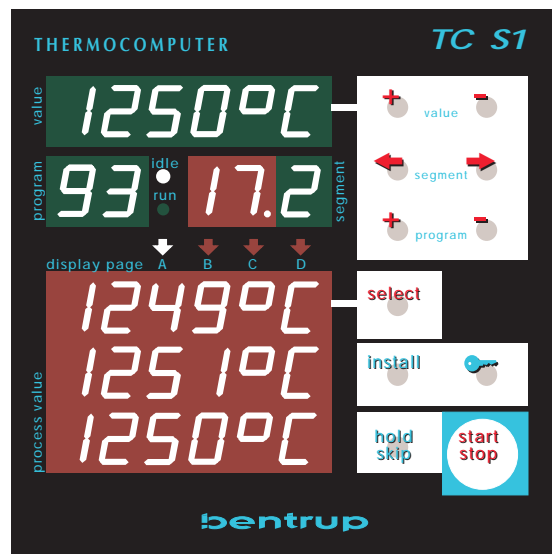


bentrup

Technical Manual



Universal Programmer

TC S1 (Version 7)

1. General Information

The bentrup TC S1 is a highly flexible control device. It provides a large number of tools like analog and digital inputs and outputs, as well as various communications which enable the user to setup a control units suitable for its applications.

The configuration defines all the TC S1 operation, ie. the controller structure (like number and operating mode of the control loops) as well as the operating parameters of each detail (like PID parameters of a control loop). The configuration further describes the input signals (thermo-couples, resistors, its input ranges etc.), output signals (analog or switching outputs for control or Alarm signals etc.), programme table parameters and appearance, which parameters to display on TC-S1 as number or graphic (allows to design the controllers screen fitting the actual kiln). Also critical event handling and programme flow is determined by the configuration.

If basic information is provided at the time of ordering the TC-S1, the configuration created by our engineers as far as possible and loaded into the controller ex work. Therefore the controller is ready for your application. However, it is the responsibility of the commissioning party to verify all settings and find the suitable according to the limits of the kiln resp. the application.

Some adjustments (like graphic charts) are just a matter of taste and therefore are set according to user requirements anyway.

Attention: The high grade of flexibility causes even small changes might have severe impact on controllers operation. Check the parameter description carefully or contact bentrup Technical Support if your are in doubt.

2. Adjusting the Configuration

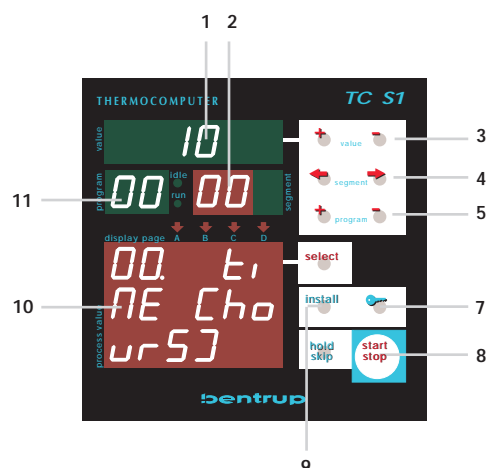
The configuration can be adjusted either on the TC S1 (via keypad) or by bentrup WinConfig (requires a Windows PC; requires "Passive Converter Cable" available from bentrup to setup physikal communication between standard serial port (RS232) and TC-S1 (RS485).

Although basically all changes can be done on TC-S1 itself or WinConfig, we recommend configuration via WinConfig since you will find it very convenient; it also allows fast and easy documentation.

2.1. Configuration on TC-S1

Turn on the controller and wait for booting completed. Press key(9) and hold it pressed until screen (1) shows the 1st page of the configuration (refer to sketch on the right hand side).

Refer to the blank configuration table showing the basic structure of TC-S1 configuration pages.



In configuration modes the TC-S1 displays read as follows: (1) reads the actual parameter value, (2) the column of the table and (10) the parameter number followed by a brief parameter description. Use keys (3) to adjust the parameter if required.

Use keys (7) and (8) to navigate up resp. down the table, keys (4) to enter next / previous column resp. page at the last/first column. Use keys (5) to directly browse between the pages.

To leave and save configuration, press the key (9) and **hold it pressed** until the configuration screen disappears. To disregard any parameter changes done before simply turn off the controller. without saving.

2.2. Configuration via WinConfig

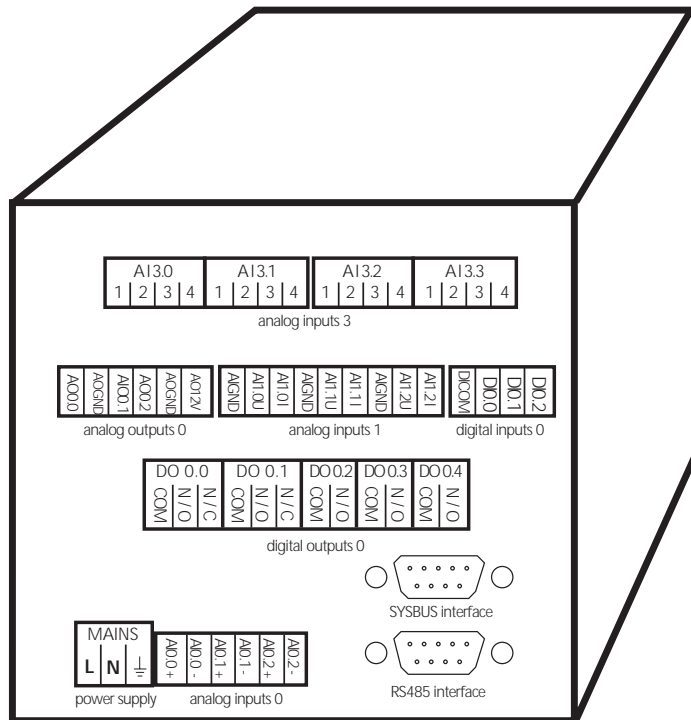
Please refer to the manual provided with WinConfig for a details explanation of procedure and options. WinConfig is available free of charge at www.bentrup.com.

3.0. Detailed Explanation of the parameters

The configuration parameters are explained in a HTML-file available in German or English. It is created by WinConfig according to the controller model. You can also download a general edition on www.bentrup.de, filename TC-S1S1e.html (english) resp. TCS1S1.html (german).

A printout of this file is appended on this manual as well.

4.0. Electrical Connections



power supply

controllers power supply (85 to 264 VAC/DC, max. 20W)

analog inputs 0

Analog inputs AI0.0 to 0.2 (non-isolated common +). Designed for thermocouple or mV-signals.



AI0.x+ ———— thermocouple
AI0.x- ————

AI0.x+ ———— voltage input 0-20/50mV
AI0.x- ————

analog inputs 1

Analog inputs AI1.0 to 1.2 (non-isolated common +). Designed for thermocouple, mV, standard 0-5/10V (use "U" input) or standard current 0/4-20mA signals (use "I" input).



AI1.xU ———— thermocouple
AI1.xI ————

AI1.xU ———— voltage input 0-5/10V
AI1.xI ————

AI1.xI ———— current input 0/4-20mA

AI1.xU ———— resistor input (2 wire)
AI1.xI ————

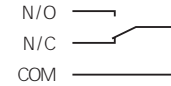
AI1.xU ———— resistor input (3 wire)
AI1.xI ————
AI0.x- ————

digital outputs 0 (5 relays type)

control outputs max. 8A/250V.

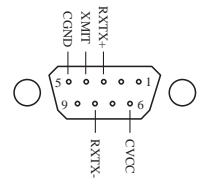
NOTE: An 8 relays type digital output board is also available. Check legend on plugs if this option is installed

DO 0.0	DO 0.1	DO 0.2	DO 0.3	DO 0.4
COM	N/O	COM	N/O	COM
N/O	N/C	N/O	N/O	N/O



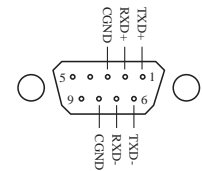
RS485 interface

communication interface according to RS485, fully electrically isolated. bentrup fieldbus protocol @115200 baud (description available at www.bentrup.de), DDE server available for simple integration to customized applications. Used by bentrup WinConfig and WinControl (SCADA). Also used for PROFIBUS option, ie. SUBD9 pin assignment according to RS485 electrical standard (up to 12Mbaud)..



