slider or enter the angle range to ensure that only straight parts pass.

6. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

![Figure 190. Bad Part—Bent Needle](image1)
![Figure 191. Bad Part—Deformed Needle](image2)

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### 8.8 Locate Tool

Use the Locate tool to find the edge of a part and to compensate for translation and rotation (if selected).

This tool finds and marks the position of the first edge along the ROI line and aligns and positions related tools consistently over a feature of interest. When Rotation is enabled, the Locate tool calculates the angle at which the tool intersects the feature’s edge and rotates the Regions of Interest (ROIs) of downstream tools accordingly.

When a Locate tool is added to an inspection, the inspection fails and there is a red box around **Use as Reference**. This is because a reference point has not yet been set. Configure the Locate tool as desired, and then set the reference point.

Example application: Adjust inspection tools for a part that moves and/or rotates in the FOV.

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#### 8.8.1 Locate Tool: Input Parameters

Use the **Input** parameters to configure how the tool analyzes an image.

![Figure 192. Locate Tool—Input Parameters](image3)

Note that the **Use as Reference** parameter appears as an error until the reference point is set.
ROI

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

The ROI is a line of pixels that can be shortened, lengthened, or widened as needed for the inspection. Tool analysis follows the direction of the arrow. Set the width and the sample rate for the region of interest. The ROI automatically displays on the Image pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

ROI Width

An ROI can be as large as the entire Field of View (FOV).

Note that:

- Narrow ROIs execute faster but could miss the edge
- Wide ROIs are more consistent but don’t execute as fast
- A wide ROI provides an average value/location, which results in improved repeatability
- The ROI must be 13 pixels or wider to calculate the rotation of a part (Locate tool only)

Sample Rate

The sample rate sets the number of samples per pixels (one sample per pixel, two samples per pixel, etc.). The sample rate determines the sub-pixel resolution, which increases the resolution of the tool, and increases the inspection time.

Threshold

The Threshold parameter marks the grayscale transition point.

The tool marks the edge where the pixel intensity crosses the threshold level. From the Threshold Type list, select one of the following:

- Absolute
- Relative (default)
- Edge Strength

Threshold Type: Relative

Finds an edge at a relative pixel intensity. This is the default threshold setting.
The brightest grayscale level found along the ROI is 100% and the darkest is 0%. While Relative threshold is more tolerant of light fluctuations between inspections than other transition types, it may find false edges.

**Relative Threshold: Percent**
Choose the percentage value at which the edge should be marked.

**Edge Polarity**
Edge Polarity defines the type of edges that the tool finds.
- Dark to Bright—Finds edges where pixel intensities start below the threshold value and cross above the threshold value.
- Bright to Dark—Finds edges where pixel intensities start above the threshold value and cross below the threshold value.
- Bright or Dark—Finds any edge

**Relative Threshold: Edge Profile Graph**

![Relative Threshold Edge Profile Graph](image)

For relative threshold, the x axis is the length of the ROI. The y axis is the pixel intensity along the ROI, with 0% as the darkest pixel in the ROI and 100% as the lightest pixel in the ROI. The light blue line shows the percentage pixel intensity relative to the horizontal gray threshold line. The threshold line moves up or down with the percent value.

**Note:** Because the pixel intensity is relative to what is seen in the ROI, this does not necessarily mean that 0% = pure black or that 100% = pure white.

Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

**Threshold Type: Absolute**
Finds an edge at a specific grayscale level.

![Absolute Threshold Parameters](image)

While Absolute threshold is less likely to find a false edge than Relative threshold, it may miss edges if the light level changes between inspections.
**Absolute Threshold: Value**

Enter a specific grayscale value from 0 to 255.

**Edge Polarity**

Edge Polarity defines the type of edges that the tool finds.

- Dark to Bright—Finds edges where pixel intensities start below the threshold value and cross above the threshold value
- Bright to Dark—Finds edges where pixel intensities start above the threshold value and cross below the threshold value
- Bright or Dark—Finds any edge

**Absolute Threshold: Edge Profile Graph**

![Graph Image]

For absolute threshold, the x axis is the length of the ROI. The y axis is the actual grayscale value from 0 to 255. The light blue line shows the absolute pixel intensity. The horizontal gray threshold line moves up or down with the threshold value. Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

**Threshold Type: Edge Strength**

Measures the rate of change of grayscale values and needs sharply-defined transitions to find edges.

![Threshold Parameter Image]

Edge strength ignores gradual changes in light levels across the tool better than other threshold types and it filters out weak or gradual edges.

**Edge Strength Threshold: Edge Strength**

Enter an edge strength value from 1 to 255.

Edges are selected by the edge strength method, which measures the rate of change from bright to dark or dark to bright. Enter an edge strength threshold in the range from 1 to 255. The default value is 20. As this value is reduced, the tool finds weak, blurry, or more gradual edges.
**Edge Polarity**

Edge Polarity defines the type of edges that the tool finds.

- **Dark to Bright**—Finds edges where pixel intensities start below the threshold value and cross above the threshold value.
- **Bright to Dark**—Finds edges where pixel intensities start above the threshold value and cross below the threshold value.
- **Bright or Dark**—Finds any edge.

**Edge Strength Threshold: Edge Profile Graph**

For edge strength threshold, the x axis is the length of the ROI. The y axis has two measurements. The first is the light blue axis. It represents Edge Strength, a measure of the rate of change of pixel grayscale values. The second is the dark gray axis. It represents Edge Profile, which gives the absolute grayscale level across the tool ROI. The blue line is the rate of change of the grayscale value along the ROI. The two horizontal gray lines are the edge strength threshold plus and minus. Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

**Filters**

Set filters for tool analysis.

**Smoothing**

Runs a rolling average along the ROI length. Smoothing filters out sharp changes in the edge profile.

**Note:** A high filter number may miss the edge of a narrow line.
**Minimum Edge Width**
Filters out small spike-of-intensity changes, and narrow dark or bright bands. It determines the distance before and after an edge that must be free from additional transitions or the end of the ROI before the edge is recognized as valid.

*Note:* A high filter number may miss the edge of a narrow line.

**Enable Rotation**
Runs a rotation compensation calculation when enabled. ROIs that follow rotate according to the difference between the reference image and the current inspection image.

**Edge Profile**
The Edge Profile graph changes depending on which threshold type is selected. Refer to the Threshold section and the specific threshold types for details on the Edge Profile graph.

**Use as Reference**
Choose whether to use this tool as a reference for other tools.

**Adjust Downstream Tool ROIs**
Select **Adjust Downstream Tool ROIs** to have tools added after this tool use the this tool to set the location of the additional ROIs.

Click **Set Reference Point** button so that the tool affects the related tools, otherwise the tool and all related tools will fail. If changes are made to the tool parameters that affect the reference point, the reference point must be set again.

**Force to Absolute**
Select **Force to Absolute** to change this tool from relative positioning to absolute positioning.

When disabled, the tool ROI positions itself independent to any other locational tool preceding it in the inspection.

**Image Overlays**
Choose whether to display or hide the annotations or the ROI when this tool is **not** selected.

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.
Hide Annotations

Hides the annotations on the live image for the tool, even when the tool is selected.

Hide ROI

Hides the ROI when the tool is not selected.

Tool Histogram

The Tool Histogram graphically displays pixel intensity information within the current ROI.

Select the Tool Histogram checkbox to enable the histogram. The default is enabled. Expand the Tool Histogram parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.

Inspection Pass/Fail

Select the Contribute to Inspection Pass/Fail check box (default) if the tool will influence the Pass/Fail status of the inspection.

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

8.8.2 Locate Tool: Test Parameters

Use the Test parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable Test parameters. The historical data begins from the last reset.
8.8.3 Locate Tool: Results

**Tools & Results** and **All Results** list information from the current and previous inspections. A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.

**All Results** displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

- **Edge Point**
  - The x and y coordinates of the Edge Point; the first suitable edge the Locate tool found.

- **Edge Angle**
  - The angle with respect to horizontal at which the Locate tool intersects the part.

- **Offset**
  - The offset between the Edge Point and the reference point.
  - Expand **Offset** to see the coordinates of the Reference Point, the Reference Angle, the Offset Point, and the Offset Angle.

- **Maximum Edge Strength**
  - The greatest rate of change value observed by the tool.
  - Available when the Threshold Type is set to Edge Strength.

- **Execution Time**
  - The execution time, in milliseconds, for the currently selected tool in the current inspection.
  - Expand **Execution Time** to see the historical minimum and maximum execution times up to this point for the selected tool.
  - Use the reset button in the Inspection Summary to reset these historical values.
Status
Status and error messages display as appropriate.

8.8.4 Using the Locate Tool

Follow these steps for an example Locate inspection to adjust for a target that moves in the field of view, allowing for the precise placement of the vision tools that follow the Locate tool.

This procedure uses a Locate tool to determine the position of the vial. Using the vial position information, three Edge tools and two Measure tools determine the position of the stopper. The Locate tool is used to ensure that the Edge02 and Edge03 tools are placed correctly alongside (but not on top of) the vial, even if the vial targets move from side to side in the field of view from inspection to inspection. See Using the Edge and Measure Tools (p. 103) for details on how to set up an Edge tool and a Measure tool.

**Note:** This procedure is an example only.

1. Add a Locate tool to the inspection.
2. Adjust the ROI position, length, and width.
   a) Position the ROI horizontally across the side of the vial.
   b) Leave the ROI Width at the default (13 px).

   ![Figure 211. Locate ROI](image)

3. Find the edge that you want the tool to locate.
   a) Expand the **Edge Profile** parameters. Use the graph as a guide for the remaining steps.
      To make sure that you find the edge you want, observe how the Edge Profile graph changes as the Inputs change. Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image. The horizontal gray line is the Threshold percent.
   b) Expand the **Threshold** parameters.
   c) Select **Edge Strength** from the **Threshold Type** list.
   d) Select **Bright to Dark** from the **Edge Polarity** list.
   e) Adjust the **Edge Strength** until only the desired edge is found. In this example it is 20.
4. Expand **Filters** and set **Smoothing** to **Smooth3** to filter out sharp changes in the edge profile.
5. Set the reference point.
   a) Expand the **Use as Reference** parameters.
   b) Leave **Adjust Downstream Tool ROIs** checked so that it is enabled (default).
   c) Click **Set Reference Point**.

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A blue circle displays on the Image pane at the location of the reference point and all following tools use this point as a reference.

![Figure 212. Reference Point]

6. If the blue circle does not represent the desired reference point, repeat steps 3 to 5 and adjust the parameters until the desired reference point is found.

7. Add an Edge tool to detect the top of the stopper.

![Figure 213. Edge Tool at the Top of the Stopper]

8. Add an Edge tool to detect the bottom of the lip on the left side of the vial.

![Figure 214. Edge Tool at the Left Side of the Vial]

9. Add an Edge tool to detect the bottom of the lip on the right side of the vial.

![Figure 215. Edge Tool at the Right Side of the Vial]

10. Add a Measure tool to measure from Edge02 (the left side of the vial) to Edge03 (the right side of the vial).

![Figure 216. Measure Tool from Edge02 to Edge03]

11. Add a Measure tool to measure from Edge01 to Measure01 to determine the position of the stopper in the vial.
12. Adjust the Measure02 Test parameters to set the pass/fail criteria.
   a) On the Test tab, select the Distance Y checkbox to enable the test parameter.
   b) Move the sliders slightly above and below the green line to allow for very slight variations in the distance.

   **Note:** The green bar indicates the current distance and the light gray background indicates the distance over time.

13. Click ![Image](image1.png) to show all ROIs at the same time.

14. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

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8.9 Match Tool

Use the Match tool to verify that a pattern, shape, or part in any orientation matches a reference pattern. The Match tool can also compensate for translation and rotation of downstream tools (if selected).

The reference pattern is taught during setup. A reference pattern might include alphanumeric characters, logos, or any other shapes. During an inspection, the sensor checks that each part or package being inspected matches the reference pattern. The number of expected patterns can also be determined.

When a Match tool is added to an inspection, the inspection fails and there is a red box around **Pattern**. This is because a reference pattern has not yet been taught. Configure the Teach ROI as desired, and then teach the reference pattern.

Example applications:
- Date/Lot code inspections
- Label inspections
- Part etching inspections
• Part orientation inspections
• Part shape inspections

8.9.1 Match Tool: Input Parameters

Use the input parameters to configure how the tool analyzes an image.

![Match Tool—Input Parameters](image1)

Search ROI

The Search Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

![Search ROI](image2)

The Search ROI is indicated by a red or green box that is always rectangular. By default the Search ROI is 20% to 30% larger than the Teach ROI, which is blue. The sensor searches for the match only within the Search ROI.

Resize the Search ROI as needed for the inspection.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.
Teach ROI

The Teach Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor uses to teach a reference pattern.

![Teach ROI](image)

Resize and rotate the ROI around the feature to be used as the reference pattern. Change the shape of the ROI to a square, ellipse, or circle as needed by expanding Teach ROI on the Parameters pane and selecting the desired shape. The Teach ROI automatically displays on the Image pane when a Match tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.

Pattern

Displays the reference pattern that the sensor is looking for. A teach is required for the Match tool. Click Teach to set the match tool criteria and display the reference pattern.

![Teach Required](image) ![Pattern Taught](image)

A red error displays until the teach is performed and the reference pattern is taught. When new patterns are added, you will need to teach the reference pattern again.

Percent Match

Set the percent match to indicate the quality of the match (10% is a slight match; 100% is a perfect match). The default is 60%.

![Percent Match](image)
Rotation Range
Select the range within which the pattern may be rotated and still count as a match to the reference image. The default is 45 degrees.

The larger the Rotation Range, the longer the execution time of the tool. In general, this means that the execution time of the inspection increases.

Precision
Select either Fine Search or Coarse Search. Course Search is the default. Fine Search is slower but provides more accurate results.

Timeout
Set the amount of time the tool looks for the pattern before it stops.

Use as Reference
Choose whether to use this tool as a reference for other tools.

Adjust Downstream Tool ROIs
Select Adjust Downstream Tool ROIs to have tools added after this tool use the this tool to set the location of the additional ROIs.
Click Set Reference Point button so that the tool affects the related tools, otherwise the tool and all related tools will fail. If changes are made to the tool parameters that affect the reference point, the reference point must be set again.
**Force to Absolute**

Select **Force to Absolute** to change this tool from relative positioning to absolute positioning. When disabled, the tool ROI positions itself independent to any other locational tool preceding it in the inspection.

**Image Overlays**

Choose whether to display or hide the annotations or the ROI when this tool is not selected.

![Image Overlays—Default](image)

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

**Hide Annotations**

Hides the annotations on the live image for the tool, even when the tool is selected.

![Show Match Tool Annotations](image) ![Hide Match Tool Annotations](image)

**Hide ROI**

Hides the ROI when the tool is not selected.

**Tool Histogram**

The Tool Histogram graphically displays pixel intensity information within the current ROI.

![Example Histogram](image)

Select the **Tool Histogram** checkbox to enable the histogram. The default is enabled. Expand the **Tool Histogram** parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.
**Inspection Pass/Fail**

Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

![Figure 236. Inspection Pass/Fail](image)

The Pass/Fail contribution influences the following:

- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

**8.9.2 Match Tool: Test Parameters**

Use the **Test** parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable **Test** parameters. The historical data begins from the last reset.

![Figure 237. Match Tool—Test Parameters](image)

**Count**
- The number of matching patterns.

**Individual Matches**
- **Specific Match**—Select **First Match** or **Specific Match**.
  - Centroid X—The location of the point of the center of mass of the selected match on the x axis.
  - Centroid Y—The location of the point of the center of mass of the selected match on the y axis.
  - Angle—The rotated angle of the matching object.

**Offset Point X**
- The x-dimension offset between the current match and the reference point.
  - Available when **Adjust Downstream Tool ROIs** is enabled.

**Offset Point Y**
- The y-dimension offset between the current match and the reference point.
  - Available when **Adjust Downstream Tool ROIs** is enabled.

**Offset Angle**
- The angular difference between the current angle and the angle from the reference point.
  - Available when **Adjust Downstream Tool ROIs** is enabled.

**8.9.3 Match Tool: Results**

**Tools & Results** and **All Results** list information from the current and previous inspections.

A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.
All Results displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

**Count**
The number of matching patterns.

**Percentage Range**
The percentage by which the found objects match the reference object. Expand Percentage Range to view the centroid (center point), angle, and percent match for the objects found within the ROI.

**Offset**
The offset between the match and the reference point.
Available when Adjust Downstream Tool ROIs is enabled.
Expand Offset to see the coordinates of the Reference Point, the Reference Angle, the Offset Point, and the Offset Angle.

**Execution Time**
The execution time, in milliseconds, for the currently selected tool in the current inspection.
Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.
Use the reset button in the Inspection Summary to reset these historical values.

**Status**
Status and error messages display as appropriate.

## 8.9.4 Using the Match Tool

Follow these steps for an example Match inspection. The Match tool requires a reference pattern that is taught during set up.

The Match tool uses two ROIs. The larger, green/red ROI is the Search ROI and defines the area that the sensor searches for the desired feature. This ROI cannot be rotated and it is always a square. The smaller, blue ROI is the Teach ROI. This ROI is used to define the feature that the sensor is looking for.

Before using the Match tool, teach the desired feature (reference pattern). While setting up a Match tool, it can be helpful to slow the trigger rate or to set the trigger to external.

**Note:** If the trigger is set to internal, there is a lag between when the TEACH occurs and when Vision Manager uses the taught feature to inspect the part(s). The time to teach the sensor is not included in the inspection time on Tools & Results or All Results.

**Note:** This procedure is an example only.

1. Add a Match tool to the inspection.

The inspection fails and a warning displays until the reference pattern is taught.
2. Adjust the Teach ROI to frame the feature to be used as the reference pattern. In this example, the feature of interest is the Banner logo.
   a) Expand Teach ROI and select the ellipse.
   b) Resize and rotate the ROI around the feature.
3. On the Parameters pane, expand Pattern and click Teach.

![Figure 238. Match Tool Defaults](image1)

*Note: If the inspection uses more than one Match tool, teach only one Match tool at a time.*

*Applying Changes* displays, then the reference pattern displays in the Pattern pane, and Tools & Results and All Results display one match.

4. If necessary, repeat steps 2 and 3 to teach the feature again.
5. Adjust the Search ROI to fill the FOV.
6. Expand **Percent Match** and set it to 99. The found pattern must closely match the taught reference pattern.

7. Expand **Rotation Range** and set it to 90. The found pattern can rotate by 90 degrees and still pass.

   **Note:** Rotation Range and Percent Match work together. The higher the Percent Match, the lower the Rotation Range to pass. In this example a 99% match fails a missing letter but passes a match that is rotated 45 degrees.

8. On the **Test** tab, select the **Count** checkbox to enable the **Count** test parameter.

9. Expand **Count** and set it to a minimum of 1 and a maximum of 1. One and only one matching pattern must be found for the inspection to pass.

10. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

### 8.9.5 Using Remote TEACH with the Match Tool

If multiple Match tools are used in the same inspection, remote TEACH teaches all Match tools at the same time using the same trigger.

The time to teach is included in the inspection time on **Tools & Results** and **All Results**.

1. Set up the inspection and Match tool(s) as desired.
2. In Vision Manager, make sure that one of the five user-defined I/O is set to **Remote Teach**.
3. Toggle the Remote Teach input. The next valid trigger input causes the Remote Teach to occur. This is when the new Match patterns are learned.
8.10  **Object Tool**

Use the Object tool to detect and measure the length of dark and bright segments in an ROI.

The Object tool measures the widths of every dark and light segment along the ROI, calculates the midpoint for every segment, and counts the total number of segments. The midpoint location can be used as an input to the Measure tool. Each segment can have a unique size limit, or all segments may have the same size limit.

Example applications:
- Measure the width of a label
- Locate the center of a box on a conveyor
- Measure the gaps between stamped metal parts

8.10.1 Object Tool: Input Parameters

Use the **Input** parameters to configure how the tool analyzes an image.

![Object Tool—Input Parameters](image)

**ROI**

The Region of Interest (ROI) is the user-defined group of pixels in the image that the sensor analyzes.

![ROI Parameters](image)

The ROI is a line of pixels that can be shortened, lengthened, or widened as needed for the inspection. Tool analysis follows the direction of the arrow. Set the width and the sample rate for the region of interest. The ROI automatically displays on the Image pane when a tool is added.

Adjust the placement of the ROI more precisely by using the arrow keys on the computer keyboard.
ROI Width
An ROI can be as large as the entire Field of View (FOV).

Note that:
- Narrow ROIs execute faster but could miss the edge
- Wide ROIs are more consistent but don’t execute as fast
- A wide ROI provides an average value/location, which results in improved repeatability
- The ROI must be 13 pixels or wider to calculate the rotation of a part (Locate tool only)

Sample Rate
The sample rate sets the number of samples per pixels (one sample per pixel, two samples per pixel, etc.). The sample rate determines the sub-pixel resolution, which increases the resolution of the tool, and increases the inspection time.

![Figure 246. 1 px Wide ROI](image)
![Figure 247. 13 px Wide ROI](image)

Threshold
The Threshold parameter marks the grayscale transition point.
The tool marks the edge where the pixel intensity crosses the threshold level. From the Threshold Type list, select one of the following:
- Absolute
- Relative (default)
- Edge Strength

Threshold Type: Relative
Finds an edge at a relative pixel intensity. This is the default threshold setting.

![Figure 248. Relative Threshold Parameters](image)
The brightest grayscale level found along the ROI is 100% and the darkest is 0%. While Relative threshold is more tolerant of light fluctuations between inspections than other transition types, it may find false edges.

Relative Threshold: Percent
Choose the percentage value at which the edge should be marked.

Object Type
Select the type of object the inspection is looking for.
- **Bright**—Finds objects brighter than the threshold value
- **Dark**—Finds objects darker than the threshold value
- **Bright or Dark**—Finds any object
**Relative Threshold: Edge Profile Graph**

For relative threshold, the x axis is the length of the ROI. The y axis is the pixel intensity along the ROI, with 0% as the darkest pixel in the ROI and 100% as the lightest pixel in the ROI. The light blue line shows the percentage pixel intensity relative to the horizontal gray threshold line. The threshold line moves up or down with the percent value.

**Note:** Because the pixel intensity is relative to what is seen in the ROI, this does not necessarily mean that 0% = pure black or that 100% = pure white.

Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

**Threshold Type: Absolute**

Finds an edge at a specific grayscale level.

While Absolute threshold is less likely to find a false edge than Relative threshold, it may miss edges if the light level changes between inspections.

**Absolute Threshold: Value**

Enter a specific grayscale value from 0 to 255.

**Object Type**

Select the type of object the inspection is looking for.

- **Bright**—Finds objects brighter than the threshold value
- **Dark**—Finds objects darker than the threshold value
- **Bright or Dark**—Finds any object
Absolute Threshold: Edge Profile Graph

For absolute threshold, the x axis is the length of the ROI. The y axis is the actual grayscale value from 0 to 255. The light blue line shows the absolute pixel intensity. The horizontal gray threshold line moves up or down with the threshold value. Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

Threshold Type: Edge Strength

Measures the rate of change of grayscale values and needs sharply-defined transitions to find edges.

Edge strength ignores gradual changes in light levels across the tool better than other threshold types and it filters out weak or gradual edges.

Edge Strength Threshold: Edge Strength

Enter an edge strength value from 1 to 255.

Edges are selected by the edge strength method, which measures the rate of change from bright to dark or dark to bright. Enter an edge strength threshold in the range from 1 to 255. The default value is 20. As this value is reduced, the tool finds weak, blurry, or more gradual edges.

Object Type

Select the type of object the inspection is looking for.

- **Bright**—Finds objects brighter than the threshold value
- **Dark**—Finds objects darker than the threshold value
- **Bright or Dark**—Finds any object
For edge strength threshold, the x axis is the length of the ROI. The y axis has two measurements. The first is the light blue axis. It represents Edge Strength, a measure of the rate of change of pixel grayscale values. The second is the dark gray axis. It represents Edge Profile, which gives the absolute grayscale level across the tool ROI. The blue line is the rate of change of the grayscale value along the ROI. The two horizontal gray lines are the edge strength threshold plus and minus. Point to a location on the graph—the corresponding location is the yellow line on the tool ROI displayed on the image.

Filters
Set filters for tool analysis.

- **Smoothing**
  Runs a rolling average along the ROI length. Smoothing filters out sharp changes in the edge profile.

- **Object Width**
  Filters out objects and spaces that are smaller than the minimum and larger than the maximum values specified.

- **Enable End Objects**
  When enabled, pixels that touch the ends of the ROI are ignored. This may ignore one or more objects.
Edge Profile

The Edge Profile graph changes depending on which threshold type is selected. Refer to the Threshold section and the specific threshold types for details on the Edge Profile graph.

Image Overlays

Choose whether to display or hide the annotations or the ROI when this tool is not selected.

These options override the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.

Hide Annotations

Hides the annotations on the live image for the tool, even when the tool is selected.

Hide ROI

Hides the ROI when the tool is not selected.

Tool Histogram

The Tool Histogram graphically displays pixel intensity information within the current ROI.

Select the Tool Histogram checkbox to enable the histogram. The default is enabled. Expand the Tool Histogram parameter to view the histogram.

The histogram is a display of the grayscale values on the x axis and the number of pixels on the y axis. The histogram displays the amount of pixels for each grayscale value. The graph displays information for all grayscale values (0 to 255). Move the pointer anywhere over the histogram to view specific information. The information updates as the position of the pointer changes.
Inspection Pass/Fail

Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

![Figure 259. Inspection Pass/Fail](image)

The Pass/Fail contribution influences the following:

- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

### 8.10.2 Object Tool: Test Parameters

Use the **Test** parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable **Test** parameters. The historical data begins from the last reset.

