



MODEL L-BAR SEALER AND SHRINK TUNNEL

SERVICE MANUAL SUPPLEMENT

ISSUED BY:
PRODUCT SERVICE DEPT.
TROY, OH 45374-0001

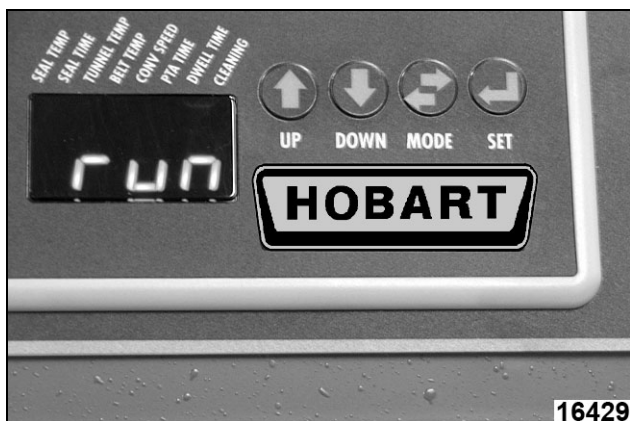
MARCH 2006

L-BAR-12

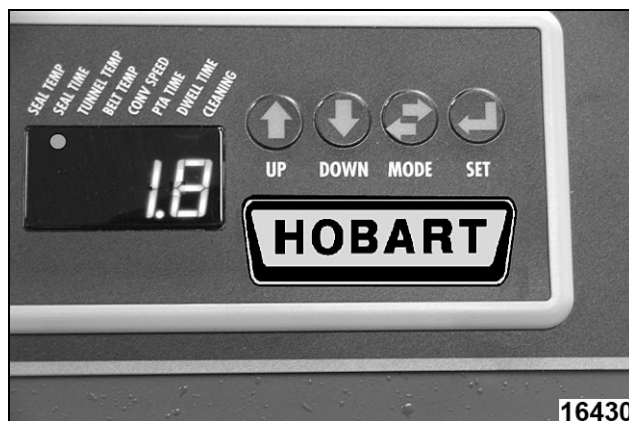
RS3 SEAL CONTROLLER ON L-BAR

The 1730 L-Bar Sealer serial # 05-1053245 and higher will have a new style seal controller. Operation and programming are explained in this SMS.

L-BAR RS3 SEAL CONTROLLER



Operator Controls



LED Indicating SEAL TIME of 1.8

Operator Controls

NOTE: The numbers from the old style seal control are not comparable to the numbers that are used on the new RS3 controller.

- ON/OFF Breaker Switch. When switch is in the off position "---" will be displayed. When in the on position "run" will be displayed. The controller will beep when first turned on.
- SEAL TIME – User adjustable from 0.0 to 2.0 seconds. This setting is the length of time the wire heats up. The higher the number the hotter the wire will become. Start at 1 second.
- CONVEYOR SPEED – User adjustable from 0 to 10. This setting controls the speed of the PTA conveyor motor. The higher the number the faster the conveyor will run. Set to 10 for all applications.
- PTA TIME – User adjustable from 0.0 to 10.0 seconds. This setting is the length of time the conveyor will run when the L-Bar arm raises. Start at 3 seconds for all applications.
- DWELL TIME – User adjustable from 0.0 to 5.0 seconds. This setting is the length of time the L-bar arm stays down after the wire stops heating up. Set to 1 second for all applications.
- CLEANING – Not user adjustable. This setting cleans residue off the wire.

Viewing The Settings

- Pressing the MODE key allows the user to view the above settings on the controller.
- Each time the MODE key is pressed it will step to the next setting.
- A red LED will indicate which setting is being viewed
- When the CLEANING LED is on and the SET key is pressed, the controller will heat the wires to clean off any residue on the wires and "cln" will be displayed. The display will switch back to "run" operation after cleaning is completed.
- If no key is pressed for 5 seconds the display will switch back to "run" operation.

Changing The Settings

- Press and hold the MODE key for 5 seconds. The red LED will start blinking to indicate to the user which setting is being viewed and that the setting can be changed.
- Use the UP and DOWN arrow keys to adjust the setting.
- Press the MODE key to step to the next setting.
- After changing the settings, press and hold the SET key for 5 seconds to save the new settings and to exit back to "run" operation. The red LED will stop blinking when the save is completed.
- If settings are changed but no key is pressed for 30 seconds, the display will switch back to "run" operation and no changed settings will be saved.

