# All counter settings – total cuts, cut length & batch quantity:

1) Red Lion CUB 4.
2) Red Lion CUB 5.
3) Hengstler 732.
4) Kübler 327.
5) Kübler 715.
6) MAXjr Count 1.

## Red Lion CUB 4 total cuts counter settings (any model):

The voltage input is set to 19.99 VDC as standard and you do not need to change this setting.

To set the amount of decimal points, select either **switches 6, 7 or 8** to the **ON** position.

To calibrate the display switch the **scale switch** 5 to the **ON** position.

Turn the scale pot until the display equals the actual speed.

## Red Lion CUB 5 total cuts counter settings:

### Counter function description

### COUNT MODES (INP A-b)

**CNt Ud** **counting with direction**
Counter “A” will increment/decrement on every negative edge. Direction is determined by the logic state of “B”.

RTE CNt Rate counter
Input “A” is used exclusively for rate indicator.

QUAd1 Quadrature X 1 – A is count / rate and B is quadrature

QUAd2 Quadrature X 2 – Same as quadx1 B is low

QUAd4 Quadrature X 4 – A & B serve as count or quad input

Dual cnt Dual counter

For more information please email: tech@gillardcutting.com

Counter “A” will increments one count on every negative edge. Counter “B” will increments one count on every negative edge.

*Add/Add  Two input Anti-coincidence Add/Add*

*Add/Sub  Two input Anti-coincidence Add/Subtract*

SELECT ENABLE

dSPELFront panel selection
If NO is selected the display will remains either on rate or count.

*If YES is selected you can toggle between rate and count.*

RESET ENABLE

rSt Enb

COUNTER A DECIMAL POINT

tot dP  select decimal points

COUNTER A SCALE FACTOR

SCLFAC  The scale factor only affects the incoming pulse count

COUNTER B DECIMAL POINT

btot dP  select decimal points

COUNTER B SCALE FACTOR

bSCLFAC  The scale factor only effects the incoming pulse count

RATE ENABLE

rate Enb  Selecting YES activates the rate indicator function.

RATE DECIMAL POINT

rAtE dP  select decimal points

RATE INPUT

rAtE INP corresponds to the rate display.

## MINIMUM UPDATE TIME

Lo-Udt This is the minimum amount of time between display updates.

## MAXIMUM UPDATE TIME

HI-Udt This is the maximum amount of time between display updates.

## DISPLAY SCROLL

dSPScrol Automatic toggle between rate and count.

## USER INPUT

USEr INP Active when the user terminal is connected to common.
User can programme from the following

Reset, Store/reset, Store, Inhibit, & Select display.

User input assignment

USEr ASg Select counter totals

## FACTORY SETTINGS

FACt SEt Loads factory default settings.

To enter into program link **common** to **program.**

| | COUNT | RATE | |
|---|---|---|---|
| Inp A-b | CNt Ud | RTE CNt | |
| Dsp Sel | YES | YES | |
| Rst Enb | YES | YES | |
| Tot dp | 0 | 0 | |
| Scl Fac | 0.10000 | 0.10000 | (adjust count scale) |
| Rate End | YES | YES | |
| Rate db | 0 | 0.0 | |
| Rate dsp | 0000.60 | 16.8 | (adjust rate scale) |
| Rate inp | 00001.0 | 00100.0 | |
| Lo udt | 00.1 | 00.1 | |
| Hi udt | 20.00 | 20.00 | |
| Dsp scroll | NO | NO | |
| Usr inp | RESET | RESET | |

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# HENGSTLER 732 cut length counter settings:

Press E1 to enter length.
E6 on power up to set to Fn 0 (counter function).
E5 on power up to enter into program.
E3 to set pre-scale.
Press 6 & 4 together to reset.

| No. | Function: | Setting: |
|---|---|---|
| F0 | Default setting | 0 |
| F1 | Count mode | 0 |
| F3 | Decimal point | 0 |
| F4 | Reset operation | 1 |
| F6 | O/P 1 time | 0.10 |
| F7 | O/P 2 time | 0 |
| F10 | I/P (pnp=1 & npn=0) | 0 |
| F11 | Count speed | 1 |
| F12 | Static/dynamic reset | 0 |
| F14 | O/P signal memory | 0 |
| F20 | Front panel reset | 0 |
| F21 | Preset 1 access | 0 |
| F23 | Prescale access | 0 |
| F29 | Lockout mode | 0 |

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# Kübler 327 cut length counter settings:

Set dip switches B-E to the OFF position = 100 KHz count frequency.
Set dip switch A to the ON position to enable programming.

The unit is programmed by scrolling through the options with the arrow keys.
Confirm each selection by pressing the “P” key.

When powered up in programming mode, the unit will display the count setting.

## Standard factory settings:

| | | |
|---|---|---|
| COUNT,- | 0 | = COUNTER |
| INPUT,- | E1 | = INPUT ‘A’ AS COUNT INPUT |
| INPUT,- | E3 | = QUADRATURE COUNT A & B) |
| INPUT,- | NEG POL | = NPN INPUT SIGNAL |
| MODE,- | 10 | = OUTPUTS 0+1 = PRESET 1 (LENGTH COUNT) |
| | | = OUTPUT 2 = PRESET 2 (BATCH COUNT) |
| FACTOR,- | 1 | = 1 PULSE = 1 COUNT |
| n0,- | 20mS | = ’SET’ OUTPUT DURATION |
| n1,- | 20mS | = ’PR1’ OUTPUT DURATION |
| n2,- | 3S | = ’PR2’ OUTPUT DURATION |
| DP,- | 00.0 | = DECIMAL POINT POSITION |

ADRESS,-This option is not used in the Gillard range.

On reaching the address setting return dip switch ‘A’ to the OFF position & press the ‘P’ key.

For more information please email: tech@gillardcutting.com

# Kübler 715 Batch counter settings:

To programme the counter set dipswitch A to the ON position.

“Cou 1” will display and by pressing button 1 it will scroll through the options; Cou 2, Cou 3, etc.

When you have selected the correct option e.g. Cou 1, press button 5 to store the function and it will change over to the next menu point, dp 1.

Settings:

| | | |
|---|---|---|
| Cou | 1 | (operating mode) |
| dP | 0 | (decimal point 0 – 3) |
| Pol | P | (polarity of the inputs) |
| In | E2 | (input modes) |
| F 1.000 | | (scaling factor) |
| T 03.00 | | (duration of output signal) |

The counter can be used as a timer.

Set dip switch A to the OFF position to exit the programme.

For more information please email: tech@gillardcutting.com

MAXjr COUNT 1 powered caterpillar booms settings:

RUN/PROG enters into the program.

Use arrows to scroll through program.

If counting negative swap channel A & B.

To lock out counter buttons put dip switch 5 (dis.prog.) to the on position.

000000
dp off
cC 0.5
in_oP.bid
in_Ab.Hi
P_rSt.off
P_Loc.on
InP A

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