![Figure 260. Object Tool—Test Parameters](image)

- **Total Count**
  - The total number of bright, dark, or all objects, depending on the bright/dark option in effect.
- **Dark Count**
  - The number of dark objects.
- **Bright Count**
  - The number of bright objects.
- **Maximum Edge Strength**
  - The greatest rate of change value observed by the tool.
  - Available when the Threshold Type is set to Edge Strength.
- **Individual Objects**
  - **Object(s) to test**—Select All Objects, First Object, or Specific Object.
  - **Dark Widths**—Select the range of dark widths to count.
  - **Bright Widths**—Select the range of bright widths to count.

### 8.10.3 Object Tool: Results

**Tools & Results** and **All Results** list information from the current and previous inspections.

A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.

**All Results** displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

- **Total Count**
  - The total number of bright, dark, or all objects, depending on the bright/dark option in effect.
- **Dark Count**
  - The number of dark objects.
**Bright Count**

The number of bright objects.

**Widths**

Expand **Widths** to view the widths and location of the objects found, sorted by order of occurrence along the **Object** tool path.

Click a number/width/location to highlight that width on the **Image** pane.

**Maximum Edge Strength**

The greatest rate of change value observed by the tool.

Available when the Threshold Type is set to Edge Strength.

**Execution Time**

The execution time, in milliseconds, for the currently selected tool in the current inspection.

Expand **Execution Time** to see the historical minimum and maximum execution times up to this point for the selected tool.

Use the reset button in the Inspection Summary to reset these historical values.

**Status**

Status and error messages display as appropriate.

### 8.10.4 Using the Object Tool

Follow these steps for an example Object inspection.

This example verifies the number and position of pins on a connector by analyzing the size of the two gaps between the pins.

> **Note:** This procedure is an example only.

1. Add an Object tool to the inspection.
2. Adjust the position, length, and width of the ROI.
   a) Move the ROI so that it crosses all of the pins.
   b) Leave the default ROI width (13 px).

![Figure 261. Object Tool](image)

3. Set the threshold.
   a) Expand the **Threshold** parameters.
   b) Leave the **Threshold Type** as the default (Relative).
   c) Leave the **Percent** as the default (50).
   d) Select **Dark** from the **Object Type** list.
4. Set the **Test** parameters to set the pass/fail criteria.
   a) Expand **Individual Objects**.
   b) Select the **All Dark Width Range** checkbox to enable the parameter.
   c) Move the sliders or enter the minimum as 141.48 and the maximum as 252.96.
5. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.
9 Using the Inspection Tools: Analysis Tools

Analysis tools include Math, Measure, and Logic.

Click a tool on Tools & Results or Tools Only to access the Parameters pane for that tool.

9.1 Math Tool

Use the Math tool to perform basic arithmetic and inequality expressions, and to calculate statistical information for inspections.

The Math tool takes one or more pieces of information from the tool data or from user-supplied constants and makes mathematical expressions out of them. The results of the Math tool’s analysis are displayed in Tools & Results and All Results.

The inputs to the Math tool are called operands. The operation is the mathematical expression used on the operands.

In general, a user-defined constant can be selected as one of the operands for the Math tool. This allows for a number of things, including scaling the output of a vision tool in real units (by dividing that output by a known conversion factor). Dynamic scaling of outputs is also possible by dividing one operand by another and then multiplying by a constant conversion factor. In this case, two Math tools would be used: one set for division, the other for multiplication. The output of the first Math tool would be an operand for the second Math tool.

Example application: Add advanced logic to an inspection using arithmetic or inequality expressions.

9.1.1 Math Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.

Operator

Select the type of mathematical expression used for the inspection operator.

<table>
<thead>
<tr>
<th>Operator</th>
<th>Summary</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>ABS (A)</td>
<td>ABS(1) = 1</td>
<td>The absolute value of an operand is its unsigned magnitude. For example, ABS(-1.5) and ABS(1.5) both return 1.5</td>
</tr>
</tbody>
</table>
**SQRT (A)**  
SQRT(1) = 1  
The square root of the operand

<table>
<thead>
<tr>
<th>Operator</th>
<th>Summary</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>A + B</td>
<td>1 + 1 = 2</td>
<td>Add</td>
</tr>
<tr>
<td>A - B</td>
<td>1 - 1 = 0</td>
<td>Subtract</td>
</tr>
<tr>
<td>A * B</td>
<td>1 × 1 = 1</td>
<td>Multiply</td>
</tr>
<tr>
<td>A / B</td>
<td>1 ÷ 1 = 1</td>
<td>Divide</td>
</tr>
<tr>
<td>MOD (A, B)</td>
<td>1 % 1 = 0</td>
<td>Modulus; the modulus, or remainder, operator divides operand A by operand B and returns the remainder</td>
</tr>
<tr>
<td>Div (A, B)</td>
<td>1 ÷ 1 = 1</td>
<td>Integer division; returns the integer part of division, and the remainder is discarded</td>
</tr>
<tr>
<td>ABS (A - B)</td>
<td></td>
<td>Returns the absolute value of operand A – B</td>
</tr>
<tr>
<td>A &gt; B</td>
<td>1 &gt; 1 = false</td>
<td>Greater than; returns True, else False</td>
</tr>
<tr>
<td>A ≥ B</td>
<td>1 ≥ 1 = true</td>
<td>Greater than or equal to; returns True, else False</td>
</tr>
<tr>
<td>A = B</td>
<td>1 = 1 = true</td>
<td>Equal to; returns True, else False</td>
</tr>
<tr>
<td>A &lt; B</td>
<td>1 &lt; 1 = false</td>
<td>Less than; returns True, else False</td>
</tr>
<tr>
<td>A ≤ B</td>
<td>1 ≤ 1 = true</td>
<td>Less than or equal to; returns True, else False</td>
</tr>
</tbody>
</table>

If the output of a relational operation is used as an input for another Math Tool, True is interpreted as 1 and False is interpreted as 0.

**Table 4: Array Operand Operations**  
Array Operations allow the user to make a long list of input data. All of these pieces of information are inputs to the selected operator. For example, select MIN(A) as the operator, and select an input tool.

<table>
<thead>
<tr>
<th>Operator</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>MIN(A)</td>
<td>Minimum—Returns the operand with the lowest value</td>
</tr>
<tr>
<td>MAX(A)</td>
<td>Maximum—Returns the operand with the highest value</td>
</tr>
<tr>
<td>MEAN(A)</td>
<td>Returns the mean value of the operands</td>
</tr>
<tr>
<td>MEDIAN(A)</td>
<td>The statistical median is the middle number of a group of numbers that have been arranged in order by size. If there is an even number of terms, the median is the mean of the two middle numbers.</td>
</tr>
<tr>
<td>COUNT(A)</td>
<td>Returns the count of the operands</td>
</tr>
<tr>
<td>SUM(A)</td>
<td>Returns the arithmetic sum of the operands</td>
</tr>
<tr>
<td>VAR(A)</td>
<td>Variance—A measure of how spread out the operands values are</td>
</tr>
<tr>
<td>STDDEV(A)</td>
<td>Standard Deviation—A measure of how spread out the operands values are</td>
</tr>
</tbody>
</table>
Operand A
Choose the first variable from the vision tools in the inspection, or select a user-defined constant value.

Operand B
Choose the second variable from the vision tools in the inspection, or select a user-defined constant value.

Inspection Pass/Fail
Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.
9.1.2 Math Tool: Test Parameters

Use the Test parameters to configure the pass/fail conditions for the tool. Select the parameter checkbox to enable it.

**Integer**
- The integer value range of the Math tool operation.

**Decimal**
- The decimal value range of the Math tool operation.

**Boolean**
- The Boolean result for the Math tool operation.

![Figure 269. Math Tool—Test Parameters](image)

9.1.3 Math Tool: Results

**Tools & Results** and **All Results** list information from the current and previous inspections. A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.

**All Results** displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

- **Integer Result**
  - The integer value result of the Math tool operation.

- **Decimal Result**
  - The decimal result of the Math tool operation.

- **Boolean**
  - The Boolean result for the Math tool operation.

- **Execution Time**
  - The execution time, in milliseconds, for the currently selected tool in the current inspection.
  - Expand **Execution Time** to see the historical minimum and maximum execution times up to this point for the selected tool.
  - Use the reset button in the Inspection Summary to reset these historical values.

- **Status**
  - Status and error messages display as appropriate.

9.1.4 Using the Math Tool

Follow these steps for an example Math inspection.

This example uses two Edge tools and a Math tool to determine whether the number of edges found by Edge01 is greater than the number of edges found by Edge02. See Using the Edge and Measure Tools (p. 103) for more information on using the Edge tool.

- **Note:** This procedure is an example only.

1. Add an Edge tool to the inspection.
2. Move the Edge01 ROI over the shapes in the image.

![Figure 270. Edge01 ROI](image)

3. Add a second Edge tool to the inspection.
4. Move the Edge02 ROI over the black area of the image.

![Figure 271. Edge02 ROI](image)

5. Add a Math tool to the inspection.
6. Expand **Operator** and choose a mathematical function to perform. For this example, select **A > B**.
7. Expand **Operand A** and select **Edge01**. This is the first variable or constant for the mathematical expression.
8. Expand **Operand B** and select **Edge02**. This is the second variable or constant for the mathematical expression.
9. Set the Test parameters to set the pass/fail criteria.
    a) On the **Test** tab, select the **Boolean** checkbox.
       This option sets whether the mathematical expression is true or false so that the part passes.
    b) Select **True**.
       Edge01 must find more edges than Edge02 for a part to pass.
10. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.

![Figure 272. Edge02 ROI](image)  ![Figure 273. Edge02 ROI](image)

9.2 **Measure Tool**

Use the Measure tool to determine distances, calculate angles, and create points and lines for use as inputs to other Measure tools.

The Measure tool operations are:
Measure from a point to a point
Determine the intersection between two lines
Measure from a line to a point

The points used in these operations are generated by a variety of vision tools and the lines are created by other Measure tools.

Example applications:
- Determine the distance between blobs
- Measure the width of a label
- Determine if two edges are parallel to each other

9.2.1 Measure Tool: Operations

Measure from a Point to a Point

In this operation, the distance between two points is calculated. In addition, the x and y components of that distance calculation are returned.

Along with distance, the following results are generated in this operation:
- A line from point 1 to point 2
- The angle of that line (relative to the x-axis)
- The midpoint location halfway between point 1 and point 2

How the Tool Measures Two Points

The inputs to the Measure tool for measuring two points are any two points that vision tools generate. The results include the total distance between the points and the x and y component distances. In addition to finding these distance values, the Measure tool also calculates the line between the two endpoints. The angle between this line and the camera’s horizontal plane, as well as the coordinates for the line’s midpoint, are also provided.

For example, a Measure01 measurement between the two points Edge01 and Edge02 appears as a dashed line. The actual measured distance between the points is a solid green line labeled Measure01 and an arrowhead indicates the direction of the measurement operation (from Edge01 to Edge02, in this case). A blue circle is the midpoint. Two shorter dashed lines represent the x and y components. The angle between Measure01 and the horizontal plane is a curved arrow. The results show the angle in degrees.

See Using the Edge and Measure Tools (p. 103) for a Measure tool example.

Intersect Two Lines

In this operation, the results of the intersection of two lines is generated. These results are:
- The angle of intersection between the two lines, measure from line 1 to line 2
- The intersection point, even if this point is not in the image

How the Tool Measures Two Lines

This mode finds the angle between two lines. Both inputs are the line outputs from existing Measure tools. The order in which these tools are input matters.

The intersection point can be off of the screen. This angle provides the ability to measure two lines for parallelism.

For example, if you have two inputs that are both existing Measure tools, Measure01 and Measure02, the output, called Measure03, is the angle between the lines of each of the inputs. Measure03 is a curved arrow from the first input, Measure01, towards the arrowhead of the second input, Measure02. The results show this angle in degrees. The intersection point of the two best fit lines is also provided in the results and is shown by the blue circle in the image pane.

See Using the Edge and Measure Tools (p. 103) for a Measure tool example.

Measure from a Line to a Point

In this operation, the software calculates the distance between a line and a point. This is the shortest distance from the line to the point, and is generated by creating a line perpendicular to the original line that intersects the point. In addition, it returns the distance calculations for the X and Y component.

Additionally, the following results are generated in this operation:
- The perpendicular line, which goes from the line to the point
- The angle of that line (relative to the x-axis)
• The intersection point between the original line and the perpendicular line

How the Tool Measures a Line and a Point

This mode finds the shortest distance between a point and a line.

The two inputs to the Measure tool are:
• Any point a vision tool generates
• Any line another measure tool generates

The shortest distance between a line and a point may lie along another line. This new line may be perpendicular to the original line.

For example, the center point of a blob, Blob01, and the nearest point in the input line Measure01 define a dashed line. The actual measured distance between Blob01 and Measure01 is labeled Measure02. A blue circle shows where Measure01 and Measure02 intersect. The results show the distance between the intersection point and the blob midpoint in pixels. Two shorter dashed lines represent the x and y components. The angle between Measure02 and the horizontal plane is a curved arrow. The results show this angle in degrees.

See Using the Edge and Measure Tools (p. 103) for a Measure tool example.

9.2.2 Measure Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.

Measure from...

Select either a constant or another tool where the Measure tool will start measuring from.

If selecting a constant, enter the x and y coordinates to begin the measurement from. The coordinates are entered in pixels, however if Units is enabled, the value entered in pixels is converted to units for the calculation.

If selecting a specific tool, select the specific characteristic in the tool to measure from.
Measure to...

Select either a constant or another tool where the Measure tool will stop measuring.

If selecting a constant, enter in the x and y coordinates to end the measurement at. The coordinates are entered in pixels, however if Units is enabled, the value entered in pixels is converted to units for the calculation.

If selecting a specific tool, select the specific characteristic in the tool to measure to.

Characteristics

Set additional parameters for the inspection.

**Preserve Sign**

When **Preserve Sign** is selected, the x and y distances are computed as distance offsets. These distance offsets are represented by signed numbers. Negative numbers indicate that the distance offset is toward the origin (0,0). Positive numbers indicate that the distance offset is away from the origin.

**Force to Absolute**

Select **Force to Absolute** to change the tool from calculating the x and y components of the measurement from relative positioning to absolute positioning. When disabled, the tool ROI positions itself independent to any other reference tool preceding it in the inspection.

Image Overlays

Choose whether to display or hide the annotations when this tool is not selected.

This option overrides the ROI view buttons on the Image Pane Parameters when no tool is selected. When a specific tool is selected, the ROI information is shown.
Inspection Pass/Fail

Select the Contribute to Inspection Pass/Fail check box (default) if the tool will influence the Pass/Fail status of the inspection.

The Pass/Fail contribution influences the following:
- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

9.2.3 Measure Tool: Test Parameters

Use the Test parameters to configure the pass/fail conditions for the tool.

Select the parameter checkbox to enable it. Where applicable, the vertical green bar shows the current parameter information and the light gray backgrounds show the range over which a value has varied over time.

Where applicable, use the sliders or enter the minimum and maximum for the selected test parameters.

The current data found and the range of historical data found are shown for applicable Test parameters. The historical data begins from the last reset.

Distance
The straight-line distance between two constants or tools.

Distance X
The x dimension vector component of the straight line distance.

Distance Y
The y dimension vector component of the straight line distance.

Angle
The angle with respect to the x axis, along which the straight line measurement vector lies. If the tool is measuring from one Line tool to another Line tool, the Angle is the measurement of the angle formed by the two lines. If the Force to Absolute parameter is selected, the angle is calculated relative to the reference tool that precedes the Measure tool.

9.2.4 Measure Tool: Results

Tools & Results and All Results list information from the current and previous inspections.

A red box around a tool indicates that the tool failed. Status provides information about the specific failure.

All Results displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

Distance
The straight-line distance between two constants or tools.

Distance X
The x dimension vector component of the straight line distance.

Distance Y
The y dimension vector component of the straight line distance.
Angle
The angle with respect to the x axis, along which the straight line measurement vector lies. If the tool is measuring from one Line tool to another Line tool, the Angle is the measurement of the angle formed by the two lines. If the Force to Absolute parameter is selected, the angle is calculated relative to the reference tool that precedes the Measure tool.

Mid Point
The x and y coordinates of the middle point between the two selected points.
Mid Point is calculated for point to point measurements only.

Projection Point
The x and y coordinates of the intersection point between the input line and a virtual line passing through the input point. The virtual line is orthogonal (perpendicular) to the input line. The intersection point is on the input line because the other line does not exist (virtual).
Projection Point is calculated for line to point measurements only.

Intersection Point
The x and y coordinates of the intersection point of two non-coincident input lines.
Intersection Point is calculated for line to line measurements only.

Execution Time
The execution time, in milliseconds, for the currently selected tool in the current inspection.
Expand Execution Time to see the historical minimum and maximum execution times up to this point for the selected tool.
Use the reset button in the Inspection Summary to reset these historical values.

Status
Status and error messages display as appropriate.

9.2.5 Using the Edge and Measure Tools
Follow these steps for an example Edge inspection to check the position of a plunger in a syringe.
This procedure uses two Edge tools and a Measure tool to determine the position of the plunger in the barrel.

Note: This procedure is an example only.

1. Add an Edge tool to the inspection.
2. Adjust the ROI position, length, and width.
   a) Position the ROI vertically over the top of the plunger.
   b) Expand ROI, then expand ROI Width.
   c) Set the ROI width to 161 px.

3. Set the threshold.
   a) Expand the Threshold parameters.
   b) Set the Threshold Type to Edge Strength.
   c) Leave Edge Strength at the default (20).
   d) Select Bright to Dark from the Edge Polarity list.
   The tool finds the top of the plunger.
4. Add a second Edge tool.
5. Adjust the ROI position, length, and width.
   a) Position the ROI vertically over the top of the barrel.
   b) Expand ROI, then expand ROI Width.
   c) Set the ROI width to 97 px.

6. Set the threshold.
   a) Expand the Threshold parameters.
   b) Set the Threshold Type to Edge Strength.
   c) Expand Edge Strength and set it to 21.
   d) Select Dark to Bright from the Edge Polarity list.
      The tool finds the lower edge of the barrel.

7. Add a Measure tool.
   a) Expand Measure From... and select Edge02 from the Tool list.
   b) Expand Measure To... and select Edge01 from the Tool list.

8. Set the Test parameters to set the pass/fail criteria.
   a) On the Test tab, select the Distance Y checkbox to enable the test parameter.
   b) Move the sliders slightly above and below the green line to allow for very slight variations in the distance.

   Note: The green bar indicates the current distance and the light gray background indicates the distance over time.

9. Click to show all ROIs at the same time.

10. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.
9.3 Logic Tool

Use the Logic tool to combine or convert tool results, or to drive discrete outputs from tool results.

The Logic tool uses Boolean logic to combine or convert tool results. The logic output can be used to pass or fail the inspection or to drive a discrete output. The results of the Logic tool’s analysis are displayed in Tools & Results and All Results.

The inputs to the Logic tool are called operands. The camera tool, vision tools, or analysis tools can be operands if they are added to the current inspection. The operation is the logical expression used on the operands. AND, OR, and XOR logic are available.

AND
A true output results if all inputs are true.

OR
A true output results if one or more of the inputs are true.

XOR
A true output results if one, and only one, of the inputs is true.

Example uses:
• Gather results from the camera tool, vision tools, or analysis tools
• Establish parameters for desired inspection results
• Tie multiple results together with logic options
• Include results in the overall Pass/Fail criteria
• Activate a discrete output based on the inspection results
• Part sorting applications

9.3.1 Logic Tool: Input Parameters

Use the Input parameters to configure how the tool analyzes an image.
Operator

Select the type of logical expression used for the Logic tool operator.

![Operator](image)

<table>
<thead>
<tr>
<th>Operator</th>
<th>Summary/Examples</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>AND (All)</td>
<td>AND(True, True, True)=True AND(False, False, True)=False</td>
<td>A true output results if all inputs are true.</td>
</tr>
<tr>
<td>OR (Any)</td>
<td>OR(True, True, True)=True OR(True, False, False)=False</td>
<td>A true output results if one or more of the inputs are true.</td>
</tr>
<tr>
<td>XOR (Only one)</td>
<td>XOR(True, True, True)=False XOR(False, False, False)=False</td>
<td>A true output results if one, and only one, of the inputs is true.</td>
</tr>
</tbody>
</table>

Operands

Choose the variables from the tools found in the inspection. The current tool result displays in the Result column.

![Operands](image)

The desired operands must be listed before the Logic tool in the Tools and Results pane so that they can be used by the Logic tool. Each operand must have its test criteria enabled for the Logic tool to use it.

Discrete Output

Select whether the Logic tool activates one of the five programmable I/O and what the active condition is.

![Discrete Output](image)

**I/O #**

Select the desired **General Output** I/O number.

To select and use I/O 1-5 in the Logic tool Discrete Output parameter, at least one I/O must be configured as General Output in the system settings. Click **System Settings > Discrete I/O** and select **General Output** from the **Function** list for the desired I/O.

**Active Condition**

Select when the output is active—either when the result is True or when the result is False. Available when an I/O # is selected.
**Inspection Pass/Fail**

Select the **Contribute to Inspection Pass/Fail** check box (default) if the tool will influence the Pass/Fail status of the inspection.

![Figure 293. Inspection Pass/Fail](image)

The Pass/Fail contribution influences the following:

- Discrete output Pass
- Discrete output Fail
- Pass/Fail results counter
- Pass (Green) and Fail (red) LEDs on the Sensor

Select this checkbox if the overall Pass/Fail status of the inspection is dependent on the current tool.

**9.3.2 Logic Tool: Test Parameters**

Use the **Test** parameters to configure the pass/fail conditions for the tool. Select the parameter checkbox to enable it.

![Figure 294. Logic Tool—Test Parameters](image)

**Logic Output**

The Boolean result for the Logic tool operation.

**9.3.3 Logic Tool: Results**

**Tools & Results** and **All Results** list information from the current and previous inspections. A red box around a tool indicates that the tool failed. **Status** provides information about the specific failure.

**All Results** displays the Result, Time, Pass Count, and Fail Count information at a glance. Expand the inspection tool to see specific results for that tool.

- **Logic Output**
  
  The Boolean result for the Logic tool operation.

- **Execution Time**
  
  The execution time, in milliseconds, for the currently selected tool in the current inspection.

  Expand **Execution Time** to see the historical minimum and maximum execution times up to this point for the selected tool.

  Use the reset button in the Inspection Summary to reset these historical values.

- **Status**
  
  Status and error messages display as appropriate.

**9.3.4 Using the Logic Tool**

Follow these steps for an example inspection that uses the Logic tool.

This example uses two Match tools and two Logic tools. The Match tools are taught independently. Each Match tool determines the presence or absence of a different logo on different size boxes. The first Logic tool passes the inspection if either Match tool finds its respective logo. The second Logic tool turns on an output if a specific logo is found. This output could be used to turn on a light or to send the box to a different line. See **Using the Match Tool** (p. 126) for more information on using the Match tool.
1. Add a Match tool to the inspection.
   a) Configure Match01 to recognize the logo on the small box.
   b) Expand Inspection Pass/Fail and remove the checkmark to disable the parameter.
   c) On the Test tab, select the Count checkbox to enable the Count test parameter.
   d) Expand Count and set it to a minimum of 1 and a maximum of 1.

   ![Figure 295. Match01](image)

2. Add a second Match tool.
   a) Configure Match02 to recognize the logo on the large box.
   b) Expand Inspection Pass/Fail and remove the checkmark to disable the parameter.
   c) On the Test tab, select the Count checkbox to enable the Count test parameter.
   d) Expand Count and set it to a minimum of 1 and a maximum of 1.

   ![Figure 296. Match02](image)

3. Add a Logic tool.
4. Expand Operator and choose the logical expression to perform. For this example, choose OR (Any).
5. Expand Operands and select the tools to include in the analysis.
   a) Remove the checkmark from Camera01 to exclude it.
   b) Select the Match01 and Match02 checkboxes to include them.
6. Leave Inspection Pass/Fail selected (default).
7. Set the Test parameters to set the pass/fail criteria.
   a) On the Test tab, select the Logic Output checkbox.
      This option sets whether the Boolean logic is true or false so that the part passes.
   b) Select True.
   If any box has a logo, the Logic tool and inspection pass.
8. Add a second Logic tool to the inspection.
9. Expand Operator and choose the logical expression to perform. For this example, choose AND (Any).
10. Expand Operands and select the tools to include in the analysis.
   a) Remove the checkmark from Camera01 to exclude it.
   b) Select the Match01 checkbox to include it.
11. Set the Discrete I/O.
   a) Click System Settings > Discrete I/O.
   b) Select General Output as the Function for one I/O. This example uses I/O 5.
12. Set the Discrete Output parameter for the Logic tool.
   a) Expand Discrete Output.
   b) Select the desired I/O from the I/O # list. In this example, select 5. General Output.
   c) Leave the Active Condition as Active when True (default).
13. Expand Inspection Pass/Fail and remove the checkmark to disable the parameter.
14. Set the Test parameters to set the pass/fail criteria.
   a) On the Test tab, select the Logic Output checkbox.
      This option sets whether the Boolean logic is true or false so that the part passes.
b) Select **True**.
The small box must have the logo to create the general output.

