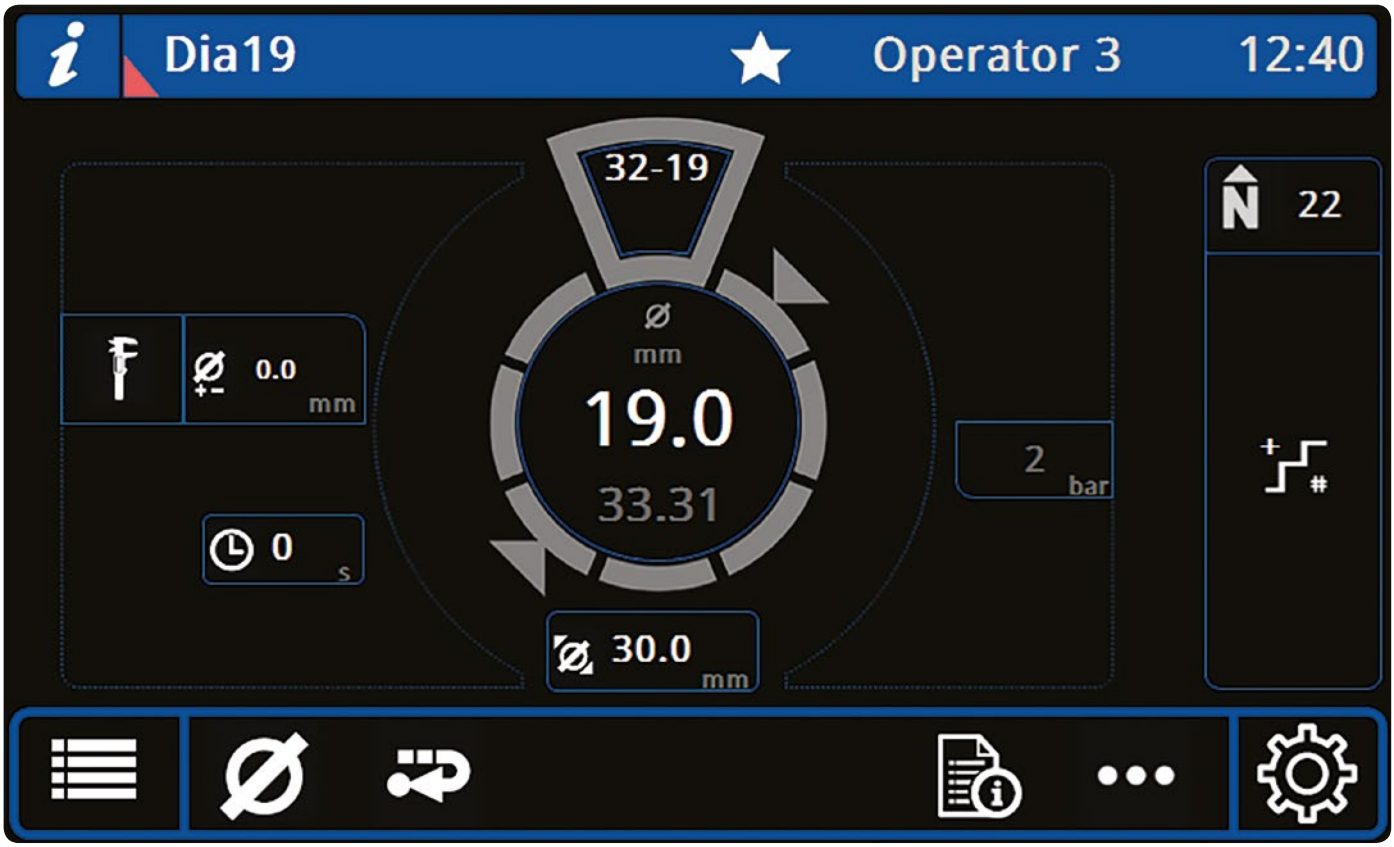
Lillbacka | Powerco FINN•POWER Crimping since 1973

FINN-POWER
ICC CONTROL

OPERATING INSTRUCTIONS

Released 6/2017



Copyright 2017 by Lillbacka Powerco Ltd. All rights reserved.

Keep this manual for future needs.

No part of this documentation may be reproduced, copied or transmitted in any form, or by any electronic, digital or other means, without permission in writing from Lillbacka Powerco Ltd. (referred to herein as the "Company"). This includes photocopying and information storage and retrieval systems. The material in this documentation is subject to change without notice.

PLEASE READ THESE TERMS AND CONDITIONS CAREFULLY BEFORE USING THE SOFTWARE INCLUDED WITH THE EQUIPMENT. BY USING THE SOFTWARE ACCOMPANYING THE EQUIPMENT YOU AGREE TO BE BOUND BY THE TERMS AND CONDITIONS OF THIS LICENSE.

All software furnished with the equipment is on a licensed basis. The Company grants to the user a non-transferable and non-exclusive license to use such software in object code only and solely in connection with the use of the equipment. Such license may not be assigned, sublicensed, or otherwise transferred by the user apart from the equipment. No right to copy a licensed program in whole or in part is granted. Title to the software and documentation shall remain with the Company. The user shall not modify, merge, or incorporate any form or portion of a licensed program with other program material, create a derivative work from a licensed program, or use a licensed program in a network. The user agrees to maintain the Company's copyright notice on the licensed programs delivered with the equipment. The user agrees not to decompile, disassemble, decode, or reverse engineer any licensed program delivered with the equipment, or any portion thereof.

LIMITED WARRANTY: The Company warrants only that the software will perform in accordance with the documentation accompanying the equipment during the equipment warranty period. The Company does not warrant that the software is error free. The user's exclusive remedy and the Company's sole liability for defects in the software as to which the Company is notified during the equipment warranty period is to repair or replace the software at the Company's option. This limited warranty does not apply if the software has been altered, the user has failed to operate the software in accordance with this documentation, or the software has been subject to abnormal physical or electrical stress, misuse, negligence or accident.

EXCEPT FOR THE EXPRESS WARRANTY SET FORTH ABOVE, THE SOFTWARE IS PROVIDED "AS IS" WITH ALL FAULTS. THE COMPANY DISCLAIMS ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING, WITHOUT LIMITATION, THOSE OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE AND NONINFRINGEMENT OR ARISING FROM A COURSE OF DEALING, USAGE, OR TRADE PRACTICE.

IN NO EVENT SHALL THE COMPANY BE LIABLE FOR ANY INDIRECT, SPECIAL, CONSEQUENTIAL, OR INCIDENTAL DAMAGES, INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR LOSS OR DAMAGE TO DATA ARISING OUT OF THE USE OR INABILITY TO USE THE EQUIPMENT, THE SOFTWARE OR ANY PART OF THIS DOCUMENTATION, EVEN IF THE COMPANY HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

CONTENTS

1. INTRODUCTION 5

GENERAL 5
FEATURES 5
WARNINGS 5

2. DRIVE PAGE IDENTIFICATIONS 6

3. OPTIONS IDENTIFICATION 7

GENERAL SCREENS AND BUTTONS 7

4. DETAILED GUIDE 10

RECIPES / SAVE RECIPE 10
MANAGE RECIPES 10
TIP – MANAGE JOB QUEUE 11
SETPOINT, TOTAL OPENING, MASTER DIE POSITION 12
DIAMETER CRIMPING / SEMI-AUTO / MANUAL / AUX DEVICE 12
DIE SET SELECT 13
DIE SET CHANGE WIZARD 14
CORRECTION / OFFSET 15
PIECE COUNTER 15
CRIMPING DELAY 15
JOB INFORMATION 16
SETTINGS BAR 16
CALIBRATION 17
TOOL SETTINGS 17
MOTOR RUN DELAY 17
SPEED CONTROL 18
DIE SET LIST 18
MINIMAL CRIMPING DIAMETER 18
MINIMAL MASTER DIE DIAMETER 18
MAXIMAL CRIMPING DIAMETER 18
MAXIMAL MASTER DIE DIAMETER 18
STATISTICS 19
USB FILE HANDLER 19
SET TIME & DATE 20
MACHINE INFO 21
USER HANDLER / LOG IN AS USER 22
MANAGE USERS 23
OPTION PACKAGES 26

5. OPTIONS 26

STEP CRIMPING (ICC2) 27
QUALITY CONTROL (ICC3) 28
AUTOMATIC CORRECTION 29
COUNTING MODE AND BAD RESULT REACTION (INCL. ICC3) 29
GRAPHICAL QUALITY CONTROL (ICC4) 30
FUNCTIONS (OPTIONS) 31
SPEED CONTROL 31
SYMBOLS 32

1. INTRODUCTION

This manual familiarizes the reader with the features and operation of the Finn-Power ICC control unit. Read the following instructions thoroughly prior to operating, installing or servicing the crimping machine. Familiarity with the operating instructions speeds up commissioning and effective utilization of the equipment.

The digital Finn-Power ICC control unit has been designed for crimping machines, utilizing modern processor technology and the possibilities provided by graphic user interface. ICC control is an intelligent control unit with a graphic display allowing the operator to control the crimping machine and utilize several miscellaneous functions. It also enables versatile fault diagnostics during the operation.

GENERAL

The crimping machine is delivered with default setups, including setups for calibration and motor stand-by time. Purchased options are installed and initialized already in a factory, although it's also possible to purchase and install options afterwards. Get to know to the machines operating and service instructions to get all the benefits out of the machine and its features. With right usage you will not only longer machines working capacity but also working life.

FEATURES

STANDARD FEATURES

- Crimping by the diameter
- Retraction
- Correction
- Crimping delay
- USB-connection
- FTP sever
- Manual / automatic mode
- Tool Change Wizard
- Recipe memory, job queue
- Ascending / descending counters
- Pressure displayed
- Die position displayed
- User management
- Energy saving mode (motor running time)
- Units; mm or inch
- Automatic brightness control

EXTENSIONS

- Pressure crimping. Crimping movement stops when the pressure or diameter limit is reached.
- Multi-step crimping. Crimping process is performed by steps. Crimping movement stops when the desired diameter or pressure limit is reached. The amount of the steps, the diameter and the pressure can be adjusted.
- Online quality monitoring, for controlling and reporting the crimping parameters. Alerts to the failure crimps. For more information see also the operating instructions for the crimping machine.

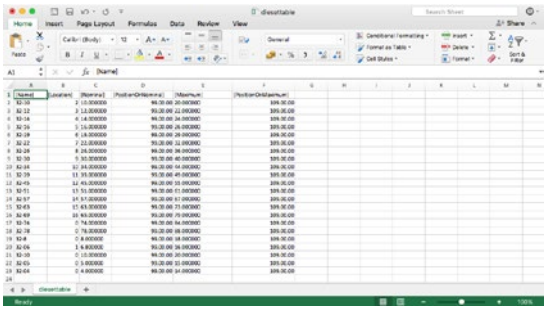
WARNINGS

When crimping sensitive materials the crimped part may brake and burst out from the machine. Make the first crimp very carefully and protect yourself and others near the machine! It is important to follow these instructions. Read also the operating instructions for the crimping machine, especially chapter *"Warnings"*.

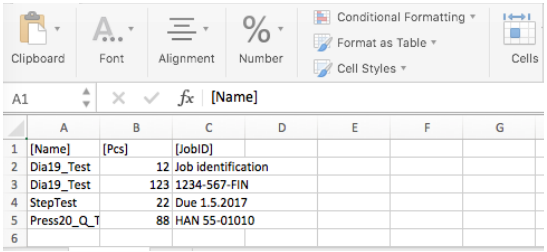
CSV-FILES

Finnpower crimping machines uses csv-files to share all important information during crimping. They also help you to manage crimping settings by allowing you to bring/save recipes, job queues and dieset presets. You can upload csv-files to machines via USB or FTP-server.

