HMI OPERATING SCREENS

INTRODUCTION

HolwegWeber machines are manufactured to fit with a multitude of floor plans and customized layouts to suit the customer's needs. The Human Machine Interface (HMI) screens are standardized panels to be compatible with the machine varieties. Items/features that are size specific are noted when applicable. However, some features may not be present or available on your machine.

GETTING STARTED

To aid the machine operators, certain methods and conventions have been adopted for the HMI screens. It is highly recommended that these methods and conventions are reviewed prior to reading the rest of the manual or operating the machine.

GENERAL SCREEN SYMBOL CONVENTIONS

The following selectors are used universally across the screens on the HMI Panel. Some are allocated for production only and other are allocated for non-production only.

SELECTOR	SCREEN ALLOCATED	DESCRIPTION
⚙	PRODUCTION	Provides additional information, status, and/or control parameters.
☰	PRODUCTION	Provides a menu to all non-Production touchscreens. Located at top of screen.
✕	PRODUCTION	Closes current screen and associated visible screen pop-up screens
◀ ▶	NON-PRODUCTION	Progresses operator to next screen or digresses to the previous screen.
◯	BOTH	Universal state indicator. Color state varies depending on machine status.

COLOR	MACHINE STATE
GRAY	OFF
GREEN	ON
AMBER	INTERMEDIATE
FLASHING	TRANSITIONING

DATA ENTRY

Entering data in the HMI Panel screens is an important part of customizing the machine setup to fit your needs. Operator data entry is available in areas with white background.

FIGURE 1. NON-PRODUCTION ITEMS MENU

Data Entry Box (Typical)
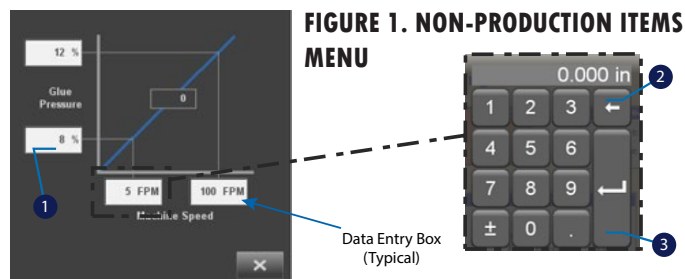
EXAMPLE

Change the low-speed pressure glue by tapping over the GLUE PRESSURE value (Figure 1, Item 1). Once selected, a pop-up buttonpad will show (Figure 1) for operator to punch in desired value.

IMPORTANT

If any screen area is selected outside the buttonpad, the data entry will be aborted, the value will not be updated, and the buttonpad will dis show.

FIGURE 2. LOCKED DATA ENTRY INPUT

Data Entry Box (Typical)
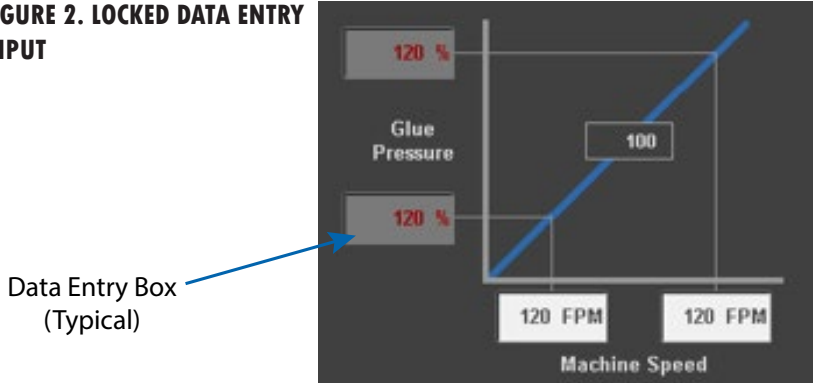
Some data entry input locations may be locked depending on the current user level. If locked, a dark gray background with dark red characters shows and no input is permitted.

FIGURE 3. ALPHA-NUMERIC KEYPAD

ALPHA-NUMERIC BUTTONPAD

Sometimes other input text is required beside numerical to provide enough information for the system to complete the task. When alpha-text is require an alpha-numeric button popup will show.

NOTE

The spacebar (Figure 3, Item 1) is located in the lower right-hand corner of the buttonpad.

TWO-STEP MOTION SEQUENCE

For operator safety, this machine is equipped with a two-step sequence to initiate any machine motion.

INITIATING MOTION

1. Press and hold a button while the warning horn sounds.

2. Once the warning horn stops, release the button momentarily.

3. Once released, the operator will have approximately 4 seconds to press the button again.

Once set, the machine will start its commanded motion.

REQUIRED 2-STEP MOTION SEQUENCES INCLUDE

- Machine Jog
- Run
- Reference

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SCREEN TYPES

Two screens types are preset on the HMI Panel depending on screen function.

| SCREEN TYPE	DESIGNATION
Production touchscreens	General Machine operation
Non-Production touchscreens	Setup, Maintenance, and General Information

PRODUCTION TOUCHSCREEN BASICS

UNDERSTANDING THE PRODUCTION TOUCHSCREEN

Production touchscreens consist of various windows to provide status and control for modules on the machine line. See Figure 4 below for typical Production touchscreen.

HEADER ⟶

BODY ⟶

CONTROL ⟶
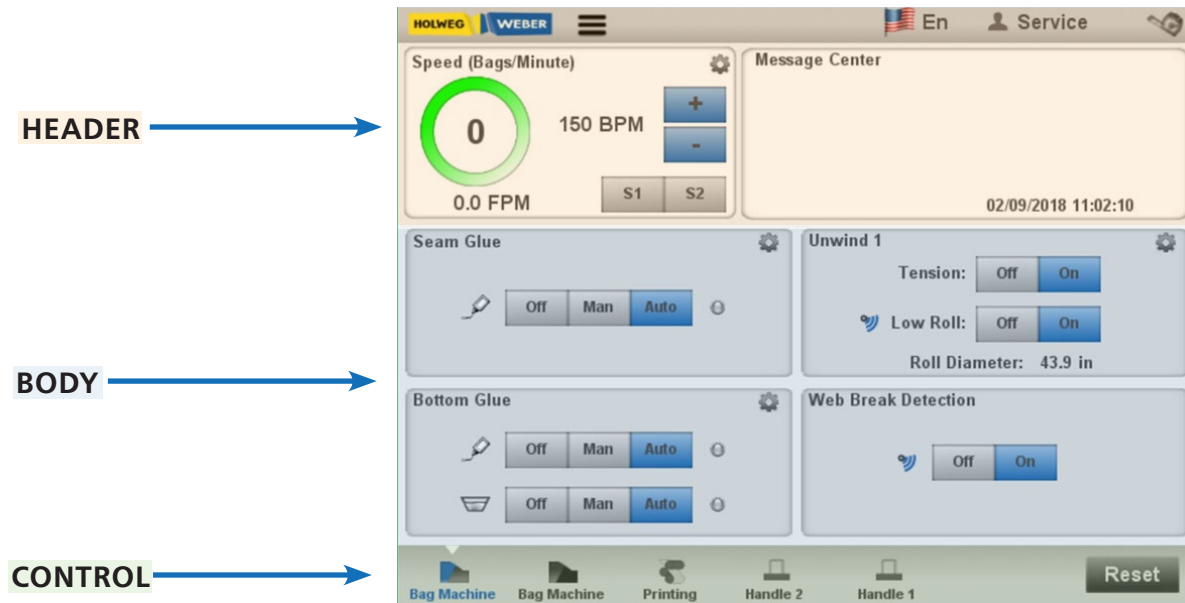
FIGURE 4

HMI PANEL PRODUCTION TOUCHSCREEN INTERFACE
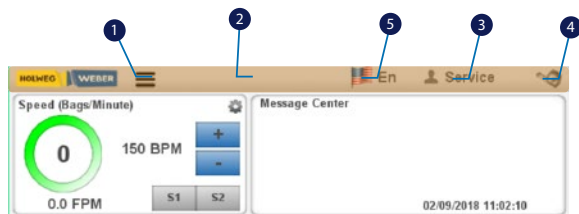
FIGURE 5. PRODUCTION SCREEN HEADER

HEADER

The HEADER interface displays the current commanded and actual speed information. The header is displayed at the top of all screens.

MENU ACCESS CONTROL

The Menu (Figure 5, Item 1) takes HMI to the menu screen. This gives the operator access to all non-Production touchscreens.

ASSET TAG INDICATION

This Asset Tag Indication (Figure 5, Item 2) displays the machine asset tag for identification purposes. The alphanumeric tags can be set/changed on the

machine info screen.

USER LEVEL INDICATION

The User Level Indication (Figure 5, Item 3) indicates the current user level.

