Instructions - Parts

PCF[™] with **PrecisionSwirl**[™]

3A2098S

Precision Dispense System

Electronically-controlled fluid metering system that provides precise continuous flow of up to four single-component sealants and adhesives through closed-loop technology.

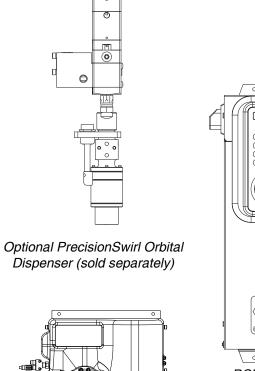
Not for use in explosive atmospheres or hazardous locations. For professional use only.



Important Safety Instructions

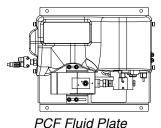
Read all warnings and instructions in this manual. Save these instructions.

See page 4 for model information. See page 5 for maximum working pressure and approvals.





This manual does not apply to some PCF systems. See note on page 3 to verify this is the correct manual for your PCF system.



1238

PCF Control Center



Contents

Related Manuals 3	Operation44
Models 4	Startup
Fluid Plate Kits 5	Load Material
Control Panel Kits	Maintenance Mode Operation 45
Expansion Swirl Enclosure Assemblies 8	Automation Control (Normal Operation)49
PrecisionSwirl Orbital Dispenser Assemblies 8	Jobs
Automation Gateway Assemblies 9	Styles
Swirl Control DGM 9	Precharge Modes51
Integration Upgrade with Advanced Map 10	Typical Job Cycle53
Warnings11	Pressure Relief Procedure61
System Configurations	Shutdown
Typical Installation - Single Swirl, Single Fluid Plate	USB Data
Typical Installation - Multiple Fluid Plates, No Swirl	_
Dispensers	System Configuration Settings File
Typical Installation - Multiple Fluid Plates, Multiple	Custom Language File
Swirl Dispensers	Download Procedure
Overview	Upload Procedure
System Overview	Troubleshooting
System Components	Fluid Plates
Fluid Plate Assembly Overview	Flow Meter
Control Center Assembly Overview	Fluid Regulator67
Key Tokens	Dispense Valves
Installation24	Gateway Module69
Before Installation	LED Diagnostic Information
Overview	Errors70
Install Control Center	View Errors70
Install Fluid Plate Assemblies	Diagnose Errors
Install Cable Assemblies	Event and Error Codes and Troubleshooting71
Install Gateway Module Interface	Maintenance 80
System Setup	Maintenance Schedule80
Overview	Advanced Display Module (ADM)81
Configure System	Upgrade Gateway Module Software (16K743) . 81
	Upgrade Gateway Module Fieldbus Map (16N601
Configure Mode Settings	or 17P799)
Configure Node Settings	Upgrade Fluid Control Module (FCM) Software
Configure Delay Settings	(16K743)
Configure Flow Meter Settings	Air Filter Maintenance
Configure Pressure Loop Settings	Swirl Dispensers
Adjust Pressure Sensors	Repair84
Configure Errors	Fluid Plate Assembly
Setup Maintenance Schedule/Parameters 41	Control Center Assembly 91
Configure Valve to Swirl Association and Motor	Parts95
Error Type	Control Centers
Configure Cateway Settings	Control Center and Expansion Swirl Enclosure
Configure Gateway Settings	Parts
Setup Styles	Fluid Plate Assembly Parts98
Configure Advanced Settings	
On/Off Delays	

Appendix A - Advanced Display Module (ADM) 10)4
Display Overview)4
Display Details)4
Setup Mode)6
Run Mode	16
Appendix B - Discrete Gateway Module (DGM)	
Connection Details	21
D-Sub Cable 123793	21
D-Sub Cable 123792 and Breakout Board 12378	3
DGM Digital Input12	25
DGM Digital Outputs12	26
DGM Analog Inputs	27
DGM Analog Outputs12	27
Appendix C - Communications Gateway Module	
(CGM) Connection Details12	28
Install Fieldbus Connections	28
CGM I/O Data Map13	31
Appendix D - I/O Signal Descriptions 14	ļ 6
Automation Inputs14	16
Automation Outputs	17
Technical Data14	18
Swirl Dispenser Technical Data14	18
Fluid Plate Assembly Technical Data 14	19
Control Center Assembly Technical Data 14	19
Graco Standard Warranty15	50
Graco Information	50

Related Manuals

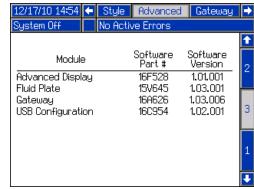
The following is a list of component manuals written in English. These manuals and any available translations can be found at www.graco.com.

Description
Original PCF Instructions - Parts (see the note below)
PrecisionSwirl Orbital Dispenser
Mastic Fluid Regulators Instructions-Parts
Fluid Pressure Regulators Instructions-Parts
Helical Gear Fluid Flow Meters Instructions-Parts
Integrated PCF Instructions
Coriolis Flow Meter Instructions - Parts

NOTE: In the Advanced screens on your system, if the Advanced Display software part number shown is 16F528 or 15V769 then this manual does not apply to your system; refer to manual 313377 for your system. Otherwise, the part number shown should be 16K405 and you should use this manual.

ADM Software Part No. 16F528 or 15V769 (see manual 313377)





ADM Software Part No. 16K405 (use this manual)



11/17/11 14:00 ← Active	Gateway Advanced No Active Errors	Fluid Plate 1	+
Module	Software Part #	Software Version	1
Advanced Display USB Configuration	16K405 16 I874	1.02.011	3
Gateway Fluid Plate 1	16J872 16J873	1.01.006 1.01.012	4
Fluid Plate 2 Swirl Control 1 Swirl Control 2	16J873 16J872 16J872	1.01.009 1.01.006 1.01.006	1
Jovent Corld Ot 2	10,1072	101000	2
			Ŧ

Models

Check the identification (ID) plate for the 6-digit part number of the fluid metering system. Use the following matrix to define the construction of the system, based on the six digits. For example, Part **PF1110** represents a PCF fluid metering system (**PF**), a two style system (**1**), a fluid plate with a cartridge regulator and no meter (**1**), a DeviceNet user interface (**1**) with a 100-240 Vac power supply (**0**).

NOTE: To order replacement parts, see Parts section in this manual. The digits in the matrix do not correspond to the Ref. Nos. in the Parts drawings and lists.

PF		1 1 1		1		1		0	
First and		Third Digit	Fourth Digit Fifth Digit Sixth		Fifth Digit		Sixth Digit		
Second Digits		Style/Size		Fluid F	Plate		User Interface	Voltage	
		Description		Regulator	Meter		Description		Description
PF	1	2 Styles	1	∗Cartridge	None	0	◆Discrete	0	100 - 240 Vac
(Precision Continuous	2	16 Styles	2	 ≉Mastic	None	1	DeviceNet [™]	1	24 Vdc
Flow)	3	256 Styles	3	*Cartridge	High Resolution	2	EtherNet/IP [™]	2	100 - 240 Vac with Integrated Swirl
			4	∗Mastic	High Resolution	3	PROFIBUS [™]	3	24 Vdc with Integrated Swirl
			5	Heated Mastic	Heated Standard Res- olution	4	PROFINET [™]		
			6	Heated Mas-	None	5	Not Used.		
				tic		6	DeviceNet No ADM		
			7	*Cartridge	Ultra High Resolution	7	EtherNet I/P No ADM		
			8	Cartridge	High Resolution /GB				
			9	Mastic	High Resolution /GB				
			С	Cartridge	Coriolis				

◆ Discrete Gateway systems do not include automation interface cables. The following Graco accessories are available for wiring to the automation system. Installers should follow **Appendix B - Discrete Gateway Module** (**DGM**) **Connection Details**, page 121, for custom wiring.

For single fluid plate systems only: 50 ft (15 m) cable with flying leads (123793)

All systems: Breakout board (123783) and 50 ft (15 m) cable (123792)

NOTE: 256 styles option is not available with Discrete Gateway systems.

These fluid metering systems have ETL certification.

NOTE: Fluid metering systems with heated mastic regulators are not ETL certified.



Intertek

9902471 Certified to CAN/CSA C22.2 No. 61010-1 Conforms to UL 61010-1

This product has been tested to the requirements of CAN/CSA-C22.2 No. 61010-1, second edition, including Amendment 1, or a later version of the same standard incorporating the same level of testing requirements.

Fluid Plate Kits

NOTE: The fluid plate kit numbers listed below include a CAN splitter. The fluid plate assembly included in each PFxxxx assembly does not include a CAN splitter.

				Includes:		
Fluid Plate Kit	Used by Model	Maximum Working Pressure	Description	Regula- tor	Flow Meter	FCM Key Token
24B958	PF13xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, High Resolution Flow Meter, 2 styles	244734	246652	16M100
24B959	PF11xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, No Flow Meter, 2 styles	244734		16M101
24B960	PF14xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, High Resolution Flow Meter, 2 styles	246642	246652	16M100
24B961	PF12xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, No Flow Meter, 2 styles	246642		16M101
24B962	PF15xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, Standard Resolution Heated Flow Meter, 2 styles	246643	246340	16M100
24C901	PF16xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, No Flow Meter, 2 styles	246643		16M101
24J873	PF17xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, Ultra High Resolution Flow Meter, 2 styles	244734	16E993	16M100
24K801	PF23xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, High Resolution Flow Meter, 16 styles	244734	246652	16M102
24K802	PF21xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, No Flow Meter, 16 styles	244734		16M103
24K803	PF24xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, High Resolution Flow Meter, 16 styles	246642	246652	16M102
24K804	PF22xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, No Flow Meter, 16 styles	246642		16M103
24K805	PF25xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, Standard Resolution Heated Flow Meter, 16 styles	246643	246340	16M102
24K806	PF26xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, No Flow Meter, 16 styles	246643		16M103
24K807	PF27xx	6000 psi (41.4 MPa, 414 bar)	Cartridge Regulator, Ultra High Resolution Flow Meter, 16 styles	244734	16E993	16M102
24K808	PF33xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, High Resolution Flow Meter, 256 styles	244734	246652	16M104
24K809	PF31xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, No Flow Meter, 256 styles	244734		16M105
24K810	PF34xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, High Resolution Flow Meter, 256 styles	246642	246652	16M104
24K811	PF32xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, No Flow Meter, 256 styles	246642		16M105
24K812	PF35xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, Standard Resolution Heated Flow Meter, 256 styles	246643	246340	16M104
24K813	PF36xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, No Flow Meter, 256 styles	246643		16M105
24K814	PF37xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, Ultra High Resolution Flow Meter, 256 styles	244734	16E993	16M104
24V592	PF18xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, Glass Bead High Resolution Flow Meter, 2 styles	244734	24P688	16M100

Models

					Includes:	
Fluid Plate Kit	Used by Model	Maximum Working Pressure	Description	Regula- tor	Flow Meter	FCM Key Token
24V593	PF28xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, Glass Bead High Resolution Flow Meter, 16 styles	244734	24P688	16M102
24V594	PF38xx	6000 psi (41 MPa, 414 bar)	Cartridge Regulator, Glass Bead High Resolution Flow Meter, 256 styles	244734	24P688	16M104
24V595	PF19xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, Glass Bead High Resolution Flow Meter, 2 styles	246642	24P688	16M100
24V596	PF29xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, Glass Bead High Resolution Flow Meter, 16 styles	246642	24P688	16M102
24V597	PF39xx	5000 psi (35 MPa, 345 bar)	Mastic Regulator, Glass Bead High Resolution Flow Meter, 256 styles	246642	24P688	16M104
24W201	PF15xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, Standard Resolution Heated Flow Meter, 2 styles	246643	246340	16M100
24W202	PF25xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, Standard Resolution Heated Flow Meter, 16 styles	246643	246340	16M102
24W203	PF35xx	5000 psi (35 MPa, 345 bar)	Heated Mastic Regulator, Standard Resolution Heated Flow Meter, 256 styles	246643	246340	16M104
25C783	PF1Cxx	5000 psi (35 MPa, 345 bar)	Cartridge Regulator, Coriolis Flow Meter, 2 styles	244734	25D026	16M100
25C784	PF2Cxx	5000 psi (35 MPa, 345 bar)	Cartridge Regulator, Coriolis Flow Meter, 16 styles	244734	25D026	16M102
25C785	PF3Cxx	5000 psi (35 MPa, 345 bar)	Cartridge Regulator, Coriolis Flow Meter, 256 styles	244734	25D026	16M104

Control Panel Kits

NOTE: The control kit numbers listed below are replacement control enclosures with their voltage and automation interface listed.

Part No.	System Type	Voltage	Automation Interface
16K601	ACCESSORY SWIRL	VAC	DeviceNet
16K602	ACCESSORY SWIRL	VAC	EtherNet/IP
16K603	ACCESSORY SWIRL	VAC	PROFIBUS
16K604	ACCESSORY SWIRL	VAC	PROFINET
16K605	ACCESSORY SWIRL	VAC	IO
16K606	ACCESSORY SWIRL	VDC	DeviceNet
16K607	ACCESSORY SWIRL	VDC	EtherNet/IP
16K608	ACCESSORY SWIRL	VDC	PROFIBUS
16K609	ACCESSORY SWIRL	VDC	PROFINET
16K610	ACCESSORY SWIRL	VDC	IO
16M350	SWIRL EXPANSION	VAC	N/A
16M351	SWIRL EXPANSION	VDC	N/A
24\$023	STANDARD	VAC	DeviceNet
25C590	STANDARD	VAC	EtherNet/IP
25C591	STANDARD	VAC	PROFIBUS
25C592	STANDARD	VAC	PROFINET
25C593	STANDARD	VAC	Ю
24\$024	STANDARD	VDC	DeviceNet
25C594	STANDARD	VDC	EtherNet/IP
25C595	STANDARD	VDC	PROFIBUS
25C596	STANDARD	VDC	PROFINET
25C597	STANDARD	VDC	Ю
25C582	INTEGRATED (No ADM)	VAC	DeviceNet
25C583	INTEGRATED (No ADM)	VAC	EtherNet/IP
25C584	INTEGRATED (No ADM)	EGRATED (No ADM) VAC	
25C585	INTEGRATED (No ADM)	VAC	EtherNet/IP
25C586	INTEGRATED (No ADM)	VDC	DeviceNet
25C587	INTEGRATED (No ADM)	VDC	EtherNet/IP
25C588	INTEGRATED (No ADM)	VDC	DeviceNet
25C589	INTEGRATED (No ADM)	VDC	EtherNet/IP

Expansion Swirl Enclosure Assemblies

The following enclosures are ETL approved. Assemblies PFxxx2, and PFxxx3 are setup for one PrecisionSwirl Orbital Dispenser. If you wish to have additional swirl dispensers, order one expansion PrecisionSwirl assembly below for each. Systems with a DGM as the automation gateway can have up to two swirl dispensers total. Systems with a CGM as the automation gateway can have up to four swirl dispensers total.

Part	Description
16M350	100 - 240 Vac
16M351	24 Vdc

PrecisionSwirl Orbital Dispenser Assemblies

See manual 309403.

Version	Part, Series	Coupler Offset	Typical Application	Maximum Working Pressure
Standard	243402, B	0.012 in. for narrow bead widths	Hem flange and after hem	
Standard	243403, B	0.028 in. for wide bead widths	Seam sealing	3500 psi (24.1 MPa,
Compact	289262, A	0.012 in. for narrow bead widths	Hem flange and after hem	241 bar)
Compact	289261, A	0.018 in. for medium bead widths	Seam sealing	

PrecisionSwirl Orbital Dispenser Cable Assemblies

Part	Description
233125	6 ft (1.8 m) motor extension cable assembly
233124	9 ft (2.7 m) motor extension cable assembly
233123	15 ft (4.6 m) motor extension cable assembly
617870	55 ft (16.8 m) motor extension cable assembly

Automation Gateway Assemblies

Each control center comes with one automation gateway assembly. The automation gateway module is either a Discrete Gateway Module (DGM) or one of the Communications Gateway Modules (CGM). To order a replacement, see the following table. You will also need to order software upgrade token (16K743).

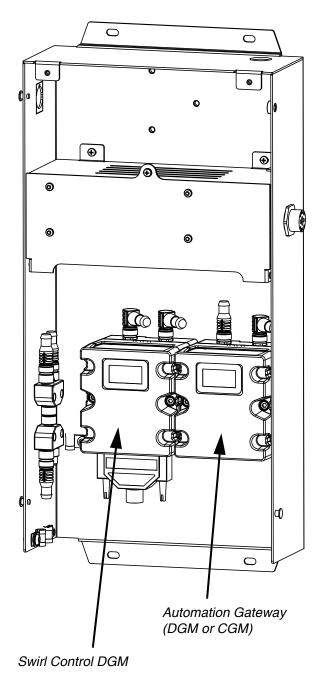
NOTE: Base and cable are not included.

PCF Model	User Interface Description	Gateway Part Number To Order	Rotary Switch Position	Compatible with Advanced CGM Map
PFxx0x	Discrete (DGM)	24B681	0	No
PFxx1x + PFxx6x	DeviceNet [™] (CGM)	15V759	Any	Yes
PFxx2x + PFxx7x	EtherNet/IP [™] (CGM)	15V760	Any	Yes
PFxx3x	PROFIBUS [™] (CGM)	15V761	Any	No
PFxx4x	PROFINET [™] (CGM)	15V762	Any	No

Swirl Control DGM

The assemblies below each contain one swirl control DGM used to control one Swirl Dispenser. To order a replacement, see the following table. You will also need to order software upgrade token (16K743).

Assembly	Part Number To Order	Rotary Switch Position
PFxxx2, PFxxx3, 16M350, 16M351	24B681	1, 2, 3, or 4; see Swirl Control DGM on page 22



Integration Upgrade with Advanced Map

NOTE: See manual 3A4649 for more information.

Graco provides an upgraded software solution for PCF systems that came with automation communication gateway modules (CGM). The table below shows which systems have the ability to upgrade their system with the update kit (25C527). This kit includes new CGM software, as well as a larger data map.

Benefits of Upgrading:

- Direct access to important information such as flowrates and pressures of the system (all four fluid plates).
- 2. Allows for a complete integration of a Graco PCF system, meaning an ADM is no longer necessary.
- 3. Much easier set up and integrate.
- Much more supporting documentation to identify what is important.

NOTE: Only systems with Ethernet I/P and Device Net are capable of upgrading to use the Advanced Map.

PCF Model	User Interface Description	Able to Upgrade	Upgrade Kit
PFxx0x	Discrete (DGM)	No	N/A
PFxx1x	Device Net (CGM)	Yes	25C527
PFxx2x	Ethernet I/P (CGM)	Yes	25C527
PFxx3x	ProfiBus (CGM)	No	N/A
PFxx4x	ProfiNet (CGM)	No	N/A
PFxx6x	Device Net (CGM)	Already has upgrade installed	Already has upgrade installed
PFxx7x	Ethernet I/P (CGM)	Already has upgrade installed	Already has upgrade installed

Table 1: Software Upgrade Tokens

Part	Description	Contents
★ № 16K743	Includes PCF software for the ADM, FCM, CGM, and DGM	System Software
★ * 16N601	PCF Gateway map token: Installs the CGM map starting on page 128.	Standard Gateway Map
16T061	PCF Gateway map token: Installs the CGM map starting on page 128.	Basic Gateway Map (2 fluid plate), No Swirl
★ 16K742	Historical PCF Gateway map token: Only for users that used the original PCF with a Gateway, have purchased a new PCF, and do not wish to change their Gateway setup from the old Gateway map to the new Gateway map.	Historical Map
25C527	Advanced integration software kit. Includes the latest PCF software for the ADM, FCM, CGM, and DGM (16K743). It also includes the larger Map (17P799). Both of these must be installed for the CGM to run, and have advanced integration features.	System Software and Advanced Map

Table 2: Fieldbus Setup Options

Basic Gateway Map: 16T061		
System Software: 16K743		
Comm. Format:	Data - SINT	
Input Assembly Instance:	100	
Input Instance Size:	10	
Output Assembly Instance:	150	
Output Instance Size:	6	
Standard Gateway Map	: 16N601	
System Software: 1	6K743	
Comm. Format:	Data - SINT	
Input Assembly Instance:	100	
Input Instance Size:	26	
Output Assembly Instance:	150	
Output Instance Size:	42	
Advanced Gateway Ma	p: 17P799	
System Software: 16K743 (n	ewest version)	
Comm. Format	Data - SINT	
Input Assembly Instance:	100	
Input Instance Size	126	
Output Assembly Instance:	150	
Output Instance Size:	44	

Warnings

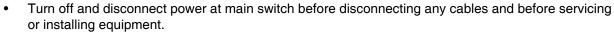
The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. When these symbols appear in the body of this manual, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.

WARNING



ELECTRIC SHOCK HAZARD

This equipment must be grounded. Improper grounding, setup, or usage of the system can cause electric shock.



- Connect only to grounded power source.
- All electrical wiring must be done by a qualified electrician and comply with all local codes and regulations.



SKIN INJECTION HAZARD

High-pressure fluid from dispensing device, hose leaks, or ruptured components will pierce skin. This may look like just a cut, but it is a serious injury that can result in amputation. Get immediate surgical treatment.



- Do not point dispensing device at anyone or at any part of the body.
- Do not put your hand over the fluid outlet.
- Do not stop or deflect leaks with your hand, body, glove, or rag.
- Follow the Pressure Relief Procedure when you stop dispensing and before cleaning, checking, or servicing equipment.
- Tighten all fluid connections before operating the equipment.
- Check hoses and couplings daily. Replace worn or damaged parts immediately.



FIRE AND EXPLOSION HAZARD

Flammable fumes, such as solvent and paint fumes, in work area can ignite or explode. To help prevent fire and explosion:



Use equipment only in well ventilated area.



Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc).



Keep work area free of debris, including solvent, rags and gasoline.



- Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present.
- Ground all equipment in the work area. See **Grounding** instructions.
- Use only grounded hoses.
- Hold gun firmly to side of grounded pail when triggering into pail.
- If there is static sparking or you feel a shock, stop operation immediately. Do not use equipment until you identify and correct the problem.
- Keep a working fire extinguisher in the work area.

MARNING



EQUIPMENT MISUSE HAZARD

Misuse can cause death or serious injury.

- Do not operate the unit when fatigued or under the influence of drugs or alcohol.
- Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See **Technical Data** in all equipment manuals.
- Use fluids and solvents that are compatible with equipment wetted parts. See **Technical Data** in all
 equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information
 about your material, request MSDS forms from distributor or retailer.
- Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only.
- Do not alter or modify equipment.
- Use equipment only for its intended purpose. Call your distributor for information.
- Route hoses and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.
- Do not kink or over bend hoses or use hoses to pull equipment.
- · Keep children and animals away from work area.
- Comply with all applicable safety regulations.



BURN HAZARD

Equipment surfaces and fluid that's heated can become very hot during operation. To avoid severe burns:

• Do not touch hot fluid or equipment.



TOXIC FLUID OR FUMES HAZARD

Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed.



- Read MSDS's to know the specific hazards of the fluids you are using.
- Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.



PERSONAL PROTECTIVE EQUIPMENT

You must wear appropriate protective equipment when operating, servicing, or when in the operating area of the equipment to help protect you from serious injury, including eye injury, hearing loss, inhalation of toxic fumes, and burns. This equipment includes but is not limited to:

- Protective eyewear, and hearing protection.
- Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer

System Configurations

Typical Installation - Single Swirl, Single Fluid Plate

NOTE: Shown with one fluid plate and one swirl dispenser.

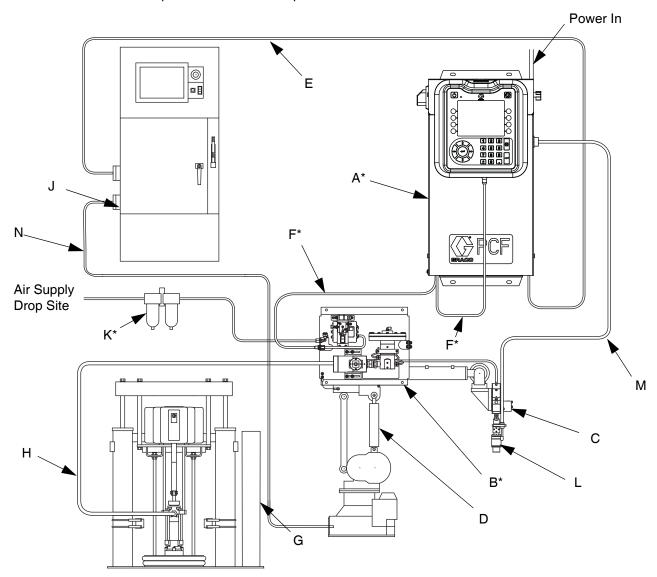


Fig. 1: Typical Ambient System Installation

Key:

- A *Control Center (User Interface)
- B *Fluid Plate Assembly
- C Applicator/Dispense Valve
- D Sealer Automation
- E Automation Interface Cable
- F *CAN Cable
- G Fluid Supply System
- H Fluid Supply Hose
- J Automation Controller

- K *Air Filter Assembly
- ◆ PrecisionSwirl Orbital Dispenser (Swirl Dispenser)
- M ◆PrecisionSwirl Cable
- N Sealer Automation Control Cable
- * Included
- ◆ Optional

Typical Installation - Multiple Fluid Plates, No Swirl Dispensers

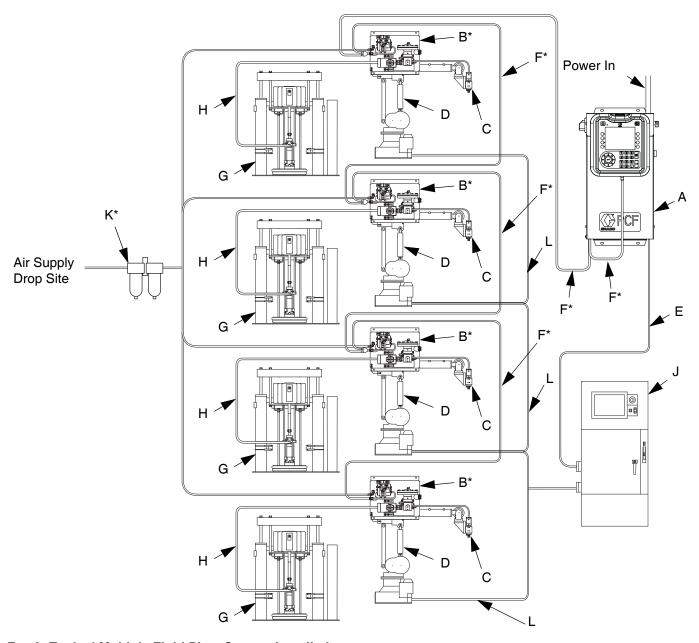


Fig. 2: Typical Multiple Fluid Plate System Installation

Key:

- A *Control Center (User Interface)
- B *Fluid Plate Assembly
- C Applicator/Dispense Valve
- D Sealer Automation
- E Automation Interface Cable

- F *CAN Cable
- G Fluid Supply System
- H Fluid Supply Hose
- J Automation Controller
- K *Air Filter Assembly
- L Sealer Automation Control Cable

^{*} Included

Typical Installation - Multiple Fluid Plates, Multiple Swirl Dispensers

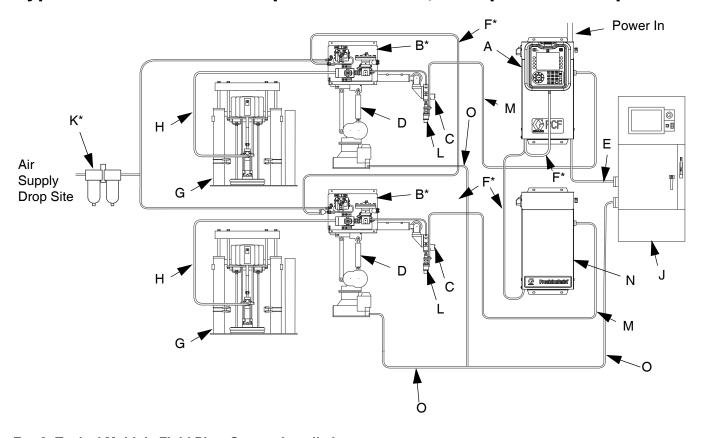


Fig. 3: Typical Multiple Fluid Plate System Installation

Key:

- A *Control Center (User Interface)
- B *Fluid Plate Assembly
- C Applicator/Dispense Valve
- D Sealer Automation
- E Automation Interface Cable
- F *CAN Cable
- G Fluid Supply System
- H Fluid Supply Hose
- J Automation Controller
- K *Air Filter Assembly
- L ◆PrecisionSwirl Orbital Dispenser (Swirl Dispenser)
- M ◆PrecisionSwirl Cable
- N ◆Expansion Swirl Enclosure
- O Sealer Automation Control Cable
- * Included
- ◆ Optional

Overview

System Overview

The PCF fluid metering system combines closed-loop pressure control with the ability to change bead profiles quickly. When used with an optional flow meter, the system automatically adjusts for fluctuations in the operating environment, such as material viscosity, temperature and tip wear, in order to maintain the desired dispense rate. The module responds to automation signals to provide an accurate and consistent output flow based on a comparison of actual to desired flow rates.

Typical Applications

- Bead dispensing
- Gasketing
- Seam sealing
- Hem flange
- Sound deadening
- Anti-flutter
- Body panel reinforcement
- Profile wrapping
- Cable filling

System Components

The diagram in Fig. 4 shows an example of the PCF module and cables.

Control Center (User Interface)

NOTE: The control center is available with or without an ADM, depending on the model you are using. See **Models** on page **4**.

The control center communicates with the PCF fluid plate assembly to control fluid pressure and dispense valve operation.

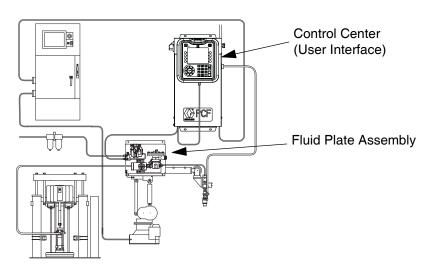
The control center receives input from the automation controller, and uses these inputs to determine communication to the fluid plate assembly.

Fluid Plate Assembly

The fluid plate assembly contains components that control and monitor fluid dispensing. A PCF fluid metering system can have up to four fluid plates. Each fluid plate can control up to four dispense valves. The system supports up to 16 dispense valves and can simultaneously dispense from up to 10 dispense valves.

PrecisionSwirl Orbital Dispenser (Swirl Dispenser), Sold Separately

The swirl dispenser dispenses material in a circular pattern at speeds from 6600 to 24000 rpm. A PCF fluid metering system can have up to four swirl dispensers. See manual 309403 for detailed information.



System shown with one fluid plate and one swirl dispenser

Fig. 4: PCF System Components

Fluid Plate Assembly Overview

Fluid Plate Components

The fluid plate assembly in Fig. 5 can be attached to an automation arm or mounted on a pedestal. The main components of the fluid plate assembly include:

- Fluid regulator (cartridge, ambient mastic, or heated mastic) (P).
- Flow meter (R) (optional) precisely measures the flow rate of fluid dispensed.
- Solenoid air valve (S) controls the dispense valve.
- Voltage to Pressure Transducer (T), abbreviated V/P transducer, adjusts the air pressure to the fluid regulator (P).
- Fluid Control Module (FCM) (U) receives pulse readings from the flow meter (R) and pressure readings from the regulator. It also controls the fluid regulator (P) and solenoid air valve (S).

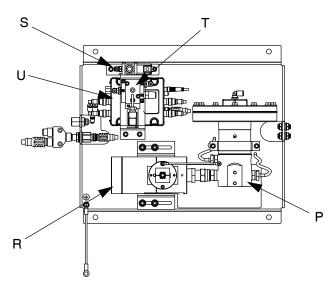


Fig. 5: Fluid Plate Components

The PCF fluid regulator is electrically controlled by the PCF fluid control module. Consistent material flow is assured by a closed-loop pressure or closed-loop flow control design. The module responds to automation-supplied signals to provide an accurate and consistent output flow based on a comparison of actual to desired flow rates. The fluid regulator uses air pressure to control fluid pressure and to provide fast response to electronic commands and ensure a precisely controlled, continuous flow of material.

The fluid plate assembly is available in two versions: ambient and heated.

Ambient Fluid Plate Assembly

There are five ambient versions available:

- cartridge regulator without a flow meter
- ambient mastic regulator without a flow meter
- cartridge regulator with a high resolution meter
- ambient mastic regulator with a high resolution meter
- cartridge regulator with an ultra high resolution flow meter
- cartridge regulator with Coriolis flow meter

Heated Fluid Plate Assembly

There are two heated versions available:

- heated mastic fluid regulator with a heated flow meter
- heated mastic fluid regulator without a flow meter

Fluid Regulator

There are three fluid regulator options:

- cartridge
- ambient mastic
- heated mastic

All of the fluid regulator options use air pressure to control fluid pressure, provide fast response to electronic commands, and ensure a precisely controlled, continuous flow of material.

Cartridge

The cartridge regulator (244734) is ideal for low to medium viscosity sealants and adhesives.

Ambient Mastic

The ambient mastic regulator (246642) is ideal for medium to high viscosity sealants and adhesives.

Heated Mastic

The heated mastic regulator (246643) is ideal for low to high viscosity warm-melt and hot-melt sealants or adhesives.

Fluid Control Module (FCM)

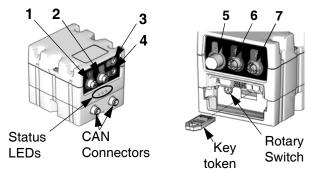


Fig. 6: FCM Sensor Connections

Table 3: FCM Sensor Connections

Connection	Sensor Description
1	Dispense solenoid
2	Flow meter
3	Outlet pressure sensor (heated systems only)
4	Voltage to Pressure (V/P) Transducer
5	Command cable (optional accessory kit)
6	Inlet pressure sensor (non-heated systems only)
7	Outlet pressure sensor (non-heated systems only)
CAN Connectors	

Rotary Switch on FCM

The rotary switch on the FCM, see Fig. 6, must be set to a valid position and each FCM must have a unique rotary switch position. The FCM rotary switch position determines which number to assign to that fluid plate. The settings, including defined styles, for each fluid plate are stored in each FCM so changing the rotary switch position causes the settings to be shown under the new number on the ADM.

Item	Rotary Switch Position
Fluid Plate 1	0 or 1
Fluid Plate 2	2
Fluid Plate 3	3
Fluid Plate 4	4

NOTE: See **LED Diagnostic Information**, page 69, for signal definitions.

Control Center Assembly Overview

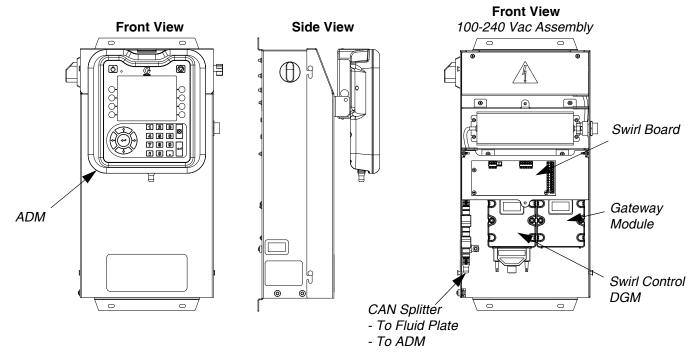


Fig. 7: Control Center Components

The control center includes the following components:

- Advanced Display Module (ADM) with USB; see page 20 for details.
- USB enables users to download job, event, and data logs; save and restore system settings; and customize the language. See USB Data on page 63.
- 24 Vdc and 100-240 Vac customer-wired options available.

- If system has a swirl dispenser: Swirl Control DGM (the module on the left) and Swirl Board.
- Automation Gateway Module (the module on the right), which can be one of the following five types:
 - Discrete (supports up to 2 Fluid Plates)
 - DeviceNet (supports up to 4 Fluid Plates)
 - EtherNet/IP (supports up to 4 Fluid Plates)
 - PROFIBUS (supports up to 4 Fluid Plates)
 - PROFINET (supports up to 4 Fluid Plates)

Expansion Swirl Enclosure

If more than one swirl dispenser is installed, the system will have one Expansion Swirl Enclosure for each additional swirl dispenser. The Expansion Swirl Enclosure is similar to the primary control center, but it does not include the ADM or the Automation Gateway module.

