

TECHNICAL DOCUMENTATION

- ROTOPLAT 7.1



Date	Revisions	Revision reasons	Issue	Checked by	Approved by
28/03/2012	01	General revision	<i>Garavelli D.</i>	<i>Garavelli D.</i>	<i>Garavelli D.</i>
05/12/2012	02	Parameters and alarms revision	<i>Garavelli D.</i>	<i>Garavelli D.</i>	<i>Garavelli D.</i>
22/07/2013	03	Load cell values revision and alarm list	<i>Garavelli D.</i>	<i>Garavelli D.</i>	<i>Garavelli D.</i>
25/04/2014	04	Parameters revision	<i>Garavelli D.</i>	<i>Garavelli D.</i>	<i>Garavelli D.</i>
03/07/2017	05	General revision	<i>Baldinini F.</i>	<i>Baldinini F.</i>	<i>Baldinini F.</i>
12/07/2018	06	Index realization	<i>Baldinini F.</i>	<i>Baldinini F.</i>	<i>Baldinini F.</i>
31/01/2021	07	Explanation of the meaning of the motherboard Fuses and troubleshooting	<i>Baldinini F.</i>	<i>Baldinini F.</i>	<i>Baldinini F.</i>
11/2021	08	New remote control group (from 2018)	<i>Baldinini F.</i>	<i>Baldinini F.</i>	<i>Baldinini F.</i>

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 2 / 53	

Index

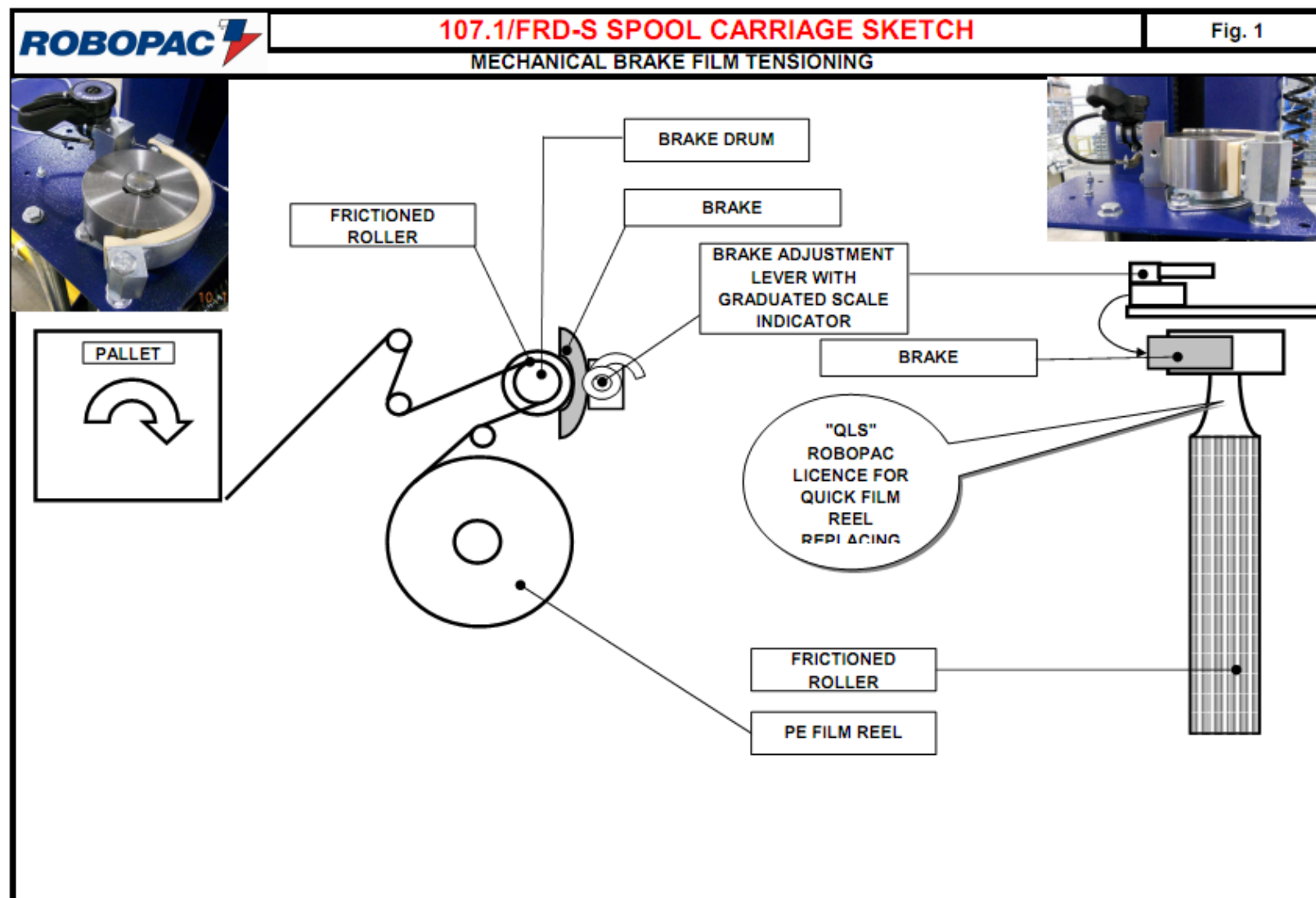
SPOOL CARRIAGES SKETCH DETAILS ROTOPLAT SERIE 7.1.....	4
OPERATOR PANEL DESCRIPTION ROTOPLAT SERIE 7.1	10
SINOPTIC PANEL DESCRIPTION ROTOPLAT SERIE 7.1	11
PARAMETER CYCLE RANGE ROTOPLAT SERIE 7.1	12
KEYBOARD LOCK FUNCTION ROTOPLAT SERIE 7.1.....	13
PACKING CYCLE WITH ALTIMETER MODE (PRODUCT PHOTOCCELL EXLUDED) ROTOPLAT SERIE 7.1	13
MANUAL FUNCTIONS	14
POWER SUPPLY TEST FOR BRAKE/CLUTCH ON SPOOL CARRIAGE ROTOPLAT SERIE 7.1	15
FILM / PRODUCTION DATA ROTOPLAT SERIE 7.1.....	15
INSTRUCTIONS TO REPLACE THE OPERATOR PANEL ROTOPLAT SERIE 7.1	16

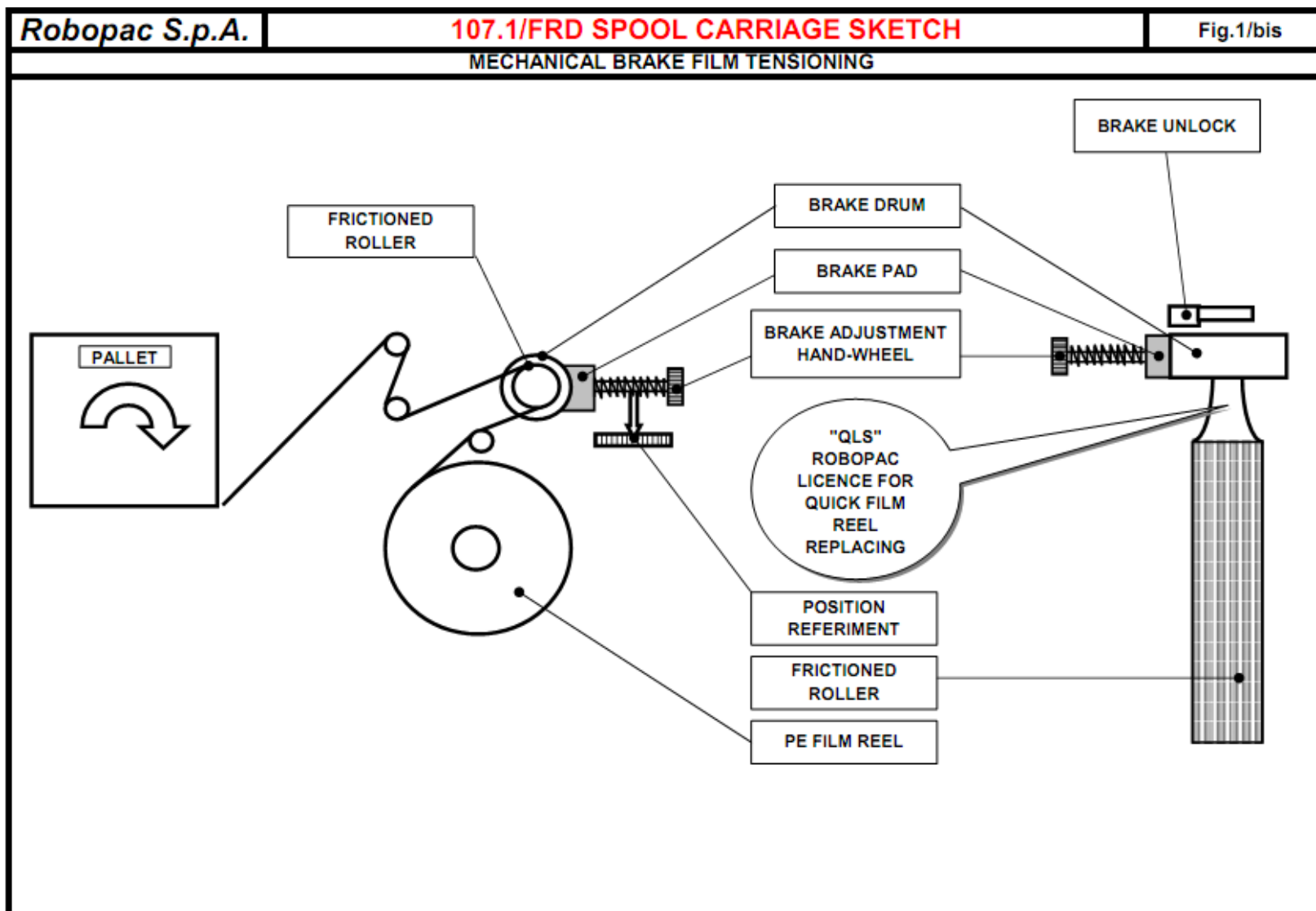
 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 3 / 53	

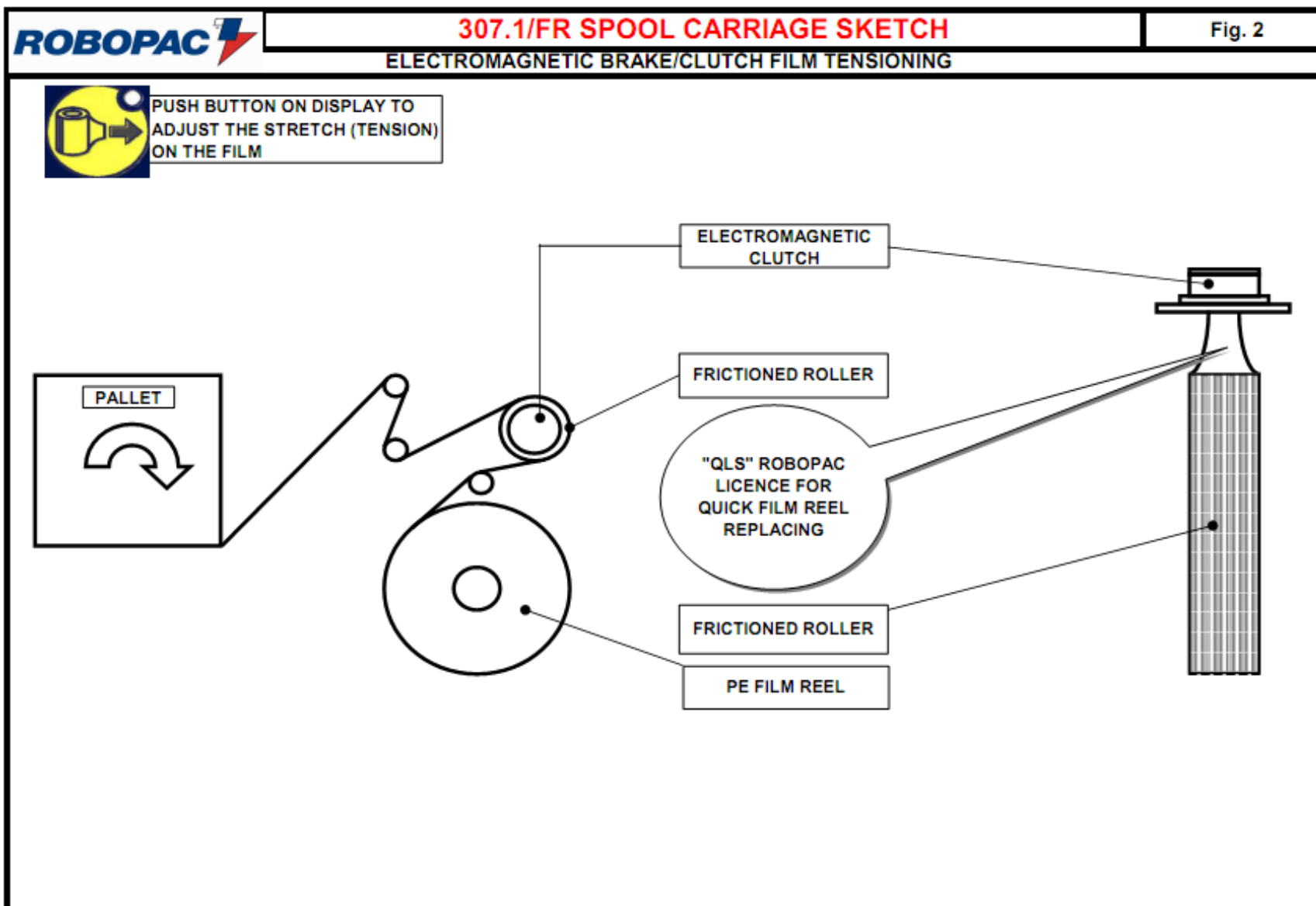
INTERNAL PARAMETER LIST AND SETTING PROCEDURE ROTOPLAT SERIE 7.1 (for 107.1 – 307.1 & 407.1 only).....	17
Machine internal parameter list suitable for Rotoplat Serie 7.1 Basic Range (software release 110 and after).....	17
Machine internal parameter list suitable for Rotoplat Serie 7.1 Basic Range (software release 113 and after).....	18
INTERNAL PARAMETER LIST AND SETTING PROCEDURE ROTOPLAT SERIE 7.1 (for 507.1 & 707.1 only).....	20
Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 232 till release 237)	20
Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 238 till release 241)	22
Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 242 and after) – EUROPE VERSION -	24
Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 242 and after) – U.S.A. VERSION -	26
DEFAULT SETTING PROCEDURE ROTOPLAT SERIE 7.1	28
DISPLAY PANEL LED & PUSH BUTTON TEST ROTOPLAT SERIE 7.1	28
DESCRIPTION LIST FOR “LED” (INPUT / OUTPUT) ON MAIN BOARD and FUSES	29
LOAD CELL CALIBRATION PROCEDURE ROTOPLAT SERIE 7.1	30
REMOTE CONTROL INSTALLATION & SETTING ROTOPLAT SERIE 7.1	31
PRODUCT DETECTION PHOTOCELL SETTINGS ROTOPLAT SERIE 7.1.....	33
STANDARD PHOTOCELL.....	33
DARK PRODUCTS PHOTOCELL	33
DOOR & WINDOW CYCLE (DWP MACHINES) ROTOPLAT SERIE 7.1.....	34
SCALE INSTRUMENT TUNING PROCEDURE FOR ROTOPLAT SERIE 7.1 (WT VERSION)	35
INSTRUMENT SETTING FOR THE CORRECT WORKING AND ACCURACY	36
SETTING PROCEDURE OF THE INSTRUMENT UPON INSTALLATION / REPLACEMENT (COMPLETE PROCEDURE).....	39
ALARM LIST AND TROUBLE-SHOOTING ROTOPLAT SERIE 7.1	47

ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 4 / 53	

SPOOL CARRIAGES SKETCH DETAILS ROTOPLAT SERIE 7.1

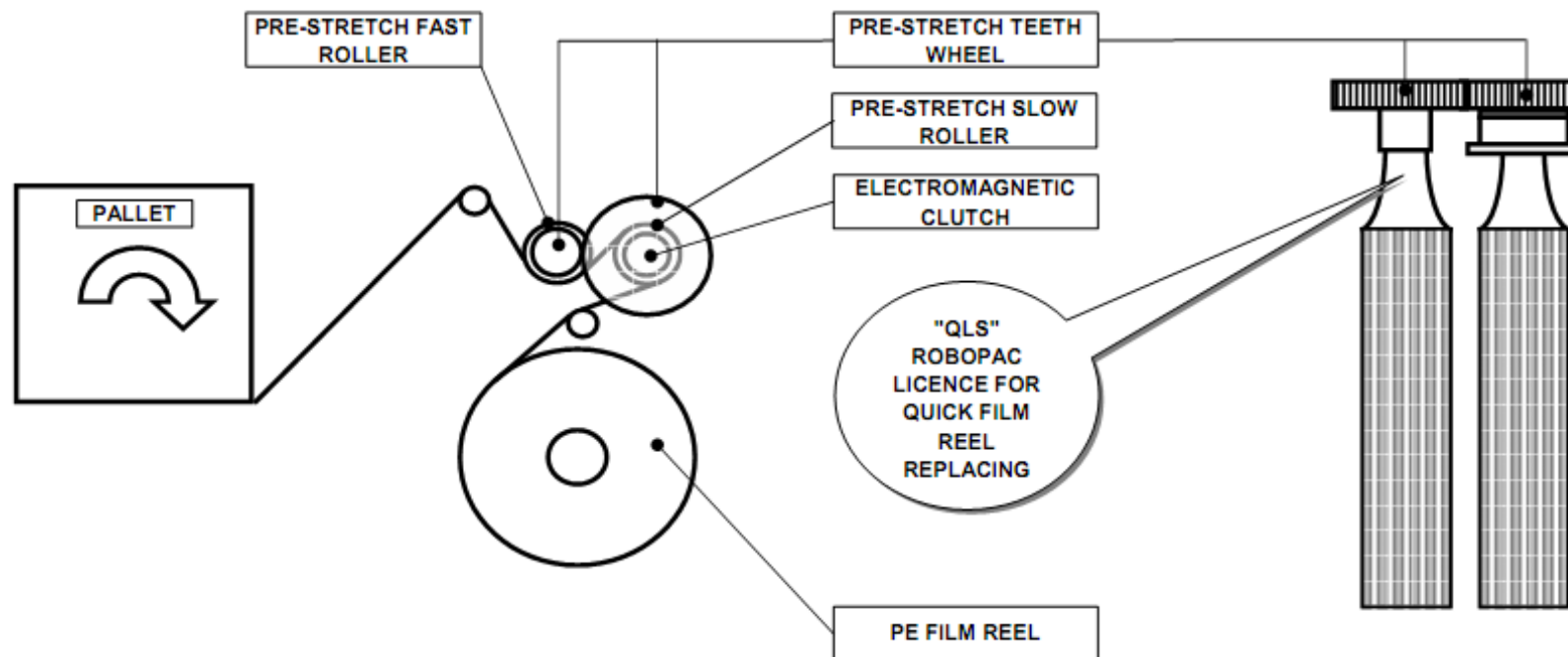


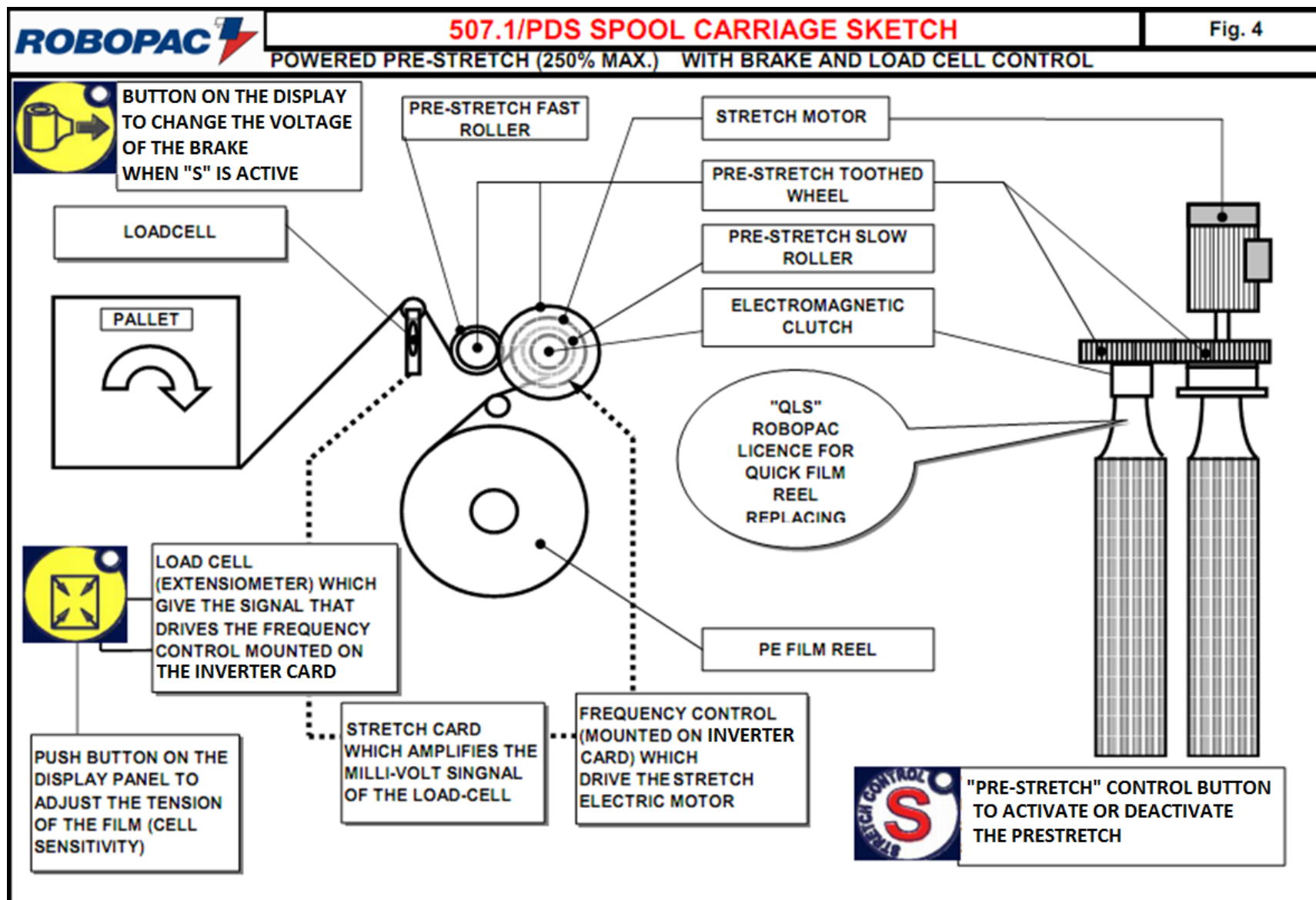


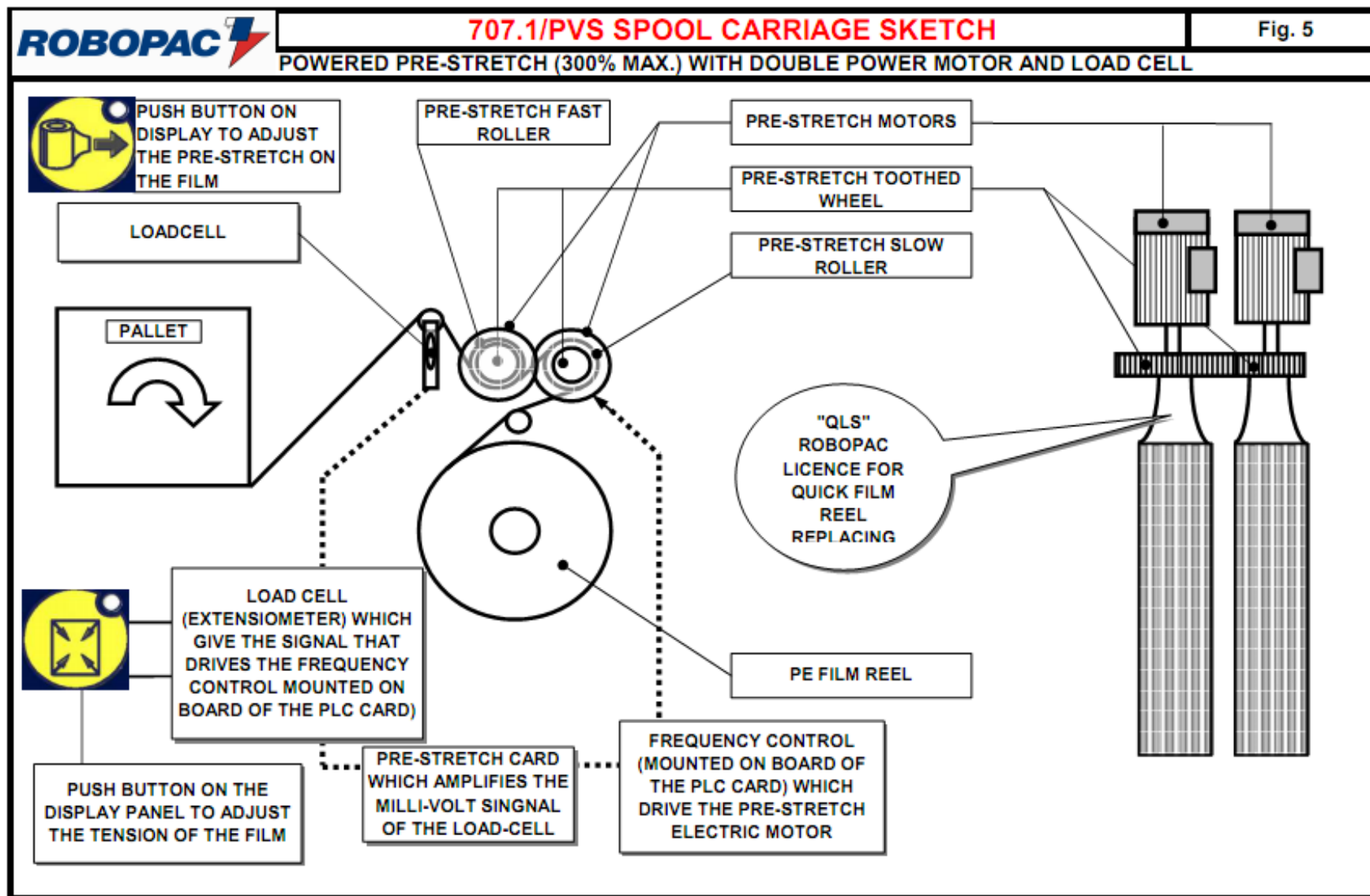




PUSH BUTTON ON DISPLAY TO
ADJUST THE PRE-STRETCH ON
THE FILM







OPERATOR PANEL DESCRIPTION ROTOPLAT SERIE 7.1

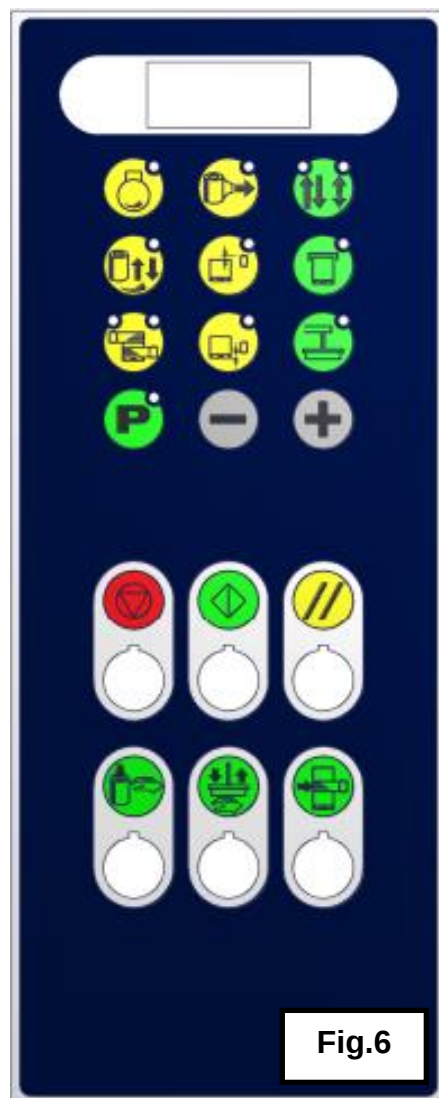


Fig.6

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

- Turntable rotation speed
- Film stretch setting (tension) / Film pre-stretch for FS carriage type.
- Packing cycle selection (Upward / downward or alternate cycle)
- Spool carriage upward / downward speed
- Photocell delay / Altimeter
- Top sheet cycle
- Bottom wrap / Top wrap setting
- Start from ground (offset)
- Enable Pneumatic top platen cycle
- Program packing cycle selection
- Decreasing / Increasing values
- STOP
- START
- RESET
- Manual downward spool carriage
- Manual UP/DOWN pneumatico top platen
- Stop spool carriage (reinforcement rounds)

