IMPORTANT: PLEASE REVIEW THIS ENTIRE PUBLICATION BEFORE INSTALLING, OPERATING OR MAINTAINING THE SOLID-STATE HYDRAULIC PRESS ELECTRICAL CONTROL SYSTEM.
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**RHPC Hydraulic Press Solid-State Control**

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SECTION 1—IN GENERAL
RHPC Hydraulic Press Solid-State Control

Safety Precautions

“DANGER” Danger is used to indicate the presence of a hazard which WILL cause SEVERE personal injury if the warning is ignored.

“!” THIS SAFETY ALERT SYMBOL IDENTIFIES IMPORTANT SAFETY MESSAGES IN THIS MANUAL. WHEN YOU SEE THIS SYMBOL !, BE ALERT TO THE POSSIBILITY OF PERSONAL INJURY, AND CAREFULLY READ THE MESSAGE THAT FollowS.

Efficient and safe machine operation depends on the development, implementation and enforcement of a safety program. This program requires, among other things, the proper selection of point-of-operation guards and safety devices for each particular job or operation and a thorough safety training program for all machine personnel. This program should include instruction on the proper operation of the machine, instruction on the point-of-operation guards and safety devices on the machine, and a regularly scheduled inspection and maintenance program.

Rules and procedures covering each aspect of your safety program should be developed and published both in an operator’s safety manual, as well as in prominent places throughout the plant and on each machine. Some rules or instructions which must be conveyed to your personnel and incorporated into your program include:

DANGER Never place your hands or any part of your body in this machine.

DANGER Never operate this machine without proper eye, face and body protection.

Never operate this machine unless you are fully trained, instructed, and you have read the instruction manual.

Never operate this machine if it is not working properly—stop operating and advise your supervisor immediately.

Never use a foot switch to operate this machine unless a point-of-operation guard or device is provided and properly maintained.

Never operate this machine unless two-hand trip, two-hand control or presence sensing device is installed at the proper safety distance. Consult your supervisor should you have any questions regarding the proper safety distance.

Never tamper with, rewire or bypass any control or component on this machine.

A company’s safety program must involve everyone in the company, from top management to operators, since only as a group can any operational problems be identified and resolved. It is everyone’s responsibility to implement and communicate the information and material contained in catalogs and instruction manuals to all persons involved in machine operation. If a language barrier or insufficient education would prevent a person from reading and understanding various literature available, it should be translated, read or interpreted to the person, with assurance that it is understood.

FOR MAINTENANCE AND INSPECTION ALWAYS REFER TO THE OEM’s (ORIGINAL EQUIPMENT MANUFACTURER’S) MAINTENANCE MANUAL OR OWNER’S MANUAL. If you do not have an owner’s manual, please contact the original equipment manufacturer.
Safety References

OSHA’S ACT AND FEDERAL REGULATIONS

Since the enclosed equipment can never overcome a mechanical deficiency, defect or malfunction in the machine itself, OSHA (Occupational Safety and Health Administration) has established certain safety regulations that the employers (users) must comply with so that the machines used in their plants, factories or facilities are thoroughly inspected and are in first-class operating condition before any of the enclosed equipment is installed.


Duties:

Sec. 5. (a) Each employer —
(1) shall furnish to each of his employees employment and a place of employment which are free from recognized hazards that are causing or are likely to cause death or serious physical harm to his employees;
(2) shall comply with occupational safety and health standards promulgated under this Act.
(b) Each employee shall comply with occupational safety and health standards and all rules, regulations, and orders issued pursuant to this Act which are applicable to his own actions and conduct.

2. OSHA’s Code of Federal Regulations, Subpart O, that an employer (user) must comply with include:

Section 1910.211 Definitions
Section 1910.212 (a) General Requirements for all Machines
Section 1910.217 Mechanical Power Presses
Section 1910.219 (b)(1) Mechanical Power-Transmission Apparatus (Flywheel and Gear Covers)


4. OSHA’s Publications


These publications can be obtained by contacting:
Superintendent of Documents
US Government Printing Office
P.O. Box 371954
Pittsburgh, PA 15250-7954
Phone: (202) 512-1800
Fax: (202) 512-2250
www.gpo.gov

ANSI SAFETY STANDARDS FOR MACHINES

The most complete safety standards for machine tools are published in the ANSI (American National Standards Institute) B11 series. The following is a list of each ANSI B11 Standard available at the printing of this publication.

B11.1 Mechanical Power Presses
B11.2 Hydraulic Presses
B11.3 Power Press Brakes
B11.4 Shears
B11.5 Iron Workers
B11.6 Lathes
B11.7 Cold Headers and Cold Formers
B11.8 Drilling, Milling and Boring
B11.9 Grinding Machines
B11.10 Sawing Machines
B11.11 Gear Cutting Machines
B11.12 Roll Forming and Roll Bending
B11.13 Automatic Screw/Bar and Chucking
B11.14 Coil Slitting Machines
B11.15 Pipe, Tube and Shape Bending
B11.16 Metal Powder Compacting Presses
B11.17 Horizontal Hydraulic Extrusion Presses
B11.18 Coil Processing Systems
B11.20 Safety Requirements for Manufacturing Systems/Cells
B11.21 Lasers
B11.22 CNC Turning Machines
B11.23 Machining Centers
B11/TR1 Ergonomic Considerations for the Design, Installation and Use of Machine Tools
B11/TR2 Mist Control
B11/TR3 Hazard ID and Control
B11/TR4 Control Reliability
R15.06 Robotic Safeguarding

These standards can be purchased by contacting:
American National Standards Institute, Inc.
11 West 42nd Street
New York, New York 10036
Phone: (212) 642-4900
Fax: (212) 302-1286
www.ansi.org

OR

Association of Manufacturing Technology (AMT)
7901 Westpark Drive
McLean, Virginia 22102
Phone: (703) 827-5211
Fax: (703) 893-1151
www.mfgtech.org

(Continued on next page.)
NATIONAL SAFETY COUNCIL SAFETY MANUALS AND DATA SHEETS

Other good references for safety on machine tools are the National Safety Council’s Safety Manuals and Data Sheets. These manuals and data sheets are written by various committees including the Power Press, Forging and Fabricating Executive Committee. Copies of the following publications are available from their library:

Manuals
- Safeguarding Concept Illustrations - 6th Edition
- Forging Safety Manual

Data Sheets
- Bench and Pedestal Grinding Wheel Operations 12304-0705
- Boring Mills, Horizontal Metal 12304-0269
- Boring Mills, Vertical 12304-0347
- Coated Abrasives 12304-0452
- Cold Shearing Billets and Bars in the Forging Industry ................................. 12304-0739
- Degreasing (Liquid), Small Metal Parts 12304-0537
- Dies, Setup and Removal of Forging Hammer 12304-0716
- Drill Presses, Metalworking 12304-0335
- Drills, Portable Reamer 12304-0497
- Drop Hammers, Steam 12304-0720
- Electrical Controls for Mechanical Power Presses 12304-0624
- Forging Hammer Dies, Setup and Removal of 12304-0716
- Forging Presses, Mechanical 12304-0728
- Gear-Hobbing Machines 12304-0362
- Handling Materials in the Forging Industry 12304-0551
- Kick (Foot) Presses 12304-0363
- Lathes, Engine 12304-0264
- Milling Machines, Metalworking 12304-0364
- Planers, Metal 12304-0383
- Power Press (Mechanical) Point-of-Operation
- Power Press Point-of-Operation Safeguarding: Type A ................................. and B Movable Barrier Devices 12304-0712

Power Press Point-of-Operation Safeguarding:
- Presence Sensing Devices 12304-0711
- Pullbacks and Restraint Devices 12304-0713
- Power Presses (Mechanical), Inspection and
- Maintenance of 12304-0603
- Power Presses (Mechanical), Removing Pieceparts
- from Dies in 12304-0534
- Power Press, Setting Up and Removing Dies 12304-0211
- Press Brakes 12304-0419
- Robots 12304-0717
- Saws, Metal (Cold Working) 12304-0584
- Shapers, Metal 12304-0216
- Shears, Alligator 12304-0213
- Shears, Squaring, Metal 12304-0328
- Upsetters, 12304-0721

Copies of these manuals and data sheets can be obtained by contacting:

National Safety Council  
1121 Spring Lake Drive  
Itasca, IL 60143-3201  
1-800-621-7619 ext. 2199  
Fax: (630) 285-0797  
www.nsc.org

OTHER SAFETY SOURCES

National Institute of Occupational Safety and Health (NIOSH)  
4676 Columbia Parkway  
Cincinnati, OH 45226  
Phone: (513) 533-8236

Robotic Industries Association (RIA)  
P.O. Box 3724  
Ann Arbor, MI 48106  
Phone: (734) 994-6088  
www.robotics.org

For additional safety information and assistance in devising, implementing or revising your safety program, please contact the machine manufacturer, your state and local safety councils, insurance carriers, national trade associations and your state’s occupational safety and health administration.

Warranty, Disclaimer and Limitation of Liability

WARRANTY

Rockford Systems, LLC, warrants that this product will be free from defects in material and workmanship for a period of 12 months from the date of shipment thereof. ROCKFORD SYSTEMS LLC’S OBLIGATION UNDER THIS WARRANTY IS EXPRESSLY AND EXCLUSIVELY LIMITED to repairing or replacing such products which are returned to it within the warranty period with shipping charges prepaid and which will be disclosed as defective upon examination by Rockford Systems, LLC. This warranty will not apply to any product which will have been subject to misuse, negligence, accident, restriction and use not in accordance with Rockford Systems, LLC’s instructions or which will have been altered or repaired by persons other than the authorized agent or employees of Rockford Systems, LLC. Rockford Systems, LLC’s warranties as to any component part is expressly limited to that of the manufacturer of the component part.

DISCLAIMER

The foregoing Warranty is made in lieu of all other warranties, expressed or implied, and of all other liabilities and obligations on the part of Rockford Systems, LLC., including any liability for negligence, strict liability, or otherwise, and any implied warranty of merchantability or fitness for a particular purpose is expressly disclaimed.

LIMITATION OF LIABILITY

Under no circumstances, including any claim of negligence, strict liability, or otherwise, shall Rockford Systems, LLC. be liable for any incidental or consequential damages, or any loss or damage resulting from a defect in the product of Rockford Systems, LLC.
SECTION 1—IN GENERAL
RHPC Hydraulic Press Solid-State Control

Operator Safety Precautions Sign—(Attachment for machine operators)

Accompanying this equipment is an 8½” x 11” operator safety precaution sign, Part No. KSC-000, for anyone operating the machine where this equipment will be installed. These precautions are to be given to all operators, including setup people, maintenance personnel and supervisors.

This sign should also be attached to the machine, readily accessible and visible to the operator. (A hole in the corner of this sign is provided for attaching purposes.) Additional copies of these precautions are available. Please call, e-mail, write, fax, or use the order form found on a later page in this manual.

When a language barrier or insufficient education prevents a person from reading or understanding the contents of these operator safety precautions, you should either translate this information or have it read or interpreted to the person. Make sure that the person understands the information. To order this pamphlet in Spanish, use Part No. KSC-000S; in French, use Part No. KSC-000F.

These precautions must be reviewed daily.

(Continued on next page.)
SECTION 1—IN GENERAL
RHPC Hydraulic Press Solid-State Control

Danger Sign(s) to be Mounted on Machine

Accompanying this equipment is a 5" x 6" polyethylene danger sign, Part No. KSC-054. This sign MUST BE PERMANENTLY MOUNTED IN A PROMINENT LOCATION on the machine where this equipment is installed. This sign must be in a LOCATION THAT IS EASILY VISIBLE to the operator, setup person, or other personnel who work on or around this machine. ALWAYS mount this sign with screws or rivets when installing the enclosed equipment. If a foot switch is ordered, a 5” x 6” polyethylene danger sign, Part No. KSC-055 is provided. This sign must also be mounted according to the above instructions.

If any danger sign becomes destroyed or unreadable, the sign must be replaced immediately. Contact factory for replacement danger sign(s).

Never operate this machine unless the danger sign(s) is in place.

“Mechanical Power Press Safety” Booklet

A copy of Booklet No. MPPS Mechanical Power Press Safety is available upon request. This booklet is copied verbatim from the CFR (Code of Federal Regulations) and contains all relevant sections of the OSHA Regulations concerning power presses with which an employer (user) must comply. The enclosed equipment must be installed, used and maintained to meet these regulations. Specifically, any time a foot switch is used, a suitable point-of-operation safeguard or device must be used to prevent bodily injury. In addition, every press must be provided with a point-of-operation safeguard! Please review this booklet and the appropriate ANSI (American National Standards Institute) Safety Standard before installing the enclosed equipment. If you are unfamiliar with these detailed safety regulations, which include regulations on safeguarding the point of operation properly, you may want to attend our regularly scheduled machine safeguarding seminar. To obtain detailed information about this training seminar, please call, fax, write, or check our web site. Our address, telephone, fax number, and web site address are on the front cover of this manual.

(Continued on next page.)
**SECTION 1—IN GENERAL**

**RHPC Hydraulic Press Solid-State Control**

**Danger and Warning Labels Provided on Control Box**

The illustrated danger and warning labels are affixed to all control boxes provided. All personnel operating or working around the machine, where this control box is installed, must be required to read, understand and adhere to all dangers and warnings. If any of these labels become destroyed or unreadable, labels MUST be replaced. Contact factory immediately for replacement labels and do not operate the machine until the danger and warning labels are all in place.

