

Customer: WAYNA FARMS

8/10/2018

Model : TF400V

Serial No.: 4269-R

## Full Load Amp (FLA) Rating

(Rated at 460VAC, 60Hz, 3 Phase)

### Machine Power

Item	Description	FLA
1	Vacuum Pump Motor (5/8 HP)	0.85
2	Main Drive Motor (1 HP)	1.90
3	Control Circuits (500 VA Transformer)	1.09
4	ITW Dynatec Dynamelt SR10 (2 Hose/Guns)	7.50
Total FLA		11.34

Largest Motor: Horsepower	1HP
FLA	1.9A

SCCR (RMS): Current Maximum	5kA
Voltage Maximum	480V

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8/14/2018

Model : TF600V

Serial No.: 4269-R

## Main Drive Settings

PowerFlex 525 (25B-D4P0N104) Drive, 460 VAC 3 Phase 60 Hz (2 HP)

Code	Function	Factory Setting	SWF Settings	Setting Description
31	Motor NP Volts	460	460	
32	Motor NP Hertz	60	60	
33	Motor OL Current	4.0	2.0	Set to Motor Name Plate FLA
34	Motor NP FLA	2.9	2.0	Set to Motor Name Plate FLA
35	Motor NP Poles	4	6	Set to Motor Name Plate Poles
36	Motor NP RPM	1750	1140	Set to Motor Name Plate RPM
37	Motor NP Power	1.50	0.75	Set to Motor Name Plate Power
41	Accel Time 1	10.0	0.20	Accel Ramp Time (Secs)
42	Decel Time 1	10.0	0.15	Decel Ramp Time (Secs)
43	Minimum Frequency	0.0	25.0	
44	Maximum Frequency	60	85	
45	Stop Mode	0	0	Ramp CF
46	Start Source1	1	2	Digital In Terminal Block
47	Speed Reference1	1	15	Speed Reference over Ethernet I/P
53	Reset to Defaults	0	0	Reset to Default parameters (2 = Reset)
62	Digital In Term Blk 02	48	48	Assign Input 2-Wire FWD
63	Digital In Term Blk 03	50	50	Assign Input 2-Wire REV
64	2-Wire Mode	0	1	Level Sense
81	Relay Out2 Sel	2	29	Safe-Off
128	EN Addr Sel	2	1	IP Address set by Parameters
129	EN IP Addr Cfg1	0	192	IP Address 192.168.0.3
130	EN IP Addr Cfg2	0	168	IP Address
131	EN IP Addr Cfg3	0	0	IP Address

132	EN IP Addr Cfg4	0	3	IP Address
133	EN Subnet Cfg1	0	255	Subnet Mask 255.255.255.0
134	EN Subnet Cfg2	0	255	Subnet Mask
135	EN Subnet Cfg3	0	255	Subnet Mask
136	EN Subnet Cfg4	0	0	Subnet Mask
434	DC Brake Time	0.0	0.5	DC braking time-duration
435	DC Brake Level	0.2	0.5	DC braking level x drive rated amps
437	DB Resistor Select	0	1	1 = Normal RA Res
541	Auto Restart Tries	0	0	
542	Auto Restart Delay	1.0	1.0	Secs

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## Glue & Cam Settings

(MicroLogix 1400 & Panelview Plus 400)

### Global Settings

Description	Value	Units
Time Delay	1.0	secs
Downstream Stop Delay	10.0	secs
Downstream Start Delay	0.0	secs
Glue Scale Factor	31.8	pulses/inch
Glue Trigger Offset	3.5	inches
Glue Speed Compensation	32	msecs

### Product Settings

Glue Settings	Product 1 Value	Product 2 Value	Product 3 Value	Product 4 Value	Product 5 Value	Units
Outside Glue Gun Bead 1	Offset	0.5	0.7			inches
	Length	1.0	1.0			inches
Outside Glue Gun Bead 2	Offset	4.0	4.0			inches
	Length	2.5	3.0			inches
Outside Glue Gun Bead 3	Offset	9.8	11.0			inches
	Length	6.0	6.2			inches
Middle Glue Gun Bead 1	Offset	0.5	0.7			inches
	Length	1.0	1.0			inches
Middle Glue Gun Bead 2	Offset	4.0	4.0			inches
	Length	2.5	3.0			inches
Middle Glue Gun Bead 3	Offset	9.8	11.0			inches
	Length	6.0	6.2			inches
Inside Glue Gun Bead 1	Offset	0.5	0.7			inches
	Length	1.0	1.0			inches
Inside Glue Gun Bead 2	Offset	4.0	4.0			inches
	Length	2.5	3.0			inches
Inside Glue Gun Bead 3	Offset	9.8	11.0			inches

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(MicroLogix 1400 &amp; Panelview Plus 400)

Length	6.0	6.2				inches
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## Glue & Cam Settings

(MicroLogix 1400 &amp; Panelview Plus 400)

### Product Settings

Misc Settings	Product 1 Value	Product 2 Value	Product 3 Value	Product 4 Value	Product 5 Value	Units
Machine Speed	70(20BPM) w/T.D.	70(20BPM) w/T.D.				Hz

Cam Settings	Product 1 Value	Product 2 Value	Product 3 Value	Product 4 Value	Product 5 Value	Units
Cycle Stop Cam	On	355	3558			degrees
	Off	315	320			degrees
Air Pushers Cam	On	320	320			degrees
	Off	345	345			degrees
Top Flap Tuckers Cam	On	285	280			degrees
	Off	315	315			degrees
Bottom Flap Tuckers Cam	On	140	160			degrees
	Off	295	295			degrees

Cam Speed Compensation Settings	Value	Units
Air Pushers Speed Compensation	140	msecs
Flap Tuckers Speed Compensation	160	msecs



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8/16/2018

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[www.swfcompanies.com](http://www.swfcompanies.com)

## Kwik Change Meter Settings

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**Machine Serial No. 4269-R**

No.		Spec. #1 Dot 1	Spec. #2 Dot 2	Spec. #3	Spec. #4
1	<b>Bottom Stops</b>	00000	00470		
2	<b>Hoppers Brackets</b>	00000	00528		
3	<b>Vertical Guides</b>	00000	00025		