Advanced Display Module (ADM)

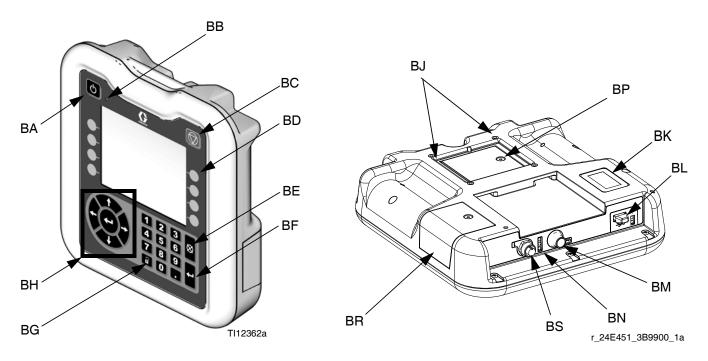


Fig. 8: Advanced Display Module Component Identification

KEY:

Callout	Function
ВА	Power On/Off Button
	Enables/disables system.
BB	System Status Indicator LED Displays system status. Green LED indicates the system is active. Orange LED indicates the system is off. Solid LEDs (green or orange) indicate the system is in Run mode. Flashing LEDs (green or orange) indicate the system is in Setup mode.
ВС	Stop Button Stops all system processes. However, it is not a safety or emergency stop.
BD	Soft Keys Functions vary depending on the screen.
BE	Cancel Button Clears system errors and cancels a selection or number entry while in the process of entering a number or making a selection.
BF	Enter Button Acknowledge changing a value or making a selection.
BG	Lock/Setup Toggle between run and setup screens. If setup screens are password protected, button toggles between run and password entry screens.

Callout	Function
ВН	Navigation Buttons Navigate within a screen or to a new screen.
BJ	Flat Panel Mount Mounts to control center bracket (optional).
BK	Model Number Tag Model number.
BL	USB Module Interface USB port and USB indicator LEDs.
ВМ	CAN Connector Power connection.
BN	Module Status LEDs See LED Diagnostic Information, page 69, for signal definitions.
BP	Battery Cover
BR	Token Access Cover
BS	Digital I/O Port for Light Tower

NOTICE

To prevent damage to the soft key buttons, do not press the buttons with sharp objects such as pens, plastic cards, or fingernails.

Automation Gateway Module

See the following table for the appropriate rotary switch position for your automation gateway module.

PCF Model	User Interface Description	Gateway Part Number To Order	Rotary Switch Position	Max Number of Fluid Plates
PFxx0x	Discrete (DGM)	24B681	0	2
PFxx1x	DeviceNet [™] (CGM)	15V759	Any	4
PFxx2x	EtherNet/IP [™] (CGM)	15V760	Any	4
PFxx3x	PROFIBUS [™] (CGM)	15V761	Any	4
PFxx4x	PROFINET [™] (CGM)	15V762	Any	4

NOTE: See Control Center Assembly Overview on page 19 for automation and swirl control DGM identification.

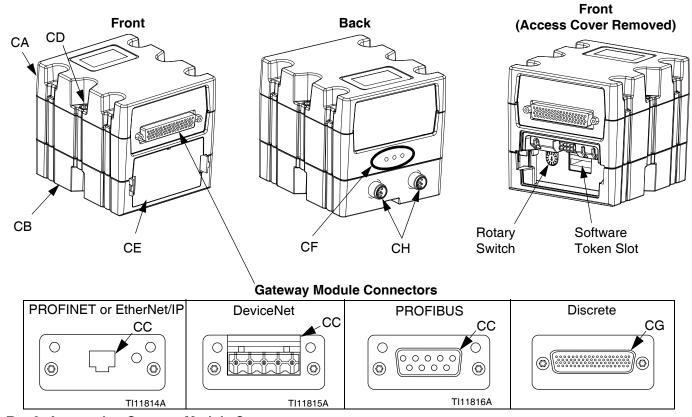


Fig. 9: Automation Gateway Module Components

Key:

- CA Gateway Module
- CB Base
- CC Fieldbus Connector (see Appendix C Communications Gateway Module (CGM) Connection

 Details, page 128, for more information)
- CD Module Connection Screws
- CE Access Cover
- CF Module Status LEDs (see **LED Diagnostic Information**, page 69)
- CG D-Subminiature (D-Sub) Connector (see Appendix B Discrete Gateway Module (DGM) Connection Details, page 121, for pinout details)
- **CH CAN Connectors**

Swirl Control DGM

One swirl control DGM is included in the integrated Swirl control center, and in each expansion swirl enclosure. Each Swirl control DGM controls one swirl orbiter.

Each swirl control DGM must have a unique rotary switch position. The rotary switch position determines the number assigned to the swirl dispenser attached to that DGM. If the rotary switch position must be changed, do so with the power off.

Each integrated swirl control center and swirl enclosure comes with a pre-installed cable between the swirl control DGM and the swirl board. The customer does not need to make any external connections with the swirl control DGM.

DGM Function	Rotary Switch Position
Swirl Control 1	1
Swirl Control 2	2
Swirl Control 3	3
Swirl Control 4	4

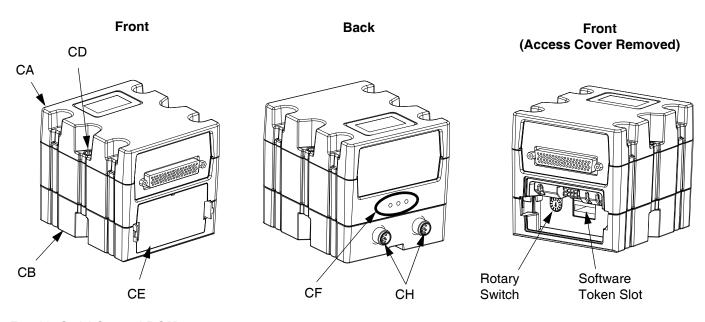
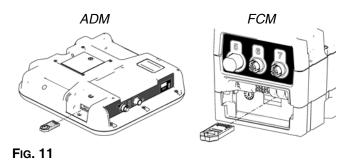


Fig. 10: Swirl Control DGM

Key Tokens

The ADM and FCM must each have a key token installed in order to operate. If the incorrect key token is installed, the module will not operate. The DGM does not require a key token.



NOTE: There is one FCM located on each fluid plate.

If a new ADM or FCM is installed, follow the instructions on page 81 to upgrade the software in the new module and to install the key token from the old module in the new module.

The following is a list of key token part numbers. If you lose your key token be sure to order the correct item to ensure proper system operation.

NOTE: The key tokens for the ADM and FCM look alike but only work in one module or the other. If the key tokens for the ADM and FCM become mixed, locate the part number on each token then refer to the following table to determine which module each token applies to.

Part	Description
16M100	FCM Key Token, 2 styles, Flow Meter, ADM required
16M101	FCM Key Token, 2 styles, No Flow Meter, ADM required
16M102	FCM Key Token, 16 styles, Flow Meter, Integrator Mode Enabled, ADM not required
16M103	FCM Key Token, 16 styles, No Flow Meter, Integrator Mode Enabled, ADM not required
16M104	FCM Key Token, 256 styles, Flow Meter, Integrator Mode Enabled, ADM not required
16M105	FCM Key Token, 256 styles, No Flow Meter, Integrator Mode Enabled, ADM not required
16M217	ADM Key Token, Standard PCF

Installation

Before Installation

- Have all system and component documentation available during installation.
- See component manuals for specific data on component requirements. Data presented here applies to the PCF assemblies only.
- Be sure all accessories are adequately sized and pressure-rated to meet system requirements.
- Use the PCF control center only with the PCF fluid plate assembly.

- For systems with swirl dispensers, install each swirl dispenser onto outlet of a dispense valve.
- 11. Connect other fluid and air lines to additional system components as instructed in their manuals.
- 12. Install fluid plate, swirl, and gateway cable assemblies, page 32.
- 13. Install Gateway interface, page 34.

Overview

The basic steps to install a PCF system are shown below. See the separate component manuals for detailed information.



To avoid injury and damage to equipment, use at least two people to lift, move, or disconnect the system. The system is too heavy for one person to lift or move.

Installation Steps

- 1. Mount control center, page 25.
- 2. For systems with multiple swirl dispensers, mount expansion Swirl enclosures, page 25.
- 3. Connect and ground control center and expansion Swirl enclosures, page 26.
- 4. Mount each fluid plate assembly, page 27.
- 5. If using a Coriolis flow meter system, mount the flow meter, page 149.
- 6. Ground each fluid plate assembly, page 31.
- 7. Check ground continuity.
- Connect fluid lines between each fluid plate and applicator. Connect fluid supply line and air supply to module. See page 31.
- 9. Plumb air filter assembly near air supply drop site that will be used for fluid plate assembly.

Install Control Center

NOTE: This section applies to both the primary control center and the expansion Swirl enclosures.

Mount

Ensure the following criteria are met before mounting the PCF control center:

- Select a location for the control center that allows adequate space for installation, service, and use of the equipment.
- For best viewing, the ADM should be 60-64 in. (152-163 cm) from the floor.
- Ensure there is sufficient clearance around the control unit to run cables to other components.
- Ensure there is safe and easy access to an appropriate electrical power source. The National Electric Code requires 3 ft (0.91 m) of open space in front of the control center.
- Ensure there is easy access to the power switch.
- Ensure the mounting surface can support the weight of the control center and the cables attached to it.

Secure the control center with appropriate size bolts through the 0.27 in. (7 mm) diameter holes in the mounting tabs. See the following mounting dimensions.

Table 4: Control Center Assembly Measurement

Α	10.50 in. (267 mm)
В	5.75 in. (146 mm)
С	22.00 in. (559 mm)
D	21.25 in. (540 mm)

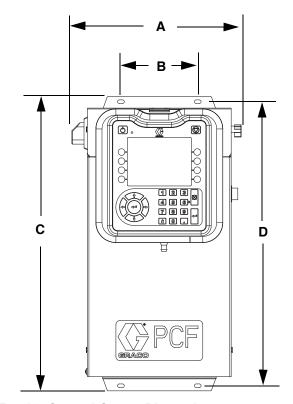


Fig. 12: Control Center Dimensions

Electrical Connections



This product must be grounded. In the event of an electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current.

- The control center must be electrically connected to a true earth ground; the ground in the electrical system may not be sufficient. Refer to your local code for the requirements for a "true earth ground" in your area.
- All wires used for grounding must be 18 AWG minimum.
- All electrical wiring must be done by a qualified electrician and comply with all local codes and regulations.
- For 24 Vdc wiring refer to Fig. 13.
- For 100-240 Vac wiring refer to Fig. 14.
- Incoming power wiring must be guarded from the enclosure. Use a protective grommet where the power wiring enters the enclosure to prevent wear.

NOTICE

If power and grounding connections are not done properly, the equipment will be damaged and the warranty voided.

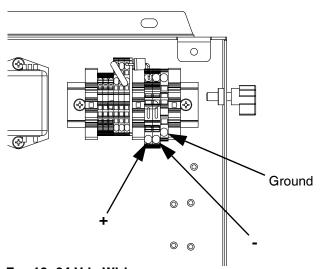


Fig. 13: 24 Vdc Wiring

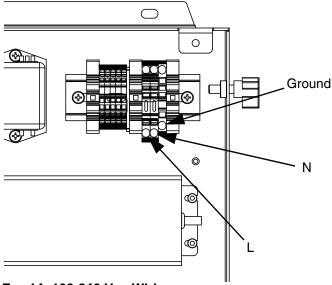


Fig. 14: 100-240 Vac Wiring

Connect Light Tower Accessory

NOTE: A light tower is not included on models that do not have an ADM. See **Models** on page **4**.

- 1. Order the 255468 Light Tower Accessory as a diagnostic indicator for the PCF system.
- 2. Connect the cable from the light tower to the digital I/O port (BS) on the ADM.

See Table 3 for a description of light tower signals.

Table 5: Light Tower Signals

Signal	Description
Green	No errors.
Yellow	An advisory exists.
Yellow flashing	A deviation exists.
Red solid	An alarm exists. One or more fluid plates may be shutdown.

NOTE: See **Errors**, page 70, for error definitions.

Install Fluid Plate Assemblies

To install the PCF fluid plate assemblies:

- Mount the fluid plate assemblies, page 27
- Ground fluid plate assemblies, page 31
- Connect one fluid plate assembly to the control center. See Install Cable Assemblies on page 32.
- If multiple fluid plates, connect the fluid plates together. See Install Cable Assemblies on page 32.
- Connect fluid lines, air lines, and cables; page 31

Mount



Before Mounting Assembly

- See component manuals for specific information on component requirements. Information presented here pertains to the PCF fluid plate assembly only.
- Have all system and subassembly documentation available during installation.
- Be sure all accessories are adequately sized and pressure-rated to meet the system's requirements.
- Use only the Graco PCF fluid plate assembly with the Graco PCF control center.

Mount Assembly

- 1. Select a location for the fluid plate assembly. Keep the following in mind:
 - Allow sufficient space for installing the equipment.
 - Make sure all fluid lines, cables and hoses easily reach the components to which they will be connected.
 - Make sure the fluid plate assembly allows the automation unit to move freely along all axis.
 - Make sure the fluid plate assembly provides easy access for servicing its components.

2. Mount and secure the fluid plate assembly to the automation unit (or other mounting surface) with appropriate size bolts through the 0.397 in. (10 mm) diameter holes in the base plate. See the mounting dimensions in Table 4 and Fig. 15.

Table 4: Fluid Plate Assembly Measurement

Α	16.5 in. (419 mm)
В	14.0 in. (356 mm)
С	14.4 in. (366 mm)
D	13.4 in. (340 mm)

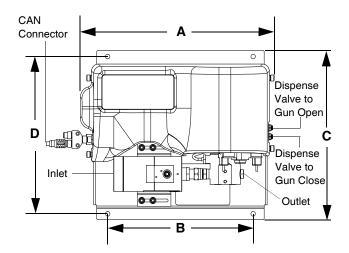


Fig. 15: Fluid Plate Assembly Dimensions

Mount Coriolis Flow Meter

NOTE: A Coriolis flow meter only comes with PFxCxx assemblies.

NOTICE

See Fluid Plate Assembly Technical Data on page 149 for the weight of your meter. The meter is heavy and must be properly supported to avoid stress on the fluid connections.



Fluid Flow Upward

Mounting so fluid flow is upward through the meter is preferred as this allows solids to settle out and air to rise away from metering tube. See Fig. 16.

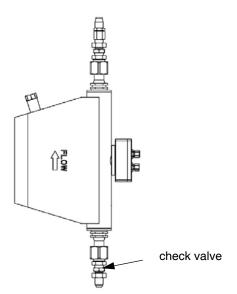
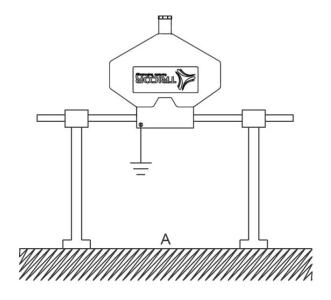


Fig. 16. Fluid Flow Upward

Horizontal Installation

The horizontal installation is the recommended installation

If the medium might contain solid particles, mount the meter as shown in position A, in all other cases as shown in position B.



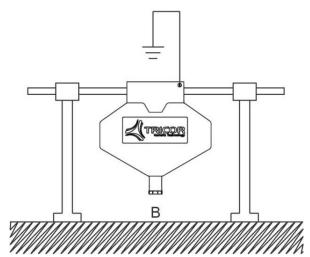


Fig. 17.

Critical Installations

The meters must be mounted at the highest point of the tubing (A), if gas bubbles are to be expected, or at the lowest point (B), if solid particles are to be expected, as in both cases also the right orientation might not help.

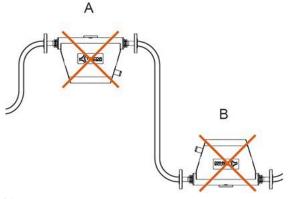


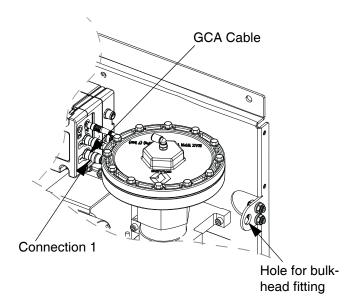
Fig. 18.

Mount Four-Valve Breakout Kit 24B693

PCF is capable of controlling up to four separate dispense valves from port 1 on the FCM. A four-valve breakout kit (24B693) is available to split the dispense solenoid connector (port 1 on the FCM) into four separate dispense solenoid connectors. For each additional dispense valve, order one dispense valve solenoid (258334) and one solenoid cable (121806).

Follow this procedure if using the four-valve breakout kit.

 Remove the existing dispense solenoid and cable from the fluid plate. 2. Install bulkhead fitting (included in the kit) into the empty hole on the fluid plate.



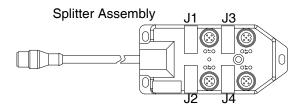


Fig. 19: Mount Breakout Kit

- Connect one end of the extension cables (included in the kit) to connection 1 on the FCM and the other end of the cable to the bulkhead fitting.
- Connect the splitter assembly to the bulkhead fitting.
- 5. Connect the dispense valve cable(s) to the connections on the splitter assembly.

Cable for:	Connects to Splitter Connection Labeled:
Dispense Valve 1	J1
Dispense Valve 2	J2
Dispense Valve 3	J3
Dispense Valve 4	J4

6. Mount splitter assembly and dispense valves, and connect air lines as necessary for application.

Custom Breakout Cable

If desired, the following connector pinout information may be used to build a custom breakout cable:

Pinout of FCM Port 1

Pin 1: Dispense Solenoid 4

Pin 2: Dispense Solenoid 2

Pin 3: Voltage - (common for all solenoids)

Pin 4: Dispense Solenoid 1 Pin 5: Dispense Solenoid 3

Dispense solenoid outputs are 24 Vdc. Dispense solenoid outputs are capable of sourcing up to 0.5A each (maximum 12W coil).

Install Command Cable Kit 24B694

Follow this procedure if using the command cable kit.

- Install bulkhead fitting (included in the kit) into the empty hole on the fluid plate. See Fig. 19 on page 29.
- 2. Connect one end of the extension cable (included in the kit) to connection 5 on the FCM and the other end of the cable to the bulkhead fitting.
- 3. Connect command cable to bulkhead fitting and wire to automation controller per the following pinout table.

		Function		
FCM Port Pin #	Command Cable Wire Color	Dispense Trigger Source: 'Command Cable' or 'Combined'	Dispense Trigger Source: 'Command Cable 3x'	
1	White	Command voltage (0-10 Vdc)	Command voltage (0-10 Vdc)	
2	Brown	No connection	Valve 3 dispense trigger (*sourc- ing input)	
3	Green	Dispense trigger (*sourcing input)	Valve 1 dispense trigger (*sourc- ing input)	
4	Yellow	No connection	Valve 2 dispense trigger (*sourc- ing input)	
5	Gray	Dispense trigger ground	Dispense trigger ground	
6	Pink	No connection	No connection	
7	Blue	Command signal ground	Command signal ground	
8	Red	No connection	No connection	

NOTE: Command cable inputs are not isolated from PCF 24 Vdc power.

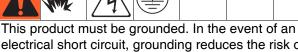
^{*} To turn on the dispense trigger, connect the dispense trigger pin to the dispense trigger ground pin (pin 5).

Ground









electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current.

- The control center must be electrically connected to a true earth ground; the ground in the electrical system may not be sufficient. Refer to your local code for the requirements for a "true earth ground" in your area.
- All wires used for grounding must be 18 AWG minimum.
- A qualified electrician must complete all grounding and wiring connections.
- For 24 Vdc wiring refer to Fig. 13.
- For 100-240 Vac wiring refer to Fig. 14.
- Incoming power wiring must be guarded from the enclosure. Use a protective grommet where the power wiring enters the enclosure to prevent wear.

NOTICE

If power and grounding connections are not done properly, the equipment will be damaged and the warranty voided.

Ground the fluid plate assembly as instructed here and in the individual component manuals. Make sure the fluid plate assembly and its components are installed correctly to ensure proper grounding.

Air and Fluid Hoses

For static dissipation, use only electrically conductive hoses or ground the applicator / dispense valves.

Dispense Valve

Follow the grounding instructions in the dispense valve manual.

Fluid Supply Container

Follow local code.

Solvent Pails Used When Flushing

Follow local code. Use only conductive metal pails, placed on a grounded surface. Do not place the pail on a non-conductive surface, such as paper or cardboard, which interrupts grounding continuity.

Connect Fluid and Air Lines

NOTICE

Route all fluid and air lines carefully. Avoid pinching and premature wear due to excessive flexing or rubbing. Hose life is directly related to how well they are supported.

Follow the instructions in your separate component manuals to connect air and fluid lines. The following are only general guidelines.

- The PCF fluid plate assembly should be installed on the automation unit or in another appropriate place, as close as practical to the dispense valve.
- Connect a fluid line between the fluid plate outlet and the dispense valve. Smaller diameter and shorter fluid lines (hoses) will provide better fluid system response.
- Connect a fluid line to the flow meter fluid inlet or to the regulator inlet if your system does not have a flow meter.
- Air must be clean and dry, between 60-120 psi (0.41-0.82 MPa, 4.14-8.27 bar). Flush air line before plumbing in air filter assembly (234967). Plumb in air filter assembly near air drop site (upstream of fluid plate module). Adding an air regulator to this line will provide more consistent dispense valve response times.
- Connect an air supply line to the 1/4 npt inlet port on the fluid plate(s) air supply inlet.
- Connect 5/32 in, or 4 mm OD air lines from the applicator's solenoid valve to the applicator. Plug any unused solenoid ports.

NOTE: To maximize system performance keep the dispense hose length and ID as small as the application will allow.

Install Cable Assemblies

NOTE: To prevent system errors, only connect cables with the power off.

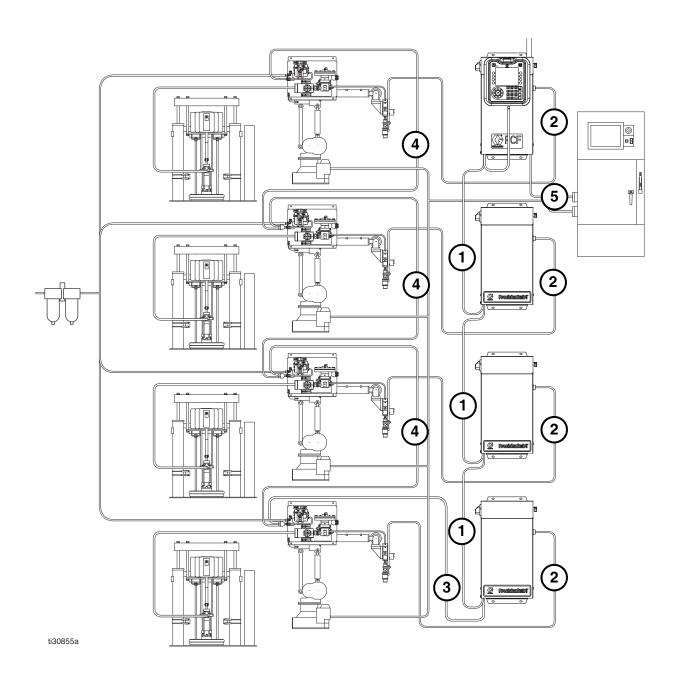
NOTE: See Fig. 20 on page 33.

- For systems with more than one swirl dispenser:
 Use a CAN cable to connect the control center to
 one swirl expansion enclosure. Use additional CAN
 cables to connect any remaining expansion swirl
 enclosures together in sequence.
- For systems with one or more swirl dispensers, use motor cable to connect each swirl dispenser to an expansion swirl enclosure or to the control center.
- Connect a CAN cable from the control center to one fluid plate assembly.
- For multiple fluid plate systems, use CAN cables to connect each fluid plate to one other fluid plate Repeat until all fluid plates are connected to one other fluid plate.

NOTE: Use the connections on the CAN splitter on the left side of each fluid plate to connect the fluid plates together. There will be a CAN splitter on all but one fluid plate.

NOTE: The control center, expansion swirl enclosures, and fluid plates may be connected in any order as long as each is connected to another system component with a CAN cable. See the example shown in Fig. 20 on page 33.

 Use the automation interface cable (not provided) to connect the Gateway module to the automation controller.



Multiple Fluid Plate and Multiple Swirl System shown

Fig. 20: Cable Installation Diagram

Install Gateway Module Interface

NOTE: Systems with swirl dispensers will have two gateway modules in the control center. The gateway module on the left is the swirl control DGM module, and does not need any setup or modification. The gateway module on the right is the automation Gateway module. This section covers the automation Gateway module.

Fieldbus Communications Gateway Module

Module Description

The Communications Gateway Module (CGM) provides a control link between the PCF system and a selected fieldbus. This provides the means for remote monitoring and control by external automation systems.

See Automation Control (Normal Operation), page 49, for details on controlling the PCF system through the Gateway module.

Data Exchange

Data is available by block transfer, cyclic transfer, change of state triggered, and explicit access to individual attributes as defined by the fieldbus specification. Refer to **Appendix C - Communications Gateway Module (CGM) Connection Details**, page 146, for details about PCF/fieldbus data map.

NOTE: The following system network configuration files are available at www.graco.com

- EDS file: DeviceNet or EtherNet/IP fieldbus networks
- GSD file: PROFIBUS fieldbus networksSDML: PROFINET fieldbus networks

CGM Status LED Signals

Signal	Description
Green on	System is powered up
Yellow	Internal communication in progress
Red Solid	CGM hardware failure
*Red	Data map load failure
(7 flashes)	Incorrect data map for fieldbus type
	No data map loaded

^{*}The red LED (CF) will flash a code, pause, then repeat.

Installation

NOTE: The following installation instructions assume the person implementing the PCF fieldbus connection fully comprehends the fieldbus being used. Ensure the installer understands the automation controller communication architecture and the fieldbus being used.

NOTE: An Integrated PCF (without ADM) has a CGM that must be configured through an ADM. A single ADM may be used to set up multiple machines.

- Install interface cables between the PCF system and the automation controller per the fieldbus standards. Refer to Appendix C -Communications Gateway Module (CGM) Connection Details, page 128, for details.
- Turn on system power. Navigate to the Gateway setup screens and ensure the data map name is: PCF 4FP. Refer to Appendix A - Advanced Display Module (ADM), page 104, for details about the data map.
- Set the PCF Gateway configuration values as required to interface with automation controller. Refer to Appendix A - Advanced Display Module (ADM), page 104, for details about the configuration settings.
- 4. Retrieve the appropriate fieldbus configuration file for the fieldbus being used from www.graco.com.
- Install the configuration file on the automation controller (fieldbus master). Configure it for communication with the PCF Gateway (fieldbus slave).
- 6. Establish communication between the automation controller and the PCF Gateway to confirm the successful configuration of the hardware and data.

NOTE: Use the ADM screens for troubleshooting field-bus data communication problems. Refer to Appendix A - Advanced Display Module (ADM), page 104, for details. Also, use the LED status indicators on the PCF Gateway module for fieldbus status information. Refer to Appendix C - Communications Gateway Module (CGM) Connection Details, page 128, for details.

Discrete Gateway Module

Module Description

The Discrete Gateway Module (DGM) provides a control link between the PCF system and an automation controller through discrete input and output connections. This provides the means for remote monitoring and control by external automation systems.

See **Automation Control (Normal Operation)**, page 49, for details on controlling the PCF system through the Gateway module.

Connect D-Sub Cable

The DGM provides all I/O through the D-Sub cable. Graco offers two options for connecting a D-Sub cable to the D-Sub connector (CG). Both options are accessories and must be ordered separately.

- For single fluid plate systems only: D-Sub to flying leads cable (123793). See Appendix B -Discrete Gateway Module (DGM) Connection Details, page 121, for details and cable interface signals.
- For multiple fluid plate systems: D-Sub cable (123972) and 78-pin breakout board (123783).
 See Appendix B - Discrete Gateway Module (DGM) Connection Details, page 121, for details and pin assignments.

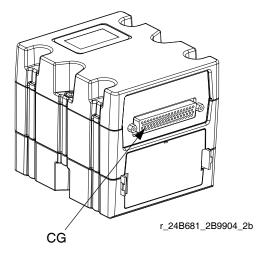


Fig. 21: Connect D-Sub Cable

DGM Status LED Signals

See **LED Diagnostic Information**, page 69, for signal definitions.

DGM Rotary Switch Position

The Discrete Gateway Module (DGM) rotary switch must be in position 0 for Automation Gateway DGMs and positions 1-4 for Swirl Control DGMs in order for the DGM to operate. See **Automation Gateway Module** on page 21 and **Swirl Control DGM** on page 22.

System Setup

Overview

The PCF system compensates for temperature, flow, or pressure fluctuations. However, if there is a hardware change on the supply system or the dispense material is changed, the PCF system must be set up again.

After material is loaded into the supply system, set up the PCF system using the Setup screens. The following procedure outlines the major system setup steps. The following subsections provide instructions to complete each setup step. Once these steps are complete the module is ready for operation.

NOTE: See the Advanced Display Module (ADM) section, page 20, and Appendix A - Advanced Display Module (ADM), page 104, for detailed operating instructions for the display keypad and each screen.

NOTE: If configuring an Integrated PCF (without ADM), at least one ADM must be purchased to allow for setup and troubleshooting.

- 1. Configure System, page 36.
- 2. Configure Control Settings, page 37.
- 3. Configure Mode Settings, page 38.
- 4. Configure Delay Settings, page 38.
- 5. Configure Flow Meter Settings, page 39.
- 6. Configure Pressure Loop Settings, page 39.
- 7. Adjust Pressure Sensors, page 40.
- 8. Configure Errors, page 40.
- 9. Setup Maintenance Schedule/Parameters, page 41.
- 10. For systems with swirl dispensers only:
 - a. Configure Swirl to valve association and error type, page 41.
 - b. Configure Swirl settings, page 42.
- 11. Configure Gateway Settings, page 42.
- 12. Setup Styles, page 42.
- 13. Configure Advanced Settings, page 42.

Configure System

Define the number of installed fluid plates (called "Dispenser" on this screen) and number of installed swirl dispensers. If a fluid plate is listed as "Uninstalled" the screens for that fluid plate will not appear in the run or setup screens.

- 1. With the system in setup mode, navigate to the System screen.
- 2. Press to access the fields to make changes.
- 3. Use the arrow keys to navigate to the desired field.
- 4. Press to open the drop-down list, and select the desired setting. Press to accept the selection.
- Repeat for the other Dispensers and Swirl Dispensers.
- 6. Press to exit edit mode.

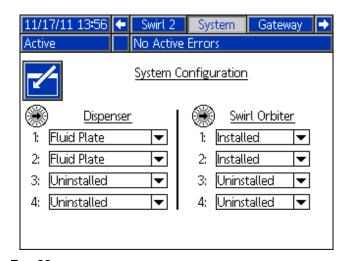


FIG. 22

Configure Control Settings

Set the controls for the dispense source, how dispense commands are sent, and job settings.

- With the system in setup mode, navigate to Fluid Plate x, screen 1 (Control Settings).
- 2. Press to access the fields to make changes.

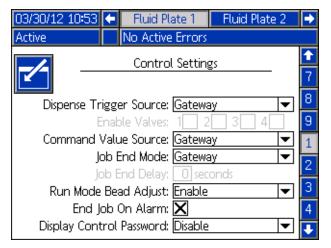


FIG. 23

- 3. Press to open the Dispense Trigger Source drop-down list, and select Gateway, Command Cable, Command Cable 3x, or Combined. If Command Cable is selected, users can enable the valves. Press to finalize the selection.
- If the dispense trigger source is set to Command
 Cable, press to move to the Enable Valves field.
 Press and to enable valves.
- 5. Press to move to the Command Value Source field. Press to open the drop-down list, and select Gateway, Command Cable, or Display. Press to enter the value.
- 6. Press to move to the Job End Mode field. Press to open the drop-down list, and select Timer or Gateway. Press to enter the value.

- 7. Press to move to the Job End Delay field. Enter the desired delay time (in seconds). Press to enter the value.
- 8. Press to move to the Run Mode Bead Adjust field. Press to open the drop-down list, and select Enable or Disable. Press to enter the value.
- 9. Press to move to the End Job on Alarm Check Box. Press to enable or disable.
- 10. Press to move to the Display Control Password field. Press to enter the value.
- 11. Press to exit edit mode.
- 12. *If multiple fluid plates are installed,* repeat this procedure for the other Fluid Plates.

Configure Mode Settings

Set valve commands, including the dispense mode (pressure, bead, shot, or full open) and flow rate or pressure for each valve. The bead scale is also adjustable from this screen.

NOTE: For a description of each dispense mode, see **Dispense Control Modes**, page 118.

- 1. With the system in setup mode, navigate to the Fluid Plate x, screen 2 (Mode Settings).
- Press to access the fields to make changes.

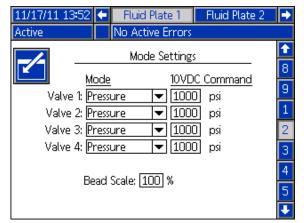


Fig. 24

- 3. Press and to set the mode for each valve that will be used to Pressure, Bead, Shot, or Full Open. Press to enter each selection.
- 4. Use the four arrow buttons to navigate to each Fixed Command field. Enter the desired value for each valve that will be used. Press to enter each value.

NOTE: The ability to dispense from multiple valves simultaneously is only allowed in either of the following scenarios.

- Each valve is set to Pressure mode and has identical Fixed Command values.
- Each valve is set to Full Open mode.

Attempting to dispense from multiple valves simultaneously using any other combination will cause an Incompatible Valves Settings alarm.

- 5. Press to move to the Bead Scale field. Enter a scale value between 50% and 150%. Press to enter the value.
- 6. Press to exit edit mode.

Configure Delay Settings

Set on and off delays (in milliseconds) for each valve and the regulator. For an explanation of the on and off delays, refer to the **On/Off Delays** section on page 43.

- 1. With the system in setup mode, navigate to the Fluid Plate x, screen 3 (Delay Settings).
- 2. Press to access the fields to make changes.

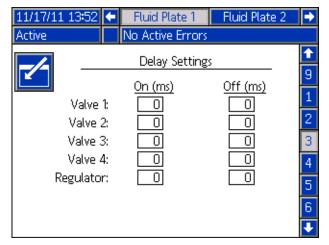


Fig. 25

- Use the four arrow buttons to navigate to each On and Off field. Enter a desired delay value (in milliseconds) for each valve that will be used and the regulator. Press to enter each value.
- 4. Press to exit edit mode.

Configure Flow Meter Settings

The accuracy of the PCF volume reporting depends on precise adjustment of the K-factor(s). The fluid plate uses the K-factor(s) to calculate the volume dispensed. If the set value is not correct, the system still delivers repeatable flow rates; however, the reported value may not be correct. See **Verify Flow Meter Calibration**, page 46, for additional K-factor information.

Table 5: Flow Meter K-Factors

Part	Description	K-Factor
246652	High Resolution Helical Gear Meter	7000
246340	Heated Helical Gear Meter	3500
16E993	Ultra High Flow Meter	33000
25D026	Coriolis Flow Meter	1176

Set Flow Meter K-Factor

NOTE: In systems without a flow meter, the flow meter settings will be grayed out.

- 1. With the system in setup mode, navigate to the Fluid Plate x, screen 4 (Pressure Loop and Flowmeter Settings).
- 2. Press to access the fields to make changes.

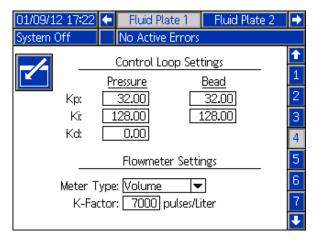


FIG. 26

- 3. Press to open the Meter Type drop-down list, and select the meter type used by the system. Select Volume for volumetric flow meters or Mass for mass flow meters. Press to enter the selection.
- 4. Press to move to the K-Factor field. Key in the K-factor value. See **Table 5: Flow Meter K-Factors** for values. Press to enter the value.
- 5. Press to exit edit mode.

NOTE: If necessary, verify flow meter calibration. See **Verify Flow Meter Calibration**, page 46, for instructions.

Configure Pressure Loop Settings

The PCF system uses variables (Kp, Ki, and Kd) in the software calculations to accurately and precisely control the fluid pressure.

NOTE: It is recommended that these values are not changed from the factory defaults of 32.00 for Kp, 128.00 for Ki, and 0.00 for Kd. However, if the values need to be adjusted, see **Manually Adjust Control Loop Parameters** on page 47.

Adjust Pressure Sensors

Set pressure offsets and pressure limits.

NOTE: Inlet sensor settings will be grayed out on this screen for systems with heated fluid plates.

- 1. With the system in setup mode, navigate to the Fluid Plate x, screen 5 (Pressure Sensors).
- 2. Press to access the fields to make changes.

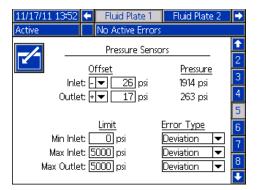


Fig. 27

NOTE: For the following steps, press



to navigate through each field, and to open drop-down menus and enter changes or selections.

3. Set the desired offset for the inlet and outlet pressures between 0 and 100 psi (0.7 MPa, 7.0 bar). Remove all pressure on the sensors, and then adjust the offset so the measured value reads 0.

NOTE: It is recommended that offsets should not be changed from the factory defaults of 0.

- Set the desired minimum and maximum pressure limits for the inlet, and the desired maximum pressure limit for the outlet.
- 5. Set the error type (alarm or deviation) that will be issued:
 - If the minimum inlet pressure decreases below the setting.
 - If the maximum inlet pressure increases above the setting.
 - If the maximum outlet pressure increases above the setting.
- Press to exit edit mode.

