

CVIL II Controllers

V 5.1.X

Operator's manual

Model	Part number
CVIL II	6159326800



Original instructions.

© Copyright 2018, Ets Georges Renault 44818 St Herblain, FR

All rights reserved. Any unauthorized use or copying of the contents or part thereof is prohibited. This applies in particular to trademarks, model denominations, part numbers and drawings. Use only authorized parts. Any damage or malfunction caused by the use of unauthorised parts is not covered by Warranty or Product Liability.

TABLE OF CONTENTS

1 - SAFETY INSTRUCTIONS	5	5 - CONTROL SCREENS	15
1.1 - Statement of use	5	5.1 - Standard screen	15
1.2 - General instructions	5	5.2 - Tightening report	15
2 - INTRODUCTION	5	5.3 - Inputs / Outputs	15
2.1 - CVIL II range	5	5.4 - Barcode reading	15
2.2 - Number of cycle and phases.....	5	5.5 - Maintenance request.....	16
2.3 - Memory size	5	5.6 - Number of pulses during the cycle	16
2.4 - Number of curves	5	5.7 - Controller temperature	16
2.5 - Communication	5	5.8 - Not ready	16
2.6 - Tools	5	6 - RESULTS	17
2.7 - Main differences between versions	6	7 - PROGRAMMING	18
2.8 - CVIPC 2000	6	7.1 - CYCLES and PARAMETERS menu	18
2.9 - CVINET WEB	6	7.2 - LEARNING menu	18
2.10 - PC Software evaluation version	6	7.3 - CYCLES menu	19
3 - DESCRIPTION	7	7.3.1 - Introduction.....	19
3.1 - Delivered equipment	7	7.3.2 - Selecting the cycle	20
3.2 - Dimensions.....	7	7.3.3 - Cycle general parameters	20
3.3 - Characteristics.....	7	7.3.4 - Programming the phase	22
3.4 - Front panel	7	7.3.5 - Programming the parameters.....	23
3.5 - Bottom panel	8	7.4 - Sequence menu	28
4 - INITIAL START UP	9	7.5 - QUICK CYCLES menu.....	29
4.1 - Installation	9	7.6 - SPINDLE menu	30
4.1.1 - STOP signal	9	7.7 - STATION menu	30
4.1.2 - Switch OFF.....	10	7.7.1 - STATION – General parameters	31
4.1.3 - Wall mounting fixation	10	7.7.2 - INPUT / OUTPUT configuration	33
4.1.4 - Tool cable connection.....	10	7.7.3 - INPUT menu.....	34
4.1.5 - 115/230 VAC cable connection	11	7.7.4 - OUTPUT menu.....	36
4.1.6 - Switch ON	11	7.7.5 - RUN REVERSE menu	38
4.2 - Start up.....	11	7.8 - PERIPHERALS menu	38
4.2.1 - How to enter or modify an alphanumeric field ...	11	7.8.1 - SERIAL PORT menu.....	38
4.2.2 - Language selection	12	7.8.2 - ETHERNET CONFIGURATION menu	39
4.2.3 - Setting the date and time	12	7.8.3 - ETHERNET SOCKET 1 menu	39
4.2.4 - Contrast adjustment	13	7.8.4 - ETHERNET SOCKET 2 menu	39
4.2.5 - Access code	13	7.8.5 - ETHERNET SOCKET 3 menu	40
4.2.6 - Activation code	14	7.8.6 - PLC menu	40
		7.8.7 - REPORT OUTPUT menu.....	41
		7.8.8 - BAR CODE menu.....	41
		7.8.9 - CVINET menu	42
		7.8.10 - TOOLSNET menu	43
		7.9 - CONTROLLER menu.....	44
		7.10 - CURVES menu	45

8 - MAINTENANCE	46	11 - TIGHTENING STRATEGY GUIDE.....	60
8.1 - MAINTENANCE menu	46	11.1 - Torque control	60
8.1.1 - TEST menu	46	11.1.1 - Normal mode (continuous)	60
8.1.2 - CHANNEL TEST menu	47	11.1.2 - Pulse mode (hybrid)	60
8.1.3 - COUNTERS menu	47	11.2 - Torque control and angle monitoring	61
8.1.4 - CALIBRATION menu.....	48	11.2.1 - Normal mode (continuous)	61
8.1.5 - Options	49	11.2.2 - Pulse mode (hybrid)	61
8.1.6 - BRDx2 - controller backup	49	11.3 - Angle control and torque monitoring.....	62
8.2 - SERVICE menu.....	49	11.4 - Seating detection.....	62
8.3 - Maintenance operation.....	50	11.4.1 - Main phase: Seating detection	62
8.3.1 - Changing the memory battery	50	11.4.2 - Second phase: Post-seating.....	62
8.3.2 - Replacing the fan	50	11.5 - Stall torque controlled tightening	63
8.3.3 - Desoutter Tool and Account Services.....	50	11.6 - Prevailing torque control.....	63
9 - CONNECTIONS	52	11.7 - Loosening - torque control and angle monitoring	64
9.1 - PC wiring diagram	52	11.8 - Loosening - angle control and torque monitoring	64
9.2 - Synchronizing several CVIL controllers	52	12 - CYCLE FLOW CHART AND TIMING CHART	65
9.2.1 - Example of connection diagram.....	52	12.1 - Cycle flow chart.....	65
9.3 - Tool cables	53	12.2 - Cycle timing chart.....	65
9.3.1 - ER cable.....	53	12.3 - Timing chart when using a crowfoot tool ...	66
9.3.2 - EME cable	54	13 - TROUBLE SHOOTING HELP	67
9.3.3 - ER / EME extension cable.....	55	13.1 - Warning	67
10 - PRINTING FORMAT FOR TIGHTENING RESULTS.....	56	13.2 - Report codes	67
10.1 - PC2 format	56	13.3 - Operating problems due to adjustment problems	71
10.2 - PC3 format	56	13.4 - Operating problems due to wear or breakdown.....	73
10.3 - PC4 format	57	14 - GLOSSARY	75
10.3.1 - Title.....	57		
10.3.2 - Result	57		
10.4 - PC5-A format.....	58		
10.4.1 - Report per spindle: torque rate, torque, angle.....	58		
10.4.2 - Reading results of spindle 1 (x times the number of spindles)	58		
10.5 - PC5-B format.....	58		
10.5.1 - Report per spindle: torque, angle, torque rate	58		
10.5.2 - Available parameters programmed for 1 spindle (x times the number of spindles).....	59		
10.5.3 - Results of spindle 1 (x times the number of spindles)	59		

1 - SAFETY INSTRUCTIONS

1.1 - Statement of use

This product is intended to be used to drive, monitor and control the ERA/ EME / ELRT range tools.

No other use permitted.

For professional use only.

EMC restriction of use: for industrial use only.

1.2 - General instructions



To reduce risk of injury, everyone using, installing, repairing, maintaining, changing accessories on, or working near this tool must read and understand the safety instructions before performing any such task. Failure to follow all instructions listed below may result in electric shock, fire and/or serious personal injury.

General safety instructions are collected in the 6159931790 tool safety booklet and quick start user manual 6159932180.



SAVE THESE INSTRUCTIONS CAREFULLY.

2 - INTRODUCTION

2.1 - CVIL II range

The CVIL II controller can control 1 portable ER and ERA type and/or fixed EME type and/or portable ELRT type electric power tool.

It is supplied ready to operate.

The default settings meet a large number of applications.

The CVIL II includes one station.

In general, the station name is the name of the application.

2.2 - Number of cycle and phases

- The system allows you to perform 50 tightening cycles of 15 phases each.
- The cycles are numbered from 1 to 50.
- 4 quick cycles (rundown speed/final speed) are pre-programmed in the controller. Torque and/or angle settings are to be updated before use.

2.3 - Memory size

- 5 000 tightening results minimum.

2.4 - Number of curves

10 ratio adjustable curves are stored.

The curves are not displayed on the controller screen, but they can be seen using the CVIPC 2000 software.

2.5 - Communication

CVIL II controllers are equipped of the following communication facilities:

- 1 Ethernet ports for CVIPC or network communication.
- 1 RS232 port to connect barcode readers or CVIPC 2000.
- 7 Logical Inputs and 8 logical Outputs.
- Optional fieldbus module.

2.6 - Tools

The complete range of Torque Control tool (except spindle equipped with second torque transducer) can work with CVIL II controllers. Every tool has a memory. When connecting the tool to a controller, the controller recognises the tool and set automatically all specific parameters.

The selection of the tool takes account of the operating conditions as stated by the user, who shall not exceed the operating limits as specified by the manufacturer at the time of the selection.

Any excessive internal temperature (over 100°C) of the tool electric motor is detected and stops the tool. It can start again only if the temperature decreases below 80°C.

Angle head	ERAL
In-line	ERDL
Pistol grip	ERPL
	ERPS
	ERPLT
Fixed tools	EME
	EMEL
	EME0
Pulse range	ELRT

2.7 - Main differences between versions

Main differences between versions	Normal mode	Pulse mode
Programming Modes		
Cycles	X	X
Quick Cycles	X	-
Learning mode	X	-
Phase characteristics		
Search sequence	X	X
Run down speed	X	X
Final speed	X	X
Run reverse	X	X
Act. On NOK	X	X
Jump	X	X
Prevail. Torque	X	X
Synchr. Waiting	X	X
Empty phase	X	X
Tightening strategies		
Torque	X	X
Torque with angle monitoring	X	X
Angle with torque monitoring	X	X
Stall torque	X	-
Seating detection	X	-
Post. Seat.	X	-

2.8 - CVIPC 2000

CVIPC 2000 is an optional PC software package.

It offers easy and user-friendly programming and real time monitoring of CVIL II controllers.

CVIPC 2000 can be installed on standard PCs running Windows 2000, XP or Vista and communicates with CVIL II controller via ethernet TCP/IP or RS232 port.

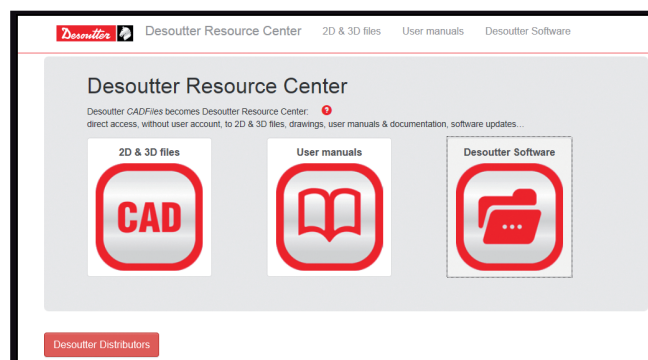
The real time monitoring functions include access to Cpk, curves, operator monitor, etc.

2.9 - CVINET WEB



CVINET WEB is intended to collect & store 100% tightening data in a real-time database with advanced analytics via a web based software in service mode.

2.10 - PC Software evaluation version



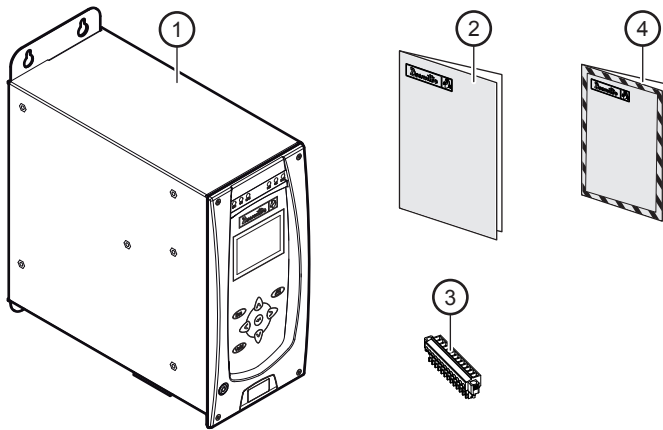
It is possible to download an evaluation version from the following web site:

<http://resource-center.desouttertools.com>

To access to last software up-date, select "Software" tab. No password is required.

3 - DESCRIPTION

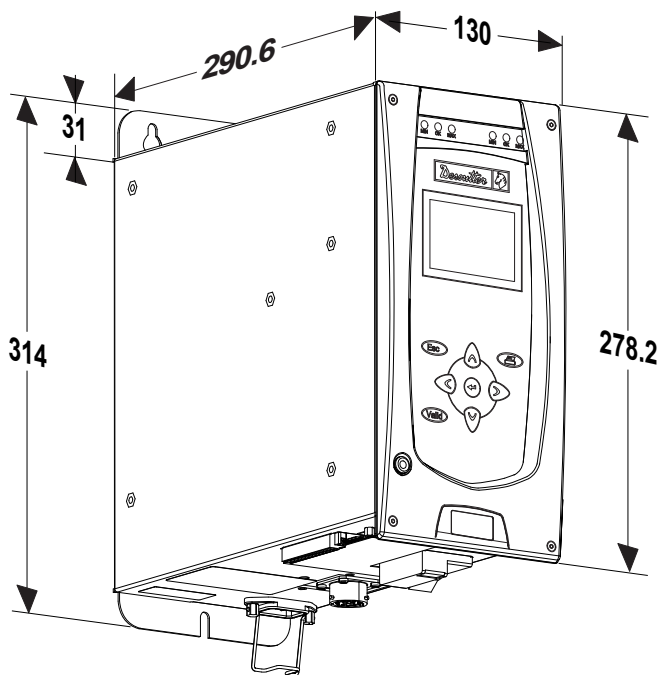
3.1 - Delivered equipment



Legend

- 1 CVIL II box
- 2 Quick start manual
- 3 Input / Output connector with "stop" jumper
- 4 Safety manual

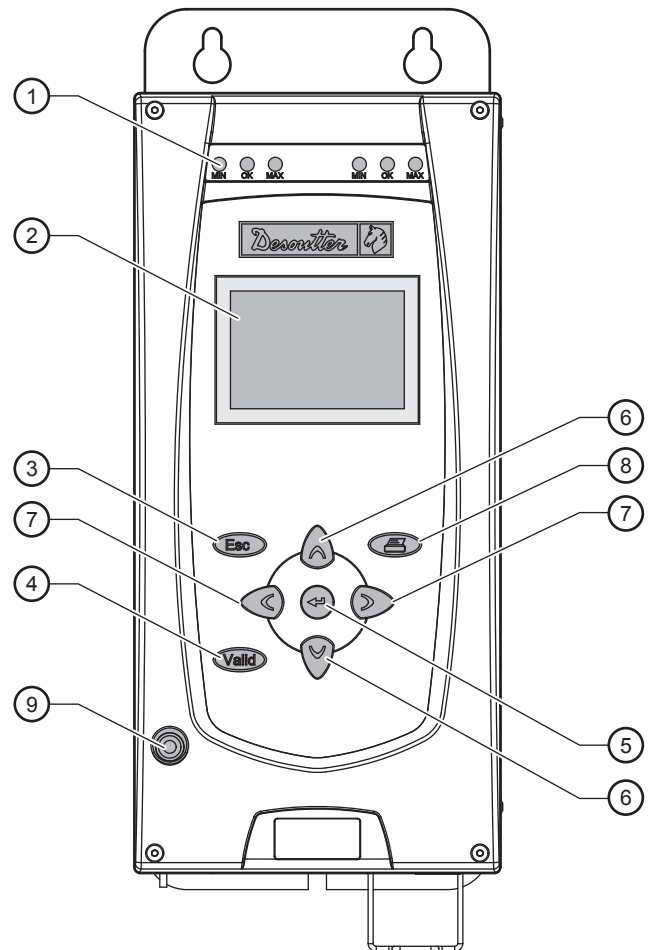
3.2 - Dimensions



3.3 - Characteristics

- Weight: 5.9 kg
- IP40: 6159326800
- IP54: 6159326870
- Working temperature: 0 / +40°C
- Voltage: 85 – 125VAC / 180 – 250VAC single phase, with automatic switching voltage between 110 and 230VAC.
- Frequency: 50 / 60 Hz
- Average power: 0,65 kW
- Power:
 - 3kW (tool cable 5m).
 - 4,5kW (tool cable 35m).

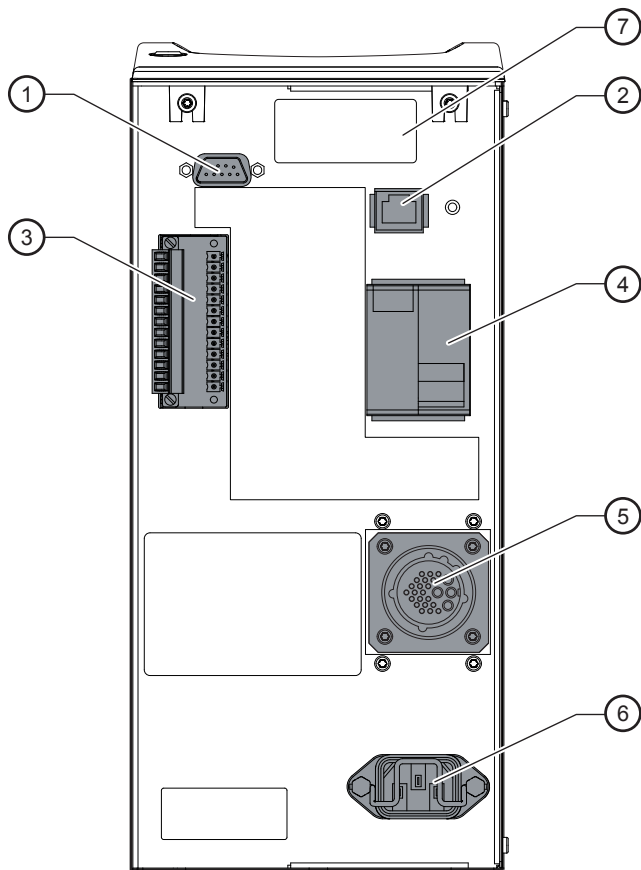
3.4 - Front panel



Legend

- 1 Min, OK, Max Leds for the display of tightening report
- 2 Display
- 3 Escape key to exit a screen without change
- 4 Validate key to exit a screen and save all changes
- 5 Enter key
 - for an alphanumeric value
 - to validate a change
 - to display the next screen
- 6 Up / Down key
 - to scroll through a menu
 - to scroll through a data entry screen
 - to increment digits in digital entry mode
- 7 Left / Right key
 - to scroll through a (lozenge-tagged) list
 - to scroll through a data entry field
 - to enter an alphanumeric value
- 8 Print key
- 9 On/Off mains power indicator

3.5 - Bottom panel



Legend

- 1 RS232 port, SubD 9 points
 - PC cable ref.: 6159170470
 - Printer cable ref.: 6159170110
 - BRDx2 ref.: 6159363280
- 2 Ethernet port
- 3 8 inputs / 8 Outputs connector for PLC or indicator box or socket tray connection, it includes the STOP signal
- 4 ON / OFF switch, over current protection and ground fault protection
- 5 Tool connection
- 6 Mains power inlet
- 7 Field bus module (optional)

4 - INITIAL START UP

4.1 - Installation

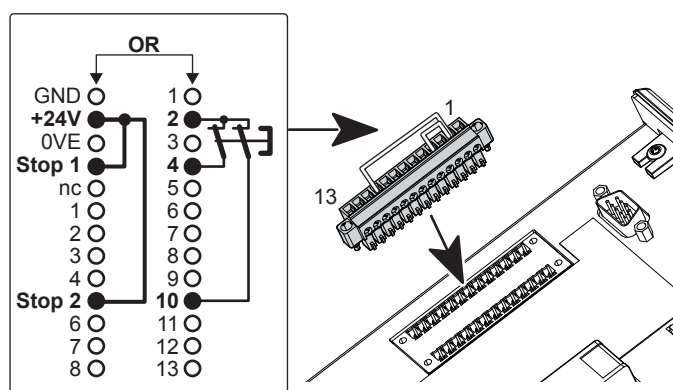


Before switching on, make sure that the controller is installed in accordance with the installation and safety instructions mentioned in this manual, see "Safety instructions", page 5.