IMPERIAL/METRIC CONTROL

Selecting the Imperial/Metric Control (Figure 5, Item 5) image changes the HMI display units between imperial (i.e. inch) and metric (i.e. millimeter) units.

FIGURE 6. PRODUCTION SCREEN BODY

BODY

The Production touchscreen body is broken up into three sections:

1. **Status**
2. **Indication**
3. **Control**

STATUS WINDOW (1) FUNCTION

SPEED (BAGS/MINUTE)

The Speed (Bags/Minute) window provides the current machine speed, speed set point, and overall machine status.

MESSAGE CENTER (2) FUNCTION

The Message Center window provides current warnings and alarms as well as the current recipe and date/time.

MODULE WINDOWS (3) FUNCTION

The Module windows are dedicated to specific functions/sections of the machine line. They can show status as well as control items for each module.

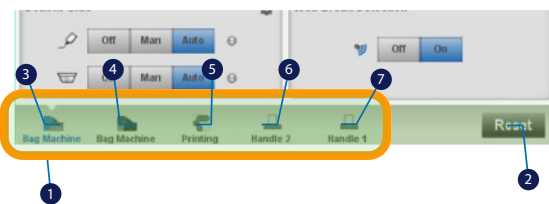**FIGURE 7. PRODUCTION SCREEN FOOTER**

CONTROL

The Control Section (Figure 7) at the bottom of the menu provides navigation between Production touchscreens (Figure 7, Item 1). Additionally, the System Reset Button (Figure 7, Item 2) is available on the right side of the Control Section. The System Reset Button resets the input from the user and puts the calculated program information back to base settings.

NAVIGATION HOTSPOT

The Navigation Hotspot (Figure 7, Item 1) at the left side of the Control Section contains menu selections (Figure 7, Item 3 - 7) that takes the user to a new menu screen based on selection.

NOTE

Navigation Hotspot selectors vary depending on customer specified machine floor plan.

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IMPORTANT

Two Bag Machine screen selectors (Figure 7, Item 3 & 4) are allocated within the Navigation Hotspot. Both screen selectors take the user to functions that control the bag machine. Both pages have separate functions that control the bag machine. Two selectors are appointed to allow space for all functions have appropriate settings.

BAG MACHINE BUTTON (FAR LEFT)

The Bag Machine button (Figure 8, Item 9) at the far left of the screen takes the user to the first bag machine Production touchscreen. The current bag machine screen contains bag production setup for set 1 - 4 of 8 total items that require bag machine setup.

1. **Seam Glue**
2. **Bottom Glue**
3. **Print Registration**
4. **Bag Machine General items**

FIGURE 8. BAG MACHINE BUTTON (FAR LEFT) PRODUCTION SETUP FUNCTIONS

BAG MACHINE BUTTON (2ND BUTTON)

The Bag Machine button (Figure 9, Item 10), directly to the right of the first Bag Machine button (Figure 8, Item 9), takes the user to the second bag machine Production touchscreen. The current bag machine screen contains bag production setup for set 5 - 8 of 8 total items that require bag machine setup.
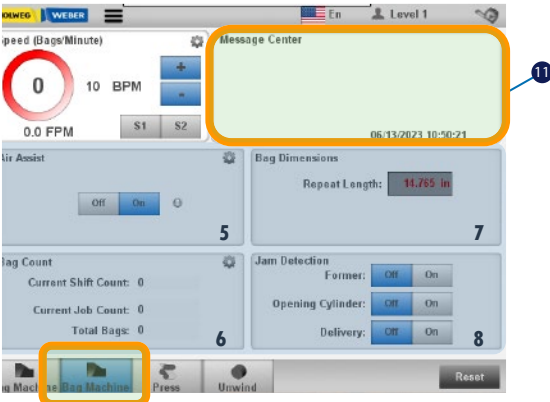

5. **Air Assist**
6. **Bag Count**
7. **Bag Dimension**
8. **Jam Detection**

FIGURE 9. BAG MACHINE BUTTON (2ND BAG MACHINE BUTTON) PRODUCTION SETUP FUNCTIONS

RESET BUTTON

The Reset button (Figure 7, Item 2) resets all displayed alarms not currently in an error state.

EXAMPLE

If the message center indicates that E-stop button 1 and E-stop button 2 are active…but only E-stop 1 button has been pulled out to the non-active position, pressing the reset button will only remove the E-stop 1 button active message…the E-stop 2 button active message will remain on the message center display.

PRODUCTION TOUCHSCREENS CONTROLS AND FUNCTIONS

The Production touchscreen interface controls the setup, preferences, and fine-tune settings for optimal bag production. This section provides an in depth layout of the controls and functions allocated on the Production touchscreen interface.
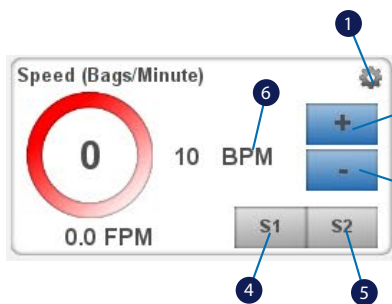
NOTE

Some screens/options may not be available on your machine.

1. Speed (Bags/Minute)
2. Message Center
3. Seam Glue
4. Print Registration
5. Bottom Glue
6. Bag Machine General

FIGURE 10. BAG MACHINE PRODUCTION TOUCH-SCREEN WINDOW FUNCTION DESCRIPTIONS

1. Settings
2. BPM Increase Speed
3. BPM Decrease Speed
4. Speed Saved Setting 1
5. Speed Saved Setting 2
6. Speed (Bags/Minute)

FIGURE 11. PRODUCTION SCREEN - SPEED WINDOW CONTROLS AND FUNCTIONS

SPEED WINDOW

The SPEED (BAGS/MINUTE) window (Figure 10, Item 1), located in the upper left corner of all production touchscreens, controls the quantity of bags produced per minute with two user saved speeds.

Machine line speed is set point in bags per minute (BPM) (Figure 11, Item 6). The value is directly entered by tapping on the value and then using the pop-up buttonpad to enter the data.

(+) PLUS BUTTON

- Selecting the (+) plus button (Figure 11, Item 2) **once**

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increases the machine line speed set point by **1 bag/minute (BPM)**.

- Select and **holding** the (+) plus button will **increase** the set point **rapidly**.

(-) MINUS BUTTON

- Selecting the (-) minus button (Figure 11, Item 3) **once decreases** the machine line speed set point by **1 bag/minute (BPM)**.

- Select and **holding** the (-) minus button **decreases** the set point **rapidly**.

S1 BUTTON

The S1 button (Figure 11, Item 4) transfers Speed Preset 1 into the current machine line speed set point.

S2 BUTTON

The S2 button (Figure 11, Item 4) transfers Speed Preset 2 into the current machine line speed set point.

SETTINGS BUTTON

The Settings button (Figure 11, Item 1) opens a settings window to access additional data related to the machine line speed.

FIGURE 12. BAG SPEED PRESET S1 & S2

SPEED PRESET WINDOW

S1 Speed Preset 1 is set in BPM (Bags Per Minute). A new value can be entered by tapping on the value and using the popup buttonpad to enter the data.

S2 Speed Preset 2 in BPM. A new value can be entered by tapping on the value and using the popup buttonpad to enter the data.

MACHINE LINE INDICATOR COLOR STATES

ALARM STATE

A red circle (Figure 12, Item 1) indicates an alarm is active that will **NOT** allow the machine to run or jog.

WARNING STATE

A yellow circle (Figure 12, Item 1) indicates the machine is in a warning state. A warning notification shows in the message center (Figure 10, Item 2) indicating that an issue is about to occur. While in a warning state the machine will typically run at a normal operating level in jog mode.

Examples of warnings that show in the message center are provided below in Figure 15 below.

READY STATE

A green circle (Figure 12, Item 1) indicates the machine is in normal operating condition. The machine will operate in both run and jog mode.
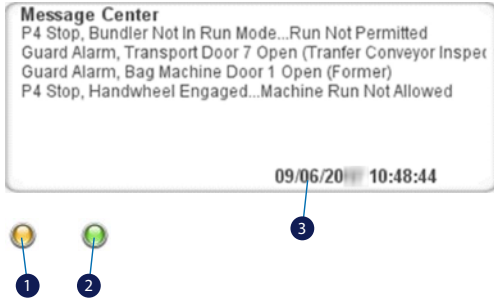
Message Center
P4 Stop, Bundler Not In Run Mode...Run Not Permitted
Guard Alarm, Transport Door 7 Open (Tranfer Conveyor Inspec
Guard Alarm, Bag Machine Door 1 Open (Former)
P4 Stop, Handwheel Engaged...Machine Run Not Allowed

09/06/20▮▮ 10:48:44

FIGURE 13. PRODUCTION SCREEN MESSAGE CENTER

MESSAGE CENTER WINDOW

The MESSAGE CENTER window (Figure 10, Item 2) is located in the upper center of all Production touchscreens (Figure 10). The message center contains all active messages (alarms, warnings, events). If the window is empty, there are no messages currently active.