Configure Errors

Set the error type (alarm, deviation, or none) that will be issued if the pressure, flow rate, volume, or computed target goes outside the tolerance settings of the active style. When an alarm occurs, the system stops dispensing. When a deviation occurs, the system will continue dispensing. See Fluid Plate x, Screen 6 (Error Type) on page 113 for more information.

NOTE: Only the low/high pressure errors will be enabled for systems without a flow meter.

- 1. With the system in setup mode, navigate to Fluid Plate x, screen 6 (Error Type).
- 2. Press to access the fields to make changes.

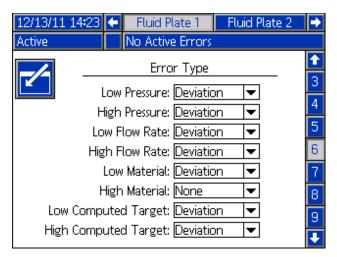


Fig. 28

- 3. Press to open the Low Pressure drop-down list, and select either Alarm or Deviation for the error type. Press to enter the selection.
- 4. Press to move to the next field. Repeat Step 4 for each field.
- 5. Press to exit edit mode.

Setup Maintenance Schedule/Parameters

Set the volume (or hours) limit that will trigger a maintenance advisory for the fluid supply, Voltage to Pressure (V/P) Transducer, fluid regulator, flow meter, and all four valves.

NOTE: Hours is shown instead of Volume for fluid plates without a flow meter.

The Volume (or Hours) column displays the current totalizer value. If this value exceeds the set limit, the value will turn red and a maintenance advisory is issued. See Fluid Plate x, Screen 7 (Maintenance Advisory Limits), page 113, for more information about maintenance totalizers.

To set limits:

- 1. With the system in setup mode, navigate to the Fluid Plate x, screen 7 (Maintenance Advisory Limits).
- 2. Press to access the fields to make changes.

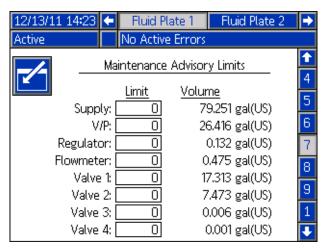


Fig. 29

- 3. Enter the desired limit for the air supply and press to enter the selection.
- 4. Press to move to the next field. Repeat Step 4 for each field.
- 5. Press to exit edit mode.

To reset a totalizer value:

- 1. Follow Steps 1-3 of **To set limits:** to make changes in Fluid Plate x, screen 7 (Maintenance Advisory Limits).
- 2. Press to scroll to the system component to reset.
- 3. Press to reset the value.

Configure Valve to Swirl Association and Motor Error Type

Define which Swirl number is installed on which dispense valve.

Set the error type (alarm or deviation) that will be issued if a motor fault occurs. When an alarm occurs, the fluid plate stops dispensing. When a deviation occurs, the fluid plate will continue dispensing.

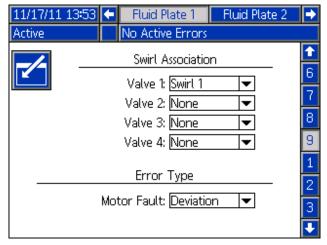


FIG. 30

Configure Swirl Settings

NOTE: This applies only to systems with swirl dispensers.

Set the individual Swirl settings for each installed Swirl.

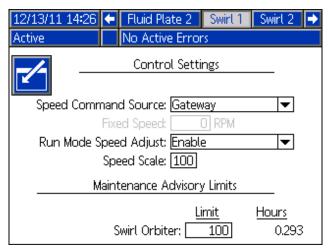


Fig. 31

Configure Gateway Settings

Gateway settings differ for each system. See **Automation Gateway Setup Screens**, page 107, for guidelines on configuring each type of Gateway interface.

Setup Styles

The PCF system can store up to 256 styles. See **Styles**, page 50, for more information about styles and instructions on setting up styles. Style 0 is always the purge style.

Configure Advanced Settings

Use the advanced settings to set or change the format and display units, such as the language, date format, and pressure units, for all PCF screens. See **Setup Mode**, page 106, for advanced setting guidelines.

On/Off Delays

The PCF fluid regulator can physically respond faster than the dispense device and its solenoid. As a result, the fluid regulator can supply material to the dispense device before the device has time to open. Supplying material to a closed device can create trapped-pressure.

At the end of a cycle, the dispense device can shut off before the pressure has dissipated. This can cause a dispense of an excess of material at the beginning of the next cycle.

To eliminate these two problems, change the delay time associated with the opening of the fluid regulator/dispense and/or the closing of the dispense device, see **Table 5: On/Off Delay Variables**. For instructions setting on/off delays, see **Configure Delay Settings**, page 38.

NOTE: On/Off delay can be set for each dispense device.

In general, delays should be adjusted so the outlet pressure during "no flow" is slightly below the outlet pressure during dispense.

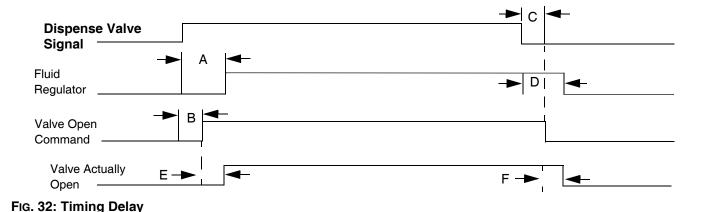
Table 5: On/Off Delay Variables

Variable:	Sets the Amount of Time:
Valve ON	Sets time from Dispense Valve High to Valve Open command
Regulator ON	Sets time from Dispense Valve High to Regulator ON
Valve OFF	Sets time from Dispense Valve Low to Valve Close command
Regulator OFF	Sets time from Dispense Valve Low to Regulator OFF

Fig. 32 and **Table 6: Delay On/Off Timing** show delay ON and OFF timing.

Table 6: Delay On/Off Timing

Iak	ile 6: Delay On/Off I	i iiiiiig
Α	Regulator ON	The user sets the fluid
	delay	regulator ON delay timing.
В	Valve ON delay	Usually set to zero. Can be
		used to change the starting
		point of a bead.
С	Valve OFF Delay	Usually set to zero. Higher
		values will lower the trapped
		pressure.
D	Regulator OFF	The user sets the regulator
	delay	OFF delay timing. Zero or
		small values will lower the
		trapped pressure.
Ε	Valve Open	Time delay for valve to
	Reaction Time	physically open. Delay
		varies based on pneumatic
		hose length and valve air
		volume.
F	Valve Close	Time delay for valve to
	Reaction Time	physically close. Delay
		varies based on pneumatic
		hose length and valve air
		volume.



Operation

Pressure control may degrade at low output pressures. It is not recommended to dispense at outlet pressures less than 500 psi (3.4 MPa, 34 bar).

Startup

Initial Startup

- Ensure the PCF control center is installed and all of the proper connections to and from the control center have been made. Ensure fittings are tight.
- Read and understand the Operation (page 44) and Advanced Display Module (ADM) (page 20) sections of this manual.
- 3. Continue startup with step 2 in Standard Startup.

Standard Startup

- Carefully inspect the entire system for signs of leakage or wear. Replace or repair any worn or leaking components before operating the system.
- 2. Press the Stop button (BC). See Fig. 8 on page 20.
- Turn on air.
- Turn on electrical power to the system.
- 5. Turn on the main power to supply power to the PCF.
- Check Interface Signals: If this is a new installation, power on each system input and verify that each input is being received.
- 7. Turn on the material supply system.

Load Material

Before using the system material must be loaded into the supply system.

- 1. If this is a new installation, follow the **Initial Startup** procedure. Otherwise, follow the **Standard Startup** procedure. See page 44.
- Turn on the fluid supply pressure to the fluid plate assembly.
- 3. Place the valve(s) over a waste container.
- 4. Enter the maintenance screen. See **Dispense From Maintenance Screen**, page 47.
- 5. Select a control mode. See **Dispense From Maintenance Screen**, page 47.
- 6. If the system status indicator LED (BB) is orange, press to turn the system on.
- 7. Press and hold . Dispense fluid until clean, air-free fluid flows from the valve.
- 8. Press to exit maintenance screen.

Maintenance Mode Operation

Fluid Plate

Maintenance Screen

11/17/11 13:49	Home	Fluid Plate	Fluid Plate 2	Maintenance Screen
11/17/11 13:49	Home	Fluid Plate 1	Fluid Plate 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2	Swirt 1	Swirt 2	Maintenance Screen
11/17/11 13:50	Fluid Plate 2			

Operating from maintenance mode enables manual dispensing () and manually starting the swirl dispenser ().

The system begins dispensing when the user presses

Dispense parameters and duration depend on the selected control. Dispensing continues for as long as is pressed.

The system starts the swirl dispenser when the user presses . The swirl dispenser continues to run until



There is one maintenance screen for each installed fluid plate and each installed Swirl. The maintenance controls for the Swirl are shown on both the Swirl maintenance screen and on the Fluid Plate maintenance screen for the fluid plate where the swirl dispenser is installed.

Verify System Operation

Use maintenance mode to manually check the operation of the PCF system components before switching over to automation control (normal operation). See **Dispense From Maintenance Screen**, page 47, for instructions on operating from maintenance mode.

NOTE: Perform the following procedures while in maintenance mode.

Set Inlet Pressure

The inlet pressure reading should be in the range of 300 psi (2.1 MPa, 21 bar) to 500 psi (3.4 MPa, 34 bar) above the outlet pressure reading under your highest flow condition.

Follow steps in the supply system manual to set the inlet pressure.

NOTICE

Inlet pressure beyond the recommended range above will cause accelerated wear on the regulating valve and the pump feed system.

Feed System Pressure Drop

During material flow, the regulator inlet pressure decreases. The amount the pressure decreases is the amount of pressure lost between the feed pump and the regulator inlet.

With high viscosity fluids, long line lengths, or small diameter line sizes this pressure decrease can be thousands of psi (hundreds of bar). This means that the static pump pressure is set much higher than the regulator needs at its inlet. To prevent excessive control regulator wear or surging, a mastic fluid pressure regulator is recommended on the feed line close to the control regulator. The mastic regulator will suppress the static feed pressure at the control regulator inlet.

Dispense from Each Valve

Dispense from each valve that will be used in normal operation to confirm that the entire system is installed correctly and is capable of delivering desired results.

Follow the steps outlined in **Dispense From Maintenance Screen**, page 47, to perform each of the following applicable system verification checks.

NOTE: Each fluid plate controls only the dispense valves connected to it.

- For each valve that will be used during normal operation, dispense at each pressure or flow rate that will be used during normal operation. This verification check confirms that the system is capable of delivering material at your maximum desired operating point.
- For systems that will operate multiple valves in pressure mode at the same time, dispense from each valve at the same time. This verification check confirms that the system is capable of delivering material at your maximum desired operating point.
- For each valve operating in bead mode, perform an initial teaching process. Follow this procedure after significant system and/or material characteristic changes.
 - a. For each flow rate that will be used during normal operation, press until PCF achieves the flow rate setpoint.

NOTE: During the initial system operation verification, it may take four to five seconds for the system to learn system characteristics.

- b. Continue to press for several seconds after the desire flow rate is reached to confirm that the system is capable of maintaining the desired flow rate.
- Repeat Steps a and b for a range of flow rates to confirm that the system responds quickly to achieve setpoint when is pressed.

Verify Flow Meter Calibration

Most sealant and adhesive materials are compressible. Since the flow meter measures the material under high pressure, the actual volume of material dispensed may vary slightly from the measured volume, due to this compressibility. If the K-factor is not correct, the displayed volume will not be accurate.

Follow either of the following methods to calibrate the flow meter during initial setup and on a routine basis to check for flow meter wear.

Method 1. Using a gram scale

- 1. Record the flow meter k-factor shown on Fluid Plate x, screen 4 (Flowmeter Settings). See Fig. 26 on page 39.
- 2. Use a 500 cc or larger beaker. Measure the mass of the empty beaker.
- Manually dispense material into the beaker. Hold the beaker so that the stream of material is submerged in the captured material to minimize air entrapment in the container.
- 4. Record the volume dispensed on Fluid Plate x, screen 1. See Fig. 33 on page 47.
- 5. Calculate the actual volume dispensed:

$$\frac{\text{fluid mass (g)}}{\text{density (g/cc)}} = \text{measure volume (cc)}$$

6. Calculate the new flow meter K-factor:

- 7. Enter new K-factor.
- 8. Repeat the procedure to verify the new K-factor.

Method 2. Without using a gram scale, visual measurement

- Record the flow meter k-factor shown on Fluid Plate x, screen 4 (Flowmeter Settings). See Fig. 26 on page 39.
- 2. Use a 500 cc or larger beaker.

- Manually dispense material into the beaker. Hold the beaker so that the stream of material is submerged in the captured material to minimize air entrapment in the container.
- 4. Record the volume dispensed on Fluid Plate x, screen 1. See Fig. 33 on page 47.
- 5. Settle the material into the beaker and view the actual volume dispensed.
- 6. Calculate the new flow meter K-factor:

- 7. Enter new K-factor.
- 8. Repeat the procedure to verify the new K-factor.

Manually Adjust Control Loop Parameters

NOTE: It is recommended that these values not be changed from the factory defaults of 32.00 for Kp, 128.00 for Ki, and 0.00 for Kd.

If the system is not maintaining the desired setpoint while in pressure or bead control mode, manually change the Kp and Ki values:

NOTE: Pressure parameters should be adjusted first, even if you typically operate in bead control mode.

1. Begin dispensing material.

NOTE: Begin a new dispense each time control parameters are changed.

- If the regulator outlet pressure does not closely follow the desired pressure, set Ki to zero then increase Kp until the proper pressure control is achieved.
- 3. If the regulator outlet pressure oscillates rapidly above and below the commanded pressure, decrease Kp by 10%. Continue to decrease the Kp value in 10% increments until the outlet pressure is stable.
- 4. Set Ki value to 2 then increase the Ki value until the system oscillates.
- 5. Decrease Ki until oscillation stops.

6. *Optional:* To fine tune the step response in pressure mode, gradually increase the Kd value.

NOTE: Increasing Kd (pressure only) is typically not necessary but it may improve step response. However setting Kd too high may cause the system to oscillate.

7. Stop dispensing.

Dispense From Maintenance Screen

 Navigate to Fluid Plate x, screen 1 for the desired fluid plate.

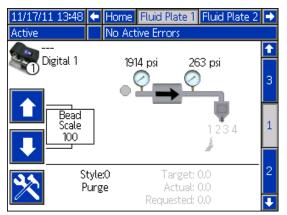


Fig. 33

2. Press to enter maintenance screen.

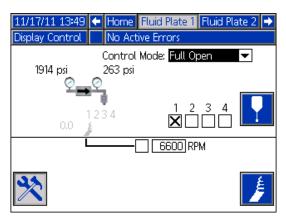


Fig. 34

3. Press to open the Control Mode drop-down list, and select the preferred control mode. Press again to exit the drop-down list.

- 4. Press to move to the target fields. Enter the target pressure, flow rate, or volume (dependent on control mode) and press to save.
- 5. Press to move to the valve check boxes. Press to select the desired valves.
- Follow step 2 4 of Manually Dispense Fluid, page 48

Manually Dispense Fluid

- 1. From Fluid Plate x, screen 1, press to enter maintenance screen.
- 2. Press and verify that the valve opens.
- 3. Continue to press as long as needed to load or dispense material.
- 4. Press again to exit maintenance screen.

Operate Swirl Dispenser From Maintenance Screen

 Navigate to the Swirl x screen for the desired Swirl Dispenser. If the Swirl Dispenser is installed on Fluid Plate x, you may also navigate to Fluid Plate x, screen 1.

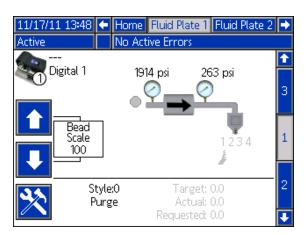


FIG. 35

2. Press to enter maintenance screen.

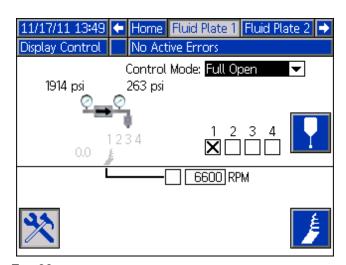


Fig. 36

- To change the RPM, use the arrow keys to navigate to the RPM box then enter the desired RPM.
- 4. Press and verify that the Swirl Dispenser begins rotating. Press again to stop the Swirl Dispenser.
- 5. Press again to exit maintenance screen.

Automation Control (Normal Operation)

During automation control (normal operation), the system can dispense or change dispense parameters when it receives a command from the automation unit.

The automation control operates using the concept of jobs and styles. For a detailed explanation of jobs and how they work within the PCF system, see **Jobs** on page 49. For a detailed explanation of styles and how they work within the PCF system, see **Styles** on page 50.

Jobs

NOTE: See **Appendix D - I/O Signal Descriptions**, page 146, for automation input and output signal descriptions.

A job is an automation sequence in which material can be dispensed. The amount of material specified for a job varies by application. In some applications, a job may be the amount of material dispensed on a part. Other applications may define a job to be the amount of material dispensed on a number of parts or dispensed over a period of time.

A job is initiated when the automation sends a Style Strobe signal to the PCF. Once the job is initiated, the PCF will start tracking the amount of volume requested by the automation and the amount of material that is actually dispensed. These volumes will be tracked until the job is completed. At the end of the job, error calculations are made and the volumes are stored on the PCF system (Job Log).

The PCF system monitors two things to determine when a job is complete. Either the Dispense Complete signal is sent by the automation or the job complete timer expires. The type of job end signal is configured to Timer or Gateway in Fluid Plate x, screen 1 (Control Settings). If the timer method is used, the timer begins counting every time the dispense valve is turned off. If the valve stays off for more than the preset timer value, the job is considered complete.

Once the job is complete, the job information is stored to memory. The most recent jobs can be viewed on the Job screen. The information stored with each job is as follows. See **Job Report Screens**, page 120, for instructions on how to view job reports.

Actual (Measured) Volume - The amount of material measured by the flow meter during a job.

Requested Volume - The amount of material that the automation tries to dispense during a job. In Bead mode, the requested volume is calculated as the requested flow rate multiplied by the duration of the dispense. In all other modes, the requested volume is same as the target volume.

Target Volume - The amount of material a job should have. This is defined in the Style.

Jobs in Bead Mode

In Bead Mode, all of the previously mentioned volumes are monitored. The High Volume, Low Volume, and Computed Target errors are evaluated at the end of the job. The volume alarms compare the measured volume to the requested volume and the computed target alarm compares the requested volume to the target volume.

Jobs in Pressure Mode

In Pressure Mode, the requested volume is not measured. In this mode, the automation command voltage corresponds to a pressure instead of flow rate. For this reason the requested volume is not available (as well as the Computed Target error). The high and low volume alarms compare the measured volume to the target volume for pressure mode.

Jobs in Shot Mode

In Shot Mode, the job is started the same as a normal job, but when the gun is triggered it dispenses until the target volume is reached. After the shot is done, the Dispense in Process bit goes low and you can check the Volume OK bit to see if the shot was within tolerance. If the Job End Mode is set to Timer, the shot times out after the specified amount of time and sends an advisory, even if target volume is not reached.

Continuously Running Applications

In some cases the target volume for a job is not known. An example of a case where the target volume is unknown is a continuously running system. This would be a system that does not run jobs, but runs continuously over a day or a shift. In this case, the flow rate becomes more important than the amount of volume dispensed in a job. The way to handle this situation is to set the target volume to a value of zero. This effectively disables the Computed Target error. The controls will still maintain the desired flow rate and report errors corresponding to the tolerance set for the running style.

Styles

The PCF system has the ability to handle up to 256 styles, depending on the selected option.

NOTE: The number of available styles depends on the fluid plate configuration. See **Models** on page 4. Style 0 is specified for purging only.

For each style, an independent target volume and tolerance can be configured. This allows for job-related errors and logs to be evaluated for each style. The style is read at the beginning of a job and cannot be changed until the next job.

PCF reads in the styles via the Gateway interface. For detailed interface information, see **Appendix B - Discrete Gateway Module (DGM) Connection Details** on page 121, and **Appendix C - Communications Gateway Module (CGM) Connection Details** on page 128, as applicable.

To setup a style:

- 1. Navigate to Fluid Plate x, screen 8.
- 2. Press to access the style setup fields.

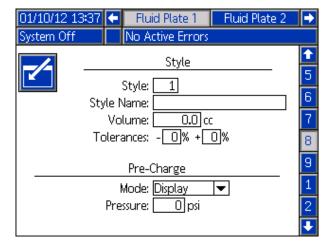


Fig. 37

- 3. Enter the style number in the Style field.
- 4. Enter Style Name:
 - a. Press while in the Style Name field to display the Keyboard screen.

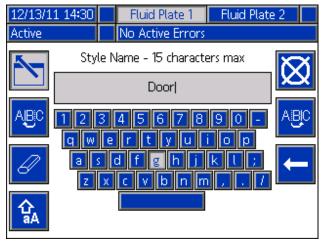


Fig. 38

- b. Use the arrow buttons on the ADM to scroll through each letter. Press to enter a letter in the style name field. See **Keyboard Screen**, page 114, for further details.
- c. Press to accept the new value.
- Enter the target volume in the Volume field, and the tolerance percentages in the Low and High Tolerance fields.
- Enter precharge mode and parameters. See Precharge Modes beginning on page 51.
- 7. Press to exit edit mode.

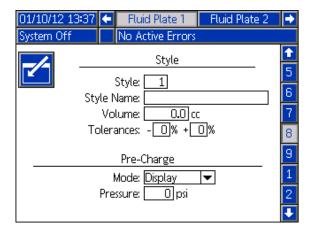
Precharge Modes

NOTE: See the diagram on the following page.

Static Precharge Mode

Display

When Display precharge mode is selected, a static precharge pressure can be defined. When a job is active and all dispense valves are closed, the regulator will maintain the defined precharge pressure.



Dynamic Precharge Modes

Dynamic precharge control allows the system to better prepare for the upcoming dispense. The pressure/flow command is used to actively set the outlet pressure to the ideal pressure while all dispense valves are closed and provide a boost while the valve is opening to help accelerate material.

The "Closed" scaling will be applied when all dispense valves are closed and the "Opening" scaling will be applied immediately after a dispense valve starts to open and continue for the user-specified duration (in milliseconds). The precharge scaling values modify the control signals that are necessary to obtain the desired pressure/flow. The precharge pressure can be changed dynamically throughout the job by varying the pressure/flow command value.

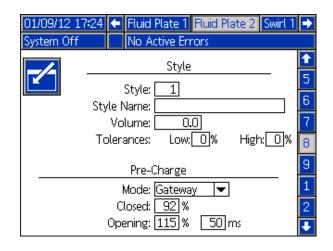
Valve 1

When the "Valve 1" precharge mode is selected, the outlet pressure will be set according to the current pressure/flow command using Valve 1 scaling values.

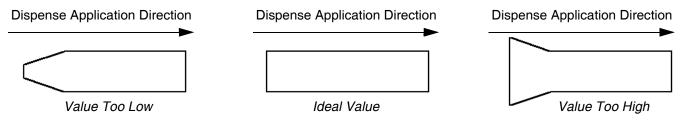
Gateway

NOTE: Gateway precharge mode is only available for systems containing CGMs.

When "Gateway" precharge mode is selected, the outlet pressure will be set according to the current pressure/flow command using the scaling set for dispense valve(s) selected through the gateway interface.

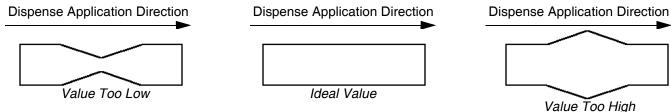


Closed Precharge Scaling Value



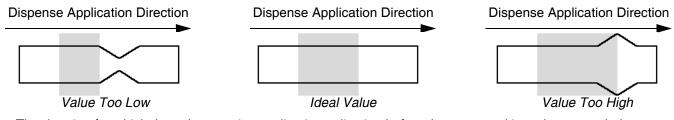
- -Controls outlet pressure based on desired command while valves are closed.
- -Ideal value is typically less than 100% due to the minimal pressure losses within the system when fluid is not flowing.

Opening Precharge Scaling Value



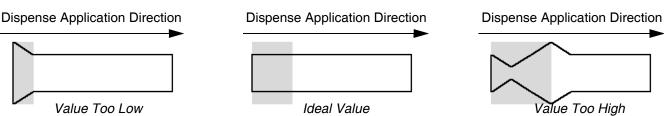
- -Provides a boost upon valve opening to accelerate material.
- -Ideal value is typically greater than 100%.

Opening Precharge Duration Value



-The duration for which the valve opening scaling is application before the command is no longer scaled.

Regulator On Delay Value



- -Controls timing of transition from valve "closed" precharge to valve "opening" precharge and regular dispense.
- -This delay should approximate the time it takes a dispense to open.

Typical Job Cycle

In order for the system to run it must be in the active

state (status LED next to on the ADM is green). Before a job begins the automation controller outputs should have the following values:

Style Strobe: 0

Dispense Complete: 0

Dispense Valve x On: all should be 0

Style: Any value is acceptable

A typical job cycle consists of the following dispensing sequence. See **Typical Job Cycle Chart**, page 54.

NOTE: Each job cycle can apply to only one fluid plate.

- 1. The automation controller checks that Dispenser (Fluid Plate) Ready signal is set to 1. If it is set to 1, a job can begin.
- 2. The automation controller sets the Style to the next desired style value.

NOTE: Each fluid plate has a unique set of styles. For example, Style 2 for Fluid Plate 1 is different from Style 2 for Fluid Plate 2.

- 3. The automation controller sets the Style Strobe to 1.
- 4. PCF reads the Style bits to select the new style. The system then starts a new job and sets Dispense In Process to 1.
- The automation controller begins dispensing. The automation controller sets and clears Dispense Valve x On bits as desired throughout the course of the job.
- 6. When the dispense is complete the automation controller sets Dispense Complete to 1.

- 7. PCF sets the following signals based on the results of the job.
 - Dispenser (Fluid Plate) No Alarm
 - Dispenser (Fluid Plate) No Error
 - Dispense Volume OK
 - Error
 - Dispensed Volume

NOTE: The automation controller should not read the Dispense Volume OK or Dispense Volume signals until after the system clears the Dispense In Process signal.

- PCF sets Dispense In Process to 0 to indicate the job is complete. At this time the signals from step 7 should be read.
- 9. The automation controller must clear Dispense Complete and Style Strobe (either can be cleared first) before the next job can start.

Jobs with Command Cable Dispense Trigger

With the Dispense Trigger Source configured to Command Cable or Command Cable 3x, users only need to trigger the dispense applicator to start a job. This configuration is useful for less demanding applications that do not require a full automation interface.

The following limitations apply when starting a job with this configuration:

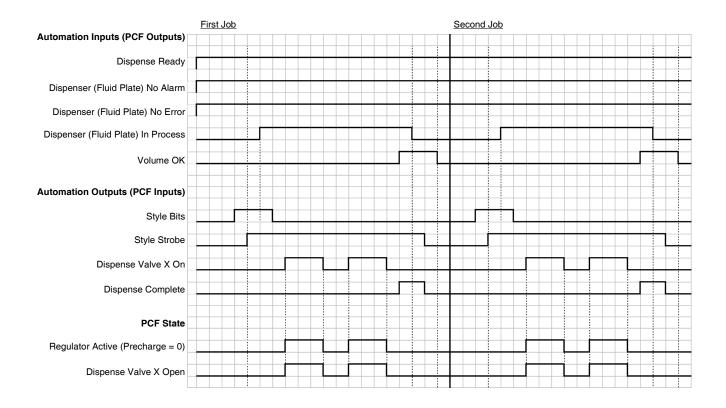
- The selected style defaults to Style 1.
- There can be up to a 100 ms delay before dispensing while PCF prepares for the new job cycle.
- The job end mode timer must be used to end a job.

Typical Job Cycle Chart

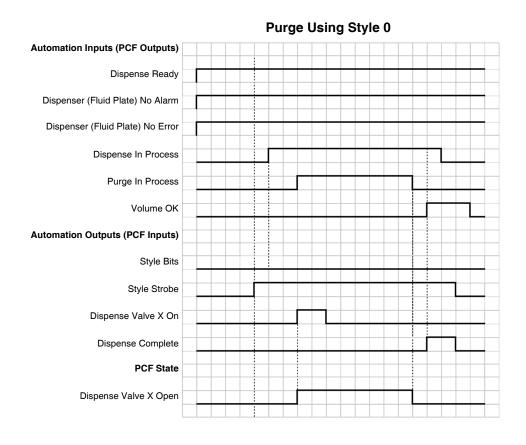
NOTE: Swirl can be turned on at any point inside of or outside of a job. Allow time for the swirl to reach desired RPM. If possible, verify Swirl speed through the automation interface prior to opening the dispense valve.

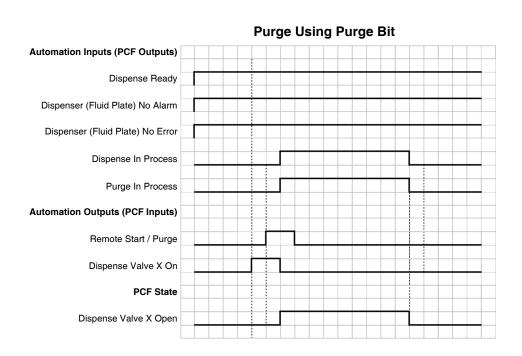
NOTE: A 50ms delay is suggested between each signal.

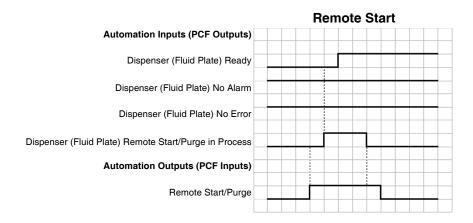
NOTE: Dispense Complete must be strobed, not held high in order to avoid an advisory.

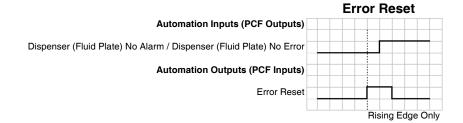


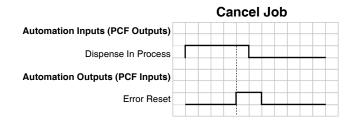
Control Charts

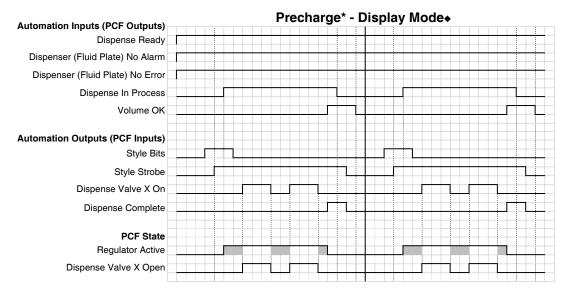








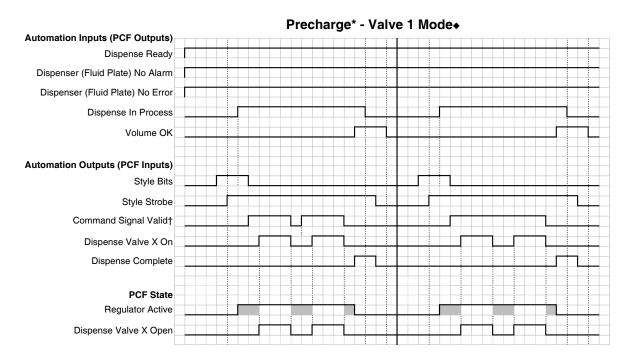




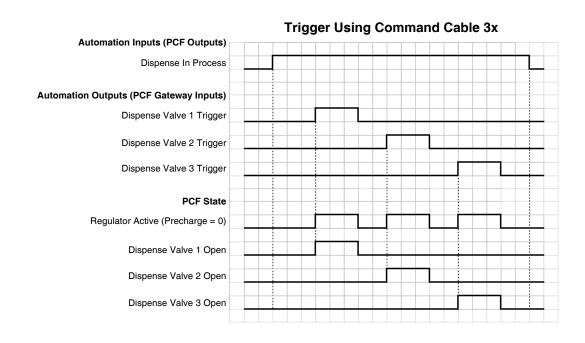
- * Precharge: After starting a job and prior to opening the dispense valve, the fluid pressure is increased to try to match the dispensing pressure. This helps the consistency of the dispense.
- ♦ Shaded areas indicate the precharge is active.

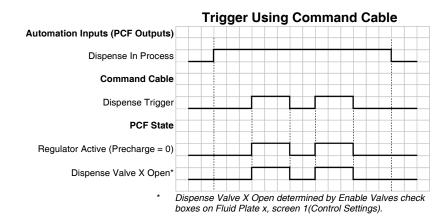
Precharge* - Gateway Mode◆ **Automation Inputs (PCF Outputs)** Dispense Ready Dispenser (Fluid Plate) No Alarm Dispenser (Fluid Plate) No Error Dispense In Process Volume OK **Automation Outputs (PCF Inputs)** Style Bits Style Strobe Precharge Valve X On† Command Signal Valid‡ Dispense Valve X On Dispense Complete **PCF State** Regulator Active Dispense Valve X Open

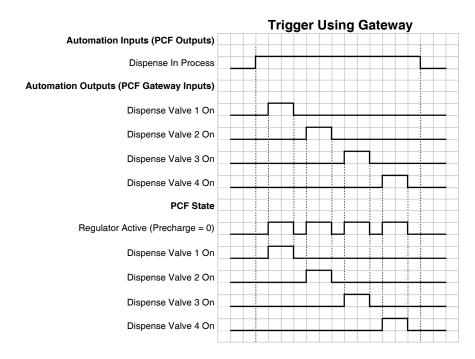
- * Precharge: After starting a job and prior to opening the dispense valve, the fluid pressure is increased to try to match the dispensing pressure. This helps the consistency of the dispense
- ♦ Shaded areas indicate the precharge is active.
- † The "Precharge Valve X On" bits are only available through a fieldbus interface. This precharge method is not valid for DGM systems.
- Only applies to command signals when either "Command Cable" or "gateway" is selected as "Command Value Source".

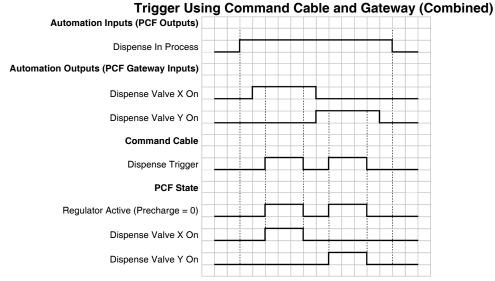


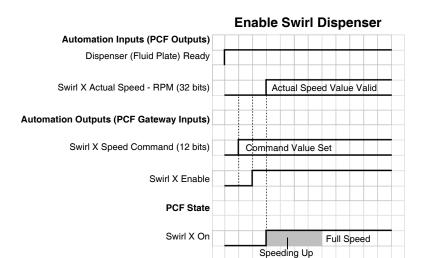
- * Precharge: After starting a job and prior to opening the dispense valve, the fluid pressure is increased to try to match the dispensing pressure. This helps the consistency of the dispense.
- Shaded areas indicate the precharge is active.
- † Only applies to command signals when either "Command Cable" or "gateway" is selected as "Command Value Source". In systems containing an automation gateway DGM, when "Digital" is selected as the "Command Value Type", the "Digital CMD 1" and "Digital CMD 2" inputs set the command.











NOTE: Swirl orbiter may take a few seconds to reach full speed.

Pressure Relief Procedure









The equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from pressurized fluid such as skin injection, splashing fluid and moving parts, follow the Pressure Relief Procedure when you stop dispensing and before cleaning, checking or servicing the equipment.

- 1. Shut off the fluid supply to the fluid plate assembly.
- 2. Place a waste container beneath the dispense valve.
- In maintenance mode, select Full Open Dispense Mode, which opens the regulator and dispense valve. Press the manual dispense button until the fluid flow stops.
- 4. If the dispense valve cannot be actuated from the control center, refer to Fig. 39 and perform the following steps to open the dispense valve and relieve fluid pressure:
 - Manually actuate the plunger on the solenoid to open all dispense valves attached to this fluid plate and relieve fluid pressure. See Fig. 39.

Dispense Valve Air Solenoid

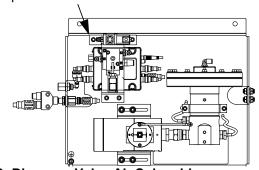


Fig. 39: Dispense Valve Air Solenoid

- Continue actuating the plunger until all pressure is purged from the system between the needle and the dispense valves attached to this fluid plate before proceeding to the next step.
- 5. For systems with multiple fluid plates, repeat previous steps for other fluid plates.
- 6. Shut off air to the fluid plate.
- Place a waste container below the air filter assembly then open drain valve on the air filter assembly. Close drain valve once air is relieved.
- 8. Turn main power switch on control panel to the OFF position.











- If you have followed the previous steps and suspect that a valve, hose, or dispense nozzle is clogged or that pressure has not been fully relieved, very slowly remove the dispense tip, clean the orifice, and continue relieving pressure.
- 10. If this does not remove the clog, cover the hose end coupling with a rag then very slowly loosen the hose end coupling to relieve pressure gradually, then loosen the coupling completely. Clear the valves or hose. Do not pressurize the system until the blockage is cleared.

