



9 Now let's get familiar with the three **Run** mode display options:

Bar Graph mode, **Analog Meter** mode and **Line Graph** mode.

To toggle the active display between the three modes press the **left** soft key under the display. During operation, you may use any of these three view modes.

To toggle the control output On and Off press the **Tension** key to the left of the display. When Tension is On, the **Tension On** LED will light. To toggle between **Auto** and **Manual** tension modes press the **Auto/Man** key to the right of the display. When the controller is in Auto Mode, the **Auto** LED will light.



10 When in **Manual** mode, at the **Run** mode display, you can turn the rotary knob clockwise to increase your **Manual Tension Setpoint**. Turn the knob counter-clockwise to decrease the setpoint.

Press the **Auto/Man** button to switch over to automatic control, and adjust the **Auto Tension Setpoint** with the rotary knob as you did with the manual setpoint.

SteadyWeb™ 5 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 On the front of the **SteadyWeb™ 5** controller, note three push-button soft keys below the LCD display panel.

The soft key functions will vary depending on the display mode you have active. The rotary knob below these buttons is for adjusting parameters and navigating menus by scrolling.

Safety features of the controller's operating system will prevent a user from making changes that could be harmful. Menus and graphics will help guide the user through calibration and setup.



2 Turn the controller power ON. The **Tension On** LED and **Auto** LED will flash briefly upon power up. After a moment the controller will typically enter the Run mode display to present real time tension and related data. You may toggle the display between **Run** mode and **Menu** mode at any time by pressing the **Menu/Run** key.

On your initial power up the display will present an **error message** stating that '*transducer calibration must be completed*'.

(For other error messages see manual **Section 9.2 Error Messages**.)



3 Before calibrating the unit, you should verify that the **Tension Units** and the **Tension Range** are set to the values you prefer. Press the **Menu/Run** button to access the Main Menu screen.

Then, by using the rotary knob and the **SELECT** button navigate to the **Tension Units** function at **Operator Menu** → **Display Configuration** → **Tension Units**.

(NOTE: Reference the instruction manual **Appendix B, Menu System Hierarchy**, for a tree diagram that outlines the complete menu system).

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

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

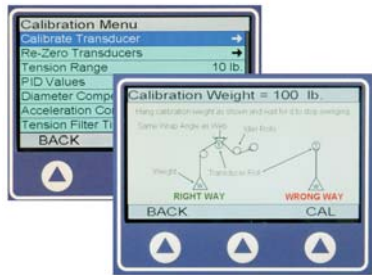
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- 4** Your **Tension Unit** choices are **lb, oz, g, kg,** or **N**. Scroll to your choice and press **SAVE** to select your units.

Press **BACK** to exit out to the Main Menu screen.

Access the **Tension Range** function from the **Calibration Menu** → **Tension Range**. Scroll to the value matching, or just above, your expected upper web tension limit, given the tension units you have selected. Press **SAVE** to select.



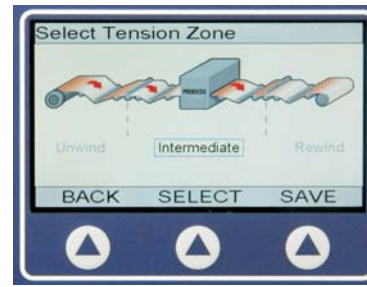
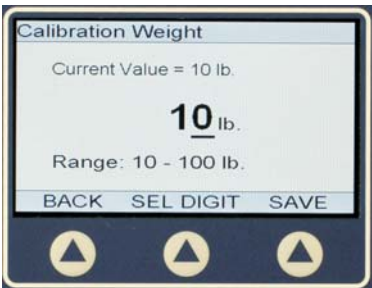
- 5** From the **Calibration Menu** navigate to and **SELECT Calibrate Transducer**.

Follow the on-screen instructions to **ZERO** and **CALIBRATE** the controller to the transducer(s).

Choose a weight of known value that weighs at least 10% of the tension maximum in your operating range. Apply the calibration weight using a length of non-extensible rope, wire or cable.

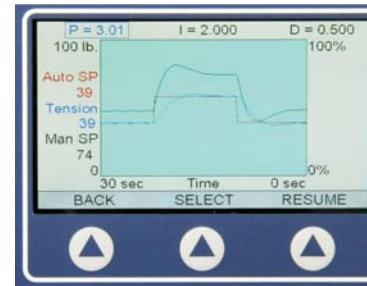
See Instruction Manual section 4.1 **Transducer Calibration** for more detail, if needed.

When **CALIBRATION** is complete, navigate back to the **Run** mode display by pressing the **Menu/Run** key. Verify that the displayed tension reading is correct.



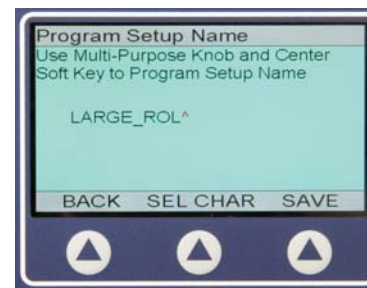
- 6** Now, if needed, calibrate any other controller inputs (Line Speed input, Roll Speed input, Diameter input) that you will be using. For details see manual **Section 4, Calibration**, for the various input signals. Note: This step is not necessary for every application.

Program settings are based on the tension zone in which the controller is being used. For an Unwind Zone, refer to manual **Section 5.2, Unwind Zone Setup**. For an Intermediate Zone, refer to manual **Section 5.3, Intermediate Zone Setup**. For a Rewind Zone, refer to manual **Section 5.4, Rewind Zone Setup**.



- 7** Some PID (Proportional, Integral, Derivative) tuning may be necessary for optimal control.

Refer to manual **Section 6, Tuning Adjustments**, for a PID control overview and tuning procedure. Use the **PID Tune View** display, located in the **Calibration Menu > PID Values** menu, to adjust the PID terms for optimal control. See manual **Section 3.5, PID Tune View**, for information on how to utilize the **PID Tune View** display



- 8** After calibrating, configuring and tuning the controller, **SAVE** the **Setup** so that it can be **Recalled** in the future. Navigate to the **Operator Menu > Store / Delete Setup** menu and select an empty slot to save the Setup. Press the right soft key, **SAVE**, and follow the on-screen instructions for saving a Setup. Provide a descriptive Setup name for future reference.

Saved Setups can later be Recalled by navigating to the **Operator Menu > Recall Setup** menu, selecting the desired Setup and pressing the right soft key, **RECALL**. Refer to manual **Section 7.3, Saving and Recalling Setups**, for more information.