# ATLANTA
## STRETCH

# HMI PANEL USER MANUAL
# WEINTEK MT8071iP/ECO BETA VERSION

| Lingua | Revisione | Data | Autore | Pag. Mod | Descrizione |
|--------|-----------|------|--------|----------|-------------|
| IT | Rev_00 | 27/12/2022 | G.Pazzaglini | | Description of functions and navigation on Weintek MT8071iP/ECO HMI panel Beta version |
| | | | | | |

# HOMEPAGE

MANUAL CONTROLS

PROGRAMMES LIST

GRID OF FUNCTIONS

PROGRAM 01     1

TOP WRAPS

2

LOW WRAPS

2

TYPE OF CYCLE

FILM TENSION

45

ROTATION SPEED

90
m/min

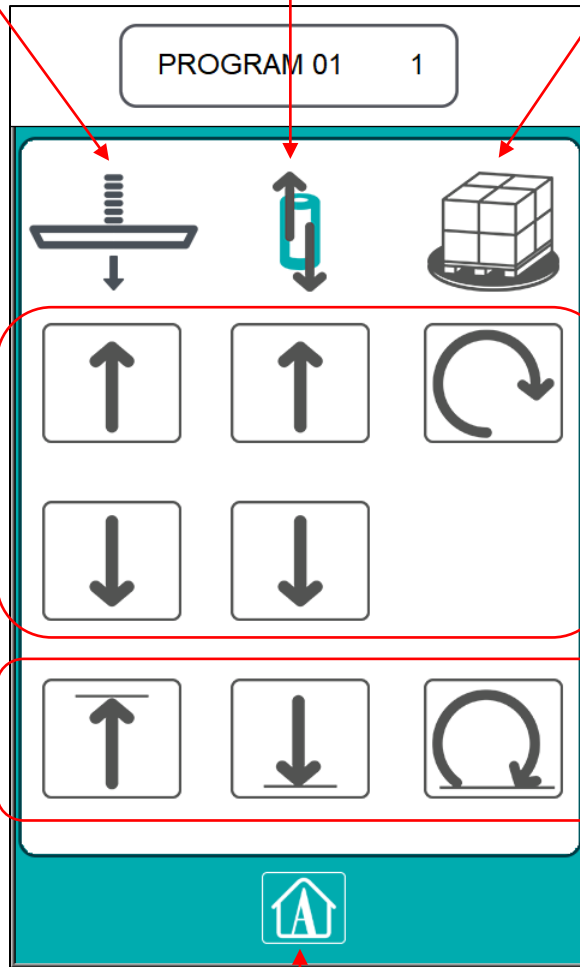UPWARDS DOWNWARDS SPEED

80
m/min
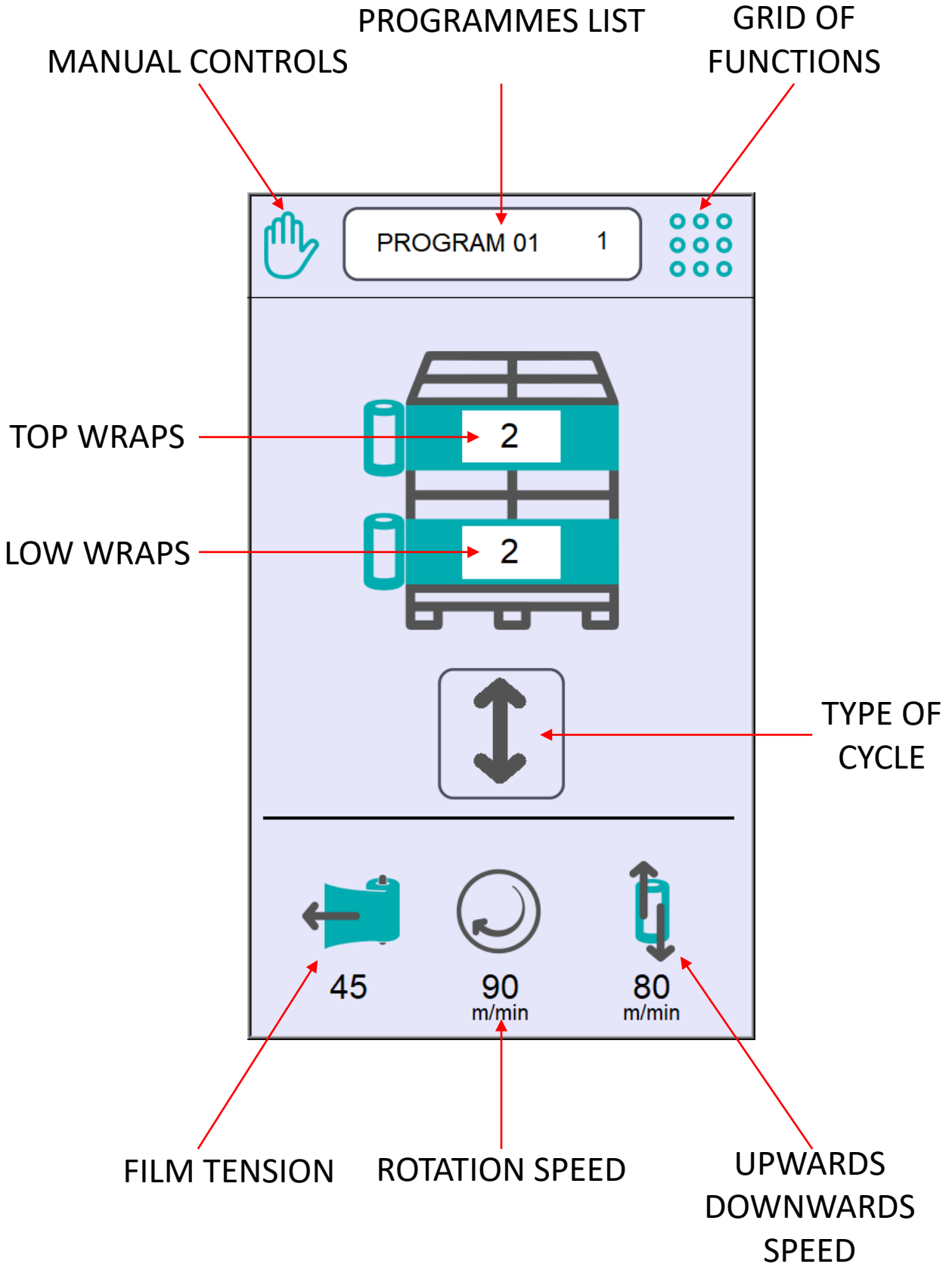
# MANUAL CONTROLS

PRESSURE UNIT
(Only for rotary tables)

SPOOL CARRIAGE

ROTATION
(Only for rotary tables)

These controls allow the top press (if fitted), carriage and table to be moved manually. The movement action remains as long as the buttons are pressed.

PROGRAM 01     1

These commands enable automatic home position search.
- Top press : high end stop
- Carriage: low end-stop
- Turntable : home position
Press once without holding down the command.

**HOME ICON**
This is the 'SAVE+Back' button and combines the functions of saving and returning to the previous window.
In this screen, it allows you to return to the Homepage