Shutdown



1. Press the Stop button (BC).



Fig. 40: ADM - Stop Button

- 2. Shut off the material supply to the fluid plate/meter.
- 3. Follow the **Pressure Relief Procedure** on page 61.
- 4. Turn off the PCF system's compressed air supply.
- 5. Turn main power switch on control panel to the OFF position.

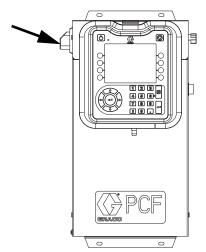


Fig. 41: Control Center Main Power Switch

USB Data

NOTE: USB data is not available on models that do not have an ADM. See **Models** on page 4.

All files downloaded from the USB are put in a DOWN-LOAD folder on the drive. For example: "E:\GRACO\12345678\DOWNLOAD\"

The 8-digit numeric folder name matches the 8-digit ADM serial number. When downloading from multiple ADMs, there will be one sub-folder in the GRACO folder for each ADM.

USB Logs

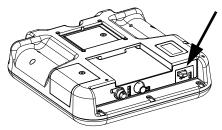


Fig. 42: ADM USB Port

During operation, PCF stores system and performance related information to memory in the form of log files. PCF maintains three types of log files: a job log, an event log, and dispense data logs. Follow the **Download Procedure**, page 65, to retrieve log files.

Event Log

The event log file name is 1-EVENT.CSV and is stored in the DOWNLOAD folder.

The event log maintains a record of the last 1,000 events. Each event record in the log file contains the date and time the event occurred, the event type, event code, and event description.

Job Log

The job log file name is 2-JOB.CSV and is stored in the DOWNLOAD folder.

The job log maintains a record of the last 10,000 jobs. At the completion of each job the following data is stored in the log file:

- Job completion date
- Job completion time

- Job number (sequential number)
- Dispenser (Fluid Plate) Number
- Style number
- Target volume (in the units shown in the volume units column)
- Requested volume (in the units shown in the volume units column)
- Actual dispensed volume (in the units shown in the volume units column)
- Volume units
- Error percentage between actual dispensed volume and requested volume (maximum of 100%)
- Minimum inlet pressure during job (measured in bar, heated systems will always read 0)
- Average inlet pressure during job (measured in bar, heated systems will always read 0)
- Maximum inlet pressure during job (measured in bar, heated systems will always read 0)
- Minimum outlet pressure during job (measured in bar)
- Average outlet pressure during job (measured in bar)
- Maximum outlet pressure during job (measured in bar)
- Minimum flow rate during job (measured in cc/min, systems with no flow meter will read 0)
- Average flow rate during job (measured in cc/min, systems with no flow meter will read 0)
- Maximum flow rate during job (measured in cc/min, systems with no flow meter will read 0)
- Elapsed time (mS)

Dispense Data Log

The dispense data log file name is 3-DATAx.CSV and is stored in the DOWNLOAD folder. There is one dispense data log file for each installed fluid plate, so there can be up to four data logs.

The dispense data log maintains a record of system inlet pressure (heated systems will always read 0), system outlet pressure, system flow rate (systems without flow meters will always read 0), and active dispense valves. This data is recorded at one second intervals when a job cycle is in process. Each dispense data log is capable of storing up to two hours of data.

System Configuration Settings File

The system configuration settings file name is SETTINGS.TXT and is stored in the DOWNLOAD folder.

A system configuration settings file automatically downloads each time a USB flash drive is inserted. Use this file to back up system settings for future recovery or to easily replicate settings across multiple PCF systems. Refer to the **Upload Procedure**, page 65, for instructions on how to use this file.

It is recommended to retrieve the SETTINGS.TXT file after all system settings are set as desired. Store the file for future use as a backup in case the settings are changed and need to be quickly changed back to the desired setup.

NOTE: System settings may not be compatible between different versions of the PCF software.

NOTE: Do not modify the contents of this file.

Custom Language File

The custom language file name is DISPTEXT.TXT and is stored in the DOWNLOAD folder.

A custom language file automatically downloads each time a USB flash drive is inserted. If desired, use this file to create a user-defined set of custom language strings to be displayed within the ADM.

The PCF system is able to display the following Unicode characters. For characters outside of this set, the system will display the Unicode replacement character, which appears as a white question mark inside of a black diamond.

- U+0020 U+007E (Basic Latin)
- U+00A1 U+00FF (Latin-1 Supplement)
- U+0100 U+017F (Latin Extended-A)
- U+0386 U+03CE (Greek)
- U+0400 U+045F (Cyrillic)

Create Custom Language Strings

The custom language file is a tab-delimited text file that contains two columns. The first column consists of a list of strings in the language selected at the time of download. The second column can be used to enter the custom language strings. If a custom language was previously installed, this column contains the custom strings. Otherwise the second column is blank.

Modify the second column of the custom language file as needed and then follow the **Upload Procedure**, page 65, to install the file.

The format of the custom language file is critical. The following rules must be followed in order for the installation process to succeed.

- The file name must be DISPTEXT.TXT.
- The file format must be a tab-delimited text file using Unicode (UTF-16) character representation.
- The file must contain only two columns, with columns separated by a single tab character.
- Do not add or remove rows to the file.
- Do not change the order of the rows.
- Define a custom string for each row in the second column.

Download Procedure

- Insert USB flash drive into USB port (BL). See Fig. 42 on page 63.
- The menu bar and USB indicator lights indicate that the USB is downloading files. Wait for USB activity to complete. A pop-up will be present until the transfer is complete if it is not acknowledged.
- 3. Remove USB flash drive from USB port (BL).
- 4. Insert USB flash drive into USB port of computer.
- The USB flash drive window automatically opens. If it does not, open USB flash drive from within Windows[®] Explorer.
- 6. Open Graco folder.
- Open system folder. If downloading data from more than one system, there will be more than one folder. Each folder is labeled with the corresponding serial number of the ADM (The serial number is on the back of the ADM.)
- 8. Open DOWNLOAD folder.
- 9. Open LOG FILES folder labeled with the highest number. The highest number indicates the most recent data download.
- Open log file. Log files open in Microsoft[®] Excel[®] by default as long as the program is installed. However, they can also be opened in any text editor or Microsoft[®] Word.

NOTE: All USB logs are saved in Unicode (UTF-16) format. If opening the log file in Microsoft Word, select Unicode encoding.

Upload Procedure

Use this procedure to install a system configuration file and/or a custom language file.

- If necessary, follow the **Download Procedure**, page 65, to automatically generate the proper folder structure on the USB flash drive.
- 2. Insert USB flash drive into USB port of computer.
- The USB flash drive window automatically opens. If it does not, open USB flash drive from within Windows Explorer.
- 4. Open Graco folder.
- Open system folder. If working with more than one system, there will be more than one folder within the Graco folder. Each folder is labeled with the corresponding serial number of the ADM. (The serial number is on the back of the module.)
- 6. If installing the system configuration settings file, place SETTINGS.TXT file into UPLOAD folder.
- 7. If installing the custom language file, place DISPTEXT.TXT file into UPLOAD folder.
- 8. Remove USB flash drive from computer.
- 9. Install USB flash drive into PCF system USB port.
- 10. The menu bar and USB indicator lights indicate that the USB is downloading files. Wait for USB activity to complete.
- 11. Remove USB flash drive from USB port.

NOTE: If the custom language file was installed, users can now select the new language from the Language drop-down menu in the Advanced Setup Screen 1.

Troubleshooting











NOTE: Check all possible solutions in the chart below before you disassemble the system.

Troubleshooting for individual fluid regulators and flow meters is also discussed in their separate manuals; refer to **Related Manuals** on page 3. Also refer to **Event and Error Codes and Troubleshooting**, page 71, for detailed information on how error codes are communicated.

Fluid Plates

Problem	Cause	Solution
No outlet pressure	Air pressure low	Verify air pressure is above 60 psi (410 kPa, 4.1 bar)
	No "Valve On" signal from automation unit	Check output and wiring from automation unit
	No air signal to air diaphragm	Check for loose/disconnected connector to Voltage to Pressure (V/P) Transducer; tighten
	False signal being sent to control	Check outlet pressure sensor output; verify that it corresponds to zero pressure; replace sensor and/or amplifier
High outlet pressure	Fluid regulator needle/seat is worn	Rebuild fluid regulator; replace needle/ seat
Air leaks from fluid plate	Loose air connections	Check air connections; tighten if necessary
	Worn gaskets	Check/replace gaskets on Voltage to Pressure (V/P) Transducer and solenoid valve

Flow Meter

Problem	Cause	Solution	
No flow measurement	Flow meter pick-up sensor loose	Tighten flow meter pick-up sensor	
	Flow too low	Verify flow rate is above minimum for the installed flow meter	
	Loose wiring Verify connection from flow FCM		
	Damaged flow meter pick-up sensor	Replace pick-up sensor	
False measurement	Flow meter not calibrated	Calibrate flow meter, page 46	
	System not grounded properly	Verify system ground	
	Noisy power source	Verify clean power supply power to main enclosure	
Flow reported is not correct or	Flow meter not calibrated	Calibrate flow meter, page 46	
inconsistent	Flow meter is worn	Replace flow meter	

Fluid Regulator

Problem	Cause	Solution
No pressure regulation	Damaged diaphragm	Replace diaphragm
	Leaking or dirty seat	Replace cartridge, or clean seat
No fluid flow	Damaged valve actuator	Replace valve actuator
Pressure creeps above setting	Metal chip or contamination	Replace cartridge, or clean seat
	between ball and seat	area
	Damaged diaphragm	Replace diaphragm
	Damaged o-ring or improper seal	Replace the o-ring under the seat
	Damaged or clogged air regulator or	Clear obstruction in line. Service
	line	regulator if necessary
	Leaking or dirty seat	Replace cartridge, or clean seat
	Large change in inlet pressure	Stabilize regulator inlet pressure
Pressure drops below setting	Empty/clogged supply line	Fill/flush supply line
	Damaged or clogged air regulator or	Clear obstruction in line. Service
	line	regulator if necessary
	Using valve beyond its rated flow	Install valve for each spray valve or
	capacity	dispensing valve
	Large change in inlet air or fluid	Stabilize air and fluid regulator inlet
	pressure	pressures
Fluid leaks from spring housing	Loose fluid housing	Tighten the four cap screws
	Damaged diaphragm	Replace diaphragm
Chatter	Excessive pressure differential be tween pump and valve	Reduce pump pressure to not more than 2000 psi (14 MPa, 138 bar) greater than required valve pressure.
	Excessive flow rate	Reduce fluid flow through regulator. Connect only one spray gun or dispense valve to each fluid regulator

Dispense Valves

Problem	Cause	Solution	
Valve not opening	Air not getting to the open port	Verify air pressure to solenoid	
	No "Valve On" signal from automation unit	Check input from automation unit	
Valve not shutting off	Air not getting to the close port	Verify air pressure to solenoid	
	(except AutoPlus valve)	Verify solenoid operation	
		Verify air line routing and connections	
	"Valve On" signal from automation unit is on	Check input from automation unit	
Sluggish open/close	Air pressure low	Verify air pressure is above 60 psi (410 kPa, 4.1 bar)	
	Needle/seat worn	Rebuild valve; replace needle/seat	
	Pressurized material past the valve shut-off is escaping	Reduce running pressure	
		Reduce nozzle length	
		Increase nozzle orifice size	
	Faulty solenoid valve	Replace solenoid valve	
	Solenoid valve muffler restricted	Clean or replace muffler	
Material leaks from back of valve	Shaft seal is worn	Rebuild valve; replace seals	
Air leaks from dispense valve	Loose air connections	Check air connections; tighten if	
		necessary	
	Worn piston o-ring	Rebuild valve; replace piston o-ring	

Swirl Dispenser

Problem	Cause	Solution
Motor not running (motor fault alarm active)	Cable disconnected	Verify cable connections to swirl board, swirl motor cable, and swirl orbiter
	CAN cable was re-connected with system power on (amber LED on swirl board will be on, this indicates circuit protection was triggered)	Cycle system power
	Shorted motor cable (amber LED on swirl board will be on, this indicates circuit protection was triggered)	Replace swirl motor cable (55 ft) then cycle power
	Faulty swirl orbiter	Replace swirl orbiter
Motor not running (motor fault alarm not active)	Cable disconnected	Verify cable connections to swirl board, swirl board power cable, and swirl control DGM
	No "Swirl Enable" signal from automation unit	Check input from automation unit
	Swirl not installed	Verify that the proper swirl orbiter is installed in the system setup screen

Motor not responding to change in speed command	No "Swirl Speed Command" signal from automation unit	Check input from automation unit
	Swirl speed source incorrectly set	Verify Speed Command Source in Swirl Setup screen

Gateway Module

Problem	Cause	Solution
No communication	Incorrect wiring	Check wiring per fieldbus standard. Refer to PCF Gateway LED status indicators and Appendix C - Communications Gateway Module (CGM) Connection Details, page 128.
	Incorrect fieldbus settings	Confirm fieldbus settings at automation controller (fieldbus master) and PCF Gateway (fieldbus slave). Refer to Appendix A - Advanced Display Module (ADM) , page 104, for information on PCF Gateway configuration settings.
Incorrect data	Incorrect fieldbus configuration file installed on automation controller (fieldbus master)	Download PCF fieldbus configuration file from www.graco.com, and install on automation controller (fieldbus master).
	Incorrect map installed on PCF Gateway	Confirm correct PCF data map is installed on PCF Gateway. Refer to Appendix A - Advanced Display Module (ADM), page 104, for information on how to determine installed data map. If necessary, install a new Gateway data map. Refer to Upgrade Gateway Module Fieldbus Map (16N601 or 17P799), page 82, for instructions, and Control Center and Expansion Swirl Enclosure Parts, page 96, for map token part number.

LED Diagnostic Information

The following LED signals, diagnosis, and solutions apply to the Advanced Display Module, Fluid Control Module, and Gateway module.

Module Status LED Signal	Diagnosis	Solution	
Green on	System is powered up	-	
Yellow	Internal communication in progress	-	
Red solid	Hardware failure	Replace module	
Red flashing fast	Uploading software	-	
Red flashing slow	Token error	Remove token and upload software token again.	
Red flashes three times, pauses, then repeats	Invalid rotary switch position (FCM and DGM only)	Change rotary switch position to a valid position then restart the system. See page 18.	

Errors

View Errors

When an error occurs, an error pop-up is displayed that takes up the entire screen until the error is acknowledged by pressing ____. Errors can also be acknowledged over the gateway. Active errors are displayed in the menu bar.

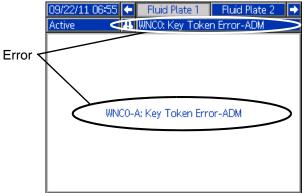


Fig. 43: Error Pop-Up

The previous 200 errors are displayed on the error report screens. See **Run Mode**, page 116, for instructions on navigating to and through the error report screens.

There are three levels of errors: alarms, deviations, and advisories. Alarms cause the system to shut down. Deviations and advisories do not shut down the system.

NOTE:

- Alarms set the dispenser (fluid plate) ready signal LOW.
- Advisories and deviations do not set the dispenser (fluid plate) ready signal LOW.

Errors can be viewed through a CGM on models that do not have an ADM. See **Appendix C**, page **128**, Output bits 0x0DB. The Error codes are described by a 4 digit ASCII string. For example: the first event code in the manual is EC0X and is represented using an ASCII table:

E = 0x45

C = 0x43

0 = 0x00

X = 0x58

Diagnose Errors

See **Event and Error Codes and Troubleshooting** on page 71 for error codes, possible causes, and solutions.

Event and Error Codes and Troubleshooting

Error codes are stored in the events log and are displayed on the error report screens. Gateway error numbers are reported over the Gateway interface.

Error codes shown as XYZ_ represent error codes XYZ1, XYZ2, XYZ3, XYZ4, where the last digit represents the number of the fluid plate to which the error applies. Error codes in the following table are sorted by gateway error number, then by event code.

NOTE: The following error list is available in the PCF Integration package at www.graco.com.

System Events and Errors

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution
			System Even	ts and Errors		
	0	No Active Errors	No errors			No action necessary
EC0X		Setup Values Changed	Setup change notification	Record only	A setup value was changed on the display	No action necessary if changes were desired
EL0X		Power Up	Control box power up	Record only		No action necessary
EM0X		Power Down	Control box power down	Record only		

Control Center Events and Errors

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution		
	Control Center Events and Errors							
EVUX		USB Disabled	USB download attempted, however, USB activity is dis- abled.	Advisory (self-clearing)	Transfers are dis- abled in Advanced Setup screen 2.	Clears when drive is removed.		
MMUX		USB Log 90% Full	One or more USB log is 90% full.	Advisory	Data in the jobs or events log has not been downloaded recently and logs are nearly full.	Download the data or disable USB errors.		
V1G0		DGM Unpowered	The Discrete Gateway Module does not have logic power supplied to it.	Advisory	24 Vdc has not been connected to the power pins.	Connect power according to Appendix B - Discrete Gateway Module (DGM) Connection Details on page 121.		
WSG0		Gateway Setup Error	System settings are incompatible with Discrete Gateway Module.	Advisory	Fluid plate 1 is not installed. Or Fluid plate 3 or fluid plate 4 is installed.	Install fluid plate 1, uninstall fluid plates 3 and 4.		
					Swirl 1 is not installed. Or Swirl 3 or Swirl 4 is installed.	Install Swirl 1, uninstall swirls 3 and 4.		
EAUX		Download to USB in Process	Information is currently being downloaded to USB	Advisory (self-clearing)		No action necessary		

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution		
	Control Center Events and Errors							
EBUX		Download to USB Complete	Download to the USB is complete	Advisory (self-clearing)		No action necessary		
WSU0		USB configura- tion error	USB configuration error	Advisory	USB configuration invalid or not present	Reinstall system soft- ware on display		
WNC0	32	ADM Key Token Error	Missing or invalid key token	Alarm	An ADM key token is required to run the system	Verify the key token is installed		
						Verify the key token part number is correct for the PCF ADM		
WNG0		Gateway Map Error	Missing or invalid map	Advisory	Missing or invalid Gateway map	Install PCF map in Gateway		
CBG0		Gateway Reset	Gateway reset	Advisory (self-clearing)	Gateway setting(s) changed	Wait for reset to com- plete before attempt- ing automation control		
WMG0		Gateway Error Detected	Gateway error detected; includes any error not covered by another more specific error	Alarm				
CBD_		Fluid Plate Com- munication Error	Fluid Plate Communication Error with ADM	Alarm	The ADM lost communications with the FCM.	Restore communication.		
CCG_		Fieldbus Com- munication Error	Fieldbus Communication Error	Alarm	The automation gateway lost communication with the automation controller.	Restore communications.		

Fluid Plate Events and Errors

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution	
	Fluid Plate Events and Errors						
CAC_		CGM Communication Error	Communication lost between CGM and Fluid Plate	Advisory	Fluid Plate and CGM are no longer communicating	Reconnect or replace CAN cable	
					CGM is not functioning	Replace the CGM if the red status LED is solid	
CAD_		Fluid Plate Communication Error	FCM lost communication with the ADM	Alarm	ADM is not communicating	Reconnect or replace CAN cable	
					ADM is not functioning	Replace FCM if red status LED is solid	
					ADM does not contain appropriate key token	Verify intended ADM key token is properly inserted	
B7C_	30	Style Out of Range	Style is out of range	Alarm	Style requested by automation controller exceeds number of styles available on the fluid plate	Use a style number that is in range	
						Increase number of styles in PCF; pur- chase accessory key token	

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution			
	Fluid Plate Events and Errors								
B30_ B40_	during last dispense		-	Alarm or Deviation (user select-	PCF regulator is not regulating correctly	Check regulator and repair if necessary			
			amount requested plus the allowed tolerance	able)	Incorrect style target volume or tolerance	Enter correct values or set tolerance to 0% to disable error			
B10_ B20_	32	Low Material	Material dispensed during last dispense	Alarm or Deviation	Partially plugged tip or supply system	Clean tip and/or supply system			
			cycle below amount requested minus the allowed tolerance	(user select- able)	Insufficient flow to PCF regulator inlet	Increase flow rate to regulator inlet			
			allowed tolerance		PCF regulator is not regulating correctly	Incorrect style target volume or tolerance setting			
					Check regulator; repair if necessary				
B1C_ B2C_	33	Low Computed Target	Requested volume/ mass differs from	Alarm or Deviation	Entered process target incorrectly	Enter correct process target			
			entered process target by more than entered	(user select- able)	Entered tolerance incorrectly	Enter correct tolerance			
		tolerance for style requested			Requested volume incorrectly	Check automation program			
					Automation problem	Verify automation is correct			
B3C_ B4C_	34	High Computed Target	Requested volume/ mass differs from	be so differs from ered process target more than entered Deviation (user selectable)	Entered process target incorrectly	Enter correct process target			
			, ,		Entered tolerance incorrectly	Enter correct tolerance			
				-		· · · · · · · · · · · · · · · · · · ·	-		Requested volume incorrectly
					Automation problem	Verify automation is correct			
WND_	51	Fluid Plate Key Token Error	Missing or invalid key token	Alarm	FCM key token is required to run system	Verify FCM key token is installed			
						Verify FCM key token is correct part number			
P6D_	52	Outlet Pressure Transducer Error	Outlet pressure trans- ducer error	Alarm	Problem detected with outlet pressure transducer	Verify outlet pressure transducer is installed and/or connected cor- rectly			
DOE	50	India A Don	lalat aussau	A de de e	Duebless det 1 1 22	Replace if necessary			
P6F_	53	Inlet Pressure Transducer Error	Inlet pressure trans- ducer error	Advisory	Problem detected with inlet pressure transducer	Verify inlet pressure transducer is installed and/or connected cor- rectly			
						Replace if necessary			
F6D_	54	Flow Meter Error	Flow Meter error	Alarm	Problem detected with flow meter	Verify flow meter is installed and/or connected correctly			
						Replace if necessary			

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution
	L		Fluid Plate Eve	ents and Errors	5	
WED_	55	V/P Error	Voltage to Pressure Transducer error	Alarm	Problem detected with V/P	Verify outlet pressure transducer is installed and/or connected cor- rectly
						Replace if necessary
WJ1_	56	Dispense Valve 1 Error	Dispense valve 1 error	Alarm	Problem detected with dispense valve 1	Verify dispense valve 1 is installed and/or connected correctly
						Replace if necessary
WJ2_	57	Dispense Valve 2 Error	Dispense valve 2 error	Alarm	Problem detected with dispense valve 2	Verify dispense valve 2 is installed and/or con- nected correctly
						Replace if necessary
WJ3_	58	Dispense Valve 3 Error	Dispense valve 3 error	Alarm	Problem detected with dispense valve 3	Verify dispense valve 3 is installed and/or connected correctly
14/14	50	D: 1/ 1	D:	A1	D 11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Replace if necessary
WJ4_	59	Dispense Valve 4 Error	Dispense valve 4 error	Alarm	Problem detected with dispense valve 4	Verify dispense valve 4 is installed and/or connected correctly
						Replace if necessary
WSD_	60	Incompatible Valve Settings	Incompatible settings for multiple valve oper- ation; attempted to dis- pense	Alarm	Attempted to dispense simultaneously from multiple valves on the same fluid plate with different pressure settings	Check settings shown on Fluid Plate x, screen 2 (Mode Settings) Verify automation programming
WSD5	60	Incompatible Valve Settings	Incompatible settings for multiple valve oper- ation; attempted to dis- pense	Alarm	Attempted to dispense simultaneously from multiple valves on the same fluid plate with different pressure settings	In the Discrete Gate- way screens, change the settings of the simultaneously dis- pensing valves to the same pressure Verify automation pro- gramming
F7D_	61	Closed Valve Flow	System reading flow meter pulses with	Alarm	Dispense hose leak	Check hose; replace if needed
			valve(s) closed		Flow meter providing false pulses	Replace flow meter sensor or calibrate meter
					Dispense valve not operating correctly	Repair dispense valve
V2D_	62	2 Low Analog	Command cable ana- log command dropped below minimum value	Deviation	Bad or loose com- mand cable connec- tion	Check command cable and connection
			of 1 V while dispensing		Entered command mode incorrectly	Enter correct com- mand code
					Automation program error	Verify correct automation program

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution
		l	Fluid Plate Eve	nts and Errors	<u> </u>	
WFD_ WFG_	Required requires flow meter. Advisory is issued if fluid plate settings require a flow meter but meter is not present.		Alarm or Advisory (self-clearing)	Selected valve mode settings require flow meter	Check valve mode settings Purchase meter enabled token for FCM and install flow meter	
			Alarm is issued if dispense is attempted in mode that requires a flow meter but meter is not present.		FCM key token miss- ing or invalid	Check for FCM key token error
EJD_	64	Job Cycle Time Out	Job cycle time out	Alarm	Automation signals did not properly end job cycle	Check automation programming per job operating instruction
WXD_	65	Fluid Plate Error Detected	Fluid plate error detected; includes any error not covered by another more specific	Alarm	Analog voltage applied to pin 1 of the com- mand cable exceeds 10 Vdc.	Limit signal on pin 1 of command cable to the range of 0-10 Vdc.
			error		Failed FCM	Replace FCM if necessary
P3F_ P4F_	66	Maximum Inlet Pressure Inlet pressure to regulator is above upper limit set for operation Inlet pressure to regulator is above upper limit (user selectable)	re tor is above upper limit	Deviation	Incorrect set limit	Verify limit is set cor- rectly
				*	Material supply pressure is too high	Decrease material sup- ply pressure
					Failed transducer	Check transducer; replace if necessary
P3D_ P4D_	67	Pressure lator is above upper		Alarm or Deviation	Incorrect set limit	Verify limit is set cor- rectly
			limit set for operation	(user select- able)	Material supply pressure is too high	Decrease material sup- ply pressure
					Failed transducer	Check transducer; replace if necessary
P1F_ P2F_	68	Minimum Inlet	ssure tor is below lower limit	Deviation	Incorrect set limit	Verify limit is set cor- rectly
			set for operation	(user select- able)	Material supply pressure is too low	Increase crease material supply pressure
					Failed transducer	Check transducer; replace if necessary
P1C_ P2C_	69	Low Pressure	Measured outlet pres- sure less than desired	Alarm or Deviation	Incorrect limit set	Verify limit is set cor- rectly
			outlet pressure minus tolerance	(user select- able)	No or insufficient material flow	Increase material flow rate
					Dispense valve needle is stuck closed	Dislodge and inspect needle
					Dispense valve leak- ing	Repair dispense valve
					Regulator not operating correctly	Repair regulator
					Pump wink passed through outlet	Increase pump pressure
					Failed transducer	Check transducer; replace if failed

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution			
	Fluid Plate Events and Errors								
P3C_ P4C_			Alarm or Deviation	Incorrect limit set	Verify limit is set cor- rectly				
			desired outlet pressure plus tolerance	(user select- able)	Dispense hose/device plugged	Clean/replace hose/device			
					Failed transducer	Check transducer; replace if failed			
					Regulator is not clos- ing completely when it should	Repair regulator			
F1D_ F2D_	71	Low Flow Rate	Measured flow rate less than desired flow rate minus tolerance	Alarm or Deviation (user select-	Fluid supply too low to achieve desired flow rate	Increase fluid supply pressure or check for clogged filter			
				able)	Tip plugged	Clean/replace tip			
					No air pressure to solenoid valves	Turn on air to solenoid valves			
					No flow meter signal	Check cable and sensor			
				No material supply	Replace drum or turn on pumps				
					Incorrect flow toler- ance of flow error time	Enter correct toler- ance or flow error time			
F3D_ F4D_	72	High Flow Rate	Measured flow rate greater than desired flow rate plus tolerance	Alarm or Deviation (user select-	Operating below mini- mum regulator operat- ing pressure	Increase fluid pres- sure above regulator minimum			
				able)	Regulator worn or not operating correctly	Repair regulator			
					Flow meter providing false pulses	Replace flow meter sensor			
					Incorrect flow error tol- erance or flow error time	Enter correct toler- ance or flow error time			
EKD_	73	Shot Terminated by Job Timer	Shot dispense cycle terminated by job timer	Advisory	Job end timer was used to stop shot dispense	No action required if timed shot is desired			
EHD_	74	Purge Timer Expired	Purge timer expired	Advisory	PCF purge timer (style 0) has expired	Automation control requests purge			
EAC_	75	Maintenance Mode Entered	Maintenance mode entered	Advisory (self-clearing)	Entered maintenance dispense mode	No action required			
EBC_	76	Maintenance Mode Exited	Maintenance mode exited	Advisory (self-clearing)	Exited maintenance dispense mode	No action required			
MHD_	77	Maintenance Due - Regulator	Maintenance due for regulator	Advisory	Totalizer exceeded limit setting	Service component			
			i egulatoi		minic security	If necessary, reset totalizer			
MFD_	78	Maintenance Due - Flow Meter	Maintenance due for flow meter	Advisory	Totalizer exceeded limit setting	Service component If necessary, reset totalizer			

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution
	<u> </u>		Fluid Plate Eve	ents and Errors		
MED_	79	Maintenance Due - V/P	Maintenance due for Voltage to Pressure Transducer	Advisory	Totalizer exceeded limit setting	Service component If necessary, reset totalizer
MCD_	80	Maintenance Due - Supply	Maintenance due for supply system	Advisory	Totalizer exceeded limit setting	Service component If necessary, reset totalizer
MD1_	81	Maintenance Due - Valve 1	Maintenance due for valve 1	Advisory	Totalizer exceeded limit setting	Service component If necessary, reset totalizer
MD2_	82	Maintenance Due - Valve 2	Maintenance due for valve 2	Advisory	Totalizer exceeded limit setting	Service component If necessary, reset totalizer
MD3_	83	Maintenance Due - Valve 3	Maintenance due for valve 3	Advisory	Totalizer exceeded limit setting	Service component If necessary, reset totalizer
MD4_	84	Maintenance Due - Valve 4	Maintenance due for valve 4	Advisory	Totalizer exceeded limit setting	Service component If necessary, reset totalizer
CCD_	85	Duplicate Module	Duplicate Fluid Control Module Detected	Alarm	Two or more FCMs have the same rotary switch setting	Verify that all FCMs have proper rotary switch settings. Reset module after changing rotary switch setting. Refer to Fluid Plate Assembly Overview section, page 17
EAD_	86	Swirl Mainte- nance Mode Entered	Swirl maintenance mode entered	Advisory (self-clearing)	Swirl zone that is associated with this fluid plate entered maintenance mode	No action required
WFC_	87	Shot No-Flow Timeout	No flow detected for five seconds on valve activated in shot mode	Alarm	Dispense valve not operating properly Fluid leak	Check dispense valve for correct operation and/or clogging Check fluid connec-
CR1_	88	Valve 1 Swirl Communication Error	Fluid plate communication error with swirl	Alarm	The fluid plate lost communication with the swirl zone associated with this valve and fluid plate	Restore communications.
CR2_	89	Valve 2 Swirl Communication Error	Fluid plate communication error with swirl	Alarm	The fluid plate lost communication with the swirl zone associated with this valve and fluid plate	Restore communications.

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution			
	Fluid Plate Events and Errors								
CR3_	90	Valve 3 Swirl Communication Error	Fluid plate communication error with swirl	Alarm	The fluid plate lost communication with the swirl zone associated with this valve and fluid plate	Restore communications.			
CR4_	91	Valve 4 Swirl Communication Error	Fluid plate communication error with swirl	Alarm	The fluid plate lost communication with the swirl zone associated with this valve and fluid plate	Restore communications.			
WD1_	92	Valve 1 Swirl Fault	Swirl motor fault	Alarm or Deviation (user-select- able)	The swirl zone associated with this valve and fluid plate caused a fault	Resolve swirl motor fault (see error WBDX for possible solutions)			
WD2_	93	Valve 2 Swirl Fault	Swirl motor fault	Alarm or Deviation (user-select- able)	The swirl zone associated with this valve and fluid plate caused a fault	Resolve swirl motor fault (see error WBDX for possible solutions)			
WD3_	94	Valve 3 Swirl Fault	Swirl motor fault	Alarm or Deviation (user-select- able)	The swirl zone associated with this valve and fluid plate caused a fault	Resolve swirl motor fault (see error WBDX for possible solutions)			
WD4_	95	Valve 4 Swirl Fault	Swirl motor fault	Alarm or Deviation (user-select- able)	The swirl zone associated with this valve and fluid plate caused a fault	Resolve swirl motor fault (see error WBDX for possible solutions)			
MB1_	96	Maintenance due - V1 Orbiter	Maintenance due on valve 1 swirl orbiter	Advisory	The active time total- izer for the swirl dis- penser associated with this valve and fluid plate exceeded limit setting	Service Component If necessary, reset totalizer			
MB2_	97	Maintenance due - V2 Orbiter	Maintenance due on valve 2 swirl orbiter	Advisory	The active time total- izer for the swirl dis- penser associated with this valve and fluid plate exceeded limit setting	Service Component If necessary, reset totalizer			
MB3_	98	Maintenance due - V3 Orbiter	Maintenance due on valve 3 swirl orbiter	Advisory	The active time total- izer for the swirl dis- penser associated with this valve and fluid plate exceeded limit setting	Service Component If necessary, reset totalizer			
MB4_	99	Maintenance due - V4 Orbiter	Maintenance due on valve 4 swirl orbiter	Advisory	The active time total- izer for the swirl dis- penser associated with this valve and fluid plate exceeded limit setting	Service Component If necessary, reset totalizer			

Swirl Events and Errors

Event Code	Gateway Error No.	Event Name	Event Description	Event Type	Cause	Solution			
Oode	Swirl Events and Errors								
CBR_		Swirl Communi- cation Error	Swirl communication error with ADM	Alarm	The ADM lost communication with the Swirl Control DGM	Restore communications			
CDR_		Duplicate Module	Duplicate Swirl Control DGM Detected	Alarm	Two or more Swirl Control DGMs have the same rotary switch setting	Verify that all Swirl Control DGMs have proper rotary switch settings. Reset mod- ule after changing rotary switch setting. Refer to Swirl Control DGM section, page 22.			
EAD_		Maintenance Mode Entered	Maintenance mode entered	Advisory (self-clear- ing)	Swirl maintenance mode entered	No action required			
EBD_		Maintenance Mode Exited	Maintenance mode exited	Advisory (self-clear- ing)	Swirl maintenance mode exited	No action required			
MBD_		Maintenance Due - Orbiter	Maintenance due on swirl orbiter	Advisory	Swirl active time total- izer exceeded limit set- ting	Service Component If necessary, reset totalizer			
WBD_		Swirl Motor Fault	Motor speed is outside the +/- 50% tolerance range for at least 5 sec- onds while operating	Alarm	Cable disconnected	Verify cable connections to swirl board, swirl motor cable, and swirl orbiter			
					Shorted motor cable (amber LED on swirl board will be on)	Replace swirl motor cable (55 ft)			
					Orbiter bearing failure	Replace bearing			
					Motor defective	Replace swirl orbiter			

Maintenance



Prior to performing any maintenance procedures, follow the **Pressure Relief Procedure** on page 61.

Maintenance Schedule

The following tables list the recommended maintenance procedures and frequencies to operate the equipment safely. The maintenance is divided between mechanical and electrical tasks. Maintenance must be performed by trained personnel per this schedule to assure safety and reliability of the equipment.

Mechanical

	Operator			Maintenan	ce Person		
Task	Daily	Weekly	Monthly	3-6 months or 125,000 cycles	18-24 months or 500,000 cycles	36-48 months or 1,000,000 cycles	7000 hours
Inspect system for leaks	✓						
Depressurize fluid, after operation	1						
Remove heat from system, after operation	1						
Inspect filter (234967) bowls and drain		1					
Check hoses for wear		✓					
Check/tighten fluid connections		✓					
Check/tighten air connections		✓					
Lubricate dispense valves*			1				
Rebuild regulator*				1			
Rebuild dispense valve*				1			
Replace air filter					✓		
Replace Solenoid						1	
Replace Voltage to Pressure (V/P) Transducer							1
* Check component manual for n	nore detailed r	maintenance	information.	•			

Electrical

Task	Weekly
Check cables for wear	1
Verify cable connections	1
Verify operation of "System Stop" button	1

^{*} Check Component Manual for more detailed maintenance information.

Advanced Display Module (ADM)

Upgrade Software (16K743)

NOTE: Back up the custom language file (if installed) before upgrading software. See **USB Data**, page 63, for more information.

- 1. Turn off power to the system.
- 2. Remove token access panel, and then remove the key token (do not discard token).

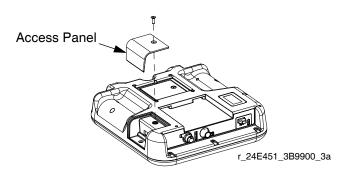


Fig. 44: Remove Access Panel

3. Insert and press software token firmly into slot.

NOTE: There is no preferred orientation of token.



Fig. 45: Insert Token

- 4. Turn on power to the system. The red indicator light (BL) will flash until new software is completely loaded.
- 5. After the red indicator light shuts off, turn off power to the system.
- 6. Remove software token.
- 7. Reinstall blue key token, and replace token access panel.

