

KNOWLEDGE BOOK



T300
Extreme®



T600
Extreme™



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PID Settings

Hot Air

KP	60
TI	520
TD	20
High Temp Limit	730
High Temp Alarm	740
Max. Output Power	89.0

Hot Wedge

KP	60
TI	520
TD	20
High Temp Limit	450
High Temp Alarm	470
Max. Output Power	89.0

Stepper Drive

Dip Switch settings

SW1	OFF
SW2	OFF
SW3	ON
SW4	OFF
SW5	ON
SW6	ON
SW7	OFF
SW8	ON

HMI

Replace Battery

- 1) Remove the access cover from the back of the T-300, this is held in place with 4 screws.



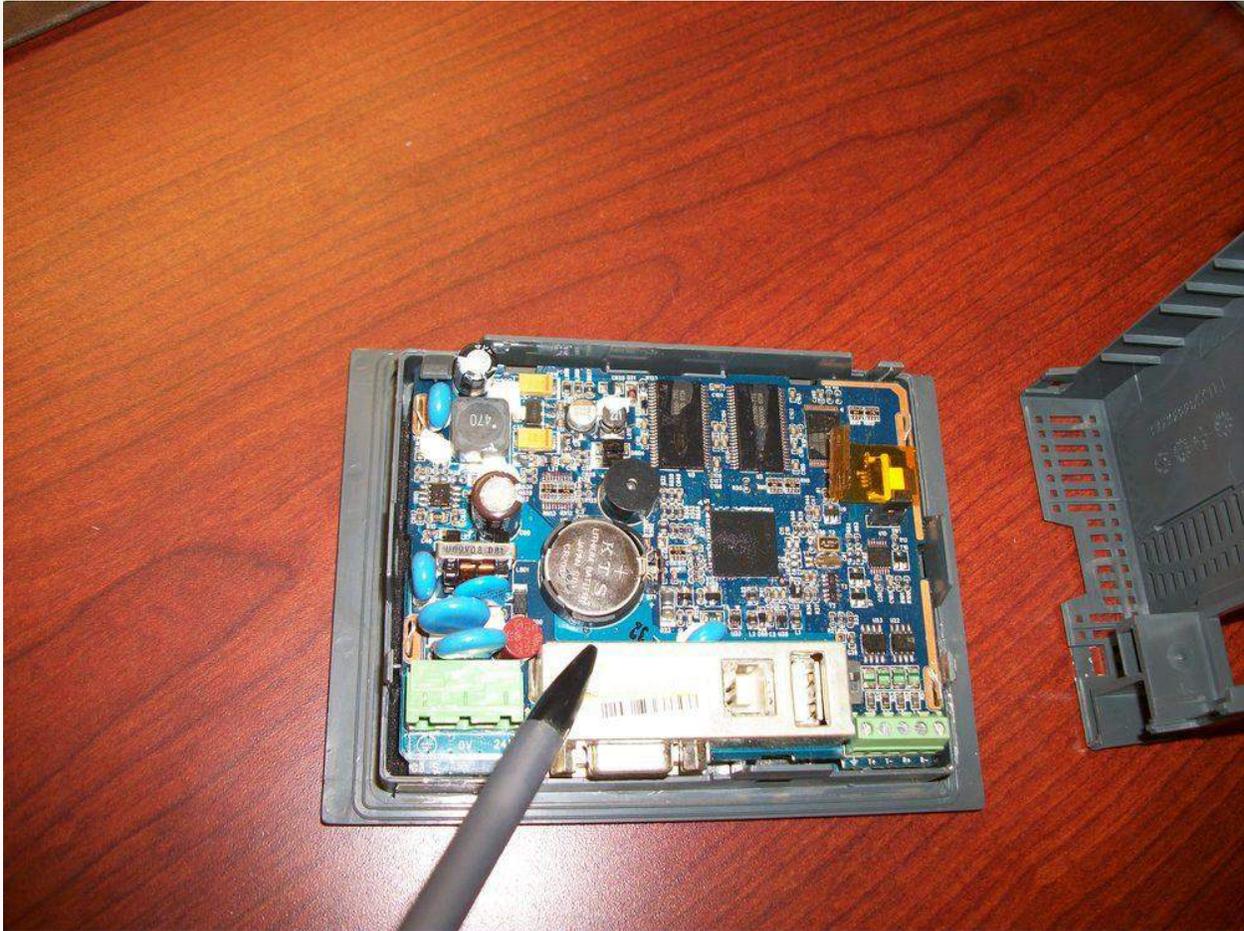
- 2) Remove the center nut this will release the retaining strap that holds the HMI in the head of the T-300.



