

**HSM-WI7
STANDUN BODYMAKER
HIGH SPEED LOGIC MODULE
KEYPAD QUICK REFERENCE**

Systems Engineering Associates, Inc.
14989 West 69th Avenue
Arvada, Colorado 80007 U.S.A.
Telephone: (303) 421-0484
Fax: (303) 421-8108
www.sea-seg.com

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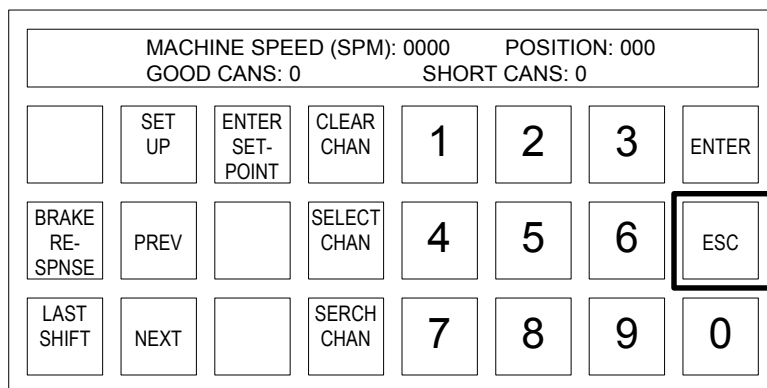
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CONVENTIONS USED IN THIS MANUAL

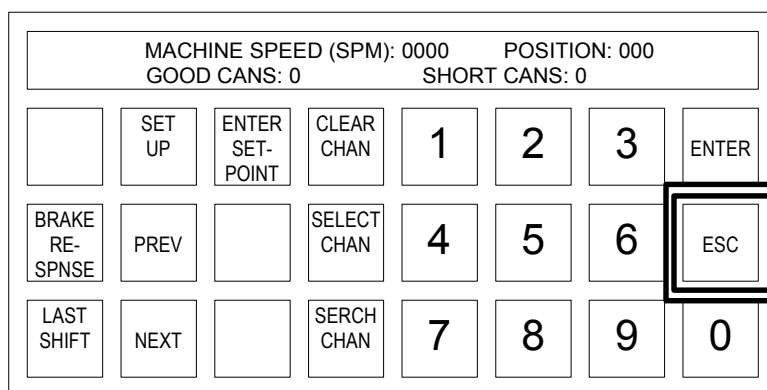
This manual is provided as a quick reference for entering parameters through the HSM-WI7 keypad. For complete details on the parameters that can be set through the HSM-WI7 keypad or for additional information on the HSM-WI7 in general, refer to the HSM-WI7 User's Manual.

The following conventions are used through-out this manual.

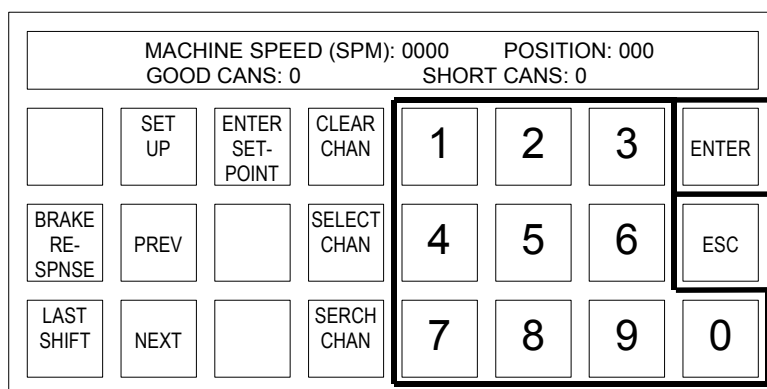
- 1) This indicates to depress that key one time.



- 2) This indicates to press that key two or more times as directed.



- 3) Indicates to enter a numeric value on the numeric keypad. Enter the desired number by depressing the corresponding numeric keys and then press the "ENTER" key to enter the number. If keypad entry error is made while a number is being entered, simply press the "ESC" key. The number will revert back to the original value at which time the correct number can be re-entered.