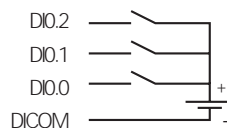
SYSBUS interface

Used to connect bentrup I/O extensions (SW808, DIO808, AI804, AO808), ie. for further digital and analog inputs and outputs (@115200 baud)

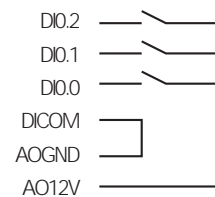


digital inputs 0 (optional)

digital signals 5 to 24VAC or DC (isolated, common - on DI COM). If the analog output option is fitted AOGND and AO12V can be used as voltage source (see sketch)



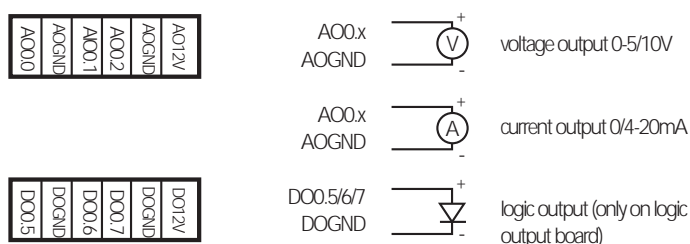
(alternatively, only if analog output option is fitted)



analog (or logic) outputs (optional)

analog outputs (isolated, common - on AOGND). Provides 0-5/10V or 0/4-20mA output signal. When logic output board installed a signal suitable for SSR (solid state relays) is provided (OFF<0.3V, ON>10V, load limited to 30mA per output).

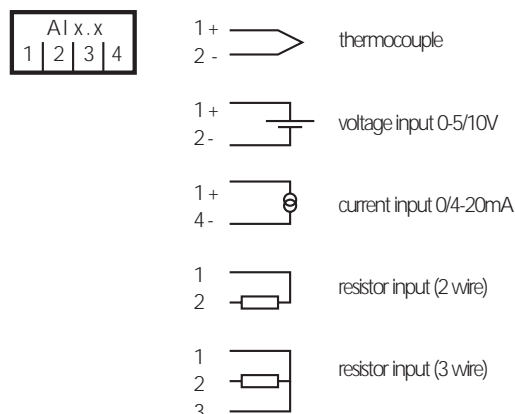
The 12V supply (AO12V/AOGND) can be used as an auxiliary control supply (max load 50mA resp. 140mA if analog/logic ports are unused). **ATTENTION:** Supply is overload protected and shuts down in an overload condition. The controller needs to be powered up again to re-established the 12V supply. The supply also affects the operation of the analog/logic outputs.



analog inputs 2 and 3 (optional)

analog inputs, fully isolated inputs. Designed for thermocouple, mV, 0-5/10V, 0/4-20mA, resistors signals

Highly sophisticated software configurable high performance 4 channel data acquisition unit (AIM4). Each channel isolated according to IEC264.



5.0. Mounting the TC S1

The TC S1 comes in a metal body plastic front case designed for panel mounting. The operating panel size is 96x96mm, the required depth is 198mm + 20mm for plugs/wiring (case with only 168mm depth on request). Recommended panel cut-out is 93x93mm +/-1mm. Brackets for fixation are integrated in TC S1 case.

bentrup TC-S1 Configuration Table Version 7.14

Table 0: clock / calender

The controller uses its real time clock / calender for different purposes. It allows the automatic commencing of programmes at predefined times as well the real time clock / calender is used to time stamp logged data and events. When configuring the controller using bentrup WinConfig / WinControl the controller is automatically updated with the PCs time / date information, Therefore manually changeing time / date is disabled

00: time (hours)(value range 00 to 23)

current time (hours) of the real time clock

01: time (minutes).....(value range 00 to 59)

current time (minutes) of the real time clock

02: date (weekday)(options MON, TUE, WED, THU, FRI, SAT, SUN)

current date (weekday) of the real time calendar

03: date (day).....(value range 01 to 31)

current date (day) of the real time calendar

04: date (month)(options JAN, FEB, MAR, APR, MAY, JUN, JUL, AUG, SEP, OCT, NOV, DEC)

current date (month) of the real time calendar

05: date (year)(value range 00 to 99)

current date (year) of the real time calendar

06: cfg.lock level(value range 0 to 5)

reserved for future used

Table 1: misc. adjustments

The following miscalleneous adjustments determine general operation parameters of the controller

00: max. segments(value range 5 to 98)

maximum number of segments per programme. Entering a smaller number increases the number of programmes you can save in your controller. In most applications a maximum of 20 segments is suitable. Note: After changing this value all programmes must be reentered because of the required reorganisation of the controllers memory

01: log rate (sec)(value range 0 to 255)

All important process values will be sampled to the controllers log memory for further examination by the operator. Since the log memory is quite limited adjust the **log rate** to the highest value suitable for your application. The log rate (specified in seconds) determines the time between two recordings. The actual size of the log memory depends on the configuration

02: manual enable.....(*options OFF, ON*)

The **manual mode** allows the user to individually operate the control outputs (digital outputs and analog outputs) manually. This feature is very helpful for kiln commissioning. Caution: For safety reasons only enable this MODE if the operator is familiar with it !

03: auto P. starts.....(*options OFF, ON*)

This feature allows automatic commencing programmes by the weekly switching clock. Depending on configuration up to 99 real time clock / weekdays controlled jobs can be entered. Enable this feature only if necessary to avoid unintentional programme commencing

04: lock programs(*options OFF, ON*)

Allows locking of all programmes (temperature curves) to avoid any unauthorized changes

05: communicat. ID.....(*value range OFF to 62*)

Sets the communication ID of the controller. Affects external communication only. Make sure that this ID fits the setting in the communication software (e.g. bentrup WinControl). Each ID must be unique on the communication network

06: <unused>(*value range 0 to 2*)

07: fctn.on pow.up(*value range 0 to 3*)

Verhalten nach dem Einschalten: **0**=Regler aus (IDLE), **1/2**=automatischer Programmstart wenn alle Bedingungen erfüllt sind (**1**=Zeit-Limit in Sekunden / **2**=Zeit-Limit in Minuten). **3**=automatischer Programmstart

08: ..only if DOxx(*value range OFF, DO0.0 to DO2.3*)

Programme is continued only if the selected output was ON before power breakdown. When selecting an output controlled by a programme EVENT, this feature can be used to enable programme continuation after a power breakdown for each segment

09: only if t<time(*value range OFF to 240*)

Programme is continued only if the duration of the power failure was less than this parameter. Depending on the selection of "fctn. on pow. up" this time limit is seconds or minutes

10: dT input sel ...(*value range OFF, IN00 to IN19*)

Selects the process value check for drop in temperature during a power breakdown

11: ..only if dT<x(*value range -9999 to 9999*)

Programme is continued only if the selected process value did not drop more than the given value during power breakdown

12: p.time MIN:SEC(*options OFF, ON*)

Set to 1 for fast programme cycles to enter segment time as minutes : seconds (MIN:SEC) instead of hours : minutes

Table 2: analog input

Specifies the analog input signals for the controller. Analog inputs are used to connect sensors like thermocouples, resistors, voltage/current signals to the controller. You can exactly define signal type (voltage, resistance, current) as well as signal range, signal conversion and correction, unit etc. The most common signal types are predefined. Each column of the table defines one process value which are named IN00, IN01 etc. The maximum number of analog input depends on the hardware.

00: input mode(options *END, T/C, LIN, ATMS, RES, FLOW, FUN*)

type of the analog input signal. Choose the appropriate kind of signal conversion from the given options:

T/C: Thermocouple input type. Selection of thermocouple and compensation mode see parameter below

LIN: Linear input type for generic use. This mode is used to convert any kind of linear input signal (as defined in the corresponding parameters) into its process parameter. An example for a typical application is to convert a 4-20mA signal from a pressure transducer into 0 to 100 Pa process parameter

ATMS: Atmosphere signal conversion. Use this selection to convert the typical signal of a circonoxyde probe into the kiln atmosphere reading. The controller uses the equation of Nerntzsch to convert the probe signal into % of oxygen. The probe temperature required for oxygen calculation is specified in the corresponding parameters as well as the kind of gas required for the carbonmonoxyde calculation. Note below on temperatures below 650°C no oxygen calculation is done (no reliable probe signal)

RES: Resistance temperature sensor conversion. Converts the resistance characteristic of most commonly used resistance sensors (like Pt100) into temperature reading

FLOW: Flow measuring device signal conversion. Use this selection of obtain the actual flow of devices based on the method of acquiring difference in pressure on an orifice valve. The controller converts the signal using the common physical laws with the optional compensation of media temperature and absolute media pressure

FUN: Non linear signal conversion. Use this selection to convert any signal which complies to the options given in the corresponding parameters (like logarithmic etc.) to its proper process value. The controller uses the formula **process value = (FUNC + constant val) / divisor val** replacing the terms with the given parameters

01: signal source(value range *AI0.0 to AI3.3*)

Specifies a physical input (AI..) of the controller. The process parameter is created from the signal on this physical input. To create two different process parameters from one physical input make sure that both signal types and ranges equals

02: average cycles(value range *1 to 11*)

Specifies the low pass signal filter. This options is used to smoothen the input signal. Can be used to eliminate signal interference as well as to improve signal quality. Setting this option to "1" disables the filter. A higher setting causes higher smoothening (low pass frequency is 1/n Hz). A setting of 4 suits most applications.

