

RES-445

Operating Instructions



Important features

- Microprocessor technology
- LC display (green), 4 lines, 20 characters, (multilingual)
Alternatively: VF display (blue), 4 lines, 20 characters, (multilingual)
- Automatic zero calibration (AUTOCAL)
- Automatic optimization (AUTOTUNE)
- Automatic configuration of the secondary voltage and current ranges (AUTORANGE, as of software revision 100)
- Automatic phase angle compensation (AUTOCOMP, as of software revision 100)
- Automatic frequency adjustment
- Large current and voltage range
- Booster connection as standard
- Heatsealing band alloy and temperature range selectable
- Time control, heatsealing time and cooling time settable
- Preheating
- Configurable relay output, e.g. "end of cycle"
- Time or temperature-controlled cooling phase
- Signal output for "Temperature OK"
- 0...10VDC analog input for set point selection, electrically isolated
- 0...10VDC analog output for ACTUAL temperature, electrically isolated
- 24VDC control inputs for AUTOCAL, PREHEAT and RESET, electrically isolated
- Alarm function with fault diagnosis

Identical design to and compatible with RES-225

Contents

1	General information	4	10	Controller functions	34
1.1	Copyright	4	10.1	Indicators and controls	35
1.2	Intended use	4	10.2	Display	35
1.3	Heatsealing band	4	10.3	Navigation in the menus	37
1.4	Impulse transformer	5	10.4	Menu structure	39
1.5	Current transformer PEX-W4/-W5	5	10.5	Two-digit numbering system up to software revision 027	41
1.6	Line filter	5	10.6	Menu steps	42
1.7	Maintenance	5	10.7	Temperature setting (set point selection)	50
1.8	Transportation	5	10.8	Temperature indication/actual value output	52
1.9	Disposal	6	10.9	Automatic zero calibration (AUTOCAL)	54
2	Application	8	10.10	"START" signal (HEAT)	55
3	Principle of operation	8	10.11	"PREHEAT" signal (preheating)	56
4	Description of the controller	9	10.12	"RESET" signal	59
5	Accessories and modifications	10	10.13	Cycle counter	59
5.1	Accessories	10	10.14	Hold mode	60
5.2	Modifications (MODs)	11	10.15	Measuring impulse duration (as of software revision 026)	61
6	Technical data	13	10.16	Automatic phase angle compensation (AUTOCOMP) (as of software revision 100)	62
7	Dimensions/front panel cutout	15	10.17	Locking the "HAND" key (as of software revision 100)	63
8	Installation	16	10.18	Temperature unit Celsius / Fahrenheit (as of software revision 106)	63
8.1	Installation procedure	16	10.19	Disabling the Configuration menu	63
8.2	Installation steps	17	10.20	Setting the display brightness (VF display only)	64
8.3	Power supply	18	10.21	Undervoltage detection	64
8.4	Line filter	19	10.22	Diagnostic interface/visualization software (as of software revision 100)	66
8.5	Current transformer PEX-W4/-W5	19	10.23	Booster connection	66
8.6	Wiring diagram (standard)	21	10.24	Time control (timer function)	67
8.7	Wiring diagram with booster connection	22	10.25	System monitoring/alarm output	79
9	Startup and operation	23	10.26	Error messages	80
9.1	Front view of the controller	23	10.27	Fault areas and causes	84
9.2	Rear view of the controller	23	11	Factory settings	86
9.3	Controller configuration	24	11.1	Customer settings (as of software revision 100)	88
9.4	Heatsealing band	31			
9.5	Startup procedure	33			

12	Maintenance	88
13	How to order	89
14	Index	91

1 General information

This RESISTRON® temperature controller is manufactured according to EN 61010-1. In the course of its manufacture it passed through quality assurance, whereby it was subjected to extensive inspections and tests. As a result of this, the product left our factory in perfect condition.

Please carefully read through the operating manual before using the RESISTRON® temperature controller. Keep the operating manual for later reference and make sure that information and functions important for the user are available.

The recommendations and warning notes contained in these operating instructions must be complied with, in order to guarantee safe operation.

The device can be operated within the limits indicated in the "Technical Data" without impairing its operational safety. Installation and maintenance may only be performed by technically trained, skilled persons who are familiar with the associated risks and warranty provisions.

1.1 Copyright

All contents, in particular texts, photographs and graphics, are protected by copyright. All rights, including to replication, publication, editing and translation, are reserved.

1.2 Intended use

RESISTRON® temperature controllers may only be used for heating and temperature control of heatsealing bands which are expressly approved for them, and providing the regulations, notes and warnings contained in these instructions are observed.

In case of non-observance or use contrary to the intended purpose, there is a risk that safety will be impaired or that the heatsealing band, electrical wiring, transformer etc. will overheat. This is the personal responsibility of the user.

1.3 Heatsealing band

The use of suitable heatsealing bands is a basic prerequisite for reliable and safe operation of the system.

The resistance of the heatsealing band which is used must have a positive minimum temperature coefficient in order to guarantee trouble-free operation of the RESISTRON® temperature controller.


The temperature coefficient must be specified as follows:

$$TCR = 10 \times 10^{-4} \text{K}^{-1} \text{ or } \text{K}^{-1} \text{ or ppm/K}$$

e.g. Alloy A20: TCR = 1100 ppm/K
LEX3500: TCR = 3500 ppm/K
Vacodil: TCR = 1100 ppm/K

The RESISTRON® temperature controller must be set and coded according to the temperature coefficient of the heatsealing band.

The temperature coefficient must be taken from the ROPEX application report and must be set accordingly.

 **The use of incorrect alloys with a too low temperature coefficient and incorrect coding of the RESISTRON® temperature controller leads to uncontrolled heating of the heatsealing band, which will ultimately burn out!**

The original heatsealing bands must be clearly identified by means of suitable markings as well as the connector geometry, length, or other means to ensure that replacement bands are identical.

1.4 Impulse transformer

A suitable impulse transformer is necessary in order to guarantee trouble-free operation of the control loop. This transformer must be designed according to EN 61558 or UL 5058 (isolating transformer with reinforced insulation) and have a one section bobbin. When the impulse transformer is installed, suitable touch protection must be provided in accordance with the national installation regulations for electrical equipment. In addition to this, water, cleaning solutions and conductive fluids must be prevented from seeping into the transformer.

Incorrect installation of the impulse transformer impairs electrical safety.

1.5 Current transformer PEX-W4/-W5

The current transformer supplied with the RESISTRON[®] temperature controller is an integral part of the control system.

Only the original ROPEX PEX-W4 or PEX-W5 current transformer may be used. Other transformers may cause the equipment to malfunction.

The current transformer may only be operated if it is correctly connected to the RESISTRON[®] temperature controller (see section "Startup and operation"). The relevant safety instructions contained in section "Power supply", must be observed. External monitoring modules can be used in order to additionally increase operating safety. They are not included in the scope of supply of the standard control system and are described in a separate document.

1.6 Line filter

ROPEX provides line filters in different power classes. The ROPEX application report lists the suitable line filter which can be ordered accordingly.

The use of an original ROPEX line filter is mandatory in order to comply with the directives mentioned in section "DECLARATION OF CONFORMITY" on page 7. This device must be installed and connected according to the instructions contained in section "Power supply" as well as the separate documentation enclosed with the line filter.

1.7 Maintenance

The controller requires no special maintenance. Regular inspection and / or tightening of the terminals – including the terminals for the winding connections on the impulse transformer – is recommended. Dust deposits on the controller can be removed with dry compressed air.



Dust deposits and dirt from liquids result in a loss of function. Accordingly, installation in a switch cabinet or terminal cabinet with IP54 is recommended.

1.8 Transportation

Store and transport the device in its original carton.

After transport, perform a visual inspection for possible damage.

1.9 Disposal



This device is subject to Directive 2012/19/EU concerning the reduction of the increasing amount of waste electrical and electronic equipment and the disposal of such waste in an environmentally sound way.

To guarantee proper disposal and / or the recover of reusable material, please take the device to a designated municipal collection point and observe local regulations.

Careless, uncontrolled disposal can cause damage to the environment and human health. By ensuring that your product is disposed of or recycled in a responsible way, you can help protect the environment and human health.



This device must not be disposed of as residual waste!

DECLARATION OF CONFORMITY

We hereby declare that the following device has been developed and manufactured in conformance with the directives cited below:

Designation: RESISTRON temperature controller with accessories
Type: RES-445 with line filter and current transformer
Operating principle: Impulse sealing of films and plastics

Compliant with following standards and directives:

EN 61010-1 Safety requirements for electrical equipment, control, and laboratory use
2014/35/EU low voltage directive
2014/30/EU electromagnetic compatibility directive
2011/65/EU RoHS directive

Note:

This declaration of conformity certifies that the device/electronic itself complies with the above-mentioned directives. The CE mark on the device/electronic does not relieve the machinery manufacturer of his duty to verify the conformity of the completely installed, wired and operationally ready system in the machine with the EMC directive.

Comments:

RESISTRON/CIRUS temperature controllers are not independently operable devices. They are used by the machinery manufacturer to form a sealing system by adding EMC-relevant components such as filters, transformers, heatsealing bands and wiring. The final configuration may vary significantly in terms of performance and physical dimensions. All information provided by us in connection with the line filter is merely intended as a guide and is based on a typical measuring setup. It serves to demonstrate that compliance with the EMC directive can be achieved by using a line filter that is suitable for the overall system. The line filter and current transformer must, however, be determined on the basis of the respective application. We also wish to point out that the transformer which is used must be designed in accordance with VDE 0551/EN 61558 or UL 5058 for safety reasons.

July 12, 2020



J. Kühner (CEO)

ROPEX Industrie-Elektronik GmbH
Adolf-Heim-Str. 4
74321 Bietigheim-Bissingen (Germany)

2 Application

This RESISTRON[®] temperature controller is an integral part of the "series 400", the outstanding feature of which is its microprocessor technology. All RESISTRON[®] temperature controllers are used to control the temperature of heating elements (heatsealing bands, beaded bands, cutting wires, heatsealing blades, solder elements etc.), as required in a variety of heatsealing processes.

The controller is most commonly used for impulse-heatsealing PE and PP films in:

- Vertical and horizontal f/f/s machines
- Pouch, filling and sealing machines
- Film wrapping machines
- Pouch-making machines
- Group packaging machines
- L-sealers
- etc.

The use of RESISTRON[®] temperature controllers results in:

- Repeatable quality of the heatseals under any conditions
- Increased machine capacity
- Extended life of the heatsealing bands and teflon coatings
- Simple operation and control of the sealing process

3 Principle of operation

The resistance of the heatsealing band, which is temperature-sensitive, is monitored 50x per second (60x at 60Hz) by measuring the current and voltage. The temperature calculated with the help of these measurements is displayed and compared with the set point.

The primary voltage of the impulse transformer is adjusted by phase-angle control if the measured values deviate from the set point. The resulting change in the current through the heatsealing band leads to a change in the band temperature and thus also its resistance. This change is measured and evaluated by the RESISTRON[®] temperature controller.

The control loop is closed: ACTUAL temperature = SET temperature. Even minute thermal loads on the heatsealing band are detected and can be corrected quickly and precisely.

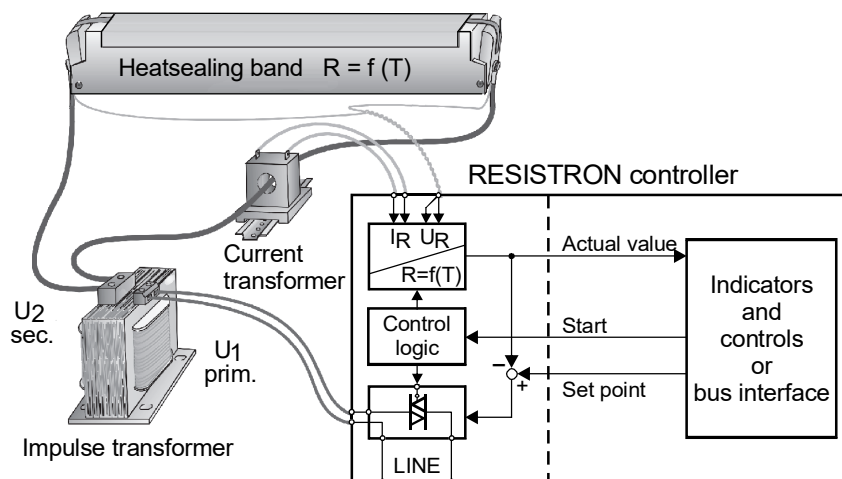
The thermoelectric control loop which is formed has a highly dynamic response because purely electrical variables are measured at a high sampling rate. A high secondary current can be controlled with only minimal power loss because power is controlled on the primary side of the transformer. This allows optimum adaptation to the load and to the required dynamic range despite the exceptionally compact dimensions of the controller.

PLEASE NOTE!

RESISTRON[®] temperature controllers play a significant role in enhancing the performance of modern machines. However, the full benefit can only be obtained from the advanced technology offered by this control system if all

the system components, in other words the heatsealing band, the impulse transformer, the wiring, the timing signals and the controller itself, are compatible with one another.

We will be pleased to contribute our many years of experience towards optimizing *your* heatsealing system.



4 Description of the controller

The microprocessor technology endows the RESISTRON[®] temperature controller RES-445 with previously unattainable capabilities:

- Very simple operation thanks to AUTOCAL, the automatic zero calibration function.
- Good dynamic response of the control system thanks to AUTOTUNE, which adapts automatically to the controlled system.
- High precision thanks to further improved control accuracy and linearization of the heatsealing band characteristic.
- High flexibility: The AUTORANGE function (as of software revision 100) covers a secondary voltage range from 0.4V to 120V and a current range from 30A to 500A.
- Automatic adjustment to the line frequency in the range from 47Hz to 63Hz.
- Increased protection against dangerous conditions, such as overheating of the heatsealing band.

A time control (timer) function integrated in the controller enables the complete heatsealing process to be controlled on simple machines, such as table heatsealing tools. A configurable relay output can be used to drive motors, energize magnets etc.

The process data is represented on an LC display with 4 lines and 20 characters. Devices with a VF display are available as an option. Various display languages can be selected.

In addition to the digital and bar indications on the display, the ACTUAL temperature of the heatsealing band is supplied to an electrically isolated, analog 0...10VDC output. The real heatsealing band temperature can thus be displayed on an external temperature meter (e.g. ATR-x).

The RESISTRON[®] temperature controller RES-445 also features an integrated fault diagnosis function, which tests both the external system (heatsealing band, wiring etc.) and the internal electronics and outputs a selective error message in case of a fault.

To increase operational safety and interference immunity, all 24VDC logic signals are electrically isolated from the controller and the heating circuit.

The menu in the temperature controller itself can be used to adapt to different heatsealing band alloys (Alloy A20, LEX3500 etc.) and set the required temperature range (0...300°C, 0...500°C etc.).




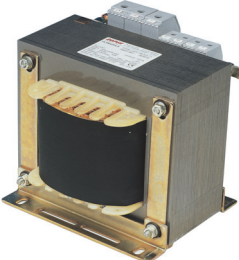
The RESISTRON[®] temperature controller RES-445 is designed for installation in a front panel cutout. The compact design and the plug-in connections make this controller easy to install.





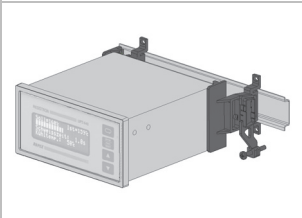


5 Accessories and modifications

A wide range of compatible accessories and peripheral devices are available for the RESISTRON[®] temperature controller RES-445. They allow it to be optimally adapted to your specific heatsealing application and to your plant's design and operating philosophy.

5.1 Accessories

The products described below are only a few of the wide range of accessories available for RESISTRON[®] temperature controllers (↪ "Accessories" leaflet).

	<p>Analog temperature meter ATR-x For front panel mounting or mounting on a top hat rail (DIN TS35). Analog indication of the ACTUAL temperature of the heatsealing band in °C. The meter damping of the unit is optimized for the abrupt temperature changes that occur in impulse mode.</p>
	<p>Digital temperature meter DTR-x For front panel mounting or mounting on a top hat rail (DIN TS35). Digital indication of the ACTUAL temperature of the heatsealing band in °C, with HOLD function.</p>
	<p>Line filter LF-xx480 Essential in order to ensure CE conformity. Optimized for the RESISTRON[®] temperature controller.</p>
	<p>Impulse transformer ITR-x Designed according to EN 61558 with a one-section bobbin. Optimized for impulse operation with RESISTRON temperature controllers. Specified according to the heatsealing application (↪ ROPEX Application Report).</p>

	<p>Communication interface CI-USB-1 Interface for connecting a RESISTRON temperature controller with diagnostic interface (DIAG) to the PC (USB port). Associated PC visualization software for displaying setting and configuration data, and for recording SET and ACTUAL temperatures in real time.</p>
	<p>Booster B-xxx400 External switching amplifier, necessary for high primary currents (continuous current > 5A, pulsed current > 25A).</p>
	<p>Monitoring current transformer For detecting frame short-circuits on the heatsealing band. Used as an alternative to the standard PEX-W2/-W3 current transformer.</p>
	<p>Transparent front cover TFA-1 For increasing the degree of protection on the front of the controller to IP65. Also facilitates applications in the food technology sector (GMP).</p>
	<p>Adapter for top hat rail mounting, HS-Adapter-01 For mounting the RESISTRON[®] temperature controller RES-445 on a top hat rail (DIN TS35). Allows the controller to be installed in the electrical cabinet, for instance, where it is only accessible to authorized persons.</p>
	<p>Lockable door TUER-S/K-1 Transparent door (with lock) for mounting on the bezel of the controller. The display is clearly legible at all times. The keyboard can only be operated, however, by authorized persons in possession of a key.</p>
	<p>Measurement cable UML-1 Twisted measurement cable for the U_R voltage measurement. Trailing cable, halogen and silicone-free.</p>

5.2 Modifications (MODs)

Owing to its universal design, the RESISTRON[®] temperature controller RES-445 is suitable for a very wide range of heatsealing applications.

Modifications (MOD) are available for the RESISTRON[®] temperature controller RES-445 for implementing special applications.


MOD 01

Amplifier for low secondary voltages ($U_R = 0.25 \dots 16 \text{ VAC}$). This modification is necessary, for example, for very short or low-resistance heatsealing bands.

MOD 33


(Software revision 010 or higher)

Important heatsealing process data can be output and logged via a serial RS232 interface (↪ MOD 33" documentation).

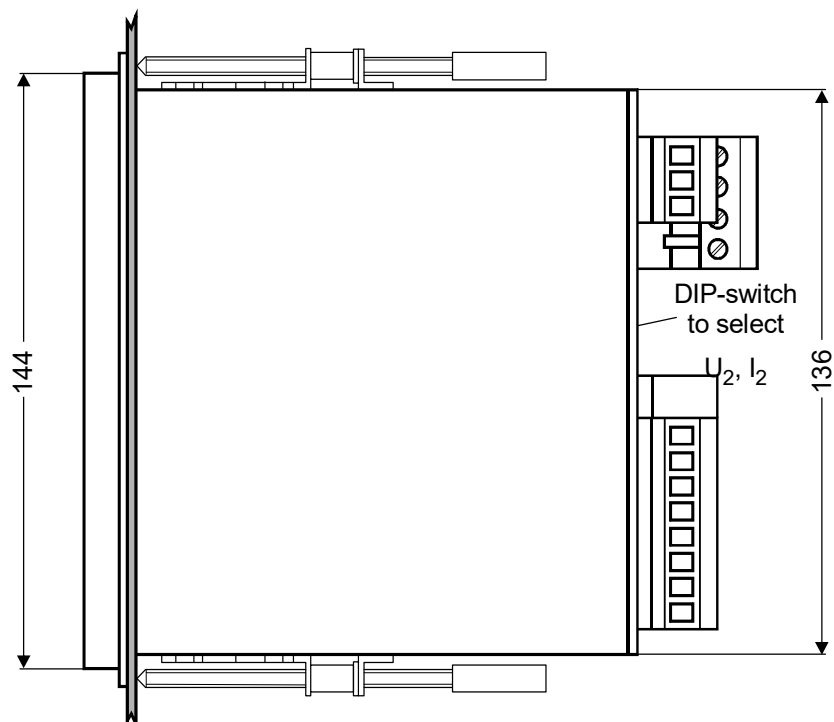
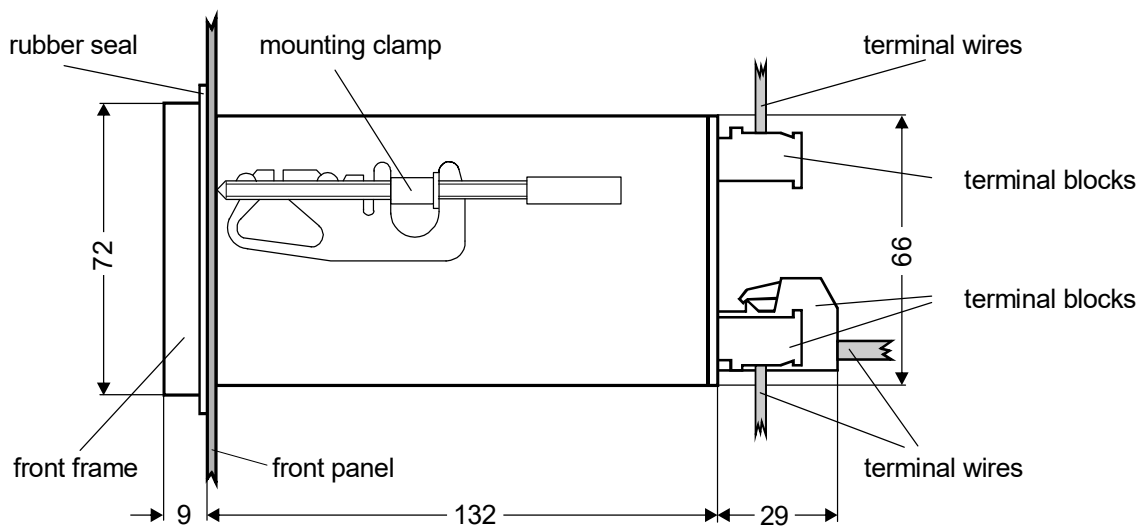
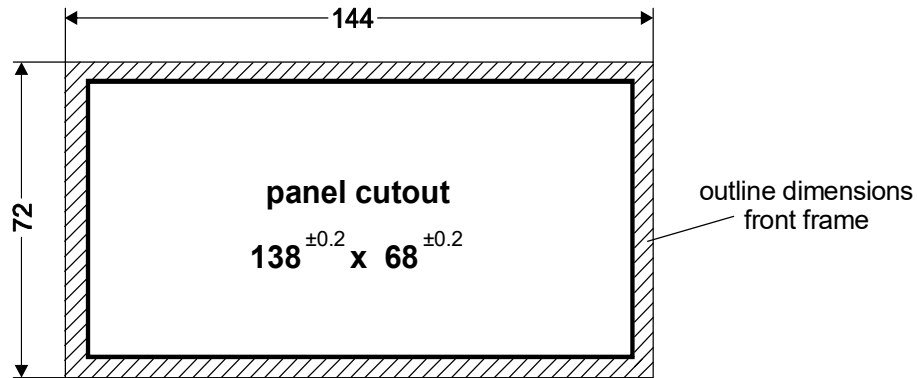
 **This modification is only recommended for existing applications. The PC visualization software (↪ section 10.22 "Diagnostic interface/visualization software (as of software revision 100)" on page 66) should be used for all new applications.**

6 Technical data

Type of construction	Housing for front panel mounting Dimensions (W x H): 144 x 72mm; depth: 161 mm (incl. terminals)
Line voltage	<p><u>All controller manufactured as of January 2006 (as of software revision 100):</u> 115VAC version: 110VAC -15%...120VAC +10% (equivalent to 94...132VAC) 230VAC version: 220VAC -15%...240VAC +10% (equivalent to 187...264VAC) 400VAC version: 380VAC -15%...415VAC +10% (equivalent to 323...456VAC)</p> <p><u>All controllers manufactured as of January 2004 up to December 2005 (up to software revision 027):</u> 115VAC version: 115VAC -15%...120VAC +10% (equivalent to 98...132VAC) 230VAC version: 230VAC -15%...240VAC +10% (equivalent to 196...264VAC) 400VAC version: 400VAC -15%...415VAC +10% (equivalent to 340...456VAC)</p> <p><u>All controllers manufactured up to December 2003:</u> 115VAC, 230VAC or 400VAC, tolerance: +10% / -15%</p> <p>depending on device version (↪ section 13 "How to order" on page 89)</p>
Line frequency	47...63Hz, automatic adjustment to frequencies in this range
Heatsealing band type and temperature range	<p><u>As of software revision 100:</u> The temperature range and temperature coefficient can be set independently of one another in the Configuration menu: Temperature range: 200°C, 300°C, 400°C or 500°C Temperature coefficient: 400...4000ppm (variable setting range)</p> <p><u>Up to software revision 027:</u> Several different ranges can be selected on the controller in the Configuration menu:</p> <ul style="list-style-type: none"> Temperature coefficient 410ppm, 0...300°C (SW revision 021 or higher) Temperature coefficient 460ppm, 0...300°C (SW revision 019 or higher) Temperature coefficient 510ppm, 0...300°C (SW revision 019 or higher) Temperature coefficient 570ppm, 0...300°C (SW revision 019 or higher) Temperature coefficient 630ppm, 0...300°C (SW revision 019 or higher) Temperature coefficient 700ppm, 0...300°C (SW revision 019 or higher) Temperature coefficient 780ppm (e.g. Alloy L) 0...200°C, 0...300°C, 0...400°C, 0...500°C (SW revision 011 or higher) Temperature coefficient 870ppm, 0...300°C (SW revision 019 or higher) Temperature coefficient 980ppm, 0...300°C (SW revision 019 or higher) Temperature coefficient 1100ppm (e.g. Alloy A20): 0...200°C, 0...300°C, 0...400°C, 0...500°C Temperature coefficient 3500ppm (e.g. LEX3500): 0...200°C, 0...300°C
Set point selection/ analog input Terminals 20+23	Via the Settings menu in the controller or the electrically isolated analog input: Input resistance: 40kohms, reverse polarity-protected 0...10VDC, equivalent to 0...300°C or 0...500°C


Analog output (actual value) Terminals 20+24	0...10VDC, $I_{max} = 5\text{mA}$ Equivalent to 0...300°C or 0...500°C Electrically isolated Accuracy: $\pm 1\%$ add. 50mV
Digital logic levels Terminals 3, 4, 22, 25, 26	LOW (0V): 0...2VDC HIGH (24VDC): 12...30VDC (max. current input 6mA) Electrically isolated, reverse polarity-protected
START with contact Terminals 2+7	Switching threshold: 3.5VDC, $U_{max} = 5\text{VDC}$, $I_{max} = 5\text{mA}$
Switching output for „Output 1“/ Temp. OK" signal Terminals 20+21	$U_{max} = 30\text{VDC}$, $I_{max} = 50\text{mA}$ $U_{ON} < 2\text{V}$ (saturation voltage) Transistor conductive if the temperature is inside the tolerance band.
Alarm relay Terminals 5+6	Contact, potential-free, $U_{max} = 30\text{V}$ (DC/AC), $I_{max} = 0.2\text{A}$
Relay K1 Terminals 16, 17, 18	Changeover contact, potential-free, $U_{max} = 240\text{VAC}/100\text{VDC}$, $I_{max} = 1.5\text{A}$ Interference suppression with 47 nF / 560 ohms for each terminal
Maximum load (primary current of impulse transformer)	$I_{max} = 5\text{A}$ (duty cycle = 100%) $I_{max} = 25\text{A}$ (duty cycle = 20%)
Power dissipation	max. 25W
Display	LC display (green), 4 lines, 20 characters, alternatively: VF display (blue), 4 lines, 20 characters
Ambient temperature	+5...+45°C
Degree of protection	Front: IP42 (IP65 with transparent front cover, Art. No. 887000) Back: IP20
Installation	Installed in front panel cutout with (W x H) $138^{(+0.2)} \times 68^{(+0.2)}\text{mm}$ Fastened with clips
Weight	Approx. 1.0kg (incl. connector plug-in parts)
Housing material	Black plastic, type Noryl SE1 GFN2
Connecting cable Type / cross-sections	Rigid or flexible; 0.2...2.5mm ² (AWG 24...12) Plug-in connectors  If ferrules are used, they must be crimped in accordance with DIN 46228 and IEC/EN 60947-1. This is essential for proper electrical contact in the terminals.