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Photo 1.1
Inside View of RHPC Control Box

(Continued on next page.)
SECTION 1—IN GENERAL
RHPC Hydraulic Press Solid-State Control

FOR REPLACEMENT SIGNS
CALL, FAX, E-MAIL, OR USE THE
ORDER FORM ON A LATER PAGE OF THIS MANUAL.

Rockford Systems, LLC.
5795 Logistics Parkway
Rockford, Illinois 61109
Toll-Free 1-800-922-7533
Phone 815-874-7891
Fax 815-874-6144
sales@rockfordsystems.com
www.rockfordsystems.com

CLOSING RAM AND DIE
You are exposed to moving machine parts that can crush, dismember, and cause death.

DO NOT operate this machine without safeguards in place.
NEVER place your hands or any part of your body in this machine.
FAILURE to obey will result in loss of fingers or limbs, or could cause death.

This sign does not cover all dangers that could happen while operating this machine.

Do not remove or cover this sign
Label No. KST-134

Photo 1.2
RHPC Control Box
SECTION 2—INTRODUCTION
RHPC Hydraulic Press Solid-State Control

General Description of Components in the System
A complete control package for hydraulic machines includes the following:

1. Literature folder containing installation manuals, Operator Safety Precautions, danger sign(s), electrical control schematics, and our latest catalog
2. Control box—standard (custom or special includes motor controls and/or disconnect switch) with danger and warning signs
3. Palm button assembly (includes two black palm buttons, two palm button guards, one red emergency-stop button, and mounting boxes. When the “automatic” mode of operation is included, one yellow return/inch-up button with mounting box is furnished.) If multiple operator stations are on a machine, more than one assembly is furnished.
4. Foot switch (optional)—If multiple operator stations are on a machine, more than one foot switch is furnished
5. Supervisory control station (required when multiple operator stations are used on the machine; one station is required for each operator.)
6. Other required components and safeguarding that may be necessary for machine (See packing list for details)

Individual packages may vary in contents. However, a packing list is always enclosed showing exactly what material was shipped on this order. Please check the components actually received against this packing list immediately. In most cases, this control package system includes two-hand control which can be used as a point-of-operation safeguarding device provided the palm buttons are mounted correctly and at the proper safety distance (see formula on page 18 of this manual). If the optional foot switch is provided, a safeguard must always be used. Examples of safeguards include barrier guards, presence sensing devices, pullbacks, restraints, gates, or two-hand control. The hands or any other part of the body of an operator, maintenance person, setup person, etc., must never be put into the point-of-operation hazard for any reason, at any time.

These controls can neither cure nor overcome a malfunctioning machine. They cannot compensate for or prevent a mechanical defect or failure of a machine part. These controls cannot prevent a repeat or unintended stroke (cycle) resulting from a mechanical or hydraulic component malfunction, defect or failure of the machine itself.

Preliminary Steps Before Installation
Before proceeding with the installation of the enclosed equipment, you should undertake the following preliminary steps.

1. Read and make sure you understand this entire Installation Manual.
2. Refer to the front cover, other line drawings and photos, then make a rough sketch of your installation to plan the location of the enclosed equipment on the machine.
3. This may be an opportunity to strip down the entire machine by removing all components, piping, wire, etc. Clean, paint and check the entire electrical, hydraulic, and mechanical systems of the machine for proper adjustment and required replacement parts before proceeding with the installation of the furnished equipment.
4. Please make sure the machine is in first-class condition. Before starting any installation, it is essential that the machine is thoroughly inspected. Be sure that all mechanical components and all collateral equipment are in first-class operating condition. Your inspection should be done according to the machine manufacturer’s installation and maintenance instruction manual. If you have any doubts or questions concerning the condition of the machine, contact the machine manufacturer for assistance. Repair or replace all parts not operating properly before proceeding.

Inspection and maintenance programs must be established and implemented to keep machines in first-class condition. Programs must include thorough inspections of each machine on a weekly basis and records kept of these inspections. Any part of the machine that is worn, damaged or is not operating properly must be replaced immediately or repaired before the machine is used.

5. Verify that the machine is in first-class condition and operating properly; shut off all power to the machine. All trapped hydraulic pressure must be released in areas of the systems that are being updated or retrofitted before proceeding. Padlock the disconnecting means in the “off” position and do not actuate the machine again until the installation of all package components has been completed. Lockout/tagout energy isolation procedures must always be practiced and enforced.
SECTION 2—INTRODUCTION
RHPC Hydraulic Press Solid-State Control

Safeguard Interlocks and Other Types Of Interlocks

Safeguard Interlocks
The machine will not operate or must not be operated until you either: (1) Electrically interlock or (2) Mechanically guard the machine’s point of operation with a safeguarding system or device.

When an electrically interlocked method of safeguarding the point of operation is chosen, connect the interlock to the safeguard interlock terminals (P7-5 and P7-6) in the control box (see page 15), and as shown on the control wiring schematic (wire numbers 82 and 83).

Point-of-operation electrically interlocked safeguards, when opened, prevent or stop normal machine operation during operator cycling modes. Examples of these types of interlocks are barrier guard interlocks and gate device interlocks.

When a mechanical guard or device (nonelectrically interlocked) is chosen, the safeguard interlock terminals (P7-5 and P7-6) are not used. In order for the machine to operate with the use of a mechanical guard or device, the safeguard interlock terminals must be connected.

The mechanical guard or device must be properly installed, used and maintained and must always prevent all personnel from bodily injury.

If the mechanical guard or device is not used, is removed, or is defeated, an electrically interlocked method of safeguarding must be used and connected to the safeguard interlock terminals (P7-5 and P7-6).

Never operate this machine without point-of-operation safeguarding.

OTHER ELECTRICAL INTERLOCKS

There are basically two types of electrical interlocks as applied to machine control circuitry:

- Interlocks for the purpose of personnel protection, as explained previously.
- Interlocks intended for the purpose of protecting the machine and its control components.

There are other locations for interlocks that, when opened, prevent all machine functions. Examples of these types of interlocks are safety block electrical cut-off systems, lubricating systems, die protection equipment, and tonnage monitoring systems.

Be sure to connect the various electrical interlocks to the proper terminals (in the control box) according to the machine wiring schematics. If your schematics do not include these electrical interlocks, please send this information to the factory and they can be added to your drawings. There is an additional charge for this service.

Features of the RHPC Control—Hydraulic Press

- Redundant and cross-checking microprocessors
- Redundant switching style DC power supplies
- Press control operates on 85-135 V AC
- Provisions for optional light curtain interface with Off/On supervised keyed selector switch
- Easy to read blacklit liquid crystal operator interface display having 4 lines x 20 characters
- Four (4) 24-V DC digital user inputs, programmable, selectable canned messages
- Two (2) ram advance (down or up) outputs, standard 120 V AC
- One (1) Ram speed change (fast-slow) output, standard 120 V AC
- One (1) ram return (up or down) output, standard 120 V AC
- Seven-digit stroke counter
- Seven-digit batch counter with preset
- Automatic mode of operation
- Automatic single stroke mode of operation
- Operator interface keypad and display, text in English or Spanish
SECTION 2—INTRODUCTION

RHPC Hydraulic Press Solid-State Control

Sequence of Operation

RUN MODE—INCH/SINGLE/AUTO

Inch—The inch mode is intended for machine setup only. In this mode of operation, pressing both palm buttons causes the ram to move in small increments—inch. The ram stops at the bottom of the stroke. Auto up (return) is not active in the inch mode. Press the yellow return palm button to inch the ram back to home. Hold the yellow palm button down to return the ram to the home position nonstop. NOTE: Never attempt to use the inch mode during a production mode.

Single—Pressing both palm buttons or pressing the foot switch causes ram movement to the bottom of the stroke and stops. The ram does not stop at sequence stop position. Auto up (return) of ram is active. After the ram reaches the bottom of the stroke, it automatically returns to home and stops—single stroke.

Auto—Pressing a prior action button and then both palm buttons causes ram movement to the bottom of the stroke and then back to top automatically. This will continue until a top stop button or E-stop button has been pressed.

SPEED CHANGE—HIGH-HIGH/LOW-LOW

High—The ram ignores the speed change position and moves to the bottom of the stroke at high speed.

High/Low—The ram moves to the speed change position at high speed, and then changes from high to low speed at the speed change position.

Low—The ram ignores the speed change position and moves to the bottom of the stroke at low speed.

RETURN—PRESS-PRESS/DIST-DIST (PRESSURE-PRESSURE/DISTANCE-DISTANCE)

Press—The ram is returned to home position when the hydraulic pressing pressure (press) reaches the preset value and closes an internal normally open contact. The setting of the preset pressing pressure is set by the customer.

Press/Dist—The ram is returned to home position when the normally open contact of the pressure switch or the bottom of stroke limit switch closes.

Dist—The ram is returned to home position when the normally open contact in the bottom of stroke limit switch closes.

NOTE: Pressing pressure may be relieved (dumped) prior to returning the ram to home position. The RHPC control module has a user programmable bottom of stroke dwell function. By enabling this function and setting the dwell time, pressing pressure is dumped prior to the ram returning to the home position. This dwell function helps in reducing hydraulic shock produced when hydraulic fluids are reversed under pressure.

OFF/PROG/RUN

Off—The off selection prevents the machine from running production. This mode is intended only for temporary shutdown. Do not use this mode for machine servicing or performing repairs. Always use lockout/tagout procedures when servicing the hydraulic press.

Prog—The prog (program) selection enables changing user defined parameters within the control module.

Run—When run is selected, the hydraulic press is in the normal process run mode.

ACTUATING MEANS—HAND-FOOT

Hand—With the mode selector set to inch and both palm buttons are pressed, the ram inches down (each time the palm buttons are pressed) and stops at the bottom of the stroke. With the mode selector set to single and both palm buttons are pressed, the ram moves to the end of the stroke in one continuous motion and stops at the bottom of the stroke. After reaching the bottom of the stroke, release both palm buttons and the ram will automatically return to the home position. This operation is commonly referred to as hand down, hand through.

Foot—With the mode selector set to single, press the foot switch. The ram moves to the bottom of the stroke and then stops. After reaching the bottom of the stroke, release the foot switch and the ram will automatically return to the home position. This is commonly referred to as foot down, foot through.

A point-of-operation safeguard must be used when selecting foot, single-stroke operation.
 SECTION 2—INTRODUCTION

RHPC Hydraulic Press Solid-State Control

Control Box

Rockford Systems RHPC hydraulic power punch press control is an economically, full-featured, dual microprocessor-based punch press control. This control system is designed to comply with OSHA 29 CFR 1910.212 and ANSI B11.2. It is an economical replacement for existing older style “relay-based” control systems found in many older machines today. Rockford Systems hydraulic press control is an excellent choice for new OEM machines, or rebuilt units.

Rockford Systems controls can be supplied in a custom enclosure with motor controls and fused disconnect or as a standard enclosure. The standard control is designed to interface directly into an existing motor control circuit. The standard hydraulic punch press control package is made up of the following: a punch press control module, a 20” x 20” x 8” NEMA 12 enclosure, a keypad/display operator interface, a light curtain Off/On keyed selector switch (light curtain optional), an Off/Prog/Run keyed selector switch, a hand/foot ACTUATING MEANS keyed selector switch, a Pressure/Pressure-Distance/Distance RETURN MODE keyed selector switch, a High/High-Low/Low SPEED CHANGE keyed selector switch, an Inch/Single/Auto MODE keyed selector switch, a 250 VA transformer (230/460 PRI, 120 V SEC) with fusing for the primary and secondary side of the transformer, a 4-pole (3 NO/1 NC force-guided contacts) master control relay that operates on 120 V AC, a 4-pole (3 NO/1 NC force-guided contacts) top-stop relay that operates on 120 V AC, and 98 wire terminals. Rockford Systems standard control may also be ordered in a plain door enclosure. The keypad/display interface and all operators may be mounted in a remote station enclosure.

Rockford Systems hydraulic punch press control module uses complimentary inputs for the foot switch, palm buttons, and light curtain inputs. All inputs are 24 V DC and are optically isolated for noise immunity. Each output from the control module is accomplished through one force-guided relay that has one NO dry contact. Each output is fused for a maximum of four amps (4 A). All outputs come standard at 120 V AC. All 120 V AC controlled devices (relays and solenoids) must be suppressed across their coils. Each control is shipped with three suppressors. If controlled devices are other than standard voltage, outputs may be reconfigured for desired voltages. The RHPC hydraulic press control comes with redundant cross-checking microprocessors and redundant DC power supplies. This provides control reliable operation of all outputs in the event one microprocessor or one DC power supply fails.
SECTION 2—INTRODUCTION

RHPC Hydraulic Press Solid-State Control

REMOTE OPERATOR-STYLE CONTROLS

Remote operator-style controls include the same features and modes of operation as the standard control boxes, however, they do not have a control transformer. These controls are intended for use where a machine’s existing magnetic motor starter, fused disconnect switch, and control transformer meet all safety requirements and will remain in use. If an existing control transformer cannot be reused, contact Rockford Systems. The three remote operator-style control boxes available have the keypad/display and all operators on the door of the enclosure. The remote operator-style control boxes available are:

- Style X—Standard RHPC control box without the control transformer
- Style Y—Standard RHPC control box without the control transformer, but with an E-stop palm button, return palm button, and prior-action push button in the enclosure
- Style Z—Standard RHPC control box without the control transformer, but with an E-stop palm button, return palm button, prior-action push button, and two (2) guarded run/inch buttons on the sides of the enclosure

CONTROL MODULE KIT

The RHPC control module kit includes the control module, two (2) forceguided relays, control module shock mounts, fasteners, suppressors, extra fuses, ferrules, danger and warning labels, and electrical schematics. The minimum area required to install this kit on an existing control panel is 18” high x 18” wide x 8” deep.

