HOT STAMPING MACHINE INSTRUMENT DATA V1

One、 Power on:

Display: upper row: InP lower row C / F – K, delay two or three seconds, the upper row displays SLH and the lower row displays SLL

Menu Description: SV indicates hot stamping time and PV indicates measured value

Two、 Parameter description

1、User parameters

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

Code	Parameter meaning	Explain	Set range	Default value	Display condition
SV and ST indicators are on	Setting of heating temperature and hot stamping time	When SV light is on, the upper row indicates the set temperatureThe lower row of St light indicates that the hot stamping time is set	SCL---SCH 0---9999	150℃ 5	

2、Engineer parameters

Press and hold the setting key for 3 seconds to enter the engineer parameter setting status. To exit, press the setting key for 3 seconds. To set the next parameter, press the setting key once. No key is pressed, and it will exit automatically after about one minute.

Code	Parameter meaning	Explain	Set range	Default value	Display condition
AL1	First alarm	There are 12 alarm modes, which are determined by OP1.	–1999℃–9999℃	20℃	OP1!=0
P	Proportional band	If it is 0, it is bit control, and I and D menus will not be displayed at this time, but oh and ohh menus will be displayed.	0℃–999℃	30℃	
I	Integral time constant	If it is zero, the integral control function is cancelled	0–3600 seconds	120s	P != 0
D	Differential time constant	If it is set to zero, the differential action is cancelled	0–999 seconds	40s	P != 0
AR	Integral limiting	For integral limiting	0–100℃(	1℃	P != 0
AT	Self setting switch	Off: off; On: on	On/off	off	P != 0
OH	Bit control	PV > (SP + ohh) control output off			(when p = 0)
OHH	Bit control	PV < (sp–oh) control on output			(when p = 0)
T	Control cycle	Action cycle of main control	1–99 seconds	20s	P != 0
Pb	Display value correction	Make the displayed value = Pb value + internal measured value;	–50℃–50℃	0℃	1
LCK	Parameter lock	=0 SV and all Engineer parameters can be set =1 only SV and time can be set =Other SVS and all parameters cannot be set =911 factory reset =190 quick access to modify manufacturer parameters =191 quick access to modify hot stamping parameters	0 – full range	0	

3、Manufacturer's parameters

Code	Significance	Explain	Set range	Default value	Display condition
INP	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	INP
CF	Celsius Fahrenheit	=0 ℃ =1 °F		00	
DP	Unitdecimal point	When int is PT100 or cu50, DP = 1 is displayed with decimal point		0	
DF	Filter coefficient	The larger the coefficient, the deeper the filtering, the smoother the display, but the slower the response	0--250	200	
OP1	First alarm mode selection	See the alarm mode description table	0-16	1	1
AH1	Poor switching of the first alarm relay	Poor switching of alarm relay	0-200	1	1
SLH	Upper range limit		-199-999	0	1
SLL	Lower range limit		-199-999	400	1
dTT	Temperature tracking quantity	Make the display temperature close to the set value within the range of the set value ± TT	0—25.0	0.1	dTT
FAC	Overtemperature display suppression	=0 turn off functionEqual to other values. After exceeding the set value, the exceeding part is displayed in proportion, and the displayed value = SV + (pv–sv) / fac	0--250	0	

3.1 Significance of parameters in alarm mode description table (OP1 and OP1)

Value of AL1T / AL2T	Significance
0	No alarm, AL1 and AL2 menus will not be displayed by default
1	Upper limit deviation alarm
2	Lower limit deviation alarm
3	Upper and lower limit deviation external alarm
4	Alarm within upper and lower limit deviation
5	Lower absolute value alarm
6	Upper absolute value alarm
11	Upper limit deviation alarm with hold
12	Lower limit deviation alarm with hold
13	External alarm of upper and lower limit deviation with hold
14	Upper and lower limit deviation alarm with hold
15	Lower absolute value alarm with hold
16	Upper absolute value alarm with hold