15. Expand the I/O Summary so that you can see the results.

![Figure 297. I/O Summary—Small Box Passes with Output](image1)

![Figure 298. I/O Summary—Large Box Passes with no Output](image2)

16. Test a complete range of good and bad samples to make sure that the sensor accepts good parts and rejects bad parts.
10 Emulators

Use **Emulators** on the **Home** screen to connect to the emulator.

![Emulators Tab](image)

Click ➡️ to connect to the desired emulator. This tab also displays the Image location on the computer, as well as the emulator version information.

Click ☑️ under Folder Location to change the directory for the reference images. The default directory for images is `C:\Users\Public\Documents\Banner Vision Manager\VE Series\VE xMP\Images`. Both 8-bit monochrome bitmap (BMP) images and inspection logs are supported. Bitmap images should be the same resolution as the VE camera. If inspection logs are placed in the Images directory, the emulator automatically extracts the image out of the inspection log and uses it to run the currently loaded inspection. Click 📁 to open the directory.

The **Emulators** tab includes all available features and all tools function the same as they do when running on a sensor. On the emulator, execution time is not calculated.

### 10.1 Backup or Restore the Emulator

Emulator settings and inspections can be backed up and restored.

Save the backup file to the location of your choice.

1. From the **Home** screen, click **Emulators**.
2. Make sure that no sensors or emulators are connected to the Vision Manager software.
3. Click ☑️, then click **Backup**.
4. Follow the prompts to save a backup file.
   A message displays saying that the backup was successful.
5. To restore the sensor data, click ☑️, then click **Restore**.
6. Follow the prompts to restore the sensor data. A sensor backup file can be used to restore the emulator.

   **Note:** This process can take several minutes.

   A message displays saying that the restore was successful.
11 Sensor Display

The LCD display on the top of the sensor provides access to view or change several settings without using Vision Manager. The display provides limited programming options:

- **ETHER**—Ethernet settings
- **PCHANGE**—Product change
- **IO**—Input/Output settings
- **IMAGE**—Image settings
- **INFO**—Sensor information
- **SYSError**—System errors, if present
- **DISPLAY**—Display settings
- **REBOOT**—Reboot

Access the sensor menu by pressing Enter from the Home Screen on the sensor display.

Note that when User Profiles are enabled, the sensor display is available as read-only. No editing can be done directly from the sensor until User Profiles are disabled for that sensor.

11.1 Sensor Display Interface

Use the sensor buttons to configure several sensor settings and to access sensor information.

### Down and Up Buttons

Press Down and Up to:
- Navigate the menu systems
- Change programming settings

When navigating the menu systems, the menu items loop.

### Enter Button

Press Enter to:
- Access the Sensor Menu
- Access the submenus
- Save changes

In the Sensor Menu, a check mark in the lower right corner of the display indicates that pressing Enter accesses a submenu.

### Escape Button

Press Escape to:
- Leave the current menu and return to the parent menu
- Leave the current menu and return to the Home Screen from any menu

**Important:** Pressing Escape discards any unsaved changes.

In the Sensor Menu, a return arrow in the upper left corner of the display indicates that pressing Escape returns to the parent menu.

Press and hold Escape for 2 seconds to return to the Home Screen from any menu.

11.2 Locking and Unlocking the Sensor

Use the lock and unlock feature to prevent unauthorized or accidental programming changes.

A lock symbol displays in the upper left corner of the display to indicate when the sensor is locked. When locked, the menus are available to view settings, but the values cannot be changed.

To lock or unlock the sensor using the buttons, press and hold Down and Escape simultaneously until the lock symbol displays.
11.3 Sensor Menu

**Top Menu**

- **Enter**
- **Select Menu Item**
- **Press to Save Setting**
- **Go Back to Parent Menu**
- **Press and Hold to Go Back to Home Screen**

**Sub Menus**

- **ETH**
- **ETHER**
- **STATUS**
- **LINK**
- **SPEED**
- **IP**
- **SUBNET**
- **GATEWAY**
- **MAC**
- **MAX SPD**
- **100 FD**
- **100 HD**
- **1000 FD**

**Product Change by Slot No.**

- **PCHANGE**
- **By NUM**

**Bit Representation of Input/Output States**

- **IO**
- **INPUT**
- **OUTPUT**
- **PSELECT**

**View Current Focus No.**

- **IMAGE**
- **FOCUS#**
- **TRIGGER**

**Sensor Info (read-only)**

- **INFO**
- **NAME**
- **MODEL**
- **FW VER**
- **BOOT**
- **HOUR**
- **SERIAL**

**System Error**

- **SYSERR**
- **VIEW**
- **CLEAR**

**Display Settings**

- **DISPLAY**
- **VIEW**
- **SLEEP**

**Reboot Device**

- **REBOOT**
- **Yes**
- **No**

*Figure 300. Menu Map*
11.4 Ethernet Menu (ETHER)

Use this menu to view or change network connection information.

**STATUS**
- **LINK**—View the connection status (UP or NONE). UP indicates that an Ethernet link has been established. NONE indicates that a link has not been established.
- **SPEED**—View the speed (100HD/100FD/1000FD).

**IP**
View or change the IP address of the sensor.

**SUBNET**
View or change the subnet address of the sensor.

**GATEWAY**
View or change the gateway address of the sensor.

**MAC**
View the MAC address of the sensor.

**MAX SPEED**
Set the speed to 100HD, 100FD, or 1000FD. The default speed is 100 full duplex.

*Note:* To use 1000 full duplex, all supporting network hardware must fully support 1000 Mb Ethernet or poor communication throughput could occur.

11.5 Product Change Menu (PCHANGE)

Use this menu to view or change the inspection by slot number.

11.6 Input/Output Menu (IO)

Use this menu to view I/O information.

**OUTPUT**
A Bit representation of the output states.

**INPUT**
A Bit representation of the input states.

**PSELECT**
The slot number represented by selected bits and a Bit representation of the Product Select input pins.

11.7 Image Menu (IMAGE)

Use this menu to view focus and trigger information.

**FOCUS#**
View the current focus number.

**TRIGGER**
Select Yes to trigger the sensor.

11.8 Information Menu (INFO)

Use this menu to view sensor information.

**NAME**
View the device name.
MODEL
View the model number.

FW VER
View the firmware version.

BOOT
View the boot number.

HOUR
View the hour count.

SERIAL
View the sensor serial number.

11.9 System Error Menu (SYSERR)
Use this menu to view or clear system errors, when present.

VIEW
View the latest system error, when present.

CLEAR
Select Yes to clear a system error state. Select No to return to the previous menu without clearing the error.
Clearing the system error state does not remove the system error from the system log.

11.10 Display Menu (DISPLAY)
Use this menu to change the display orientation and sleep mode settings.

VIEW
View or change the display orientation of the sensor. For applications where the sensor must be mounted so that
the display is not right-reading, invert the display for readability.
• Normal—The display is right-reading
• Invert—The display is inverted. The down and up buttons do not change when the display is inverted.

SLEEP
View or change when the display is put to sleep.
• Disabled
• 1min—1 minute
• 5min—5 minutes (default)
• 15min—15 minutes
• 60min—60 minutes

11.11 Reboot Menu (REBOOT)
Use this menu to reboot the sensor. The sensor retains the current settings after the reboot.
Select Yes to reboot the sensor. Select No to return to the Reboot option without rebooting the sensor.
12 Communications Guide

12.1 Communication Summary

The VE Series camera communicates with other devices via Ethernet.

To establish an Ethernet connection to the sensor, the external device must be configured with the correct IP address and support a communication protocol supported by the sensor.

12.1.1 Communication Channels

The VE Series camera supports up to three communications channels.

To access the channels, go to System Settings > Communications.

- Industrial Ethernet—A bi-directional communication channel that allows the user to control the sensor and access sensor results using Ethernet/IP, Modbus/TCP, PROFINET®, or PCCC protocol
- Data Export—Used to export inspection data to a remote device
- Image Export—Used to export inspection images to a remote device

12.1.2 Industrial Ethernet

The VE Series camera can be controlled or monitored over Industrial Ethernet using Ethernet/IP, Modbus/TCP, PROFINET®, or PCCC protocols.

Use this document to set up the VE Series camera in the desired configuration and to provide information needed to connect to the master device (PLC, HMI, etc.).

Navigate: System Settings > Communications > Industrial Protocols.

12.1.3 Data Export

Data export is a way to publish inspection data over Ethernet or Serial channels.

Navigate: System Settings > Communications > Data Export.

On the Data Export tab, set the data export parameters:

**Export**

Set which results to export:

- Disabled (default)
- All
- Pass only
- Fail only

**Channel**

Select which channel to use:

- Ethernet (default)
- Serial

**Port Number**

Set the port number to use for the export. The default is 32100.

Note that the port number cannot be the same as any other port in use.
**Hold Ready**

During the data export operation the sensor's output channels might become full. This can occur if the sensor is exporting data faster than the data can be exported from the device (due to bandwidth limitations) or faster than the client is reading the channel export data.

The **Hold READY** setting affects how the sensor behaves in this situation.

- Select the **Hold READY** checkbox to prevent new triggers from being accepted until the current results have been exported. This ensures that all results are exported. In this case, the READY signal will remain inactive (sensor is busy) until all the results have been added to the channel for export. Triggers might be missed during this time.
- Clear the **Hold READY** checkbox to accept new triggers while the current results are exported. This causes the sensor to discard the new results if the channel is full and activate the READY signal immediately after the current inspection is complete. In this case, the discarded results will not be exported.

**Important:** When the checkbox is cleared, not all results will be exported. When the checkbox is selected, the sensor will be busy (not ready) until the result has been written to the network; inspection times will increase based on network throughput.

Use the data export map to select the results to publish. These include:

- Slot
- Tool Type
- Tool Name—The Tool Name must match the tool name included in the inspection for the results to export
- Result—Choose the desired result based on the tool selected

**Note:** A Slot of ANY means that if an inspection includes a tool with the exact name (for example, *AverageGray01*), the results are output. If an inspection does not have a tool with the exact name (for example *AverageGrayAssemblyLine01*), no results are output for that tool and that inspection.

The Data Type is dependent on the tool selected. Options include the following:

- **Boolean** (0 or 1)
- **Float**
- **Integer**
- **String**
- **HEX**

Click ![above the map to return the map to the default settings. All user-defined output data is deleted. Click ![in the Actions column to delete an individual entry.

Use the data export map to select the results to publish. Use ![to add additional entries at the end of the list. Click ![ or ![ to add additional entries above or below the currently selected entry. Use ![ and ![ to move an entry to either up or down in the map.

Shown below the map is the data that is currently available to be exported.

The Frame Format settings are located to the right of the map:

**Delimiter**

- , <Comma> (default)
- : <Colon>
- ; <Semicolon>
- \n <x0A\x0D>
- \r <x0D>
- <None>

**Start String**

Enter the desired start string. The default is none. If desired, enter ASCII hex values for the start string in the format of \xXX. For example, \x0D. Three special characters are available: \r, \n, and \t.

**End String**

Enter the desired end string. The default is \n\n.
Note: If Data Export is enabled, the receiver application is running under Microsoft Windows, and the sensor is observed experiencing occasional extended not ready states, examine the value of the TCPAckFrequency parameter in the Windows Registry. An incorrect setting of this Windows Registry parameter can cause the sensor to slow down when exporting data to Windows systems. Consult your local IT support personnel with specific questions.

The Missing Data Format settings are also located to the right of the map:

**Publish**
- None
- Delimiter only (default)
- Fill String

**Fill String**
Enter the desired content (fill string) to replace the missing data. The default is 0.

**Banner Data Export Sample Program**

The VE Series camera has a Data Export sample application that provides a way to save exported results. In a production environment, you will need to write your own application to process exported results, for example to display them on an HMI or to save them to disk.

The Banner Data Export Sample Program installs automatically when the Vision Manager software is installed. The source code to write your own application is located at C:\Users\Public\Documents\Banner Vision Manager\Sample Programs\Source\Data Export.

**12.1.4 Image Export: TCP/IP**

Image export **TCP/IP** is a proprietary TCP/IP protocol that is supported only on Ethernet ports.

Navigate: System Settings > Communications > Image Export, select which images to export, and select TCP/IP from the Ethernet Protocol list.

**Image Type**
- Select the image type to export: BMP or JPEG.

**Port Number**
- Set the port number to use for the export. The default is 32200.
- Note that the port number cannot be the same as any other port in use.
Hold READY

During the image export operation the sensor’s output channels might become full. This can occur if the sensor is producing export data (images) faster than the data can be exported from the device (due to bandwidth limitations) or faster than the client is reading the channel export data.

The Hold READY setting affects how the sensor behaves in this situation.

- Select the Hold READY checkbox prevent new triggers from being accepted until the current image has been exported. This ensures that all images are exported. In this case, the READY signal will remain inactive (sensor is busy) until the new image has been added to the channel for export. Triggers might be missed during this time.
- Clear the Hold READY checkbox to accept new triggers while the current image is exported. This causes the sensor to discard the new image if the channel is full and activate the READY signal immediately after the current inspection is complete. In this case, the discarded images will not be exported.

Important: When the checkbox is cleared, not all images will be exported. When the checkbox is selected, the sensor will be busy (not ready) until the image has been written to the network; inspection times will increase based on network throughput.

Inspection images match the resolution of the camera and are 8-bits per pixel grayscale images in Windows BMP format that represent all of the data in a full Field of View (FOV).

Each exported image is composed of a header (64 bytes) followed by the image data; see the following tables. All 16- and 32-bit numeric entries are little endian.

Table 5: Header Information

<table>
<thead>
<tr>
<th>Byte Offset</th>
<th>Field</th>
<th>Size in Bytes</th>
<th>Data Type</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>0-15</td>
<td>Header Prefix</td>
<td>16</td>
<td>char</td>
<td>“VE IMAGE”</td>
</tr>
<tr>
<td>16-19</td>
<td>Header Version</td>
<td>4</td>
<td>UInt32</td>
<td>2</td>
</tr>
<tr>
<td>20-23</td>
<td>Image Size</td>
<td>4</td>
<td>UInt32</td>
<td>Number of bytes; see the table below</td>
</tr>
<tr>
<td>24-27</td>
<td>Image Frame Number</td>
<td>4</td>
<td>UInt32</td>
<td>Most recently snapped image frame number</td>
</tr>
<tr>
<td>28-29</td>
<td>Image Width</td>
<td>2</td>
<td>UInt16</td>
<td>Based on camera resolution</td>
</tr>
<tr>
<td>30-31</td>
<td>Image Height</td>
<td>2</td>
<td>UInt16</td>
<td>Based on camera resolution</td>
</tr>
<tr>
<td>32-33</td>
<td>Image Format</td>
<td>2</td>
<td>UInt16</td>
<td>0: Bitmap</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1: JPEG</td>
</tr>
<tr>
<td>34-63</td>
<td>Reserved</td>
<td>30</td>
<td>byte</td>
<td>Reserved for future use</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Field of View (FOV)</th>
<th>Image Size (bytes)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2592 x 2048</td>
<td>5,309,494</td>
</tr>
<tr>
<td>1600 x 1200</td>
<td>1,921,078</td>
</tr>
<tr>
<td>1280 x 1024</td>
<td>1,311,798</td>
</tr>
<tr>
<td>752 x 480</td>
<td>362,038</td>
</tr>
</tbody>
</table>

Note: If Image Export is enabled, the receiver application is running under Microsoft Windows, and the sensor is observed experiencing occasional extended not ready states, examine the value of the TCPAckFrequency parameter in the Windows Registry. An incorrect setting of this Windows Registry parameter can cause the sensor to slow down when exporting images to Windows systems. Consult your local IT support personnel with specific questions.

Banner Image Export Sample Program

The VE Series camera includes an Image Export sample application that provides a way to save exported images. In a production environment, you will need to write your own application to process exported images, for example to display them on an HMI or to save them to disk.

[Note: Windows BMP image. Image size is not fixed for JPEG images (if supported).]
The Banner Image Export Sample Program installs automatically when the Vision Manager software is installed. The source code to write your own application is located at C:\Users\Public\Documents\Banner Vision Manager\Sample Programs\Source\Image Export.

12.1.5 Image Export: FTP

Image Export FTP supports exporting images over an FTP connection.

Navigate: System Settings > Communications > Image Export, select which images to export, and select FTP from the Ethernet Protocol list.

**Image Type**
- Select the image type to export: BMP or JPEG.

**File Name Format**
- Set which elements to include in the file names of images that are exported using FTP. Result shows a sample file name. If nothing is selected, the frame number is used as the file name.
  - Inspection Pass/Fail—Adds P or F to the file name.
  - Device Name—Adds the name of the device to the file name. For example, VE202G21.
  - Inspection Slot Number—Adds S# to the file name. For example, S1.
  - Inspection Name—Adds the name of the inspection to the file name. For example, Inspection 01.
  - Frame Number—Adds N#### to the file name. For example, N1234.
  - Custom String—Select and enter the desired text to include in each file name. The maximum number of characters is 100.
  - Industrial Protocol String—Adds custom text to the file name from the industrial protocol. The maximum number of characters is 52. See the section on your protocol for information on how to set the custom string (FTP Input String). The string, if available, displays. The string is not saved and cycling the power will delete the string.

To assign the Industrial Protocol string:
1. Make sure that the FTP Input String bit on the Input Bits Register is set to 0.
2. Write the desired string length into the FTP Filename String Length area.
3. Write the desired string content into the FTP Filename String area.
4. Set the FTP Input String bit to 1 to apply the custom string. After the input string is saved in the system, the FTP Input String Ack bit will be set to 1.

**Note:** The specific industrial protocol must be enabled on the Industrial Protocols tab.

For register information and input bits, see the following sections:
- **EtherNet/IP** (p. 169)
- **Modbus/TCP** (p. 188)
- **PLC5, SLC500, and MicroLogix (PCCC)** (p. 197)
- **PROFINET** (p. 207)

This is an example file name that uses most of the **File Name Format** options: PVE202G21S1Inspection01N1234.bmp. This example does not include any custom strings or industrial protocol strings.
Hold READY

During the image export operation the sensor’s output channels might become full. This can occur if the sensor is producing export data (images) faster than the data can be exported from the device (due to bandwidth limitations) or faster than the client is reading the channel export data.

The Hold READY setting affects how the sensor behaves in this situation.

- Select the Hold READY checkbox prevent new triggers from being accepted until the current image has been exported. This ensures that all images are exported. In this case, the READY signal will remain inactive (sensor is busy) until the new image has been added to the channel for export. Triggers might be missed during this time.
- Clear the Hold READY checkbox to accept new triggers while the current image is exported. This causes the sensor to discard the new image if the channel is full and activate the READY signal immediately after the current inspection is complete. In this case, the discarded images will not be exported.

**Important:** When the checkbox is cleared, not all images will be exported. When the checkbox is selected, the sensor will be busy (not ready) until the image has been written to the network; inspection times will increase based on network throughput.

Result

Displays the image export result as well as the name of the file being exported.

Inspection images match the resolution of the camera and are 8-bits per pixel grayscale images in Windows BMP format that represent all of the data in a full Field of View (FOV).

<table>
<thead>
<tr>
<th>Field of View (FOV)</th>
<th>Image Size (bytes)$^9$</th>
</tr>
</thead>
<tbody>
<tr>
<td>2592 x 2048</td>
<td>5,309,494</td>
</tr>
<tr>
<td>1600 x 1200</td>
<td>1,921,078</td>
</tr>
<tr>
<td>1280 x 1024</td>
<td>1,311,798</td>
</tr>
<tr>
<td>752 x 480</td>
<td>362,038</td>
</tr>
</tbody>
</table>

The FTP Server Settings are empty by default. The settings must be set before you run an Image Export using FTP server.

**IP Address**

The IP address of the user’s FTP server.

**Port Number**

The port number required to access the FTP server.

**User Name**

The user name required to access the FTP server.

**Password**

The user’s password used to access the FTP server.

**Folder Name**

Enter a folder name to save the exported images to a specific user-created folder on the FTP server. If the Folder Name field is:

- blank—images are saved to the root folder
- foldername1—images are saved in [foldername1] under the root folder
- foldername1/foldername2—images are saved in [foldername2] under the [foldername1] folder

**Passive Mode**

A connection mode defined by the official FTP protocol in which the client establishes the command channel and the data channel. The server tells the client which port should be used for the data channel.

**Connection Mode**

Just in time—Select to connect to the FTP server each time an image is sent. This option limits network bandwidth.

Always connected—Select to keep the connection to the FTP server active at all times.

**Status**

Displays status messages regarding the FTP connection.

---

$^9$ Windows BMP image. Image size is not fixed for JPEG images (if supported).
12.1.6 Input String

Input String is a way for the sensor to receive data over Ethernet channels.

Navigate: 

System Settings > Communications > Input String.

On the Input String tab, set the parameters:

- **Input String**
  Enable the Input String so that the sensor can receive data over the defined Ethernet port.

- **Port Number**
  Set the port number to use for communication. The default is 32300.
  Note that the port number cannot be the same as any other port in use.

- **String Header**
  The character array that defines the beginning of a valid string. Maximum size is 25 characters.
  The header is optional.
  To use non-printable ASCII characters, use the format \xYY where “YY” is the hexadecimal representation of any ASCII character.
  The default value for the Header is \x02.

- **String Footer**
  The character array that defines the end of a valid string. Maximum size is 25 characters.
  The footer is required.
  To use non-printable ASCII characters, use the format \xYY where “YY” is the hexadecimal representation of any ASCII character.
  The default value for the Header is \x03.

- **Use as a trigger source**
  Select Use as a trigger source checkbox to use a valid input string to trigger the sensor.

  **Note:** If Use as a trigger source is checked, valid input strings are ignored if the READY signal is inactive.

The maximum size, including the header, content, and footer, is 50 bytes.

**Examples**

**Example 1:**
- Header: none
- Footer: End\x03
- User supplied data: Banner EngineeringEnd\x03
- Extracted String: Banner Engineering

**Example 2:**
- Header: \x02Start
- Footer: End\x03
- User supplied data: \x02StartBanner EngineeringEnd\x03
- Extracted String: Banner Engineering

**Example 3:**
- Header: \x02
- Footer: \x03
- User supplied data: \x02Test\x02Banner Engineering\x03Test\x03
- Extracted String: Banner Engineering

12.2 Enabling Communications

12.2.1 Setting Up Ethernet Communications

Configure the PC to communicate with the sensor using the following instructions.
12.2.2 Windows 7

1. On the Windows 7\textsuperscript{10} PC, click the Start button, then on the Start menu, click Control Panel.
2. In Control Panel, click Network and Internet, then click Network and Sharing Center, and then click Change adapter settings.
3. Right-click on the connection that you want to change, then click Properties.
   
   If you are prompted for an administrator password or confirmation, enter the password or provide confirmation.
4. In the connection properties, click Internet Protocol Version 4 (TCP/IPv4), and then click Properties.

![Figure 303. Local Area Connection Properties Screen](image1)

5. In Internet Protocol (TCP/IPv4) Properties, select Use the following IP address.
6. Make sure that the IP address is 192.168.0.2, and the subnet mask is 255.255.255.0.

![Figure 304. Internet Protocol (TCP/IPv4) Properties Screen](image2)

12.2.3 Communications Channel Ports

The default Ethernet port setting for the communication channels is: Image Export—32200 and Data Export—32100.

---

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13 Industrial Ethernet Overview

13.1 Industrial Ethernet Setup

13.1.1 Set the Industrial Ethernet Protocol (EtherNet/IP™, PROFINET®, Modbus/TCP, PCCC)

The Industrial Ethernet communication channel is disabled by default.

To enable this channel, use the following instructions:

1. From the System Settings screen, click Communications, then click Industrial Protocols.
2. Select the desired protocol from the list.
   - Disabled (default)
   - EtherNet/IP
   - PROFINET
   - Modbus/TCP
   - PCCC

   Only one type of connection can be established at a time.
3. Select the desired 32 Bit Format from the list.

   32 bit Format determines how 32 bit integers and floating point values are stored in sequential 16 bit registers (words)—least significant word first (LSW-MSW) or most significant word first (MSW-LSW).

<table>
<thead>
<tr>
<th>Word</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>LSW</td>
</tr>
<tr>
<td>1</td>
<td>MSW</td>
</tr>
</tbody>
</table>

   OR

<table>
<thead>
<tr>
<th>Word</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>MSW</td>
</tr>
<tr>
<td>1</td>
<td>LSW</td>
</tr>
</tbody>
</table>

   Note: To configure the tool-specific results, see:
   - Tool-Specific Results: EtherNet/IP (p. 175)
   - Tool-Specific Results: Modbus/TCP (p. 195)
   - Tool-Specific Results: PCCC (p. 205)
   - Tool-Specific Results: PROFINET (p. 214)

13.1.2 Set the Trigger Mode

Trigger the sensor using either the hardware trigger or through the Industrial Ethernet.

To only accept triggers generated through the Industrial Ethernet communication channel, set the trigger to Industrial Ethernet.

Note: An Industrial Protocol must be enabled from System Settings > Communications > Industrial Protocols before setting the trigger to Industrial Ethernet.

1. On the Sensor screen, click the Camera tool.
   The Inputs tab displays.
2. On the Inputs tab, expand Trigger.
3. Select Industrial Ethernet from the Trigger Mode list.
13.2 Supported Functions

The VE Series camera is controlled over an Industrial Ethernet connection using the input and output data it makes available over the protocol.

The following are examples of sensor functions that can be performed using input and output values:

- Product change
- Remote teach
- Sensor trigger
- Read output indicators (pass/fail/ready/error)
- Read counters (pass, fail, error code, missed trigger, frame count, inspection time)
- FTP filename string

Note: If an input or an output register or a bit is marked as Reserved, its value at any time is indeterminate.