NOTE: This control module kit is not furnished with an enclosure, enclosure panel, control transformer, control fuses, terminals, or wiring.

KEYPAD/DISPLAY KIT

The RHPC keypad/display kit includes the Off/Run/Prog keyed selector switch, light curtain Off/On keyed selector switch, actuating means Hand/Foot keyed selector switch, Inch/Single/Auto mode keyed selector switch, High/High-Low/Low speed change keyed selector switch, Pressure/Pressure-Distance/Distance return keyed selector switch, all nameplates, and 25’ of shielded cable. Additional operators may have been furnished. The minimum area required to install this keypad/display kit is 11” high x 10” wide x 2” deep.

(Continued on next page.)
CONTROL MODULE ASSEMBLY

The solid-state control module assembly below, Part No. FTL-068, is 8 ¾" high x 8 ¼" wide x 4" deep. It is considered an open device and must be installed inside a NEMA 12 rated enclosure. Four (4) shock/vibration mounting pads and four (4) ¼-20 socket head cap screws are used to secure it to an enclosure subpanel. The module cover is held in place with four (4) 8-32 socket button-head screws for easy removal during troubleshooting. LED indicators on each input and output are used as aids in troubleshooting problems. Inputs to the press control may be configured for sinking or sourcing inputs. Whichever type is selected, \textbf{ALL inputs must be sinking or ALL inputs must be sourcing}. Mixing of sinking and sourcing inputs is \textbf{NOT} allowed.

(Continued on next page.)
Control Module Assembly (continued)

If necessary, the cover of the module can be taken off by removing the screws on the corners and pulling the top straight off. The dual-CPU circuit board is then exposed as shown in the photo below.

Photo 3.4
Control Module without Cover

User-serviceable parts on the dual CPU board are the relays, core module, fuses F1- F6, and the battery. If any changes to the circuit boards are required, instructions will be sent with the new parts.
SECTION 3—INSTALLATION OF COMPONENTS
RHPC Hydraulic Press Solid-State Control

Keypad/Display Assembly

Photo 3.5
Keypad/Display

The keypad/display assembly, Part No. FTL- 062, is used to enter setup information and to monitor machine operation. The keypad/display can be furnished in a remote enclosure up to a maximum of 150’ from the control module. All programming is accessed by a keyed selector switch on the keypad/display unit.

If the keypad/display is supplied in a remote enclosure, please refer to the section on wiring and the electrical schematic prints that came with the control box on the proper wiring connection.

Mounting the Control Box
Solidly mount the control box in an accessible location, either on or near the machine to be controlled. A convenient location will keep conduit runs to a minimum length.

Although operation of this control will not be adversely affected by normal machine operation, excessive shock or vibration may require shock mounting in specific applications.

The key must be removed from the off/run/program selector switch after the control is programmed and before the machine is released to production. All keys must be supervisory controlled at all times.

(Continued on next page.)
SECTION 3—INSTALLATION OF COMPONENTS
RHPC Hydraulic Press Solid-State Control

PART NO. CTL-525 - PALM BUTTON ASSEMBLY (if furnished, see Installation Manual No. KSL-071 or KSL-073)

When the standard modes of operation of off, inch, single stroke, automatic, and auto single are furnished, the palm button assembly will consist of four buttons (two run/inch buttons with ring guards, one red emergency-stop button, and one yellow return/inch-up button). Along with these buttons will be four mounting boxes (three double hub and one single hub). Optionally available are the Touchdown™ or chrome “light push” palm buttons. These may be furnished in place of the standard black run/inch palm buttons. The palm buttons can be assembled as shown in Photo 3.7 and mounted according to the requirements of the application. Nipples for connecting and running wire are not furnished.

⚠️ Install the palm “run” buttons in such a way that it requires the use of both hands to cycle the machine.

The two “run” palm buttons, on hydraulic machines, can be used to initiate a machine cycle and as a method of safeguarding the point of operation. ANSI’s B11.2 has established certain requirements for these buttons when used as a safeguarding method. According to ANSI B11.2 - 1995, the total stopping time of the press should include the total response time of the control system and the time it takes the press to cease slide motion. The following formula should be used when calculating the safety distance:

\[
D_s = K (T_s + T_c + T_r + T_{spm})
\]

where:

- \(D_s\) = minimum safety distance between the device and the nearest point-of-operation hazard (inches)
- \(K\) = the hand speed constant = 63 inches/second.
- \(T_s\) = the stop time of the machine tool measured at the final control element
- \(T_c\) = the response time of the control system.
- \(T_r\) = response time of any hand control device, if provided, including its interface
- \(T_{spm}\) = the additional time allowed for the stopping performance monitor to compensate for variations in the normal stopping time

When applying the two palm “run” buttons to meet the requirements for a “point-of-operation safeguarding device,” make certain these buttons are located on the machine so they meet the minimum safety distance required by the ANSI formula.

⚠️ Simply stated, safety distance is the mounting and location of the palm buttons at a distance where the operator cannot reach into the point-of-operation hazard before the ram has stopped or completed its downward travel.

⚠️ To obtain the stopping time, a portable stop-time measurement unit can be used.

(For a portable unit, please contact Rockford Systems, LLC.)
SECTION 3—INSTALLATION OF COMPONENTS

Rockford Systems, LLC
Call: 1-800-922-7533

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Red Emergency-Stop Palm Button (Required)

The red emergency-stop button is used to stop the machine anywhere in its cycle. When the operator depresses
the button, it should stop the hazardous motion of the machine immediately by shutting off the hydraulic drive pump
motor. This palm button assembly includes a double hub mounting box. It can be located between the two “run” palm
buttons as part of the operator’s control station. (Please refer to page 18.) This button has a mechanical latch that
must be reset after depressing the button.

NOTE: More than one emergency-stop button may be furnished for additional control stations or for convenience.

Photo 3.8

Yellow Return/Inch-Up Button

The yellow return/inch-up button is used to stop the machine when it is in the “automatic” mode of operation. When
the operator depresses the button, almost anywhere in the stroke of the machine, it will return the ram to the up
position. This palm button assembly includes a double hub mounting box. It can be located between the two “run”
palm buttons, along with the red emergency-stop button, as part of the operator’s control station. (Please refer to
page 18.)

Photo 3.9

Automatic Prior-Action Pushbutton Station (Part No. LLD-6100 Automatic and Automatic Single Stroke)

According to ANSI B11.2 - 1995, control systems that include an automatic cycle mode shall require:

“Selection of the automatic mode; and a prior or deliberate action by the operator; and operation of the actuating
means; and an intended action by the operator before an interrupted cycle may be resumed.”

These prior-action stations have a recessed push button that must be depressed and released by the operator before
depressing the two palm buttons in order to initiate the continuous or automatic RUN type of press operation. This is
sometimes referred to as “walk-away” continuous.

Mount the remote stations on the machine so that it is convenient for the operator to depress and release these push
buttons prior to depressing the two palm buttons. These buttons may be mounted as part of the operator’s control
station. After releasing the button, the operator has a 5-second time period in which to depress the run buttons. If the
operator should wait longer than this time setting, the prior action must be depressed and released again.

Photo 3.10

(Continued on next page.)
SECTION 3—INSTALLATION OF COMPONENTS
RHPC Hydraulic Press Solid-State Control

PART NO. CTD-011—FOOT SWITCH (optional) (See enclosed Installation Manual No. KSL-001)

If a foot switch control is used, all personnel must be warned that it is NOT a point-of-operation safeguard. It is the responsibility of the employer (user) to always provide an appropriate guard and/or device to prevent bodily injury whenever a foot switch is used to initiate a machine cycle. (See ANSI B11.2 for safeguarding.)

When using a foot switch, please see page 11 for information on electrically interlocking or mechanically guarding the point of operation. When installing the optional foot switch, be sure that the wiring schematics are referenced for proper connections. Be sure to maintain the foot switch in first-class condition. It must always be wired properly and the protection on the top, sides and front must always remain in place.

Never use a foot switch to operate this machine unless a point-of-operation guard or device is provided and properly maintained.

The mechanical guard or device must be properly installed, used and maintained. It must always prevent all personnel from bodily injury.

If the mechanical guard or device is not used, is removed or is defeated, an electrically interlocked method of safeguarding must be used and connected to the safeguard interlock terminals (P7-5 and P7-6).

PART NO. LLD-6101—SUPERVISORY CONTROL STATION (Required for multiple operator stations)
PART NO. LLD-283—SUPERVISORY CONTROL STATION (Required for multiple operator stations and when a USC-000 is used—see below)

When two or more palm button or foot switch operating stations are required on one machine, one supervisory control station is required at each operator station. This remote control station consists of one station on indicator light and an off/on keyed selector switch in an enclosure. The on position allows the operator to use that station and the off position deactivates only that station. If all the supervisory control stations are in the on position, the palm buttons or foot switches must be depressed within the timing period set in the anti-tie-down program (page 67) in order to initiate a machine stroke.

NOTE: If the USC-000 multiple-operator junction box is used, the anti-tie-down setting in the SSC-1500 Gen II control becomes irrelevant, since the junction box has its own timers.

PART NO. USC-000—MULTIPLE OPERATOR JUNCTION BOX (If furnished, see Installation Manual KSL-266)

When multiple operator stations are required, this junction box is furnished separately for wiring up to four (4) operator stations. This junction box interfaces palm button assemblies/control bars and foot switches, and will not allow the press to run if palm buttons or a foot switch is actuated without its supervisory control station on. Refer to the electrical schematic furnished with your order for proper wiring of each station.
SECTION 3—INSTALLATION OF COMPONENTS
RHPC Hydraulic Press Solid-State Control

Other Required Components (Not supplied as part of standard package unless specifically ordered)

MAIN POWER DISCONNECT SWITCH

A main power disconnect switch may have been supplied in this control package shipment, either in a custom control box or separately. This switch is designed to disconnect the primary voltage to the press and lock it out. Please refer to the enclosed wiring schematics for proper wiring of this switch, if furnished separately.

ANSI Standard B11.2 requires that:

1. A main power disconnect switch capable of being locked in the “Off” position shall be provided with every power press control system.

2. If the machine already has a main power disconnect switch, it must be checked for the “locking off” and lockout feature. Some switches use construction which can be easily altered mechanically to comply with this requirement. If this is not possible, or an electrical disconnect switch is not provided, then you must obtain and install a proper disconnect switch. (For proper disconnect switch, please contact Rockford Systems, LLC.)

MOTOR STARTER

A nonreversing motor starter may have been supplied with this control package. The main purpose of this starter is to drop out the main drive motor and the hard-wired emergency-stop relay when a power failure occurs. Please refer to the enclosed wiring schematics for proper wiring of this starter. If an existing starter is used, a 120 VAC coil is required.

ANSI Standard B11.2 requires that:

1. The motor start button shall be protected against accidental operation.

2. All mechanical power press controls shall incorporate a type of drive motor starter that disconnects the drive motor from the power source in the event of control voltage or power source failure. It shall also require operation of the motor start button to restart the motor when voltage conditions are restored to normal.

The above requirements are normally met by using a magnetic motor starter. This starter operates with a 120 VAC coil which is powered from the secondary of the control transformer on the control panel. Refer to the electrical schematics supplied to obtain details of how to wire the starter and associated motor start/stop push buttons. If a new magnetic motor starter is required, please contact Rockford Systems, LLC.

CUSTOM OR SPECIAL CONTROL BOX

Instead of the standard hydraulic control box, you may have ordered and received a custom or special control box. This box usually includes a magnetic motor starter and disconnect switch complying to the previous requirements. Be sure to wire in primary voltage and components to terminals as indicated on the enclosed wiring schematics. 120 volt electrical power to hydraulic controls, operator controls, solenoids, etc., must be obtained from the furnished transformer with isolated secondary.

COLLATERAL EQUIPMENT

All collateral press room and plant equipment such as spring or air-slide counterbalances, die cushions, feeding equipment, and robots must be safeguarded if they create hazards to personnel.

POINT-OF-OPERATION SAFEGUARDS

For compliance to ANSI B11.2 Safety Standard, please refer to Section 9—Methods of Safeguarding, for examples of point-of-operation safeguards for presses.

(Continued on next page.)
SECTION 3—INSTALLATION OF COMPONENTS
RHPC Hydraulic Press Solid-State Control

Other Required Components (continued)
PRESENCE SENSING DEVICE

According to ANSI B11.2 - 1995, the total stopping time of the press (for presence sensing devices) should include the total response time of the presence sensing device, as stated by the manufacturer, the response time of the interface, the response time of the control system and the time it takes the press to cease slide motion. The following formula should be used when calculating the safety distance:

\[ D_s = K(T_s + T_c + T_r + T_{spm}) + D_{pf} \]

where:
- \( K \) = the hand speed constant = 63 inches/second.
- \( T_s \) = the stop time of the press measured from the final deenergized control element.
- \( T_c \) = the response time of the press control.
- \( T_r \) = response time of the presence sensing device and its interface, if any, as stated by the manufacturer or measured by the employer.
- \( T_{spm} \) = the additional time allowed for the stopping performance monitor to compensate for variations in the normal stopping time.
- \( D_{pf} \) = the added distance due to the penetration factor as recommended in Table 3.1. The minimum object sensitivity is stated by the manufacturer. If beam blankouts or floating window features are used, these figures should be added to the object sensitivity figure before using the chart.