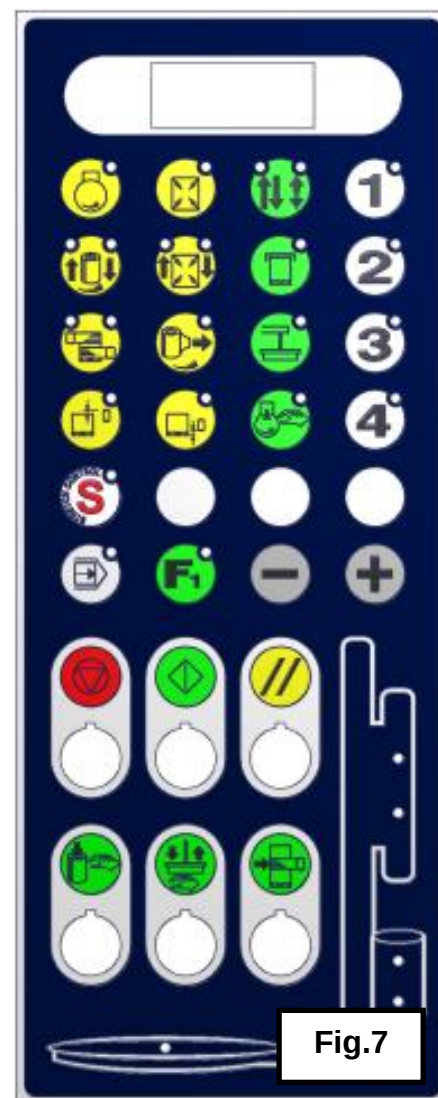


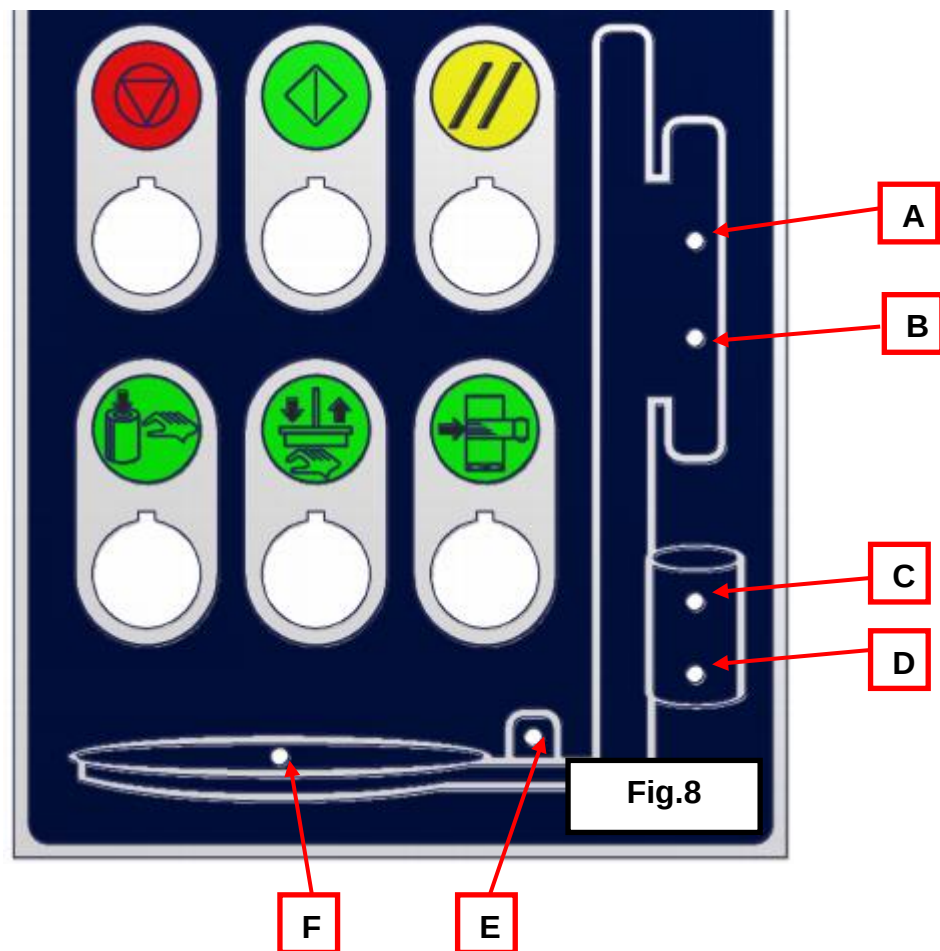
Fig.7

Rotoplat Serie 7.1 High Range (507.1 – 707.1)

- Turntable rotation speed
- Film stretch setting (tension)
- Packing cycle selection (Upward / downward or alternate cycle)
- Program packing cycle selection
- Spool carriage upward / downward speed
- Load-cell sensitivity setting (film stretch UP/DOWN spool carriage)
- Top sheet cycle
- Bottom wrap / Top wrap setting
- Film pre-stretch setting
- Enable Pneumatic top platen cycle
- Photocell delay / Altimeter
- Start from ground (offset)
- Manual movement turntable
- Pre-stretch control enable (fix pre-stretch / adjustable pre-stretch).
- Film Data (packing counters)
- F1 (Free push button for further applications)
- Decreasing / Increasing values
- STOP
- START
- RESET
- Manual downward spool carriage
- Manual UP/DOWN pneumatico top platen
- Stop spool carriage (reinforcement rounds)

SINOPTIC PANEL DESCRIPTION ROTOPLAT SERIE 7.1

(for Rotoplat 507.1 & 707.1 only)



A – Main inverter alarm.

Main inverter overheating message.

B – Spool carriage lifting motor alarm.

Motor failure message.

C – Broken film alarm (707).

Broken film or empty film reel message..

D – Pre-stretch motor alarm.

Motor failure message.

E – Clamp unit alarm.

Clamp unit failure message.

F – Blocked turntable alarm.

Turntable blocked message caused by an obstacle or a failure.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 12 / 53	

PARAMETER CYCLE RANGE ROTOPLAT SERIE 7.1

Rotoplat Serie 7.1 Basic Range
(107.1 – 307.1 – 407.1)

Parameter	Min. – Max.	Step	Measure unit
Bottom wraps	0 – 10	1	Rounds
Top wraps	0 – 10	1	Rounds
Photocell delay	0 – 100	1	Cm
Altimeter	50 -- 305	1	Cm
Offset from ground	0 – 100	1	Cm
Turntable speed rotation (variable by disc diameter):		1	Rpm
• Diameter 1650 mm	4 – 12		
• Diameter 1800 mm	4 – 11		
• Diameter 2200 mm	4 – 8		
• Diameter 2400 mm	4 – 8		
Up-ward spool carriage speed	1.0 – 4.0	0.1	mt/minute
Down-ward spool carriage speed	1.0 – 4.0	0.1	mt/minute

FRD SPOOL CARRIAGE

Parameter	Min –Max.	Step	Measure unit
Film stretch (mechanical)	--	--	--

FR SPOOL CARRIAGE

Parameter	Min –Max.	Step	Measure unit
Film stretch	0 – 100	10	No dimension

FS SPOOL CARRIAGE

Parameter	Min –Max.	Step	Measure unit
Film pre-stretch	0 – 200	10	%

Rotoplat Serie 7.1 High Range
(507.1 – 707.1)

Parameter	Min. – Max.	Step	Measure unit
Bottom wraps	0 – 10	1	Rounds
Top wraps	0 – 10	1	Rounds
Photocell delay	0 – 100	1	Cm
Altimeter	50 -- 305	1	Cm
Offset from ground	0 – 100	1	Cm
Turntable speed rotation (variable by disc diameter):		1	Rpm
• Diameter 1650 mm UE no PVS	4 – 12		
• Diameter 1650 mm UE PVS	9 – 12		
• Diameter 1650 mm USA PDS	6 - 15		
• Diameter 1650 mm USA PVS	10 - 15		
• Diameter 1800 mm	4 – 11		
• Diameter 2200 mm	4 – 8		
• Diameter 2400 mm	4 – 8		
Up-ward spool carriage speed	1.0 – 4.0	0.1	mt/minute
Down-ward spool carriage speed	1.0 – 4.0	0.1	mt/minute
Film stretch when carriage stop (bottom / top and reinforcement wraps)	0 – 100	10	No dimension
Film stretch on carriage up-ward	0 – 100	10	No dimension
Film stretch on carriage down-ward	0 – 100	10	No dimension

PDS SPOOL CARRIAGE

Parameter	Min. – Max.	Step	Measure unit
Film pre-stretch	0 – 25	10	No dimension

CARRELLO PVS

Parameter	Min. – Max.	Step	Measure unit
Film pre-stretch	150 -- 400	10	%
Film stretch when carriage stop (bottom / top and reinforcement wraps)	0 -- 100	10	No dimension
Film stretch on carriage up-ward	0 -- 100	10	No dimension
Film stretch on carriage down-ward	0 -- 100	10	No dimension

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 13 / 53	

KEYBOARD LOCK FUNCTION ROTOPLAT SERIE 7.1

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

It is possible to lock the keyboard to avoid anybody to change the packing cycle parameters selecting between the 4 packing programs, giving the operator the only possibility to select one of the programs pressing the button  and  '+' & '-' to choose the desired one and START and STOP buttons to start and stop the packing.

To lock and unlock the keyboard it is necessary to perform the following operations:

1. Turn OFF the machine.
2. Press simultaneously and keep pressed the push button  "TURNTABLE ROTATION SPEED" &  "BOTTOM WRAPS / TOP WRAPS SETTING" and turn ON the machine till will shown on the display the message rES (RESET).

To remove the locking to the keyboard, it is enough to repeat the same procedure.

Rotoplat Serie 7.1 High Range (507.1 – 707.1)

It is possible to lock the keyboard to avoid anybody to change the packing cycle parameters selecting between the 4 packing programs, giving the operator the only possibility to select one of the programs pressing the button , , ,  to choose the desired one and START and STOP buttons to start and stop the packing.

To lock and unlock the keyboard it is necessary to perform the following operations:

1. Turn OFF the machine.
2. Press simultaneously and keep pressed the push button  "TURNTABLE ROTATION SPEED" &  "BOTTOM WRAPS / TOP WRAPS SETTING" and turn ON the machine till will shown on the display the message rES (RESET).

To remove the locking to the keyboard, it is enough to repeat the same procedure.

PACKING CYCLE WITH ALTIMETER MODE (PRODUCT PHOTOCELL EXLUDED) ROTOPLAT SERIE 7.1

It is possible to use the machine without product detection by the photocell and manually set the high of the pallet in CMS..

To work with this kind of wrapping cycle it is necessary to perform the following operations:

1. Be sure that the machine is on STOP mode.
2. Press and keep pressed the push button  "PHOTOCELL DELAY / ALTIMETER" for 4 seconds until the related led will blinks.
3. The display will shows the value which represent the high of the pallet in CMS.
4. To change the value press the buttons  '+' & '-'
5. To return back to the working cycle with detection of the product by the photocell, press the push button  "PHOTOCELL DELAY / ALTIMETER" push button for 4 seconds until the related led will not blinks anymore.

The working cycle (with photocell detection or with altimeter) is memorized into the Parameter cycles.

It will be possible then to have the Program No.1 that works with photocell detection, and the Program No.2 that works with altimeter perhaps.

7. This setting will be kept if the machine will switched off.

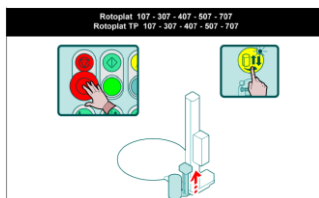
ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 14 / 53	

MANUAL FUNCTIONS

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

To enable the manual function to move up-ward the spool carriage, it is necessary to press the “STOP” push button, in the same time of the “SPOOL CARRIAGE UP-WARD / DOWN-WARD SPEED” push button, as shown in the sketch on the side.

Manual operation up-ward spool carriage



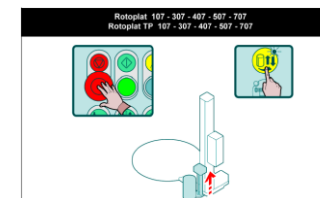
Manual operation down-ward spool carriage

To enable the manual function to move down-ward the spool carriage, it is necessary to press “MANUAL DOWN-WARD SPOOL CARRIAGE” push button

Manual operation turntable rotation

Rotoplat Serie 7.1 High Range (507.1 – 707.1)

To enable the manual function to move up-ward the spool carriage, it is necessary to press the “STOP” push button, in the same time of the “SPOOL CARRIAGE UP-WARD / DOWN-WARD SPEED” push button, as shown in the sketch on the side.