13.2.1 Sensor Input Values

The VE Series camera operation can be controlled through input bits.

*Table 6: Input Bits*

The following commands can be executed only using bits.

<table>
<thead>
<tr>
<th>Input Coil Bit</th>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Product Change</td>
<td>Execute a product change (the inspection number specified in the &quot;Product Change Number&quot; 32-bit integer register)</td>
</tr>
<tr>
<td>1</td>
<td>Teach Latch</td>
<td>Latch a teach bit; the Teach is executed on the next trigger</td>
</tr>
<tr>
<td>2</td>
<td>Trigger</td>
<td>Causes the system to trigger an inspection if ready</td>
</tr>
</tbody>
</table>

13.2.2 Sensor Output Values

The following information can be obtained using output values:

- ACK bits (acknowledgement bits) for input commands, including error codes
- System indicators (Ready, Pass/Fail, Output signals, Execution Error, etc.)
- Inspection History (Iteration Count, Pass Count, Fail Count, etc.)
- Sensor Pass/Fail Bits (Indications of whether each tool in the inspection passed or failed, individually)

See the section on protocols for more information.

ACK Bits

For each of the input bits there is a corresponding ACK bit. The vision sensor sets the ACK bit when the corresponding action is complete. Input bits cause actions to occur on the low-to-high transition of that bit.

Important: You must clear the input bit after the corresponding ACK bit has been observed to be high.

As an example, to use the Trigger ACK bit, the programming steps for triggering an inspection are:

1. Wait for ready.
2. Set Trigger input bit to 1.
3. Wait for Trigger ACK to go to 1.
4. Set Trigger input bit to 0.
In this context, references to EtherNet/IP™ refer specifically to EtherNet/IP transport class 1. Sometimes referred to as cyclic EtherNet/IP IO data transfer or implicit messaging, this connection is meant to approximate a real-time data transfer to and from the PLC and the target device.

Allen-Bradley’s CompactLogix and ControlLogix family of PLCs uses this communication protocol. The programming software used by these PLCs is RSLogix5000 or Studio 5000 Logix Designer.

The VE Series camera is controlled via EtherNet/IP using assembly objects. From the point of view of a PLC, there are three input assemblies and two output assemblies.

The Originator of the EtherNet/IP connection is the PLC. The Target of the EtherNet/IP connection is the VE Series camera. The direction of communication can be described as T > O or O > T (sometimes also shown as T2O or O2T).

The following rules apply for the use of input bit commands:

- Only one VE Series camera input bit can be set at a time
- Corresponding ACK bits are set high only on completion of the command (if the VE input bit is still high)
- Corresponding ACK bits are cleared when the VE input bit is cleared
- When multiple VE input bits are set simultaneously, the Execution Error input bit is set and an Error Code value is reported in the Error Code register
- The Execution Error VE output bit is cleared when all ACK bits are cleared, or a new valid command is received

---

EtherNet/IP™ is a trademark of ODVA, Inc.
Start

Write 0 to Input Bits Register

Make sure camera is ready – bit 0 is set to 1 in Output Bits Register

Execute Trigger: set bit 2 of the Input Bits Register to 1

Is Trigger ACK (bit 2 in Input Bits ACK Register) set to 1?

Yes

Is Execution Error (Output Bits Register bit 15) set to 1?

Yes

Read error code. Correct the error condition

No

Trigger Successful. Read values as required

Done

No

Figure 305. Trigger—Modbus/TCP, EtherNet/IP, PCCC

Trigger

RPI

0 1 X X +Y X +Y+Z

Set

Trigger = 1

Set

Trigger = 0

Verify :

Ready = 1

TriggerACK = 0

Read Results

Verify :

Ready = 1

TriggerACK = 0

Figure 306. Trigger Timing Diagram

X, Y, Z: Represent snapshots in time
No

Write 0 to Input Bits Register

Start

Make sure camera is ready – bit 0 is set to 1 in Output Bits Register

Execute Teach Latch: set bit 1 of the Input Bits Register to 1

Is Teach Latch (bit 1 in Input Bits ACK Register) set to 1?

Yes

Is Execution Error (Output Bits Register bit 15) set to 1?

Yes

Read error code. Correct the error condition

No

Teach Latch successful. The next valid trigger teaches camera the new condition. After that trigger, examine bit 1 in the Output Bits Register. If it is set to 1, Teach was executed successfully. If it is set to 0, Teach was unsuccessful.

Done

Figure 307. TEACH—Modbus/TCP, EtherNet/IP, PCCC

Teach Latch

RPI 0 1 X X+Y X+Y+Z

Teach Latch

Ready

Teach Latch ACK

Set TeachLatch = 1

Set TeachLatch = 0

Verify:
Ready = 1
TeachLatch ACK = 0

TeachLatch ACK = ‘1’
Teach will execute on next trigger

Verify:
Ready = 1
TeachLatchACK = 0

X, Y, Z: Represent snapshots in time

Figure 308. Teach Latch Timing Diagram

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13.3.1 Inputs to the Sensor (Outputs from the PLC)

PLC Assembly Instance 112 (0x70) - 6 Registers (Sensor Inputs/PLC Outputs)  
\( O > T \)

Data transfer direction: Originator (PLC) to Target (VE). Assembly Instance 112 (0x70) is a small group of registers used for basic control of the VE Series camera.
PLC Assembly Instance 117 (0x75) - 34 Registers (Sensor Inputs/PLC Outputs)  
O > T

Data transfer direction: Originator (PLC) to Target (VE). Assembly Instance 117 (0x75) is a group of registers used for the FTP file name.

<table>
<thead>
<tr>
<th>WORD #</th>
<th>WORD NAME</th>
<th>DATA TYPE</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Input Bits Register (see Input and Output Bits (p. 174))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>1-2</td>
<td>Product Change Number</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>3-5</td>
<td>reserved</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>6-7</td>
<td>FTP Filename String Length</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>8-33</td>
<td>FTP Filename String</td>
<td>String (52 characters)</td>
</tr>
</tbody>
</table>

13.3.2 Outputs from the Sensor (Inputs to the PLC)

PLC Assembly Instance 100 (0x64) - 30 Registers (Sensor Outputs/PLC Inputs)  
T > O

Data transfer direction: Target (VE) to Originator (PLC). Assembly Instance 100 (0x64) is a small block of registers providing basic inspection results and 13 user-configurable registers for tool-specific results from the VE Series camera.

<table>
<thead>
<tr>
<th>WORD #</th>
<th>RESULT</th>
<th>DATA TYPE</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Input Bits ACK Register (see Input and Output Bits (p. 174))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>1</td>
<td>Output Bits Register (see Input and Output Bits (p. 174))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>2-3</td>
<td>Error Code</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>4-5</td>
<td>Inspection Number</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>6-7</td>
<td>Frame Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>8-9</td>
<td>Pass Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>10-11</td>
<td>Fail Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>12-13</td>
<td>Missed Triggers</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>14-15</td>
<td>Current Inspection Time</td>
<td>32-bit float</td>
</tr>
<tr>
<td>16</td>
<td>Sensor Pass/Fail Bits (see Sensor Pass/Fail Bits (p. 175))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>17-29</td>
<td>User-defined (see Tool-Specific Results: EtherNet/IP (p. 175))</td>
<td>Selection dependent</td>
</tr>
</tbody>
</table>

PLC Assembly Instance 101 (0x65) - 240 Registers (Sensor Outputs/PLC Inputs)  
T > O

Data transfer direction: Target (VE) to Originator (PLC). Assembly Instance 101 (0x65) is a large block of registers that provides both basic inspection results and 223 user-configurable registers for tool-specific results.

<table>
<thead>
<tr>
<th>WORD #</th>
<th>WORD NAME</th>
<th>DATA TYPE</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Input Bits ACK Register (see Input and Output Bits (p. 174))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>WORD #</td>
<td>WORD NAME</td>
<td>DATA TYPE</td>
</tr>
<tr>
<td>-------</td>
<td>-----------------------------------------------</td>
<td>-----------------</td>
</tr>
<tr>
<td>1</td>
<td>Output Bits Register (see Input and Output Bits (p. 174))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>2-3</td>
<td>Error Code</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>4-5</td>
<td>Inspection Number</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>6-7</td>
<td>Frame Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>8-9</td>
<td>Pass Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>10-11</td>
<td>Fail Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>12-13</td>
<td>Missed Triggers</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>14-15</td>
<td>Current Inspection Time</td>
<td>32-bit float</td>
</tr>
<tr>
<td>16</td>
<td>Sensor Pass/Fail Bits (see Sensor Pass/Fail Bits (p. 175))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>17-239</td>
<td>User-defined (see Tool-Specific Results: EtherNet/IP (p. 175))</td>
<td>Selection dependent</td>
</tr>
</tbody>
</table>

PLC Assembly Instance 102 (0x66) - 60 Registers (Sensor Outputs/PLC Inputs) T > O

Data transfer direction: Target (VE) to Originator (PLC). Assembly Instance 102 (0x66) is a large block of registers that provides both basic inspection results and 43 user-configurable registers for tool-specific results.

<table>
<thead>
<tr>
<th>WORD #</th>
<th>WORD NAME</th>
<th>DATA TYPE</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Input Bits ACK Register (see Input and Output Bits (p. 174))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>1</td>
<td>Output Bits Register (see Input and Output Bits (p. 174))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>2-3</td>
<td>Error Code</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>4-5</td>
<td>Inspection Number</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>6-7</td>
<td>Frame Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>8-9</td>
<td>Pass Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>10-11</td>
<td>Fail Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>12-13</td>
<td>Missed Triggers</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>14-15</td>
<td>Current Inspection Time</td>
<td>32-bit float</td>
</tr>
<tr>
<td>16</td>
<td>Sensor Pass/Fail Bits (see Sensor Pass/Fail Bits (p. 175))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>17-59</td>
<td>User-defined (see Tool-Specific Results: EtherNet/IP (p. 175))</td>
<td>Selection dependent</td>
</tr>
</tbody>
</table>

13.3.3 Input and Output Bits

Table 7: Input Bits Register (Command Bits)

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>15</th>
<th>14</th>
<th>13</th>
<th>12</th>
<th>11</th>
<th>10</th>
<th>9</th>
<th>8</th>
<th>7</th>
<th>6</th>
<th>5</th>
<th>4</th>
<th>3</th>
<th>2</th>
<th>1</th>
<th>0</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>FTP Input String</td>
<td>reserved</td>
<td>reserved</td>
</tr>
</tbody>
</table>

Table 8: Input Bits ACK Register (ACK Bits)

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>15</th>
<th>14</th>
<th>13</th>
<th>12</th>
<th>11</th>
<th>10</th>
<th>9</th>
<th>8</th>
<th>7</th>
<th>6</th>
<th>5</th>
<th>4</th>
<th>3</th>
<th>2</th>
<th>1</th>
<th>0</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>FTP Input String ACK</td>
<td>reserved</td>
<td>reserved</td>
</tr>
</tbody>
</table>
13.3.4 Sensor Pass/Fail Bits

For the sensor pass/fail bits, pass = 1 and fail = 0.

### Table 10: Sensor Pass/Fail Bits

|--------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|

13.3.5 Tool-Specific Results: EtherNet/IP

Configure the VE to output user-defined, tool-specific results to the PLC using a custom map. Each assembly instance includes system-defined and user-defined results in the map. To set the user-defined, tool-specific results in the custom map, navigate: System Settings > Communications > Industrial Protocols.

The results are configurable only for the current inspection. However, all user-defined results in the custom map are shown on the Industrial Protocols tab whether or not they are included in the current inspection. To make changes to a different inspection, switch to the desired inspection and then make changes to the custom map. Updating the map does not disconnect the sensor from the PLC.

To configure the map:
1. Click + to add a new line to the map.
2. Set the Word/Register/Byte, Tool Name, and Result. See the following descriptions for more information.
3. Click Apply Changes to send the current map to the camera.

**Important:** Click Apply Changes or all user-defined data is lost when you click away from the Industrial Protocols tab.

4. Click 🏞️ to print and save a PDF of the current map. The PDF includes all data, whether system-defined or user-defined.

5. To return the map to the default settings, click 📀. All user-defined output data is deleted.

Column descriptions:

**WORD #**
The data location.

**Inspection #**
Shows whether this tool result applies to the current inspection only (inspection number) or to any inspection (ANY) that includes the selected tool.

An Inspection # of ANY means that if an inspection includes a tool with the exact name (for example, AverageGray01), the results are output. If an inspection does not have a tool with the exact name (for example AverageGrayAssemblyLine01), no results are output for that tool and that inspection.

**Tool Type**
Displays a graphic that represents the type of tool selected in the Tool Name column.

**Tool Name**
Select the desired Tool Name from the list. The list includes the tools available in the current inspection only. Select a different inspection from the inspection list, if necessary.

**Result**
The information to output.

**Data Type**
The type of information to output.

**Actions**
Click 🗑️ to delete a result. You cannot delete system-defined results that contain the 🔐 symbol.

### 13.3.6 Configuration Assembly Object

The VE Series camera EtherNet/IP implementation does not support an assembly object Configuration instance. However, one is required for the creation of implicit Class 1 connections on a ControlLogix® family PLC. Therefore, a configuration instance is defined as instance number 128 (0x80). Its size is zero.

### 13.3.7 Data Formats

The VE Series camera EtherNet/IP implementation supports 32-bit integers in LSW_MSW data format (default) or MSW_LSW data format. The LSW_MSW data format is such that the least significant word is stored first, then the most significant word. This format is used for Allen-Bradley ControlLogix PLCs.

The string format is compatible with the Allen-Bradley ControlLogix built-in string data type. This format is a 32 bit (DINT) length followed by character bytes (SINT). This results in the following string format as viewed from the VE Series camera:

<table>
<thead>
<tr>
<th>Word</th>
<th>0</th>
<th>1</th>
<th>2</th>
<th>3</th>
<th>4</th>
</tr>
</thead>
<tbody>
<tr>
<td>Length</td>
<td>LSW</td>
<td>Length</td>
<td>MSW</td>
<td>byte 1</td>
<td>byte 0</td>
</tr>
</tbody>
</table>

### 13.3.8 Minimum Requested Packet Interval (RPI) Value

The VE Series camera can operate with input and output Requested Packet Intervals (RPIs) as low as 50 milliseconds. **The device may not operate reliably if a lower RPI value is selected.**

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ControlLogix® is a trademark of Rockwell Automation, Inc.
13.3.9 VE Series Smart Camera EDS File Installation in ControlLogix Software

Use the EDS Hardware Installation Tool to register the Electronic Data Sheet (EDS) file.

1. On the Tools menu, click EDS Hardware Installation Tool.
   The Rockwell Automation's EDS Wizard dialog displays.

2. Click Next.
3. Select the Register an EDS file(s) option.

4. Browse to locate the EDS file and click Next.
   If Vision Manager is installed on the computer, a copy of the EDS file is available at C:\Users\Public\Documents \Banner Vision Manager\VE Series\Industrial Protocols\EthernetIP.
5. Click **Next** to register the tested file.

6. Click **Next** when you see the icon associated with the EDS file.
7. Click **Next** to register the EDS file.

8. Click **Finish** to close the **EDS Wizard**.

9. Right-click on the PLC’s Ethernet adapter and select **New Module**...
10. Locate the VE Series camera from the catalog and click **Create**.

![Select Module Type](image1.png)

**Figure 319. Select Module Type**

11. Enter a name, description (optional), and IP address for the VE Series camera.

![New Module](image2.png)

**Figure 320. New Module**

12. Click **Change** in the **Module Definition** field.
13. Select the desired connection in the **Module Definition** window. Each of the items in the Name list represents a fixed grouping of input and output assembly instances:

<table>
<thead>
<tr>
<th>Name</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Small T20 (100)</td>
<td>O&gt;T PLC/Sensor Assembly 112 (0×70)</td>
</tr>
<tr>
<td></td>
<td>T&gt;O PLC/Sensor Assembly 100 (0×64)</td>
</tr>
<tr>
<td>Medium T20 (102)</td>
<td>O&gt;T PLC/Sensor Assembly 112 (0×70)</td>
</tr>
<tr>
<td></td>
<td>T&gt;O PLC/Sensor Assembly 102 (0×66)</td>
</tr>
<tr>
<td>Large T20 (101)</td>
<td>O&gt;T PLC/Sensor Assembly 112 (0×70)</td>
</tr>
<tr>
<td></td>
<td>T&gt;O PLC/Sensor Assembly 101 (0×65)</td>
</tr>
<tr>
<td>String + Small T20 (100)</td>
<td>O&gt;T PLC/Sensor Assembly 117 (0×75)</td>
</tr>
<tr>
<td></td>
<td>T&gt;O PLC/Sensor Assembly 100 (0×64)</td>
</tr>
<tr>
<td>String + Medium T20 (102)</td>
<td>O&gt;T PLC/Sensor Assembly 117 (0×75)</td>
</tr>
<tr>
<td></td>
<td>T&gt;O PLC/Sensor Assembly 102 (0×66)</td>
</tr>
<tr>
<td>String + Large T20 (101)</td>
<td>O&gt;T PLC/Sensor Assembly 117 (0×75)</td>
</tr>
<tr>
<td></td>
<td>T&gt;O PLC/Sensor Assembly 101 (0×65)</td>
</tr>
</tbody>
</table>

14. Select **INT** as the data type.

15. Click **OK** twice and download the program to the PLC.
13.3.10 RSLogix5000 Configuration

To create an implicit Class 1 configuration to the VE Series camera using EtherNet/IP when using a ControlLogix family PLC, configure the VE as a “Generic Ethernet Module” under the ENET_MODULE. The following is a sample setup of a Banner device:

1. Add a generic Ethernet module to the PLC’s Ethernet card.
   a. Click **New Module**.
   b. Click **Communications**, then **Generic Ethernet Module**.
2. Configure the Module Properties.

   **Note:** The data type in the Comm Format must be changed to an INT.

See *Inputs to the Sensor (Outputs from the PLC)* (p. 172) and *Outputs from the Sensor (Inputs to the PLC)* (p. 173) for more information on each specific assembly instance.
Figure 326. Example: PLC Input Assembly Instance 0x64 (100), PLC Output Assembly Instance 0x70 (112)

Figure 327. Example: PLC Input Assembly Instance 0x65 (101), PLC Output Assembly Instance 0x71 (113)
3. If the module configuration was successful, the following information displays:

**Note:** The minimum allowed RPI is 50 ms.
If the module configuration was not successful, the RSLogix 5000 software will indicate errors similar to the following figures:

4. Locate the memory map setup from the Banner module to the PLC memory map.
C = Configuration (not used)
I = Inputs to PLC (outputs from the device)
O = Outputs from PLC (inputs to the device)

Figure 333. Memory Map
The VE Series camera memory map expanded. I = Inputs to PLC (outputs from the device).

Figure 334. Memory Map Expanded

13.4 Modbus/TCP

The Modbus/TCP protocol provides device information using register and coil banks defined by the slave device. This section defines the register and coil banks. By specification, Modbus/TCP uses TCP port 502.

The following registers are used to send values back and forth from the vision sensor to the PLC. VE Series camera read-only output data can be read as Input Registers (30000) using Modbus function code 04 (Read Input Registers). Because some devices like the Modicon family of PLCs cannot access data using the 30000 range of registers, the same values can also be seen as Holding Registers (40000) using Modbus function code 03 (Read Holding Registers).

The Input Bits can be set as Coils using Modbus function code 05 (Force Single Coil). The state of the Input ACK Bits and Status Bits can be read as Inputs (10000) using Modbus function code 02 (Read Input Status).

Modbus Function Codes Supported

- 01: Read Coil Status
- 02: Read Input Status
- 03: Read Holding Registers
- 04: Read Input Registers
- 05: Force Single Coil
- 06: Preset Single Register
- 07: Read Exception Status
- 16: Preset Multiple Registers
### Table 11: Input Bits (Coils 00001-00016)

<table>
<thead>
<tr>
<th>Register</th>
<th>Bit Position</th>
<th>WORD Name</th>
</tr>
</thead>
<tbody>
<tr>
<td>00001</td>
<td>0</td>
<td>Product Change</td>
</tr>
<tr>
<td>00002</td>
<td>1</td>
<td>Teach Latch</td>
</tr>
<tr>
<td>00003</td>
<td>2</td>
<td>Trigger</td>
</tr>
<tr>
<td>00004</td>
<td>3</td>
<td>reserved</td>
</tr>
<tr>
<td>00005</td>
<td>4</td>
<td>reserved</td>
</tr>
<tr>
<td>00006</td>
<td>5</td>
<td>reserved</td>
</tr>
<tr>
<td>00007</td>
<td>6</td>
<td>reserved</td>
</tr>
<tr>
<td>00008</td>
<td>7</td>
<td>FTP Input String</td>
</tr>
<tr>
<td>00009</td>
<td>8</td>
<td>reserved</td>
</tr>
<tr>
<td>00010</td>
<td>9</td>
<td>reserved</td>
</tr>
<tr>
<td>00011</td>
<td>10</td>
<td>reserved</td>
</tr>
<tr>
<td>00012</td>
<td>11</td>
<td>reserved</td>
</tr>
<tr>
<td>00013</td>
<td>12</td>
<td>reserved</td>
</tr>
<tr>
<td>00014</td>
<td>13</td>
<td>reserved</td>
</tr>
<tr>
<td>00015</td>
<td>14</td>
<td>reserved</td>
</tr>
<tr>
<td>00016</td>
<td>15</td>
<td>reserved</td>
</tr>
</tbody>
</table>

### Table 12: Input ACK Bits (Inputs 10001-10016)

<table>
<thead>
<tr>
<th>Register</th>
<th>Bit Position</th>
<th>WORD Name</th>
</tr>
</thead>
<tbody>
<tr>
<td>10001</td>
<td>0</td>
<td>Product Change ACK</td>
</tr>
<tr>
<td>10002</td>
<td>1</td>
<td>Teach Latch ACK</td>
</tr>
<tr>
<td>10003</td>
<td>2</td>
<td>Trigger ACK</td>
</tr>
<tr>
<td>10004</td>
<td>3</td>
<td>reserved</td>
</tr>
<tr>
<td>10005</td>
<td>4</td>
<td>reserved</td>
</tr>
<tr>
<td>10006</td>
<td>5</td>
<td>reserved</td>
</tr>
<tr>
<td>10007</td>
<td>6</td>
<td>reserved</td>
</tr>
<tr>
<td>10008</td>
<td>7</td>
<td>FTP Input String ACK</td>
</tr>
<tr>
<td>10009</td>
<td>8</td>
<td>reserved</td>
</tr>
<tr>
<td>10010</td>
<td>9</td>
<td>reserved</td>
</tr>
<tr>
<td>10011</td>
<td>10</td>
<td>reserved</td>
</tr>
<tr>
<td>10012</td>
<td>11</td>
<td>reserved</td>
</tr>
<tr>
<td>10013</td>
<td>12</td>
<td>reserved</td>
</tr>
<tr>
<td>10014</td>
<td>13</td>
<td>reserved</td>
</tr>
<tr>
<td>10015</td>
<td>14</td>
<td>reserved</td>
</tr>
<tr>
<td>10016</td>
<td>15</td>
<td>reserved</td>
</tr>
</tbody>
</table>
Table 13: Status Bits (Inputs 10017-10032)

<table>
<thead>
<tr>
<th>Register</th>
<th>Bit Position</th>
<th>WORD Name</th>
</tr>
</thead>
<tbody>
<tr>
<td>10017</td>
<td>0</td>
<td>Ready</td>
</tr>
<tr>
<td>10018</td>
<td>1</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>10019</td>
<td>2</td>
<td>reserved</td>
</tr>
<tr>
<td>10020</td>
<td>3</td>
<td>Ready Latch</td>
</tr>
<tr>
<td>10021</td>
<td>4</td>
<td>reserved</td>
</tr>
<tr>
<td>10022</td>
<td>5</td>
<td>Output 1</td>
</tr>
<tr>
<td>10023</td>
<td>6</td>
<td>Output 2</td>
</tr>
<tr>
<td>10024</td>
<td>7</td>
<td>Output 3</td>
</tr>
<tr>
<td>10025</td>
<td>8</td>
<td>Output 4</td>
</tr>
<tr>
<td>10026</td>
<td>9</td>
<td>Output 5</td>
</tr>
<tr>
<td>10027</td>
<td>10</td>
<td>reserved</td>
</tr>
<tr>
<td>10028</td>
<td>11</td>
<td>reserved</td>
</tr>
<tr>
<td>10029</td>
<td>12</td>
<td>Missed Trigger</td>
</tr>
<tr>
<td>10030</td>
<td>13</td>
<td>Teach Error</td>
</tr>
<tr>
<td>10031</td>
<td>14</td>
<td>System Error</td>
</tr>
<tr>
<td>10032</td>
<td>15</td>
<td>Execution Error</td>
</tr>
</tbody>
</table>

The following rules apply for the use of input bit commands:

- Only one VE Series camera input bit can be set at a time
- Corresponding ACK bits are set high only on completion of the command (if the VE input bit is still high)
- Corresponding ACK bits are cleared when the VE input bit is cleared
- When multiple VE input bits are set simultaneously, the Execution Error input bit is set and an Error Code value is reported in the Error Code register
- The Execution Error VE output bit is cleared when all ACK bits are cleared, or a new valid command is received
Start
- Write 0 to Input Bits Register
- Make sure camera is ready – bit 0 is set to 1 in Output Bits Register
- Execute Trigger: set bit 2 of the Input Bits Register to 1
- Is Trigger ACK (bit 2 in Input Bits ACK Register) set to 1?
  - Yes: Is Execution Error (Output Bits Register bit 15) set to 1?
    - Yes: Read error code. Correct the error condition
    - No: Trigger Successful. Read values as required
  - No: Trigger Ready

Verify:
- Ready = 1
- TriggerACK = 0

Figure 336. Trigger Timing Diagram

X, Y, Z: Represent snapshots in time

Figure 335. Trigger—Modbus/TCP, EtherNet/IP, PCCC
Write 0 to Input Bits Register

Make sure camera is ready – bit 0 is set to 1 in Output Bits Register

Execute Teach Latch: set bit 1 of the Input Bits Register to 1

Is Teach Latch (bit 1 in Input Bits ACK Register) set to 1?

