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SINCERT



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Technical Documentation

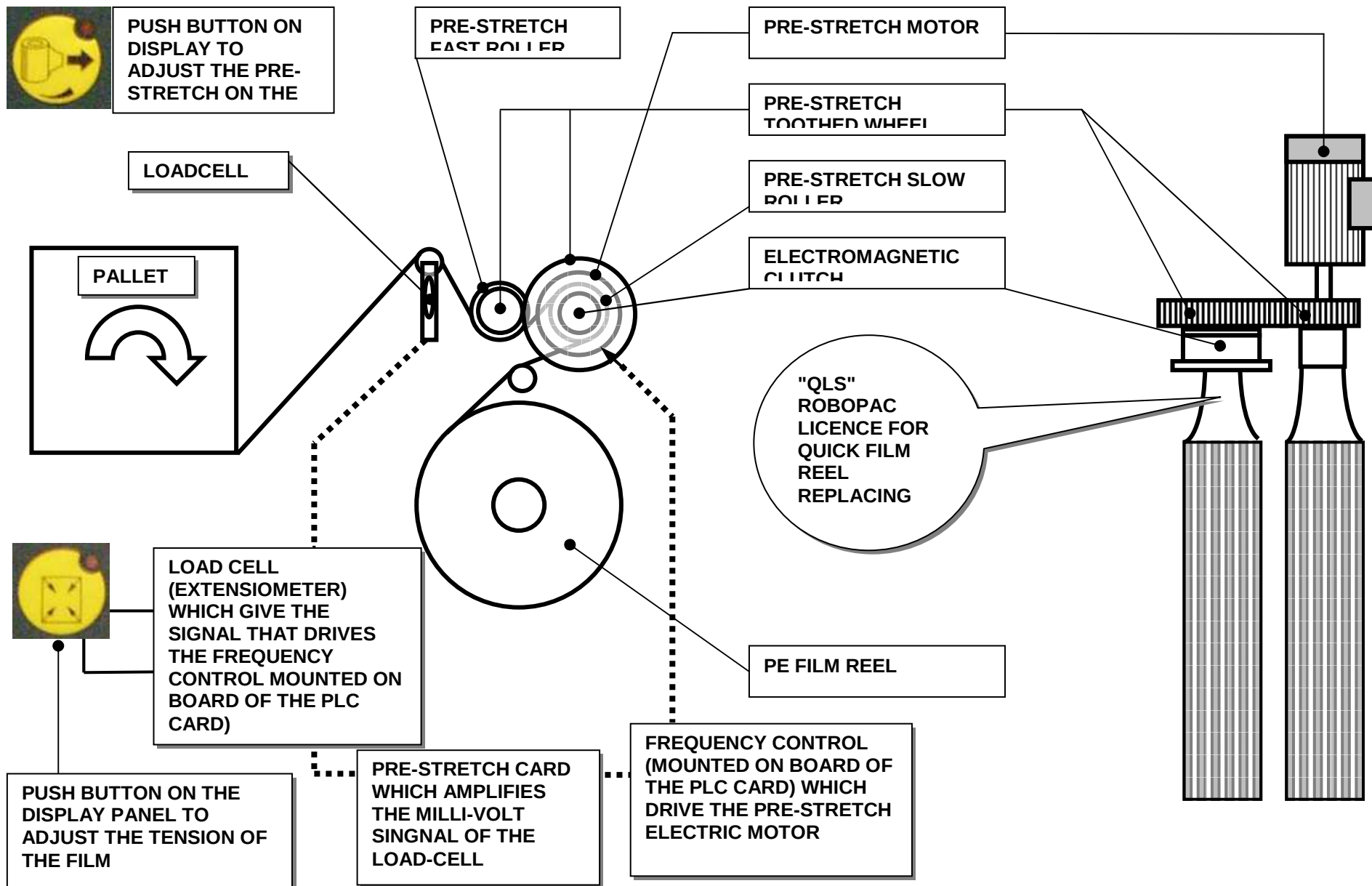
ROTOPLAT HIGH RANGE 507 - 707

1. SPOOL CARRIAGES SKETCH DETAILS

Robopac S.A.

507/PFS SPOOL CARRIAGE SKETCH

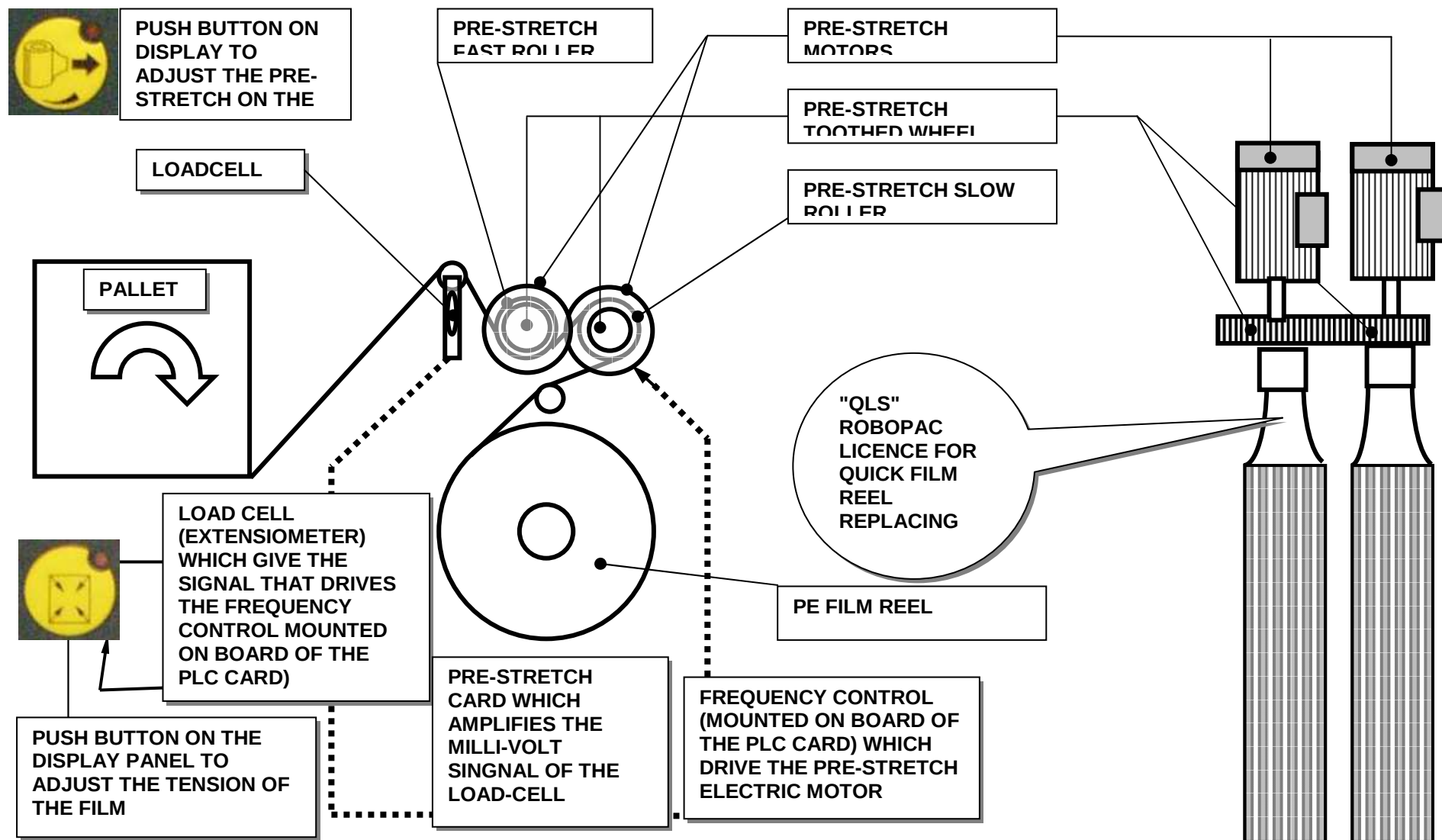
POWERED PRE-STRETCH (250% MAX.)



Robopac S.A.

707/PVS SPOOL CARRIAGE SKETCH

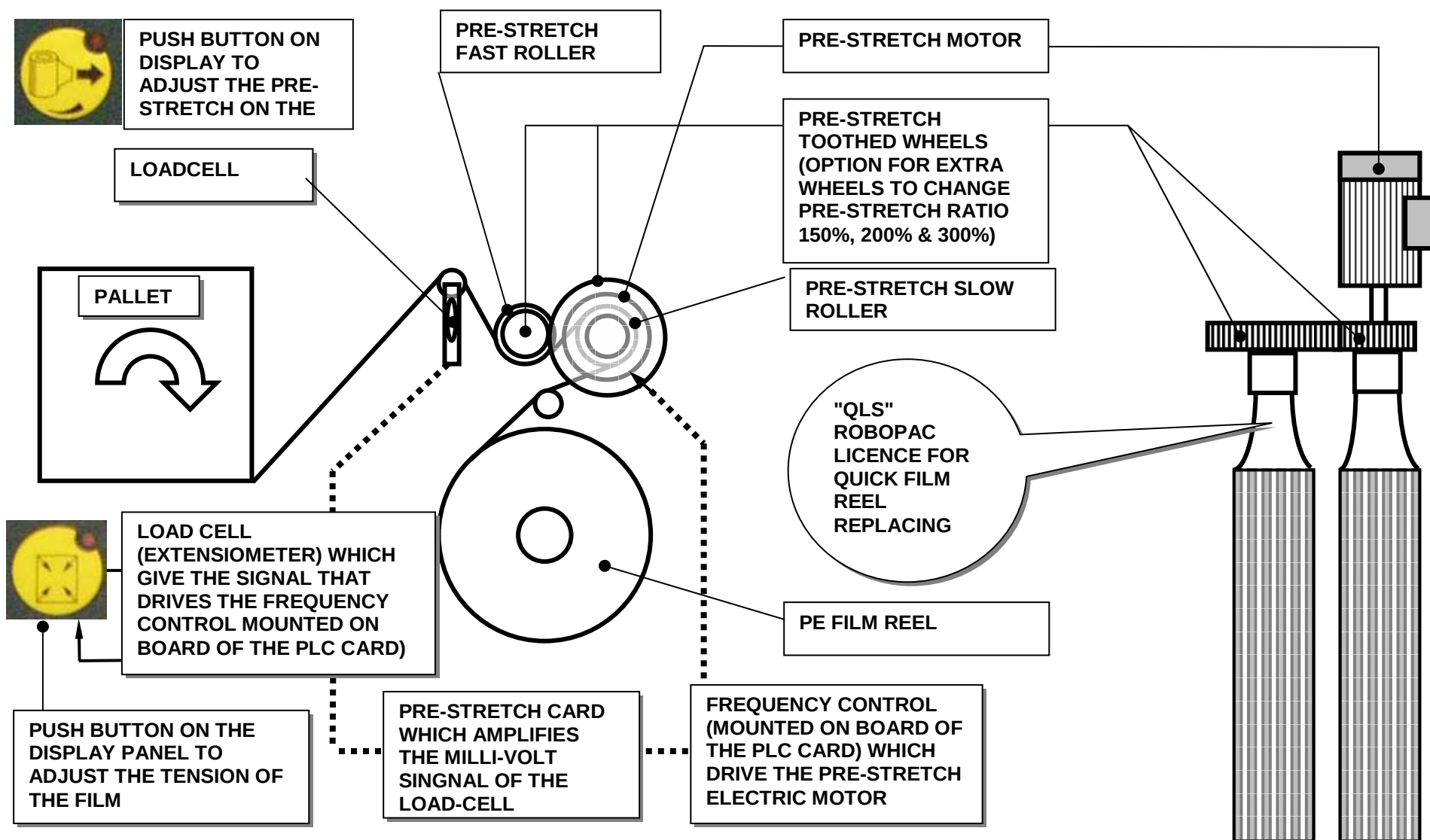
POWERED PRE-STRETCH (400% MAX.)