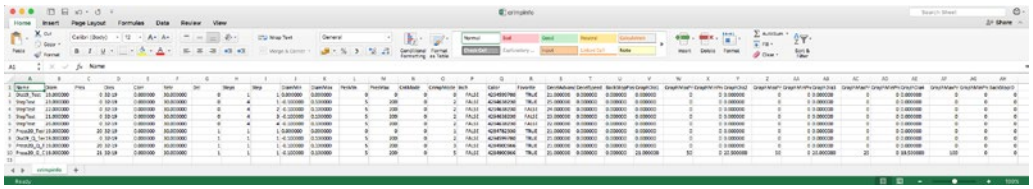
diesettable.csv
Includes all available die sets. Here you find also nominal diameters for diesets, master die positions and dieset maximum crimps.



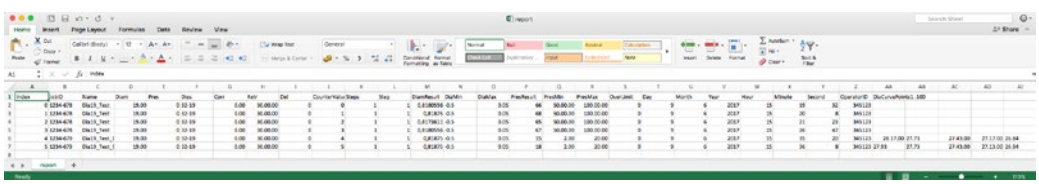
jobs.csv
Here you find job queue. Jobs are listed with recipe name, pieces to made and job identification.



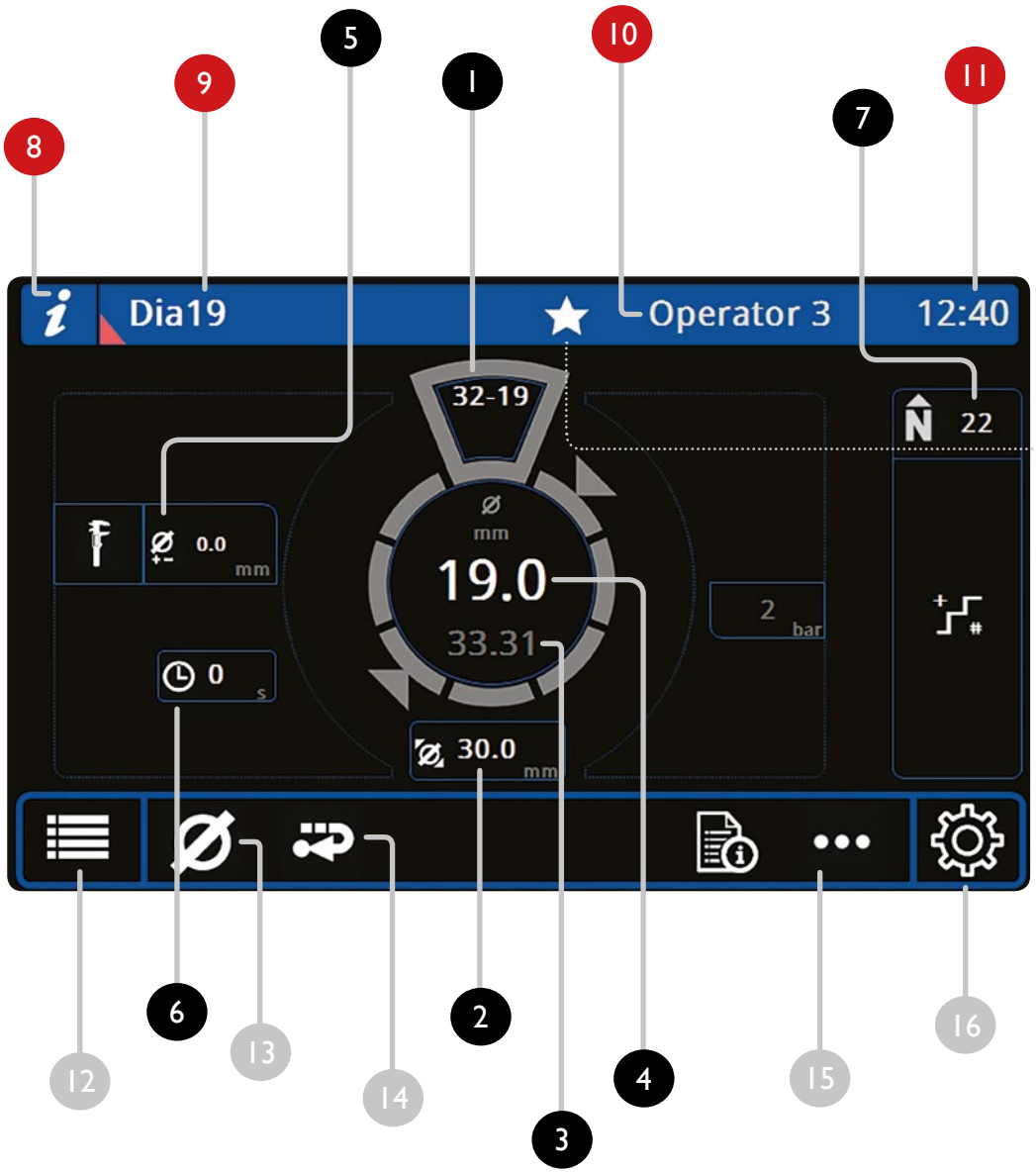
crimpinfo.csv
Gives you all available information of recipes; for examble minimum and maximum limits and setspoints for diameter tolerance and pressure, current steps and step counts, retractions and corrections.
Here you can also find multiple diameter points and max and min values of pressure for ICC4 option.



report.csv
Includes crimping parameters from ICC3 and ICC4. Report.csv gathers 10 000 lines of parameters together and afterward, saves itself for current date (for example report_20170614.csv) and starts with a new file. It is recommended to upload files after every 10 000 - 100 000 crimps or once a year.



2. DRIVE PAGE IDENTIFICATIONS

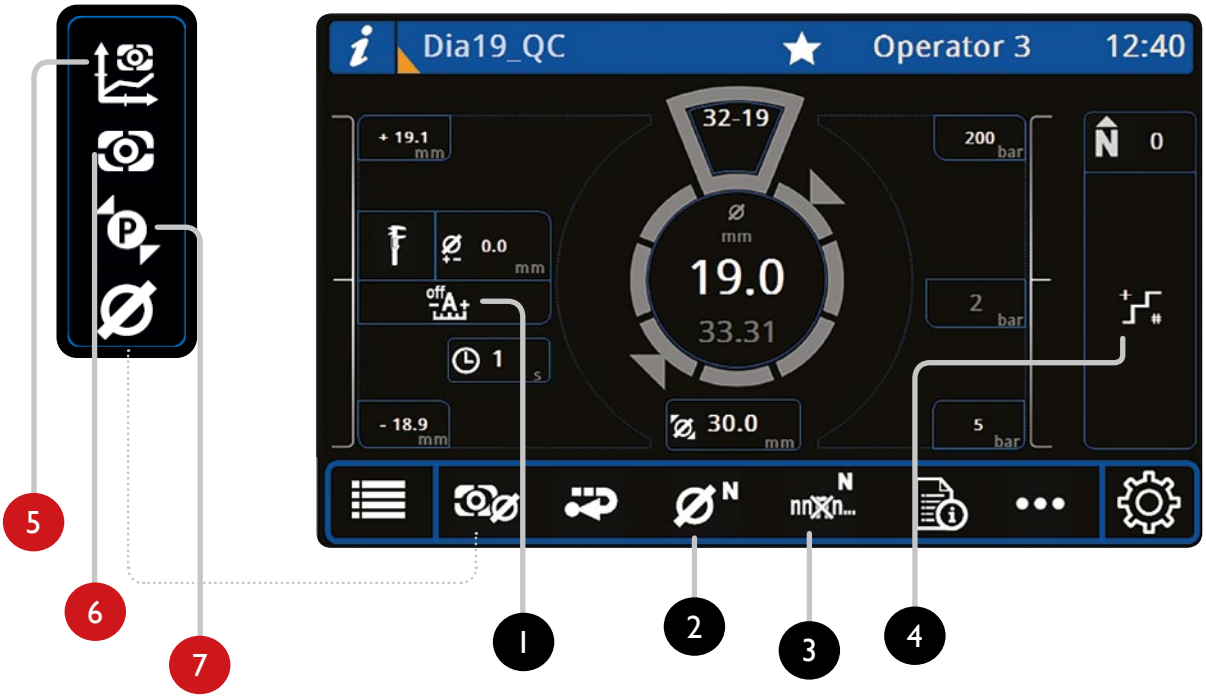


1. **Current Die Set**
2. **Opening**
3. **Actual crimping diameter**
4. **Set point**
5. **Correction / Offset**
6. **Crimping delay**
7. **Piece- counter**

8. **Machine Info**
9. **Selected recipe**
10. **User Handler**
11. **Time / Date**

12. **Menu**
13. **Crimping mode**
14. **Manual / Auto / Auxiliary device**
15. **Functions**
16. **Settings**

3. OPTIONS IDENTIFICATION



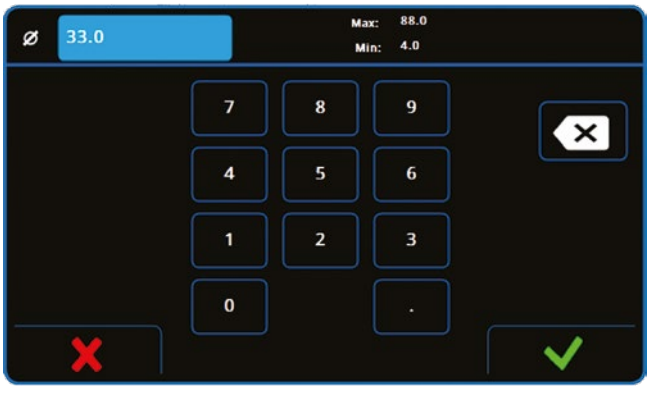
1. **Automatic correction**
2. **Counting mode**
3. **Bad results reaction**
4. **Step Crimping**

5. **Graphical quality control**
6. **Quality control**
7. **Pressure crimping**

GENERAL SCREENS AND BUTTONS

CANCEL-BUTTON ✗ **ACCEPT-BUTTON** ✓

NUMPAD



KEYPAD

4. DETAILED GUIDE

RECIPES / SAVE RECIPE 10
MANAGE RECIPES 10
TIP – MANAGE JOB QUEUE 11
SETPOINT, TOTAL OPENING, MASTER DIE POSITION 12
DIAMETER CRIMPING / SEMI-AUTO /
MANUAL / AUX DEVICE 12
DIE SET SELECT 13
DIE SET CHANGE WIZARD 14
CORRECTION / OFFSET 15
PIECE COUNTER 15
CRIMPING DELAY 15
JOB INFORMATION 16
SETTINGS BAR 16
CALIBRATION 17
TOOL SETTINGS 17
MOTOR RUN DELAY 17
SPEED CONTROL 18
DIE SET LIST 18
MINIMAL CRIMPING DIAMETER 18
MINIMAL MASTER DIE DIAMETER 18
MAXIMAL CRIMPING DIAMETER 18
MAXIMAL MASTER DIE DIAMETER 18
STATISTICS 19
USB FILE HANDLER 19
SET TIME & DATE 20
MACHINE INFO 21
USER HANDLER / LOG IN AS USER 22
MANAGE USERS 23
OPTION PACKAGES 26

4. DETAILED GUIDE

You can add new recipe to favorites by clicking favorite button. An other push will delete the recipe from favorites list.

RECIPES / SAVE RECIPE

(Option 1 or 2.)

Make desired changes to the crimping page. You can save the current crimping settings as a *RECIPE*.

