Quick Start Guide Press Control 70
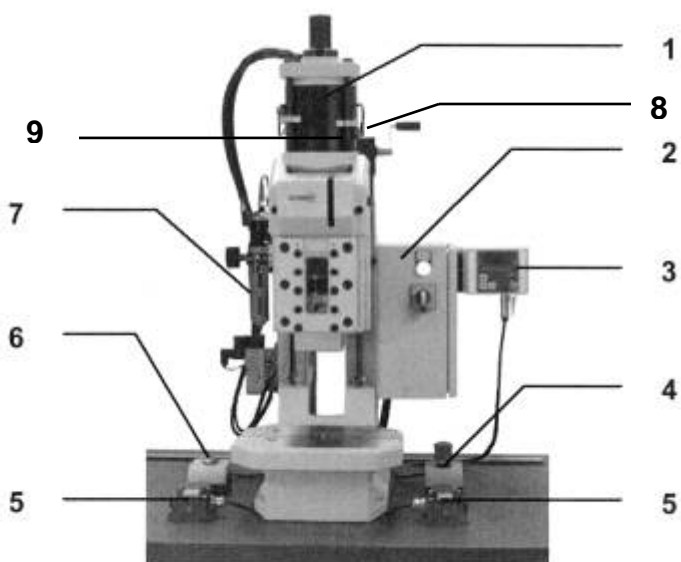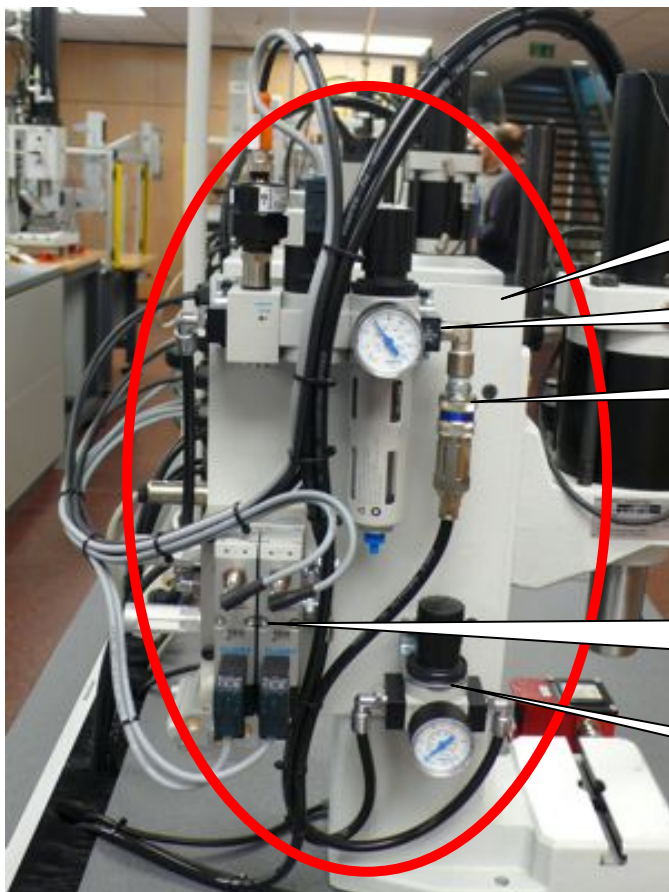
Press System with Safety Module

1. Press
2. Safety Module
3. PressControl 70
4. Emergency Stop Button
5. Two Hand Start Buttons
6. Fault Reset Button
7. Pneumatic Block
8. BDC sensor
9. TDC sensor

6. Pneumatic safety block. Size for a PP23 with service unit.

6.1. Service unit

6.2. Main Air Supply

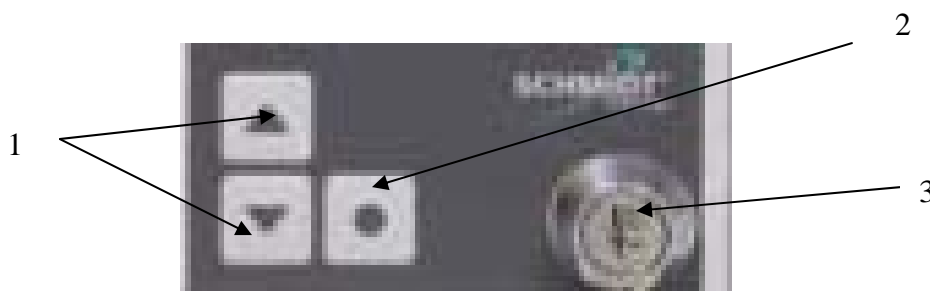6.3. Pneumatic valves with spool position switches for safety.