- 3) When removing the HMI you will need to use caution not to damage the wires that are attached to the plug.



- 4) Once the HMI is removed from the machine the back cover will need to be removed to access the battery.



- 5) When the cover has been removed you can remove the old battery, then install the new battery and reinstall the back cover.
- 6) After the new battery has been installed the HMI can be reinstalled back into the T-300.

PLC

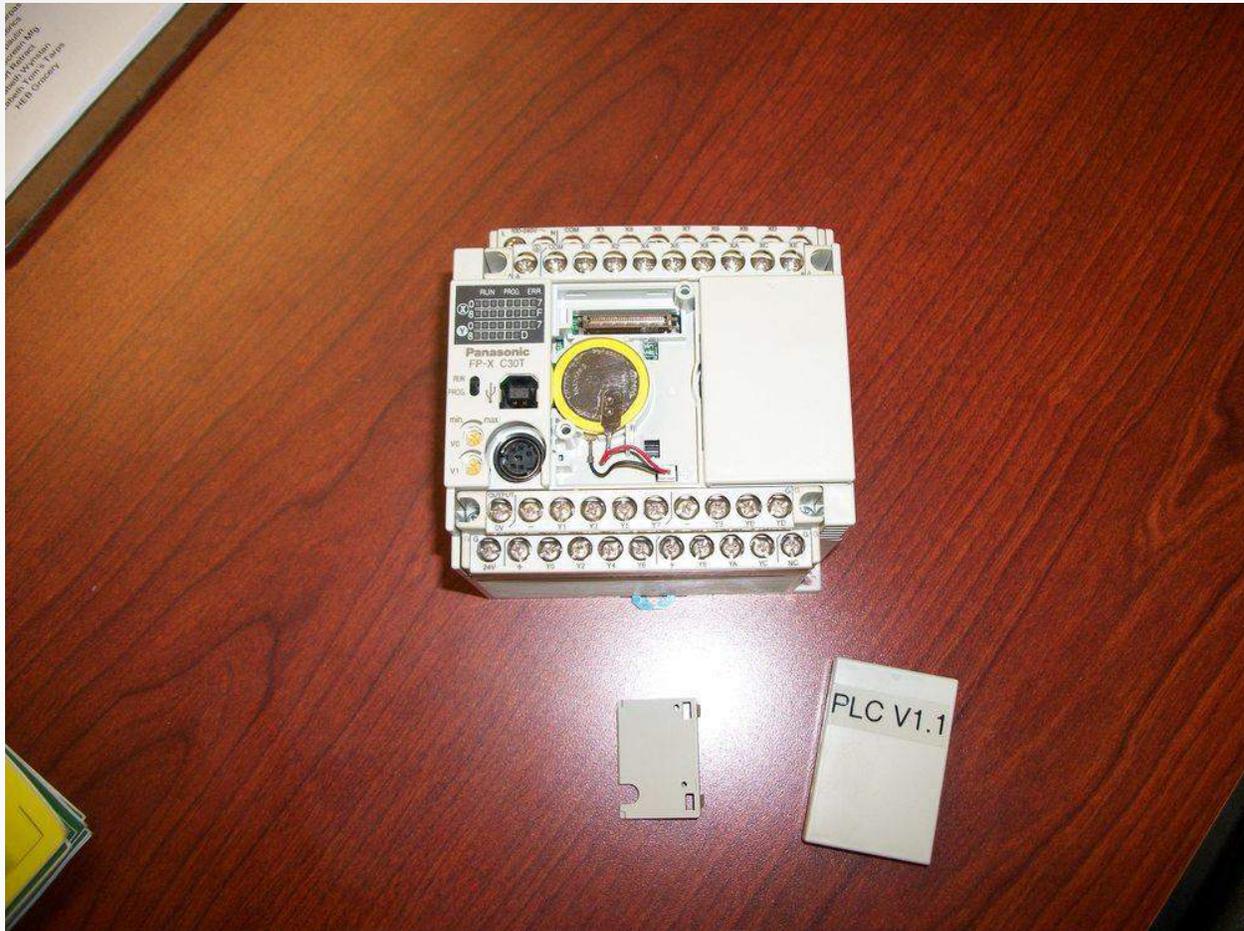
Replace Battery

When replacing the PLC battery it is important to have the machine **POWER ON** during the entire procedure to ensure there is no memory loose.