Robopac S.A.

507/PGS SPOOL CARRIAGE SKETCH

POWERED PRE-STRETCH (250% MAX.) WITH MECHANICAL FIX RATIO AND LOAD CELL CONTROL



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2. PERATOR PANEL DESCRIPTION NEW ROTOPLAT HIGH RANGE 507 - 707

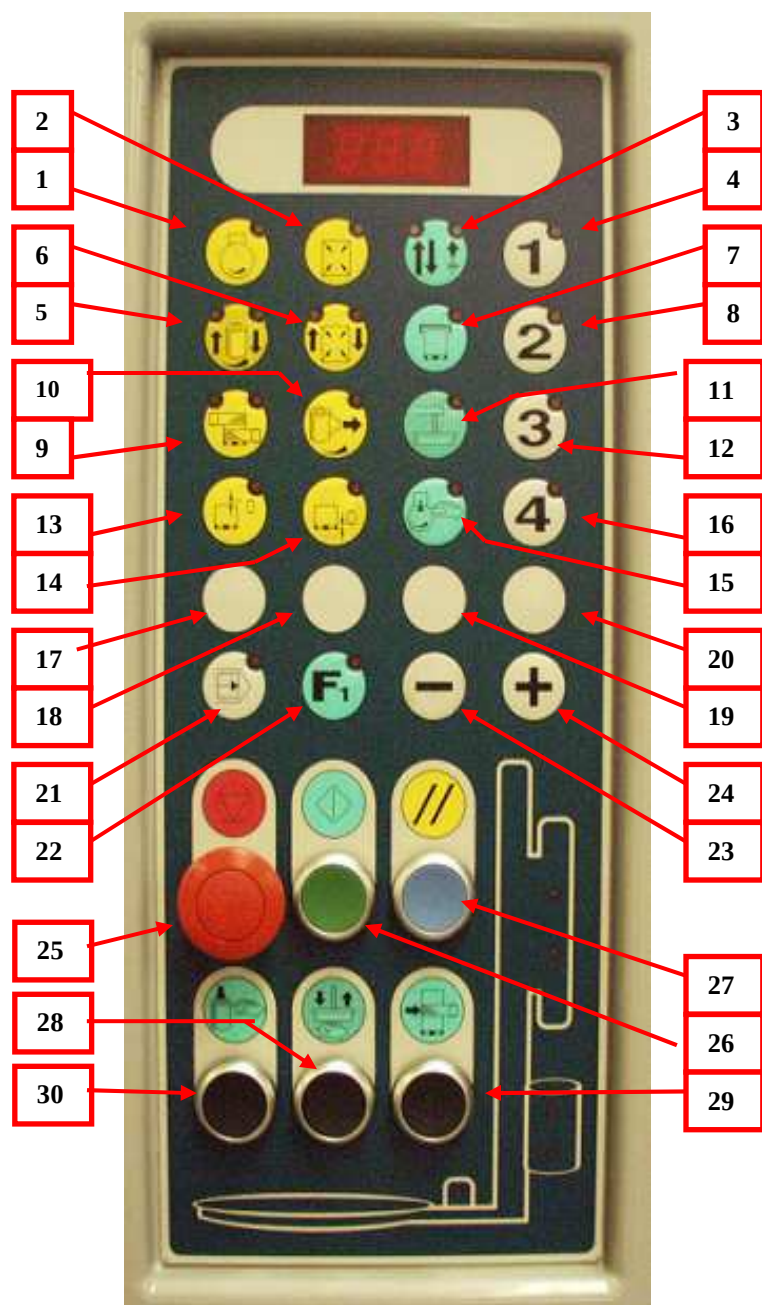
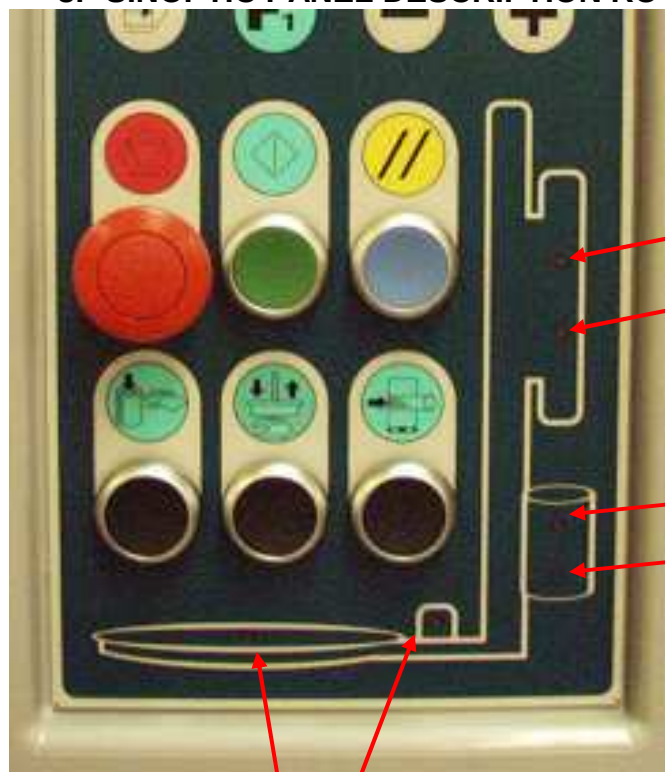


Fig.1

- 1 – Turntable rotation speed
- 2 – Film stretch (tension)
- 3 – Upward / downward or alternate cycle
- 4 – Program 1
- 5 – Spool carriage upward / downward speed
- 6 – Film stretch sensitivity upward / downward
- 7 – Top sheet cycle
- 8 – Program 2
- 9 – Bottom wrap / Top wrap
- 10 – Film pre-stretch
- 11 – Pressure cycle
- 12 – Program 3
- 13 – Photocell delay / Altimeter
- 14 – Start from ground (offset)
- 15 – Manual movement turntable
- 16 – Program 4
- 17 – Free push button (further applications)
- 18 – Free push button (further applications)
- 19 – Free push button (further applications)
- 20 – Free push button (further applications)
- 21 – Output data (production)
- 22 – F1 (free button for further application)
- 23 – Decreasing values
- 24 – Increasing values
- 25 – STOP
- 26 – START
- 27 – RESET
- 28 – Manual pressure upward / downward
- 29 – Stop spool carriage (reinforcement rounds)
- 30 – Manual downward spool carriage

3. SINOPTIC PANEL DESCRIPTION ROTOPLAT 507 – 707.



- A – Main inverter alarm.**
Main inverter overheating message.
- B – Spool carriage lifting motor alarm.**
Motor failure message.
- C – Broken film alarm (706).**
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.

Fig.2

4. PARAMETER CYCLE RANGE.

PARAMETER	MIN. – MAX.	STEP	MEASURE UNIT
BOTTOM OVERWRAPS	0 – 10	1	Rounds
TOP OVERWRAPS	0 – 10	1	Rounds
PHOTOCELL DELAY	0 – 100	1	CMS
ALTIMETER	0 – 305	1	CMS
OFFSET FROM GROUND	0 – 100	1	CMS
TURNTABLE SPEED	4 – 12	1	Rounds /minutes
UPWARD SPOOL CARRIAGE SPEED	1.0 – 4.0	0.1	m/ minutes
DOWNWARD SPOOL CARRIAGE SPEED	1.0 – 4.0	0.1	m/ minutes
FILM STRETCH (spool carriage not moving)	0 – 100	10	No dimension
FILM STRETCH (spool carriage upward moving)	0 – 100	10	No dimension
FILM STRETCH (spool carriage downward moving)	0 – 100	10	No dimension

PFS SPOOL CARRIAGE

PARAMETER	MIN. – MAX.	STEP	MEASURE UNIT
PRESTRETCH	0 – 250	10	%

PVS SPOOL CARRIAGE

PARAMETER	MIN. – MAX.	STEP	MEASURE UNIT
PRESTRETCH	0 -- 400	10	%

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5. TEST ON LED OF PUSH BUTTONS

It is possible to test if the push buttons are working properly or not.

