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OPERATING INSTRUCTIONS FOR RW COUNTER CHECK

SW VERSION 3.3

INDEX

INDEX	2
SYSTEM DESCRIPTION	3
FRONT PANEL DISPLAY	4
MENUS ORGANIZATION	5
LABELS COUNT MODE.....	6
REWINDER MODE	7
CONFIGURATION MENU	8
WORKING:.....	8
END OF PRODUCTION:	8
COUNT MODE:	8
STOP MISSING LABEL:	9
SPEED:	9
LABEL:	10
LANGUAGE:	11
ERRORS	11
CALIBRATION OF PHOTOCELL	11

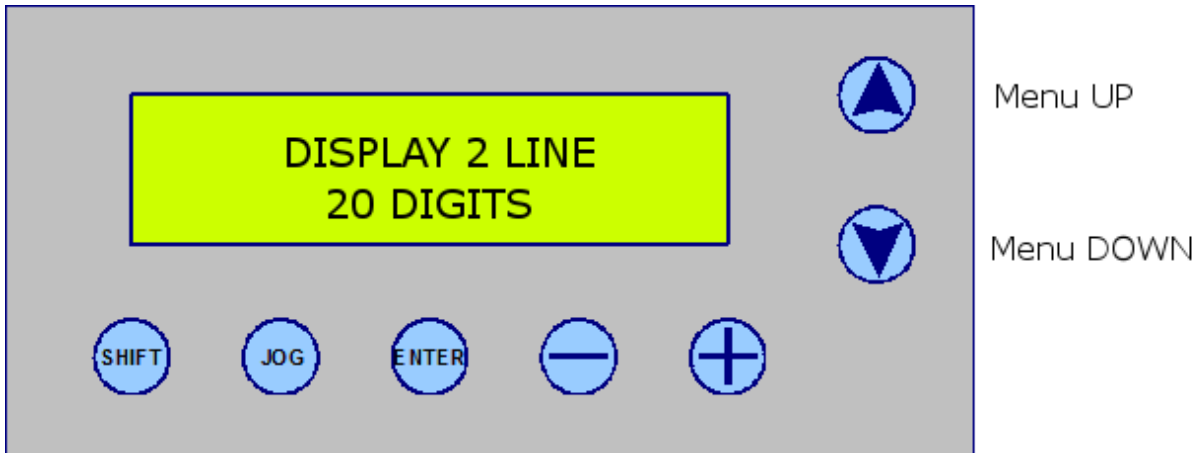
SYSTEM DESCRIPTION



- A) Unwinder
- B) Display
- C) Unwinder switch
- D) Rewinder switch
- E) Rewinder
- F) Photocell
- G) Brush
- H) Arm

FRONT PANEL DISPLAY

The panel comprises a display with 2 lines of 20 LCD digits and a keyboard with 7 keys.



To enter the **SETUP** menu press the **SHIFT** and **ENTER** keys. It is possible to scroll the different parameters by means of the **Menu UP** and **Menu Down** keys. To change a parameter, press the **ENTER** key. You thus enter the "Edit Mode" (this is also revealed by the flashing cursor): the values may be changed by means of the **Menu UP** and **Menu DOWN** keys. By pressing the **SHIFT** key and the **UP** and **DOWN** ones you can increment or decrement at a rate of 10. In case of end of production, this makes the cursor shift. In order to confirm the set value, press the **ENTER** key again to leave the "Edit Mode" and to store the set value. All set values are kept stored even with the unit switched off. To leave the **SETUP** menu and return to the **COUNT** or **REWINDER** mode press again the **SHIFT** and **ENTER** keys.

MENUS

The operational parameters are subdivided into 2 menus: the **COUNT** or **REWINDER** menu shows the unit state, the counted labels and the possible missing labels, while the **SETUP** one makes it possible to set the working parameters of the unit. By switching the unit on it is possible to enter the **SETUP** menu to set the parameters or to enter the **COUNT** or **REWINDER** mode to start the unit and the count of the labels.

The parameters that make up the **SETUP** menu are the following:

WORKING

LABELS COUNT / REWINDER

If WORKING is COUNT LABELS:

COUNT MODE

INCREMENTAL / DECREMENTAL

END PRODUCTION

NUMBER OF LABELS or NO end production

STOP MISSING LABEL

NO / 1 label / 2 labels

SPEED

manual with 7 speeds/automatic

DIRECTION

ext-ext / int-int / ext-int / int-ext

LANGUAGE

selected language

LABELS COUNT MODE

After switching the unit on, it is possible to start the count by pressing the **ENTER** key; the display will show the following messages:

STOP	JOG:START
0 /1000	LABELS

The numbers shown hereafter are used only as an example, and depend on the number of the counted and missing labels.