Selecting anywhere within the blank message area activates the active message screen containing the time/date stamping data (Figure 13, Item 3) for each message.

MESSAGE CENTER INDICATOR RADIO BUTTON

GREEN radio indicator (Figure 13, Item 2) shows there is **no difference** between the **active** recipe and the **stored** recipe.

AMBER radio indicator shows there **is a difference** between the **active** recipe and the **stored** recipe. The operator should go to the recipe screen to save the active recipe and avoid losing the current recipe values.

Date/time: The date and time (Figure 13, Item 3) at the bottom of the Message Center screen is the most current in the system.

All the information listed in the printer registration section is on every machine. Some assemblies are optional. Please disregard information not applicable on purchased specific machine.
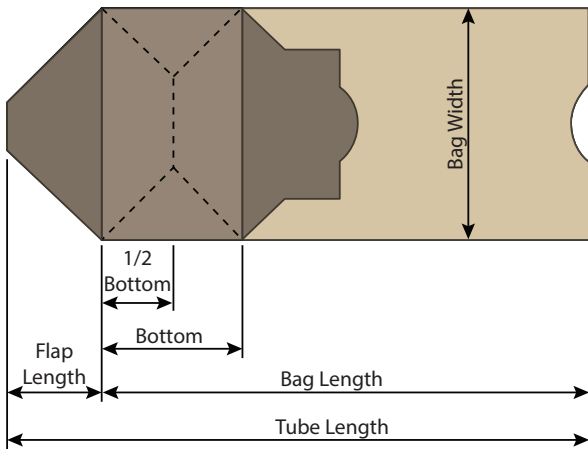

FIGURE 14. SCORING LOCATION ON BAG / TUBE

PRINT REGISTRATION

The PRINT REGISTRATION screen offset value (Figure 16, Item 2) adjustment and performing set up for the print registration. When registration is first turned ON (Figure 15, Item 7), the registration function will capture the first appropriate registration mark (Figure 23, Item 1) and use it to compare all subsequent registration mark captures.

EXAMPLE

When print registration is turned ON (Figure 15, Item 7), the print position, relative to the bag machine knife cutoff, will be maintained. After print registration is captured, once ON (Figure 15, Item 7) is selected, the print phase relative to the bag machine can be changed by adjusting the print offset.
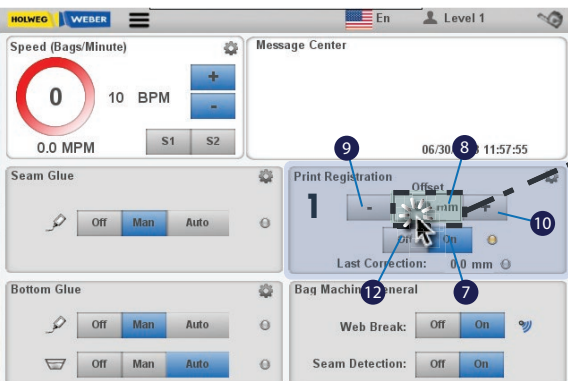

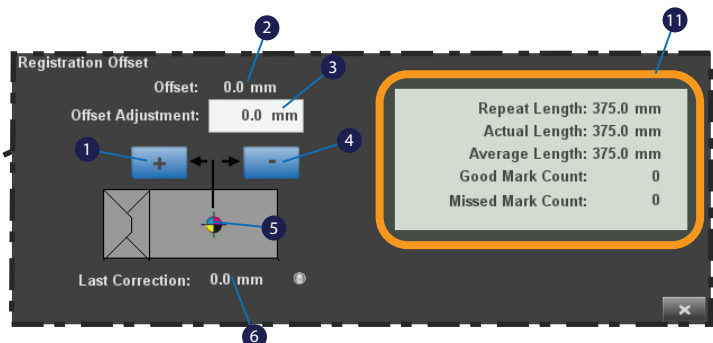**FIGURE 15. PRODUCTION SCREEN PRINT REGISTRATION**

FIGURE 16. PRODUCTION SCREEN MESSAGE CENTER

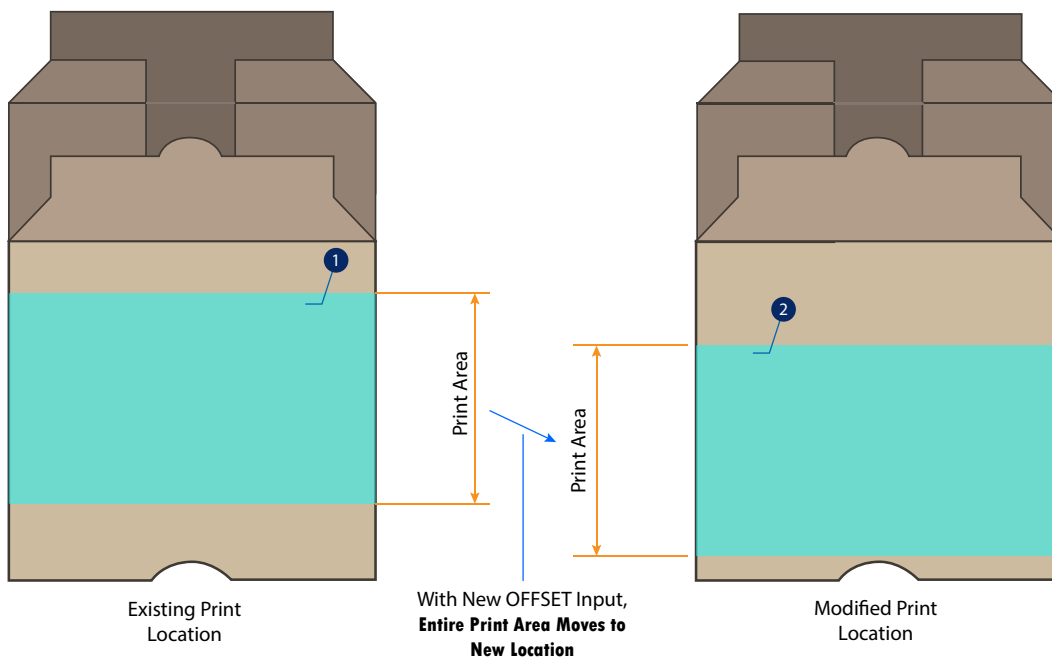Sustainable solutions for daily life packaging!

PRINT REGISTRATION OFFSET

OFFSET

The OFFSET data display (Figure 15, Item 8) & (Figure 16, Item 2) is the parameter setting that moves the overall print area (Figure 17, Item 1) to a new location (Figure 17, Item 2). Adjusting the offset (Figure 15, Item 8) moves the entire printed area on the bag t other adjusted specified location (Figure 17, Item 1 & 2) on the screen. The displayed screen data (Figure 16, Item 2) is the current distance the web has been set to align the print in the correct location.

When print registration is turned ON (Figure 16, Item 7), the value (Figure 15, Item 8) is preset to zero. The valid range for this parameter is **plus/minus** the tube length (Figure 14). The standard distance between the press block and holder (Figure 38, Item 4) is .060 before adjusting the OFFSET. When the OFFSET distance is modified by the operator, the press cylinder (Figure 38, Item 1) & press block (Figure 38, Item 3) raise the adjusted OFFSET distance spec'd on screen. Once the new adjustment is set, the press block and holder go back to original location.

The servo feed roller motor power the adjustment for the OFFSET distance. The servo motors speed up or slow down to compensate for the OFFSET adjustment.