Perform the following test:

1. Turn OFF the machine
2. Move the switch 1 of SW1 to position "ON" (see Fig.3)
3. Turn ON the machine
4. Press all the push button on the display operator panel and check that all the related LED light ON.
5. Move back the switch 1 of the SW1 to position "OFF"(see Fig.3)
6. Turn OFF the machine

6. KEYBOARD LOCK PROCEDURE

It is possible to lock the keyboard to avoid that anybody which is not allowed change the cycle parameters and setting. The selections of one of the 8 selectable wrapping cycles and START & STOP buttons will be active.

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

1. Turn OFF the machine
2. Press and keep pressed the push button No.1 "Table rotation speed".
3. Press and keep pressed the push button No.9 "Bottom wraps/Top wraps".
4. Turn ON the machine
5. Press the RESET push button.

To restore the machine and unlock the keyboard, repeat the same operations.

7. TEST ON POWER SUPPLY TO BRAKE/CLUTCH FOR PRE-STRETCH ON SPOOL CARRIAGE (for Rotoplat 507/PFS only)

With parameter P15=100 and parameter P26=30 and pre-stretch of the film set to the maximum, turn ON the machine and measure the voltage on the connectors of the friction on the spool carriage.

The value measured must be 9.4 Volt $\pm$ 1 Volt.

8. INTERNAL PARAMETER SETTING PROCEDURE.

PROCEDURE FOR INITIALIZATION OF THE CYCLE PARAMETERS (TO RESET E42 ALARM):

1. Turn OFF the machine
2. Move the switch 1 of SW1 to position "ON" (see Fig.3)
3. Turn ON the machine
4. The display will show the parameter 'P1' blinking alternatively with the set value
5. Push the button No.20 "Enter" push button until you'll see "SET" on the display
6. Push simultaneously the button No.1 "Turntable speed" and push button No.2 "Film tension"
7. The display will show for 1 second the indication "dEF"
8. To move between the parameters, push button No.20 "Enter" push button.
9. To modify the value of a parameter, push the button '+' & '-'
10. Turn OFF the machine

PROCEDURE FOR INITIALISATION OF THE INTERNAL PARAMETERS (TO RESET E43 ALARM)

11. Move back the switch 1 of the SW1 to position "OFF"(see Fig.3)
12. Hold pushed the button "Program 1" and turn on the machine. Hold it pushed until you'll see "'888', 'rx.x', 'SET', 'RES'.res".

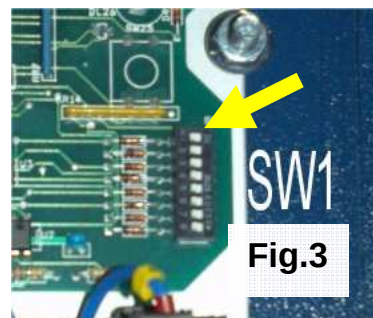


Fig.3

Machine internal parameter list suitable for Rotoplat serie 7 (from rel. 219 & after)

PAR.	RANGE	STEP	U.M	DEF.	DESCRIPTION
P1					Free
P2	10-30	5	Pre-stretch (%)/10		Fix PGS pre-stretch spool carriage
P3	1-4	1	--	1	Carriage type (1=PFS; 2=PFS2; 3=PVS. 4=PGS)
P4	0-1	1	--	0	Enable broken film alarm
P5			--	0	Enable blocked spool carriage alarm
P6	0-1	1	--	0	Enable Top Platen
P7	0-1	1	--	1	Enable blocked turntable alarm
P8	0-1	1	--	0	Free
P9	0 - 100	5	--	0	Film tension during film cutting (0=disabled)
P10	0 - 5	1	--	1	Selection for special packing cycles: 0 = standard cycle 1 = Automatic cutting 2 = Door & windows cycle (DWP). 3 = Turntable self-braking motor 4 = Turntable self-braking motor + idle roller conveyor 5 = Turntable self-braking motor + idle roller conveyor + door & window.
P11	0-100	1	--	50	Corner before turntable deceleration 1. TP basement parameter P11 = 42 (always) 2. Standard basement: gearbox Varvel brand parameter P11= 48 gearbox Bonfiglioli brand parameter P11 = 42
P12	10-30	1	Sec/10	30	Beep time duration
P13	1-50	1		22	Acceleration
P14	1-50	1		22	Deceleration
P15	0-200	1	--	100	Maximum voltage output friction
P16	0-60	1	Sec/2	12	Top platen downward delay on wrapping cycle start
P17	25-30	5	Pre-stretch (%)/10	25	Maximum pre-stretch
P18	12-15	3	Rpm	12	Maximum turntable speed
P19	0-255	1	Sec/10	10	Delay time for blocked clamp alarm (0=disabled)
P20	0-1	1	--	0	Turntable gearbox selection (0=Varvel; 1=Bonfiglioli)
P21	5-99	1	--	20	Kp: proportional Gain on pre-stretch load cell
P22	1-30	1	--	5	Software filter for push buttons
P23	0-255	1	1,7 mt/sec	100	Enable & setting time PWM for SCS
P24	1-99	1	--	40	Maximum film stretch setting.
P25	1-255	1	Hz./sec	200	Acceleration/deceleration Inverter stretch and pre-stretch
P26	0-30	1	Pre-stretch (%)/10	14	SCS disactivation inferior limit
P27	0-200	1	--	150	SCS shutter
P28	0-255	1	--	255	Power voltage to friction in SCS mode
SET					To reset all parameters to default value

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9. WRAPPING CYCLE WITH ALTIMETER MODE (PRODUCT PHOTOCELL EXLUDED).

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 No.13“Photocell/Altimeter delay” push button for 4 seconds
3. The related LED will start to blink.
4. The display will shows the value which represent the high of the pallet in CMS.
5. To change the value press the buttons ‘+’ & ‘-’
6. To return back to the working cycle with detection of the product by the photocell, press the push button No.13 “Photocell/Altimeter delay” push button for 4 seconds.

The working cycle (with photocell detection or with altimeter) is shown with the Parameter cycles. It will be possible to have the Program No.1 that works with photocell detection, and the Program No.2 that works with altimeter. This setting still remain if the machine will switched off.

10. FILM DATA

Press the push button No.21, DATI. The display will show the message ‘Dx’ alternatively with the set value. Pressing again the push button ‘DATI’ it will be possible to list the available data. Moving to parameter “D1” and pressing simultaneously the push buttons ‘+’ & ‘-’

The partial counter cycle “D1” will be reset. .

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

Meanwhile the machine shows the value D3, keeping pressed the “DATA” push buttons for 4 seconds at least, it is possible to access and visualize the following hidden parameter:

- D4 FW release of the Main board (power PLC).
- D5 FW release of the pre-stretch card.
- D6 Instant value of the weight applied on the load cell of the pre-stretch.

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

LED DL7-18

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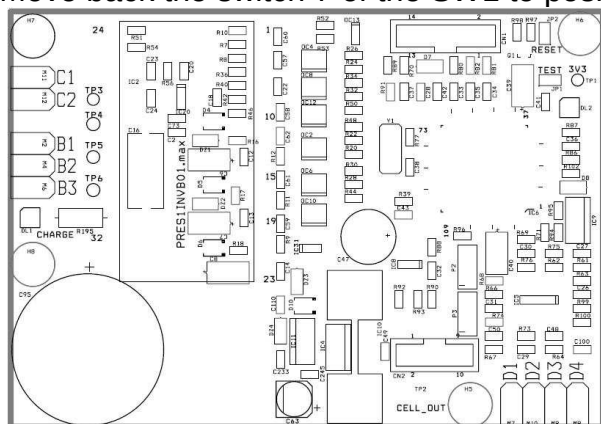
12. DESCRIPTION TABLE FOR “LED” ON MAIN BOARD (refer to Fig.4)

LED	CONNECTOR	DESCRIPTION
DL2	G2	NO LED
DL3	G3	(Free OUTPUT)
DL4	G7	Upward pressure
DL5	G8	Downward pressure
DL6	G4	Electromagnetic clutch
DL7	--	Presence 24 Vdc
DL8	H2	Detecting product Photocell
DL9	H5	Turntable phase
DL10	H7	Emergency transpallet photocell
DL11	H10	NO LED
DL12	H12	NO LED
DL13	H13	NO LED
DL14	L1	NO LED
DL15	L5	Spool Carriage Safty Alarm (base of spool carriage)
DL16	L6	Unwinding film button (on Spool Carriage)
DL17	L7	Top Limit switch of Spool Carriage
DL18	L9	Low Limit switch of Spool Carriage
DL20	--	Upward Spool Carriage
DL21	--	Downward Spool Carriage
DL22	--	Rotation of turn table plate

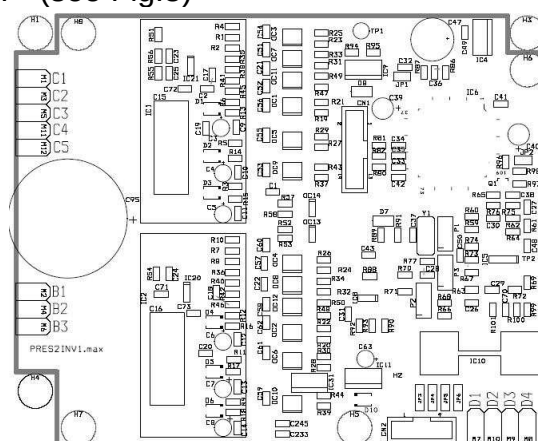
13. PRE-STRETCH CARD TUNING. OFFSET TUNING

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

1. The MUST be in ON MODE for 2 minutes at least
2. Move the switch 7 of SW1 to position “ON” (see Fig.3)
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
5. Press again and keep pressed the ‘DATA FILM’ push button for 4 seconds 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)
7. Move back the switch 7 of the SW1 to position “OFF” (see Fig.3)



LAYOUT PRE-STRETCH CARD FOR
ROTOPLAT 507 – PRES1INV - (fig.6a)



LAYOUT PRE-STRETCH CARD FOR
ROTOPLAT 707 – PRES21INV - (fig.6b)

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14. REMOTE CONTROL INSTALLATION & SETTING.

o Instructions to install and set the receiver card last generation.

To enable the remote control option, it is necessary to perform the “self-learning” of the codes by the receiver to get the signals TX & RX.