5、Hot stamping parameter description

Code	Significance	Explain	Set range	Default value
OTC	Advance alarm time	When the minus one countdown time is equal to the OTC time, the built-in buzzer rings the OTC time	0—250 S	0
SCT	Lower row digital display mode	= 0, the setting time or countdown time is displayed in normal state, and the parameter value is displayed when setting parameters. = display the SV temperature setting value in other normal states, display the countdown time after starting the timing, and display the parameter value when setting the parameters.	0——3	0
ToF	Time output type	When the time relay (buzzer) pulls in the output after the countdown the function is effective and turns off after delaying TOF time = 00, pull in until the start switch is disconnected = 100, it will be output at an interval of 0.5 seconds until the start switch is turned off = 104, it will output intermittently for 4 seconds in 0.5 seconds, that is, it will be disconnected after 4 sounds = 003, it will be output for 4 seconds and then disconnected	0—199 S	00
M-S	Time unit	=0 minus one time in seconds =1 hour minus 1 time unit is 0.1 second =2 / 3 hour minus one time unit: minute	0-3	0
OTS	Hot stamping type	=0: when the switch is closed, the countdown is displayed. The countdown is 0. The time relay is pulled in and the internal buzzer rings. The relay is released and the buzzer does not ring until the switch is disconnected. One operation is completed; =1: When the switch is closed, the countdown is displayed, the time relay is engaged, the countdown is 0, the relay is released, and the buzzerThe buzzer rings until the switch is disconnected, and the buzzer does not ring until one operation is completed; =7: When the head is powered on, it is judged that the measured value is greater than or equal to the set value, and the switch is closed effectively: the switch is closed, the countdown is displayed, the time relay is engaged, the countdown is 0, the relay is released, and the buzzer rings. The buzzer does not ring until the switch is disconnected, and one operation is completed. The switch is closed again to start the countdown and no longer judge the temperature value. =3: Jog the switch input to start the countdown. The countdown is 0. The relay is closed and the buzzer rings. When the jog switch input relay is released again and the buzzer does not ring, one operation is completed; =4: The jog switch input starts the countdown, the relay is closed, the countdown is 0, the relay is released, and the buzzer rings. When the jog switch input buzzer does not ring again, one operation is completed; =5: The inching switch input starts the countdown. The countdown is 0. The relay is closed and the buzzer rings. One operation is completed. When the next inching switch input starts, the relay is released and the buzzer does not ring; =6: The inching switch input starts the countdown, the relay is pulled in, the countdown is 0, the relay is released, the buzzer rings, and one operation is completed. When the next inching switch input starts, the relay is pulled in again and the buzzer does not ring;	0---17	0
		=15: High and low temperature control: when the temperature is less than the set low temperature, there is output, when it rises to the set low temperature, there is no output, when the switch is closed, the temperature is less than the high temperature setting value, there is output, when it rises to the high temperature setting value, there is no output, and the countdown starts; =16. Jog the key to start, jog the time and add the key to display the countdown. The countdown is 0. The time relay is closed, and the internal buzzer rings. Wait for the key to be jogged again, the relay is released, the buzzer does not ring, and one operation is completed; =17: Jog the key to start, jog the time plus key to display the countdown, the time relay is engaged, the countdown is 0, the relay is released, the buzzer rings, wait for the key to start again, the buzzer does not ring, and one operation is completed;=Other useless		
OSH	High temperature timing	It is useful when OTS = 15. It turns on when the measured temperature reaches Osh, such as timing	00---SCH	200
OSL	Low temperature start	It is useful when OTS = 15. When the measured temperature reaches OSL, the start switch is effective	00---SCH	50
OTM	Built in buzzer prompt type	OTM * 10ms, when = 30, the countdown ends, and the buzzer turns on and off at the frequency of 0.3 seconds. It is recommended to set it to 60 if necessary= 0 makes a long sound	0---100	00
OTA	Temperature prompt time	After power on, when PV > = SV time, the buzzer rings and OTA time is 0, there is no such function	00---30 S	00