To enable the manual function to move down-ward the spool carriage, it is necessary to press “MANUAL DOWN-WARD SPOOL CARRIAGE” push button

To enable the manual function to run the turntable of the machine, it is necessary to press “MANUAL MOVEMENT TURNTABLE” push button. Pressing the push button one time only, the turntable run in slow speed from starting phase position to stop phase position. Pressing the push button meanwhile the table is manually running, it stops instantly in that position.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 15 / 53	

POWER SUPPLY TEST FOR BRAKE/CLUTCH ON SPOOL CARRIAGE ROTOPLAT SERIE 7.1

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

for FR and FS spool carriages only

Set the parameter P15=100 and the film stretch/pre-stretch () on the display to maximum, turn ON the machine and play a packing cycle measuring on the connectors on the brake on the spool carriage that got to be 9,4 Volt $\pm$ 1 Volt.

Rotoplat Serie 7.1 High Range (507.1 – 707.1)

for PDS spool carriage only

Set the parameter P15=160 and the film stretch () on the display to maximum (200).
Turn ON the machine and play a packing cycle measuring on the connectors on the brake on the spool carriage the voltage that must be 12 Volt $\pm$ 1 Volt.

FILM / PRODUCTION DATA ROTOPLAT SERIE 7.1

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

Press the button  “P” and keep it pressed for 3 seconds.
The display will show the message “Dx” alternatively with the set value. Keeping pressed the button  “P” and pressing the button   “+” it will be possible to scroll through the Data list, D1, D2, D3, D4.

When it shows “D1”, pressing the button  “BOTTOM WRAPS / TOP WRAPS SETTING”, the partial counter cycle “D1” will be reset to zero.

- D1 = partial counter cycle (it is possible to reset)
- D2 = total counter cycle (1.000 – 999.000)
- D3 = total counter (0 - 999)
- D4 = Main board software release.

To exit from the data menu, press each one of the yellow push buttons on the display.

Rotoplat Serie 7.1 High Range (507.1 – 707.1)

Press the push button  “DATA “, the display of the machine will show the message ‘Dx’ alternately to the value.

Pressing again the push button  ‘DATA’ will be possible to scroll the list of all available production DATA .

It is possible to RESET to zero, the partial counter “D1” pressing simultaneously the push buttons   “-” & “+”.

- D1 = partial counter cycle (it is possible to reset)
- D2 = total counter cycle (1.000 – 999.000)
- D3 = total counter (0 - 999)

Meanwhile the value of D3 is visualized keeping pressed the push button DATA for 4 seconds at least will be possible to access to a second level hidden values:

- D4 = mother board Software release FW.
- D5 = pre-stretch card Software release FW.
- D6 = load-cell (extensometer) actual value.
- D7 = film tension inverter frequency actual value

To exit from the data menu, press each one of the yellow buttons.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 16 / 53	

INSTRUCTIONS TO REPLACE THE OPERATOR PANEL ROTOPLAT SERIE 7.1

(This procedure must be followed to replace machine's software also)

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

1. Turn the machine OFF.
2. Move the switch 1 di SW1 in position ON (please refer to fig.9).
3. Turn the machine ON.
4. The display will show the parameter 'P1' blinking alternatively with the set value
5. Keep note of all the internal parameter of the machine (il possible)
6. Replace to operator panel of the machine or the micro-chip which contains the machine's software mounted on the display panel card.
7. Move back the switch 1 of the SW1 to position "ON" (please refer to fig.9).
8. Turn the machine ON
9. To scroll the parameters, push button  'ENABLE PNEUMATIC TOP PLATEN CYCLE' (Enter) to visualize 'SET' on the display.
10. Press simultaneously the buttons  'TURNTABLE ROTATION SPEED' & 'FILM STRETCH / FILM PRE-STRETCH' to visualize the message 'dEF' (this operation will avoid that the machine shows the alarm message **E43 "WRONG INITIALIZAZION OF CYCLE PARAMETERS"** upon next RESTART).
11. Reinsert the internal parameters like original to restore the machine To end-user requirements using the buttons   '+' & '-'
12. Turn the machine OFF.
13. Move back switch 1 of the SW1 to position "OFF" (please refer to fig.9).
14. Turn the machine ON keeping pressed the button  "ENABLE PNEUMATIC TOP PLATEN CYCLE" until The display will shows the next messages '888', 'rel.x', 'SET', 'RES' in sequence (this operation will avoid that the machine shows the alarm message **E42 "WRONG INITIALIZAZION OF INTERNAL PARAMETERS"**).

Rotoplat Serie 7.1 High Range (507.1 – 707.1)

1. Turn the machine OFF.
2. Move the switch 1 di SW1 in position ON (please refer to fig.10).
3. Turn the machine ON.
4. The display will show the parameter 'P1' blinking alternatively with the set value
5. Keep note of all the internal parameter of the machine (il possible)
6. Replace to operator panel of the machine or the micro-chip which contains the machine's software mounted on the display panel card.
7. Move back the switch 1 of the SW1 to position "OFF" (please refer To fig.10).
8. Turn the machine ON
9. To scroll the parameters, push button  'FREE PUSH BUTTON' (Enter) to visualize 'SET' on the display.
10. Press simultaneously the buttons  'TURNTABLE ROTATION SPEED' &  'FILM STRETCH SETTIN' to visualize the message 'dEF' (this operation will avoid that the machine shows the alarm message **E43 "WRONG INITIALIZAZION OF CYCLE PARAMETERS"** upon next RESTART).
11. Reinsert the internal parameters like original to restore the machine to end-user requirements using the buttons   '+' & '-'
12. Turn the machine OFF.
13. Move back switch 1 of the SW1 to position "OFF" (please refer to fig.10).
14. Turn the machine ON keeping pressed the button  "PROGRAMMA 1" until The display will shows the next messages '888', 'rel.x', 'SET', 'RES' in sequence (this operation will avoid that the machine shows the alarm message **E42 "WRONG INITIALIZAZION OF INTERNAL PARAMETERS"**).

ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 17 / 53	

INTERNAL PARAMETER LIST AND SETTING PROCEDURE ROTOPLAT SERIE 7.1 (for 107.1 – 307.1 & 407.1 only)

1. Turn the machine OFF.
2. Move the switch 1 di SW1 in position ON (please refer to fig.9).
3. Turn the machine ON.
4. The display will show the parameter 'P1' blinking alternatively with the set value
5. To scroll the parameters, push button  'ENABLE PNEUMATIC TOP PLATEN CYCLE' (Enter).
6. To modify the value of the parameter, press the buttons   '+' & '-'
7. Turn the machine OFF.
8. Move back switch 1 of the SW1 to position "OFF" (please refer to fig.9).
9. Turn the machine ON to restore the machine to the packing mode.

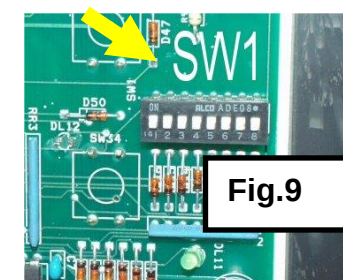


Fig.9

Machine internal parameter list suitable for Rotoplat Serie 7.1 Basic Range (software release 110 and after)

Parameter	Range	Step	Measure unit	Default (producer values)	Parameter description	End-user internal parameter setting
SET					To reset all parameters to default value (producer values)	
P1	0-2			0	Turntable diameter setting: • 0 → 1650 mm: max speed disk rotation 12 rpm. • 1 → 1800 mm: max speed disk rotation 11 rpm. • 2 → 2200 mm or 2400 mm: max speed disk rotation 8 rpm.	
P2				0	Free parameter for further applications	
P3	1-3	1		1	Film spool carriage type (1=FRD; 2=FS; 3=FR)	
P4				0	Free parameter for further applications	
P5	0-1	1		0	Enable self-brake motor on turntable (output G3)	
P6	0-1	1		0	Enable Top Platen	

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1				Date November 2021	Rev.08
	ENGLISH				PAGE 18 / 53	

P7	0-1	1		1	Enable blocked turntable alarm	
P8	0-1	1	--	0	Enable door & windows device (DWP machine model)	
P9				0	Free parameter for further applications	
P10				0	Free parameter for further applications	
P11	0-100	1		50	Corner before turntable deceleration (set it to 42 always)	
P12	10-30	1	Sec/10	30	Beep length (acoustic signal on wrapping start)	
P13	1-50	1	--	22	Acceleration	
P14	1-50	1	--	22	Deceleration	
P15	0-200	2		100	Maximum voltage output friction on spool carriage (pre-stretch)	
P16	0-60	1	Sec/2	12	Top platen downward delay time upon wrapping cycle start	
P17	1-30	1		5	Software filter for push buttons (to rectify electrical disturbs)	
P18				0	Free parameter for further applications	
P19				0	Free parameter for further applications	
P20				0	Free parameter for further applications	

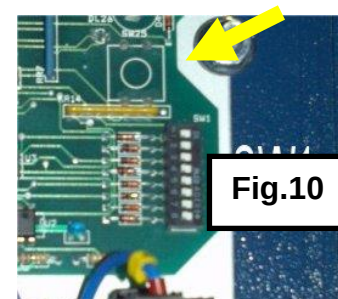
Machine internal parameter list suitable for Rotoplat Serie 7.1 Basic Range (software release 113 and after)						
Parameter	Range	Step	Measure unit	Default (producer values)	Parameter description	End-user internal parameter setting
SET					To reset all parameters to default value (producer values)	
P1	0-4			0	Turntable diameter setting: 0 → 1650 mm: max speed disk rotation 12 rpm. 1 → 1800 mm: max speed disk rotation 11 rpm. 2 → 2200 mm o 2400 mm: max speed disk rotation 8 rpm.	

					• 3 → TP diam.1800 mm: max speed disk rotation 11 rpm. • 4 → TP diam.1650 mm: max speed disk rotation 12 rpm.	
P2	1-3	1		1	Film spool carriage type (1=FRD; 2=FS; 3=FR)	
P3	0-1	1		0	Enable fo up/down spool carriage geabox with ratio 1/80	
P4	0-1	1		0	Free roller conveyor enable.	
P5	0-1	1		0	Enable self-brake motor on turntable (output G3)	
P6	0-1	1		0	Enable Top Platen	
P7	0-1	1		1	Enable blocked turntable alarm	
P8	0-1	1	--	0	Enable door & windows device (DWP machine model)	
P9				0	Free parameter for further applications	
P10				0	Free parameter for further applications	
P11	0-100	1		50	Corner before turntable deceleration (set it to 42 always)	
P12	10-30	1	Sec/10	30	Beep length (acoustic signal on wrapping start)	
P13	1-50	1	--	22	Acceleration	
P14	1-50	1	--	22	Deceleration	
P15	0-200	2		100	Maximum voltage output friction on spool carriage (pre-stretch)	
P16	0-60	1	Sec/2	12	Top platen downward delay time upon wrapping cycle start	
P17	1-30	1		5	Software filter for push buttons (to rectify electrical disturbs)	
P18				0	Free parameter for further applications	
P19				0	Free parameter for further applications	
P20				0	Free parameter for further applications	

ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 20 / 53	

INTERNAL PARAMETER LIST AND SETTING PROCEDURE ROTOPLAT SERIE 7.1 (for 507.1 & 707.1 only)

1. Turn the machine OFF.
2. Move the switch 1 di SW1 in position ON (please refer to fig.10).
3. Turn the machine ON.
4. The display will show the parameter 'P1' blinking alternatively with the set value
5. To scroll the parameters, push button  'FREE PUSH BUTTON' (Enter)
6. To modify the value of the parameter, press the buttons   '+' e '-'
7. Turn the machine OFF.
8. Move back switch 1 of the SW1 to position "OFF" (please refer to fig.10).
9. Turn the machine ON to restore the machine to the packing mode.



Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 232 till release 237)						
Parameter	Range	Step	Measure unit	Default (producer values)	Parameter description	End-user internal parameter setting
SET					To reset all parameters to default value (producer values)	
P1	0 – 4	1	--	0	Parameter not active for USA market machines software. • 0 →1650 mm: max speed disk rotation 12 rpm. • 1 →1800 mm: max speed disk rotation 11 rpm. • 2 →2200 mm o 2400 mm: max speed disk rotation 8 rpm. • 3 →1800 mm TP: max speed disk rotation 11 rpm. • 4 →1650 mm TP: max speed disk rotation 12 rpm.	
P2	1-3	1	--	2	Film spool carriage selection (2=PDS; 3=PVS)	
P3	0-1	1	--	1	Enable blocked turntable alarm	
P4	0-1	1	--	0	Enable broken film alarm	

P5	0-1	1	--	1	Enable blocked film spool carriage alarm	
P6	0-1	1	--	0	Enable fo up/down spool carriage gearbox with ratio 1/80	
P7	0-60	1	Sec/2	6	Top platen downward delay time upon wrapping cycle start	
P8	1-30	1	--	5	Software filter for push buttons (to rectify electrical disturbs from source)	
P9	10-40	5	(%) / 10	25	Maximum pre-stretch value for PVS film spool carriage or pre-stretch value shown on display for PDS In case of PVS film spool carriage, set it like: • 30 if machine is for European market • 40 if machine is for USA market	
P10	0-5	1	--	1	Special packing cycle selection: →0 = Standard cycle →1 = Automatic cutting →2 = Door & windows cycle (DWP machines model). →3 = Turntable with self-braking motor →4 = Turntable with self-braking motor + idle roller conveyor →5 = Turntable with self-braking motor + idle roller conveyor + door & window.	
P11	0-100	5	--	15	Film tension during film cutting (0=disabled)	
P12	0-150	1	Sec/10	28	Film tail length from rolls after cutting (time delay)	
P13	0-100	1		25	Film spool carriage down-ward time fro Top Sheet Cycle	
P14	1-200	1	Sec/100	25	Forward time for cutter device	
P15	0-255	5	--	160	Maximum voltage output friction on spool carriage without SCS (prestretch)	
P16	5-99	1	--	20	Kp: proportional Gain on pre-stretch load cell	
P17	1-99	1	--	40	Film stretch constant	
P18	1-255	1	--	120	Acceleration/deceleration Inverter stretch and pre-stretch	
P19	0-30	1	(%) / 10	14	SCS deactivation lower limit	
P20	0-200	1	--	140	SCS shutter	
P21	0-200	1	1 / Hz	22	Turntable deceleration	
P22	0-200	1	1 / Hz	100	Turntable deceleration for TP shaped basement	
P23	0-1	1	--	0	Enable Top Platen	