➤ Code input

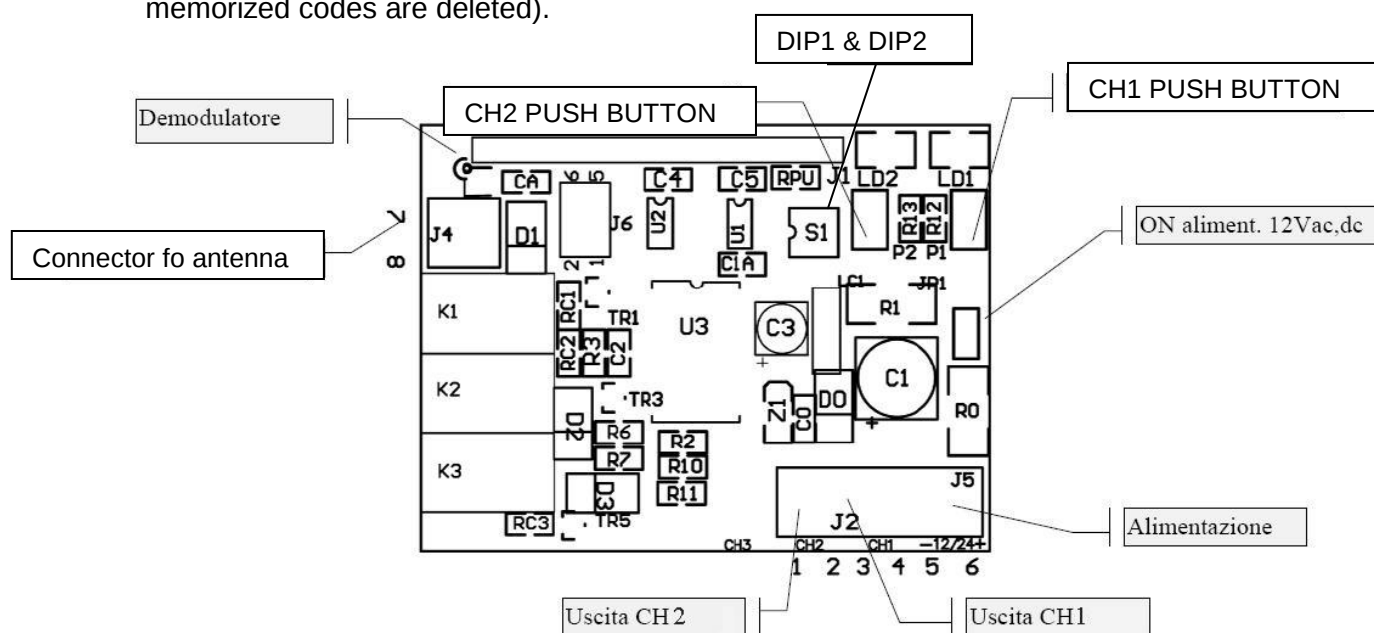
1. Set the two dipswitch (dip 1 & dip 2) on **OFF**.
2. For the channel 1, press the push button P1 on the receiver until the LED1 will become **ON**.
3. Press the push button of the remote control (START) and keep it pressed until the second led will become ON too (the second led will just blink).
4. Release the (**START**) push button on the remote control.
5. The receiver will confirm the correct memorization by a double blinking of the two LED.
6. In case of memorization error the LED related to the channel without double blink of confirm on the receiver will become OFF.
7. If the memory of the codes is full the receiver will advise that by seven blinks of the two LED.
8. For the channel 1, press the push button P1; and repeat all the other operations performed to set the channel 1 (START) but working on channel 2 (**STOP**).

➤ Operation to delete a memorized code

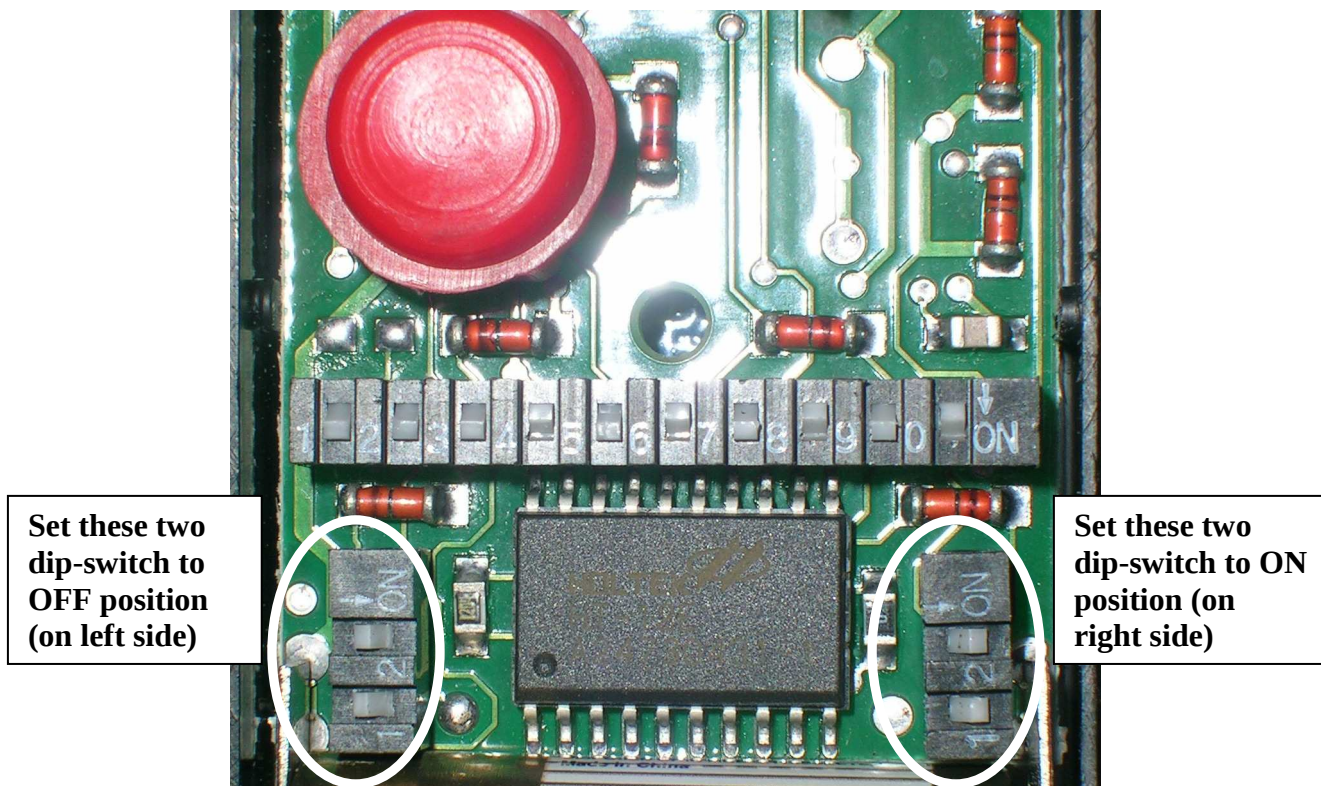
1. Press the push button P1 (or P2) until will become **ON** the related LED (LED1 or LED2).
2. Press the push button Ch.1 (or Ch.2) on the remote control (START or STOP).
3. The receiver will confirm that the code has been deleted by five blinks of the two LED.
4. In case of error, the LED related to the selected channel (START or STOP) on the receiver will become OFF (without making the five blinks of confirmation).

➤ Operation to delete all the memorized codes

1. Press the push button P1 until the LED1 will become **ON**, and keep it pressed until it will become **OFF**.
2. The LED1 on the receiver will become ON and after 7 seconds will become OFF again (the memorized codes are deleted).



o Emitter card setting (remote).



ELECTRICAL CONNECTIONS

1,2	N.O. contact channel 2 (STOP)
3,4	N.O. contact channel 1 (START)
5	0 V ac,dc
6	+12V,+24V ac,dc
7,8	Antenna

TECHNICAL DATA

Power supply	+12V,+24V ac,dc
Consumption	50 mA
Receiver Frequency	433.92 MHz e 30.875 MHz
Min / Max. temperature of working	-25°C +70°C
Dimensions	+12V,+24V ac,dc

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15. ALARM LIST

E10	<u>(For “TP” model machines only)</u> ALLARME FOTOCELLULA TRASPALLET TRASPALLET PHOTOCELL ALARM <u>(For “Conveyors” model machines only)</u> ALLARME FOTOCELLULA BLOCCO RULLI STOPPING ROLLER PHOTOCELL ALARM <u>(For “WT” model machines only)</u> ALLARME SOVRACCARICO BILANCIA MAXIMUM APPLICABLE LOAD ON MACHINE ALARM
E11	ALLARME SICUREZZA DISCESA CARRELLO / SAFETY SPOOL CARRIAGE DOWNWARD ALARM
E30	ALLARME INVERTER PRINCIPALE / MAIN INVERTER ALARM
E31	ALLARME INVERTER CARRELLO / LIFTING SPOOL CARRIAGE INVERTER ALARM
E32	ALLARME MOTORE PRESTIRO / PRE-STRETCH MOTOR ALARM
E33	ALLARME INVERTER TIRO / STRETCH INVERTER ALARM
E41	ERRORE COMUNICAZIONE SERIALE / SERIAL COMMUNICATION ERROR
E42	MANCATA INIZIALIZZAZIONE PARAMETRI CICLI WRONG INITIALIZAZION OF CYCLE PARAMETERS
E43	MANCATA INIZIALIZZAZIONE PARAMETRI CONFIGURAZIONE MACCHINA WRONG INITIALIZAZION OF INTERNAL PARAMETERS
E44	POSSIBILE RESET ACCIDENTALE DEL PLC POSSIBLE ACCIDENTAL RESET OF PLC
E45	CELLA DI CARICO NON COLLEGATA O ROTTA / LOAD CELL NOT CONNECTED OR DEFECTIVE
E46	ERRORE COMUNICAZIONE SERIALE CON SCHEDA PRESTIRO SERIAL COMMUNICATION ERROR ON PRE-STRETCH CARD
E47	ERRORE COMUNICAZIONE SERIALE CON SCHEDA ESPANSIONE I/O SERIAL COMMUNICATION ERROR ON I/O EXPANSION CARD
E60	ALLARME ROTTURA FILM / BROCKEN-FINISHED FILM ALARM
E61	ALLARME TAVOLA BLOCCATA / BLOCKED TURNTABLE ALARM
E62	ALLARME PINZA BLOCCATA / BLOCKED CUT&CLAMP UNIT ALARM
E63	ALLARME POSIZIONE PINZA / WRONG CUT&CLAMP UNIT POSITION ALARM
E70	FUNZIONE NON ABILITATA / FREE FUNCTION FOR FURTHER APPLICATIONS
E90	VRETE BASSA / LOW VOLTAGE ALARM
E91	VRETE ALTA / HIGH VOLTAGE ALARM

16. INSTRUCTIONS TO INSTALL THE PNEUMATIC TOP PLATEN ON ROTOPLAT SERIE 6 BASIC RANGE (507 - 707)

o Instructions to make the mechanical assembling.