03: units(options °C, °F, °K, dg, mV, mA, O2, CO, %, ev, mb, m , m h, kh, kwh, Pa, AT)

Specifies the unit of the process value

04: trim +/- %(value range -10.0 to 10.0)

Allows full scale input signal correction. In certain applications it is required to compensate for any deviations of the installation. Example: Setting this parameter to -5.0% will cause the process value to be trimmed to 95°C instead of 100°C. **Note:** This parameter should be used with care since on most applications deviations errors should to be compensated by eliminating the real cause of the deviation rather than compensating on the controller

05: offset +/- val(value range -10.0 to 10.0)

Allows zero offset signal correction. Adjust this parameter if you need to adjust the input offset value. **Note:** This parameter should be used with care since on most applications deviations errors should to be compensated by eliminating the real cause of the deviation rather than compensating on the controller

06: min value(value range -10000 to 10000)

Minimum value of the process value. Specifies the lower value limit of the process parameter. Any lower value is respected as underrun (causing an error)

07: max value(value range -10000 to 10000)

Maximum value of the process value. Specifies the upper value limit of the process parameter. Any higher value is respected as overrun (causing an error)

following parameters apply on selection **T/C** only:

08: thermocouple(options S, R, K, J, B)

Select the IEC code of the thermocouple used

09: external CJC ..(value range OFF, IN00 to IN19)

Could junction compensation temperature. Set to "OFF" for internal compensation (recommended). Make sure that the proper compensating wire is used

following parameters apply on selection **LIN** only:

18: signal type(options OFF, 0-20mV, 0-50mV, 0-5V, 0-10V, 0-20mA, 4-20mA, -500R2, -500R3)

Type of input signal. Set this parameter to fit the signal of the device connected to the physical input. **Note:** Adapt the jumper settings of the physical input accordingly (done automatically on some devices)

19: val.@zeropoint(value range -3000.0 to 3000.0)

Process value at lower reference of input value. Example: A pressure transducer supplying 4 to 20mA at -250 to +250 Pa. Set this parameter to "-250" since this is the process value at the lower reference of 4mA

20: val.@fullscale (value range -3000.0 to 3000.0)

Process value at upper reference of input value. Example: A pressure transducer supplying 4 to 20mA at -250 to +250 Pa. Set this parameter to "250" since this is the

process value at the upper reference of 20mA

following parameters apply on selection **ATMS** only:

28: temp. source(value range IN00 to IN19)

Selects the process value representing the temperature of the atmosphere sensor. The temperature is required for the calculation of the oxygen

29: min. CO temp(value range 600 to 1800)

Minimum temperature **in centigrade Kelvin** required for carbonmonoxyde calculation. A minimum temperature of 900°C (1273°K) is recommended for reliable calculation

30: press.source..(value range OFF, IN00 to IN19)

Selects the process value representing the over pressure of the reference air. This is used to supervise the referece air for the oxygen probe. Set to "OFF" if not used

31: min. pressure.....(value range 0 to 250)

Minimum pressure limit of reference air. Oxygen process value is set to "INVALID" if reference over pressure falls below this limit

32: type of gas(options NATGAS, PROPAN, BUTHAN)

Kind of the gas used. This selection is only used for calculating carbonmonoxyde

following parameters apply on selection **RES** only:

38: resist.type(options PT100)

Kind of the resistance sensor used

39: signal type.....(options -500R2, -500R3)

Type of input signal. Set this parameter to fit the signal of the device connected to the physical input. **Note:** Adapt the jumper settings of the physical input accordingly (done automatically on some devices)

following parameters apply on selection **FLOW** only:

48: signal type(options OFF, 0-20mV, 0-50mV, 0-5V, 0-10V, 0-20mA, 4-20mA, -500R2, -500R3)

Type of input signal. Set this parameter to fit the signal of the device connected to the physical input. **Note:** Adapt the jumper settings of the physical input accordingly (done automatically on some devices)

49: sig.@ max.flow(value range 0.0 to 1000.0)

Process value at upper reference of input value (at maximum flow)

50: media tmp.sens(value range OFF, IN00 to IN19)

Selects the process value representing the media temperature. Used to compensate the flow information for the media temperature. Set to "OFF" if not used

51: media std.temp(value range -100 to 120)

Temperature that has been used as "standard temperature" on orifice calculation

52: media prs.sens(value range OFF, IN00 to IN19)

Selects the process value representing the media over pressure. Used to compensate the flow information for the media over pressure. Set to "OFF" if not used

53: media std.ov.p(value range 0 to 250)

Pressure that has been used as "standard pressure" on orifice calculation

following parameters apply on selection **FUN** only:

58: signal type(options OFF, 0-20mV, 0-50mV, 0-5V, 0-10V, 0-20mA, 4-20mA, -500R2, -500R3)

Type of input signal. Set this parameter to fit the signal of the device connected to the physical input. **Note:** Adapt the jumper settings of the physical input accordingly (done automatically on some devices)

59: function sel(options —, EXP, EXP10, LN, LOG, SIN, COS)

Select the kind of function see term "FUNC" in formula)

60: constant val ..(value range -30.000 to 30.000)

Value "constant val" of the formula)

61: divisor val(value range -30.000 to 30.000)

Value "divisor val" of the formula)

Table 3: digital input

Digital inputs can be used for different purposes. First they are used to create a process value depending on a frequency or number of pulses. Second they are used to control programme execution in different ways. Third, they are used by the optional PLC. **Note:** PLC provides you with total flexibility of the controller. If you are using the PLC of the controller you must **not** do any adjustments in this digital input section since all features are programmed by PLC networks

00: input mode(options END, CNT, PRC)

Sets the operation mode of the digital inputs. Set to END when using the PLC

CNT: Pulse signals supplied to this input are converted into a process value. Obsolete feature

PRC: Used to control the programme flow externally. See below for a list of available control commands

01: signal source(value range DI0.0 to DI8.0)

Physical input used for the function

following parameters apply on selection **CNT** only:

02: units(options °C, °F, °K, dg, mV, mA, O2, CO, %, ev, mb, m, m h, kh, kwh, Pa, AT)
no explanation available

03: min value(value range -10000 to 10000)

no explanation available

04: max value(value range -10000 to 10000)

no explanation available

05: count unit x / (value range -2000.0 to 2000.0)

no explanation available

06: count unit / x(value range -2000.0 to 2000.0)

no explanation available

following parameters apply on selection **PRC** only:

12: process mode(value range 0 to 15)

Defines the procedure to be commenced when the selected inputs is activated:

0=programme starts all over again / 1=programme starts / 2=programme stops

3=ON:programme starts all over again OFF:programme stops / 4=ON:programme stops

OFF:programme stops / 5=programme HOLD

13: process ID(value range a to a)

Table 4: analog output

Analog outputs are used to drive of analog devices like steady power control units (thyristor controls), voltage controlled frequency converters or any kind of recorders. The analog output can be any kind of voltage (0 to 10V etc.) or current (0-20mA etc.) signal. The controller can be configured to drive an analog output by any kind of process value (control channel output, process value output etc.)

00: output mode(options END, PRZ, ANA)

Sets the operation mode of the analog output:

PRZ: Sets the analog output to be used to send the channel output value for controlling the heating resp. cooling device. Example: Use this mode to provide a 4-20mA steady output signal (according to 0 to 100% heating) for driving a thyristor

ANA: Sets the analog output to send any internal process value as analog signal within adjustable boundaries. Example: Use this mode to create a 0 to 10V output signal according to 0°C to 1000°C programme setpoint

01: output type(options OFF, 0-20mV, 0-50mV, 0-5V, 0-10V, 0-20mA, 4-20mA)

Signal type. Note that changing from voltage to current mode (and vice versa) requires adapting the jumper settings resp. reconnecting the outlets to a different position

02: destination(value range AO0.0 to AO3.3)

Selects the physical output of the signal

03: process ID(value range a to f)

following parameters apply on selection **PRZ** only:

04: channel source *.(value range CH00 to *CH'09)*

Selects the control channel (loop) used to drive the output. The options MX../A resp. MX../G are the outputs of the air / gas mixer (for combustion units)

05: output charact *.....(value range 0 to 5)*

Specifies the operation range of the output. Used to limit an output assigned to a heating / cooling loop (range +100% to -100%) to the physical range of operation. In an typical application one output (eg. controlling the heating elements) is set to "0 to +100%" and a 2nd output (eg. controlling a fan) is set to "0 to -100%" (both outputs assigned to the same control channel). The available settings are 0=0% to +100% / 1=+100% to 0% / 2=0% to -100% / 3=-100% to 0% / 4=-100% to +100% / 5=+100% to -100%. The further settings will repeat the choices but use the motor characteristic for non-linear devices: 6 to 11: motor char.#0 / 12 to 17: motor char.#1 18 to 23: motor char#3 etc.