4.1.1 - STOP signal

CVIL II controllers are equipped of redundant emergency "STOP" signals which provide a high level of reliability to this function (Category 2, level "d" according ISO 13849 standard).

Check that the "STOP" signals are correctly connected to the Input connector of the controller. The Input connector delivered with the controller is wired so:

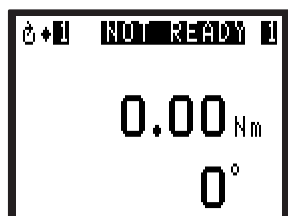


Opening one of the STOP contact disables the power circuit. To be ready and run the controller needs to receive 24V on the 2 inputs "STOP1" and "STOP2". Note that it is recommended to wire an Emergency STOP button when using handheld tools, but that it is absolutely necessary for fixed tools.

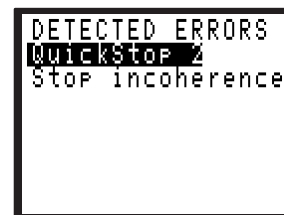
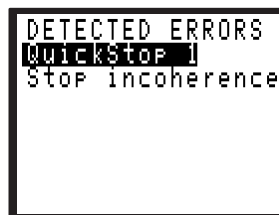
The "Emergency STOP" button should be placed at a convenient place to stop the machine by the operator himself or a colleague in case of emergency.

Getting one of these screens means that the Emergency Stop is open, please check that the jumpers are in place or that the emergency stop button is correctly wired and in the correct position.

When switching on the controller:



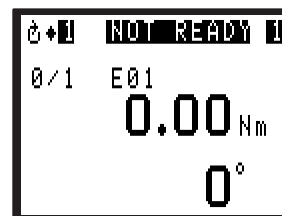
- Press to display the following detailed information:



- When starting the tool:



The tool in fact doesn't run and E01 message appears.

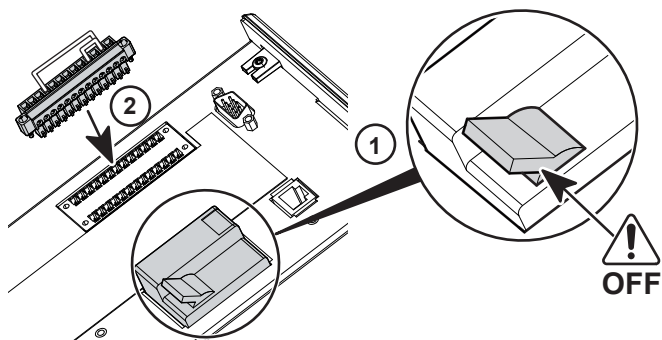


- Pressing you will get similar message as previously.

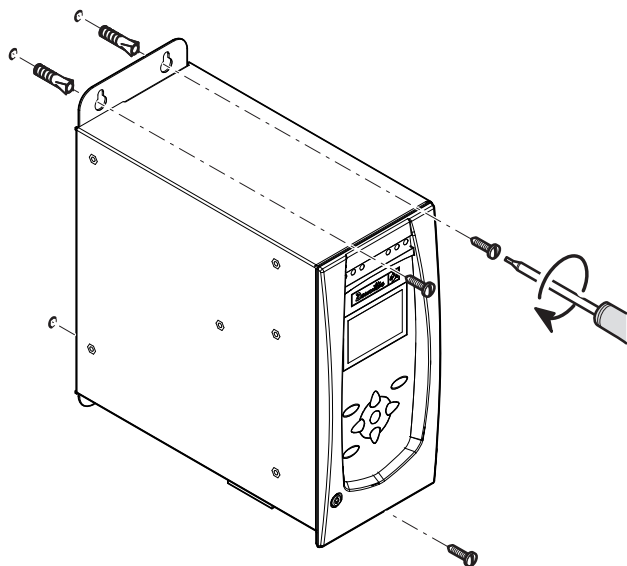
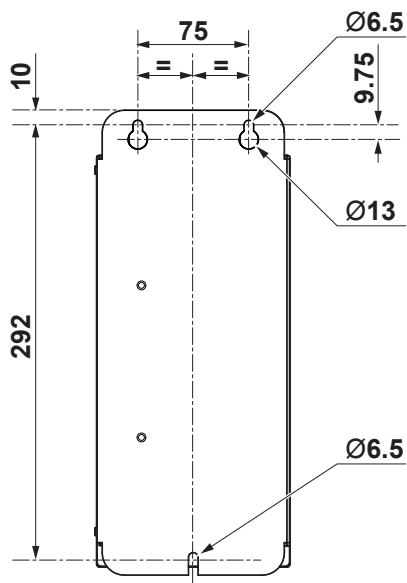


For more information about these messages please report to "Trouble shooting help", page 67.

4.1.2 - Switch OFF



4.1.3 - Wall mounting fixation

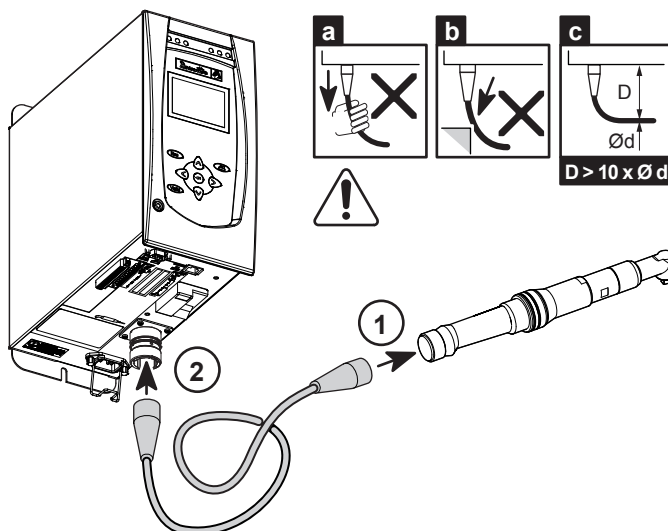


Make sure the fasteners are adapted to support and to the device.

4.1.4 - Tool cable connection



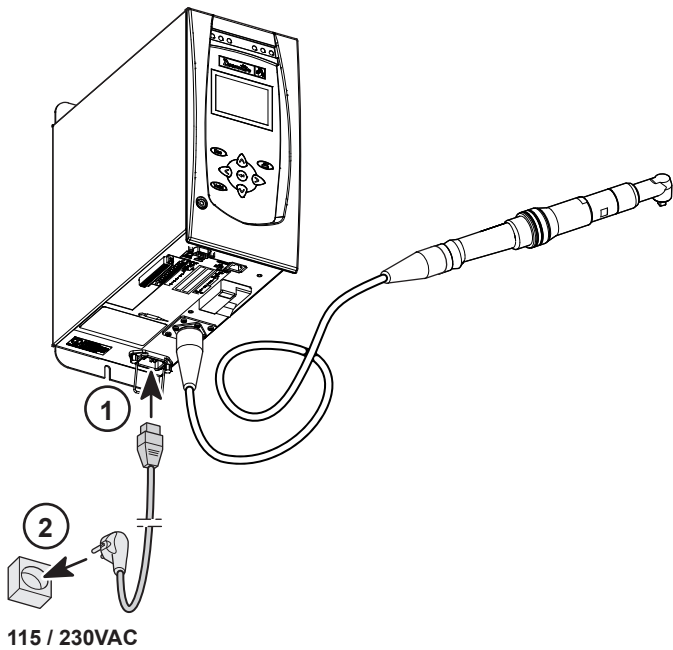
- Do not connect several extension cables together.
- Preferably use the longest length of extension cable and the shortest length of tool cable.
- In case of failure when implementing the extension cables, contact your local Desoutter representative for more information.



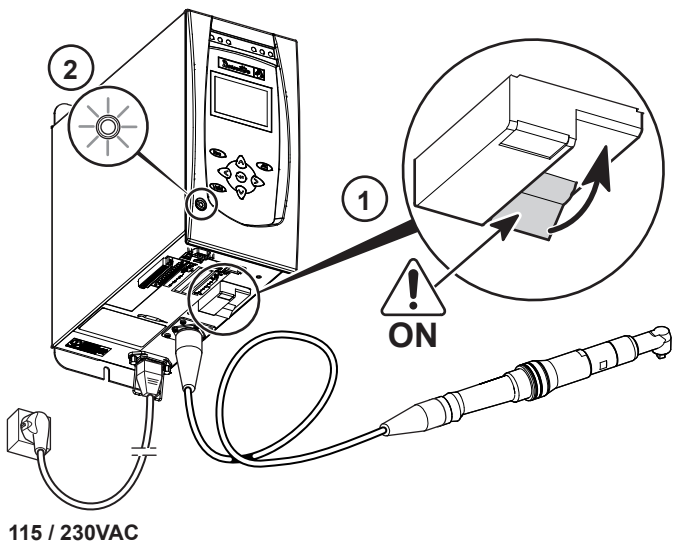
Although our cables are designed to work under drastic conditions, we recommend that you check the following points for longer service life:

- Bending radii should not be lower than 10 times the cable diameter (c).
- Friction with the outer sheath should be restricted (b).
- Any direct pull on the cable should be avoided (a).

4.1.5 - 115/230 VAC cable connection



4.1.6 - Switch ON



4.2 - Start up

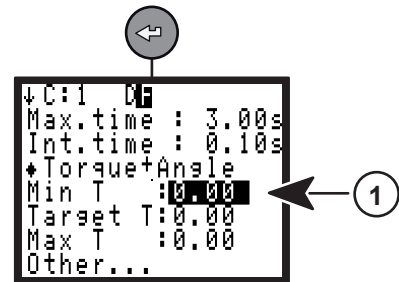
When switched on, the controller automatically detects the correct operation of the tool and of the controller itself.

If everything is OK, the control screen is displayed by the CVIL II.

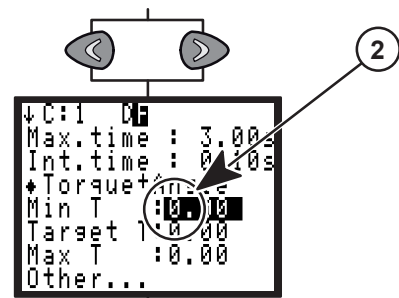
If a problem occurs when the controller is switched on, the screen displays: NOT READY.

Press to display a second screen which provides more details about the cause of the problem.

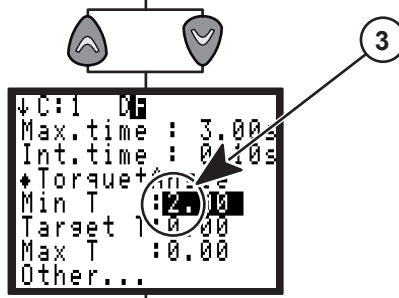
4.2.1 - How to enter or modify an alphanumeric field



- Press to position the cursor under the different field (1).

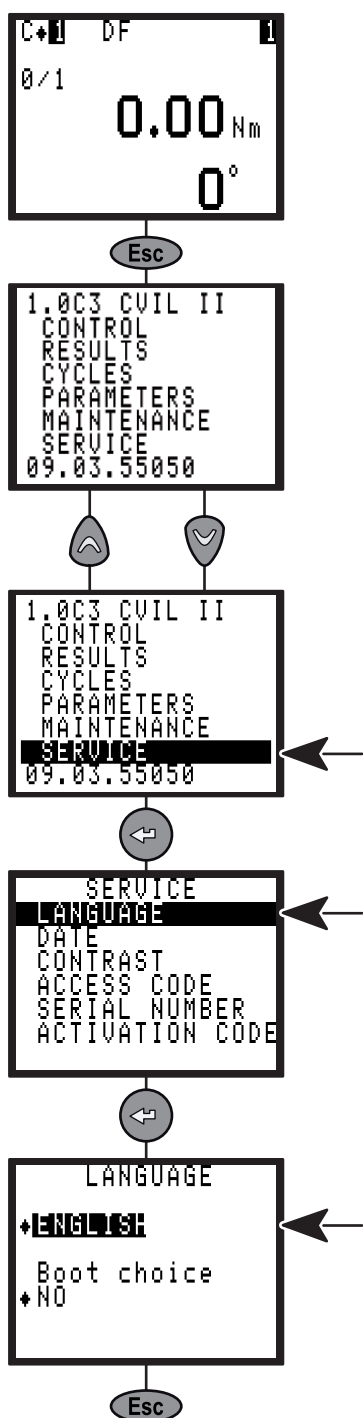


- Press or to position the cursor under the desired character (2).

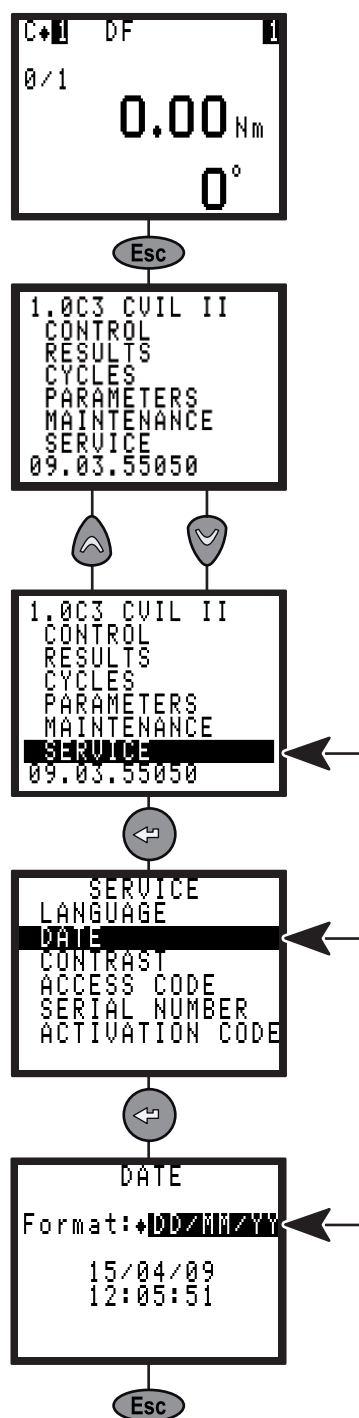


- Press or to change the field (3).
- Press or to position the cursor under the next character.
- When finished, press to validate.

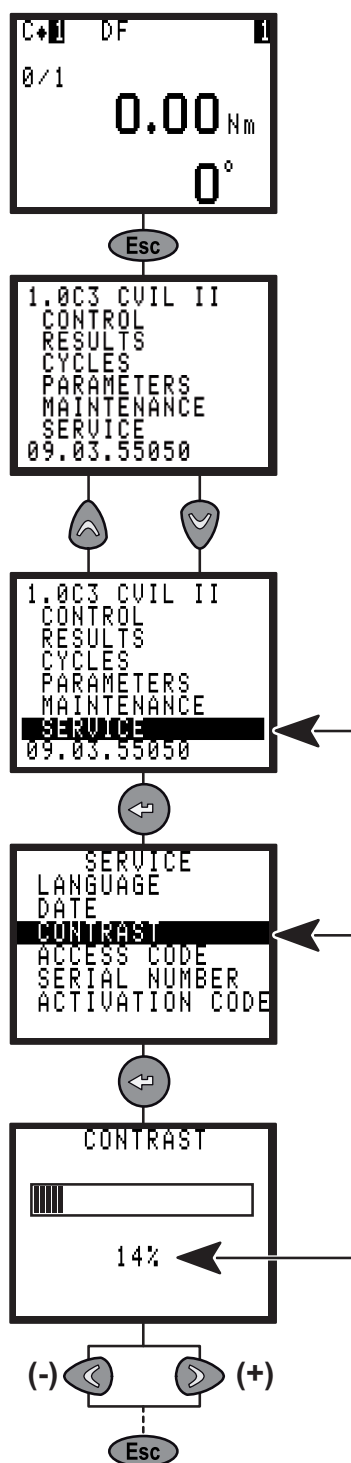
4.2.2 - Language selection



4.2.3 - Setting the date and time



4.2.4 - Contrast adjustment



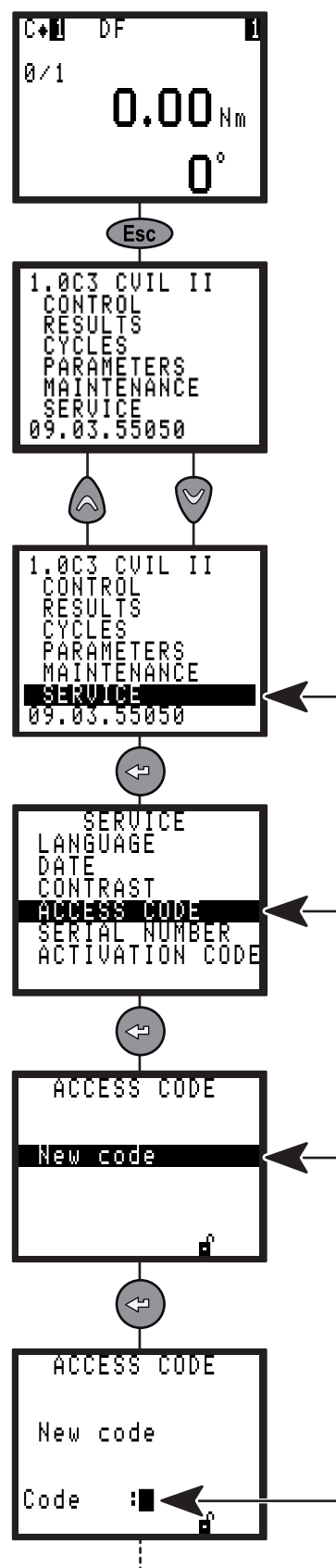
Press or to adjust the contrast and validate.

4.2.5 - Access code

The access code is used to protect the controller against any keying error.

At the time of delivery, no code is programmed; the icon is displayed on the screen.