Table 3.1

DEPTH PENETRATION FACTOR
This table represents the depth of penetration into the light curtain at which an object will be detected.
SECTION 3—INSTALLATION OF COMPONENTS
RHPC Hydraulic Press Solid-State Control

Other Installation Considerations

WIRING
National Electrical Code practices, including NFPA-79, are usually followed for wiring the control system, especially color coding and the use of numbered wire markers on both ends of every wire. Color coding is Black for line voltage and control at line voltage, Red for 120 VAC control circuits, Blue for 24 VDC control circuits, White for current carrying ground (commonly referred to as the “Neutral”), and Green for any equipment grounding conductor. All terminal blocks in the control cabinet are color coded for easy identification.

1. Install and wire the main disconnect switch (unless one already exists or is furnished in a custom control) using black wire. Follow wiring instructions shown on the electrical schematics. Make certain this switch is capable of being locked in the “Off” position only.

2. Install and wire the motor starter (unless one already exists or is installed in a custom control box) using black wire for the power; red and white wires for the coil and interlock circuit; and blue for the motor forward connection to the RHPC control module.

3. All necessary outputs from the RHPC control module are wired from the green printed circuit board to the terminal block. All necessary inputs need to be wired to the green printed circuit board terminal strip P2 for installation.

4. Run two black power lines (any two lines) from the load side of the disconnect switch (or from the line side of the motor starter) to the control enclosure. Connect the two black wires to the proper terminals on the control transformer (see electrical schematic or transformer nameplate for proper connections for different primary voltages).

   NOTE: If a control box with a disconnect has been provided, this step is not necessary.

5. Run a green ground wire from the incoming system ground to the control panel.

6. Wire the motor starter and start/stop control according to the connection schematics.

   NOTE: If a custom control box with a starter has been provided, this step is not necessary.

Keypad/Display - Remote
If the keypad/display is furnished in a remote station, an optional seven-conductor shielded cable can be run in conduit or sealtite with other low voltage signal conductors. This cable carries low voltage signals and should not be located near or in the same conduit or raceway with conductors for main power feeds or motor leads. 25’ of cable is supplied as standard and can be cut to length if required. Do not splice or interrupt signals. The cable should be wired directly into the RHPC control module terminal strip P5, as shown in the schematic prints that were sent with the control box. Please contact Rockford Systems, LLC. if a longer cable is required.

Palm Button Assembly
These palm buttons are normally wired as an assembly with the blue wires routed from the control box to the nearest palm button and then the others, as required, within the units. Wires between the two “run/inch” buttons are not connected back to the control box. If “Touchdown™” (proximity) palm buttons are furnished, please refer to the enclosed Installation Manual No. KSL-073 and the connection print.

If the palm button assembly is not bolted directly to the machine frame, then a separate green ground wire should be run from the control box to all palm buttons. Attach one end of the wire to each mounting box by a lug under one of the mounting bolts and the other end of the wire to the “GND” terminal in the control box to assure proper grounding.

These operator controls should be mounted in a convenient location, keeping ergonomics in mind. To comply with ANSI Standards for “two-hand controls,” the “run/inch” buttons must be located according to the “minimum safety distance” requirements of each individual machine as defined by the standard (see page 18 of this manual). A stop-time measurement unit is necessary for checking stopping time before installation begins. The palm button assembly must be fixed at the proper safety distance so that only a supervisor or safety engineer is capable of relocating them.

Supervisory Control Station (See page 20)
When two or more two-hand or foot switch operating stations are required on one machine, one supervisory control station is required at each operator station. This remote control station consists of one “station on” indicator light and a key-locked “off/on” selector switch in an enclosure. The “on” position allows the operator to use that station and the
Other Installation Considerations (continued)

“off” position deactivates only that station. If all the supervisory control stations are in the “on” position, all two-hand palm buttons must be depressed within the timing period set in the Anti-Tiedown (page 31) program in order to initiate a machine stroke. These supervisory control stations must be wired to prevent actuation of the clutch if all operating stations are turned off and controls are operational. See wiring schematics for proper wiring of these supervisory control stations.

⚠️ Do not operate the press if the ground indicator light does not illuminate when the station is turned on.

Press Ground

The machine frame must always be firmly connected to ground in order to ensure that the control potential will never exceed 120 volts above ground. Run a green grounding wire from the control box to some convenient location directly on the machine frame. Connect one end solidly to the frame using a mounting bolt or other convenient means of attachment. Scrape any paint, rust, etc., from the area, to ensure an adequate ground connection. Connect the other end to the “GND” terminal in the control box.

NOTE: All exposed metal components, which may be touched by personnel during normal operation or adjustment, must be firmly grounded to the machine frame. The disconnect switch and motor starter should also be grounded if they are mounted separately.
Setup and Programming

Before programming this control, an understanding is required as to how this control monitors its inputs. It is also important to understand that certain settings in the control require the correct input variable to produce an output.

This control system can be used with limit switches (default) or an encoder (purchased separately) to monitor top of stroke, bottom of stroke, speed change, and muting. Depending on the method, these functions may need to be programmed accordingly.

**Limit Switches (Default)** — The logic (N.O. & N.C.) has been preset in the software and cannot be set in the control. Refer to the electrical schematic for the correct wiring.

**Encoder** — A separate encoder is needed in order to use the extra functions that the encoder allows. ENCODER ENABLE must be turned ON in order to use the encoder functions. See step #5 in the power-up procedures (pages 26-28) to turn the encoder ON and OFF. Also refer to pages 57-58 in the configuration menu in the SYSTEM SETUP section.

The flowchart in Figures 4.0 and 4.1 outline the order and method of setting up and programming the RHPC hydraulic press control system after installation. Use the keypad and display on the control box or remote operator station for viewing screens and for programming.
Power-Up Procedure

1. Turn on the main power disconnect that supplies power to the machine and control module. The following screen will be displayed.

![Screen 1](image1)

NOTE: If you are receiving tech. support over the phone and are asked for the software version of your press control module, simply turn off the main disconnect to this machine and turn it back on. The above message appears every time the power is turned on to the control module.

2. Press YES on the keypad if safeguards are in place. The following message appears.

Start the motor. If this message does not clear once the motor has started, then the control’s inputs are not receiving or are missing the correct signal. Check that the existing inputs are sinking (common). The default is set to sourcing inputs (24V DC), and the JP1 jumper may need to be set to sinking. If the jumper is set to the wrong position, the above screen will be displayed and only CPU lights will be on the control.

3. The following screen is displayed when the Off/Prog/Run selector switch is in the OFF position.

![Screen 2](image2)

4. Select the PROG position of the Off/Prog/Run selector switch. The two MAIN PROGRAM SCREENS will be displayed as shown.

![Screen 3](image3)

5. ENABLE THE ENCODER DEVICE—When an encoder device is connected to the control module, ENCODER ENABLE must be turned ON in order to use the encoder functions. On the MAIN PROGRAM SCREEN, press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed as shown.

Enter the security code (ENTER is the default setting).

The system setup screens will be displayed. Use ↓ and ↑ on the keypad to scroll through the system setup screens. Press ENTER when the arrow symbol (>) is next to CONFIGURATION. The supervisor code screen will be displayed as shown.
**Power-Up Procedure (cont.)**

5. (continued)

Enter the supervisor code (1 is the default setting). Press **ENTER**.

The configuration screens will be displayed. Use ↓ and ↑ on the keypad to scroll through the configuration screens. Press **ENTER** when the double arrow symbol (>>) is next to ENCODER ENABLE. The encoder enable programming screen will be displayed as shown.

<table>
<thead>
<tr>
<th>PROGRAMMING</th>
</tr>
</thead>
<tbody>
<tr>
<td>Encoder Enable</td>
</tr>
<tr>
<td>OFF</td>
</tr>
</tbody>
</table>

Use ↑ on the keypad to choose ON. Press **ENTER** to finish.

The encoder is now enabled. Press **ESC** twice to return to the MAIN PROGRAM SCREEN.

**HOME THE PRESS**—Once the encoder is enabled or anytime thereafter that the power to the control has been turned off then on, you must HOME the press upon initial start up.

With power on to the control, and YES has been pressed on the keypad if safeguards are in place, select the **RUN** position of the Off/Prog/Run selector switch.

Select the **INCH** position of the Inch/Single/Auto mode selector switch. Simultaneously press and hold the right palm button and the yellow return button. At this point, if the press is already at TOS (top of stroke), the ram will start to move down for a preset amount of time and then will return to the home limit switch. The control will now be at 0 (HOME).

To program a new HOME time, see Home Off Time in SYSTEM SETUP under the configuration screen—pages 57-58.

Proceed to step 6, next column.

6. Safeguard parameters must be edited for control operations. On the MAIN PROGRAM SCREEN, press **ENTER** when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed as shown.

```
| ENTER SECURITY CODE |
| _ CODE |
```

Enter the security code (**ENTER** is the default setting).

The system setup screens will be displayed. Use ↓ and ↑ on the keypad to scroll through the system setup screens. Press **ENTER** when the arrow symbol (>) is next to CONFIGURATION. The supervisor code screen will be displayed as shown.

```
| ENTER SUPRVSR CODE |
| _ CODE |
```

Enter the supervisor code (1 is the default setting). Press **ENTER**.

The configuration screens will be displayed. Use ↓ and ↑ on the keypad to scroll through the configuration screens. Press **ENTER** when the double arrow symbol (>>) is next to LIGHT CURTAIN TYPE. Use ↓ and ↑ on the keypad to reach the setting you desire for the light curtain type. If light curtains are not used, verify that 2 N.O. is selected as the type and connect input 13 (Light Curtain Off) to the input signal (+24 or common).

Press **ENTER** to finish. Go to step 7 on the next page.
Power-Up Procedure (cont.)

7. While in the configuration screen, use ↓ and ↑ on the keypad to scroll to SAFEGUARD FUNCTION. Press ENTER when the double arrow symbol (><) symbol is next to SAFEGUARD FUNCTION. Use ↓ and ↑ on the keypad to choose the best option for your application from the two options available: Always Required—the light curtain will always be required unless it is not installed; or Foot/Sing & Cont—the light curtain will be required for those modes only.

Press ENTER to finish. Press ESC twice to return to the MAIN PROGRAM SCREEN.

8. If the control has been properly installed and the previous steps have been followed, then the basic control functions have been set and you are now ready for operation.

Turn the key switch to RUN. The screen will display the current operating configuration that has been selected.

To reprogram or verify a current setting, refer to pages 29 through 62 for detailed programming information.
Programming Overview

The following sections outline the programming of the RHPC press control on a hydraulic press after installation of all components has been completed, and the Power-Up Procedure and Main Program Screens sections of this manual have been read and understood.

MAIN PROGRAM SCREENS

The RHPC press control has two main programming screens from which you can access all of the programmable features of the control.

To program the control, select the PROG position of the Off/Prog/Run selector switch. The MAIN PROGRAM SCREENS will be displayed. A pound symbol (#) will be next to one of the following program options as shown.

Use ↓ and ↑ on the keypad to scroll between the two main program screens.

Each main program option is described in detail on the following pages.

<table>
<thead>
<tr>
<th>1. PRESS SETTINGS</th>
<th>2. COUNTERS</th>
<th>3. INPUT/OUTPUT</th>
<th>4. SYSTEM SETUP</th>
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</tr>
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When the pound symbol (#) is next to the program option you want to edit, press ENTER. Once the new information is input and ESC is pressed, the display returns to the MAIN PROGRAM SCREEN. If incorrect information has been entered, return to the setting and reenter the correct information.

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PRESS SETTINGS

The press settings menu is for editing top of stroke, bottom of stroke, speed change, and muting.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.2. Enter the security code. After the correct security code has been entered, the PRESS SETTINGS SCREEN(S) will be displayed.

The screen shown in Figure 4.3 is the screen that is displayed without the encoder enabled. The screens in Figures 4.4 through 4.6 are the screens that are displayed with the encoder enabled. Use ↓ and ↑ on the keypad to scroll between the press settings screens.

NOTE: Without the encoder enabled, BOTTOM DWELL is the only screen available to edit in PRESS SETTINGS.

Figure 4.2
Security Code Screen

ENTER SECURITY CODE

CODE

Figure 4.3
Press Settings Program Screen (Without Encoder Enabled)

>Bottom Dwell

Figure 4.4
First Press Settings Program Screen (With Encoder Enabled)

>Bottom Dwell
PSI or Position
TOS Position
BOS Position

Figure 4.5
Second Press Settings Program Screen (With Encoder Enabled)

>Speed CHG Position
Mute Position
Down Low SPD Coast
Down HI SPD Coast

Figure 4.6
Third Press Settings Program Screen (With Encoder Enabled)

>Up Low SPD Coast
Up HI SPD Coast
**BOTTOM DWELL**

This setting allows the press to stop or dwell at bottom of stroke under pressure for the selected amount of time up to 600 seconds. When the ram reaches the BOS (bottom of stroke) timing device, the down valve stays energized until the bottom dwell timer (if programmed) times out. Once the time runs out, the up valve will energize, returning the ram to the TOS (top of stroke) timing device.

*NOTE: BOTTOM DWELL is the only screen available to edit in PRESS SETTINGS without the encoder enabled.*

**HOW TO PROGRAM BOTTOM DWELL**

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.7. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press **ENTER** when the arrow symbol (>) is next to BOTTOM DWELL. The bottom dwell programming screen will be displayed. See Figure 4.8.

Enter the desired number of seconds up to 600 using the keypad. Press **ENTER** to finish.

If a mistake is made, press **BKSP** to backspace, or press **CLR** to delete the entry and start over, or press **ESC** to stop and return to the programming screen.

Press **ESC** to return to the MAIN PROGRAM SCREEN.