06: outp.% on IDLE *.....(value range 0 to 100)*

Whenever the controller is IDLE the output is fixed to this value

07: outp. % on ERR *.....(value range 0 to 100)*

Whenever the entire controller is in ERROR status the output is fixed to this value. Note that this only applies on system errors and not an operation error on a single channel

08: min. output % *.....(value range 0 to 100)*

Lower output signal limit. The output will never drop below this limit. Can be used for instance to obtain permanent minimum heating. Care should be taken since high settings might interfere with the control loop

09: max. output % *.....(value range 0 to 100)*

Upper output signal limit. The output will never exceed this limit. Can be used for instance to limit the maximum heating of a kiln. Note that limiting can cause problems if the applications lacks of heating power (gradient check errors etc.)

following parameters apply on selection **ANA** only:

14: outp. param *.....(value range SP00 to CH19)*

Selects a process value sent to the analog output. The output is driven according to to the process value in the range given by the following parameters "lower base value" and "upper base value". Example: Assuming a signal type 0 to 10V / lower base value 0°C / upper base value 1000°C the output provides 7,5 V on a process value of 750°C

15: lower base val *....(value range -9999 to 9999)*

Sets the lower base value for a process value output. For details refer to the example given at "outp. param."

16: upper base val *....(value range -9999 to 9999)*

Sets the upper base value for a process value output. For details refer to the example given at "outp. param."

Table 5: digital output

Digital outputs are used to switch any kind of ON/OFF devices as well as motorized valves (using 2 digital outputs in sequence). Depending on controller hardware the output is either a switching relay output (8A / 250V) or a logic output (OFF=0V / ON=12V). The following parameters select the kind of operation (control outputs, alarms, events etc.). Digital outputs used by the PLC must **not** be assigned in this section

00: output mode(options *END, PRZ, MOT, LIM, PRC, EVE, TAB, CMB*)

Selects an operation mode of the digital outputs:

PRZ: Used to provide the output value of a control channel (loop) to an ON/OFF device. The most common application is to control a contactor used for heating

MOT: Used to provide the output value of a control channel (loop) to a servomotor device. A typical application when controlling a motorized butterfly valve on a gas kiln. A servomotor is controlled by 2 digital outputs (OPEN and CLOSE). The physical output CLOSE is automatically assigned to the output following OPEN

LIM: Output works as limit switch (commonly called ALARMS). Any kind of comparison of process of constant values can be done

PRC: Indication of selectable process conditions. Can be used to activate an output on programme end, process errors, process holds etc.

EVE: Used to configure the output as programme event. Can be programmed to ON or OFF for each segment. During programme run the output is set accordingly

TAB: Used to control a group of outputs according to the bit pattern provided in the corresponding column of the programme table. Typically used in combination with a PLC

CMB: Output is driven according to the result of the network defined by the following parameters. Used to create simple logic networks, ie. output do0.2 is only if do1.0 and do1.1 is active. For more complex networks ask for the optional, integrated PLC

01: destination(value range *DO0.0 to DO8.0*)

Selects the physical output of the signal

02: process ID(value range *a to f*)

following parameters apply on selection **PRZ** only:

03: channel source .(value range *CH00 to *CH'09*)

Selects the control channel (loop) used to drive the output. The options MX../A resp. MX../G are the outputs of the air / gas mixer (for combustion units)

04: output charact(value range *0 to 5*)

Specifies the operation range of the output. Used to limit an output assigned to a heating / cooling loop (range +100% to -100%) to the physical range of operation. In an typical application one output (eg. controlling the heating elements) is set to "0 to +100%" and a 2nd output (eg. controlling a fan) is set to "0 to -100%" (both outputs assigned to the

same control channel). The available settings are 0=0% to +100% / 1=+100% to 0% / 2=0% to -100% / 3=-100% to 0% / 4=-100% to +100% / 5=+100% to -100%. The further settings will repeat the choices but use the motor characteristic for non-linear devices: 6 to 11: motor char.#0 / 12 to 17: motor char.#1 18 to 23: motor char#3 etc.

05: outp.% on IDLE(value range 0 to 100)

Whenever the controller is IDLE the output is fixed to this value

06: outp. % on ERR.....(value range 0 to 100)

Whenever the entire controller is in ERROR status the output is fixed to this value. Note that this only applies on system errors and not an operation error on a single channel

07: min. output %.....(value range 0 to 100)

Lower output signal limit. The output will never drop below this limit. Can be used for instance to obtain permanent minimum heating. Care should be taken since high settings might interfere with the control loop

08: max. output %.....(value range 0 to 100)

Upper output signal limit. The output will never exceed this limit. Can be used for instance to limit the maximum heating of a kiln. Note that limiting can cause problems if the applications lacks of heating power (gradient check errors etc.)

09: cyclus time.....(value range 0 to 100)

Cyclus time (seconds) of the digital output. The output value is converted into an ON and OFF period accordingly (T on + T off = T cyclus). Decreasing the cyclus time improves accuracy but might decrease lifetime of the heating device. A typical value for contactors on kilns is 30. Set to 0 for the Logic Output Option (different hardware). A signal 1 Hz PWM 0-100% for solid state relays is provided on the output

following parameters apply on selection **MOT** only:

13: channel source .(value range CH00 to *CH'09)

Selects the control channel (loop) used to drive the output. The options MX../A resp. MX../G are the outputs of the air / gas mixer (for combustion units)

14: output char.....(value range 0 to 30)

Specifies the operation range of the output. Used to limit an output assigned to a heating / cooling loop (range +100% to -100%) to the physical range of operation. In an typical application one output (eg. controlling the heating elements) is set to "0 to +100%" and a 2nd output (eg. controlling a fan) is set to "0 to -100%" (both outputs assigned to the same control channel). The available settings are 0=0% to +100% / 1=+100% to 0% / 2=0% to -100% / 3=-100% to 0% / 4=-100% to +100% / 5=+100% to -100%. The further settings will repeat the choices but use the motor characteristic for non-linear devices: 6 to 11: motor char.#0 / 12 to 17: motor char.#1 18 to 23: motor char#3 etc.

15: outp.% on IDLE(value range 0 to 100)

Whenever the controller is IDLE the output is fixed to this value

16: outp.% on ERR.....(value range 0 to 100)

Whenever the entire controller is in ERROR status the output is fixed to this value. Note

that this only applies on system errors and not an operation error on a single channel

17: travel time(value range 0 to 250)

Enter the time (in seconds) for the servomotor to move over the entire actual operation range (fully close to fully open)

18: delay 1/10s(value range 0 to 150)

Delay time of the servomotor on direction changes. This parameter (given as 100ms units) is used to compensate for gearbox lags etc.

19: update time(value range 0 to 250)

Rate in seconds the servomotor position is updated. Decreasing this rate causes more stress to the servomotor

20: hyst. %/steps.....(value range 0 to 100)

Hysteresis for updating the servomotor position. Decreasing this rate causes more stress to the servomotor. However, in most application a hysteresis of 1% is recommended

21: feedback input(value range OFF, IN00 to IN19)

The position feedback option is used for best tracking of the actual servomotor position. Typically a position potentiometer is connected to an analog input (configured as linear resistance input 0-100%). Enter the process parameter number of this input here. Set to OFF is unused

22: steps (MOT808)(value range -10000 to 10000)

no explanation available

following parameters apply on selection **LIM** only:

23: compare mode(options 1>2+c, 1<2+c, dif<c, dif>c)

Selects the kind of equation of the formula given as **limit 1 ? limit 2 + limit const**. The "?" is replaced depending on this parameter: 0 stands for ">=", 1 stands for "<=", 2 means "limit 1 - limit 2 less then limit const", 3 means "limit 1 - limit 2" more than limit const. The digital output is ON when the equation is true. Example: To activate the output whenever the actual temperature exceeds the setpoint more than 30°K (= overtemperature alarm) set the parameters as follows: compare more = 0 / limit 1 = IN00 / limit 2 = SP00 / limit const = 30

24: limit 1(value range OFF, SP00 to CH19)

Selects the process value used as "limit 1" in the formula. This can be a setpoint, an actual temperature, a channel (loop) output or "OFF" to insert "0" in the formula. For detailed explanation including an example refer to "compare mode"

25: limit 2(value range OFF, SP00 to CH19)

Selects the process value used as "limit 2" in the formula. This can be a setpoint, an actual temperature, a channel (loop) output or "OFF" to insert "0" in the formula. For detailed explanation including an example refer to "compare mode"

26: limit const(value range -10000 to 10000)

The constant value used as "limit const" in the formula. For detailed explanation including an example refer to "compare mode"

27: output on IDLE(value range 0 to 2)

Defines the state of the digital output when the controller is IDLE: 0 = same as during programme run / 1 = OFF / 2 = ON

28: output on ERR(value range 0 to 2)

Defines the state of the digital output when the controller enters a system error: 0 = same as during programme run / 1 = OFF / 2 = ON

following parameters apply on selection **PRC** only:

33: process mode(value range 0 to 22)

Selects the process state the digital output is indicating: 0=programme run (also ON during segment 0 and at the end of the firing) / 1=programme run (also ON during segment 0) / 2=programme run / 3=end of the firing / 4=any channel error / 5=programme HOLD / 6=OFF / 7=ON / 10/11/12=mixer in air excess/stoichiometric/cooling mode / 13=programme continues after power breakdown / 14=do0.6 and not do0.7 / 15=do0.6 and do0.7 / 16=not do0.6 and do0.7 / 17=control channel off band / 18=programme interrupted due to off band / 19=any monitored channel error / 20=final temperature matches in all monitored channels / 21=any monitored channel in control range / 22=any monitored channel out of control range

following parameters apply on selection **EVE** only:

43: EVENT number(value range 0 to 10)

Digital output works as programme EVENT number #. This number must fit the EVENT number specified in the programme table

44: output on IDLE(value range 0 to 1)

Defines the state of the digital output when the controller is IDLE: 0 = OFF / 1 = ON

45: output on ERR(value range 0 to 1)

Defines the state of the digital output when the controller enters a system error: 0 = same as during programme run / 1 = OFF / 2 = ON

following parameters apply on selection **TAB** only:

53: table dat.src(value range TA00 to TA19)

Select the column number of the programme table the programme value is taken

54: outp. width(value range 0 to 8)

number of digital outputs in sequence used for this function

following parameters apply on selection **CMB** only:

63: combinat. type(options OR, NOR, AND, NAND, XOR, XNOR)

Select the type of combinatoric operator applied to the selected bits

64: output on IDLE(value range 0 to 2)

Defines the state of the digital output when the controller is IDLE: 0 = same as during programme run / 1 = OFF / 2 = ON

65: output on ERR(value range 0 to 2)

Defines the state of the digital output when the controller enters a system error: 0 = same as during programme run / 1 = OFF / 2 = ON

66: 1. DOxx sel.(value range DO0.0 to DO8.0)

67: 2. DOxx sel.(value range OFF, DO0.0 to DO8.0)

68: 3. DOxx sel.(value range OFF, DO0.0 to DO8.0)

69: 4. DOxx sel.(value range OFF, DO0.0 to DO8.0)

70: 5. DOxx sel.(value range OFF, DO0.0 to DO8.0)

71: 6. DOxx sel.(value range OFF, DO0.0 to DO8.0)

72: 7. DOxx sel.(value range OFF, DO0.0 to DO8.0)

73: 8. DOxx sel.(value range OFF, DO0.0 to DO8.0)

Selects the bits (digital outputs) used in the combinatoric network. Set to "OFF" when unused

Table 6: programme table

The programme table determines the parameters and the sequence to be entered for each programme segment. The first programme parameter is always a time followed by a temperature. Depending on the application the following programme segment parameters could be for instance offset temperatures (for multizone kilns), programme events etc. The parameter sequence after the 1st temperature is variable; however, keeping all programme EVENTS together saves programme memory

00: value type(options END, TIME, VAL-L, --, VAL-S, EVENT, ATMS)

Select the kind of value in each column of the programme table:

TIME: The very first column of the programme table holds the segment time

VAL-L: Programme value in the range of -10000 to 10000. Typically used for any kind of absolute value (like kiln temperature etc.)

--: selection not used

VAL-S: Programme value in the range of -127 to 128. Typically used for any kind of relative values (like offset temperature for zones)

EVENT: EVENT value, ie. holds ON or OFF. When requiring multiple events defining them one after the other saves programme memory

ATMS: Programme value to define an atmosphere

01: designator 1(alphanumerical characters)

02: designator 2(alphanumerical characters)

03: designator 3(alphanumerical characters)

Used to give each programme table column an individual name (consisting of up to 3 alphanumeric letters)

following parameters apply on selection **TIME** only:

04: lower time lim(value range -101 to -2)

Limits the value range entered as a time. Note that the values smaller than minus 2 enable the programme link feature (-3 = allow linking to programme number 1, -4 = allow linking to programme number 2 etc.)

05: upper time lim.....(value range 1 to 6998)

Upper limit when adjusting the time. The 1000 steps beyond this limit stand for setting the gradient as centigrade kelvin per period

following parameters apply on selection **VAL-L** only:

14: value unit(options °C, °F, °K, dg, mV, mA, O2, CO, %, ev, mb, m , m h, kh, kwh, Pa, AT)

Specifies the unit of the programme table value

15: lower val. lim(value range -9999 to 9999)

Lower limit of the programme table value. Used for instance to ensure the values entered by the user stay within the operation limits of the kiln

16: upper val. lim.....(value range -9999 to 9999)

Upper limit of the programme table value. Used for instance to ensure the values entered by the user stay within the operation limits of the kiln

following parameters apply on selection **--** only:

24: value unit(options °C, °F, °K, dg, mV, mA, O2, CO, %, ev, mb, m , m h, kh, kwh, Pa, AT)

Specifies the unit of the programme table value

25: lower val. lim(value range -9999 to 9999)

Lower limit of the programme table value. Used for instance to ensure the values entered by the user stay within the operation limits of the kiln

26: upper val. lim.....(value range -9999 to 9999)

Upper limit of the programme table value. Used for instance to ensure the values entered by the user stay within the operation limits of the kiln

following parameters apply on selection **VAL-S** only:

34: value unit(options °C, °F, °K, dg, mV, mA, O2, CO, %, ev, mb, m , m h, kh, kwh, Pa, AT)

Specifies the unit of the programme table value

35: lower val. lim(value range -128 to 127)

Lower limit of the programme table value. Used for instance to ensure the values entered by the user stay within the operation limits of the kiln

36: upper val. lim(value range -128 to 127)

Upper limit of the programme table value. Used for instance to ensure the values entered by the user stay within the operation limits of the kiln

following parameters apply on selection **EVENT** only:

44: EVENT number(value range 0 to 15)

This unique number identifies the EVENT in the programme table for the digital output

following parameters apply on selection **ATMS** only:

54: atmosphere cde.....(options AT)

Wählt die Einstellungsart des Atmosphären-Sollwertes aus. Wert nicht veränderbar

Table 7: process flow setup

The parameters of this section specify the reaction of the controller to any kind of unusual conditions that might happen during a programme run. Examples for unusual conditions are broken temperature sensors, heat up problems of the kiln, control channel errors etc. As well the conditions to enter the next segment during a running programme can be adjusted as required

00: time in ramps(options KEEP, UPDAT)

If the temperature of the pilot input (IN00) is higher than the start temperature of the ramp the time of the ramp can be either kept or reduced accordingly

KEEP: Segment time is kept, setpoint begins as programmed

UPDAT: Segment time is reduced accordingly. Example: Segment 0 is 0°C, segment 1 is "in 2 hours to 500°C". Assuming a kiln temperature of 250°C when starting the firing, the time is reduced to 1 hour (causing a setpoint of 250°C)

01: monitor ch(value range -CH25 to CH25)

Only the channels specified are monitored for process problems. This setting allows to include only the channel(s) which are important for the process. Either a single channel can be selected (e.g. on single zone kilns) or a range of channels (e.g. ch00 to ch02 on a 3 zone kiln). A range is entered as minus channel (e.g. "-ch02" stands for ch00 to ch02)

02: temp match %o.....(value range 0.0 to 100.0)

An uncontrolled ramp (SKIP) the end of the segment is determined by match of actual temperature and final segment temperature. Since the controller slows down temperature move at the end to avoid over/undershoot it might take some time to finally reach the temperature although it is not required by the process. This parameter allows to specify a window to earlier complete the segment. Example: 2.0 ppm of 1320°C (max. channel temperature) = 2.64°C, SKIP segment ends at 997.36°C assuming a final ramp

temperature of 1000°C

03: num of matches(value range 1 to 250)

An uncontrolled ramp (SKIP) is only completed if the temperature matched the specified number of cycles. The check is done each 0.5 seconds. This is used to avoid leaving the segment if the temperature only overshoots for a short time. Example: The setting of 6 lets the controller to complete the current segment if the temperature matched for at least 3 seconds

04: end of SKP seg.(options *DISR, WAIT.X, INFIN*)

no explanation available

DISR: Causes the controller to disregard the temperature, ie. to leave a SKIP segment immediately

WAIT.X: Causes the controller to wait for temperature match, but maximum for the specified time (see next parameter). This option is strongly recommended on multi zone kilns, e.g. at a time of 10 minutes. Otherwise the process might lock up itself. For instance in a cooling SKIP, the thermocouple of zone 2 has a little deviation and therefore zone 2 is heated 4°C higher; if the heating affects zone 1 this zone will never cool down as necessary. The time begins to count if the first zone starts to control. If the time is elapsed the segment is finished disregarding the temperature of the zones matches

INFIN: Causes the controller to wait for temperature match for infinite time

05: chk rate (sec).....(value range 0 to 9999)

no explanation available

06: act.on CH unco(options *DISR, WAIT.BR, WAIT.CO, INFI*)

In a controlled ramp it might happen that the kiln temperature can not follow the requested increase although the controller asks for maximum heating (resp. the requested decrease in a cooling segment). The following actions can be selected:

DISR: Causes the controller to disregard this situation

WAIT.BR: Causes the controller to hold the firing to give the kiln temperature time to catch up. If the kiln couldn't catch up within the specified time (see next parameter) the firing is interrupted (break). The hold mode (same as hold used during programme run) can also be released manually by pressing the hold skip button

WAIT.CO: Causes the controller to hold the firing but - after the time has elapsed - continues the firing disregarding the temperature

INFI: Causes an immediate break if the temperature can not follow.