Existing Print Location

With New OFFSET Input, **Entire Print Area Moves to New Location**

Modified Print Location

FIGURE 17. PRINT OFFSET

OFFSET ADJUSTMENT

The OFFSET ADJUSTMENT (Figure 16, Item 3) data entry input from the operator is the criteria used to adjust the registration offset output. The offset specified in user input box (Figure 16, Item 3) is modified, the distance specified moves the registration mark (Figure 37, Item 1). The distance that the registration mark is offset, offsets the entire print location on the bag face.
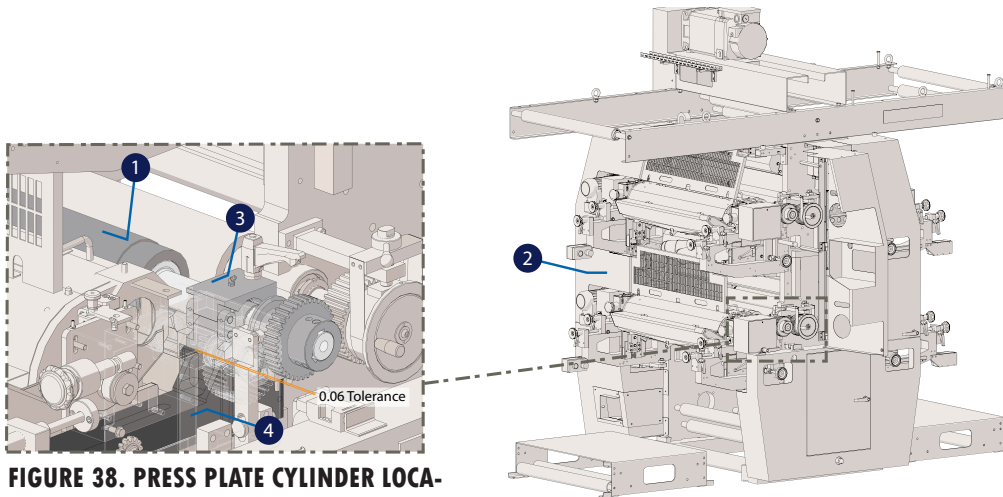
FIGURE 38. PRESS PLATE CYLINDER LOCATION

EXAMPLE

For this example, the print registration mark (Figure 37, Item 1) needs to move 1.25 in. (31.75mm) towards the bottom of the bag.

1. Start with a sample bag.

2. Turn ON registration (Figure 15, Item 7).

3. Tap the **plus/minus** (Figure 15, Item 9 & 10) to **1.25** (31.75mm) to adjust the print offset.

NOTE
Selecting the plus or minus button ONCE will move the print in the corresponding direction by 0.010" (0.254mm).

- **Selecting and HOLDING the plus or minus button,** the offset value will continually change in the corresponding direction until the button is released.

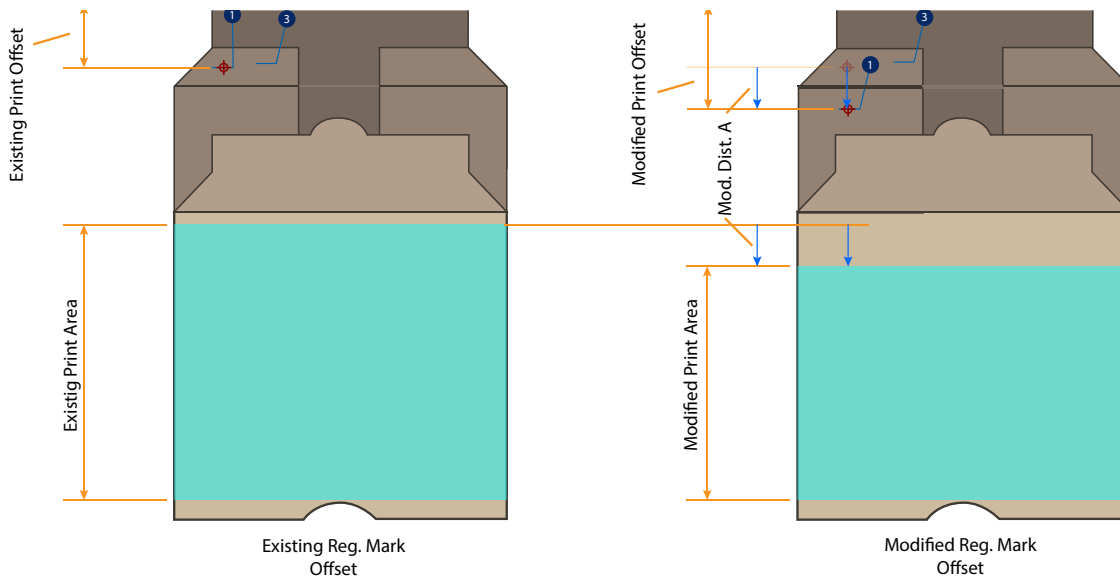4. Once set, the print will begin moving, and the adjust value is zeroed.

FIGURE 37. PRINT OFFSET ADJUSTMENT

REPEAT LENGTH

The REPEAT LENGTH output data (Figure 16, Item 11) displays the active programmed overall print area repeat distance. Data is displayed in inches or millimeters.

ACTUAL LENGTH

The ACTUAL LENGTH output data (Figure 16, Item 11) displays the actual repeat length generated by the registration function in inches or millimeters.

AVERAGE LENGTH

The AVERAGE LENGTH output data (Figure 16, Item 11) displays the average repeat length generated by registration. Data is display in inches or millimeters.

GOOD MARK COUNT

The GOOD MARK COUNT output data (Figure 16, Item 11) displays the current good mark count from registration. The output number is the accumulated quantity of web registration marks recognized by the registration photo eye.

MISSED MARK COUNT

The MISSED MARK COUNT output data (Figure 16, Item 11) displays the current missed mark count from registration. The good/missed mark counts are useful in troubleshooting registration functions. The data can help determine if registration marks are being recognized or missed.

PRINT REGISTRATION SETUP

The print REGISTRATION SETUP screen (Figure 19) allows the operator to apply additional print settings not on the production main screen (Figure 19). Select the settings icon (Figure 18, Item 11) on the Print Registration region of the main Production screen (Figure 18).

MAX CORRECTION

The MAX CORRECTION (Figure 19, Item 3 & 4) data output displays the maximum amount of corrections per repeat that the registration allows in inches or millimeters. The output data is displayed in red and is the result of input data from the operator. Data in red cannot be over typed by operator and it can only be modified by resetting data in other print registration areas allocated for the operator. A typical setting for this parameter is 0.063" (1.60mm).

WEIGHTING FACTOR

The WEIGHING FACTOR (Figure 19, Item 1) output value is a multiplier for the correction generated by registration.

EXAMPLE

If the weighting factor (Figure 19, Item 1) is 0.5 in. (12.7mm) and registration window (Figure 19, Item 2) generates a sum of 0.020 in. (50.8mm) max correction (Figure 19, Item 3 & 4), the actual output max correction is 0.5x0.020", or 0.010". This value has a range of 0.3 to 1.0 with 0.7 being a typical setting.

SHUTDOWN COUNT: (MISSED MARK)

The SHUTDOWN COUNT: (MISSED MARK) (Figure 19, Item 6) is the total amount of consecutive bags in a row the machine will allow with a web registration **missed mark**. When the overall count is reached the machine will shut down and display REGISTRATION MISSED MARK SHUTDOWN alarm in MESSAGE CENTER window (Figure 19, Item 13). This feature is meant to alert the operator of a registration problem and reduce waste.

TO DISABLE THE SHUTDOWN COUNT PERFORM ONE THE FOLLOWING OPTIONS

Option 1.   Turn OFF Print Registration (Figure 19, Item 14) on the main Production Screen (Figure 19).

Option 2. Input a quantity of **0** in the Shutdown Count: (Missed Mark) (Figure 19, Item 6).

SHUTDOWN COUNT (OUT OF TOLERANCE)

This SHUTDOWN COUNT: (MISSED MARK) (Figure 19, Item 7) displays the number of consecutive bags the machine will allow that have registration corrections exceeding the maximum correction preset on the registration setup screen. Once the shutdown count designated amount has been reached, the machine will shut down and display a REGISTRATION OUT OF TOLERANCE SHUTDOWN alarm. This feature is meant to alert the operator of a registration problem and reduce waste.
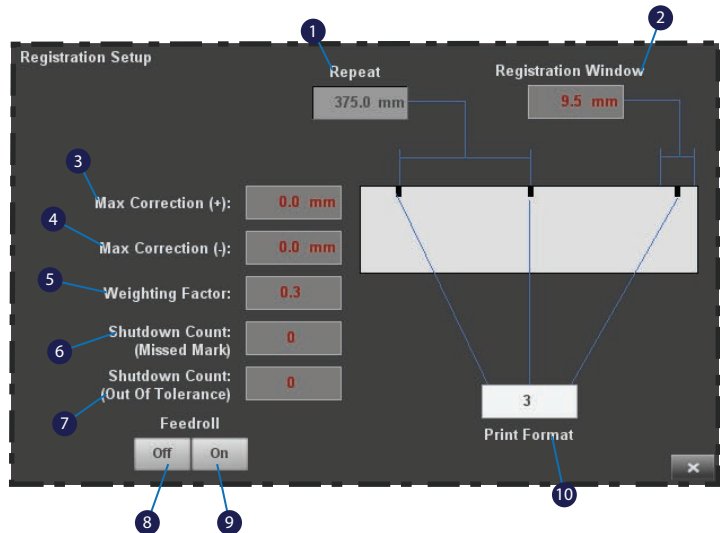
TO DISABLE THE SHUTDOWN COUNT PERFORM ONE THE FOLLOWING OPTIONS

Option 1. Turn OFF Print Registration (Figure 19, Item 14) on the main Production Screen (Figure 18).
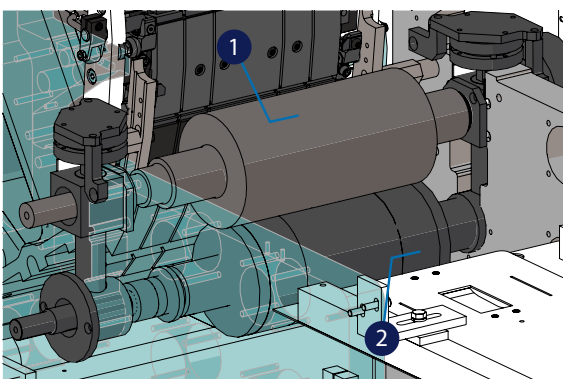
Option 2. Input of a quantity of **0** in the Shutdown Count: (Out of Tolerance). (Figure 19, Item 6).

