



JOB #20-324

Turret Rewinder

TOUCH SCREEN/OPERATORS MANUAL

Contents

TOUCHSCREEN OPERATION..... 3

 STARTUP SCREEN 3

 MAIN SCREEN..... 4

 SETUP SCREEN 6

 SERVOS SCREEN..... 8

 VFDS/MOTORS SCREEN 10

 FACTORY SETUP SCREEN 11

 INTERLOCKS SCREEN 13

 INPUTS SCREEN 14

 OUTPUTS/FORCES SCREEN 15

TOUCHSCREEN OPERATION

STARTUP SCREEN

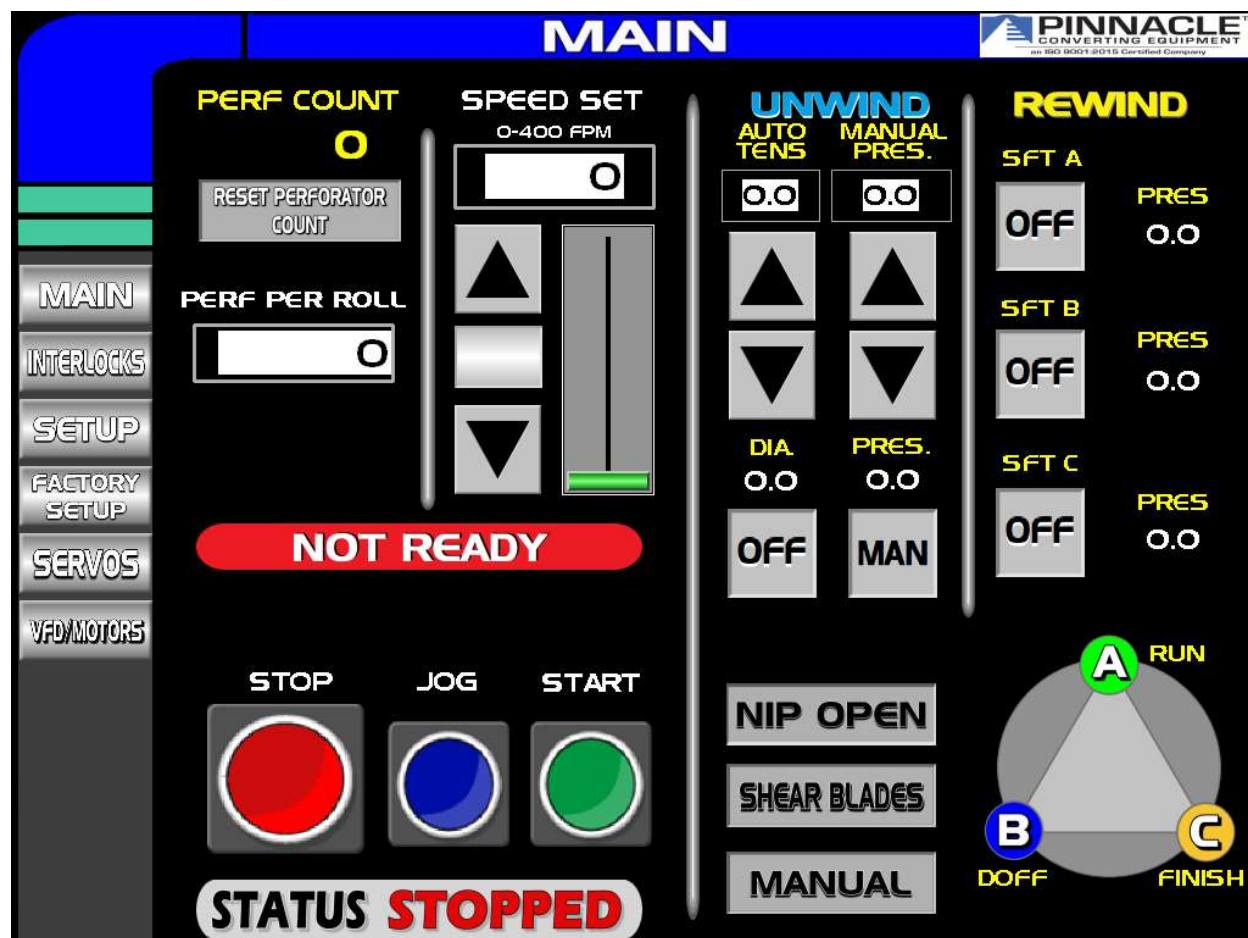


Job #20-324



This is the startup screen that is displayed when the machine is first turned on. Touch the screen to advance to the main operating screen.