Montaggio pressore pneumatico (opzionale)

- 1 - Fissare la guida (P) all'albero di scorrimento con le apposite viti (Q).
- 2 - Montare il braccio (R) alla guida e fissarlo con le viti (S).
- 3 - Montare il piatto pressore (T) al braccio.

Pneumatic presser assembly (optional)

- 1 - Fasten the guide (P) to the slide guide mast with the screws (Q).
- 2 - Assemble the arm (R) to the guide and fasten with the screws (S).
- 3 - Assemble the presser plate (T) to the arm.



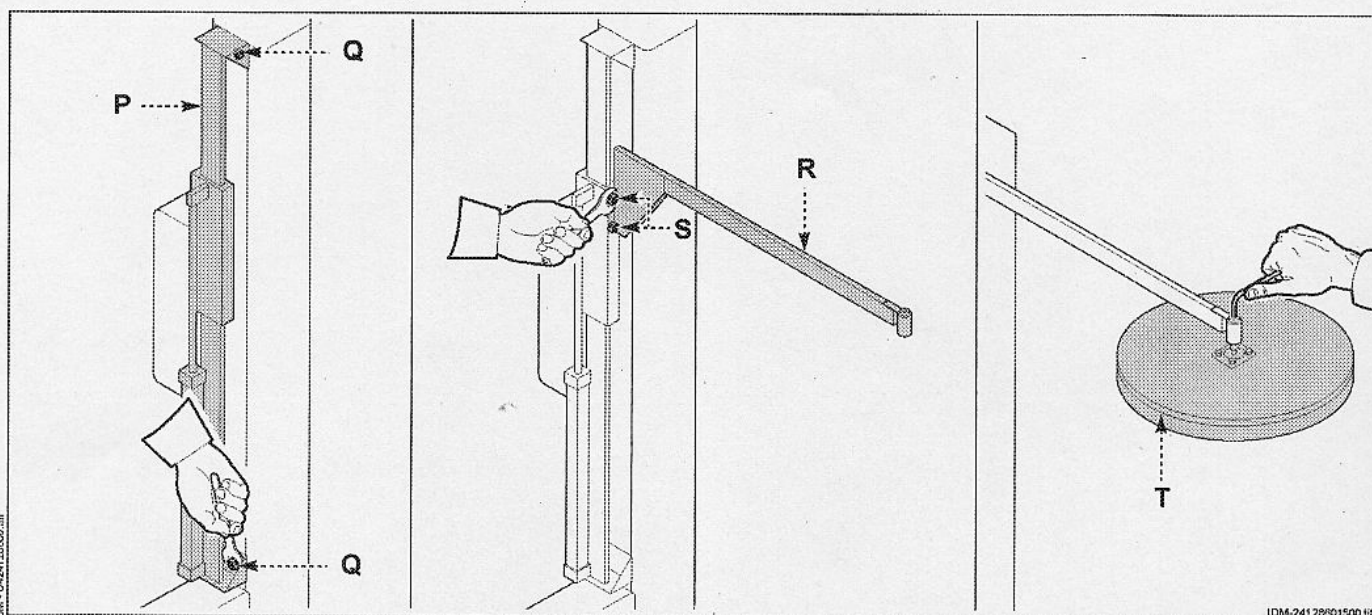
Importante

Se il pressore viene consegnato con la macchina, i collegamenti pneumatici sono già realizzati dal costruttore.



Important

If the presser is delivered with the machine, the pneumatic connections have already been performed by the manufacturer.



5.5. REGOLAZIONE ALTEZZA PRESSORE

Cilindro pneumatico con stelo

Per questa operazione procedere nel modo indicato.

- 1 - Allentare la vite (A).
- 2 - Regolare l'altezza del cilindro pneumatico (B) sulla guida (C) in base alle dimensioni del prodotto da avvolgere.
- 3 - Serrare la vite (A).

Nota: per carichi di altezza inferiore a 1400 mm, occorre capovolgere il braccio pressore (vedi § 4.5.).

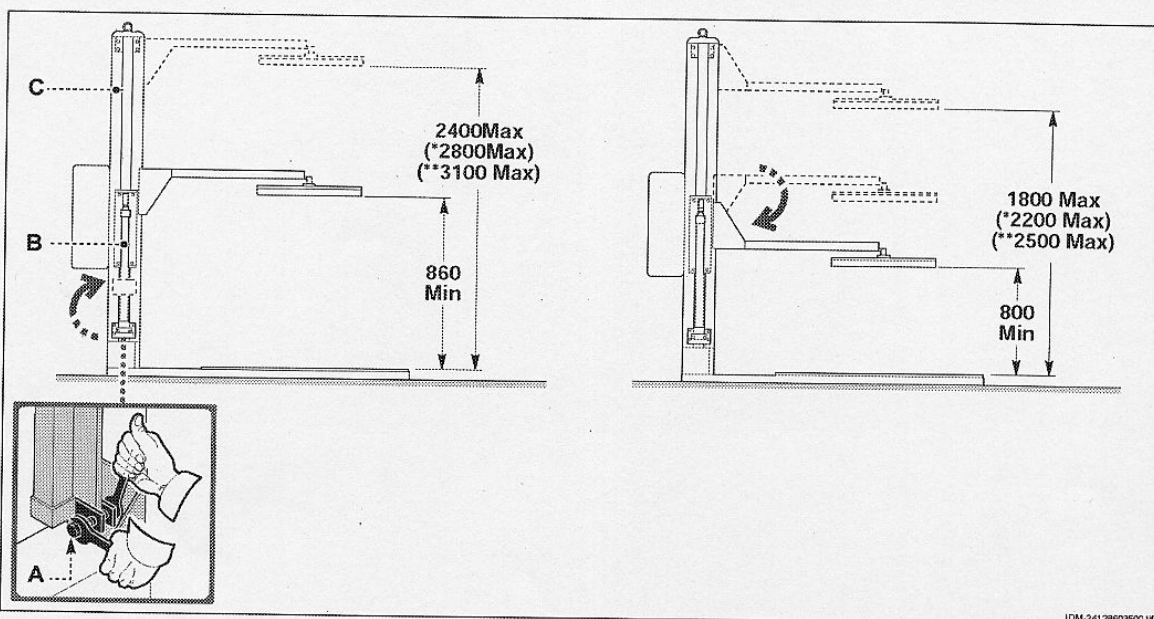
5.5. PRESSER HEIGHT ADJUSTMENT

Rod pneumatic cylinder

Proceed as follows for this operation.

- 1 - Loosen the screw (A).
- 2 - Adjust the height of the pneumatic cylinder (B) on the guide (C) according to the size of the product to be wrapped.
- 3 - Tighten the screw (A).

Note: for loads less than 1400 mm high, the presser arm must be overturned (see § 4.5.).



* Pressore pneumatico H=2800.
** Pressore pneumatico H=3100

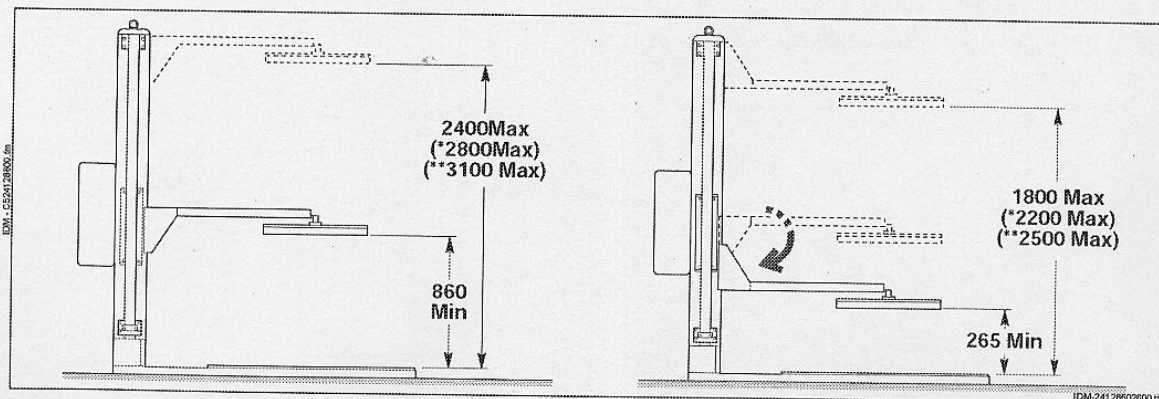
* Pneumatic presser H=2800.
** Pneumatic presser H=3100.

Cilindro pneumatico senza stelo

Questo cilindro, non necessita di regolazioni, per altezze di avvolgitura superiori a 860 mm. Per altezze inferiori è necessario capovolgere il braccio pressore (vedi § 4.5.).