At this stage the unit is not working. By pressing the **JOG** key the unit starts off and with it also the count of the labels. The display shows the following message:

RUN	JOG: STOP
25 /1000	LABELS

While the unit is working, a new pressure on the **JOG** key makes the unit stop and the message of the display will change into:

STOP	JOG:START
3450/5000	LABELS

When the system is not working, by pressing the **UP** and **DOWN** keys the labels count will be set to zero to make a new start possible.

In case of a missing label or missing gap, the display will show the number of the missing labels(M),the number of missing gap(G) and the number of the counted labels.

STOP	JOG:START
3450/5000	4M 1G

When the number of the counted labels gets near the value set for the end of production (if other than 0), the system will slow down till the label that follows the one set for the end of production arrives under the photocell. The message on the display will be the following:

END PRODUCTION
10000 LABELS

Or if they had occurred error

END PRODUCTION
10000/1000 2M 1G

To leave this standstill state and restart operations, press the **ENTER** key; this will also reset the counters at zero .

If the roll ends before having reached the number set for the end of production (or when this is set at 0), the system will go on running for 1 second and then it will stop. The message on the display will be the following:

END ROLL
8735 2M 1G

To leave this standstill state and restart operations, press the **ENTER** key; this will also reset the counters at zero.

To start or restart the system does not report the presence of missing labels up to passage 6/7 labels beneath the photocell. Even at the end of production when it is the last 6/7 labels, the system will not report the lack of etiquette. This is 'because that the speed of scroll is varying due to the acceleration / deceleration, and 'control algorithm, it can not operate correctly.

REWINDER MODE

After switching the unit on, it is possible to start the count by pressing the **ENTER** key; the display will show the following messages:

STOP JOG:START

At this stage the unit is not working. By pressing the **JOG** key the unit starts off and with it also the count of the labels. The display shows the following message:

RUN JOG: STOP

While the unit is working, a new pressure on the **JOG** key makes the unit stop and the message of the display will change into:

STOP JOG:START

In this mode the photocell is inhibited and will not count the labels.

The machine in case of breakup or end of roll will stop after 5 seconds, the display showing the following message:

END ROLL

It is recommended, to obtain a good result on winding, support siliconised, assembly of external disk, of the Rings guide and of the brush (mounted with a light pressure on the support siliconised).

CONFIGURATION MENU

WORKING:

It allows to choose the mode of operation of the machine.

Pressing the key **Enter** he enters formality "*Edit Mode*" and and possible with the keys **UP** and **DOWN** to vary the formality of operation between **COUNT LABELS** or **REWINDER**.

A further pressure of the key Enter will determine the confirmation of the selected formality.

In the formality **REWINDER**, the voices of menù **END OF PRODUCTION**, **COUNT MODE** and **STOP MISSING LABEL** they are not available.

END OF PRODUCTION:

It shows the number of labels to be counted.

The system will stop when the label that comes after the set value arrives under the photocell (ex.: if the **END OF PRODUCTION** has been set at a value of 1000, under the photocell there will be label n. 1001).

When this parameter is shown on the display, press the **ENTER** key to enter the "*Edit Mode*". The cursor will flash next to the figure to be changed: this can be done by means of the **UP** and **DOWN** keys. It is possible to move the cursor to the left by pressing the **SHIFT** and **DOWN** keys, while by pressing the **SHIFT** and **UP** keys the cursor will move to the right.

A new pressure on the **ENTER** key will confirm the set value and make the system leave the "*Edit Mode*".

999999 is the highest figure that can be set for the **END OF PRODUCTION** parameter.

In the "*Edit Mode*", when pressing the **UP** and **DOWN** keys simultaneously the parameter value will be reset at zero, which also means the deactivation of the stop function at the end of the production.

A second pressure on the **ENTER** key will confirm the value and make the system leave the "*Edit Mode*".

COUNT MODE:

It shows the type of count that can be incremental or decremental.

When this parameter is shown on the display, press the **ENTER** key to enter the "*Edit Mode*", it is then possible to change the parameter value by means of the **UP** and **DOWN** keys.

If the **END OF PRODUCTION** parameter is set to the **NO** value, this parameter has a fixed value for the incremental count.

A new pressure on the **ENTER** key determines the confirmation of the set value and the exit from the "*Edit Mode*".

STOP MISSING LABEL:

The unit can check if there is a missing label on the roll. It is possible to set the system behavior in case this occurs.

