WSJ700 YHKJ LCD hot stamping machine operating instructions Manual

1、 Power-on:

Power-on process: 8.8.8/8.8.8 (including all lights on) about 1 second ----, inp /K U0-XX (U0 is the version number, XX is the time mode) about 2.5 seconds, SCH/SCL about 2.5 seconds

Key Description:

The leftmost reset counting key, press for more than 1 second to reset the current counting value

The second is the function key, the third is the minus key, and the far right is the plus key

2、 Parameter Description

1. User parameters

In the normal measurement and control state, press the setting button to enter the user control target value setting. Press the setting button again to complete the setting.

code name	Parameter meaning	illustrate	Set range	Defaults
SV and ST indicators are on	Heating temperature and stamping time setting	The upper row flashes to indicate the set temperature The lower row flashes to set the hot stamping time	SCL---SCH 0---999	150℃ 5

2. Engineer parameters

Press and hold the SET button for 3 seconds to enter the state of engineer parameter setting. To exit, press the SET button for 3 seconds. To set the next parameter, press the SET button once. It will automatically exit after about one minute without pressing any key.

code name	Parameter meaning	illustrate	Set range	Defaults
AL1	first alarm	There are 12 alarm methods, which are decided by OP1.	-1999℃-9999℃	20℃
P	proportional band	If it is 0, it is bit control, and the I and D menus will not be displayed at this time, but the OH and OHH menus will be displayed.	0℃-999℃	30℃
I	Integration time constant	If it is zero, the integral control function is cancelled.	0-3600 seconds	240 s
D.	Differential time constant	If set to zero, the differential effect is cancelled.	0-3600 seconds	60s
AR	Integral limiter	Used as integral limiter	0-100	100
ATU	self-tuning switch	off: turn off; on: turn on	On /off	off
Oh	Bit control	PV>(SP+OHH) control output off		
OHH	bit control	PV<(SP-OH) controls to open the output		
T	control cycle	The action cycle of the main control	1-99 seconds	20s
SC	Display value correction amount	Make the displayed value = Pb value + internal measurement value;	-50℃-50℃	0℃

Lck	parameter lock	=0 SV and all engineer parameters can be set =1 only SV and time can be set =0ther SVs and all parameters cannot be set =8 cooperates with combination keys. =911 restore factory default =199 Quick access to modify factory parameters =190 Quick access to modify stamping parameters =192 Quick access to modify counting parameters	0-full scale	0

3. Manufacturer parameters

At LCK= 199, press the Set key again to enter the following menu,

code name	significance	other instructions	scope	Defaults
SL1	Select sensor input signal	= 0 K = 1 J = 2 R = 3 S = 4 B = 5 E = 6 N = 7 T = 8 PT100 = 9 CU50 = other selected		K
Uint	Celsius Fahrenheit	=0 degrees Celsius =1 degree Fahrenheit		00
DP	decimal point	When INT is PT100 or CU50, DP=1 will display with decimal point		0
DF	filter coefficient	The larger the coefficient, the deeper the filter and the smoother the display, but the	0--250	200

		response is slower		
OP1	First alarm alarm mode selection	**See the alarm method description table**	0-16	1
AH1	The first alarm relay switching difference	Poor alarm relay switching	0-200	1
SCH	Upper limit of measuring range		-1999-9999	0
SCL	Lower limit of measuring range		-1999-9999	400
KEY	Built-in buzzer control mode			
dY	Temperature tracking volume	Make the displayed temperature close to the set value within the range of set value ±dEYT	0 — 20.0	0.6

3.1 The meaning of the parameters in the alarm mode description form (OP1 and OP1)

O p1	significance
0	No alarm, AL1, AL2 menu will not be displayed by default
1	Upper limit deviation alarm
2	Lower limit deviation alarm
3	Alarm outside the upper and lower limit deviation
4	Alarm within upper and lower limit deviation
5	Lower limit absolute value alarm
6	Upper limit absolute value alarm
11	Upper limit deviation alarm with hold
12	Lower limit deviation alarm with hold
13	Upper and lower limit deviation alarm with hold
14	Alarm within upper and lower limit deviation with hold
15	Lower limit absolute value alarm with hold
16	Upper absolute value alarm with hold