SECTION 1

VIEWING LAST SHIFT COUNTS

The Last Shift data menu displays the “Total Good Can” count and the “Total Short Can” fault count. This data is the totals for the last shift. Note that the current shift counts are displayed as part of the main menu.

To display the Last Shift counts, perform the following:

- 1) with the main menu displayed, press the “LAST SHIFT” key.

MACHINE SPEED (SPM): 0000 POSITION: 000							
GOOD CANS: 0 SHORT CANS: 0							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 2) The total good can count and short can fault count for the last shift will be displayed. Press the “ESC” key to return back to the main menu when finished viewing the counts.

-- LAST SHIFT (TOTALS FOR SHIFT) --							
GOOD CANS:250,000 SHORT CANS: 6							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 2 DISPLAY BRAKE RESPONSE

The brake response screen displays the brake response for both the low speed and high speed stops. The response is the number of degrees it takes the press to stop from when the clutch is de-activated for a BDC stop to the position that the machine comes to rest.

To display the brake response, perform the following:

- 1) With the main menu displayed, press the “BRAKE RESPNSE” key.

MACHINE SPEED (SPM): 0000 POSITION: 000 GOOD CANS: 0 SHORT CANS: 0							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 2) Both the low and the high speed brake response from the last respective stops are displayed. When finished viewing the responses, press the “ESC” key to return back to the main menu.

-- ACTUAL BRAKE RESPONSE (IN DEGREES) -- LOW SPEED STOP: XXX HIGH SPEED STOP: XXX							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 3

ENABLE BRAKE WEAR COMPENSATION

The brake wear compensation feature is used to stop the press at BDC regardless of the actual braking response of the clutch/brake. Enabling the brake wear compensation consists of enabling the feature and setting both the high speed and low speed desired stopping positions (the angular position that the main crank is at when the machine stops).

To enable the brake wear compensation perform the following:

- 1) With the main menu displayed, press the “SET-UP” key.

MACHINE SPEED (SPM): 0000 POSITION: 000									
GOOD CANS: 0 SHORT CANS: 0									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 2) Enter the 5 digit passcode on the numeric keypad and press “ENTER”.

Note: The passcode is set by the user as desired. Refer to the HSM-WI7 User’s manual for details on setting the passcode.

-- SYSTEM SET-UP (TUNING) --									
ENTER PASSCODE: *****									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 3) Press the “1” key to enter the “Set bodymaker Parameters” menu.

1: SET BODYMAKER PARAMETERS									
2: SET TRIMMER PARAMETERS									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

SECTION 3

ENABLE BRAKE WEAR COMPENSATION

- 4) At the “Brake Wear Comp Enable?” prompt, press the “1” (YES) key if the brake wear compensation is to be enabled. If the brake wear compensation is to be disabled, press the “0” (NO) key instead and skip steps (5) and (6) following.

-- BODYMAKER SET-UP PARAMETERS -- BRAKE WEAR COMP ENBLE? (0=NO, 1=YES):							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 5) On the numeric keypad, enter the desired low speed stopping position in degrees and press “ENTER”.

-- BODYMAKER SET-UP PARAMETERS -- DESIRED BDC STOP POS (LOW SPEED):							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 6) On the numeric keypad, enter the desired high speed BDC stopping position in degrees and press “ENTER”.

-- BODYMAKER SET-UP PARAMETERS -- DESIRED BDC STOP POS (HIGH SPEED):							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

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SECTION 3

ENABLE BRAKE WEAR COMPENSATION

- 7) The Brake wear compensation is now enabled. Press the “ESC” key to return to the primary set-up menu. Press the “ESC” key again to return to the main menu.

-- BODYMAKER SET-UP PARAMETERS -- MAXIMUM ALLOWED STOPPING RESPONSE:							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 4

SET MAXIMUM ALLOWED STOPPING RESPONSE

The “Maximum Allowed Stopping Response” defines what the maximum allowed brake response is before the “Brake Response Too Long” alarm is generated. If the actual brake response, when a BDC stop is performed, is longer than this value, the alarm is generated. If the actual response is less than this value, the alarm is not generated.

