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SETUP OF THE KBIC-120 90VDC DRIVE BOARD

Caution! The following instructions refer to settings to be performed with a dangerous level of voltage present and mechanical movement and action occurring. These instructions should be performed only by persons trained accordingly and authorized by your facility.

If the setup of the KBIC-120 is required, it should be performed before the setup of the KBSI-240D Isolation-Follower board. Throughout this setup procedure, the idle pot will be referenced. This device is the remotely-mounted potentiometer located on the right side of the control panel's backing plate.

Before beginning this procedure, it is recommended that the Gartech Glue System be cleaned of dried glue in all areas, especially inside both Gartech Glue Shoes and Gartech Glue Wheels. If equipped with Advanced Wash Cycle function, this should be performed prior to shutting down the system.

It is important to follow the setup as described and in order.

Step 1: Adjust the maximum (Max) speed of the KBIC-120 to 50% of scale.

Step 2: Adjust the Idle Pot fully counter-clockwise (CCW).

Step 3: Adjust the Accel of the KBIC-120 fully counter-clockwise (CCW). The turn clockwise (CW) to achieve .3 seconds of acceleration time. Note: This should be checked with the Gartech Glue System idling and with a rapid increase of the Idle Pot from counter-clockwise position to fully clockwise.

Step 4: Adjust the Idle Pot fully clockwise. With a DC volt meter connected to A1 and A2, adjust the maximum speed on the KBIC-120 to achieve 90 VDC.

Step 5: Adjust the Idle Pot fully counter-clockwise and adjust the minimum (Min) speed of the KBIC-120 to the position where the Gartech Glue Wheels are barely turning.

(continued)

Step 6: Repeat steps 4 and 5 until both are true; meaning 90VDC is achieved and, at Min, the wheels are barely turning.

Step 7: Adjust the IR Comp on the KBIC-120 clockwise while rapidly increasing speed with the Idle Pot only. Each time the IR Comp is increased, check for instability of the glue wheel speed after accelerating. Once instability is found, decrease the IR Comp by turning counter-clockwise until stability is achieved. After stability is obtained, adjust the IR Comp and additional 5% of scale counter-clockwise.

Step 8: Adjust the Current Limit (CL) 25% of scale. Adjust the Idle Pot to 25% of scale. The Gartech Glue Wheel or output shaft must be locked for this setting. With the motor turned on, and an amperage meter monitoring the current on A1, adjust the CL clockwise until a setting of 16 amperes is achieved.

Step 9: After unlocking the Gartech Glue Wheel or motor, the Idle Pot should be adjusted to a setting of approximately 9 VDC on A1 and A2 or a satisfactory Idle Speed of the Gartech Glue Wheel.

SETUP OF THE KBSI-240D ISOLATION-FOLLOW BOARD

Caution! The following instructions refer to settings to be performed with a dangerous level of voltage present and mechanical movement and action occurring. These instructions should be performed only by persons trained accordingly and authorized by your facility.

These instructions detail the speed-scaling setup of the Gartech Glue System. If the Gartech Glue Wheel suddenly appears to not be following at a correct speed, both upper and lower wheels, as well as the Gartech Glue Shoes, should be removed and inspected for dried glue or burrs. It is not recommended to continue this calibration process otherwise. If the parts are dirty and producing excessive drag, clean, re-install, and recheck the speed.

If the setup of the KBIC-120 is also required, it should be performed before the setup of the KBIC-240D board.

Before beginning this procedure, it is recommended that the Gartech Glue System be cleaned of dried glue in all areas, especially inside both Gartech Glue Shoes and Gartech Glue Wheels. If equipped with Advanced Wash Cycle function, this should be performed prior to shutting down the system. The Gartech Glue Shoe should be reset to meter .0025” of glue and a Glue Cycle turned on.

Step 1: With the press running at the MINIMUM speed, and a Glue Cycle chosen for either the Upper or Lower Gartech Glue Wheel, determine the current speed of the folding rail belts with a handheld tachometer or accurate laser tachometer. It is important to check this measurement at a place where the belt is flat, and not upon a wheel or pulley, to provide an accurate reading. Record the reading and check the speed of the Gartech Glue Wheel or Gartech Pressure Wheel that is not applying glue in the present Glue Cycle. (If running Lower Glue, check the upper wheel.) On the KBSI-240D, find the 20-turn potentiometer (Pot) that is labeled MIN. Adjust this pot until the speed of the Gartech Glue Wheel matches the speed of the folding rail belt.

Note: Adjust only the MIN Pot on the KBSI-240D.

Step 2: With the press running at MAXIMUM speed, determine the folding rail belts with the handheld tachometer. Record the reading, and check the surface speed of the Gartech Glue Wheel or Gartech Pressure Wheel. Adjust this Pot until the speed of the Gartech Glue System matches that of the folding rail belt.

Note: Adjust only the MAX Pot on the KBSI-240D.

Step 3: Repeat STEP 1, then repeat STEP 2. Continue this process until both are satisfied.

Note: It's normal to repeat these steps 3-5 times. Also, given that DC-based technology cannot track as closely as AC-based technology, speeds will not match identically. 5% speed regulation is optimal. (With an AC-based system, speed regulation would be 1% and the KBIC-120 board is eliminated.)

CORRECTING SCALED REFERENCE OFFSET

If, while adjusting the MIN or the MAX settings, one of the pots should become noticeably more sensitive than the other, the offset may be corrected in this manner:

If the MIN is more sensitive, decrease the MAX by 1 turn counter-clockwise and continue STEP 1, or increase the MIN by 1 turn clockwise and continue STEP 2.

If the MAX is more sensitive, decrease the MIN by 1 turn counter clockwise and continue STEP 2, or increase MAX by 1 turn clockwise and continue STEP 1.

If you need additional help, you can reach our office by calling 217.324.6527 or our service techs:

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