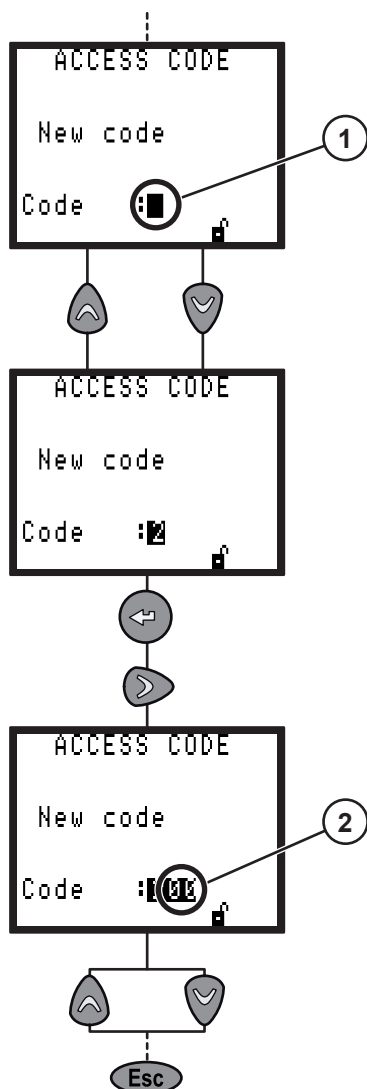
Enter the new code.



4.2.6 - Activation code



8 alphanumeric characters maximum.

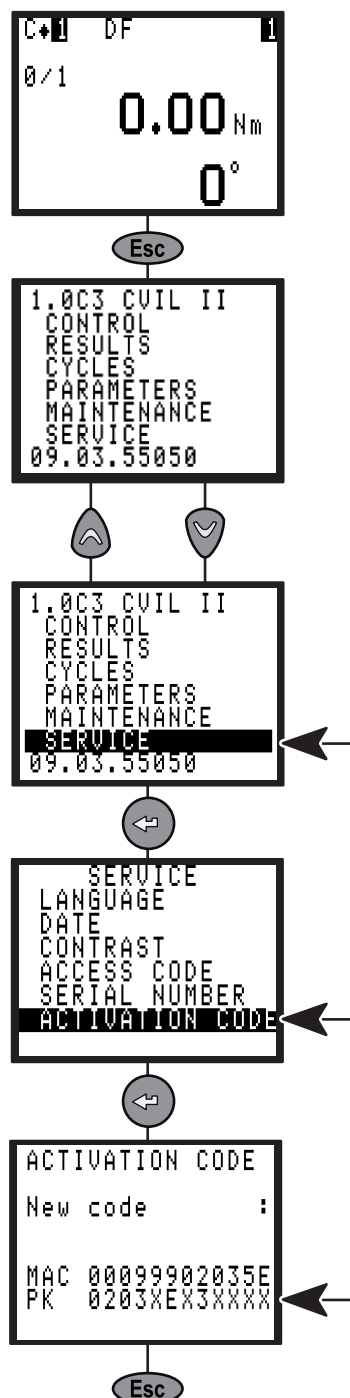


- Press or to write (1).
- Press to validate.
- Press or to position the cursor under the next character (2).

Lock access by entering your code again. The padlock icon will lock meaning that writing is prohibited.



If an access code has been programmed and the operator wants to change the data stored, it is necessary to enter the code each time the controller is switched on.

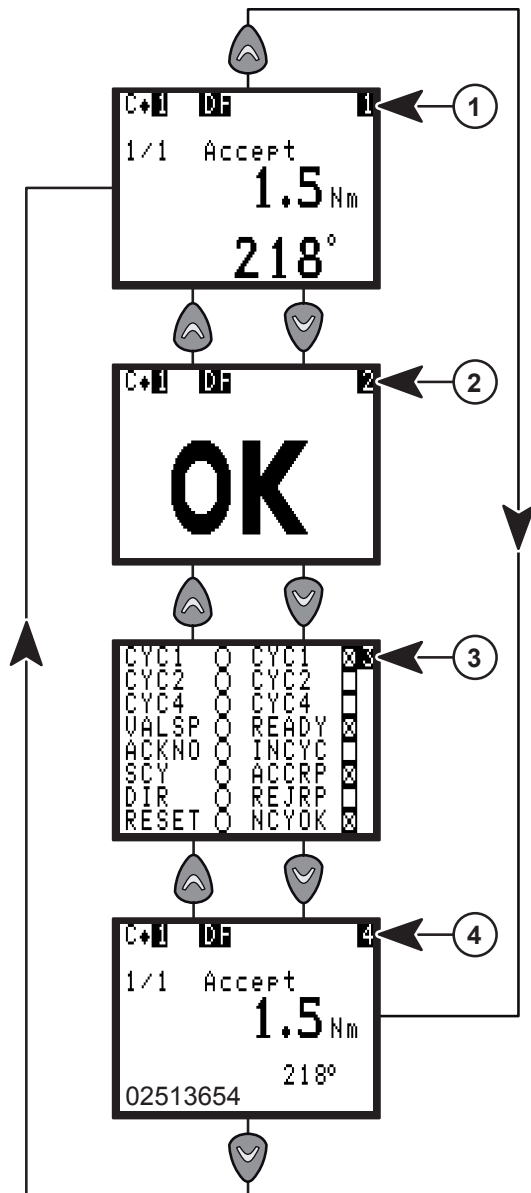


Some controller functionalities are protected by an activation code associated to a software licence.

To get the activation code corresponding to a functionality (for example the communication to a ToolsNet data base), you will need the "PK" number of the controller given in the above example.

After the registration procedure you will get the activation code to be completed in this screen, activating the functionality.

5 - CONTROL SCREENS



- Press to display an additional message providing information on the origin of the fault.
- Press or to move from one screen to another.

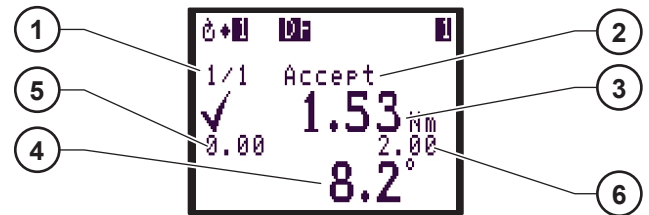


>>> When CVINET or TOOLSNET FIFO alarm threshold is reached, this symbol is blinking at the top of the Control screen.

E09 CVINET FIFO is full.
The cycle can not start because the Locking on when FIFO is full option is validated and there is no free memory space left in the FIFO.
Problem with the Ethernet connection or configuration may be the cause.

e09 CVINET FIFO is full.
The cycle can start but there is no free memory space left in the FIFO.
Problem with the Ethernet connection or configuration may be the cause.

5.1 - Standard screen

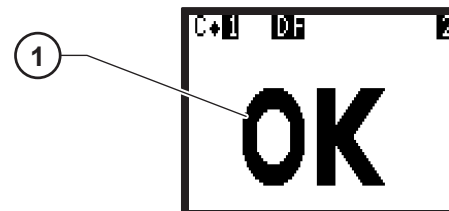


Legend

- Counter
- Status of the NcyOK counter
- Tightening results
- Detailed tightening report
- Min. torque
- Max. torque

This screen displays the tightening results of the last run cycle (3), the detailed tightening report (4) and the status of the NcyOK counter (2).

5.2 - Tightening report

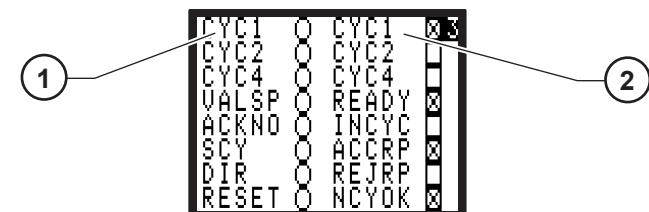


Legend

- Tightening report

This screen displays the tightening report (1) : OK or NOK.

5.3 - Inputs / Outputs

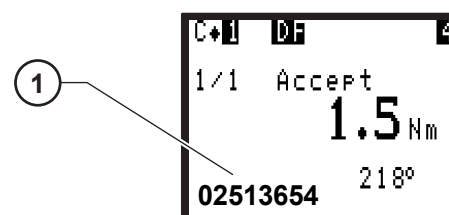


Legend

- Status of inputs
- Status of outputs

This screen provides information on the status of inputs (1) (left-hand column) and outputs (2) (right-hand column) according to tightening report.

5.4 - Barcode reading



Legend

- Result of a bar code reading

This screen displays the result of a bar code reading (1).

5.5 - Maintenance request



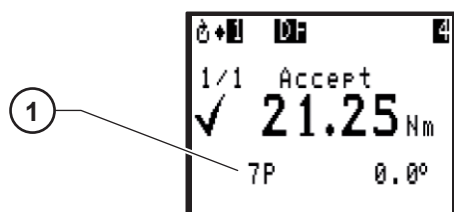
This icon will blink on the Control screen when the maintenance is ON.

Refer to chapter 8.3.8.1 – Maintenance info screen.

5.6 - Number of pulses during the cycle

In the Pulse mode, the number of pulses done during the cycle is displayed on the lower left of the screen.

For example:



Legend

1 Number of pulses

5.7 - Controller temperature



This icon will blink at the bottom right of the Control screen when the controller temperature is higher than 65°C.



If the temperature reaches 70°C, the controller will stop working for safety reasons.

5.8 - Not ready

NOT READY

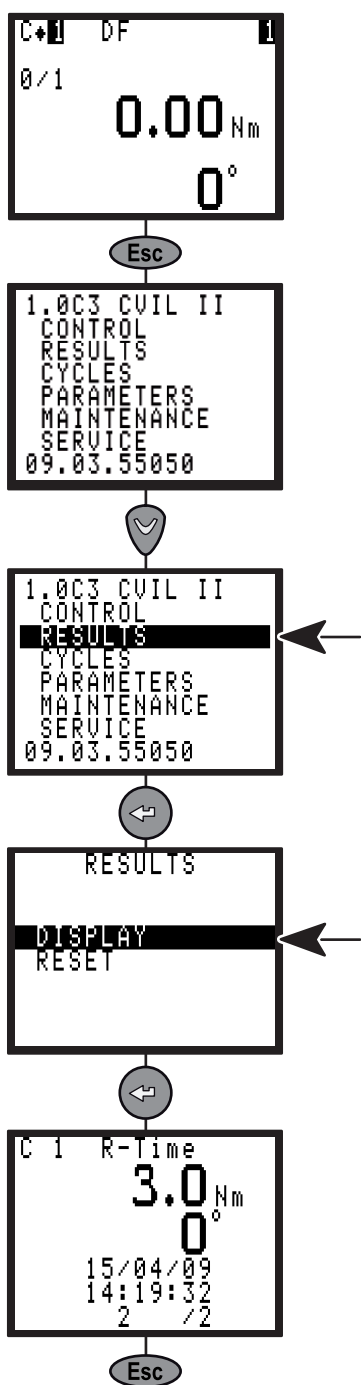
This icon will blink at the top of the screen when an unsupported tool is connected to the controller.



Press this icon to display the message:



6 - RESULTS



This menu allows you to display and delete the tightening results.

7 - PROGRAMMING

7.1 - CYCLES and PARAMETERS menu

The CYCLES menu allows you to:

Action	Menu
Determine the best programming	LEARNING
Change the programming of a cycle in detail	CYCLES
Quickly program a cycle	QUICK CYCLES
Create a sequence	SEQUENCE

The PARAMETERS menu allows you to:

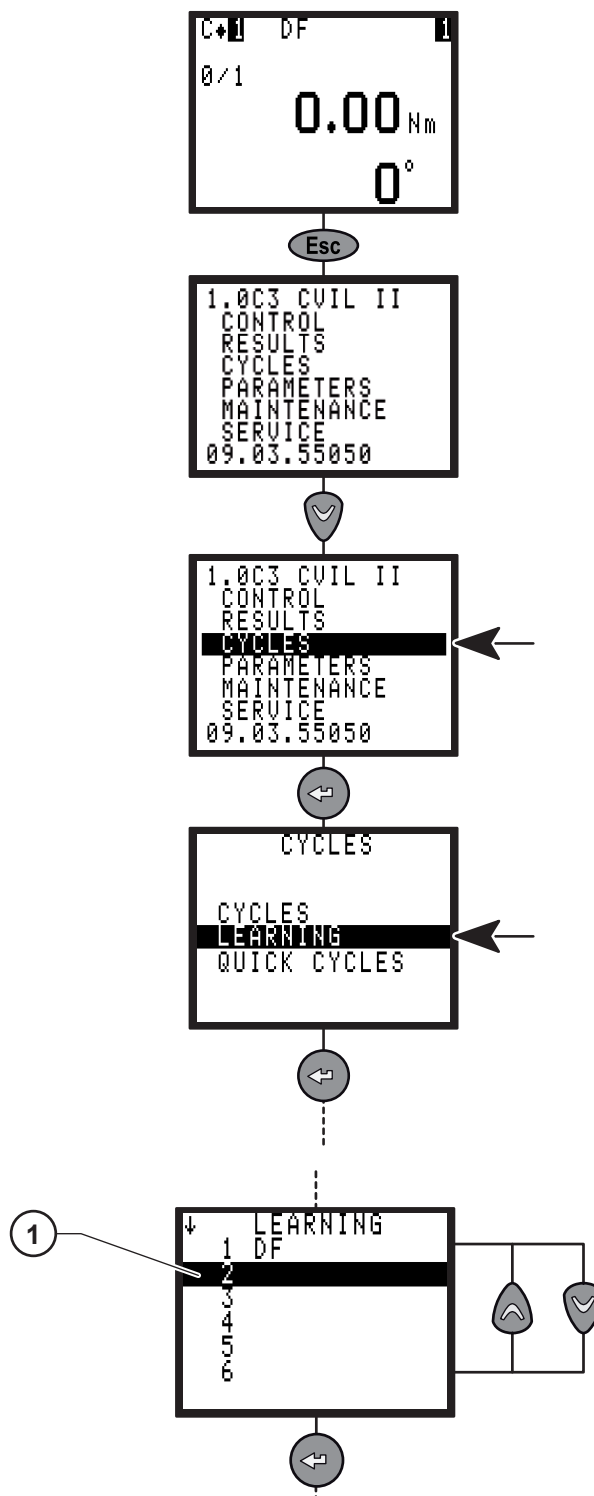
Action	Menu
Display the tool features	SPINDLE
Dedicate the application	STATION
Program the serial port, the report output, the bar code	PERIPHERALS
Program a comment, Bolt number	CONTROLLER
Set up curves	CURVES

7.2 - LEARNING menu

This is a very simple and fast way and to program a cycle for non expert people.

The controller adapts automatically speeds and all other parameters by analysing the joint.

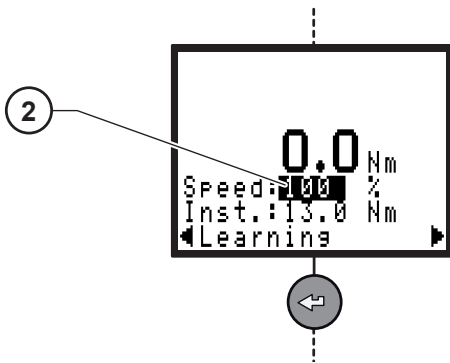
Nevertheless if you are not completely satisfied it is always possible to adjust any parameters using the CYCLES menu.



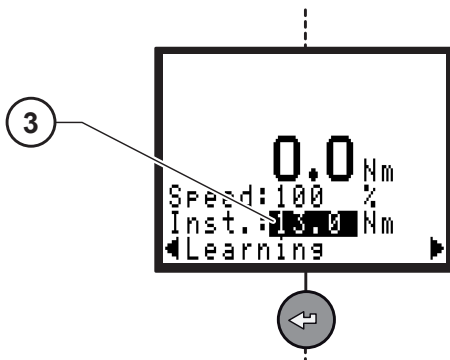
Legend

1 Cycle

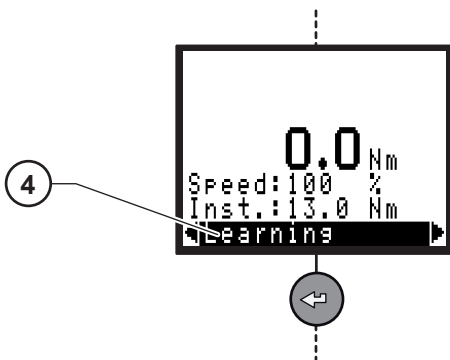
- Press **Up Arrow** or **Down Arrow** to select a cycle.
- Press **Left Arrow** to validate.

**Legend****2 Max speed limit**

- Enter max speed limit (if required).
- Press to validate.

**Legend****3 Final torque**

- Enter final torque.
- Press to validate.

**Legend****4 Learning**

- Perform 3 tightening operations.
- Press to validate.

7.3 - CYCLES menu**7.3.1 - Introduction**

The CYCLES menu allows you to change or create the programming of the cycles.

A tightening cycle consists of a sequence of phases run consecutively.

Each phase is defined by main parameters and tightening instructions according to the selected type of tightening and motor settings.

Various phases available in a cycle	Letter	Normal mode	Pulse mode
Search sequence	S	X	X
Run down speed	D	X	X
Final speed	F	X	X
Run reverse	R	X	X
Act. on NOK	V	X	X
Jump	J	X	X
Prevail. Torque	P	X	X
Synchr. waiting	W	X	X
Empty phase		X	X

The procedure for programming the cycle can be broken down as follows:

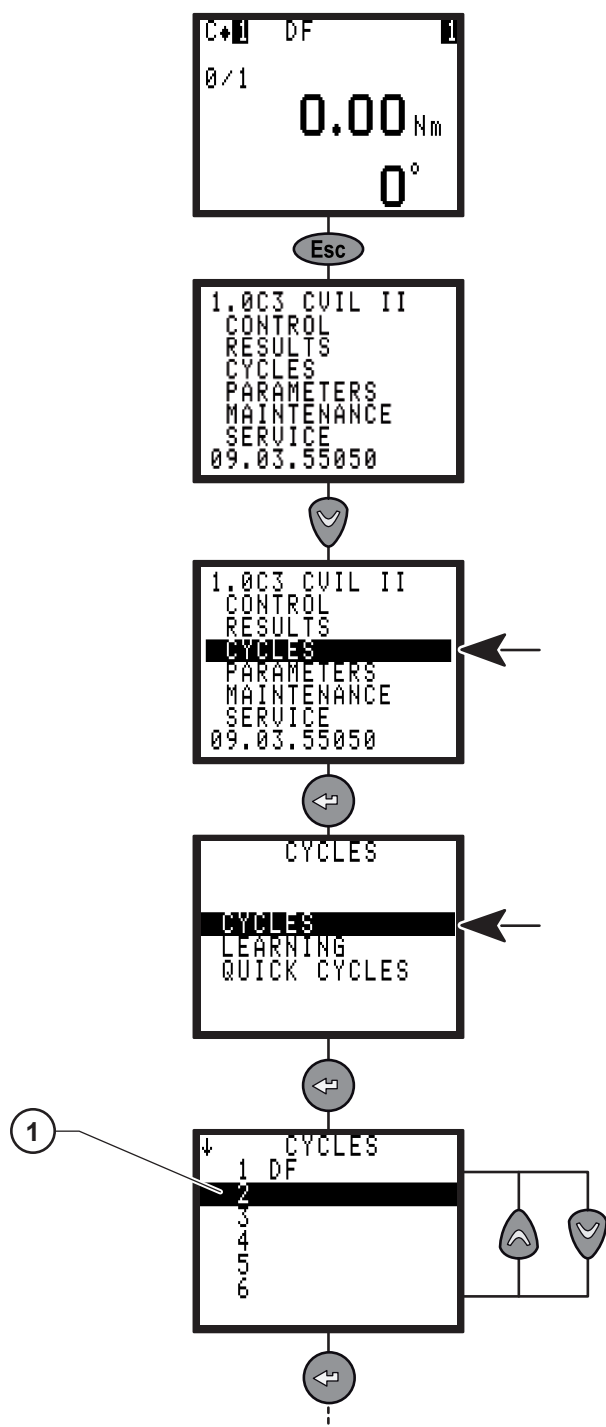
- Selecting the station mode: Normal / Pulse.
Refer to chapter 7.7.1.