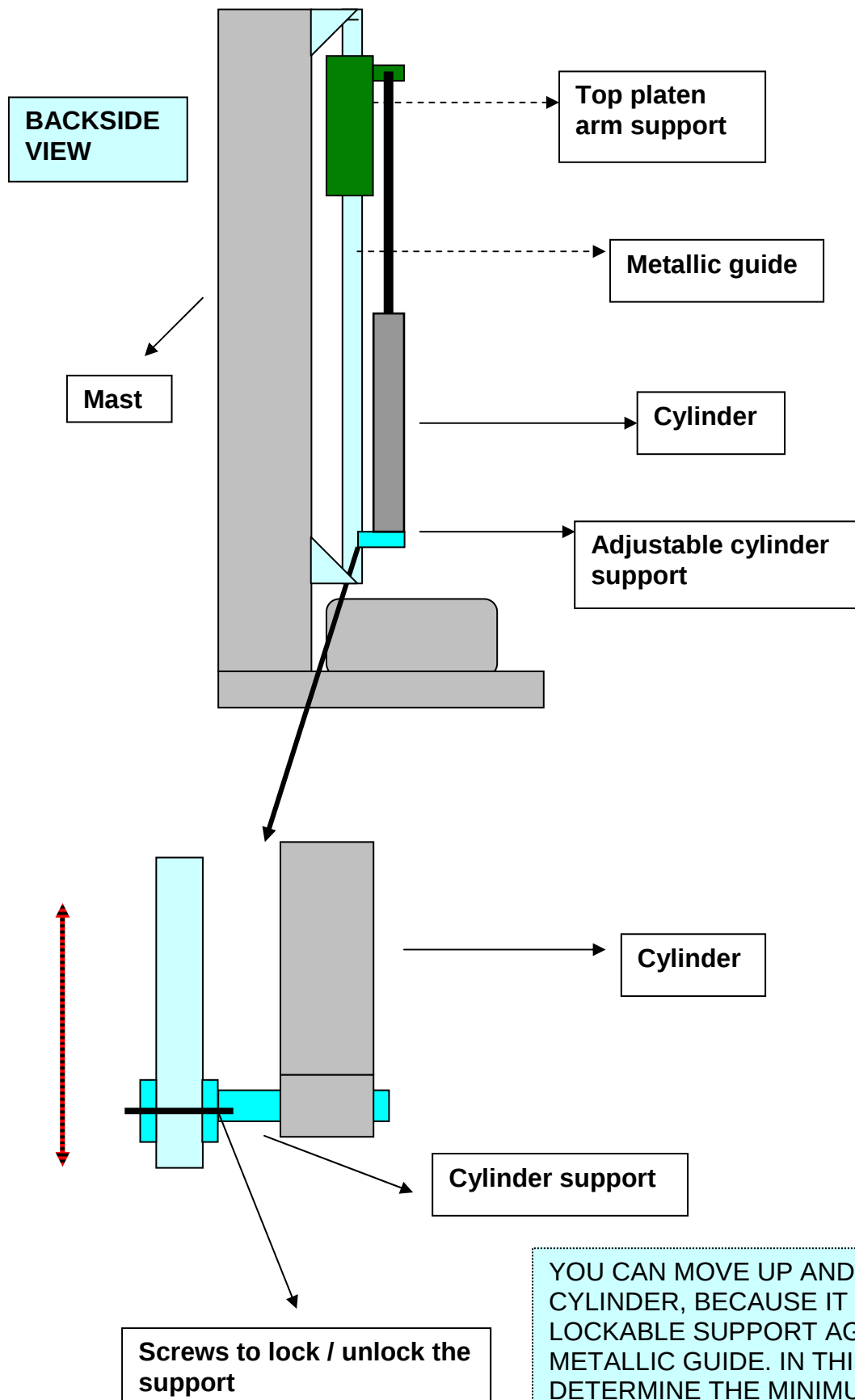
No rod pneumatic cylinder

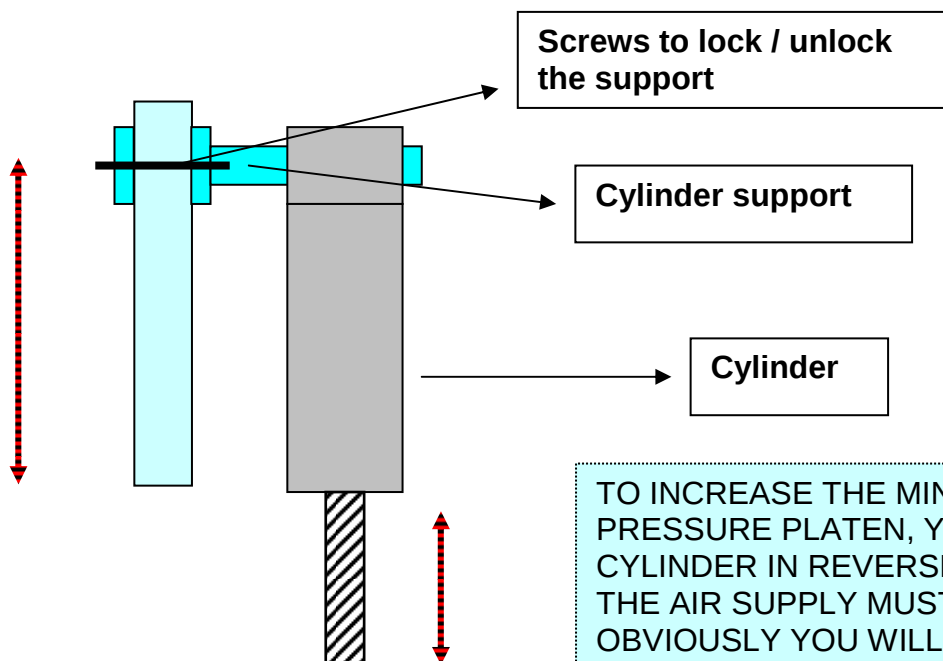
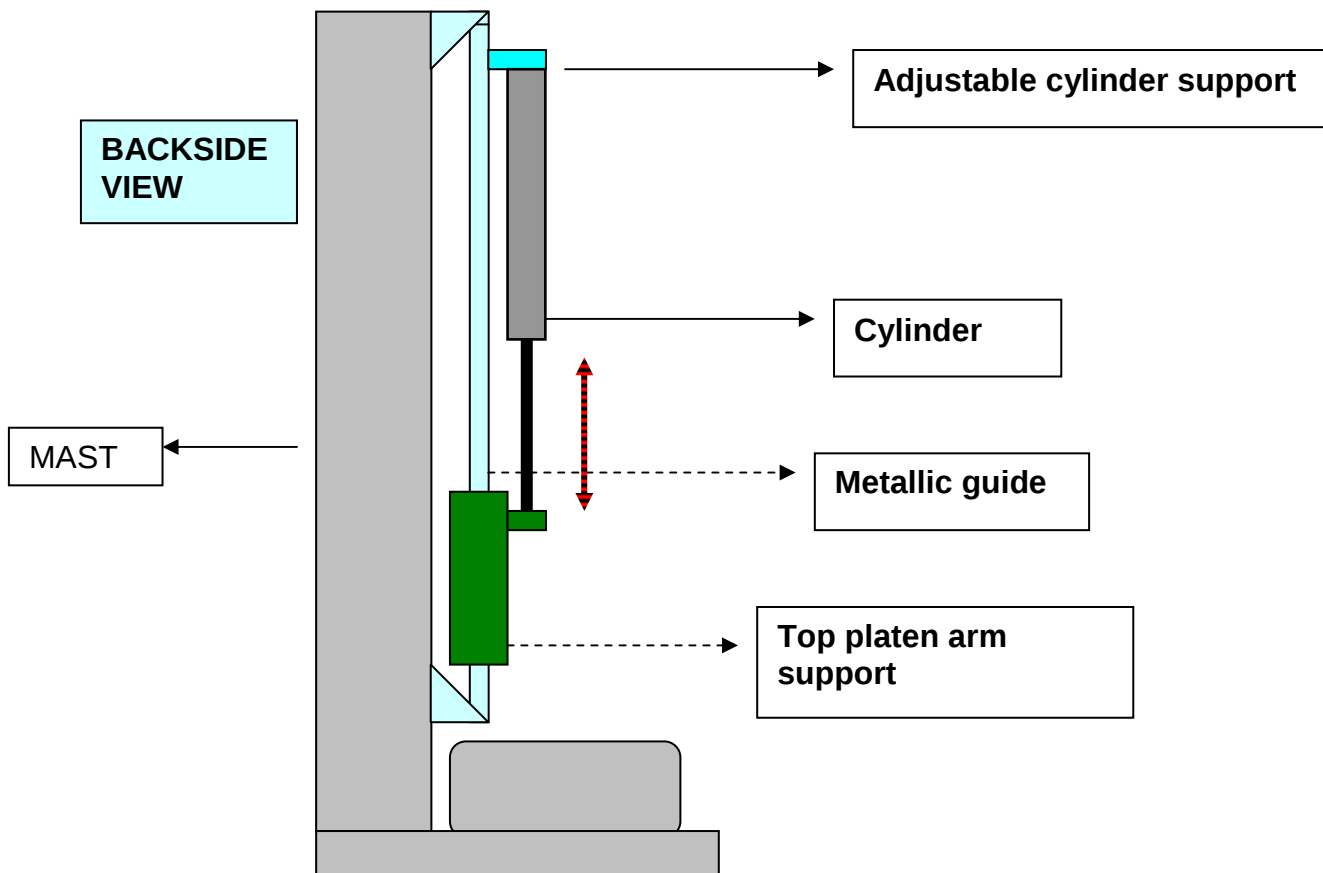
This cylinder does not require adjustments for wrapping heights over 860 mm. The presser arm must be overturned for lower heights (see § 4.5.).



* Pressore pneumatico H=2800.
** Pressore pneumatico H=3100

* Pneumatic presser H=2800.
** Pneumatic presser H=3100.





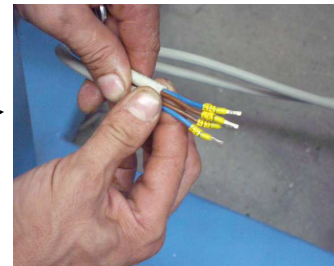
TO INCREASE THE MINIMUM HEIGHT OF THE PRESSURE PLATEN, YOU CAN FIX THE CYLINDER IN REVERSED POSITION (ALSO THE AIR SUPPLY MUST BE REVERSED). OBVIOUSLY YOU WILL LOSE IN MAXIMUM HEIGHT.