烫印机仪资料 V1

一、 上电：

显示：上排：inp 下排 C/F –K ˙延时二三秒，上排显示 SLH ，下排显示 SLL

菜单说明：SV 表示烫印时间，PV 表示测量值

二、 参数说明

1. 用户参数

在正常测控状态下，按一下设定键，便可进入用户控制目标值设定。再按一下设定键，设定完毕。

代号	参数含义	说 明	设置范围	默认值	显示条件
SV 和 ST 指示灯亮	加热温度和烫印时间设置	SV 灯亮上排表示设置温度 ST 灯亮下排表示设置烫印时间	SCL—SCH 0—9999	150℃ 5	

2. 工程师参数

按住设定键 3 秒钟，便可进入工程师参数设定状状，若要退出 则按设定键 3 秒钟，若要设定下一参数，则按设定键一次。无任何按键按下约一分钟后自动退出。

代号	参数含义	说 明	设置范围	默认值	显示条件
AL1	第一报警	有 12 种报警方式，具体由 OP1 决定。	-1999℃-9999℃	20℃	OP1!=0
P	比例带	若为 0，为位式控制，且此时不会显示 I、D 菜单，但会显示 OH 和 OHH 菜单。	0℃-999℃	30℃	
I	积分时间常数	若为零，取消积分控制作用	0-3600 秒	120s	P != 0
D	微分时间常数	若设定为零，取消微分作用	0-999 秒	40s	P != 0
AR	积分限幅	作积分限幅使用	0-100℃(	1℃	P != 0
AT	自整定开关	off：关闭； on：开启	On/off	off	P != 0
OH	位式控制	PV>(SP+OHH)控制输出关闭			（P=0 时）
OHH	位式控制	PV<(SP-OH)控制打开输出			（P=0 时）
T	控制周期	主控制的动作周期	1-99 秒	20s	P != 0
Pb	显示值修正量	使显示值=Pb 值+内部测量值；	-50℃-50℃	0℃	1
LCK	参数锁	=0 SV 和所有工程师参数可被设置 =1 只有 SV 和和时间可被设置 =其它 SV 和所有参数不能被设置 =911 恢复出厂值 =190 快速进入修改厂家参数 =191 快速进入修改烫印参数	0-全量程	0	

3. 厂家参数

代号	意义	其它说明	范围	默 认 值	显示条件
INP	选择传感器输入信号	=0 K =1 J =2 R =3 S =4 B =5 E =6 N =7 T =8 PT100 =9 CU50 =其它 选定		K	INP
CF	摄氏华氏单位	=0 摄氏度 C =1 华氏度 F		00	
DP	小数点	当 INT 为 PT100 或 CU50 时 DP=1 则带小数点显示		0	
DF	滤波系数	系数越大，滤波越深，显示越平稳，但反应较慢	0--250	200	
OP1	第一报警报警方式选择	**见报警方式说明表格**	0-16	1	1
AH1	第一报警继电器切换差	报警继电器切换差	0-200	1	1
SLH	量程范围上限		-199-999	0	1
SLL	量程范围下限		-199-999	400	1
dTT	温度跟踪量	使得显示温度在设定值±Tt 的范围内向设定值靠近	0—25.0	0.1	dTT
FAC	超温显示抑制	=0 关闭功能 等于其它值，超过设定值后超过部分按比例显示，显示值=SV+(PV-SV)/FAC	0--250	0	

3.1 报警方式说明表格(OP1 与 OP1)参数的意义

AL1T/AL2T 的值	意义
0	无报警，默认情况下不会出显 AL1,AL2 菜单
1	上限偏差报警
2	下限偏差报警
3	上下限偏差外报警
4	上下限偏差内报警
5	下限绝对值报警
6	上限绝对值报警
11	带保持的上限偏差报警
12	带保持的下限偏差报警
13	带保持的上下限偏差外报警
14	带保持的上下限偏差内报警
15	带保持的下限绝对值报警
16	带保持的上限绝对值报警