Change station
mode WARNING,
Cycles will be
erased.
INL YES

- Selecting the cycle.
- Selecting and sequencing the phases.
- Programming the parameters of each phase.
- Selecting an Action on NOK or not.
- Entering a comment.
- Programming the Number of cycles OK.

7.3.2 - Selecting the cycle



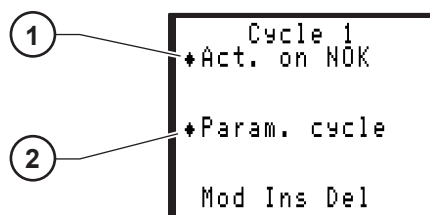
Legend

1 Cycles

The list of the already programmed cycles is displayed.

- Press or to select a cycle (1).
- Press to validate.

7.3.3 - Cycle general parameters



Legend

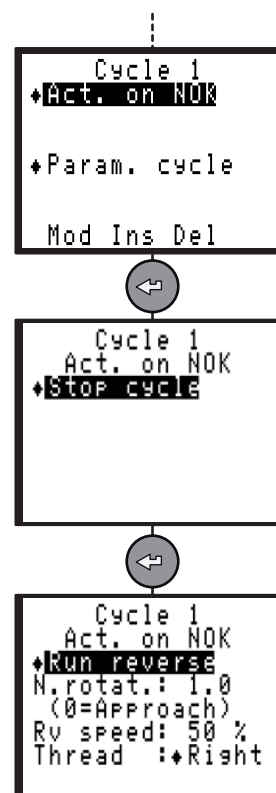
1 Action on NOK

2 Parameters cycle

7.3.3.1 - Programming the action on NOK for each cycle

Associated with the cycle, this menu allows you to detect anomalies at various stages of the tightening cycle. As soon as a reject report is emitted by a phase (Approach, Final speed phase, Run Reverse, Prevailing torque) one of the following actions can be performed.

- Stop the cycle at this phase.
- Stop the cycle then run reverse a given number of rotations.



This menu is used as an alternative to the insertion of an Action on NOK Phase, with the following advantages:


- Sequencing of a cycle (Approach, Run Down Speed, Final Speed) without inter-phase stop.
- No additional phase.
- A single programming to monitor all the stages of the tightening cycle.

Except for the approach phase, this action on NOK is performed only if an inter-phase time is programmed.



Warning: when used with hand held tools, programming an action on NOK with run reverse may be dangerous for the operator.

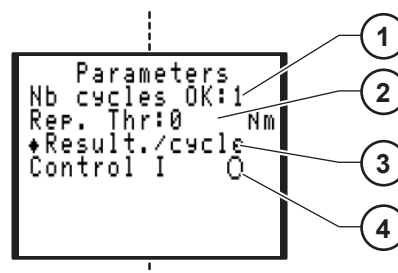
Select the relevant action:

Parameter	Comment
Unused	The option is disabled.
Stop cycle	As soon as one of the torque or angle parameters is out of tolerances at the end of one of the phases, the cycle stops at the end of this phase.
Run reverse	<p>The cycle stops under the same circumstances as in the Stop Cycle option, then the tool un-tightens with the programmed number of rotations.</p> <ul style="list-style-type: none"> Number of rotations: <ul style="list-style-type: none"> - 1 – 9 Run reverse speed: <ul style="list-style-type: none"> - 50% by default. <p> In the Pulse mode, the "Run reverse speed" is set to 30% by default.</p> <ul style="list-style-type: none"> Thread: <ul style="list-style-type: none"> - Right / Left.
Rv speed	Run reverse speed associated with an action on NOK per cycle or per phase.
Thread	Right / Left.
Time	Time to run reverse.



When an action on NOK phase has been programmed, it will be processed as a priority with respect to the action on NOK of the cycle.

7.3.3.2 - Parameters cycle (in Normal mode)



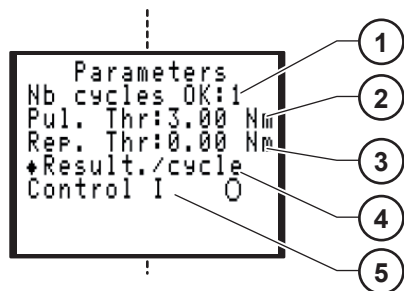
Legend

- 1 Nb of cycles OK
- 2 Report threshold value
- 3 Control current strategy
- 4 Results strategy

Select the relevant action:

Parameter	Comment
Nb cycles OK	Number of correct cycles to activate the NCYOK output.
Rep. Thr	Torque threshold value to allow to send a cycle report.
Result./	<p>Cycle: Report is generated when cycle is completed.</p> <p>Phase: Report is generated any time a phase is completed.</p>
Control I	<p>(●) Enabled (Yes): Torque and current are evaluated to generate cycle report.</p> <p>() Disabled (No): Only torque is evaluated to generate cycle report.</p>


7.3.3.3 - Parameters cycle (in Pulse mode)



Legend

- 1 Nb of cycles OK
- 2 Pulse threshold (Pulse mode)
- 3 Report threshold value
- 4 Results strategy
- 5 Control current strategy

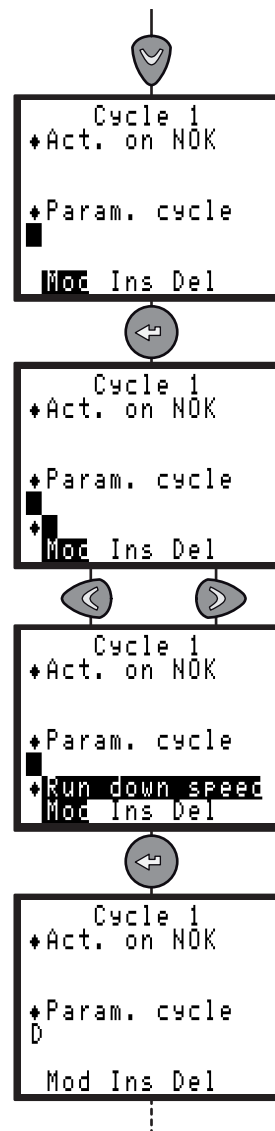
Select the relevant action:

Parameter	Comment
Nb cycles OK	Number of correct cycles to activate the NCYOK output.
Pul. Thr	<p>The Pulse mode allows to do both continuous and pulse tightening with the same tool within the same phase. The transition from continuous to pulse is done automatically when the torque is higher than the pulse threshold. In opposite, the transition from pulse to continuous is done automatically when the torque is lower than the pulse threshold.</p> <p> The pulse threshold cannot be higher than the tool max torque continuous.</p> <p>This functionality is available for the following phases:</p> <ul style="list-style-type: none"> • Rundown speed. • Final speed (Torque, Torque + angle, Angle + torque). • Run reverse (Torque, Torque + angle, Angle + torque). <p>By default: 3 Nm. When the ELRT tool is connected, set the value from 0 to 4.8 Nm. If the pulse threshold is above, the error "Prg" will be displayed at cycle start.</p>
Rep. Thr	Torque threshold value to allow to send a cycle report.
Result./	<p>Cycle: Report is generated when cycle is completed.</p> <p>Phase: Report is generated any time a phase is completed.</p>
Control I	<p>(●) Enabled (Yes): Torque and current are evaluated to generate cycle report.</p> <p>() Disabled (No): Only torque is evaluated to generate cycle report.</p>

7.3.4 - Programming the phase

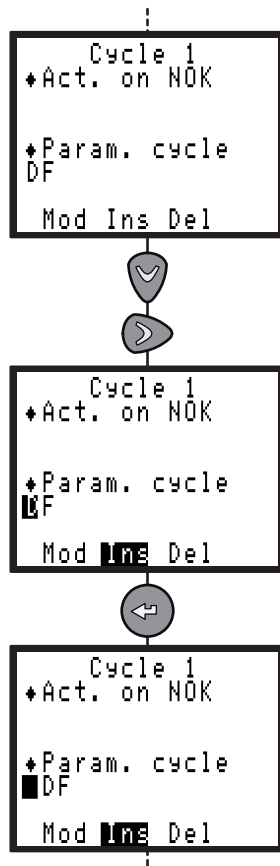
After selecting a cycle, the cursor will move to the line where the various phases of the selected cycle are shown. You will be allowed to modify, insert or delete a phase.

7.3.4.1 - Creating (or changing) a phase



7.3.4.2 - Inserting a phase

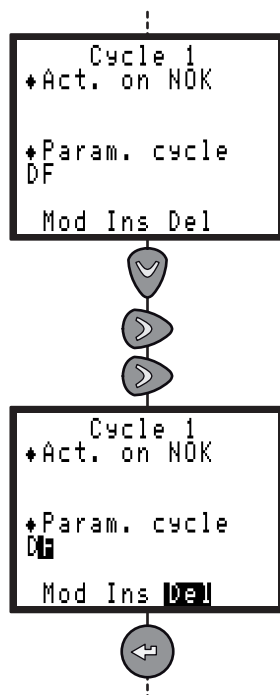
- Create a blank before the phase before which you want to insert a new phase:



- Proceed as before to create a phase.

7.3.4.3 - Deleting a phase

- Position the cursor on the phase that you want to delete.



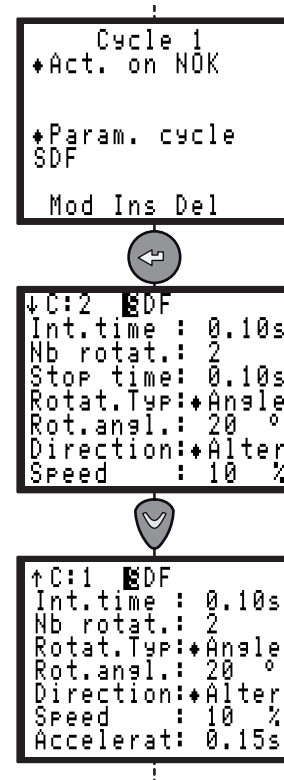
7.3.5 - Programming the parameters

- Using and , position the cursor on the phase whose parameters you want to program.
- Press to validate.

7.3.5.1 - Search sequence phase (Normal mode and Pulse mode)

This phase may be useful to insert the bolt head in the socket.

It allows rotating slowly the socket in one direction or the other or alternatively to a predefined angle or time.



The maximum time is simply displayed for the search sequence phase as it implicitly equals the number of rotations multiplied by the rotation time + stop time.

Parameter	Comment
Int.time	Time programmed between this phase and the next one: 0 - 20 s.
Nb rotat.	Number of rotations: 1 - 9.
Stop time	Stop time: 0 - 20 s.
Rotat.Type	Rotation type: Time / Angle.
Rot.time or Rot angl.	Rotation time: 0 - 50 s / rotation angle: 0 - 9,999°.
Direction	Right / Left / Alter. If the direction is alternate, half the rotations are clockwise and the other half are in the opposite direction.
Speed	Rotational speed: 0 - 100%.
Accelerat	0 - 20 s. Acceleration or deceleration time to switch from one speed to another, this parameter is enabled for the first phase and when the inter-phase time is not equal to zero. When the inter-phase time is equal to zero, acceleration is automatically optimized.

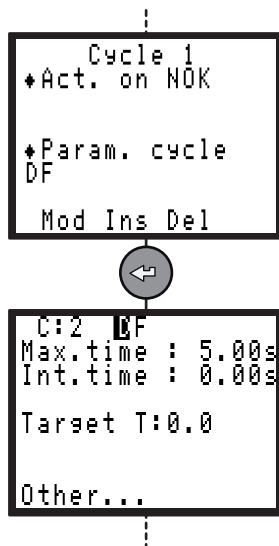
Parameter	Comment
Power	1 - 100%

7.3.5.3 - Final Speed Phase (Normal mode and Pulse mode)



No result for this phase.

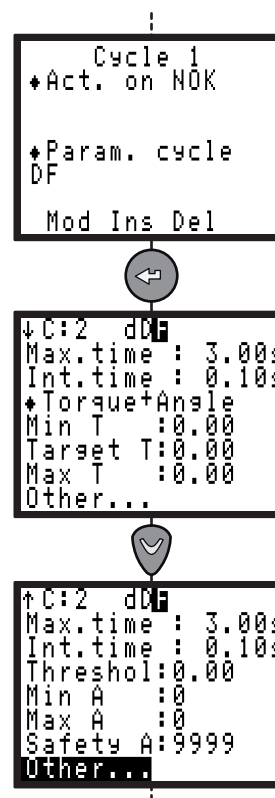
7.3.5.2 - Run Down Speed Phase (Normal mode and Pulse mode)



Parameter	Comment
Max.time	Maximum phase running time: 0.01 - 99 s.
Int.time	Time programmed between this phase and the next one: 0 - 20 s.
Target T	Target torque: 0 Nm to maximum value of the spindle (screw approach torque).
Other...	See Motor parameters.



No result for this phase.



Parameter	Comment
Max.time	Maximum phase running time: 0.01 - 99 s.
Int.time	Time programmed between this phase and the next one: 0 - 20 s.
Tightening strategy	Torque / Torque + Angle. Angle + Torque. Stall torque. Seating. Post-seating.
Min T	Minimum torque: 0 Nm to maximum value of the spindle.
Target T	Target torque: 0 Nm to maximum value of the spindle.
Max T	Maximum torque: 0 Nm to maximum value of the spindle.
Threshold	Angle threshold: 0 Nm to maximum value of the spindle.
Latch angle	The angle reading can be stopped in each individual phase in a cycle. There are 3 different settings: <ul style="list-style-type: none"> • Threshold (by default): the controller starts measuring the angle when the torque is above the torque threshold, even after the motor stop. • Motor stop: the angle is not read anymore after the motor stop. • None: no latch angle.
Min A	Minimum angle: 0 - 9,999°.
Max A	Maximum angle: 0 - 9,999°.
Safety A	Safety angle: 0 - 9,999°.

Parameter	Comment
Stall time	0.000 - 9.990 seconds.
Other...	See motor parameters

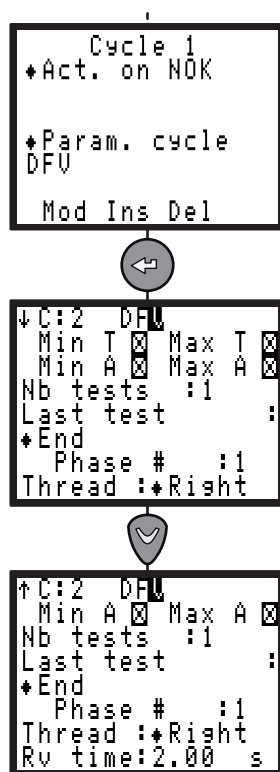


Detailed RP: See "Tightening strategy guide", page 60.

7.3.5.4 - Action on NOK Phase (Normal mode and Pulse mode)

When a report is rejected (max. torque or angle reached, etc.), it is possible to apply a specific corrective action to the cycle, either by stopping the cycle or by programming a corrective phase.

For example: untighten the screw, repeat tightening, etc.



You must first choose:

- The fault(s) to which you want to apply a corrective action.
- The number of tests (from 1 to 99).

Various actions on NOK are available:

Parameter	Comment
End	To stop the tightening cycle.
Rrv.+End	A Run Reverse phase is run according to the programmed time then the cycle is stopped.
Jump	The cycle proceeds to the indicated phase.
Rrv.+Jump	A run reverse phase is run according to the programmed time, then the cycle proceeds to the indicated phase.
Thread	Right / Left.
Rv time	Run reverse time: 0 - 99 s



No phase RP.

7.3.5.5 - Run reverse phase (Normal mode and Pulse mode)

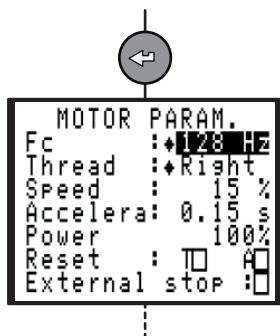


Parameter	Comment
Max.time	Phase running time out: 0.01 - 99 s.
Int.time	Time programmed between this phase and the next one: 0 - 20 s.
Strategy	Torque/Torque+Angle/Angle+Torque.
Min T	Minimum torque: 0 Nm to maximum value of the spindle.
Target T	Target torque: 0 Nm to maximum value of the spindle (torque or torque + angle strategy).
Max T	Maximum torque: 0 Nm to maximum value of the spindle.
Safety T	Safety torque: 0 Nm to maximum value of the spindle.
B-away T	Breakaway torque: starts the torque control (strategies: torque or torque + angle), must be higher than final torque.
Threshol	Angle threshold: 0 Nm to maximum value of the spindle.
Min A	Minimum angle: 0 - 9,999°.
Target A	Target angle: 0 - 9,999° (angle + torque strategy).
Max A	Maximum angle: 0 - 9,999°.
Other...	See motor parameters.

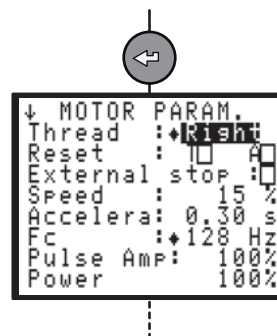


Detailed RP: See "Tightening strategy guide", page 60.