7 Dimensions/front panel cutout



8 Installation

↪ See also section 1 "General information" on page 4.

 **Installation and startup may only be performed by technically trained, skilled persons who are familiar with the associated risks and warranty provisions.**

8.1 Installation procedure

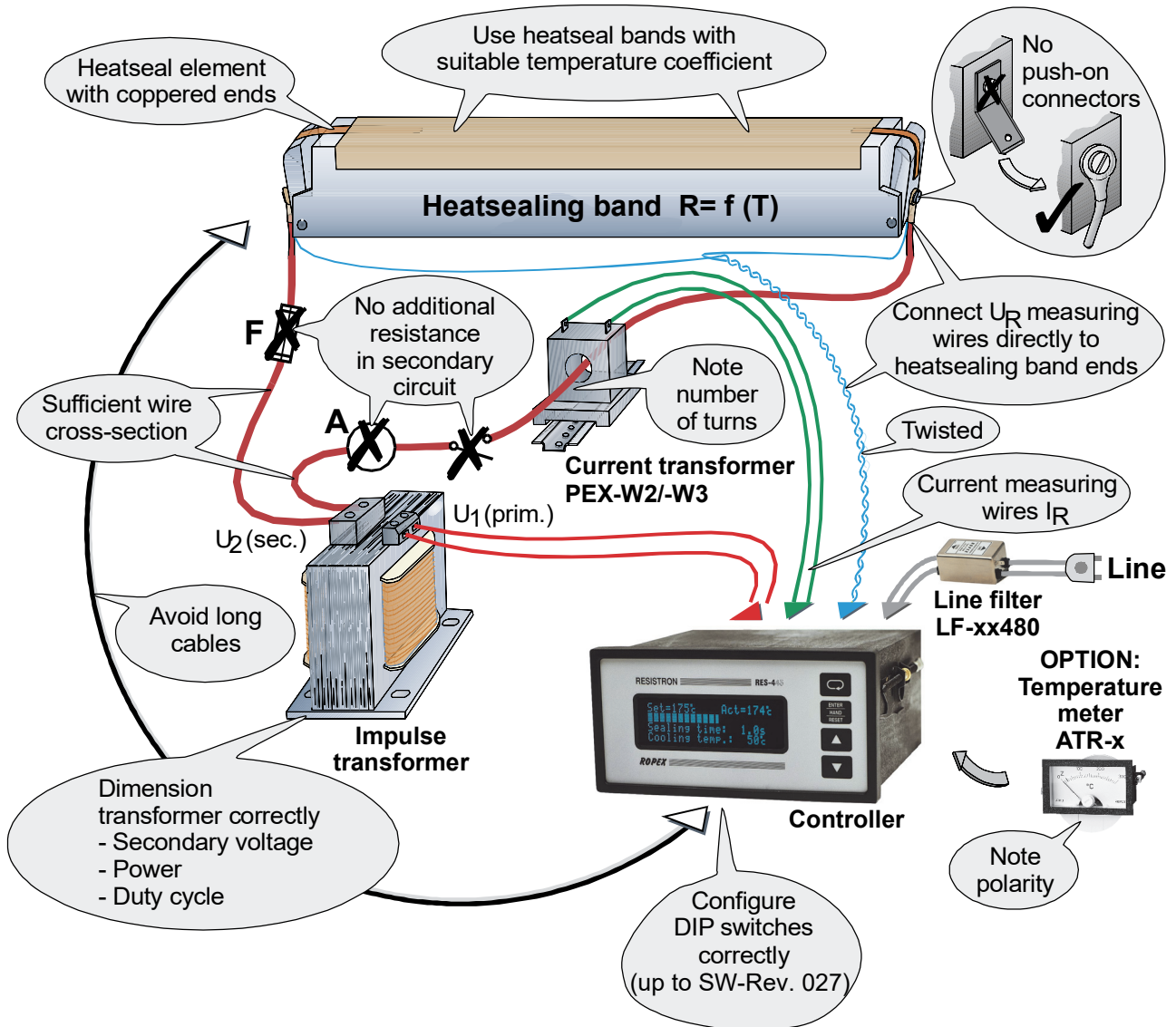
Proceed as follows to install the RESISTRON[®] temperature controller RES-445:

1. Switch off the line voltage and verify that all circuits are deenergized.
2. The supply voltage specified on the nameplate of the RESISTRON[®] temperature controller must be identical to the line voltage that is present in the plant or machine. The line frequency is automatically detected by the temperature controller in the range from 47Hz to 63Hz.
3. Install the RESISTRON[®] temperature controller in the front panel cutout. It is fastened by means of two clips which snap onto the side of the controller housing.
4. Wire the system in accordance with the instructions in section 8.3 "Power supply" on page 18, section 8.6 "Wiring diagram (standard)" on page 21 and the ROPEX Application Report. The information provided in section 8.2 "Installation steps" on page 17 must be heeded additionally.

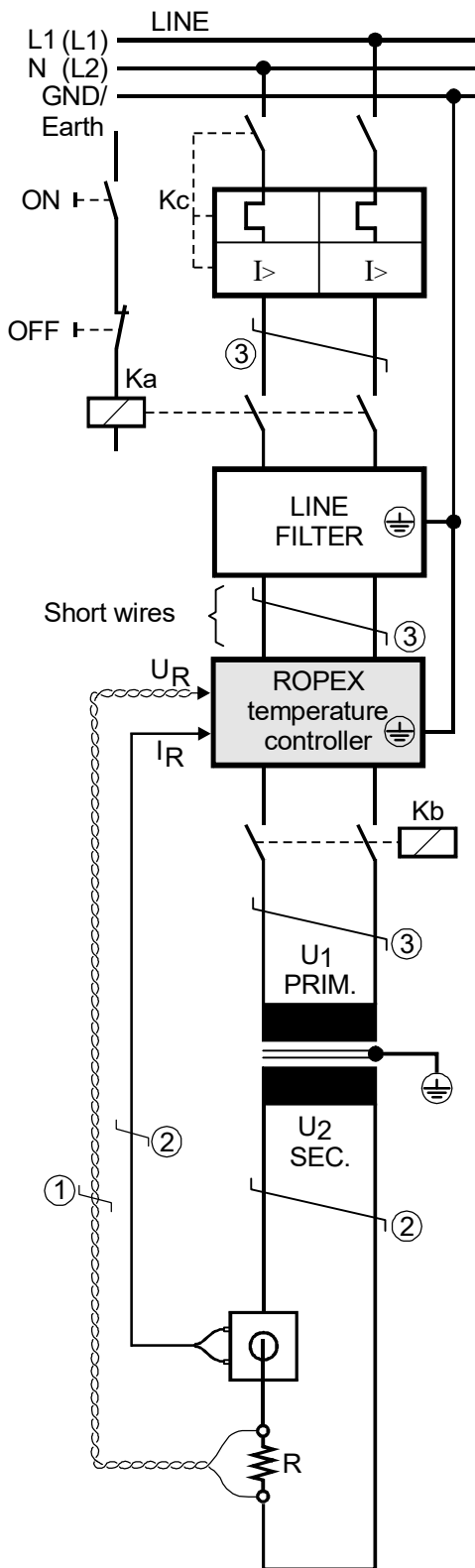
 **Check the tightness of all the system connections, including the terminals for the impulse transformer windings.**

5. Make sure that the wiring conforms to the relevant national and international installation regulations.

8.2 Installation steps



8.3 Power supply



Line

Over-current protection

Double-pole circuit-breaker or fuses,
(☞ ROPEX Application Report)

⚠ Short-circuit protection only. RESISTRON® temperature controller not protected.

Relay Ka

For "HEAT ON - OFF" function (all-pole) or "EMERGENCY STOP".

Line filter

The filter type and size must be determined according to the load, the transformer and the machine wiring (☞ ROPEX Application Report).

⚠ Do not run the filter supply wires (line side) parallel to the filter output wires (load side).

RESISTRON® temperature controller

Relay Kb

Load break (all-pole), e.g. in combination with the alarm output of the temp. controller (ROPEX recommendation).

⚠ When using a series resistor RV-....-1 the relay Kb shall be installed.

Impulse Transformer

Designed according to EN 61558 (isolating transformer with reinforced insulation). Connect core to ground.

⚠ Use transformers with a one section bobbin. The power, duty cycle and voltage values must be determined individually according to the application (☞ ROPEX Application Report and "Accessories" leaflet for impulse transformers).

Wiring

The wire cross-sections depend on the application (☞ ROPEX Application Report).

- ① Wires must always be twisted (min. 20 turns/meter).
- ② These wires must be twisted (min. 20 turns/meter) if several control loops are laid together ("crosstalk").
- ③ Twisting (min. 20 turns/meter) is recommended to improve EMC.

8.4 Line filter

To comply with EMC directives – corresponding to EN 50081-1 and EN 50082-2 – RESISTRON control loops must be operated with line filters.

These filters damp the reaction of the phase-angle control on the line and protect the controller against line disturbances.



The use of a suitable line filter is part of the standards conformity and a prerequisite of the CE mark.

ROPEX line filters are specially optimized for use in RESISTRON control loops. Providing that they are installed and wired correctly, they guarantee compliance with the EMC limit values.

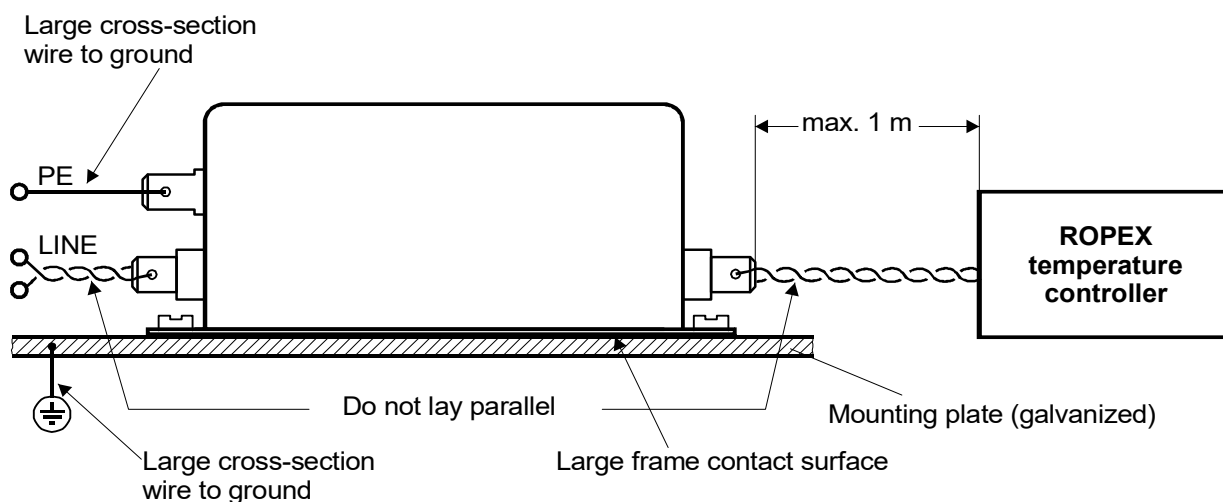
You can find the exact specification of the line filter in the ROPEX Application Report calculated for your particular heatsealing application.

For more technical information: ↗ "Line filter" documentation.

It is permissible to supply several RESISTRON control loops with a single line filter, providing the total current does not exceed the maximum current of the filter.

The wiring instructions contained in section 8.3 "Power supply" on page 18 must be observed.

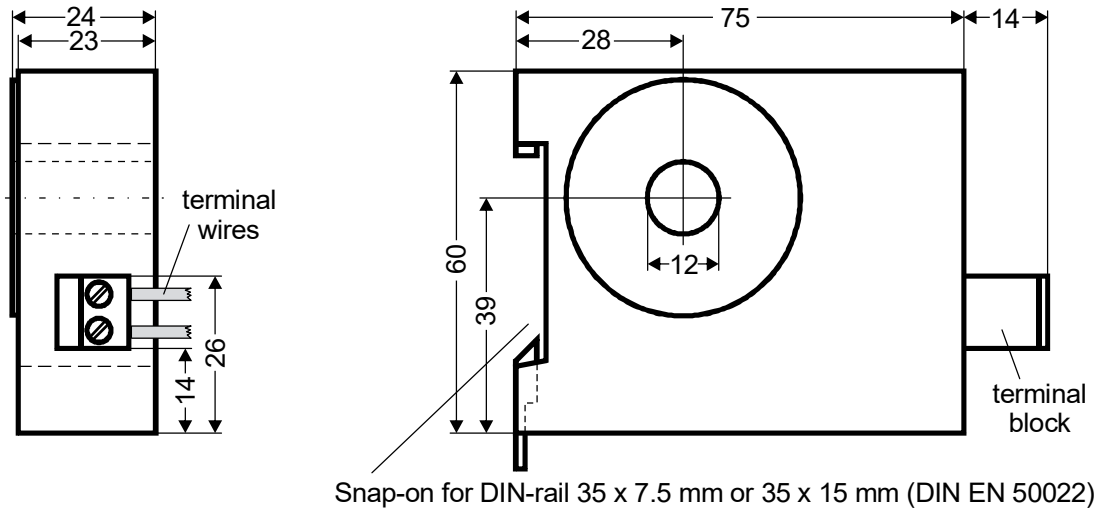
Example drawing for LF-06480:



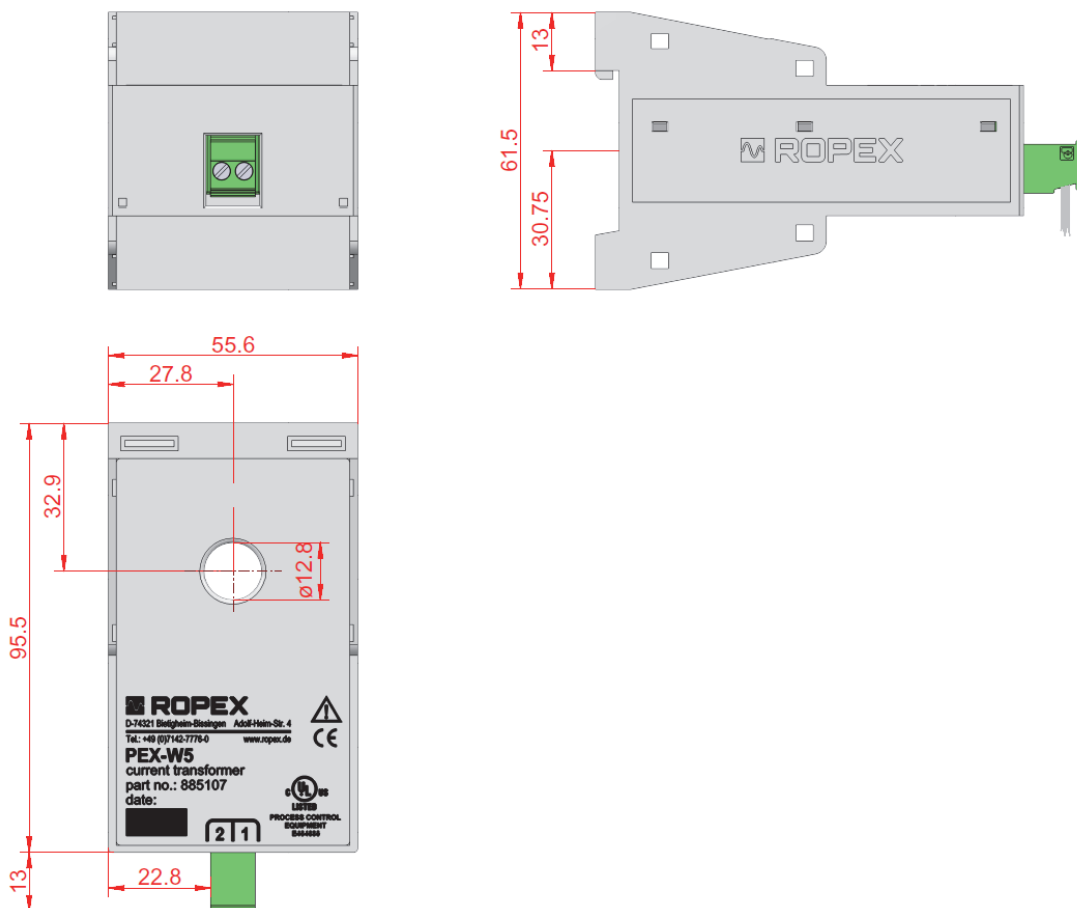
8.5 Current transformer PEX-W4/-W5

The PEX-W4/-W5 current transformer supplied with the RESISTRON[®] temperature controller is an integral part of the control system. The current transformer may only be operated if it is connected to the temperature controller correctly (↗ section 8.3 "Power supply" on page 18).

8.5.1 PEX-W4

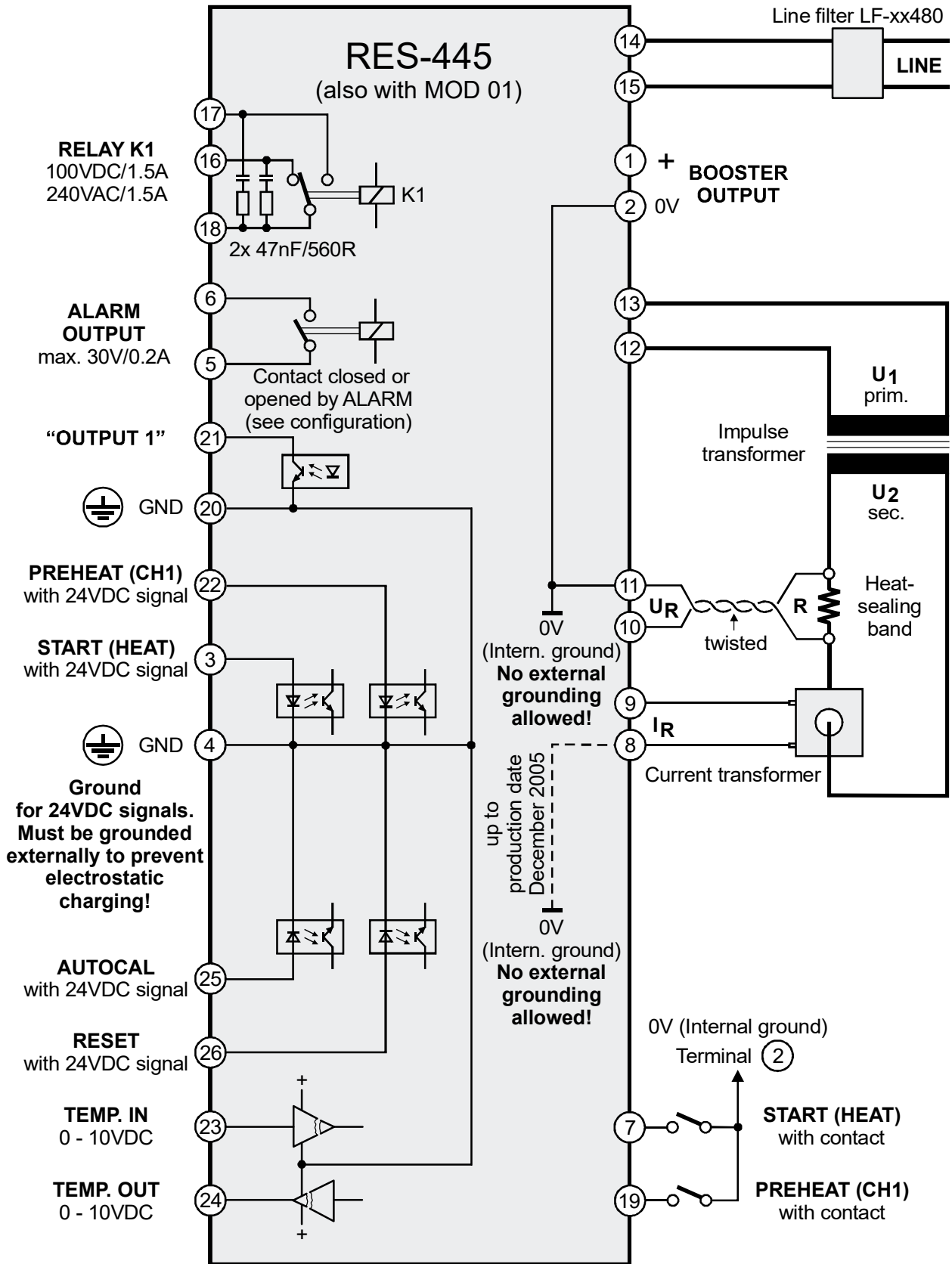


8.5.2 PEX-W5

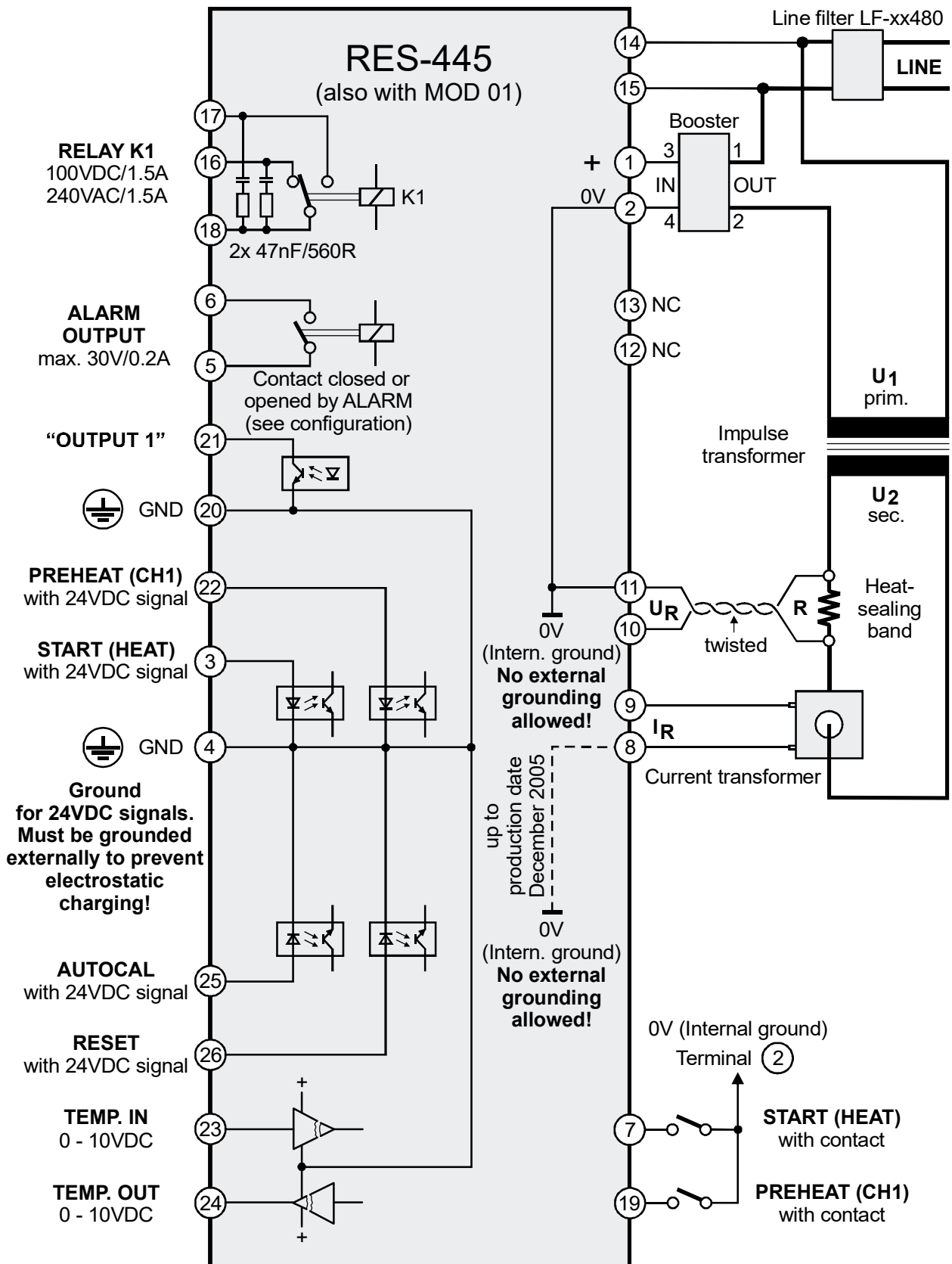


Mounting on DIN-rail 35 x 7.5 mm or 35 x 15 mm (DIN EN 50022).