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o Instructions to make the electrical wiring & parameter setting.



Detail of the connectors inside the second chamber of the mast of the machine pre-set for the connection of the Top platen unit.



Numbering detail of the wires inside the mast of the machine to electrically connect the Top platen unit to the electrical box of the machine



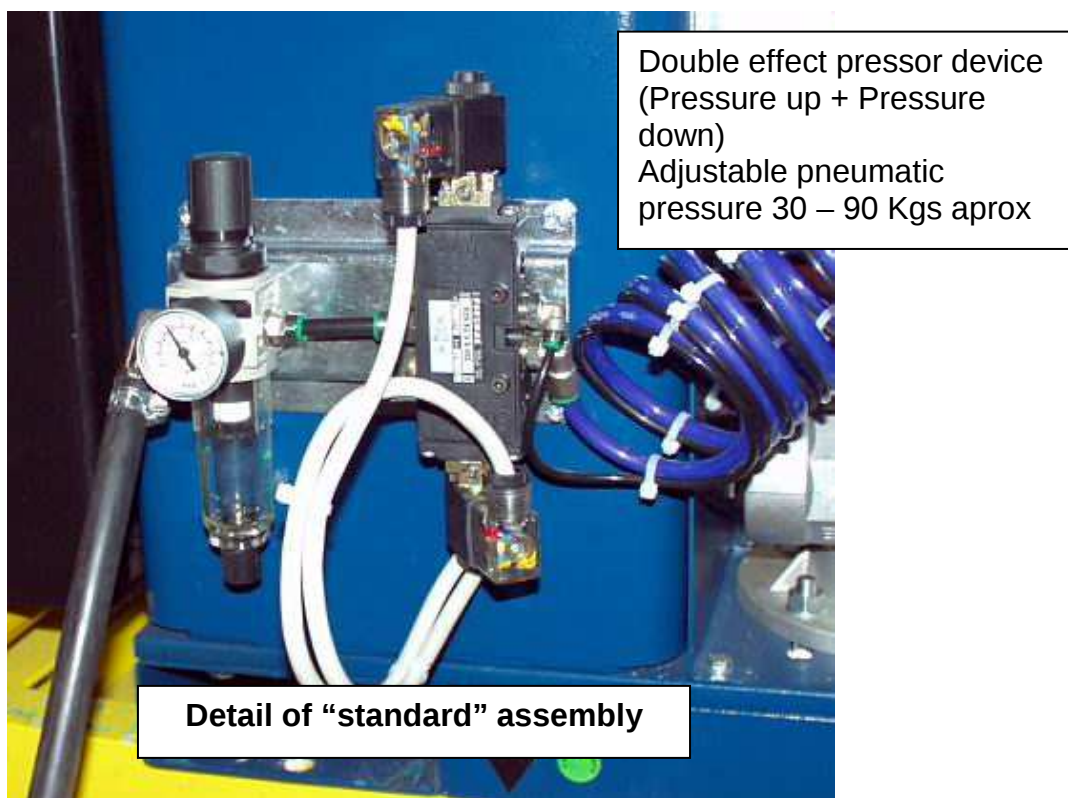
Hole in the mast to insert the wires 42 + 43 & 45 + 46 to electrically connect the Top platen device to the electrical box of the machine.

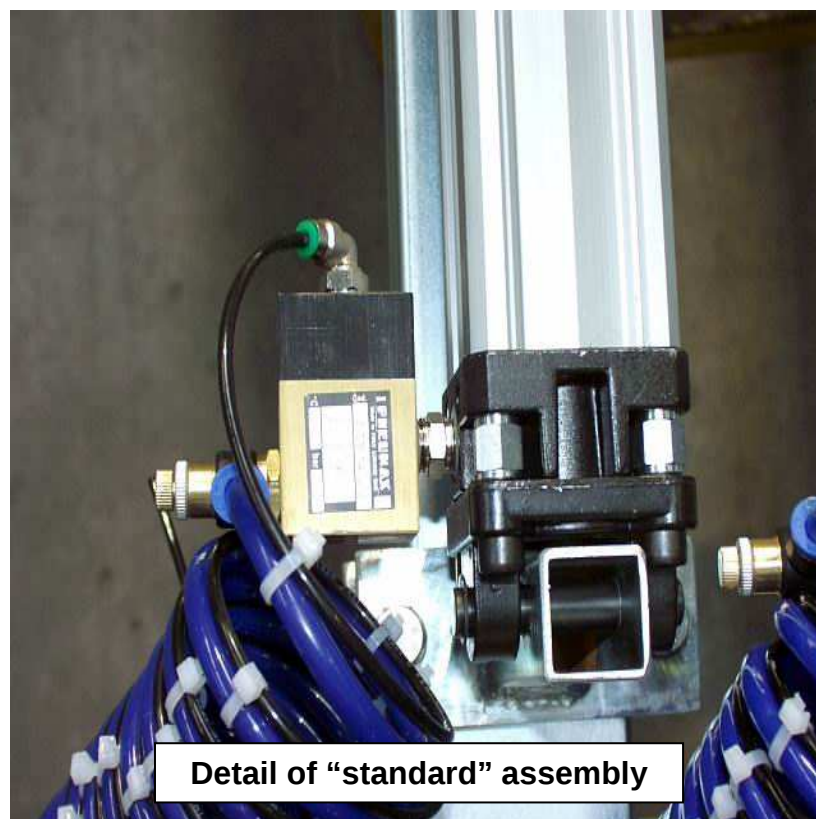
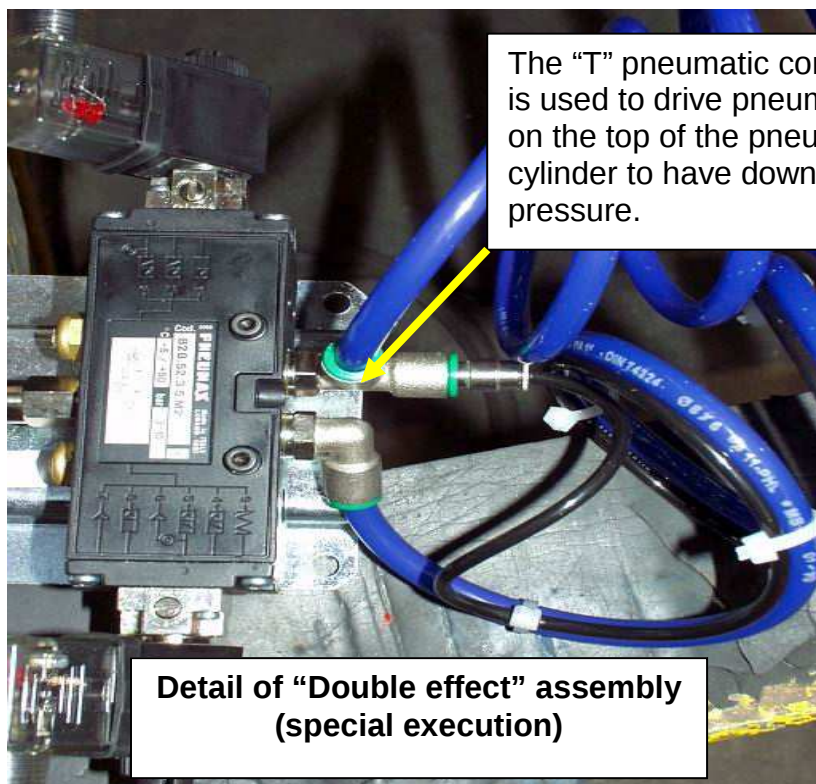
o **Parameter setting for Rotoplat Basic Range (507 - 707)**

To set the configuration parameters of the new Top platen device, it is necessary to enable it setting the parameter P6 = 1 (Enable Top Platen).

