



**1. What is Legacy Mode?**

- a. Legacy Mode is an operational setting in which the BSC-3000 allows the sensor to function on a fixed (yet adjustable) swing-angle, versus having to first learn a specific monitoring position. The detection range is input by the user through the BSC-3000, as opposed to the mechanical adjustment knob associated with Allora's Legacy sensor, the PCS-100.

**2. Which sensors can take advantage of Legacy Mode?**

- a. Both the PCS-350 as well as the PCS-ER+ can operate in Legacy Mode.

**3. Why was Legacy Mode added to the capabilities of the BSC-3000?**

- a. Historically, the demand for the PCS-100 significantly exceeded the demand of the PCS-250 ("Teachable Sensor"), therefore it was imperative that Allora incorporate this functionality to maintain its "Legacy" within its new products.
- b. The successful legacy of the PCS-100 is due to its ability to operate in a simple, "right-out-of-the-box" fashion, relying upon the sensor's needle or wand to contact a tool (or any object) within a user-selected swing range, without the requirement of learning a specific position.
- c. By eliminating the need to "Teach" a specific monitoring position, a user can operate the system down to its very basic function, simply by looking for presence or absence of a tool or part within a swing range.

**4. How does Legacy Mode work?**

- a. The default setting for Legacy Mode is a Swing Angle setting of 4 (~ 90°) and Contact Force "CF" setting at 4.
- b. Upon sending a Start signal, the wand will swing in the CW or CCW direction (based on the directional Dip-Switch setting) and rotate, moving with the purpose of contacting the tool to confirm its presence ("OK") or absence ("Fault") before it reaches the destination angle. If Reverse Logic is selected, a "Fault" reading will be given when the sensor needle contacts an object, and an "OK" reading will appear if the needle completes the cycle without contacting anything.
- c. Different Swing angle settings can easily be chosen by performing a straightforward setting procedure as outlined in the User Manual and without any mechanical adjustment of the Sensor.