8.6 Wiring diagram (standard)

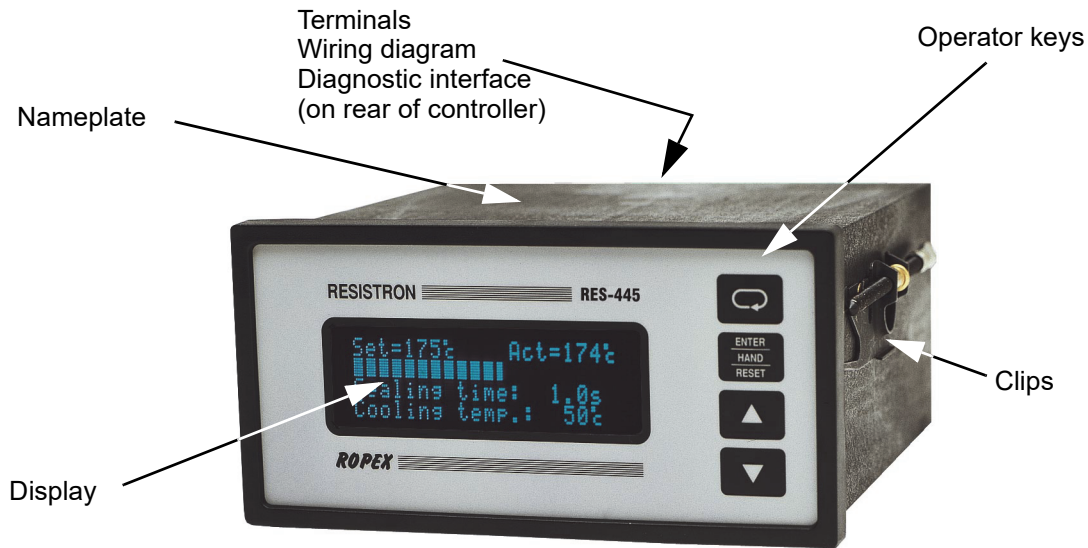


8.7 Wiring diagram with booster connection



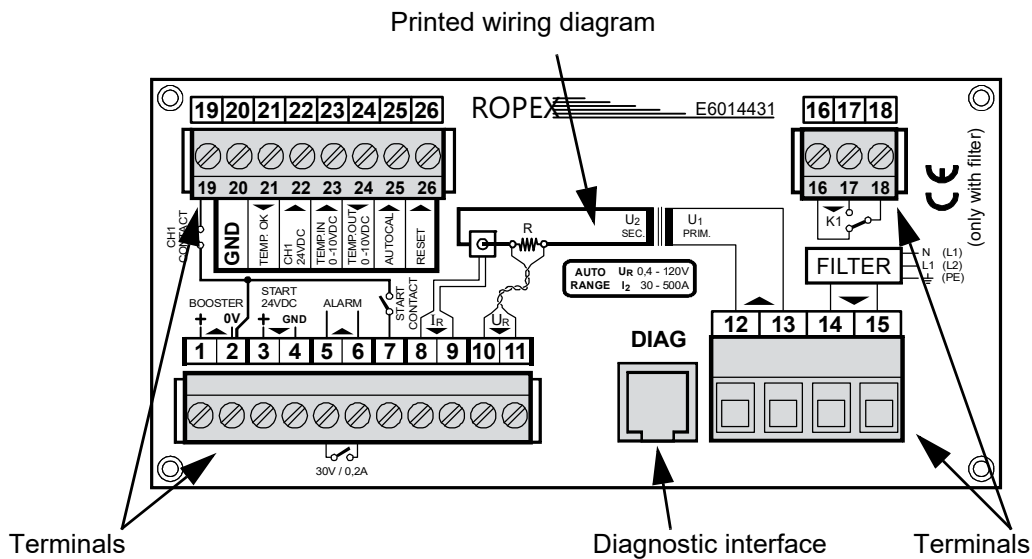
9 Startup and operation

9.1 Front view of the controller



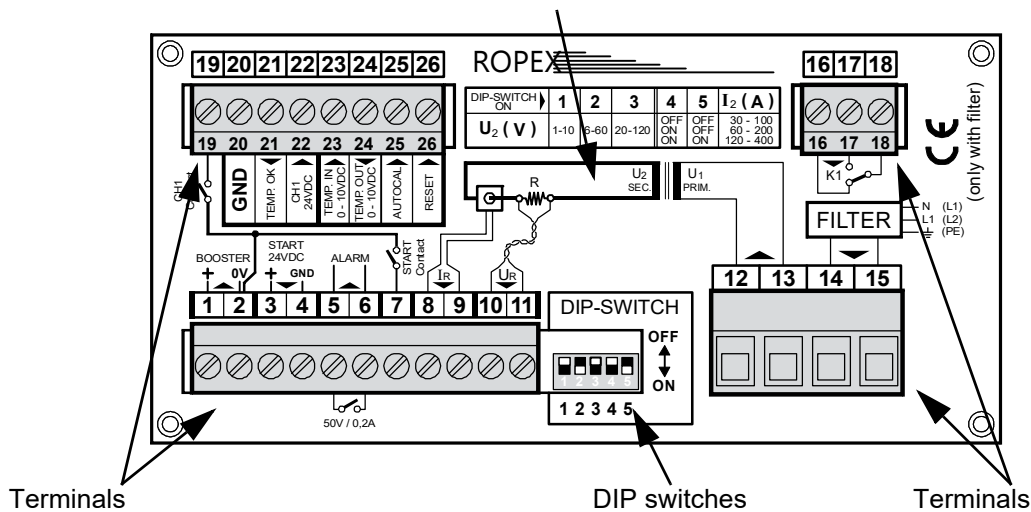
9.2 Rear view of the controller

As of software revision 100:



Up to software revision 027:

Printed wiring diagram



9.3 Controller configuration

The possible controller configurations are explained in the following sections. Proceed as described in section 9.5.1 "Initial startup" on page 33 to start up the controller for the first time.

9.3.1 Configuration of the DIP switches for secondary voltage and current

! The controller must be switched off in order to configure the DIP switches.

Automatic configuration (AUTORANGE)

(as of software revision 100)

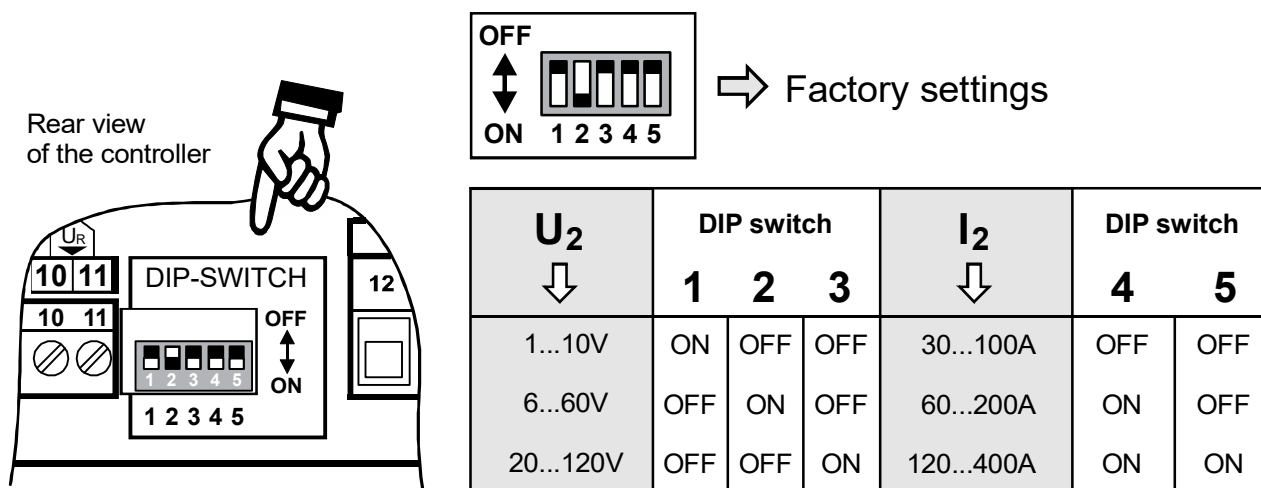
The secondary voltage and current ranges are automatically configured by the automatic calibration function (AUTOCAL). The voltage is configured in the range from 0.4VAC to 120VAC and the current in the range from 30A to 500A. If the voltage and/or the current is outside the permissible range, a detailed error message appears on the controller (↪ s. section 10.27 "Fault areas and causes" on page 84).

Configuration with coding switches

(up to software revision 027)

Set the DIP switches for matching the secondary voltage U_2 and the secondary current I_2 to the correct position for **your** application.

! You can find the exact configuration of the DIP switches in the ROPEX Application Report calculated for your particular application.



If the secondary current I_2 is less than 30A, the secondary high-current wire must be laid twice (or several times) through the PEX-W2 or PEX-W3 current transformer (↪ ROPEX Application Report).



9.3.2 Setting the language

The menu language can be changed on the controller without interrupting operation. It is set with step 20 in the Configuration menu:

The following settings are possible:

English, German, Italian

Software revision 015 or higher also:

French, Spanish, Dutch, Danish, Finnish, Swedish, Greek, Turkish.

Software revision 024 or higher also: Portuguese.

⚠ The language which is selected in this menu remains set even if the factory settings are restored (step 202 [21] in the Configuration menu).

⚠ As of software revision 103, the language setting with step 202 can still be changed even if the Configuration menu is disabled (↪ section 10.19 "Disabling the Configuration menu" on page 63).

9.3.3 Restoring the factory settings

The internal controller settings can be reset to the factory settings with step 202 [21] in the Configuration menu. Only the language setting (step 201 [20] in the Configuration menu) remains unchanged.

Please refer to section 11 "Factory settings" on page 86 for more information about the factory settings.

⚠ If the controller settings are unknown when it is started up for the first time, the factory settings must be restored in order to prevent malfunctions.

9.3.4 Configuration of the alloy and the temperature range (up to software revision 027)

These parameters are set with step 22 in the Configuration menu:

Several different ranges can be selected:

1. **Temperature coefficient 410 ppm, 0...300°C**
(software revision 021 or higher)
2. **Temperature coefficient 460 ppm, 0...300°C**
(software revision 019 or higher)
3. **Temperature coefficient 510 ppm, 0...300°C**
(software revision 019 or higher)
4. **Temperature coefficient 570 ppm, 0...300°C**
(software revision 019 or higher)
5. **Temperature coefficient 630 ppm, 0...300°C**
(software revision 019 or higher)
6. **Temperature coefficient 700 ppm, 0...300°C**
(software revision 019 or higher)
7. **Temperature coefficient 780 ppm, 0...200°C**
(e.g. Alloy L, software revision 011 or higher)
8. **Temperature coefficient 780 ppm, 0...300°C**
(e.g. Alloy L, software revision 011 or higher)
9. **Temperature coefficient 780 ppm, 0...400°C**
(e.g. Alloy L, software revision 011 or higher)
10. **Temperature coefficient 780 ppm, 0...500°C**
(e.g. Alloy L, software revision 011 or higher)
11. **Temperature coefficient 870 ppm, 0...300°C**
(software revision 019 or higher)
12. **Temperature coefficient 980 ppm, 0...300°C**
(software revision 019 or higher)
13. **Temperature coefficient 1100 ppm, 0...200°C**
(e.g. Alloy A20)
14. **Temperature coefficient 1100 ppm, 0...300°C**
(Factory settings)
(e.g. Alloy A20)
15. **Temperature coefficient 1100 ppm, 0...400°C**
(e.g. Alloy A20)
16. **Temperature coefficient 1100 ppm, 0...500°C**
(e.g. Alloy A20)
17. **Temperature coefficient 3500 ppm, 0...200°C**
(e.g. LEX3500)
18. **Temperature coefficient 3500 ppm, 0...300°C**
(e.g. LEX3500)

9.3.5 Configuration of the alloy (Temperature coefficient) (as of software revision 100)

The heatsealing band alloy (and the temperature coefficient respectively) can be set with steps 203 and 204 in the Configuration menu.

In step 203 predefined values for the alloy (and the temperature coefficient respectively) are available:

1. **Temperature coefficient 780 ppm**
(e.g. Alloy L)
2. **Temperature coefficient 1100 ppm**
(Factory setting)
(e.g. Alloy A20)

3. **Temperature coefficient 1400 ppm**
(e.g. ROPEX CIRUS system)
4. **Temperature coefficient 1700 ppm**
(e.g. ROPEX CIRUS system)
5. **Temperature coefficient 3500 ppm**
(e.g. LEX3500)
6. **Temperature coefficient „variable“**
Further settings in step 204.
In step 204 the temperature coefficient can be set in a range of 400...4000 ppm individually for the used heat-sealing band then.



Step 204 in the Configuration menu is available when step 203 is set to "variable" only.

9.3.6 Configuration of the temperature range (as of software revision 100)

The temperature range can be set with steps 205 in the Configuration menu.
The setting can be 200°C, 300°C (Factory setting), 400°C or 500°C.

9.3.7 Configuration of the timer function



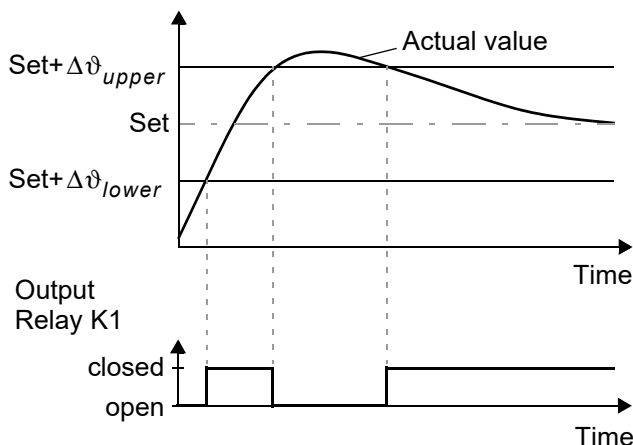
The necessary controller settings are explained in the detailed functional descriptions in section 10.6 "Menu steps" on page 42 and section 10.24 "Time control (timer function)" on page 67. They are only allowed to be entered by technically trained persons.

The timer function is activated with step 26 in the Configuration menu.

9.3.8 Relay K1 (without time control)

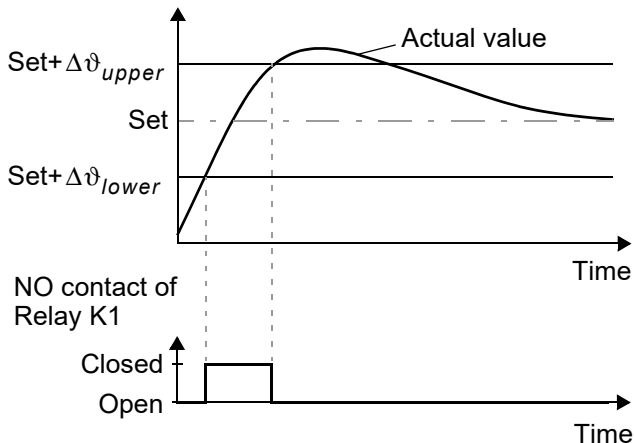
The function of relay K1 is specified with step 212 [29] in the Configuration menu. The following settings are possible when time control is deactivated:

1. **"Off" (Factory setting)**
Relay K1 has no function
2. **"Active if Tact = Tset"**
Relay K1 is activated if the actual value is inside the specified temperature tolerance band (steps 207 [24], 208 [25]). If the actual temperature is outside the tolerance band, relay K1 is deactivated (see graph below).



3. "Active if Tact = Tset", with latch function (as of software revision 100)

Relay K1 is closed if the actual value is inside the specified temperature tolerance band (steps 207, 208). If the actual temperature leaves the tolerance band once while the "START" signal is active, relay K1 is opened. The relay is not closed again until the next "START" signal is activated. The switching state of relay K1 can thus also be interrogated by the higher-level PLC after a heatsealing process (latch function, see graph below).

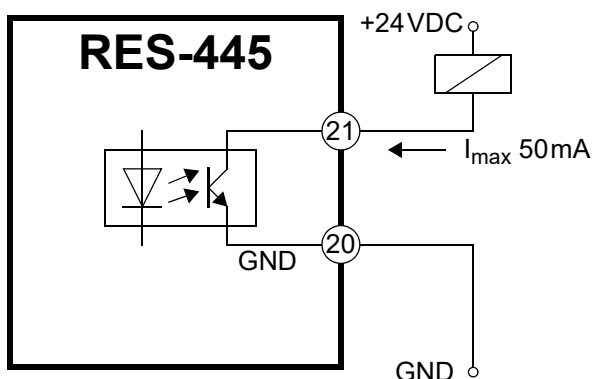


Other settings are available in this menu when time control (timer function) is active. They are described in section 10.24.7 "Relay K1 (with time control)" on page 73.

9.3.9 "Output 1"/ "Temperature OK" signal (without time control)

! On controllers up to software revision 027, the switching output at terminals 20+21 was called "Temperature OK". The more general name "Output 1" is used as of software revision 100 because this output now also supports other functions.

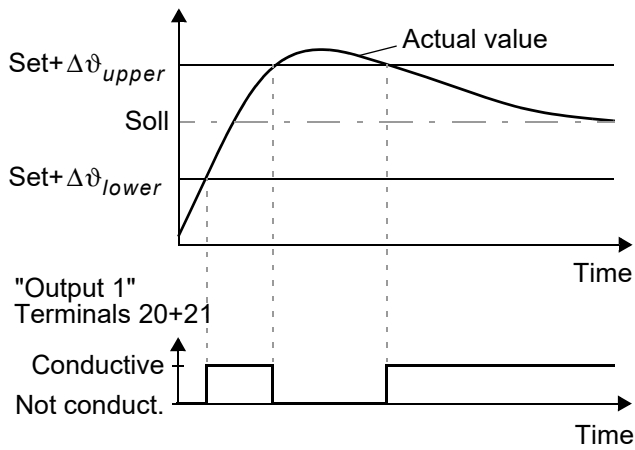
The "Output 1" signal is available at terminals 20+21 as a digital control signal.




Up to software revision 027:

The RES-445 checks whether the ACTUAL temperature is inside a specifiable tolerance band ("OK" window) on either side of the SET temperature. The lower ($\Delta\vartheta_{lower}$) and upper ($\Delta\vartheta_{upper}$) limits of the tolerance band can be changed independently of one another by means of steps 24+25 in the Configuration menu.

If the actual temperature is inside the specified tolerance band, the output signal at terminals 20+21 is switched (see graph below):



 **The ACTUAL temperature is evaluated, and the output signal at terminals 20+21 activated, in all operating states except when a fault is signaled.**

As of software revision 100:

If time control (timer function) is deactivated, the same configuration options are available for "Output 1" as for relay K1 (↪ section 9.3.8 "Relay K1 (without time control)" on page 27). The options for "Output 1" are specified with step 222 in the Configuration menu as followed:

1. **"Off"**

"Output 1" has no function

2. **"Active if Tact = Tset"**

Output 1 is conductive if the actual value is inside the specified temperature tolerance band (steps 207, 208).

If the actual temperature is outside the tolerance band, "Output 1" is not conductive.

This function is the same as for the "Temperature OK" signal up to software revision 027.

3. **"Active if Tact = Tset", with latch function**

(factory setting)

"Output 1" is conductive if the actual value is inside the specified temperature tolerance band (steps 207, 208).

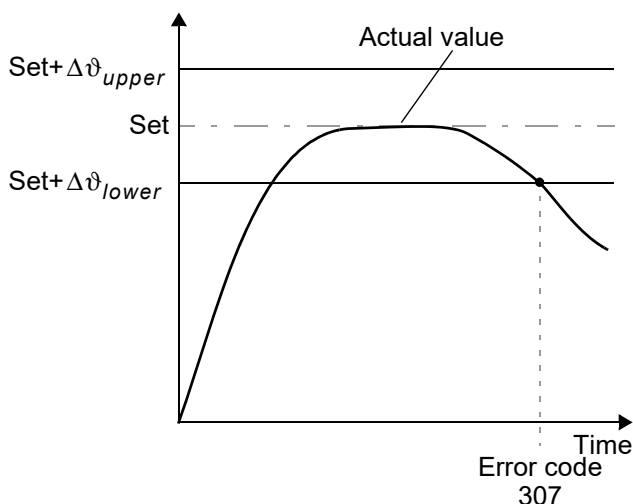
If the actual temperature leaves the tolerance band once while the "START" signal is active, "Output 1" is no longer conductive. "Output 1" does not become conductive again until the next "START" signal is activated and can thus also be interrogated by the higher-level PLC after a heatsealing process.

Other settings are available in this menu when time control (timer function) is active. They are described in section 10.24.8 "'Output 1"/ "Temperature OK" signal (with time control)" on page 75.

9.3.10 Temperature diagnosis (as of software revision 100)

The temperature diagnosis function can be activated by means of step 217 in the Configuration menu. The RES-445 then checks whether the ACTUAL temperature is inside a specifiable tolerance band ("OK" window) on either side of the SET temperature. The lower ($\Delta\vartheta_{lower}$) and upper ($\Delta\vartheta_{upper}$) limits of the tolerance band can be changed independently of one another by means of steps 207 [24] + 208 [25] (factory setting: -10K or +10K).

If the ACTUAL temperature is inside the specified tolerance band when the "START" signal is activated, the temperature diagnosis is also activated. If the ACTUAL temperature leaves the tolerance band, the corresponding error code (307, 308) is indicated and the fault output is switched (↪ section 10.27 "Fault areas and causes" on page 84). If a heatsealing cycle is in progress, it is immediately interrupted.



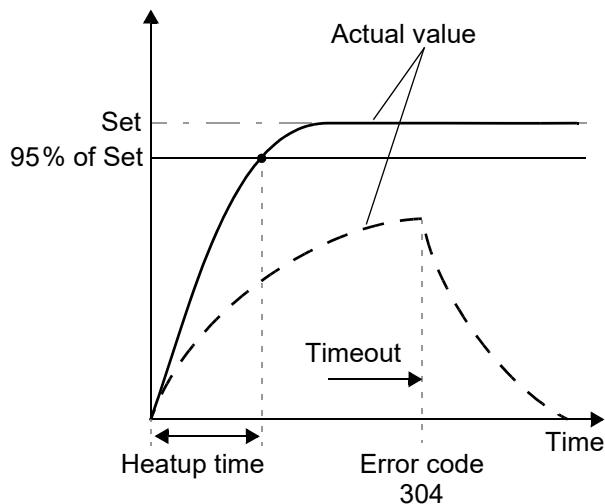
If the temperature diagnosis is not activated by the time the "START" signal is deactivated (i.e. if the ACTUAL temperature does not exceed the upper or lower tolerance band limit), the corresponding error code (309, 310) is indicated and the fault relay is switched.

If the temperature diagnosis function is activated, an additional delay time of 0 to 9.9s can be parameterized for the temperature timeout with step 218 in the Configuration menu. The first time the lower tolerance band limit is exceeded, the temperature diagnosis is not activated until the parameterized delay time has elapsed. The tem-

perature diagnosis function can thus be explicitly deactivated, e.g. if the temperature drops temporarily owing to the closure of the sealing jaws.

9.3.11 Heatup timeout (as of software revision 100)

The heatup timeout can be parameterized with step 219 in the Configuration menu ("0" = OFF). This timeout starts when the START signal is activated. The RES-445 then monitors the time required for the ACTUAL temperature to reach 95% of the SET temperature. If this time is longer than the parameterized time, the corresponding error code (304) is indicated and the fault relay is switched (↪ section 10.27 "Fault areas and causes" on page 84).



9.3.12 Configuration of the alarm relay

The alarm relay is set with step 215 [31] in the Configuration menu. There are two possible settings:

1. **"Normal" (Factory setting)**
Alarm relay contact closed by a fault
2. **"Inverse"**
Alarm relay contact opened by a fault

9.4 Heatsealing band

9.4.1 General

The heatsealing band is a key component in the control loop, since it is both a heating element and a sensor. The geometry of the heatsealing band is too complex to be discussed at length here. We shall therefore only refer to a few of the most important physical and electrical properties:


The measuring principle applied for this system necessitates a heatsealing band alloy with a suitable temperature coefficient TCR, i.e. one whose resistance increases as the temperature rises.

Too low a TCR leads to oscillation or uncontrolled heating.

When heatsealing bands with a higher TCR are used, the controller must be calibrated for this.

The first time the heatsealing band is heated to approximately 200...250 °C, the standard alloy undergoes a once-only resistance change (burn-in effect). The cold resistance of the heatsealing band is reduced by approximately 2...3%. However, this at first glance slight resistance change results in a zero point error of 20...30 °C. The zero point must therefore be corrected after a few heating cycles (↪ chap. 9.4.2 „Burning in the heatsealing band“, page 32).

One very important design feature is the copper or silver-plating of the heatsealing band ends. Cold ends allow the temperature to be controlled accurately and increase the life of the teflon coating and the heatsealing band.

 **An overheated or burned-out heatsealing band must no longer be used because the TCR has been altered irreversibly.**


9.4.2 Burning in the heatsealing band

If a new heatsealing band has been used, the zero point is first of all calibrated while the band is still cold by activating the "AUTOCAL" function on the controller. When the "AUTOCAL" function has finished, the controller outputs the preselected calibration temperature (default value: 20°C). Adjust the set point to approximately 250°C and press the "HAND" key (display in home position) to heat for approximately 1 second. After recooling, the controller usually indicates a value less than 20°C. Repeat the "AUTOCAL" function. The heatsealing band has now been burned in and the change in the alloy properties stabilized.

The burn-in effect described here does not occur if the heatsealing band has already been thermally pretreated by the manufacturer.

9.4.3 Replacing the heatsealing band

All power supply leads must be disconnected from the RESISTRON[®] temperature controller in order to replace the heatsealing band.

 **The heatsealing band must be replaced in accordance with the instructions provided by the manufacturer.**

Each time the heatsealing band is replaced, the zero point must be calibrated with the AUTOCAL function while the band is still cold, in order to compensate production-related resistance tolerances. The burn-in procedure described above must be performed for all new heatsealing bands.

9.5 Startup procedure

Please also refer to section 1 "General information" on page 4 and section 2 "Application" on page 8.



Installation and startup may only be performed by technically trained, skilled persons who are familiar with the associated risks and warranty provisions.

9.5.1 Initial startup

Prerequisites: The controller must be correctly installed and connected (↪ section 8 "Installation" on page 16). The possible settings are described in detail in chap. 9.3 „Controller configuration“, page 24 and chap. 10 „Controller functions“, page 34.

The essential controller configurations are described below:

1. Switch off the line voltage and verify that all circuits are deenergized.
2. The supply voltage specified on the nameplate of the controller must be identical to the line voltage that is present in the plant or machine. The line frequency is automatically detected by the temperature controller in the range from 47 to 63Hz.
3. In case of controllers up to software revision 027, the setting of the DIP switches on the controller are indicated in the ROPEX Application report and depend on the heatsealing band (section 9.3 "Controller configuration" on page 24).
4. Make sure that a START signal is not present.
5. Switch on the line voltage.
6. A power-up message appears on the display for approximately 2 seconds when the controller is switched on to indicate that it has been started up correctly.
7. One of the following states then appears:

DISPLAY	ACTION
Main menu	Go to 8
Error message with error codes 104...106, 111...113, 211	Go to 8
Error message with error codes 101...103, 107, 108, 201...203, 801, 9xx	Fault diagnosis (↪ 10.27)

8. Set the controller configuration as described in section 9.3 "Controller configuration" on page 24. The following settings are always required:

Setting	Step in Configuration menu
Language	201 [20]
Restore factory settings	202 [21]
Temperature range and heat-sealing band alloy	203, 204, 205 [22]

9. Activate the AUTOCAL function while the heatsealing band is still cold (with step 7 in the Settings menu or by means of the "AUTOCAL" signal, terminals 20+25). The progress of the calibration process is indicated by a

counter on the display (approx. 10...15s). A voltage of app. 0VDC appears at the same time at the actual value output (terminals 20+24). If an ATR-x is connected, it indicates 0...3°C.