PROGRAMMING THE FEATURES OF THE RS3 CONTROLLER – 1730 L-BAR HOT WIRE

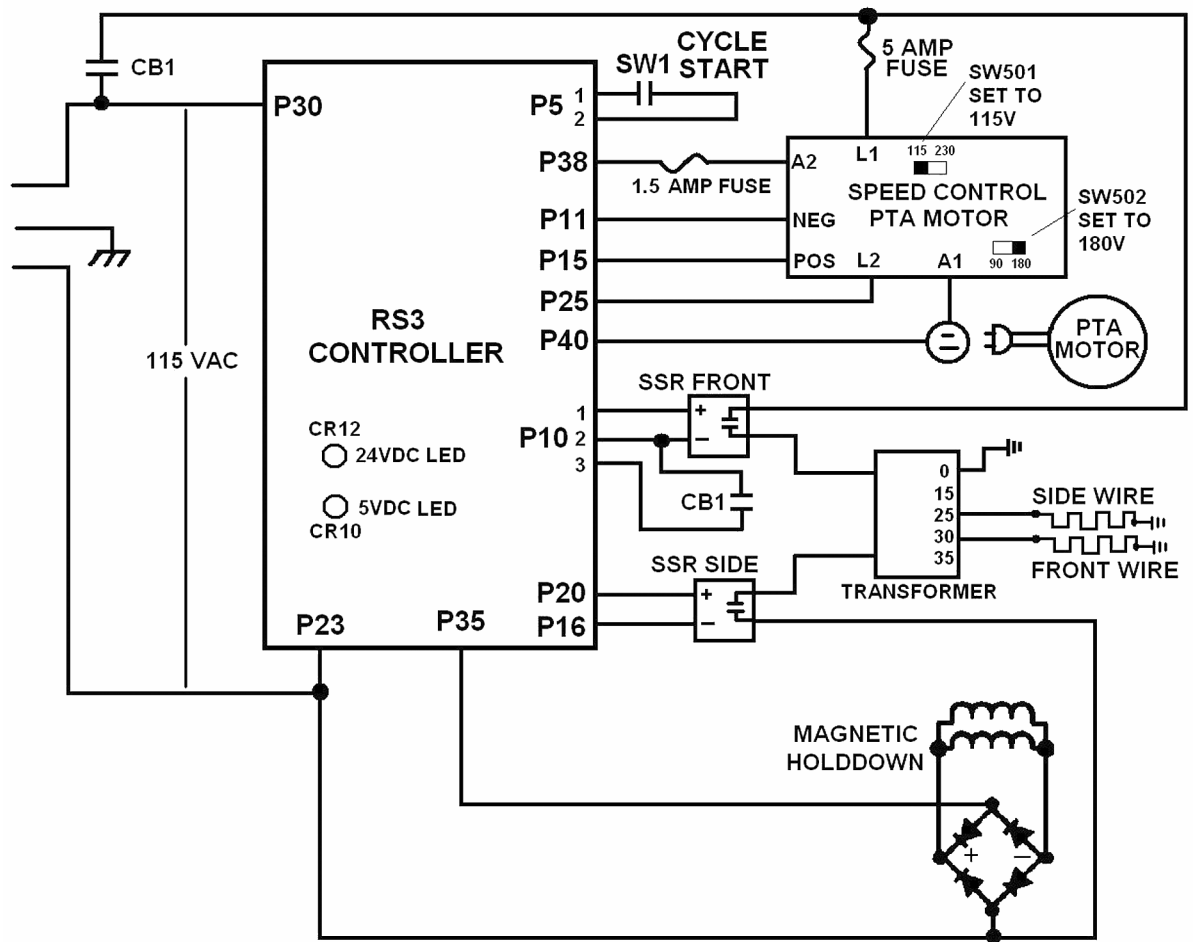
The features (parameters) of the RS3 Controller can be programmed by the technician. There are 26 parameters that can be changed, but there are only 6 parameters that will affect the operation of the Hot Wire L-Bar Sealer; P05, P06, P12, P13, P25 and P26.

To Change Parameters:

1. Make sure unit is in the Off Mode ("- - -" will be displayed)
2. Press and hold **mode** key for 20 seconds or until the first parameter appears, then release the SET key. (P01 will be on the display)
3. Pressing the SET key again will toggle between the parameter name and the value in that parameter.
4. Use the UP or DOWN Arrow keys to change the value in the parameter.
5. Press the SET to go back to parameter name.
6. Press the UP or DOWN Arrow key to go to the next parameter you want to change.
7. When at the next parameter you want to change, press the SET key to toggle to the value in that parameter. Repeat Steps 3 thru 7 until all the parameters you want to change are done.
8. Press and hold the SET key for 5 seconds until the display shows "- - -". This locks in the changes. Also if no key is pressed for 30 seconds the display will go back to "- - -" with the changes locked in.
9. If needing to reset all parameters to factory default, turn off the circuit breaker and press the DOWN Arrow key while the power cord is unplugged and plugged back in. A short audible beep will confirm the values have been reset.