1

1. Press *RECIPE NAME (Dia19)* *SAVE / SAVE as* window appears.

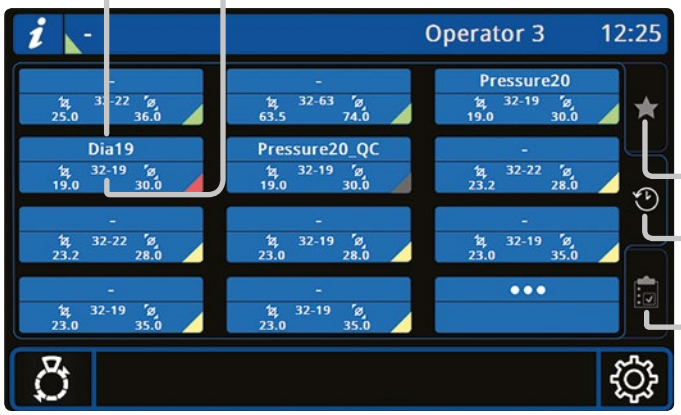
2. Press *SAVE* to save the current crimping settings on the current recipe used.

2

1. Press *SAVE AS* to save as new. *RECIPE KEYPAD* appears.

2. Type new recipe name and press *ACCEPT.*

MANAGE RECIPES



Recipe name

Recipe tech specs

Choose recipe or job by pressing ☰ on drive page. Recipes -page will show (left). Choose recipe from different tabs on the right.

Favorites -tab

History -tab / Lastly used parameters, unsaved and unnamed crimpings.

Job queue -tab / Jobs

1. Press desired tab on right.

2. If desired recipe is shown on page, choose recipe by pressing recipe name. Alternatively press ●●● for full list.

Press → to show more information from recipes. By scrolling down you find all recipes. Choose desired recipe from list. Confirm by pressing *ACCEPT.*

By pressing icon recipes can be sorted according to name, color, diameter etc.

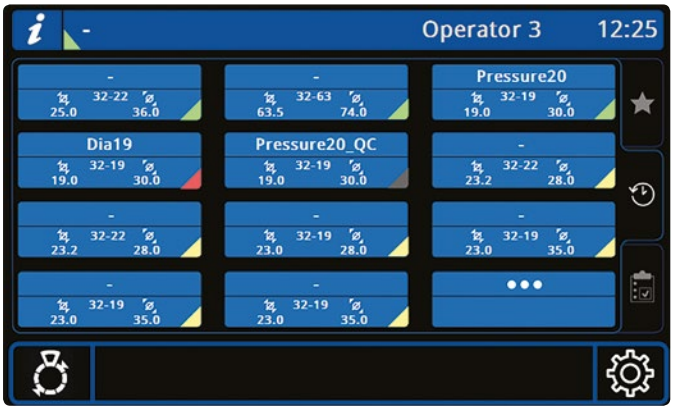
Search function
Search recipe by name.

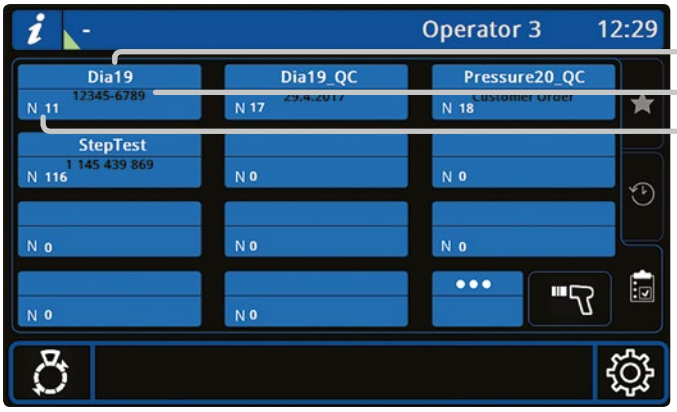
Change of color
Press the row for 2s. Choose color from popup and press the accept button.

Delete
Delete recipe by choosing recipe and pressing the icon.

N.B. Recipe name max 15 marks. Saved recipes max 1 000.

HISTORY SCREENS



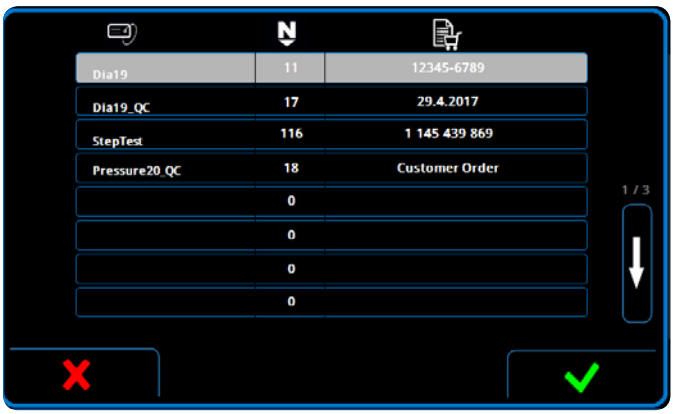


JOB QUEUE SCREENS

Choose Job in list.

- Recipe name
- Job identification
- Crimping count

N.B. Job ID max 20 marks. Job queue max 24 jobs.



TIP – MANAGE JOB QUEUE

In the standard control you can bring jobs with a JOBS.CSV -document via USB or FTP-server.

Bring jobs with Bar Code Reader (option) to jobs list.
OR with a TCP / IP (option) connection.

BAR CODE READER

SETPOINT, TOTAL OPENING, MASTER DIE POSITION

These three values show the crimping setpoint, total opening of dies in between crimpings, and realtime die position. Set these values directly in crimping page or choose recipe. *(Detailed guide – recipes / save recipe)*

Set point
1. Press (number symbol) to set crimping set-point. NUMPAD appears.

2. Enter desired set point value.

Note! *Die set has to be changed if crimping diameter changes a significantly.*

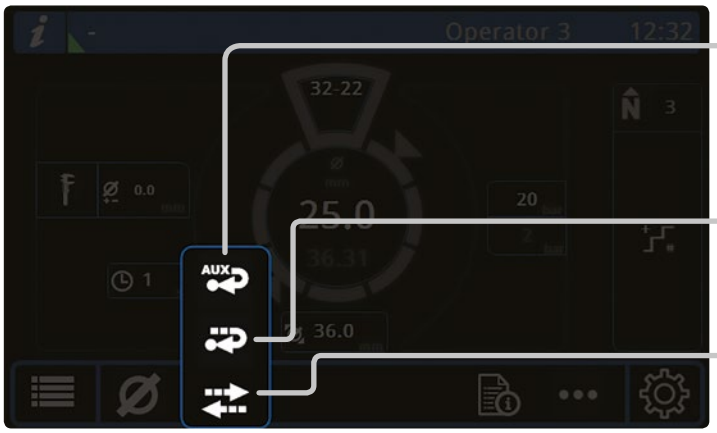
Set total opening
This value shows the total opening of crimping dies between each opertion.

1. Press ⌀ to change crimping total opening.

Actual Die position
This value shows the die position.

DIAMETER CRIMPING / SEMI-AUTO / MANUAL / AUX DEVICE

Select control mode for machine. When using Aux or semi-auto. Dies can be opened with manual opening button to full open.



AUX device
Set machine to start crimping by auxiliary device. Aux device is operated as semi-auto mode.

Semi-auto
Set machine to semi-auto mode.

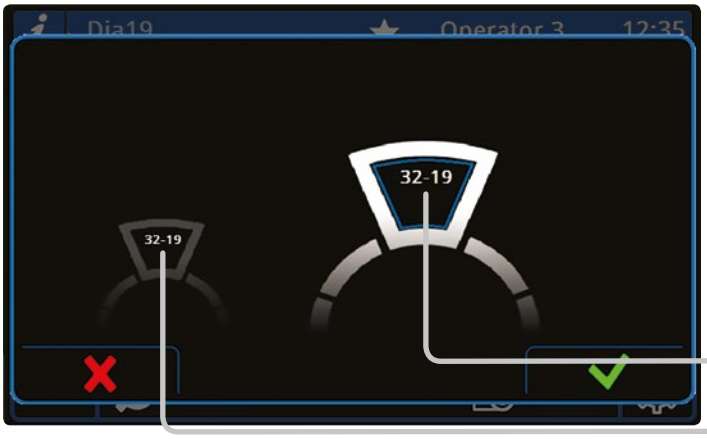
Manual
Set machine to manual mode.

The dies are opened/closed manually by pressing the push buttons. The movement can be interrupted by releasing the button. The movement stops when the desired crimping diameter or pressure is reached or when the retraction position is reached.

If an aux device or semi-auto mode is on and manual open is set, the dies open completely.

DIE SET SELECT

When either changing crimping set point or choosing a recipe / job that can't be operated with current dies, you need to change die set. When die set needs to be changed, the DIE SET segment starts blinking (picture right).



To start die set selection

1. Press the blinking die set segment. Die set pop-up appears.

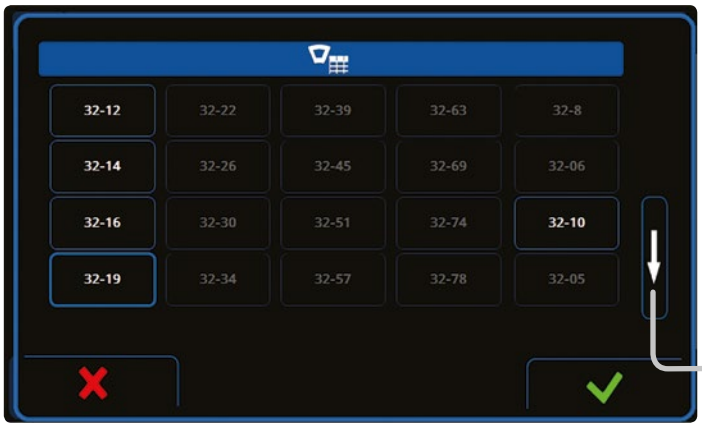
The control suggests the best suitable die set as shown in the picture. You can also choose a different die set.

2. Suggested Dies set can be selected by pressing OK. If you want to select different die set, press die set icon. If you choose die set manually DIE SET TABLE appears (down left).

Note! *When die set is chosen you are directed to this page with a prompt to launch the die set wizard or cancel. When pressing cancel you are directed to crimping page.*

Suggested die set
Press to set die set manually.

Present die set



Choosing die set manually

Die sets are shown in table. You can scroll up / down all die sets available. Unsuitable dies for the diameter are dimmed.

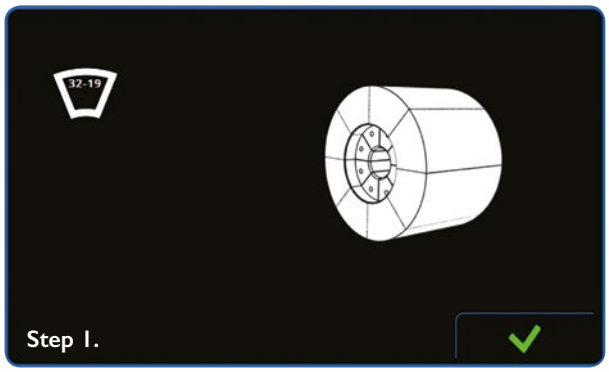
1. Choose desired die set in table.

2. Press ACCEPT to select and return to previous page, cancel to not select and return.

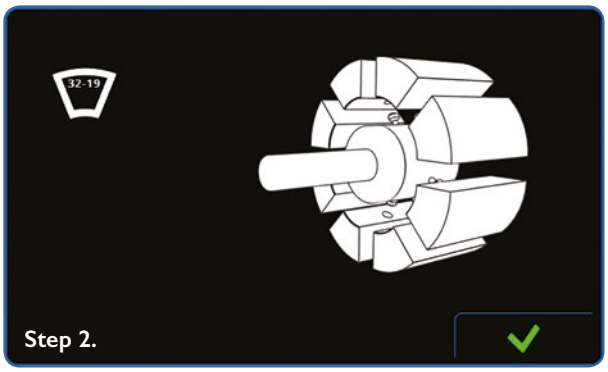
Scroll up / down.