5. 烫印参数说明

代号	意义	其它说明	范围	默认值
OTC	提前报警时间	当减一倒计时时间等于 OTC 时间时内置蜂鸣器响 OTC 时间	0—250 秒	0
SCT	下排数码显示方式	=0 正常状态下显示设定时间或倒计时时间，设置参数时显示参数数值。 =其它 正常状态下显示 SV 温度设定值，启动计时后显示倒计时时间，设置参数时显示参数数值。	0——3	0
ToF	时间输出类型	当倒计时结束后时间继电器（蜂鸣器）吸合输出时该功能有效，延时 TOF 时间后断开 =00 时则吸合直到启动开关断开 =100 时则一直以 0.5 秒间隔输出直到启动开关断开 =104 时则以 0.5 秒断续输出 4 秒即 4 声后断开 =003 时则一直输出 4 秒后断开	0—199 秒	00
M-S	时间单位	=0 时减一时间单位为秒钟 =1 时减一时间单位为 0.1 秒钟 =2/3 时减一时间单位为分钟	0-3	0
OTS	烫印类型	=0：开关闭合，显示倒计时，倒计时为 0，时间继电器吸合，内部蜂鸣器响，一直等到开关断开，继电器才释放，蜂鸣器才不响，一次操作完成； =1：开关闭合，显示倒计时，时间继电器吸合，倒计时为 0，继电器释放，蜂器响，一直等到开关断开，蜂鸣器才不响，一次操作完成； =7：头上电判断测量值大于等于设置值后开关闭合有效:开关闭合，显示倒计时，时间继电器吸合，倒计时为 0，继电器释放，蜂器响，一直等到开关断开，蜂鸣器才不响，一次操作完成。开关再次闭合启动倒计时不再判断温度值。 =3：点动开关输入启动倒计时，倒计时为 0，继电器吸合，同时蜂鸣器响，等到再次点动开关输入继电器释放和蜂鸣器不响，一次操作完成； =4：点动开关输入启动倒计时，继电器吸合，倒计时为 0，继电器释放，同时蜂鸣器响，等到再次点动开关输入蜂鸣器不响，一次操作完成； =5：点动开关输入启动倒计时，倒计时为 0，继电器吸合，同时蜂鸣器响，一次操作完成，等到下次点动开关输入启动时，继电器才释放和蜂鸣器不响； =6：点动开关输入启动倒计时，继电器吸合，倒计时为 0，继电器释放，蜂鸣器响，一次操作完成，等到下次点动开关输入启动时，继电器又再次吸合和蜂鸣器不响； =15：高低温控制，当温度小于设定低温有输出，升到设定低温无输出，开关闭合温度小于高温设定值，有输出，升到高温设定值无输出，开始倒计时； =16 点动按键启动，点动时间加键，显示倒计时，倒计时为 0，时间继电器吸合，内部蜂鸣器响，等待再次点动按键，继电器才释放，蜂鸣器才不响，一次操作完成； =17：点动按键启动，点动时间加键，显示倒计时，时间继电器吸合，倒计时为 0，继电器释放，蜂鸣器响，等待再次启动按键，蜂鸣器才不响，一次操作完成； =其它 无用	0---17	0
OSH	高温计时	OTS=15 时有用，当测量温度到达 OSH 时开如计时	00---SCH	200
OSL	低温启动	OTS=15 时有用，当测量温度到达 OSL 时启动开关有效	00---SCH	50
OTM	内置蜂鸣器提示类型	OTM * 10Ms, 当=30 时，则倒计时结束蜂鸣器以 0.3 秒为频率通断，需要时建议设置为 60。=0 则长响	0---100	00
OTA	温度提示时间	上电后当 PV>=SV 时间蜂鸣器响 OTA 时间 为 0 无此功能	00---30 秒	00