



PLI Meter Retrofit Instructions

Eurotherm Model 142

Introduction

These instructions explain the installation and calibration of the PLI (Pounds Linear Inch) web tension meter for TECTURN I units.

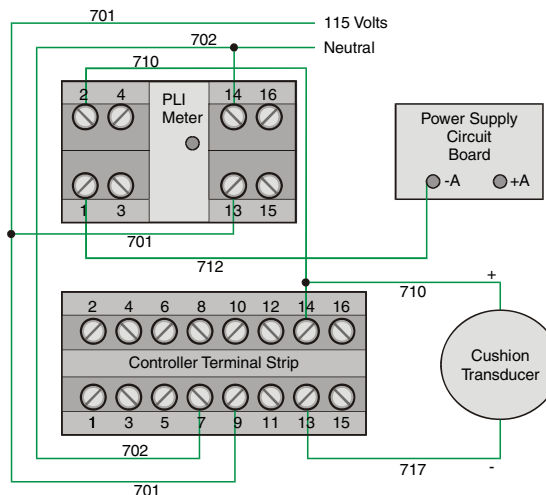
Installation

1. install PLI meter in cabinet or console. Refer to the meter manufacturer's "Installation and Operating Instruction" manual for installing meter.
2. Connect jumper wires from PLI meter terminal strip to TECTURN controller and power supply terminal strips as shown in Figure 1.
 - a. Connect a jumper wire between PLI meter terminal #1 to power supply terminal # -A.
 - b. Connect a jumper wire between PLI meter terminal #2 to controller terminal #14.
 - c. Connect a jumper wire between PLI meter terminal #13 to controller terminal #9.
 - d. Connect a jumper wire between PLI meter terminal #14 to controller terminal #7.

Calibration

1. Cut the web at the last blanket roll, as shown in Figure 2.
2. Use splice tape to form a pocket that hangs below bottom of 95 TECTURN, as shown in Figure 2. The web should not be taped to the TECTURN bar.
3. Locate and weigh two or more steel core shafts for "spanning". (Recommend a weight of approximately 22 pounds each. For webs wider than 38 inches, use heavier weights).

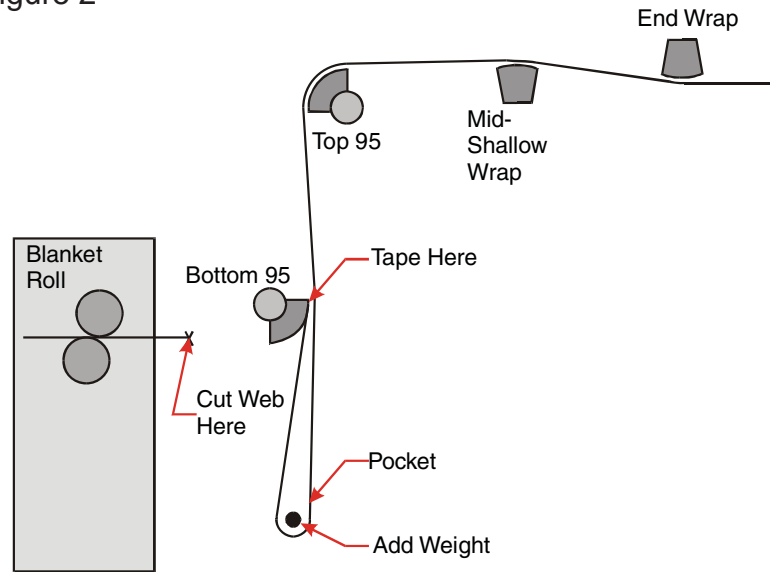
Figure 1



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Figure 2



4. With the TECTURN fan OFF, locate the cushion transducer power supply in the electrical cabinet. Adjust the power supply to approximately 13.10 volts DC, until the PLI meter indicates zero. Do the same with the supply transducer power supply.
5. With the TECTURN fan ON and controller AUTO ratio switch set at 150, press the EMERGENCY STOP push button.
6. Carefully insert one known weight into the pocket loop, as shown in Figure 2.
7. Insert the known values and calculate the PLI meter reading, using the following formula:
8. Adjust the PLI meter SPAN pot if meter does not display the calculated value. The PLI meter must be removed from sleeve to gain access to SPAN pot on the right side of meter.
9. Insert the second known weight to verify linearity.



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10. Check the transducer null value output:
 - a. Supply transducer for 0 millivolts.
 - b. Cushion transducer for 20 millivolts.
11. When operating, observe the PLI meter while increasing the chill speed or infeed. The PLI meter indicates if the web tension has been increased or decreased.

For more information, please contact MEGTEC Systems Parts/Service Department at (920) 337-1410 or 1-800-558-5535.