---

**Figure 4.7**
Security Code Screen

```
ENTER SECURITY CODE

_ CODE
```

**Figure 4.8**
Bottom Dwell Screen

```
PROGRAMMING:

Bottom Dwell
0.0 Seconds
```
PSI or POSITION

This setting allows selection of returning under pressure or position.

NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.

HOW TO PROGRAM PSI OR POSITION

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.9. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press ENTER when the arrow symbol (>) is next to PSI or POSITION. The PSI or position programming screen will be displayed. See Figure 4.10.

Toggle between ↓ and ↑ on the keypad to choose position or pressure. Press ENTER to finish.

Press ESC to return to the MAIN PROGRAM SCREEN.

Figure 4.9
Security Code Screen

ENTER SECURITY CODE

 _ CODE

Figure 4.10
PSI or Position Screen

PROGRAMMING:

PSI or Position
Position
**TOP OF STROKE POSITION**

This setting determines the position of the TOS (top of stroke) from 0 to 30 inches.

*NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.*

### HOW TO PROGRAM TOS POSITION

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.11. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press **ENTER** when the arrow symbol (>) is next to TOS POSITION. The top of stroke position programming screen will be displayed. See Figure 4.12.

Enter the desired number of inches up to 30 using the keypad. Press **ENTER** to finish.

If a mistake is made, press **BKSP** to backspace, or press **CLR** to delete the entry and start over, or press **ESC** to stop and return to the programming screen.

Press **ESC** to return to the MAIN PROGRAM SCREEN.
**SECTION 4—PROGRAMMING**

*RHPC Hydraulic Press Solid-State Control*

**BOTTOM OF STROKE POSITION**

This setting determines the position of the BOS (bottom of stroke) from 0 to 30 inches.  

*NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.*

**HOW TO PROGRAM BOS POSITION**

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.13. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press **ENTER** when the arrow symbol (>) is next to BOS POSITION. The bottom of stroke position programming screen will be displayed. See Figure 4.14.

Enter the desired number of inches up to 30 using the keypad. Press **ENTER** to finish.

If a mistake is made, press **BKSP** to backspace, or press **CLR** to delete the entry and start over, or press **ESC** to stop and return to the programming screen.

Press **ESC** to return to the MAIN PROGRAM SCREEN.

---

**Figure 4.13**  
Security Code Screen

```
ENTER SECURITY CODE
    CODE
```

**Figure 4.14**  
Bottom of Stroke Position Screen

```
PROGRAMMING:

BOS Position
4.000_ Inches
```
**SECTION 4—PROGRAMMING**

RHPC Hydraulic Press Solid-State Control

**HOW TO PROGRAM SPEED CHANGE POSITION**

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.15. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press **ENTER** when the arrow symbol (>) is next to SPEED CHG POSITION. The speed change position programming screen will be displayed. See Figure 4.16.

Enter the desired number of inches up to 30 using the keypad. Press **ENTER** to finish.

If a mistake is made, press **BKSP** to backspace, or press **CLR** to delete the entry and start over, or press **ESC** to stop and return to the programming screen.

Press **ESC** to return to the MAIN PROGRAM SCREEN.

**SPEED CHANGE POSITION**

This setting determines at what position the speed will change (from 0 to 30 inches).

*NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.*
SECTION 4—PROGRAMMING
RHPC Hydraulic Press Solid-State Control

MUTE POSITION
This setting determines at what position muting will occur (from 0 to 30 inches).

NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.

HOW TO PROGRAM MUTE POSITION
Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.17. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press ENTER when the arrow symbol (>) is next to MUTE POSITION. The mute position programming screen will be displayed. See Figure 4.18.

Enter the desired number of inches up to 30 using the keypad. Press ENTER to finish.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC to return to the MAIN PROGRAM SCREEN.

Figure 4.17
Security Code Screen

Figure 4.18
Mute Position Screen

PROGRAMMING:
Mute Position
3.000_ Inches

NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.
DOWN LOW SPEED COAST

This setting allows selection of a low speed offset if the press is not stopping at its bottom of stroke position in low speed (up to 1 inch).

NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.

HOW TO PROGRAM DOWN LOW SPEED COAST

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.19. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press ENTER when the arrow symbol (>) is next to DOWN LOW SPD COAST. The down low speed coast programming screen will be displayed. See Figure 4.20.

Enter the desired number up to 1 inch using the keypad. Press ENTER to finish.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC to return to the MAIN PROGRAM SCREEN.
SECTION 4—PROGRAMMING

RHPC Hydraulic Press Solid-State Control

DOWN HIGH SPEED COAST

This setting allows selection of a high speed offset if the press is not stopping at its bottom of stroke position in high speed (up to 1 inch).

NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.

HOW TO PROGRAM DOWN HIGH SPEED COAST

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.21. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press ENTER when the arrow symbol (>) is next to DOWN HI SPD COAST. The down high speed coast programming screen will be displayed. See Figure 4.22.

Enter the desired number up to 1 inch using the keypad. Press ENTER to finish.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC to return to the MAIN PROGRAM SCREEN.
UP LOW SPEED COAST

This setting allows selection of a low speed offset if the press is not stopping at its top of stroke position in low speed (up to 1 inch).

NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.

HOW TO PROGRAM UP LOW SPEED COAST

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.23. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press ENTER when the arrow symbol (> ) is next to UP LOW SPD COAST. The up low speed coast programming screen will be displayed. See Figure 4.24.

Enter the desired number up to 1 inch using the keypad. Press ENTER to finish.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC to return to the MAIN PROGRAM SCREEN.
**SECTION 4—PROGRAMMING**

RHPC Hydraulic Press Solid-State Control

**UP HIGH SPEED COAST**

This setting allows selection of a high speed offset if the press is not stopping at its top of stroke position in high speed (up to 1 inch).

*NOTE: This PRESS SETTING screen is available to edit only when the encoder is enabled.*

**HOW TO PROGRAM UP HIGH SPEED COAST**

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to PRESS SETTINGS. The security code screen will be displayed. See Figure 4.25. Enter the security code. Use ↓ and ↑ on the keypad to scroll between the press settings screens. Press **ENTER** when the arrow symbol (>) is next to UP HI SPD COAST. The up high speed coast programming screen will be displayed. See Figure 4.26.

Enter the desired number up to 1 inch using the keypad. Press **ENTER** to finish.

If a mistake is made, press **BKSP** to backspace, or press **CLR** to delete the entry and start over, or press **ESC** to stop and return to the programming screen.

Press **ESC** to return to the MAIN PROGRAM SCREEN.

![Figure 4.25 Security Code Screen](image)

![Figure 4.26 Up High Speed Coast Screen](image)
COUNTERS

The RHPC hydraulic control has a batch counter that can be used for die maintenance, quality control checks, or part bin exchanges. These counters have a programmable preset that will signal the press to top stop when the preset is reached. There is also a total clear which has security code protection.

When the batch counter has reached its preset value and BATCH COUNT EXPIRED is displayed, the machine will not operate until the message has been acknowledged by the operator—press ENTER, CLR, or ESC on the keypad.

**HOW TO PROGRAM THE COUNTERS**

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to COUNTERS. The security code screen will be displayed. See Figure 4.27. You will be prompted to enter the security code.

After the correct security code has been entered, the COUNTER PROGRAM SCREEN will be displayed. See Figure 4.28.

**To clear the batch counter:**

Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to BATCH CLEAR. You will see the clear batch counter screen. See Figure 4.30.

Press YES to confirm; the counter will be cleared and will return to the COUNTER PROGRAM SCREEN.

Press NO to return to the COUNTER PROGRAM SCREEN.

**To enter a batch preset:**

Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to BATCH PRESET. You will see the batch preset programming screen. See Figure 4.29.

After you have entered a preset value, press ENTER to finish. This will bring you back to the COUNTER PROGRAM SCREEN.

Figure 4.27
Security Code Screen

---

> ENTER SECURITY CODE

---

Figure 4.28
Counter Program Screen

---

> Batch Clear
Batch Preset
Total Clear

---

Figure 4.29
Batch Preset Screen

---

PROGRAMMING:

Batch Preset
0, Strokes

---

Figure 4.30
Clear Batch Counter Screen

---

Clear BATCH Counter?

Press: YES or NO

(Continued on next page.)
HOW TO PROGRAM THE COUNTERS (continued)

To clear the total counter:

Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to TOTAL CLEAR. The Security Code Screen will be displayed. See Figure 4.31. You will be prompted to enter the security code.

After the correct security code has been entered, you will see the CLEAR TOTAL COUNTER SCREEN which also displays the total counter. See Figure 4.32.

To only view the counter and not clear it, press NO to return to the COUNTER PROGRAM SCREEN.

To clear the total counter, press YES to confirm; the counter will be cleared and will return to the COUNTER PROGRAM SCREEN.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.

Figure 4.31
Security Code Screen

```
ENTER SECURITY CODE

_     CODE
```

Figure 4.32
Clear Total Counter Screen

```
Clear TOTAL Counter?
0000919
Press:     YES  or  NO
```
INPUT/OUTPUT

The RHPC press control has four (4) static-type programmable user inputs that can be programmed for equipment monitoring or other user-defined functions. See page 44 for programming information.

NOTE: If the optional ethernet I/O (Input/Output) card was added, there will be eight (8) additional programmable user inputs and four (4) PLS (programmable limit switch) outputs. See pages 45-47 for programming information.

Static-type means that when the inputs are set to be on, they are continuously monitoring for a change of state in the logic. When a change of state occurs, the input will go true, and the control will stop the machine. The static-type inputs are intended to diagnose fault conditions of auxiliary equipment specific to the machine, such as clutch/brake air pressure fault, counterbalance air pressure fault, and dual solenoid fault.

There are three (3) parameters that can be programmed for the three static-type inputs. All inputs are 24-V DC current-sinking (NPN) inputs.

PROGRAMMABLE PARAMETERS FOR USER INPUTS

1. **Logic:** This setting is used to change the logic that activates the input. The programming choices are N.O. (normally open), N.C. (normally closed), and OFF (disabled). Select one setting for each input.

2. **Stop Type:** When the input is activated or goes true, the press cycle will stop in one of two ways. E-STOP (emergency stop) will immediately stop the cycle in progress. T-STOP (top stop) will stop the cycle in progress at TDC (top dead center). Select the type of stop that is required for each input.

3. **Message:** When the input is activated, a fault message is displayed. This fault message is assigned to the input according to its function. Figure 4.33 shows a list of fault messages that can be assigned to each input.

<table>
<thead>
<tr>
<th>User Input Fault Messages</th>
</tr>
</thead>
<tbody>
<tr>
<td>LUBE FAULT</td>
</tr>
<tr>
<td>HIGH LUBE PRESSURE</td>
</tr>
<tr>
<td>LOW LUBE PRESSURE</td>
</tr>
<tr>
<td>LOW LUBE LEVEL</td>
</tr>
<tr>
<td>MAIN MOTOR OVERLOAD</td>
</tr>
<tr>
<td>LUBE MOTOR OVERLOAD</td>
</tr>
<tr>
<td>AUX MOTOR OVERLOAD</td>
</tr>
<tr>
<td>GUARD INTERLOCK OPEN</td>
</tr>
<tr>
<td>FRONT GUARD OPEN</td>
</tr>
<tr>
<td>REAR GUARD OPEN</td>
</tr>
<tr>
<td>LEFT SIDE GUARD OPEN</td>
</tr>
<tr>
<td>RIGHT SIDE GRD OPEN</td>
</tr>
<tr>
<td>FEEDER FAULT</td>
</tr>
<tr>
<td>LOAD MONITOR FAULT</td>
</tr>
<tr>
<td>SAFETY BLK INTERLOCK</td>
</tr>
<tr>
<td>DIE PROTECTION FAULT</td>
</tr>
<tr>
<td>HYD OVERLOAD FAULT</td>
</tr>
<tr>
<td>HYD SYS OIL LEV LOW</td>
</tr>
<tr>
<td>SHORT FEED FAULT</td>
</tr>
<tr>
<td>PART EJECTION FAULT</td>
</tr>
<tr>
<td>STOCK BUCKLE FAULT</td>
</tr>
<tr>
<td>END OF STOCK FAULT</td>
</tr>
<tr>
<td>PILOT PIN FAULT</td>
</tr>
</tbody>
</table>

(Continued on next page.)
FOLLOW THESE STEPS WITHOUT THE OPTIONAL ETHERNET I/O CARD

HOW TO PROGRAM USER INPUTS 1-4

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to INPUT/OUTPUT. The security code screen will be displayed. See Figure 4.34. Enter the security code.

Press ENTER when the arrow symbol (>) is next to USER INPUTS. The user inputs screen will be displayed. See Figure 4.35.

Press ENTER when the arrow symbol (>) is next to the user input you want to program. The PROGRAMMABLE PARAMETERS SCREEN shown in Figure 4.36 will be displayed. If EXTN RELAY MONITOR is turned on and/or AUTO SINGLE MODE is turned on, you will not be able to program user inputs #3 and #4 respectively.

Use ↓ and ↑ on the keypad to scroll through the programmable parameters. Press ENTER when the double arrow symbol (>>) is next to the parameter you want to program. A screen similar to the one shown in Figure 4.37 will be displayed.

Once you are in the programming screen of the parameter you want to program, use ↓ and ↑ on the keypad to reach the setting you desire for that parameter. Press ENTER to finish.

Press ESC to return to the MAIN PROGRAM SCREEN.