MAIN SCREEN



This is the main operating screen. The menu buttons on the left open additional screens.

Speed Setting		The machine runs at the speed indicated, use the slider to adjust or tap the data field to input a new value
Perf Counter & Setpoints	Perf Count	Displays the perf count wound onto the rewind shaft
	Reset Button	Resets the perf counter
	Perf Per Roll	Sets the number of perfs to be wound onto each roll
Machine Control Buttons & Indicators	Ready Indicator	Indicates if the machine is ready or not ready to start
	Status Indicator	Indicates of the status of the machine (running, stopped, etc)
	Start Button	Starts the machine cycle
	Jog Button	Jogs material through the machine
	Stop button	Stops the machine
	Nip Open	Open/Closes the nip
	Shear Blades	Toggles the shear blades on/off
	Turret Diagram	Displays what position each shaft is indexed in

Unwind Settings/ Controls	Auto Tension (Mode)	Automatically controls the air pressure based on the current diameter of material on the unwind roll. The set value scales the default unwind brake pressure mapping.
	Manual Pressure (Mode)	Applies the set pressure regardless of the diameter of material on the unwind roll. The set value is the actual air pressure delivered to the unwind brake.
	Diameter Display	Displays the actual diameter of the unwind roll
	Pressure Display	Displays the actual pressure delivered to the unwind brake
	On/Off Button	Toggles the unwind brake on and off
	Auto/Manual Button	Toggles air pressure control between manual and auto mode
	Unwind Control Button	Press this button to select between brake or driven unwind modes
Rewind Settings/ Controls	Shaft On/Off Buttons	Toggles pressure to each respective rewind shaft clutch on/off
	Pressure	Displays the current pressure on each rewind shaft clutch

SETUP SCREEN

SETUP

UNWIND

OFF Diameter: 0.0 in Pressure: 0.0

MAN Core Press: 0.0 Max Press: 0.0

Low Unwind Diameter Setpoint 0.0 in

AUTO TUCK Warmup **OFF**

FINISH SEQUENCE

TUCKER BLADE DELAY 0.000 sec

TUCKER BUMP DELAY 0.000 sec

FINISH ROLL TIME 0.000 sec

TOTAL LENGTH 0.0 **RESET LENGTH**

REWIND

PRESSURE

	ACTUAL	TRANSFER	RUN	CUT
A:	0.0	0.0	0.0	0.0
B:	0.0	0.0	0.0	0.0
C:	0.0	0.0	0.0	0.0

Draw: 0.0 %

ANVIL Draw: 0.0 %

BELT TRANSFER Draw: 0.0 %

LAYON Draw: 0.0 %

Layon Press Setpoint 0.0

Layon Transfer Press Set 0.0

PERFORATOR

PERF LENGTH 0.0 in

PERFS BEFORE TRANSFER 0

Unwind Settings	On/Off Button	Toggles the unwind brake/rewind shaft clutch on and off
	Auto/Manual Button	Toggles unwind brake/rewind shaft air pressure control between manual and auto mode
	Pressure Display	Displays the current pressure delivered to the unwind brake/rewind shaft
	Core/Max Pressure Setting	Sets the core/max air pressure to be used in AUTO mode
	Low Unwind Diameter SP	Sets the diameter of the unwind roll at which the machine will stop.
Rewind Settings	Actual Pressure	Displays the current pressure to each rewind shaft clutch
	Pressure Settings	Sets the air pressure setpoint to each rewind shaft during the transfer, run, and cut sequences
	Draw	Sets the overspeed of the rewind shafts, anvil shaft, belt transfer, and layon roll