DIE SET CHANGE WIZARD

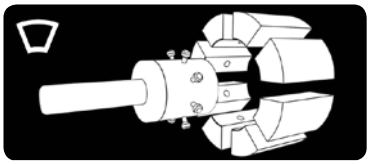
The die set change wizard opens when die set is chosen.

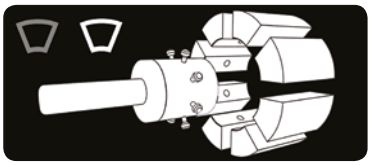


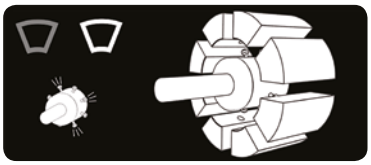
1. Close the dies completely (Step 1).



2. Insert the pins of the tool into the die set and open the dies (Step 2).


Step 3.1.


Step 3.2.


Step 3.3.

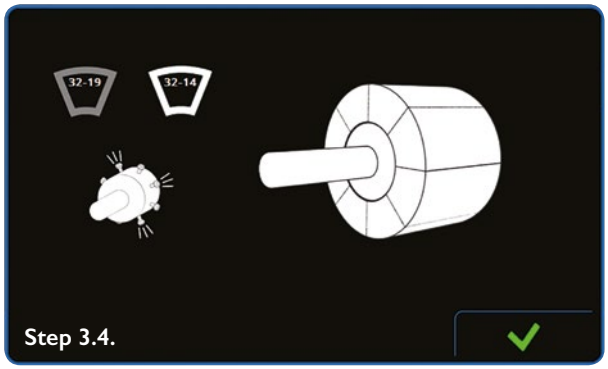
3. Install the new die set and close the dies (Step 3):

3.1. Pull the whole set out and place the set to the die set rack. Turn the QC-Tool counter clockwise until the die set is locked to its place and pull the tool out. Choose the new die set by inserting the pins of the tool into the die set in the rack, turn the tool clockwise and pull the whole die set out.

3.2. Hold the handle of the QC-Tool and make sure your hand will not get between the dies. Mount the die set between the master dies.

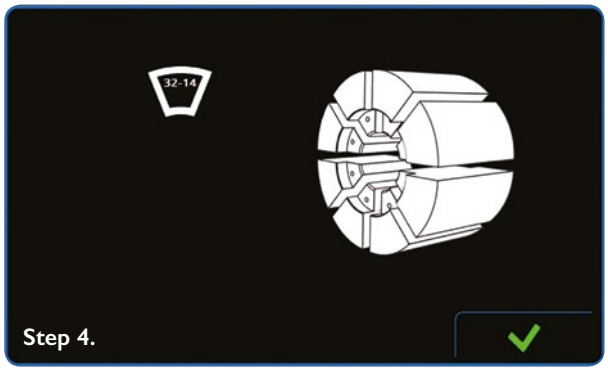
3.3. Close the dies very carefully.

TO AVOID DAMAGING MACHINE AND DIES, MAKE SURE THAT ALL DIE SET PINS HIT IN THEIR HOLES.



3.4. Close the dies completely until the locking pins are locked in their position.

4. Remove the quick change tool and open the dies to the retraction position (Step 4). The dies are now ready for use and Tool Change Wizard will be shut automatically.



CORRECTION / OFFSET

Correction / Offset function adjusts crimping to desired value if there are differences between the crimping diameter and the crimped part. Perform the fine adjustment by using the correction function. ***Note!*** *Always make the test crimp after adjusting the crimping diameter or changing the dies.*

Set crimping correction / offset
1. Press -symbol. NUMPAD appears.

2. Set value for desired correction / offset.
Value can be +/- 1.0mm.

OR Press caliber icon to set actual measured value of crimped part. Correction is then calculated automatically.

4. Make a test crimp, check the result and measure the diameter. If necessary, make a new correction and crimp again.

CRIMPING DELAY

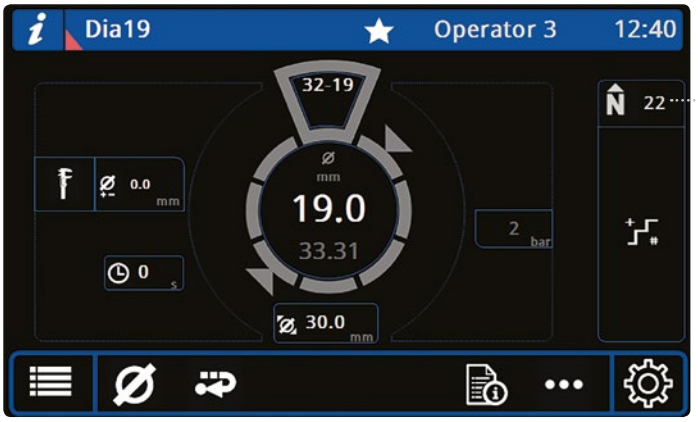
Crimping delay is a specific time, when dies are closed after crimping. After crimping delay dies open automatically. New crimps are disabled until the crimping cycle is fully completed.

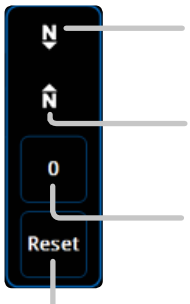
To set crimping delay
1. Press -symbol. NUMPAD appears.
2. Set value for desired crimping delay.
3. Press ACCEPT.

PIECE COUNTER

Piece counter helps you to keep track of the jobs. You can choose to count crimps descending and ascending.

BARCODE FUNCTIONS (OPTION). Work queue mode set the counting direction down and the counting value from selected job.





Descending: Shows remaining crimps. When zero, the counter blinks and desables crimping.

Ascending: Shows total crimped quantity in a job.

Crimp count: Shows current crimping count in job.

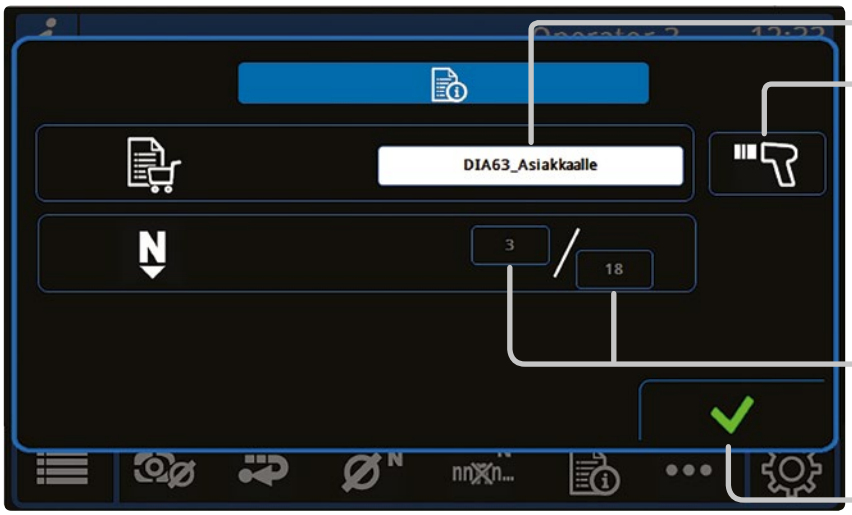
Reset: Reset counting.

To change counting mode

1. Press -symbol. Pop-up appears.
2. Choose desired counting method.
3. Reset counter or set desired value.

JOB INFORMATION

When pressing Job Information symbol in functions menu, you can view information of job in operation.



Job identification

Barcode reader
With BCR option you can read identification with bar code reader.

1. Press button. Frame lits.
2. Read Code
3. ID appears, button blanks

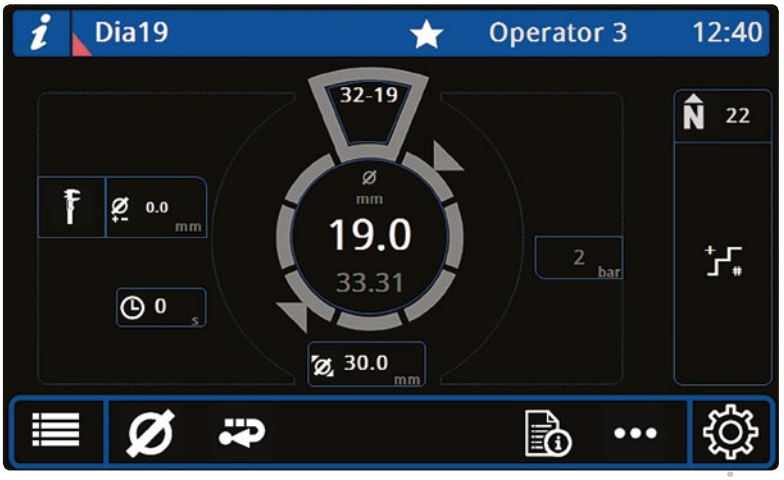
Current / Total count of the order

Press ACCEPT to close Job Information.

Modified order
If the job information has been modified, the ID turns black.

SETTINGS BAR

You can access general settings by pressing -symbol.



Tools
Only for service need.

Settings

Motor run delay + grease settings

Speed / slow down

Statistics

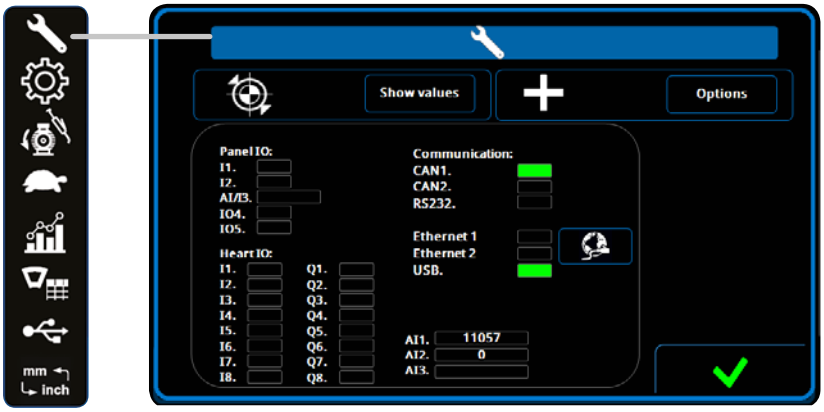
Die set table

USB file handler

Change diameter unit
Press to change unit (mm/inch).

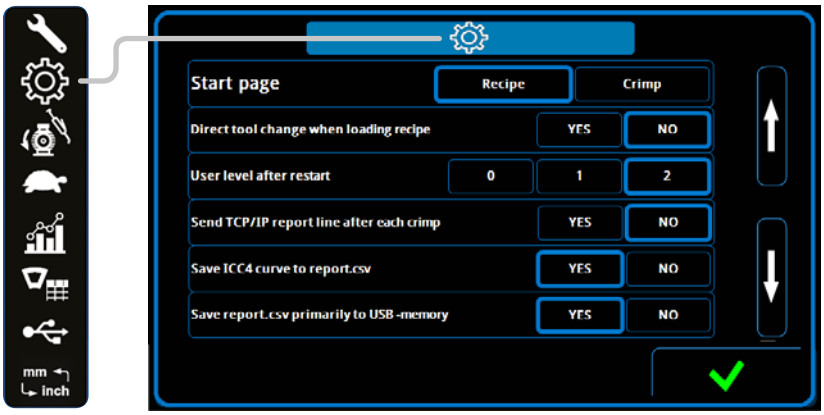
TOOLS

Machine IO status can be monitored. Service can enter to calibration functions.