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 22 / 53	

Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 238 till release 241)						
Parameter	Range	Step	Measure unit	Default (producer values)	Parameter description	End-user internal parameter setting
SET					To reset all parameters to default value (producer values)	
P1	0 – 4	1	--	0	Parameter not active for USA market machines software. • 0 →1650 mm: max speed disk rotation 12 rpm. • 1 →1800 mm: max speed disk rotation 11 rpm. • 2 →2200 mm o 2400 mm: max speed disk rotation 8 rpm. • 3 →1800 mm TP: max speed disk rotation 11 rpm. • 4 →1650 mm TP: max speed disk rotation 12 rpm.	
P2	1-3	1	--	2	Film spool carriage selection (2=PDS; 3=PVS)	
P3	0-1	1	--	1	Enable blocked turntable alarm	
P4	0-1	1	--	0	Enable broken film alarm	
P5	0-1	1	--	1	Enable blocked film spool carriage alarm	
P6	0-1	1	--	0	Enable fo up/down spool carriage gearbox with ratio 1/80	
P7	0-60	1	Sec/2	6	Top platen downward delay time upon wrapping cycle start	
P8	1-30	1	--	5	Software filter for push buttons (to rectify electrical disturbs from source)	
P9	10-40	5	(%) / 10	25	Maximum pre-stretch value for PVS film spool carriage or pre-stretch value shown on display for PDS In case of PVS film spool carriage, set it like: • 30 if machine is for European market • 40 if machine is for USA market	
P10	0-1	1	--	1	Enable for automatic cut	
P11	0-100	5	--	15	Film tension during film cutting (0=disabled)	

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1				Date November 2021	Rev.08
	ENGLISH				PAGE 23 / 53	

P12	0-150	1	Sec/10	28	Film tail length from rolls after cutting (time delay)	
P13	0-100	1		25	Film spool carriage down-ward time fro Top Sheet Cycle	
P14	1-200	1	Sec/100	25	Forward time for cutter device	
P15	0-255	5	--	160	Maximum voltage output friction on spool carriage without SCS (prestretch)	
P16	5-99	1	--	20	Kp: proportional Gain on pre-stretch load cell	
P17	1-99	1	--	40	Film stretch constant	
P18	1-255	1	--	120	Acceleration/deceleration Inverter stretch and pre-stretch	
P19	0-30	1	(%) / 10	14	SCS deactivation lower limit	
P20	0-200	1	--	140	SCS shutter	
P21	0-200	1	1 / Hz	22	Turntable deceleration	
P22	0-200	1	1 / Hz	100	Turntable deceleration for TP shaped basement	
P23	0-1	1	--	0	Enable Top Platen	
P24	0-1	1	--	0	Enable for self-brake motore on turntable	
P25	0-1	1	--	0	Enable for free roll conveyor on turntable (input for E10 alram message)	
P26	0-1	1	--	0	Enable for machine equipped with (DW system) – packing door & wondows	

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 24 / 53	

**Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 242 and after) – EUROPE
VERSION -**

Parameter	Range	Step	Measure unit	Default (producer values)	Parameter description	End-user internal parameter setting
SET					To reset all parameters to default value (producer values)	
P1	0 – 4	1	--	0	• 0 →1650 mm: max speed disk rotation 12 rpm. • 1 →1800 mm: max speed disk rotation 11 rpm. • 2 →2200 mm o 2400 mm: max speed disk rotation 8 rpm. • 3 →1800 mm TP: max speed disk rotation 11 rpm. • 4 →1650 mm TP: max speed disk rotation 12 rpm.	
P2	1-3	1	--	2	Film spool carriage selection (2=PDS; 3=PVS)	
P3	0-1	1	--	1	Enable blocked turntable alarm	
P4	0-1	1	--	0	Enable broken film alarm	
P5	0-1	1	--	1	Enable blocked film spool carriage alarm	
P6	0-1	1	--	0	Enable fo up/down spool carriage geabox with ratio 1/80	
P7	0-60	1	Sec/2	6	Top platen downward delay time upon wrapping cycle start	
P8	1-30	1	--	5	Software filter for push buttons (to rectify electrical disturbs from source)	
P9	10-40	5	(%) / 10	25	Maximum pre-stretch value for PVS film spool carriage or pre-stretch value shown on display for PDS In case of PVS film spool carriage, set it like: • 30 if machine is for European market	
P10	0-1	1	--	1	Enable for automatic cut	
P11	0-100	5	--	15	Film tension during film cutting (0=disabled)	
P12	0-150	1	Sec/10	28	Film tail length from rolls after cutting (time delay)	



Norm. Tecn.
60.2.51_05

TECHNICAL DOCUMENTATION

ROTOPLAT SERIE 7.1

Date

November 2021

Rev.08

ENGLISH

PAGE 25 / 53

P13	0-100	1		25	Film spool carriage down-ward time fro Top Sheet Cycle	
P14	1-200	1	Sec/100	25	Forward time for cutter device	
P15	0-255	5	--	160	Maximum voltage output friction on spool carriage without SCS (prestretch)	
P16	5-99	1	--	20	Kp: proportional Gain on pre-stretch load cell	
P17	1-99	1	--	40	Film stretch constant	
P18	1-255	1	--	120	Acceleration/deceleration Inverter stretch and pre-stretch	
P19	0-30	1	(%) / 10	14	SCS deactivation lower limit	
P20	0-200	1	--	140	SCS shutter	
P21	0-200	1	1 / Hz	22	Turntable deceleration	
P22	0-200	1	1 / Hz	100	Turntable deceleration for TP shaped basement	
P23	0-1	1	--	0	Enable Top Platen	
P24	0-1	1	--	0	Enable for self-brake motore on turntable	
P25	0-1	1	--	0	Enable for free roll conveyor on turntable (input for E10 alram message)	
P26	0-1	1	--	0	Enable for machine equipped with (DW system) – packing door & wondows	
P27	0-200	1	--	5	ki/10 (PID integral coefficient)	

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 26 / 53	

**Machine internal parameter list suitable for Rotoplat Serie 7.1 High Range (software release 242 and after) – U.S.A.
VERSION -**

Parameter	Range	Step	Measure unit	Default (producer values)	Parameter description	End-user internal parameter setting
SET					To reset all parameters to default value (producer values)	
P1	0	0	--	0	NOT USED	
P2	2-3	1	--	2	Film spool carriage selection (2=PDS; 3=PVS)	
P3	0-1	1	--	1	Enable blocked turntable alarm	
P4	0-1	1	--	0	Enable broken film alarm	
P5	0-1	1	--	1	Enable blocked film spool carriage alarm	
P6	1-2	1	--	1	1= Enable fo up/down spool carriage geabox with ratio 1/80 2 = Enable fo up/down spool carriage geabox with ratio 1/70 with pinon Z22	
P7	0-60	1	Sec/2	6	Top platen downward delay time upon wrapping cycle start	
P8	1-30	1	--	5	Software filter for push buttons (to rectify electrical disturbs from source)	
P9	10-40	5	(%) / 10	25	Maximum pre-stretch value for PVS film spool carriage or pre-stretch value shown on display for PDS In case of PVS film spool carriage, set it like: • 40 if machine is for U.S.A. market	
P10	0-1	1	--	1	Enable for automatic cut	
P11	0-100	5	--	15	Film tension during film cutting (0=disabled)	
P12	0-150	1	Sec/10	28	Film tail length from rolls after cutting (time delay)	
P13	0-100	1		25	Film spool carriage down-ward time fro Top Sheet Cycle	
P14	1-200	1	Sec/100	25	Forward time for cutter device	

P15	0-255	5	--	160	Maximum voltage output friction on spool carriage without SCS (prestretch)	
P16	5-99	1	--	20	Kp: proportional Gain on pre-stretch load cell Set 20 for PDS carriage	
P17	1-99	1	--	40	Film stretch constant	
P18	1-255	1	--	120	Acceleration and deceleration for stretch and pre-stretch inverter Set 120 for PDS carriage 250 for PVS carriage	
P19	0-30	1	(%) / 10	14	SCS deactivation lower limit	
P20	0-200	1	--	140	SCS shutter	
P21	0-200	1	1 / Hz	22	Turntable deceleration	
P22	0-200	1	1 / Hz	100	Turntable deceleration for TP shaped basement	
P23	0-1	1	--	0	Enable Top Platen	
P24	0-200	1	--	5	ki/10 (PID integral coefficient) Set 0 for PDS carriage 5 for PVS carriage	

ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 28 / 53	

DEFAULT SETTING PROCEDURE ROTOPLAT SERIE 7.1

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

To reset the machine to default “producer parameters” it is necessary to follow the next procedure:

1. Keep note of all the internal parameter of the machine (please refer to the above paragraph #10 from point 1 to 5).
2. Turn the machine OFF.
3. Turn the machine ON keeping pressed the push button 
“PACKING CYCLE SELECTION (UP / DOWN CYCLE OF ALTERNATE CYCLE)”.
4. The display will shows the next messages ‘888’, ‘rel.x’, ‘SET’, ‘RES’ in sequence.
5. Turn the machine OFF to restore to the “packing mode”.

Rotoplat Serie 7.1 Hign Range (507.1 – 707.1)

To reset the machine to default “producer parameters” it is necessary to follow the next procedure:

1. Keep note of all the internal parameter of the machine (please refer to the above paragraph #10 from point 1 to 5).
2. Turn the machine OFF.
3. Turn the machine ON keeping pressed the push button 
“PROGRAM 1”.
4. The display will shows the next messages ‘888’, ‘rel.x’, ‘SET’, ‘RES’ in sequence.
5. Turn the machine OFF to restore to the “packing mode”.

DISPLAY PANEL LED & PUSH BUTTON TEST ROTOPLAT SERIE 7.1

Rotoplat Serie 7.1 Basic Range (107.1 – 307.1 – 407.1)

It is possible to test if the touch push button of the operator panel are working properly, following the next procedure:

1. Turn OFF the machine
2. Move the switch 7 on SW1 in ON position (see Fig.9)
3. Turn ON the machine
4. Press all the push button on the display panel checking that their related LED will light ON.
5. Move the switch 7 on SW1 in its original OFF position (see Fig.9) and turn OFF the machine

Rotoplat Serie 7.1 Hign Range (507.1 – 707.1)

It is possible to test if the touch push button of the operator panel are working properly, following the next procedure:

1. Turn OFF the machine
2. Move the switch 8 on SW1 in ON position (see Fig.10)
3. Turn ON the machine
4. Press all the push button on the display panel checking that their related LED will light ON.
5. Move the switch 8 on SW1 in its original OFF position (see Fig.10) and turn OFF the machine

DESCRIPTION LIST FOR “LED” (INPUT / OUTPUT) ON MAIN BOARD and FUSES

Led	Connector	Description	Leds at START
DL2	G2	NO LED	OFF
DL3	G3	(Free OUTPUT)	OFF
DL4	G7	Upward pressure	OFF
DL5	G8	Downward pressure	OFF
DL6	G4	Electromagnetic clutch	OFF
DL7	--	Presence 24 Vdc	OFF
DL8	H2	Detecting product Photocell	ON
DL9	H5	Turntable phase	ON
DL10	H7	Emergency TP photocell	ON
DL11	H10	NO LED	OFF
DL12	H12	NO LED	OFF
DL13	H13	NO LED	OFF
DL14	L1	NO LED	OFF
DL15	L5	Spool Carriage Safety Alarm	ON
DL16	L6	Film reel unwinding input	OFF
DL17	L7	Spool Carriage Top switch	ON
DL18	L9	Spool Carriage bottom switch	OFF
DL20	--	Upward Spool Carriage	OFF
DL21	--	Downward Spool Carriage	OFF
DL22	--	Rotation of turn table plate	OFF

F1 = PHASE of the power supply (16A)

F2 = NEUTRAL of the power supply (16A)

F3 = POSITIVE POLE DC bus – rectified – (1,6A)

F4 = +24Vdc logic (2A)

