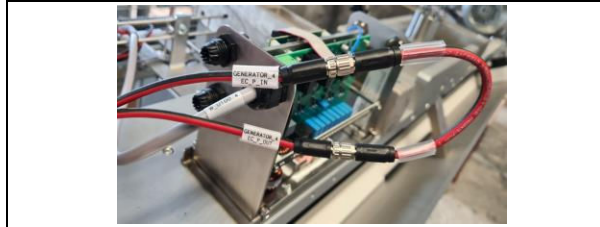
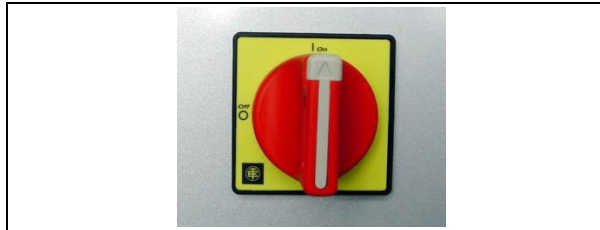


7.8 Bridge generator in case of failure



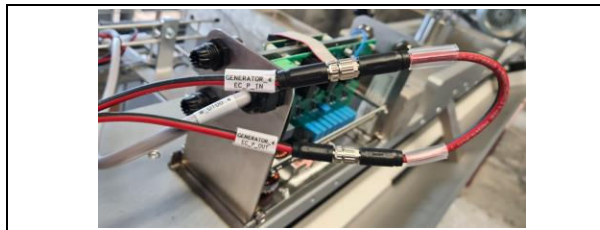
If a generator fails, production can be continued by bridging the generator.

7.8.1 Bridging the generator



WARNING

The machine must be completely switched off before bridging the generator!
Completely switched off means the main switch must be locked and secured in the left (or 0) position.



Disconnect both EtherCAT P cables from the generator and connect them with the supplied bridging cable.

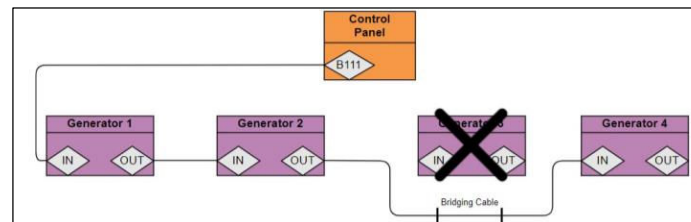
Then unplug the power cable "W_100.xxx" first from the corresponding terminals in the control cabinet.
After that, it can also be disconnected from the generator.

7.8.2 Re-supply EtherCAT P junction



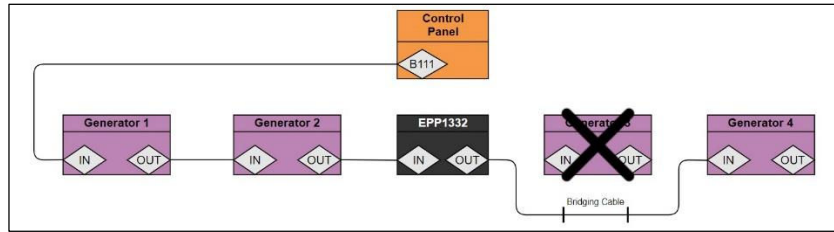
If more than approx. 5 generators are serially connected, a re-supply EtherCAT P junction (EPP1332) is connected in between.

Depending on which generator failed, the position of the re-supply junction must be adjusted.



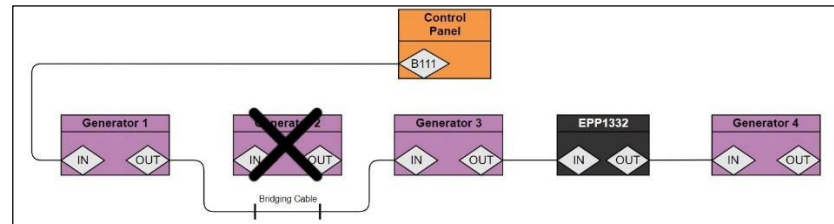
Generator failure without re-supply junction:

No adjustment necessary



Generator failure after re-supply junction:

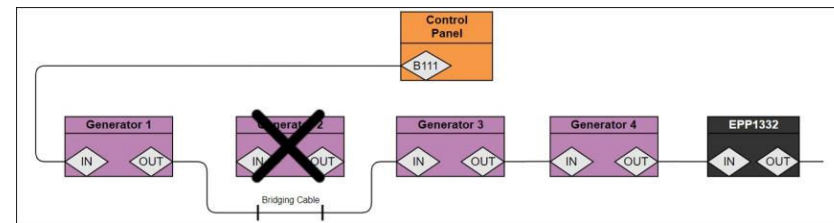
No adjustment necessary



Generator failure before re-supply junction:

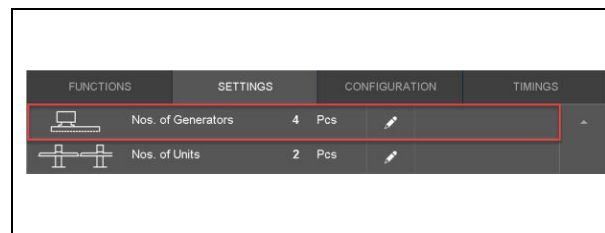
Adjustment necessary.