When the zero point has been calibrated, the display is reset to the home position and 20°C is indicated as the actual value. A voltage of 0.66VDC (for the 300°C range) or 0.4VDC (for the 500°C range, equivalent to 20°C), appears at the actual value output. If an ATR-x is connected, it must be set to "Z" (20°C).

If the zero has not been calibrated successfully, an error message indicates error codes 104...106, 211. In this case the controller configuration is incorrect (↪ section 9.3 "Controller configuration" on page 24 and ROPEX Application Report). Repeat the zero point calibration after the controller has been configured correctly.

10. When the zero point has been calibrated successfully, the main menu appears on the display again. Then specify a defined temperature (heatsealing temperature) with step 1 in the Settings menu (or apply a 0...10VDC voltage to the analog input, terminals 20+23) and activate the "START" signal (HEAT). Alternatively, a heatsealing process can be started by pressing the "HAND" key (display in home position). The indication of the ACTUAL temperature on the display (digital value and dynamic bar) permits the heating and control process to be monitored.

The controller is functioning correctly if the temperature indicated on the display has a continuous curve, in other words it must not jump abruptly, fluctuate or deviate temporarily in the wrong direction. This kind of behavior would indicate that the U_R measuring wire has been laid incorrectly.

If an error code is displayed, please proceed as described in section 10.27 "Fault areas and causes" on page 84.


 **If the heatsealing temperature is selected via the analog input at terminals 20+23, the specified voltage value must be checked with a voltmeter before the heatsealing process begins, in order to prevent incorrect settings or excessively high heatsealing temperatures.**

11. Burn in the heatsealing band (↪ section 9.4 "Heatsealing band" on page 31) and repeat the AUTOCAL function.

The controller is now ready

9.5.2 Restart after replacing the heatsealing band

To replace the heatsealing band, proceed as described in section 9.4 "Heatsealing band" on page 31.

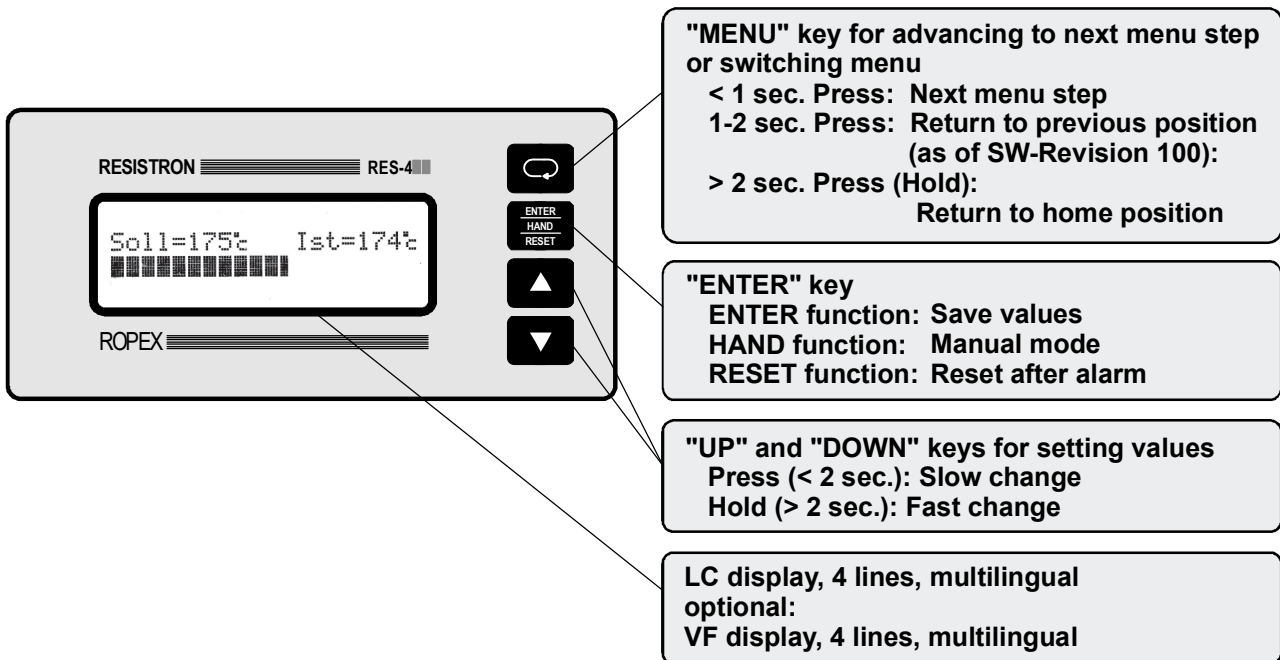
 **Always use a heatsealing band with the correct alloy, dimensions and copper-plating in order to avoid malfunctions and overheating.**

Continue with section 9.5.1, steps 9 and 10.

10 Controller functions

See also section 8.6 "Wiring diagram (standard)" on page 21.

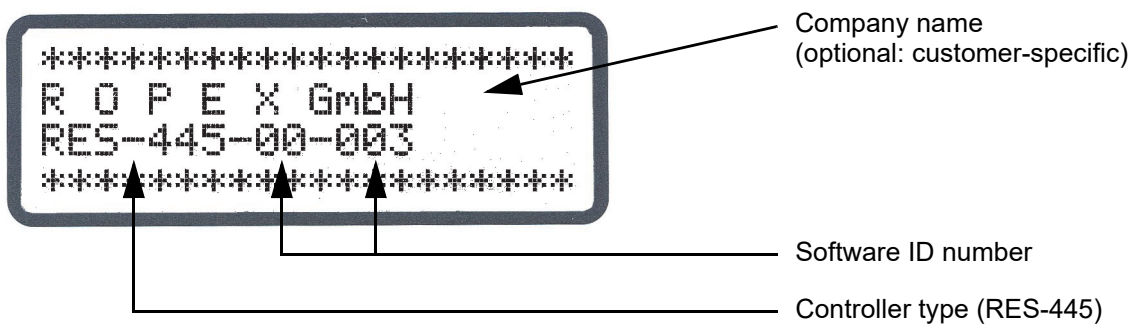
10.1 Indicators and controls



10.2 Display

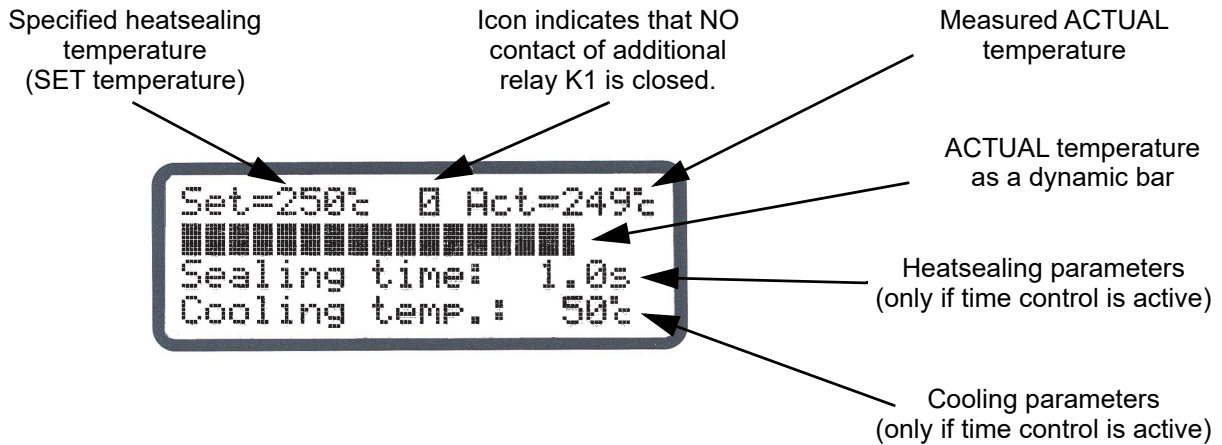
10.2.1 Power-up message

A power-up message appears on the display for approximately 2 seconds when the controller is switched on. This message also includes details of the software version.



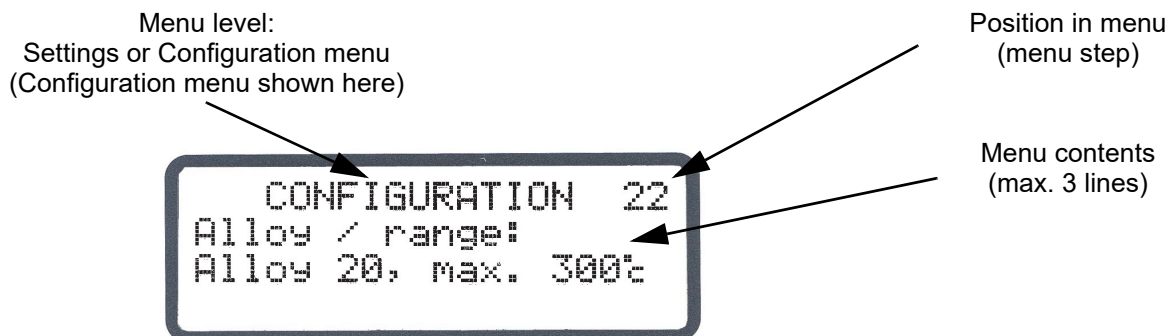
10.2.2 Display in home position

If no settings are entered on the controller and no error message are present, the display is in the home position, in other words it indicates the SET temperature as a digital value and the ACTUAL temperature as a digital value and a dynamic bar. If time control (timer function) is active, the time control settings are also displayed.



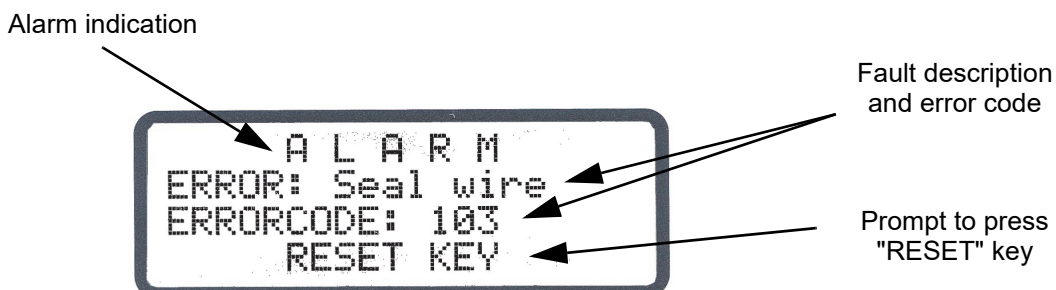
10.2.3 Settings/Configuration menus

The required parameters are set on two menu levels: the Settings (control) menu and the Configuration menu (↪ section 10.4 "Menu structure" on page 39).



10.2.4 Error messages

The fault diagnosis function of the controller is always active. If a fault is detected, it is indicated on the display immediately in the form of an error message (↪ section 10.25 "System monitoring/alarm output" on page 79).



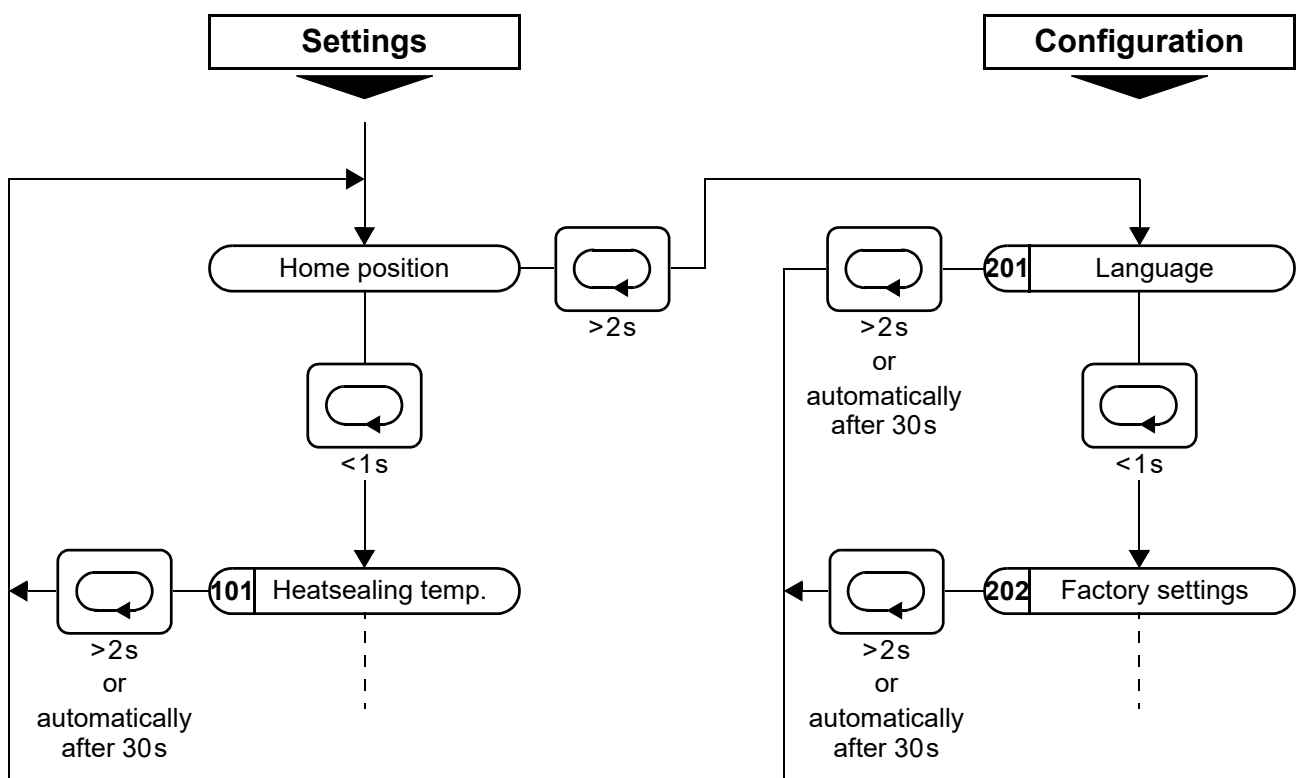
10.3 Navigation in the menus

10.3.1 Navigation in menus without a fault

A "MENU" key is provided for navigating through the various menu steps and levels. By pressing this key briefly (<1s) at any time, you can jump to the next menu step. As of software revision 100, you can also jump to the previous menu step by pressing the "MENU" key for 1-2s. By pressing the key for longer (>2s), you can return to the home position from anywhere in the menu structure, providing a controller alarm is not active. In this case, the Alarm menu is opened instead.

If the display is in the home position or an alarm is indicated and you press the "MENU" key for longer than 2s, you are taken directly to the configuration level (starting at step 201 [20]).

In addition, you always return to the home position if you do not press any keys for a period of 30s. There is no automatic return after 30s from "AUTOCAL" or "Alarm".

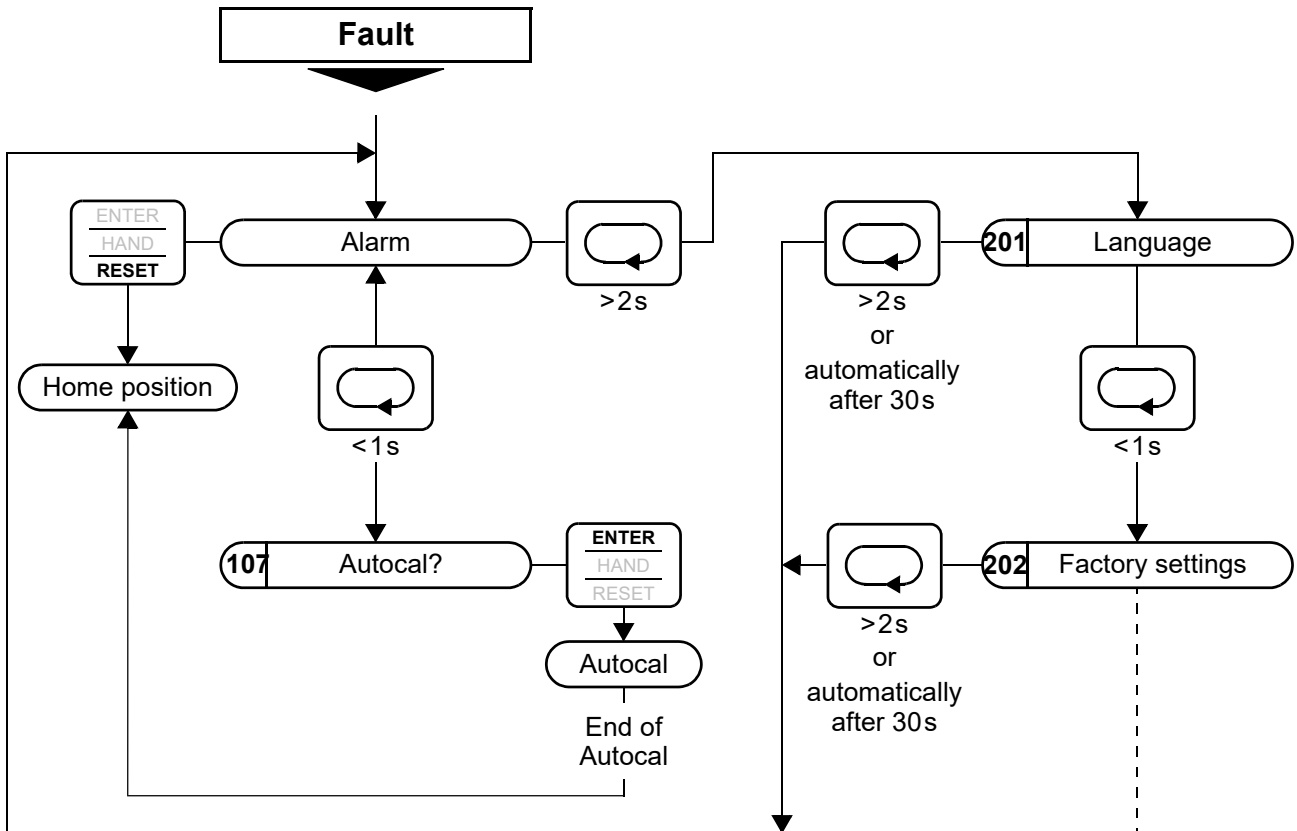


10.3.2 Navigation in menus with a fault

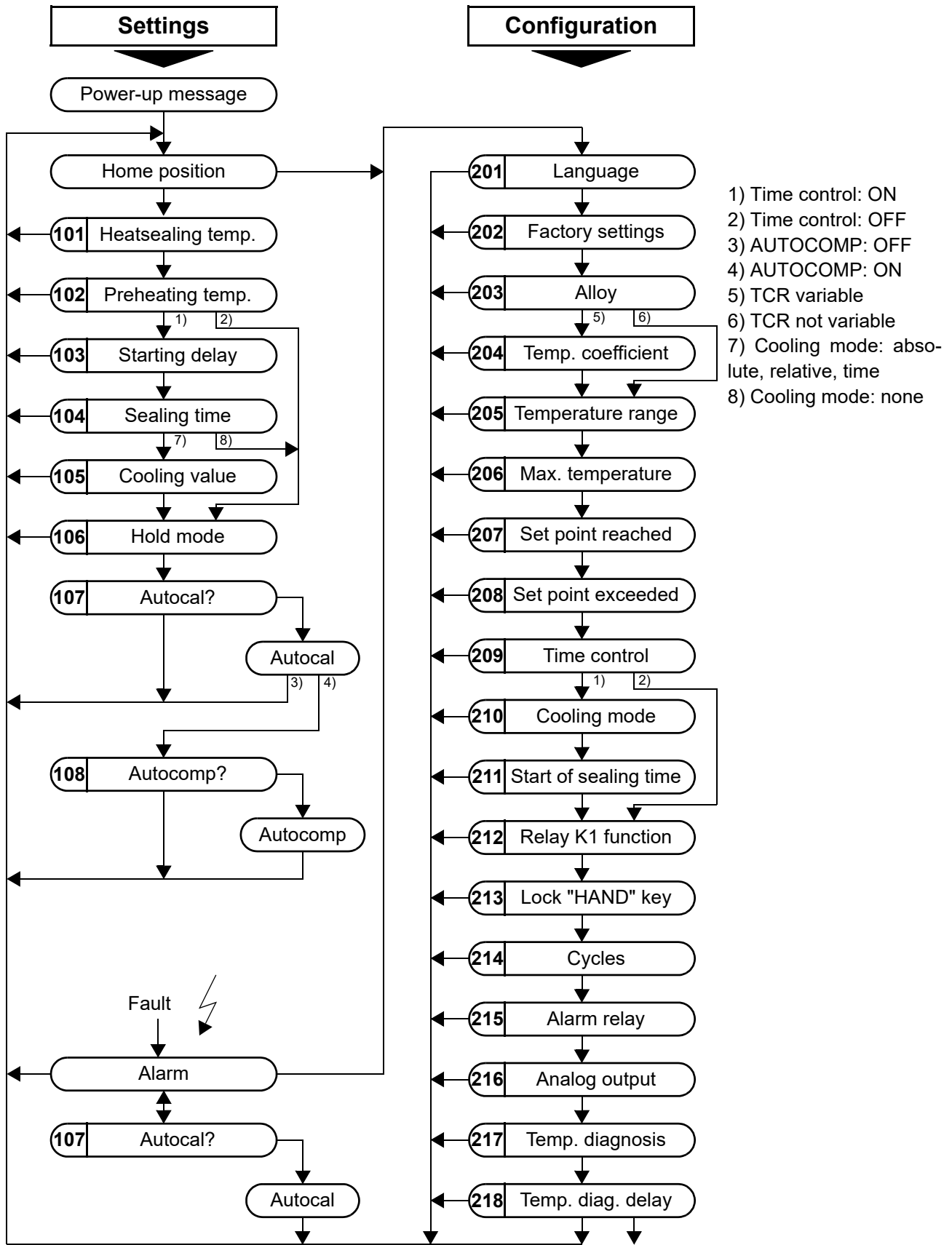
If an alarm is signaled, the controller switches to the Alarm menu. Some faults can be acknowledged by pressing the "RESET" key (↵ section 10.25 "System monitoring/alarm output" on page 79). In this case, the controller switches back to the home position.

If the fault can be rectified by executing the AUTOCAL function, you can select the "AUTOCAL" menu step directly by briefly pressing the "MENU" key (<2s). You can then activate the "AUTOCAL" function by pressing the "ENTER" key (↵ section 10.9 "Automatic zero calibration (AUTOCAL)" on page 54).

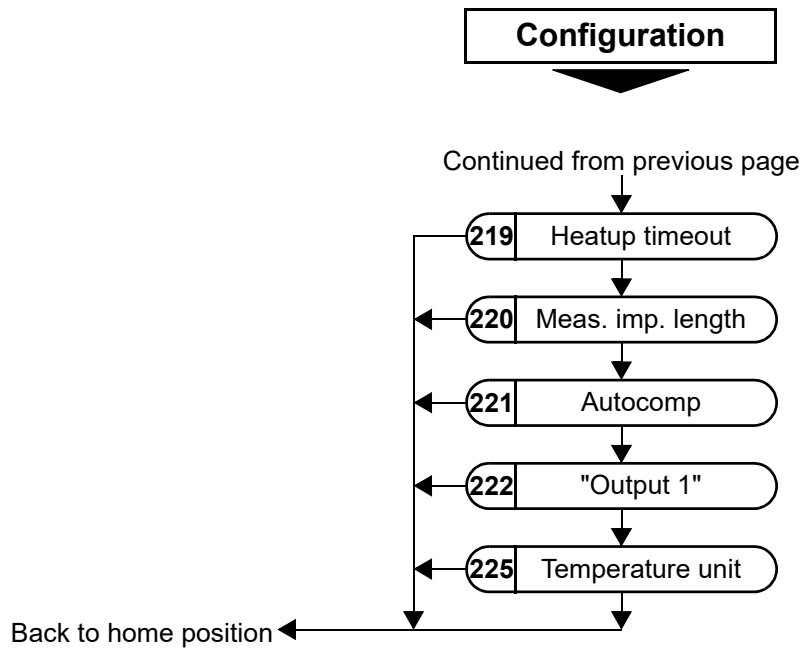
If you press the "MENU" key for longer than 2s in the Alarm menu, you are taken directly to the configuration level (starting at step 201 [20]). You can return from the Configuration menu to the Alarm menu either by pressing the "MENU" key for longer than 2s or by not pressing any keys for 30s.



10.4 Menu structure



Continued on next page




10.5 Two-digit numbering system up to software revision 027

A system of one and two-digit numbers was used for the Settings and Configuration menus up to software revision 027. Three-digit numbers were introduced in software revision 100 to improve the clarity of the menu structure.


The table below compares the two numbering systems:

Menu	Menu steps	Numbering up to software revision 027	Numbering as of software revision 100
Settings menu	Heatsealing temperature	1	101
	Preheating temp. (PREHEAT)	2	102
	Starting delay	3	103
	Heatsealing time	4	104
	Cooling value	5	105
	Hold mode	6	106
	AUTOCAL	7	107
Configuration menu	Language	20	201
	Factory settings	21	202
	Alloy / TCR	22	203, 204
	Maximim temperature	23	206
	Set point reached	24	207
	Set point exceeded	25	208
	Time control	26	209
	Cooling mode	27	210
	Sart of heatsealing time	28	211
	Relay K1 function	29	212
	Cycles	30	214
	Alarm relay	31	215
	Measuring pulse length	32	220
	Analog output	33	216

 All number sor menu steps not listed above are only available as of software revision 100 and are described in chap. 9 „Startup and operation“, page 23 (and section 10.4 "Menu structure" on page 39 respectively).




 The new, three-digit menu step numbers are described first in all relevant sections of this document. The older, two-digit numbers are indicated afterwards in square brackets (e.g. step 201 [20]).