# PROGRAMMES LIST

The programme names are listed in the programme list. By default, each programme is called 'PROGRAM XX' where XX is the programme number in succession.
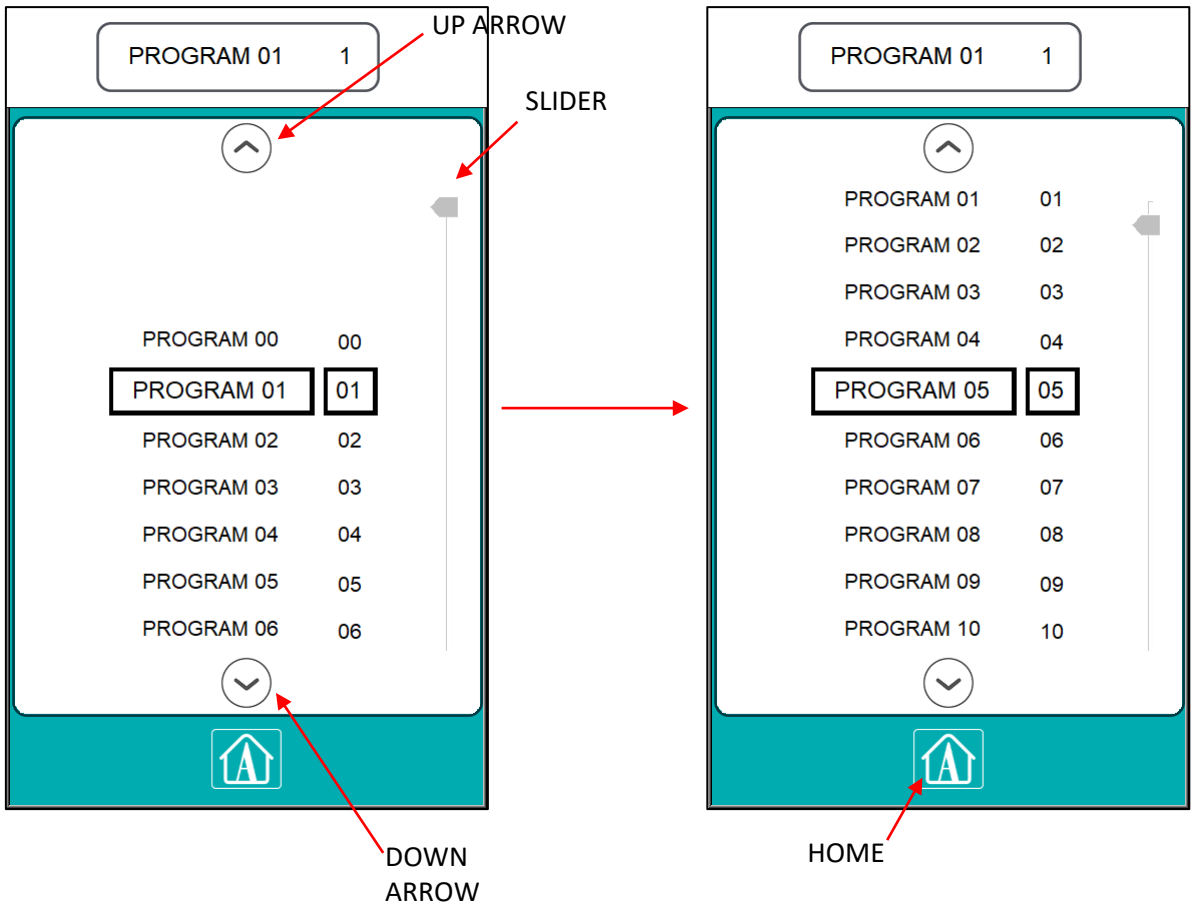


With the UP ARROW and DOWN ARROW buttons you can scroll through the programme list. Pressing once on either arrow scrolls by 1 programme, holding down an arrow has no effect. To scroll faster you can use the VERTICAL SLIDER on the right, by holding it down and scrolling up/down in the list.

Clicking on the Home button will change the current programme to the one selected in the black rectangle, and all function values of that programme will be loaded.

# PROGRAMMES LIST

By selecting the desired programme and pressing for at least 3s on the programme name, it is possible to rename the selected programme



OLD NAME
NEW NAME

The DELETE button deletes the programme name so that a new one can be written.

DELETE
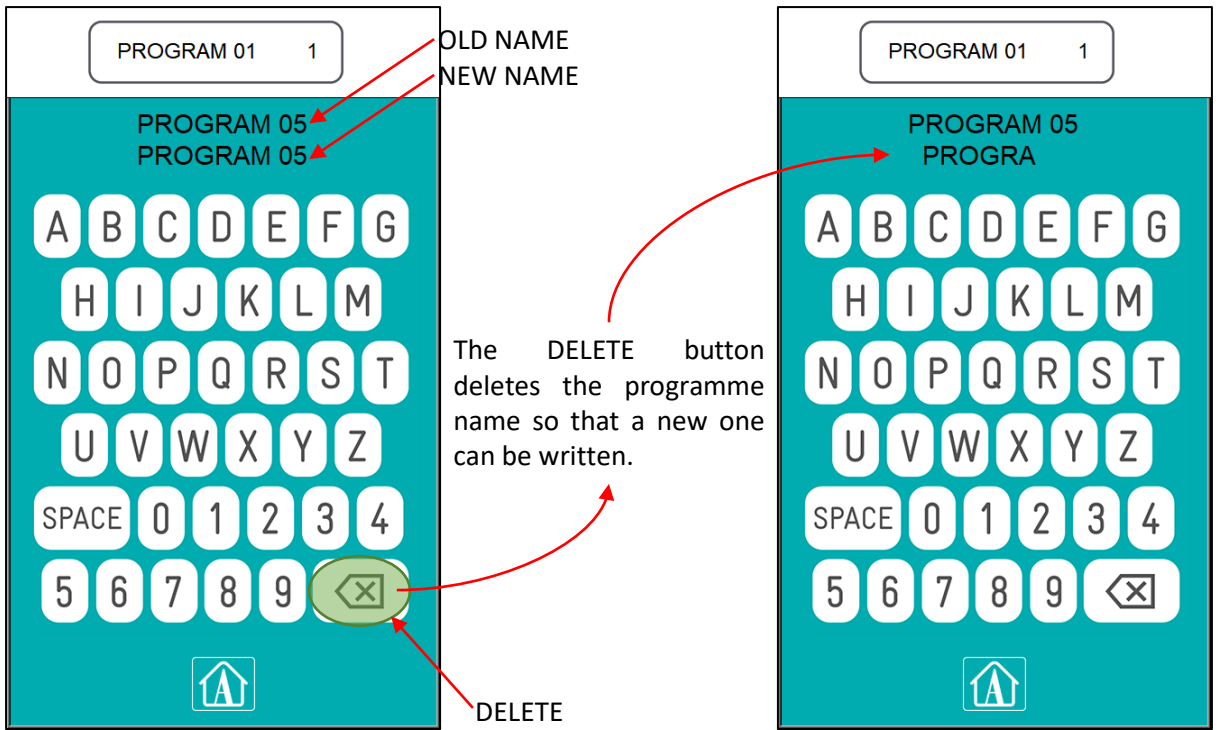
You have 10 characters including spaces. When the new name is complete, save it by pressing the HOME button, so that you also return to the programme list. The new programme has now been renamed and saved. As you can see from the pictures below, this only renames. You can see the active programme on the machine in the white rectangle above. To change the programme, therefore, carry out the procedure shown on the previous slide.