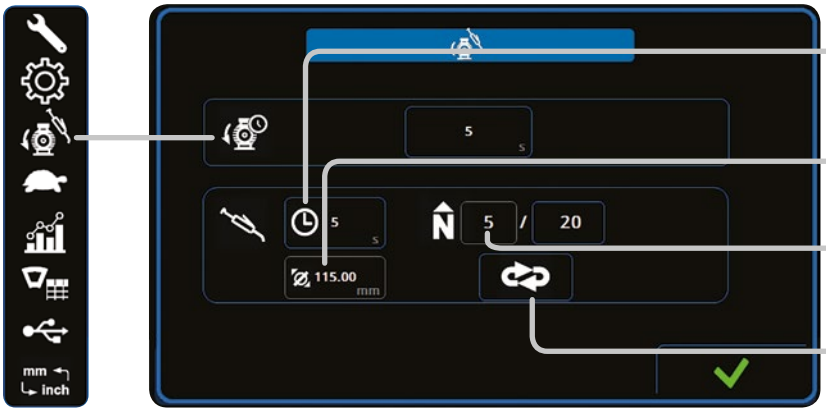
TOOL SETTINGS

Here you can modify machines general settings.



MOTOR RUN DELAY

Modify parameters for motor running delay and greasing.



Greasing parameters

Greasing time. Can be modified to longer time which results in more grease at once.

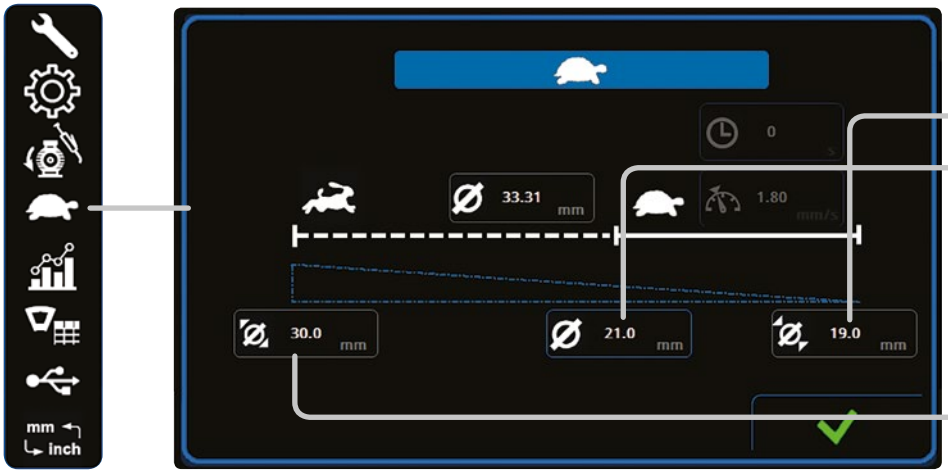
115mm information for maximum grease opening.

Counter. Current crimp count / Greasing interval. Modify if needed.

Bleeding. Brightens when pressed. Uses greasing pump until turned off.

SPEED CONTROL

When pressing speed control symbol in settings bar, you can change crimping operation speed in speed control settings. Crimping speed can be set to ease operation and increase safety and efficiency.



Set point (informative)

Slow down position
This value shows the position of the crimping tools when crimping slows down. Change position:

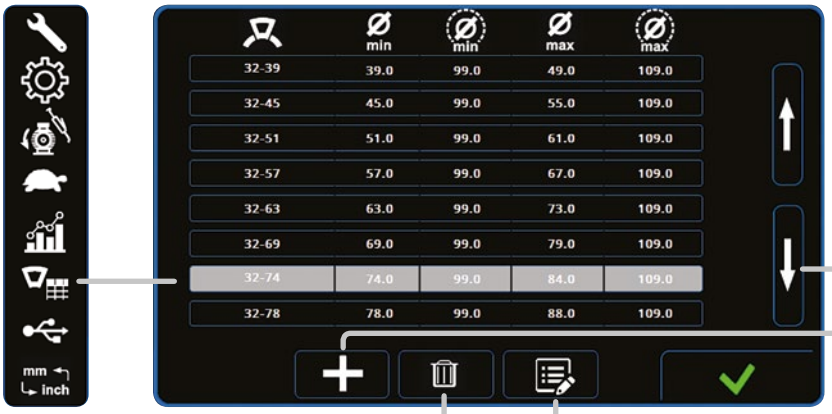
1. Press symbol. NUMPAD appears.

2. Set value of desired position for slower crimping speed.

Total opening (informative)

DIE SET LIST

Die set list shows all the die sets available for the machine in operation.



Die set

Minimal crimping diameter

Minimal master die diameter

Maximal crimping diameter

Maximal master die diameter

Scroll up / down

Add

Add a new die set to list:
1. Press ADD -button. New row appears in list
2. Add values for the new die set
3. Press ACCEPT

Edit

To edit die set values:
1. Press desired die set
2. Press edit button. Edit symbol brightens. Numpad appears.
3. Add desired value.

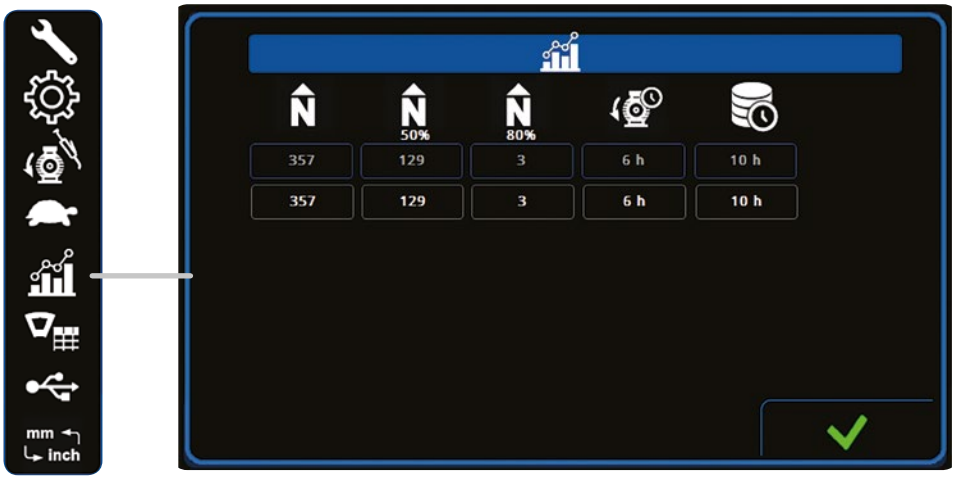
Delete

To delete a die set from list:
1. Press desired die set
2. Press delete

N.B. DieSet name max 6 marks.
Saved tools max 100.

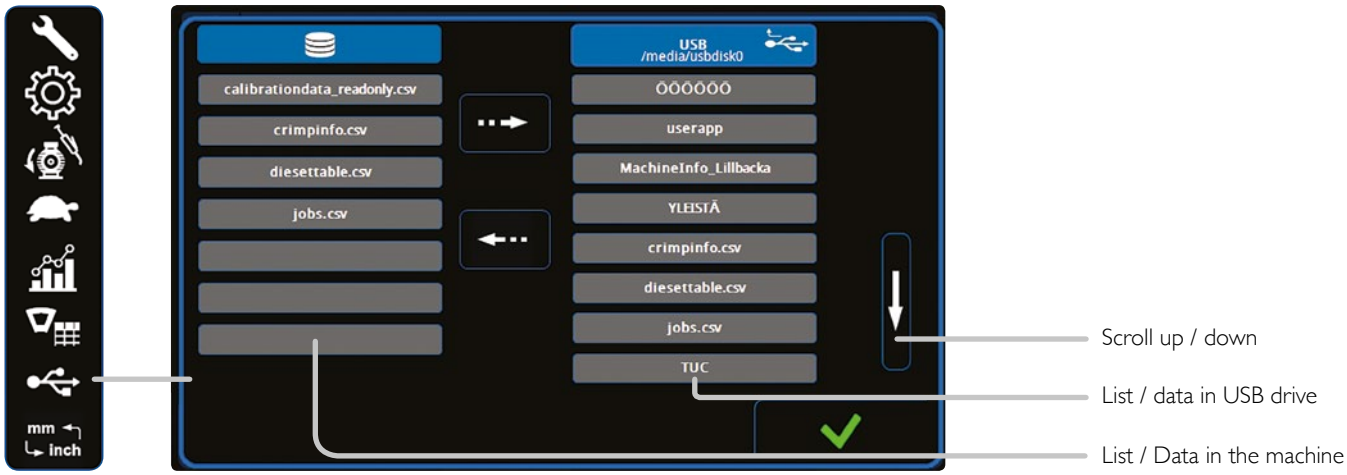
STATISTICS

Statistics give you measurable data of the crimping operation.



USB FILE HANDLER

In USB file handler you can manage jobs and recipes.



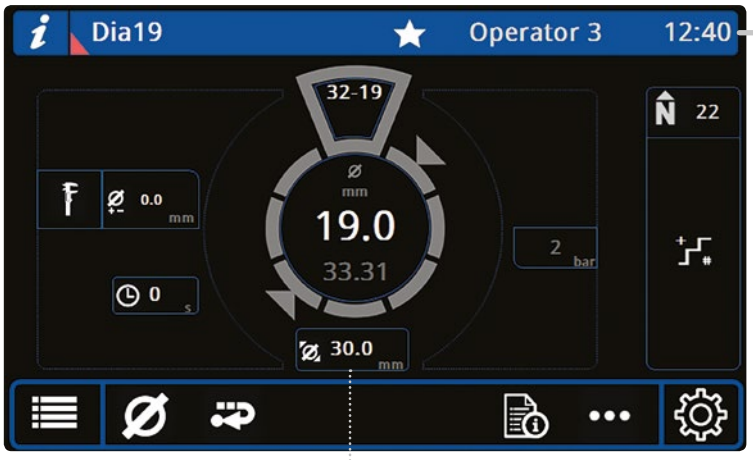
Open folder in USB drive:
1. Press folder for 2 seconds. Symbol shows when folder in opening.
Folder opens and shows files.
2. Press to open root folder.

To transfer file from USB drive to machine:
1. Press a file you want to transfer in USB drive
2. Press -button to transfer file to machine.
The file is transferred.
3. Press ACCEPT to quit.

To transfer file from machine to USB drive:
1. Press a file you want to transfer in machine.
2. Press -button to transfer file to USB drive.
The file is transferred.
3. Press ACCEPT to quit.

SET TIME & DATE

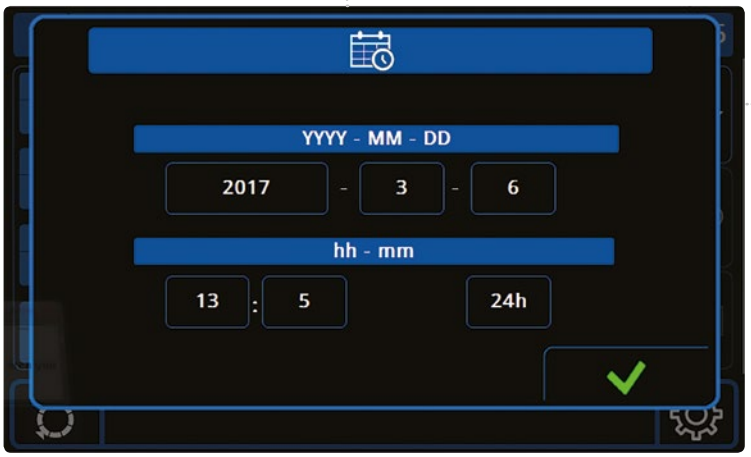
You can set the right time and date for the machine.



Time / Date

1. Press (time symbol)

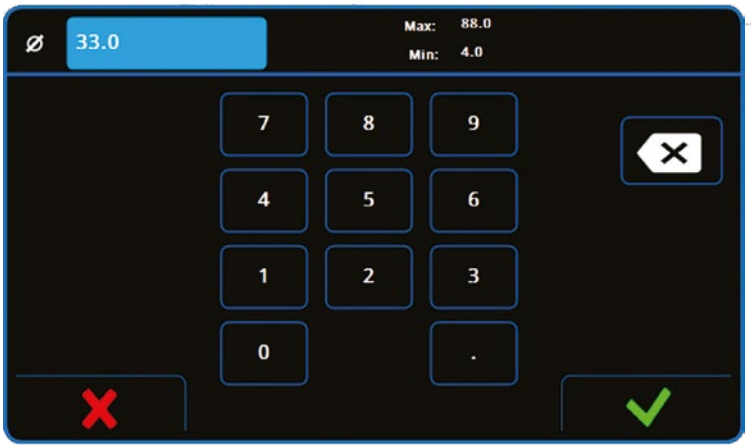
2. Change time and date in window that appears and press ACCEPT. (See more detailed instructions below)



Press TIME & DATE symbol on the top of the screen. TIME & DATE window appears.