Cleaning

Use any alcohol-based household cleaner, such as glass cleaner, to clean the display.

Upgrade Gateway Module Software (16K743)

NOTE: The Gateway module connection to the system is temporarily disabled during the use of upgrade tokens. The following instructions apply to all Gateway modules.

- 1. Turn off power to the system.
- 2. Remove the access cover.

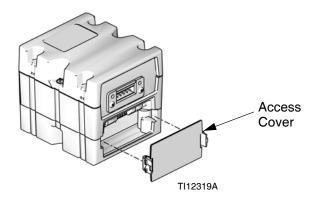


Fig. 46: Remove Access Cover

3. Insert and press token firmly into slot.

NOTE: There is no preferred orientation of token.

4. Press and hold the button shown in Fig. 47 for ~1 second, then release. The red indicator light (CK) will flash until new software is completely loaded.

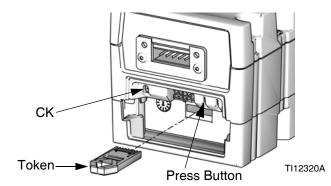


Fig. 47: Insert Token

- After the red indicator light shuts off, turn off power to the system.
- Remove token.
- 7. Replace access cover.

Upgrade Gateway Module Fieldbus Map (16N601 or 17P799)

NOTE: The fieldbus connection is temporarily disabled during the use of a map token. The following instructions apply to all Gateway modules.

- Perform Upgrade Gateway Module Software (16K743). Software must be upgraded before upgrading the fieldbus map.
- 2. Remove the access cover.

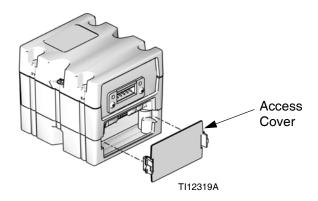


Fig. 48: Remove Access Cover

3. Insert and press map token firmly into slot.

NOTE: There is no preferred orientation of the token.

 Press and hold the push button for three seconds and then release. The red indicator light (CK) will flash twice, pause, and then once after the data map is uploaded.

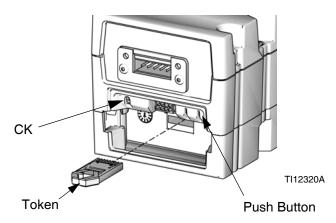


Fig. 49: Insert Token

- 5. Remove map token (CC) when software has successfully uploaded.
- 6. Replace access cover.

Upgrade Fluid Control Module (FCM) Software (16K743)

NOTE: The FCM connection is temporarily disabled during the use of the upgrade token.

- 1. Turn off power to the system.
- 2. Remove access cover then remove key token (do not discard token).

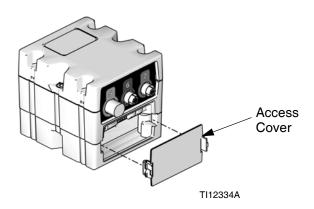


Fig. 50: Remove Access Cover

3. Insert and press software token firmly into slot.

NOTE: There is no preferred orientation of token.

 Press and hold the button shown in Fig. 51 for ~1 second, then release. The red indicator light (CK) will flash until new software is completely loaded.

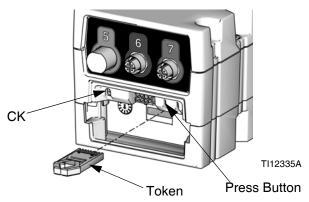


Fig. 51: Insert Token

- 5. After the red indicator light shuts off, turn off power to the system.
- 6. Remove software token.

7. Reinstall blue key token, and replace access cover.

Air Filter Maintenance

To prevent filter element damage, replace air filter every two years or when pressure drop becomes 100 kPa (1.0 bar, 14.5 psi) or greater; which ever occurs first.

Replacement Air Filters for Dual Filter Assembly (234967)

Part	Description
123091	5 micron air filter
123092	0.3 micron air filter

Swirl Dispensers

See manual 309403 for maintenance schedule.

Repair

Fluid Plate Assembly



This section describes how to remove and replace components on the fluid plate assembly.

Prepare Fluid Plate Assembly for Repair

- 1. Disconnect the CAN cable from the fluid plate.
- 2. Perform Pressure Relief Procedure on page 61.
- 3. Remove the fluid plate assembly shroud. See **Fluid Plate Assembly Parts**, page 98.

Repair Flow Meter

For complete flow meter (129) repair instructions refer to the maintenance and repair section of manual 309834. **NOTE:** The Coriolis flow meter is not field repairable.

Remove Flow Meter from Mounting Plate

- Prepare Fluid Plate Assembly for Repair, page 84.
- Disconnect the flow meter cable (131) from the flow meter sensor. See Fig. 52.
- 3. Disconnect the material hose.
- 4. Disconnect the swivel fitting (109) from the regulator.
- 5. Loosen the four screws (127) and washers (125, 126); remove the bracket (124) and flow meter (129).
- 6. The flow meter weighs approximately 15 lbs. (6.75 kg). Carefully lift it off the mounting plate (101).

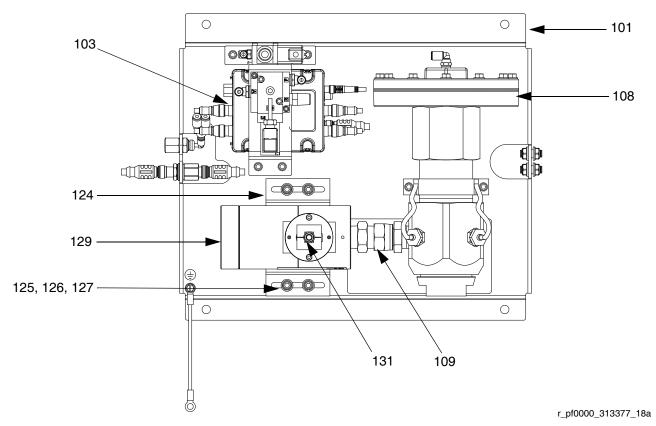
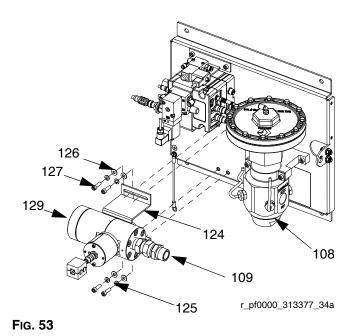


Fig. 52: Fluid Plate Assembly

Install Flow Meter on Mounting Plate

NOTE: The Coriolis flow meter does not mount to the fluid plate.

- 1. Rest the flow meter (129) and bracket (124) on the fluid plate while threading the swivel fitting (109) onto the regulator material inlet. See Fig. 52.
- Tighten the swivel fitting to the regulator material inlet.
- 3. Tighten the four screws (127) and washers (125, 126) to hold the bracket and flow meter in place.



- 4. Check that the flow meter and regulator (108) are still aligned.
- 5. Connect the material hose.
- 6. Connect the flow meter cable (131).

Replace Solenoid

- 1. Prepare Fluid Plate Assembly for Repair, page 84.
- 2. Disconnect FCM cable and all three air tubes.
- 3. Remove both screws (137) from transducer bracket (118).

4. Remove the dispense valve solenoid (132) and replace it with a new solenoid.

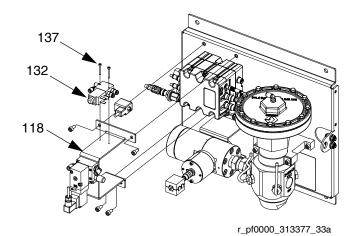


Fig. 54

- 5. Secure the new solenoid to the bracket with screws.
- 6. Reconnect the FCM cable and all three air tubes.

Replace Voltage to Pressure (V/P) Transducer

- Prepare Fluid Plate Assembly for Repair, page 84.
- 2. Disconnect the FCM cable and both air tubes.
- 3. Remove both transducer screws (122) from transducer bracket (118).
- 4. Remove the V/P transducer (121) and replace it with a new V/P transducer.

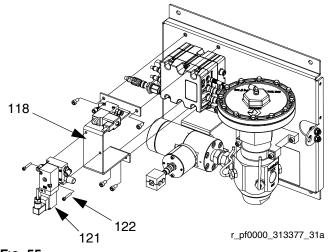
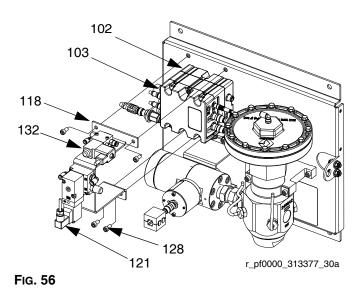


Fig. 55

- 5. Secure the new V/P transducer to the bracket with screws.
- Reconnect the FCM cable and both air tubes.

Replace Fluid Control Module

- Prepare Fluid Plate Assembly for Repair, page 84
- Remove the four screws (128) from the transducer bracket (118), and remove the bracket. (Leave the dispense valve solenoid (132) and V/P transducer (121) attached to the transducer bracket.)



- 3. Remove the following cables from FCM:
 - dispense valve solenoid cable
 - meter sensor cable
 - both V/P cables
 - I/O cable
 - inlet pressure transducer cable (ambient models only)
 - outlet pressure transducer cable
- 4. Remove the two screws from FCM (103) and replace with a new FCM.
- 5. Secure the new FCM to the base (102) with screws.
- 6. Reconnect the cables listed in step 3.
- 7. Reattach the transducer bracket using screws.

Replace Fluid Control Module Base

- Prepare Fluid Plate Assembly for Repair, page 84.
- Remove the FCM (103); follow Replace Fluid Control Module. (Leave the cables attached to the FCM.)
- 3. Remove the power supply cable from the base (102).
- 4. Remove the four screws (105) and ground screw (106) from the base and replace it with a new base.

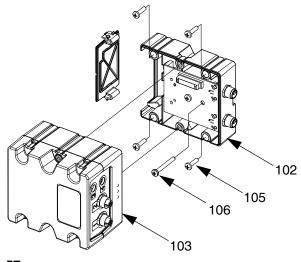


FIG. 57

- 5. Secure the base to the fluid plate (101) with screws.
- 6. Reconnect the power supply cable.
- 7. Reattach the FCM; follow **Replace Fluid Control Module**.

Replace Transducer O-Rings

- 1. **Prepare Fluid Plate Assembly for Repair**, page 84.
- 2. Remove the fluid outlet pressure sensor (117) from the regulator (108).

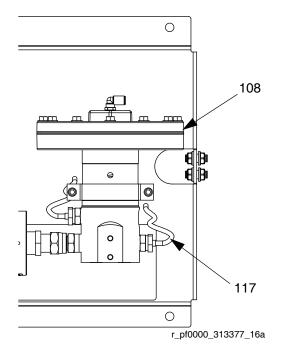


FIG. 58

- 3. Press the transducer (CG) out of the retainer nut (CH).
- 4. Remove the faulty o-ring (120) and replace with new.

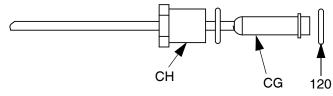


Fig. 59

- 5. Press the transducer back into the retainer nut.
- 6. Reconnect the fluid outlet pressure sensor to the regulator.

Repair Fluid Regulator

For complete cartridge fluid regulator repair refer to instruction manual 308647. For complete mastic fluid regulator repair refer to instruction manual 307517.

See Fig. 60 and perform the following steps.

NOTICE

Carefully handle the hard carbide ball, valve actuator, and valve seat to avoid damaging them.

- 1. Prepare Fluid Plate Assembly for Repair, page 84.
- 2. Remove the cartridge assembly by loosening the valve housing (CE) with a 6 mm hex wrench and pulling the cartridge assembly out of the base housing (CD).

NOTE: The retaining nut (CC) often loosens when removing the cartridge assembly from the base housing. Be sure to re-torque as described in step 4.

3. Inspect and clean the internal walls of the base housing (CD).

NOTE: Be careful to not scrape or gouge the internal walls of the base housing. They are a sealing surface.

 Re-torque the retaining nut (CC) to 140-160 in-lb (16-18 N•m).

NOTE: You must re-torque the retaining nut before you install it in the base housing during step 5.

5. Install the new cartridge assembly in the base housing (CD), and torque the valve housing (CE) to 30-35 ft-lb (41-48 N•m).

NOTE: The valve seat is double sided and may be reversed for extended life. The o-ring and ball must be replaced. See instruction manual 308647.

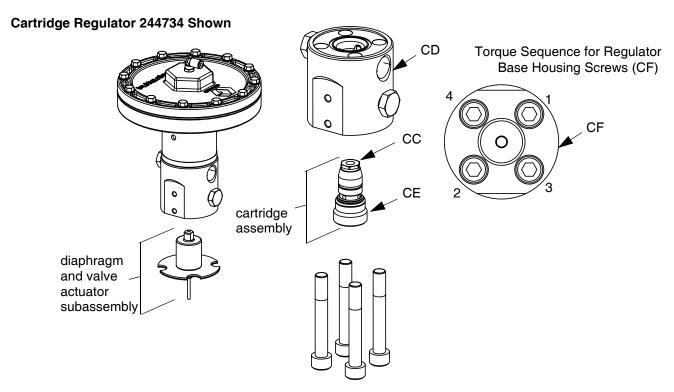


Fig. 60: Replace Cartridge Assembly

Replace Amplifier

(Heated fluid plates only)

- Prepare Fluid Plate Assembly for Repair, page 84.
- 2. Disconnect pressure sensor cable (117) and power output cable.

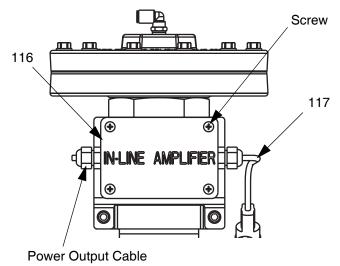


Fig. 61: Replace Amplifier

- Loosen four screws on amplifier (116) cover, and then remove cover.
- 4. Remove four screws (105) securing amplifier to bracket.
- 5. Remove amplifier and replace with a new amplifier.
- 6. Secure new amplifier to bracket with four screws.
- 7. Replace amplifier cover and tighten screws.
- Reconnect pressure sensor cable (117) and power output cable.

Calibrate Amplifier

(Heated fluid plates only)

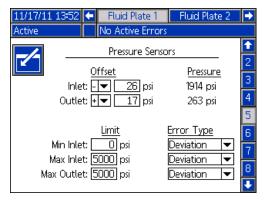
- Prepare Fluid Plate Assembly for Repair, page 84.
- 2. Remove outlet pressure sensor from outlet fitting to ensure there is no pressure applied to the sensor.

Adjust Display Settings

- 3. With the system in setup mode, navigate to the Advanced screens.
- 4. Press 1 to scroll to Advanced screen 2.



- 5. Press to access the fields to make changes.
- 6. Press to move the Pressure Units field. Press to open the drop-down list, and select psi. Press to enter the new units.
- 7. Press to exit edit mode.
- 8. With the system still in setup mode, navigate to Fluid Plate x, screen 5 (Pressure Sensors).



- 9. Press to access the fields to make changes.
- 10. Press to move the Outlet Offset field. Set the psi to 0. Press to enter the new setting.
- 11. Press to exit edit mode.

Adjust Amplifier Settings

- 12. Remove cover from amplifier (116). See **Replace Amplifier**, page 89.
- 13. Ensure the EXCITATION SELECTOR jumper is in the middle position (5 Vdc). See Fig. 62 on page 90.
- 14. Ensure the COARSE GAIN dipswitch 1 is set to ON. All others should be set to OFF.
- 15. Adjust the FINE ZERO potentiometer until the outlet pressure on the display reads 0.
- 16. Use a small piece of jumper wire or a paper clip to connect the SHUNT CAL and ENABLE terminals.

- 17. Use the data from the certificate of calibration for the pressure sensor (included with PCF documentation or the replacement pressure sensor) to calculate the Shunt Calibration Pressure using the following formula:
 - Shunt Calibration Pressure = (Shunt Cal Factor / Calibration Factor) * 5000 psi
- 18. Adjust the FINE GAIN potentiometer until the Outlet Pressure on Fluid Plate x, screen 5 (Pressure Sensors) matches the calculated Shunt Calibration Pressure.
- 19. Remove the jumper wire or paper clip from the SHUNT CAL and ENABLE terminals.
- 20. Repeat steps 15 19 at least one additional time to ensure proper calibration.

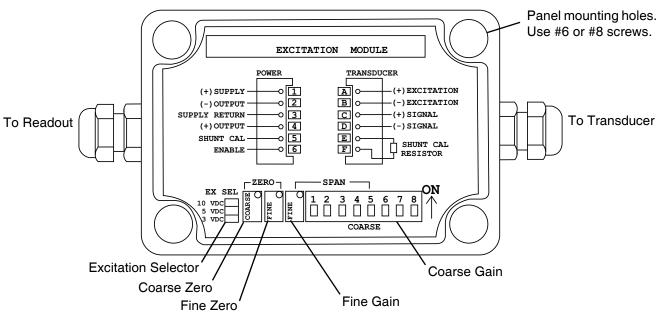


Fig. 62: Amplifier Settings

- 21. Replace the amplifier cover. See **Replace Amplifier**, page 89.
- 22. Reconnect the outlet pressure sensor cable if it was removed.
- 23. If desired, change pressure units to desired setting on Advanced screen 2.

Control Center Assembly



Prepare Control Center for Repair

- 1. Power off the display.
- 2. Disconnect main power to the control center assembly.
- 3. Remove the control center assembly front cover (20).

Replace Gateway Module

- 1. Prepare Control Center for Repair, page 91.
- 2. Remove the automation communications cable (AE).
- 3. Remove the two screws holding the Gateway module (5) to the base (3), and remove the module.

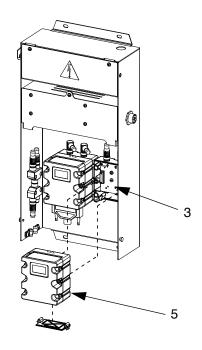


FIG. 63

- Attach a new Gateway module to the base using two screws.
- 5. Reconnect the automation interface cable.
- 6. Upgrade software, page 81, then upgrade fieldbus map, page 82.

Replace Gateway Module Base

- 1. Prepare Control Center for Repair, page 91.
- Remove the Gateway module (5); follow Replace Gateway Module. (Leave automation communications cable (AE) attached to Gateway module.)
- 3. Disconnect the CAN cable (19) and power supply cable (6) from the base (3).
- 4. Remove the four screws (16) and grounding screw (12) from the base and replace it with a new base.

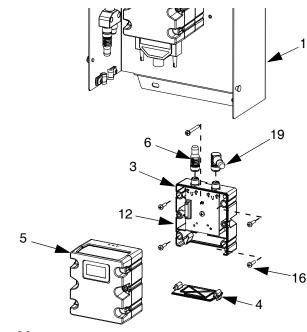


Fig. 64

- 5. Secure the new base to rear cover (1) using the five screws.
- Reattach Gateway module; follow Replace Gateway Module.

Replace Swirl Board 16K570:

- Prepare Control Center for Repair, page 91.
- Remove screw (a) from swirl board cover. Open swirl board cover.
- 3. Remove cable connectors (b) from swirl board.
- Remove the four screws (c) from the swirl board.
 Replace with new board and secure using the four screws (c).
- 5. Insert cable connectors (b) into the new board.
- 6. Reassemble the swirl board cover using screw (a).

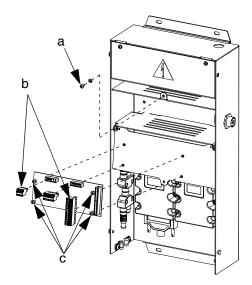


FIG. 65

Replace Advanced Display Module

- 1. Prepare Control Center for Repair, page 91.
- 2. Disconnect the CAN cable (18) from the ADM (2).

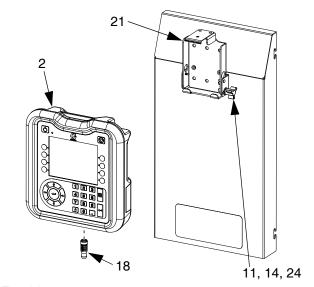


FIG. 66

- 3. Remove the ADM by snapping it out of the mounting bracket.
- 4. On old ADM, remove token access panel then remove key token. Do not discard token.
- 5. Connect the CAN cable to the new ADM.
- 6. Upgrade new ADM software, page 81.
- 7. Insert key token into new ADM. Replace token access panel.
- 8. Install the new ADM by snapping it into the mounting bracket.

Replace Advanced Display Module Bracket

- 1. Prepare Control Center for Repair, page 91.
- 2. Remove the ADM (2); follow **Replace Advanced Display Module**. (Leave the CAN cable attached to the ADM.)
- 3. Remove the speed clips (25) and rivets (26) from the mounting bracket (21).

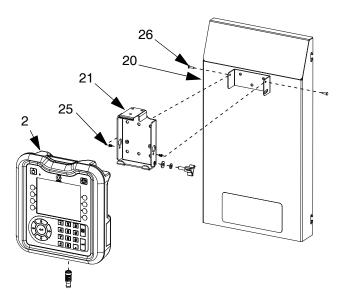


FIG. 67

- 4. Remove the mounting bracket from the front cover (20) and replace with a new bracket.
- 5. Secure the new bracket to the front cover with speed clips and rivets.
- 6. Reinstall the ADM.

Replace DIN Rail Assembly

- 1. Prepare Control Center for Repair, page 91.
- 2. Remove both screws (22) and washers (28) from the line voltage assembly cover (7). Remove the cover.

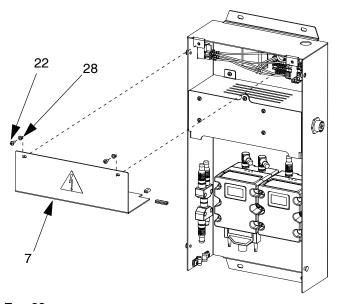


FIG. 68

- 3. Disconnect all wiring from the din rail module and filter.
- 4. Remove the four screws (40) from the din rail and filter.
- 5. Disconnect wires from rocker/rotary switch. Take note of wire positions for easy connection in Step 7.

 Remove the din rail, filter, and rocker switch (snaps into place). Replace with new components. Secure din rail and filter to the rear control center assembly. cover (1) using the four screws (40). Snap rocker/rotary switch into position.

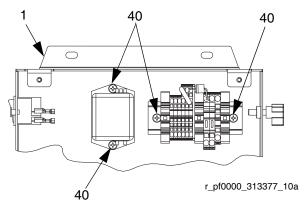


Fig. 69: 24 Vdc Din Rail Assembly

- 7. Reconnect all wiring to the din rail module, filter, and rocker/rotary switch.
- 8. Reassemble the line voltage assembly cover using the screws and washers.

Replace Fuses

Replace fuses on the din rail assembly.

- For 24 Vdc control centers: see Technical Data on page 148 for fuse specifications.
- For 100-240 Vac control centers: Order fuse 115805.

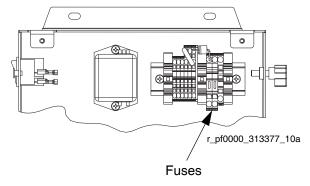


Fig. 70: Fuse Location

Parts

Control Centers

Software Upgrade Tokens

Refer to the **Software Upgrade Tokens** table on page 10.

Control Center Key Token Part Numbers

See **Key Tokens** on page 23 for more information about key tokens.

Part	Description
★16M217	ADM Key Token, Standard PCF

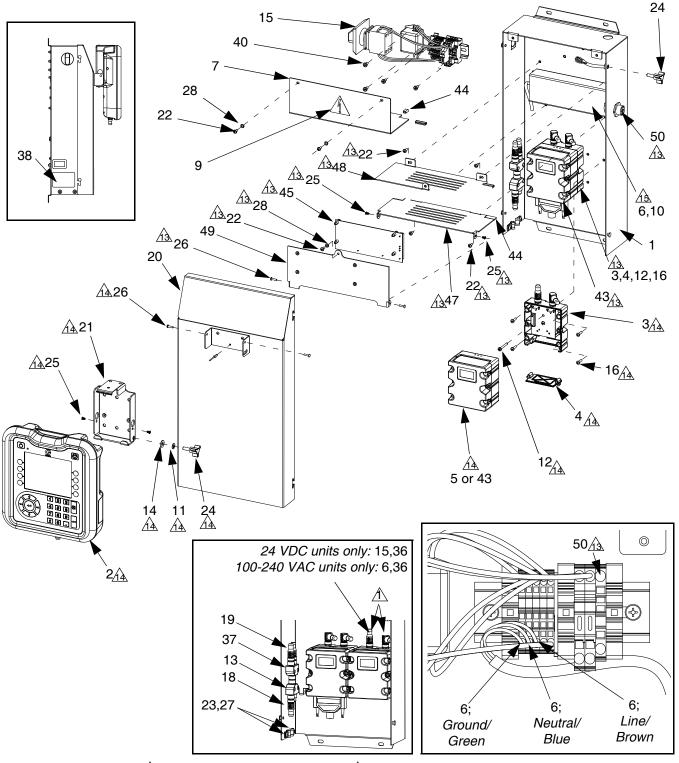
Gateway Module Part Numbers

PCF Model	User Interface Description	Gateway Part Number To Order
PFxx0x	Discrete	★ 24B681
PFxx1x	DeviceNet [™]	★15V759
PFxx2x	Ether- Net/IP [™]	★ 15V760
PFxx3x	PROFI- BUS [™]	★ 15V761
PFxx4x	PROFINET™	★15V762

[❖] Parts included with 24 Vdc Module kit 24B929.

^{*} Fieldbus Gateway modules do not have a PCF-specific map installed. Use map token (16N601) to install map before use.

Control Center and Expansion Swirl Enclosure Parts



Add ferrite (36) to cable. Locate as close to cable connector as possible.

Included in swirl models only (both control centers and expansion swirl enclosures).

Control centers only. Not included in expansion swirl enclosures.

100-240 Vac models only.

Control Center Assembly Parts

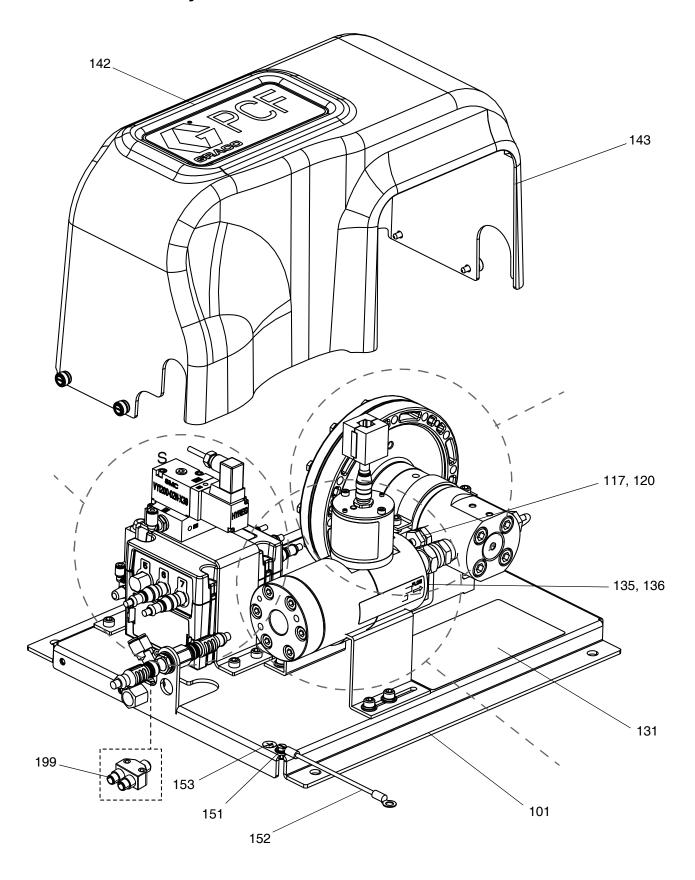
			Qty
Ref.	Part	Description	
1		COVER, rear	1
2₩	24E451	DISPLAY, with USB	1
3◆	289697		1
4◆	277674	ENCLOSURE, cube door	1
5₩		MODULE, Gateway; see table on	1
		page 95 for part number	
6‡		SUPPLY, power	1
7 ‡ �		COVER, line voltage	1
8 ‡ �		GROMMET	1
9▲‡	196548	LABEL, warning, electric shock	1
10‡		SCREW, cap, socket hd; m4 x 6	4
11🌣		WASHER, lock	1
	121820	, , , , , , , , , , , , , , , , , , ,	1
13	121807	· •	1
14 :	110755	WASHER, plain	1
15‡❖		MODULE, line voltage	1
16◆		, , ,	4
18		CABLE, CAN, female / female 1.0m	
19	125789	CABLE, CAN, female / female 0.5m	1
20		COVER, front	1
21		BRACKET, mounting	1
22‡�		SCREW, mach, pan hd	2
23	120143	•	2
24 \$	121253	KNOB, display	2
25		CLIP, speed, tubular	2
26		RIVET, aluminum	1
27	112925		2 2 2 1 2 2 2
28	100020		2
36		SUPPRESSOR, box snap, ferrite	2
37	124654	CONNECTOR, splitter	1

			Qty
Ref.	Part	Description	
38		LABEL	1
40	110637	SCREW, mach, pan hd	4
43₽	24B681	MODULE, DGM	1
44		GUARD, edging	1
45	16K570	BOARD, circuit, swirl	1
46		BRACKET, display pivot	1
47		COVER, swirl, hinge side	1
48		COVER, swirl, latch side	1
49		COVER, swirl, lid	1
50	24K455	CABLE, swirl board, panel mount	1
51	24K458	CABLE, SWIRL-DGM	1
52	121597	CABLE, CAN, 90 female/90 female	1

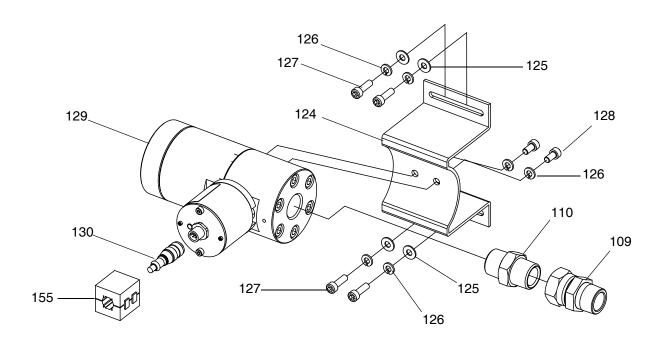
- ▲ Replacement Danger and Warning labels, tags, and cards are available at no cost.
- ‡ Parts included with 100-240 Vac Module kit 24B928.
- ❖ Parts included with 24 Vdc Module kit 24B929.
- ✿ Parts included with Display Mounting Bracket kit 24B930.
- ₱ Base electronic components do not have PCF-specific software installed. Use software upgrade token (16K743) to install software before use.
- * Fieldbus Gateway modules do not have a PCF-specific map installed. Use map token (16N601) to install map before use.

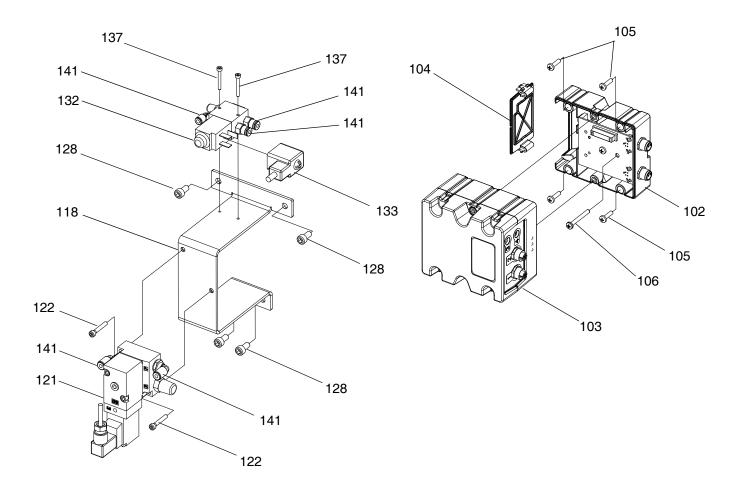
--- Not for sale.

Fluid Plate Assembly Parts

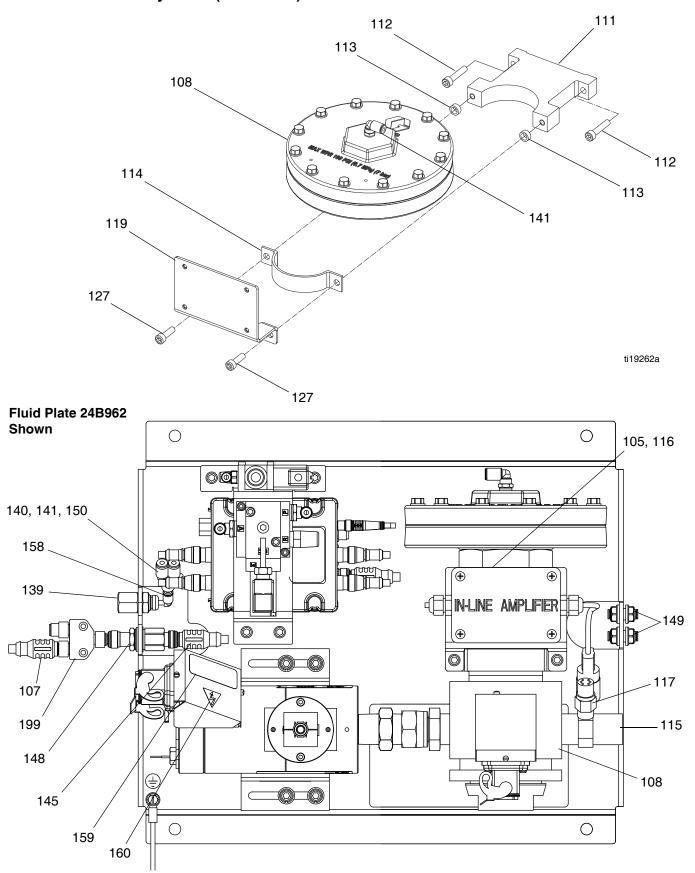


Fluid Plate Assembly Parts (continued)



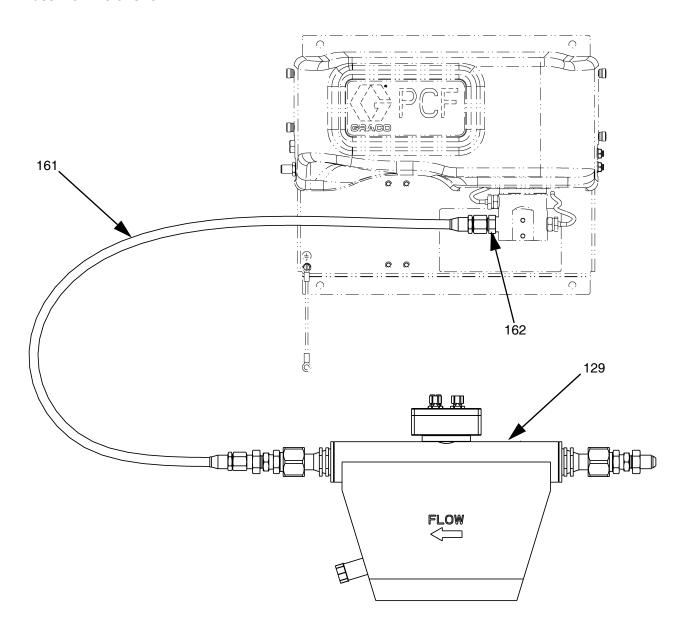


Fluid Plate Assembly Parts (continued)



Fluid Plate Assembly Parts (continued)

Mass Flow Meter Shown



Fluid Plate Assembly Parts					
Ref.	Part	Description	Qty.		
101		PLATE, fluid	1		
102	289697	BASE, cube	1		
103₽	289696	FCM, cube	1		
104	277674	ENCLOSURE, cube door	1		
105✓		SCREW, mach, pan hd			
106	121820	SCREW, machine, pan hd; m4 x	1		
100	121020		'		
407	101000	35			
107	121228	CABLE, CAN, female/female;	1		
		15.0 m			
108✓		REGULATOR, assy			
109✔		UNION, adapter			
110✓		NIPPLE, reducing, hex; 1/2			
		npt(f) x 3/4 npt(f)			
111	198269	BRACKET, flow meter, lower	1		
112	110580	SCREW, cap, socket hd	2		
113✓		SPACER	_		
114	198268	BRACKET, flow meter	1		
115 ×	624545	FITTING, tee; 3/4(m) x 1/4(f)	1		
116#	258530	AMPLIFIER, signal conditioner	1		
117✓			2		
		SENSOR, pressure, fluid outlet	1		
118	 10D010	BRACKET, valve			
119*	16P819	BRACKET, signal conditioner	1		
1201		O-RING			
121	120010	REGULATOR, I/P	1		
122	111119	SCREW, valve	2		
124✓		BRACKET, helical gear meter			
125✓		WASHER, plain			
126✓		WASHER, lock, spring; m6			
127✓		SCREW, cap, socket hd			
128✓		SCREW, cap, socket hd, hex			
129✓		METER, assy			
130✓		CABLE; m12-5p			
131▲	15X756	LABEL, warning, main	1		
132	258334	VALVE, dispense, fluid plate	1		
133	121806	CABLE, solenoid	1		
135▲₩	189285	LABEL, caution, hot surface	1		
136		LABEL	1		
137	117820		2		
139	198179	FITTING, bulkhead, union	1		
140	198175	FITTING, push	1		
141		TUBE, nylon, round, black; 5.5	•		
142		LABEL	1		
143		SHROUD, fluid plate	1		
145	121226	CABLE,CAN, male/female; 0.5	1		
145	121220		'		
146★	234967	m KIT, dual filter	1		
			1		
147√★	101610	TOKEN, key	4		
148	121612	CONNECTOR, thru; m12, m x f	1		
149	121818	BULKHEAD, tube; 5/32	2		
150		TAG, installation	1		
151	114391	SCREW, grounding	1		

Ref.	Part	Description	Qty.
152	194337	WIRE, grounding, door	1
153▲	186620	LABEL, ground	1
155✓		SUPPRESSOR, box snap, fer-	
		rite	
158	122610	ELBOW	1
159▲	290228	LABEL, caution, hot surface	1
160▲	189930	LABEL, caution, electric shock	1
161#		HOSE, 1/2 x 44 ss	1
162#		FITTING, adapter	1
199*	124654	SPLITTER, CAN	1

- ▲ Replacement Danger and Warning labels, tags, and cards are available at no cost.
- ✓ See Parts Varying by Assembly table, page 103, for part number and quantity.
- * Only included with fluid plates that use a heated mastic regulator.
- ₱ Base electronic components do not have PCF-specific software installed. Therefore, use software upgrade token (16K743) to install software before use.
- ★ Not shown.
- --- Not for sale.
- * CAN splitter is not included with the fluid plate assembly included in the PFxxxx assembly. It is included only with the additional fluid plate kits.
- # Only included with fluid plates that use a Coriolis flow meter.