7.3.5.6 - Motor parameters (Normal mode)



7.3.5.7 - Motor parameters (Pulse mode)

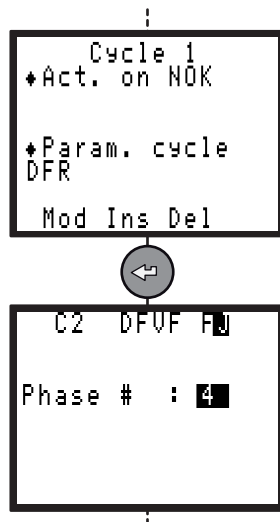


Parameter	Comment
Fc	Bandwidth adjustment from 4 to 512 Hz. 128 Hz by default. Reducing this value allows you to filter the defects in the Torque signal and improve the dispersion of the torque installed (Cp or Cam), which may be useful in particular when using a Crowfoot head. Warning: as a result, the adjustment of the torque (Cpk) may be modified. It can be adjusted by calibrating the tool on the assembly ("CALIBRATION menu", page 48).
Thread	Right / Left.
Speed	Rotational speed: 0 - 100%. 15% by default.
Accelera	0 - 20 s. 0.30 s by default. Acceleration or deceleration time to switch from one speed to another, this parameter is enabled for the first phase and when the inter-phase time is not equal to zero. When the inter-phase time is equal to zero, acceleration is optimized automatically.
Power	100% by default.
Reset	The Reset function allows you to reset the torque and/or angle values at the beginning of the current phase.
External stop	Yes/No. The following conditions must be met for the system to stop the current phase and shift to the next one: <ul style="list-style-type: none"> The External Stop parameter must be on Yes in this screen. The signal at the External Stop input of the Input/Output connector must shift to 1.

Parameter	Comment
Thread	Right / Left.
Reset	The Reset function allows you to reset the torque and/or angle values at the beginning of the current phase.
External stop	Yes/No, the following conditions must be met for the system to stop the current phase and shift to the next one: <ul style="list-style-type: none"> The External Stop parameter must be on Yes in this screen. The signal at the External Stop input of the Input/Output connector must shift to 1.
Speed	Rotational speed: 0 - 100%. 15% by default.
Accelera	0 - 20 s. 0.30 s by default. Acceleration or deceleration time to switch from one speed to another, this parameter is enabled for the first phase and when the interphase time is not equal to zero. When the inter-phase time is equal to zero, acceleration is optimized automatically.
Fc	Bandwidth adjustment from 4 to 512 Hz. 128 Hz by default.
Pulse Amp (except for Prevailing torque)	0 - 115%. 100% by default. Amplitude of the pulse command.
Power	100% by default.

7.3.5.8 - Jump to another phase (Normal mode and Pulse mode)

This phase allows you to design more sophisticated cycles. For example: D F1 V1 F2 — F3 J1



D	Phase 1	Run down speed
F1	Phase 2	Final speed
V1	Phase 3	Action on NOK: IF NOK, jump to phase 6 (F3) ELSE run phase 4 (F2), then stop the cycle
F2 P	Phase 4	Final speed
—	Phase 5	Empty phase: the cycle is stopped
F3	Phase 6	SCY phase in case of NOK on phase 2 (V1)
J1	Phase 7	Jump to phase 4 (F2) to finish



No phase RP.

7.3.5.9 - Prevailling Torque Phase (Normal mode and Pulse mode)



In Pulse mode, the prevailing tightening is limited to the tool max. continuous torque (for example: 6 Nm for the ELRT25 tool).
The message "Prg" is displayed when the safety torque is higher than the max. continuous torque.

This phase allows you to monitor the load moment (prevailing torque) of a screw or nut.

The initial time out (expressed in time or angle) allows you to eliminate the shock pulse when starting the motor and the mechanism.



Parameter	Comment
Max.time	Phase running time out: 0.01 - 99 s.
Int.time	Time programmed between this phase and the next one: 0 - 20 s.
Target A	Target angle: 0 - 9,999°.
Min T	Minimum torque: 0 Nm to max. value of the spindle.
Max T	Maximum torque: 0 Nm to max. value of the spindle.
Safety T	Safety torque: 0 Nm to max. value of the spindle.
Start typ	Type of start: Time / Angle.
Rot.angl. or Rot.time	Rotation Angle or Time: 0-9,999° or 0 - 20 s.
Directio	Direction: Right/Left.
Speed	Rotational speed: 0 - 100%.
Accelerat	0 - 20 s.
Reset: Angle	Yes / No
Reset: Torque	Yes / No
Offset	Ignore/Add/Substract
External stop	Yes / No - The following conditions must be met for the system to stop the current phase and shift to the next one: <ul style="list-style-type: none"> The External Stop parameter must be on Yes in this screen. The signal at the External Stop input of the Input/Output connector must shift to 1.



Detailed RP: See "Tightening strategy guide", page 60.

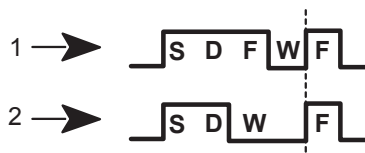
7.3.5.10 - Synchro Waiting Phase (Normal mode and Pulse mode)

This phase allows you to synchronize the phases of several controllers. To synchronize several controllers, you must program a waiting phase for each controller and use the Synchro signals (see "INPUT / OUTPUT configuration", page 33).

Principle:

Each controller reports to the others that it has reached its waiting phase by resetting to 0 the Synchro signal.

Then it waits until the other controllers reach their own waiting phase by scanning the Synchro input.

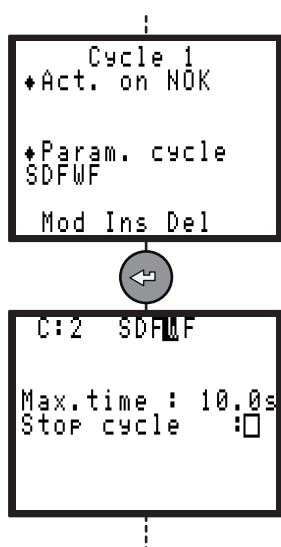


Legend

- 1 Controller n° 1
2 Controller n° 2

In the example, the controller no. 2 runs the beginning of the cycle (Search Sequence, Run Down Speed), then waits until the controller no.1 has completed its phases (Search Sequence, Run Down Speed, Final Speed) to run together the end of the cycle.

After a 10 s delay (max. time programmed by default), the controller continues or stops the cycle.



7.4 - Sequence menu

A sequence is a chain of cycles.

The CVIL II can comprise one sequence only and this sequence can be made up of 8 cycles as a maximum.

During the course of the sequence, when the active cycle is valid, the sequence advances. If not it stops on the cycle in progress.

- Before creating the sequence, go to the [Station] menu to activate the parameter [Sel. Sequence].

```

↓ STATION PARAM.
Name:

Mode      :+Pulse
Unit      :+Nm
Cyc.Src   :+Keypad
Tool En   :+None
Sel.sequence  @
  
```

- Go in the [Cycles] menu to create the sequence.

```

SEQUENCE
#
Cycle    :+01  *004
Cycle    :+02  *001
Cycle    :+End
  
```

In this example, the cycle no. 01 will start the sequence and will be repeated 4 times (as its "Nb cycles OK" parameter is set at 4).

It is possible to name the sequence by adding a comment on the 1st line.

When the "Lock.NbCyOK" parameter in the [Station] menu is set at "yes", the tool is locked at the end of the sequence.

At the end of a successful sequence, the output "Sequence OK" (SEQOK) is set to 1.

```

↓ OUTPUTS
01      :+SEQOK
02      :+CYC2
03      :+CYC4
04      :+READY
05      :+INCYC
06      :+ACCRP
07      :+REJRP
  
```



No phase RP.

7.5 - QUICK CYCLES menu

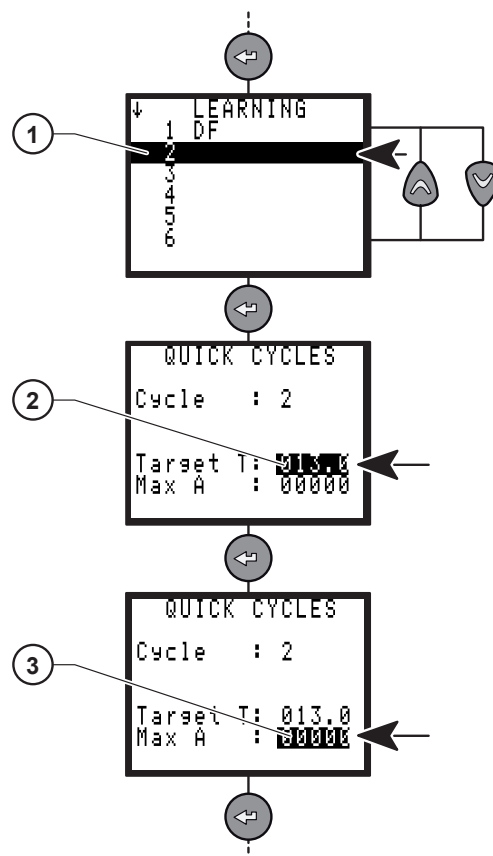
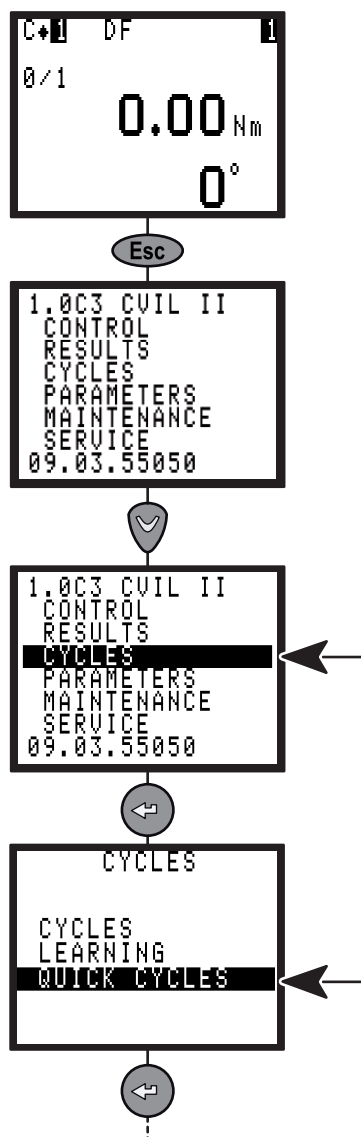
This menu allows you to quickly program the cycles.

By default, the quick cycles consist of a run down speed and final speed phase.

The operator only programs the target torque and the maximum angle on the screen.

It is the controller itself which calculates the speeds and all of the other default parameters.

Nevertheless if you are not completely satisfied it is possible to adjust any parameters using the CYCLES menu.



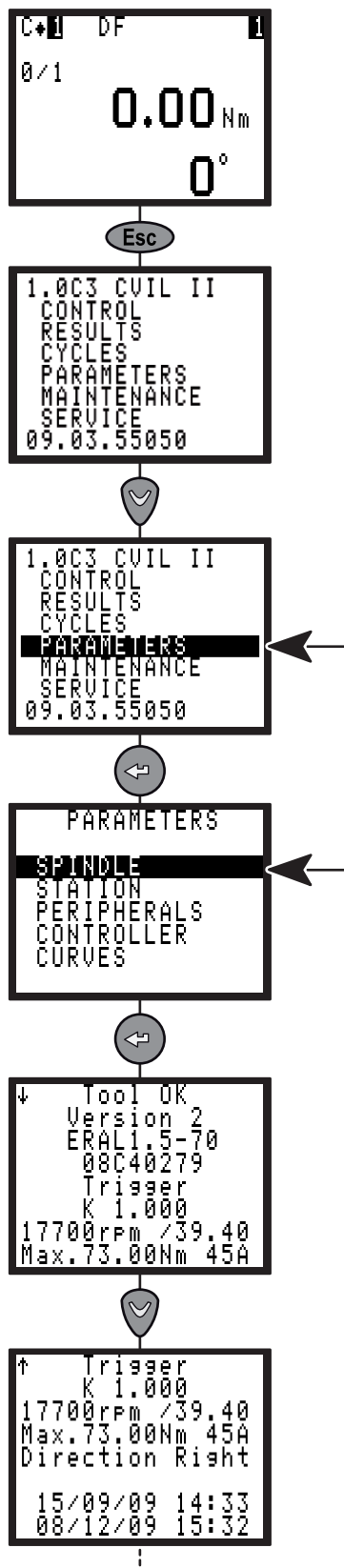
Legend

- 1 Cycle
- 2 Final torque
- 3 Max angle

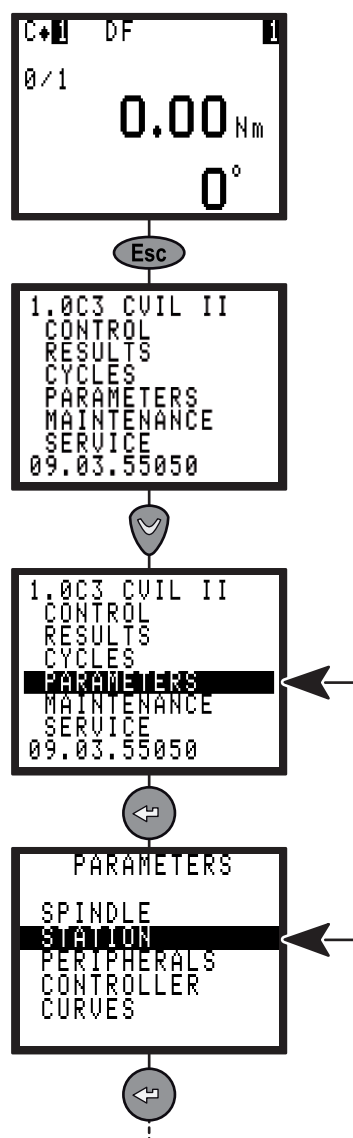
- Press or to select a cycle (1).
- Press to validate.
- Enter final torque (2).
- Press to validate.
- Enter max Angle (3).
- Press to validate.

7.6 - SPINDLE menu

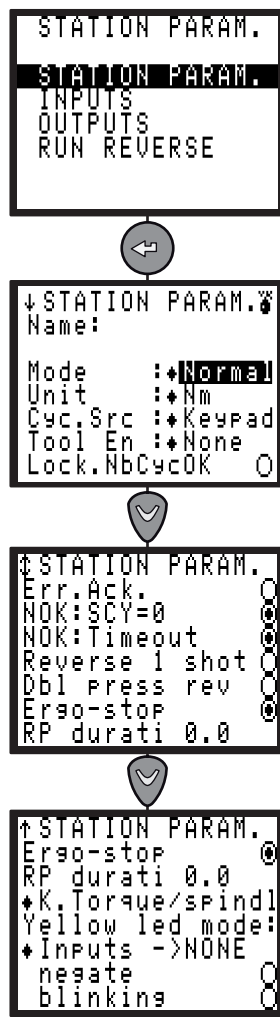
This menu displays controller and tool identification and characteristics.




7.7 - STATION menu



7.7.1 - STATION – General parameters



Screen name	By default	Comment
Name	-	Possibility to associate a name to the station.
Station comment	-	Enter a comment.
Mode	Normal	<p>Normal/Pulse Enter Pulse mode for ELRT tools - and Normal mode for all other tools. When programming a cycle, the machine mode is written into the cycle. ELRT tools cannot be used in Normal mode and normal tools cannot be used in Pulse mode: the cycle would simply not start.</p> <div>  <p>The controller must be configured in Pulse mode for ELRT tools to get the correct functionalities.</p> </div>
Unit	Nm	Nm / Ft Lb / In Lb / kg m / kg cm / Ncm / InOzf / gf cm.
Cyc.Src	Keypad	Keypad / PC / Bar code / I/O Source of the cycle number: peripheral used to program the current cycle: keyboard, PC, Bar code, Inputs/Outputs (binary programming).
Lock.NbCyOK	No	Lock N cycles OK: when this function is enabled, the system locks the start cycle as soon as the number of cycles run with an accept report has reached the programmed number of cycles. A reset command must be sent to unlock the cycle start.

Screen name	By default	Comment
Scy pulse	No	<p>Start cycle by pulses: the Start Cycle signal can be activated with a pulse. For safety purposes, this parameter is only available on fixed spindles.</p> <div style="display: flex; align-items: center;"> <p>Warning: It is strongly advised against programming the SCY pulse option if handheld tools are used. As the tool only stops at the end of the tightening cycle, this may result in a risk of injury for the operator.</p> </div>
Tool Enable	No	Spindle validation: the spindle operation is validated or not by the PLC.
Stop sp En=0	No	Stop the tool when tool enable signal disappears. Requires Tool Enable to Yes
Err.Ack.	No	Yes / No (to validate start cycle after a reject report).
NOK :SCY=0	Yes	<p>Report NOK when start cycle is released.</p> <ul style="list-style-type: none"> When this function is enabled (Yes), the report is NOK and the "Scy" message is displayed when the start cycle is released. When the function is disabled (No), the report is OK and the "Scy" message is displayed when the start cycle is released.
NOK time out	Yes	<p>Report NOK when time out occurs.</p> <ul style="list-style-type: none"> When this function is enabled (Yes), the report is NOK and the "Time-Time" message is displayed when the time-out occurs. When the function is disabled (No), the report is OK and the "Time" message is displayed when the time-out occurs.
Ergo-stop	Yes	<p>Displayed in Normal mode only.</p> <p>When the function is enabled, the operator will experience less of a jerk at the end of the tightening operation.</p>
RP durat	0.0	A value which is different from 0 allows you to program the pulse (0.1 to 4.0 s) reports (accept, reject, NCYOK) at end of cycle. With a value equal to 0, you can program a continuous status of the reports at end of cycle.
K torque/spindle or K torque/cycle		<p>This option allows you to define:</p> <ul style="list-style-type: none"> Either one correction coefficient per spindle, stored in the tool memory. It is set to 1 by default and can be changed using the manual calibration procedure, starting from the maintenance menu. This coefficient is used to calculate the torque, independently of the cycle run. Or one correction coefficient per cycle, stored in the controller memory. It is set to 1 by default and can be changed using the manual calibration procedure for each programmed cycle. The coefficient used to calculate the torque is that associated with the current cycle.
Reverse One shot	No	<ul style="list-style-type: none"> No => Alternate: Briefly press the inversion button. Then either press Push Start or press the lever to activate the tool. To get back into tightening mode, briefly press the inversion button once again. Yes => 1 shot: Briefly press the inversion button. Then either press PUSH START or press the lever to activate the tool. At the next start, the tool automatically will be in tightening mode.
Double press reverse	No	<ul style="list-style-type: none"> Yes: the operator has to press twice the reverse button to switch to reverse mode. This option is available only for ERAL tools fitted with push reverser
Yellow LED		<p>The yellow LED on the tool can be used to give the operator specific information. One of the following functions can be connected to the yellow LED:</p> <ul style="list-style-type: none"> Output: Free / Ready / IN CYC / Bad report / Good report / NCY OK / CYC 1 / CYC 2 / CYC 4 / SYNC / CYC 8 / CYC 16 / Torque OK / Torque NOK / Angle OK / Angle NOK Negate: If ticked, the meaning of the output signal is inverted to the usual meaning. Blink: If ticked, the output signal blinks when activated.
Keep counter NcyOK	No	Allows to not reset batch counter if cycle is modified.