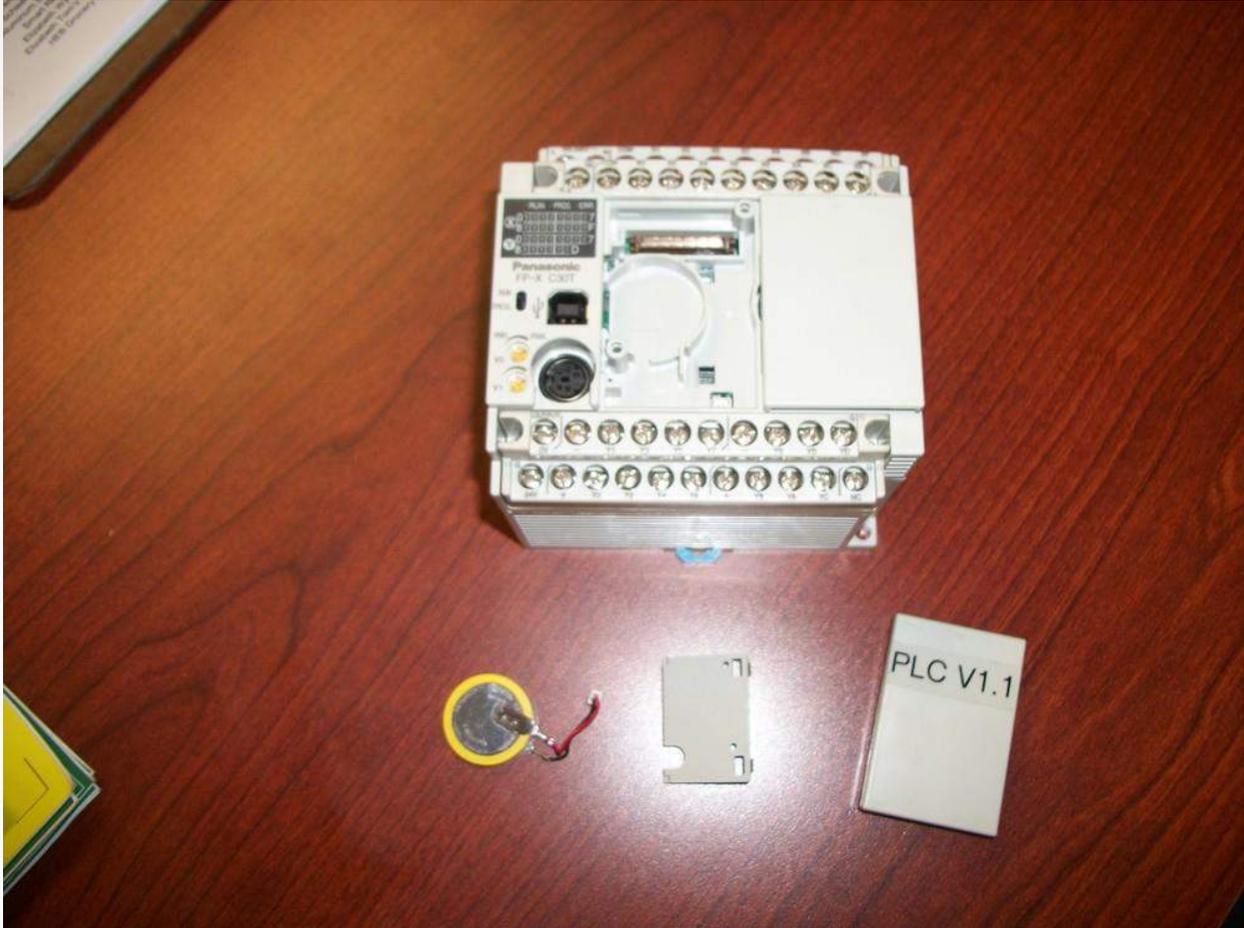
- 1) Remove access cover from PLC.



2) Remove battery cover.



3) Remove battery.



4) Install new battery and replace the battery and access cover and the machine should be good to proceed with normal operation.

General Knowledge

- 1) 90 PSI input air pressure
- 2) 0.2 PSI weld roller air pressure
- 3) Speed is meter/min
- 4) Weld roller speed:
 - a) Hem – 101
 - b) Pockets – 100
- 5) Heat has to be off when changing recipes

Lockout Code (System Tool Check)

If the T-300's Lockout Code (System Tool Check) is turned on there will be a small black indicator light in the lower right corner of the Menu Screen. If this function is turned off the indicator light will be white.

If this function is turned on the machine will lock out at the first of every month, and will stay locked out until a new System Tool Code is entered.

To turn the T-300's Lockout Code (System Tool Check) on. The installing Tech must:

1. Turn on the Heat Swing.
2. Set the machine direction to reverse.
3. Press and hold the Weld Roller Foot Pedal.
4. Press and hold the Version Number in the Menu Screen at the same time.