Fluid Plate Key Token Part Numbers

See **Key Tokens** on page 23 for more information about key tokens.

Part	Description
★16M100	FCM Key Token, 2 styles, Flow Meter, ADM required
★16M101	FCM Key Token, 2 styles, No Flow Meter, ADM required
★16M102	FCM Key Token, 16 styles, Flow Meter, ADM not required
★16M103	FCM Key Token, 16 styles, No Flow Meter, ADM not required
★16M104	FCM Key Token, 256 styles, Flow Meter, ADM not required
★16M105	FCM Key Token, 256 styles, No Flow Meter, ADM not required

Parts Varying by Assembly

The following table lists the varying part numbers by fluid plate assembly, and the quantity for each assembly.

	1		Fluid Plate Assemblies						
Ref.	Part	Description	Cartridge Regulator with High Resolution Meter	Cartridge Regulator with No Meter	Mastic Regulator with High Resolution Meter	Mastic Regulator with No Meter	Heated Mastic Regulator with Heated High Resolution Meter	Heated Mastic Regulator with No Meter	Cartridge Regulator with Coriolis Meter
105	195875	SCREW, mach, pan hd	4	4	4	4	8	8	4
108	244734	REGULATOR, assy	1	1					1
	246642				1	1			
	246643						1	1	
109	156684	UNION, adapter	1	1					
	157785				1		1		
110		NIPPLE, reducing,	1						
	C20487	hex; 1/2 npt(f) x 3/4 npt(f)			1		1		
113	C34045	SPACER	2	2					2
117		SENSOR, pressure,	2	2	2	2			2
	117764	fluid outlet					1	1	
120		O-RING	2	2	2	2			2
124		BRACKET, helical gear meter	1		1		1		
125	C19197	WASHER, plain	4		4		4		
126		WASHER, lock, spring; m6	6		6		6		
127	108328	SCREW, cap, socket hd	6	2	6	2	6	2	
128	107530	SCREW, cap, socket hd, hex	6	4	6	4	6	4	
129	246652	METER, assy.	1		1				
	246340						1		
	25D026								1
130		CABLE; m12-5p	1		1		1		1
147★		TOKEN, key, 2 styles, meter enabled	1		1		1		1
	16M101	TOKEN, key, 2 styles, meter disabled		1		1		1	
	16M102	TOKEN, key, 16 styles, meter enabled	1		1		1		1
	16M103	TOKEN, key, 16 styles, meter disabled		1		1		1	
	16M104	TOKEN, key, 256 styles, meter enabled	1		1		1		1
	16M105	TOKEN, key, 256 styles, meter disabled		1		1		1	
155	121901	SUPPRESSOR, box snap, ferrite	1		1		1		1

⁻⁻⁻ Not for sale.

Appendix A - Advanced Display Module (ADM)

A PCF can operate without an ADM if it is fully integrated and all signals come from the automation controller.

Display Overview

The ADM display is divided into two main functions: Setup Mode and Run Mode.

Setup Mode Functions

The setup mode functions enable users to:

- configure installed system components
- set units, adjust values, set formats, and view software information for each component
- set or change information regarding the Gateway module
- view information regarding the particular Gateway module used
- · set controls and valve commands
- set on and off delays for valves and the regulator
- set k-factor, pressure, and flow rate variables
- set offsets for inlet and outlet pressures
- set error types
- set variables for maintenance advisories
- set up to 256 styles for models with a CGM and set up to 16 styles for models with a DGM

Run Mode Functions

The run mode functions enable users to:

- · adjust the bead scale
- perform manual dispensing
- view a chronological list of system errors
- view a chronological list of jobs stored/performed in the system
- use a preventative maintenance schedule for the supply system, displacement pump, and air motor

Display Details

Power Up Screen

The following screen appears when the ADM is powered up. It remains on while the ADM runs through initialization and establishes communication with other modules in the system.



Menu Bar

The menu bar appears at the top of each screen.



Date and Time

The date and time are always displayed in one of the following formats. The time is always displayed as a 24-hour clock.

- DD/MM/YY HH:MM
- MM/DD/YY HH:MM
- YY/MM/DD HH:MM

Arrows

The left and right arrows indicate screen navigation.

Screen Menu

The screen menu indicates the currently active screen, which is highlighted. It also indicates the associated screens that are available by scrolling left and right.

System Mode

There are five modes: Active, Job in Cycle, Display Control, Swirl Setup, and System Off. The current system mode is displayed at the left of the menu bar.

Alarm/Deviation

If there is an active system error, one of the following icons is displayed in the middle of the menu bar. There are four possibilities:

Icon	Function	Description		
No Icon	No information or no error has occurred			
Δ	Advisory	Informational		
Φ	Deviation	Important but will not shut down the affected fluid plate		
A	Alarm	Very important and will immedi- ately shut down the affected fluid plate		

Status

The current system status is displayed at the right of the menu bar.

Soft Keys

Icons next to the soft keys indicate which mode or action is associated with each soft key. Soft keys that do not have an icon next to them are not active in the current screen.

NOTICE

To prevent damage to the soft key buttons, do not press the buttons with sharp objects such as pens, plastic cards, or fingernails.

Jump In/Jump Out

In screens that have editable fields, press to access the fields and make changes. When changes are complete press again to exit edit mode.

Navigation within Screens

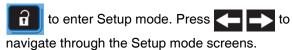
Press to open drop-down menus on Setup screens. Also, press to enter changes or make a selection.

Press to navigate to new screens and to navigate left and right within a screen.

Press to navigate to new screens and to navigate up and down within a screen. Also press to move between fields within a drop-down menu, and to increment or decrement numbers within a field.

Setup Mode

Setup mode screens are divided into five sections: System setup, Advanced setup, Gateway setup, Fluid Plate setup, and Swirl setup. While in Run mode, press



If the setup screens are password protected, a password entry screen will appear after pressing [7]. The password is defined in the Advanced setup screen. If the password is set to 0000, the password is disabled.

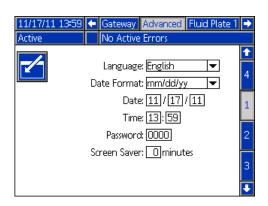
Advanced Setup Screens

There are four Advanced setup screens, which enable users to set units, adjust values, set formats, define USB settings, and view software information for each component. Press to scroll through the Advanced setup screens. Once in the desired Advanced setup screen, press to access the fields to make changes. Press to exit edit mode.

NOTE: Users must be out of edit mode to scroll through the Advanced setup screens.

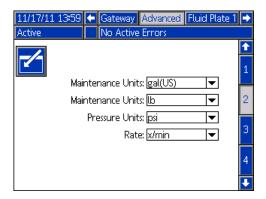
Advanced Setup Screen 1

This screen enables users to set the language, date format, current date and time, password, and number of minutes before the screen saver comes on. The time does not automatically update for daylight savings time.



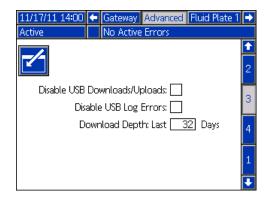
Advanced Setup Screen 2

This screen enables users to set the units of measure for maintenance volume, maintenance mass, pressure, and flow rate.



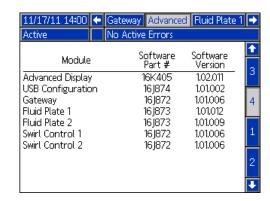
Advanced Setup Screen 3

This screen enables users to setup USB-related settings. The Disable USB Log Errors option disables recording events when the logs are at least 90% full.



Advanced Setup Screen 4

This screen displays the software part number and version for the ADM, USB configuration, Gateway module, and fluid plates.



Automation Gateway Setup Screens

There are up to three automation Gateway Setup screens (depending on fieldbus), which enable users to set or change information regarding the automation Gateway module used on the PCF system. These screens also enable users to view information regarding the particular automation Gateway module used.

Press to scroll through the Gateway Setup screens. Once in the desired Advanced Setup screen, press to access the fields to make changes. Press to exit edit mode.

NOTE: Users must be out of edit mode to scroll through the Gateway Setup screens.

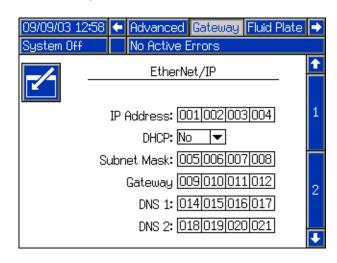
Gateway Setup Screen 1 - DeviceNet

This screen enables users to set the device address and the baud rate. The DeviceNet screen displays the hardware revision number, system serial number, map ID, name, revision number, and install date.



Gateway Setup Screen 1 - EtherNet/IP

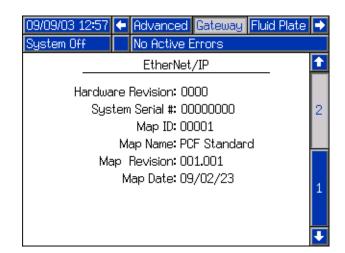
This screen enables users to set the IP address, subnet mask, Gateway, DNS 1, DNS 2, and if a DHCP is used.



Gateway Setup Screen 2 - EtherNet/IP

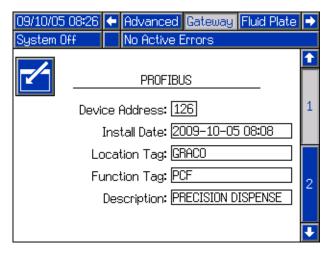
This screen is the same for EtherNet/IP and PROFIBUS. It enables users to view the following information regarding the Gateway module used on the PCF system:

- hardware revision number
- system serial number
- map ID number
- map name
- map revision number
- · date the map was created



Gateway Setup Screen 1 - PROFIBUS

This screen enables users to set the device address, install date, location tag, function tag, and system description.

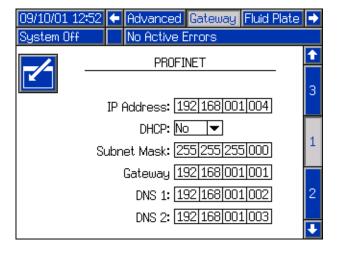


Gateway Setup Screen 2 - PROFIBUS

This screen is the same for EtherNet/IP and PROFIBUS. See **Gateway Setup Screen 2 - EtherNet/IP**, page 107, for details.

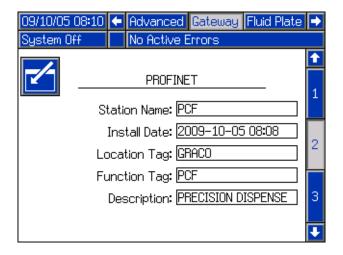
Gateway Setup Screen 1 - PROFINET

This screen enables users to set the IP address, subnet mask, Gateway, DNS 1, DNS 2, and if a DHCP is used.



Gateway Setup Screen 2 - PROFINET

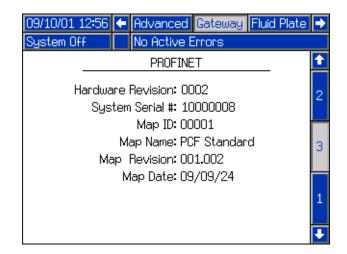
This screen enables users to set the device address, install date, location tag, function tag, and system description.



Gateway Setup Screen 3 - PROFINET

This screen enables users to view the following information regarding the Gateway module used on the PCF system:

- hardware revision number
- system serial number
- map ID number
- map name
- map revision number
- date the map was created



Discrete Gateway (Automation) Setup Screen

NOTE: The Discrete Gateway Setup <u>screen</u> is not available if an automation Discrete Gateway Module (DGM) is not attached to the system.

NOTE: If Swirl Dispensers are installed, a Swirl Discrete Gateway Module will be installed. This section is not related to that module. See **Control Center Assembly Overview** on page 19 for gateway identification.

NOTE: The system cannot be integrated or run without an ADM with a Discrete Gateway Module.

This screen enables users to set Active Errors to High (default) or Low. If High is selected, alarm and error signals are low during normal operation and high if an alarm or error exists. If Low is selected, alarm and error signals are high under normal operation and low if an alarm or error exists.

This screen also enables users to select the Command Value Type signal (Analog or Digital) the automation system will provide to PCF. If Analog control is selected, the user must provide an analog voltage to the proper input on the DGM. See **Appendix B - Discrete Gateway Module (DGM) Connection Details**, page 121, for connection details.

If Digital control is selected and one fluid plate is installed, the user can define three digital settings for each dispense valve. If Digital control is selected and two fluid plates are installed, the user can define two digital settings for each dispense valve. The user must provide two digital signals to the proper inputs on the DGM. See Appendix B - Discrete Gateway Module (DGM) Connection Details, page 121, and the Digital Command Logic Table for connection details.

NOTE: The control mode for each dispense valve is set in the Fluid Plate x, Screen 2 (Mode Settings), page 111. For example, if Valve 1 is set to Pressure mode on the Fluid Plate x, Screen 2 (Mode Settings), then the digital commands for Valve 1 are pressure values.

The Digital Command Logic Table indicates which value each input must be set to in order to select a particular setting.

Digital Command Logic Table (Single Fluid Plate Systems)

Digital Command Input 1	Digital Command Input 2	Resulting Digital Command Selection
Low	Low	Setting #1
High	Low	Setting #2
	High	Setting #3

Digital Command Logic Table (2-Fluid Plate Systems)

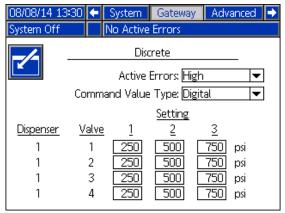
Digital Command Input 1	Digital Command Input 2	Resulting Digital Command Selection
Low		Fluid Plate 1, Setting #1
High		Fluid Plate 1, Setting #2
	Low	Fluid Plate 2, Setting #1
	High	Fluid Plate 2, Setting #2

Press to access the fields to make changes. Press

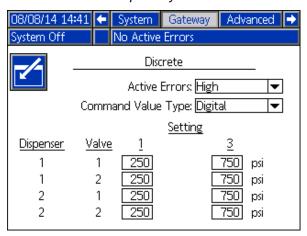


to exit edit mode.

Single fluid plate system



2-fluid plate system



Fluid Plate Setup Screens

There are nine fluid plate setup screens, which enable users to:

- Set controls and valve commands
- Set on and off delays for valves and the regulator
- Set k-factor, pressure, and flow rate variables
- Set offsets for inlet and outlet pressures
- Set error types
- Set variables for maintenance advisories
- Define styles
- Associate swirl dispenser with fluid plate

Press 1 to scroll through the fluid plate setup

screens. Once in the desired screen, press



access the fields to make changes. Press edit mode.



NOTE: Users must be out of edit mode to scroll through the fluid plate setup screens.

Fluid Plate x, Screen 1 (Control Settings)

This screen enables users to:

- Set the dispense trigger source to Gateway, Command Cable, Command Cable 3x, or Combined. If it is set to Command Cable, users can enable the valves.
- Set the command value source to Gateway, Command Cable, or Display.
- Set the Job End Timer to Timer or Gateway. If this field is set to Timer, users can set Job End Delay.
- Set the Display Control Password to Enable or Disable. When entering maintenance mode, a password prompt will appear if the Display Control Password is set to Enable and a password is set in the Advanced setup screens.
- Set the Run Mode Bead Adjust to Enable or Disable.

NOTE: Run mode bead adjust allows a user to quickly adjust flow rate or pressure from the run screen.



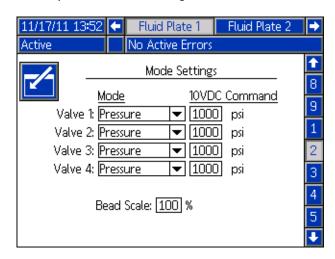
Fluid Plate x, Screen 2 (Mode Settings)

This screen enables users to set valve commands. Use this screen to select a mode (pressure, bead, shot, or full open) for each valve. Users can also set the flow rate or pressure for each valve, and adjust the bead scale.

NOTE: The ability to dispense from multiple valves simultaneously is only allowed in either of the following scenarios.

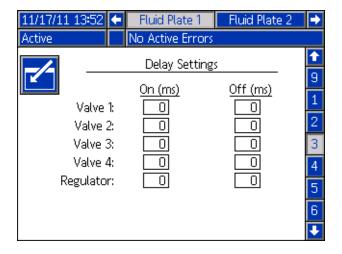
- Each valve is set to Pressure mode and has identical command values.
- Each valve is set to Full Open mode.

Attempting to dispense from multiple valves simultaneously using any other combination will cause an Incompatible Valves Settings alarm.



Fluid Plate x, Screen 3 (Delay Settings)

This screen enables users to set on and off delays (in milliseconds) for each valve and the regulator. For an explanation of the on and off delays, refer to the **On/Off Delays** section on page 43.

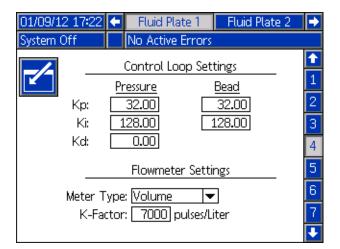


Fluid Plate x, Screen 4 (Control Loop and Flowmeter Settings)

This screen enables users to set the meter type (volume or mass) and the K-Factor for the flowmeter. Users can also set the Kp, Ki, and Kd for the pressure control loop as well as Kp and Ki for bead control loop.

NOTE: In systems without a flow meter, the flow meter settings will be grayed out.

NOTE: It is recommended that these values not be changed from the factory defaults of 32.00 for Kp, 128.00 for Ki, and 0.00 for Kd.

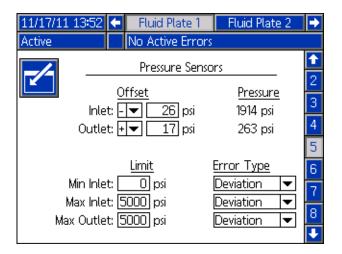


Fluid Plate x, Screen 5 (Pressure Sensors)

NOTE: Inlet sensor settings will be grayed out on this screen for systems with heated fluid plates.

This screen enables users to:

- Set the offset for the inlet and outlet pressures.
 NOTE: The offset value must be set to a non-zero value before '-' can be selected from the +/-drop-down menu.
- Set the minimum and maximum pressure limits for the inlet, and the maximum pressure limit for the outlet
- Set the error type (alarm or deviation) that will be issued if the inlet and/or outlet pressure go outside of the set limits.

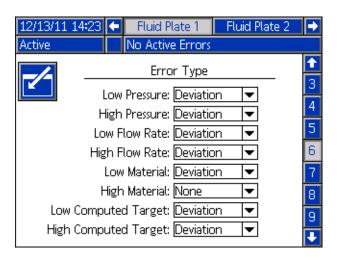


Fluid Plate x, Screen 6 (Error Type)

This screen enables users to set the error type (none, alarm, or deviation) that will be issued if the pressure, flow rate, volume, or computed target goes outside the tolerance settings of the active style. See **Configure Errors** on page 40.

NOTE: Only the low/high pressure errors will be enabled for systems without a flow meter.

- The pressure and flow rate errors are relative to the value commanded (through the command cable, gateway or display)
- The volume is relative to the requested volume and computed target errors are relative to the target volume defined in the style

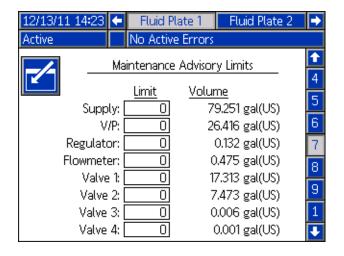


Fluid Plate x, Screen 7 (Maintenance Advisory Limits)

This screen enables users to set volume (or hours) limit that will trigger a maintenance advisory for the air supply, voltage to pressure (V/P) transducer, fluid regulator, flow meter, and all four valves.

NOTE: Hours is shown instead of Volume for fluid plates without a flow meter.

The Volume (or Hours) column displays the current totalizer value. If this value exceeds the set limit, the value will turn red and a maintenance advisory is issued. See **Fluid Plate x**, **Screen 3 (Maintenance Totalizers)**, page 119, for more information about maintenance totalizers.

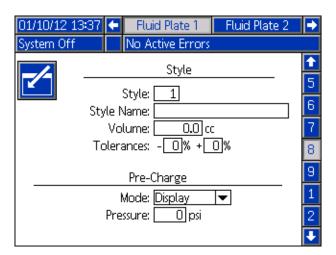


Fluid Plate x, Screen 8 (Style)

This screen enables users to set up to 256 styles, depending on system configuration. Press to access the style setup fields. Enter the style number in the Style field, the target volume in the Volume field, and the tolerance percentage in the Tolerance field.

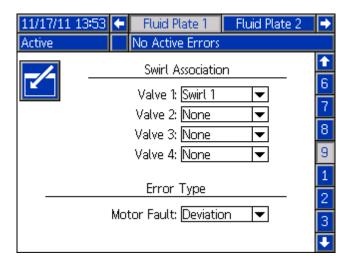
NOTE: The number of possible styles is dependent on the model type.

To enter the style name, press while in the Style Name field. See **Keyboard Screen**, page 114, for instructions on using the keyboard screen to enter the style name.



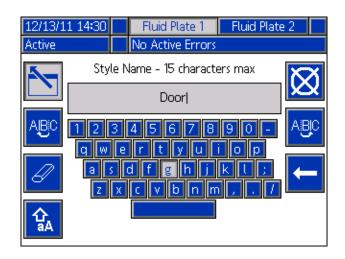
Fluid Plate x, Screen 9 (Swirl Association)

This screen enables users to set the swirl to fluid plate association. This allows the system to apply errors to the correct fluid plate when a swirl error occurs, and to stop the correct fluid plate from dispensing when certain swirl errors occur.



Keyboard Screen

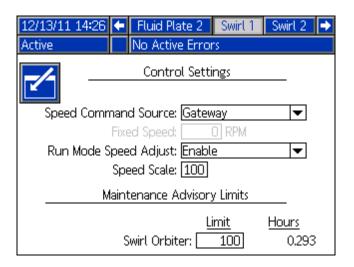
The keyboard screen appears when text is edited. Use all four arrow buttons to select each letter; press to enter the letter. To back space, press . To delete the entire style name entered, press . To enter the style name, press . To cancel the entry and exit the keyboard screen, press .



Swirl Setup Screen

This screen enables users to:

- Set the Speed Command Source to Display or Gateway. If it is set to Display, users can set the fixed speed
- Set the Run Mode Speed Adjust to Enable or Disable
- Set the speed scale from 50-150%
- Set the Swirl Orbiter Maintenance Advisory Limit



Run Mode

Run mode screens are divided into six sections: home, fluid plates, swirls, events, errors, and jobs. While in

Setup mode press



to enter Run mode. Press





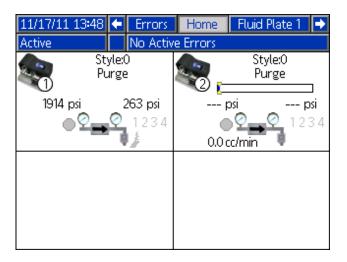
to navigate through the Run mode screens.

Fluid Plate Home Screen

NOTE: This screen only appears if more than one fluid plate is installed.

The Fluid Plate Home screen shows an overview for each of the individual fluid plates. The screen displays the following items:

- Open dispense valves
- Active style number and name
- Flow rate
- Inlet and outlet pressures
- Progress bar indicating actual amount dispensed (blue shaded portion), requested volume (upper and lower arrows) and target volume (end of white bar).

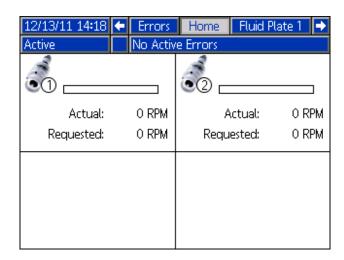


Swirl Home Screen

NOTE: This screen only appears if more than one Swirl Dispenser is installed.

To access the Swirl Home screen, press the down arrow key from the Fluid Plate Home screen. The Swirl Home screen shows an overview for each of the individual Swirl Dispensers. The screen displays the following items:

- Requested motor speed
- Actual motor speed
- Progress bar indicating requested and actual motor speed



Fluid Plate x, Screen 1

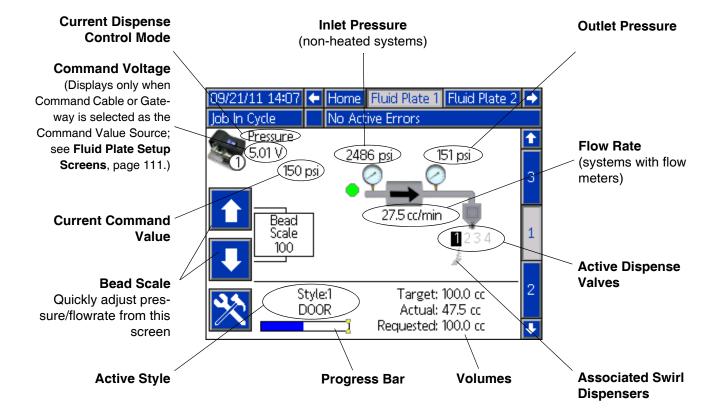
This screen displays the current dispense control mode used, the current pressure, and the current style being dispensed. It also displays the target dispense volume, the actual dispense volume, and the requested dispense volume.

From this screen users can adjust the bead scale and enter maintenance mode. Press and to change the bead scale. Press to enter maintenance mode.

The PCF system has two operating modes:

- Dispense mode enables the module to begin dispensing when it receives a command from the automation unit.
- Maintenance mode enables the module to begin dispensing when the user presses the manual dispense button. Dispense parameters and duration depend on the selected control.

Dispensing continues for as long as the manual dispense button is pressed.

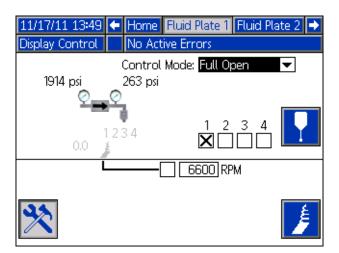


Maintenance Mode

Press from Fluid Plate x, screen 1 (Control Center) to enter maintenance mode. Maintenance mode enables users to change the control mode, volume to be dispensed, target pressure, and number of dispense valves used in the system.

NOTE: Volume, pressure, and dispense valve options change according to mode.

See **Maintenance Mode Operation**, page 45, for instructions on changing the control mode, target pressure, and number of dispense valves used.



Dispense Control Modes

The PCF system has four fluid dispensing control modes.

- Bead Control the system controls the flow rate of the material being dispensed. The regulator outlet pressure is varied to control the fluid flow rate to the requested value. Use the bead control when a consistent bead size is required.
- Shot Control the regulator outlet pressure is controlled to the requested value. The dispense valve is closed when the target volume is reached or when the automation controller provides a signal.
- **Pressure Control** the regulator outlet pressure is controlled to the requested value.
- Full Open Control the PCF system does not control fluid pressure or flow. Instead the regulator opens to allow for recirculation applications.

Fluid Plate x, Screen 2 (Control Center)

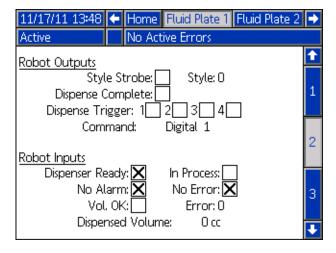
NOTE: Users must be out of maintenance mode in Fluid Plate x, screen 1 in order to scroll to this screen.

NOTE: The term "Robot" on this screen refers to the automation controller.

This screen enables users to view and monitor the current status of the "robot" outputs and inputs. An X is displayed in the applicable check box when:

- Using a style strobe
- The dispense is complete
- A dispense trigger occurs
- The dispenser (fluid plate) is ready
- The dispense is in process
- There are no alarms or errors
- The dispense volume is correct

This screen also displays the current dispense style, command voltage, Gateway error number/code, and the volume dispensed.



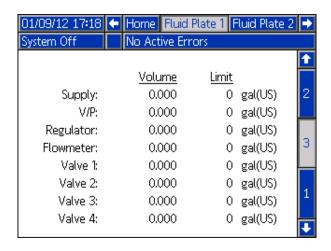
Fluid Plate x, Screen 3 (Maintenance Totalizers)

This screen enables users to view the maintenance totalizers for each system component and the limits set that will trigger a maintenance advisory.

Maintenance totalizers keep track of the total volume (or hours) that each system component has been running. If the totalizer value exceeds the set limit, the totalizer value will turn red and a maintenance advisory is issued.

The limits are set in the Fluid Plate x, Screen 7 (Maintenance Advisory Limits), page 113, for the air supply, voltage to pressure (V/P) transducer, fluid regulator, flow meter, and all four valves.

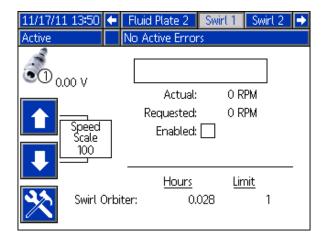
NOTE: If a flow meter is not included in the system, this screen shows hours instead of volume and the flow meter entry is grayed out.



Swirl X Screen

There is one Swirl X screen for each installed swirl dispenser. This screen displays the following items:

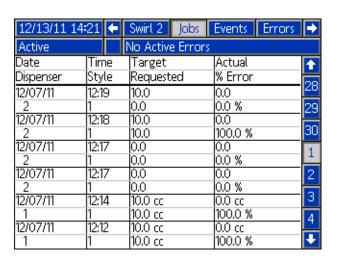
- Swirl Enable signal from the automation interface
- Speed command voltage from automation interface
- Actual and requested speed
- Active time and maintenance advisory limit



Job Report Screens

The job report screens store and display a chronological list of 180 jobs performed by the system. Each job record includes the date and time the job was completed; the style dispensed; the error percentage; and the target, requested, and actual dispense volumes.

Press 1 to scroll through each job report screen.



Event Report Screens

The event report screens display a chronological list of system events. These screens display the last 200 events. Each event report screen displays the date, time, event code, and description for each event.

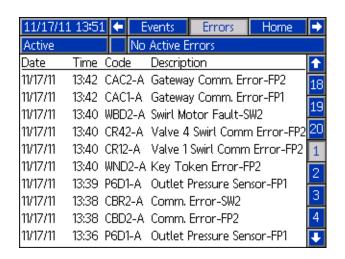
Press to scroll through each event report screen.

11/17/1:	1 13:5:	1 🗕]	obs	Events	Errors	Home	
Active		No.	o Act	ive Error:	S		
Date	Time	Code	Des	cription			1
11/17/11	13:51	EBD2-R	: Mai	nt. Mode	Exited-SV	V2	18
11/17/11	13:51	EAD2-F	R Mai	nt. Mode	Entered-	SW2	10
11/17/11	13:50	EBD1-R	Mai	nt. Mode	Exited-SV	V1	19
11/17/11	13:50	EAD1-R	Mai	nt. Mode	Entered-	SW1	20
11/17/11	13:50	EBC2-R	. Mai	nt. Mode	Exited-FP	2	1
11/17/11	13:50	EAC2-R	: Mai	nt. Mode	Entered-	FP2	2
11/17/11	13:49	EBD1-R	Mai	nt. Mode	Exited-SV	V1	
11/17/11	13:49	EBC1-R	Mai	nt. Mode	Exited-FP	1י	3
11/17/11	13:49	EAD1-R	Mai	nt. Mode	Entered-	SW1	4
11/17/11	13:49	EAC1-R	Mai	nt. Mode	Entered-	FP1	T.

Error Report Screens

The error report screens display a chronological list of system errors. These screens display the last 200 errors. Each error report screen displays the date, time, error code, and description for each error. See **Errors**, page 70, for more information on errors, a list of error codes, and information on error troubleshooting.

Press to scroll through each error report screen.



Appendix B - Discrete Gateway Module (DGM) Connection Details D-Sub Cable 123793

The D-sub cable 123793 is only compatible with single fluid plate systems. Systems with 2 fluid plates must use cable 123792 and breakout board 123783.

The cable length of interface cable assembly 123793 is 50 ft (15.2 m). The following table identifies the cable interface signals.

NOTE: See Appendix D - I/O Signal Descriptions, page 146, for I/O signal descriptions.

Wire Color		Description	Pin Type	D-Sub Pin No.
Green/Yellow	<u> </u>	Isolated Logic Power Supply	Supply	51 and 27
Gray		Isolated Logic GND	Supply	70
Blue/Green		Dispense Ready	Digital Output	9
Brown/Green	<u> </u>	Dispense Error*	Digital Output	11
Blue/Orange		Dispense In Process	Digital Output	12
White		Dispense Purge	Digital Output	15
Blue	<u> </u>	Dispense Remote Start	Digital Output	16
White/Yellow		Style Bit 1	Digital Input	52
Blue/Yellow	<u> </u>	Style Bit 2	Digital Input	53
Brown/Yellow	<u> </u>	Style Bit 3	Digital Input	54
Black/Red		Style Bit 4	Digital Input	55
White/Red	<u> </u>	Style Strobe	Digital Input	56
Blue/Red	<u> </u>	Dispense Complete	Digital Input	57
Brown/Red	<u> </u>	Error Reset	Digital Input	58
Black		Remote Start/Purge	Digital Input	59
Black/Gray	<u> </u>	Dispense Valve 1	Digital Input	73
Brown/Orange		Dispense Valve 2	Digital Input	74
Brown		Command Value	Analog Input	1
Black/Yellow		Analog GND	Analog Input	2
White/Gray				3
Blue/Gray		Swirl 1 Speed Command ◆	Analog Input	21
Brown/Gray		Swirl 2 Speed Command ◆	Analog Input	23
White/Orange		Dispense Valve 3/ Swirl 1 Enable◆	Digital Input	75
Black/Orange		Dispense Valve 4/ Swirl 2 Enable◆	Digital Input	76
Black/Green	<u> </u>	Digital CMD 1	Digital Input	77
White/Green		Digital CMD 2	Digital Input	78
Orange	<u> </u>			N/C

[◆] Swirl-related inputs apply only to systems with Swirl Dispensers.

^{*} Dispense Error may be active high or low, depending on the setting on the Gateway setup screen. See **Discrete Gateway (Automation) Setup Screen**, page 109.

D-Sub Cable 123792 and Breakout Board 123783

The cable length of the interface cable assembly 123792 is 50 ft (15.2 m). The following table identifies the pin assignments for the 78-pin breakout board.

NOTE: See Appendix D - I/O Signal Descriptions on page 146.

