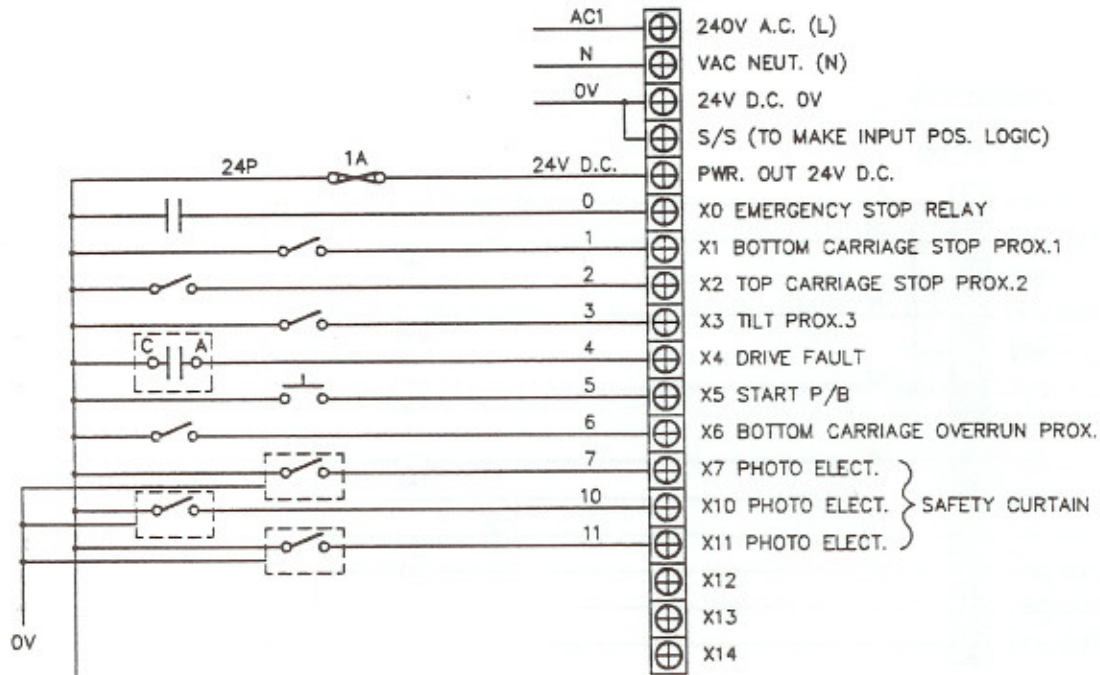


DESCRIPTION		DRN	CHK		SCALE	N.T.S.	TITLE		COATING MACHINE/KEYPAD		FILE No.
					DATE	27.07.97	ELECTRICAL DIAGRAMS				
				DRN	T.C.	CHK		SHT. OF SHTS.	REV	DRAWING No.	CT-033
				CHK		SIZE	A3	1	3	0	

MITSUBISHI PLC  
INPUTS  
FIXED PLC



REV.	DATE.	DESCRIPTION.	DRN.	CHK.

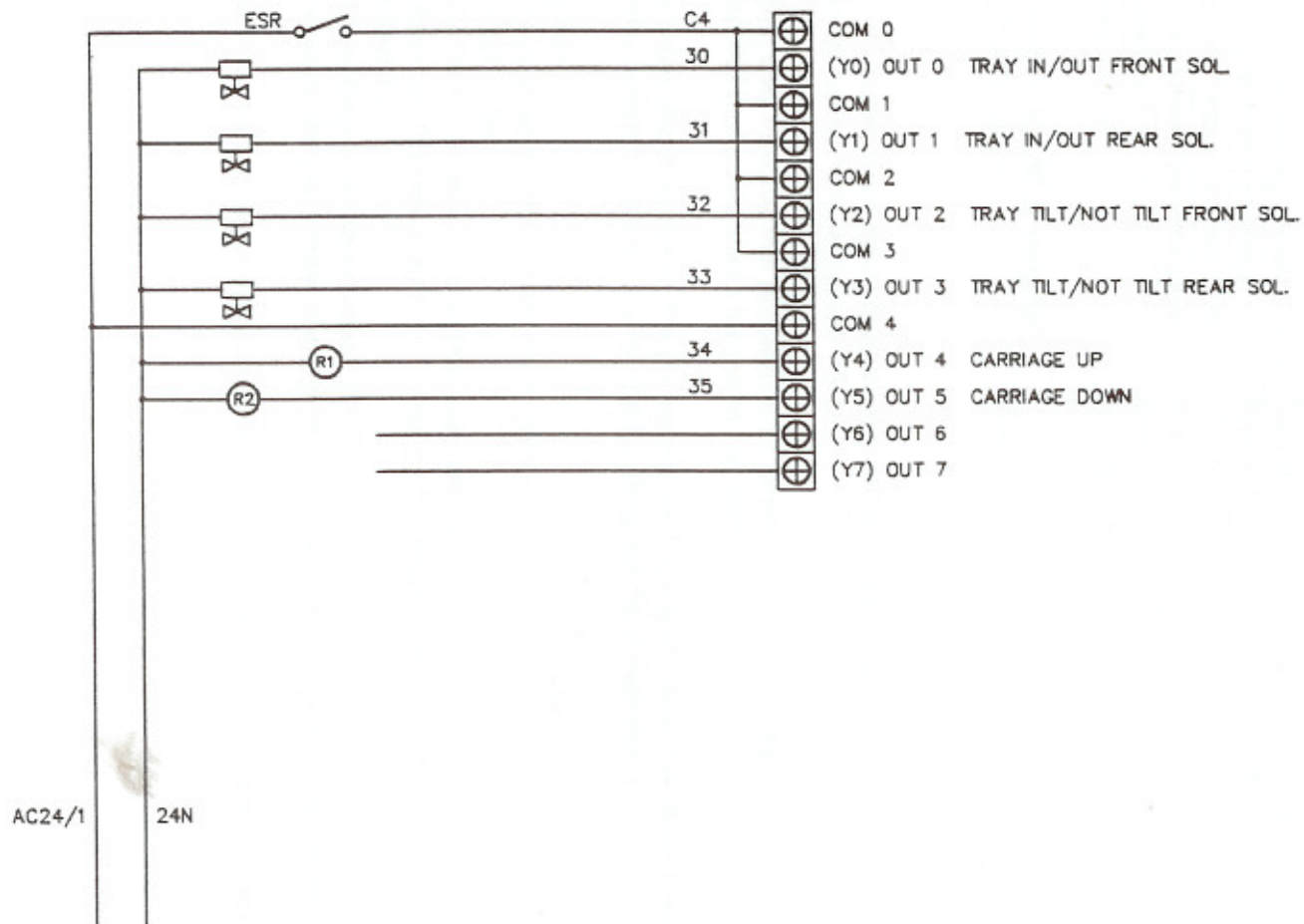
**CONTECH**  
ELECTRICAL PTY. LTD.