There must be the same no. of generators before the re-supply junction as there were before the failure.



If, for example, the junction was between generator 3 and 4, the junction must be displaced between generator 4 and 5.

7.8.3 Adjust settings after bridging



Adjust the No. of generators in the service area.

Refer to [chapter 4.5.2.](#)



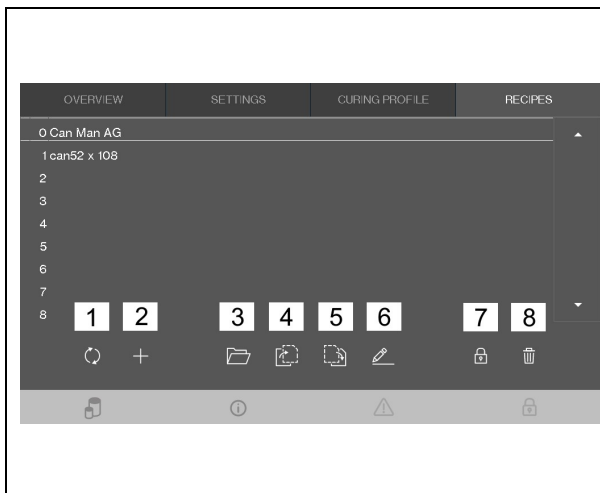
Deselect the bridged generator in the configuration tab in the service area.

Refer to [chapter 4.5.3.](#)



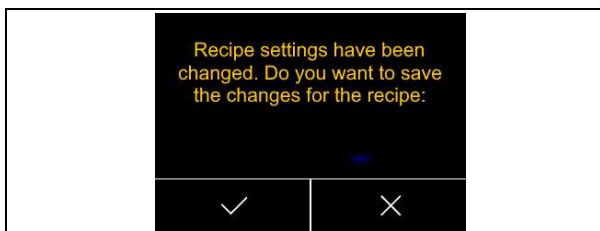
NOTE

Locked recipes are marked with a "★" symbol.



When logged in, the following functions are available:

- 1 Save (all changes are saved to the active recipe)
- 2 New (create a new recipe)
- 3 Load recipe
- 4 Copy (the selected recipe is copied)
- 5 Paste (the copied recipe is pasted as a new recipe)
- 6 Rename recipe
- 7 Lock / unlock (locked recipes cannot be modified)
- 8 Delete recipe



If you have adjusted values in the settings ([chapter 4.4.](#)) and switch to the recipes tab, a pop-up window shows up.

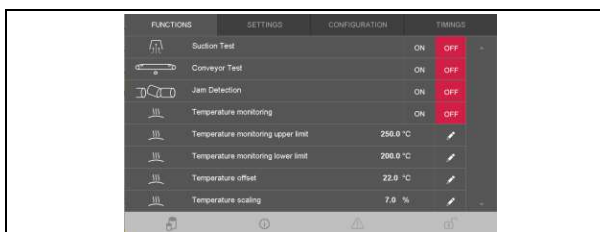
By tapping "✓" the changes are saved directly to the active recipe.

4.5 Service area (login level 1)

4.5.1 Test functions



Tap on this symbol to log in and get access the service area.



The functions available here are very helpful to carry out different trials or in error identification.



	Suction Test	ON	OFF
	Conveyor Test	ON	OFF
	Jam Detection	ON	OFF

Suction Test:
Starts / stops the fume extraction.
For fume extraction refer to [chapter 5.1.3](#).

Conveyor Test:
Starts / stops the conveyors.
Belt run and belt speed can be tested.
Refer to [chapter 5.4](#)

Jam Detection:
Enables / disables the jam sensor.
Refer to [chapter 5.5.1](#).

	Temperature monitoring	ON	OFF
	Temperature monitoring upper limit	250.0 °C	
	Temperature monitoring lower limit	200.0 °C	
	Temperature offset	22.0 °C	
	Temperature scaling	7.0 %	

Temperature Sensor (optional):
Different settings for the temperature sensor.
Refer to [chapter 5.5](#) to set the sensor correctly.

4.5.2 Service settings

	Nos. of Generators	1	Pcs	
	Nos. of Units	1	Pcs	

In this window, the number of 3m units, as well as the number of generators can be set.