If Teach Latch was successful, the next valid trigger teaches camera the new condition. After that trigger, examine bit 1 in the Output Bits Register. If it is set to 1, Teach was executed successfully. If it is set to 0, Teach was unsuccessful.

Is Execution Error (Output Bits Register bit 15) set to 1?

Read error code. Correct the error condition

Done

---

Figure 337. TEACH—Modbus/TCP, EtherNet/IP, PCCC

Teach Latch

<table>
<thead>
<tr>
<th>RPI</th>
<th>0</th>
<th>1</th>
<th>X</th>
<th>X+Y</th>
<th>X+Y+Z</th>
</tr>
</thead>
<tbody>
<tr>
<td>Teach Latch</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Ready</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Teach Latch ACK</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Verify:
- Ready = 1
- TeachLatch ACK = 0
- Teach will execute on next trigger

Verify:
- Ready = 1
- TeachLatchACK = 0

X, Y, Z: Represent snapshots in time

Figure 338. Teach Latch Timing Diagram
13.4.1 Sensor Input Values

Holding Registers (40000) are used by the PLC or HMI to write values to the VE Series camera. To write, use function codes 6 (Preset Single Register) or 16 (Preset Multiple Registers).
13.4.2 VE Series camera Output Values

The VE Series camera sends output data to the PLC or HMI via a bank of Input Registers (30000). Some devices, like the Modicon family of PLCs, cannot access data using the 30000 range of register addresses. For these devices, the VE output data is also made available as Holding Registers (40000). To access this data, use either function code 04 (Read Input Registers) or function code 03 (Read Holding Registers).

Table 15: VE Series camera Output Values (Modbus/TCP Input or Holding Registers)

<table>
<thead>
<tr>
<th>Input REG #</th>
<th>Holding REG #</th>
<th>WORD NAME</th>
<th>DATA TYPE</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1001</td>
<td>Input ACK Bits (see Input and Output Bits (p. 194), and also Inputs 10001-16)</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>2</td>
<td>1002</td>
<td>Status Bits (see Input and Output Bits (p. 194), and also Inputs 10017-32)</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>3-4</td>
<td>1003-4</td>
<td>Error Code</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>5-6</td>
<td>1005-6</td>
<td>Inspection Number</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>7-8</td>
<td>1007-8</td>
<td>Iteration Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>9-10</td>
<td>1009-10</td>
<td>Pass Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>11-12</td>
<td>1011-12</td>
<td>Fail Count</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>13-14</td>
<td>1013-14</td>
<td>Missed Triggers</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>15-16</td>
<td>1015-16</td>
<td>Current Inspection Time</td>
<td>Float</td>
</tr>
<tr>
<td>17</td>
<td>1017</td>
<td>Sensor Pass/Fail Bits (see Sensor Pass/Fail Bits (p. 175))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>18-500</td>
<td>1018-500</td>
<td>User-defined (see Tool-Specific Results: Modbus/TCP (p. 195))</td>
<td>16-bit integer</td>
</tr>
</tbody>
</table>

13.4.3 Input and Output Bits

Writable Input Bits are inputs to the VE Series camera (outputs from the PLC or HMI). They are used for basic control of the VE Series camera. They are accessible using function code 6 (Preset Single Register). The same control is also possible using Coils 00001-16, function code 05 (Force Single Coil).

Table 16: Input Bits: PLC Holding Register 1, also Coils 00001-16

<table>
<thead>
<tr>
<th>Coil 16</th>
<th>Coil 15</th>
<th>Coil 14</th>
<th>Coil 13</th>
<th>Coil 12</th>
<th>Coil 11</th>
<th>Coil 10</th>
<th>Coil 9</th>
<th>Coil 8</th>
<th>Coil 7</th>
<th>Coil 6</th>
<th>Coil 5</th>
<th>Coil 4</th>
<th>Coil 3</th>
<th>Coil 2</th>
<th>Coil 1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bit 15</td>
<td>Bit 14</td>
<td>Bit 13</td>
<td>Bit 12</td>
<td>Bit 11</td>
<td>Bit 10</td>
<td>Bit 9</td>
<td>Bit 8</td>
<td>Bit 7</td>
<td>Bit 6</td>
<td>Bit 5</td>
<td>Bit 4</td>
<td>Bit 3</td>
<td>Bit 2</td>
<td>Bit 1</td>
<td>Bit 0</td>
</tr>
<tr>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Trigger</td>
<td>Teach</td>
<td>Latch</td>
<td>Product Change</td>
</tr>
</tbody>
</table>
Read-only **Input ACK Bits** are outputs from the VE Series camera (inputs to the PLC or HMI). They are used to acknowledge each of the input bits sent from the PLC. For example, if the PLC changes the Trigger bit (from Input Bits, above) from a 0 to a 1, the VE changes the Trigger ACK bit from a 0 to a 1 in response. This information is available as Input Registers or Holding Registers. Use either function code 04 (Read Input Registers) or function code 03 (Read Holding Registers). The same data can also be read from Inputs (10000) using Modbus function code 02 (Read Input Status).

Table 17: Input ACK Bits: PLC Input Register 1 or Holding Register 1001, also Inputs 10001-16

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>Input 16</th>
<th>Input 15</th>
<th>Input 14</th>
<th>Input 13</th>
<th>Input 12</th>
<th>Input 11</th>
<th>Input 10</th>
<th>Input 9</th>
<th>Input 8</th>
<th>Input 7</th>
<th>Input 6</th>
<th>Input 5</th>
<th>Input 4</th>
<th>Input 3</th>
<th>Input 2</th>
<th>Input 1</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bit 15</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
</tr>
<tr>
<td>Bit 14</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
</tr>
<tr>
<td>Bit 13</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
</tr>
<tr>
<td>Bit 12</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
</tr>
<tr>
<td>Bit 11</td>
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<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
</tr>
<tr>
<td>Bit 10</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
</tr>
<tr>
<td>Bit 9</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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<td>reserved</td>
</tr>
<tr>
<td>Bit 8</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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</tr>
<tr>
<td>Bit 7</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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<tr>
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<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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<tr>
<td>Bit 5</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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<td>reserved</td>
</tr>
<tr>
<td>Bit 4</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
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<td>reserved</td>
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<tr>
<td>Bit 3</td>
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<td>reserved</td>
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<td>reserved</td>
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<td>reserved</td>
</tr>
<tr>
<td>Bit 1</td>
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<td>reserved</td>
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</tr>
<tr>
<td>Bit 0</td>
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<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
</tr>
</tbody>
</table>

Read-only **Status Bits** are outputs from the VE Series camera (inputs to the PLC or HMI). They are used to report the basic status of the VE Series camera and the last inspection run. This information is available as Input Registers or Holding Registers. Use either function code 04 (Read Input Registers) or function code 03 (Read Holding Registers). The same data can also be read from Inputs (10000) using Modbus function code 02 (Read Input Status).

Table 18: Status Bits: PLC Input Register 2 or Holding Register 1002, also Inputs 10017-32

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>Input 32</th>
<th>Input 31</th>
<th>Input 30</th>
<th>Input 29</th>
<th>Input 28</th>
<th>Input 27</th>
<th>Input 26</th>
<th>Input 25</th>
<th>Input 24</th>
<th>Input 23</th>
<th>Input 22</th>
<th>Input 21</th>
<th>Input 20</th>
<th>Input 19</th>
<th>Input 18</th>
<th>Input 17</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bit 15</td>
<td>Execution</td>
<td>System</td>
<td>Error</td>
<td>reserved</td>
<td>reserved</td>
<td>Output 5</td>
<td>Output 4</td>
<td>Output 3</td>
<td>Output 2</td>
<td>Output 1</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
</tr>
<tr>
<td>Bit 14</td>
<td>Error</td>
<td>Teach</td>
<td>Error</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 13</td>
<td>Missed</td>
<td>Trigger</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 12</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 11</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 10</td>
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<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 9</td>
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<td>reserved</td>
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<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 8</td>
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<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 7</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 6</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 5</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 4</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 3</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 2</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 1</td>
<td>reserved</td>
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<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
<tr>
<td>Bit 0</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
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<td>Pass/Fail</td>
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<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
<td>Pass/Fail</td>
</tr>
</tbody>
</table>

13.4.4 Sensor Pass/Fail Bits

For the sensor pass/fail bits, pass = 1 and fail = 0.

Table 19: Sensor Pass/Fail Bits

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>15</th>
<th>14</th>
<th>13</th>
<th>12</th>
<th>11</th>
<th>10</th>
<th>9</th>
<th>8</th>
<th>7</th>
<th>6</th>
<th>5</th>
<th>4</th>
<th>3</th>
<th>2</th>
<th>1</th>
<th>0</th>
</tr>
</thead>
</table>

13.4.5 Tool-Specific Results: Modbus/TCP

Configure the VE to output user-defined, tool-specific results to the PLC using a custom map.

The sensor output values (Modbus/TCP Input or Holding Registers) include both system-defined and user-defined results in the map. To set the user-defined, tool-specific results in the custom map, navigate: **System Settings > Communications > Industrial Protocols**.
The results are configurable only for the current inspection. However, all user-defined results in the custom map are shown on the Industrial Protocols tab whether or not they are included in the current inspection. To make changes to a different inspection, switch to the desired inspection and then make changes to the custom map. Updating the map does not disconnect the sensor from the PLC.

To configure the map:

1. Click to add a new line to the map.
2. Set the Word/Register/Byte, Tool Name, and Result. See the following descriptions for more information.
3. Click Apply Changes to send the current map to the camera.

Important: Click Apply Changes or all user-defined data is lost when you click away from the Industrial Protocols tab.

4. Click to print and save a PDF of the current map. The PDF includes all data, whether system-defined or user-defined.

5. To return the map to the default settings, click . All user-defined output data is deleted.

Column descriptions:

**REG #**
The data location.

**Inspection #**
Shows whether this tool result applies to the current inspection only (inspection number) or to any inspection (ANY) that includes the selected tool.

An Inspection # of ANY means that if an inspection includes a tool with the exact name (for example, AverageGray01), the results are output. If an inspection does not have a tool with the exact name (for example AverageGrayAssemblyLine01), no results are output for that tool and that inspection.

**Tool Type**
Displays a graphic that represents the type of tool selected in the Tool Name column.
Tool Name
Select the desired Tool Name from the list. The list includes the tools available in the current inspection only. Select a different inspection from the inspection list, if necessary.

Result
The information to output.

Data Type
The type of information to output.

Actions
Click to delete a result. You cannot delete system-defined results that contain the symbol.

13.5 PLC5, SLC500, and MicroLogix (PCCC)
Allen-Bradley’s PLC5, SLC 500, and MicroLogix family of devices uses PCCC communications protocol.
PCCC is also known as EtherNet/IP transport class 3 and uses explicit Read and Write message commands, or EIP messaging, placed into the ladder logic program, to interface with the VE Series camera.
These PLCs do not support cyclic EtherNet/IP IO data transfer (referred to as EtherNet/IP in this manual). The programming software used by these PLCs is RSLogix 5 (PLC5) or RSLogix 500 (SLC500 and MicroLogix series).
The VE Series camera supports these PLCs using input and output register arrays.
The Output bits, ACK bits and Input bits bit definitions are the same as defined in the I/O Assembly Objects section. The terms “Input” and “Output” are from the point of view of the PLC.
The following rules apply for the use of input bit commands:
• Only one VE Series camera input bit can be set at a time
• Corresponding ACK bits are set high only on completion of the command (if the VE input bit is still high)
• Corresponding ACK bits are cleared when the VE input bit is cleared
• When multiple VE input bits are set simultaneously, the Execution Error input bit is set and an Error Code value is reported in the Error Code register
• The Execution Error VE output bit is cleared when all ACK bits are cleared, or a new valid command is received
Start

Write 0 to Input Bits Register

Make sure camera is ready – bit 0 is set to 1 in Output Bits Register

Execute Trigger: set bit 2 of the Input Bits Register to 1

Is Trigger ACK (bit 2 in Input Bits ACK Register) set to 1?

Yes

Is Execution Error (Output Bits Register bit 15) set to 1?

Yes

Read error code. Correct the error condition

No

Trigger Successful. Read values as required

Done

Figure 342. Trigger—Modbus/TCP, EtherNet/IP, PCCC

Trigger

RPI 0 1 X X +Y X +Y+Z

Trigger

Ready

TriggerACK

Set Trigger = 1

Set Trigger = 0

Verify : Ready = 1 TriggerACK = 1

Read Results

Verify : Ready = 1 TriggerACK = 0

X, Y, Z: Represent snapshots in time

Figure 343. Trigger Timing Diagram

Figure 342. Trigger—Modbus/TCP, EtherNet/IP, PCCC
Write 0 to Input Bits Register

Make sure camera is ready – bit 0 is set to 1 in Output Bits Register

Execute Teach Latch: set bit 1 of the Input Bits Register to 1

Is Teach Latch (bit 1 in Input Bits ACK Register) set to 1?

Yes

Is Execution Error (Output Bits Register bit 15) set to 1?

Yes

Read error code. Correct the error condition

No

Teach Latch successful. The next valid trigger teaches camera the new condition. After that trigger, examine bit 1 in the Output Bits Register. If it is set to 1, Teach was executed successfully. If it is set to 0, Teach was unsuccessful.

No

Done

Figure 344. TEACH—Modbus/TCP, EtherNet/IP, PCCC

Teach Latch

Verify:
Ready = 1
TeachLatch ACK = 0

Set
TeachLatch = 1

TeachLatch ACK

Verify:
Ready = 1
TeachLatch ACK = 0

X, Y, Z: Represent snapshots in time

Figure 345. Teach Latch Timing Diagram
13.5.1 Configuration

The following images represent a typical configuration.
**PLC Read Message Command**

<table>
<thead>
<tr>
<th>This Controller</th>
<th>Target Device</th>
</tr>
</thead>
<tbody>
<tr>
<td>Communication Command = PLC5 Read</td>
<td>Data Table Address = Integer table &quot;Nx&quot;</td>
</tr>
<tr>
<td>Data Table Address = N7:0</td>
<td>Data Table Address = N7:x</td>
</tr>
</tbody>
</table>

**Example message command reading from N7 table on the VE and sending the data to the N7 table on the PLC**

Figure 348. General tab: Example message command reading from N7 table on the VE and sending the data to the N7 table on the PLC
To Address = IP address of the VE

Figure 349. MultiHop tab: IP Address of the VE is entered here
### PLC Write Message Command

<table>
<thead>
<tr>
<th>Control Bits</th>
<th>Ignored if timed out (TO)</th>
<th>0</th>
</tr>
</thead>
<tbody>
<tr>
<td>To be ended (NR)</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>Awaiting Execution (EW)</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>Continuous Run (CR)</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>Error (ER)</td>
<td>0</td>
<td></td>
</tr>
</tbody>
</table>

**This Controller**

- Communication Command = PLC5 Write
- Data Table Address = Integer table "Nx"

**Target Device**

- Data Table Address = N14:x

**Figure 350.** General tab: Example message command writing to N14 table on the VE from the N14 table of the PLC
13.5.2 Inputs to the Sensor (Outputs from the PLC)

The registers below are used by the PLC to push values to the VE Series camera. MSG (message) commands are used to write (N14) to the sensor.

Table 20: PCCC PLC Output Registers (Sensor Inputs, N14 Table on the Sensor)

<table>
<thead>
<tr>
<th>WORD #</th>
<th>WORD NAME</th>
<th>DATA TYPE</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Input Bits Register (see Input and Output Bits (p. 205))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>1-2</td>
<td>Product Change Number</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>3-5</td>
<td>reserved</td>
<td>16-bit Integer</td>
</tr>
<tr>
<td>6-7</td>
<td>FTP Filename String Length</td>
<td>32-bit Integer</td>
</tr>
<tr>
<td>8-33</td>
<td>FTP Filename String</td>
<td>String (52 characters)</td>
</tr>
<tr>
<td>34-500</td>
<td>reserved</td>
<td>32-bit integer</td>
</tr>
</tbody>
</table>

13.5.3 Outputs from the Sensor (Inputs to the PLC)

The registers below are used to send output values from the VE Series camera to the PLC. MSG (message) commands are used to read (N7) from the sensor.

Table 21: PCCC PLC Input Registers (Sensor Outputs, N7 Table on the Sensor)

<table>
<thead>
<tr>
<th>WORD #</th>
<th>WORD NAME</th>
<th>DATA TYPE</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>Input Bits ACK Register (see Input and Output Bits (p. 205))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>1</td>
<td>Output Bits Register (see Input and Output Bits (p. 205))</td>
<td>16-bit integer</td>
</tr>
<tr>
<td>2-3</td>
<td>Error Code</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>4-5</td>
<td>Inspection Number</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>6-7</td>
<td>Iteration Count</td>
<td>32-bit integer</td>
</tr>
</tbody>
</table>
### 13.5.4 Input and Output Bits

The Input Bits are used to command execution of basic functions. The Output Bits are used to push single bit outputs from the VE Series camera to the PLC. The 32 bits of VE Series camera output can also be accessed using the bits of the first two Output Registers (Input Bits ACK Register(word 0) and Output Bits Register (word1)).

**Table 22: Input Bits Register (Command Bits)**

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>15</th>
<th>14</th>
<th>13</th>
<th>12</th>
<th>11</th>
<th>10</th>
<th>9</th>
<th>8</th>
<th>7</th>
<th>6</th>
<th>5</th>
<th>4</th>
<th>3</th>
<th>2</th>
<th>1</th>
<th>0</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>FTP Input String</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Trigger</td>
<td>Teach</td>
<td>Latch</td>
</tr>
</tbody>
</table>

**Table 23: Input Bits ACK Register (ACK Bits)**

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>15</th>
<th>14</th>
<th>13</th>
<th>12</th>
<th>11</th>
<th>10</th>
<th>9</th>
<th>8</th>
<th>7</th>
<th>6</th>
<th>5</th>
<th>4</th>
<th>3</th>
<th>2</th>
<th>1</th>
<th>0</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>FTP Input String</td>
<td>ACK</td>
<td>reserved</td>
<td>reserved</td>
<td>reserved</td>
<td>Trigger</td>
<td>ACK</td>
<td>Teach</td>
</tr>
</tbody>
</table>

**Table 24: Output Bits Register (Sensor Status Bits)**

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>15</th>
<th>14</th>
<th>13</th>
<th>12</th>
<th>11</th>
<th>10</th>
<th>9</th>
<th>8</th>
<th>7</th>
<th>6</th>
<th>5</th>
<th>4</th>
<th>3</th>
<th>2</th>
<th>1</th>
<th>0</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Execution Error</td>
<td>System Error</td>
<td>Teach Error</td>
<td>Missed Trigger</td>
<td>reserved</td>
<td>reserved</td>
<td>Output 5</td>
<td>Output 4</td>
<td>Output 3</td>
<td>Output 2</td>
<td>Output 1</td>
<td>reserved</td>
<td>Ready</td>
<td>Latch</td>
<td>reserved</td>
<td>Pass/Fail</td>
</tr>
</tbody>
</table>

### 13.5.5 Sensor Pass/Fail Bits

For the sensor pass/fail bits, pass = 1 and fail = 0.

**Table 25: Sensor Pass/Fail Bits**

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>15</th>
<th>14</th>
<th>13</th>
<th>12</th>
<th>11</th>
<th>10</th>
<th>9</th>
<th>8</th>
<th>7</th>
<th>6</th>
<th>5</th>
<th>4</th>
<th>3</th>
<th>2</th>
<th>1</th>
<th>0</th>
</tr>
</thead>
</table>

### 13.5.6 Tool-Specific Results: PCCC

Configure the VE to output user-defined, tool-specific results to the PLC using a custom map.

The output submodule includes both system-defined and user-defined results in the map. To set the user-defined, tool-specific results in the custom map, navigate: **System Settings > Communications > Industrial Protocols**.
The results are configurable only for the current inspection. However, all user-defined results in the custom map are shown on the Industrial Protocols tab whether or not they are included in the current inspection. To make changes to a different inspection, switch to the desired inspection and then make changes to the custom map. Updating the map does not disconnect the sensor from the PLC.

To configure the map:

1. Click \( \square \) to add a new line to the map.
2. Set the Word/Register/Byte, Tool Name, and Result. See the following descriptions for more information.
3. Click **Apply Changes** to send the current map to the camera.

**Important:** Click **Apply Changes** or all user-defined data is lost when you click away from the Industrial Protocols tab.

4. Click \( \square \) to print and save a PDF of the current map. The PDF includes all data, whether system-defined or user-defined.
5. To return the map to the default settings, click \( \square \). All user-defined output data is deleted.

**Column descriptions:**

**WORD #**
The data location.

**Inspection #**
Shows whether this tool result applies to the current inspection only (inspection number) or to any inspection (ANY) that includes the selected tool.

An Inspection # of ANY means that if an inspection includes a tool with the exact name (for example, AverageGray01), the results are output. If an inspection does not have a tool with the exact name (for example AverageGrayAssemblyLine01), no results are output for that tool and that inspection.

**Tool Type**
Displays a graphic that represents the type of tool selected in the Tool Name column.
Tool Name
Select the desired Tool Name from the list. The list includes the tools available in the current inspection only. Select a different inspection from the inspection list, if necessary.

Result
The information to output.

Data Type
The type of information to output.

Actions
Click \( \) to delete a result. You cannot delete system-defined results that contain the \( \) symbol.

13.6 PROFINET®

PROFINET® is a data communication protocol for industrial automation and processes. PROFINET IO defines how controllers (IO controllers) and peripheral devices (IO devices) exchange data in real time.

The image sensor, VE Series camera, supports PROFINET IO. The data communication protocol is TCP/IP; the data transmission medium is copper wire; the PROFINET conformance class is CC-A.25

Note: In this document, outputs from the VE device are referred to as "inputs" to the controller (PLC). Outputs from the controller (PLC) are referred to as "inputs" to the VE device.

13.6.1 General Station Description (GSD) File

The General Station Description (GSD) file contains module information, such as:
- Configuration data
- Data information (pass count, inspection status, etc.)
- Diagnostics

13.6.2 VE Series camera PROFINET IO Data Model

The PROFINET IO data model is based on the typical, expandable field device that has a backplane with slots. Modules and submodules have different functionalities.

Modules are plugged into slots; submodules are plugged into subslots. In the PROFINET IO data model, Slot 0 Subslot 1 is reserved for the Device Access Point (DAP) or network interface.

Both modules and submodules are used to control the type and volume of data that is sent to the controller (PLC).
- A submodule is typically designated as input type, output type, or combined input/output type
- An input submodule is used to send data to the controller (PLC)
- An output submodule is used to receive data from the controller (PLC)
- The combined input/output submodule simultaneously receives and sends data in both directions

13.6.3 Configure the VE Series Smart Camera for a PROFINET IO Connection

The VE Series camera and the controller (PLC) must be configured for PROFINET®.

1. On the System Settings screen, select Communications, then select the Industrial Protocols tab.
2. Select PROFINET from the Protocol list.
   The sensor configuration is complete. Configure the PLC to complete the PROFINET connection.

The default PROFINET configuration consists of a single module plugged into Slot 1. This module, called the Device Control and Status Module, accepts two submodules: the Inspection Result Submodule, plugged into Subslot 1, and the Device Control Submodule, plugged into Subslot 2.

The Inspection Result Submodule provides the inspection results from the VE Series camera, including Pass Count, Fail Count, and Current Inspection Time. See Table 30 (p. 209).

---

24 PROFINET® is a registered trademark of PROFIBUS Nutzerorganisation e.V.
25 CC-A ensures that the device has the minimum properties regarding functionality and interoperability.
Note: The Inspection Result Submodule does not provide any sensor-specific output data.

The Device Control Submodule allows the user to issue commands to the VE, such as Trigger, TEACH, and Product Change. This submodule also provides the user with command feedback. See Table 31 (p. 210).