NOTE: The appropriate user input terminals in the control box must be wired so they correspond to the assigned fault messages. If the order of the messages is changed or if other fault messages are assigned, the connections to the terminal strip must also be rearranged to reflect the changes.
FOLLOW THESE STEPS WITH THE OPTIONAL ETHERNET I/O CARD

HOW TO ENABLE OPTIONAL ETHERNET I/O CARD, AND HOW TO PROGRAM USER INPUTS 1-12 AND PLS OUTPUTS 1-4

To Enable Optional Ethernet I/O Card:

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.38. Enter the security code.

Use ↓ and ↑ on the keypad to scroll through the system setup screens. Press ENTER when the arrow symbol (>) is next to CONFIGURATION. The supervisor code screen will be displayed. See Figure 4.39. Enter the supervisor code. The configuration screens will be displayed. See Figures 4.40 through 4.43. Use ↓ and ↑ on the keypad to scroll between the configuration screens.

Press ENTER when the arrow symbol (>>) is next to ETHERNET IO ENABLE. Toggle between ↓ and ↑ on the keypad to choose ON or OFF. Choose ON and press ENTER to finish.

Press ESC twice to return to the MAIN PROGRAM SCREEN. Proceed to programming user inputs and PLS outputs on the next two pages.

Figure 4.38
Security Code Screen

```
ENTER SECURITY CODE

_ CODE
```

Figure 4.39
Supervisor Code Screen

```
ENTER SUPRVSR CODE

_ CODE
```

Figure 4.40
First Configuration Screen

```
>>Ethernet IO Enable
Encoder Enable
Home Off Time
LC Active On Up
```

Figure 4.41
Second Configuration Screen

```
>>Blk Valve SW Type
SC Valve Polarity
Auto Single Mode
Return Speed
```

Figure 4.42
Third Configuration Screen

```
>>Foot Trip
Finish STK On Mute
Blk Valve Monitor
Blk Valve On Up
```

Figure 4.43
Fourth Configuration Screen

```
>>Ethernet IO Enable
Encoder Enable
Home Off Time
LC Active On Up
```

(Continued on next page.)
SECTION 4—PROGRAMMING
RHPC Hydraulic Press Solid-State Control

FOLLOW THESE STEPS WITH THE OPTIONAL ETHERNET I/O CARD

To Program User Inputs 1-12:

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to INPUT/OUTPUT. The security code screen will be displayed. See Figure 4.44. Enter the security code.

Press ENTER when the arrow symbol (>) is next to USER INPUTS. The user inputs screens will be displayed. See Figures 4.45, through 4.47. Use ↓ and ↑ on the keypad to scroll between the user input screens.

Press ENTER when the arrow symbol (>) is next to the user input you want to program. The PROGRAMMABLE PARAMETERS SCREEN shown in Figure 4.48 will be displayed. Use ↓ and ↑ on the keypad to scroll through the programmable parameters. If EXTN RELAY MONITOR is turned on and/or AUTO SINGLE MODE is turned on, you will not be able to program user inputs #3 and #4 respectively.

Press ENTER when the double arrow symbol (>>) is next to the parameter you want to program. A screen similar to the one shown in Figure 4.49 will be displayed.

Once you are in the programming screen of the parameter you want to program, use ↓ and ↑ on the keypad to reach the setting you desire for that parameter. Press ENTER to finish.

Press ESC until you return to the MAIN PROGRAM SCREEN.

NOTE: The appropriate user input terminals in the control box must be wired so they correspond to the assigned fault messages. If the order of the messages is changed or if other fault messages are assigned, the connections to the terminal strip must also be rearranged to reflect the changes.

Figure 4.44
Security Code Screen

Figure 4.45
First User Inputs Screen

Figure 4.46
Second User Inputs Screen

Figure 4.47
Third User Inputs Screen

Figure 4.48
Programmable Parameters

Figure 4.49
Example of a Programming Screen

(Continued on next page.)
FOLLOW THESE STEPS WITH THE OPTIONAL ETHERNET I/O CARD (continued)

PLS Outputs

The RHPC press control provides four (4) PLS (programmable limit switch) outputs which are fused at 4 amp 120 VAC. These user programmable outputs can be used to sequence events during the press stroke.

The PLS outputs can be used for automatic operations such as lube mist, air blowoff, or feed initiation. Each output can be programmed to turn on or off on the downstroke, upstroke, or both. The PLS outputs can be programmed by time if you are using limit switches, or by position if you are using an encoder.

LIMIT SWITCH—To activate a PLS, you must tell the control when to turn the PLS on by setting a down delay in milliseconds. Next, you must tell the control how long to keep the PLS on by setting a down duration in milliseconds. To turn a PLS On or Off on the upstroke, you must set an up delay, up duration, and off delay.

ENCODER—To activate a PLS, you must tell the control when to turn the PLS on by setting a down on position. Next you must tell the control when to turn the PLS off by setting a down off position. To turn a PLS on or off for the upstroke, you must set an up on position and an up off position.

To turn a PLS On or Off during the downstroke and upstroke, choose PLS TYPE as down, up, or both. You can also choose to keep the PLS on or off when the press is stopped. This applies to limit switch use and encoder use.

To Program PLS Outputs 1-4:

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to INPUT/OUTPUT. The security code screen will be displayed. See Figure 4.50. Enter the security code.

Press ENTER when the arrow symbol (>) is next to PLS OUTPUTS. The PLS output screen will be displayed. See Figure 4.51.

Press ENTER when the arrow symbol (>) is next to the PLS output you want to program. The PROGRAMMABLE PARAMETERS SCREENS shown in Figures 4.52 and 4.53 will be displayed (time screens when using limit switches, or position screens when using an encoder). Use ↓ and ↑ on the keypad to scroll through the programmable parameters screens.

Press ENTER when the double arrow symbol (>>) is next to the parameter you want to program. Use ↓ and ↑ on the keypad to reach the setting you desire for that parameter, or use the keypad to enter a numeric setting. Press ENTER to finish.

Press ESC until you return to the MAIN PROGRAM SCREEN.
SYSTEM SETUP

The RHPC press control has system setup screens that are used to edit operating preferences and parameters.

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.54. Enter the security code.

After the correct security code has been entered, one of the SYSTEM SETUP SCREENS will be displayed. See Figures 4.54 through 4.57.

Use ↓ and ↑ on the keypad to scroll through the system setup screens. Press ENTER when the arrow symbol (>) is next to the setting to be programmed.

Figure 4.54
Security Code Screen

ENTER SECURITY CODE

CODE

Figure 4.55
First System Setup Screen

>Anti-Tie-Down
Security Code
Restore Defaults
Muting

Figure 4.56
Second System Setup Screen

>Auto Return
Decompress Timer
Blk Valve Dly ms
Spanish

Figure 4.57
Third System Setup Screen

>Configuration
Config Secure Code
ANTI-TIE-DOWN
When beginning a machine stroke, all actuating means [palm buttons or foot switch(es)] must be operated concurrently. This means that the operator(s) must depress all actuating means within the set time in order to start the machine stroke. As soon as any one of the actuating means is operated, the timer starts. The time for this setting depends on the number of operators. The range of 100-7000 ms allows enough time for single or multiple operators to operate all actuating means. The typical setting for one operator is 250 ms or 1/4 of a second (factory setting).

HOW TO PROGRAM ANTI-TIE-DOWN
Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.58. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to Anti-Tie-Down. The ANTI-TIE-DOWN SCREEN will be displayed. See Figure 4.59

Enter a number between 100-7000 ms for the desired time using the keypad. Press ENTER to confirm.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.
SECURITY CODE

The security code is user-programmable up to a 4-digit number which is required to edit certain control parameters that affect operation.

HOW TO PROGRAM THE SECURITY CODE

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.60. Enter the security code (factory default is ENTER or 0).

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to SECURITY CODE. The security code program screen will be displayed. See Figure 4.61.

Use the keypad to enter a new security code up to a 4-digit number. Press ENTER when finished.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.
FACTORY DEFAULT SETTING

The RHPC hydraulic control has factory default settings. The factory default settings can be restored in the Systems Setup screen. See pages 61-62 for the factory settings.

HOW TO RESTORE FACTORY DEFAULT SETTINGS

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.62. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to Restore Defaults. The RESTORE DEFAULTS SCREEN will be displayed. See Figure 4.63.

Press YES to confirm and the factory default settings will be restored.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.
MUTING
When muting is turned on, the control will ignore the light curtain inputs past the user-defined light curtain limit switch and on the upstroke.

HOW TO PROGRAM MUTING
Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.64. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to Muting. The MUTING SCREEN will be displayed. See Figure 4.65.

Use ↓ and ↑ on the keypad to reach the setting you desire. Press ENTER to finish.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.
AUTO RETURN

When auto return is enabled, the ram will automatically return to the top of the stroke once the light curtain has been broken or the operating means have been released.

HOW TO PROGRAM AUTO RETURN

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.66. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press **ENTER** when the arrow symbol (>) is next to Auto Return. The AUTO RETURN SCREEN will be displayed. See Figure 4.67.

Use ↓ and ↑ on the keypad to reach the setting you desire. Press **ENTER** to finish.

Press **ESC** when finished to return to the MAIN PROGRAM SCREEN.
DECOMPRESS TIMER

When the ram reaches the BOS (bottom of stroke) timing device, the down valve will de-energize causing the decompress timer (if programmed) to time out. Once the time runs out, the up valve will energize, returning the ram to the TOS (top of stroke) timing device. The range of time is between 50-250 ms.

HOW TO PROGRAM THE DECOMPRESS TIMER

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.68. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to Decompress Timer. The DECOMPRESS TIMER SCREEN will be displayed. See Figure 4.69.

Enter a number between 50-250 ms for the desired time using the keypad. Press ENTER to confirm.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.
SECTION 4—PROGRAMMING
RHPC Hydraulic Press Solid-State Control

BLOCK VALVE DELAY

When the ram reaches the BLk (block) valve timing device, the block valve will de-energize causing the timer (if programmed) to time out. Once the time runs out, the block valve will energize, returning hydraulic fluid back into the tank (0-500 ms).

HOW TO PROGRAM THE BLOCK VALVE DELAY

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.70. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to Blk Valve Dly ms. The BLK VALVE DLY SCREEN will be displayed. See Figure 4.71.

Enter a number between 0-500 ms for the desired time using the keypad. Press ENTER to confirm.

If a mistake is made, press BKSP to backspace, or press CLR to delete the entry and start over, or press ESC to stop and return to the programming screen.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.

Figure 4.70
Security Code Screen

ENTER SECURITY CODE

Figure 4.71
Blk Valve Delay Screen

PROGRAMMING

BLK Valve Dly Ms
0_Milliseconds
**SECTION 4—PROGRAMMING**

*RHPC Hydraulic Press Solid-State Control*

**SPANISH**

When this setting is turned on, the display of text will be in Spanish.

**HOW TO PROGRAM SPANISH TEXT DISPLAY**

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.72. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press **ENTER** when the arrow symbol (>) is next to Spanish. The SPANISH SCREEN will be displayed. See Figure 4.73.

Use ↓ and ↑ on the keypad to reach the setting you desire. Press **ENTER** to finish.

Press **ESC** when finished to return to the MAIN PROGRAM SCREEN.

---

**Figure 4.72**

**Security Code Screen**

<table>
<thead>
<tr>
<th>ENTER SECURITY CODE</th>
</tr>
</thead>
<tbody>
<tr>
<td>_ CODE</td>
</tr>
</tbody>
</table>

**Figure 4.73**

**Spanish Screen**

<table>
<thead>
<tr>
<th>PROGRAMMING</th>
</tr>
</thead>
<tbody>
<tr>
<td>Spanish OFF</td>
</tr>
</tbody>
</table>
SECTION 4—PROGRAMMING

RHPC Hydraulic Press Solid-State Control

CONFIGURATION

The configuration menu is for editing logic setting to the valves, relays, switches, and for safeguard functions. It is important not to change any settings unless advised by tech. support and with a supervisor’s permission. Wiring must reflect any changes to the programming otherwise injury and/or damage to the machine could occur.

CONFIGURATION MENU

BLK VALVE SW TYPE—This setting defines what logic the control will monitor the blocking valve switch. Choice of N.O. or N.C.

SC VALVE POLARITY—This setting defines what logic the control will monitor and energize the speed change if applicable. Choice of ON=Slow or OFF=Slow. If ON=Slow is selected, the press will energize the speed change output when the speed change input signal (P8-21) is supplied. If OFF=Slow is selected, the speed output will energize when the signal is removed from the input.

AUTO SINGLE MODE—When on, this setting will engage the ram when a signal is presented on the auto single input. The initial stroke requires a signal on the prior action input before the actuation means are depressed. Choice of ON or OFF.

RETURN SPEED—This setting allows selection of the speed at which the press will return to the top of stroke. Choice of LOW or HIGH speed.

FOOT TRIP—When on, this setting allows the press to be actuated by pressing and releasing a foot switch. Choice of ON or OFF.

FINISH STK ON MUTE—This setting mutes/disables the light curtains from stopping the press at the bottom of the stroke until the press reaches the top-of-stroke position. Choice of ON or OFF.

BLK VALVE MONITOR—When on, this setting allows the control to monitor the blocking valve (if applicable). Choice of ON or OFF.

BLK VALVE ON UP—When on, this setting allows block valve input (if applicable). Choice of ON or OFF.

PWR UP RET REQUEST—When on, this setting allows the press to be returned to the top of stroke if the ram is stopped anywhere other than at the top of the stroke (during power up only). Choice of ON or OFF.

LIGHT CURTAIN TYPE—This setting is directly related to the light curtain CH1 and CH2 wiring on the inputs. The selection made defines how the light curtain is monitored by the control. If the inputs are connected 1 normally open and 1 normally closed, select 1 N.O. & 1 N.C. If the inputs are connected 2 normally open relays, then select 2 N.O. Choice of 1 N.O. & 1 N.C or 2 N.O.