4. Setting parameter description

5. Description of hot stamping parameters

LCK= 190 , press the set key to enter the following menu:

code name	significance	other instructions	scope	Defaults
RUS	timing direction	The switch starts the timing direction, forward and reverse timing in minutes. =0 Countdown is counting down or counting down by 1 =Other positive timings add 1 to the timing	0---3	0
OTC	advance alarm time	When the countdown time minus one equals the OTCN time, the built-in buzzer sounds for the OTCN time	0 — 250 seconds	0
MS	time unit	=0, minus one time unit is second When =2, minus one time unit is 0.1 second =1 minus one time unit is minute	0-3	0

		= 3 hours minus one time unit is 0.1 minutes		
OTS	Hot stamping type	=0: The switch is closed, the countdown is displayed, and the countdown is 0, The time relay picks up, the internal buzzer sounds, and a Wait until the switch is turned off or delay T2oF time After the relay is released, the buzzer does not sound. operation completed; =1: switch closed, display countdown, time relay Pull in, the countdown is 0, the relay releases, the bee The buzzer will sound until the switch is turned off. No sound, one operation is completed; =3: The jog switch input starts the countdown, the countdown is 0, the relay pulls in, and the buzzer sounds at the same time, wait until the jog switch is input again or after a delay of T2oF, the relay is released and the buzzer does not sound, and one operation is completed; =4: The jog switch input starts the countdown, the relay pulls in, the countdown is 0, the relay is released, and the buzzer sounds at the same time, wait until the jog switch input again, the buzzer does not sound, and one operation is completed; =5: The jog switch input starts the countdown, the countdown is 0, the relay pulls in, and the buzzer sounds at the same time, one operation is completed, and the relay is released and the buzzer is not released until the next jog switch input is started or after a delay of T2oF no sound; =6: The inching switch input starts the countdown, the relay closes, the countdown is 0, the relay releases, the buzzer sounds, and one operation is completed. When the next inching switch input starts, the relay closes again and the buzzer stops . ring; =15: High and low temperature control, when the temperature is lower than the set low temperature, there is an output, when it rises to the set low	0---17	0

		temperature, there is no output, when the switch closing temperature is lower than the high temperature set value, there is an output, when it rises to the high temperature set value, there is no output, and the countdown starts; =16 Jog button start, jog time plus key, display Indicates the countdown, the countdown is 0, the time relay Pull in, the internal buzzer sounds, wait for another click Press the button, the relay will be released, and the buzzer will No sound, one operation is completed; =17: Jog button start, jog time plus key , display Indicates the countdown, the time relay is closed, and the countdown When it is 0, the relay releases, the buzzer sounds, etc. The buzzer will not sound until the button is turned on again. One operation is completed; =other useless		
OSH	Pyrometer	Useful when OTSY=15, when the measured temperature reaches OSH, it will start as a timer	00---SCH	200
OSL	Low temperature start	It is valid when OTSY=15, and the start switch is valid when the measured temperature reaches OSL	00---SCH	50
OTM	Built-in buzzer prompt type	OTM * 10 M s, when =30, the countdown end buzzer will turn on and off at a frequency of 0.3 seconds. It is recommended to set it to 60 if necessary. =0 means long ringing	0---100	00
dE	Start TK delay	Switch input delay time, up to 300 milliseconds, up to Short 10 milliseconds, default 20 which is 200MS	0--30	0

6. Description of counting parameters

LCK= 192 , press the set key to enter the following menu:

code name	significance	other instructions	scope	Defaults
cod	spare		0---3	0
coh	spare		0 — 999	0

K	Clear accumulated password	=120, after displaying ADD, you can press and hold the reset key to clear the accumulated number	0---999	0
add	current accumulative count	It is the current accumulated number, the time window is the upper three digits, and the counting window is the lower five digits, the maximum is 999 99999	When CoK=120, you can press the clear key Clear	0
CT	Window selection	=0The counting window displays the current counting value =0ther counting windows display the SP setting value	0-3	0
coy	Power-on count selection	=1 Power-on clear count value (start counting from 0) =0ther power-on starts counting from the power-off count value	0--3	1
SLP	sleep settings	=0, no sleep function, =30 If there is no operation within 30 minutes, it will sleep with a black screen	0---999 Unit minutes	0
T2S	spare			