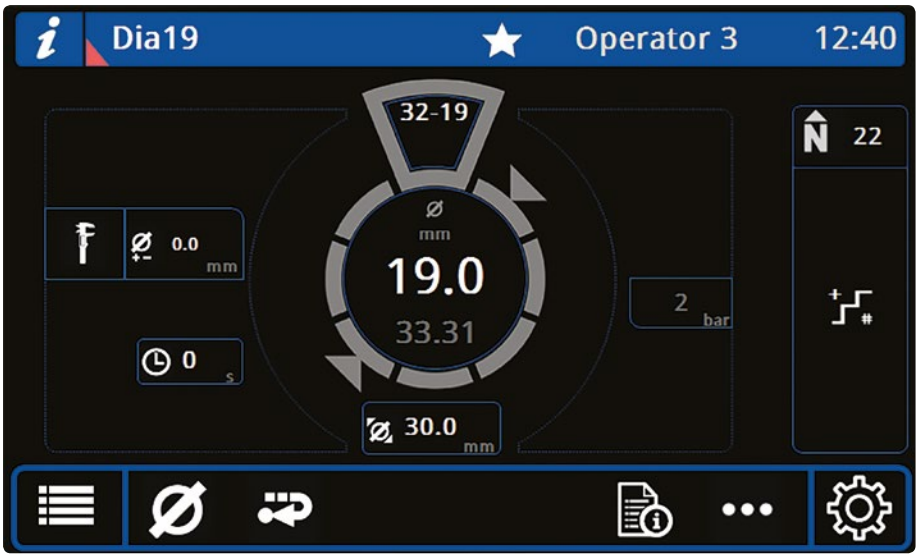
Press *year, month, day, time and 24h/12h* to set value for each one.

NUMPAD appears. Enter desired value.

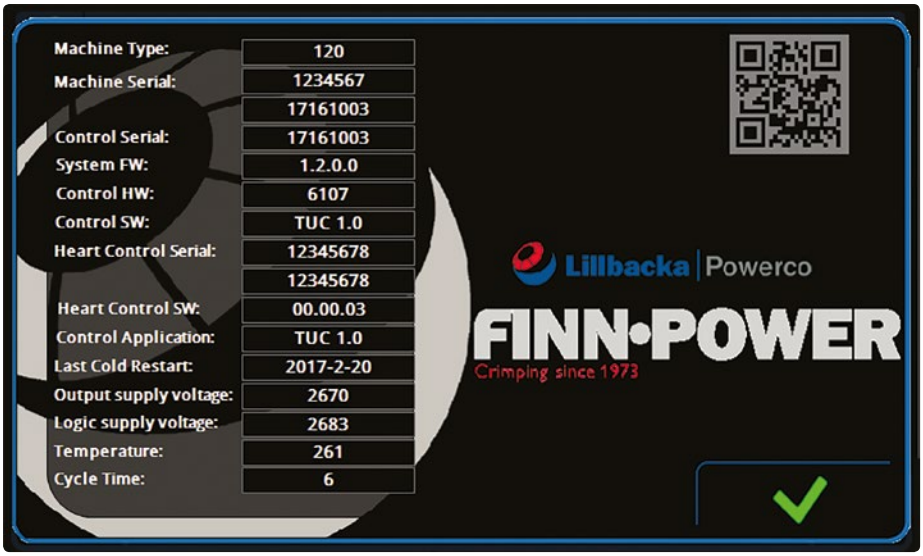


NUMPAD

MACHINE INFO

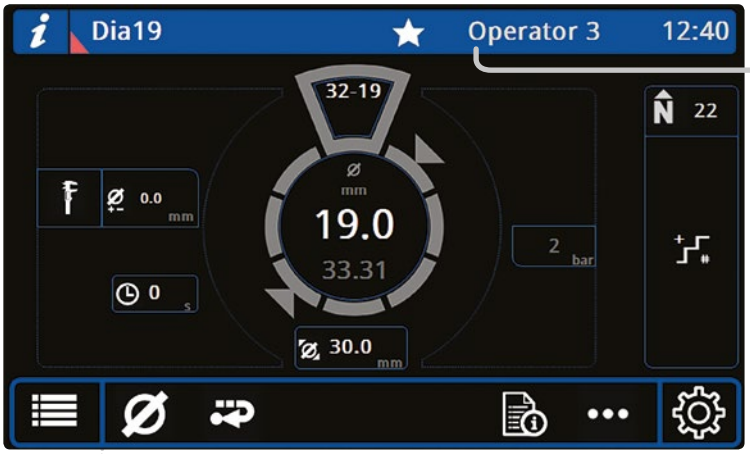


1. Press -icon to view MACHINE INFO. Window below will appear.

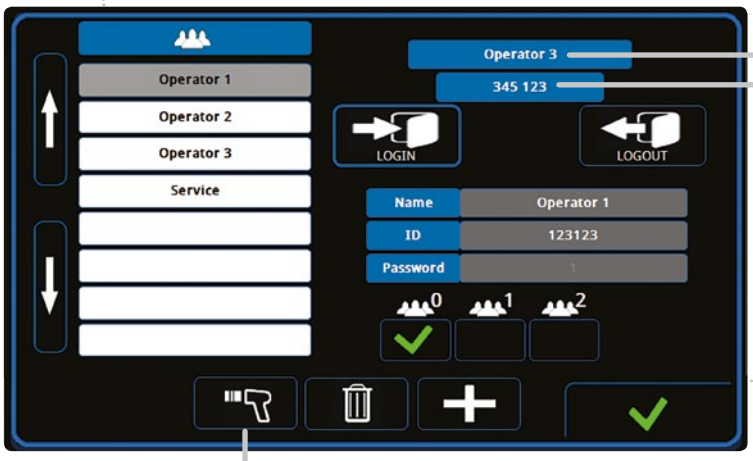


In case of service, open this window to give the needed machine info to Lillbacka service personnel.

USER HANDLER / LOG IN AS USER



1. Press USER HANDLING symbol. USER HANDLING window appears with different user levels.



Logged user level

Logged user ID

Bar code reader. OPTION. You can scan your working ID to LOG IN as user.

2. Select user you want to log in. Press log in and write password. OK

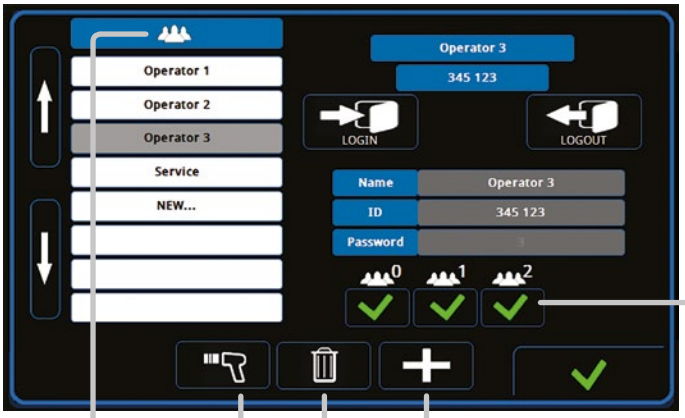
3. Press ACCEPT in USER HANDLING WINDOW to save and quit.

LOG OUT AS USER

1. Press USER HANDLING symbol on info bar on the top of the screen. USER HANDLING WINDOW appears.
2. Press LOGOUT-button.
3. Press ACCEPT to save and quit.

MANAGE USERS

As a LEVEL 2 (advanced) or 3 (service) you can preview and change user data.



Level of selected user 0, 1, 2 or 3.

Add

1. Press + to add user(s).
New line will appear.

2. Type user information to fields: *name, ID* and *password.*

3. Press *accept* to save new user.

Delete

1. Choose user from list

2. Press -symbol to delete user from list.

Barcode reader (Option)

Sign in from identification card by reading barcode.

More information: see Barcode reader user guide.

Preview and change user data

1. Log in as service or advanced (level 2 or 3).

2. Choose user you want to preview / change data in.

3. Change data by pressing *name / ID / password.*
Keypad appears.

4. Type new data. Press *accept* in keypad to save.

5. Press *accept* to save and quit *user handling*.

N.B. User name, user ID and password max 15 marks. Max number of users 100.

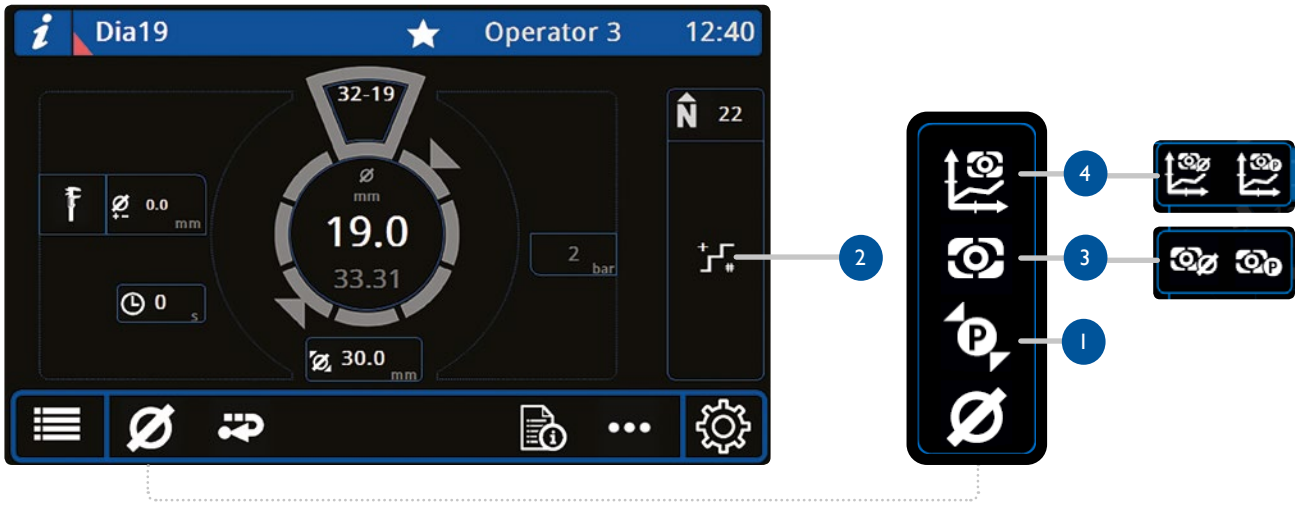
5. OPTIONS

PRESSURE CRIMPING (ICC1) 26
STEP CRIMPING (ICC2) 27
QUALITY CONTROL (ICC3) 28
AUTOMATIC CORRECTION 29
COUNTING MODE (INCL. ICC3) 29
BAD RESULT REACTION (INCL. ICC3) 29
GRAPHICAL QUALITY CONTROL (ICC4) 30
FUNCTIONS (OPTIONS) 31
SPEED CONTROL 31
SYMBOLS 32