13.6.4 Description of Modules and Submodules

Table 26: Module Slot Assignment

<table>
<thead>
<tr>
<th>Slot</th>
<th>Module</th>
</tr>
</thead>
<tbody>
<tr>
<td>Slot 1</td>
<td>VE Control and Status Module</td>
</tr>
<tr>
<td>Slot 2</td>
<td>VE Output Module</td>
</tr>
<tr>
<td>Slot 3</td>
<td>VE Input Module</td>
</tr>
</tbody>
</table>

Table 27: VE Control and Status Module (Ident 0×000010)

<table>
<thead>
<tr>
<th>Subslot</th>
<th>Submodule</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Subslot 1</td>
<td>VE Inspection Results Submodule (see VE Inspection Results Submodule (p. 209))</td>
<td>Always present.</td>
</tr>
<tr>
<td>Subslot 2</td>
<td>VE Device Control Submodule (see VE Device Control Submodule (p. 210))</td>
<td>Present by default, but can be removed.</td>
</tr>
</tbody>
</table>

Table 28: Sensor Output Module (Ident 0×000040)

<table>
<thead>
<tr>
<th>Subslot 1</th>
<th>Submodule</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Subslot 1</td>
<td>Sensor output submodules (various) (see Sensor Output Submodules (p. 213))</td>
<td>There are six versions of this submodule supporting payloads of 16, 32, 64, 128, 256, and 512 bytes.</td>
</tr>
</tbody>
</table>

Table 29: Sensor Input Module (Ident 0×000041)

<table>
<thead>
<tr>
<th>Subslot 1</th>
<th>Submodule</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Subslot 1</td>
<td>Sensor input submodules (see Sensor Input Submodule (p. 215))</td>
<td>This module is input only.</td>
</tr>
</tbody>
</table>
13.6.5 Description of Submodules

VE Inspection Results Submodule

The VE Inspection Result submodule contains inspection results and sends input data into the controller (PLC). This submodule is plugged into Slot 1 Subslot 1 and cannot be removed.

Table 30: VE Inspection Result Submodule (Ident 0x000101)

<table>
<thead>
<tr>
<th>PLC Input Data Name</th>
<th>Input Data Type</th>
<th>PLC Output Data Name</th>
<th>Output Data Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inspection Status Word</td>
<td>Unsigned16</td>
<td>Not applicable</td>
<td>Not applicable</td>
</tr>
<tr>
<td>Inspection Number</td>
<td>Unsigned32</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Sensor Pass/Fail Bits</td>
<td>Unsigned32</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Iteration Count</td>
<td>Unsigned32</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Pass Count</td>
<td>Unsigned32</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Fail Count</td>
<td>Unsigned32</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Missed Trigger Count</td>
<td>Unsigned32</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Current Inspection Time</td>
<td>Unsigned32</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Inspection Status Word

<table>
<thead>
<tr>
<th>Bit Position for Cyclic Input Data</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bit 0</td>
<td>System Ready</td>
</tr>
<tr>
<td>Bit 1</td>
<td>Inspection Pass/Fail</td>
</tr>
<tr>
<td>Bit 3</td>
<td>Ready Signal Latch</td>
</tr>
<tr>
<td>Bit 5</td>
<td>Output 1 ON/OFF</td>
</tr>
<tr>
<td>Bit 6</td>
<td>Output 2 ON/OFF</td>
</tr>
<tr>
<td>Bit 7</td>
<td>Output 3 ON/OFF</td>
</tr>
<tr>
<td>Bit 8</td>
<td>Output 4 ON/OFF</td>
</tr>
<tr>
<td>Bit 9</td>
<td>Output 5 ON/OFF</td>
</tr>
</tbody>
</table>

Sensor Pass/Fail Bits

<table>
<thead>
<tr>
<th>Bit Position</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bit 0</td>
<td>Camera Tool Pass/Fail</td>
</tr>
<tr>
<td>Bit 1</td>
<td>Vision Tool 1 Pass/Fail</td>
</tr>
<tr>
<td>...</td>
<td>...</td>
</tr>
<tr>
<td>Bit 32</td>
<td>Vision Tool 31 Pass/Fail</td>
</tr>
</tbody>
</table>
VE Device Control Submodule

The VE Device Control Submodule contains controller (PLC) input and output data, including device controls for the VE. The Device Control Submodule is plugged into Slot 1, Subslot 2 by default but it can be removed.

Table 31: VE Device Control Submodule (Ident 0x000001)

<table>
<thead>
<tr>
<th>PLC Input Data Name</th>
<th>Input Data Type</th>
<th>PLC Output Data Name</th>
<th>Output Data Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>Device Control ACK Word</td>
<td>Unsigned16</td>
<td>Device Control Command Word</td>
<td>Unsigned16</td>
</tr>
<tr>
<td>Return Error Code</td>
<td>Unsigned32</td>
<td>Product Change Number</td>
<td>Unsigned32</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Device Control ACK Word</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bit 0</td>
<td>Product Change Acknowledgement</td>
</tr>
<tr>
<td>Bit 1</td>
<td>Teach Latch Acknowledgement</td>
</tr>
<tr>
<td>Bit 2</td>
<td>Trigger Acknowledgement</td>
</tr>
<tr>
<td>Bit 7</td>
<td>FTP Input String Acknowledgement</td>
</tr>
<tr>
<td>Bit 13</td>
<td>Teach Error</td>
</tr>
<tr>
<td>Bit 14</td>
<td>System Error</td>
</tr>
<tr>
<td>Bit 15</td>
<td>Command Execution Error</td>
</tr>
</tbody>
</table>

The following rules apply for the use of input bit commands:
- Only one VE Series camera input bit can be set at a time
- Corresponding ACK bits are set high only on completion of the command (if the VE input bit is still high)
- Corresponding ACK bits are cleared when the VE input bit is cleared
- When multiple VE input bits are set simultaneously, the Execution Error input bit is set and an Error Code value is reported in the Error Code register
- The Execution Error VE output bit is cleared when all ACK bits are cleared, or a new valid command is received
Write 0 to Device Control Command Word

Make sure Camera is Ready – bit 0 is set to 1 in Inspection Status Word

Execute Trigger: set bit 2 of the Device Command Word to 1

Is Trigger ACK (bit 2 in Device Control ACK word) set to 1?

Yes

Is Execution Error (Device Control ACK Word bit 15) set to 1?

Yes

Read error code. Correct the error condition

No

Trigger Successful. Read values as required

Done

Figure 353. Trigger—PROFINET

X, Y, Z: Represent snapshots in time

Figure 354. Trigger Timing Diagram
Start

Write 0 to Device Control Command Word

Make sure camera is ready – bit 0 is set to 1 in Inspection Status Word

Execute Teach Latch: set bit 1 of the Device Command Word to 1

Is Teach Latch ACK (bit 1 in Device Control ACK word) set to 1?

Yes

Is Execution Error (Device Control ACK Word bit 15) set to 1?

Yes

Read error code. Correct the error condition

No

Teach Latch successful. The next valid trigger teaches camera the new condition. After that trigger, examine bit 1 in the Inspection Status Word. If it is set to 1, Teach was executed successfully. If it is set to 0, Teach was unsuccessful.

Done

No

Verify:
Ready = 1
TeachLatchACK = 0
TeachLatch = ‘1
Teach will execute on next trigger

Figure 355. TEACH—PROFINET

Figure 356. Teach Latch Timing Diagram

X, Y, Z: Represent snapshots in time
Sensor Output Submodules

The Sensor Output Submodules contain user-defined maps of sensor output data. There are six versions with 16, 32, 64, 128, 256, and 512 bytes, depending on the size of the output data. A sensor output submodule can be added to slot 2, subslot 1.

Table 32: Sensor Output Submodule

<table>
<thead>
<tr>
<th>Submodule</th>
<th>PLC Input Data</th>
<th>PLC Output Data</th>
</tr>
</thead>
<tbody>
<tr>
<td>Name</td>
<td>Ident No.</td>
<td>Type</td>
</tr>
<tr>
<td>16-Byte Custom Map</td>
<td>0x000028</td>
<td>User-mapped Sensor Result Data Block</td>
</tr>
</tbody>
</table>
### Tool-Specific Results: PROFINET

Configure the VE to output user-defined, tool-specific results to the PLC using a custom map.

The sensor output submodule includes both system-defined and user-defined results in the map. To set the user-defined, tool-specific results, navigate: **System Settings > Communications > Industrial Protocols**.

#### Tool-Specific Results: PROFINET

Configure the VE to output user-defined, tool-specific results to the PLC using a custom map.

The sensor output submodule includes both system-defined and user-defined results in the map. To set the user-defined, tool-specific results, navigate: **System Settings > Communications > Industrial Protocols**.

The results are configurable only for the current inspection. However, all user-defined results in the custom map are shown on the Industrial Protocols tab whether or not they are included in the current inspection. To make changes to a different inspection, switch to the desired inspection and then make changes to the custom map. Updating the map does not disconnect the sensor from the PLC.

To configure the map:

1. Click ![add](add_icon.png) to add a new line to the map.
2. Set the Word/Register/Byte, Tool Name, and Result. See the following descriptions for more information.
3. Click **Apply Changes** to send the current map to the camera.

**Important:** Click **Apply Changes** or all user-defined data is lost when you click away from the **Industrial Protocols** tab.
4. Click to print and save a PDF of the current map. The PDF includes all data, whether system-defined or user-defined.

5. To return the map to the default settings, click . All user-defined output data is deleted.

Column descriptions:

**Byte**
The data location.

**Inspection #**
Shows whether this tool result applies to the current inspection only (inspection number) or to any inspection (ANY) that includes the selected tool.

An Inspection # of ANY means that if an inspection includes a tool with the exact name (for example, AverageGray01), the results are output. If an inspection does not have a tool with the exact name (for example AverageGrayAssemblyLine01), no results are output for that tool and that inspection.

**Tool Type**
Displays a graphic that represents the type of tool selected in the Tool Name column.

**Tool Name**
Select the desired Tool Name from the list. The list includes the tools available in the current inspection only. Select a different inspection from the inspection list, if necessary.

**Result**
The information to output.

**Data Type**
The type of information to output.

**Actions**
Click to delete a result.

---

**Sensor Input Submodule**
Ident 0x000130

<table>
<thead>
<tr>
<th>Byte</th>
<th>PLC Data Name</th>
<th>Data Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>0 - 3</td>
<td>FTP Filename String Length</td>
<td>32-bit integer</td>
</tr>
<tr>
<td>4 - 55</td>
<td>FTP Filename String</td>
<td>String (52 Characters)</td>
</tr>
</tbody>
</table>

To use this submodule, the **Industrial Protocol String** checkbox must be selected. See *Image Export: FTP* (p. 163).

---

**13.6.6 Configuration Instructions**

**Using Siemens TIA Portal (v13) Software**

**Installing the Banner VE Series camera GSD File**

Use these instructions to install the Banner VE Series camera GSD file in the Siemens TIA Portal (v13) software. Use these instructions as a basis for installing the Banner VE Series camera GSD file in another controller (PLC).

1. Start the Siemens TIA Portal (v13) software.
2. Click **Open existing project**.
3. Select a project and open it.
4. Click **Devices & networks** after the project has been uploaded.
5. Click **Configure networks**.

6. Click **Options** and select **Install general station description file (GSD)**.
The **Install general station description file** window opens.

7. Click the browse button (...) to the right of the **Source path** field.

8. Navigate to `C:\Users\Public\Documents\Banner Vision Manager\VE Series\Industrial Protocols\Profinet`.

9. Select the VE GSD file.

10. Click **Install**.
The system installs the VE GSD file and places it in the Hardware catalog. In the above example, the VE GSD file is located under Other field devices > PROFINET IO > Sensors > Banner Engineering Corp. > Banner Vision Sensors > VE Series Vision Sensor > VE Series > VE.

**Note:** If the VE GSD file does not install properly, save the log and contact Banner Engineering Corp.

### Adding a Device to a Project

Use these instructions to add a VE Series camera device to a Siemens TIA Portal (v13) project, and to configure the device. Use these instructions as a basis for adding a VE Series camera device to another controller (PLC).

1. Start the Siemens TIA Portal (v13) software.
2. Click **Open existing project**.
3. Select a project and open it.
4. Click **Devices & networks** after the project has been uploaded.
5. Click **Configure networks**.

**Network view** displays.

*Note: For Step 6 through Step 10, **Network view** must be open.*

6. Locate the VE Series camera in the **Hardware catalog**.
In the above example, the VE device is located under Other field devices > PROFINET IO > Sensors > Banner Engineering Corp > Banner Vision Sensors > VE Series Vision Sensor > VE Series > VE.

7. Select the device and add it to the configuration.

<table>
<thead>
<tr>
<th>Selection Option</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drag</td>
<td>Drag the VE from the Hardware catalog directly into the configuration.</td>
</tr>
<tr>
<td>Double-click</td>
<td>Double-click on the VE and add it to the configuration.</td>
</tr>
</tbody>
</table>

8. Click the green square on the VE icon. Drag the pointer to the green square on the PLC_1 icon to connect the device to the controller (PLC).

The connection is made.

9. Double-click the VE icon to open the Device window.
10. Select the desired modules or submodules from the Hardware catalog and drag them onto the Device overview tab on the Device view tab.

The VE device is configured.
Changing the Device IP Address

Use these instructions to change the IP address of the VE device, using the Siemens TIA Portal (v13) software. Use these instructions as a basis if you are using another controller (PLC).

1. Start the Siemens TIA Portal (v13) software.
2. Click **Open existing project**.
3. Select a project and open it.
4. Click **Devices & networks** after the project has been uploaded to go to **Network view**.

**Network View** displays.

5. Double-click on the VE icon to open the **Device view**.
6. Click on the VE icon in the graphic area of the **Device view** to open the **Module properties** window. The module can now be configured.
7. Click **Properties**.
8. Click **General**.
9. Select **PROFINET interface > Ethernet addresses**.

10. Select **Set IP address in the project**.

The project sets the IP address of the device.

11. Enter the IP address.
12. Right-click on the device icon and select **Online & diagnostics**.
The **Online & diagnostics** window displays.

13. Select **Assign IP address** under **Functions**.
14. Click **Accessible devices**.

![Image of Online & Diagnostics window](image)

**Figure 373. Online & Diagnostics**

The **Select device** window searches the network for available devices.

15. Determine the device to be adjusted via the MAC address and select it.

![Image of Assign IP Address—Accessible Devices](image)

**Figure 374. Assign IP Address—Accessible Devices**

**Note:** Use the Vision Manager software to find the MAC address: **Home > Sensor Neighborhood > Active Sensors**.

16. Click **Apply**.
The IP address for the device is updated.

17. Click Assign IP address to complete the step.

This step is completed for every device.

Note: PROFINET devices commonly lack an IP address on startup (IP address = all zeros). However, VE devices require an IP address to connect to Vision Manager to set the device configuration.

By default, each camera shipped from the factory is assigned the IP address 192.168.0.1. The default address can be changed using Vision Manager.

Immediately after the PROFINET protocol has been enabled in the camera, but before the PLC discovers and connects to the camera, the camera will retain its IP address. After the PLC discovers and connects to the camera, the behavior of the IP address depends on how the PLC was configured to assign the camera IP address. Two configuration options are available.

- The IP address is set in the project: If the PLC is told to assign the camera IP address (for example, using the Set IP address in the project option in Siemens TIA Portal), the camera receives the specified address, but only after the program has been loaded into the PLC and is running.

  If the camera is restarted after it was discovered and configured by the PLC, the camera has an IP address of 0.0.0.0 until the PLC discovers it and assigns it the specified address again.

  When the camera has no IP address assigned, it is still possible to assign an IP address to the camera using Vision Manager. However, if this address is different than what is specified in the PLC, the camera reverts to the address specified in the PLC when the PLC becomes active again.

- The IP address is set at the device: If the PLC is told that the camera IP address is configured at the device (for example, using the IP address is set directly at the device option in Siemens TIA Portal), the camera always retains the IP address that was assigned to through Vision Manager.

These configuration options conform to the PROFINET standard.
Changing the Device Name

Use these instructions to change the name of the VE device, using the Siemens TIA Portal (v13) software. Use these instructions as a basis if you are using another controller (PLC).

1. Open a project and click on Devices & networks to go to the Network view.

![Network View](image)

2. Double-click on the VE icon to open Device view.

3. Click on the VE icon in the graphic area of Device view to open the Module properties window.

4. Click General.

5. Select PROFINET interface [X1] > Ethernet addresses.

![Ethernet Addresses](image)

6. Deselect Generate PROFINET device name automatically.

![PROFINET Device Name](image)

7. Enter a unique name in the PROFINET device name field.

8. Enter a unique device number in the Device number field.

   **Note:** Each device number is used only once.

9. Right-click on the device icon and select Online & diagnostics.
10. Select **Assign name** under **Functions**.

   The **Assign name** window displays. The devices in the network are discovered.

11. Select the device that will have a name assigned to it.

12. Click **Assign name** to start the process.

   The name is assigned.
## 13.7 Troubleshooting

### 13.7.1 Industrial Ethernet Error Codes

The VE Series camera provides error codes when coil bit commands fail to execute successfully. If such an error occurs, the Execution Error flag is set in the Output Bits/Status Register. When this bit is set, read the Error Code register to know the reason for the failure.

<table>
<thead>
<tr>
<th>Error Code</th>
<th>Text ID</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>520</td>
<td>IE_COIL_ACTION_FAILED</td>
<td>The coil action resulted in a failure.</td>
<td>Clear all coil bits. Verify that the corresponding acknowledgement bits are reset to zero. The error code clears when the next valid command is issued.</td>
</tr>
<tr>
<td>521</td>
<td>IE_COIL_ALREADY_BUSY</td>
<td>The coil was asserted before the previous execution completed.</td>
<td>Verify that the corresponding acknowledgement bit gets set. Then clear all coil bits and try again.</td>
</tr>
<tr>
<td>522</td>
<td>IE_COIL_NOT_FINISHED</td>
<td>The coil was de-asserted prior to the execution completing.</td>
<td>Verify that the corresponding acknowledgement bit gets set. Then clear all coil bits and try again.</td>
</tr>
<tr>
<td>523</td>
<td>IE_COIL_ANOTHER_ACTION_PENDING</td>
<td>The coil was asserted prior to another coil execution completing.</td>
<td>Verify that the corresponding acknowledgement bit gets set. Then clear all coil bits and try again.</td>
</tr>
<tr>
<td>524</td>
<td>IE_COIL_MULTIPLES_DETECTED</td>
<td>Multiple coils were asserted simultaneously.</td>
<td>Clear all coil bits. Verify that the corresponding acknowledgement bits are reset to zero. The error code clears when the next valid command is issued.</td>
</tr>
<tr>
<td>525</td>
<td>IE_COIL_ACK_INHIBITED</td>
<td>The coil action’s output ACK was inhibited because the input coil was no longer set.</td>
<td>Keep the corresponding coil bit set during the execution period.</td>
</tr>
<tr>
<td>10252</td>
<td>COMMAND_NOT_FINISHED</td>
<td>Attempt to issue command when a previous command has not finished</td>
<td>Wait for acknowledgement of the previous command before issuing a new command.</td>
</tr>
<tr>
<td>10900</td>
<td>SENSOR_NOT_READY</td>
<td>Command specified requires the device to be in the READY state.</td>
<td>Verify that the sensor bootup or product change operation is complete. Use of ONLINE output signal is recommended.</td>
</tr>
<tr>
<td>80200</td>
<td>SYSTEM_ERROR_NOT_ACTIVE</td>
<td>The System Error must be active to execute this command</td>
<td>When no system error is active, do not set the bit to clear system errors.</td>
</tr>
<tr>
<td>80300</td>
<td>TEACH_SENSOR_TYPE_INVALID</td>
<td>Teach requires Match sensor.</td>
<td>Execute a teach command only when a Match tool is present in the currently running inspection.</td>
</tr>
<tr>
<td>80400</td>
<td>PRODUCT_CHANGE_WHEN_NOT_READY</td>
<td>The sensor must be in the Ready state to perform a product change.</td>
<td>Clear the Product Change bit. Verify that the Product Change acknowledgement bit has been reset to zero. Wait until the sensor is Ready. Re-assert the Product Change bit.</td>
</tr>
<tr>
<td>80401</td>
<td>PRODUCT_CHANGE_INVALID_INSPECTION</td>
<td>Attempt to product change to an unknown or invalid inspection.</td>
<td>Clear the Product Change bit. Verify that the Product Change acknowledgement bit has been reset to zero. Set the inspection slot to a valid value. Re-assert the Product Change bit.</td>
</tr>
<tr>
<td>80403</td>
<td>PRODUCT_CHANGE_TO_SAME_INSPECTION</td>
<td>Attempt to product change to the same inspection.</td>
<td>Product change to a different inspection.</td>
</tr>
</tbody>
</table>
13.7.2 PROFINET

Discovering VE Series camera Devices

The Siemens TIA Portal (v13) software discovery and configuration protocols are used to discover VE Series camera devices on a network.

1. Start the Siemens TIA Portal (v13) software.
2. Click **Open an existing project**.
3. Select a project and open it.
4. Click **Devices & networks** after the project has been uploaded.
5. Click **Configure networks**.
6. Click the **Accessible devices** icon. The **Accessible devices** window opens.
7. Select an interface connection in the **Type of the PG/PC interface** list.
8. Select an interface connection in the **PG/PC interface** list.

   ![Figure 383. PG/PC Interface](image)

   The PC scans the network for PROFINET® devices. If the device you are looking for is not present, check the cabling.

Example of Scanning Results

Under **Online status information**, the scan shows that three devices were found.

![Figure 384. Select Device—Online Status Information](image)

Diagnosing Errors

The Siemens TIA Portal (v13) software includes numerous diagnostic tools. When a computer is connected to the controller (PLC), diagnostic information is available. The controller (PLC) generates a message that displays in the **Diagnostics** window. A flashing red light on the CPU module of the controller (PLC) indicates an error.

1. Click on the text in the **Details** column to request detailed information about the device that caused the error.
All system and device messages are displayed in the **Diagnostics buffer** window under **Events** and **Details on event**.

2. Select a message in the table, **Display CPU Time Stamps in PG/PC local time**.

   ![Figure 386. Diagnostics Buffer](image)

   The respective information displays in the **Description** field under **Details on event**.

3. Read the message to learn about the error and resolve it. When the error is resolved, the icon that corresponds to the displayed message is green.
14 Webserver Image Viewing

The webserver automatically refreshes live images from the VE.

Access the images using a URL. The URL is the IP address of the VE followed by /liveimage.html. For example, a VE with the IP address 192.168.0.195 has a URL of: http://192.168.0.195/liveimage.html

The default resolution of the image using this URL is 640 × 480 pixels, regardless of the native resolution of the VE. The default refresh interval is 1 second, regardless of the total inspection time or the camera trigger rate.

14.1 Image Size

All images sent from the Webserver are 8-bit grayscale Windows bitmaps (.bmp).

The default size of the images is 640 × 480 pixels. To preserve the aspect ratio of the raw image, a smaller version of the raw camera image is centered in a 640 × 480 frame and black pixels are added around the image as needed.

In the following figure, a WVGA model VE (752 × 480 raw image) has a smaller version of the raw image (represented by the gray box) centered within the 640 × 480 frame. Black pixels are added to both the top and bottom because the height of the raw picture is smaller than the height of the frame. The aspect ratio of the raw VE image is preserved, creating a scaled 640 × 408 raw image inset in the 640 × 480 frame.

![Figure 387. WVGA image in 640 × 480 frame](image1)

It is possible to access an image larger than 640 × 480 pixels. To do this, use a slightly different URL format that includes the desired width and height and refresh rate within the URL. For example: http://192.168.0.195/liveimage_w800_h600_r250.html.

In this format, the “w” and “h” are the desired width and height, in pixels, of the frame, and the “r” is the desired refresh rate, in milliseconds. The maximum frame size is W = 1920 pixels and H = 1080 pixels. The minimum refresh value is 250 milliseconds.

In the following example, a 5 MP model VE has a smaller version of the raw image (represented by the gray box) centered within a custom 800 × 600 frame.

![Figure 388. 5 MP image in 800 × 600 frame](image2)

Reduce the presence of black fill pixels by choosing a frame size proportional to the raw image size of the desired VE. The table below shows the maximum width and height image sizes, based on VE model used.

<table>
<thead>
<tr>
<th>Resolution</th>
<th>Width, maximum</th>
<th>Height, maximum</th>
<th>Aspect Ratio</th>
<th>Example Width</th>
<th>Example Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>WVGA</td>
<td>752</td>
<td>480</td>
<td>1.33</td>
<td>500</td>
<td>320</td>
</tr>
<tr>
<td>1.3 MP</td>
<td>1280</td>
<td>1024</td>
<td>1.57</td>
<td>500</td>
<td>400</td>
</tr>
<tr>
<td>2 MP</td>
<td>1600</td>
<td>1200</td>
<td>1.25</td>
<td>500</td>
<td>376</td>
</tr>
<tr>
<td>5 MP</td>
<td>2592</td>
<td>2048</td>
<td>1.27</td>
<td>500</td>
<td>396</td>
</tr>
</tbody>
</table>

**Note:** To ensure maximum compatibility with all browser and computer types, the width and height values should be divisible by 4.

---

Note: The maximum size image available via the Webserver is 1920 w × 1080 h.
14.2 Images on Example HMIs

On a Human Machine Interface (HMI), the size of the embedded web component should match the URL framed output image size. See the following examples.

Allen-Bradley PanelView Plus 7 Performance Series HMI

On an Allen-Bradley PanelView Plus 7 Performance Series HMI, the web component used to display the image is called *ME Web Browser Control*. When entering the image URL, use double quotes around the URL string.

![Example URL with double quotes entered in an Allen-Bradley ME Web Browser Control](image)

Siemens Simatic TP 1500 HMI

On a Siemens Simatic TP 1500 HMI, the web component used to display the image is called *HTML Browser*. Enter the URL in *Properties > General*, as shown in the following figure.

![Example URL in a Siemens TP 1500 HTML Browser](image)

Proface Win GP Windows Runtime HMI

On a Proface Win GP Windows Runtime HMI (SP5000 Series Open Box, PS5000 Series IPC, and General Windows PC), use the *Switch Feature Special Switch* to start an external application and to pass a parameter with the required URL.
RedLion HMI

On a RedLion HMI, the IP Camera protocol is used to make a connection to the image webserver.