10.6 Menu steps

No.	Name	Description	Setting range
	Home position	<p>The specified set value and the current actual value are displayed in digital form. The actual value is also represented as a dynamic bar.</p> <p>If time control (step 209 [26]) is active, the heat-sealing time and the cooling value are also displayed.</p> <p>The heatsealing band can be heated manually (to the specified heatsealing temperature) by pressing the "HAND" key.</p>	
101 [1]	Heatsealing temperature	<p>The required heatsealing temperature (set point) can be set with the "UP" and "DOWN" keys. The maximum selectable set point can be limited with step 203 [22] (alloy/range) and step 204 [23] (max. temperature). If the heatsealing temperature is to be determined by a voltage at the analog input at terminals 20+23, it must be set to 0°C with this menu step. The set point is indicated in the home position.</p> <p> If an external heatsealing temperature (analog input, terminals 20+23) and an internal heatsealing temperature (step 101 [1]) are specified simultaneously, the higher of the two temperatures is used and indicated in the main menu.</p>	Depends on setting of step 205 [22]: 0, 40°C...maximum temperature (step 206 [23])
102 [2]	Preheating temperature	<p>The required preheating temperature can be set with the "UP" and "DOWN" keys. The maximum temperature (step 206 [23]) applies to both the heatsealing temperature and the preheating temperature.</p> <p>The preheating function can be deactivated by entering 0°C.</p>	Depends on setting of step 205 [22]: 0, 40°C...maximum temperature (step 206 [23])
103 [3]	Starting delay	<p>This option allows the heatsealing time to be preceded by a starting delay. This delay time begins as soon as the start signal is applied. When it elapses, the heatsealing time is activated.</p> <p>This function can only be selected if time control (step 209 [26]) is active.</p>	0...9.9s
104 [4]	Heatsealing time	<p>The length of the heatsealing pulse can be set with the "UP" and "DOWN" keys. The specified heatsealing time is indicated in the home position.</p> <p>This function can only be selected if time control (step 209 [26]) is active.</p>	0...99.9s, EXT

No.	Name	Description	Setting range
105 [5]	Cooling value	<p>The cooling value can be specified here according to the cooling mode (absolute, relative, time) selected with step 210 [27].</p> <ul style="list-style-type: none"> • Absolute: The cycle ends if the "cooling temperature" falls below the set value (in °C). • Relative: The cycle ends if the "cooling temperature" falls below the set percentage value, whereby 100% corresponds to the specified set point (step 101 [1]). • Time: The cycle ends when the set "cooling time" in seconds has elapsed. The current cooling value is indicated in the home position. <p>This function can only be selected if time control (step 209 [26]) is active.</p>	<p>50°C to maximum temperature (step 206 [23])</p> <p>40%...100%</p> <p>0...99.9s</p>
106 [6]	Hold mode	<p>If the "Hold" function is activated, the last measured value at the end of the heating phase is stored and displayed.</p> <p>The "ACT" (actual value) information in the home position is replaced by "Hold". This procedure is repeated for every cycle and the displayed value is updated. The word "Hold" is invisible for 100ms before the value is updated.</p> <p>If you select the "2 second hold" function, the display changes back from hold mode to the actual value in real time after 2 seconds. The hold function is then activated again for 2 seconds at the end of the next cycle.</p>	<p>ON</p> <p>OFF</p> <p>2 s</p>
107 [7]	Autocal	<p>The AUTOCAL function matches the controller to the current and voltage signals that are present in the system.</p> <p>The required calibration temperature can be set with the "UP" and "DOWN" keys. Pressing the "ENTER" key stores the set value and starts the "AUTOCAL" function.</p> <p>The word "- Calibration -" appears on the display while the AUTOCAL function is executing and a counter counts down from 15 to 0. When the controller has been calibrated successfully, the display switches back directly to the home position providing the "AUTOCOMP" function is deactivated. If "AUTOCOMP" is active, the display jumps to step 108.</p> <p>If the controller cannot be calibrated, the AUTOCAL function is aborted and an error message is displayed instead.</p>	<p>0...40°C</p> <p>Software revision 103 or higher also: EXT</p>

No.	Name	Description	Setting range
108	Autocomp	Pressing the "ENTER" key starts the "AUTOCOMP" function. If the "ENTER" key is not pressed within 2s, the display returns to the home position. The home position is automatically displayed if the "AUTOCAL" function is successfully executed and "AUTOCOMP" is active.	
201 [20]	Language	The desired display language can be selected with this menu step.	English German Italian Software revision 015 or higher also: French, Spanish, Dutch, Danish, Finnish, Swedish, Greek, Turkish. Software revision 024 or higher also: Portuguese.
202 [21]	Factory settings	The controller can be reset to the factory settings by pressing the "ENTER" key (↵ section 11 "Factory settings" on page 86). In addition, as of software revision 100: The "UP" and "DOWN" keys can be used to select whether <ul style="list-style-type: none"> • The controller should be reset to the ROPEX factory settings • The current configuration should be specified as the default setting • The controller should be reset to a previously specified default setting 	

No.	Name	Description	Setting range
22	Alloy/range	<p> This step in the Configuration menu is available up to software revision 027 only.</p> <p>Various heatsealing band alloys and temperature ranges can be selected here. The corresponding characteristic for the controller parameters is calculated on the basis of this setting.</p> <p> Please be very careful to select the heat-sealing band material with the correct alloy.</p> <p>The temperature range setting permits the controller to be matched to the required operating range. This also determines the scale for the bar display and the analog output.</p>	<p>(Availability depends on software revision)</p> <p>TCR 410ppm, 300°C TCR 460ppm, 300°C TCR 510ppm, 300°C TCR 570ppm, 300°C TCR 630ppm, 300°C TCR 700ppm, 300°C TCR 780ppm, 200°C TCR 780ppm, 300°C TCR 780ppm, 400°C TCR 780ppm, 500°C TCR 870ppm, 300°C TCR 980ppm, 300°C TCR 1100ppm, 200°C TCR 1100ppm, 300°C TCR 1100ppm, 400°C TCR 1100ppm, 500°C TCR 3500ppm, 200°C TCR 3500ppm, 300°C</p>
203	Alloy	<p>Various heatsealing band alloys can be selected here. The corresponding characteristic for the controller parameters is calculated on the basis of this setting.</p> <p> Please be very careful to select the heat-sealing band material with the correct alloy.</p>	<p>(Availability depends on software revision)</p> <p>TCR 780ppm TCR 1100ppm TCR 3500ppm variable</p>
204	Temperature coefficient	<p>If you selected "Variable" with step 203, you can specify the temperature coefficient of the heat-sealing band material here in 10ppm increments using the "UP" and "DOWN" keys.</p>	400...4000ppm
205	Temperature range	<p>Various temperature ranges can be selected here. The temperature range setting permits the controller to be matched to the required operating range. This also determines the scale for the bar display and the analog output.</p>	200°C 300°C 400°C 500°C
206 [23]	Maximum temperature	<p>This menu item specifies the maximum selectable set point (step 101 [1]) and the maximum selectable preheating temperature (step 102 [2]) within the range defined by step 205 [22].</p>	0 to max. temperature range (step 205 [22])

No.	Name	Description	Setting range
207 [24]	Set point reached (low limit)	<p><u>As of software revision 100:</u> If the actual value is greater than the switching threshold specified here and less than the threshold set with step 208, "Output 1" and/or relay K1 can be activated depending on the configuration (step 212 or 222).</p> <p><u>Up to software revision 027:</u> If the actual value is greater than the switching threshold specified here and less than the threshold set with step 25, the "Temperature OK" output is activated.</p> <p>The value is entered in Kelvins (K) and subtracted from the set point in order to calculate the switching threshold.</p>	-5K...-99K
208 [25]	Set point exceeded (upper limit)	<p><u>As of software revision 100:</u> If the actual value is less than the switching threshold specified here and greater than the threshold set with step 207, "Output 1" and/or relay K1 can be activated depending on the configuration (step 212 or 222).</p> <p><u>Up to software revision 027:</u> If the actual value is less than the switching threshold specified here and greater than the threshold set with step 24, the "Temperature OK" output is activated.</p> <p>The value is entered in Kelvins (K) and added to the set point in order to calculate the switching threshold.</p>	+5K...+99K
209 [26]	Time control	This menu step specifies whether the controller should operate with or without time control.	ON, ON with START monitoring, OFF

No.	Name	Description	Setting range
210 [27]	Cooling mode	<p>The end of the cooling-down phase (end of cycle) can be configured by specifying the required cooling mode.</p> <ul style="list-style-type: none"> • Absolute: The cycle ends if the actual value falls below the cooling temperature set here. • Relative: The cycle ends if the actual value falls below the relative cooling temperature (percentage of the set point) set here. • Time: The cycle ends when the set cooling time has elapsed. <p>This function can only be selected if time control (step 209 [26]) is active.</p>	<p>Absolute (in °C)</p> <p>Relative (in %)</p> <p>Time (in s)</p>
211 [28]	Start of heatsealing time	<p>This menu step specifies whether the heatsealing time (step 104 [4]) should begin as soon as the start signal is applied or when 95% of the set point is reached.</p> <p>This function can only be selected if time control (step 209 [26]) is active.</p>	<p>Heatsealing time starts when heating starts</p> <p>Heatsealing time starts when temperature reached</p>
212 [29]	Relay K1 function	<p>The energizing behavior of relay K1 can be configured as follows:</p> <p>Time control OFF:</p> <ul style="list-style-type: none"> • K1 is not activated • Relay K1 is energized if the actual value is inside the specified temperature tolerance band (steps 207 [24], 208 [25]). 	<p>Relay K1 OFF</p> <p>Relay K1 active if Tact = Tset</p>

No.	Name	Description	Setting range
		<ul style="list-style-type: none"> • In addition, as of software revision 100: K1 is energized if the actual value is inside the specified temperature tolerance band (steps 207, 208). The relay remains energized at the end of the heatsealing cycle and is not deenergized again until the next "START" signal is activated. 	Relay K1 active if Tact = Tset, with latch function
213	Lock of "HAND" key	You can specify here whether or not the heatsealing band can be heated in the home position by pressing the "HAND" key.	ON, OFF
214 [30]	Cycle counter	The number of heating impulses (not manual impulses) is counted and displayed with this menu step. The counter can be reset either by pressing the "ENTER" key or by restoring the factory settings.	Reset with "ENTER" key

No.	Name	Description	Setting range
215 [31]	Alarm relay	<p>This menu step permits the switching characteristics of the alarm relay to be configured.</p> <ul style="list-style-type: none"> • Normal: The alarm relay output (terminals 5+6) operates as an NO contact in the event of a fault. • Inverse: The alarm relay output (terminals 5+6) operates as an NC contact in the event of a fault. 	<p>Normal</p> <p>Inverse</p>
216 [33]	Analog output	<p>This menu step determines whether the current actual value or a 10V reference voltage is output at the actual value output (terminal 24). (This setting is possible as of software revision 017). The 10V reference can be used for the connection of an external potentiometer as temperature preset.</p>	Real temperature, 10V reference
217	Temperature diagnosis	If this value is set to "ON" and the actual temperature leaves the tolerance band (steps 207, 208), a fault signal indicating error code 307/308 is output.	OFF ON
218	Temperature diagnosis delay time	<p>This delay time starts when the actual temperature enters the tolerance band. The temperature timeout and fault output are not activated until after the delay time has elapsed.</p> <p>This step can only be selected if the temperature diagnosis function (step 217) is active.</p>	0...99.9s
219	Heatup timeout	If the actual temperature is outside the tolerance band when the specified time elapses (after the "START" signal has been activated), a fault signal indicating error code 304 is output.	OFF, 0...99.9s
220 [32]	Measuring impulse length	The length of the measuring impulse can be changed here. This function is only available with a few special applications (MOD 1).	1.7...3.0ms
221	Autocomp	Activates the „AUTOCOMP“ function	OFF, ON
222	"Output 1"	The energizing behavior of output 1 can be configured as follows:	
		<p>Time control OFF:</p> <ul style="list-style-type: none"> • Output 1 is not activated • Output 1 is energized if the actual value is inside the specified temperature tolerance band (steps 207, 208). 	<p>"Output 1" OFF</p> <p>"Output 1" active if Tact = Tset</p>

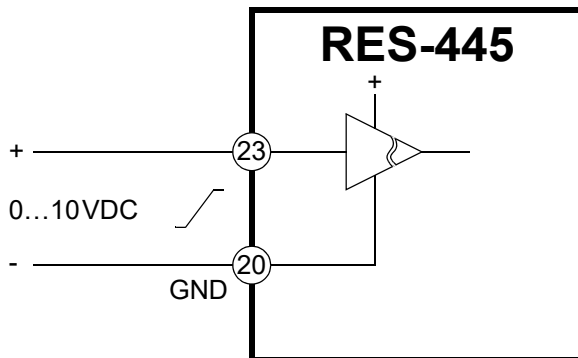
No.	Name	Description	Setting range
		<ul style="list-style-type: none"> Output 1 is energized if the actual value is inside the specified temperature tolerance band (steps 207, 208). The relay remains energized at the end of the heatsealing cycle and is not deenergized again until the next "START" signal is activated. 	"Output 1" active if Tact = Tset, with latch function
		Time control ON: <ul style="list-style-type: none"> Output 1 is not activated Output 1 is energized if the start signal is present. The relay is deenergized at the end of the cooling phase. Output 1 is energized when the actual value reaches 95% of the set point. The relay is deenergized at the end of the cooling phase. Output 1 is energized at the end of the heating phase and deenergized again at the end of the cooling phase. (This setting is possible as of software revision 010) Output 1 is energized for up to 0.5 seconds at the end of the cooling phase (momentary impulse). The length of the momentary impulse can be shortened by applying the "START" signal (during the impulse). Output 1 is energized if the actual value is inside the specified temperature tolerance band (steps 207, 208). Output 1 is energized if the actual value is inside the specified temperature tolerance band (steps 207, 208). The relay remains energized at the end of the heatsealing cycle and is not deenergized again until the next "START" signal is activated. 	"Output 1" OFF "Output 1" active with START signal "Output 1" active when temperature reached "Output 1" active during cooling phase "Output 1" generates end-of-cycle impulse "Output 1" active if Tact = Tset "Output 1" active if Tact = Tset, with latch function
225	Temperature unit	Unit for temperature display and input values	Celsius Fahrenheit

10.7 Temperature setting (set point selection)

The heatsealing temperature can be set on the RES-445 controller in three ways:

- By means of the setting in menu step 101 [1].

- By applying a 0...10VDC voltage to the analog input at terminals 20+23.



The relationship between the applied voltage and the SET temperature is linear.

Voltage values:

0VDC → 0°C

10VDC → 300°C or 500°C (depending on the controller configuration).

Please refer to section 10.8 "Temperature indication/actual value output" on page 52 for a circuit diagram.

If the heatsealing temperature is to be determined by a voltage at the analog input at terminals 20+23, it must be set to 0°C with menu step 101 [1].

! If an external heatsealing temperature (analog input, terminals 20+23) and an internal heatsealing temperature (step 101 [1]) are specified simultaneously, the higher of the two temperatures is used and indicated in the home position.

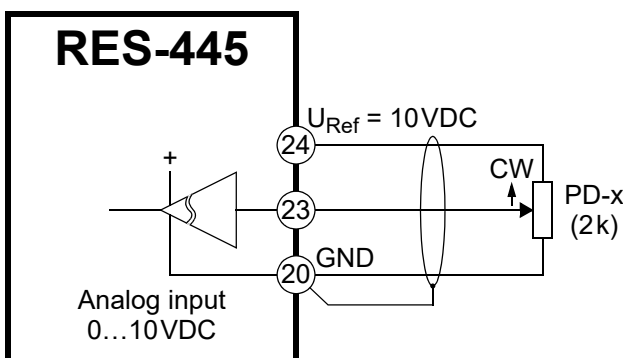
! The maximum value of the setting range is limited either by the maximum value specified with step 206 [23] in the Configuration menu or by the heatsealing band type/temperature range set with step 205 [22].

The set point that is selected for the heatsealing temperature must be greater than 40°C. If not, the heatsealing band will not be heated up when the "START" signal is activated or the "HAND" key is pressed.

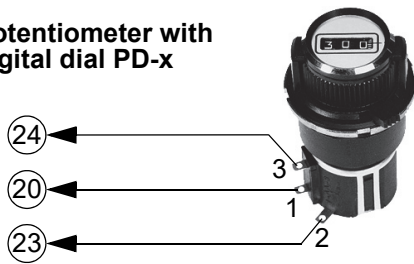
The set heatsealing temperature is displayed in the main menu once it has been entered.

! If the heatsealing temperature is specified via the analog input at terminals 20+23, the external voltage must be activated at least 100ms before the heatsealing process starts. If not, the heatsealing temperature will not reach the required value.

- By connecting a 2kohm potentiometer (e.g. PD-3 or PD-5) to terminals 20, 23 and 24:
(This setting is possible as of software revision 017)



Potentiometer with digital dial PD-x



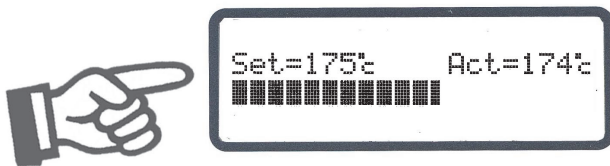
The controller is configured for this purpose so that a fixed 10VDC reference voltage is available at the analog output at terminal 24 (↪ menu step 216 [33], section 10.8 "Temperature indication/actual value output" on page 52).

This voltage is divided by the PD-x set point potentiometer and supplied to the analog input at terminal 23. You can then specify the set temperature in °C in the digital window of the potentiometer.

Once again, the set temperature must be set to zero in step 101 [1].

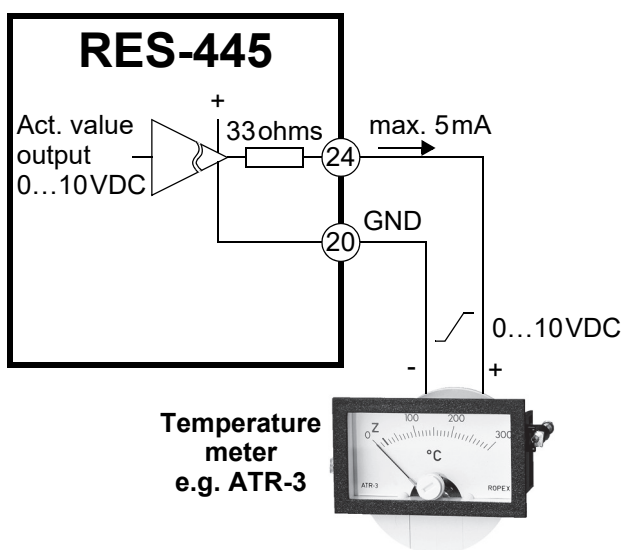
10.8 Temperature indication/actual value output

If the display is in the home position, the ACTUAL temperature is indicated there as a digital value and as a dynamic bar.



The heating and control process can thus be monitored at any time.

In addition, the RES-445 controller outputs an electrically isolated, analog 0...10VDC signal, which is proportional to the real ACTUAL temperature, at terminals 20+24.

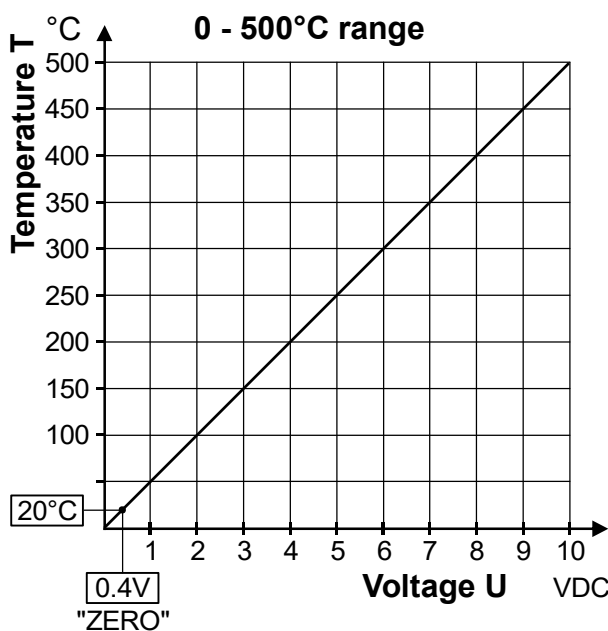
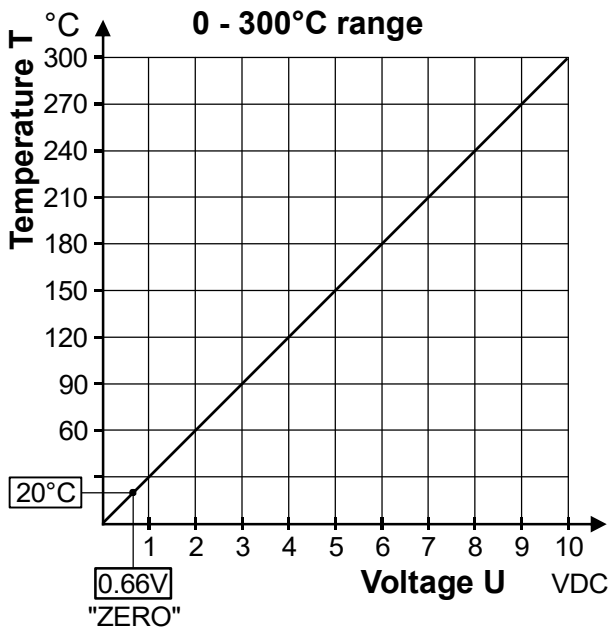


Voltage values:

0VDC → 0°C

10VDC → 300°C or 500°C (depending on the controller configuration).

The relationship between the change in the output voltage and the ACTUAL temperature is linear.



Only the two temperature ranges 300°C and 500°C appear at this actual value output. If a temperature range of 200°C is set for the controller with step 205 [22] in the Configuration menu, it appears at this output in the 0...300°C range. A 400°C temperature range is indicated as 0...500°C.

An indicating instrument can be connected to this output in order to visualize the temperature of the heatsealing band.

The characteristics of the ROPEX ATR-x temperature meter (size, scaling, dynamic response) are ideally suited to this application (↳ section 5 "Accessories and modifications" on page 10).

It not only facilitates SET-ACTUAL comparisons, but also enables other criteria such as the heating rate, set point reached within the specified time, cooling of the heatsealing band etc. to be evaluated.

This meter moreover permits disturbances in the control loop (loose connections, contacting or wiring problems) as well as any line disturbances to be observed extremely effectively and interpreted accordingly. The same applies if mutual interference occurs between several neighboring control loops.

If a fault is signaled, this analog output is used – in addition to the value indicated on the controller – to display a selective error message (↪ section 10.27 "Fault areas and causes" on page 84).

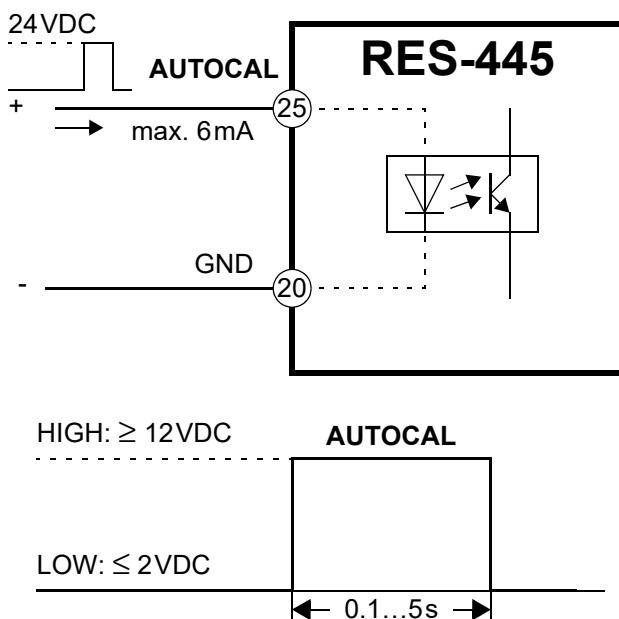
If you want a fixed 10V reference voltage to appear at the analog output (terminal 24), you can configure this in the Configuration menu, step 216 [33] (analog output):

- **Actual temperature (Factory setting)**
The actual value output indicates the current ACTUAL value as a 0...10VDC analog voltage.
- **10V reference**
(This setting is possible as of software revision 017)
A fixed 10VDC reference voltage is output at the actual value output.

10.9 Automatic zero calibration (AUTOCAL)

Owing to the automatic zero calibration (AUTOCAL) function, there is no need to adjust the zero point manually on the controller. The "AUTOCAL" function matches the controller to the current and voltage signals that are present in the system. This function can be activated in two ways:

- By means of a 24VDC signal at terminals 20+25.



- By selecting step 107 [7] in the Settings menu and pressing the "ENTER" key

The initial temperature (ambient temperature) of the heatsealing bar(s) which is currently valid for calibration can be set beforehand in the 0...40°C range using the "UP" and "DOWN" keys.

The zero point is calibrated in the factory to 20°C.

Variable base temperature:

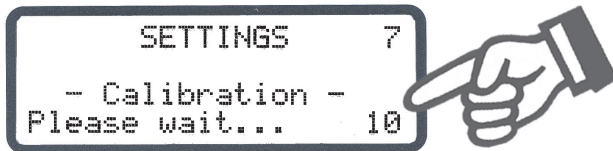
As of software revision 103 you can also specify a base temperature in the +3...+40°C range via the analog input (terminals 20+23). To do this, select "EXT" with step 107 [7] in the Settings menu.

⚠ If you specify the variable base temperature at the analog input via terminals 20+23, the external voltage must be activated at least 200ms before the "AUTOCAL" function is executed. If not, the base temperature will not have the required value.

If the specified temperature is too high (greater than 40°C) or if the selected value varies, an error message appears (error codes 115 and 116; ↪ section 10.26 "Error messages" on page 80).

The automatic calibration process takes around 10...15 seconds. The heatsealing band is not heated until the calibration process has finished.

The message "- Calibration - Please wait..." appears on the display while the "AUTOCAL" function is executing and a counter counts down from 13 to 0. The actual value output (terminals 20+24) is set to 0...3°C (corresponds to app. 0VDC) for the duration of the calibration process.



If the temperature of the heatsealing band varies on controllers as of software revision 100, the "AUTOCAL" function is executed a maximum of three times. If the function still cannot be terminated successfully, an error message appears (↪ section 10.27 "Fault areas and causes" on page 84).



You should always wait for the heatsealing band and the bar to cool down (to ambient temperature) before activating the "AUTOCAL" function.

Reasons for disabled AUTOCAL function:

1. The "AUTOCAL" function cannot be activated if the heatsealing band cools down at a rate of more than 0.1K/second. This is additionally indicated with step 107 [7] in the Settings menu by the message "Heatsealing band still hot! Please wait...".
As of software revision 012, this message is also displayed if the controller cannot be calibrated when the external "AUTOCAL" signal is activated (cooling rate too fast).
2. If the "START" signal (24VDC or contact) or the "PREHEAT" signal (24VDC or contact) is activated, the AUTOCAL function is not executed. As of software revision 024 this is additionally indicated with step 107 [7] in the Settings menu by the message „Autocal locked ! (START-Sig. active)“ or „Autocal locked ! (PREHEAT-Sig. active)“.
3. Directly after the controller is powered up, the AUTOCAL function cannot be activated if a fault with error code 101...103, 201...203, 801 or 9xx occurs (↪ section 10.27 "Fault areas and causes" on page 84). If the controller has already operated correctly - a minimum of once - after powering up, the AUTOCAL function cannot be activated with error codes 201...203, 801 or 9xx.