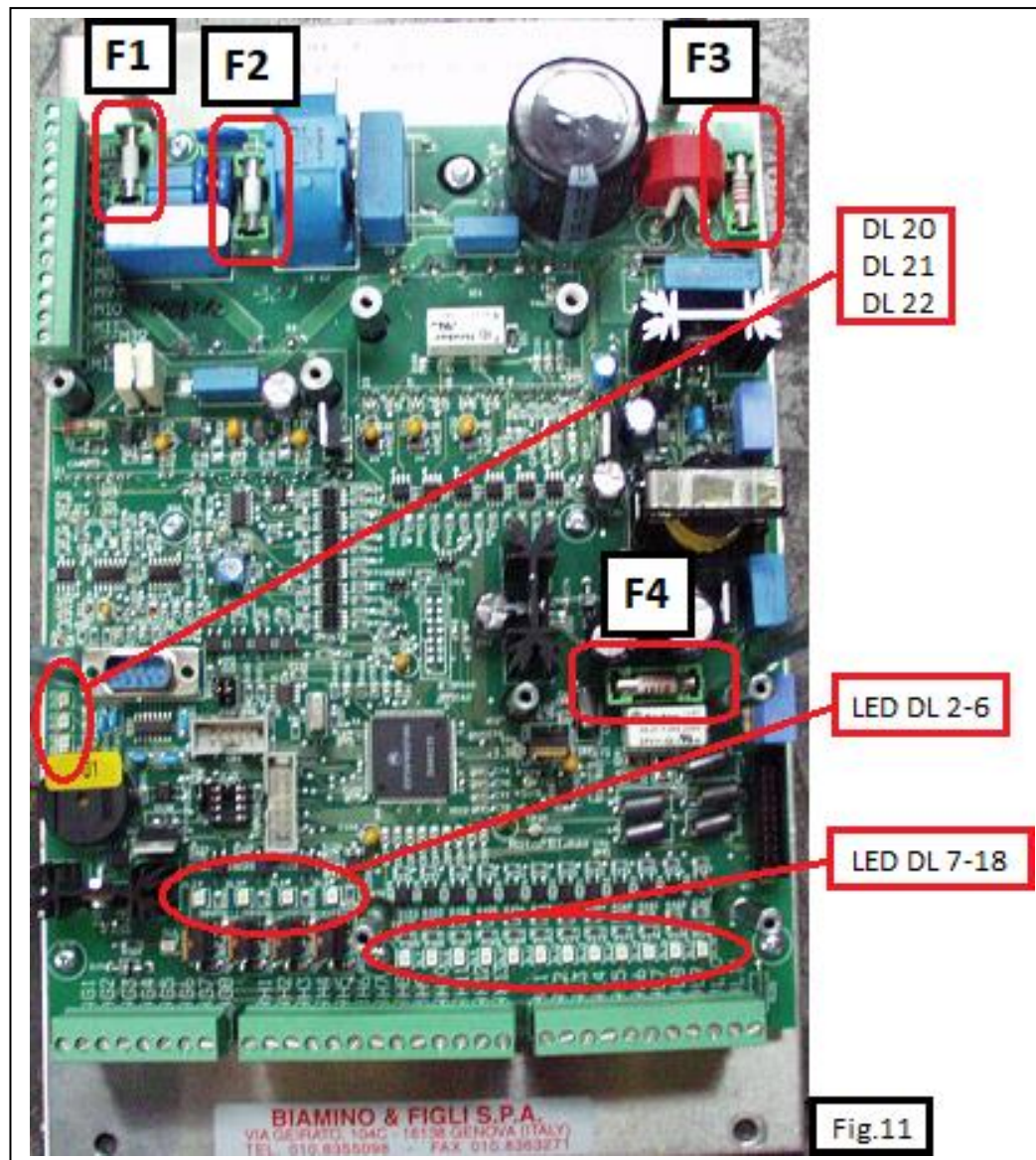
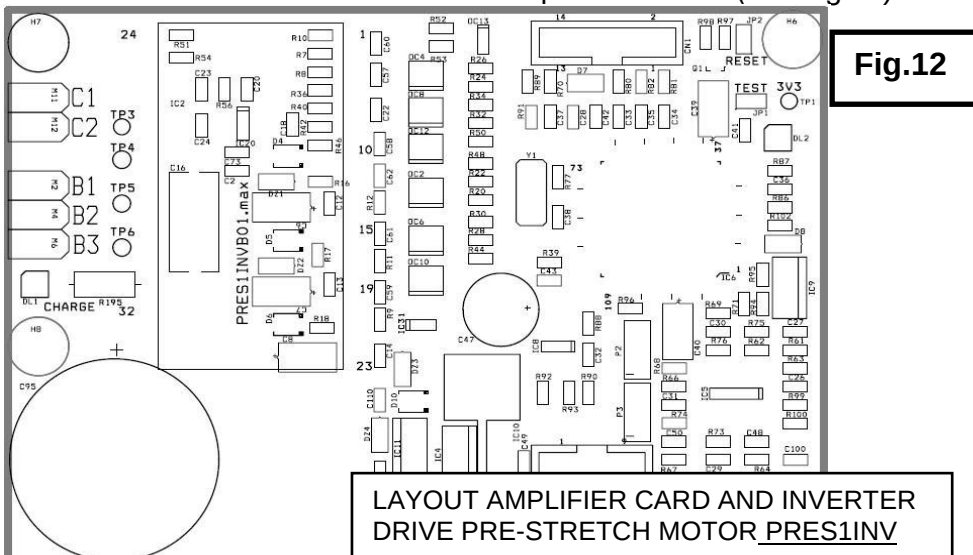


Fig.11

LOAD CELL CALIBRATION PROCEDURE ROTOPLAT SERIE 7.1

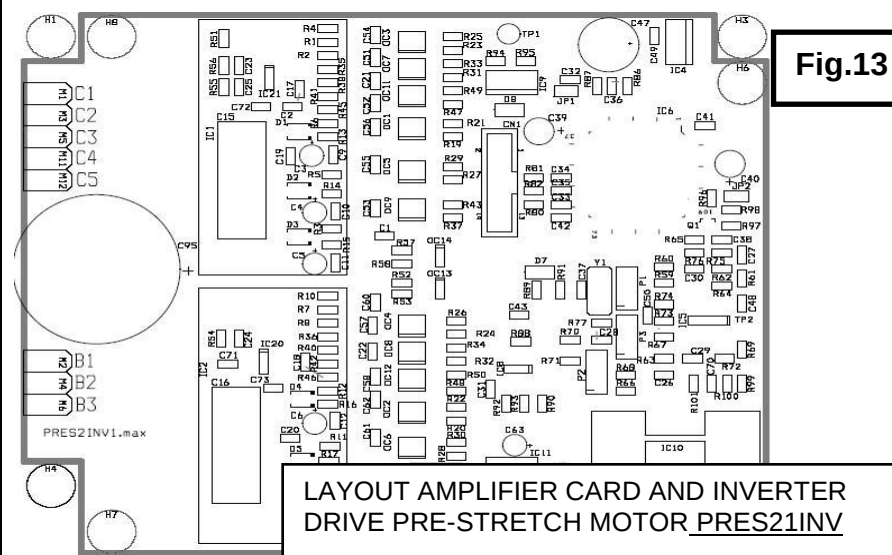
To perform the offset of the load cell it is necessary to carry out the following operations:

1. The machine MUST be in ON MODE for 2 minutes at least
2. Move the switch 7 of SW1 to position "ON" (see Fig.10)
3. Check to be sure that the load cell is completely free and on rest position.
4. Press the  'DATA FILM' push button to visualize D3 or DP.
5. Press again and keep pressed the  'DATA FILM' push button for 4 sec at least (it access to D4)
6. Press the  'DATA FILM' push button to visualize D6 (Instant value of the weight applied on the load cell, that for Rotoplat 507 and Rotoplat 707 that equips pre-stretch boards produced before board's s/n **12F8032** it must be comprised between **280 & 330 points**, and for machines Rotoplat 707 that equips pre-stretch cards produced starting from boards s/n **12F8032** it must be comprised between **440 and 500 points**
7. Move back the switch 7 of the SW1 to position "OFF" (see Fig.10).



Trouble-shooting for amplifier / inverter card pre-stretch motor

Led DL2	OFF	Card not powered / defected
	ON	Card ready to work
	Regular continuous blinking	Normal working and regular communication with mother-board
	1 Blink	Power supply of logic section of the card non sufficient
	2 Blinks	Power module not initialized
	3 Blinks	Over temperature alarm
	4 Blinks	Overload alarm
	5 Blinks	Film break alarm



 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 31 / 53	

REMOTE CONTROL INSTALLATION & SETTING ROTOPLAT SERIE 7.1

To install the remote control it is necessary to perform the procedure of RX & TX codes in self-learning of the receiver.

1. New code setting

- 1.1. Set the dip switch 1 & 2 to OFF.
- 1.2. For the channel 1, press the button P1 till the related led will become ON (LED1).
- 1.3. Press the (START) push button of the remote and keep it pressed until the second led will become ON too (the second led makes a blink).
- 1.4. Release the (START) push button of the remote
- 1.5. The receiver will confirm the successful setting by a double blinks (2) of the two leds
- 1.6. In case of failed setting, the receiver will turn OFF the related led of the channel and will not make any double blink of setting confirmation. If the memory of the codes is full, the receiver will advise this event by seven (7) blinks of the two leds.
- 1.7. For the channel 2, press the push button P2; the other operations works the same as above (setting the STOP push button of the remote).

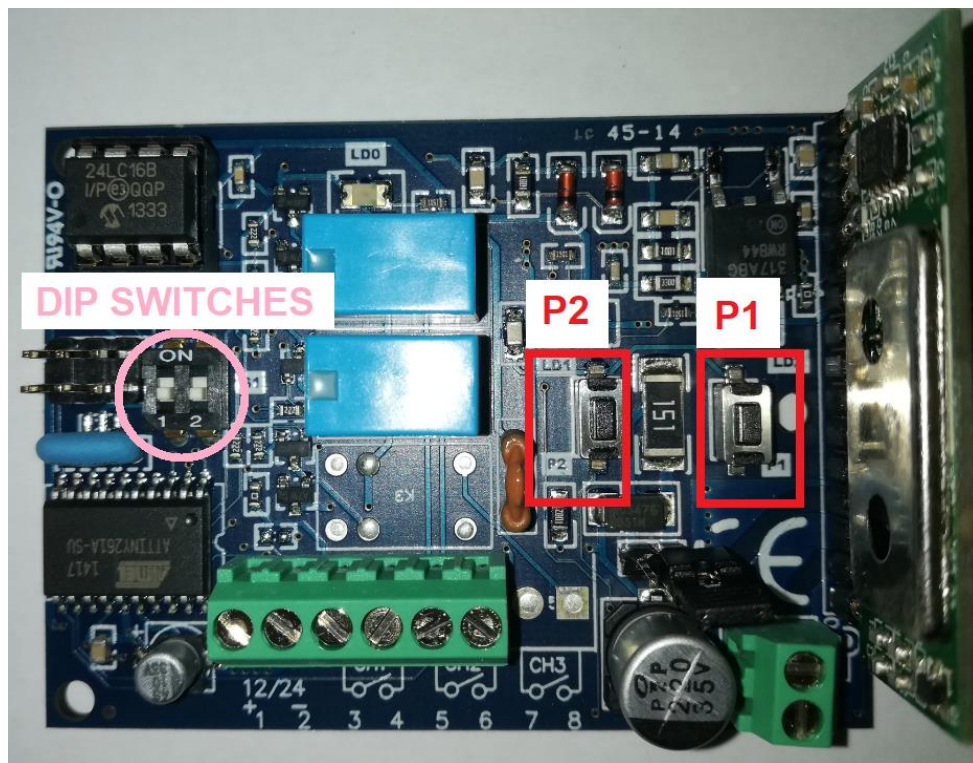
2. Set code deleting

- 2.1. Press the push button P1 (or P2) until the related led will become ON LED1 (or LED2).
- 2.2. Press the push button Ch.1 (or Ch.2) of the remote.
- 2.3. The receiver will confirm the successful deleting by five (5) blinks of the two leds
- 2.4. In case of failure on the receiver the related led of the selected channel and will not make the five blinks of confirmation.

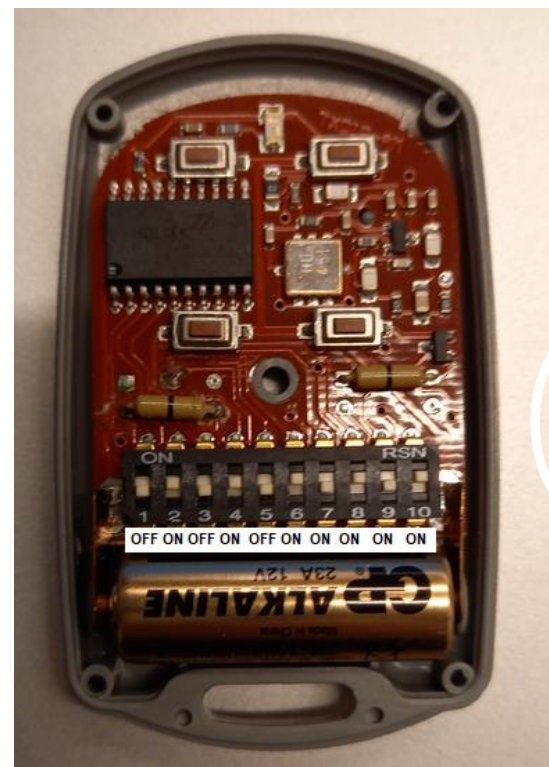
3. All set code deleting

- 3.1. Press the push button P1 until the LED1 will become ON and keep it pressed until it will become OFF again..
- 3.2. On the receiver will become ON the LED1, and after 7 seconds will become OFF again giving confirmation of the deleted codes.

Receiver card detail



Remote emitter card configuration.



4. Electrical connections

9,10	Central "Antenna" – Sock "Antenna"
3,4	N.O. contact channel 1 (START)
5,6	N.O. contact channel 2 (STOP)
1	0 V ac,dc
2	+12V,+24V ac,dc

5. Technical characteristics

Power supply	+12V,+24V ac,dc
--------------	-----------------

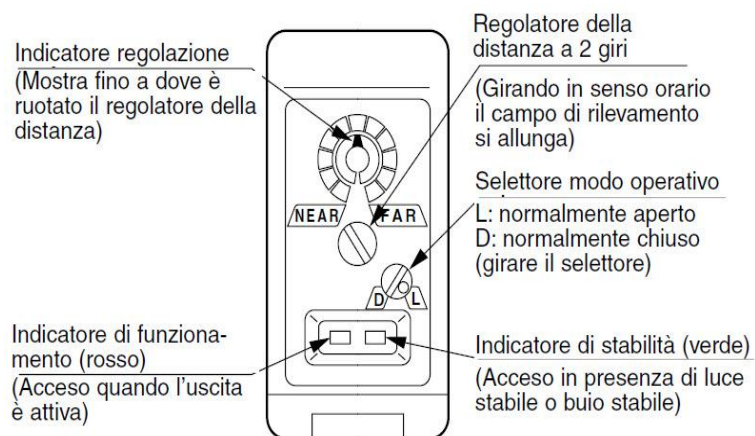
ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 33 / 53	

PRODUCT DETECTION PHOTOCELL SETTINGS ROTOPLAT SERIE 7.1

STANDARD PHOTOCELL

Adjust the trimmer of the photocell sensitivity (distance detection) to the centre of the product to pack

DARK PRODUCTS PHOTOCELL



Set the selector "operation mode" to "L" (turn the selector clock-wise direction till the end).

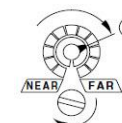
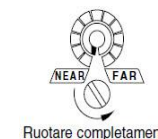
Sensitivity setting for dark product photocell

Description

Turn completely the selector counter clock-wise direction in case of minimum distance (about 0.2mm).

