INSTRUCTION MANUAL Addendum
VERSATEC™ S15
MODELS: VTC-S15 & VTCE-S15

Description

The VERSATEC S15 incorporates the following changes from the standard VERSATEC:

1. The only mode available is DANCER with SPEED output.
2. Taper Tension, Diameter Sensor and Tension Output are all functions that are enabled by default.
3. Diameter calculation is preformed for a surface winding application. For this application, the distance from the US-2 sensor to the axis of rotation changes.
4. A splice time feature has been added to accommodate a flying spice.
5. Gain Scheduling and the Remote TENSION UP/ TENSION DOWN feature have been disabled.

Dancer Mode Setup

Refer to the VERSATEC instruction manual (850A232-1) for installation instructions and electrical connections.
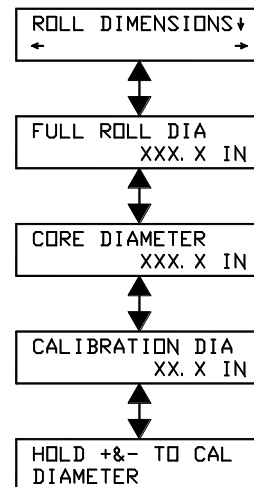
Setup cannot be performed if E-Stop is open, or if RUN/STOP is in run mode.

1. Configure the diameter signal.

Press **PROGRAM**, and ← or → to enter the Roll Dimensions menu. Press ↓. Enter the maximum Full Roll Diameter, the minimum Core Diameter and the Calibration Diameter. Calibration Diameter is the current diameter of the roll that is presently on the machine.
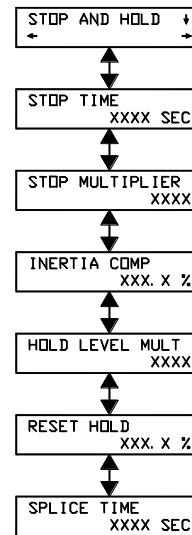
2. Calibrate Diameter

With the Calibration Diameter equal to the present Diameter, Press **+** and **-** until the display says OK. Press ↓.

```
┌──────────────────────┐
│ ROLL DIMENSIONS↓      │
│ ←                  →  │
└──────────────────────┘
           ↕
┌──────────────────────┐
│ FULL ROLL DIA        │
│             XXX.X IN  │
└──────────────────────┘
           ↕
┌──────────────────────┐
│ CORE DIAMETER        │
│             XXX.X IN  │
└──────────────────────┘
           ↕
┌──────────────────────┐
│ CALIBRATION DIA      │
│              XX.X IN  │
└──────────────────────┘
           ↕
┌──────────────────────┐
│ HOLD +&- TO CAL      │
│ DIAMETER             │
└──────────────────────┘
```

3. Splice Feature

Press **PROGRAM** and ← or → to enter the Stop and Hold menu. Press ↓. Enter the Splice Time.

The splice feature provides a splice input signal (TB3-18) and a splice time for changing rolls. The splice time is entered in seconds. Upon a momentary contact closure betweenTB3.18 and TB3.15, the diameter value is forced to the core diameter for the duration of the splice time. The normal diameter display is returned when the splice time expires.

```
┌─────────────────────┐
│ STOP AND HOLD    ↓  │
│ ←                →  │
└─────────────────────┘
          ↕
┌─────────────────────┐
│ STOP TIME           │
│            XXXX SEC │
└─────────────────────┘
          ↕
┌─────────────────────┐
│ STOP MULTIPLIER     │
│                XXXX │
└─────────────────────┘
          ↕
┌─────────────────────┐
│ INERTIA COMP        │
│            XXX.X %  │
└─────────────────────┘
          ↕
┌─────────────────────┐
│ HOLD LEVEL MULT     │
│                XXXX │
└─────────────────────┘
          ↕
┌─────────────────────┐
│ RESET HOLD          │
│            XXX.X %  │
└─────────────────────┘
          ↕
┌─────────────────────┐
│ SPLICE TIME         │
│            XXXX SEC │
└─────────────────────┘
```

4. Set the Dancer Position

Press **PROGRAM**, ↓ to enter the Dynamic Tuning menu.
While holding the dancer arm in the desired running position, press **+** and **-** until the display says OK.
Press ↓.

5. Tuning

The screen to the right is the Tuning screen.

Pressing ← or → when in this screen chooses CORE, FULL, or EXIT. Pressing ↑ or ↓ adjusts the dancer position (if necessary). Pressing **+** or **–** adjusts the tuning (**+** will normally increase the stability and **–** will increase the responsiveness.)

```
┌────────────────────────┐
│ TUNE+-         POS↑↓   │
│ ←FULL CORE EXIT→       │
└────────────────────────┘
```

In the following steps, the words **+** (FULL) means to press **+** when FULL is selected, **-** (FULL) means to press **–** while FULL is selected, etc. When asked to "STABLIZE" an oscillation, perform one of the following steps:

1. If the dancer is oscillating rapidly (faster than several seconds per cycle), press + until the oscillation stops.

                                              OR

2. If the dancer is oscillating slowly (several seconds per cycle), press – until the oscillation stops.

   NOTE: The next step requires that the machine be running near full roll. If this is a rewind, a preliminary adjustment can be made at core with final tuning done at full roll. If the dancer position oscillates during winding, use the appropriate method above to stop the oscillation.

With a full roll mounted, run the machine at a low speed.
If the dancer position is oscillating stabilize the dancer. If necessary, adjust the dancer position using ↑ or ↓.
If the dancer position is not oscillating, press **–** (FULL) until the dancer position begins to oscillate.

NOTE: The next step requires that the machine be running near core. If this is an unwind you may mount a small roll, or you may continue to unwind until the roll approaches core. Select CORE. If the dancer position oscillates at any time during the unwind stabilize the dancer.

Press ← or → to select CORE.
Run the machine at a low speed near core.
If the dancer position is oscillating stabilize the dancer.
If the dancer position is not oscillating, press **–** (CORE) until the dancer position begins to oscillate, and then press **+** (CORE) until oscillations stop.

Tuning is complete. Select EXIT and press ↓. This screen shows the condition of AUTO POSITION. It will normally be ON after tuning CORE and OFF after tuning FULL. It can be turned ON or OFF using this screen, but it is best left ON. If controlling a torque device with diameter signal, the AUTO POSITION is always ON, so the AUTO POSITION screen does not display in this mode.
Press **HOME**.