07: uncontr = ..CH.....(options *ALL, ANY*)

Selects the criteria the controller judges to the kiln as non following the temperature increase:

ALL: all channels out of control (maximum or minimum heating)

ANY: any channel out of control

08: max hold (sec)(value range 0 to 9999)

wait time in seconds for the feature specified previously

09: act.on error(options DISR, WAIT.BR)

If any error in the control channels happens (e.g. overtemperature because of break of thermocouple) the reaction of the controller can be adjusted:

DISR: Causes the controller to disregard this event and to continue the process with the remaining channels

WAIT.BR: Causes the controller to hold for a specified time (see next parameter). This delay time can be used to notify the user (e.g. by a process alarm of the controller) and to fix the problem. When the time is elapsed the firing is terminated. Set time to "0" if the process is to be finished after channel error immediately

10: max hold (sec)(value range 0 to 9999)

wait time in seconds for the feature specified previously

Table 8: programme setpoint

The programme setpoints are calculated according to the programme resp. temperature curve entered by the operator. Some adjustments are possible for easy operation. Automatic setpoint calculation required for cascade control systems is also entered by the following settings

00: setpoint type ..(options END, CON, MOD, CHA)

The following basic types creating a setpoint can be selected:

CON: Use initial value of the programme segment only. Typical applications are offset values for zone temperatures or flap positions

MOD: Programme setpoint modulated by the segment time. This is the common setting causing the programme setpoint to count upwards resp. downwards over the segment time (e.g. within 2:00 hours from 0°C up to 1000°C)

CHA: Setpoint calculated by cascade control algorithm - for details refer to the example below

01: process ID(value range a to a)

following parameters apply on selection **CON** only:

02: table source(value range TA01 to TA19)

Selects the column of the programme table used for setpoint calculation. TA01 is the 1st column, ie. usually the primary temperature

03: offset src SP .(value range OFF, SP00 to SP09)

Defines a setpoint which refers to an existing setpoint, ie. the setpoint is calculated by adding another setpoint to it. Used e.g. for the setpoint of the slave zones of a multizone kiln. Using this option allows the operator to enter the temperature of the slave zones as

offset (temperature difference) relative to the master zone setpoint. In this example the master zone setpoint is entered in this option

04: idle setpoint(value range -10000 to 10000)

Setpoint whenever the controller is not in a programme run (IDLE). Can be used to ensure a certain temperature is maintained without a programme run. Entering "0" switches off this feature

05: error setpoint ..(value range -10000 to 10000)

Setpoint whenever the controller is not in a programme run (IDLE). Can be used to ensure a certain temperature is maintained without a programme run. Entering "0" switches off this feature

following parameters apply on selection **MOD** only:

12: table source(value range TA01 to TA19)

Selects the column of the programme table used for setpoint calculation. TA01 is the 1st column, ie. usually the primary temperature

13: offset src SP .(value range OFF, SP00 to SP09)

Defines a setpoint which refers to an existing setpoint, ie. the setpoint is calculated by adding another setpoint to it. Used e.g. for the setpoint of the slave zones of a multizone kiln. Using this option allows the operator to enter the temperature of the slave zones as offset (temperature difference) relative to the master zone setpoint. In this example the master zone setpoint is entered in this option

14: idle setpoint(value range -10000 to 10000)

Setpoint whenever the controller is not in a programme run (IDLE). Can be used to ensure a certain temperature is maintained without a programme run. Entering "0" switches off this feature

15: error setpoint ..(value range -10000 to 10000)

Setpoint whenever the controller is not in a programme run (IDLE). Can be used to ensure a certain temperature is maintained without a programme run. Entering "0" switches off this feature

following parameters apply on selection **CHA** only:

22: based on SP(value range SP00 to SP09)

Selects the programme setpoint used for the cascade control, ie. the programme setpoint for the target

23: charg.ctrl.CH(value range CH00 to *CH'09)

Selects the master control channel (loop). The basic idea of a cascade control is as follows: An application requires a large target (e.g. a piece of aluminium) to follow a temperature curve. An appropriate solution is using an air convection kiln. Using an ordinary control it will give different problems depending on the position of the thermocouple: When sensing the ambient temperature the actual temperature of the target (aluminium) will be far (might be even hundreds of degrees centigrade) behind

since it is very lag. Sensing the target temperature might cause damage to the kiln since the controller does not pick up the temperature of the heaters. Additionally, temperature oscillations are likely when the target temperature is getting close. **A cascade control eliminates these problems and works as follows:** Two control channels are combined. The master control channel is configured as normal, ie. using the programme temperature as setpoint and the target temperature as actual temperature. The output of this channel is used to create a 2nd temperature setpoint according to the settings in this section. This setpoint and the actual ambient temperature are assigned to the slave control channel driving directly the heating device of the kiln. Note that the master control channel is configured as heating/cooling loop with a wide proportional range and slow integral time (P/I/D = 10.0% / 400 s / 0 s)

24: max. temp.diff.(*value range -10000 to 10000*)

Limits the maximum difference in temperature between the target and the ambient temperature. Used to avoid damage of the target if sensitive. A high limit, however, speeds up the process of the target reaching the programme setpoint

25: max envir.temp(*value range -10000 to 10000*)

Limits the maximum ambient temperature. Used to avoid damage of the target if sensitive. A high limit, however, speeds up the process of the target reaching the programme setpoint

Table 9: control channel

The control loops are designed to operate in totally different modes. Each operation mode can be tuned individually

00: ctrl.algorithm(*options END, PID, C-PID, D-HYS, P-DIR*)

Depending on your application different control algorithms are available

PID: Default control algorithm suitable for most applications

C-PID: As before, but provides independent disable feature for heating and cooling range. Important on heating/cooling applications where heating and cooling depends on external conditions. Also used to avoid heating and cooling ranges chasing each other. Activation is done by any bit (e.g. a digital output). Typical applications are gas kilns where heating range (0 to +100%) is disabled once the burner control bit goes OFF

D-HYS: Hysteresis control for heating devices which require either temperature deviation or do not allow short cyclic activation (e.g. discontinuous burners)

P-DIR: Direct control. The setpoint is directly converted into a control value referring to the given value boundaries. Typical application is setting a flap position directly (e.g. 0 to 100%)

01: setpoint chn(*value range SP00 to CH19*)

Selects the setpoint used for this control channel

02: input chn(*value range SP00 to CH19*)

Selects the process value used for this control channel

03: power % on ERR(*value range -100 to 100*)

Predefined process output if an error occurs in the control channel. The control channel

enters error state if a.) the process value fails (overrun, underrun, invalid), b.) the process value exceeds the process value limit specified in the channel configuration or c.) the gradient check indicates failure

04: maximum value(value range 0 to 10000)

Maximum process value. Used to limit the process input value for safety reasons as well as setting the operation range. If the process value exceeds the limit the control channel enters error state which can only be cleared by re-starting the programme. Set this value above the actual operation range to allow overshooting

05: grdnt check s(value range 0 to 3600)

The gradient check is used for safety reasons. Prevents the unit from damage if the feedback signal (e.g. the thermocouple) fails. Checking the increase of the process value is performed on maximum output (typically +100%). This parameter defines the checking period in seconds. Set to "0" to disable checking. If the gradient check determines an error the channel is switched off (gradient error state)

06: grdnt chk dif(value range 0 to 10000)

Increase of the process value required per checking period on maximum heating

07: ctrl charact(value range 0 to 3)

Depending on the application select the operation range of the control channel to one of the following options: 0 = 0% to 100% / 1 = 100% to 0% / 2 = -100% to +100% / 3 = +100% to -100%

following parameters apply on selection **PID** only:

08: prop. band %(value range 0.0 to 1000.0)

Control parameter "proportional band" in % of the maximum value

09: integral time(value range 0 to 10000)

Control parameter "integral time" in seconds

10: derivat. time(value range 0 to 10000)

Control parameter "derivative time" in seconds

11: prop. shift ⇐(value range 0 to 4)

Determines the operating range of the proportional band: 0 = prop. band below setpoint / 1 = prop. band one quarter above setpoint / 2 = .. half above setpoint / 3 = .. three quarters above setpoint. In most applications a setting of "1" ensures best results (ie. fast reaching the setpoint with minimum overshoot)

following parameters apply on selection **C-PID** only:

18: prop. band %(value range 0.0 to 1000.0)

Control parameter "proportional band" in % of the maximum value

19: integral time(value range 0 to 10000)

Control parameter "integral time" in seconds

20: derivat. time.....(value range 0 to 10000)

Control parameter "derivative time" in seconds

21: prop. shift -(value range 0 to 4)

Determines the operating range of the proportional band: 0 = prop. band below setpoint / 1 = prop. band one quarter above setpoint / 2 = .. half above setpoint / 3 = .. three quarters above setpoint. In most applications a setting of "1" ensures best results (ie. fast reaching the setpoint with minimum overshoot)

22: + activat. DOx(value range OFF, DO0.0 to DO8.0)