6.4. Force output pre-selector (Optional)

Operating elements

1. 7-segment display
2. Operational status indicator
3. Lock-out key switch
4. Keypad
5. Stroke takeover indicator

Operating elements

1. Arrow Keys
2. Apply / Enter Key
3. Lock-out key switch

Selection level	Press both arrow keys and set the key-operated switch to the vertical position at the same time ▲▼	
Setting level	Allow setting changes in vertical position	
Operation level	Settings cannot be changed in horizontal position	

Quick Start Guide Press Control 70

SETUP

1. Connect compressed Air; filtered, non-lubricated 80 – 130 psi

2. Connect electrical supply; 100 – 240 V, 50 / 60 Hz

3. Connect PRC70 to Safety Module

OPERATION

- Reset E-STOP (pull knob)
- Push ● >> Control & Air supply ON
- TDC sensor (ram retracted) must be ON
- BDC sensor must be within 0.25" / 6 mm from fully extended Ram position

- Check settings
     ▲Push (up arrow) repeatedly >> BDC timer (press dwell timer) and Cycle counter values will be displayed
- Change press timer (Operator's Manual page 19)
     1. Key switch ①
     2. Push ▲ until P04
     3. Push ●
     4. Push ▲ to change value
     5. Push ▼ to change digit (maximum: 999.99 seconds)
     6. Push ● when finished
     7. Key switch ⊖
     8. Check setting (see above)

- RESET Counter (Operator's Manual page 23)
     1. Key switch ①
     2. Push ▲ until P01
     3. Push ●
     4. Push ▲ until 'reset'
     5. Push ●
- Reset a Fault (Operator's Manual page 23)
     1. Push ●

Refer to Operator's Manual for:
- Presetable Batch Counter, page 23
- External signal for Ram return, page 22
- Setup mode, page 19
- Cycle Permissive (only allow press cycle when part in fixture), page 20
…. and more features

Quick Start Guide Press Control 70

Display Indication List

Status List
As the press executes a cycle, status will be displayed as follows:
I 000   Parts inquiry / permissive
I001   Slide table in working (press) position
I002   Active stroke, in progress
I003   External return stroke
I004   Ram dwell time
I005   Press cycle aborted
I006   Slide table in load position
I007   Parts inquiry OFF
I008   External return stroke
I009   Control OFF
I010   Setup mode active

Error code list
E001   Incomplete press cycle (two hand released too early, stroke not taken over, light curtain
            interrupted)
E002   Part inquiry / permissive (part is not present or has not been removed)
E003   External stroke return, ram does not retract
E004   Position error, slide table
E005   Parameter default set for fault while loading parameters
E006   Valve sensor of press valve 1
E007   Valve sensor of press valve 2
E008   Switching operation mode
E015   Operation mode PRC70 / Safety Module is different

Display errors
F009   Emergency Stop channel 1
F010   Emergency Stop channel 2
F011   Air supply fault (inadequate / lost supply)
F012   Protection area contaminated
F013   Safety Module not responding
F014   Pre-selection counter set to Zero

Fatal errors
Err01   24V supply failed
Err02   Used
Err03   TDC sensor does not respond
Err04   BDC sensro does not respond
Err05   Light curtain fault, Error UE470 – press ‚APPLY / ENTER' key
Err06   Valve Sensor of press valve 1 with lock out of Safety Module, static
Err07   Valve Sensor of press valve 2 with lock out of Safety Module, static
Err08   Valve Sensor of press valve 1 with lock out of Safety Module, dynamic
Err09   Valve Sensor of press valve 2 with lock out of Safety Module, dynamic