FIGURE 18. PRODUCTION SCREEN PRINT REGISTRATION

FIGURE 19. PRODUCTION SCREEN PRINT REGISTRATION SETUP SETTINGS

FIGURE 20. FEED ROLLER LOCATION

FEEDROLL (SERVO OPTION ONLY)

The FEEDROLL system (Figure 20, Item 1 & 2) can be turned ON or OFF using the designated buttons (Figure 16, Item 8 & 9). The Servo motor will speed up or slow down the feed rollers to adjust the print location on the paper.

PRINT REGISTRATION WINDOW

The REGISTRATION WINDOW (Figure 19, Item 2) shows the location where a proper print registration mark (Figure 23, Item 1) can be recognized and detected on the tube. The value is critical if there is print on the tube other than the print registration marks that the registration photo eye may detect.

The registration window function detects a valid mark (Figure 23, Item 1), then ignores any print on the web for a distance of the tube length (Figure 14) minus half the registration window (Figure 19, Item 1).

RESULT OF OPERATOR SETTING

The registration function will ignore any print on the web 15 in. (38.1mm) past the last detected mark. The value of this window is usually set at 2 inches.

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PRINT FORMAT

The PRINT FORMAT (Figure 19, Item 10) value sets the quantity of marks allocated per tube.

PRINT FORMAT CONDITIONS

Entering a quantity of 1: The registration eye (Figure 22, Item 3) detects a valid register location (Figure 23, Item 1) for every repeat mark.

Entering a quantity of 2: The registration eye (Figure 22, Item 3) detects a valid register location (Figure 23, Item 1) for every second repeat mark.

This setting minimizes registration corrections due to anomalies on web printed with two or more repeats per revolution of the press plate cylinder (Figure 21, Item 1).

The standard range is 1 - 4 marks, with 1 - 2 being the most commonly used.
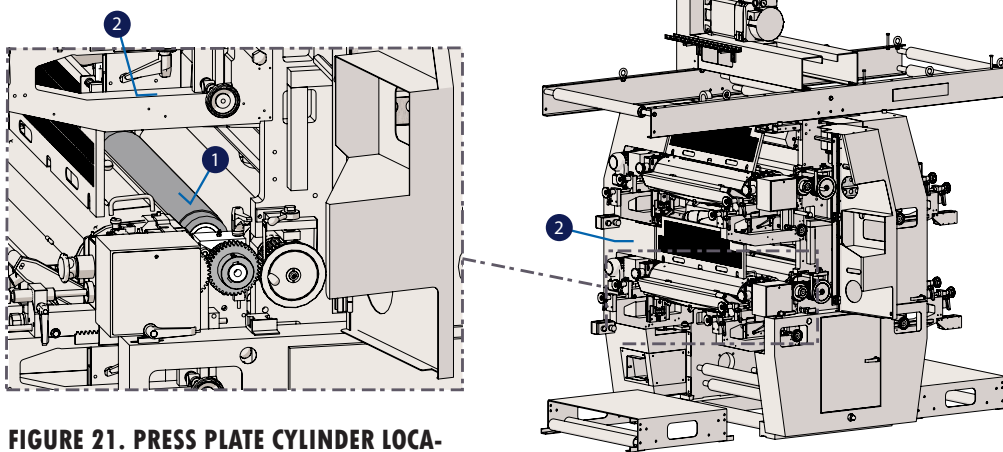
FIGURE 21. PRESS PLATE CYLINDER LOCATION

IMPORTANT

For the registration eye (Figure 22, Item 3) to detect the registration mark (Figure 23, Item 1), the registration mark must be on the roller (Figure 22, Item 4) or any other surface. Otherwise, the laser eye will go through the paper and the mark will not be detected.
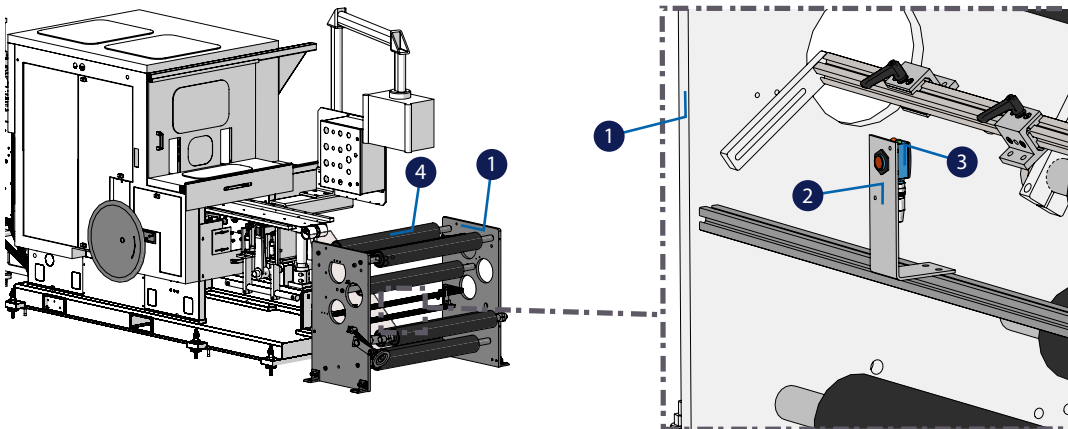
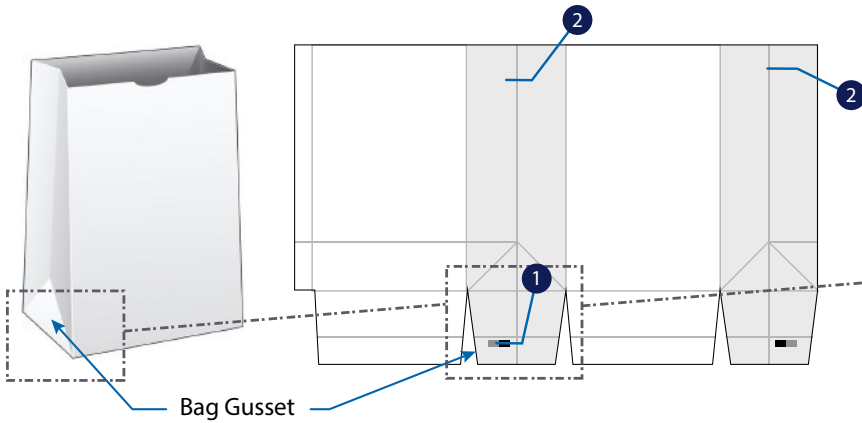**FIGURE 22. WEB REGISTRATION EYE AT SEAM PASTE STAND ROLLER**