7.7.2 - INPUT / OUTPUT configuration

The STATION menu also allows you to reconfigure the addresses of the input and output functions on the I/O connector.

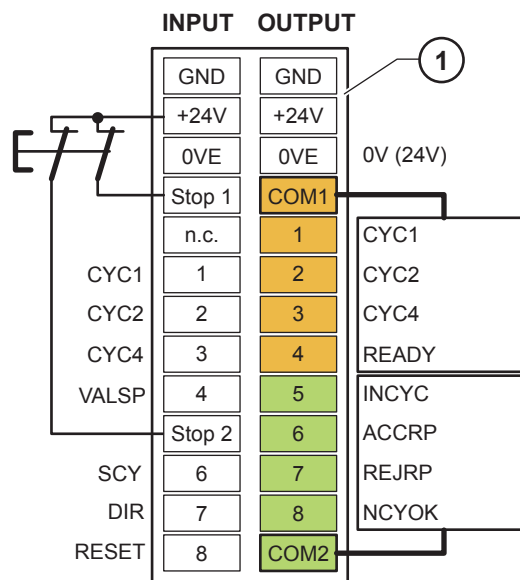
According to the desired operation, you can use either the default configuration, or the dedicated configuration with functions not defined in the default configuration.

All functions can be configured on any input or output available.

You can configure the same output function on several outputs of the I/O connector.

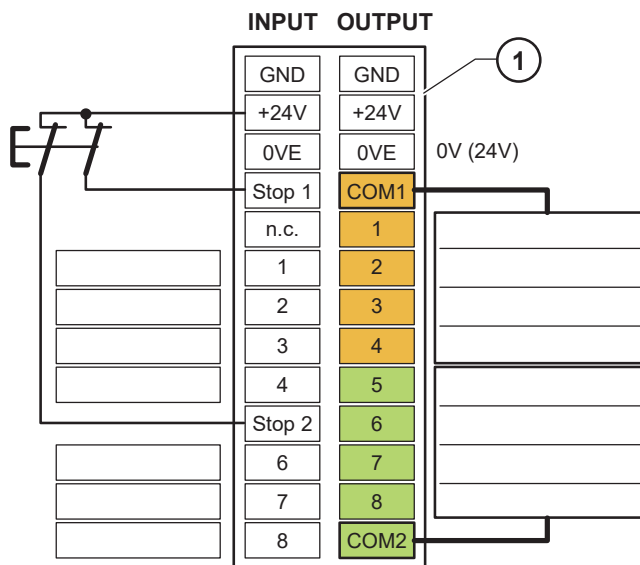
Note that there are 2 separate common circuits on OUTPUT:

- COM1 common for output 1 to 4.
- COM2 common for output 5 to 8.
- It is possible to connect COM1 and COM2 together to get a unique common circuit for all outputs.



Legend

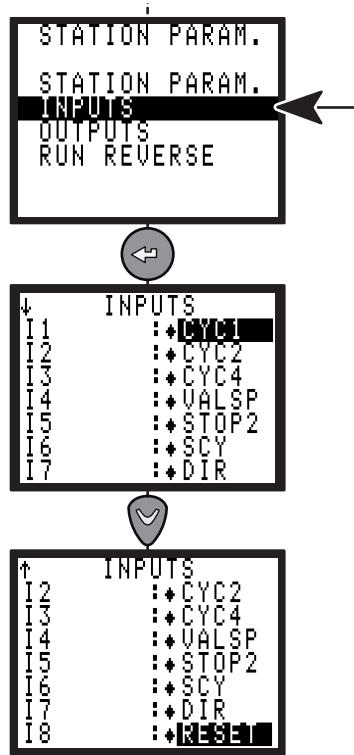
1 Manufacturing configuration



Legend

1 Note your customized configuration

7.7.3 - INPUT menu



Do not change SCY and DIR settings.

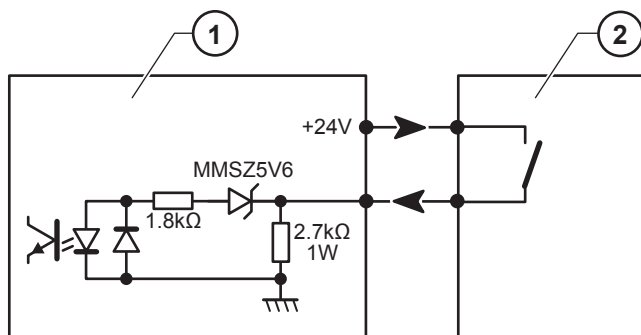
Inputs	Name	Factory config.	Comments
Cycle 1 selection	CYC1	X	Binary coding - weight 1, i.e. from 0 to 1.
Cycle 2 selection	CYC2	X	Binary coding - weight 2, i.e. from 0 to 3.
Cycle 4 selection	CYC4	X	Binary coding - weight 4, i.e. from 0 to 7.
Cycle 8 selection	CYC8	X	Binary coding - weight 8, i.e. from 0 to 15.
Cycle 16 selection	CYC16		Binary coding - weight 16, i.e. from 0 to 31.
Spindle validation	SPVAL	X	Validates - or not - the tool start in both tightening directions if "Sp. val." is enabled in the Station Menu.
Tightening direction validation	VPSTIG		Validates - or not - the tool start in the tightening direction if "Sp. val." is enabled in the Station Menu.
Run reverse direction validation	VPSLOO		Validates - or not - the tool start in the run reverse direction if "SpV.rrv" is enabled in the Station Menu.
Error acknowledgement	ACKNOW		Validates again the tool operation after a reject report if the error acknowledgement function in the Station Menu is enabled.
Start cycle	SCY	X	The cycle is run as long as the signal is at 1. When the signal drops, the cycle stops and the report is sent to the PLC.
Tightening / Run reverse	DIR	X	Validates the un-tightening direction as soon as the Start Cycle signal appears, at the speed programmed in the Station Menu and with the maximum current of the tool.
Reset	RESET	X	This signal resets the tightening reports and deletes the results displayed.
External stop	EXSTOP		When the parameter is programmed on Yes in the programming screen of the run down speed, final speed and run reverse phases, the system stops the current phase on a pulse and switches to the next one.

Inputs	Name	Factory config.	Comments
Synchronization	SYNC		Validates the synchronization of the tightening phases of several controllers (see "Synchronizing several cvil controllers", page 52).
Quick stop 2	STOP2	X	This input is not configurable. This is the redundant input of STOP1 (see "STOP signal", page 9).
Pass Through	P.TRU		Allows the PLC to receive Input status.

7.7.3.1 - PLC output, CVIL input wiring

Two configurations are available.

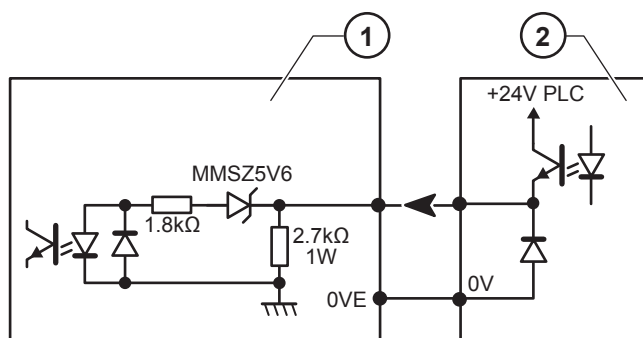
- The CVIL 24V is used as the Common of a PLC relay board.



Legend

- 1 Controller input
- 2 PLC output

- By default, the PLC 24V is sent to the inputs of the controller.



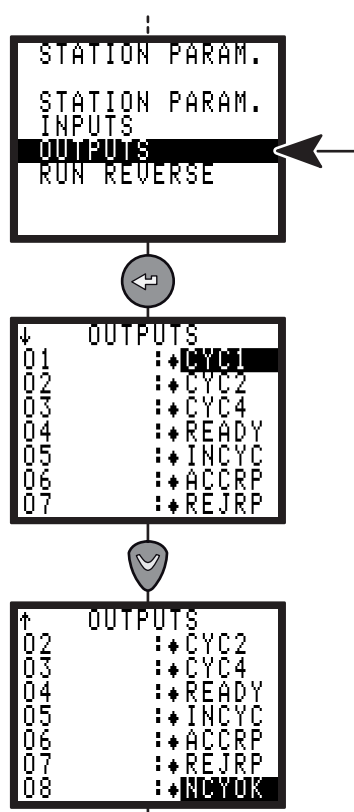
Legend

- 1 Controller input
- 2 PLC output

The inputs are type II as per standard CEI 61131-2 (24 V / 13 mA per input).

- High detection threshold (standard 61131):
 $V_{in} \geq 11V$ and $30mA \geq I \geq 6mA$.
- Low detection threshold (standard 61131):
 $V_{in} \leq 5V$ and $2mA \leq I \leq 30mA$.

7.7.4 - OUTPUT menu

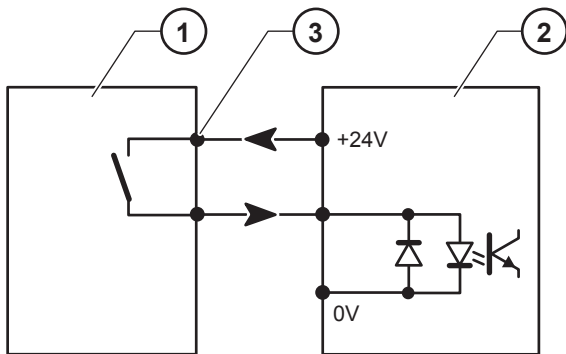


Outputs	Name	Factory config.	Comments
Cycle 1 acknowledgement	CYC1	X	Binary coding -weight 1. The cycle acknowledgement is sent back only if it corresponds to a programmed cycle; otherwise it is at "0".
Cycle 2 acknowledgement	CYC2	X	Binary coding -weight 2. The cycle acknowledgement is sent back only if it corresponds to a programmed cycle; otherwise it is at "0".
Cycle 4 acknowledgement	CYC4	X	Binary coding -weight 4. The cycle acknowledgement is sent back only if it corresponds to a programmed cycle; otherwise it is at "0".
Cycle 8 acknowledgement	CYC8	X	Binary coding -weight 8. The cycle acknowledgement is sent back only if it corresponds to a programmed cycle; otherwise it is at "0".
Cycle 16 acknowledgement	CYC16		Binary coding -weight 16. The cycle acknowledgement is sent back only if it corresponds to a programmed cycle; otherwise it is at "0".
Pass Through	PTHRU		Allows the PLC to drive the output directly.
Maintenance	MAINT		In case a maintenance is requested (tool counter reached or maintenance date).
Ready	READY	X	This signal is at "1" when the controller is in working order.
In cycle	INCYC	X	Response to the Start Cycle request. Drops to "0" at end of cycle.
Global report OK	ACCRP	X	Sent to the PLC when the cycle is over and the global report is OK.
Global report NOK	REJRP	X	Sent to the PLC when the cycle is over and the global report is NOK.
Number of cycles OK	NCYOK	X	This signal switches to "1" when the number of cycles run with an Accept report is equal to the programmed number of cycles OK. This output is reset after the "RP duration" time set in the "Station - general parameters" menu.
Synchronization	SYNC		The synchronization signal falls down at the end of the phase and is used, connected with synchronization of other controllers to synchronize the next phase (see "Synchronizing several cvil controllers", page 52).
Torque report OK	TOROK		Sent to the PLC when the cycle is over and the torque report is OK.
Torque report NOK	TORNOK		Sent to the PLC when the cycle is over and the torque report is NOK.
Angle report OK	ANGOK		Sent to the PLC when the cycle is over and the angle report is OK.
Angle report NOK	ANGNOK		Sent to the PLC when the cycle is over and the angle report is NOK.

7.7.4.1 - CVIL output, PLC input wiring

Below are shown the two wiring configurations available for the relayed outputs of the CVIL.

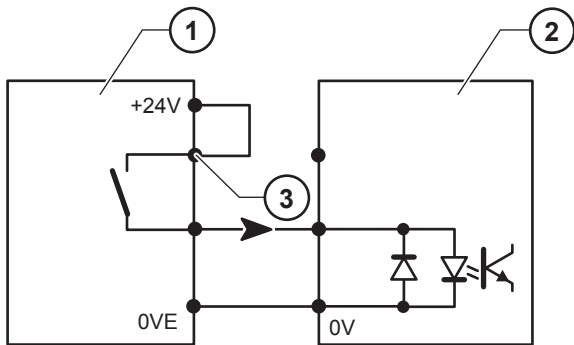
- The PLC 24V is connected to the CVIL output common. The PLC input do not receive external 24V.



Legend

- 1 Controller output
- 2 PLC input
- 3 Common of the output relays

- By default, the PLC 24V is sent to the inputs of the controller.



Legend

- 1 Controller output
- 2 PLC input
- 3 Common of the output relays

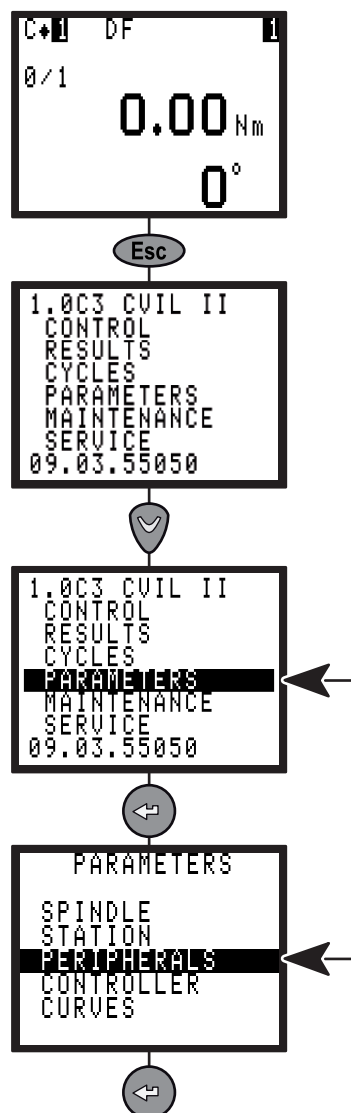
All outputs are enabled at 1 and relayed in the controller with a common point (4) for all outputs.

Features of the contacts: 1A / 30V / 30W max. DC on resistive charge.

7.7.5 - RUN REVERSE menu

Parameters		Comments
Tool En. Rev.		<ul style="list-style-type: none"> Yes: the operator cannot perform a loosening operation unless the SPVALRV (spindle reverse validation) input is activated. No: the operator is allowed to perform a loosening operation.
Rev Type	Default	Reverse in opposite of the spindle way with default parameters.
	LastPha	Reverse in the opposite way of the last tightening phase programmed in the current cycle.
	OnCycle	Use a cycle programmed in the cycles list.
The next display depends on the Reverse type (Rev Type)		
Rv speed		Speed for the continuous reverse.
Rev Cyc N		List of valid cycles programmed in the cycles list. ("none" if no cycle programmed).

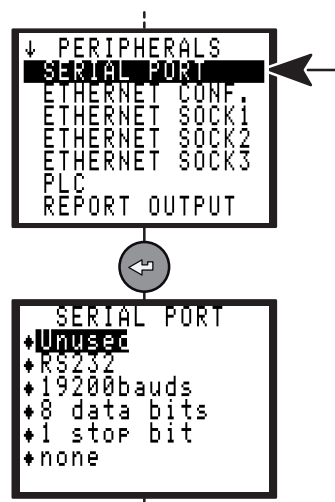
7.8 - PERIPHERALS menu



7.8.1 - SERIAL PORT menu

The serial port is used for the following functions:

- PC transfer (used to communicate with CVIPC 2000 software).
- Bar code and report output.
- Printing the results in order of occurrence (ASCII, use Bar code and report output selection).
- Automatic calibration with the DELTA measuring unit (no programming is required).

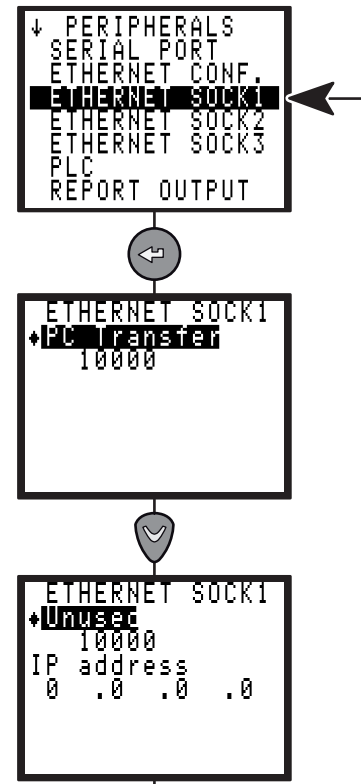


7.8.2 - ETHERNET CONFIGURATION menu



Parameter	Comment
IP Address	IP address of the controller in the network
Mask	In case of integrating the controller in an existing network, please contact your administrator to get the correct mask
Gateway	to be set when the network uses "Gateway"
Ping IP	IP address of another equipment connected to the controller
Nb ping startup	Starting the controller, execute several pings at the corresponding address

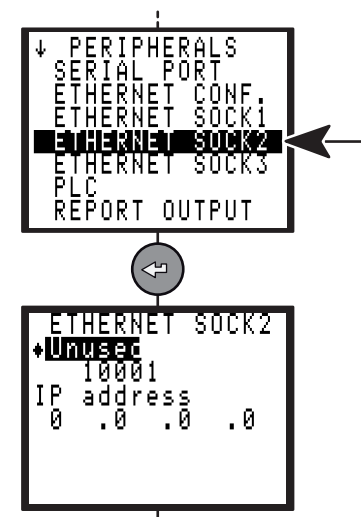
7.8.3 - ETHERNET SOCKET 1 menu



The ethernet socket 1 is used for the following function:

- PC transfer (used to communicate with CVIPC 2000 software)

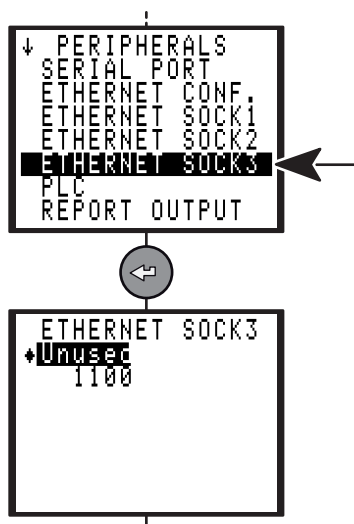
7.8.4 - ETHERNET SOCKET 2 menu



The ethernet socket 2 is used for the following functions:

- CVINET data collector
- ToolsNet data collector (this choice needs to get a license).