These settings must be identical to the configuration of your system.

If a generator is added or removed, the settings must be adjusted.

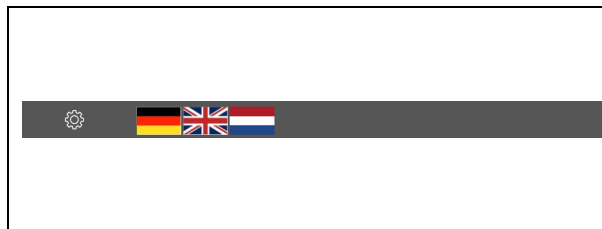
NOTE
The "Nos. of Generators" in the settings only apply to the generators installed on the PowerCURE.
If a pre-heating generator is installed on the exit conveyor of the welder, it must not be added to this value!

	Preheating Coil	ON	OFF
	Lift ON / OFF	ON	OFF

If there is a pre-heating generator on the exit conveyor of the welder, the function "Preheating Coil" must be activated.

If the first module is equipped with a lift unit, the function "Lift ON / OFF" must be activated.

Change of language



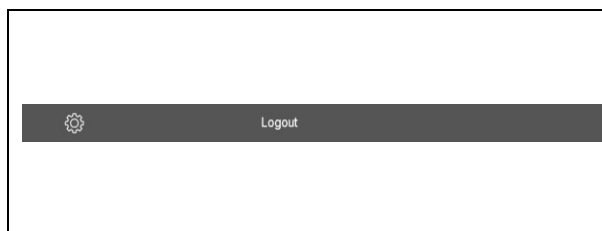
The language can be changed by tapping on the flag symbol.

Change of time and date



Time and date can be adjusted as well by tapping on the text symbols.

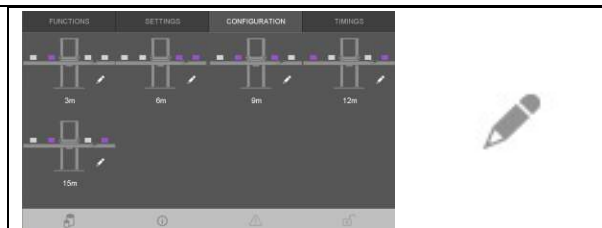
Logging out



There are different ways to log out:

- Automatic logout is set to 10 minutes. (Factory setting)
- You can manually log out by tapping on Logout.

4.5.3 Configuration

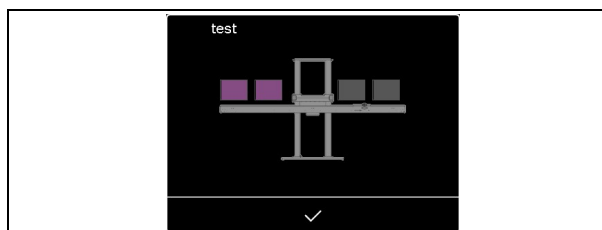


In this window the actual configuration of the PowerCURE is shown.

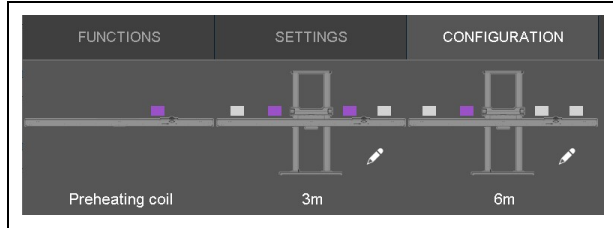
To adjust the number and position of generators, tap on the pencil symbol.

NOTE

The selected configuration must correspond to the values of the settings in [chapter 4.5.2](#) and the installed curing system.



In the pop-up window the number and position of the generators on each 3m unit can now be selected.



If the function "Preheating Coil" is activated, an additional module (exit conveyor welder) with an additional generator is shown.

4.5.4 Timings

	Suction OFF Delay	2.0 min	
	Welder to PowerCure	0.0 sec	

The following parameters can be set in the tab "Timings":

Suction OFF Delay:
Time how long the fume extraction keeps running after production is stopped.

Welder to PowerCure:
Time how long the coil continues heating after production is stopped.

The value corresponds to the time a canbody needs to get transported from the downstacker of the welder to the entry of the PowerCure.

4.6 Start / Stop signals

NOTE
The start / stop of production is controlled by 2 signals connected to the welding machine.

NOTE
Refer to the electrical diagram in [chapter 12.1](#)

Enable main switch (MS) ON/OFF
Enable curing (HF) ON/OFF
Error signal

Enable Main switch (MS):

- X150_154
- X150_155

Enable curing (HF):

- X150_156
- X150_157

Error signal:

- X150_158
- X150_159