FIGURE 23. REGISTRATION MARK AT GUSSET BASE

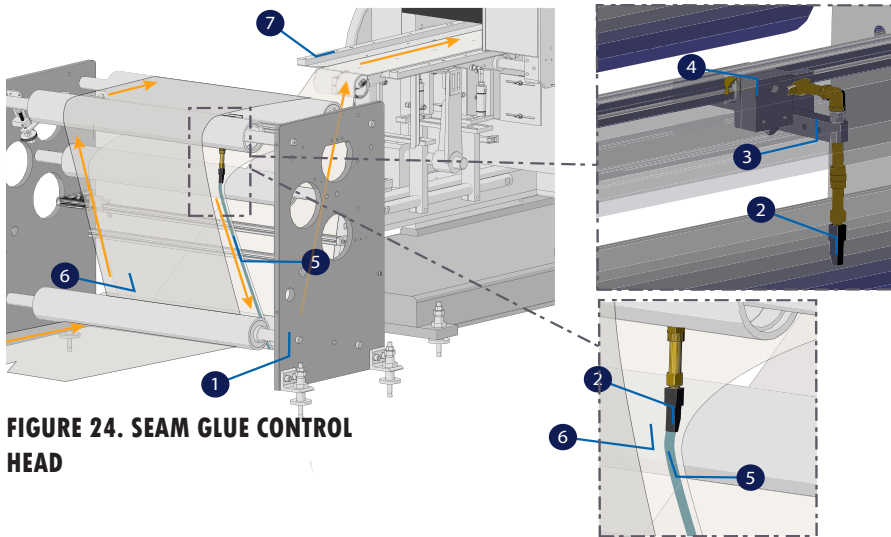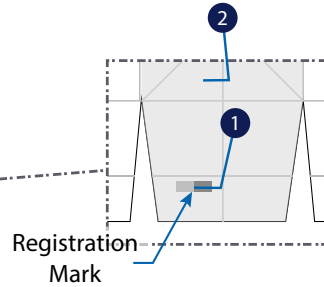Bag Gusset

Registration Mark

FIGURE 24. SEAM GLUE CONTROL HEAD

SEAM GLUE

The seam glue control window controls the flow of cold glue (Figure 24, Item 5) onto the edge of the web (Figure 24, Item 6) before reaching the former (Figure 24, Item 7).

SEAM GLUE CONTROL

Selecting one of the three buttons **OFF, MAN,** or **AUTO** (Figure 18, Item 1, 2, & 3) changes the seam glue control between different modes of operation. The active mode selected by operator is highlighted in **blue**. In Figure 18, Item 2, **MAN** is the active button.
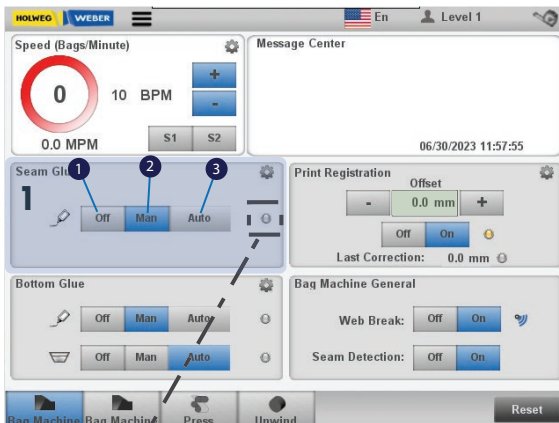

FIGURE 25. PRODUCTION SCREEN PRINT SETTINGS

SEAM GLUE BUTTON CONTROLS

OFF mode (Figure 25, Item 1), all seam glue pressure is removed from the system and NO glue heads (Figure 25, Item 2) will turn ON.

MAN mode (Figure 25, Item 2), the seam glue pressure and glue head ON/OFF are controlled by the operator from the seam glue settings screen.

AUTO mode (Figure 25, Item 3), seam glue pressure and glue head (Figure 24, Item 2) ON/OFF are controlled automatically by the machine based off the parameters of the seam glue settings / Cold Seam Glue Control screen (Figure 26, Item 16).

STATUS INDICATORS

**GREEN** radio indicator (Figure 25, Item 5) shows seam glue is in an OFF state.

WHITE radio indicator (Figure 13, Item 4) shows seam glue is in an ON state.

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SEAM GLUE SETTINGS

To modify the seam glue settings, select the settings icon in the top, right corner of the Seam Glue control panel (Figure 26, Item 1) on the Product Screen interface.
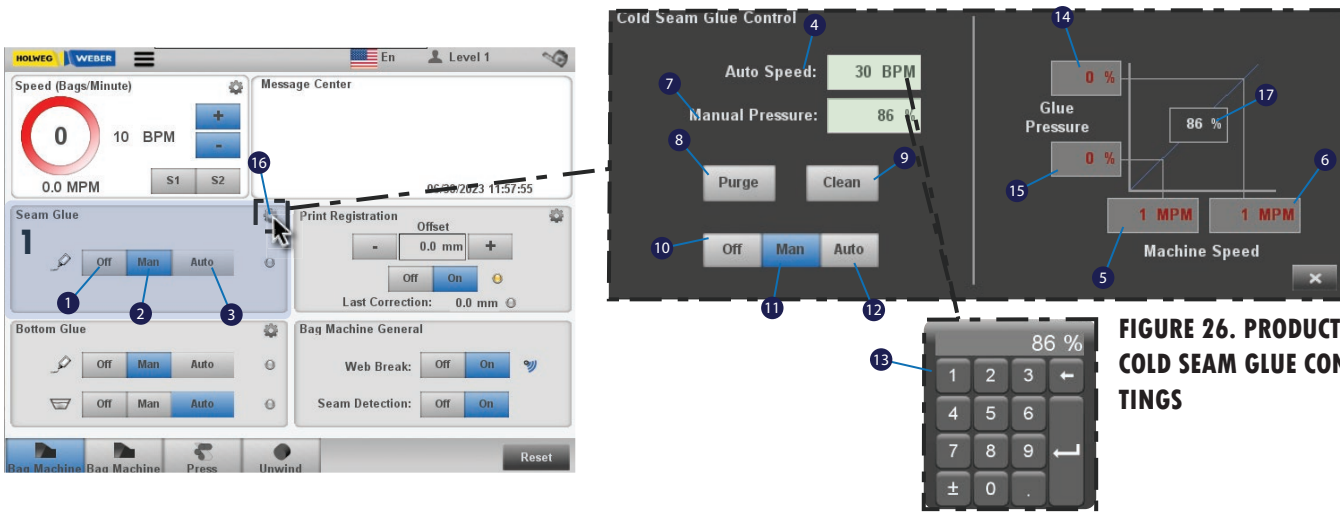
FIGURE 26. PRODUCTION SCREEN COLD SEAM GLUE CONTROL SETTINGS

SEAM GLUE BUTTON CONTROLS

Purge (Figure 26, Item 5), initiates continuous flow of glue through the seam glue nozzle (Figure 24, Item 2). Glue flows continuously while **Purge** button is pressed by operator. Glue flow stops when the button is released. The Purge button is active only while in the **MAN** mode (Figure 26, Item 11).

Clean (Figure 26, Item 6) initiates a rapid fire actuation of the seam glue nozzle to aid in clearing a blockage. Glue flow stops when the button is released.

IMPORTANT

The **Clean** button is only active while in **MAN** (Manual) glue mode (Figure 26, Item 11).

OFF mode, (Figure 26, Item 10) seam glue is turned off and no glue applied (Figure 26, Item 10).

MAN mode, (Figure 26, Item 11) seam glue system is pressurized at the manual pressure setting (Figure 26, Item 11) preset by operator.

AUTO mode, (Figure 26, Item 12) seam glue is actuated when the machine speed reaches the auto speed (Figure 26, Item 12) threshold.

SEAM GLUE DETECTION WARNING TIME

The seam glue detection warning time is amount of time the machine continues to run without the seam glue detection sensor detecting a presence of glue. The machine will toggle the horn during this time and a "Warning: Seam Glue Absent" message will be displayed on the screen. The machine will automatically turn off after this amount of time unless seam glue is detected. (Timer can be reset by selecting the reset button).

AUTO SPEED

The Auto Speed (Figure 26, Item 4) threshold of when glue is applied in **AUTO** glue mode.

MANUAL PRESSURE

The Manual Pressure (Figure 26, Item 7) setting is used to extract the glue while **MANUAL** glue mode is selected.

