Thiele Technologies

SWF — A Barry-Wehmiller Company

Customer: **WAYNA FARMS**   8/10/2018
Model : **TF400V**   Serial No.: **2147-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

Customer: **WAYNA FARMS** 8/14/2018

Model : **TF600** Serial No.: **2147-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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Customer: **WAYNE FARMS**

Model : **TF600VB**   Serial No.: **2147-R**

Glue & Cam Settings
(MicroLogix 1400 & Panelview Plus 400)

Global Settings

Description	Value	Units
Time Delay	0.8	secs
Downstream Stop Delay	5.0	secs
Downstream Start Delay	0.0	secs
Glue Scale Factor	43.9	pulses/inch
Glue Trigger Offset	4.6	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	6.3	7.0				inches
	Length	3.7	4.0				inches
Outside Glue Gun Bead 2	Offset	17.6	17.3				inches
	Length	3.7	4.0				inches
Outside Glue Gun Bead 3	Offset						inches
	Length						inches
Inside Glue Gun Bead 1	Offset						inches
	Length						inches
Inside Glue Gun Bead 2	Offset						inches
	Length						inches
Inside Glue Gun Bead 3	Offset						inches
	Length						inches

Glue & Cam Settings

(MicroLogix 1400 & 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)	70(20BPM)				Hz

Cam Settings		Product 1 Value	Product 2 Value	Product 3 Value	Product 4 Value	Product 5 Value	Units
Cycle Stop Cam	On	355	355				degrees
	Off	335	335				degrees
Air Pushers Cam	On	290	275				degrees
	Off	330	320				degrees

Kwik Change Meter Settings

Customer: Wayne Farms

Machine Serial No. 2147-R

No.		Spec. #1 M2B Export 5" Body	Spec. #2 M2C 5" Lid	Spec. #3	Spec. #4
1	**Bottom Stops**	00000	00000		
2	**Hoppers Brackets**	00000	00227		
3	**Vertical Guides**	00052	99801		
4	**Top Compression**	99999	00170		
5	**Side Compression**	99994	99897		
6	**Lower Hopper Bracket**	Up Position	Down Position		
7	**Front Vertical Guide Blank Guide**	Blank Guide ON			
			Blank Guide OFF Note: add additional vertical guide small bent guides		