	Perf Length	Sets the length of material between perfs
	Perfs Before Transfer	Sets the number of perfs to be performed before the transfer sequence is initiated.
Finish Sequence	Auto Tuck	Initiated the auto-tuck sequence for initial machine threading
	Warmup	Toggles the warmup sequence on/off
	Tucker Blade Delay	Sets the time delay before the tucker blade fires
	Tucker Bump Delay	Sets the time delay before the tucker bump roll fires
	Finish Roll Time	Sets the length of time the roll is finished
	Total length	Displays the total length of material that has been processed
	Reset Length	Rests the length counter

SERVOS SCREEN

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TURRET SERVO TURRET HOME

RUN SPEED

JOG SPEED

ACCEL

DECEL

HOME OFFSET

JOG FORWARD

JOG REVERSE

MOVE TO HOME

MOVE TO NEXT

PERFORATOR SERVO

RUN SPEED

JOG SPEED

ACCEL

DECEL

PERFORATOR COUNT

JOG FORWARD

RESET PERFORATOR COUNT

DOFF SERVO

JOG SPEED

RUN SPEED

ACCEL

DECEL

RETURN SPEED

RETURN ACCEL

DOFF POSITION

HOME POSITION

HOME OFFSET

AWAY POSITION

DOFF RESET

RUN DOFF SEQUENCE

MOVE TO HOME

JOG FORWARD

JOG REVERSE

Common	Run Speed	Sets the run speed of each respective servo
	Jog Speed	Sets the jog speed of each respective servo
	Accel	Set the acceleration behavior of each respective servo
	Decel	Sets the deceleration behavior of each respective servo
	Jog Buttons	Jogs the servo in each applicable/respective direction
	Fault Acknowledge	Acknowledges servo drive faults that interrupt operation
Turret Servo	Turret Home Button	Initiates the turret homing cycle
	Move To Home/Next	Cycles the turret to the home or next index position
Perforator Servo	Doff Position	Displays the current position of the doff sled
	Home/Away Positions	Sets the Home/Away position of the doff sled
	Home Offset	Sets offset position of the doff sled from the home position