NON-PRODUCTION TOUCHSCREEN TYPES

Non-Production touchscreens are designated for setup, status, and maintenance for the machine line. Selecting the ☰ symbol in the header bar gains access to the menu for all non-Production touchscreens. See Figure 27 for a typical non-Production touchscreen menu.
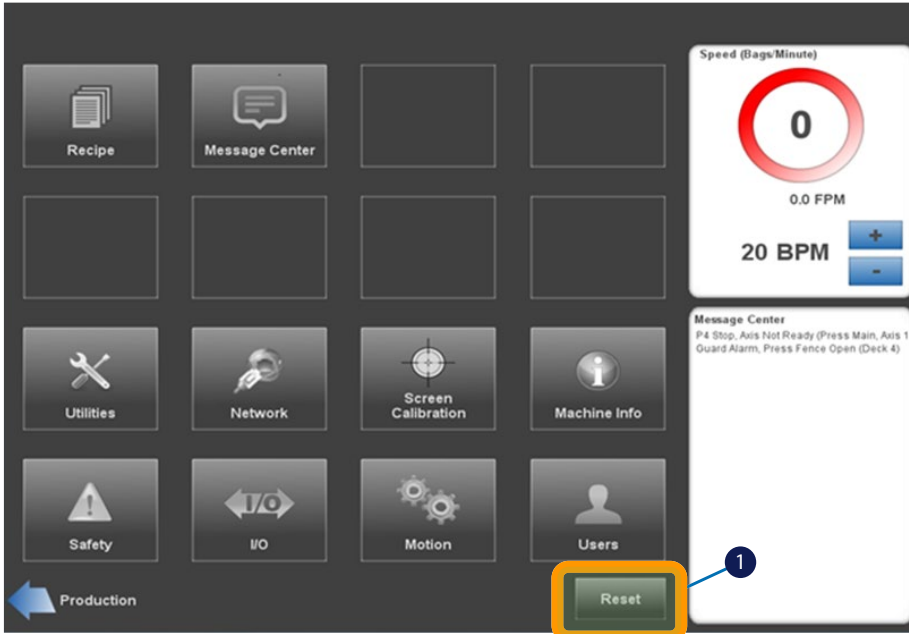
FIGURE 27. NON-PRODUCTION SCREEN MENU

RESET

Global reset for the system (Figure 27, Item 1).

STATISTICS SCREEN

The Statistics Screen (Figure 28) displays recorded activities of the system operation such as run time, down time, and total number of bags produced for the time frame specified.

FIGURE 28. STATISTICS SCREEN

	Run Time	Down Time	Bags
Wed Sep 6	0 hrs 0 min	1 hrs 33 min	0
Tues Sep 5	0 hrs 0 min	1 hrs 21 min	0
Fri Sep 1	0 hrs 0 min	9 hrs 58 min	0
Thur Aug 31	0 hrs 0 min	9 hrs 9 min	0
Wed Aug 30	0 hrs 23 min	7 hrs 40 min	0
Tues Aug 29	0 hrs 0 min	10 hrs 32 min	0
Mon Aug 28	0 hrs 32 min	11 hrs 59 min	0
Sat Aug 26	0 hrs 23 min	9 hrs 51 min	0
Lifetime	4 hrs	125 hrs	0

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RECIPE SCREEN

The Recipe Screen (Figure 29) allows the operator to select recipes for personalized settings based on user preferences.

RECIPES SETTINGS

FIGURE 29. RECIPE SCREEN

Load	Loads selected recipe and its values to the active recipe. See in instructions on how to load a recipe below.
Save	Saves the current values to the current recipe that is loaded. See instructions on how to save a recipe below.
Copy	Copies an existing recipe. The operator will be prompted to rename the new recipe.
Rename	Renames an existing recipe.
Refresh	Refreshes and displays data of the latest recipes available.
Delete	Deletes the selected recipe and its values.
Create	Creates a new recipe. The current values in the machine will be saved into the new recipe.

RECIPES SETTING DESCRIPTIONS

LOADING A RECIPE TO THE SYSTEM

1. Scroll down to the desired recipe to load on the list using the up or down arrows on the right side of the screen.

    NOTE
    Selected recipes are highlighted in blue.

2. With the desired recipe highlighted, select load on the screen. Once loaded a confirmation window will show.

3. Select the ✓ box to confirm the selected recipe you want to load.

4. Select the ✕ box to close the confirmation window.

SAVING A CURRENT RECIPE

1. Select an existing recipe from the list using the up or down arrows on the right side of the screen.

    NOTE
    Selected recipes are highlighted in blue.

2. Select Save on the screen. Once saved a confirmation window will show.

3. Select the ✓ box to save the recipe.

4. Select the ✕ box to close the confirmation window.

COPYING AN EXISTING RECIPE

1. Select an existing recipe from the list using the up or down or arrows.

   NOTE
   Selected recipes are highlighted in blue.

2. Select Copy on the screen. Once copied a confirmation window will show.

3. Select the ☑ box to copy the selected recipe.

4. Select the ☒ box to close the Confirmation window.

5. Enter a new name in the input field to rename the existing recipe.

DELETING A CURRENT RECIPE

1. Select an existing recipe from the list using the up or down arrows.

   NOTE
   Selected recipes are highlighted in blue.

2. Select Delete on the screen. Once deleted a confirmation window will show.

3. Select the ☑ box to delete the selected recipe.

4. Select the ☒ box to close the Confirmation window.

CREATING A NEW RECIPE

1. Select an existing recipe from the list using the up or down arrows.

   NOTE
   Selected recipes are highlighted in blue.

2. Select Create on the screen. Once created a confirmation window will show.

3. Enter a name in the input field.

4. Select the ☑ box to create a new recipe.

5. Select the ☒ box to close the Confirmation window.

RENAMING A RECIPE

1. Locate the desired recipe to rename on the list using the up or down arrows.

   NOTE
   Selected recipes are highlighted in blue.

2. With the desired recipe highlighted, select Rename. Once renamed a confirmation window will show.

3. Enter the new name in the input field.

4. Select the ☑ box to rename the recipe.

5. Select the ☒ box to close the Confirmation window.

MESSAGE CENTER SCREEN

The Message Center screen (Figure 30) records and displays messages of past and current activities of the machine operation.

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RECORDED MESSAGE TYPES

- **Error**
- **Fault**
- **Alarms**
- **Jams**
- **Status**

Each error is stamped with a real time stamp.

HISTORY SCREEN

The History panel (Figure 30) displays reasons or patterns that cause the machine to stop unexpectedly. Screen displays the past messages of the system. The history list stores the past 500 messages.

ACTIVE SCREEN

The Active panel (Figure 30) displays reasons the machine will not start. The screen displays the current system messages.
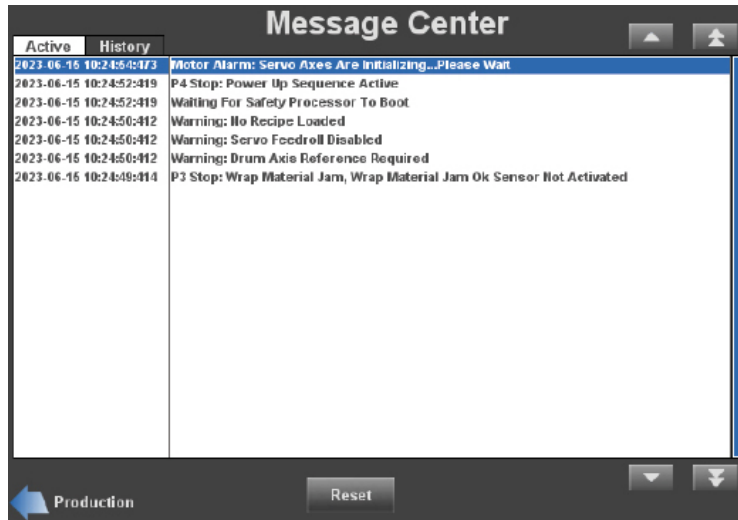
FIGURE 30. MESSAGE CENTER SCREEN
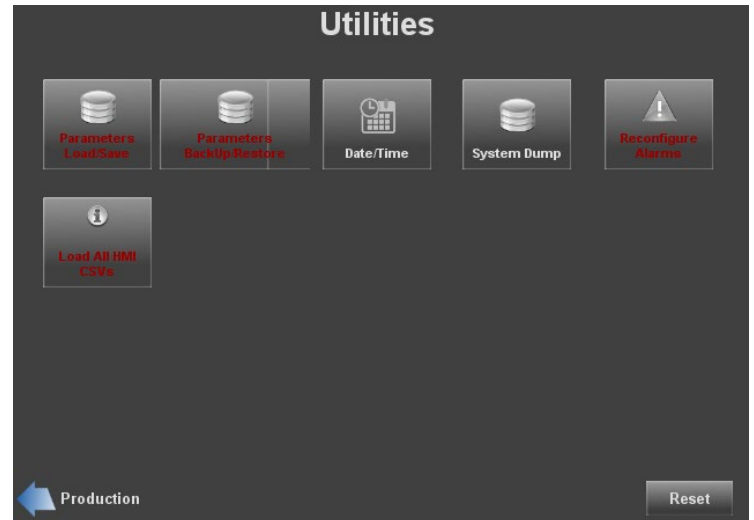
FIGURE 31. UTILITIES SCREEN

UTILITIES SCREEN

The Utilities Screen (Figure 31) loads and/or saves system parameters, transfers machine data & system information, and changes the date and time.

PARAMETERS LOAD/SAVE SCREEN

This Parameters Load/Save screen loads & saves all system parameters to/from the screen to touchscreen memory. The parameters are necessary for proper machine operation that are NOT included in the recipe.