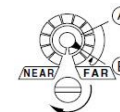
Locate the object to detect from the photocell (pallet centre) and turn the selector clock-wise direction till "A" to set the photocell in "light" condition (output active)

Distance selector

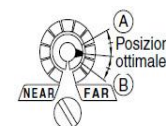


ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 34 / 53	

Remove the a.m. object. Turn the selector in clock-wise direction till switch again the photocell to “light” condition. When it become on, turn again the selector to switch to “dark” to “B” (if absence of the object to detect the photocell do not switch to “light” condition ON, the “B” point must be considered like maximum point of the setting range).



Set the selector to half range (middle between point “A” and point “B” that should be the best point to detect the object



DOOR & WINDOW CYCLE (DWP MACHINES) ROTOPLAT SERIE 7.1

It is possible to move the top platen in manual mode by pressing the pneumatic pedal.

To wraps the product, move the top platen downward pressing the pedal.

When the top platen reached and blocked the door or the window, press the START push button starting the packing cycle. The upward movement of the spool carriage, will be stopped by the top limit switch and not by the photocell. When the packing cycle is complete, rise up the top platen by pressing the pedal.

It is important that during the automatic cycle (packing) pressing the pedal, the top platen MUST not move in any direction..

ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 35 / 53	

SCALE INSTRUMENT TUNING PROCEDURE FOR ROTOPLAT SERIE 7.1 (WT VERSION)

The pallet weighing device (model SD/01) must be set performing the following procedure:

- 20.1. Instrument setting for the correct functioning and accuracy.**
 - 19.1.1. "Zero" scale setting.
- 20.2. Setting procedure of the Instrument upon installation / replacement (complete procedure).**
 - 20.2.1 Setting for maximum value of the Set Point A to 2000 KG (5000 Lb for USA machines).
 - 20.2.2 Select the "Set Point A" as N.C. (normally closed contact) and active and positive.
 - 20.2.3 Set the serial output..
 - 20.2.4 Set the parameter of the converter.
 - 20.2.5 Set the parameter of the Instrument.
 - 20.2.6 Set-up the "Zero" of the scale.

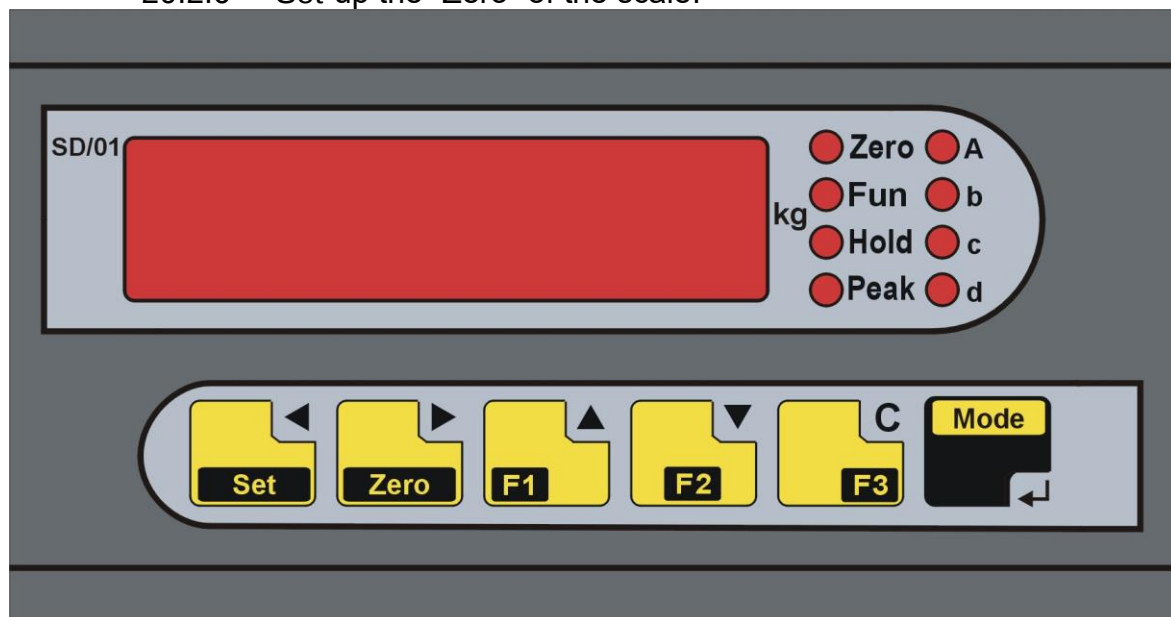


Fig.16

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 36 / 53	

INSTRUMENT SETTING FOR THE CORRECT WORKING AND ACCURACY

In case that the instrument is not properly working, and it displays wrong or not precise products weight, we suggest you to make the “Zero scale” of the instrument following the next procedure:

20.1.1. “ZERO” SCALE SETTING.

To modify the parameters of the converter, it is necessary to use a password (code **C00400**) as described here below.



press within 3 seconds key **Mode** (pn) & key **Zero** (pn)



it shows **C00000** to insert the access codes.

Pressing the key **Mode** (pn) when **C00000** is shown, it return in weighing mode.



Set the code **C00400**



The following operations must be performed without film reel and all the protection cover mounted on the machine.



press the key Mode to confirm it.



the display will shows **Unit** for 3 seconds aprox and than it introduce the set value of the division.



the display will shows **d nnn**. Set **nnn** to value **0.2** by the buttons  &  and to **0.5** for the USA machines.



press the key Mode to accept it.



it shows **CALibr** for 3 seconds aprox and than it shows the weight value from the scale.



this value is number that change when the weight change and with the division, but it doesn't correspond to the real weight of the product (except if you made a calibration before).

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 37 / 53	



on the scale(all machine) there must not be any weights except the fixed tare.



press **F2** to perform the zero setting.



it shows **t 0** that correspond to the net weight 0 (zero).



now you must load a known weight (sample weight) on the machine



you will see a value that will not be the real weight (making the weight tare, the two value will coincide).



press key **F1** to proceed with weight tare.



it shows **PESO 1** for 3 seconds aprox and than it goes ahead to the next message.



it shows **P00000** with first digit blinking.

Wright the known weight loaded on the machine (sample weight = 1000).

For the USA machines you should consider that 1,0 Lb is 0,453 Kgs, so the weight load to input in the instrument is x/0,453.



press the key **Mode** to memorise the value.



it shows **PESO 2** for 3 seconds aprox and than it goes ahead to the next message.



it shows **P00000** with first digit blinking.

If the value of **P00000** is not modified, then, it is possible to complete the operation pressing **Mode**



Setting a new sample value, that must be same of the real weight of the sample applied on the turntable, it is possible to get a second calibration to get a most accuracy performance of the instrument.

it shows **P00000** with first digit blinking. Wright the known weight loaded on the machine (sample weight = 500).

For the USA machines you should consider that 1,0 Lb is 0,453 Kgs, so the weight load to input in the instrument is x/0,453.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 38 / 53	



press the key **Mode** to memorise the value.



it shows **PESO 3** for 3 seconds aprox and than it goes ahead to the next message.



it shows **P00000** with first digit blinking.

If the value of **P00000** is not modified, then, it is possible to complete the operation pressing **Mode** . Setting a new sample value, that must be same of the real weight of the sample applied on the turntable, it is possible to get a second calibration to get a most accuracy performance of the instrument. it shows **P00000** with first digit blinking. Wright the known weight loaded on the machine (sample weight = 250). **For the USA machines you should consider that 1,0 Lb is 0,453 Kgs, so the weight load to input in the instrument is x/0,453.**



press the key **Mode** to memorise the value.



it shows **Calibr** for 3 seconds aprox and than the calibrated weight will be shown.



the calibrated weight must be equal to the sample weight loaded on the machine. If you made a mistake and the calibrated weight doesn't correspond to the sample weight, re-start the operation pressing again the key .



press few times **Mode** till display the message  (the instrument goes back to weighing mode)



To check out that all the above operations have been properly carried out, perform the following procedure:

- Rise-up the sample weight.
- Insert the film reel into the spool carriage.
- Press the key .
- Re-position the sample weight on the machine.
- Check that the Weigher display shows the correct sample weight on the machine.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 39 / 53	

SETTING PROCEDURE OF THE INSTRUMENT UPON INSTALLATION / REPLACEMENT (COMPLETE PROCEDURE)

In case it will be necessary to replace the scale instrument, upon its installation and wiring, it is necessary to make the complete procedure of setting as indicated below:

19.2.1. SETTING FOR MAXIMUM VALUE OF THE “Set Point A” TO 2000 KG (5000 Lb for USA machines).



A ProG

Press the key **Set** (keep it pressed for 2 seconds aprox.) to visualise the “Set point A”.
it shows **A ProG** for 2 seconds aprox and then it shows the set “Set A” value.

To set the required value, select the digit to change using the keys ‘set’ & ‘zero’, then change these value with push buttons ‘F1’ (increase) & ‘F2’ (decrease).

Set the value to **A 2000.0** or **A 5000.0** for USA machines.



Press few times the key **Mode** and keep it pressed until will be shown the message

MEMOr

19.2.2. SELECR “Set Point A” AS N.C. (NORMALLY CLOSED CONTACT).



ModE

press the key **Mode** (keep it pressed for 2 seconds aprox.) to have

it shows **ModE** for 3 seconds otherwise it exit.



A conF

press the key **Set** within these 3 seconds.

it shows **A conF**.



A OPEn

press the key **Mode**

the display will show “A OPEn”.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 40 / 53	



Press the push button **Zero**.

A CLOS

The display will shows **A CLOS**.



press the key **Mode**.

A bid

The display will shows **A bid**.



Press the push button **Zero**.

A POSI

The display will shows **A POSI**.



press few times the key **Mode** to memorize visualizing the message



 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 41 / 53	

20.2.3.

SET THE SERIAL OUTPUT



Press the key **Mode** (keep it pressed for 2 seconds aprox.)



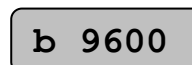
it shows **Mode** for 2 seconds otherwise it exit.



press the key **F3** within 2 seconds.



it shows **BAUd** for 3 seconds, and then, the message



press few times the key **Mode** until you will see the message



press "**Zero**" to pass to transmission for printer.

the display will shows the message



pressing "**Mode**" you will memorise the selection for printer.



it will shows **A PSt** automatic transmission with stable weight when the weight is out from the zero control.



press "**Zero**" to pass to transmission from keyboard



it shows **dA tAS** transmission weight from keyboard



press few times the key **Mode**



it shows **MEMOr** for 2 seconds aprox, than it return in weighing mode.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 42 / 53	

20.2.4. SET THE PARAMETER OF THE CONVERTER.

To modify the parameters of the converter, it is necessary to use a **password** (code **C11770**) as described here below.



press within 3 seconds in fast sequence the key **Mode** (pn) & key **Zero** (pn)



it shows **C00000** to insert the access codes.

Pressing the key **Mode** (pn) when **C00000** is shown, it return in weighing mode.



set the a.m. password code using the arrows and press the key **Mode**  , if the code is correct, you have access to the required program (if wrong, press the key C to retry the password). After inserting of the password **C11770** it will be shown a message



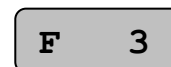
it is shown for 2 seconds and than displays the message



press the key **Mode** to go ahead.



it shows for 2 seconds and than it introduce the number of the set filter



Press **F2** to set the value give to



press the key **Mode** to go ahead.



it shows **bip**.



Press the push button "**Zero**".



The display will shows **uni**.



press the key **Mode** to visualize the message



 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 43 / 53	

20.2.5. Set the parameter of the Instrument.



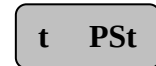
Using the arrows, set the code (**C00022**) and press few times the key  until you will see the message **P MASS**

The display shows **P MASS** for about 2 seconds the displays **P 0000.0**.

Set this value to 2000 **P 2000.0** or **P 5000.0** (for the USA machines).



press few times the key **Mode**

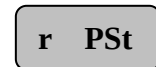


The display will show the message '**T PST**' for about 2 seconds, then displays **10**

Using the arrows, set the value to **05**



press few times the key **Mode**



The display will show the message '**R PST**' for about 2 seconds, then displays **c 020**

set the value to **c 001**



press few times the key **Mode** until you will see the message '**T AUO**' **t Auto**

set the value to **t 0005.0**



press few times the key **Mode** to visualize the message .

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1 ENGLISH	Date November 2021	Rev.08 PAGE 44 / 53
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20.2.6. SET-UP THE “Zero” OF THE SCALE.

To modify the parameters of the converter, it is necessary to use a password (code **C00400**) as described here below.



press within 3 seconds key **Mode** (pn) & key **Zero** (pn)



it shows **C00000** to insert the access codes.

Pressing the key **Mode** (pn) when **C00000** is shown, it return in weighing mode.



Set the code **C00400**



The following operations must be performed without film reel and all the protection cover mounted on the machine.



press the key Mode to confirm it.



the display will shows **Unit** for 3 seconds aprox and than it introduce the set value of the division.



the display will shows **d nnn**. Set **nnn** to value **0.2** by the buttons  &  and to **0.5** for the USA machines.



press the key Mode to accept it.



it shows **CALibr** for 3 seconds aprox and than it shows the weight value from the scale.



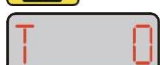
this value is number that change when the weight change and with the division, but it doesn't correspond to the real weight of the product (except if you made a calibration before).



on the scale(all machine) there must not be any weights except the fixed tare.



press **F2** to perform the zero setting.



it shows **t 0** that correspond to the net weight 0 (zero).



now you must load a known weight (sample weight) on the machine

ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1	Date November 2021	Rev.08
	ENGLISH	PAGE 45 / 53	

T nnnn

you will see a value that will not be the real weight (making the weight tare, the two value will coincide).

F1

press key **F1** to proceed with weight tare.

PESO 1

it shows **PESO 1** for 3 seconds aprox and than it goes ahead to the next message.

P00000

it shows **P00000** with first digit blinking.

Wright the known weight loaded on the machine (sample weight = 1000).

For the USA machines you should consider that 1,0 Lb is 0,453 Kgs, so the weight load to input in the instrument is x/0,453.

Mode

press the key **Mode** to memorise the value.

PESO 2

it shows **PESO 2** for 3 seconds aprox and than it goes ahead to the next message.