# TIPE OF CYCLE

PROGRAM 01      1

CURRENT SELECTION
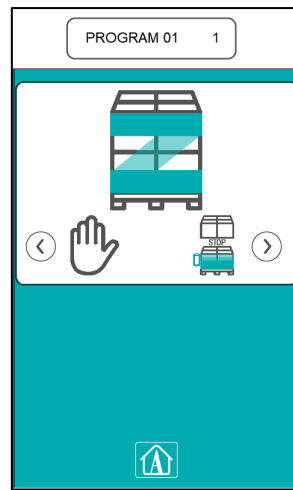
PREVIOUS AND SUCCESSIVE CYCLE
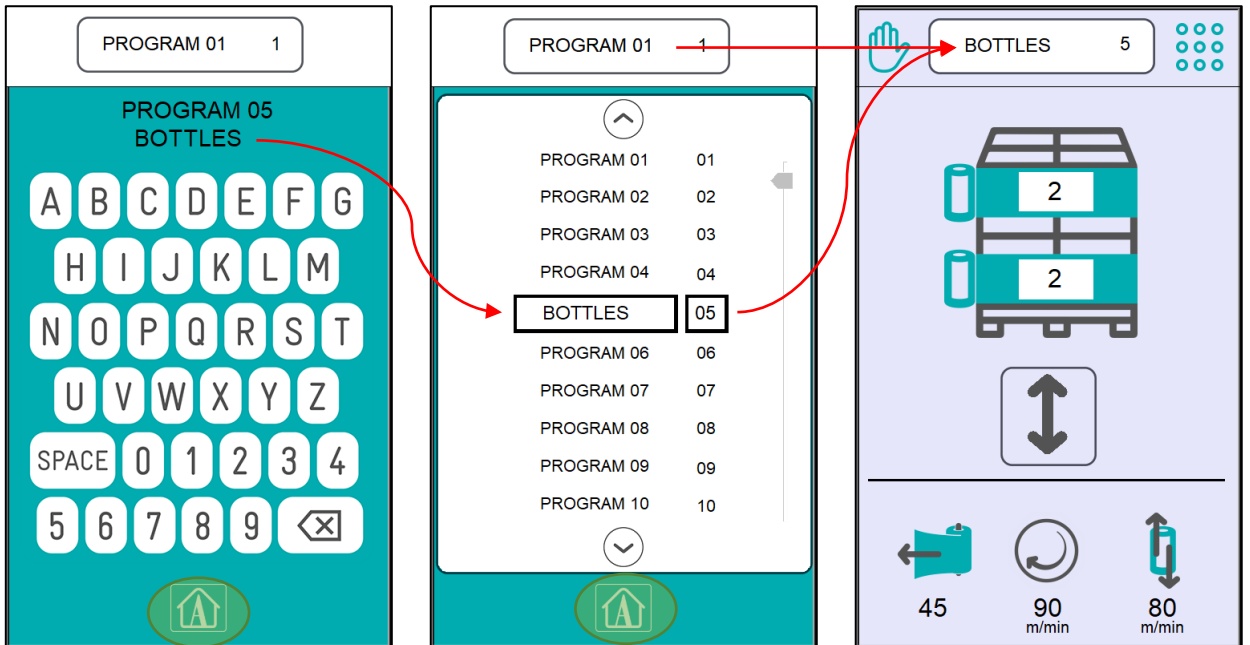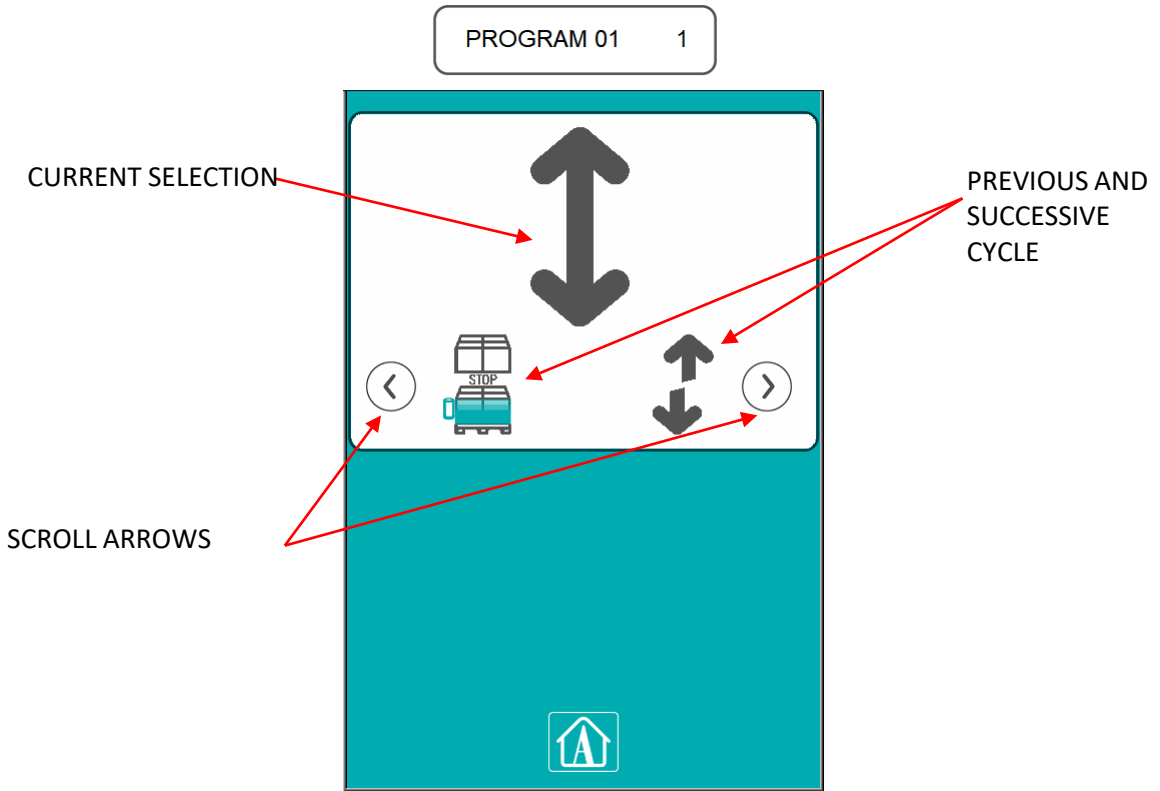
SCROLL ARROWS

The cycle type is selected here. If this has been activated, it will be selectable. Use the ARROWS to scroll left and right in the menu and the selected cycle type will be displayed large in the centre. To confirm the selected cycle press the HOME button in the centre and you will return to the previous screen. Please refer to the machine's "Operating Panel Instruction Manual" for details of cycle operation. The cycles are as follows:
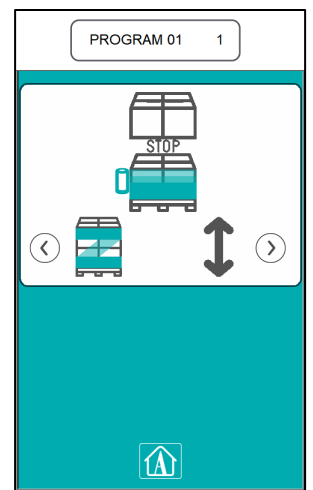
PROGRAM 01      1

PROGRAM 01      1

PROGRAM 01      1

PROGRAM 01      1
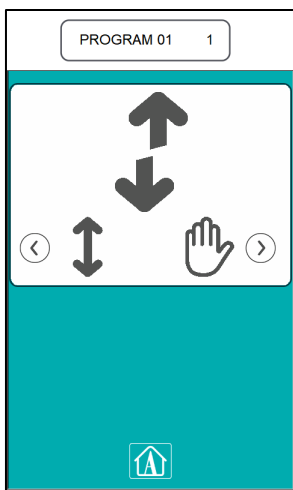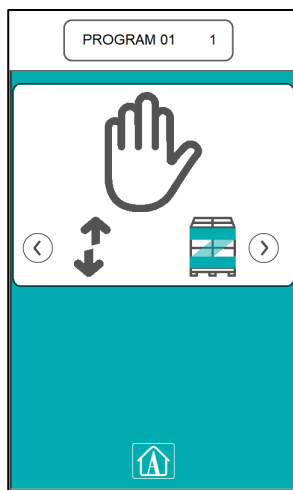
UNLY UP / ONLY DOWN CYCLE          MANUAL CYCLE          FAST CYCLE          LAYER CYCLE
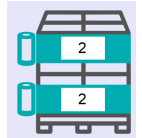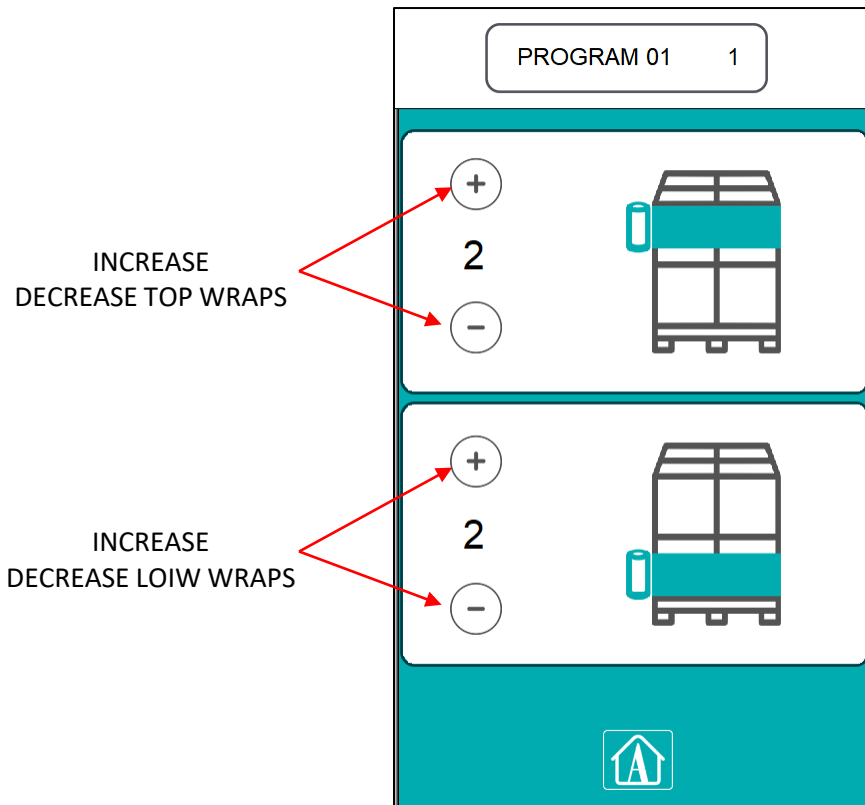
# TOP WRAPS / LOW WRAPS

Here you can set the number of TOP and LOW WRAPS using the '+' and '-' buttons.



**INCREASE DECREASE TOP WRAPS**

**INCREASE DECREASE LOIW WRAPS**

IMPORTANT: The change to the Number of wraps does not take effect until the HOME button at the bottom centre is pressed, since home button has a save function. So the change of values within the screen remains not confirmed (not executed by the programme) until the HOME button is pressed and then until saved.