EXTN RELAY MONITOR—When on, this setting allows the control to monitor external relay contacts for the down outputs in case of a relay failure. Choice of ON or OFF.

SAFEGUARD FUNCTION—This selection allows the choice of when the light curtains are activated. When Always Required is selected, the light curtains will be activated except when the light curtain is muted. When Foot/Sing & Auto is selected, the light curtains will only be required for operation in the foot/single or automatic mode of operation except when the light curtain is muted. Choice of ALWAYS REQUIRED or FOOT/SING & AUTO.

ETHERNET IO ENABLE—When on, this setting will recognize the optional ethernet I/O card. This will allow eight (8) additional inputs plus four (4) PLS outputs. Choice of ON or OFF.

ENCODER ENABLE—When on, this setting tells the control to use an encoder for positioning. Choice of ON or OFF.

HOME OFF TIME—When the encoder is enabled (ON), this setting tells the control how long to come off of the home position limit switch when homing the press. This setting is programmable only with the encoder enabled. Choice of time in seconds.

LC ACTIVE ON UP—When on, this setting makes the light curtain active on the up stroke of the press regardless of muting. Choice of ON or OFF.

(Continued on next page.)
HOW TO EDIT THE CONFIGURATION SCREEN

Select the PROG position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press ENTER when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.74. Enter the security code (ENTER is the default setting).

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press ENTER when the arrow symbol (>) is next to CONFIGURATION. The supervisor code screen will be displayed. See Figure 4.75. Enter the supervisor code (1 is the default setting). Press ENTER.

Use ↓ and ↑ on the keypad to scroll up and down through the configuration menu choices described on page 55 and shown in Figures 4.76 through 4.79. Press ENTER when the double-arrow symbol (>>) is next to the configuration you want to change. Use ↓ and ↑ on the keypad to reach the setting you desire for each menu choice. Press ENTER to finish.

Press ESC when finished to return to the MAIN PROGRAM SCREEN.

Figure 4.74
Security Code Screen

ENTER SECURITY CODE

_      CODE

Figure 4.75
Supervisor Code Screen

ENTER SUPRVSR CODE

_      CODE

Figure 4.76
First Configuration Screen

>>BLK Valve SW Type
SC Valve Polarity
Auto Single Mode
Return Speed

Figure 4.77
Second Configuration Screen

>>Foot Trip
Finish STK On Mute
BLK Valve Monitor
BLK Valve On Up

Figure 4.78
Third Configuration Screen

>>Power Up RET Request
Light Curtain Type
EXTN Relay Monitor
Safeguard Function

Figure 4.79
Third Configuration Screen

>>Ethernet IO Enable
Encoder Enable
Home Off Time
LC Active On Up
CONFIRM SECURE CODE

This is the **supervisor code** which is required to edit certain control parameters that affect operation. The supervisor code is user-programmable up to a 4-digit number.

**HOW TO PROGRAM THE CONFIGURE SECURE CODE SCREEN**

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to SYSTEM SETUP. The security code screen will be displayed. See Figure 4.80. Enter the security code.

After the correct security code has been entered, the SYSTEM SETUP SCREEN will be displayed. Use ↓ and ↑ on the keypad to scroll up and down. Press **ENTER** when the arrow symbol (> ) is next to CONFIG SECURE CODE. The supervisor code screen will be displayed. See Figure 4.81. Enter the supervisor code (1 is the default setting). Press **ENTER**. The CONFIG SECURE CODE SCREEN will be displayed. See Figure 4.82.

Use the keypad to enter a new secure code up to a 4-digit number. Press **ENTER** when finished.

If a mistake is made, press **BKSP** to backspace, or press **CLR** to delete the entry and start over, or press **ESC** to stop and return to the programming screen.

Press **ESC** when finished to return to the MAIN PROGRAM SCREEN.
SECTION 4—PROGRAMMING

RHPC Hydraulic Press Solid-State Control

SIGNAL TIMER

This setting defines the amount of time the auto-single input will wait for its next signal before it times out and requires an operator action to restart from a range of 0-300 seconds.

HOW TO PROGRAM THE SIGNAL TIMER

Select the **PROG** position of the Off/Prog/Run selector switch. One of the MAIN PROGRAM SCREENS will be displayed.

On the MAIN PROGRAM SCREEN, use ↓ and ↑ on the keypad to scroll through the program options. Press **ENTER** when the pound symbol (#) is next to SIGNAL TIMER. The security code screen will be displayed. See Figure 4.83. Enter the security code.

After the correct security code has been entered, the SIGNAL TIMER SCREEN will be displayed. See Figure 4.84.

Use the keypad to enter the desired number of seconds up to 300. Press **ENTER** to finish and the MAIN PROGRAM SCREEN is displayed.

If a mistake is made, press **BKSP** to backspace, or press **CLR** to delete the entry and start over, or press **ESC** to stop and return to the MAIN PROGRAM SCREEN.
### QUICK REFERENCE TABLE—FACTORY SETTINGS AND VALID RANGES

<table>
<thead>
<tr>
<th>SCREEN</th>
<th>PROGRAM SETTING</th>
<th>VALID ENTRY RANGE</th>
<th>FACTORY DEFAULT SETTING</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Press Settings</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Bottom Dwell</td>
<td>0-600 seconds</td>
<td>Bottom Dwell</td>
<td>0 seconds</td>
</tr>
<tr>
<td>PSI or Position</td>
<td>Pressure or Position</td>
<td>PSI or Position</td>
<td>Position</td>
</tr>
<tr>
<td>TOS Position</td>
<td>0-30 inches</td>
<td>TOS Position</td>
<td>1.0 inch</td>
</tr>
<tr>
<td>BOS Position</td>
<td>0-30 inches</td>
<td>BOS Position</td>
<td>4.0 inches</td>
</tr>
<tr>
<td>Speed Change Position</td>
<td>0-30 inches</td>
<td>Speed Change Position</td>
<td>3.0 inches</td>
</tr>
<tr>
<td>Mute Position</td>
<td>0-30 inches</td>
<td>Mute Position</td>
<td>3.0 inches</td>
</tr>
<tr>
<td>Down Low Speed Coast</td>
<td>0-1 inch</td>
<td>Down Low Speed Coast</td>
<td>0.0 inches</td>
</tr>
<tr>
<td>Down High Speed Coast</td>
<td>0-1 inch</td>
<td>Down High Speed Coast</td>
<td>0.0 inches</td>
</tr>
<tr>
<td>Up Low Speed Coast</td>
<td>0-1 inch</td>
<td>Up Low Speed Coast</td>
<td>.780 inches</td>
</tr>
<tr>
<td>Up High Speed Coast</td>
<td>0-1 inch</td>
<td>Up High Speed Coast</td>
<td>.900 inches</td>
</tr>
<tr>
<td><strong>Counters</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Batch Clear</td>
<td>Yes or No</td>
<td>Batch Clear</td>
<td>N/A</td>
</tr>
<tr>
<td>Batch Preset</td>
<td>0-9,999,999 strokes</td>
<td>Batch Preset</td>
<td>0 strokes</td>
</tr>
<tr>
<td>Total Clear</td>
<td>Yes or No</td>
<td>Total Clear</td>
<td>N/A</td>
</tr>
<tr>
<td><strong>Input/Output (Eithout Ethernet Option)</strong></td>
<td>Logic</td>
<td>Off, N.O., or N.C.</td>
<td>Logic</td>
</tr>
<tr>
<td>User Inputs 1-9</td>
<td>Stop Type</td>
<td>E-Stop r Top Stop</td>
<td>Stop Type</td>
</tr>
<tr>
<td>User Inputs 1-9</td>
<td>Message</td>
<td>See list of user messages (p.43)</td>
<td>Message</td>
</tr>
<tr>
<td><strong>Input/Output (With Ethernet Option)</strong></td>
<td>Logic</td>
<td>Off, N.O., or N.C.</td>
<td>Logic</td>
</tr>
<tr>
<td>User Inputs 1-9</td>
<td>Stop Type</td>
<td>E-Stop r Top Stop</td>
<td>Stop Type</td>
</tr>
<tr>
<td>User Inputs 1-9</td>
<td>Message</td>
<td>See list of user messages (p.43)</td>
<td>Message</td>
</tr>
<tr>
<td><strong>Input/Output (With Ethernet Option)</strong></td>
<td>Logic</td>
<td>Off, N.O., or N.C.</td>
<td>Logic</td>
</tr>
<tr>
<td>User Input #10 Part in Place</td>
<td>Logic</td>
<td>Off, N.O., or N.C.</td>
<td>Logic</td>
</tr>
<tr>
<td>User Input #11 &amp; 12 Part in Place</td>
<td>Logic</td>
<td>On or Off</td>
<td>Logic</td>
</tr>
<tr>
<td><strong>PLS Outputs 1-4 Using Limit Switches</strong></td>
<td>PLS Type</td>
<td>Down, Up or Both</td>
<td>PLS Type</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Limit Switches</td>
<td>Down Delay</td>
<td>0-60 seconds</td>
<td>Down Delay</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Limit Switches</td>
<td>Down Duration</td>
<td>0-60 seconds</td>
<td>Down Duration</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Limit Switches</td>
<td>Up Delay</td>
<td>0-60 seconds</td>
<td>Up Delay</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Limit Switches</td>
<td>Up Duration</td>
<td>0-60 seconds</td>
<td>Up Duration</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Limit Switches</td>
<td>Off if Stopped</td>
<td>Yes or No</td>
<td>Off if Stopped</td>
</tr>
<tr>
<td><strong>PLS Outputs 1-4 Using Encoder</strong></td>
<td>PLS Type</td>
<td>Down, Up or Both</td>
<td>PLS Type</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Encoder</td>
<td>Down On Position</td>
<td>0-30 inches</td>
<td>Down On Position</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Encoder</td>
<td>Down Off Position</td>
<td>0-30 inches</td>
<td>Down Off Position</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Encoder</td>
<td>Up On Position</td>
<td>0-30 inches</td>
<td>Up On Position</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Encoder</td>
<td>Up Off Position</td>
<td>0-30 inches</td>
<td>Up Off Position</td>
</tr>
<tr>
<td>PLS Outputs 1-4 Using Encoder</td>
<td>Off if Stopped</td>
<td>Yes or No</td>
<td>Off if Stopped</td>
</tr>
</tbody>
</table>

**NOTE:** If external relay monitoring is turned on, you will not be able to make programming changes to Input #3.
If auto single is turned on, you will not be able to make programming changes to Input #4.
### Quick Reference Table—Factory Settings and Valid Ranges (Continued)

<table>
<thead>
<tr>
<th>Screen</th>
<th>Program Setting</th>
<th>Valid Entry Range</th>
<th>Factory Default Setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>System Setup</td>
<td>Security Code</td>
<td>User Programmed up to a 4-digit #</td>
<td>Anti-Tie-Down</td>
</tr>
<tr>
<td></td>
<td>Factory Default</td>
<td>Restore: Yes or No</td>
<td>Factory Default: N/A</td>
</tr>
<tr>
<td></td>
<td>Muting</td>
<td>On or Off</td>
<td>Muting: Off</td>
</tr>
<tr>
<td></td>
<td>Auto Return</td>
<td>On or Off</td>
<td>Auto Return: Off</td>
</tr>
<tr>
<td></td>
<td>Decompress Timer</td>
<td>50-250 ms</td>
<td>Decompress Timer: 100 ms</td>
</tr>
<tr>
<td></td>
<td>Block Valve Delay</td>
<td>0-500 ms</td>
<td>Block Valve Delay: 0 ms</td>
</tr>
<tr>
<td></td>
<td>Spanish</td>
<td>On or Off</td>
<td>Spanish: Off</td>
</tr>
<tr>
<td>Configuration</td>
<td>Block Valve Switch Type</td>
<td>N.O. or N.C.</td>
<td>Block Valve Switch Type: N.O.</td>
</tr>
<tr>
<td></td>
<td>Speed Change Valve Polarity</td>
<td>On = Slow or Off = Slow</td>
<td>Speed Change Valve Polarity: On = Slow</td>
</tr>
<tr>
<td></td>
<td>Automatic Single Mode</td>
<td>On or Off</td>
<td>Automatic Single Mode: Off</td>
</tr>
<tr>
<td></td>
<td>Return Speed</td>
<td>Low, High or Speed Selector</td>
<td>Return Speed: Low Speed</td>
</tr>
<tr>
<td></td>
<td>Foot Trip</td>
<td>On or Off</td>
<td>Foot Trip: Off</td>
</tr>
<tr>
<td></td>
<td>Finish Stroke On Mute</td>
<td>On or Off</td>
<td>Finish Stroke On Mute: Off</td>
</tr>
<tr>
<td></td>
<td>Block Valve Monitor</td>
<td>On or Off</td>
<td>Block Valve Monitor: On</td>
</tr>
<tr>
<td></td>
<td>Block Valve On Up</td>
<td>On or Off</td>
<td>Block Valve On Up: Off</td>
</tr>
<tr>
<td></td>
<td>Power-Up Return Request</td>
<td>On or Off</td>
<td>Power-Up Return Request: Off</td>
</tr>
<tr>
<td></td>
<td>Light Curtain Type</td>
<td>2 N.O. or 1 N.O. and 1 N.C.</td>
<td>Light Curtain Type: 2 N.O.</td>
</tr>
<tr>
<td></td>
<td>External Relay Monitor</td>
<td>On or Off</td>
<td>External Relay Monitor: On</td>
</tr>
<tr>
<td></td>
<td>Safeguard Function</td>
<td>Always Required to Foot/Sing. &amp; Cont.</td>
<td>Safeguard Function: Always Required</td>
</tr>
<tr>
<td></td>
<td>Ethernet I/O Enable</td>
<td>On or Off</td>
<td>Ethernet I/O Enable: Off</td>
</tr>
<tr>
<td></td>
<td>Encoder Enable</td>
<td>On or Off</td>
<td>Encoder Enable: Off</td>
</tr>
<tr>
<td></td>
<td>Home Off Time</td>
<td>0-2 seconds</td>
<td>Home Off Time: 1.0 second</td>
</tr>
<tr>
<td></td>
<td>Light Curtain Active On Up</td>
<td>On or Off</td>
<td>Light Curtain Active On Up: On</td>
</tr>
<tr>
<td></td>
<td>Configure Secure Code</td>
<td>User Programmed up to a 4-digit #</td>
<td>Configure Secure Code: 1</td>
</tr>
<tr>
<td></td>
<td>Signal Timer</td>
<td>0-300 seconds</td>
<td>Signal Timer: 5.0 seconds</td>
</tr>
</tbody>
</table>
Troubleshooting

All troubleshooting, as well as installation, must be performed by qualified and properly trained personnel. Also, when a defective component is found, do not operate the machine until that component has been replaced with an exact replacement part.