SCALE N.T.S.  
DATE 27.07.97  
DRN. T.C.  
CHK.  
DRG. SIZE A3

TITLE COATING MACHINE/KEYPAD  
ELECTRICAL DIAGRAMS

SHT. OF SHTS. REV. DRAWING No. CT-033 FILE No.

MITSUBISHI  
FIXED PLC  
OUTPUTS



AC24/1

24N

REV.	DATE	DESCRIPTION	DRN.	CHK.

**CONTECH**  
ELECTRICAL PTY. LTD.

SCALE N.T.S.

DATE 27.07.97

DRN. T.C.

CHK.

DRG. SIZE A3

TITLE COATING MACHINE/KEYPAD  
ELECTRICAL DIAGRAMS

SHT. OF SHTS. 3 3

REV. 0

DRAWING No. CT-033

FILE No.

## TSN002 – Technical Support Note

### Parameter settings for Mitsubishi FRU-120S-N0.4K Variable Frequency Drive

Function #	Function Name	Setting Range	Setting Unit	Factory Setting	Actual Setting
0	Torque Boost	0 to 15%	1%	6%	12%
1	Upper Limit Frequency	0 to 120 Hz	0.1 Hz	120 Hz	50 Hz
2	Lower Limit Frequency	0 to 60 Hz	0.1 Hz	0 Hz	10 Hz
7	Acceleration Time	0.1 to 999 sec	0.1 sec	5.0 sec	1.5 sec
8	Deceleration Time	0.1 to 999 sec	0.1 sec	5.0 sec	0.1 sec
9	Electronic Thermal Relay	0 to 15 Amp	0.1 Amp	Rated Current	1.9 Amp
11	DC Dynamic braking operation time	0 to 10 sec	0.1 sec	0.5 sec	0.2 sec
12	DC Dynamic braking voltage	0 to 15%	1%	8%	15%
22	Frequency Setting Voltage Bias	0 to 60 Hz	0.1 Hz	0 Hz	50 Hz
23	Stall Prevention Operation Level	0 to 10	1	5	5
73	Terminal2 is 0-5V or 0-10V	0 or 1	1	1	0
79	Operation Mode	1, 2, 3 or 4	1	1	2
	<i>This function should be done last</i>				
77	Write Forbid Selection	0 or 1	1	0	1

Problem: Coating arm stalls when doing final scrape at top of run when coating speed potentiometer is set at below 30% ie approx 16Hz.

Solution: The easiest way to solve this problem is to increase the torque boost setting in the drive parameters so the motor has more torque at low speeds.

Please refer to the table above outlining the parameter settings and follow the steps below to modify the parameter settings. The most important setting will be Parameter '0'.

- Press [MODE] key
- Using the  keys to select the parameter number
- Then press the [SET] key
- The setting value of the selected parameter will display
- Using the  keys set the new parameter setting ( the display will flicker until the setting has been completed )
- Once the correct setting is achieved press [SET]
- Once this is complete the parameter number and the new setting flashes alternately

Please set Parameter '0' as per the chart above. This should fix the problem that is currently occurring.