To set the “Maximum Allowed Stopping Response”, perform the following:

- 1) With the main menu displayed, press the “SET-UP” key.

MACHINE SPEED (SPM): 0000 POSITION: 000									
GOOD CANS: 0 SHORT CANS: 0									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 2) Enter the 5 digit passcode on the numeric keypad and press “ENTER”.

Note: The passcode is set by the user as desired. Refer to the HSM-WI7 User’s manual for details on setting the passcode.

-- SYSTEM SET-UP (TUNING) --									
ENTER PASSCODE: *****									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 3) Press the “1” key to enter the “Set Bodymaker Parameters” menu.

1: SET BODYMAKER PARAMETERS									
2: SET TRIMMER PARAMETERS									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

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SECTION 4

SET MAXIMUM ALLOWED STOPPING RESPONSE

- 4) Press the “NEXT” key until the “Maximum Allowed Stopping Response” prompt is displayed.

-- BODYMAKER SET-UP PARAMETERS -- BRAKE WEAR COMP ENBLE? (0=NO, 1=YES):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 5) On the numeric keypad, enter the desired maximum allowed stopping response in degrees and press “ENTER”.

-- BODYMAKER SET-UP PARAMETERS -- MAXIMUM ALLOWED STOPPING RESPONSE:							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 6) The maximum allowed stopping response is now set. Press the “ESC” key to return to the primary set-up menu. Press the “ESC” key again to return to the main menu.

-- BODYMAKER SET-UP PARAMETERS -- RUNNING BODYMAKER LOW SPEED (SPM):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 5

SET BODYMAKER RUNNING LOW AND HIGH SPEEDS

The “Bodymaker Running Low and High” speeds are the actual speeds that the body maker will run at when the respective speed is selected. Note that the values entered are not used as speed references to make the body maker actually run at the respective speed but are instead simply references to switch between the BDC high and low timing, etc.

To set the bodymaker high and low speed references, perform the following:

- 1) With the main menu displayed, press the “SET-UP” key.

MACHINE SPEED (SPM): 0000 POSITION: 000									
GOOD CANS: 0 SHORT CANS: 0									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 2) Enter the 5 digit passcode on the numeric keypad and press “ENTER”.

Note: The passcode is set by the user as desired. Refer to the HSM-WI7 User’s manual for details on setting the passcode.

-- SYSTEM SET-UP (TUNING) --									
ENTER PASSCODE: *****									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 3) Press the “1” key to enter the “Set Bodymaker Parameters” menu.

1: SET BODYMAKER PARAMETERS									
2: SET TRIMMER PARAMETERS									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

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SECTION 5

SET BODYMAKER RUNNING LOW AND HIGH SPEEDS

- 4) Press the “NEXT” key until the “Running Bodymaker Low Speed” prompt is displayed.

-- BODYMAKER SET-UP PARAMETERS -- BRAKE WEAR COMP ENBLE? (0=NO, 1=YES):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 5) On the numeric keypad, enter the actual speed in strokes per minutes that the bodymaker will run at when it s in low speed and press “ENTER”.

-- BODYMAKER SET-UP PARAMETERS -- RUNNING BODYMAKER LOW SPEED (SPM):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 6) On the numeric keypad, enter the actual speed in strokes per minute that the bodymaker will run at when it is in high speed and press “ENTER”.

-- BODYMAKER SET-UP PARAMETERS -- RUNNING BODYMAKER HIGH SPEED (SPM):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 5

SET BODYMAKER RUNNING LOW AND HIGH SPEEDS

- 7) The bodymaker running low and high speeds are now set. Note that when the high speed value is entered, the primary set-up menu is returned to. From here press the “ESC” key to return back to the main menu.