Selects the bit (digital output) which activates the positive operation range (heating). When the bit is off the channel enters OFF status as long as heating applies

23: - activat. DOx(value range OFF, DO0.0 to DO8.0)

Selects the bit (digital output) which activates the negative operation range (cooling). When the bit is off the channel enters OFF status as long as cooling applies

following parameters apply on selection **D-HYS** only:

28: hyster. units(value range 0.0 to 100.0)

Hysteresis of the control channel. The hysteresis is specified as absolute value. A small value results in higher accuracy but causes higher switching rates. A large value causes less accuracy due to larger oscillations of the process value

29: derivat. time.....(value range 0 to 10000)

Control parameter "derivative time" in seconds

30: min. ON time.....(value range 0 to 120)

Minimum time for output activation specified in seconds. Used to suppress short time output activation. A typical application is when driving certain types of burners which need a minimum startup time for ignition

31: min. OFF time(value range 0 to 120)

Minimum time for output deactivation specified in seconds. Used to suppress short time output deactivation. A typical application is when driving certain types of burners which should not be interrupted for short periods

following parameters apply on selection **P-DIR** only:

38: lower val.base.(value range -10000 to 10000)

Sets the lower base value which corresponds to 0% control channel output

39: upper val.base.(value range -10000 to 10000)

Sets the upper base value which corresponds to 100% control channel output

Table 10: infobox

Defines the process parameters displayed on the controller front panel. Each infobox defines one process parameter to show. The number of process parameters to be displayed simultaneously depends on the controller model. Pressing the *select* button shows one infoboxes after the other

00: infobox type(*options END, SPACE, VAL, VAL-B, VALx2, CHAN, DOx, AOx, MOT, PRC.I, DIx, AIx, MIXER, FLWRT, KWH, VOL., RTC, PLC.S*)

Selects the kind of information shown on the infobox

SPACE: Shows a blank line

VAL: Displays a process value

VAL-B: Displays a process value in large letters

VALx2: Displays a twin process value (like atmosphere O2 / CO)

CHAN: Displays a channel status

DOx: Displays a group of 8 digital outputs

AOx: Displays a group of 4 analog outputs

MOT: Displays position and movement of a servomotor output

PRC.I: Displays generic process information

DIx: Displays a group of 8 digital inputs

AIx: Displays a group of 8 analog inputs

MIXER: Displays the status of the atmosphere mixer

FLWRT: Displays a flow ratio

KWH: Displays the power pickup

VOL.: Displays a media flow volume

RTC: Displays real time / calendar

PLC.S: Displays various PLC status information

following parameters apply on selection **SPACE** only:

01: display value(*value range SP00 to CH19*)

Selects the process value to be shown

following parameters apply on selection **VAL** only:

11: display value(*value range SP00 to CH19*)

Selects the process value to be shown

following parameters apply on selection **VAL-B** only:

21: display value(*value range SP00 to CH19*)

Selects the process value to be shown

following parameters apply on selection **VALx2** only:

31: display value(*value range SP00 to CH19*)

Selects the process value to be shown

following parameters apply on selection **CHAN** only:

41: channel info.....(value range CH00 to *CH'09)

Selects the channel to be shown

following parameters apply on selection **DOx** only:

51: DOx output(value range DO0 to DO7)

Selects a digital output (bit) to display

following parameters apply on selection **AOx** only:

61: AOx output(value range AO0 to AO3)

Selects an analog output to display

following parameters apply on selection **MOT** only:

71: step.mot.info(value range DO0.0 to DO7.7)

Used to display position and movement of a servomotor. The parameter selects the column number of the digital output which must be defined for servomotor operation

following parameters apply on selection **PRC.I** only:

81: info mode(options PROCS)

no explanation available

following parameters apply on selection **DIx** only:

91: DIx input(value range DI0 to DI7)

Selects a digital input (bit) to display

following parameters apply on selection **AIx** only:

101: AIx input(value range AI0 to AI3)

Selects an analog input to display

following parameters apply on selection **MIXER** only:

111: mixer info(value range 0 to 1)

no explanation available

following parameters apply on selection **FLWRT** only:

121: flow ratio.air.....(value range IN00 to IN19)

no explanation available

122: flow ratio.gas(value range IN00 to IN19)

no explanation available

following parameters apply on selection **KWH** only:

131: power calc.CH.(value range -CH25 to CH25)

Selects either a single control channel of a range of control channels used for calculating power pickup. Negative channel number stands for CH00 to CH.. *Example: "-CH02" will add up control channels CH00, CH01 and CH02*

132: power ratng.kw.....(value range 0 to 250)

Enter the total power of the kiln. The calculation assumes all zones having the same amount of power

following parameters apply on selection **VOL.** only:

141: volume calc(value range IN00 to IN19)

no explanation available

following parameters apply on selection **RTC** only:

151: time/date(value range 0 to 1)

"0" = time / "1" = date

following parameters apply on selection **PLC.S** only:

161: PLC type(value range 0 to 3)

Value to display : "0" = PLC variable / "1" = timer / "2" = counter

162: PLC index(value range 0 to 255)

Index of the value selected previously

Table 11: infograph

Applies only if the controllers is capable of displaying graphs (like TC M2). Different kind of display modes are available

00: graph type(options END, TIM/S, VALUE, CHAN, DOx, AOx)

Selects the kind of graphic used to show process parameters

TIM/S: Displays a time axis (including real time and programme segment information)

VALUE: Displays a process value as chart. Up to 4 process values can be shown in one chart together. Colors are assigned automatically

CHAN: Displays a channel output value as chart. Up to 4 channel output values can be shown in one chart together. Colors are assigned automatically

DOx: Displays up to 8 digital outputs. Note that depending on time scale short switching cycles disappear

AOx: Displays up to 4 analog outputs as chart

01: time scale(value range 0 to 18)

Select the grafic moving rate according to the speed of the process. The width of one grafic screen equals to 1=2.5 min / 2=5min / 3=10min / 4=20min / 5=40min / 6=1h / 7=2h / 8=4h / 9=8h / 10=16h / 11=1 day / 12=2 days / 13=4 days / 14=8 days / 15=16 days / 16=1 months / 17=2 months / 18=3 months

following parameters apply on selection **TIM/S** only:

02: time axis type(value range 0 to 1)

no explanation available

following parameters apply on selection **VALUE** only:

12: vertic. scale(value range 1 to 11)

Vertical extension of the graph. "1" equals to 10% of the total window height, "2"=20% etc. On some kind of graphs (e.g. digital outputs) the vertical extension of the graph is determined by the number of informations only. **Note:** Multiple graphs are shown together on the screen if they are adjusted to the same time scale as well as vertical display space is sufficient

13: grph.lower lim.(value range -10000 to 10000)

Sets the value representing the lower display border

14: grph.upper lim (value range -10000 to 10000)

Sets the value representing the upper display border

15: 1. graph val(value range SP00 to CH19)

16: 2. graph val..(value range OFF, SP00 to CH19)

17: 3. graph val..(value range OFF, SP00 to CH19)

18: 4. graph val..(value range OFF, SP00 to CH19)

Selects the process value shown as a graph

following parameters apply on selection **CHAN** only:

22: vertic. scale(value range 1 to 10)

Vertical extension of the graph. "1" equals to 10% of the total window height, "2"=20% etc. On some kind of graphs (e.g. digital outputs) the vertical extension of the graph is determined by the number of informations only. **Note:** Multiple graphs are shown together on the screen if they are adjusted to the same time scale as well as vertical display space is sufficient

23: CH graph range(value range 0 to 2)

Selects the display range of the channel output: 0=0 to +100% / 1=-100 to 0% / 2=-100 to +100%

24: 1. graph CH(value range CH00 to *CH'09)

25: 2. graph CH(value range OFF, CH00 to *CH'09)

26: 3. graph CH(value range OFF, CH00 to *CH'09)

27: 4. graph CH(value range OFF, CH00 to *CH'09)

Selects the channel output shown as a graph

following parameters apply on selection **DOx** only:

32: 1. graph DOx(value range DO0.0 to DO8.0)

33: 2. graph DOx(value range OFF, DO0.0 to DO8.0)

34: 3. graph DOx(value range OFF, DO0.0 to DO8.0)

35: 4. graph DOx(value range OFF, DO0.0 to DO8.0)

36: 5. graph DOx(value range OFF, DO0.0 to DO8.0)

37: 6. graph DOx(value range OFF, DO0.0 to DO8.0)

38: 7. graph DOx(value range OFF, DO0.0 to DO8.0)

39: 8. graph DOx(value range OFF, DO0.0 to DO8.0)

Selects a digital output shown as a graph

following parameters apply on selection **AOx** only:

42: 1. graph AOx.....(value range AO0.0 to AO4.0)

43: 2. graph AOx.....(value range OFF to AO4.0)

44: 3. graph AOx.....(value range OFF to AO4.0)

45: 4. graph AOx.....(value range OFF to AO4.0)

Selects an analog output shown as a graph

Table 12: systembus

The bentrup systembus is used to extend the inputs and outputs of the controller. The systembus clients are external devices which are linked serially to the controller. The following settings register the systembus clients at the controller