The procedure for changing a value is:

Press on an icon
↓
Change values
(which remain not confirmed )
↓
Press HOME to save
(they will be written and saved into the programme and executed)
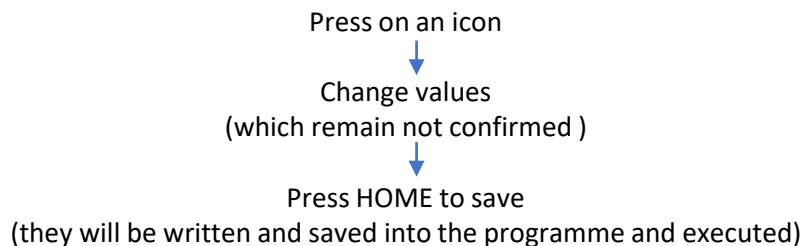
**Example.** You enter this screen to change the low wraps to 5. It is initially set to 2 and is changed to 5 BUT the HOME button is not pressed yet. The programme therefore still has the value 2 in memory. When the cycle starts the programme will execute 2 low wraps. **To confirm the change the operator should have pressed the HOME button.** Thus the programme would have executed 5 low revolutions.

**This is valid for all functions: when they are changed, this change will only take effect when the HOME button is pressed.**

# FILM TENSION
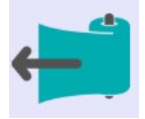
Here you can set the FILM TENSION
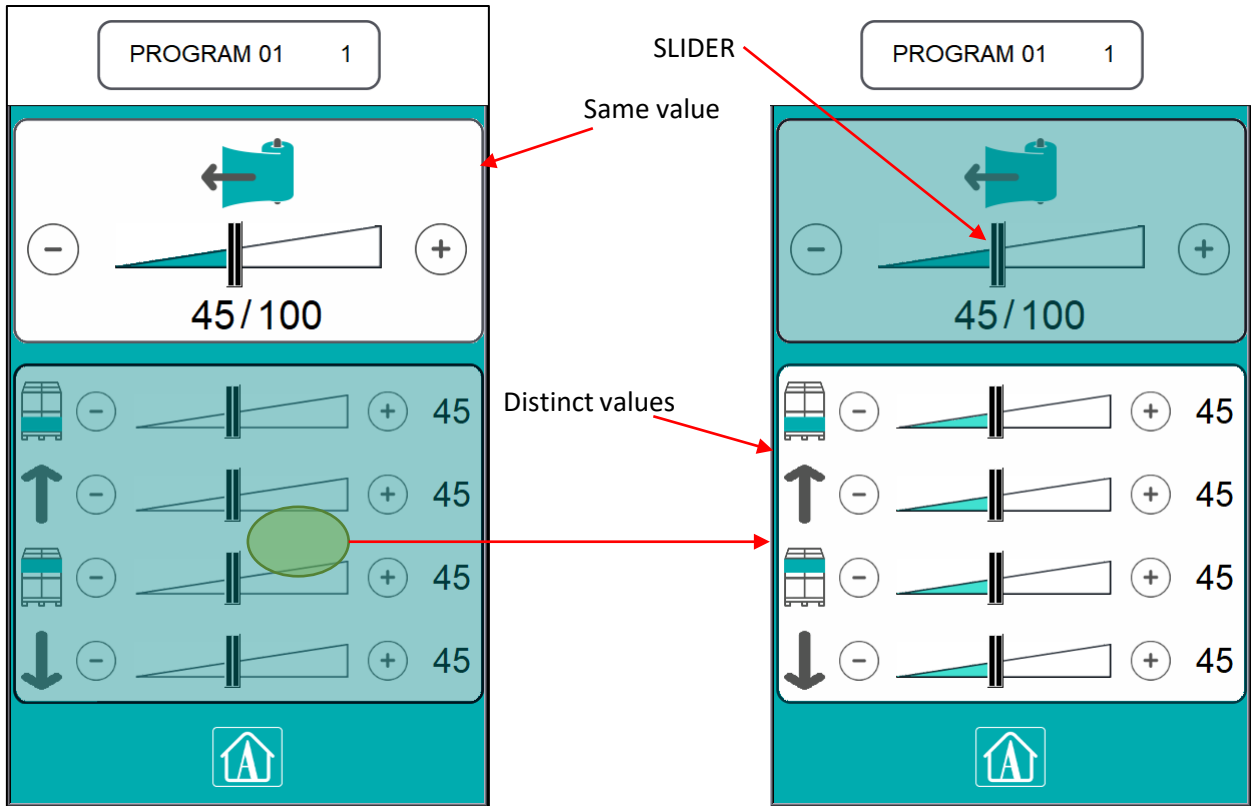


In this screen you can adjust the film tension in 2 ways:
- Setting a single value, the same for all phases of the cycle
- Setting 4 separate values
To switch between the two modalities, simply press on the dark area.
To change values by 1 unit use the '+' and '-' buttons. For faster changing you can drag the slider to the left and right. To save, press the HOME button.

The currently active shooting values will also be displayed in the HOMEPAGE

# ROTATION SPEED

Here, the turntable's ROTATION SPEED can be adjusted using the '+' and '-' buttons. For faster editing, the SLIDER can be dragged left and right. To save, press the HOME button.
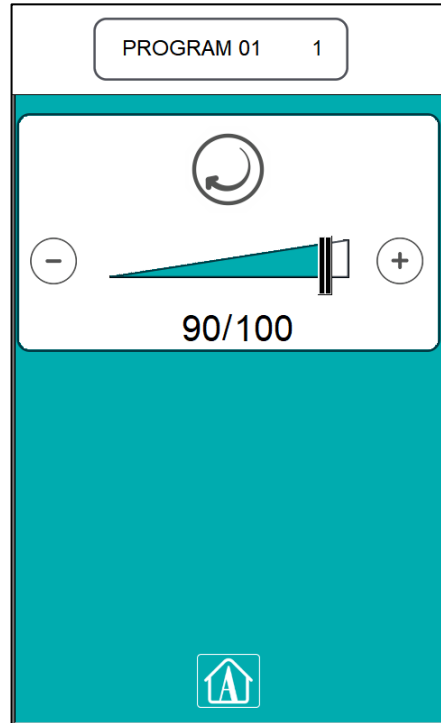


# UP / DOWN SPEED OF THE SPOOL CARRIAGE

Here you can adjust the up and down speed of the SLIDER using the '+' and '-' buttons. For faster editing, the SLIDER can be dragged left and right. To save, press the HOME button. As in the previous slide, you can choose between selecting a single speed for ascent and descent, or set them separately.
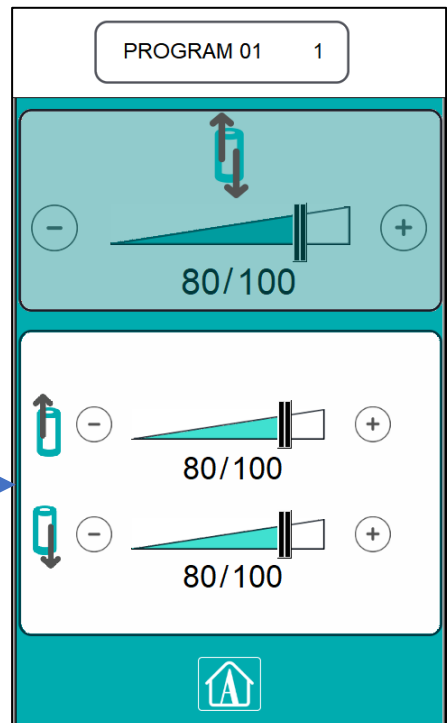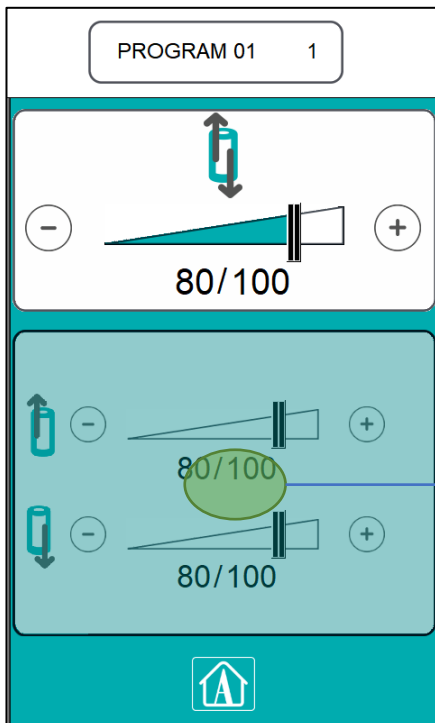
# FUNCTIONS GRID

The icons of the various functions present and active on the machine are shown here. Use the arrows at the top right/left to scroll through the functions. Functions have a representation of their status (ON/OFF) or set value on the outside. Press the HOME button to return to the HOMEPAGE.