Enter the following information:

- **IP Address**—The IP address of the sensor
- **Port Number**—80
- **Image URI**—The path to the bitmap image component served from the webserver

For display, use a Camera primitive linked to this IP Camera protocol.

- **Note**: Polling for an image more frequently than every 100 ms is not recommended.
14.3 Images on a Web Browser

When viewed from a desktop PC web browser, the framed output image is centered on a white background.

![Image](image.png)

*Figure 393. 5 MP image in 800 x 600 frame, centered in white background (web browser)*
15 Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Solution</th>
</tr>
</thead>
</table>
| The Vision Manager software will not connect to my sensor | Make sure that:  
  • The sensor is powered on  
  • The sensor is connected to the computer or the network  
  • You are connecting to the correct sensor (verify the sensor name and IP address) |
| The image is not clear                      | Make sure that:  
  • The lens is properly screwed onto the sensor  
  • The lens is clean  
  • The lens is properly focused (see Acquire a Good Image (p. 17)) |
| No images appear in the Image pane          | Make sure that:  
  • The exposure is correct (run Auto Exposure)  
  • The sensor is receiving trigger signals |
| I changed a test parameter but the test does not seem to be working | Make sure that the test parameter checkbox is selected to enable the test parameter |

Depending on the situation, a message may appear on the computer screen. These messages include an identification number, a message description, and a list of recommended solutions. There is also an option to send a report to Banner Engineering.

15.1 Vision Manager Error Codes

<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
</table>
| 10000      | The sensor's feature set is too old to work with this version of Vision Manager. | • Update the sensor firmware to a version compatible with this application  
  • Install an older version of this application |
| 10001      | The sensor’s feature set is too new to work with this version of Vision Manager. | • Install a newer version of this application  
  • Downgrade the sensor firmware to a version compatible with this application |
| 10005      | The sensor was not found at the specified IP address. Network PING results indicate no device present at the specified IP address. | • Verify the sensor is energized  
  • Verify the sensor communication cable is connected  
  • Verify all inline network equipment is energized, properly configured and connected  
  • Verify all required network equipment cables are connected  
  • Verify the network adaptor is properly configured  
  • Verify the sensor IP address is valid  
  • Verify the sensor subnet is valid |
| 10010      | A connection to the sensor could not be established. One or more required channels failed to connect. | • Verify the sensor is energized  
  • Verify the sensor communication cable is connected  
  • Verify all inline network equipment is energized, properly configured and connected  
  • Verify all required network equipment cables are connected  
  • Verify the network adaptor is properly configured  
  • Verify the sensor IP address is valid  
  • Verify there are no other devices using the same IP address  
  • Verify the sensor subnet is valid  
  • Verify the sensor can be successfully pinged  
  • Verify the network firewall settings support connection to the sensor |
<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
</table>
| 10011      | A connection to the sensor could not be established. One or more required channels failed to connect. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10012      | A connection to the sensor could not be established. A timeout occurred connecting required channels. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10020      | A connection to the sensor could not be established. One or more required channels failed to connect. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10021      | A connection to the sensor could not be established. One or more required channels failed to connect. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10022      | The connection to the sensor was lost while sending data.                     | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
</table>
| 10023      | The connection to the sensor was lost while receiving data. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10024      | The connection to the sensor was lost while receiving data. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10025      | The connection to the sensor was lost while receiving data. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10026      | The connection to the sensor was lost while receiving data. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 10027      | The connection to the sensor was lost.             | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
<table>
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<tr>
<th>Error Code</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>10040</td>
<td>The device at the specified IP address is already connected to another application. This can happen when another Vision Manager is already connected to the sensor.</td>
<td>• Disconnect the other application and try again</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify there are no other devices using the same IP address</td>
</tr>
<tr>
<td>10041</td>
<td>The device at the specified IP address rejected the connection attempt. This can happen when the network device does not support the Vision Manager protocol.</td>
<td>• Verify the sensor’s firmware version is compatible with this application</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify the device at the specified IP address is a Banner Vision sensor</td>
</tr>
<tr>
<td>10050</td>
<td>The connection to the sensor was lost.</td>
<td>• Verify the sensor is energized</td>
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<tr>
<td></td>
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<td>• Verify the sensor communication cable is connected</td>
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<td>• Verify all inline network equipment is energized, properly configured and connected</td>
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<td>• Verify all required network equipment cables are connected</td>
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<td>• Verify the network adaptor is properly configured</td>
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<td></td>
<td>• Verify the network firewall settings support connection to the sensor</td>
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<tr>
<td>10051</td>
<td>The connection to the sensor was lost.</td>
<td>• Verify the sensor is energized</td>
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<td>• Verify the sensor communication cable is connected</td>
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<td>• Verify the network firewall settings support connection to the sensor</td>
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<tr>
<td>10053</td>
<td>The connection to the sensor was lost while receiving data.</td>
<td>• Verify the sensor is energized</td>
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<tr>
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<td>• Verify the sensor communication cable is connected</td>
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<td>• Verify the network firewall settings support connection to the sensor</td>
</tr>
<tr>
<td>10054</td>
<td>The Connection to the sensor was lost while receiving data.</td>
<td>• Verify the sensor is energized</td>
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<td>• Verify the sensor communication cable is connected</td>
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<td>• Verify the network firewall settings support connection to the sensor</td>
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</tr>
<tr>
<td>10055</td>
<td>The Connection to the sensor was lost due to network keep alive expiration.</td>
<td>• Verify the network adaptor link speed and duplex settings</td>
</tr>
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<td></td>
<td>• Verify the is sensor not stalled, or in shutdown mode</td>
</tr>
<tr>
<td>10070</td>
<td>The Connection to sensor was lost due to a receive state machine error.</td>
<td>• Verify the is sensor not stalled, or in shutdown mode</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify the sensor is supported by this version</td>
</tr>
<tr>
<td>10071</td>
<td>The Connection to sensor was lost due to a receive state machine error.</td>
<td>• Verify the is sensor not stalled, or in shutdown mode</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify the sensor is supported by this version</td>
</tr>
<tr>
<td>10080</td>
<td>The Connection to sensor was lost.</td>
<td>• Verify the sensor is energized</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify the sensor communication cable is connected</td>
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<td>• Verify the network adaptor is properly configured</td>
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<td>• Verify the network firewall settings support connection to the sensor</td>
</tr>
<tr>
<td>10085</td>
<td>A connection to the sensor could not be established. One or more required</td>
<td>• Verify the sensor is energized</td>
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<tr>
<td></td>
<td>channels failed to connect.</td>
<td>• Verify the sensor communication cable is connected</td>
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<td>• Verify all inline network equipment is energized, properly configured and connected</td>
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<td>• Verify the sensor can be successfully pinged</td>
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<td>• Verify the network firewall settings support connection to the sensor</td>
</tr>
<tr>
<td>10086</td>
<td>The connection to the sensor was lost while receiving data.</td>
<td>• Verify the sensor is energized</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify the sensor communication cable is connected</td>
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<td>• Verify the sensor can be successfully pinged</td>
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<td></td>
<td>• Verify the network firewall settings support connection to the sensor</td>
</tr>
<tr>
<td>10091</td>
<td>Receiving data from the sensor timed out (no data was received).</td>
<td>• Verify the network adaptor link speed and duplex settings</td>
</tr>
<tr>
<td></td>
<td>The connection to the sensor was aborted by this application.</td>
<td>• Verify the is sensor not stalled, or in shutdown mode</td>
</tr>
<tr>
<td>10092</td>
<td>Receiving data from the sensor timed out (partial data was received).</td>
<td>• Verify the network adaptor link speed and duplex settings</td>
</tr>
<tr>
<td></td>
<td>The connection to the sensor was aborted by this application.</td>
<td>• Verify the is sensor not stalled, or in shutdown mode</td>
</tr>
<tr>
<td>10093</td>
<td>A parsing error was detected while receiving data from the sensor.</td>
<td>• Verify the network adaptor link speed and duplex settings</td>
</tr>
<tr>
<td></td>
<td>The connection to the sensor was aborted by this application.</td>
<td>• Verify the is sensor not stalled, or in shutdown mode</td>
</tr>
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</tbody>
</table>
| 10094      | A receive overrun was detected while receiving data from the sensor. The connection to the sensor was aborted by this application. | • Verify the network adaptor link speed and duplex settings  
• Verify the is sensor not stalled, or in shutdown mode |
| 10095      | Receiving data from the sensor timed out (internal error). The connection to the sensor was aborted by this application. | • Verify the network adaptor link speed and duplex settings  
• Verify the is sensor not stalled, or in shutdown mode |
| 10096      | A transmit timeout occurred while sending data to the sensor (no data was sent). The connection to the sensor was aborted by this application. | • Verify the network adaptor link speed and duplex settings  
• Verify the is sensor not stalled, or in shutdown mode |
| 10097      | A transmit timeout occurred while sending data to the sensor (partial data was sent). The connection to the sensor was aborted by this application. | • Verify the network adaptor link speed and duplex settings  
• Verify the is sensor not stalled, or in shutdown mode |
| 10100      | The connection to the sensor was lost while sending data.                    | • Install an newer version of this application  
• Verify the device at the specified IP address is a Banner Vision sensor  
• Verify the sensor’s firmware version is compatible with this application  
• Check the firewall setup on computer  
• Go to Sensor Neighborhood and reconnect to the sensor |
| 10101      | The connection to the sensor was lost while sending data.                    | • Install an newer version of this application  
• Verify the device at the specified IP address is a Banner Vision sensor  
• Verify the sensor’s firmware version is compatible with this application  
• Check the firewall setup on computer  
• Go to Sensor Neighborhood and reconnect to the sensor |
| 10110      | The connection to the sensor was aborted by this application due to an internal processing error. | • Install an newer version of this application  
• Verify the device at the specified IP address is a Banner Vision sensor  
• Verify the sensor’s firmware version is compatible with this application  
• Check the firewall setup on computer  
• Go to Sensor Neighborhood and reconnect to the sensor |
| 10111      | The connection to the sensor was aborted by this application due to an internal processing error. | • Install an newer version of this application  
• Verify the device at the specified IP address is a Banner Vision sensor  
• Verify the sensor’s firmware version is compatible with this application  
• Check the firewall setup on computer  
• Go to Sensor Neighborhood and reconnect to the sensor |
| 10120      | The connection to the sensor was aborted by this application due to an internal processing error. | • Install an newer version of this application  
• Verify the device at the specified IP address is a Banner Vision sensor  
• Verify the sensor’s firmware version is compatible with this application  
• Check the firewall setup on computer  
• Go to Sensor Neighborhood and reconnect to the sensor |
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<th>Error Code</th>
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</tr>
</thead>
<tbody>
<tr>
<td>10125</td>
<td>The connection to the sensor was aborted by this application due to an internal processing error.</td>
<td>• Install an newer version of this application &lt;br&gt; • Verify the device at the specified IP address is a Banner Vision sensor &lt;br&gt; • Verify the sensor’s firmware version is compatible with this application &lt;br&gt; • Check the firewall setup on computer &lt;br&gt; • Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>10126</td>
<td>The connection to the sensor was aborted by this application due to an internal processing error.</td>
<td>• Install an newer version of this application &lt;br&gt; • Verify the device at the specified IP address is a Banner Vision sensor &lt;br&gt; • Verify the sensor’s firmware version is compatible with this application &lt;br&gt; • Check the firewall setup on computer &lt;br&gt; • Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>10140</td>
<td>The Connection to the sensor was lost due to network keep alive expiration.</td>
<td>• Install an newer version of this application &lt;br&gt; • Verify the device at the specified IP address is a Banner Vision sensor &lt;br&gt; • Verify the sensor’s firmware version is compatible with this application &lt;br&gt; • Check the firewall setup on computer &lt;br&gt; • Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>10150</td>
<td>The connection to the sensor was aborted by this application due to an internal processing error.</td>
<td>• Install an newer version of this application &lt;br&gt; • Verify the device at the specified IP address is a Banner Vision sensor &lt;br&gt; • Verify the sensor’s firmware version is compatible with this application &lt;br&gt; • Check the firewall setup on computer &lt;br&gt; • Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>10190</td>
<td>The connection to the sensor was aborted by this application due to an internal threading error.</td>
<td>• Install an newer version of this application &lt;br&gt; • Verify the device at the specified IP address is a Banner Vision sensor &lt;br&gt; • Verify the sensor’s firmware version is compatible with this application &lt;br&gt; • Check the firewall setup on computer &lt;br&gt; • Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>10300</td>
<td>Vision Manager and the sensor's release types must exactly match. Release types are specified as part of the version (e.g. ALPHA, BETA, EVAL). The connection was aborted by this application.</td>
<td>• Install the version of this application which matches the release of the sensor &lt;br&gt; • Update the sensor firmware to match the release type of this application</td>
</tr>
<tr>
<td>10900</td>
<td>The file selected for firmware update is not valid for use with this application.</td>
<td>• Select a firmware update file which is supported by this application</td>
</tr>
<tr>
<td>10910</td>
<td>The file selected for firmware update is too old to work with this application.</td>
<td>• Install an older version of this application</td>
</tr>
<tr>
<td>10911</td>
<td>The file selected for firmware update is too new to work with this application.</td>
<td>• Install an newer version of this application</td>
</tr>
<tr>
<td>10912</td>
<td>The firmware update process timed out.</td>
<td>• Verify the sensor is energized &lt;br&gt; • Verify the is sensor not stalled, or in shutdown mode &lt;br&gt; • Reboot the sensor</td>
</tr>
<tr>
<td>20000</td>
<td>An application error occurred while refreshing the display. An unhandled exception was detected.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>Error Code</td>
<td>Description</td>
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</tr>
<tr>
<td>20001</td>
<td>An application error occurred while refreshing the display. There was a problem parsing data from the sensor.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20010</td>
<td>An application error occurred while refreshing the display. There was a problem creating screen elements.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20011</td>
<td>An application error occurred while refreshing the display. There was a problem releasing screen elements.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20020</td>
<td>An application error occurred while refreshing the display. There was a problem synchronizing data.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20021</td>
<td>An application error occurred while refreshing the display. There was a problem releasing data resources.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20030</td>
<td>An application error occurred while refreshing the display. There was a problem synchronizing with the inspection.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20040</td>
<td>An application error occurred while refreshing the display. There was a problem updating input data.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20041</td>
<td>An application error occurred while refreshing the display. There was a problem updating result data.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20050</td>
<td>This application detected an error while refreshing the display. There was a problem rendering the image.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20060</td>
<td>An application error occurred while refreshing the display. There was a problem updating pixel annotations.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20061</td>
<td>An application error occurred while refreshing the display. There was a problem updating pixel annotations.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20070</td>
<td>An application error occurred while refreshing the display. There was a problem updating vector annotations.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20071</td>
<td>An application error occurred while refreshing the display. There was a problem updating vector annotations.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20072</td>
<td>An application error occurred while refreshing the display. There was a problem releasing vector annotations.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20073</td>
<td>An application error occurred while refreshing the display. There was a problem releasing display elements.</td>
<td>• Go to Sensor Neighborhood and reconnect to the sensor</td>
</tr>
<tr>
<td>20100</td>
<td>There was a problem using the specified file.</td>
<td>• Verify the user has access to the file</td>
</tr>
<tr>
<td>Error Code</td>
<td>Description</td>
<td>Recommended Solution</td>
</tr>
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<td>------------------------------------------------------------------------------</td>
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</tr>
<tr>
<td>20101</td>
<td>An invalid file format was detected.</td>
<td>• Verify the selected file is compatible with this application</td>
</tr>
<tr>
<td>20103</td>
<td>The maximum number of tools has been added to the device.</td>
<td>• Remove some tools from the device</td>
</tr>
<tr>
<td>20104</td>
<td>There was a problem restoring the selected file to the sensor.</td>
<td>• Call Banner Customer Support</td>
</tr>
<tr>
<td>20105</td>
<td>There was a problem creating the backup of the sensor.</td>
<td>• Call Banner Customer Support</td>
</tr>
<tr>
<td>20130</td>
<td>There was a problem viewing the selected inspection log.</td>
<td>• Install a newer version of this application</td>
</tr>
<tr>
<td>20150</td>
<td>Connection to the emulator failed.</td>
<td>• Call Banner Customer Support</td>
</tr>
<tr>
<td>20151</td>
<td>There was an error starting the emulator.</td>
<td>• Reinstall this application</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Check the firewall setup on computer</td>
</tr>
<tr>
<td>20152</td>
<td>The selected emulator could not be found.</td>
<td>• Reinstall this application</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Check the firewall setup on computer</td>
</tr>
<tr>
<td>20153</td>
<td>There was a problem closing the previous emulator session.</td>
<td>• Reboot the computer to end any processes which did not shut down properly</td>
</tr>
<tr>
<td>20154</td>
<td>There was a problem closing the previous emulator session.</td>
<td>• Reboot the computer to end any processes which did not shut down properly</td>
</tr>
<tr>
<td>20155</td>
<td>There was a problem closing the previous emulator session.</td>
<td>• Reboot the computer to end any processes which did not shut down properly</td>
</tr>
<tr>
<td>20156</td>
<td>There was a problem closing the previous emulator session.</td>
<td>• Reboot the computer to end any processes which did not shut down properly</td>
</tr>
<tr>
<td>20157</td>
<td>There was an error starting the emulator.</td>
<td>• Reinstall this application</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Check the firewall setup on computer</td>
</tr>
<tr>
<td>20158</td>
<td>There was an error starting the emulator.</td>
<td>• Reinstall this application</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Check the firewall setup on computer</td>
</tr>
<tr>
<td>20159</td>
<td>There was an error starting the emulator.</td>
<td>• Reinstall this application</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Check the firewall setup on computer</td>
</tr>
</tbody>
</table>
| 20160      | Another emulator session is currently running. Only one emulator session can be run at a time. | • Close the other Vision Manager currently connected to the emulator  
• Reboot the computer to end any processes which did not shut down properly |
| 20203      | Uploading the image to the sensor failed due to timeout.                      | • Reboot the sensor  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
</table>
| 20208      | Downloading the inspection from the sensor failed due to a timeout. | - Reboot the sensor  
- Verify the sensor communication cable is connected  
- Verify all inline network equipment is energized, properly configured and connected  
- Verify all required network equipment cables are connected  
- Verify the network adaptor is properly configured  
- Verify the sensor IP address is valid  
- Verify there are no other devices using the same IP address  
- Verify the sensor subnet is valid  
- Verify the sensor can be successfully pinged  
- Verify the network firewall settings support connection to the sensor |
| 20209      | Inspection download invalid parameter. | - Go to Sensor Neighborhood and reconnect to the sensor  
- Reboot the sensor  
- Update the sensor firmware to the latest version  
- Update the Vision Manager Application to the latest version |
| 20210      | Downloading the inspection from the sensor failed (inspection not found). | - Go to Sensor Neighborhood and reconnect to the sensor  
- Reboot the sensor  
- Update the sensor firmware to the latest version  
- Update the Vision Manager Application to the latest version |
| 20211      | Downloading the inspection from the sensor failed (invalid header detected). | - Go to Sensor Neighborhood and reconnect to the sensor  
- Reboot the sensor  
- Update the sensor firmware to the latest version  
- Update the Vision Manager Application to the latest version |
| 20212      | Downloading the inspection from the sensor failed (incompatibility detected). | - Go to Sensor Neighborhood and reconnect to the sensor  
- Reboot the sensor  
- Update the sensor firmware to the latest version  
- Update the Vision Manager Application to the latest version |
| 20215      | Uploading the inspection to the sensor failed due to a timeout. | - Reboot the sensor  
- Verify the sensor communication cable is connected  
- Verify all inline network equipment is energized, properly configured and connected  
- Verify all required network equipment cables are connected  
- Verify the network adaptor is properly configured  
- Verify the sensor IP address is valid  
- Verify there are no other devices using the same IP address  
- Verify the sensor subnet is valid  
- Verify the sensor can be successfully pinged  
- Verify the network firewall settings support connection to the sensor |
| 20216      | Uploading the inspection to the sensor failed due to an invalid parameter. | - Go to Sensor Neighborhood and reconnect to the sensor  
- Reboot the sensor  
- Update the sensor firmware to the latest version  
- Update the Vision Manager Application to the latest version |
| 20219      | Upload inspection to sensor failed. The inspection being uploaded contains features which are not compatible with the sensor. | - Update the sensor firmware to the latest version  
- Update the Vision Manager Application to the latest version |
<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
</table>
| 20231      | A firmware update error was detected. | • Verify the sensor is energized  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 20232      | A firmware update timeout was detected. | • Reboot the sensor  
• Verify the sensor communication cable is connected  
• Verify all inline network equipment is energized, properly configured and connected  
• Verify all required network equipment cables are connected  
• Verify the network adaptor is properly configured  
• Verify the sensor IP address is valid  
• Verify there are no other devices using the same IP address  
• Verify the sensor subnet is valid  
• Verify the sensor can be successfully pinged  
• Verify the network firewall settings support connection to the sensor |
| 20233      | A maintenance service internal error was detected. | • Go to Sensor Neighborhood and reconnect to the sensor  
• Reboot the sensor  
• Update the sensor firmware to the latest version  
• Update the Vision Manager Application to the latest version |
| 20400      | An application error occurred while applying the new industrial protocol settings. The settings will be reverted to their previous value. | • Update the sensor firmware to the latest version  
• Update the Vision Manager Application to the latest version |
| 20500      | An application error occurred while applying the new data export settings. The settings will be reverted to their previous value. | • Call Banner Customer Support |
| 20600      | An application error occurred while applying the new user profile settings. The settings will be reverted to their previous value. | • Call Banner Customer Support |
| 30151      | Firmware update cannot proceed. Selected sensor may be connected to another Vision Manager application | • Disconnect the other application and try again |
| 30152      | Firmware update cannot be completed due to internal error. | • Reboot the sensor |
| 30153      | Firmware update cannot be completed due to internal error. | • Reboot the sensor |
| 30154      | Firmware update cannot be completed due to internal error. | • Reboot the sensor |
| 30155      | Firmware update cannot be completed due to internal error. | • Reboot the sensor |
| 30156      | Firmware update cannot be completed due to internal error. | • Reboot the sensor |
### Error Code Description Recommended Solution

<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>30157</td>
<td>Firmware update cannot be completed due to internal error.</td>
<td>• Reboot the sensor</td>
</tr>
<tr>
<td>30199</td>
<td>Firmware update cannot be completed due to internal error.</td>
<td>• Call Banner Customer Support</td>
</tr>
</tbody>
</table>

### 15.2 VE Error and Warning Codes

<table>
<thead>
<tr>
<th>ID</th>
<th>Description</th>
<th>Recommended Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 - 999</td>
<td>Internal System Error</td>
<td>• Clear the error using Vision Manager or Industrial Ethernet</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• If the error occurs repeatedly, contact Banner Engineering</td>
</tr>
<tr>
<td>1008</td>
<td>Inspection at selected slot contains unsupported settings.</td>
<td>Delete the inspection and recreate it using current firmware or emulator</td>
</tr>
<tr>
<td>1009</td>
<td>Inspection marked as Startup Inspection could not be loaded at bootup.</td>
<td>A new inspection will be created with default settings</td>
</tr>
<tr>
<td>1100</td>
<td>Inspection was created with Scaled Units enabled. Inspection modified as Scaled Units feature is currently disabled.</td>
<td>Review the inspection parameter settings. If this behavior is not desired, verify that the Scaled Units settings are set as required by the inspection.</td>
</tr>
<tr>
<td>1101</td>
<td>Inspection was created with Scaled Units disabled. Inspection modified as Scaled Units feature is currently enabled.</td>
<td>Review the inspection parameter settings. If this behavior is not desired, verify that the Scaled Units settings are set as required by the inspection.</td>
</tr>
<tr>
<td>1102</td>
<td>Inspection was created with different Scaled Units settings. Inspection modified to match current Scaled Units settings.</td>
<td>Review the inspection parameter settings. If this behavior is not desired, verify that the Scaled Units settings are set as required by the inspection.</td>
</tr>
<tr>
<td>1103</td>
<td>Current inspection settings modified to match current firmware version.</td>
<td>Review the inspection parameter settings</td>
</tr>
<tr>
<td>1104</td>
<td>Inspection was created using features which are incompatible with current firmware and is not allowed to be loaded.</td>
<td>Recreate this inspection with the current firmware version</td>
</tr>
<tr>
<td>1111</td>
<td>Formatted inspection results exceed the maximum output size.</td>
<td>The data included for export exceeds capacity of this channel. Remove some items to export.</td>
</tr>
<tr>
<td>1112</td>
<td>Data export timed out.</td>
<td>• Verify that the receiving application is running and connected</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify that the network bandwidth is sufficient to transmit the data</td>
</tr>
<tr>
<td>1113</td>
<td>Image export timed out.</td>
<td>• Verify that the receiving application is running and connected</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify that the network bandwidth is sufficient to transmit the data</td>
</tr>
<tr>
<td>1200-1290</td>
<td>Device boot error.</td>
<td>• Check that the power to device is within recommended levels and is stable</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Check that the device is properly grounded as recommended in the Instruction Manual</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Verify that electric static noise around the device does not exceed CE specifications</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• If the error still persists, contact Banner Engineering</td>
</tr>
</tbody>
</table>
15.3 TCP and UDP Port Numbers

The following TCP and UDP ports are used for full communication between the VE sensor and the control system (PC, PLC, HMI, etc.).

If firewall or antivirus software is interfering with the use of the VE sensor, use this information to modify the firewall or antivirus settings.