5. OPTIONS

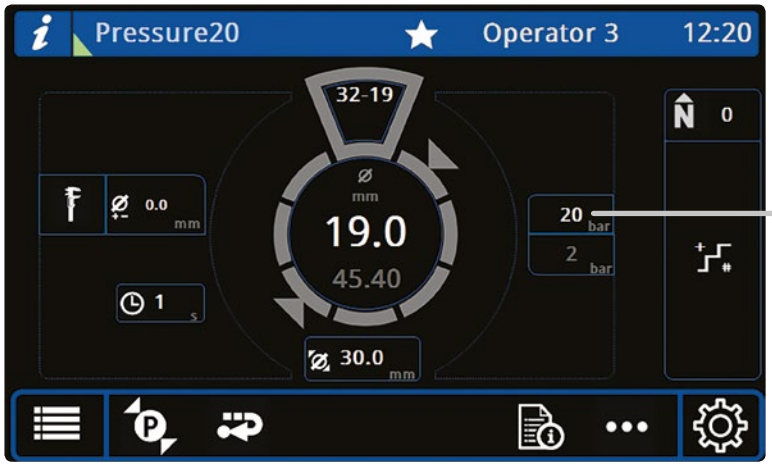
OPTION PACKAGES

1. Pressure crimping **ICC1**
2. Step Crimping **ICC2**
3. Quality control **ICC3**
4. Graphical quality control **ICC4**



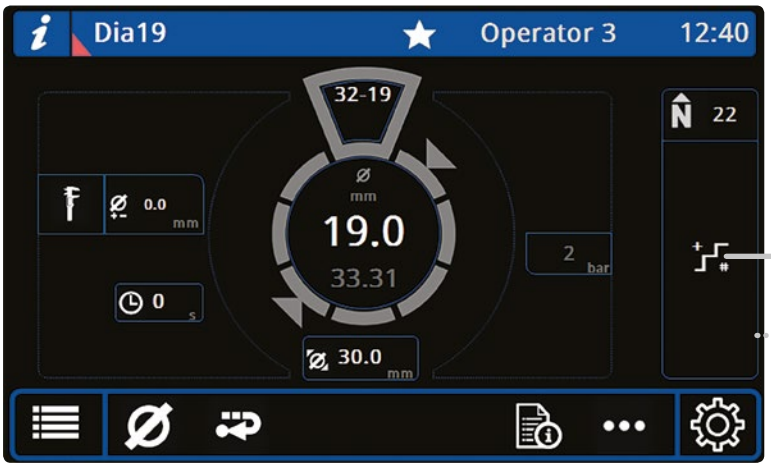
PRESSURE CRIMPING (ICC1)

With pressure crimping you can also define the stopping pressure of the crimping. Diameter or pressure stops the crimping, the one that is reached first.



PRESSURE CRIMPING
Press to set point for pressure.

STEP CRIMPING (ICC2)



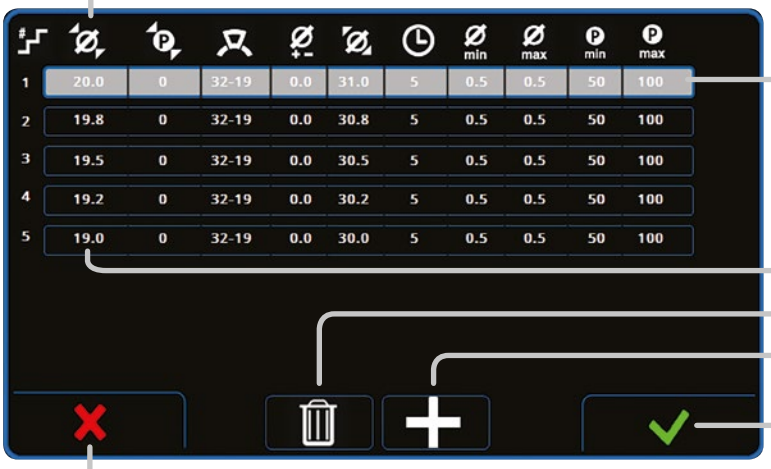
Step crimping button
Press to start step crimping.

If any steps haven't been made, you'will be asked rather to choose step list view or step wizard. Read more about step wizard on page 28.

Step list view

Step wizard

STEP LIST VIEW



Diameter set point

Current active step

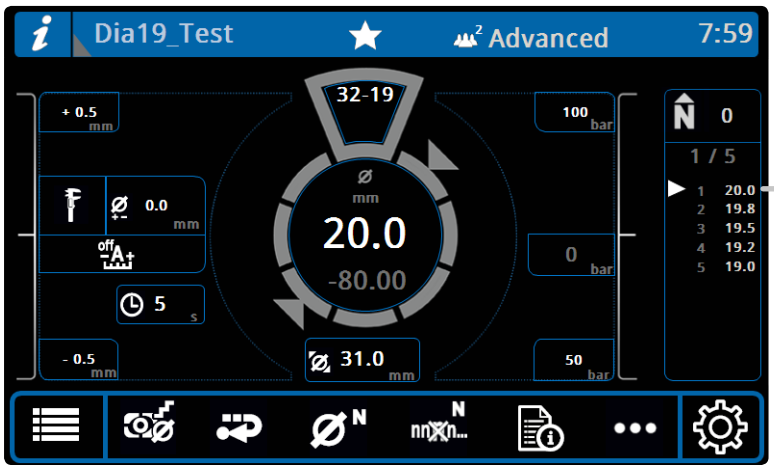
Value

Delete steps

Add steps

Accept selected step to current and go to crimp view.

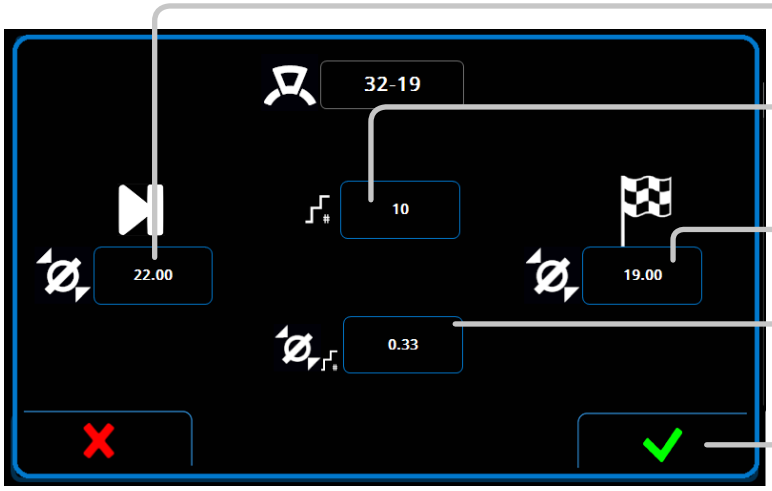
Continue with previous step and go to Crimp view.



Here are the modified steps in order. Push box to show step list.

N.B. Step crimping option max 50 steps.

STEP WIZARD



Start point for crimping diameter
Press to set first point for diameter.

Automatical step point
Press to set step count. Machine calcutes automatically step point changes for diameter.

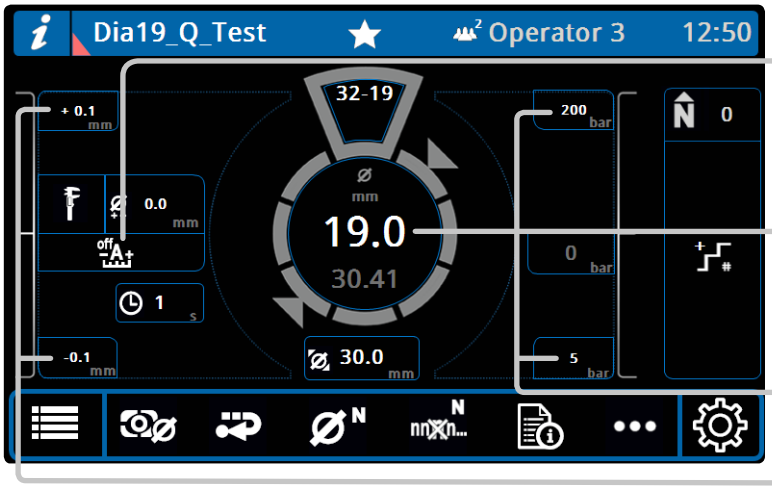
End point for crimping diameter
Press to set last point for diameter.

Diameter transition
Press to set step point value. Machine calcutes automatically step counts.

Accept to proceed
Step list view opens.

QUALITY CONTROL (ICC3)

With quality control you can define the tolerance for the crimping part. This ensures the quality of the part. After crimping, the control measures and saves value of the crimping and accepts or rejects it.

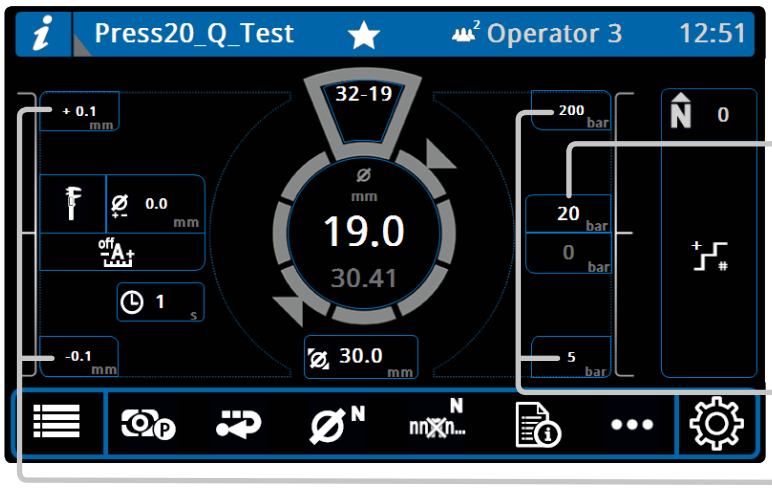


Auto correction.

DIAMETER QUALITY CONTROL CRIMPING
Press to set point for diameter.

Maximum and minimum limits for pressure.
Press value to change limits.

Maximum and minimum limit for diameter.
Press value to change limits.

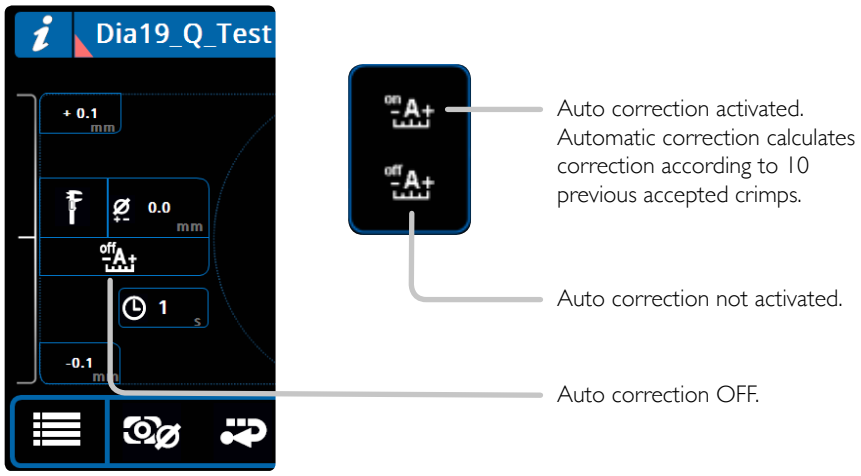


PRESSURE QUALITY CONTROL CRIMPING
Press to set point for pressure.

