HOT STAMPING MACHINE INSTRUMENT DATA V1

One、 Power on:

Display: upper row: InP lower row C / F – K, delay two or three seconds, the upper row displays SLH and the lower row displays SLL

Menu Description: SV indicates hot stamping time and PV indicates measured value

Two、 Parameter description

1、User parameters

In the normal measurement and control state, press the setting key once to enter the user control target value setting. Press the setting key again to complete the setting.

Code	Parameter meaning	Explain	Set range	Default value	Display condition
SV and ST indicators are on	Setting of heating temperature and hot stamping time	When SV light is on, the upper row indicates the set temperatureThe lower row of St light indicates that the hot stamping time is set	SCL---SCH 0---9999	150℃ 5	

2、Engineer parameters

Press and hold the setting key for 3 seconds to enter the engineer parameter setting status. To exit, press the setting key for 3 seconds. To set the next parameter, press the setting key once. No key is pressed, and it will exit automatically after about one minute.

Code	Parameter meaning	Explain	Set range	Default value	Display condition
AL1	First alarm	There are 12 alarm modes, which are determined by OP1.	–1999℃–9999℃	20℃	OP1!=0
P	Proportional band	If it is 0, it is bit control, and I and D menus will not be displayed at this time, but oh and ohh menus will be displayed.	0℃–999℃	30℃	
I	Integral time constant	If it is zero, the integral control function is cancelled	0–3600 seconds	120s	P != 0
D	Differential time constant	If it is set to zero, the differential action is cancelled	0–999 seconds	40s	P != 0
AR	Integral limiting	For integral limiting	0–100℃(	1℃	P != 0
AT	Self setting switch	Off: off; On: on	On/off	off	P != 0
OH	Bit control	PV > (SP + ohh) control output off			(when p = 0)
OHH	Bit control	PV < (sp–oh) control on output			(when p = 0)
T	Control cycle	Action cycle of main control	1–99 seconds	20s	P != 0
Pb	Display value correction	Make the displayed value = Pb value + internal measured value;	–50℃–50℃	0℃	1
LCK	Parameter lock	=0 SV and all Engineer parameters can be set =1 only SV and time can be set =Other SVS and all parameters cannot be set =911 factory reset =190 quick access to modify manufacturer parameters =191 quick access to modify hot stamping parameters	0 – full range	0	

3、Manufacturer's parameters

Code	Significance	Explain	Set range	Default value	Display condition
INP	Select sensor input signal	=0 K =1 J =2 R =3 S =4 B =5 E =6 N =7 T =8 PT100 =9 CU50 =Other selected		K	INP
CF	Celsius Fahrenheit	=0 ℃ =1 °F		00	
DP	Unitdecimal point	When int is PT100 or cu50, DP = 1 is displayed with decimal point		0	
DF	Filter coefficient	The larger the coefficient, the deeper the filtering, the smoother the display, but the slower the response	0--250	200	
OP1	First alarm mode selection	See the alarm mode description table	0-16	1	1
AH1	Poor switching of the first alarm relay	Poor switching of alarm relay	0-200	1	1
SLH	Upper range limit		-199-999	0	1
SLL	Lower range limit		-199-999	400	1
dTT	Temperature tracking quantity	Make the display temperature close to the set value within the range of the set value ± TT	0—25.0	0.1	dTT
FAC	Overtemperature display suppression	=0 turn off functionEqual to other values. After exceeding the set value, the exceeding part is displayed in proportion, and the displayed value = SV + (pv–sv) / fac	0--250	0	

3.1 Significance of parameters in alarm mode description table (OP1 and OP1)

Value of AL1T / AL2T	Significance
0	No alarm, AL1 and AL2 menus will not be displayed by default
1	Upper limit deviation alarm
2	Lower limit deviation alarm
3	Upper and lower limit deviation external alarm
4	Alarm within upper and lower limit deviation
5	Lower absolute value alarm
6	Upper absolute value alarm
11	Upper limit deviation alarm with hold
12	Lower limit deviation alarm with hold
13	External alarm of upper and lower limit deviation with hold
14	Upper and lower limit deviation alarm with hold
15	Lower absolute value alarm with hold
16	Upper absolute value alarm with hold