P00000

it shows **P00000** with first digit blinking.

If the value of **P00000** is not modified, then, it is possible to complete the operation pressing **Mode**

Mode

Setting a new sample value, that must be same of the real weight of the sample applied on the turntable, it is possible to get a second calibration to get a most accuracy performance of the instrument.

it shows **P00000** with first digit blinking. Wright the known weight loaded on the machine (sample weight = 500).

For the USA machines you should consider that 1,0 Lb is 0,453 Kgs, so the weight load to input in the instrument is x/0,453.

Mode

press the key **Mode** to memorise the value.

PESO 3

it shows **PESO 3** for 3 seconds aprox and than it goes ahead to the next message.

P00000

it shows **P00000** with first digit blinking.

If the value of **P00000** is not modified, then, it is possible to complete the operation pressing **Mode**

Mode

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1 ENGLISH	Date November 2021 PAGE 46 / 53	Rev.08
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Setting a new sample value, that must be same of the real weight of the sample applied on the turntable, it is possible to get a second calibration to get a most accuracy performance of the instrument.

it shows **P00000** with first digit blinking. Wright the known weight loaded on the machine (sample weight = 250).

For the USA machines you should consider that 1,0 Lb is 0,453 Kgs, so the weight load to input in the instrument is x/0,453.



press the key **Mode** to memorise the value.



it shows **Calibr** for 3 seconds aprox and than the calibrated weight will be shown.



the calibrated weight *must* be equal to the sample weight loaded on the machine.

If you made a mistake and the calibrated weight doesn't correspond to

the sample weight, re-start the operation pressing again the key 



press few times **Mode** till display the message  (the instrument goes back to weighing mode)



To check out that all the above operations have been properly carried out, perform the following procedure:

- Rise-up the sample weight.
- Insert the film reel into the spool carriage.
- Press the key 
- Re-position the sample weight on the machine.
- Check that the Weigher display shows the correct sample weight on the machine.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 47 / 53	

ALARM LIST AND TROUBLE-SHOOTING ROTOPLAT SERIE 7.1

Alarm code	Alarm description		Troubleshooting	Cause of the fault	Solution
E10	Rotoplat 107 – 307 – 407 – 507 – 707	TP shaped basement photocell alarm	Check the alignment of the photocell with reflector	Wrong alignment of the photocell with reflector	Make the appropriate alignment
			Check that safety photocell works properly	Photocell defective or wiring damaged	Replace the photocell/reflector or the wiring
				The mother-board of the machine is defected	Replace mother-board card
		Idle roller conveyor's locked rolls alarm	Check the alignment of the photocell with reflector	Wrong alignment of the photocell with reflector	Make the appropriate alignment
			Check that safety photocell works properly	Photocell defective or wiring damaged	Replace the photocell/reflector or the wiring
				The mother-board of the machine is defected	Replace mother-board card
		Overload scale device alarm	The weight of the product on the turntable exceeds the maximum acceptable	Improper use of the machine	Load on the machine's turntable a product according the technical specification
			Check the scale instrument SD01	The scale instrument SD01 is not appropriate wired to the mother-board	Check and make the appropriate wiring
				The scale instrument SD01 is defected	Replace the scale instrument SD01
				The mother-board of the machine is defected	Replace mother-board card
E11	Rotoplat 107 – 307 – 407 – 507 – 707	Safety film spool carriage down-ward alarm	Check the mechanical conditions of the emergency plate below the carriage	The plate is mechanically stuck	Adjust the mechanical position of the plate.
			Check the conditions of the mechanical switch and its wiring	The mechanical switch is defective or wrongly wired	Replace the mechanical switch or the electrical wiring

ROBOPAC Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 48 / 53	

E30	Rotoplat 107 – 307 – 407 – 507 – 707	Rotation turntable inverter alarm	Disconnect the turntable rotation motor from the mother-board and start a packing cycle.	If the alarm message disappears there is a fault of the turntable rotation motor	Replace turntable rotation motor
				If the alarm message doesn't disappear, there is a fault on the mother-board.	Replace mother-board.
			Check the gearbox connected to the turntable rotation motor	Possible fault of the gearbox	Replace the gearbox
E31	Rotoplat 107 – 307 – 407 – 507 – 707	Up-ward / down-ward spool carriage inverter alarm	Disconnect the up-ward / down-ward spool carriage motor from the mother-board and start a packing cycle.	If the alarm message disappears there is a fault of the up-ward / down-ward spool carriage motor	Replace up-ward / down-ward spool carriage motor
				If the alarm message doesn't disappear, there is a fault on the mother-board.	Replace mother-board.
			Check the gearbox connected to the up-ward / down-ward spool carriage motor	Possible fault of the gearbox	Replace the gearbox
E32 / E33	Rotoplat 507 – 707	Pre-stretch inverter alarm	Disconnect the pre-stretch motor from the inverter card and start a packing cycle.	If the alarm message disappears there is a fault of the pre-stretch motor	Replace pre-stretch motor
				If the alarm message doesn't disappear, there is a fault on the inverter card.	Replace inverter card.
E34	Rotoplat 507 – 707	+15V missing on pre-stretch card	Check the in-feed power supply on the mother-board and then, on the pre-stretch card.	Power supply not conform to the machine's specification	Fix the power supply to the machine according the specifications
				Damage to the mother-board	Replace mother-board.
				Electrical wiring between mother-board and pre-stretch card damaged, or missing.	Fix the wiring between mother-board and pre-stretch card if missing, or replace it in case it is defective

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 49 / 53	

E41	Rotoplat 107 – 307 – 407 – 507 – 707	Serial communication error	Check the flat cable which connect the mother-board card to the operator panel display card	Defect of the flat cable.	Replace the flat cable
			Check the mechanical condition of the connectors of the two cards (mother-board and operator panel display).	Defect of one of the two cards	Replace the defected card.
E42	Rotoplat 107 – 307 – 407 – 507 – 707	Missing cycle parameters list initialization		Installation of the operator panel display card or machine's software not completed	Make the initialization procedure as indicared at pag. 16.
E43	Rotoplat 107 – 307 – 407 – 507 – 707	Missing internal parameters list initialization		Installation of the operator panel display card or machine's software not completed	Make the initialization procedure as indicared at pag. 16.
E46	Rotoplat 507 – 707	Serial communication error with pre-stretch card	Check the flat cable which connect the mother-board card to the amplifier card	Defect of the flat cable.	Replace the flat cable
			Check the mechanical condition of the connectors of the two cards (mother-board and amplifier card).	Defect of one of the two cards	Replace the defected card.
E47	Rotoplat 507 – 707	Serial communication error with I/O expansion card	Check the flat cable which connect the mother-board card to the I/O expansion card	Defect of the flat cable.	Replace the flat cable
			Check the mechanical condition of the connectors of the two cards (mother-board and I/O expansion card).	Defect of one of the two cards	Replace the defected card.
E48	Rotoplat 507 – 707	Firmware pre-stretch card not compatible		Pre-stretch card not compatible with mother-board card	Replace the pre-stretch card with a last release firmware
E49	Rotoplat 507 – 707	Firmware mother board card not compatible		Mother board card not compatible with pre-stretch card	Replace mother-board card with a last release firmware

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 50 / 53	

E60	Rotoplat 507 – 707	Broken / End film alarm (option)			Apply on the machine the correct film and run it properly into the rolls following the instructions and press START.
			Check the appropriate working of the load-cell (extensometer)	The load cell (extensometer) doesn't give signals to the inverter/amplifier card	Replace load-cell (extensometer)
				The load-cell (extensometer) works fine	Replace the inverter/amplifier card
E61	Rotoplat 107 – 307 – 407 – 507 – 707	Blocked turntable alarm	Check the position of the mechanical switch compared to its cam	Wrong positioning of the mechanical switch	Fit the mechanical switch in the appropriate position.
			Check that the mechanical switch is working properly	Damage of the mechanical switch or related wiring	Replace the mechanical switch
			Check that input #H5 (DL9) on the mother-board card works properly	Possible fault on the mother-board card.	Replace mother-board.
			Check the input I14 (DL17) on the expansion card	Possible fault on the expansion card.	Replace expansion card
E64	Rotoplat 107 – 307 – 407 – 507 – 707	Spool carriage blocked alarm	Check the conditions and the appropriate working of the top and bottom mechanical switches on the carriage	Wrong position of the cam of the mechanical switches	Properly fit the cam of the top or bottom switch
				Possible damage of one of the mechanical switches or their wiring	Replace the detective switch or fit the wiring
			Check input L7 (DL17) and input L9 (DL18) on the main board.	Possible damage of the mother-board	Replace mother-board
E70	Rotoplat 107 – 307 – 407 – 507 – 707	Function not active information	Operator panel display locking activated		Unlock the operator panel as indicated at pag. 13.
			Check the control operator panel display card and mother-board card.	Possible fault of one of the two cards.	Replace mother-board card or operator panel display card.

 Norm. Tecn. 60.2.51_05	TECHNICAL DOCUMENTATION ROTOPLAT SERIE 7.1		Date November 2021	Rev.08
	ENGLISH		PAGE 51 / 53	

E71	Rotoplat DW	Wrong position of the clamp of the top platen device	Check the conditions of the sensor which check the appropriate position of the clamp	Possible damage of the sensor or possible damage of the wiring	Set the sensor in the appropriate position, or replace it in case of fault , or fix the wiring.
E90	Rotoplat 107 – 307 – 407 – 507 – 707	Low power supply voltage alarm	Check the power supply that must be according the machine's specifications	The power supply isn't according the technical specification. Mother-board card is defected	Adjust the power supply according the specification Replaced mother-board card
E91	Rotoplat 107 – 307 – 407 – 507 – 707	High power supply voltage alarm	Check the power supply that must be according the machine's specifications	The power supply isn't according the technical specification. The mother-board card is defected	Adjust the power supply according the specification Replaced mother-board card
E92	Rotoplat 507 - 707	Pre-stretch card low tension	Check the power supply to the mother-board and then to the pre-stretch card	Power supply not conform to the machine's specification Damage to the mother-board Electrical wiring between mother-board and pre-stretch card damaged, or missing.	Fix the power supply according the specifications Replace mother-board. Check and fix the wiring between mother-board and pre-stretch card
Rotoplat 407 – 507 – 707	The machine does not stretch or pre-stretch the film		Make a view check of the rubber rolls	The rolls are dirty	Clean the rubber rolls (do not uses chemical additives)
				The rolls are worn	Replace the rubber rolls
			Check the run of the film into the rolls of the spool carriage and check the quality of the film.	Possible improper use of the machine.	Apply on the machine the correct film and run it properly into the rolls following the instructions
			Check that the brake on the spool carriage is not completely consumed, mechanically damaged or dirty/greased.	The brake is consumed or dirty or greased.	Replace the brake
			Check that the output voltage from the mother-board	Check that mother-board output gives the appropriate voltage	Replace the mother-board
				Check that mother-board output gives the appropriate voltage	Replace the brake

Rotoplat 107 – 307 – 407 507 – 707	The spool carriage doesn't move up- ward or down-ward	Check top and bottom mechanical safety switches.	One of the two mechanical switch are defective.	Replace the defective switches.
		Check that top and bottom mechanical switches give signals to the mother-board.	Possible electrical fault of one of the two mechanical switches or an electrical interruption.	Replace the mechanical switches or adjust the wiring
		Check that mother-board is working properly.	Possible fault of the mother- board.	Replace the mother-board card
Rotoplat 107 – 307 – 407 507 – 707	The film broken during the packing of it is not properly applied to the pallet (too light or too tight)	Check that the film is running through the last dancing roller of the spool carriage (where it is connected the sensitivity sensor – load cell)	Wrong film insertion onto the spool carriage.	Insert the film on the spool carriage in the proper way following the instructions in the user manual.
		Make a view check of the rubber rolls	The rolls are dirty and sign the film	Clean the rubber rolls (do not uses chemical additives)
		Check that the sensitivity sensor – load cell isn't mechanical damaged or not properly fit (the dancing roller must move of just few millimetres in the top and bottom fitting points).	The sensitivity sensor – load cell is too tight or mechanically damaged.	Loosen the screws that fit the instrument to the carriage frame/dancing roller. If the instrument is mechanical defective, replace it.
		Check that the sensitivity sensor – load cell is working properly (no electrical fault).	Electrical damage on the instrument.	Make the tuning of the load-cell (extensometer) as indicated in paragraph, if not solve replace the instrument
		Check that the pre-stretch card properly manage the signal of the sensitivity sensor – load cell.	Possible fault of the pre-stretch card.	Make the tuning of the load-cell (extensometer) as indicated in paragraph, if not solve replace amplifier/inverter card

Rotoplat 107 – 307 – 407 507 – 707	The machine does not react on RESET pushing.	Check that the contact of the RESET push button is working properly.	Possible damage of the contact of the push button.	Replace the contact and the push button
		Check the presence of the 24Vdc on the mother-board.	Possible fault on the mother-board that burn the 24Vdc fuse.	Replace the fuse.
			Possible fault on the mother-board.	Replace the mother-board card.
Rotoplat 107 – 307 – 407 507 – 707	The machine (standard shape basement configuration) shows E10 alarm even if that it shouldn't happen	Check the connector X3 which connect the base of the machine to the mast	The bridge on X3 connector is opened	Close the bridge on connector X3.
		Check the input on the mother-board	Mother-board defected	Replace the mother-board card
Rotoplat 107 – 307 – 407 507 – 707	F1 Fuse blows Power supply	If the fuse continues to blow after replacement	Check the input power supply	Alimentazione di ingresso fuori dal range dei dati machina
Rotoplat 107 – 307 – 407 507 – 707	F2 Fuse blows Power supply		Disconnect all inputs, outputs and motors	Check every single input, output or motor
Rotoplat 107 – 307 – 407 507 – 707	F3 Fuse blows Power supply			Replace the mother-board card
Rotoplat 107 – 307 – 407 507 – 707	F4 Fuse blows 24VDC	If the fuse continues to blow after replacement	Disconnect all inputs, outputs and motors	Check every single input, output or motor
				Replace the mother-board card