7.8.5 - ETHERNET SOCKET 3 menu



The ethernet socket 3 is used for the following functions:

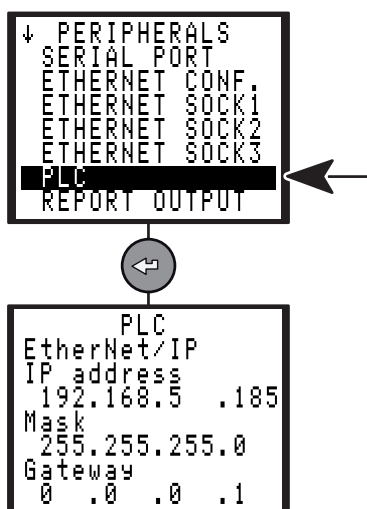
- Open Protocol.
- Desoutter Protocol.

7.8.6 - PLC menu

To get the functionalities it is necessary to insert an optional fieldbus module.

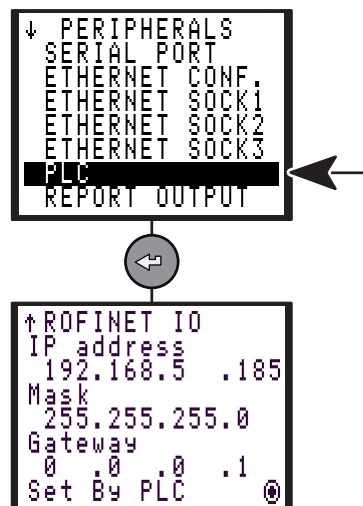
The layout of the setting screens shall differ according to the inserted module.

7.8.6.1 - Ethernet/IP module



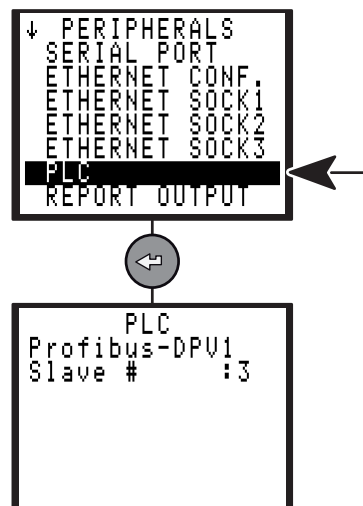
Parameter	Comment
IP Address	IP address of the controller in the PLC network (must differ from Ethernet address see "ETHERNET CONFIGURATION menu", page 39).
Mask	In case of integrating the controller in an existing network, please contact your administrator to get the correct mask.
Gateway	To be set when the PLC network uses "Gateway".

7.8.6.2 - Profinet IO module



Parameter	Comment
IP Address	IP address of the controller in the PLC network (must differ from Ethernet address see "ETHERNET CONFIGURATION menu", page 39).
Mask	In case of integrating the controller in an existing network, please contact your administrator to get the correct mask.
Gateway	To be set when the PLC network uses "Gateway".
Set by PLC	Tick "Set By PLC" to have the IP address, mask and gateway set by the PLC.

7.8.6.3 - Profibus module



Parameter	Comment
Slave #	Slave number of the controller in the PLC network.

7.8.6.4 - Reset a dynamic mapping

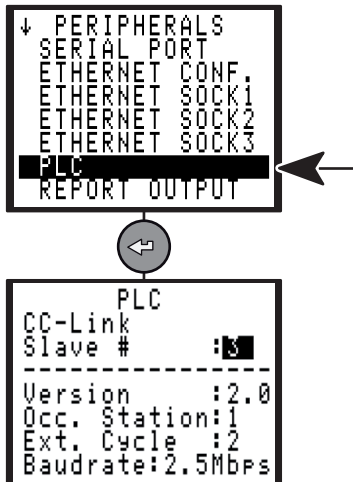
Any standard dynamic mapping can be reset.

Check that a Fieldbus module is connected to the controller.

- Go to "Parameters/Peripherals/PLC".
- Press the keys "Up/Left/Down/Right/Enter" one after the other.

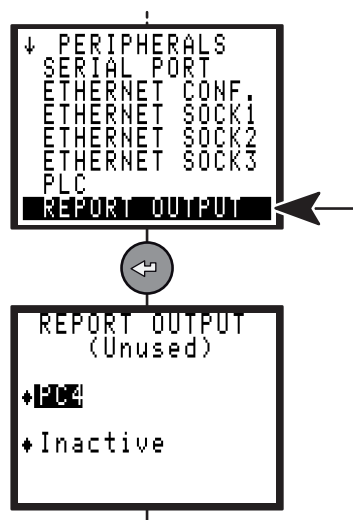
3 bips are emitted, the mapping is reset and the controller is rebooted.

7.8.6.5 - CC-Link



Parameter	Comment
Slave #	Slave number of the controller in the PLC network.

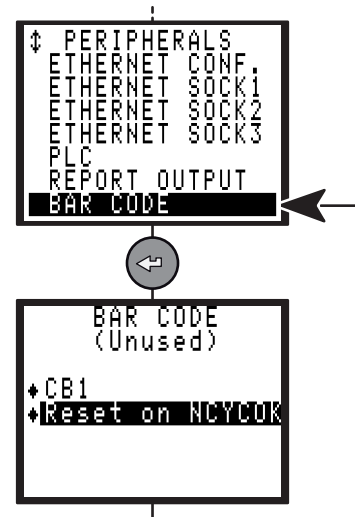
7.8.7 - REPORT OUTPUT menu



The report is printed according to the following parameters:

- Format: PC2 / PC3 / PC4 / Specific / PC5A / PC5B / PC5C.
- Upon request at end of cycle (See "Printing format for tightening results", page 56).

7.8.8 - BAR CODE menu



The bar code reader allows you to automatically select one of the cycles previously programmed in the controller.

To enable the barcode reader, you need to do the following:

- Declare the source of selection of the cycles as being the bar code.
- Configure the serial link:

Barcode function
9,600 bauds
8 data bits
1 stop bit
No parity

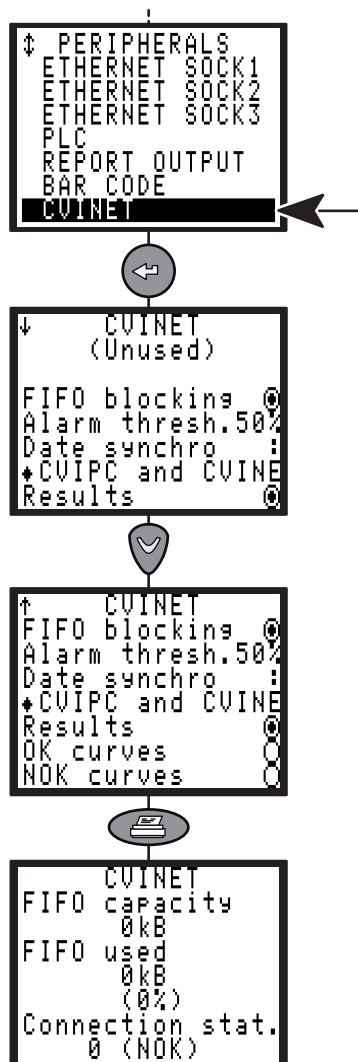
They cannot be programmed by the PC.

Set up the table of selection of the cycles according to the barcode numbers, which can be done only with the CVIS / CVIC PC2000 software.

As the barcode is read by the controller, it can perform one of the following actions:

Parameter	Comment
No action	No action is performed.
Reset	Reading the code leads to an action which is identical to the Reset action.
Reset on NCYCOK	Reading the code leads to a Reset when the programmed number of cycles OK is reached.

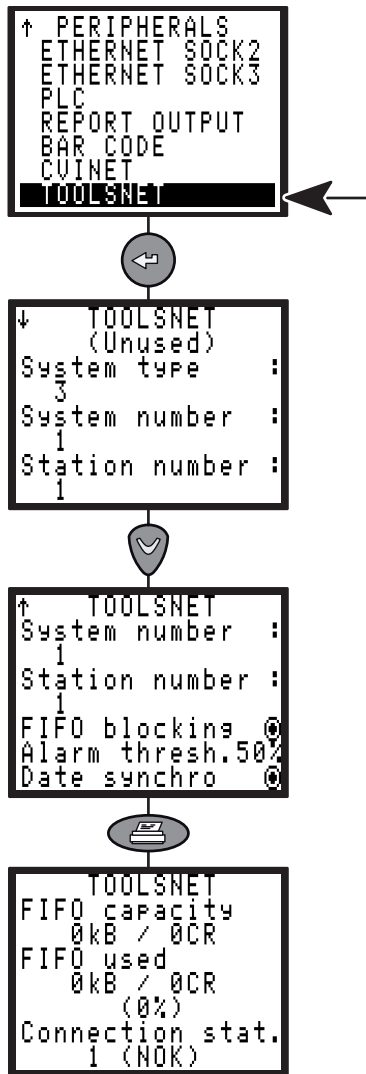
7.8.9 - CVINET menu



Parameter	Comment
FIFO blocking	When the result memory to be transmitted is full, the start cycle that follows can be locked or not (the start cycle is not locked on, but next results are not saved).
Alarm thresh.	When the memory filling rate reaches this value (1 to 99%), an alarm is displayed.
Date synchro	Choose how to update the machine on time (CVIPC / CVINET / CVIPC and CVINET).
Results	Tightening results.
OK curves	Tightening curves with tightening report=accept.
NOK curves	Tightening curves with tightening report=reject.
FIFO capacity	Memory space allocated for not transmitted results.
FIFO used	Memory space used in the FIFO.
Connection status	NOK: not connected to the CVINET server. OK: connection established.

The CVINET software can be used to recover the tightening results and the curves on PC via Ethernet.
This screen is the configuration of the CVINET data collector.

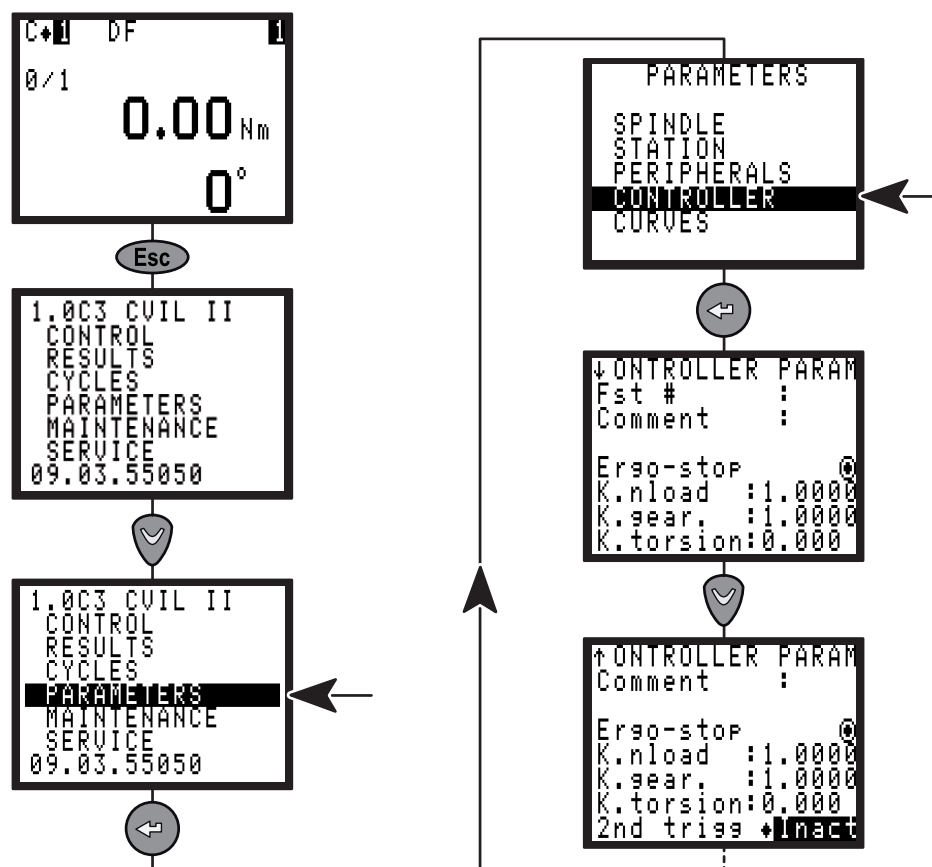
7.8.10 - TOOLSNET menu



Parameter	Comment
System type	Type of system for ToolsNet server (3 is the default: OP Undefined controller).
System number	Identification of the system in the controller network (group of stations).
Station number	Identification of the station in the controller network (individual station).
FIFO blocking	When the result memory to be transmitted is full, the start cycle that follows can be locked or not (the start cycle is not locked on, but next results are not saved).
Alarm thresh.	When the memory filling rate reaches this value (1 to 99%), an alarm is displayed.
Date synchro	Check the box to synchronize the controller date with the ToolsNet server.
FIFO capacity	Memory space allocated for not transmitted results
FIFO used	Memory space used in the FIFO
Connection stat.	NOK: not connected to the CVINET server. OK: connection established.

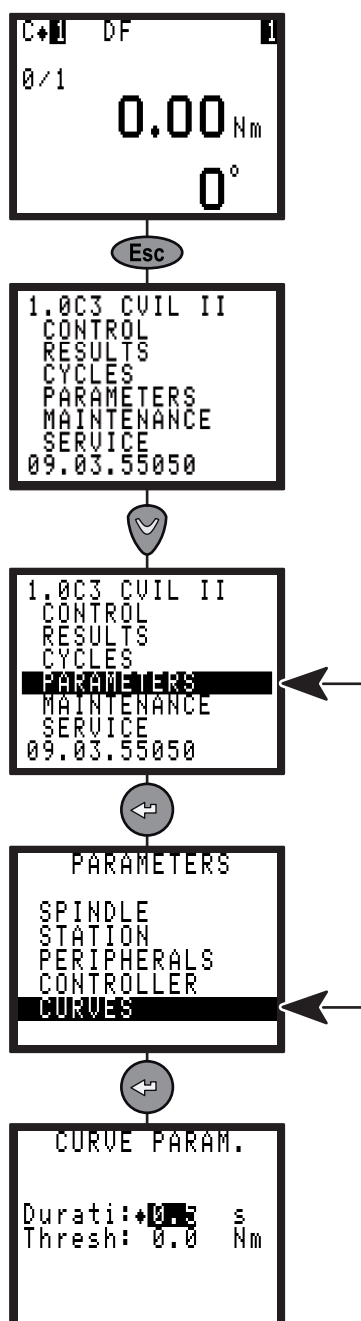
The ToolsNet software can be used to recover the tightening results and the curves on PC via Ethernet.
This screen is the configuration of the ToolsNet data collector.

7.9 - CONTROLLER menu



Parameter	Comments
Comment	Possibility to add a comment up to 15 characters to identify the controller.
Fst	Possibility to add a comment or figures up to 3 characters to identify the fastener.
Ergo-stop	Displayed in Normal mode only. Activates or not the ergo-stop function at the end of the tightening operation. This reduces the reaction shocks at the end of the tightening and is recommended for portable tools.
K.nload	Nominal load coefficient for use of external torque multiplier. Update torque calibration.
K.gear	Gear ratio coefficient for use of an external torque multiplier. Update angle calibration.
K.torsion	Torsion coefficient used in control angle strategies to compensate the mechanical torsion of the installation.
2nd trigg	Second trigger mode for ERAL 1.5 & 2 tools (inactive / or / and).

7.10 - CURVES menu



Parameter	Comment
Durat	Recording time.
Thresh	Threshold = 0: The curve is displayed back from motor stop for the recording time. Threshold > 0: The curve is displayed from the defined torque threshold and for the recording time.

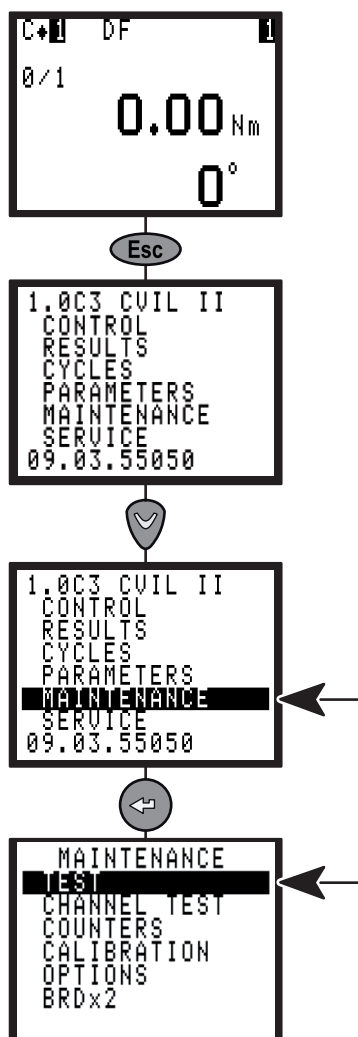
8 - MAINTENANCE

This section helps the maintenance operator to:

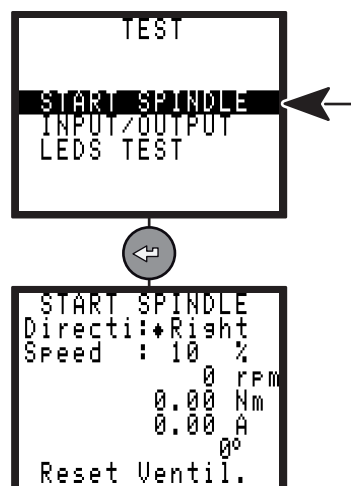
- Check that the controller + tool assembly operates correctly.
- Know the number of cycles run.
- Tune the system manually or automatically.
- Adjust the contrast of the display, update controller date, select the language and program an access code.
- Change the memory batterie.
- Backup and restore the controller.

8.1 - MAINTENANCE menu

8.1.1 - TEST menu



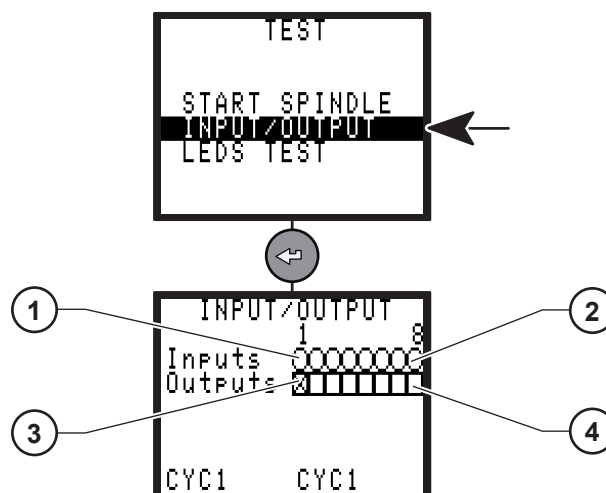
8.1.1.1 - START SPINDLE menu



The START SPINDLE menu allows you to check the correct operation of the tool.

