CHAPTER 9 Technical Manual

1. The shipment setting value for the controller

The parameter for the user setting mode

Of pushing SV switch every, the parameter indicator switches over. But when pushing SV switch more than 5 seconds, changes to the engineering setting mode. Be careful.

Use	Character	Setting range	Initial setting value
Dry temperature	SV	0~160°C	80°C
Start-up timer	dLY	0.0~99.5 hour	0.0 hour
NO.1 Convey time	Fd1	0~999 sec.	20 sec.(MJ3-10～150)
			25 sec.(MJ3-200～300)
NO.2 Convey time	Fd2	0~999 sec.	15 sec. (MJ3-10～150)
			25 sec.(MJ3-200～300)
NO.3 Convey time	Fd3	0~999 sec.	15 sec. (MJ3-10～150)
			25 sec.(MJ3-200～300)
NO.1 Discharge time	dc1	0~999 sec.	25 sec.
NO.2 Discharge time	dc2	0~999 sec.	25 sec.
NO.3 Discharge time	dc3	0~999 sec.	25 sec.
NO.2 Raw material beginning time	bt2	0~99 sec.	2 sec.
NO.3 Raw material beginning time	bt3	0~99 sec.	2 sec.

The parameter for the engineering setting mode

When pushing SV switch more than 5 seconds, changes to the engineering setting mode. Of pushing SV switch every by the engineering setting mode, the character switches over.

Use	Character	Setting range	Initial setting value
Upper limit temperature alarm detection delay time	ULt	0~999 sec.	(*1)5 sec.
Feed 1 Convey malfunction detection count	LCt	0~999 count	50 count
Dry unit level gage malfunction count	FCt	0~999 count	20 count
Feed 1 Convey malfunction detection delay time	1Ed	0~999 min.	120 min.
Feed 2 Convey malfunction detection delay time	2Ed	0~999 sec.	180 sec.
Feed 3 Convey malfunction detection delay time	3Ed	0~999 sec.	180 sec.
Upper limit temperature alarm (dry temperature deviation)	dUS	0~40°C	(*1)10°C
Upper limit temperature alarm (regeneration temperature deviation)	rUS	0~40°C	(*1)10°C
Dry system broken detection time (dry)	dLP	0~999 min.	0 min.
Regeneration system broken detection time (regeneration)	rLP	0~999 min.	0 min.
Feed1 Level switch demand delay	L1d	0~999 sec.	3 sec.
Feed2 Level switch demand delay	L2d	0~999 sec.	3 sec.
Feed3 Level switch demand delay	L3d	0~999 sec.	3 sec.

⚠ CAUTION For the safety, please use *1-marked portion with initial setting value. Operation should be absolutely avoided with high setting value more than necessary. It causes detecting delay in the event of failure, breakdowns and accidents.

2. The start-up method for the auto tuning

(1)During the dry unit operating, starts the auto tuning when push continuing ▲ and ▼ key at the same time for 2 seconds during display of the dry temperature measurement value. (During auto tuning, displays alternately at the period in 1 second in the measurement temperature and “At”)

(2) When the auto tuning ends, returns to usual PV display and starts PID control by the adjustment result.

(3)The operation when stopping auto tuning compulsorily is the operation that is the same as (1) completely.

※ Because this controller isn't displaying an error in the auto tuning, when the auto tuning error occurs, (when a sensor is broken or the auto tuning time passes for equal to or more than 3 hours) doesn't perform the display and the buzzer alarm operation.
Also, when the auto tuning error occurs once, in the power, unless restarting, it isn't possible for the auto tuning to be again.

3. About influence of gas that occurs from the resin

The information on influence of gas that occurs from the resin

The unit sometimes can’t function normally with influence of gas that occurs from the resin.
As for the resin that releases gases, suppressing the influence of gas becomes necessary.
There are different methods of installing a gas collecting unit which are compatible. However, the method must be chosen by the dry material.
Also, currently there is not a solution to all resins.
Therefore, depending on the resin, the constant regular maintenance and the replacements of consumable parts become necessary.
When the following phenomenon is confirmed during use, there is possibility that the unit undergoes influence by gas. In such case, please consult with us.

1) The oily liquid that oozes from the filter box, the pipe connection part and the dry hopper etc.
2) There is discoloration in the filter box. Or, adheres to oil.
3) The thin smoke from the regeneration exhaust port.
4) Oil covering the whole unit.
5) Oil adheres to the floor.

As for the resin that has possible influence of gas, refer to the list the next page