-- SYSTEM SET-UP (TUNING) -- PRESS ONE OF THE FOLLOWING KEYS (1-4):							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 6

SET TRIMMER SPEED REFERENCES

The trimmer speed references are used to actually control the speed of the trimmer via the 0-10 volt analog output of the HSM-WI7 module. The references include the maximum speed (speed at which the output is at the full 10 volts), the minimum (idle) speed (speed trimmer runs at with body maker stopped), and the trimmer high speed offset (speed added to bodymaker speed when trimmer infeed high sensor is covered).

To set the trimmer speed references, perform the following:

- 1) With the main menu displayed, press the “SET-UP” key.

MACHINE SPEED (SPM): 0000 POSITION: 000							
GOOD CANS: 0 SHORT CANS: 0							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 2) Enter the 5 digit passcode on the numeric keypad and press “ENTER”.

Note: The passcode is set by the user as desired. Refer to the HSM-WI7 User’s manual for details on setting the passcode.

-- SYSTEM SET-UP (TUNING) --							
ENTER PASSCODE: *****							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 3) Press the “2” key to enter the “Set Trimmer Parameters” menu.

1: SET BODYMAKER PARAMETERS							
2: SET TRIMMER PARAMETERS							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 6

SET TRIMMER SPEED REFERENCES

- 4) On the numeric keypad, enter the desired trimmer calibrate (maximum) speed in cans per minute and press “ENTER”. This is the speed that the analog output will be at 10 volts.

-- TRIMMER SET-UP PARAMETERS -- TRIMMER CALIBRATE (MAX) SPEED (CPM):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 5) On the numeric keypad, enter the desired trimmer minimum (idle) speed in cans per minute and press “ENTER”.

-- TRIMMER SET-UP PARAMETERS -- TRIMMER MINIMUM (IDLE) SPEED (CPM):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 6) On the numeric keypad, enter the desired trimmer high speed offset in cans per minute and press “ENTER”. This is the speed added to the bodymaker speed when the trimmer infeed high sensor is covered.

-- TRIMMER SET-UP PARAMETERS -- TRIMMER HIGH SPEED OFFSET (CPM):							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

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SECTION 6

SET TRIMMER SPEED REFERENCES

- 7) the trimmer speed references are now set. Note that when the trimmer high speed offset is entered, the primary set-up menu is returned to. From here press the “ESC” key to return to the main menu

-- SYSTEM SET-UP (TUNING) -- PRESS ONE OF THE FOLLOWING KEYS (1-4):							
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 7

ZERO MACHINE (SET RESOLVER OFFSET)

Back Dead Center (BDC) is defined as the zero position of the machine. Since the HSM-WI7 uses a resolver for machine timing instead of an encoder, the zero of the machine can be set electronically instead of having to move the shaft of the resolver as would have to be done on an encoder.

To zero the resolver, position the machine at Back Dead Center and perform the following:

- 1) With the main menu displayed, press the “SET-UP” key.

MACHINE SPEED (SPM): 0000 POSITION: 000									
GOOD CANS: 0 SHORT CANS: 0									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 2) Enter the 5 digit passcode on the numeric keypad and press “ENTER”.

Note: The passcode is set by the user as desired. Refer to the HSM-WI7 User’s manual for details on setting the passcode.

-- SYSTEM SET-UP (TUNING) --									
ENTER PASSCODE: *****									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 3) Press the “4” key to enter the “Zero Machine” menu.

3: SET MACHINE TIMING (SET-POINTS, ETC.)									
4: ZERO MACHINE (SET RESOLVER OFFSET)									
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

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SECTION 7

ZERO MACHINE (SET RESOLVER OFFSET)

- 4) +Press the “0” key to zero the resolver. The HSM-WI7 will calculate the offset required to make the current position “000” and display this number in the “Offset” field.

TO ZERO THE RESOLVER, LOCATE MACHINE AT BDC AND PRESS “0” OR “ESC” TO EXIT:							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 5) The resolver is now zeroed. Press the “ESC” key to exit the timing channel set-points menu. Press the “ESC” key again to exit back to the main menu.