The HMI will change to the Enter System Tool Code Screen where the tech will have to enter that month's System Tool Code. Then installing tech will press the Exit button.



Note:

The tech should verify that the Lock Code (System Tool Check) is turned on, by looking for the indicator light to turn black in the lower right corner of the Menu Screen.

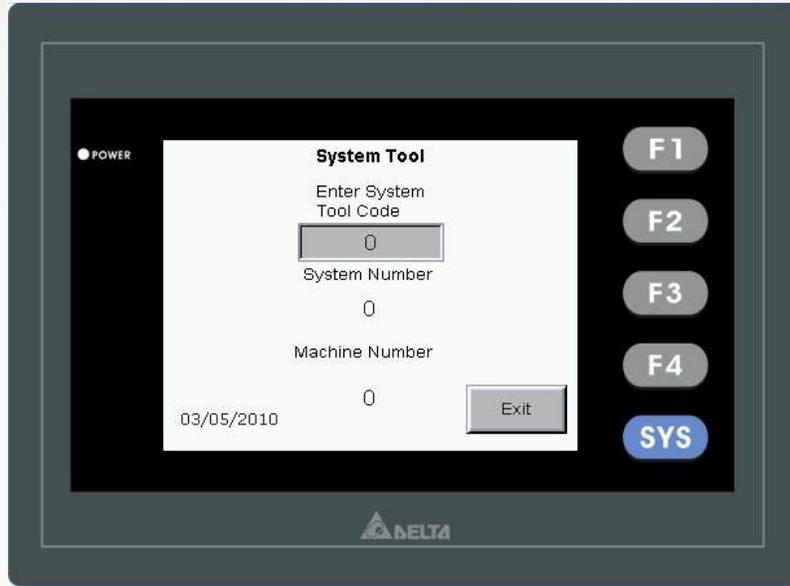
Customer Operation:

When the Enter System Tool Code Screen appears, the customer will need to call into the supplier with the machine date (located in the lower corner of the System Tool Code Screen), the machines last 4 digits of the serial number, and the system number. If the customer's account is good the supplier will take the information from the customer and enter that into the spreadsheet. The spreadsheet will calculate a new System Tool Code Number. The customer will need to then enter the new System Tool Code into the System Tool Code Entry box. Then press the Exit button in the lower right corner.

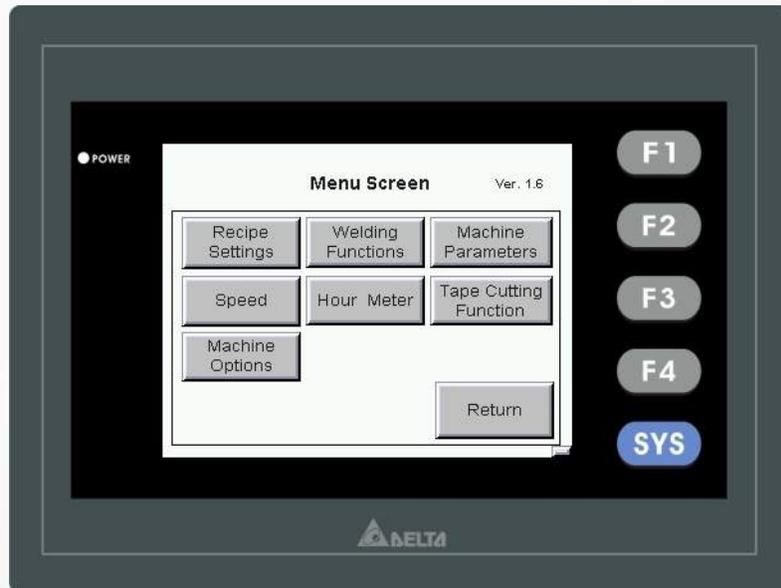
To turn the Lockout Code (System Tool Check) completely off, the customer will need to enter the Master System Tool Code. This works on the same concept as the above System Tool Code. The customer will need to give the supplier the System Number and the machines last 4 digits of the serial number. The supplier will enter this information into a spreadsheet and the Master Tool Code will be calculated.

Once the customer enters either the System Tool Code or the Master System Tool Code, the customer will need to press the Exit button on the lower right corner of the screen. This will take them back the Main Screen.

Below is a picture of what the System Tool Code Screen looks like.



Below is a picture of the Menu Screen. Showing the Version Number (Hidden Push Button in the upper right) and the System Tool Code on/ off indicator light (lower right).





Revision Level	Date	Description	Author
1.0	4/15/2016	Initial Release	B. Mills

For additional questions, please contact service@weldmaster.com or call 330-833-6739