- if this parameter is set at **NO**, the system will count the actual labels, will show how many are missing and the missing gap, but it will not enter into error state
- if this parameter is set at **1 Label**, the system will enter into error state when it occurs that 1 labels is missing. In this condition the display will signal the error with the message **ERROR MISSING LABEL** or **ERROR MISSING GAP** in case the error is due a to single missing gap. To leave the error state press the **ENTER** key to return to the **COUNT** mode
- if this parameter is set at **2 Labels**, the system will enter into error state when it occurs that 2 consecutive labels are missing on the roll. In this condition the display will signal the error with the message **ERROR 2 MISSING LABELS** or **ERROR 2 MISSING GAP** in case the error is due a two missing gap. To leave the error state press the **ENTER** key to return to the **COUNT** mode

To change this parameter press the **ENTER** key to enter the “Edit Mode”: when the parameter appears on the display make use of the **UP** and **DOWN** keys to change the value. A new pressure on the **ENTER** key will confirm the value and make the system leave the “Edit Mode”.

SPEED:

It allows the operator to choose the speed at which the unit must run.

There are 7 manual speeds and an automatic one: value 1 is the lowest speed while value 7 is the highest one. If the operator has set the manual mode and the system is in **COUNT** mode, it is possible to modify the speed without stopping the unit by pressing the the **Menu UP** key to get a speed increase or the **Menu DOWN** one to decrease it.

If the operator has decided for the automatic speed, the unit will run at its maximum speed only. On start off and stop of the system, the unit will automatically connect the ramps necessary for a flowing running with no jerks.

The system provides to slow down automatically when the speed of reeling, the latter exceeds the unwinding speed of the unwinding section.

For a change of this parameter, press the **ENTER** key to enter the “Edit Mode”; when the parameter is shown on the display, make use of the **UP** and **DOWN** keys to change the value. A new pressure on the **ENTER** key will confirm the value and make the system leave the “Edit Mode”.

LABEL:

This function allows the operator to decide the rotation direction of the labels on the unwinder and on the rewinder. The flowing direction of the labels is always from the left, where the unwinder is, to the right where the rewinder is placed. With this function it is possible to handle rolls having the labels face in or face out and to rewind them in the same way or in the opposite one.

The left part of the display refers to the unwinder while the right one refers to the rewinder. The following running operations are possible:

←EXT ETI EXT→

The unwinder will run clockwise and will unwind rolls with the labels face out.

The rewinder will run clockwise and will rewind the labels face out.

←INT ETI INT→

The unwinder will run anti-clockwise and will unwind rolls with the labels face in.

The rewinder will run anti-clockwise and will rewind the labels face in.

←EXT ETI INT→

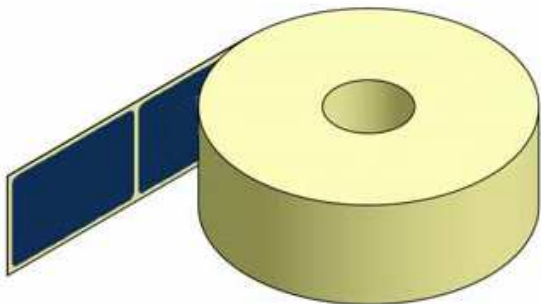
The unwinder will run clockwise and will unwind the rolls with the labels face out.

The rewinder will run anti-clockwise and will rewind the labels face in.

←INT ETI EXT→

The unwinder will run anti-clockwise and will unwind the rolls with the labels face in.

The rewinder will run clockwise and will rewind the labels face out.



**Label
face in**



**Label
face out**

To change this parameter press the **ENTER** key to enter the “Edit Mode”; when the parameter appears on the display, make use of the **UP** and **DOWN** keys to change the value. A new pressure on the **ENTER** key will confirm the value and make the system leave the “Edit Mode”.

LANGUAGE:

To modify this parameter press the **ENTER** key to enter the "*Edit Mode*"; when the parameter appears on the display make use of the **UP** and **DOWN** keys to change the value. A new pressure on the **ENTER** key will confirm the value and make the system leave the "*Edit Mode*".

ERRORS

The system can go in error, also, in the following cases:

- the departure, for more than 2 seconds do not pass labels under the photocell.
- The photocell remain obscured by a label.
- The photocell NOT CORRECTLY calibrated or working.

In this case, the display will give the following error message:

ERROR
RESET: ENTER

CALIBRATION OF PHOTOCELL

place under the photocell a label and clockwise or outlet the potentiometer to regulate place on the body of photocell, until the LED of presence label does not turn on. After that position under the photocell the gap (the only support siliconised without a label) and turn the potentiometer in a manner contrary to what was previously, until the LED of presence label has not turned off. Once the LED is off turn the potentiomer for 2 laps