

Variable Frequency Drive (VFD)

There are parameters for the VFD that should be set prior to you receiving the machine. To ensure they are set properly or to reset the parameters upon replacement of a VFD here are the instructions and the factory defaults.

Instructions



Press the “Sel” button until you see the display change to a letter followed by numbers. The letter should be flashing. Press the up arrow to change the letter. Stop on the “P” letter.

Press the “Sel” button again and the last digit should start flashing. Press the up or down arrow to change the number to whichever parameter you wish to adjust. Stop on that parameter number (i.e. stop on P039).

Press the “Sel” button again and the display should change to the value for that particular parameter. The last digit of the value should be flashing. Press the up or down arrow to change the value of the parameter. In the case of P039 stop on “0.5” for the best acceleration from a dead stop. Hit the “Enter” button (it looks like an arrow pointing to the left) and the value should stop flashing.

Now press the “Esc” button until you get back to the main screen as it appears in the photo above.

Factory Defaults:

P035 = 55*	Maximum Hertz
P036 = 2	Sets the start and stop from wired switches.
P038 = 2**	
P039 = 0.5***	
P040 = 0.1****	

Key notes:

*P035 Controls the maximum frequency in Hertz of the machine. Set to 55 the machine should not cycle faster than 40 cycles per minute (CPM). Changing this and running faster than 40 CPM can cause additional table detent faults, excessive wear to the VFD through hesitation of the filler and increase damage should a jam occur.

**P038 Controls the input method for speed control. If it is set to “2” then speed is controlled from the speed pot on the touch screen panel. If it is set to “0” then speed is controlled from the speed pot on the VFD (effectively overriding the operator’s ability to change the speed).

***P039 controls the acceleration of the machine from a dead stop. We have found that setting this to 0.5 keeps the machine from creating unnecessary table detent faults. If you are finding that you still receive table detent faults because the table is starting too fast, increase this up to 1.0. This will only affect the initial start up. It will not affect normal indexing of the machine.

**** P040 controls the deceleration of the machine from the time the machine logic signals the VFD to stop. We recommend leaving this as is, because the machine is timed to stop with the heater head in the up position. Changing this can lead to the table stopping with the heater head in the down position leaving a heat source directly on a cup.