00: client type(options A.SET, END, NONE, SW808, DIO808, CNT808, AI812, TC802Z, MOT808, AO808, S1/M2)

Selects the systembus client types. Make sure that this setup matches the physical sequence of the clients. Enter "ASETUP" to read the presently connected members and re-enter configuration to manually adjust input / output assignement

SW808: Defines a SW808 digital output extension on the sysbus

DIO808: Defines a DIO808 digital input/output extension on the sysbus

AI812: Defines a AI812 analog input extension on the sysbus

TC802Z: Defines a TC802Z external zone controller on the sysbus

AO808: Defines a AO808 analog output extension on the sysbus

S1/M2: Defines a S1/M2 client on the sysbus

following parameters apply on selection **NONE** only:

01: SW808 data src.....(value range DO1 to DO7)

Selects the group of digital outputs represented by the client

following parameters apply on selection **SW808** only:

11: SW808 data src.....(value range DO1 to DO7)

Selects the group of digital outputs represented by the client

following parameters apply on selection **DIO808** only:

21: DIO808 dat.dst(value range DI1 to DI7)

Selects the group of digital inputs represented by the client

22: DIO808 dat.src(value range DO1 to DO7)

Selects the group of digital outputs represented by the client

following parameters apply on selection **CNT808** only:

31: CNT808 dat.dst(value range DI1 to DI7)

no explanation available

32: CNT808 dat.src(value range DO1 to DO7)

no explanation available

following parameters apply on selection **AI812** only:

41: AI812 data dst(value range AI1 to AI3)

Selects the group of analog inputs represented by the client

following parameters apply on selection **TC802Z** only:

51: TC802Z dat.dst(value range IN00 to IN19)

no explanation available

52: TC802Z dat.src(value range CH00 to *CH'09)

no explanation available

following parameters apply on selection **MOT808** only:

61: MOT808 motor A(value range 0 to 19)

no explanation available

62: MOT808 motor B(value range 0 to 19)

no explanation available

following parameters apply on selection **AO808** only:

71: AO808 data src(value range AO1 to AO3)

Selects the group of analog outputs represented by the client

following parameters apply on selection **S1/M2** only:

81: S1/M2 com typ(value range 0 to 0)

no explanation available

Table 13: virtual input

Virtual inputs allow very flexible control loops. Depending to the configuration setup process parameters are automatically assigned to the virtual input

00: select type(options *END, AVG, MIN, MAX, SEL*)

Selects the kind of algorithm used to create the virtual input:

AVG: Virtual input is calculated by averaging all specified inputs. If one of the inputs is in error state (overrun etc.) it is not considered

MIN: Virtual input is created by picking the input representing the lowest value of all specified inputs. An input in error state is not considered

MAX: Virtual input is created by picking the input representing the highest value of all specified inputs. An input in error state is not considered

SEL: Virtual input is created by picking the input selected according to the specified bits (ie. virtual input operates as multiplexer)

01: input A(value range *SP00 to CH19*)

02: input B(value range *OFF, SP00 to CH19*)

03: input C(value range *OFF, SP00 to CH19*)

04: input D(value range *OFF, SP00 to CH19*)

Selects the process parameters to be used for calculation. Set unused process parameters to "OFF"

following parameters apply on selection **AVG** only:

05: value offset A(value range *-9999 to 9999*)

06: value offset B(value range *-9999 to 9999*)

07: value offset C.....(value range *-9999 to 9999*)

08: value offset D(value range *-9999 to 9999*)

This value is added to the corresponding process parameter before calculation. Can be used for example to make selection of thermocouple dependant on temperature deviations

following parameters apply on selection **MIN** only:

15: value offset A(value range *-9999 to 9999*)

16: value offset B(value range *-9999 to 9999*)

17: value offset C.....(value range *-9999 to 9999*)

18: value offset D(value range *-9999 to 9999*)

This value is added to the corresponding process parameter before calculation. Can be used for example to make selection of thermocouple dependant on temperature deviations

following parameters apply on selection **MAX** only:

25: value offset A(value range -9999 to 9999)

26: value offset B(value range -9999 to 9999)

27: value offset C.....(value range -9999 to 9999)

28: value offset D(value range -9999 to 9999)

This value is added to the corresponding process parameter before calculation. Can be used for example to make selection of thermocouple dependant on temperature deviations

following parameters apply on selection **SEL** only:

35: output sel.A.....(value range DO0.0 to DO8.0)

Sets the bit (digital output) to be used for the selection of the thermocouple. Can be used to change the temperature sensor used for controlling automatically during programme run (e.g. using an EVENT)

36: output sel.B(value range OFF, DO0.0 to DO8.0)

As before, but selects between options 0/1 and 2/3. Set to "OFF" if not used

Table 14: motor char.

Some output devices have a non-linear characteristic. A typical example is a butterfly valve. Each motor characteristic is a list of value pairs **controller percentage output vs. required (true) percentage output**. Missing values are interpolated. A motor characteristic can be selected as "output char." in "digital output - motorized valve

00: outp % on 0%(value range 0 to 100)

01: outp % on 7%(value range 0 to 100)

02: outp % on 14%(value range 0 to 100)

03: outp % on 21%(value range 0 to 100)

04: outp % on 29%(value range 0 to 100)

05: outp % on 36%(value range 0 to 100)

06: outp % on 43%(value range 0 to 100)

07: outp % on 50%(value range 0 to 100)

08: outp % on 57%(value range 0 to 100)

09: outp % on 64%(value range 0 to 100)

10: outp % on 71%(value range 0 to 100)

11: outp % on 79%(value range 0 to 100)

12: outp % on 86%(value range 0 to 100)

13: outp % on 93%(value range 0 to 100)

14: outp % on 100%(value range 0 to 100)

Enter the actual position which equals to the this control output

Table 15: atmosph. mix. setup

The atmosphere mixer allows the controller to operate the core of a smart complex control system for any gas fired kiln. The basic operation modes are **air excess**, **stoichiometric**, **cooling**. In **air excess** mode the heat up power controls the amount of gas (gas leads air by a ratio control). In **stoichiometric** mode the heat up power controls the amount of air (air leads gas). In **cooling** mode the cooling power controls inverted the amount of air (gas closed)

00: tempCtrl 0 CH(value range OFF, CH00 to CH09)

01: tempCtrl 1 CH(value range OFF, CH00 to CH09)

02: tempCtrl 2 CH(value range OFF, CH00 to CH09)

Selects the control channel which controls the temperature for this zone

03: atmosphere SP(value range OFF, SP00 to SP09)

Selects the setpoint representing the atmosphere

04: atmosphere AI(value range OFF, IN00 to IN19)

no explanation available

05: cooling Dxx(value range OFF, DO0.0 to DO8.0)

Selects the digital output (bit) used for cooling mode activation. This information is required by the mixer

06: air flow 0 AI ..(value range OFF, IN00 to IN19)

07: air flow 1 AI ..(value range OFF, IN00 to IN19)

08: air flow 2 AI ..(value range OFF, IN00 to IN19)

Selects the process parameter representing the actual air flow for this zone

09: gas flow 0 AI.(value range OFF, IN00 to IN19)

10: gas flow 1 AI.(value range OFF, IN00 to IN19)

11: gas flow 2 AI.(value range OFF, IN00 to IN19)

Selects the process parameter representing the actual gas flow for this zone

Table 16: atmosph. mix. adj.

Fine tune parameters for the stoichiometric mode of the atmosphere mixer

00: max % gas airX.....(value range 30 to 100)

Limits the maximum amount of air during AIR EXCESS mode. Typically used to set 4% O2 on maximum power

01: min % air stoi.....(value range 0 to 70)

Limits the minimum amount of air during STOCHIOMETRIC mode. Typically used to limit air/gas ratio to normal operation range

02: air/gas @ 4%O2.....(value range 1.0 to 40.0)

volume ratio air / gas on n=1.2 (ie. 4% O2)

03: fact. @ 0.4%O2(value range 1.0 to 1.00)

04: fact. @ 0.1%O2(value range 1.0 to 1.00)

05: fact. @ 0.1%CO(value range 1.0 to 1.00)

06: fact. @ 0.4%CO(value range 1.0 to 1.00)

07: fact. @ 4.0%CO(value range 1.0 to 1.00)

coefficient respecting to $n=1.2$ to reach the atmosphere

08: corr.each+100K(value range 1.0 to 1.50)

coefficient to compensate factor for each +100K increase in temperature

09: PWR corr.@ CO%(value range 0 to 100)

The controller assumes essential stronger temperature increase on reduction. The grade of anticipation is defined by this parameter (100% = double power on 0.5% CO)

10: max.rat.mod. %.....(value range 0 to 75)

Maximum amount of modulation of the ratio by the atmosphere control loop

11: atms.integral(value range 10 to 10000)

integral time for the atmosphere control loop

12: atms.dev.eval.(value range 1.0 to 4.0)

Actual deviation is powered by this value before adding to the integral. Use to obtain non-linear control characteristic