10.10 "START" signal (HEAT)

The heating process is activated by means of the "START" signal in different ways, depending on the time control status (timer function) (↪ Configuration menu, step 209 [26]) :

1. Time control off (deactivated):

When the "START" signal is activated, the controller-internal set/actual comparison is enabled immediately and the heatsealing band is heated up to the SET temperature. It remains at this temperature until the signal is deactivated again. This process can also be started independently of the "START" signal by pressing the "HAND" key while the display is in the home position.

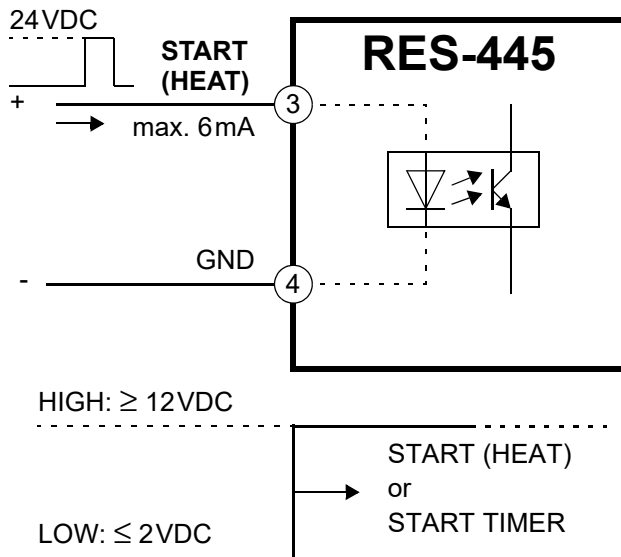
2. Time control on (activated):

If time control (timer function) is on, activating the "START" signal starts the internally parameterized timeout. The time at which the heatsealing band begins to heat up depends on the setting of this parameter. The "START" signal must be deactivated again before the next timeout is activated.

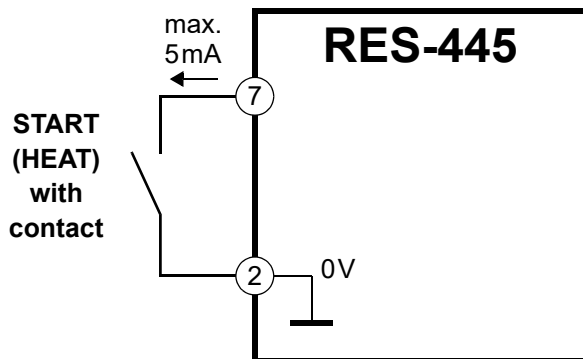
Pressing the "HAND" key while the display is in the home position causes the heatsealing band to start heating up immediately (as described in 1). The internal timeout is not started.

The "START" signal can be activated in two ways:

- By means of a 24VDC signal at terminals 3+4.



- By means of a control contact at terminals 2+7



⚠ The "START" signal is disabled as long as the AUTOCAL function is executing in the Settings menu (with step 107 [7]) or the "RESET" signal is active.

The set point that is selected for the heatsealing temperature (step 101 [1] in the Settings menu) must be greater than 40°C. If not, the heatsealing band will not be heated up.

The alarm relay is switched if the "START" signal is activated while an error message is indicating error codes 104...105, 111...113 or 211 (↘ section 10.27 "Fault areas and causes" on page 84). The heatsealing band is likewise not heated.

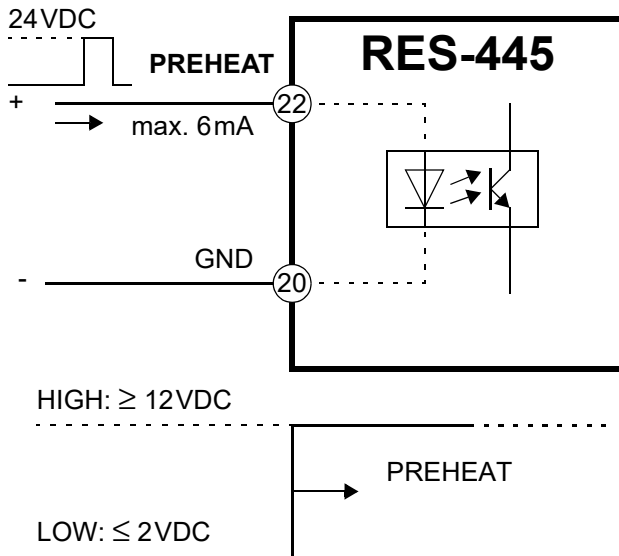
If a "PREHEAT" signal is used, it is deactivated internally during the heating and control process. The heatsealing band is not returned to the set preheating temperature until the "PREHEAT" signal is activated again at the end of the control process for the main heat (section 10.11 ""PREHEAT" signal (preheating)" on page 56).

10.11 "PREHEAT" signal (preheating)

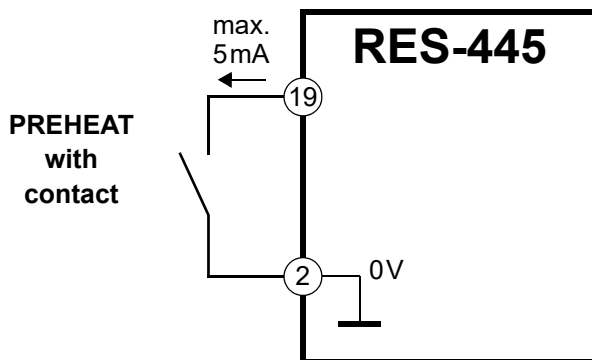
The heatsealing band can be heated to a specified preheating temperature with the "PREHEAT" function, in order to shorten the temperature rise time to the selected SET temperature for time-critical applications.

The preheating temperature is set with step 102 [2] in the Settings menu. The "PREHEAT" signal can be activated in two ways:

- By means of a 24VDC signal at terminals 20+22.



- By means of a control contact at terminals 2+19

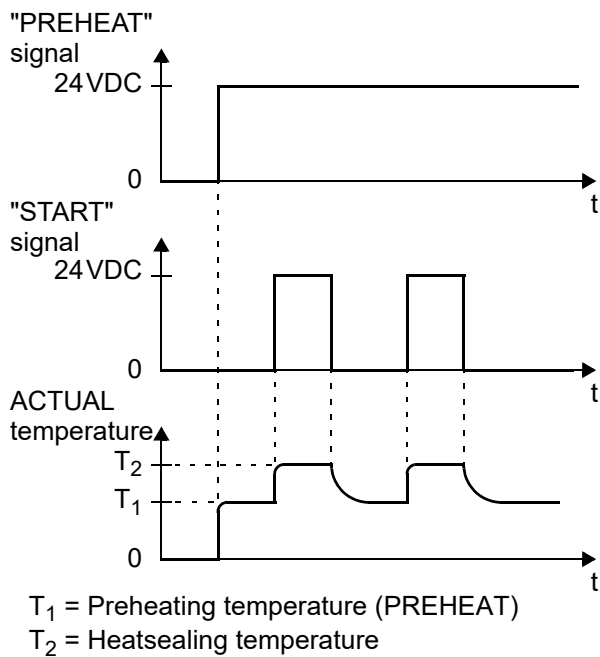


⚠ The "START" signal is disabled as long as the AUTOCAL function is executing in the Settings menu (with step 107 [7]).

The value that is selected for the preheating temperature (step 102 [2] in the Settings menu) must be greater than 40 °C. If not, the heatsealing band will not be heated up.

The alarm relay is switched if the "PREHEAT" signal is activated while an error message is indicating error codes 104...105, 111...113 or 211 (↪ section 10.27 "Fault areas and causes" on page 84). The heatsealing band is likewise not heated.

If a "PREHEAT" signal is active, it is deactivated internally for the duration of a heating and control process that is activated either by means of the "START" signal or by pressing the "HAND" key.



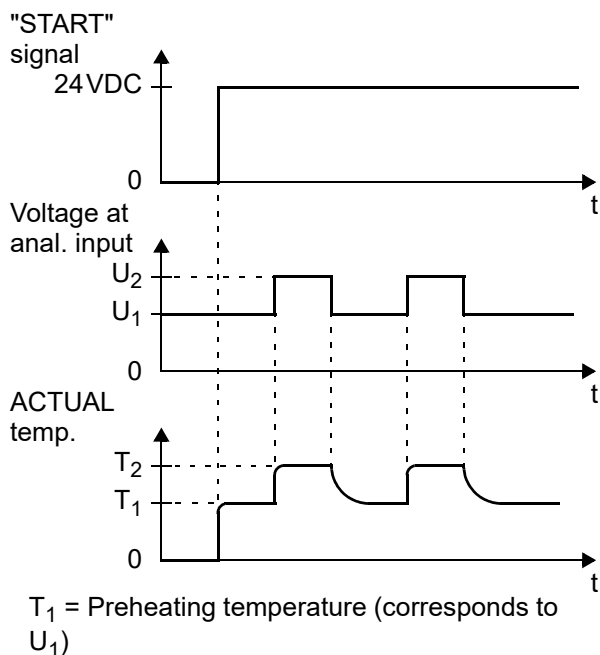
The ACTUAL temperature shows whether the heatsealing band is heated up to the preheating temperature correctly, providing the display is in the home position.

Please note the following if the "PREHEAT" function is used and the temperature is selected via the analog input at terminals 20+23:

The voltage at the analog input is valid for the preheating temperature and the heatsealing temperature. Preheating cannot be activated with the "PREHEAT" signal in conjunction with the analog input.

If this function is used, the preheating temperature must be set by altering the voltage value at the analog input. The "START" signal is always activated for this purpose (the "PREHEAT" signal is deactivated).

The timing sequence is shown in the diagram below:

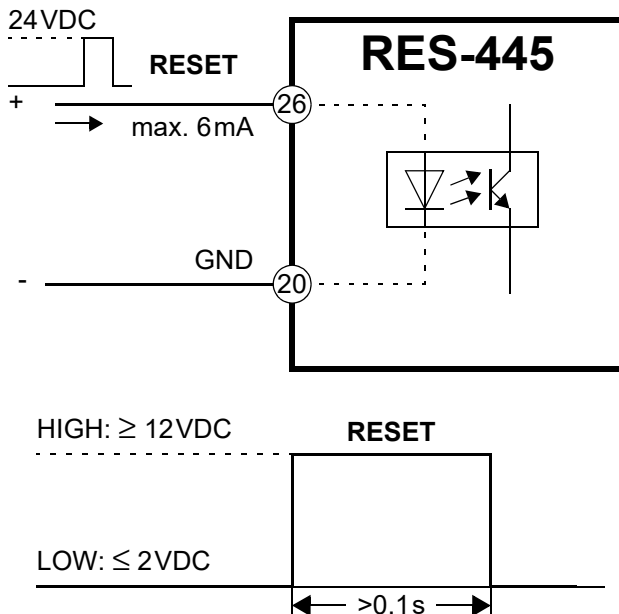


10.12 "RESET" signal

The RESISTRON® temperature controller RES-445 can be reset by means of an external "RESET" signal at terminals 20+26.

As a result:

- A heatsealing cycle is aborted if one is in progress
- No more measuring impulses are generated
- An error message is reset if one is present



The actual value output changes to 0...3°C (i.e. approximately 0VDC) while the "RESET" signal is being activated. This may be interpreted by the higher-level controller (e.g. a PLC) as feedback.

The message "External RESET signal active" is additionally displayed on the controller as of software revision 009 when the "RESET" signal is active.

The "AUTOCAL" function is not aborted if the "RESET" signal is activated while it is still executing.

! The controller executes an internal initialization for approximately 500ms after the "RESET" signal is deactivated. The next heatsealing process cannot be started until it has finished.

! If a contactor Kb is used to deactivate the control loop (see section 8.3 "Power supply" on page 18), it must be reliably energized again 200ms at the latest after the "RESET" signal is deactivated (note the contactor switching and delay times). If it is energized too late, an error message will be output by the controller.

10.13 Cycle counter

Each activation of the "START" signal during operation is detected by a cycle counter integrated in the controller. Actuations of the "HAND" key are not counted. The counter reading can be displayed with step 214 [30] in the Configuration menu.

The cycle counter is reset to 0 if the "ENTER" key is pressed or if the maximum count of 999.999.999 cycles is exceeded.

10.14 Hold mode

The behavior of the digital indication of the ACTUAL temperature in the home position can be changed with step 106 [6] in the Settings menu. The following settings are possible:

1. **"OFF" (Factory setting)**

If the main menu is visible on the display, the real ACTUAL temperature is always indicated.

2. **"ON"**

If the display is in the home position, the ACTUAL temperature that was valid at the end of the last heatsealing phase is always indicated as a digital value. When the controller is switched on, the real ACTUAL temperature is indicated until the end of the first heating phase.

3. **"2 s"**

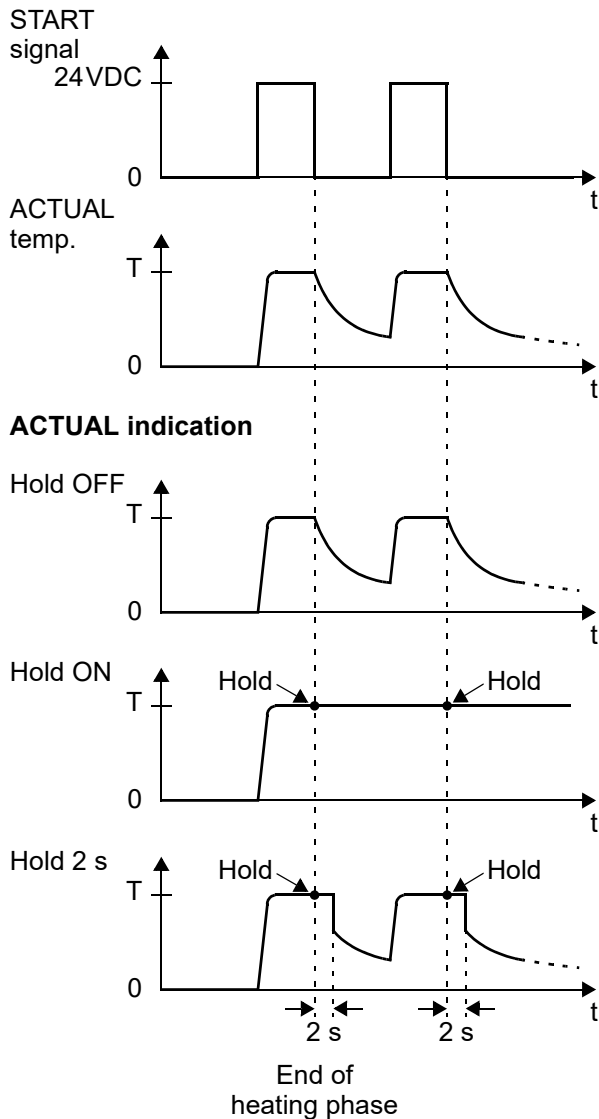
(Software revision 005 or higher)

It causes the current ACTUAL temperature to be displayed as a digital value for an additional 2 seconds at the end of a heatsealing phase. This temperature is then indicated again in real time until the end of the next heating phase.

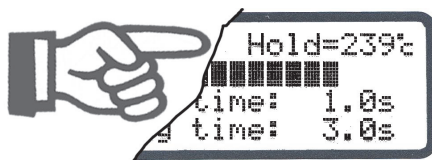


Hold mode only affects the digital value on the display. The ACTUAL temperature in real time is always indicated, regardless of the setting, by the dynamic bar and the actual value output.

The various hold modes are shown below:



The word "Hold" appears on the display if a temperature value is indicated in hold mode. It disappears for approximately 100ms whenever the hold value is updated.



10.15 Measuring impulse duration (as of software revision 026)

The length of the measuring impulses generated by the controller can be set with this parameter by means of step 220 [32]. It may be necessary to set a measuring impulse that is longer than the default 1.7ms for certain applications (↪ ROPEX Application Report).

10.16 Automatic phase angle compensation (AUTOCOMP) (as of software revision 100)

It may be necessary to compensate the phase angle displacement between the U_R and I_R measuring signals in certain heatsealing applications (☞ ROPEX Application Report). The "AUTOCOMP" function is provided for this purpose. It can be parameterized with step 221 as followed:

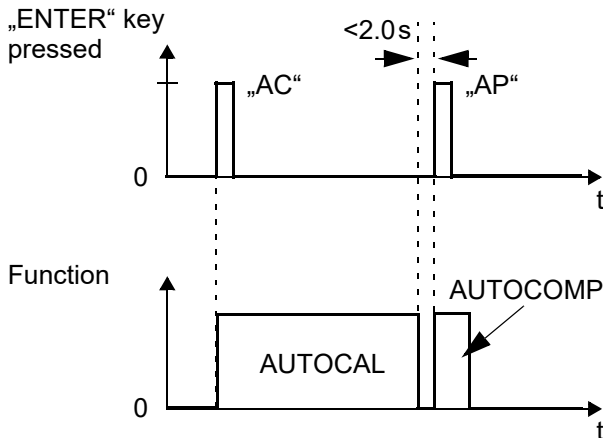
1. „OFF“ (Factory setting)

The „AUTOCOMP“ function is deactivated.

2. „ON“

The „AUTOCOMP“ function is activated by pressing the "ENTER" key after the "AUTOCAL" function has been successfully executed (☞ section 10.9 "Automatic zero calibration (AUTOCAL)" on page 54). The interval after the end of the "AUTOCAL" function must be less than 2.0s ("Start AUTOCOMP? Start with ENTER" appears on the display during this time). The subsequent "AUTOCOMP" function is executed in approximately 2.0s ("- AUTOCOMP - Please wait..." appears on the display during this time).

If the interval following the successful execution of the "AUTOCAL" function is longer than 2.0s, the display returns to the home position and the "AUTOCOMP" function is not executed.

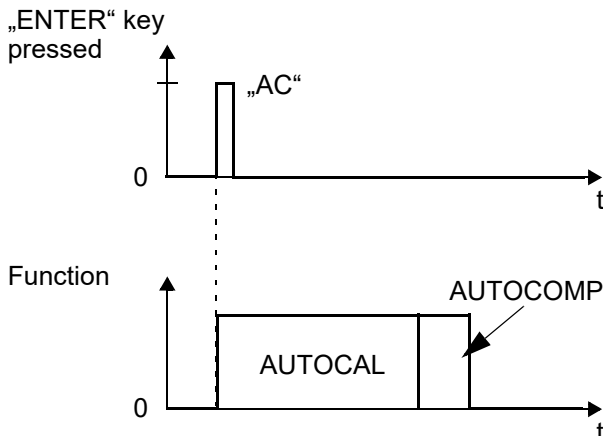


The actual value output (terminals 24+4) is set to 0...3°C (i.e. approx. 0 VDC) when the "AUTOCOMP" function is executed.

3. „AUTO“

(as of software revision 105)

With this setting the „AUTOCOMP“ function is activated automatically after the "AUTOCAL" function has been successfully executed.



The actual value output (terminals 24+4) is set to 0...3°C (i.e. approx. 0VDC) when the "AUTOCOMP" function is executed.

10.17 Locking the "HAND" key (as of software revision 100)

The "HAND" key function can be configured with step 213 in the Configuration menu when the display is in home position.

This prevents the heatsealing bands from being heated if the "HAND" key is pressed inadvertently.

The following settings are possible:

1. Lock „OFF“ (Factory setting)

Pressing the "HAND" key while the display is in the home position starts a manual heating process. The heat-sealing band is heated as long as the "HAND" key remains pressed.

2. Lock „ON“

The "HAND" key is locked when the display is in the home position, in other words it has no function.

10.18 Temperature unit Celsius / Fahrenheit (as of software revision 106)

As of software revision 106 the unit for the temperature indication and value selection can be switched between °C (Celsius) and °F (Fahrenheit). It can be parameterized with step 225 as followed:

1. „Celsius“ (Factory setting)

Temperature indication and value selection in Celsius (°C).

2. „Fahrenheit“

Temperature indication and value selection in Fahrenheit (°F)

Up to software revision 105 only Celsius (°C) can be specified on the controller as the temperature unit.



The degree unit can be changed on the controller without interrupting operation



If you specify temperature indication and value selection in Fahrenheit (°F), the controller still uses Celsius (°C) internally. Value steps are therefore possible with this function owing to the conversion from Celsius to Fahrenheit.

10.19 Disabling the Configuration menu

(Software revision 010 or higher)


It is possible to disable all changes to values/parameters in the Configuration menu. This prevents the controller configuration from being tampered with by unauthorized persons.


The Configuration menu can be disabled or enabled by pressing the "MENU" key for 2.0seconds while the power-up message is displayed (after switching on the controller, ↪ section 10.2.1 "Power-up message" on page 35).

The display then shows a message confirming that the disable function is active for 3.0seconds before returning to the home position.

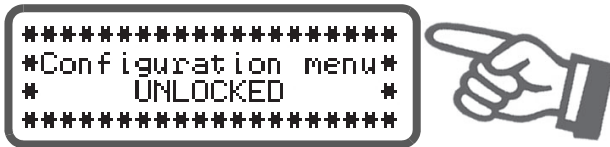


The same message is also displayed for 5.0seconds when you open the Configuration menu to indicate that this menu is disabled.

 **You can still display all steps, values and parameters even if the Configuration menu is disabled. You are no longer allowed to enter or change values, however.**

 **As of software revision 103 the language in menu pos. 201 can be changed while the configuration menu is locked (↪ section 9.3.2 "Setting the language" on page 25).**

The Configuration menu remains disabled until the disable function is canceled again. To do so, repeat the above procedure (press the "MENU" key for 2.0seconds while the power-up message is displayed). The display then shows a message confirming that the disable function has been canceled.



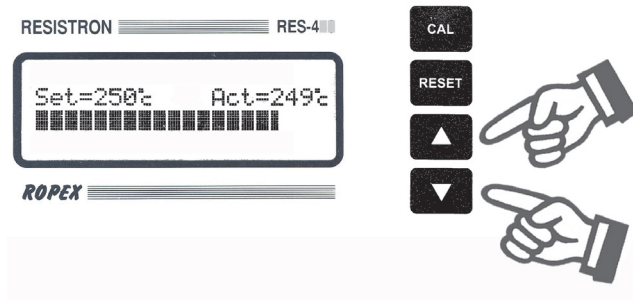
In the factory setting the Configuration menu is not disabled.

10.20 Setting the display brightness (VF display only)

(Software revision 019 or higher)

If the display is in the home position, the brightness of the VF display (blue) can be set in 4 steps (25%, 50%, 75%, 100%) with the "UP" and "DOWN" keys.

The factory setting is 75%.

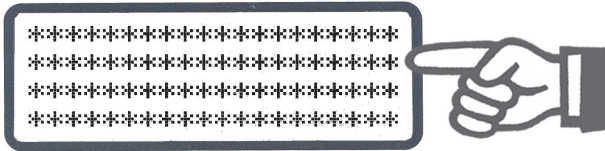


The life of the VF display can be prolonged by reducing the brightness.

10.21 Undervoltage detection

Trouble-free operation of the temperature controller is guaranteed within the line voltage tolerance range specified in section 6 "Technical data" on page 13.

If a line voltage which is less than the lower limit of the permissible range occurs, the controller is switched to a standby mode. No more heatsealing processes take place and no more measuring impulses are generated. The display changes to indicate this.



The main menu is displayed again, and operation is resumed, when the input voltage returns to the specified tolerance range.

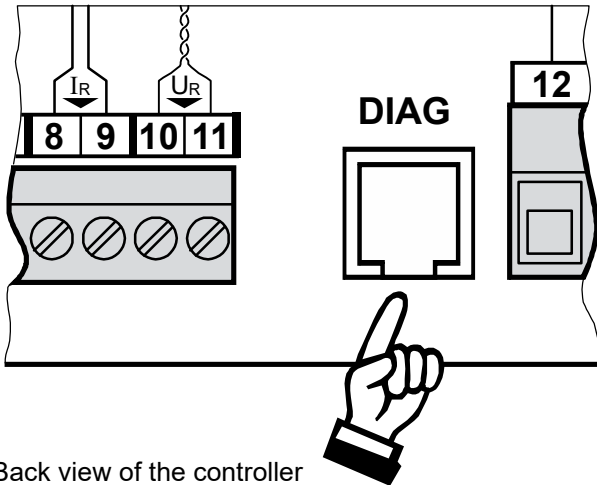
The alarm relay (terminals 5+6) is only switched by an undervoltage condition in controllers up to and including software revision 002. The last valid temperature value continues to appear at the analog output (terminals 20+24).

The alarm relay in controllers with a higher software revision number is not switched if an undervoltage condition occurs. The standby mode is indicated by 0...3°C (corresponds to app. 0V) at the analog output.

⚠ Trouble-free operation of the controller is only guaranteed within the specified input voltage tolerance range. An external voltage monitor must be connected to prevent defective heatseals as a result of low line voltage.

10.22 Diagnostic interface/visualization software (as of software revision 100)

An interface with a 6-pole Western socket is provided for systemdiagnostics and process visualization. This interface allows a data connection to be set up to the ROPEX visualization software using the ROPEX communication interface CI-USB-1.



Back view of the controller

! Only a ROPEX communication interface is allowed to be connected to the diagnostic interface. Connecting another device (e.g. a telephone cable) could result in malfunctions or damage to the controller.

The ROPEX visualization software is described in a separate document.

10.23 Booster connection

The RES-445 controller has a connection for an external switching amplifier (booster) as standard. This connection (at terminals 1+2) is necessary for high primary currents (continuous current > 5A, pulsed current > 25A). The switching amplifier should be connected as described in section 8.7 "Wiring diagram with booster connection" on page 22. No settings are required in the menu.

10.24 Time control (timer function)

10.24.1 Activation and indication



The settings described here are only allowed to be entered by technically trained persons. An incorrectly parameterized timer function may cause disruptions to operation and damage to the machine.

The timer function is activated with step 209 [26] in the Configuration menu. There are two possible settings in this menu:

1. **"OFF" (Factory setting)**

Time control (timer function) deactivated

2. **"ON"**

Time control (timer function) activated.

The internal timeout is started by activating the "START" signal. The timeout either ends with the parameterized cooling phase or is interrupted by activating the "RESET" signal.