NAVIGATION ARROWS

TOP COVER CYCLE

FILM PRE STRETCH

REINFORCEMENT WRAPS

FUNCTION STATUS AND/OR VALUE

WRAPPING HEIGHT

STEP CYCLE

SOFT START

PROGRAM 01     1

200 %     OFF     0|80

ON     OFF     OFF
10

NAVIGATION ARROWS

END CYCLE HEIGHT

START CICLO HEIGHT

NAVIGATION ARROWS

CONFORT HEIGHT

PRESSURE UNIT

ARYA SYSTEM

FILM CUT

PROGRAM 01     1

START     STOP

OFF     OFF     50 cm

0.20 SEC     ON     ON

# FUNCTIONS GRID

This is the restricted area for technicians, not accessible by the user

PROGRAM 01    1

# FILM PRE STRETCH

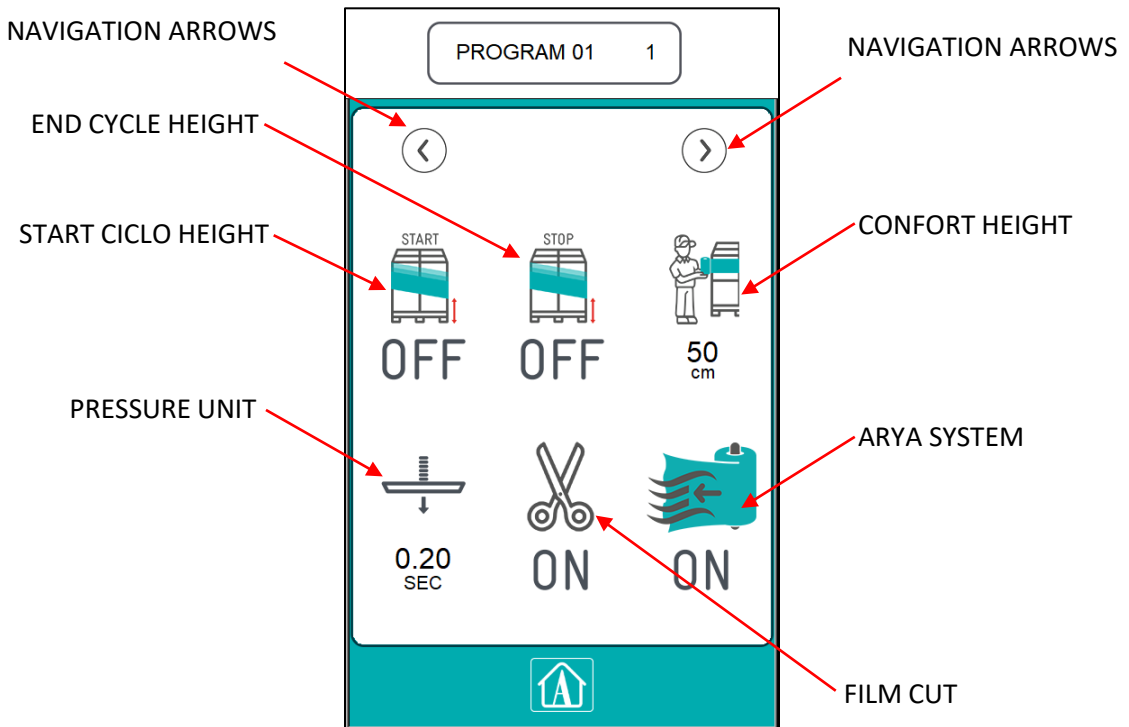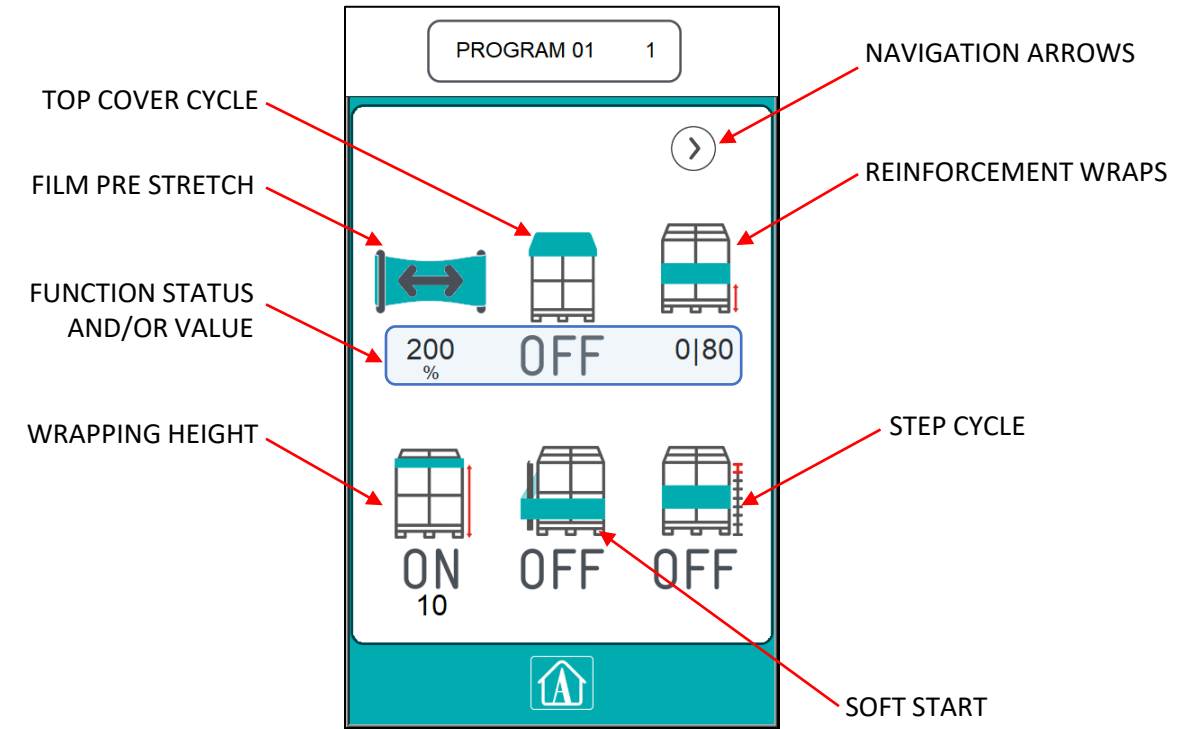Here you can adjust the FILM PRE STRETCH using the '+' and '-' buttons. For faster setting, the SLIDER can be dragged left and right. To save, press the HOME button. You can choose between selecting a single speed for upwards / downwards, or set them separately.

PROGRAM 01    1

200/400

200
200
200
200

PROGRAM 01    1

200/400

200
200
200
200
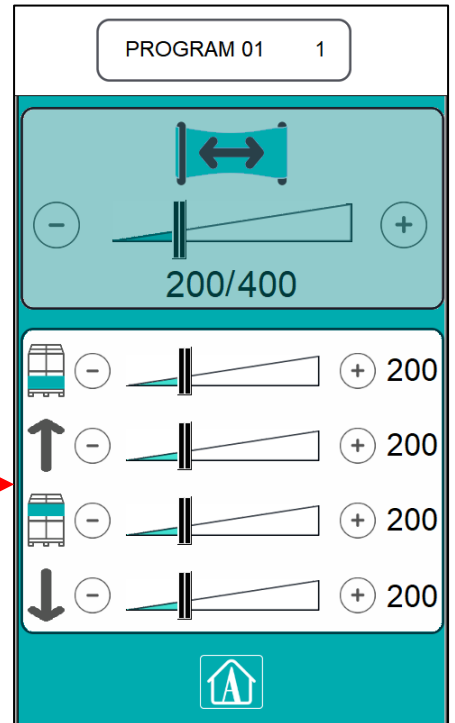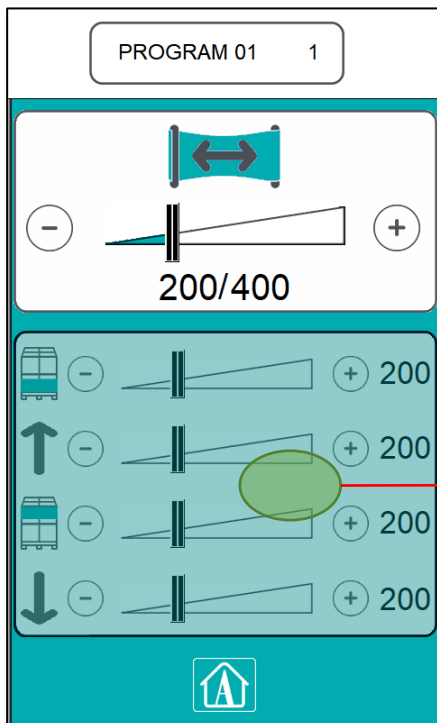
# TOP COVER CYCLE

Here you can activate/deactivate the TOP COVER CYCLE by pressing the ON/OFF switch. In the screen below, the downward height of the carriage during the cover-laying phase is indicated. This measure can be changed using the '+' and '-' buttons. For a faster change you can drag the SLIDER up and down. To save, press the HOME button, returning to the functions grid.