5、Hot stamping parameter description

Code	Significance	Explain	Set range	Default value
OTC	Advance alarm time	When the minus one countdown time is equal to the OTC time, the built–in buzzer rings the OTC time	0—250 S	0
SCT	Lower row digital display mode	= 0, the setting time or countdown time is displayed in normal state, and the parameter value is displayed when setting parameters. = display the SV temperature setting value in other normal states, display the countdown time after starting the timing, and display the parameter value when setting the parameters.	0——3	0
ToF	Time output type	When the time relay (buzzer) pulls in the output after the countdown, the function is effective and turns off after delaying TOF time = 00, pull in until the start switch is disconnected = 100, it will be output at an interval of 0.5 seconds until the start switch is turned off = 104, it will output intermittently for 4 seconds in 0.5 seconds, that is, it will be disconnected after 4 sounds = 003, it will be output for 4 seconds and then disconnected	0—199 S	00
M-S	Time unit	=0 minus one time in seconds =1 hour minus 1 time unit is 0.1 second =2 / 3 hour minus one time unit: minute	0-3	0
OTS	Hot stamping type	=0: when the switch is closed, the countdown is displayed. The countdown is 0. The time relay is pulled in and the internal buzzer rings. The relay is released and the buzzer does not ring until the switch is disconnected. One operation is completed; =1: When the switch is closed, the countdown is displayed, the time relay is engaged, the countdown is 0, the relay is released, and the buzzerThe buzzer rings until the switch is disconnected, and the buzzer does not ring until one operation is completed; =7: When the head is powered on, it is judged that the measured value is greater than or equal to the set value, and the switch is closed effectively: the switch is closed, the countdown is displayed, the time relay is engaged, the countdown is 0, the relay is released, and the buzzer rings. The buzzer does not ring until the switch is disconnected, and one operation is completed. The switch is closed again to start the countdown and no longer judge the temperature value. =3: Jog the switch input to start the countdown. The countdown is 0. The relay is closed and the buzzer rings. When the jog switch input relay is released again and the buzzer does not ring, one operation is completed; =4: The jog switch input starts the countdown, the relay is closed, the countdown is 0, the relay is released, and the buzzer rings. When the jog switch input buzzer does not ring again, one operation is completed; =5: The inching switch input starts the countdown. The countdown is 0. The relay is closed and the buzzer rings. One operation is completed. When the next inching switch input starts, the relay is released and the buzzer does not ring; =6: The inching switch input starts the countdown, the relay is pulled in, the countdown is 0, the relay is released, the buzzer rings, and one operation is completed. When the next inching switch input starts, the relay is pulled in again and the buzzer does not ring;	0---17	0
		=15: High and low temperature control: when the temperature is less than the set low temperature, there is output, when it rises to the set low temperature, there is no output, when the switch is closed, the temperature is less than the high temperature setting value, there is output, when it rises to the high temperature setting value, there is no output, and the countdown starts; =16. Jog the key to start, jog the time and add the key to display the countdown. The countdown is 0. The time relay is closed, and the internal buzzer rings. Wait for the key to be jogged again, the relay is released, the buzzer does not ring, and one operation is completed; =17: Jog the key to start, jog the time plus key to display the countdown, the time relay is engaged, the countdown is 0, the relay is released, the buzzer rings, wait for the key to start again, the buzzer does not ring, and one operation is completed;=Other useless		
OSH	High temperature timing	It is useful when OTS = 15. It turns on when the measured temperature reaches Osh, such as timing	00---SCH	200
OSL	Low temperature start	It is useful when OTS = 15. When the measured temperature reaches OSL, the start switch is effective	00---SCH	50
OTM	Built in buzzer prompt type	OTM * 10ms, when = 30, the countdown ends, and the buzzer turns on and off at the frequency of 0.3 seconds. It is recommended to set it to 60 if necessary= 0 makes a long sound	0---100	00
OTA	Temperature prompt time	After power on, when PV > = SV time, the buzzer rings and OTA time is 0, there is no such function	00---30 S	00