D-Sub Pin No.	Description	Pin Type	Voltage (Vdc)
1	Command Value (Fluid Plate 1)	Analog In	0 - 10
2	Command Value Ground (Fluid Plate 1)	Analog In Ground	0
3	Command Value (Fluid Plate 2)	Analog In	0 - 10
4	Command Value Ground (Fluid Plate 2)	Analog In Ground	0
5			
6			
7			
8			
9	◆ Dispense Ready	Digital Out - Bank 1	0 - voltage connected to Pin 27
10	◆† Dispense Alarm/Error on Data	Digital Out - Bank 1	0 - voltage connected to Pin 27
11	◆† Dispense Error	Digital Out - Bank 1	0 - voltage connected to Pin 27
12	◆ Dispense In Process	Digital Out - Bank 1	0 - voltage connected to Pin 27
13	◆ Dispense Volume OK	Digital Out - Bank 1	0 - voltage connected to Pin 27
14	Fluid Plate Selected	Fluid Plate Selected	Fluid Plate Selected
15	◆ Dispense Purge	Digital Out - Bank 1	0 - voltage connected to Pin 27
16	◆ Dispense Remote Start	Digital Out - Bank 1	0 - voltage connected to Pin 27
17	◆ * Data 1	Digital Out - Bank 2	0 - voltage connected to Pin 68
18	◆ * Data 2	Digital Out - Bank 2	0 - voltage connected to Pin 68
19	◆ * Data 4	Digital Out - Bank 2	0 - voltage connected to Pin 68
20	◆ * Data 8	Digital Out - Bank 2	0 - voltage connected to Pin 68
21	Swirl 1 Speed Command	Analog In	0 - 10
22	Swirl 1 Speed Command Ground	Analog In Ground	0
23	Swirl 2 Speed Command	Analog In	0 - 10
24	Swirl 2 Speed Command Ground	Analog In Ground	0
25	Owin 2 Opeca Commana around	Analog in Ground	
26			
27	Digital Out Supply - Bank 1	Isolated Logic Supply V+	10-30
28	◆ * Data 16	Digital Out - Bank 2	0 - voltage connected to Pin 68
29	◆ * Data 32	Digital Out - Bank 2	0 - voltage connected to Pin 68
30	◆ * Data 64	Digital Out - Bank 2	0 - voltage connected to Pin 68
31	◆ * Data 128	Digital Out - Bank 2	0 - voltage connected to Pin 68
32	◆ * Data 256	Digital Out - Bank 3	0 - voltage connected to Pin 69
33	◆ * Data 512	Digital Out - Bank 3	0 - voltage connected to Pin 69
34	◆ * Data 1024	Digital Out - Bank 3	0 - voltage connected to Pin 69
35	◆ * Data 1024	Digital Out - Bank 3	0 - voltage connected to Pin 69
36	◆ * Data 4096	Digital Out - Bank 3	0 - voltage connected to Pin 69
		•	
37	◆ * Data 8192	Digital Out - Bank 3 Digital Out - Bank 3	0 - voltage connected to Pin 69 0 - voltage connected to Pin 69
38	◆ * Data 16384		
39	◆ * Data 32768	Digital Out - Bank 3	0 - voltage connected to Pin 69
40	Swirl 1 Actual Speed	Analog Out	0 - 10
41	Swirl 1 Actual Speed Ground	Analog Out Ground	0
42	Swirl 2 Actual Speed	Analog Out	0 - 10
43	Swirl 2 Actual Speed Ground	Analog Out Ground	0
44 - 50	Lisalete di La via Davus Conti	Hadatad Lasi C. L.Y.	10.00
51	Isolated Logic Power Supply	Isolated Logic Supply V+	10-30
52	Style Bit 1	Digital In	0-30
53	Style Bit 2	Digital In	0-30
54	Style Bit 3	Digital In	0-30
55	Style Bit 4	Digital In	0-30

D-Sub			
Pin No.	Description	Pin Type	Voltage (Vdc)
56	Style Strobe Fluid Plate 1	Digital In	0-30
57	◆ Dispense Complete	Digital In	0-30
58	◆ Error Reset	Digital In	0-30
59	◆ Remote Start/Purge	Digital In	0-30
60 -67			
68	Digital Out Supply - Bank 2	Isolated Logic Supply V+	10-30
69	Digital Out Supply - Bank 3	Isolated Logic Supply V+	10-30
70	Isolated Logic GND	Isolated Ground	0
71	Style Strobe Fluid Plate 2	Digital In	0-30
72	◆ Fluid Plate Selector	Digital In	0-30
73	1 installed fluid plate, no swirl:	Digital In	0-30
	Fluid Plate 1, Dispense Valve 1		
	2 installed fluid plates, no swirl:		
	Fluid Plate 1, Dispense Valve 1		
	1 installed fluid plate, one or more swirl:		
	Fluid Plate 1, Dispense Valve 1		
	2 installed fluid plates, one or more swirl:		
	Fluid Plate 1, Dispense Valve 1		
74	1 installed fluid plate, no swirl:	Digital In	0-30
	Fluid Plate 1, Dispense Valve 2		
	2 installed fluid plates, no swirl:		
	Fluid Plate 1, Dispense Valve 2		
	1 installed fluid plate, one or more swirl:		
	Fluid Plate 1, Dispense Valve 2		
	2 installed fluid plates, one or more swirl:		
	Fluid Plate 2, Dispense Valve 1		
75	1 installed fluid plate, no swirl:	Digital In	0-30
	Fluid Plate 1, Dispense Valve 3		
	2 installed fluid plates, no swirl:		
	Fluid Plate 2, Dispense Valve 1		
	1 installed fluid plate, one or more swirl:		
	Swirl 1 Enable		
	2 installed fluid plates, one or more swirl:		
	Swirl 1 Enable		
76	1 installed fluid plate, no swirl:	Digital In	0-30
	Fluid Plate 1, Dispense Valve 4		
	2 installed fluid plates, no swirl:		
	Fluid Plate 2, Dispense Valve 2		
	1 installed fluid plate, one or more swirl:		
	Swirl 2 Enable		
	2 installed fluid plates, one or more swirl:		
	Swirl 2 Enable		
77	Digital CMD 1	Digital In	0-30
78	Digital CMD 2	Digital In	0-30
. •		g	1

^{* 16-}bit data outputs contain either volume or error information depending on state of dispense alarm/error on data.

Pin 72 = 1: Inputs and outputs apply to fluid plate 2.

[◆] Fluid plate selector input (pin 72) toggles the plate to which these inputs and outputs will apply: Pin 72 = 0: Inputs and outputs apply to fluid plate 1.

[†] Alarm and Error signals may be active high or low, depending on the setting on the Gateway setup screen. See **Discrete Gateway (Automation) Setup Screen**, page 109.

Pin References

NOTE: To avoid ground loops and noise immunity issues, do not ground the shield of the D-subminiature connector cable; it is already grounded through the mounting screw on the base of the DGM.

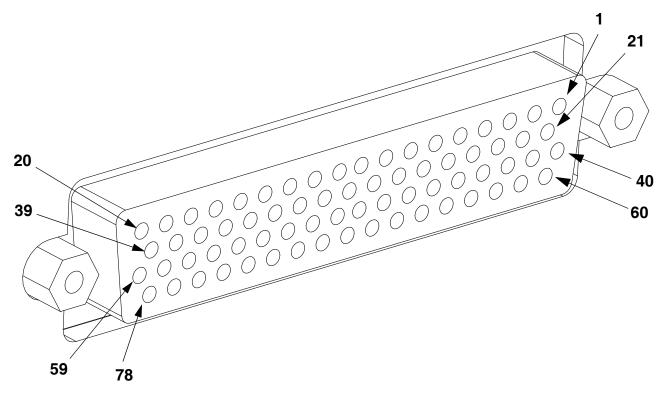


Fig. 71: D-Subminiature Connector - Pin References

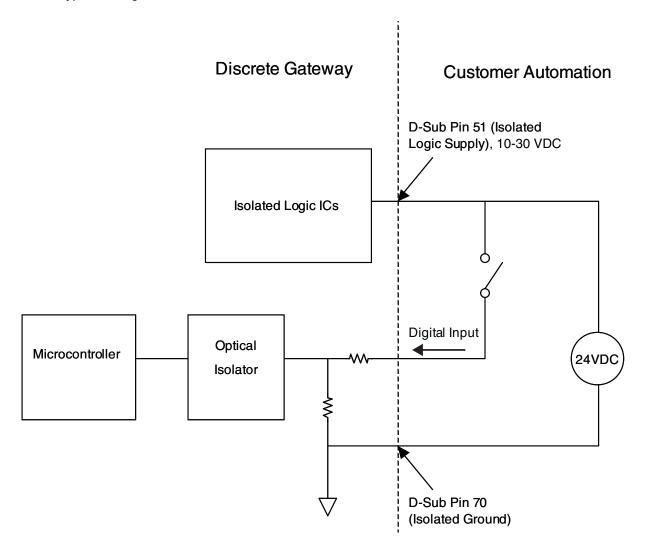
DGM Digital Input

The digital inputs function only when power is supplied to pin 51 and there is a ground connection to pin 70. See **Pin References**, page 124, for details. The digital input is rated at 0-30 Vdc, and requires an NEC Class 2 power supply connected to pin 51. The DGM provides optical isolation as shown in the following illustration.

• Pins: 52 – 59, 71-78

Type: Sinking

Maximum current draw: 3.6 mA

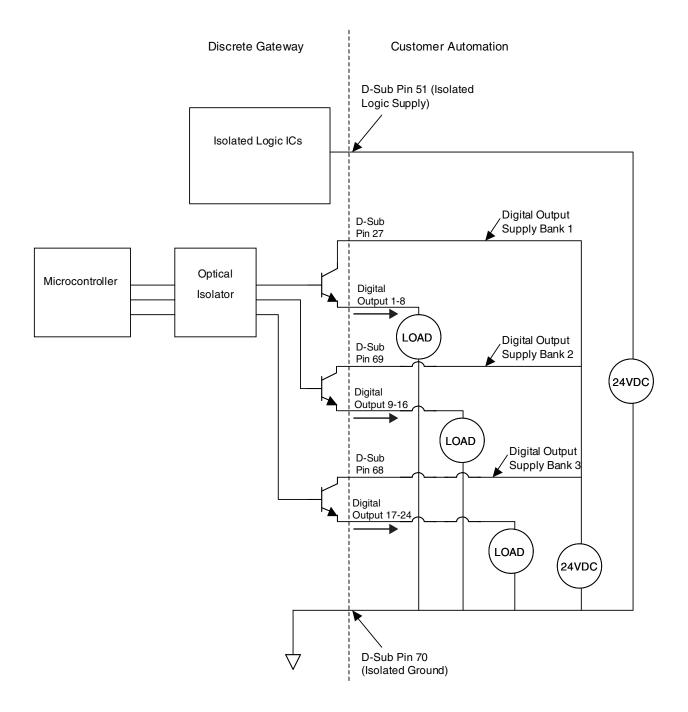


DGM Digital Outputs

The digital outputs function only when power is supplied to pins 27, 68, and 69 and there is a ground connection to pin 70. See **Pin References**, page 124, for details. The digital output is rated at 0-30 Vdc, and requires an NEC Class 2 power supply connected to pin 27 for supply bank 1, pin 69 for supply bank 2, and pin 68 for supply bank 3. The DGM provides optical isolation as shown in the following illustration.

Pins: 9-20, 28-39Type: Sourcing

- Maximum continuous current output: 350 mA (sourced from customer supply)
- Recommended continuous current: 100 mA



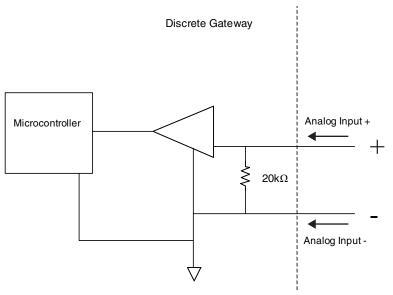
DGM Analog Inputs

The analog inputs function only when the DGM is connected to a power supply through the CAN connection. Each analog input has a corresponding reference (ground) pin. See **Pin References**, page 124, for details.

Type: Sinking

Voltage Rating: 0-10 Vdc

• Input Impedance: 20 $k\Omega$

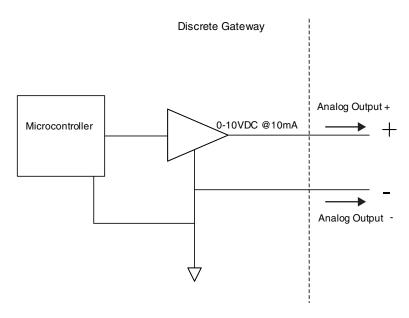


DGM Analog Outputs

The analog outputs function only when the DGM is connected to a power supply through the CAN connection. Each analog output has a corresponding reference (ground) pin. See **Pin References**, page 124, for details.

Type: Sourcing

Voltage Rating: 0-10 Vdc, 10 mA at 10 Vdc



Appendix C - Communications Gateway Module (CGM) Connection Details

Install Fieldbus Connections

Connect cables to fieldbus per fieldbus standards.

PROFINET

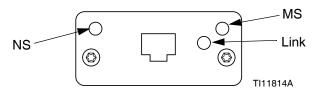


Fig. 72: PROFINET Fieldbus Connections

The Ethernet interface operates at 100Mbit, full duplex, as required by PROFINET. The Ethernet interface is auto-polarity sensing and auto-crossover capable.

Network Status (NS)

State	Description	Comments
Off	Offline	No power No connection with IO Controller
Green	On-line, (RUN)	Connection with IO Controller established IO Controller with RUN state
Flashing Green	On-line, (STOP)	Connection with IO Controller established IO Controller in STOP state

Module Status (MS)

State	Description	Comments
Off	Not initial- ized	No power or module in "SETUP" or "NW_INIT" state
Green	Normal operation	Diagnostic event(s) present
Flashing Green	Initialized, diagnostic event(s) present	Used by engineering tools to identify node on network
Red	Exception error	Module in state "EXCEPTION"
Red (1 flash)	Configura- tion error	Expected Identification differs from Real Identification
Red (2 flashes)	IP Address not set	Set IP address via system monitor or DNS server
Red (3 flashes)	Station Name not set	Set Station Name via system monitor
Red (4 flashes)	Major Inter- nal Error	Cycle system power; replace module

Link/Activity (Link)

State	Description
Off	No Link, no communication present
Green	Link established, no communication present
Green, flashing	Link established, communication present

EtherNet/IP

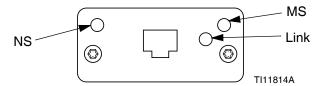


Fig. 73: EtherNet/IP Fieldbus Connections

The Ethernet interface operates at 100Mbit, full duplex, as required by PROFINET. The Ethernet interface is auto-polarity sensing and auto-crossover capable.

Network Status (NS)

State	Description
Off	No power or no IP address
Green	On-line, one or more connections established (CIP Class 1 or 3)
Flashing Green	On-line, no connections established
Red	Duplicate IP address, FATAL error
Flashing Red	One or more connections timed out (CIP Class 1 or 3)

Module Status (MS)

State	Description
Off	No power
Green	Controlled by a Scanner in Run state
Flashing Green	Not configured, or Scanner in Idle state
Red	Major fault (EXCEPTION-state, FATAL error etc.)
Flashing Red	Recoverable fault(s)

LINK/Activity (Link)

State	Description
Off	No link, no activity
Green	Link established
Flashing Green	Activity

DeviceNet

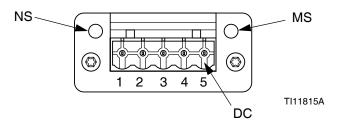


Fig. 74: DeviceNet Fieldbus Connections

Network Status (NS)

State	Description
Off	Not online / No power
Green	On-line, one or more connections are established
Flashing Green (1 Hz)	On-line, no connections established
Red	Critical link failure
Flashing Red (1 Hz)	One or more connections timed-out
Alternating Red/Green	Self test

Module Status (MS)

State	Description
Off	No power or not initialized
Green	Initialized
Flashing Green (1 Hz)	Missing or incomplete configuration, device needs commissioning
Red	Unrecoverable Fault(s)
Flashing Red (1 Hz)	Recoverable Fault(s)
Alternating Red/Green	Self test

DeviceNet Connector (DC)

Pin	Signal	Description
1	V-	Negative bus supply voltage
2	CAN_L	CAN low bus line
3	SHIELD	Cable shield
4	CAN_H	CAN high bus line
5	V+	Positive bus supply voltage

PROFIBUS

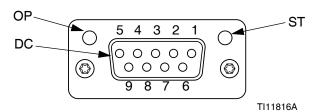


Fig. 75: PROFIBUS Fieldbus Connections

Operation Mode (OP)

State	Description
Off	Not online / No power
Green	On-line, data exchange
Flashing Green	On-line, clear
Flashing Red (1 flash)	Parameterization error
Flashing Red (2 flashes)	PROFIBUS Configuration error

Status Mode (ST)

State	Description
Off	No power or not initialized
Green	Initialized
Flashing Green	Initialized, diagnostic event(s) present
Red	Exception error

PROFIBUS Connector (DC)

Pin	Signal	Description
1	-	-
2	-	-
3	B Line	Positive RxD/TxD, RS485 level
4	RTS	Request to send
5	GND Bus	Ground (isolated)
6	+5V Bus Output	+5V termination power (isolated)
7	-	-
8	A Line	Negative RxD/TxD, RS485 level
9	-	-
Housing	Cable Shield	Internally connected to the Anybus protective earth via cable shield filters according to the PROFIBUS standard.

CGM I/O Data Map

See **Appendix D - I/O Signal Descriptions** on page 146.

Automation Inputs (signals from PCF)

Byte	Input		
	Bit	Description	Zone
0	100	Dispenser (Fluid Plate) Ready	
	I01	Dispenser (Fluid Plate) No Alarm	
	102	Dispense No Error	
	103	Dispense in Process	
	104	Dispense Volume OK	Fluid
	105		Plate 1
	106	Dispenser (Fluid Plate) Purge	
		Request	
	107	Dispenser (Fluid Plate) Remote	
		Start / Purge In Process	
1	108	Pressure Units - Bit 0	
-	109	Pressure Units - Bit 1	
	I10	Heartbeat	
	l11		Fluid
	l12		Plate 1
	I13		
	l14		
	l15		
2	I16		
_	l17		
	l18		
	I19		Fluid
	120		Plate 1
	l21		
	122		
	123		
3	124	Error - 1	
	125	Error - 2	
	126	Error - 4	
	127	Error - 8	Fluid
	128	Error - 16	Plate 1
	129	Error - 32	
	130	Error - 64	
	I31	Error - 128	
4	132	Dispenser (Fluid Plate) Ready	
	133	Dispenser (Fluid Plate) No Alarm	
	134	Dispense No Error	
	135	Dispense in Process	
	136	Dispense Volume OK	Fluid
	137		Plate 2
	138	Dispenser (Fluid Plate) Purge	
		Request	
	139	Dispenser (Fluid Plate) Remote	
		Start / Purge In Process	
		<u> </u>	l .

Byte	Input Bit	Description	Zone
5	140	Pressure Units - Bit 0	
5	141	Pressure Units - Bit 1	-
	142	Heartbeat	†
	143		Fluid
	144		Plate 2
	145		1
	146		-
	147		-
6	148		
	149		-
	150		+
	151		Fluid
	152		Plate 2
	153	 	1 1010 2
	154		+
	155		+
7	156	Error - 1	
'	157	Error - 2	+
	158	Error - 4	-
	159	Error - 8	Fluid
	160	Error - 16	Plate 2
	161	Error - 32	I late 2
	162	Error - 64	-
	163	Error - 128	-
8	164	Dispenser (Fluid Plate) Ready	
0	165	Dispenser (Fluid Plate) No Alarm	-
	166	Dispense No Error	-
	167	Dispense in Process	-
	168	Dispense Volume OK	Fluid
	169		Plate 3
	170	Dispenser (Fluid Plate) Purge	i late 5
	170	Request	
	l71	Dispenser (Fluid Plate) Remote	-
	17 1	Start / Purge In Process	
_	172	Pressure Units - Bit 0	
9	172	Pressure Units - Bit 0	-
	173	Heartbeat	1
	174	i learibear	Fluid
			Fluid
	176		Plate 3
	177		-
	178		-
	179		
10	180		1
	181		-
	182		Elected
	183		Fluid
	184		Plate 3
	185]
	186		
	187		

Byte	Input		
•	Bit	Description	Zone
11	188	Error - 1	
	189	Error - 2	
	190	Error - 4	
	I91	Error - 8	Fluid
	192	Error - 16	Plate 3
	193	Error - 32	
	194	Error - 64	
	195	Error - 128	
12	196	Dispenser (Fluid Plate) Ready	
	197	Dispenser (Fluid Plate) No Alarm	
	198	Dispense No Error	
	199	Dispense in Process	
	I100	Dispense Volume OK	Fluid
	I101		Plate 4
	l102	Dispenser (Fluid Plate) Purge	
		Request	
	I103	Dispenser (Fluid Plate) Remote	
		Start / Purge In Process	
13	I104	Pressure Units - Bit 0	
.0	I105	Pressure Units - Bit 1	
	I106	Heartbeat	1
	1107		Fluid
	1108		Plate 4
	1109		1
	1110		
	1111	 	
14	l112		
• •	1113		-
	1114		-
	I115		Fluid
	1116		Plate 4
	1117		1
	I118		-
	1119		-
15	1120	Error - 1	
13	1121	Error - 2	-
	1122	Error - 4	-
	1123	Error - 8	Fluid
	1124	Error - 16	Plate 4
	1125	Error - 32	1 1010 1
	1126	Error - 64	_
	1127	Error - 128	4
16	1128	Command Interface - Value - Bit 0	
16	1120	See CGM Command Interface on	
		page 138 for command interface	
		details.	
	l129	Command Interface - Value - Bit 1	All Fluid
	1129	Command Interface - Value - Bit 1	Plates/Swi
	1131	Command Interface - Value - Bit 2	rls
	1132	Command Interface - Value - Bit 4	- 115
	1132	Command Interface - Value - Bit 4 Command Interface - Value - Bit 5	4
	1133	Command Interface - Value - Bit 5 Command Interface - Value - Bit 6	4
		Command Interface - Value - Bit 6	4
	l135	Command interface - value - Bit /	

Byte	Input		
	Bit	Description	Zone
17	I136	Command Interface - Value - Bit 8	
	l137	Command Interface - Value - Bit 9	
	l138	Command Interface - Value - Bit 10	All Fluid
	l139	Command Interface - Value - Bit 11	Plates/Swi
	l140	Command Interface - Value - Bit 12	rls
	l141	Command Interface - Value - Bit 13	113
	1142	Command Interface - Value - Bit 14	
	l143	Command Interface - Value - Bit 15	
18	l144	Command Interface - Value - Bit 16	
	1145	Command Interface - Value - Bit 17	
	I146	Command Interface - Value - Bit 18	All Fluid
	l147	Command Interface - Value - Bit 19	Plates/Swi
	I148	Command Interface - Value - Bit 20	rls
	l149	Command Interface - Value - Bit 21	115
	I150	Command Interface - Value - Bit 22	
	l151	Command Interface - Value - Bit 23	
19	l152	Command Interface - Value - Bit 24	
	I153	Command Interface - Value - Bit 25	
	l154	Command Interface - Value - Bit 26	All Fluid
	l155	Command Interface - Value - Bit 27	Plates/Swi
	l156	Command Interface - Value - Bit 28	rls
	l157	Command Interface - Value - Bit 29	115
	I158	Command Interface - Value - Bit 30	
	l159	Command Interface - Value - Bit 31	
20	I160	Command Interface Status - Com-	
		mand Active	
	l161	Command Interface Status - Com-	
		mand Success	
	l162	Command Interface Status - Com-	All Fluid
		mand Failure	Plates/Swi
	I163	Command Interface Status - Value	rls
		Coerced	119
	l164		
	I165		
	I166		
	l167		
21-	I168-		
25	1207		
لـــــــا		1	

Automation Outputs (signals to PCF)

Byte	Output Bit	Description	Zone
0	O00	Style Strobe	
	O01	Dispense Complete	
İ	O02	Dispense Valve 1 On	
	O03	Dispense Valve 2 On	Fluid
	O04	Dispense Valve 3 On	Plate 1
İ	O05	Dispense Valve 4 On	
	O06	Error Reset / Cancel Job	
	O07	Remote Start / Purge	
1	O08	Swirl Enable	
	O09		
•	O10		
	011		Swirl 1
•	012		Swift i
ľ	O13		
	014		†
-	015		1
2	016	Style - 1	
_	017	Style - 2	1
	O18	Style - 4	_
•	O19	Style - 8	Fluid
•	O20	Style - 16	Plate 1
•	021	Style - 32	-
•	022	Style - 64	-
•	023	Style - 128	-
3	024	Dispense Valve 1 Precharge On	
Ŭ	025	Dispense Valve 2 Precharge On	-
•	026	Dispense Valve 3 Precharge On	-
-	027	Dispense Valve 4 Precharge On	Fluid
-	028		Plate 1
ŀ	029		
	O30		
-	O31		+
4	O32	Command Value - 1	
7	O33	Command Value - 2	
	O34	Command Value - 4	
	O35	Command Value - 8	Fluid
	O36	Command Value - 16	Plate 1
	O37	Command Value - 32	- 10.0
-	O38	Command Value - 64	-
	O39	Command Value - 128	-
5	O40	Command Value - 256	
٦	041	Command Value - 512	+
	042	Command Value - 1024	+
	O42	Command Value - 2048	Fluid
	043		Plate 1
	045		1 1016 1
	O45 O46		+
	046	 	4
	047		

Byte	Output		
	Bit	Description	Zone
6	O48	Swirl Command Value - 1	
	O49	Swirl Command Value - 2	
	O50	Swirl Command Value - 4	
	O51	Swirl Command Value - 8	Swirl 1
	O52	Swirl Command Value - 16	
	O53	Swirl Command Value - 32	
	O54	Swirl Command Value - 64	
	O55	Swirl Command Value - 128	
7	O56	Swirl Command Value - 256	
•	O57	Swirl Command Value - 512	1
	O58	Swirl Command Value - 1024	
	O59	Swirl Command Value - 2048	Swirl 1
•	O60		Swill i
•	O61		
•	O62		
	O63		1
8	O64	Style Strobe	
	O65	Dispense Complete	1
	O66	Dispense Valve 1 On	
	O67	Dispense Valve 2 On	Fluid
	O68	Dispense Valve 3 On	Plate 2
	O69	Dispense Valve 4 On	
	070	Error Reset / Cancel Job	
	071	Remote Start / Purge	
9	072	Swirl Enable	
	073		
	074		
	075	 	1
	076		Swirl 2
	077		
	078	 	†
	079	 	†
10	080	Style - 1	
	O81	Style - 2	†
	O82	Style - 4	
	O83	Style - 8	Fluid
	O84	Style - 16	Plate 2
	O85	Style - 32	1
	O86	Style - 64	1
	087	Style - 128	†
11	O88	Dispense Valve 1 Precharge On	+
''	O89	Dispense Valve 2 Precharge On	†
	0 90	Dispense Valve 3 Precharge On	†
	O91	Dispense Valve 4 Precharge On	Fluid
	O92		Plate 2
	093		-
	O94	 	†
	O95	 	†
		J	1

Byte	Output		
Dyte	Bit	Description	Zone
12	O96	Command Value - 1	
12	O97	Command Value - 2	-
	O98	Command Value - 4	-
	099	Command Value - 8	Fluid
	O100	Command Value - 16	Plate 2
	O101	Command Value - 32	- 1 1010 - 1
	O102	Command Value - 64	-
	0103	Command Value - 128	-
13	O104	Command Value - 256	+
13	O105	Command Value - 512	-}
	0106	Command Value - 1024	-
	0107	Command Value - 2048	Fluid
	O107		Plate 2
	O100	<u> </u>	- 1 1010 2
	O110		
	0111	 	⊣
14	0112	Swirl Command Value - 1	
14	0112	Swirl Command Value - 2	⊣
	0113	Swirl Command Value - 2	⊣
	0114	Swirl Command Value - 4	⊣
	0116		Swirl 2
	0116	Swirl Command Value - 16	
		Swirl Command Value - 32	
	O118	Swirl Command Value - 64	→
	O119	Swirl Command Value - 128	
15	O120	Swirl Command Value - 256	
	0121	Swirl Command Value - 512	
	0122	Swirl Command Value - 1024	→
	O123	Swirl Command Value - 2048	Swirl 2
	0124		
	0125		
	O126		
	0127		
16	O128	Style Strobe	
	O129	Dispense Complete	
	O130	Dispense Valve 1 On	
	O131	Dispense Valve 2 On	Fluid
	O132	Dispense Valve 3 On	Plate 3
	O133	Dispense Valve 4 On	
	O134	Error Reset / Cancel Job	
	O135	Remote Start / Purge	-
17	O136	Swirl Enable	
	O137		
	O138		7
	O139		Swirl 3
	O140		SWIIIS
	0141		
	0142		-
	0143		
18	0144	Style - 1	+
'	0145	Style - 2	
	0146	Style - 4	
	0147	Style - 8	Fluid
	0148	Style - 16	Plate 3
	O149	Style - 32	
	O150	Style - 64	-
	O150	Style - 128	⊣
	0101	Oly16 - 120	

Byte	Output		
Dyte	Bit	Description	Zone
19	0152	Dispense Valve 1 Precharge On	
	O153	Dispense Valve 2 Precharge On	1
	O154	Dispense Valve 3 Precharge On	1
	O155	Dispense Valve 4 Precharge On	Fluid
	O156		Plate 3
	O157		1
	O158		1
	O159		1
20	O160	Command Value - 1	
	O161	Command Value - 2	1
	O162	Command Value - 4	1
	O163	Command Value - 8	Fluid
	O164	Command Value - 16	Plate 3
	O165	Command Value - 32	1
	O166	Command Value - 64	1
	0167	Command Value - 128	†
21	O168	Command Value - 256	
-	O169	Command Value - 512	┪ ┃
	0170	Command Value - 1024	1
	0171	Command Value - 2048	Fluid
	0172		Plate 3
	0173	 	1
	0174	 	1
	0175		-
22	0176	Swirl Command Value - 1	
22	0177	Swirl Command Value - 2	-
	0178	Swirl Command Value - 4	-
	0179	Swirl Command Value - 8	-
	0180	Swirl Command Value - 16	Swirl 3
	0181	Swirl Command Value - 32	-
	0182	Swirl Command Value - 64	-
	0183	Swirl Command Value - 128	-
23	0184	Swirl Command Value - 256	
23	O185	Swirl Command Value - 512	-
	0186	Swirl Command Value - 1024	-
	0187	Swirl Command Value - 2048	-
	O188		Swirl 3
	O189	 	-
	O190		-
	0190		-
24	0192	Style Strobe	+
24	0193	Dispense Complete	
	0194	Dispense Valve 1 On	-
	O195	Dispense Valve 2 On	Fluid
	O196	Dispense Valve 3 On	Plate 4
	O197	Dispense Valve 4 On	- 1 1410 7
	O198	Error Reset / Cancel Job	-
	O198	Remote Start / Purge	-
25	0200	Swirl Enable	+
25	O200		-
	0201		-
	0202		4
	O203		Swirl 4
			4
	O205		4
	O206		4
	O207		

Byte	Output Bit	Description	Zone
26	O208	Style - 1	
20	O209	Style - 2	+
	0210	Style - 4	+
	0211	Style - 8	Fluid
	0212	Style - 16	Plate 4
	0213	Style - 32	- I late +
•	0214	Style - 64	-
•	0215	Style - 128	-
27	0216	Dispense Valve 1 Precharge On	
21	0210	Dispense Valve 2 Precharge On	4
•			4
	O218	Dispense Valve 3 Precharge On	
	O219	Dispense Valve 4 Precharge On	Fluid
	O220		Plate 4
	0221		
	0222		
	O223		
28	0224	Command Value - 1	
	O225	Command Value - 2	
	O226	Command Value - 4	
	O227	Command Value - 8	Fluid
	O228	Command Value - 16	Plate 4
•	O229	Command Value - 32	
•	O230	Command Value - 64	1
ļ	O231	Command Value - 128	7
29	O232	Command Value - 256	
_	O233	Command Value - 512	1
	O234	Command Value - 1024	7
ŀ	O235	Command Value - 2048	Fluid
	O236		Plate 4
	0237		1
•	0238	 	†
	0239		†
30	0240	Swirl Command Value - 1	
00	0241	Swirl Command Value - 2	+
	0242	Swirl Command Value - 4	+
	0243	Swirl Command Value - 8	+
	0244	Swirl Command Value - 16	Swirl 4
	0245	Swirl Command Value - 32	4
	0246	Swirl Command Value - 64	+
	0240	Swirl Command Value - 04	4
0.4	0247		
31		Swirl Command Value - 256	4
	0249	Swirl Command Value - 512	4
	O250	Swirl Command Value - 1024	4
	O251	Swirl Command Value - 2048	Swirl 4
	O252		↓
	O253		
	O254		_
	O255		

Byte	Output		
	Bit	Description	Zone
32	O256	Command Interface - Command - Bit 0 See CGM Command Interface on page 138 for command interface details.	
	O257	Command Interface - Command - Bit 1	
	O258	Command Interface - Command - Bit 2	All Fluid
	O259	Command Interface - Command - Bit 3	Plates/S wirls
	O260	Command Interface - Command - Bit 4	
	O261	Command Interface - Command - Bit 5	
	O262	Command Interface - Command - Bit 6	
	O263	Command Interface - Command - Bit 7	
33	O264	Command Interface - Command - Bit 8	
	O265	Command Interface - Command - Bit 9	
	O266	Command Interface - Command - Bit 10	
	O267	Command Interface - Command - Bit 11	All Fluid Plates/S
	O268	Command Interface - Command - Bit 12	wirls
	O269	Command Interface - Command - Bit 13	
	O270	Command Interface - Command - Bit 14	
	O271	Command Interface - Command - Bit 15	
34	O272	Command Interface - Command - Bit 16	
	O273	Command Interface - Command - Bit 17	
	O274	Command Interface - Command - Bit 18	All Fluid Plates/S
	O275	Command Interface - Command - Bit 19	wirls
	O276		
	O277		
	O278		
	O279		
35	O280- O287		

Appendix C - Communications Gateway Module (CGM) Connection Details

Byte	Output		
Dyte	Bit	Description	Zone
36		Command Interface - Value - Bit 0	
	O288	See CGM Command Interface on	
	0200	page 138 for command interface	
		details.	
	O289	Command Interface - Value - Bit 1	All Fluid
	O290	Command Interface - Value - Bit 2	Plates/S
	O291	Command Interface - Value - Bit 3	wirls
	O292	Command Interface - Value - Bit 4	
	O293	Command Interface - Value - Bit 5	
	O294	Command Interface - Value - Bit 6	
	O295	Command Interface - Value - Bit 7	
37	O296	Command Interface - Value - Bit 8	
	O297	Command Interface - Value - Bit 9	
	O298	Command Interface - Value - Bit 10	All Fluid
	O299	Command Interface - Value - Bit 11	Plates/S
	O300	Command Interface - Value - Bit 12	wirls
	O301	Command Interface - Value - Bit 13	WIIIS
	O302	Command Interface - Value - Bit 14	,
	O303	Command Interface - Value - Bit 15	
38	O304	Command Interface - Value - Bit 16	
	O305	Command Interface - Value - Bit 17	
	O306	Command Interface - Value - Bit 18	All Fluid
	O307	Command Interface - Value - Bit 19	Plates/S
	O308	Command Interface - Value - Bit 20	wirls
	O309	Command Interface - Value - Bit 21	WITIS
	O310	Command Interface - Value - Bit 22	
	O311	Command Interface - Value - Bit 23	
39	O312	Command Interface - Value - Bit 24	
	O313	Command Interface - Value - Bit 25	
	O314	Command Interface - Value - Bit 26	All Fluid
	O315	Command Interface - Value - Bit 27	Plates/S
	O316	Command Interface - Value - Bit 28	wirls
	O317	Command Interface - Value - Bit 29	WILIS
	O318	Command Interface - Value - Bit 30	
	O319	Command Interface - Value - Bit 31	
40	0220	Command Interface - Control Bits -	
	O320	Read	
	0201	Command Interface - Control Bits -	
	O321	Write	All Fluid
	O322		Plates/S
	O323		wirls
	O324		
	O325		
	O326		
	O327		
41	O328-		
	O335		

Inputs to PLC; Outputs from Graco PCF

For Basic Gateway Map 16T061

Signal	Data Type	BIT	BYTE
FP1 - Dispenser Ready	Boolean	0	0
FP1 - Dispenser No Alarm	Boolean	1	
FP1 - Dispense No Error	Boolean	2	
FP1 - Dispense in Process	Boolean	3	
FP1 - Dispense Volume OK	Boolean	4	
(Spare)	Boolean	5	
FP1 - Dispenser Purge	Boolean	6	
Requested			
FP1 - Dispenser Remote	Boolean	7	
Start / Purge in Process			
FP1 - Pressure Units - Bit 0	Boolean	0	1
FP1 - Pressure Units - Bit 1	Boolean	1	
FP1 - Heartbeat	Boolean	2	
FP1 - Error	Integer	0-7	2
FP2 - Dispenser Ready	Boolean	0	3
FP2 - Dispenser No Alarm	Boolean Boolean	0	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error		1 2	3
FP2 - Dispenser No Alarm	Boolean	1	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error	Boolean Boolean	1 2	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare)	Boolean Boolean Boolean	1 2 3	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK	Boolean Boolean Boolean Boolean	1 2 3 4	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare)	Boolean Boolean Boolean Boolean Boolean	1 2 3 4 5	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare) FP2 - Dispenser Purge	Boolean Boolean Boolean Boolean Boolean	1 2 3 4 5	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare) FP2 - Dispenser Purge Requested FP2 - Dispenser Remote Start / Purge in Process	Boolean Boolean Boolean Boolean Boolean Boolean Boolean	1 2 3 4 5 6	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare) FP2 - Dispenser Purge Requested FP2 - Dispenser Remote Start / Purge in Process FP2 - Pressure Units - Bit 0	Boolean Boolean Boolean Boolean Boolean	1 2 3 4 5 6	3
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare) FP2 - Dispenser Purge Requested FP2 - Dispenser Remote Start / Purge in Process	Boolean Boolean Boolean Boolean Boolean Boolean Boolean	1 2 3 4 5 6	
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare) FP2 - Dispenser Purge Requested FP2 - Dispenser Remote Start / Purge in Process FP2 - Pressure Units - Bit 0	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	1 2 3 4 5 6	
FP2 - Dispenser No Alarm FP2 - Dispense No Error FP2 - Dispense in Process FP2 - Dispense Volume OK (Spare) FP2 - Dispenser Purge Requested FP2 - Dispenser Remote Start / Purge in Process FP2 - Pressure Units - Bit 0 FP2 - Pressure Units - Bit 1	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	1 2 3 4 5 6	

Outputs from PLC; Inputs to Graco PCF

For Basic Gateway Map 16T061

Signal	Data Type	BIT	BYTE
FP1 - Style Strobe	Boolean	0	0
FP1 - Dispense Complete	Boolean	1	
FP1 - Dispense Gun 1 On	Boolean	2	
FP1 - Dispense Gun 2 On	Boolean	3	
FP1 - Dispense Gun 3 On	Boolean	4	
FP1 - Dispense Gun 4 On	Boolean	5	
FP1 - Error Reset	Boolean	6	
FP1 - Remote Start / Purge	Boolean	7	
FP1 - Style	Integer	0-7	1
FP1 - Dispense Valve 1	Boolean	0	2
Precharge on			
FP1 - Dispense Valve 2	Boolean	1	
Precharge on			
FP1 - Dispense Valve 3	Boolean	2	
Precharge on			
FP1 - Dispense Valve 4	Boolean	3	
Precharge on			
(Spare)	Boolean	4-7	
FP1 - Flow Command	Integer	0-11	3-4
Voltage	J		
(Spare)	Boolean	12-15	
FP2 - Style Strobe		12-15 0	5
FP2 - Style Strobe FP2 - Dispense Complete	Boolean Boolean Boolean		5
FP2 - Style Strobe FP2 - Dispense Complete	Boolean	0	5
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On	Boolean Boolean	0	5
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On	Boolean Boolean Boolean	0 1 2	5
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On	Boolean Boolean Boolean Boolean	0 1 2 3	5
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On	Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4	5
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge	Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5	5
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style	Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5	5
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7	7
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Pre-	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7 0-7	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7 0-7	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on FP1 - Dispense Valve 3 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7 0-7	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on FP1 - Dispense Valve 3 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Integer Boolean Boolean	0 1 2 3 4 5 6 7 0-7 0	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 4 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7 0-7	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 4 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Integer Boolean Boolean Boolean	0 1 2 3 4 5 6 7 0-7 0	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 4 Precharge on FP1 - Dispense Valve 4 Precharge on FP1 - Dispense Valve 4 Precharge on (Spare)	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Integer Boolean Boolean Boolean Boolean Boolean	0 1 2 3 4 5 6 7 0-7 0 1 2	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 4 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Integer Boolean Boolean	0 1 2 3 4 5 6 7 0-7 0	
FP2 - Style Strobe FP2 - Dispense Complete FP2 - Dispense Valve 1 On FP2 - Dispense Valve 2 On FP2 - Dispense Valve 3 On FP2 - Dispense Valve 4 On FP2 - Error Reset FP2 - Remote Start / Purge FP2 - Style FP1 - Dispense Valve 1 Precharge on FP1 - Dispense Valve 2 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 3 Precharge on FP1 - Dispense Valve 4 Precharge on	Boolean Boolean Boolean Boolean Boolean Boolean Boolean Boolean Integer Boolean Boolean Boolean	0 1 2 3 4 5 6 7 0-7 0	7

CGM Command Interface

NOTE: The CGM command interface is only available for fluid plates with 16 or 256 styles.