Parameters

- | | | |
|-----|---|---|
| P01 | - | Not used. Hot Knife only. Temperature display of Fahrenheit or Celsius. Values F or C. |
| P02 | - | Not used. Hot Knife only. Tunes front knife probe location. Value of -50 to 50. Should be 0. |
| P03 | - | Not used. Hot Knife only. Tunes side knife probe location. Value of -50 to 50. Should be 0. |
| P04 | - | Not used. For Shrink tunnel probe. Value should be 0. |
| P05 | - | Selects type of L-Bar, Impulse (Hot wire) or Hot Knife. Value of I or H, select I. |
| P06 | - | For Hot Wire L-Bar only. Clean Cycle Time. Value of 0 to 3. Set to 2.0 |
| P07 | - | Not used. For Shrink Tunnel only. Should be 15. |
| P08 | - | Not used. Hot Knife only Max. adjustable Front Knife temperature. Value from 140 to 400 F. |
| P09 | - | Not used. Hot Knife only Max. adjustable Side Knife temperature. Value from 140 to 400 F. |
| P10 | - | Not used. Maximum Shrink Tunnel temperature. Should be 375. |
| P11 | - | Not used. Maximum Shrink Tunnel temperature control. Should be 100. |
| P12 | - | Maximum L-Bar PTA conveyor time. Values of 0 to 10. Set to 10. |
| P13 | - | For Hot Wire L-Bar only. Maximum Dwell time. Value of 0 to 5. set to 5.0 |
| P14 | - | Not used. Hot Knife only Front Knife High temperature alarm. Set to 425 F or 218 C. |
| P15 | - | Not used. Hot Knife only Side Knife High temperature alarm. Set to 425 F or 218 C. |
| P16 | - | Not used. For Shrink Tunnel High temperature alarm. Should be 425 F or 218 C. |
| P17 | - | Not used. For Shrink Tunnel temperature controls. Should be 10. |
| P18 | - | Not used. For Shrink Tunnel temperature controls. Should be 100. |
| P19 | - | Not used. For Shrink Tunnel temperature controls. Should be 2 for F or 1 for C. |
| P20 | - | Not used. For Shrink Tunnel temperature controls. Should be 0. |
| P21 | - | Not used. Hot Knife only Hot Knife temperature control. Set to 10 for F or 5 for C. |
| P22 | - | Not used. Hot Knife only Hot Knife temperature control. Set to 100. |
| P23 | - | Not used. Hot Knife only Hot Knife temperature control. Set to 2 for F or 1 for C. |
| P24 | - | Not used. Hot Knife only Hot Knife temperature control. Set to 0. |
| P25 | - | Enable/Disable Shrink Tunnel temperature input. Set to OFF. |
| P26 | - | Trim rate. For Hot Wire L-Bar Value of 0 to 100. Set to 50. This setting controls the temperature of the cut-off wire. The higher the number, the hotter the cut-off wire will become when running multiple packages. |



MODEL 1730 L-BAR
SERIES B1 RS3

16431

RS3 CONTROLLER – SEQUENCE OF OPERATION & VOLTAGE CHECKS

1. CB1 circuit breaker off. 120 VAC applied to controller across P30 and P23. CR10 & CR12 LED on.
2. CB1 circuit breaker off. 3 VDC across P10 - 2/3. Controller senses CB1 off because of 3 VDC.
3. CB1 circuit breaker on. 0 VDC across P10 - 2/3. Controller senses CB1 on. Controller beeps and "run" will be displayed.
4. Operator lowers L-Bar arm, which closes SW1 Cycle Start switch. 5 VDC across P5, pins 4 & 6 when the switch is open, 0 VDC when the switch is closed.
5. "on" is displayed.
6. The magnetic hold down circuit is activated. 120 VAC across P23 & P35
7. Seal Time begins and activates the Front and Side seal SSR, which puts 120 VAC to transformer for cut off wires. 5 VDC across P10 - 2/3 for the front SSR and 5 VDC across P20 & P16 for the side SSR. Seal Time is the time set in the operator controls.
8. Seal Time ends and deactivates the Front & Side SSR. Cut off wires have voltage removed.
9. Dwell Time begins. Dwell Time is the time set in the operator controls.
10. Dwell Time ends, deactivating the magnetic hold down circuit, allowing the L-Bar arm to rise.
11. The Cycle Start SW1 switch will open, activating the PTA motor circuit and PTA Time. 10-60 VDC across A1 & P40, voltage depends on Conveyor Speed setting in operator controls. PTA Time is the time set in operator controls. The Conveyor Speed setting will also cause the DC voltage across P11 & P15 to vary, voltage will be .6VDC at 1 to 2.60VDC at 10.
12. PTA Time ends and PTA motor circuit is deactivated.
13. "run" is now displayed. The L-Bar is now ready for the next package cycle.

