

TEXTILE COUNTER TC – 723 INSTRUCTION MANUAL

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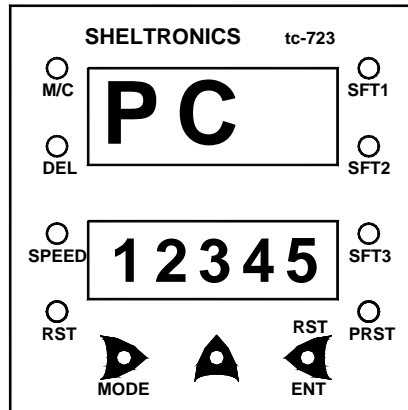
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TEXTILE COUNTER TC-723



LED INDICATION (FRONT FACIA DETAILS)

❖ M/C	⓪	MACHINE STATUS
❖ DEL	⓪	DELIVERY SENSOR STATUS
❖ SPD	⓪	SPEED SENSOR STATUS
❖ RST	⓪	RESET SENSOR STATUS
❖ SFT1	⓪	SHIFT 1 INDICATION
❖ SFT2	⓪	SHIFT 2 INDICATION
❖ SFT3	⓪	SHIFT 3 INDICATION
❖ PRST	⓪	PRESET LENGTH REACHED INDICATION

PARAMETERS TO BE SET

PRESS  KEY AND THEN PRESS  KEY TO SET THE FOLLOWING

PAS



PASSWORD TO RESET DATA

- 1111 ⓪ RESET FINAL COUNT
- 2222 ⓪ RESET PRODUCTION METER COUNT
- 3333 ⓪ RESET HOUR METER & EFFICIENCY
- 5555 ⓪ MASTER RESET



PASSWORD TO ALTER MACHINE/PRODUCTION FACTORS

- 1477 ⓪ TO ALTER PL1, PL2, SFT, CNT
- 2588 ⓪ TO ALTER PL1, PL2, SFT, CNT, F1 TO F8

PARAMETERS

PL1

⌘ PRESET COUNT (RL1 ON)

PL2

⌘ FINAL COUNT (RL2 ON)

SFt

⌘ SHIFT NUMBER IN WHICH TO OPERATE (1,2,3)

Cnt

⌘ COUNT DIRECTION
0 ⌘ DOWN COUNT
1 ⌘ UP COUNT

F1

⌘ NUMBER OF PULSES PER UNIT LENGTH

= $[1000 / (3.14 \times \text{Delivery Roller Dia in mm})] \times \text{NO OF PULSES PER REVOLUTION}$

F2

⌘ RESET SELECTION [0/1/2/3]

- 0 – (DEFAULT) RESET IS POSSIBLE ONLY THROUGH S2 INPUT (EXTERNAL RESET).
1 – RESET THROUGH EXTERNAL RESET S2 (EXTERNAL RESET) + ENTER/RESET KEY.
2 – RESET THROUGH S2 (EXTERNAL RESET) + AUTO RESET.
3 – ALL ABOVE 3 RESETS IS POSSIBLE.
4 – RESET THROUGH S2 (EXTERNAL RESET) + AUTO IMMEDIATE.

F3

⌘ SPEED CONSTANT

= $[\text{SPEED REQUIRED} \times \text{F3 VALUE}] / \text{SPEED DISPLAYED}$

F4

⌘ DELIVERY CONSTANT

= $[\text{DELIVERY REQUIRED} \times \text{F4 VALUE}] / \text{DELIVERY DISPLAYED}$

F5

⌘ TPI CONSTANT

= $[\text{TPI REQUIRED} \times \text{F5 VALUE}] / \text{TPI DISPLAYED}$

F6

⌘ PRODUCTION COUNT SELECTION VALUE FOR SHIFT COUNT
= 1.000 to display KM / 0.768 to display HANK

F7

⌘ TO SELECT DEFAULT DISPLAY

0 - FOR **PC** , 1 - FOR **SPD** , 2 - FOR **DLY**

F8*

⌘ FACTOR FOR MACHINE INTERLOCK TO STOP FOR OVER RUN SPEED OF LICKERIN / CYLINDER.
(OPTION FOR LICKERIN / CYLINDER SPEED MEASUREMENT)

VIEW PARAMETERS

DEFAULT DISPLAY

PC



PRODUCTION COUNT

DLY



DELIVERY RATE

SPD



SPINDLE SPEED, CYLINDER, LICKERIN SPEED.

PRESS



KEY TO VIEW THE FOLLOWING PARAMETERS

1Pr



1st SHIFT PRODUCTION

2Pr



2nd SHIFT PRODUCTION

3Pr



3rd SHIFT PRODUCTION

tPr



TOTAL PRODUCTION

1Hr



RUN HOURS 1st SHIFT, 2Hr, 3Hr, tHr

1dC



SHIFT DOFF 1st SHIFT, 2dC, 3dC, tdC

INSTALLATION

Set the number of pulses per unit length in parameter F1.

Set the unit for shift count (KM/HANK) in F6.

Set the count direction in Cnt.

Set the Speed constant, Delivery constant, TPI constant using the calculations given above.

Select the default display in parameter F7.

Select the Reset type in parameter F2.

OPERATION DETAILS

Production counter and shift counter count according to the set values in parameter F1 and F6.

Delivery rate is displayed in meters/min or yards/min according to F1.

Shift counting is based on the shift selected.

Production counter is cumulative.

Production counter value is reset to initial value at reset input.

At doff reached condition, predoff reached and doff reached indications are reset when Reset input is present.

Hour meter counts the machine on time upto 9999.9 hours.

Auto reset: when production counter reached to set value (count = up or down), Doff reached fault, production count, RL1, RL2 will be reset after 5 sec when no pulse from S4 input (Delivery pulse).

Auto reset (immediate) : when production counter reached to set value (count = up or down), Doff reached fault, production count, RL1, RL2 will be reset immediately.

FAULT INDICATION

DOF REACH

- ❖ Displayed when doff length is reached. Reset input clears the fault and resets the production count.

SPECIFICATIONS

POWER SUPPLY	:	60Vϕ270V 50-60 Hz 1 PHASE AC / DC
INPUTS	:	4 DIGITAL INPUTS (12 V)
OUTPUTS	:	3 RELAY OUTPUTS (5A/250V Rating)
PANEL CUTOUT	:	69 MM x 69 MM
DISPLAY	:	SEVEN SEGMENT LED DISPLAY