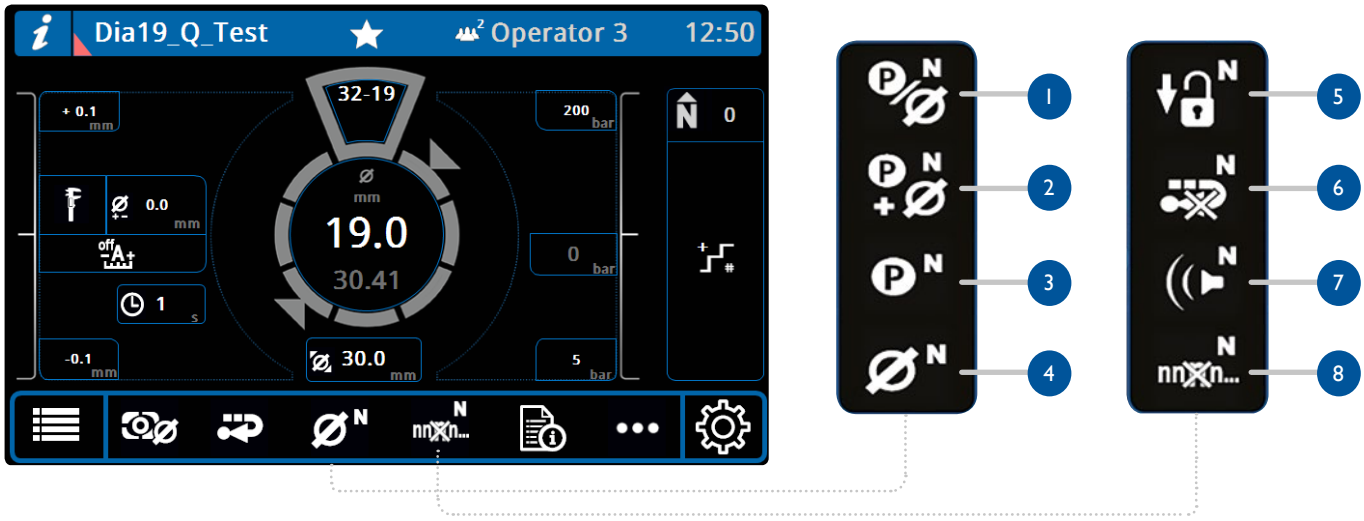
Maximum and minimum limits for pressure.
Press value to change limits.

Maximum and minimum limit for diameter.
Press value to change limits.

AUTOMATIC CORRECTION



COUNTING MODE AND BAD RESULT REACTION (INCL. ICC3)



1. Counting is performed when the set crimping diameter OR crimping pressure has reached the given tolerance limits. Available only in quality control mode.

2. Counting is performed when the set crimping diameter AND crimping pressure has reached the given tolerance limits. Available only in quality control mode.

3. Counting is performed when the set crimping pressure has reached the given tolerance limits. Available only in quality control mode.

4. Counting is performed when the set crimping diameter has reached the given tolerance limits. Available in standard control.

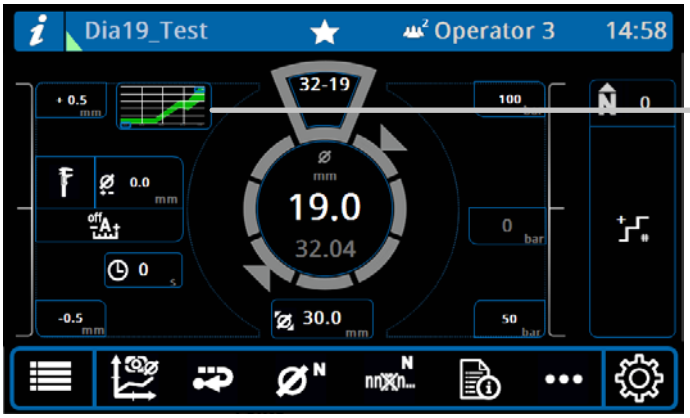
5. Control locking. In case of faulty crimping the dies stay closed. Dies can be opened with password (user levels 2 and 3).

6. Die movement disabled. The dies stay closed and the faulty part cannot be removed. Dies can be opened by pressing open button.

7. Alarm. An exterior alarm light or alarm signal, connected to ICC control, alerts to the faulty crimping.

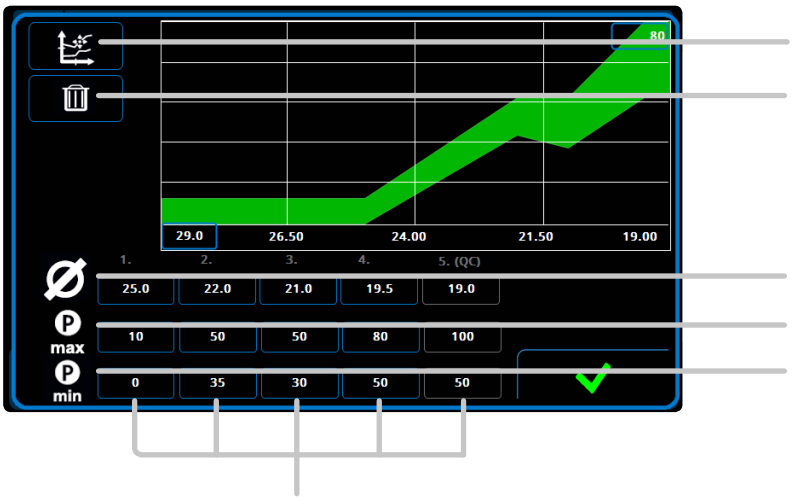
8. Counting disabled. The counter stops, but machine operates normally. Faulty crimping will be dismissed.

GRAPHICAL QUALITY CONTROL (ICC4)



In front view with ICC4 option you can see icon of the diameter. By pushing the icon the diameter window pops up.

10 LATEST PRESSURE GRAPHS



Calculate initial values.
Note. Crimp 1...10

Delete curves from display

Diameter.

Maximum pressure.

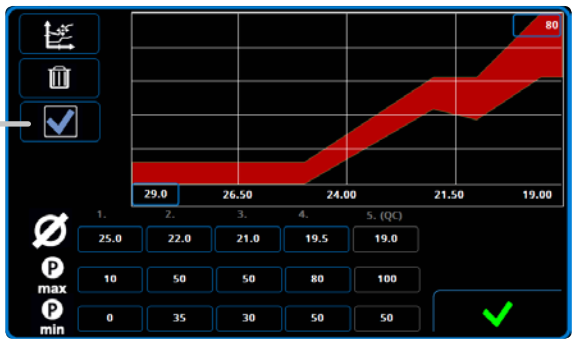
Minimum pressure.

You can set limit values by five points. In the last field (5) you can set limit value for quality control. You can modify the first four fields.

1. Set the desired value for diameter for the field on top.
2. Set minimum and maximum limits for diameter for the lower fields.

If the limits are exceeded when crimping this window shows.

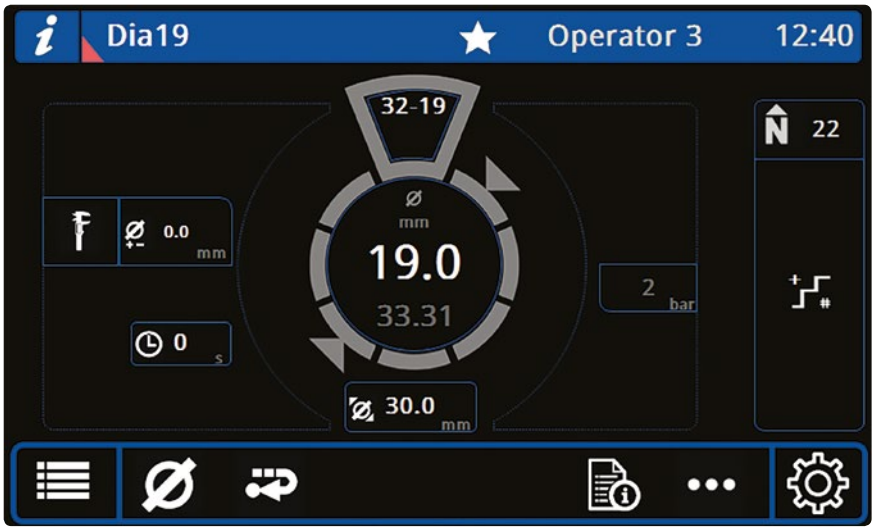
1. Alarm popup.
Press cancel to proceed.



2. Press to finish crimping or to open dies.

N.B. Max accuracy 0.1mm/1bar. Max measuring range 100 points = 10mm.

FUNCTIONS (OPTIONS)

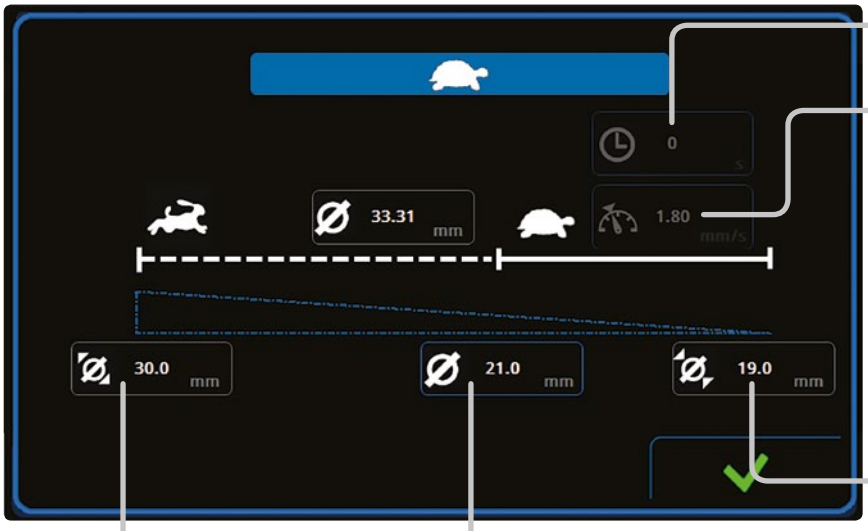


Functions

1. Press ●●● -symbol to access functions.

SPEED CONTROL (OPTION)

When pressing speed control symbol in settings bar, you can change crimping operation speed in speed control settings. Crimping speed can be set to ease operation and increase safety and efficiency. Besides slow down position, this option gives you access to set other values too for speed control.



Slower speed in seconds
(only available with speed control option)

Slower speed in mm/s
(only available with speed control option)

Set slower speed
You can set slower speed either in seconds or in mm/s.

1. Press either *speed in seconds* or *speed in mm/s*. NUMPAD appears.

2. Set value for desired speed.

Set point (informative)

Total opening (informative)

Slow down position
This value shows the position of the crimping tools when crimping slows down. Change position:

1. Press symbol. NUMPAD appears.

2. Set value of desired position for slower crimping speed.

Note! *Some machine types are not equipped with slow down hydraulic unit.*

SYMBOLS

Crimping diameter

Crimping pressure

Diameter quality control

Pressure quality control

Semi automatic start mode

Back stop

Foot pedal

Auxiliary start mode

Manual start mode

Counting from diameter

Counting from pressure

Counting from pressure and diameter

Counting from pressure or diameter

Target

Alarm after faulty crimp

No automatic return after faulty crimp

No count after faulty crimp

Instruction to press crimp button

Step list view

Step wizard

Tools

Settings

Correction

Find

Statistics

Die set list

Save

Save as

Favorite

Job queue

History

Calibration

Backspace

Barcode reader

Memory

Recovery

Quality control

Delete

Auto correction ON

Auto correction OFF

Lock after faulty crimp

Locked

Unlocked

Slow speed

Fast speed

USB

USB root

Mm to inch conversion

Add

Download heart software

More

Date and time

Ethernet status

Cancel

Accept / select

Accept / select

Users

Info

Recipe name

Tool change

Motor and grease settings

Motor running delay

Grease settings

Count up

Count down

Count

Up

Down

Transfer

Transfer

Bleeding

Login

Logout

Step

Add steps

Tool

Diameter

Pressure

Opening / retraction

Correction

Right

Left

List

3 part window layout

Delay time

Diameter min

Diameter max

Diameter min (masterdie)

Diameter max (masterdie)

Pressure min

Pressure max

Start

Linearization

Graph

Adjust limits

Job identification

Job information

Window size

Crimp mode diameter with steps

Crimp mode pressure with steps

Crimp mode quality control diameter with steps

Crimp mode quality control pressure with steps

Graphical quality control diameter

Graphical quality control pressure

Graphical quality control

FINN-POWER
ICC CONTROL

OPERATING INSTRUCTIONS

Lillbacka | Powerco

FINN•POWER
Crimping since 1973