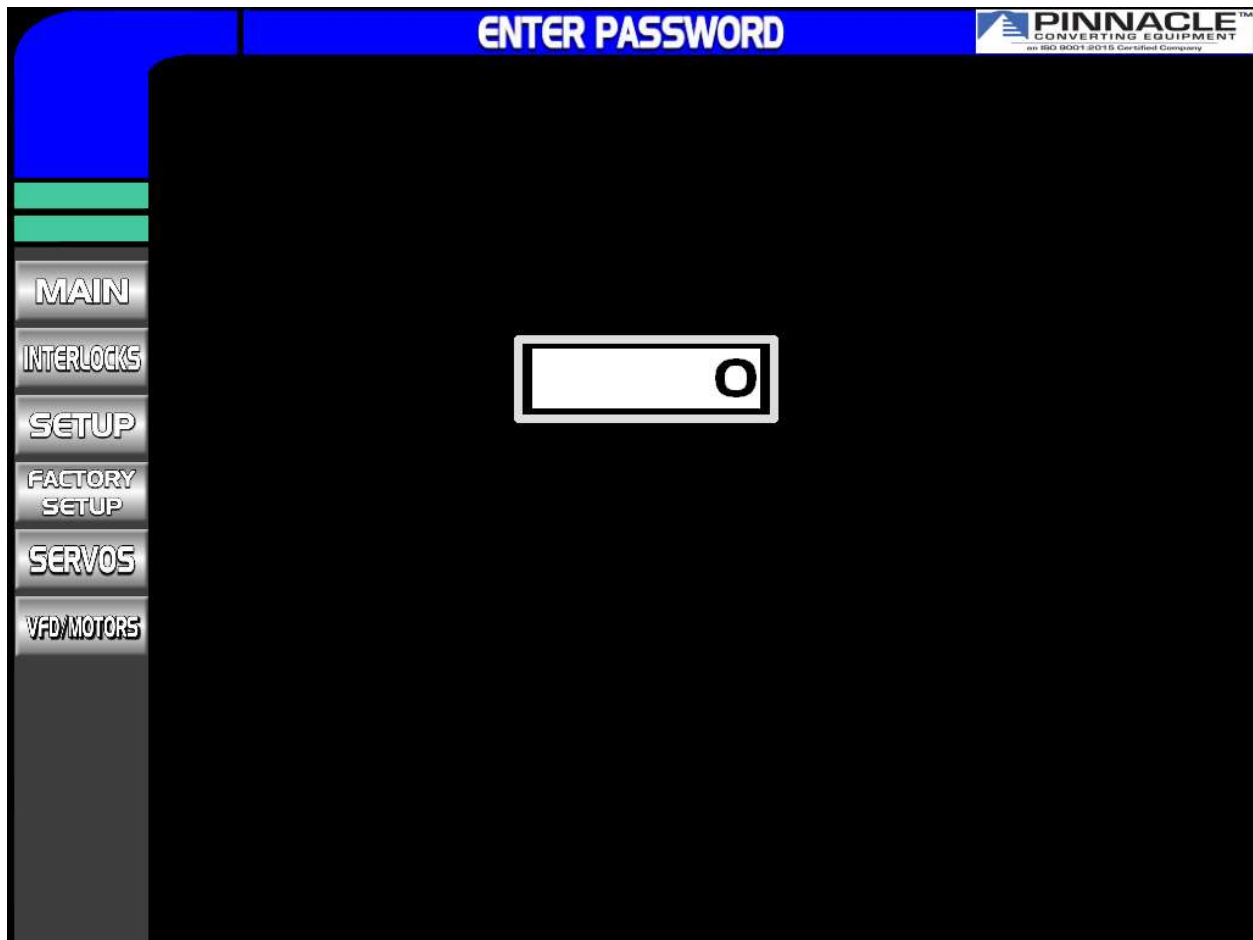
	Return Speed/Accel	Sets the return speed and acceleration of the doff servo
	Doff Reset Button	Resets the doff servo
	Run Doff Sequence	Initiates the doff sequence
	Move to Home	Moves the doff sled to the home position

VFDS/MOTORS SCREEN



Common	Jog Forward/Reverse	Jogs each respective motor in the indicated direction
	Run – Jog Forward/Reverse	Continuously jogs each respective motor in the indicated direction
	Jog Speed	Sets the jog speed of each respective motor

FACTORY SETUP SCREEN



Only qualified individuals should modify settings in the factory setup screen. Enter the password at the password screen to access these settings.

FACTORY SETUP

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MAIN

INTERLOCKS

SETUP

FACTORY
SETUP

SERVOS

VFD/MOTORS

INPUTS

OUTPUTS

SERVO
OUTPUTS

UNWIND

JOG SPEED

0

FPM

Core Dia :

0.0

in

Max Dia :

0.0

in

REWIND

SHAFT FILL

SHAFT A

SHAFT B

SHAFT C

PERF LENGTH
CALIBRATION

0.000

Warmup Press:

0.0

PSI

Warmup Time:

0

Min

Warmup Speed:

0

%

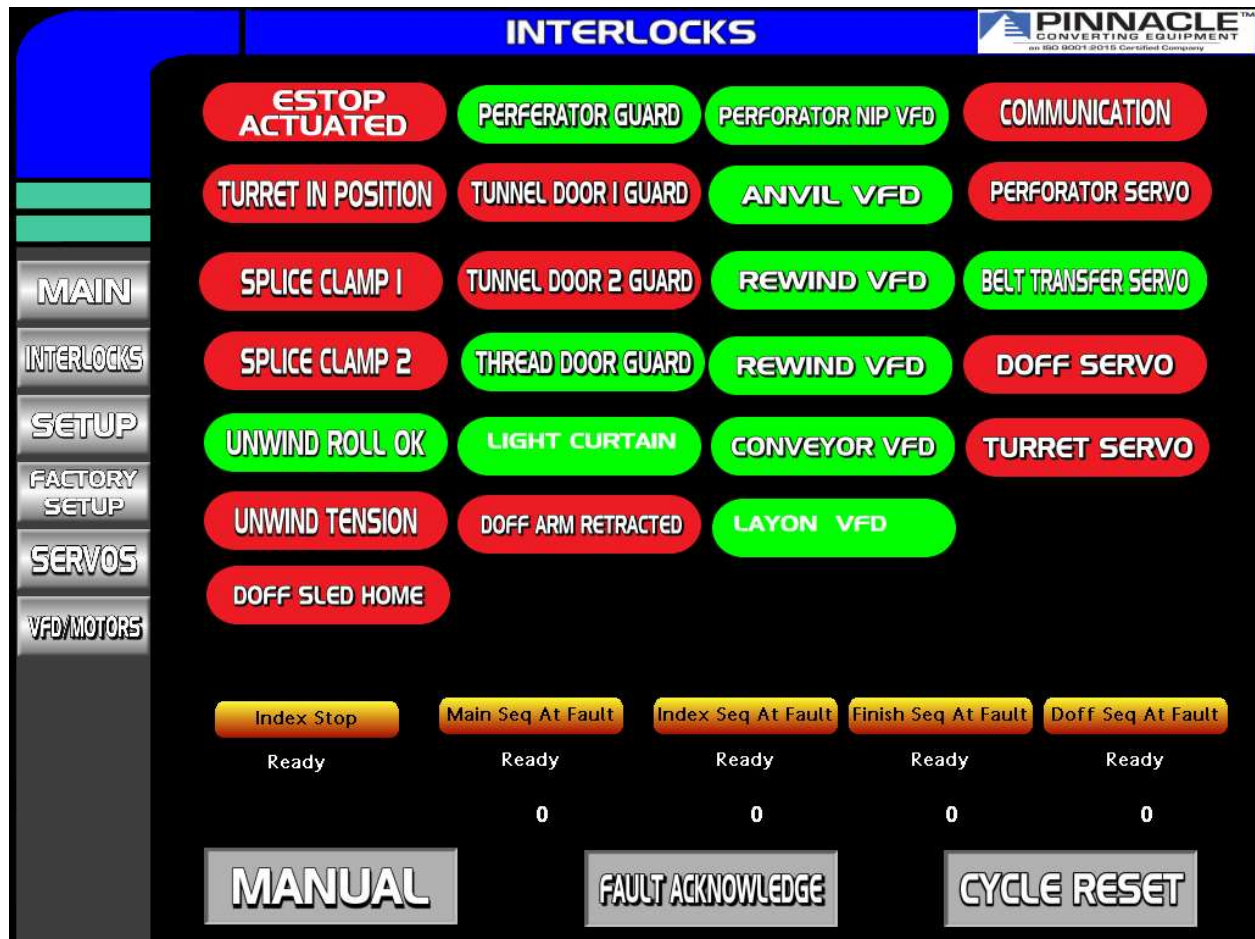
START/CUTOUT
SPEED

0.0

FPM

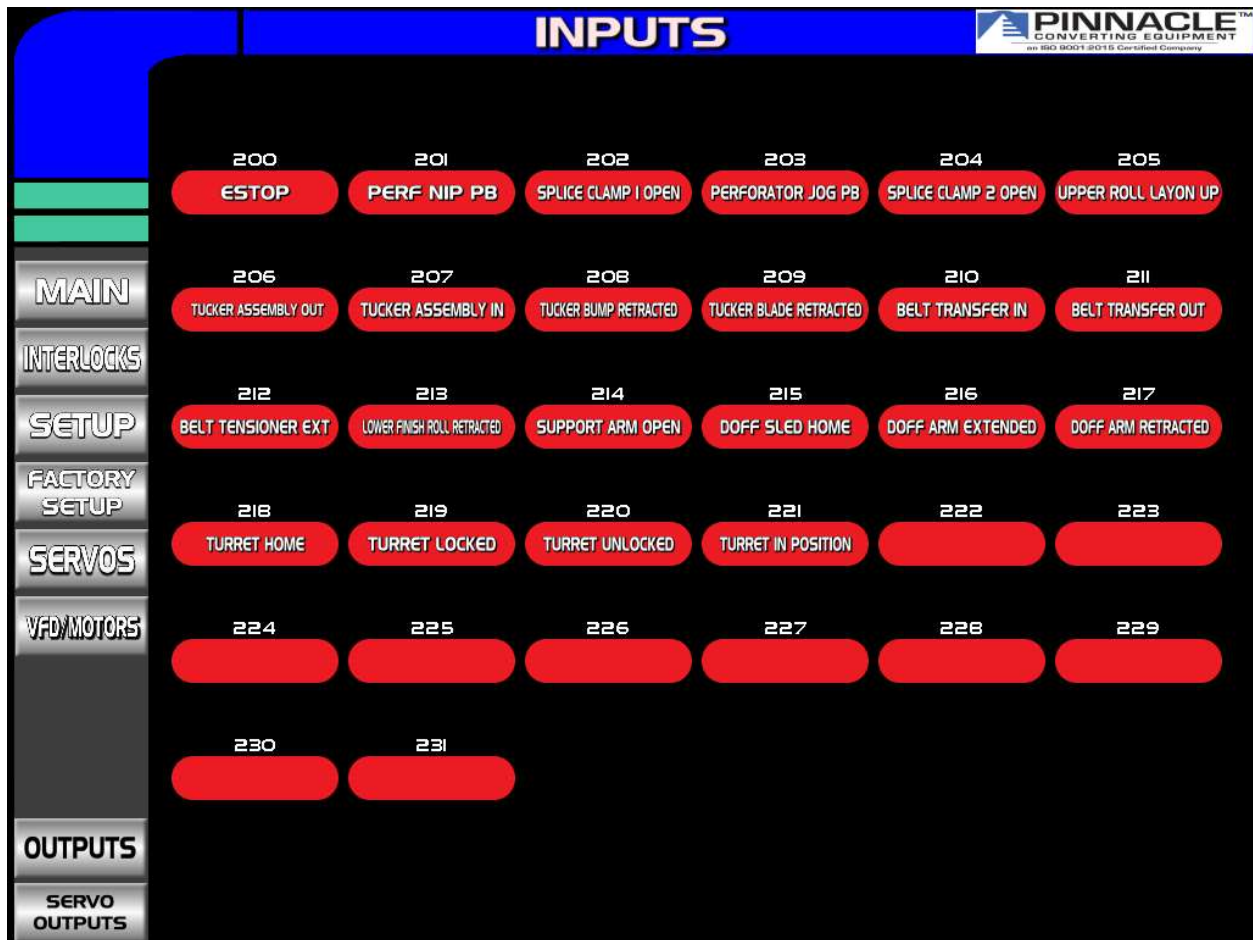
Unwind Settings	Core Diameter Setting	Sets the physical core diameter used, this value is used in machine control calculations
	Maximum Diameter Setting	Sets the maximum physical role diameter desired, this value is used in machine control calculations
Rewind Settings	Shaft Fill Buttons	Inflates or deflates each respective rewind shaft
	Perf Length Calibration	Setting used to calibrate the length between perforations
	Warmup Settings	Sets the rewind clutch pressure, time and speed used in the warmup sequence
	Start/Cutout Speed	Sets the speed above which the machine will enter a normal cycle

INTERLOCKS SCREEN



The GREEN/RED indicators display conditions of the machine that may prevent the machine from starting or cause the machine to stop. When any of these conditions occur, the condition must be cleared and the reset button on the machine must be pressed to start the machine again.

INPUTS SCREEN



The Inputs screen shows indicators that depict the status of individual machine parts/functions.

OUTPUTS/FORCES SCREEN



The Outputs screen allows the operator to manually actuate machine functions.