PROGRAM 01     1

ENABLING
DISABLING   TOP
COVER CYCLE

OFF     ON

25 cm

DOWNWARD
HEIGHT OF THE
CARRIAGE

PROGRAM 01     1

OFF     ON

25 cm

# REINFORCEMENT WRAPS

Here, the REINFORCEMENT WRAPS and the REINFORCEMENT QUOTE at which they are to be performed can be set. The value is changed using the '+' and '-' buttons. For faster editing, the SLIDER can be dragged left and right. To save, press the HOME button, returning to the function grid.

PROGRAM 01     1

REINFORCEMENT
WRAPS

0

REINFORCEMENT
QUOTE

80 cm

# WRAPPING HEIGHT

Here, you can set HOW the WRAPPING HEIGHT is detected.

The green/red switch below the photocell symbol allows you to switch between the two HEIGHT DETECTION modes:

-Using the photocell, automatic height **green selector switch, ftc activated**

-By setting a height in cm, manual height **red selector, ftc deactivated**

When the photocell is activated, an additional wrapping quote can be added using the '+' and '-' buttons. When the photocell is deactivated the wrapping height has to be set manually by means of the "+" and "-" buttons at the bottom of the screen, or for a faster change you can drag the SLIDER up and down. To save, press the HOME button, returning to the function grid.
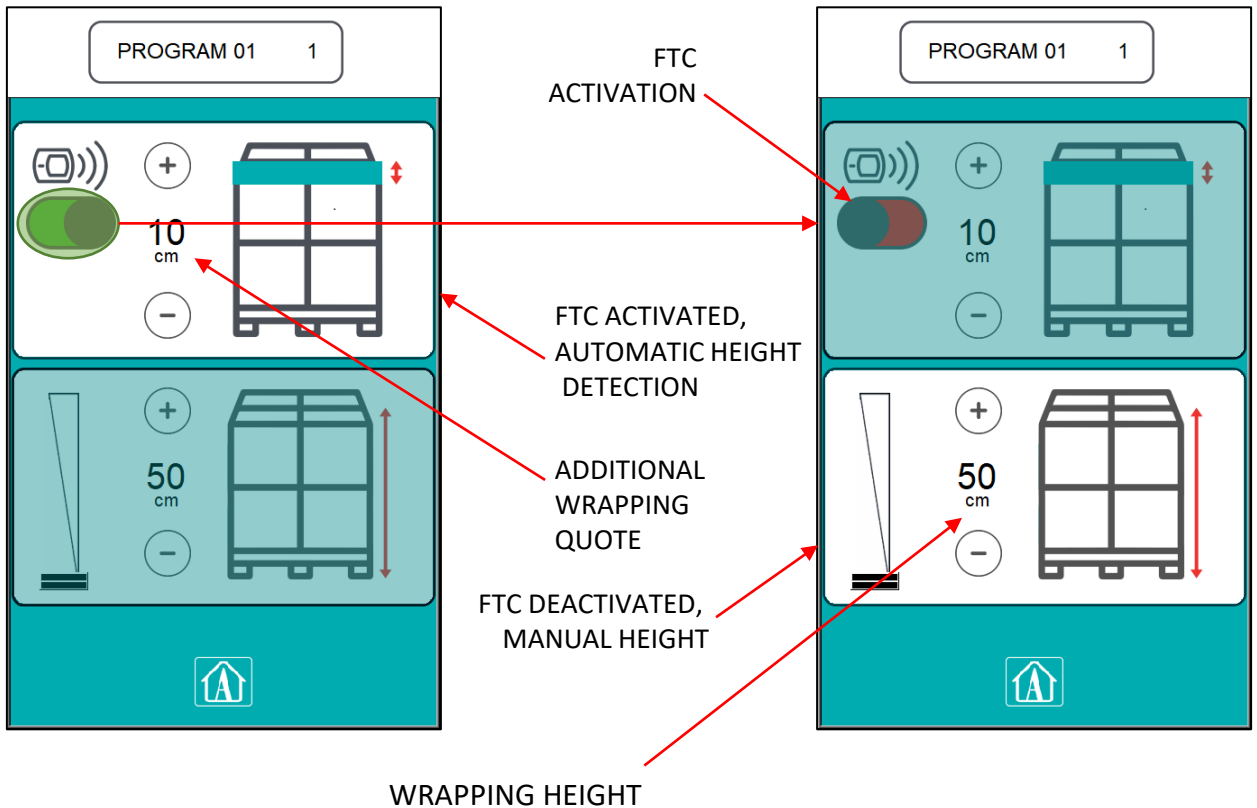
# SOFT START

Here you can activate/deactivate the SLOW START by pressing the ON/OFF switch. In the screen below, the seconds of slow rotation of the turntable at the beginning of the cycle are indicated. This time can be changed using the '+' and '-' buttons. For faster editing, you can drag the SLIDER up and down. To save, press the HOME button, returning to the function grid.



ACTIVATION DEACTIVATING SOFT START

SLOW ROTATION DURATION

# STEP CYCLE

Here you can activate/deactivate the STEP CYCLE by pressing the ON/OFF switch . In the top box, the number of wraps to be performed at each step and the step height are indicated. In the box below, it is possible to choose the tension and the prestretch to be applied during the step cycle.

All values can be changed using the '+' and '-' buttons. For faster editing, you can drag the SLIDER to the right and left. To save, press the HOME button, returning to the functions grid.



ACTIVATION DEACTIVATING SOFT START

NUMBER OF WRAPS

HEIGHT OF THE STEP

TENSION DURING STEP CYCLE

PRE STRETCH DURING STEP CYCLE

# START CYCLE HEIGHT

Here you can activate/deactivate the CYCLE START HEIGHT by pressing the ON/OFF selector. In the screen below, the height (in centimetres) of the carriage during the initial phase of the cycle indicates the wrapping start height. This height can be changed using the '+' and '-' buttons. For faster editing, you can drag the SLIDER up and down. To save, press the HOME button, returning to the functions grid.

START

PROGRAM 01    1

ACTIVATION DEACTIVATING START CYCLE HEGHT

START

OFF    ON

START CYCLE HEGHT

1 cm

START
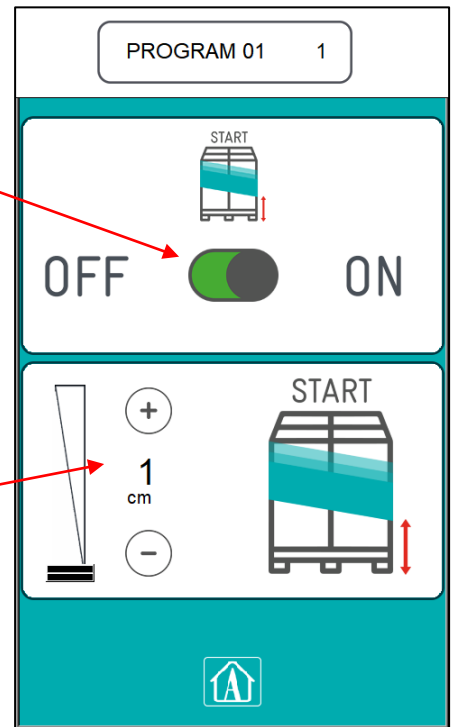
# STOP CYCLE HEIGHT

Here the CYCLE STOP HEIGHT can be activated/deactivated by pressing the ON/OFF switch. In the screen below, the height (in centimetres) of the carriage during the final phase of the cycle indicates the wrapping stop height. This height can be changed using the '+' and '-' buttons. For a faster change you can drag the SLIDER up and down. To save, press the HOME button, returning to the function grid.