3. **"ON with START monitoring"**

(Software revision 021 or higher)

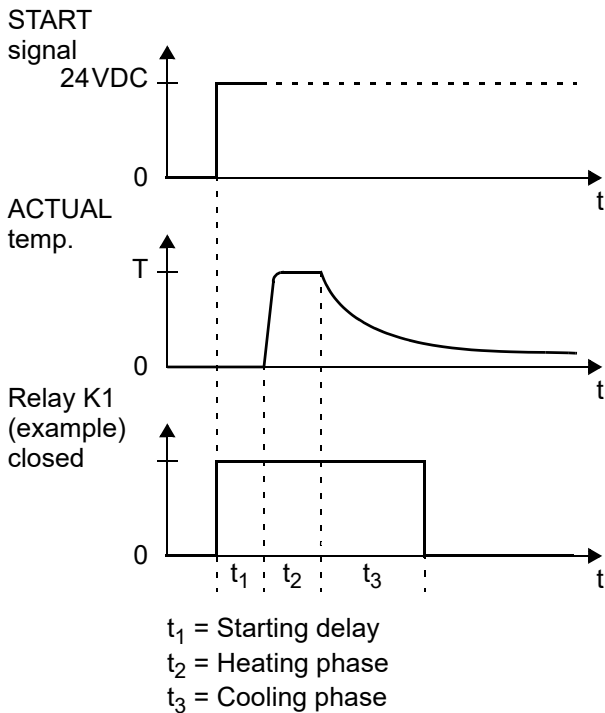
Time control (timer function) activated and "START" signal monitored.

Once again, the internal timeout is started by activating the "START" signal. In this setting, however, the "START" signal must remain activated until the end of the parameterized cooling phase. If the "START" signal is deactivated before the end of the cooling phase - or if the "RESET" signal is activated - the timeout is interrupted.

If time control is on, activating the "START" signal starts the internally parameterized timeout. This timeout comprises:

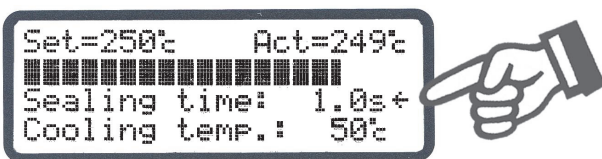
- Starting delay (delay at the beginning of the heating phase)
- Heating phase (heating and control process)
- Cooling phase
- Relay K1 function

! If time control (timer function) is activated, it is only possible to start a heating process with the "HAND" key on the controller. The timeout of the internal time control cannot be started with this key.

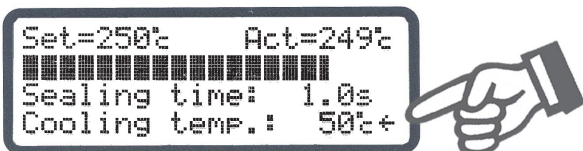


! The timeout of the internal time control (timer function) can be interrupted by activating the external "RESET" signal (software revision 009 or higher) or by switching off the controller. As of software revision 021, it can also be interrupted by deactivating the "START" signal if time control "ON with START monitoring" is configured.

If the display is in the home position, the individual timeouts can be monitored there. The remaining heatsealing time is indicated on the display in the form of a countdown at the end of the heating phase. A direction arrow indicates the active process.

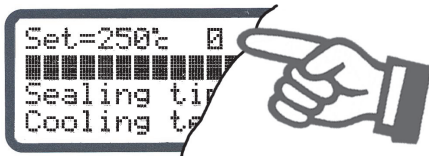


The active cooling phase is subsequently marked with the direction arrow at the end of the heating phase.



The direction arrow disappears again at the end of the cooling phase (i.e. at the end of the internal timeout).

The current condition of relay K1 is indicated by means of a separate icon. If the icon is visible, the normally open contact of the relay is closed.

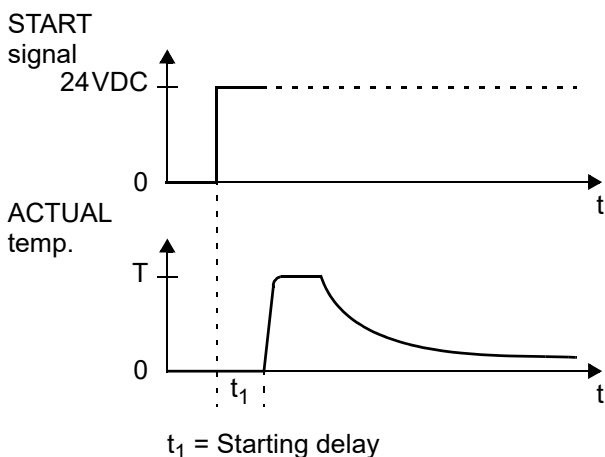


Separate settings can be entered for the individual timeouts. These settings are possible with steps 103 [3], 104 [4] and 105 [5] in the Settings menu and with steps 210 [27], 211 [28] and 212 [29] in the Configuration menu. The options available with these advanced settings are described below.

10.24.2 Setting the starting delay

The start of the heating process can be explicitly delayed by entering a starting delay time with step 103 [3] in the Settings menu, e.g. in order to bridge the closing time of the heatsealing bars.

When the "START" signal is activated, the controller waits for the time specified with this menu step to elapse before commencing the heating process.



The starting delay can be set in the range from 0 to 9.9s. A delay of 0s is defined as the factory setting. In this case, the heating process begins as soon as the "START" signal is activated.

10.24.3 Setting the heatsealing time

This menu step is used to enter the heatsealing time. There are two possible ways to set the heatsealing time:

1. **"0...99.9s"**

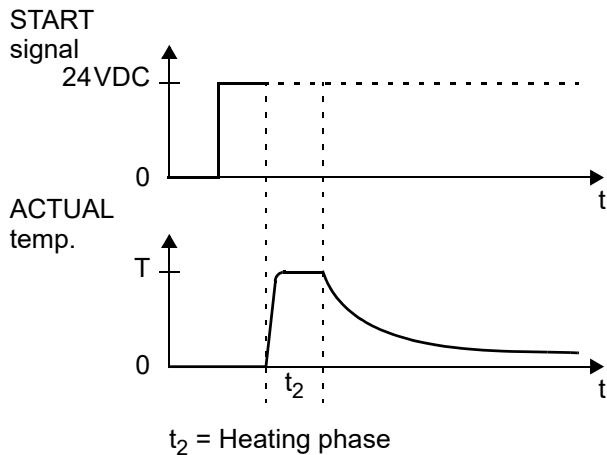
The heatsealing time can be set in the range from 0 to 99.9s. The factory setting is 1.0s.

2. **"EXT"**

(This setting is possible as of software revision 013)

The heatsealing time is controlled by the "START" signal (24VDC signal applied to terminals 3+4 or contact

applied to terminals 2+7). The duration of the heatsealing time is equal to the active time of the "START" signal.



10.24.4 Setting the cooling mode

Various criteria for the end of the cooling phase can be specified with step 210 [27] in the Configuration menu of the RES-445 controller. The possible settings are as follows:

1. **"Absolute" (Factory setting)**

The cooling phase ends when the ACTUAL temperature of the heatsealing band falls below a specified temperature value. This cooling temperature can be set with step 105 [5] in the Settings menu.

2. **"Relative"**

The cooling phase ends when the ACTUAL temperature falls to a value corresponding to X% of the SET temperature. This percentage cooling value can be set with step 105 [5] in the Settings menu.

Example:

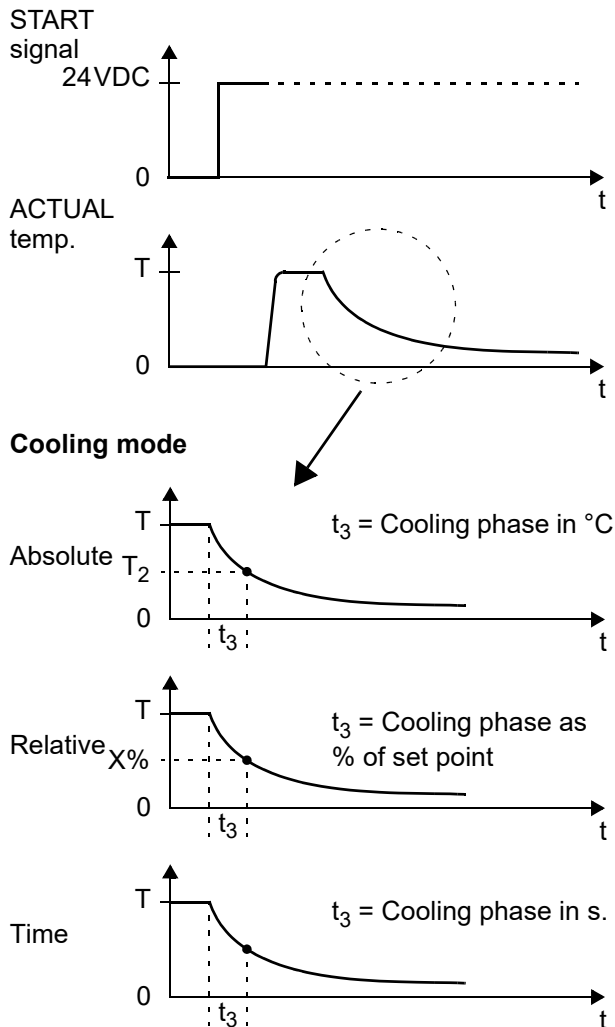
SET temperature = 180 °C, cooling value = 60%

→ Cooling phase ends when ACTUAL temperature ≤ 108 °C

3. **"Time"**

The cooling phase ends after a specified time in seconds and is independent of the ACTUAL temperature. This cooling time can be set with step 105 [5] in the Settings menu.

The various cooling modes are shown below:



10.24.5 Setting the cooling value

After the cooling phase has been configured with step 27 in the Configuration menu (→ section 10.24.4 "Setting the cooling mode" on page 70), you can specify the cooling parameters with step 105 [5] in the Settings menu.

⚠ The options available with step 105 [5] in the Settings menu vary according to the selection made with step 210 [27] in the Configuration menu. All settings entered with menu step 105 [5] are overwritten if step 210 [27] is changed subsequently.

The possible settings are as follows:

1. "Cooling temp. in °C"

(if setting with menu step 210 [27] = "Absolute")

The cooling phase of the internal timeout ends when the ACTUAL temperature of the heatsealing band falls below the set temperature.

The minimum settable temperature is 50°C. This is also the factory setting.

⚠ The maximum value of the setting range is limited either by the maximum value specified with step 206 [23] in the Configuration menu or by the heatsealing band type/temperature range set with step 205 [22].

2. "Cooling temp. in %"

(if setting with menu step 210 [27] = "Relative")

The cooling phase of the internal timeout ends when the ACTUAL temperature falls to the specified percentage of the SET temperature. This value can be set between 40 and 100%.

The factory setting is 40%.

3. "Cooling time in s"

(if setting with menu step 210 [27] = "Time")

The cooling phase ends when the specified time elapses. This time can be set between 0 and 99.9s.

The factory setting is 10.0s.

10.24.6 Setting the start of the heatsealing time

The condition for the start of the set heatsealing time (step 104 [4] in the Settings menu) can be specified with step 211 [28] in the Configuration menu. The following settings are possible:

1. "When heating starts"

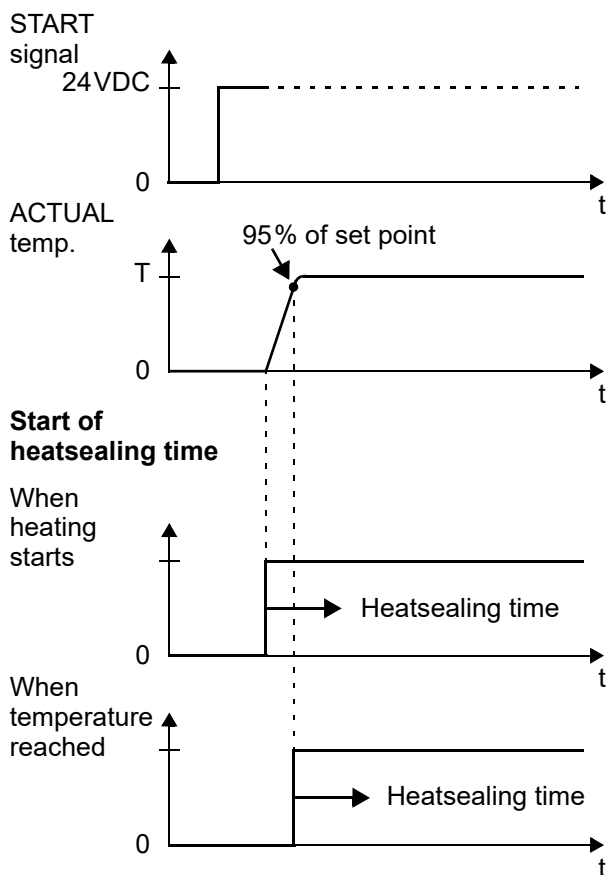
The parameterized heatsealing time starts as soon as the set starting delay elapses (↪ Settings menu, step 103 [3]).

If the starting delay = 0s, the heatsealing time begins as soon as the "START" signal is activated.

2. "When temperature reached" (Factory setting)

Once again, the heating process starts as soon as the set starting delay elapses (↪ Settings menu, step 103 [3]). The specified heatsealing time does not start, however, until the ACTUAL temperature of the heatsealing band reaches 95% of the SET temperature.

These two alternatives are shown below:

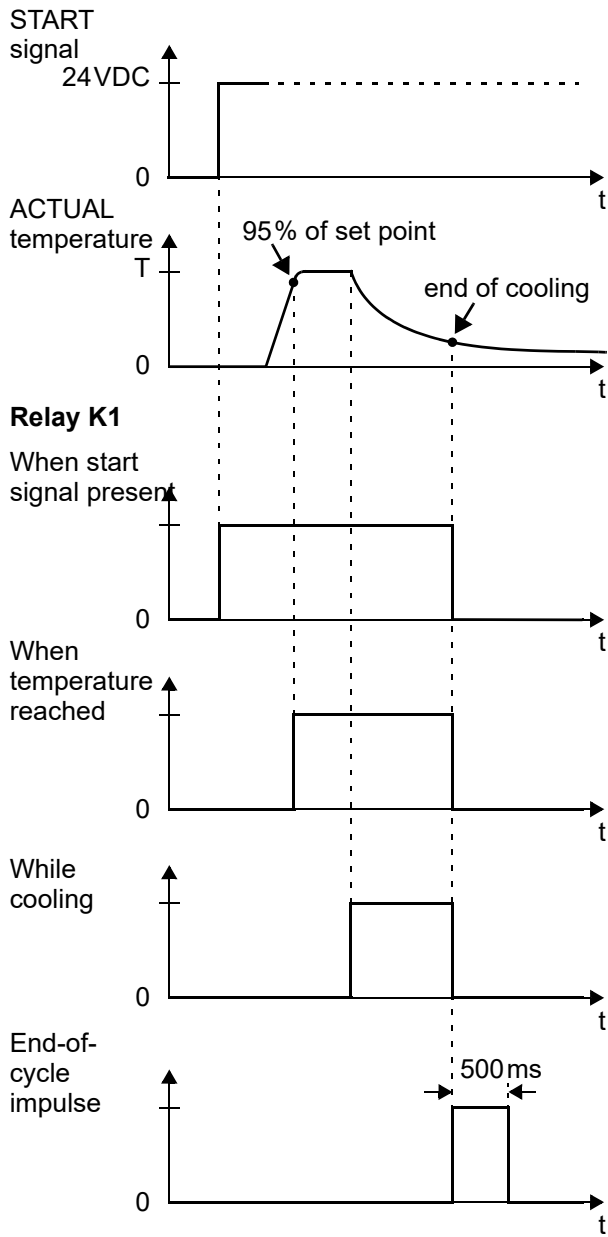


10.24.7 Relay K1 (with time control)

The function of relay K1 when time control is active is also specified with step 212 [29] in the Configuration menu (see section 9.3.8 "Relay K1 (without time control)" on page 27). The settings described here are only possible if time control is active. These settings can be selected as follows:

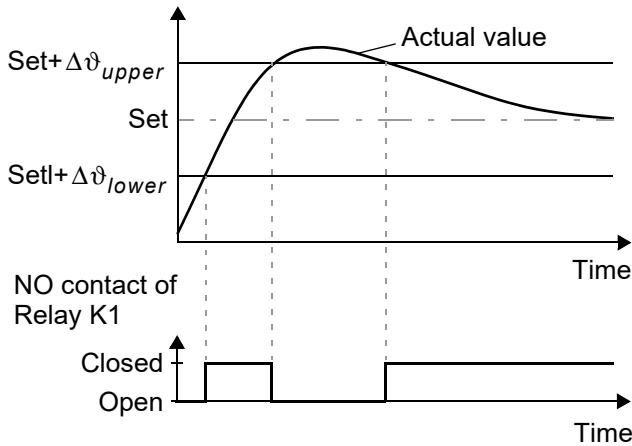
1. **„OFF“**
Relay K1 without function
2. **"When start signal present"**
The normally open contact of relay K1 closes as soon as the "START" signal is activated and remains closed until the end of the parameterized timeout (i.e. until the end of the cooling phase).
3. **"When temperature reached" (Factory setting)**
The normally open contact of relay K1 closes when the ACTUAL temperature reaches 95% of the SET temperature and remains closed until the end of the parameterized timeout (i.e. until the end of the cooling phase).
4. **"While cooling" (Software revision 010 or higher)**
The normally open contact of relay K1 closes at the end of the heating phase and opens again at the end of the cooling phase.
This configuration permits air cooling to be activated with relay K1 during the cooling phase, for instance.
5. **"End-of-cycle impulse"**
The normally open contact of relay K1 closes at the end of the parameterized timeout (i.e. at the end of the cooling phase) and opens again after approximately 500ms. If a "START" signal is activated while relay K1 is still closed, the relay opens again immediately.

The possible settings are shown below:



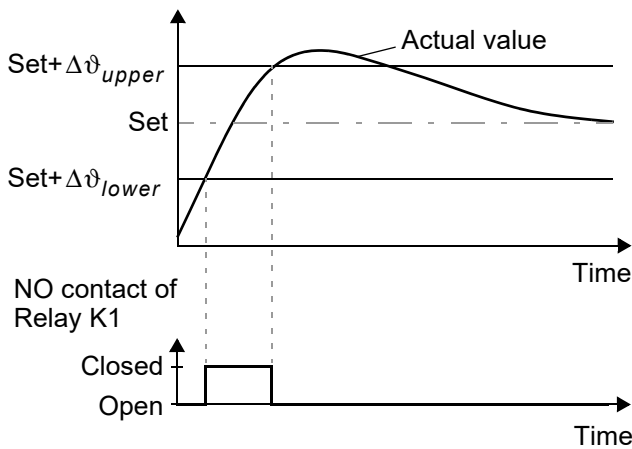
6. "Active if Tact = Tset" (This setting is possible as of software revision 100)

Relay K1 is activated if the actual value is inside the specified temperature tolerance band (steps 207, 208). If the actual temperature is outside the tolerance band, relay K1 is deactivated (see graph below).




7. "Active if Tact = Tset", with latch function (This setting is possible as of software revision 100)

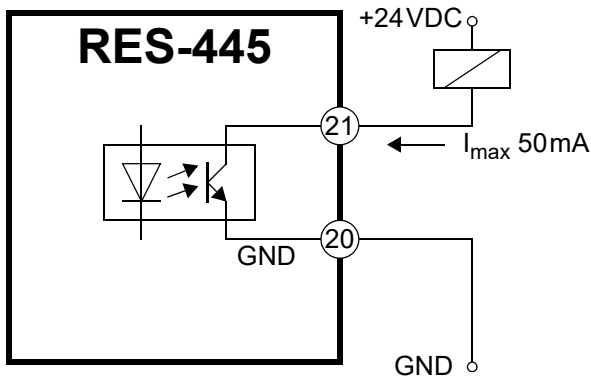
Relay K1 is closed if the actual value is inside the specified temperature tolerance band (steps 207, 208). If the actual temperature leaves the tolerance band once during the heatsealing phase, relay K1 is opened. The relay is not closed again until the next "START" signal is activated. The switching state of relay K1 can thus also be interrogated by the higher-level PLC after a heatsealing process (latch function, see graph below).



10.24.8 "Output 1"/ "Temperature OK" signal (with time control)

 On controllers up to software revision 027, the switching output at terminals 20+21 was called "Temperature OK". The more general name "Output 1" is used as of software revision 100 because this output now also supports other functions.

The "Output 1" signal is available at terminals 20+21 as a digital control signal.



Up to software revision 027:

The switching output at terminals 20+21 ("Temperature OK" signal) always has the function "Active if Tact = Tset" (↪ section 9.3.9 "Output 1"/ "Temperature OK" signal (without time control)" on page 28).

As of software revision 100:

If time control (timer function) is active, the switching output at terminals 20+21 ("Output 1") can be parameterized in the same way as relay K1. The options for "Output 1" are specified with step 222 in the Configuration menu as followed:

1. "Off"
2. "When start signal present"
3. "When temperature reached"
4. "While cooling"
5. "End-of-cycle impulse"
6. "Active if Tact = Tset"
7. "Active if Tact = Tset", with latch function (factory setting)

For a detailed description of these functions, see section 10.24.7 "Relay K1 (with time control)" on page 73.

10.24.9 Preheating (with time control)

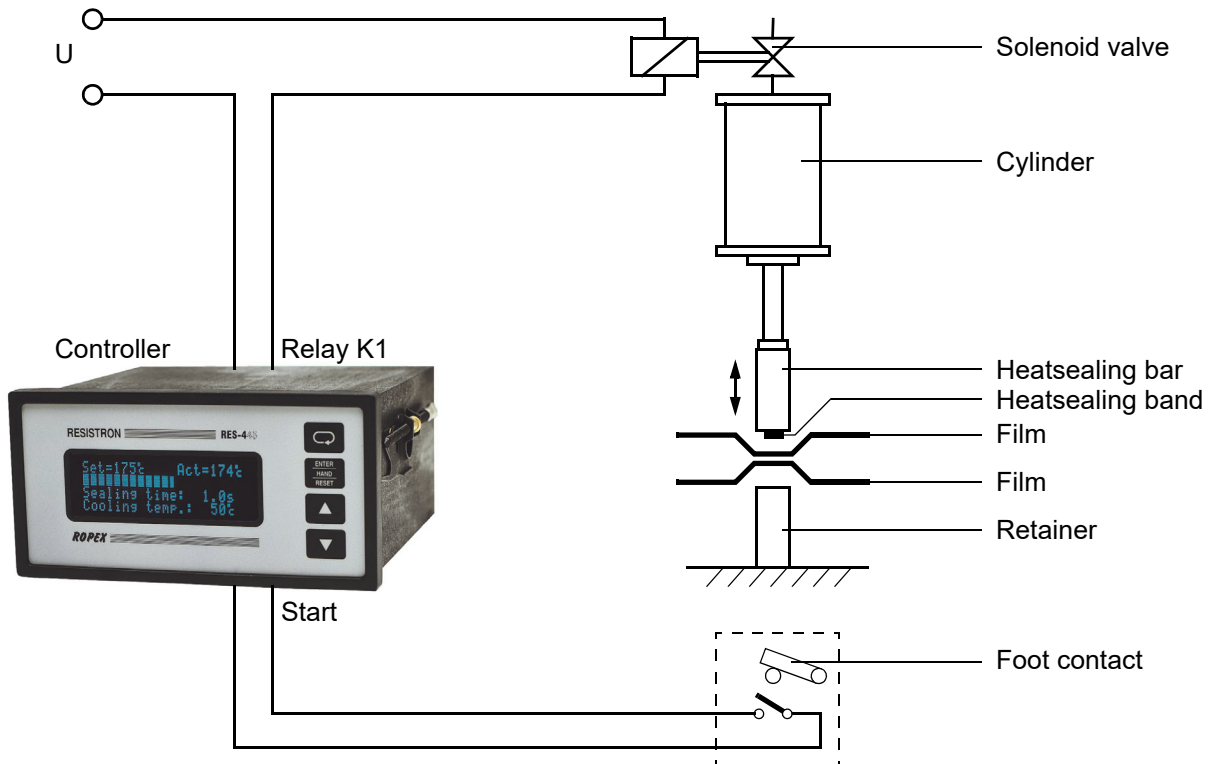
If time control is active, the preheating temperature (↪ section 10.11 "PREHEAT" signal (preheating)" on page 56 is only deactivated during the heating phase. Preheating is active during the starting delay and the cooling phase. The ACTUAL temperature consequently cannot fall below the set preheating temperature during the cooling phase.

The temperature which is set for the end of the cooling phase (↪ section 10.24.5 "Setting the cooling value" on page 71) must always be higher than the preheating temperature. If not, the end of the cooling phase is never reached, i.e. the internal timeout does not elapse.

If the cooling temperature is required to be lower than the preheating temperature, the "PREHEAT" signal must be deactivated until the end of the cooling phase and then activated again.

10.24.10 Example

The example below illustrates the basic design of a pneumatically operated L-sealer with a solenoid valve. The heatsealing process is started by means of a foot switch.

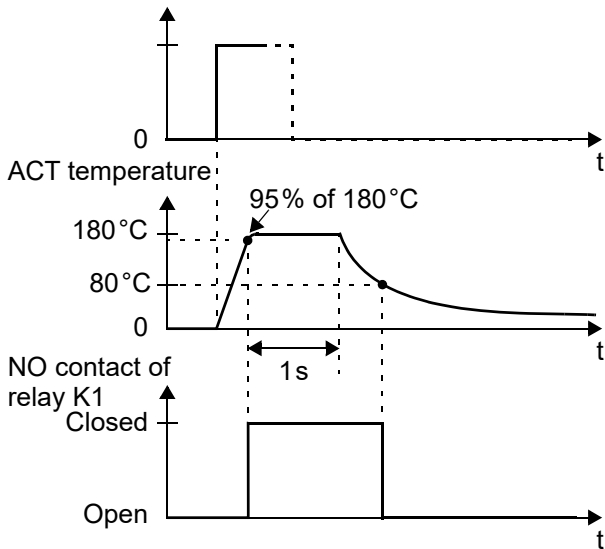


The functional sequence is as follows:

1. The controller receives the "START" signal for internal time control via the foot switch.
2. The heating process must begin immediately – without a starting delay.
3. When the ACTUAL temperature reaches 95% of the SET temperature ($T = 180^{\circ}\text{C}$), the normally open contact of relay K1 must close. The solenoid valve is then energized and the sealing jaws are closed. The heatsealing time ($t_2 = 1\text{ s}$) begins simultaneously.
4. The heatsealing bands are not heated any further at the end of the heatsealing phase (i.e. at the end of the heatsealing time). The cooling phase begins.
5. The cooling phase must end when the ACTUAL temperature of the heatsealing bands falls to $T \leq 80^{\circ}\text{C}$. The sealing jaws are still closed (the normally open contact of relay K1 is also still closed).
6. The normally open contact of relay K1 opens again at the end of the cooling phase. The sealing jaws are also opened again.
7. End of the heatsealing process.