CH00 SETPOINT:150 BDC (HIGH) TIMING RPM:0000 POS:000 OFFSET:000 SCALE:360							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 8

ADJUSTING TIMING CHANNEL SET-POINTS

The timing channels of the HSM-WI7 are defined as follows:

CH00: BDC (High) timing
 CH01: BDC (Low) timing
 CH02: Short Can Check timing
 CH03: Sensor Check timing
 CH04: Cupfeed timing
 CH05: Air Strip (Low) timing
 CH06: Air Strip (High) timing
 CH07: PLC timing

To adjust any of the above timing channels, perform the following:

- 1) With the main menu displayed, press the “SET-UP” key.

MACHINE SPEED (SPM): 0000 POSITION: 000									
GOOD CANS: 0 SHORT CANS: 0									
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 2) Enter the 5 digit passcode on the numeric keypad and press “ENTER”.

Note: The passcode is set by the user as desired. Refer to the HSM-WI7 User’s manual for details on setting the passcode.

-- SYSTEM SET-UP (TUNING) --									
ENTER PASSCODE: *****									
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

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SECTION 8

ADJUSTING TIMING CHANNEL SET-POINTS

- 3) Press the “3” key to enter the “Set Machine Timing” menu.

3: SET MACHINE TIMING (SET-POINTS, ETC.) 4: ZERO MACHINE (SET RESOLVER OFFSET)							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 4) Press the “SELECT CHAN” key and enter the channel number to be adjusted on the numeric keypad and then press “ENTER”.

Note: The “NEXT” and “PREV” keys can also be used to advance to the next channel or retard to the previous channel. The following examples will use channel 07 as the selected channel.

CH00 SETPOINT:150 BDC (HIGH) TIMING RPM:0000 POS:000 OFFSET:000 SCALE:360							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 5) To view the location of the existing set-point, press the “SEARCH CHAN” key repeatedly. The location the set-point turns “ON” will be displayed with the “state” indicator solid. Locations where the set-point turns “off” will be displayed with the “state” indicator “off”.

Write down the “ON” and “off” set-point locations for later use.

CH07 SETPOINT:000 ■ PLC TIMING RPM:0000 POS:000 OFFSET:000 SCALE:360							
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

SECTION 8

ADJUSTING TIMING CHANNEL SET-POINTS

To adjust the set-point, perform the following:

- 6) Press the “CLEAR CHAN” key to clear the existing set-point.

CH07 SETPOINT:000				PLC TIMING			
RPM:0000 POS:000				OFFSET:000 SCALE:360			
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 7) Press the “ENTER SET-POINT” key.

CH07 SETPOINT:___				PLC TIMING			
RPM:0000 POS:000				OFFSET:000 SCALE:360			
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

- 8) On the numeric keypad, enter the position, in degrees, where the set-point should go “ON” and press “ENTER”

“ON” SETPOINT:___				PLC TIMING			
RPM:0000 POS:000				OFFSET:000 SCALE:360			
	SET UP	ENTER SET-POINT	CLEAR CHAN	1	2	3	ENTER
BRAKE RE-SPNSE	PREV		SELECT CHAN	4	5	6	ESC
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0

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SECTION 8

ADJUSTING TIMING CHANNEL SET-POINTS

- 9) On the numeric keypad, enter the position, in degrees, where the set-point should go “off” and press “ENTER”

“OFF” SETPOINT:___ ■ PLC TIMING RPM:0000 POS:000 OFFSET:000 SCALE:360									
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		

- 10) The timing channel has now been adjusted. Press the “ESC” key to return back to the primary set-up menu. Press the “ESC” again to return back to the main menu.

CH07 SETPOINT:000 ■ PLC TIMING RPM:0000 POS:000 OFFSET:000 SCALE:360									
	SET UP	ENTER SET- POINT	CLEAR CHAN	1	2	3	ENTER		
BRAKE RE- SPNSE	PREV		SELECT CHAN	4	5	6	ESC		
LAST SHIFT	NEXT		SERCH CHAN	7	8	9	0		