<table>
<thead>
<tr>
<th>Port Number</th>
<th>Protocol</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>0-1024</td>
<td>TCP+UDP</td>
<td>Telnet, FTP, HTTP, etc.</td>
</tr>
<tr>
<td>502</td>
<td>TCP+UDP</td>
<td>ModbusTCP</td>
</tr>
<tr>
<td>2222</td>
<td>UDP</td>
<td>EtherNet/IP IO</td>
</tr>
<tr>
<td>19995</td>
<td>UDP</td>
<td>Sensor Discovery</td>
</tr>
<tr>
<td>32000</td>
<td>TCP</td>
<td>Command Channel default port[^7]</td>
</tr>
<tr>
<td>32100</td>
<td>TCP</td>
<td>Data Export default port[^7]</td>
</tr>
<tr>
<td>32200</td>
<td>TCP</td>
<td>Image Export default port[^7]</td>
</tr>
<tr>
<td>38510-38534</td>
<td>TCP</td>
<td>Sensor to GUI communication</td>
</tr>
<tr>
<td>38536-38539</td>
<td>UDP</td>
<td>Discovery Ports</td>
</tr>
<tr>
<td>34962-38964</td>
<td>TCP+UDP</td>
<td>PROFINET</td>
</tr>
<tr>
<td>44818</td>
<td>TCP</td>
<td>EtherNet/IP UCMM</td>
</tr>
<tr>
<td>49162</td>
<td>TCP+UDP</td>
<td>PROFINET</td>
</tr>
</tbody>
</table>

[^7]: These are the default port numbers, however they can be changed in the Vision Manager software. They cannot be changed to any port number that is already in use.
16 Accessories

16.1 Cordsets

All measurements are listed in millimeters [inches], unless noted otherwise.

Power, Discrete I/O Cordsets

I/O sealed high-flex cordsets, 12 flying leads

<table>
<thead>
<tr>
<th>Model</th>
<th>Length</th>
<th>Style</th>
<th>Dimensions</th>
<th>Pinout (Female)</th>
</tr>
</thead>
<tbody>
<tr>
<td>MQDC2S-1206</td>
<td>1.83 m</td>
<td>Straight</td>
<td>44 Typ.</td>
<td>1 = White</td>
</tr>
<tr>
<td>MQDC2S-1215</td>
<td>4.57 m</td>
<td>Straight</td>
<td>47.4 Typ.</td>
<td>2 = Brown</td>
</tr>
<tr>
<td>MQDC2S-1230</td>
<td>9.14 m</td>
<td>Straight</td>
<td>ø 14.5</td>
<td>3 = Green</td>
</tr>
<tr>
<td>MQDC2S-1250</td>
<td>15.2 m</td>
<td>Straight</td>
<td>ø 14.5</td>
<td>4 = Yellow</td>
</tr>
<tr>
<td>MQDC2S-1275</td>
<td>22.9 m</td>
<td>Straight</td>
<td>ø 14.5</td>
<td>5 = Gray</td>
</tr>
<tr>
<td>MQDC2S-1206RA</td>
<td>1.83 m</td>
<td>Right Angle</td>
<td>32 Typ.</td>
<td>6 = Pink</td>
</tr>
<tr>
<td>MQDC2S-1215RA</td>
<td>4.57 m</td>
<td>Right Angle</td>
<td>30 Typ.</td>
<td>7 = Blue</td>
</tr>
<tr>
<td>MQDC2S-1230RA</td>
<td>9.14 m</td>
<td>Right Angle</td>
<td>ø 14.5</td>
<td>8 = Red</td>
</tr>
<tr>
<td>MQDC2S-1250RA</td>
<td>15.2 m</td>
<td>Right Angle</td>
<td>ø 14.5</td>
<td>9 = Orange</td>
</tr>
</tbody>
</table>

Ethernet Cordsets

<table>
<thead>
<tr>
<th>Model</th>
<th>Length</th>
<th>Style</th>
<th>Dimensions</th>
<th>Pinout</th>
</tr>
</thead>
<tbody>
<tr>
<td>STP-M12-806</td>
<td>1.83 m</td>
<td>Straight, Cat5e Shielded</td>
<td>ø 14.5</td>
<td>1 = White/Black</td>
</tr>
<tr>
<td>STP-M12-815</td>
<td>4.57 m</td>
<td>Straight</td>
<td>ø 14.5</td>
<td>2 = White/Brown</td>
</tr>
<tr>
<td>STP-M12-830</td>
<td>9.14 m</td>
<td>Straight</td>
<td>ø 14.5</td>
<td>3 = Brown</td>
</tr>
</tbody>
</table>

The following Ethernet cables are used with 4-pin D-code Ethernet models only.

<table>
<thead>
<tr>
<th>Model</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>BWA-E2M</td>
<td>Ethernet cable, RSCD RJ45 440, 2 m (6.6 ft)</td>
</tr>
<tr>
<td>BWA-E8M</td>
<td>Ethernet cable, RSCD RJ45 440, 8 m (26.2 ft)</td>
</tr>
</tbody>
</table>
16.2 Brackets

All measurements are listed in millimeters [inches], unless noted otherwise.

**SMBVERA**
- Right-angle mounting bracket with curved slots
- 12-gauge stainless steel
- M3 × 0.5 mounting hardware included

**SMBVEMP**
- Painted black aluminum
- Adapter holes for mounting hardware

16.3 Lenses

Additional models are available. See [www.bannerengineering.com](http://www.bannerengineering.com).

Table 33: C-Mount Standard Lens Focal Length—For use with WVGA models only

<table>
<thead>
<tr>
<th></th>
<th>4 mm</th>
<th>8 mm</th>
<th>12 mm</th>
<th>16 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>LCF04</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>LCF08</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>LCF12</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>LCF16</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Table 34: C-Mount Megapixel Lens Focal Length—For use with WVGA, 1.3MP, or 2MP models

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>5 mm</th>
<th>6 mm</th>
<th>7 mm</th>
<th>8 mm</th>
<th>12 mm</th>
<th>16 mm</th>
<th>25 mm</th>
<th>35 mm</th>
<th>50 mm</th>
<th>75 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Computar</td>
<td>LCF05LCMP</td>
<td>-</td>
<td>LCF08LCMP</td>
<td>LCF12LCMP</td>
<td>LCF16LCMP</td>
<td>LCF25LCMP</td>
<td>LCF35LCMP</td>
<td>LCF50LCMP</td>
<td>LCF75LCMP</td>
<td>LCF50LCMP</td>
</tr>
<tr>
<td>Evetar</td>
<td>-</td>
<td>LCF06LEVMP</td>
<td>LCF08LEVMP</td>
<td>LCF12LEVMP</td>
<td>LCF16LEVMP</td>
<td>LCF25LEVMP</td>
<td>LCF35LEVMP</td>
<td>LCF50LEVMP</td>
<td>LCF75LEVMP</td>
<td>LCF50LEVMP</td>
</tr>
<tr>
<td>Edmund Optics</td>
<td>-</td>
<td>LCF08LEMP</td>
<td>LCF12LEMP</td>
<td>LCF16LEMP</td>
<td>LCF25LEMP</td>
<td>LCF35LEMP</td>
<td>LCF50LEMP</td>
<td>LCF75LEMP</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Tamron</td>
<td>-</td>
<td>-</td>
<td>LCF08LTMP</td>
<td>LCF12LTMP</td>
<td>LCF16LTMP</td>
<td>LCF25LTMP</td>
<td>LCF35LTMP</td>
<td>LCF50LTMP</td>
<td>-</td>
<td>-</td>
</tr>
</tbody>
</table>

Table 35: C-Mount 1-Inch Format Lens—For use with 5MP models only

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>6 mm</th>
<th>8 mm</th>
<th>12 mm</th>
<th>16 mm</th>
<th>25 mm</th>
<th>35 mm</th>
<th>50 mm</th>
<th>75 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Kowa</td>
<td>LCF06LK1F</td>
<td>LCF08LK1F</td>
<td>LCF12LK1F</td>
<td>LCF16LK1F</td>
<td>LCF25LK1F</td>
<td>LCF35LK1F</td>
<td>LCF50LK1F</td>
<td>LCF75LK1F</td>
</tr>
</tbody>
</table>

16.3.1 WVGA Lens Working Distance and Field of View

For use with VE200G1A models.

Table 36: C-Mount Standard Lens Focal Length—Working Distance and Field of View

<table>
<thead>
<tr>
<th>WD (mm)</th>
<th>4 mm</th>
<th>8 mm</th>
<th>12 mm</th>
<th>16 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150</td>
<td>162 x 103</td>
<td>71 x 45</td>
<td>46 x 29</td>
<td>32 x 20</td>
</tr>
<tr>
<td>600</td>
<td>656 x 419</td>
<td>303 x 193</td>
<td>198 x 126</td>
<td>141 x 90</td>
</tr>
</tbody>
</table>

For 2 MP lenses only: Denotes specific lens used for WD and FOV example.
Not compatible with the sealed lens cover.
Use with 60 mm sealed lens cover. Requires LHKW-1 setscrew accessory packet.
Using a 0.25 mm spacer (LEKS).
### Table 37: C-Mount Megapixel Lens Focal Length—Working Distance and Field of View

<table>
<thead>
<tr>
<th>WD (mm)</th>
<th>6 mm</th>
<th>8 mm</th>
<th>12 mm</th>
<th>16 mm</th>
<th>25 mm</th>
<th>35 mm</th>
<th>50 mm</th>
<th>75 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150</td>
<td>100 x 80</td>
<td>66 x 53</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>600</td>
<td>469 x 375</td>
<td>318 x 254</td>
<td>229 x 183</td>
<td>147 x 118</td>
<td>111 x 89</td>
<td>71 x 57</td>
<td>-</td>
<td></td>
</tr>
<tr>
<td>1500</td>
<td>1207 x 966</td>
<td>822 x 658</td>
<td>598 x 478</td>
<td>381 x 305</td>
<td>289 x 231</td>
<td>191 x 153</td>
<td>124 x 99</td>
<td></td>
</tr>
</tbody>
</table>

**Notes:**
- Using a 0.25 mm spacer (LEKS).

**Figure 394. Working Distance and Field of View**

### 16.3.2 1.3 MP Lens Working Distance and Field of View

For use with VE201G1A models.
16.3.3 2 MP Lens Working Distance and Field of View

For use with VE202G1A and VE202G2A models.

Table 38: C-Mount Megapixel Lens Focal Length—Working Distance and Field of View

<table>
<thead>
<tr>
<th>WD (mm)</th>
<th>5 mm</th>
<th>6 mm</th>
<th>8 mm</th>
<th>12 mm</th>
<th>16 mm</th>
<th>25 mm</th>
<th>35 mm</th>
<th>50 mm</th>
<th>75 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>150</td>
<td>188</td>
<td>140</td>
<td>126</td>
<td>72</td>
<td>55</td>
<td>36</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>600</td>
<td>822</td>
<td>663</td>
<td>549</td>
<td>340</td>
<td>259</td>
<td>164</td>
<td>114</td>
<td>75</td>
<td>47</td>
</tr>
<tr>
<td>1500</td>
<td>2091</td>
<td>1710</td>
<td>1393</td>
<td>874</td>
<td>667</td>
<td>422</td>
<td>300</td>
<td>205</td>
<td>132</td>
</tr>
</tbody>
</table>

Approximate Horizontal × Vertical Field of View (FOV) in mm

<table>
<thead>
<tr>
<th>WD (mm)</th>
<th>100 × 75</th>
<th>200 × 158</th>
<th>300 × 225</th>
<th>400 × 316</th>
<th>600 × 450</th>
</tr>
</thead>
<tbody>
<tr>
<td>300</td>
<td>565</td>
<td>265</td>
<td>122</td>
<td>229</td>
<td>442</td>
</tr>
<tr>
<td>600</td>
<td>1212</td>
<td>566</td>
<td>335</td>
<td>288</td>
<td>545</td>
</tr>
<tr>
<td>1500</td>
<td>3154</td>
<td>1469</td>
<td>1038</td>
<td>2305</td>
<td>833</td>
</tr>
</tbody>
</table>

Approximate Working Distance (WD) in mm

<table>
<thead>
<tr>
<th>FOV (mm)</th>
<th>Approximate Working Distance (WD) in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>100 × 75</td>
<td>88</td>
</tr>
<tr>
<td>200 × 158</td>
<td>164</td>
</tr>
<tr>
<td>300 × 225</td>
<td>229</td>
</tr>
<tr>
<td>400 × 316</td>
<td>224</td>
</tr>
<tr>
<td>600 × 450</td>
<td>409</td>
</tr>
</tbody>
</table>

Figure 396. Working Distance and Field of View

16.3.4 5 MP Lens Working Distance and Field of View

For use with VE205G1A models.

Table 39: C-Mount Megapixel Lens Focal Length—Working Distance and Field of View

<table>
<thead>
<tr>
<th>WD (mm)</th>
<th>6 mm</th>
<th>8 mm</th>
<th>12.5 mm</th>
<th>16 mm</th>
<th>25 mm</th>
<th>35 mm</th>
<th>50 mm</th>
<th>75 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>300</td>
<td>565</td>
<td>415</td>
<td>265</td>
<td>211</td>
<td>138</td>
<td>93</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>600</td>
<td>1212</td>
<td>867</td>
<td>566</td>
<td>445</td>
<td>289</td>
<td>200</td>
<td>130</td>
<td>-</td>
</tr>
<tr>
<td>1500</td>
<td>3154</td>
<td>2305</td>
<td>1469</td>
<td>1147</td>
<td>742</td>
<td>521</td>
<td>352</td>
<td>233</td>
</tr>
</tbody>
</table>

Approximate Horizontal × Vertical Field of View (FOV) in mm

<table>
<thead>
<tr>
<th>FOV (mm)</th>
<th>Approximate Working Distance (WD) in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>200 × 158</td>
<td>164</td>
</tr>
<tr>
<td>400 × 316</td>
<td>229</td>
</tr>
<tr>
<td>800 × 632</td>
<td>409</td>
</tr>
</tbody>
</table>

Approximate Working Distance (WD) in mm

<table>
<thead>
<tr>
<th>FOV (mm)</th>
<th>Approximate Working Distance (WD) in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>200 × 158</td>
<td>164</td>
</tr>
<tr>
<td>400 × 316</td>
<td>229</td>
</tr>
<tr>
<td>800 × 632</td>
<td>409</td>
</tr>
</tbody>
</table>
16.4 C-Mount Lens Filter Models

Use filters to improve the image contrast and system reliability in vision applications. For additional filter information, see p/n 173239.

<table>
<thead>
<tr>
<th>Family</th>
<th>Color</th>
<th>Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>FLT</td>
<td>B470 (Blue)</td>
<td>25.5 (25.5 mm)</td>
</tr>
<tr>
<td></td>
<td>G525 (Green)</td>
<td>27 (27 mm)</td>
</tr>
<tr>
<td></td>
<td>I850 (Infrared)</td>
<td>30.5 (30.5 mm)</td>
</tr>
<tr>
<td></td>
<td>R635 (Red)</td>
<td>34 (34 mm)</td>
</tr>
<tr>
<td></td>
<td>R660 (Dark Red)</td>
<td>35.5 (35.5 mm)</td>
</tr>
<tr>
<td></td>
<td>PR032 (Linear Polarizer)</td>
<td>35 (35.5 mm)</td>
</tr>
<tr>
<td></td>
<td>- (dash)</td>
<td>43 (43 mm)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>46 (46 mm)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>55 (55 mm)</td>
</tr>
</tbody>
</table>

Filters are available in six sizes, specific to the inside thread diameter of the lens. Use the table below to select the corresponding filter for each C-mount lens available through Banner Engineering.

<table>
<thead>
<tr>
<th>Size</th>
<th>Lens Option</th>
</tr>
</thead>
<tbody>
<tr>
<td>25.5 mm</td>
<td>Edmund Optics, Tamron</td>
</tr>
<tr>
<td>27 mm</td>
<td>Ricoh, Evetar (8 mm, 12 mm, 16 mm, 25 mm, 35 mm)</td>
</tr>
<tr>
<td>30.5 mm</td>
<td>Computar (8 mm, 12 mm, 16 mm, 25 mm, 35 mm, 50 mm, 75 mm), Evetar (50 mm)</td>
</tr>
<tr>
<td>34 mm</td>
<td>Evetar (6 mm, 75 mm)</td>
</tr>
<tr>
<td>35.5 mm</td>
<td>Kowa (12 mm, 16 mm, 25 mm, 35 mm)</td>
</tr>
<tr>
<td>43 mm</td>
<td>Computar (5 mm)</td>
</tr>
<tr>
<td>46 mm</td>
<td>Kowa (75 mm)</td>
</tr>
<tr>
<td>55 mm</td>
<td>Kowa (8 mm)</td>
</tr>
</tbody>
</table>

**Important:** These filters are for the C-mount lens only. Depending on the lighting technique used, a polarizing filter may be needed for both the lens and the light source. See [www.bannerengineering.com](http://www.bannerengineering.com) for Banner’s selection of light filters.

16.5 Sealed Lens Cover

When used, the optional sealed lens covers offer an IP67 rating for the sensor for wet or dirty environments. The cover is painted black aluminum.

The following sealed lens covers are compatible with all WVGA, 1.3 MP, and 2 MP models with lenses installed. The sealed lens covers are compatible with some 5 MP models with lenses installed.

---

32 The filter is not compatible with the sealed lens cover when installed on this lens.
33 The filter is not compatible with the lens and 60 mm sealed lens cover installed.
### 16.6 Display Cover

Use the Display Cover to protect the display and buttons from the elements.

**VEDC-BG**
- Painted anodized aluminum with borosilicate glass window
- Mounting hardware included

### 16.7 Ring Lights

For additional ring light information, see p/n 192656 for standard lights and p/n 192657 for high intensity lights. Additional (standalone) lights are available. See [www.bannerengineering.com](http://www.bannerengineering.com).

Due to the size of the 5 MP lenses, a ring light cannot be mounted to the 5 MP camera and lens. However, they can be mounted nearby, connected to and controlled by the camera.

#### Standard Ring Lights

<table>
<thead>
<tr>
<th>62 × 62 mm Models</th>
<th>80 × 80 mm Models</th>
<th>Color</th>
<th>Connection</th>
</tr>
</thead>
<tbody>
<tr>
<td>LEDIRV62X62M</td>
<td>LEDIRV80X80M</td>
<td>Infrared, 940 nm</td>
<td>300 mm (12 in) cable with a threaded 3-pin Pico-style connector</td>
</tr>
<tr>
<td>LEDRRV62X62M</td>
<td>LEDRRV80X80M</td>
<td>Visible red, 630 nm</td>
<td></td>
</tr>
<tr>
<td>LEDWRV62X62M</td>
<td>LEDWRV80X80M</td>
<td>White, all visible</td>
<td></td>
</tr>
<tr>
<td>LEDBRV62X62M</td>
<td>LEDBRV80X80M</td>
<td>Visible blue, 464 nm to 475 nm</td>
<td></td>
</tr>
<tr>
<td>LEDGRV62X62M</td>
<td>LEDGRV80X80M</td>
<td>Visible green, 520 nm to 540 nm</td>
<td></td>
</tr>
</tbody>
</table>

#### High Intensity Ring Lights

<table>
<thead>
<tr>
<th>Model</th>
<th>LED Color</th>
<th>Intensity Adjustment</th>
<th>Connection</th>
</tr>
</thead>
<tbody>
<tr>
<td>LEDRRV70XD5-XM</td>
<td>Visible red, 620 nm to 630 nm</td>
<td></td>
<td>300 mm (12 in) cable with a threaded 3-pin Pico-style connector</td>
</tr>
<tr>
<td>LEDWRV70XD5-XM</td>
<td>White, 5000 K to 8300 K</td>
<td>Fixed</td>
<td></td>
</tr>
<tr>
<td>LEDBRV70XD5-XM</td>
<td>Visible blue, 465 nm to 485 nm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDGRV70XD5-XM</td>
<td>Visible green, 520 nm to 535 nm</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

---

34 For 5 MP camera and lens, only compatible with 25 mm and 35 mm focal lengths without a filter installed.
35 For 5 MP camera and lens, compatible with 12 mm to 75 mm focal lengths without filter installed. With filter installed the sealed lens cover is only compatible with 25 mm to 35 mm focal lengths.
36 Connects directly to the VE Series smart cameras
### LED Color Intensity Adjustment Connection

<table>
<thead>
<tr>
<th>Model</th>
<th>LED Color</th>
<th>Intensity Adjustment</th>
<th>Connection</th>
</tr>
</thead>
<tbody>
<tr>
<td>LEDIRV70XD5-XM</td>
<td>Infrared, 850 nm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDUV395RV70XD5-XM</td>
<td>Ultraviolet, 395 nm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDRRV70XD5-PM</td>
<td>Visible red, 620 nm to 630 nm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDWRV70XD5-PM</td>
<td>White, 5000 K to 8300 K</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDBRV70XD5-PM</td>
<td>Visible blue, 465 nm to 485 nm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDGRV70XD5-PM</td>
<td>Visible green, 520 nm to 535 nm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDIRV70XD5-PM</td>
<td>Infrared, 850 nm</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LEDUV395RV70XD5-PM</td>
<td>Ultraviolet, 395 nm</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### 16.8 Interface Module

For additional interface module information, see p/n 193821.

<table>
<thead>
<tr>
<th>Models</th>
<th>Trigger</th>
<th>Connections</th>
</tr>
</thead>
<tbody>
<tr>
<td>VESIM-PT</td>
<td>Current Sourcing (PNP)</td>
<td>Two 13-pin Terminals</td>
</tr>
</tbody>
</table>
17 Product Support and Maintenance

17.1 Repairs

Contact Banner Engineering for troubleshooting of this device. **Do not attempt any repairs to this Banner device; it contains no field-replaceable parts or components.** If the device, device part, or device component is determined to be defective by a Banner Applications Engineer, they will advise you of Banner’s RMA (Return Merchandise Authorization) procedure.

*Important:* If instructed to return the device, pack it with care. Damage that occurs in return shipping is not covered by warranty.

17.2 Maintenance

Maintenance tasks include keeping the hardware free of dust and dirt and updating the Vision Manager software and sensor firmware as new versions become available.

17.2.1 Clean the VE

Regularly remove any dust or dirt from the sensor using a soft cloth.

If needed, slightly dampen the cloth with a weak solution of neutral detergent. Avoid getting dirt on the imager (the area behind the lens). If the imager is dirty, use anti-static compressed air to blow off the dust.

17.2.2 Clean the Lens

Regularly remove dust, dirt, or fingerprints from the lens.

Use anti-static compressed air to blow off dust. If necessary, use a lens cloth and lens cleaner or window cleaner to wipe off remaining debris.

17.2.3 Update the Software and Firmware

The current version of Vision Manager software and the sensor firmware is available for download from www.bannerengineering.com.

17.3 Contact Us

Banner Engineering Corp. headquarters is located at:

9714 Tenth Avenue North
Minneapolis, MN 55441, USA
Phone: + 1 888 373 6767

For worldwide locations and local representatives, visit www.bannerengineering.com.

17.4 Banner Engineering Corp Limited Warranty

Banner Engineering Corp. warrants its products to be free from defects in material and workmanship for one year following the date of shipment. Banner Engineering Corp. will repair or replace, free of charge, any product of its manufacture which, at the time it is returned to the factory, is found to have been defective during the warranty period. This warranty does not cover damage or liability for misuse, abuse, or the improper application or installation of the Banner product.

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For patent information, see www.bannerengineering.com/patents.
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  settings 42
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  . See DAP
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discrete I/O
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<th><strong>TEACH</strong></th>
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<td>About 26</td>
</tr>
<tr>
<td></td>
<td>Active Sensors 22</td>
</tr>
<tr>
<td></td>
<td>All Results 31</td>
</tr>
<tr>
<td></td>
<td>Favorites 23</td>
</tr>
<tr>
<td></td>
<td>Network Adapters 24</td>
</tr>
<tr>
<td></td>
<td>Tools &amp; Results 30</td>
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<td>Tools Only 30</td>
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<table>
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<th><strong>S</strong></th>
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<tbody>
<tr>
<td></td>
<td>backup 25</td>
</tr>
<tr>
<td></td>
<td>boot count 36</td>
</tr>
<tr>
<td></td>
<td>firmware version 36</td>
</tr>
<tr>
<td></td>
<td>gateway 36</td>
</tr>
<tr>
<td></td>
<td>hour count 36</td>
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<tr>
<td></td>
<td>IP address 36</td>
</tr>
<tr>
<td></td>
<td>MAC address 36</td>
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<td></td>
<td>menu 156</td>
</tr>
<tr>
<td></td>
<td>model number 36</td>
</tr>
<tr>
<td></td>
<td>name 36</td>
</tr>
<tr>
<td></td>
<td>reset 54</td>
</tr>
<tr>
<td></td>
<td>restore 25</td>
</tr>
<tr>
<td></td>
<td>serial number 36</td>
</tr>
<tr>
<td></td>
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<tr>
<th><strong>V</strong></th>
<th><strong>Vision Manager</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>about 26</td>
</tr>
<tr>
<td></td>
<td>version number 26</td>
</tr>
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<table>
<thead>
<tr>
<th><strong>U</strong></th>
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<tr>
<td></td>
<td>46</td>
</tr>
<tr>
<td></td>
<td>use as reference 115, 123</td>
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<tr>
<td></td>
<td>user 52–54</td>
</tr>
<tr>
<td></td>
<td>User</td>
</tr>
<tr>
<td></td>
<td>add 53</td>
</tr>
<tr>
<td></td>
<td>user name 54</td>
</tr>
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