NOTE: Some data instances are offered directly on the map and through the command interface. It is recommended that you use the data available directly to improve communication speed.

The CGM command interface utilizes bits in the CGM I/O Data Map, page 131, to support many additional functions that are not available in the other CGM I/O bits.

NOTE: When changes are made over the command interface, the ADM screen may not update immediately. it may be necessary to navigate away from the screen then back to it.

The CGM command interface uses automation output bits 256 to 327. These bits can be used to request the value of a current system setting (read) or change a system setting (write).

- Output bits 256-267 are used to identify the individual command. Each bit will have a single binary value to create the hex code listed in the commands table.
- Output bits 268-275 are used to identify the individual Fluid Plate or Swirl dispenser to which the commands will apply.
- Output bits 288-319 are used to identify the value of the command specified by bits 256-267 and 268-275.
- Output bit 321 identifies the command as a write command.
- Output bit 320 identifies the command as a read command.

The CGM command interface uses automation input bits 128-159 to read the current system values. It also uses input bits 160-163 to identify the status of commands:

- Bit 160: Command Active
- Bit 161: Command Success
- Bit 162: Command Failure
- Bit 163: Value Coerced

NOTE: If both output bits 320 (read) and 321 (write) are high during a command the result will be a command failure identified by input bit 162 (command failure) going high.

Examples

NOTE: See the timing diagram and tables starting on page 139 for detailed descriptions of the input and output bits.

Example 1: if output bits 256-275 are 0xB0203, output bits 288-319 are 0x0004, and output bit 321 is high, this means:

- The command relates to the purge period in minutes (0x_203)
- The command relates to fluid plate 1 (0xB0_____
- The command is a write command (bit 321 high)
- The value of the command is 4 (0x0004)

Combine these individual pieces to understand the command as a whole: Change the purge period setting on fluid plate 1 to 4 minutes.

Example 2: if output bits 256-275 are 0xB3212, input bits 288-319 are 0x0000, and output bit 320 is high, this means:

- The command relates to whether valve 1 is enabled (0x_212)
- The command relates to fluid plate 4 (0xB3_____
- The command is a read command (bit 320 high)
- The value of the command is 0 (0x0000)

Combined, this means: Valve 1 on fluid plate 4 is disabled.

Command Interface Timing Diagram

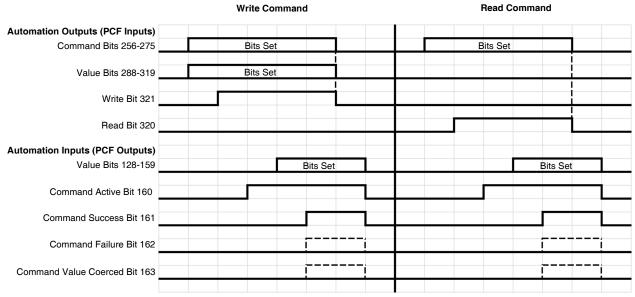


Fig. 76: CGM Command Interface Timing Diagram

Command Interface Write Operation

- Set Command Identification Bits and Fluid Plate/Swirl Identification Bits to the desired values.
- Set Value Bits (Output) with the value that is desired to be written.
- 3. Set Write Bit.
- 4. Wait for the Command Active Bit to become set. This indicates that an operation is in process.
- Wait for the Command Success Bit, Command Failure Bit, or Command Value Coerced Bit to become set.

NOTE: The Value Bits (Input) now contain the value that was actually written.

Clear the Write Bit to end the write command operation.

Command Interface Read Operation

- Set Command Identification Bits and Fluid Plate/Swirl Identification Bits to the desired values.
- 2. Set Read Bit.
- 3. Wait for the Command Active Bit to become set. This indicates that an operation is in process.

4. Wait for the Command Success Bit or Command Failure Bit to become set.

NOTE: If Command Success Bit has been set, valid data will be present within the Value Bits (Input).

Clear the Read Bit to end the read command operation.

Fluid Plate/Swirl Identification Commands

Output Bits 268-275	Description
0xB0	Fluid Plate 1
0xB1	Fluid Plate 2
0xB2	Fluid Plate 3
0xB3	Fluid Plate 4
0xE1	Swirl 1
0xE2	Swirl 2
0xE3	Swirl 3
0xE4	Swirl 4

Fluid Plate Commands

Output Bits 256-267	Description	Units *See Units Definitions, page 145	Read or Write
0x004	Software Part Number	STR_3_0	Read Only
0x005	Software Part Number	STR_7_4	Read Only
0x006	Software Part Number	STR_11_8	Read Only

Output		Units	
Bits		*See Units	Read or
256-267	Description	Definitions , page 145	Write
0x007	Software Part Number	STR_15_12	Read Only
0x008	Software Version	Version	Read Only
0x0DD	Maintenance Units Type	Maintenance Units Enumeration	Read Only
0x0DF	Enabled Styles	###	Read Only
0x203	Purge Period	#### (minutes)	Read / Write
0x204	Dispense Trig- ger Source	Dispense Trigger Source Enumeration	Read / Write
0x208	Command Value Source	Command Value Source Enumeration	Read / Write
0x20F	Bead Scale	### (percent)	Read / Write
0x210	Job End Mode	Job End Mode Enu- meration	Read / Write
0x211	Job End Delay Time	Integer (Seconds)	Read / Write
0x2B5	End Job On Alarm	Boolean	
0x212	Valve 1 Enable	Boolean	Read / Write
0x213	Valve 2 Enable	Boolean	Read / Write
0x214	Valve 3 Enable	Boolean	Read / Write
0x215	Valve 4 Enable	Boolean	Read / Write
0x216	Regulator On Delay	### (mS)	Read / Write
0x217	Regulator Off Delay	### (mS)	Read / Write
0x218	Valve 1 On Delay	### (mS)	Read / Write
0x219	Valve 2 On Delay	### (mS)	Read / Write
0x21A	Valve 3 On Delay	### (mS)	Read / Write
0x21B	Valve 4 On Delay	### (mS)	Read / Write
0x21C	Valve 1 Off Delay	### (mS)	Read / Write
0x21D	Valve 2 Off Delay	### (mS)	Read / Write
0x21E	Valve 3 Off Delay	### (mS)	Read / Write
0x21F	Valve 4 Off Delay	### (mS)	Read / Write
0x230	Flow Meter Type	Flow Meter Type Enu- meration	Read / Write

Output		Units	
Bits		*See Units	Read or
256-267	Description	Definitions , page 145	Write
0x231	Flow Meter	##### (pulses/Liter,	Read /
	K-Factor	pulses/kg)	Write
0x23C	Outlet Pres-	sint32; #### (psi);	Read /
	sure Sensor	###.# (bar); ##.##	Write
0000	User Offset	(Mpa)	Decid /
0x23D	Inlet Pressure	sint32; #### (psi); ###.# (bar); ##.##	Read / Write
	Sensor User Offset	(Mpa)	vvnie
0x241	Maximum Out-	uint32; #### (psi);	Read /
UX241	let Pressure	###.# (bar); ##.##	Write
	let Fressure	(Mpa)	vviile
0x244	Minimum Inlet	uint32; #### (psi);	Read /
UXZ44	Pressure	###.# (bar); ##.##	Write
	1 1033410	(Mpa)	VVIIIC
0x245	Maximum Inlet	uint32; #### (psi);	Read /
CAL FO	Pressure	###.# (bar); ##.##	Write
		(Mpa)	
0x248	Pressure Kp	####.##	Read /
0,12.0			Write
0x249	Pressure Ki	####.##	Read /
07.2.0			Write
0x247	Pressure Kd	####.##	Read /
· · ·			Write
0x254	Bead Kp	####.##	Read /
· .	2000.10		Write
0x255	Bead Ki	####.##	Read /
			Write
0x260	Regulator Time	##### (hours)	Read /
	Advisory Limit	,	Write
0x262	Regulator Vol-	Volume: #####	Read /
	ume/Mass	(gal(US)); ######	Write
	Advisory Limit	(gal(Uk)); ######	
		(Liters); Mass: #####	
		(lb), ###### (kg)	
0x264	Flow meter	##### (hours)	Read /
	Time Advisory		Write
	Limit		
0x266	Flow meter	Volume: ######	Read /
	Volume/Mass	(gal(US)); ######	Write
	Advisory Limit	(gal(Uk)); ######	
		(Liters); Mass: #####	
0,000	Cupply Time	(lb), ##### (kg)	Bood /
0x268	Supply Time Advisory Limit	###### (hours)	Read / Write
Ovoc A	=	Volume: ######	_
0x26A	Supply Vol- ume/Mass	Volume: ##### (gal(US)); #####	Read / Write
	Advisory Limit	(gal(US)); ###### (gal(Uk)); ######	VVIILE
	, tavisory Ellrill	(Liters); Mass: #####	
		(lb), ###### (kg)	
		, , , , , , , , , , , , , , , , , , ,	i .
0x26C	V/P Time Advi-	##### (hours)	Read /

Output		Units	
Bits		*See Units	Read or
256-267	Description	Definitions , page 145	Write
0x26E	V/P Vol- ume/Mass Advisory Limit	Volume: ##### (gal(US)); ##### (gal(Uk)); ##### (Liters); Mass: ##### (lb), ##### (kg)	Read / Write
0x270	Valve 1 Time Advisory Limit	##### (hours)	Read / Write
0x271	Valve 2 Time Advisory Limit	##### (hours)	Read / Write
0x272	Valve 3 Time Advisory Limit	###### (hours)	Read / Write
0x273	Valve 4 Time Advisory Limit	###### (hours)	Read / Write
0x278	Valve 1 Vol- ume/Mass Advisory Limit	Volume: ##### (gal(US)); ##### (gal(Uk)); ##### (Liters); Mass: ##### (lb), ##### (kg)	Read / Write
0x279	Valve 2 Vol- ume/Mass Advisory Limit	Volume: ###### (gal(US)); ###### (gal(Uk)); ###### (Liters); Mass: ###### (lb), ###### (kg)	Read / Write
0x27A	Valve 3 Vol- ume/Mass Advisory Limit	Volume: ###### (gal(US)); ###### (gal(Uk)); ###### (Liters); Mass: ###### (lb), ###### (kg)	Read / Write
0x27B	Valve 4 Vol- ume/Mass Advisory Limit	Volume: ###### (gal(US)); ###### (gal(Uk)); ###### (Liters); Mass: ##### (lb), ###### (kg)	Read / Write
0x283	Swirl Fault Error Type	Error Type Enumera- tion 2	
0x284	Low Flow Rate Error Type	Error Type Enumera- tion 1	Read / Write
0x285	High Flow Rate Error Type	Error Type Enumera- tion 1	Read / Write
0x286	Low Pressure Error Type	Error Type Enumera- tion 1	Read / Write
0x287	High Pressure Error Type	Error Type Enumera- tion 1	Read / Write
0x289	High Outlet Pressure Error Type	Error Type Enumera- tion 2	Read / Write
0x28A	Low Volume Error Type	Error Type Enumera- tion 1	Read / Write
0x28B	High Volume Error Type	Error Type Enumera- tion 1	Read / Write
0x28C	Low Com- puted Target Error Type	Error Type Enumeration 1	Read / Write

Output		Units	<u> </u>
Bits	December 41	*See Units	Read or
256-267	Description	Definitions , page 145	Write
0x28D	High Com-	Error Type Enumera-	Read /
	puted Target Error Type	tion 1	Write
0x28E	Low Inlet Pres-	Error Type Enumera-	Read /
	sure Error Type	tion 2	Write
0x28F	High Inlet	Error Type Enumera-	Read /
	Pressure Error Type	tion 2	Write
0x292	Valve 1 Mode	Valve Mode Enumera-	Read /
		tion	Write
0x293	Valve 2 Mode	Valve Mode Enumera-	Read /
		tion	Write
0x294	Valve 3 Mode	Valve Mode Enumera-	Read /
		tion	Write
0x295	Valve 4 Mode	Valve Mode Enumera-	Read /
		tion	Write
0x296	Valve 1 10	Volume: #####	Read /
	VDC Analog	(cc/sec); #####	Write
	Scale Flow	(cc/min); Mass: #####	
	rate	(g/sec); ##### (g/min)	
0x297	Valve 2 10	Volume: ####	Read /
	VDC Analog	(cc/sec); #####	Write
	Scale Flow	(cc/min); Mass: #####	
	rate	(g/sec); ##### (g/min)	
0x298	Valve 3 10	Volume: #####	Read /
	VDC Analog	(cc/sec); #####	Write
	Scale Flow	(cc/min); Mass: #####	
	rate	(g/sec); ##### (g/min)	
0x299	Valve 4 10	Volume: #####	Read /
	VDC Analog	(cc/sec); #####	Write
	Scale Flow	(cc/min); Mass: #####	
	rate	(g/sec); ##### (g/min)	
0x29A	Valve 1 10	Pressure: #### (psi);	Read /
	VDC Analog	###.# (bar); ##.##	Write
	Scale Pressure	` ' '	
0x29B	Valve 2 10	Pressure: #### (psi);	Read /
	VDC Analog	###.# (bar); ##.##	Write
	Scale Pressure	(Mpa)	
0x29C	Valve 3 10	Pressure: #### (psi);	Read /
	VDC Analog	###.# (bar); ##.##	Write
	Scale Pressure	(Mpa)	
0x29D	Valve 4 10	Pressure: #### (psi);	Read /
	VDC Analog	###.# (bar); ##.##	Write
	Scale Pressure	(Mpa)	
0x302	Regulator	Volume: #####	Read /
	Maintenance -	(gal(US)); #####	Write
	Dispensed Vol-	(gal(Uk)); ######	
	ume*	(Liters); Mass: #####	
	i .	(lb), ###### (kg)	İ

Output		Units	
Bits 256-267	Description	*See Units Definitions, page 145	Read or Write
0x303	Flow meter	Volume: ######	Read /
ολοσο	Maintenance -	(gal(US)); #####	Write
	Dispensed Vol-	(gal(Uk)); ######	
	ume*	(Liters); Mass: #####	
		(lb), ###### (kg)	
0x304	Supply Mainte-	Volume: #####	Read /
	nance - Dis-	(gal(US)); ######	Write
	pensed Volume*	(gal(Uk)); ###### (Liters); Mass: ######	
	Volume	(lb), ###### (kg)	
0x305	V/P Mainte-	Volume: ######	Read /
ONOGO	nance - Dis-	(gal(US)); ######	Write
	pensed	(gal(Uk)); ######	
	Volume*	(Liters); Mass: #####	
		(lb), ###### (kg)	
0x308	Valve 1 Main-	Volume: #####	Read /
	tenance - Dis-	(gal(US)); ######	Write
	pensed Volume*	(gal(Uk)); ######	
	Volume	(Liters); Mass: ##### (lb), ###### (kg)	
0x309	Valve 2 Main-	Volume: ######	Read /
0x309	tenance - Dis-	(gal(US)); #####	Write
	pensed	(gal(Uk)); ######	VIIIO
	Volume*	(Liters); Mass: #####	
		(lb), ###### (kg)	
0x30A	Valve 3 Main-	Volume: #####	Read /
	tenance - Dis-	(gal(US)); ######	Write
	pensed	(gal(Uk)); ######	
	Volume*	(Liters); Mass: ##### (lb), ###### (kg)	
0x30B	Valve 4 Main-	Volume: #####	Read /
OXOOD	tenance - Dis-	(gal(US)); #####	Write
	pensed	(gal(Uk)); ######	
	Volume*	(Liters); Mass: #####	
		(lb), ###### (kg)	
0x312	Regulator	##### (hours)	Read /
	Maintenance -		Write
	Dispense Time*		
0x313	Flow meter	###### (hours)	Read /
0.010	Maintenance -	mmmmm (Hours)	Write
	Dispense		
	Time*		
0x314	Supply Mainte-	##### (hours)	Read /
	nance - Dis-	, ,	Write
	pense Time*		
0x315	V/P Mainte-	##### (hours)	Read /
	nance - Dis-		Write
	pense Time*		
0x318	Valve 1 Main-	##### (hours)	Read /
	tenance - Dis-		Write
0.010	pense Time*		Dood /
0x319	Valve 2 Main- tenance - Dis-	##### (hours)	Read / Write
	pense Time*		AAIIIG
	P31100 111110		

Output		Units	
Bits	December	*See Units	Read or
256-267	Description	Definitions , page 145	Write
0x31A	Valve 3 Main- tenance - Dis- pense Time*	###### (hours)	Read / Write
0x31B	Valve 4 Main- tenance - Dis- pense Time*	###### (hours)	Read / Write
0x800	Purge Defini- tion - Volume	#####.# (cc)	Read / Write
0x801	Purge Definition - Pressure	Pressure: #### (psi); ###.# (bar); ##.## (Mpa)	Read / Write
0x802	Purge Defini- tion - Toler- ances	Tolerances Type	Read / Write
0x803	Purge Defini- tion - Duration	#### (seconds)	Read / Write
0x804	Style 1 Definition - Volume	#####.# (cc)	Read / Write
0x805	Style 1 Definition - Pressure	Pressure: #### (psi); ###.# (bar); ##.## (Mpa)	Read / Write
0x806	Style 1 Defini- tion - Toler- ances	Tolerances Type	Read / Write
0x807	Style 1 Definition - Precharge Settings	Precharge Settings Type	Read / Write
0xBFC	Style 255 Defi- nition - Volume	#####.# (cc)	Read / Write
0xBFD	Style 255 Defi- nition - Pres- sure	Pressure: #### (psi); ###.# (bar); ##.## (Mpa)	Read / Write
0xBFE	Style 255 Defi- nition - Toler- ances	Tolerances Type	Read / Write
0xBFF	Style 255 Defi- nition - Pre- charge Settings	Precharge Settings Type	
0xC04	Style 1 Defini- tion - Name	STR_3_0	Read / Write
0xC05	Style 1 Definition - Name	STR_7_4	Read / Write
0xC06	Style 1 Definition - Name	STR_11_8	Read / Write
0xC07	Style 1 Definition - Name	STR_15_12	Read / Write
0xC3C	Style 15 Definition - Name		Read / Write
0xC3D	Style 15 Defini- tion - Name	STR_7_4	Read / Write

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Output Bits		Units *See Units	Read or
256-267	Description	Definitions , page 145	Write
0xC3E	Style 15 Defini-	STR_11_8	Read /
	tion - Name		Write
0xC3F	Style 15 Definition - Name	STR_15_12	Read / Write
0x29E	Pressure Units	Pressure Units Enu- meration	Read / Write
0x29F	Rate Units	Rate Units Enumera- tion	Read / Write
0x2A0	Maintenance Volume Units	Volume Units Enumeration	Read / Write
0x2A1	Maintenance Mass Units	Mass Units Enumera-	Read / Write
0x2A2	Maintenance Time Units	Mass Units Enumera- tion	Read / Write
0x2AD	Valve 1 Swirl Association (Swirl Zone)	Swirl Enumeration	Read / Write
0x2AE	Valve 2 Swirl Association (Swirl Zone)	Swirl Enumeration	Read / Write
0x2AF	Valve 3 Swirl Association (Swirl Zone)	Swirl Enumeration	Read / Write
0x2B0	Valve 4 Swirl Association (Swirl Zone)	Swirl Enumeration	Read / Write
0x2B5	End Job On Alarm	Boolean	Read / Write
0x3FB	Style Bits	###	Read / Write
0x115	Command Value	uint12	Read / Write
0x116	Error Reset / Remote Start	Dispense Control 2 Bit- field	Read / Write
0x118	Disable Dis- pensing	Boolean	Read / Write
0x3FF	Dispense Control	Dispense Control 1 Bit- field	Read / Write
0x0FB	Inlet Pressure	Pressure: #### (psi); ###.# (bar); ##.## (Mpa)	Read Only
0x0FC	Outlet Pressure	Pressure: #### (psi); ###.# (bar); ##.## (Mpa)	Read Only
0x0DC	Pressure Com- mand	Pressure: #### (psi); ###.# (bar); ##.## (Mpa)	Read Only
0x403	Flowrate Com- mand	##### cc/min	Read Only
0x404	Flowrate Actual	##### cc/min	Read Only
0x406	Fluid Plate Status 0	Fluid Plate Status 0 bitfield	Read Only

Output		Units	
Bits	December	*See Units	Read or Write
256-267	Description	Definitions , page 145	write
0x409	Fluid Plate Faults	Gateway Error Num- ber	Read Only
0x0FF	Fluid Plate Dispensed Volume	#####.# (cc)	Read Only
0x0DB	Active Fault Error Code	Fault Error Code	Read Only
0x0F8	Fluid Plate Sta- tus Bits	Fluid Plate Status bit- field	Read Only
0x0FE	Requested Volume	#####.# (cc)	Read Only
0X0D5	Job Percent Error	#####.#	Read Only
0x0D6	Selected Style	###	Read Only
0x0D7	Target Volume	#####.#	Read / Write
0x100	Enable Fluid Plate	xx	Read / Write

Maintenance dispensed volume/time can only be set to 0.

Swirl Commands

			1
Output Bits 264-275	Description	Gateway Units	Read or Write
0x004	Software Part Number	STR_3_0	Read Only
0x005	Software Part Number	STR_7_4	Read Only
0x006	Software Part Number	STR_11_8	Read Only
0x007	Software Part Number	STR_15_12	Read Only
0x00B	Software Version	Version	Read Only
0x400	Swirl Speed Source	Speed Source Enumeration	Read / Write
0x401	Swirl Fixed Speed	##### (RPM)	Read / Write
0x403	Swirl Speed Scaling	### (percent)	Read / Write
0x404	Swirl Maintenance Time Advisory Limit	##### (hours)	Read / Write
0x3FF	Swirl - Actual Run Time	##### (hours)	Read / Write
0x2FC	Swirl Status Bits 1	Swirl Status Bit- field 1	Read Only
0x4FE	Swirl Actual Speed	##### (RPM)	Read Only
0x500	Swirl Control	Swirl Control Enumeration	Read / Write
0x501	Swirl Requested Speed	uint12	Read / Write

Units Definitions

Unit s String	Definition		
Command Value Source Enumeration	0 - Display, 1 - Command Cable, 2 - Gateway		
Dispense Control 1 Bitfield	BitFunction 3Valve 2 On 6Error Reset 0Style Strobe 4Valve 3 On 7Remote Start/Purge 1Dispense Complete 5Valve 4 On 2Valve 1 On		
Dispense Control 2 Bitfield	Bit 14 - Error Reset, Bit 15 - Remote Start		
Dispense Trigger Source Enumeration	0 - Command Cable, 1 - Gateway, 2 - Combined, 3 - Command Cable 3x		
Error Type Enumeration 1	0 - None, 1 - Alarm, 2 - Deviation		
Fault Error Code	A 32-bit string in the format of 0xDDCCBBAA where 0xAA represents the most significant ASCII character in the string and 0xDD represents the least significant character in the string.		
Flow Meter Type Enumeration	1 - Volume, 2 - Mass		
Fluid Plate Status 0 Bitfield	Bit Function 3 Dispense In Process 7 Purge in Process/Remote 0 0 Dispense Ready 4 Dispensed Volume OK Start in Process 1 Dispense No Alarm 5 Dispense No Error 6 Dispense Purge Request		
Fluid Plate Status 3 Bitfield	Bit Function 11 Alarm Active 24 Valve 3 Swirl Installed 0-2 Operation Mode (see Valve Mode Enumeration) 12 Deviation Active Deviation Active 25 Valve 4 Swirl Installed 3 Precharge Active Active 14 Dispensing Disabled Dispensing Disabled Dispensing Disabled Dispensing Disabled Plate Enabled Dispension Dispensio		
Job End Mode Enumeration	0 - Timer, 1 - Gateway		
Maintenance Units Enumeration			
Mass Units Enumeration	0 - lb, 1 - kg		
Precharge Settings Type	A 32 bit value in the format of 0xDDCCBBA: 0xAPrecharge mode enumeration: 0 - Display, 1 - Gateway, 2 - Valve 1 0xBBBPrecharge valve opening duration (ms) 0xCCPrecharge scale - valve closed (%) 0xDDPrecharge scale - valve opening (%)		
Pressure Units Enumeration	0 - psi, 1 - bar, 2 - MPa		
Rate Units Enumeration	0 - x/min, 1 - x/sec		
sint32	A 32 bit positive or negative value		
Speed Source Enumeration	0 - Display, 1 - Gateway		
STR_X_Y	A 32 bit value where X signifies which character in the string that the most significant byte represents and Y signifies which character in the string that the least significant byte represents.		
Swirl Control Enumeration	0 - Swirl Enable		
Swirl Enumeration	0 - None, 1 - Swirl 1, 2 - Swirl 2, 3 - Swirl 3, 4 - Swirl 4		
Swirl Status Bitfield 1	0 - Swirl Active, 1 - Swirl Ready, 2 - Swirl Enabled		
Tolerances Type	A 32 bit value in the format of 0x0000BBAA where 0xAA represents the low tolerance (%) and 0xBB represents the high tolerance (%). A value of 0 means that tolerance is disabled.		
Valve Mode Enumeration	0 - Pressure, 1 - Bead, 2 - Shot, 3 - Full Open, 5 - None		
uint12	A 12 bit positive value		
uint32	A 32 bit positive value		
Version	A 32 bit value in the format of 0x00CCBBAA where 0xAA represents the major version, 0xBB represents the minor version and 0xCC represents the build version.		
Volume Units Enumeration	0 - gal(US), 1 - gal(UK), 2 - Liters		

Appendix D - I/O Signal Descriptions

This section provides details about the CGM and DGM Automation Input and Output signals.

Automation Inputs

Dispenser (Fluid Plate) Ready

This signal is 0 on power up. This signal will be 1 under in the following conditions:

- The system is in an active state, and
- The dispenser (fluid plate) does not have an active Alarm (Deviations have no effect).

Dispenser (Fluid Plate) No Alarm

For systems with a CGM, this signal will be 1 under the following condition:

- The system does not have an alarm.
- For systems with a DGM, this signal can be configured to be active high or active low. See Discrete Gateway (Automation) Setup Screen, page 109.

Dispenser (Fluid Plate) No Error

For systems with a CGM, this signal will be 1 under the following condition:

- The system does not have an error (alarm, deviation, or advisory).
- For systems with a DGM, this signal can be configured to be active high or active low. See Discrete Gateway (Automation) Setup Screen, page 109.

Dispense in Process

This signal is 0 on power up. This signal will be 1 under the following condition:

The system is in the middle of a job.

Dispense Volume OK

This signal will be 1 under the following conditions:

- The system has completed a job, and
- the volume of the job is within the tolerance specified, and
- the style strobe is 1.

Dispenser (Fluid Plate) Purge Request

This signal is 1 on power up if a purge interval has been defined, 0 on power up otherwise. Any dispensing will turn off this bit and reset the purge timer. This signal will be 1 under the following condition:

The system purge interval timer has expired.

Dispenser (Fluid Plate) Remote Start / Purge in Process

This signal is 0 on power up. This signal will be 1 under the following conditions:

- A remote start sequence is in process. This signal shall remain asserted until the dispense equipment has achieved Dispense Ready status.
- A purge sequence is in process. This signal shall remain asserted until the purge sequence is complete.

Units

All units settings are set in the Advanced Display Module. The following signals are used to communicate this information to the automation controller.

Pressure Units

Value	Units
0	psi
1	bar
2	MPa
3	reserve

Errors

Error numbers are formed by 8 bits. This is the error number in the system.

Automation Outputs

Style

The desired style of the next job. These 8 bits are read at the start of a job to determine the selected style.

Style Strobe

This bit is used to start a new job. A new job is started when the style strobe changes from 0 to 1.

Dispense Complete

This bit is used to signal the end of a job. A job is ended when this signal changes from 0 to 1.

Dispense Valve X On

These 4 bits are used to signal the turn on and turn off of each of the 4 dispense valves on the applicable fluid plate.

Command Value

This 12 bit value indicates the analog command value from 0-10Volts (0x000-0xFFF). This analog value is scaled to a flow rate (in bead mode) or pressure (in pressure or shot mode) command based on the configured scale factor.

Error Reset / Cancel Job

If the "End Job On Alarm" setting is enabled:

- If in a job, setting this bit will cancel the current job.
- If not in a job, setting this will reset errors.

If the "End Job On Alarm" setting is disabled:

 Setting this bit will reset errors regardless of job status.

Remote Start / Purge

This bit is used to restart the dispense system from any "not-ready" state. If the system is already in a Dispense Ready state, this signal shall initiate a purge based on the configured purge parameters.

Swirl X Enable

This bit is used to signal the on and off status of each swirl dispenser motor.

Swirl Command Value

This 12-bit value indicates a swirl speed command from 0-10 volts. 0 volts (0x000) represents a speed of 6,600 rpm and 10 volts (0xFFF) represents 24,000 rpm.

Dispense Valve X Precharge On

These 4 bits are used to turn on precharge for each of the 4 dispense valves when the precharge mode is set to Gateway.

Technical Data

	6 cc/minute with ultra-high resolution (ambient) helical flow meter 25 cc/minute with high-resolution (ambient) helical flow meter 50 cc/minute with heated helical flow meter 661 cc/minute with Coriolis flow meter 4,000 cc/minute with ultra-high resolution (ambient) helical flow meter 7,500 cc/minute with high-resolution (ambient) helical flow meter 22,500 cc/minute with heated helical flow meter 65,535 cc/minute with Coriolis flow meter
Maximum Fluid Working Pressure	
feed pressure to fluid plate (cartridge regulator) feed pressure to fluid plate (mastic regulator) at regulator outlet	5000 psi (35 MPa, 345 bar) 4500 psi (31 MPa, 310 bar)
tridge regulator)	5000 psi (35 MPa, 310 bar)
Minimum Fluid Working Pressure (at regulator outlet)	
Air Supply Pressure Range	60-120 psi (0.4 - 0.8 MPa, 4.1- 8.3 bar) - 10 Micron filtration
Fluid Filtration Required* *Viscosity Range of Fluids *Minimum Dispensed Shot Size	
Wetted Parts (meters and fluid plates)	303, 304, 321, 17- 4 stainless steel; tungsten carbide, PTFE, steel, fluoroelastomer
Power Requirements 100-240 Vac 24 Vdc Power Supply Voltage Range Operating Temperature Range control center heated fluid plate	full load-4A, fuse rating-4A 100-240 Vac, 50-60 Hz, single phase 40°F (4°C) - 120°F (49°C) 40°F (4°C) - 400°F (204°C)
ambient fluid plate	, ,
- p	

^{*} Flow rates and viscosities are general estimates. Flow rates drop as viscosity increases. Fluids are expected to shear under pressure. New applications or fluids should always be tested to determine proper line sizes and equipment selections. See your Graco authorized distributor for other capabilities.

Swirl Dispenser Technical Data

Refer to manual 309403.

Fluid Plate Assembly Technical Data

Mounting dimensions and parts breakdowns for the fluid plate assemblies are in the installation section of this manual.

	Cartridge Regulator	Mastic Regulator
Regulator Manual	308647	307517
Weight - No Flow Meter	25.5 lb (11.6 kg)	33 lb (15 kg)
Weight - Helical	40 lb (18 kg)	48 lb (22 kg)
Weight - Coriolis Flow Meter	20 lb (9 kg)	N/A
Fluid Port Inlet	Helical: 3/4 in. npt(f)	3/4 in. npt(f)
Fluid Port Outlet	1/2 in. npt(f)	3/4 in. npt(f)
Maximum Fluid Working Pressure*	See Models on page 4	See Models on page 4
Air Supply	1/4 in. npt(f)	1/4 in. npt(f)
Maximum Air Working Pressure	100 psi (0.7 MPa, 7.0 bar)	100 psi (0.7 MPa, 7.0 bar)
Minimum Air Working Pressure	60 psi (410 kPa, 4.1 bar)	60 psi (410 kPa, 4.1 bar)
Fluid Operating Temperature	Ambient 40° - 120°F (4° - 50°C)	Heated 40° - 400°F (4° - 204°C) Ambient 40° - 120°F (4° - 50°C)
Minimum Flow Rate - Helical	Ambient 190 cc/min	Heated 190 cc/min Ambient 190 cc/min

^{*}Maximum system pressure depends on dispense valve.

Air outlets, open and close to dispense valve	5/32 in. (4 mm) tube fittings
Electric Power Requirements	24 Vdc or 100-240 Vac
Power Supplied to Dispense Valve Solenoid(s)	24 Vdc
Fluid Specifications	For use when dispensing fluids that meet at least one of the following conditions for non-flammability:
	The fluid has a flash point above 140° F (60° C) and a maximum organic solvent concentration of 20% by weight, per ASTM Standard D93.
	The fluid does not sustain burning when tested per ASTM Standard D4206 Sustained Burn Test.
Ambient Air Temperature Range	40° to 120° (4° to 50° C)

Control Center Assembly Technical Data

	100 - 240 Vac Assemblies	24 Vdc Assembly
Voltage	100-240 Vac	24 Vdc
Phase	1	
Frequency	50-60 Hz	
Full Load Current	1.4 A	4.0 A
Fuse Rating	250 Vac, 2.5A T	125 Vac, 4A F
Control Box Weight	25.5 lbs (11.6 kg)	

Graco Standard Warranty

Graco warrants all equipment referenced in this document which is manufactured by Graco and bearing its name to be free from defects in material and workmanship on the date of sale to the original purchaser for use. With the exception of any special, extended, or limited warranty published by Graco, Graco will, for a period of twelve months from the date of sale, repair or replace any part of the equipment determined by Graco to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with Graco's written recommendations.

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