1. This procedure is written as a general guide for troubleshooting most hydraulic control systems. In all cases, please refer to the individual control wiring schematic for particular test points and terminal numbers.

2. Each control system may be slightly different depending on the various functions provided. Be sure to follow the schematic and select the proper modes of operation when troubleshooting.

ABBREVIATIONS

SW—Switch
N.O.—Normally Open
N.C.—Normally Closed
L.S.—Limit Switch
TOS—Top of Stroke
BOS—Bottom of Stroke
FLT—Fault
LC—Light Curtain
SEQ Stop—Sequence Stop

FAULTS

The control will alert you with a message either when a circuit failure has occurred, unsafe conditions are detected, or when certain logical conditions are not met. These messages are categorized three ways; Warning, User Input, and Fatal.

WARNING FAULTS
These faults generally occur when a setup is wrong or a certain condition has changed. These faults can be cleared by pressing ESC (escape).

NO INTERLOCKS
This message is displayed when the control is in the Continuous/Foot operation mode or when the Always Required setting is selected in the safeguard function. In either condition, a safety device is required to satisfy the inputs and operate the press.

USER INPUTS
These messages display when certain logical conditions are not met. User inputs are monitored N.O. or N.C. Selecting the wrong condition or a change in condition will display the error message selected for that user input. These messages can be cleared by pressing ESC. See page 27 for a list of user input fault messages.
SECTION 5—TROUBLESHOOTING
RHPC Hydraulic Press Solid-State Control

FAULTS (continued)

FATAL FAULTS
When these are displayed, further troubleshooting and/or technical support is usually required. These messages may require an E-stop or power disconnection to clear them.

CPU#2 Fault—Possible circuit failure with CPU#2 or K2 relay. If fault persists after replacing the K2 relay, there may be a CPU or circuit failure. Contact the factory for technical support.

K1 FAILED SAFE TEST—K1 failed to operate upon initial startup. Remove and inspect relays for signs of damage. If fault persists after replacing relay, contact the factory for technical support.

K2 FAILED SAFE TEST—K2 failed to operate upon initial startup. Remove and inspect relays for signs of damage. If fault persists after replacing relay, contact the factory for technical support.

K1 OFF FAULT—Possible component failure or K1 Relay fault. Remove and inspect relay for signs of damage. If fault persists after replacing relay, contact the factory for technical support.

K1 On FAULT—Possible K1 Relay fault or no source voltage. Check the input voltage on the control and inspect relay for signs of damage. If fault persists after replacing relay, contact the factory for technical support.

K2 OFF FAULT—Possible component failure or K2 Relay fault. Remove and inspect relay for signs of damage. If fault persists after replacing relay, contact the factory for technical support.

K2 ON FAULT—Possible K2 Relay fault or no source voltage. Check the input voltage on the control and inspect relay for signs of damage. If fault persists after replacing relay, contact the factory for technical support.

CPU 2 Failed test—Possible CPU#2 fault. Disconnect power and remove battery from circuit board and wait 10 minutes. If fault persists possible CPU#2 fault. Contact the factory for technical support.
SECTION 5—TROUBLESHOOTING

RHPC Hydraulic Press Solid-State Control

FAUL TS (continued)

LIMIT SWITCH FAULTS

If you are experiencing any of the faults below, it is important not to jump into the software and change logic settings unless you are told to do so or are confident it will fix your problem. The settings programmed into your control are factory default and are set to work with the drawing provided. The basic setup to function your press is as follows: TOS = N.C. and BOS = N.O. Other variables such as sequence stop, muting, and speed change are factory designed to be N.O. Always be careful and remember what settings you change—a wrong setting could cause a fault message to display that masks the root problem. Another consideration is that if the TOS or BOS limits are not correctly set, the press will not display a message or may display the wrong message.

SEQ STOP SW ON FLT (Sequence Stop Switch On Fault)—The control has monitored that the sequence stop limit switch isn’t coming on or changing state. If the fault persists, confirm the logical wiring and that the correct logic is selected in the setup. To change logic settings, refer to pages 39-40 for information on configuration programming.

SEQ STOP SW off FLT (Sequence Stop Switch Off Fault)—The control has monitored that the sequence stop limit switch isn’t turning off or the wrong logical state is detected. Confirm that the limit switch isn’t being depressed during the whole stroke. Inspect wiring for any possible shorts and reconfirm its logic. Set the software to the correct logic. To change logic settings, refer to pages 39-40 for information on configuration programming.

Mute SW ON FLT (Mute Switch On Fault)—The control has monitored that the mute limit switch isn’t coming on or changing its logical state. If the fault persists, confirm the logical wiring and that the correct logic is selected in the setup. To change logic settings, refer to pages 39-40 for information on configuration programming.

MUTE SW OFF FLT (Mute Switch Off Fault)—The control has monitored that the mute limit switch is not turning off or is monitoring the wrong logic in the circuit. Observe the limit switch to confirm it’s not being depressed during the whole stroke. If the fault persists, confirm the logical wiring and that the correct logic is selected in the setup. To change logic settings, refer to pages 39-40 for information on configuration programming.
SECTION 6—MAINTENANCE AND INSPECTION
RHPC Hydraulic Press Solid-State Control

This control system can never cure nor overcome a misadjusted, worn, broken or malfunctioning part or mechanical failure. Inspect all parts for adjustment, excessive wear, looseness or breakage. Do not operate this machine until all parts are adjusted, repaired or replaced.

Visual inspections and examinations of the entire machine must be made at least once per shift by qualified personnel.

Machines must always be inspected and tested on a weekly basis to determine the condition of the mechanical, hydraulic, and electrical system. Necessary maintenance and repair must be done before the machine is operated again, and the employer must maintain records of both the inspections and the maintenance work performed.

After any maintenance, always operate the machine numerous times in all modes before allowing the operator to start production. Always make sure all point-of-operation safeguarding is in place, adjusted and operating properly for the job and the operator.

ANSI Regulations for Inspections
ANSI B11.2 - 1995 Inspection and Maintenance

7.3 The employer shall have the responsibility to establish and follow a systematic program of periodic and regular inspection of production systems utilizing presses to ensure that all their parts, auxiliary equipment, and safeguarding are in safe operating condition and adjustment.

E7.3 The employer should consider the manufacturer’s instructions and recommendations in determining maintenance programs.

The employer should determine the period between inspections based on their use and the manufacturer’s recommendations.

ANSI Regulations for Operator Training
ANSI B11.2 - 1995 Instructions to Operators

10.2 The employer shall instruct operators in the proper care and use of the press production system.

E10.2 The instructions should include but not be limited to:

1. A description of the assigned task;
2. The function of controls to be encountered in performing the assigned task;
3. The hazards associated with the assigned task;
4. The designated method of feeding;
5. The designated method of safeguarding;
6. The methods of function-testing or otherwise assuring the proper function of safeguarding means.

Operators should be instructed to report inconsistent or unpredictable performance of the press production system.

Electrical Controls

Switch the main power disconnect to the “Off” position and lockout before inspecting or maintaining electrical controls. Make a periodic inspection of the control box and electrical machine components for loose or broken wires. Relays and switches must be examined for burned or worn contacts. Look for loose or broken conduit and cable fittings. The control box and other components must be kept closed and locked. Keys must be removed to prevent someone from opening and tampering with the control box, and to prevent exposure to the dirt, chips and oil present in most plants.
OSHA 1910.217 Section (c) under General Requirements states:

(i) It shall be the responsibility of the employer to provide and insure the usage of “point-of-operation guards” or properly applied and adjusted point-of-operation devices on every operation performed on a mechanical power press.

This means that for every mechanical power press that is being used in United States industry, there must be protection for the operator by a guard or a device (safeguard). This protection may also be accomplished by the use of a combination of guards and devices.

When updating a power press, the most important decision is the selection of the proper guard or device. The following are methods of safeguarding part revolution power presses.

**Barrier Guards on Power Presses**

OSHA 1910.217 Section (c), General Requirements, (c)(2) Point of Operation Guards and Table 0-10

(Ref. enclosed MPPS, pages 19 - 20)

**Light Curtain Presence Sensing Devices on Power Presses**

Light Curtain or Radio Frequency

OSHA 1910.217 Section (c)(3)(iii)(a)

Presence Sensing (Ref. enclosed MPPS, pages 16 - 17)

**Two-Hand Control on Power Presses**

OSHA 1910.217 Section (c)(3)(vii) Two-Hand Control (Ref. MPPS, pages 15 and 16)

**Pullback (Pull-out) on Power Presses**

OSHA 1910.217 Section (c)(3)(iv)(b) Pull-out

(Ref. MPPS, page 18)
SECTION 7—METHODS OF SAFEGUARDING MACHINES

RHPC Hydraulic Press Solid-State Control

Restraint (Holdout) on Power Presses

OSHA 1910.217 Section (c)(3)(vi)
Restraint or Holdout
(Ref. MPPS, page 18)

Type “A” or “B” Gate on Power Presses

OSHA 1910.217 Section (c)(3)(ii)(c)
Gate or Movable Barrier Device
(Ref. MPPS, page 18)

Auxiliary Safeguarding on Power Presses

Auxiliary safeguarding is additional protection from injuries for all personnel in the machine area. It is used in conjunction with primary safeguarding devices. Auxiliary safeguarding also involves the guarding of other components or hazardous openings on machines.

Auxiliary safeguards include such items as point-of-operation side end barriers when light curtains are used, pressure sensitive floor mats, workpiece tables or horizontal light curtains. Light curtains can be used horizontally to prevent an operator or other persons from standing between the vertical plane of light and the point-of-operation hazard.

Danger signs, used for warning, can be mounted on the machine in a position that is readily visible to the operator, setup person or other personnel. Hand tools can be used as auxiliary safeguarding. They are often used when feeding and retrieving small pieceparts. Hand tools themselves are NOT a point-of-operation safeguarding device.

OSHA 1910.217 Section (c) (Ref. MPPS, page 13)
(4) Hand feeding tools. Hand feeding tools are intended for placing and removing material in and from the press. Hand feeding tools are not a point-of-operation guard or protection device and shall not be used in lieu of the guards or devices required.

Other Safety Considerations

Other areas of machine safety must be considered in order to comply to the OSHA Regulations and ANSI Standards as we know them. This includes, but is not limited to, items such as a main power disconnect switch, which must be provided for each machine, and a magnetic type motor starter for the main drive motor and slide adjust motor. Mechanical power-transmission apparatus of the machine, such as rotating flywheels, gears, sprockets, chains, and shafts, must be covered in accordance with OSHA 1910.219. As with all machinery, best safety practices must be a continuing program. The operator, die setter and all personnel must be fully trained and instructed on all safety procedures and have full knowledge of the safeguarding device being used.


When using the devices described, for point-of-operation protection, sides and rear of hazardous area must be guarded to protect the operator and other employees in the machine area (OSHA Section 1910.212).
### SECTION 8—RETURN MATERIALS AUTHORIZATION FORM

**RHPC Hydraulic Press Solid-State Control**

To return material for any reason contact the sales department in our organization at 1-800-922-7533 for an R.M.A. Number. All returned materials shipments must be prepaid. Complete this form and send with material to 5795 Logistics Parkway, Rockford, IL 61109. Make sure the R.M.A. Number is plainly identified on the outside of the shipping container.

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**Items Authorized To Return on R.M.A. No.**

Original Invoice No. __________ Date __________

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**Service Requested**

[ ] Full Credit

[ ] 25% Restocking

[ ] Repair & Return

[ ] Warranty Replacement

Reason for return (describe in detail):

________________________________________________________________________

________________________________________________________________________

________________________________________________________________________

________________________________________________________________________

________________________________________________________________________

Return Materials Authorized by ____________________________ Date __________
This instruction manual references signs and literature available for your machines. This order form is for your convenience to order additional signs and/or literature as needed. (This order form is part of your installation manual so please make a copy of it when ordering.)

Company ____________________________________________

Address ______________________________________________________________________________________

Cty ___________________________ State ___________________________ Zip ___________________________

Phone __________________________________________________________________________________________

Fax _____________________________________________________________________________________________

Name __________________________________________________________________________________________

Purchase Order No. _____________ Date __________________________

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For prices and delivery, please use address, phone or fax number listed on the front cover of this manual.

Your Signature ____________________________________________ Date __________________________

KSL2790119