

PVC WELDING CONTROL UNIT PARAMETER TUNING INSTRUCTIONS

1. If you put the heater button at the same time melting button SFr 1 0 appear on the display and prg led is on.
2. with arrow buttons (start , stop buttons) first key is entered
3. To OK your Key press heater button once
4. On the display appears SFr 1 X and second key apperars (Keys can be numbers between 1 to 99)
5. with arrow buttons (start , stop buttons) second key is entered
6. To OK your Key press heater button once and you reach the parameters below.

With arrow key you can change the parameter you needed . When you push the heater button every time you reach the next parameter.

	EXPLANATIONS	RANGE	DEFAULT	NEEDED
	TIME PERIODS			
ZR-1	Tradle is pressed Za 01 time is the axe's input time	1 – 9.9 SEC	1.5 SEC	
ZR-2	Plate closing time.	1 – 9.9 SEC	1.5 SEC	
ZR-3	When you press the tradle 1. press on	1 – 9.9 SEC	1.5 SEC	
ZR-4	When you press the tradle 1. press on all other operations follows automatically	1 – 9.9 SEC	1.5 SEC	
ZR-5	Plate opening time	1 - 9.9 SEC	1.5 SEC	
ZR-6	Axe out time	1 – 9.9 SEC	1.0 SEC	
ZR-7	Resistance input time	1 – 9.9 SEC	2.0 SEC	
ZR-8	Plate closing time	1 – 9.9 SEC	3.0 SEC	
	Melting time starts	99 SEC	20 SEC	
ZR-9	Plate opening time	1 – 9.9 SEC	1.5 SEC	
ZR-10	Resistance input time	1 – 9.9 SEC	1.5 SEC	
ZR-11	Plate closing time	1 – 9.9 SEC	1.5 SEC	
	Welding (cooling) time starts	99 SEC	20 SEC	
ZR-12	1. press breaking time	1 – 9.9 SEC	0.1 SEC	
ZR-13	2. press breaking time	1 – 9.9 SEC	0.1 SEC	
ZR-14	Plate opening time	1 – 9.9 SEC	0.1 SEC	
ZR-15	When you press stop, stop times	1 – 9.9 SEC	1.0 SEC	
	PROGRAMME PARAMETERS			
PR-1	1. Key	0 - 99	1	
PR-2	2. Key	0 - 99	1	
PR-3	unused	0 - 99	0	
PR-4	Machine Special Funcions 0. it is not working before set value of heater			

	1. Machine always ready for working + 0. Emergency Stop NO contact 2. Emergency Stop NC contact + 0. Plate with switch 4. Plate without switch + 0. Max set value 300 C 8. Max set value 400 C = needed function numbers added and write this field	0 - 1	14 (can be different as the different productors machines)	
<i>PR-5</i>	Resolution on set point. Entered number as under or upper shows set point With resolution you can not see PR-5 value as changing on the heaters value	0 – 5	2	
<i>PR-6</i>	ADC approximate (changing this value can be caused not proper working)	0 – 7	5	
<i>PR-7</i>	ADC sampling rate (changing this value can be caused not proper working)	0 – 255	28	
<i>PR-8</i>	PID Propotional constant (changing this value can be caused not proper working)	0 - 255	180	
<i>PR-9</i>	PID Differantial constant (changing this value can be caused not proper working)	0 – 255	100	
<i>PR-10</i>	PID Integral Constant ((changing this value can be caused not proper working)	0 – 255	28	
<i>PR-11</i>	PID cyling time	0 – 255	6	

P.S. : The parameters are given on the table are factory defaults can be changed as your needs.

