

9 There are two tension display options, the **Analog Meter** and **Trend-Line Graph**, which can be toggled back and forth using the **Display** button.

For more information about the display mode, see **Section 1.2** of the **Operating Instructions**.



10 When in tension display screens, you may bring up velocity-sensitive “+” and “-” adjustment buttons by touching the tension display. These buttons, for adjusting the Auto Setpoint or Manual Output will time out a few seconds after discontinued use.



SteadyWeb™ 6 Tension Controller Quick Start Guide

Use this guide once your SteadyWeb 5 Tension Controller has been unpacked, installed and wired as described in the instruction manual, **Section 3 Installation**.

1 With no mechanical knobs, switches or buttons to operate, all SteadyWeb 6 Controller functions are context driven from the touchscreen display. Menus and graphics, described in the **Technical Reference Manual** (DFE P/N 801-2540), hereafter referred to as **The Manual**, will guide the user through calibration and setup, and safety features embedded in the controller’s operating system will prevent the user from making changes that could be harmful.

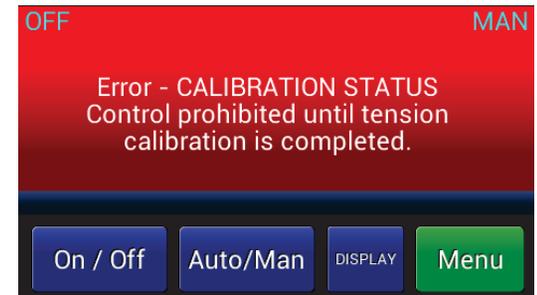


2 For ease of use, the critical-use buttons / critical-awareness indicators are located consistently from one screen to the next. Those buttons and indicators include blue **On/Off**, **Auto/Man**, and **Display** toggle buttons on the bottom of the screen, and **Tension On/Off** and **Auto/Man** status indicators in the upper LH and upper RH corners of the display. The remaining button in the lower RH corner is green and displays as **Menu**, **Back** or **Save**, depending on what screen is current, and is used to advance to other menus, to back out of menus, or to save selections or adjustments. For more detail about buttons and indicators, see Section 1.1 of the **Operating Instructions** (DFE P/N 801-2539), hereafter referenced as **The Operating Instructions**.



3 After first connecting the controller to power, the **POWER** LED will light, and an error message will display, indicating that transducer calibration must be completed (for other error messages, see **Section 9.2** of **The Manual**).

To calibrate the controller, press the **Menu** button to enter the menu mode. Reference **Appendix B** of **The Manual** for a diagram of the complete menu structure. You can always exit Menu mode and return to Display mode by pressing the **Display** button.



Please call tech Support, available 24/7, if you need assistance.

Phone: 603-332-6150 E-mail: techsupport@dfc.com

DOC 801-2541

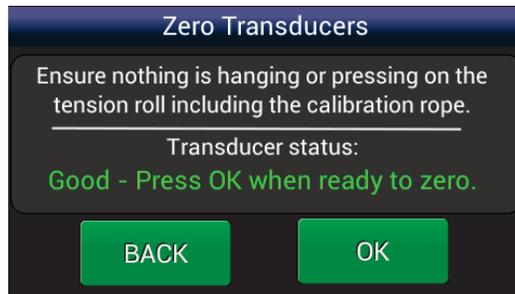
4 Before calibrating the unit, you should verify that the **Tension Units, Tension Range, Tension Source, Calibration Weight Percentage** and **Transducer Type** are set to values you desire. Press **Menu > Calibration Menu > Calibrate** buttons to get to the Select Units screen. Confirm that the preset units are correct, or choose your preferred units and then press **OK**.



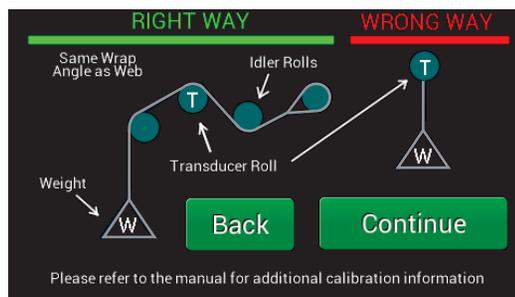
After confirming or selecting new tension units, the controller will similarly guide you through selection of the tension range, the source of the tension signal, calibration weight percentage and transducer type to be used. The tension range should be set at, or just above your expected upper web tension limit.



5 With no other loads on the transducer roll, **ZERO** the transducers, hang a calibration weight of known value with an inelastic rope, strap or cable, and **CALIBRATE** the transducer signal, exactly as instructed in Section 4.1.1 of **The Manual**. The calibration weight should weigh at least 10% of your maximum expected web tension.

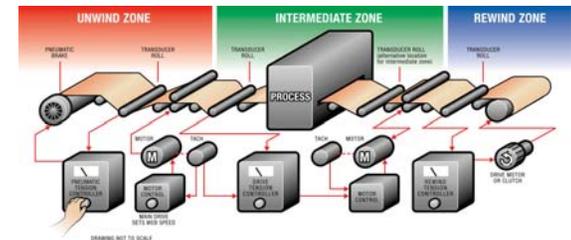


When the transducer signal is calibrated, press the **Display** button to return to the tension display.

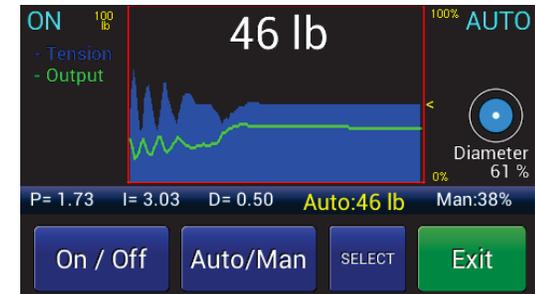


6 If additional calibration is required for inputs of Line Speed, Roll Speed or Roll Diameter, refer to **Section 4.2 of The Manual**.

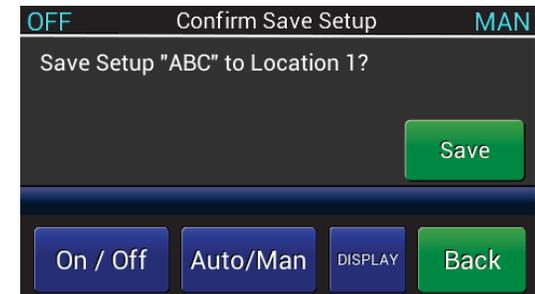
Program settings are based on the tension zone in which the controller is being used. For setting up Unwind, Intermediate and Rewind Zones, refer to **Sections 5.2, 5.3 and 5.4 of The Manual**, respectively.



7 Some PID (Proportional, Integral and Derivative) tuning may be necessary to control tension optimally. Refer to **Section 6 of The Manual** for a PID control overview and tuning procedure. Use the PID Tune View display located at **Menu > Calibration Menu > Tune PID Values** to adjust the PID terms for optimal control. See **Section 3.5 of The Manual** for information on how to utilize the PID Tune View display.



8 After calibrating, configuring and tuning the controller, save the setup at **Operator Menu > Store / Delete Setup**, by selecting **Store Setup**, scrolling to the desired setup location and pressing the **Select** button. Follow the on-screen instructions to name the setup (it helps to be descriptive), press the **OK** button, and press the **Save** button on the next screen.



To recall a setup, visit **Operator Menu > Recall Setup**, scroll to the desired setup and press the **Recall** button, press **Recall** again on the next screen, and press **OK**.

For more information about saving, recalling and deleting setups, see **Section 2.3 of the Operating Instructions**.