STOP

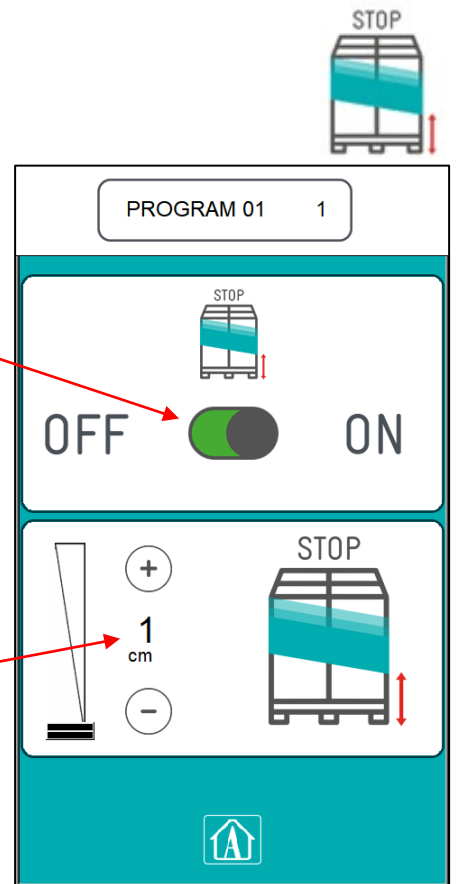PROGRAM 01    1

ACTIVATION DEACTIVATING STOP CYCLE HEGHT

STOP

OFF    ON

STOP CYCLE HEGHT

1 cm
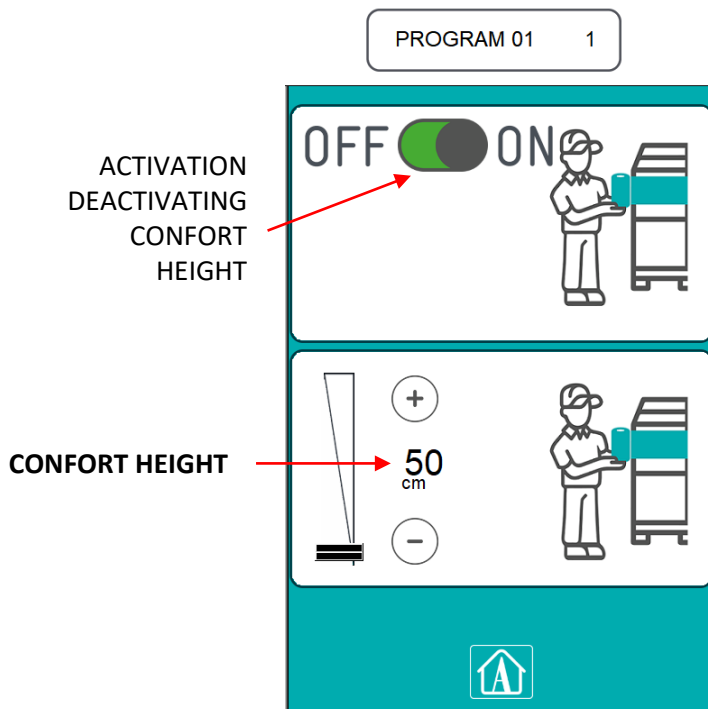
STOP

# CONFORT HEIGHT

Here you can activate/deactivate the CONFORT QUOTA at the end of the cycle by pressing the ON/OFF switch. As shown in the box below, if the comfort quota is activated at the end of the cycle, the carriage will rise to the indicated quota (in centimetres). This height can be changed using the '+' and '-' buttons. For faster editing you can drag the SLIDER up and down. To save, press the HOME button, returning to the function grid.

PROGRAM 01    1

OFF ON

ACTIVATION DEACTIVATING CONFORT HEIGHT

**CONFORT HEIGHT** → 50 cm

# PRESSURE UNIT

Here you can activate/deactivate the pressure unit. The display below shows the stop delay of the pressure plate during descent (increasing this value makes the pressure of the plate on the product increase). The value is changed using the '+' and '-' buttons. For faster editing you can drag the SLIDER up and down. To save, press the HOME button, returning to the function grid.
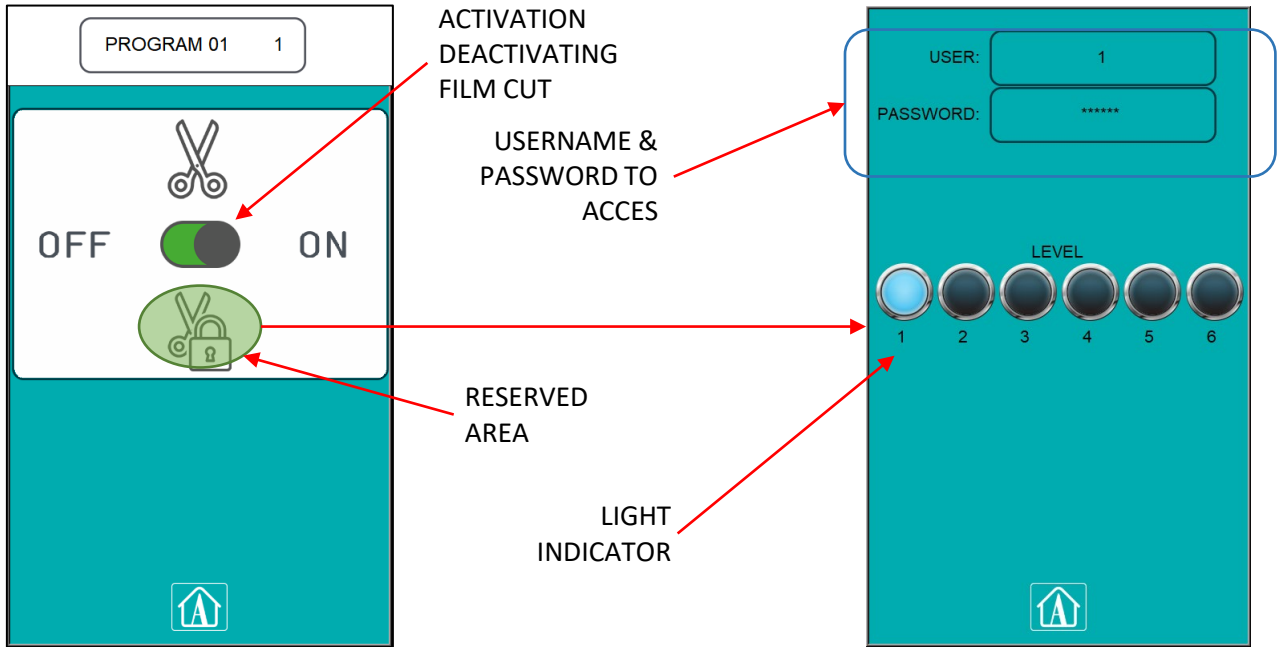
PROGRAM 01    1