The timing sequence can be represented as follows:

START signal (foot switch)



Required controller settings:

The following controller settings are required for time control (the basic settings such as the temperature range, alloy etc. should already have been entered).

The settings should be undertaken in the specified order.

Step in Configuration menu	Setting
26 (Time control)	"ON"
27 (Cooling mode)	"Absolute"
28 (Start of heatsealing time)	"When temp. reached"
29 (Relay K1 function)	"When temp. reached"

Then:

Step in Settings menu	Setting
101 [1] (Heatsealing temp.)	180°C
103 [3] (Starting delay)	0.0 s
104 [4] (Heatsealing time)	1.0 s
105 [5] (Cooling value)	Cooling temp. = 80°C

10.25 System monitoring/alarm output

To increase operating safety and to avoid faulty heatsealing, the controller incorporates special hardware and software features that facilitate selective fault detection and diagnosis. Both the external wiring and the internal system are monitored.

These features crucially support the system owner in localizing the cause of an abnormal operating state. A system fault is reported or differentiated by means of the following elements.

A.) Error message on the display:



The cause of a fault can be localized quickly and easily with the help of the error code that appears on the display. Please refer to section 10.27 "Fault areas and causes" on page 84 for a list of the possible error codes.

B.) Alarm relay (relay contact, terminals 5+6):

This contact is set in the factory as follows:

- **OPEN** if error code 104...106, 111...113 or 211 is displayed. The contact closes, however, if a "START" signal is activated in this state.
- **CLOSED** if error code 101...103, 107, 108, 201...203, 801 or 9xx appears.

If the alarm relay is configured differently from the factory setting (↪ section 9.3.12 "Configuration of the alarm relay" on page 31), these states are inverted.

C.) Error code output via the 0 to 10VDC actual value output (terminals 20+24):

Since a temperature indication is no longer necessary if a fault occurs, the actual value output is used to display error codes in the event of a fault.


13 voltage levels (up to software revision 027: 12 voltage levels) are offered for this purpose in the 0...10VDC range, each of which is assigned an error code (↪ section 10.27 "Fault areas and causes" on page 84).

If a state that requires AUTOCAL occurs – or if the controller configuration is incorrect – (error codes 104...106, 111...113 or 211), the actual value output jumps back and forth at 1Hz between the voltage value that corresponds to this error and the end of the scale (10VDC, i.e. 300°C or 500°C). If the "START" signal is activated in one of these states, the voltage value does not change any more.

Selective fault detection and indication can thus be implemented simply and inexpensively using the analog input of a PLC with a corresponding error message (↪ section 10.27 "Fault areas and causes" on page 84).

 **An error message can be reset by pressing the "RESET" key, by activating the "RESET" signal at terminals 20+26 (↪ section 10.12 ""RESET" signal" on page 59) or by switching the controller off and then on again.**




 **Invalid error messages may appear when the controller is switched off owing to the undefined operating state. This must be taken into account when they are evaluated by the higher-level controller (e.g. a PLC) in order to avoid false alarms.**

10.26 Error messages

The table below shows how the analog voltage values that appear at the actual value output correspond to the faults that have occurred. It also describes each fault and the required corrective action. The block diagram in section 10.27 "Fault areas and causes" on page 84 permits each fault to be cleared quickly and efficiently

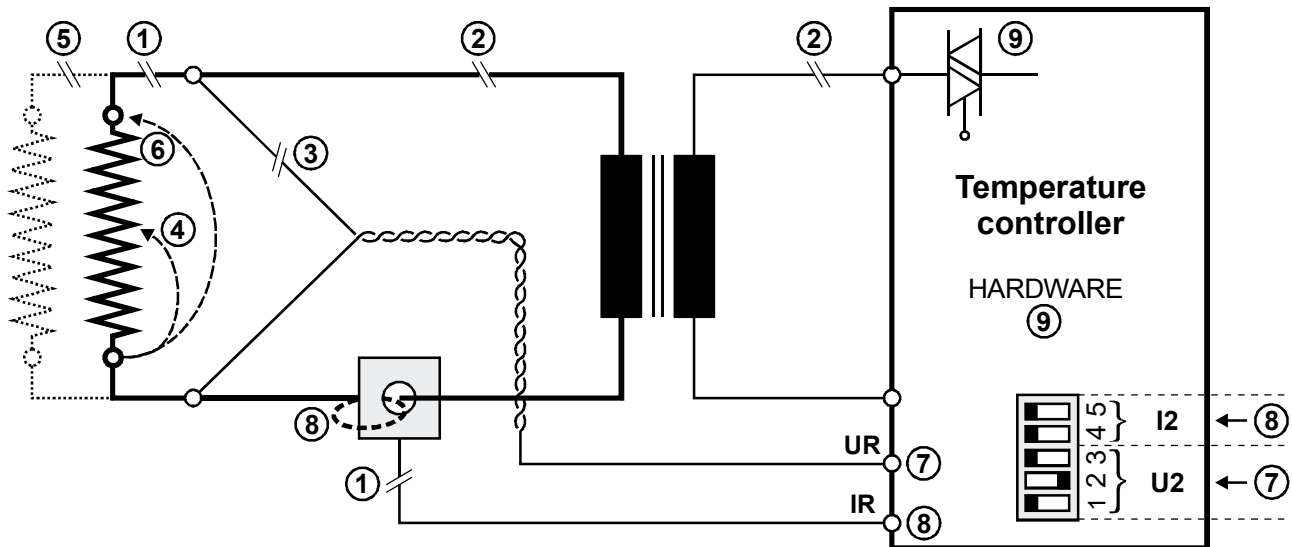
The error codes described below can also be displayed in the ROPEX visualization software (↪ section 10.22 "Diagnostic interface/visualization software (as of software revision 100)" on page 66) to facilitate troubleshooting.

 **If the actual value output is evaluated in order to identify an error message - in the higher-level controller, for instance - the tolerance window must be adjusted to prevent it from being incorrectly interpreted. Please note the tolerances of the actual value output (↪ section 6 "Technical data" on page 13).**

Part 1 of 3:								
Error code	Act. value output; Voltage [V]	Temp. 300 °C [°C]	Temp. 500 °C [°C]	STATUS of alarm relay (factory set.)	Cause	Action if machine started for first time	Action if machine already operating, HS band not chang.	
1	101	0,66	20	Closed	I _R signal missing	Fault area ①	Fault area ①	
2	102	1,33	40		U _R signal missing	Fault area ③	Fault area ③	
3	103	2,00	60		U _R and I _R signals missing	Fault area ②	Fault area ②⑨	
4	107				Temperature step, down	Fault area ④⑤⑥ (loose contact)	Fault area ④⑤⑥ (loose contact)	Fault area ④⑤⑥ (loose contact)
	108							
5	307	2,66	80		Temperature too low/high (↘ section 9.3.10)			
	308							
	309							
	310							
6	201	3,33	100		Frequency fluctuation, inadmissible line frequency		Check power supply	Check power supply
	202							
	203							
7	304	4,00	120	Heatup time too long (↘ section 9.3.11)	Run RESET	Run RESET	Run RESET	
9	901	4,66	140	Int. fault, contr. defective	Int. fault, contr. defective	Replace controller	Replace controller	
	913							
	914							
	915							
	916							

Part 2 of 3:						
NOTE: The specified error messages are initially output as warnings (actual value output jumps back and forth between two values; alarm relay is open). When the "START" signal is activated, the warning changes to a fault (actual value output no longer jumps back and forth, see bold italic values ; alarm relay is closed).						
Error code	Act. value output; Voltage [V]	Temp. 300 °C [°C]	Temp. 500 °C [°C]	STATUS of alarm relay (factory set.)	Cause	Action if machine already operating, HS band not chang.
8	104			Warning: Open Fault: Closed (voltage value at actual value output then no longer changes)	I _R signals incorrect, incorrect specification of impulse-transformer	Run AUTOCAL , Check specification of transformer, Fault area ⑦ ⑧
	105				U _R signals incorrect, incorrect specification of impulse-transformer	
	106	↕ 5,33 ↕ ↕ 10 ↕	↕ 160 ↕ ↕ 300 ↕		U _R and/or I _R signals incorrect, incorrect specification of impulse-transformer	
9	302 (AC)			Temperature too low, AUTOCAL wasn't performed, loose contact, ambient temp. fluctuates	Run AUTOCAL and/or fault area ④ ⑤ ⑥ (loose contact)	Run AUTOCAL and/or fault area ④ ⑤ ⑥ (loose contact)
	303 (AC)					
	211	↕ 6,00 ↕ ↕ 10 ↕	↕ 300 ↕ ↕ 500 ↕		Data error	Run AUTOCAL

Part 3 of 3:									
NOTE: The specified error messages are initially output as warnings (actual value output jumps back and forth between two values; alarm relay is open). When the "START" signal is activated, the warning changes to a fault (actual value output no longer jumps back and forth, see bold italic values ; alarm relay is closed).									
Error code	Act. value output; Voltage [V]	Temp. 300 °C [°C]	Temp. 500 °C [°C]	STATUS of alarm relay (factory set.)	Cause	Action if machine started for first time	Action if machine already operating, HS band not chang.		
10	↔ 6,66 ↳ 10 ↲	↔ 200 ↳ 300 ↲	↔ 333 ↳ 500 ↲	Warning: Open Fault: Closed (voltage value at actual value output then no longer changes)	I _R signal incorrect, calibration not possible	Fault area ⑧, check configuration	---		
11	↔ 7,33 ↳ 10 ↲	↔ 220 ↳ 300 ↲	↔ 366 ↳ 500 ↲		U _R signal incorrect, calibration not possible	Fault area ⑦, check configuration	---		
12	↔ 8,00 ↳ 10 ↲	↔ 240 ↳ 300 ↲	↔ 400 ↳ 500 ↲		U _R and I _R signals incorrect, calibration not possible	Fault area ⑦⑧, check configuration	---		
13	↔ 8,66 ↳ 10 ↲	↔ 260 ↳ 300 ↲	↔ 433 ↳ 500 ↲	Temperature fluctuates, calibration not possible	Ext. calibration temperature too high,				
14				Ext. calibration temperature fluctuates					
15									
16									

10.27 Fault areas and causes


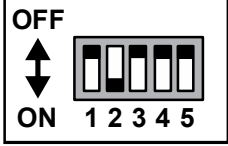
The table below explains the possible fault causes.

Fault area	Explanation	Possible causes
①	Load circuit interrupted after U_R pickoff point	- Wire break, heatsealing band break - Contacting to heatsealing band defective
	PEX-W2/W3 current transformer signal interrupted	- I_R measuring wire from current transformer interrupted
②	Primary circuit interrupted	- Wire break, triac in controller defective - Primary winding of impulse transformer interrupted
	Secondary circuit interrupted before U_R pickoff point	- Wire break - Secondary winding of impulse transformer interrupted
③	U_R signal missing	- Measuring wire interrupted
④	Partial short-circuit (delta R)	- Heatsealing band partially bypassed by conducting part (clamp, opposite heatsealing bar etc.)
⑤	Parallel circuit interrupted	- Wire break, heatsealing band break - Contacting to heatsealing band defective
⑥	Total short-circuit	- Heatsealing band installed incorrectly, insulation at heatsealing bar ends missing or incorrectly installed - Conducting part bypasses heatsealing band completely
⑦	U_R signal incorrect	- Up to software revision 027: DIP switches 1 - 3 configured incorrectly (U_2 range) - As of software revision 100: U_2 outside permissible range from 0.4...120VAC

Fault area	Explanation	Possible causes
⑧	I_R signal incorrect	<ul style="list-style-type: none">- Up to software revision 027: DIP switches 4+5 configured incorrectly (I_2 range)- As of software revision 100: I_2 outside permissible range from 30...500A
	Turns through PEX-W2/W3 current transformer incorrect	<ul style="list-style-type: none">- Check number of turns (two or more turns required for currents < 30A)
⑨	Internal controller fault	<ul style="list-style-type: none">- Hardware fault (replace controller)

11 Factory settings

The RESISTRON® temperature controller RES-445 is configured in the factory as follows:

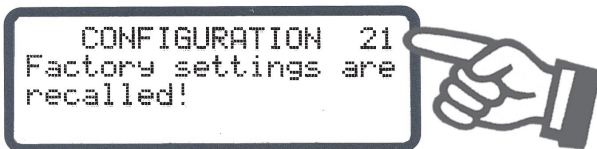
<p><u>DIP switches</u> for secondary voltage U_2 and current I_2 (Up to software revision 027)</p>		<p>$U_2 = 6...60VAC$ $I_2 = 30...100A$</p> <p>DIP switches: 2 ON 1, 3, 4, 5 OFF</p> <p>These switches are automatically set by the AUTO-RANGE function on all controllers as of software revision 100.</p>																																																											
<p><u>Settings menu</u></p>	<table border="0"> <tr> <td>No. 101 [1]</td> <td>Heatsealing temperature:</td> <td>0°C</td> </tr> <tr> <td>No. 102 [2]</td> <td>Preheating temperature:</td> <td>0°C</td> </tr> <tr> <td>No. 103 [3]</td> <td>Starting delay:</td> <td>0s</td> </tr> <tr> <td>No. 104 [4]</td> <td>Heatsealing time:</td> <td>1s</td> </tr> <tr> <td>No. 105 [5]</td> <td>Cooling value:</td> <td>Cooling time: 10s Absolute cooling temperature: 50°C Relative cooling temperature: 40 % of heatsealing temperature</td> </tr> <tr> <td>No. 106 [6]</td> <td>Hold mode:</td> <td>OFF</td> </tr> <tr> <td>No. 107 [7]</td> <td>AUTOCAL temperature:</td> <td>20°C</td> </tr> </table>	No. 101 [1]	Heatsealing temperature:	0°C	No. 102 [2]	Preheating temperature:	0°C	No. 103 [3]	Starting delay:	0s	No. 104 [4]	Heatsealing time:	1s	No. 105 [5]	Cooling value:	Cooling time: 10s Absolute cooling temperature: 50°C Relative cooling temperature: 40 % of heatsealing temperature	No. 106 [6]	Hold mode:	OFF	No. 107 [7]	AUTOCAL temperature:	20°C																																							
No. 101 [1]	Heatsealing temperature:	0°C																																																											
No. 102 [2]	Preheating temperature:	0°C																																																											
No. 103 [3]	Starting delay:	0s																																																											
No. 104 [4]	Heatsealing time:	1s																																																											
No. 105 [5]	Cooling value:	Cooling time: 10s Absolute cooling temperature: 50°C Relative cooling temperature: 40 % of heatsealing temperature																																																											
No. 106 [6]	Hold mode:	OFF																																																											
No. 107 [7]	AUTOCAL temperature:	20°C																																																											
<p><u>Configuration menu</u></p>	<table border="0"> <tr> <td>No. 201 [20]</td> <td>Language</td> <td>German This selection is NOT changed if the factory settings are restored with step 202 [21] in the Config. menu.</td> </tr> <tr> <td>No. 203, 204 [22]</td> <td>Alloy/range:</td> <td>Alloy A20/max. 300°C</td> </tr> <tr> <td>No. 206 [23]</td> <td>Maximum temperature:</td> <td>300°C</td> </tr> <tr> <td>No. 207 [24]</td> <td>Set point reached:</td> <td>-10K</td> </tr> <tr> <td>No. 208 [25]</td> <td>Set point exceeded:</td> <td>+10K</td> </tr> <tr> <td>No. 209 [26]</td> <td>Time control:</td> <td>OFF</td> </tr> <tr> <td>No. 210 [27]</td> <td>Cooling mode:</td> <td>Absolute</td> </tr> <tr> <td>No. 211 [28]</td> <td>Start of heatsealing time:</td> <td>When temperature reached</td> </tr> <tr> <td>No. 212 [29]</td> <td>Relay K1 function:</td> <td>Active when temperature reached</td> </tr> <tr> <td>No. 213</td> <td>Lock of „HAND“ key</td> <td>OFF</td> </tr> <tr> <td>No. 214 [30]</td> <td>Cycle counter:</td> <td>0</td> </tr> <tr> <td>No. 215 [31]</td> <td>Alarm relay:</td> <td>Normal (contact closed by a fault)</td> </tr> <tr> <td>No. 216 [33]</td> <td>Analog output:</td> <td>Actual temperature</td> </tr> <tr> <td>No. 217</td> <td>Temperature diagnosis:</td> <td>OFF</td> </tr> <tr> <td>No. 218</td> <td>Temp.diagnosis delay time:</td> <td>0s</td> </tr> <tr> <td>No. 219</td> <td>Heatup timeout:</td> <td>OFF</td> </tr> <tr> <td>No. 220 [32]</td> <td>Measuring impulse length:</td> <td>Standard (1.7 ms)</td> </tr> <tr> <td>No. 221</td> <td>Autocomp:</td> <td>OFF</td> </tr> <tr> <td>No. 222</td> <td>"Output 1":</td> <td>Active if Tact = Tset, with latch function</td> </tr> <tr> <td>No. 225</td> <td>Temperature unit:</td> <td>Celsius</td> </tr> </table>	No. 201 [20]	Language	German This selection is NOT changed if the factory settings are restored with step 202 [21] in the Config. menu.	No. 203, 204 [22]	Alloy/range:	Alloy A20/max. 300°C	No. 206 [23]	Maximum temperature:	300°C	No. 207 [24]	Set point reached:	-10K	No. 208 [25]	Set point exceeded:	+10K	No. 209 [26]	Time control:	OFF	No. 210 [27]	Cooling mode:	Absolute	No. 211 [28]	Start of heatsealing time:	When temperature reached	No. 212 [29]	Relay K1 function:	Active when temperature reached	No. 213	Lock of „HAND“ key	OFF	No. 214 [30]	Cycle counter:	0	No. 215 [31]	Alarm relay:	Normal (contact closed by a fault)	No. 216 [33]	Analog output:	Actual temperature	No. 217	Temperature diagnosis:	OFF	No. 218	Temp.diagnosis delay time:	0s	No. 219	Heatup timeout:	OFF	No. 220 [32]	Measuring impulse length:	Standard (1.7 ms)	No. 221	Autocomp:	OFF	No. 222	"Output 1":	Active if Tact = Tset, with latch function	No. 225	Temperature unit:	Celsius
No. 201 [20]	Language	German This selection is NOT changed if the factory settings are restored with step 202 [21] in the Config. menu.																																																											
No. 203, 204 [22]	Alloy/range:	Alloy A20/max. 300°C																																																											
No. 206 [23]	Maximum temperature:	300°C																																																											
No. 207 [24]	Set point reached:	-10K																																																											
No. 208 [25]	Set point exceeded:	+10K																																																											
No. 209 [26]	Time control:	OFF																																																											
No. 210 [27]	Cooling mode:	Absolute																																																											
No. 211 [28]	Start of heatsealing time:	When temperature reached																																																											
No. 212 [29]	Relay K1 function:	Active when temperature reached																																																											
No. 213	Lock of „HAND“ key	OFF																																																											
No. 214 [30]	Cycle counter:	0																																																											
No. 215 [31]	Alarm relay:	Normal (contact closed by a fault)																																																											
No. 216 [33]	Analog output:	Actual temperature																																																											
No. 217	Temperature diagnosis:	OFF																																																											
No. 218	Temp.diagnosis delay time:	0s																																																											
No. 219	Heatup timeout:	OFF																																																											
No. 220 [32]	Measuring impulse length:	Standard (1.7 ms)																																																											
No. 221	Autocomp:	OFF																																																											
No. 222	"Output 1":	Active if Tact = Tset, with latch function																																																											
No. 225	Temperature unit:	Celsius																																																											


Up to software revision 027:

The controller can be reset with step 21 in the Configuration menu:



The factory settings are restored if the "ENTER" key is pressed. An acknowledgment message is displayed for approximately 2s.



 **The language which is selected with step 20 in the Configuration menu remains set even if the factory settings are restored.**

11.1 Customer settings (as of software revision 100)

The controller factory settings can be specified or restored with step 202 in the Configuration menu. You can also store customer settings in addition to the Ropex settings:



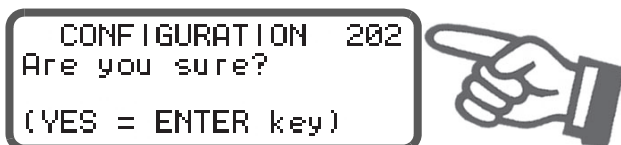
The following settings are possible:

1. **„Restore Ropex settings“ (Factory setting)**
 Selecting this option restores the menu values listed in section 11 "Factory settings" on page 86. These values correspond to the factory settings with which the controller was delivered.
2. **„Define customer settings“**
 Selecting this option saves the values that are currently set in the controller Settings and Configuration menus as "customer settings". These "customer settings" are independent of the Ropex settings. Machine-specific settings can be stored in the controller in this way.
3. **„Restore customer settings**
 Selecting this option restores the "customer settings" that were saved as described in 2.

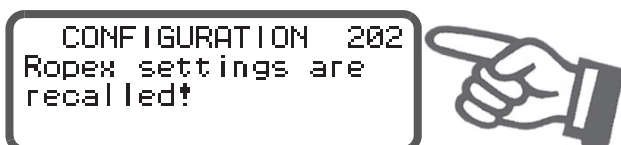


When the controller is first delivered, the "customer settings" are identical to the Ropex settings.

After pressing the "ENTER" key in this menu step, you are asked to confirm the new settings (safety query).



Another message appears if you now confirm these settings by pressing the "ENTER" key for approximately 2seconds.



You can also cancel the new settings by pressing the "MENU", cursor "UP" or cursor "DOWN" keys. Step 203 then appears on the display.




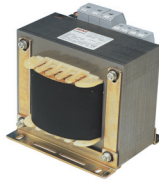





The language which is selected with step 201 in the Configuration menu remains set even if the previous settings are restored.

12 Maintenance

The controller requires no special maintenance. Regular inspection and/or tightening of the terminals – including the terminals for the winding connections on the impulse transformer – is recommended. Dust deposits on the controller can be removed with dry compressed air.

13 How to order

	<p>Contr. RES - 445- . / . . . VAC</p> <ul style="list-style-type: none"> L / 115: LC display, line voltage 115VAC, Art. No. 744511 L / 230: LC display, line voltage 230VAC, Art. No. 744512 L / 400: LC display, line voltage 400VAC, Art. No. 744513 V / 115: VF display, line voltage 115VAC, Art. No. 744521 V / 230: VF display, line voltage 230VAC, Art. No. 744522 V / 400: VF display, line voltage 400VAC, Art. No. 744523 <p>Scope of supply: Controller includes connector plug-in parts (current transformer must be ordered separately)</p> <p>Modification MOD . . (optional, if required)</p> <ul style="list-style-type: none"> e.g. 01: MOD 01, Art. No. 800001 (amplifier for low voltage) <p>Please indicate the article numbers of the controller and the required modifications (optional) in all orders,</p> <p>e.g. RES-445-L/400VAC + MOD 01 (controller with LC display for 400VAC line voltage and amplifier for low voltage) Art. Nos. 744513 + 800001 must be ordered</p>
	<p>Current transformer PEX-W3</p> <p>Art. No. 885105</p>
	<p>Line filter LF- . . 480</p> <ul style="list-style-type: none"> 06: Continuous current 6A, 480VAC, Art. No. 885500 35: Continuous current 35A, 480VAC, Art. No. 885506
	<p>Impulse transformer</p> <p>See ROPEX Application Report for design and ordering information</p>
	<p>Communication interface CI-USB-1</p> <p>Art. No. 885650</p>
	<p>Temp. meter ATR- .</p> <ul style="list-style-type: none"> 3: 300°C range, Art. No. 882130 5: 500°C range, Art. No. 882150

	<p>Booster B-...400</p> <p>↘ → 075: Max. pulse load 75A, 400VAC, Art. No. 885301</p> <p>100: Max. pulse load 100A, 400VAC, Art. No. 885304</p>
---	---

For more accessories: ↪ "Accessories" leaflet

14 Index

A

Accessories 10
Actual value output 52
Adapter for top hat rail mounting 11
Additional relay K1 14
Alarm output 79
Alarm relay 14, 31
Alloy 25, 26, 34
Ambient temperature 14
Analog temperature meter 10
Application 8
Application Report 16, 19, 24
AUTOCAL 9, 33, 54
AUTOCOMP 62
Automatic phase angle compensation 62
Automatic zero calibration 9, 33, 54
AUTOTUNE 9

B

Booster 11, 22, 90
Booster connection 66
Burning in heatsealing band 32, 34

C

Celsius °C 63
Circuit-breaker 18
CI-USB-1 11, 66, 89
Communication interface 11, 66, 89
Controller configuration 24
Controls 35
Current transformer 11, 19, 89
Customer settings 88
Cycle counter 59

D

Degree of protection 14
Diagnostic interface 66
Digital temperature meter 10
Dimensions 15
DIP switches 24
Disabling Configuration menu 63
Display 35
Display brightness 64
Disposal 6

E

Error messages 80
External switching amplifier 11, 22

F

Factory settings 25, 86
Fahrenheit °F 63
Fault areas 84

Fault diagnosis 10, 79
Front cover 11
Fuse 18

H

HEAT 34, 55
Heatsealing band type 13
Heatsealing time 69
Heatup timeout 31
Hold mode 60

I

Impulse heatsealing method 8
Impulse transformer 10, 18, 89
Installation 14, 16
Installation procedure 16
Installation regulations 16

L

Line filter 5, 10, 18, 19, 89
Line frequency 9, 13
Line voltage 13
Locking the "HAND" key 63

M

Maintenance 5, 88
Manual mode 51
Measurement cable 11
Measuring impulse duration 61
Modifications 11, 89
MODs 11, 89
Monitoring current transformer 11

O

Output 1 14, 28, 75
Over-current protection 18
Overheating of heatsealing band 9

P

PEX-W3 89
PEX-W4/-W5 5, 19
Phase angle compensation 62
Power dissipation 14
Power supply 18
Preheat 56
"PREHEAT" signal 56
Principle of operation 8

R

Relay K1 27, 73
Replacing heatsealing band 32, 34
"RESET" signal 59

S

Sealing time 69
Secondary current I_2 24
Secondary voltage U_2 24
Set point selection 13, 50
Standby mode 65
"START" signal 34, 55
System diagnostics 66
System monitoring 79

T

TCR 4, 31
Temperature coefficient 4, 26, 31
Temperature control 8
Temperature diagnosis 30
Temperature indication 52
Temperature meter 10, 53, 89
Temperature OK 14
Temperature OK signal 14
Temperature range 13, 25, 27

Temperature setting 50
Temperature unit 63
Time control 27
Timer function 27, 55
Transformer 5, 10, 18, 89
Transportation 5
Type of construction 13

U

Undervoltage detection 64

V

View of controller 23
Visualization software 66

W

Wiring 16, 18
Wiring diagram 21, 22