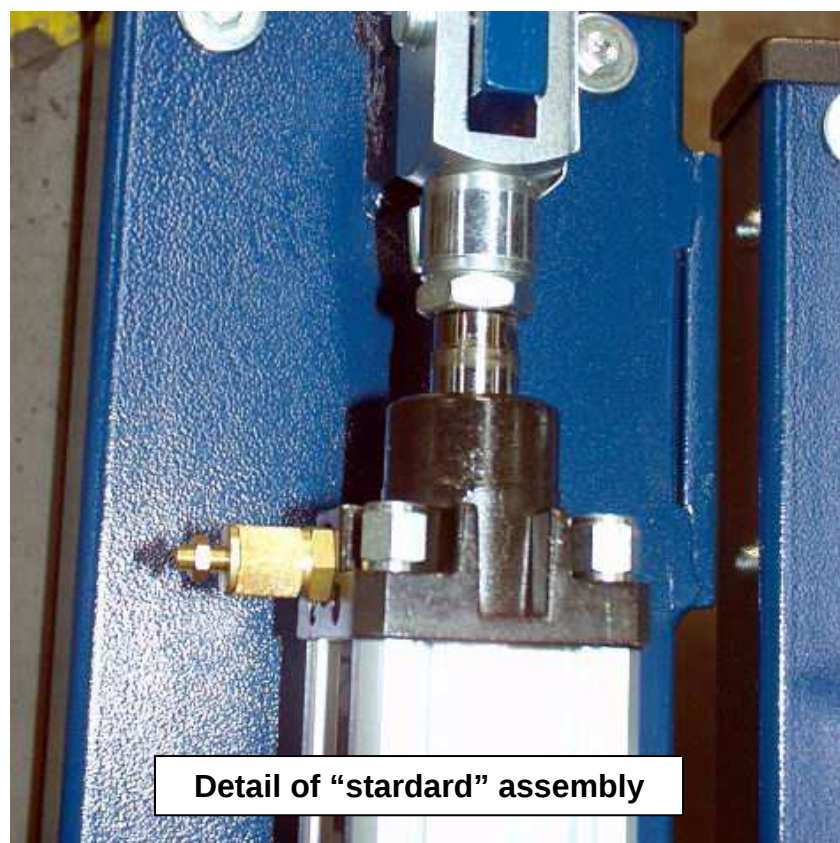
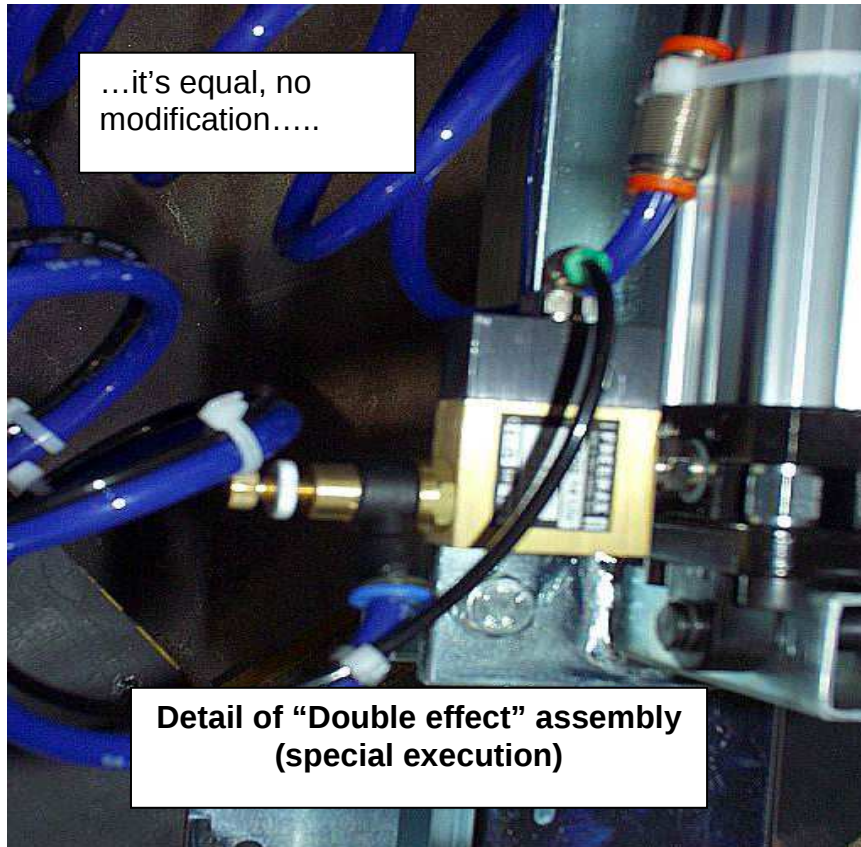
P5	0-1	1	--	0	Enable blocked spool carriage alarm
P6	0-1	1	--	1	Enable Top Platen
P7	0-1	1	--	1	Enable blocked turntable alarm

o **Instructions to modify the standard PNEUMATIC TOP PLATEN KIT into the special one in DOUBLE EFFECT TYPE.**

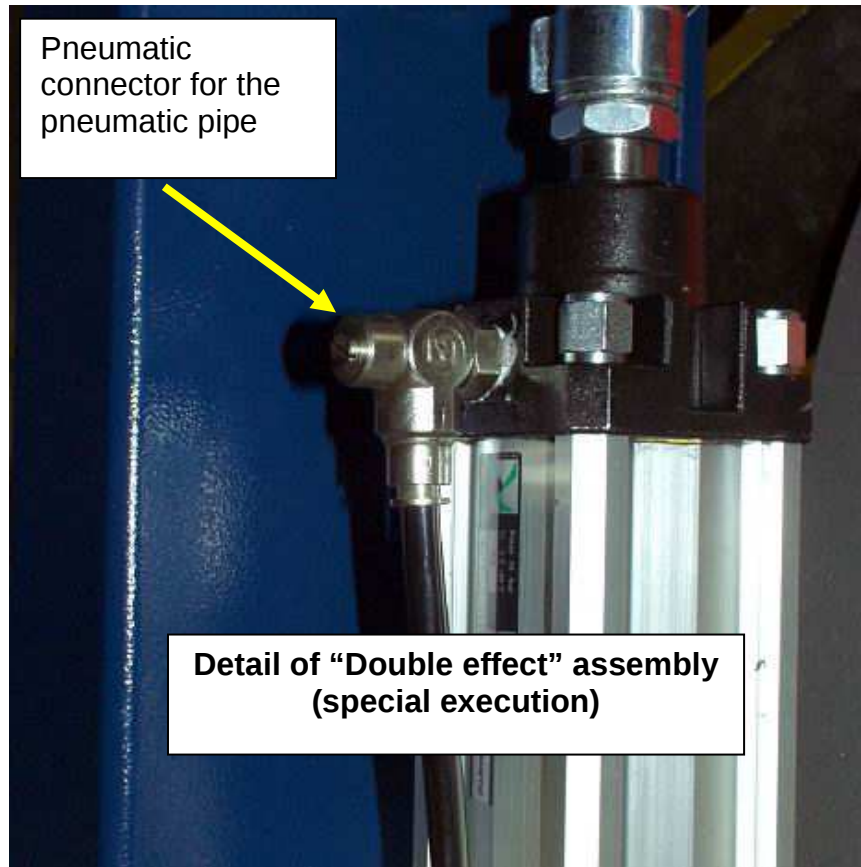




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17. DOOR & WINDOW CYCLE (DWP MACHINE).

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.

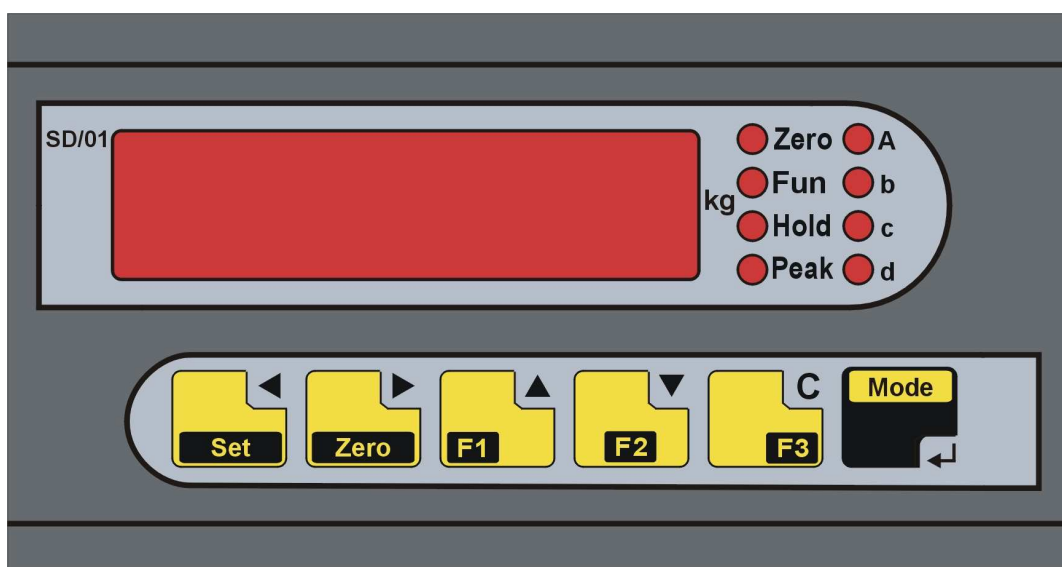
It is important that during the automatic cycle (packing) pressing the pedal, the top platen **MUST** not move in any direction.

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18. ROTOPLAT WT TUNING PROCEDURE (SCALE MACHINE).

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

1. Set the maximum value of the “Set Point A” to 2000 KGS (5000 Lb for USA machines).
2. Select the “Set Point A” as N.C. (normally closed contact) and active and positive.
3. Set the serial output.
4. Set the parameter of the converter.
5. Set the parameter of the Instrument.
6. Set-up the “Zero” of the scale.



1. Set the maximum value of the “Set Point A”



Press the key **Set** (keep it pressed for 2 seconds aprox.) to visualise the “**Set point A**”.

A ProG

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

MEMOr

2. Select the “Set Point A” as N.C. (normally closed contact).



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

ModE

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



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

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it shows **A conF** .



press the key **Mode** you will go inside in the configuration of the “**set A**”.
to set the N.C. contact press the key ‘**Zero**’



the display will shows “**A OPEn**”.



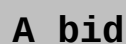
Press the push button “**Zero**”.



The display will shows “**A CLOS**”.



press the key “**Mode**”.



The display will shows “**A bid**”.



Press the push button “**Zero**”.



The display will shows “**A POSI**”.



press the key “**Mode**” to memorize visualizing the message



3. Set the serial output



Press the key **Mode** (keep il 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 the key **Mode** until you will see the message




press “**Zero**” to pass to transmission for printer.

the display will shows the message



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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 Mode



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

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 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

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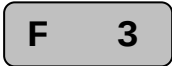
it is shown for 2 seconds and then it introduces the model of the used converter..



press the key  to go ahead.



it shows for 2 seconds and then it introduces the number of the set filter





set the value of the filter to **1** by the button 

press the key  to go ahead.



press the key  to visualise the unipolar status of the system.

press the key  to go ahead.



it shows **bip**.



Press the push button “Zero”.



The display will show **uni**.

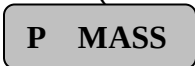


press the key Mode to visualize the message 

5. Set the parameter of the Instrument.

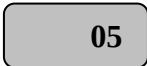


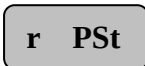
Using the arrows, set the code (**C00022**) and press the key  until you will see the message ‘**P MASS**’



Set this value to 2000  or  (for the USA machines).

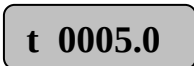
press the key  until you will see the message ‘**T PST**’  and set the value to



press the key  until you will see the message ‘**R PST**’  and set the value to



press the key  until you will see the message ‘**T AUO**’  and set the value to





press the key Mode to visualize the message 

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6. Set-up the “Zero” of the weigher.

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



Set the code **C00400**



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.



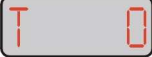
this value is number that change when the weight change and with the division, but it doesn't correspond to the real weight of the product (except if you made a calibration before).

NB 

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).

NB 

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 C** 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 = 10000).

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.

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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 twice **Mode** to return back to the weighing mode..



it shows **MEMOr** for two second aprox and than return 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.

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