ACTIVATION DEACTIVATING PRESSURE UNIT

OFF ON

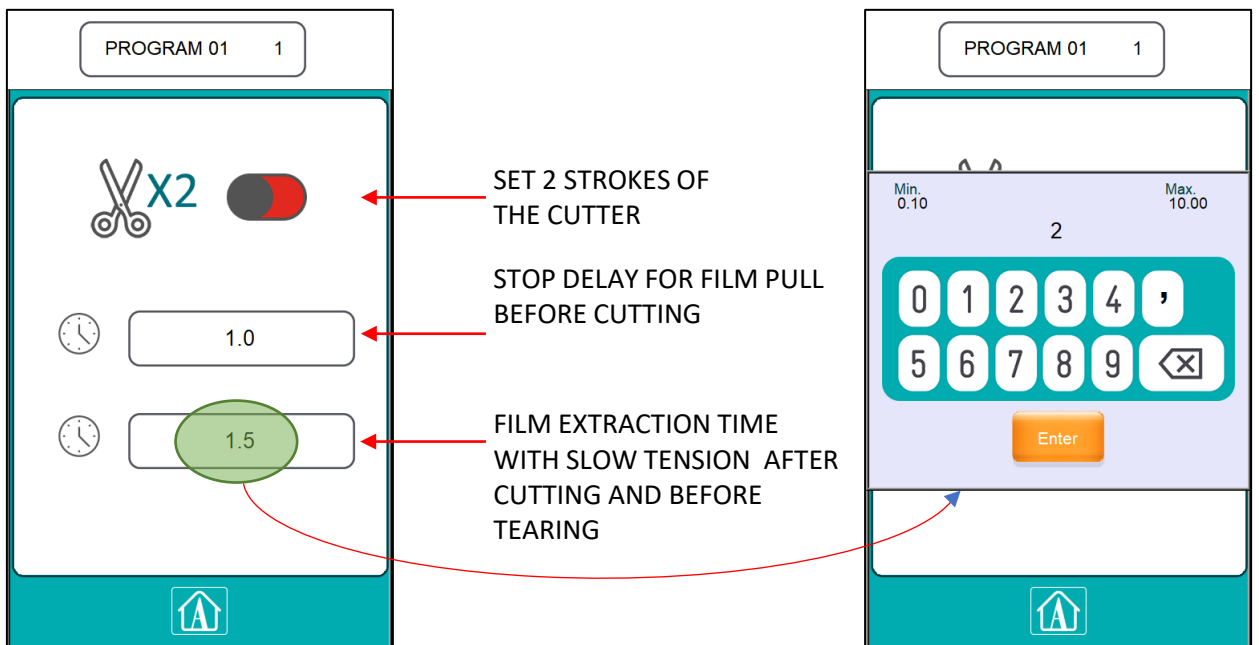STOP DELAY OF THE PRESSURE → 0.20 SEC
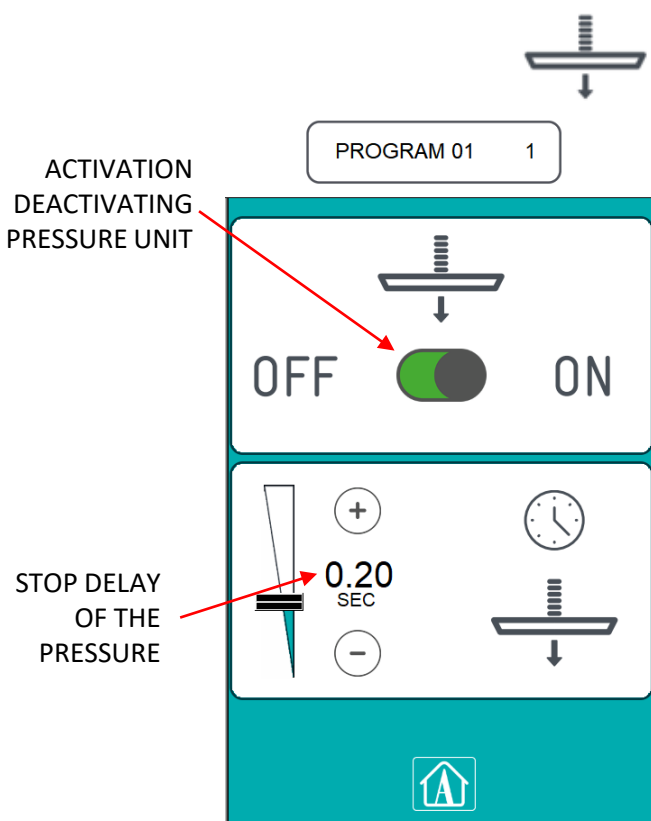
# AUTOMATIC FILM CUT

Here you can activate/deactivate AUTOMATIC FILM CUT at cycle end by pressing the ON/OFF switch. To save, press the HOME button, returning to the function grid.

ACTIVATION DEACTIVATING FILM CUT

USERNAME & PASSWORD TO ACCES

RESERVED AREA

LIGHT INDICATOR

PROGRAM 01    1

OFF    ON

USER:    1

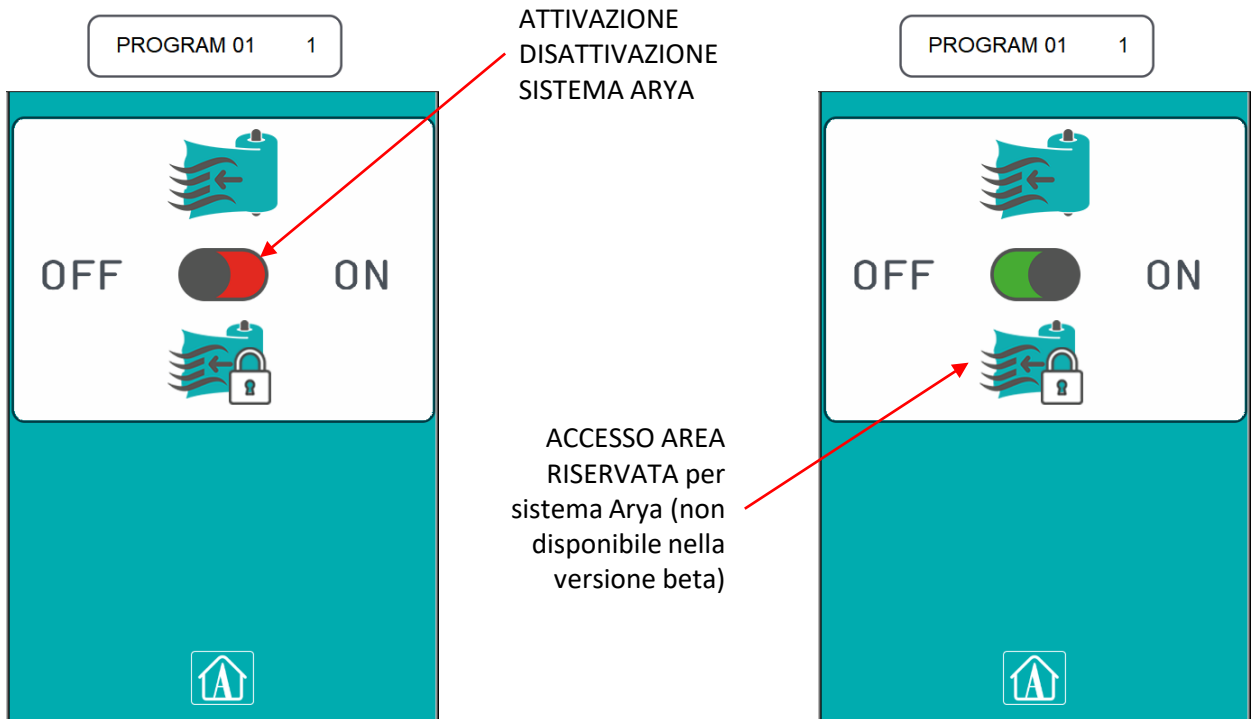PASSWORD:    ******

LEVEL
1    2    3    4    5    6

By pressing on the padlock icon, you will access a reserved area where you can change the 2 parameters related to film cutting. A new window will invite you to enter USER= [1] and PASSWORD=[111111] (enter the number 1 six times). Then 6 indicator lights will appear: if the operation was successful, indicator 1 will be on, otherwise an error occurred and and you will have to repeat the procedure to access again. Then press the HOME key to access the parameter editing. In the screen below you can activate the double cutter stroke, modify the film tension time before cutting and the film tension time after cutting (before tearing). These two values are usually set during the test phase and do not need to be changed routinely. When you have finished editing, press the HOME button to save and return to the previous screen.

PROGRAM 01    1

✂X2

1.0

1.5

SET 2 STROKES OF THE CUTTER

STOP DELAY FOR FILM PULL BEFORE CUTTING

FILM EXTRACTION TIME WITH SLOW TENSION AFTER CUTTING AND BEFORE TEARING

PROGRAM 01    1

Min.
0.10

Max.
10.00

2

0  1  2  3  4  ,

5  6  7  8  9  ⌫

Enter

# ARYA SYSTEM

Here you can activate/deactivate the ARYA System at the beginning of the cycle by pressing the ON/OFF switch. Access to the reserved area for editing Arya System parameters is not available in the beta version of the panel, it will be available in future releases. To save, press the HOME button, returning to the function grid.

ATTIVAZIONE DISATTIVAZIONE SISTEMA ARYA

| PROGRAM 01 | 1 |

OFF ⬤ ON

ACCESSO AREA RISERVATA per sistema Arya (non disponibile nella versione beta)

| PROGRAM 01 | 1 |

OFF ⬤ ON

Access to the restricted area for editing Arya System parameters is not available in the beta version of the panel, it will be available in future releases

# MACHINE ALARM

When the machine is in alarm mode,  this red screen is displayed. It shows:
-The code of the alarm on the machine
-The QR code with a link to the machine's panel manual, with the list of alarms and how to solve them
-The panel RESET button
When the problem is resolved, the RESET button on the display can be pressed to resolve the alarm. If the alarm concerns the machine's emergency circuit, it may be necessary first to press the BLUE RESET button below the display. If several different alarms occur at the same time, when the RESET button on the display is pressed, the alarm code at the top may change, thus indicating that there is another error in addition to those already resolved.
When the alarms are resolved, the screen will turn green when the reset button is pressed. Then press the HOME button to return to the previous screen.

ALARM CODE

QR CODE FOR ACCESS THE MACHINE PANEL MANUAL WITH LIST OF ALARMS

RESET BUTTON