SAVING SYSTEM PARAMETERS FROM THE MACHINE TO THE SCREEN MEMORY

1. Select Save on the screen. Once saved, a Confirmation window will show.
2. Select the ✓ box to save the system parameters.
3. Select the ✕ box to close the Confirmation window.

Follow the same procedure for loading the system parameters from a memory device to the machine.

LOADING SYSTEM PARAMETERS FROM THE SCREEN MEMORY TO THE MACHINE

1. Select Load on the screen. Once loaded, a Confirmation window will show.

2. Select the ✔ box to save the system parameters.

3. Select the ✖ box to close the Confirmation window.

Follow the same procedures for loading the system parameters from a memory device to the machine.

BACKING UP MACHINE DATA FROM THE HMI

1. Insert USB memory device into the front USB port on the HMI.

2. Select Backup on the screen. Once complete a Confirmation window will show.

3. Select the Backup box to back up the machine data.

   • OPERATION SUCCESSFUL shows confirming the machine data has been backed up successfully once complete.

4. Select the ✖ box to close the Confirmation window.

RESTORING MACHINE DATA FROM A USB MEMORY DEVICE TO THE HMI

1. Select Restore on the screen. Once restored, a Confirmation window will show.

2. Select the ✔ box to restore the machine data.

   • OPERATION SUCCESSFUL shows confirming the machine data has been backed up successfully once complete.

3. Select the ✖ box to close the Confirmation window.

USER LEVELS

Four user levels are preset in the Level dropdown list at the top of the screen. Each level has a specific classification, set of conditions, and uses. See below for level descriptions.

USER LEVEL DESCRIPTION
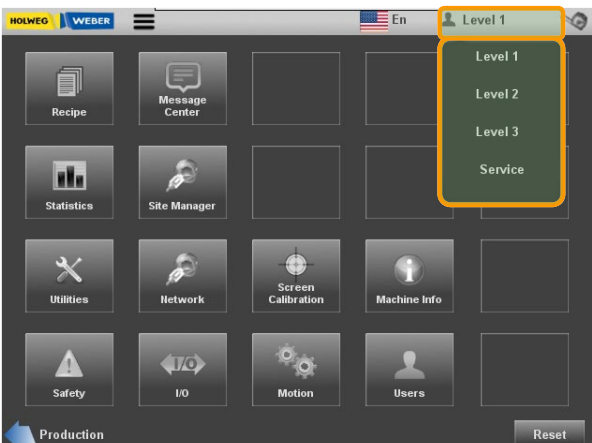
FIGURE 32 USER LEVELS

LEVEL 1

DOES NOT require a password and is used for **operators**.

LEVEL 2

DOES require a password (resettable) and is used for **Supervisors**.

LEVEL 3

DOES require a password (resettable) and is used for **maintenance personnel**.

SERVICE

DOES require a password (non-resettable) and is used for **HG Weber personnel ONLY**.

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Data entry for many parameters is based on the current level specified by the user. If data entry for a parameter is NOT allowed in the current level, the parameter value is shown in dark red with a dark gray background (Figure 15).

IMPORTANT

The user level can only be changed while in Production mode.

RETURNING TO PRODUCTION MODE

1. Select back arrow at the bottom of the screen on the left side (Figure 32).

2. Select the current user **(Level)** on the right side of the header (Figure 32).

   - When the current user area is selected, if a password is required, the buttonboard will show and user can enter password with the buttonboard.

     - **If the password is correct**, the new user level will be shown in the header area (Figure 16).

     - **If the password was incorrect**, the previous user level is shown in the header area and a message will popup in the message center window denoting a password failure.

NETWORK SETTINGS SCREEN

The NETWORK SETTINGS (Figure 33) screen allows the user to either SET or GET the current network settings contained in the main HMI. The input settings allow the user to either view or change the current network settings.

GET BUTTON FUNCTIONALITY

Selecting the GET button retrieves the current setting and allows the user to view the current network settings.

SET BUTTON FUNCTIONALITY

Each network parameter (IP address, Subnet mask, and Default gateway) can be changed by selecting the corresponding parameter to get a data entry buttonpad. After input parameters have been updated by the user, use the SET button to activate the new parameters.
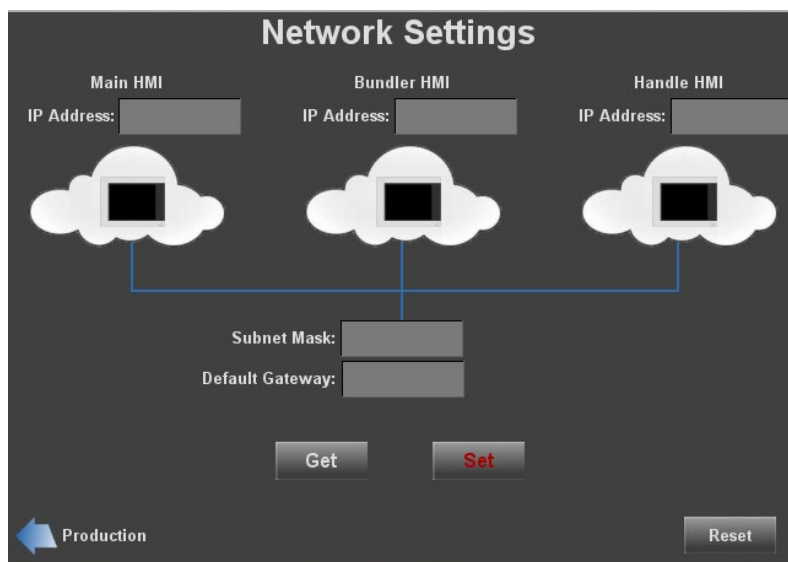

FIGURE 33 NETWORK SETTINGS

SAFETY SCREEN

The SAFETY PROCESSOR INTERFACE screen (Figure 34) provides data allowing the user to easily upgrade, change, and/or replace any/all safety network components (i.e. firmware, I/O modules, etc.).

ITEMS TO CONSIDER WHEN USING THE SAFETY SCREEN

-   Any changes must be accepted through this screen before the safety system is operational again.

-   All items on this screen are password protected and will generally not be used unless directed by HolwegWeber.

-   If use of this screen is required, special instructions will be issued by HolwegWeber personnel that are specific to your machine.

BUTTON FUNCTIONALITY

READ STATUS

Allows user to view the Safety Processor Interface status.

RESET SAFELOGIC

Resets the SafeLogic set by user.

FIGURE 34 SAFETY PROCESSOR INTERFACE SCREEN

FIGURE 35 I/O SETTINGS SCREEN

I/O SCREENS

The I/O screen (Figure 34) provides accessibility to various maintenance control setting for components and assemblies throughout the machine. The state of every I/O point on the machine is brought out to various HMI screens. By selecting the machine module buttons at the bottom of the screen the status of all I/O on the machine can be monitored.

Each I/O point has an indicator ( ) showing the current state of each function.

-   GRAY indicates I/O point is **OFF**.

-   GREEN indicates I/O point is **ON**.

MOTION SCREEN

The MOTION STATUS screen (Figure 36) provides additional trouble shooting for the servo axes. The status of each component with a servo axis can be viewed by selecting the desired component from the list at the top of the screen, and select the button to

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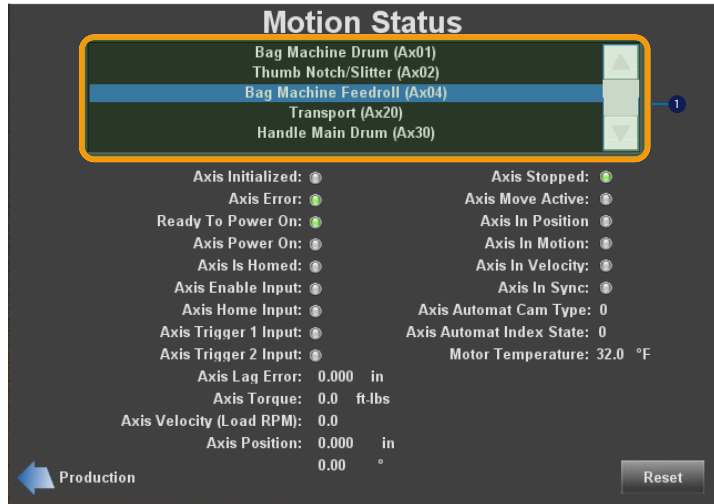
display its current status.

FIGURE 36 I/O MOTION STATUS SCREEN

Each I/O point has an indicator ( ) showing the current state of each function.

•GRAY indicates I/O point is **OFF**.

•GREEN indicates I/O point is **ON**.

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