- Select the speed and rotation direction (Directi reverser for a hand held tool or in the menu for a fixed tool) then press the trigger for a hand held tool of ER type or press the On button for a fixed tool of EME or EML type.
- Select Reset to reset the display.
- Select Ventil. to start the fan and check its working order.

8.1.1.2 - INPUT / OUTPUT menu



Legend

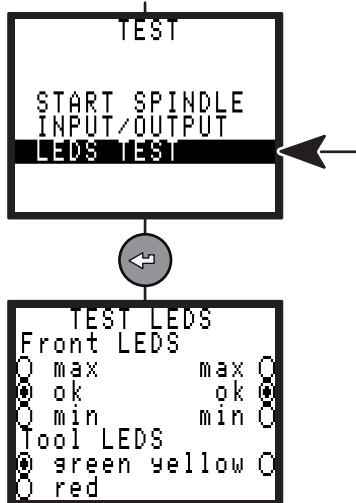
- 1 Input no 1
- 2 Input no 8
- 3 Output no 1
- 4 Output no 8

The INPUT/OUTPUT menu allows you to check the status of inputs and to test the outputs.

Testing the outputs:

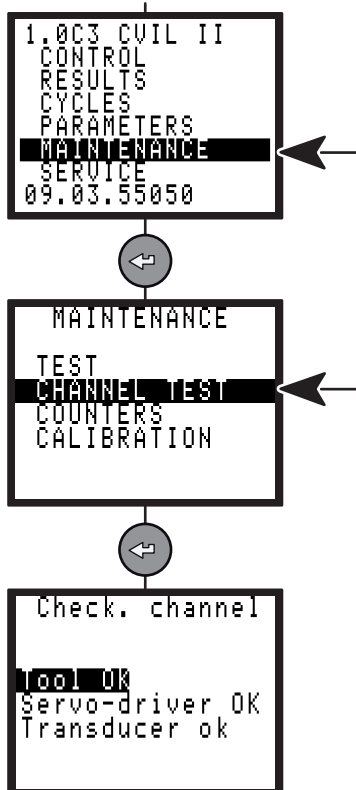
- The cursor blinks on output 1 (3).
- Press **Down Arrow** to move the cursor.
- Press **Right Arrow** to validate the box or not.
- The selected output is or is not enabled.
- Then it is possible to check the efficiency of the status change of this output on the corresponding input, for example on the PLC.

8.1.1.3 - LEDS TEST menu



This menu allows for testing the LEDs located on the front side of the CVIL and for testing the LEDs on the tool.

8.1.2 - CHANNEL TEST menu



This menu is used to test the operation of the controller and tool. There is a sequence of two tests:

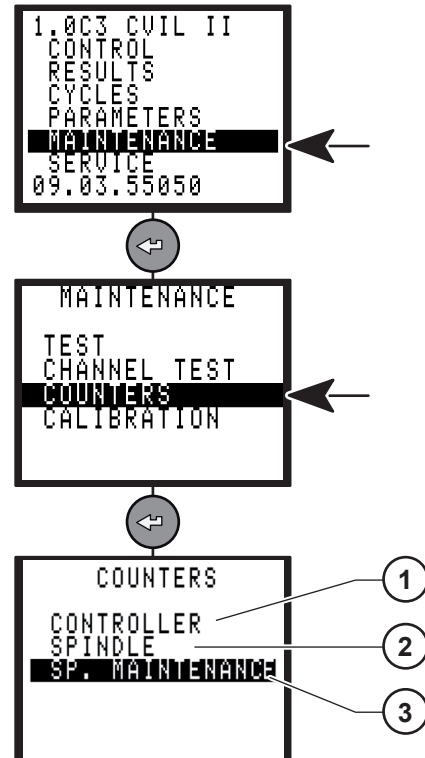
- Reading the information contained in the tool memory.
- Checking the servo drive board.



If an error arises, a message is displayed.
Press  to display an additional error message.

8.1.3 - COUNTERS menu

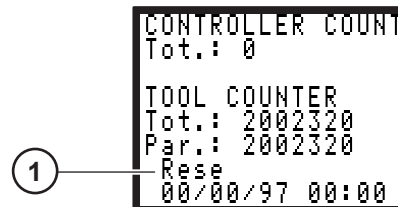
8.1.3.1 - Tool and controller counters



Legend

- 1 Controller counter
- 2 Spindle counter
- 3 SP. Maintenance counter

This menu allows the maintenance technician to know the number of cycles run.



Legend

- 1 Reset counter

- The Controller counter shows the number of cycles run since delivery.
- The Tot. (total) and Par. (partial) counters show the number of cycles run by the tool.
- Select Reset to reset the partial counter of the tool.

8.1.3.2 - Maintenance counters + date

```

MAINTENANCE INFO
Tot.: 30000
Reset
05/11/11 00:00
MAINT OFF

```

- Maintenance is configured but is not yet reached (MAINT OFF).

```

MAINTENANCE INFO
Tot.: 30000
Reset
05/11/11 00:00
MAINT ON (time)

```

- Maintenance is configured and reached (MAINT ON (time)).


8.1.3.3 - Tool counter in Pulse mode

```

TOOL COUNTER
Cycle: Reset
Tot.: 640
Par.: 640
Pulse:
Tot.: 3876
Par.: 3876

```

In the "Pulse mode", the total and partial numbers of pulses are stored in the tool memory.

- Select [Reset] and press  to reset the partial counters.
- Place the cursor on the total number of pulses to display the date of the first pulse.
- Place the cursor on the partial number of pulses to display the date of the last reset.

For example:

```

TOOL COUNTER
Cycle: Reset
Tot.: 640
Par.: 0
Pulse:
Tot.: 3876
Par.: 0
29/10/14 12:10

```

8.1.4 - CALIBRATION menu

```

1.0C3 CVIL II
CONTROL
RESULTS
CYCLES
PARAMETERS
MAINTENANCE
SERVICE
09.03.55050

```



```

MAINTENANCE
TEST
CHANNEL TEST
COUNTERS
CALIBRATION

```



```

CALIBRATION
SPINDLE MANU

```

The calibration procedure is recommended to compensate for any possible drift of the tool torque or after each change of tool element.

8.1.4.1 - SPINDLE MANU menu

```

SPINDLE MANU
C+1 1.0000
1.0000
1/5
Torque :0.00
Ref.Value:0.000
Reset value Rese

```

This menu is used to calculate and to apply a torque correction coefficient to the torque value of the selected cycle.

The torque transducer inserted in line with the tool can be connected to any measuring unit in the Desoutter range.

Run a tightening cycle 5 times and manually enter the values read on the standard instrument.

- The Reset value key resets the readings.
- The Reset coeff. key displays coefficient 1 by default.

Depending on the option selected (K Torque/spindle or K Torque/cycle) in the "STATION – General parameters", page 31, the Torque correction coefficient is saved:

- Either in the tool memory.
- Or in the controller.



The torque and angle reports MUST be correct to allow the procedure to be processed in normal conditions.

8.1.4.2 - Calibration service

For full certified calibration, to cover your quality systems needs please consult your local Desoutter Customer Service Center that are fully prepared to support you, either at your site or in one of our workshops.

Being the equipment manufacture we are prepared not only to provide the calibration service and certification, but also to adjust your equipment for its fullest performance.

Our labs can provide you with either a local traceability chain to National standards or a International level, through ISO 17025 certified labs.

8.1.5 - Options

Contact your Desoutter representative for support.

8.1.6 - BRDx2 - controller backup



The minimum software version of the controller must be: V 5.1.A9.

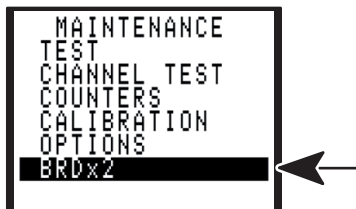
Use this device to clone a controller.

Both configuration and firmware are copied during the process.

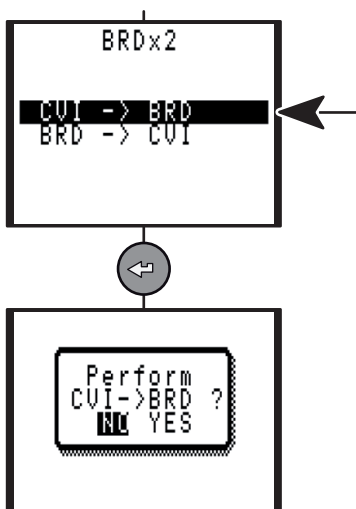
Before restoring, check that the target controller is not connected to the same Ethernet network as the source controller as this may cause a conflict between IP addresses.

Connect the BRDx2 to the serial port of the controller as described in the user manual 6159922590.

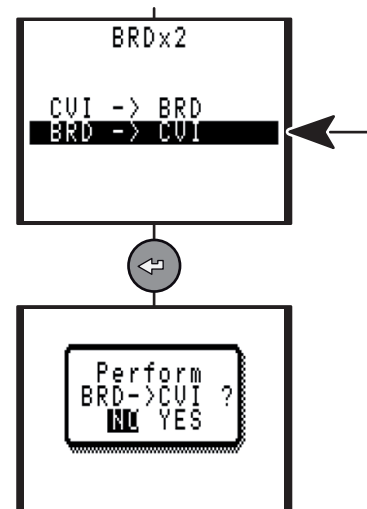
Go to the Maintenance menu and select "BRDx2".



8.1.6.1 - Backup



8.1.6.2 - Restore



8.2 - SERVICE menu

See "Start up", page 11.

8.3 - Maintenance operation

8.3.1 - Changing the memory battery

The memory battery allows you to save the parameters and results in of mains power failure.

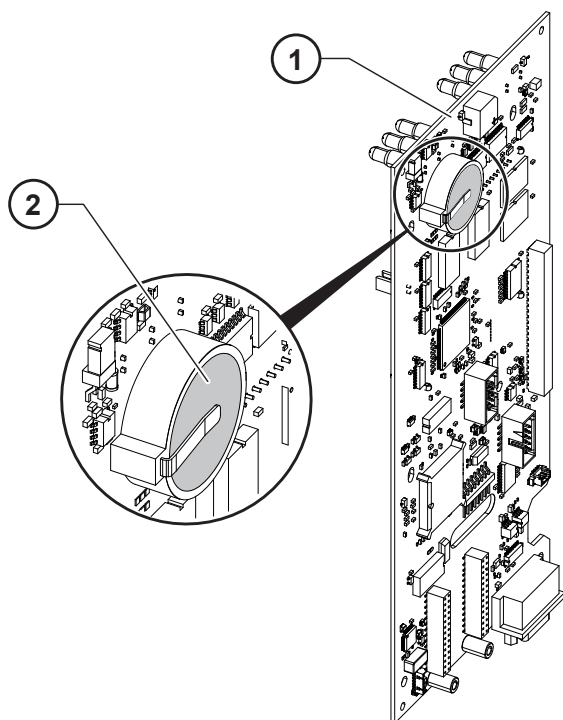
A maximum lifetime of 10 years is indicated in the manufacturer's specifications.



For safety purposes, it is recommended to change the battery every 5 years.



Prior to any battery change, it is recommended to save the tightening program as well as the results, using the CVIS / CVIC PC2000 software.



Legend

- 1 CPU board
- 2 Battery



ATTENTION

This procedure requires that the controller be disassembled and handled by certified technicians.

It also means that they should not be performed during warranty coverage or service contracts coverage, since it would void them.

Please consult your local Desoutter Customer Service Center, which have fully capable and trained engineers to perform any of your service needs in relation to the tightening system.

8.3.2 - Replacing the fan

The fan allows to cool down the controller.

A lifetime of 7 years in continuous operation is indicated in the manufacturer's specifications.

For safety purposes, it is recommended to change the fan every 5 years.

8.3.3 - Desoutter Tool and Account Services

The performance of your industrial tools directly affects the quality of your products and the productivity of your processes as well as the health and safety of your operators.

Please consult us on the "Tool Care" program that includes production support and maintenance solutions.

8.3.3.1 - Tool Services

Our experts can keep your tools running at their best, reducing downtime and helping in making costs more predictable.

Thanks to our experience in power tools running in demanding applications all over the world, we can optimize the maintenance for each tool based on your application.

Calibration

To enable you to meet quality system criteria and pass audits, we offer a complete calibration service. With it you get scheduling, full management and traceable documentation. Properly calibrated equipment provides confidence that your products meet their highest performance and specifications.

Installation & set-up

Get new tools up and running faster with our installation and set-up services. A qualified Desoutter service engineer commissions new tools to specification. To save time, tools are optimized through simulation before they are shipped out for installation. They are then tested and their performance verified on-line. Based on application and joint analysis, the engineer tunes each tool for maximum reliability. Depending on the customer's need, our engineers can then provide a follow up of the production during the ramp up and final line speed. This ensures that the highest tightening capability is achieved at mass production levels.

Repairs

We reduce the administrative hassle of managing repairs, thanks to fixed price repair service and rapid tool turnaround. We always take advantage of the repair time to perform a complete overhaul, which helps tools to last longer on the production line, high uptime. For even faster turnaround, we can keep exchange parts in stock as part of your service contract. We can track the repair history of all tools, and we can provide extensively analysis report of the services provided, throughout the life of the tools.

Preventative Maintenance

We customize, through our dedicated software, our preventative maintenance plan to your application requirements, taking into account parameters such as annual cycles, cycle times, torque settings and joint quality. This reduces ownership costs and keeps tools working at their best. Preventative maintenance is available with fixed pricing to help you manage your budget better. In some cases, tools maintained by us are eligible for extended warranties. We offer Extended Warranty Programs that provide a comprehensive service/support program for new tool purchases.

Please consult us on the "Tool Care" program that includes production support and maintenance solutions.

8.3.3.2 - Account Services

In addition to optimizing the individual tool performance, we also help you simplify tool management and ownership.

Training

To improve the performance of your operators and the expertise of your line managers, we provide comprehensive training and seminar programs. We offer hands-on training at your plant or at one of our training centers. Training covers tool function and handling and includes torque adjustment, case and the basics of threaded fastener assembly. By improving the knowledge and skills of your operators, you will increase operator job satisfaction and productivity.

Full service plans

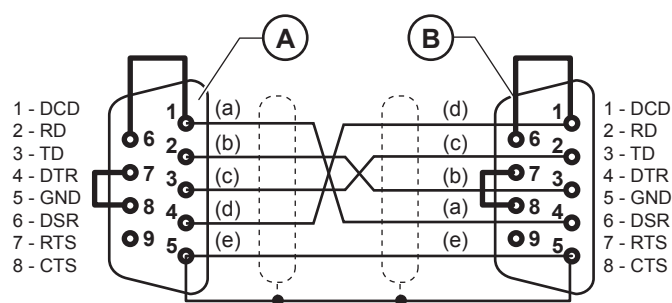
When managing a wide range of tool systems, it is important to keep costs under control. Our full service plans are tailored to your needs. They reduce spare part inventory, lower administration costs and provide budget predictability. Full service plans are available for single facilities or for multiple plants, whether in a single country, region or around the world. Desoutter will provide you with a full cost analysis and return of investment to ensure that you get the best optimization for taking care of your equipment. Take the challenge and let us demonstrate it to you!

Please consult us on the "Tool Care" program that includes production support and maintenance solutions.

9 - CONNECTIONS

9.1 - PC wiring diagram

- number 6159170470



Legend

- A** Sub D 9 contacts socket (PC side)
- B** Sub D 9 contacts socket (Controller side)
- a** White
- b** Brown
- c** Blue
- d** Red
- e** Black

9.2 - Synchronizing several CVIL controllers

To synchronize several CVIL controllers, you must:

- Allocate the "Synchro In" and the "Synchro Out" signals to unused inputs and outputs.
- Connect the controller Synchro signals and program a "Synchr. Waiting Phase" for each controller.

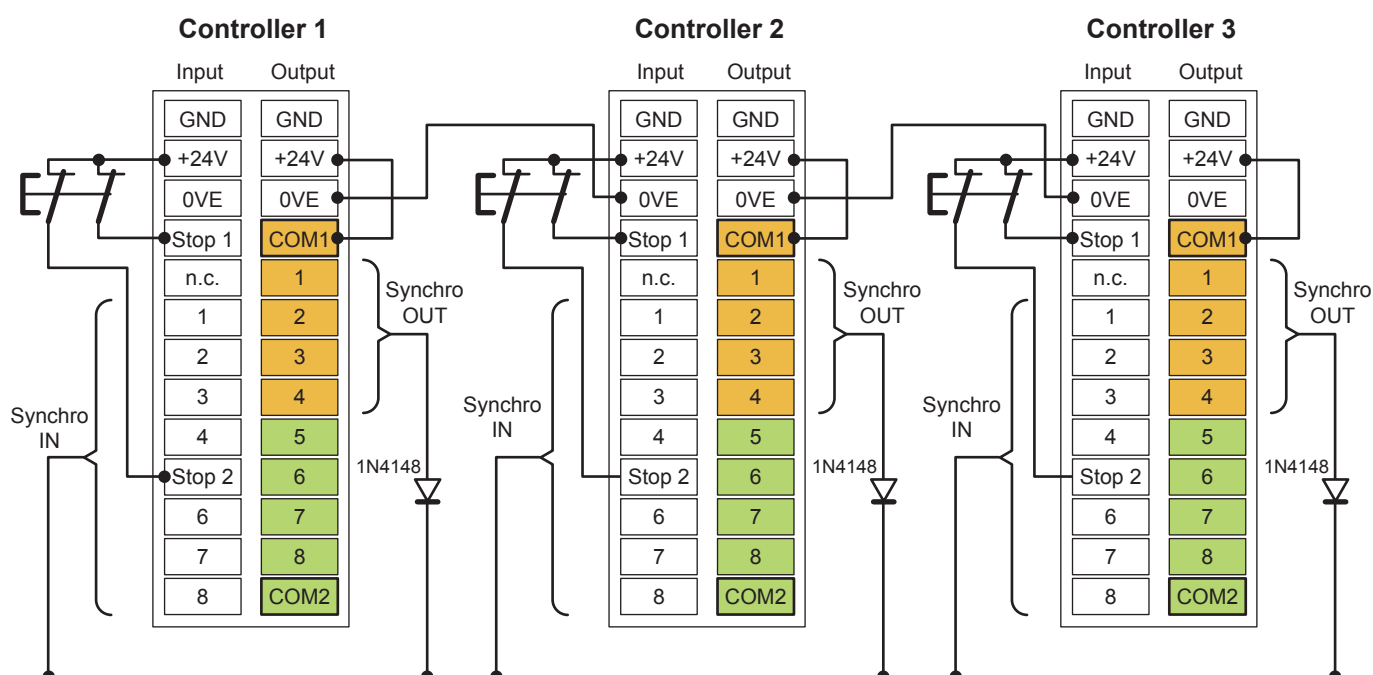


The 0 VE of the I/O connectors of each controller are connected to each other. All other signals (cycle number, run...) must be connected to each controller.

9.2.1 - Example of connection diagram

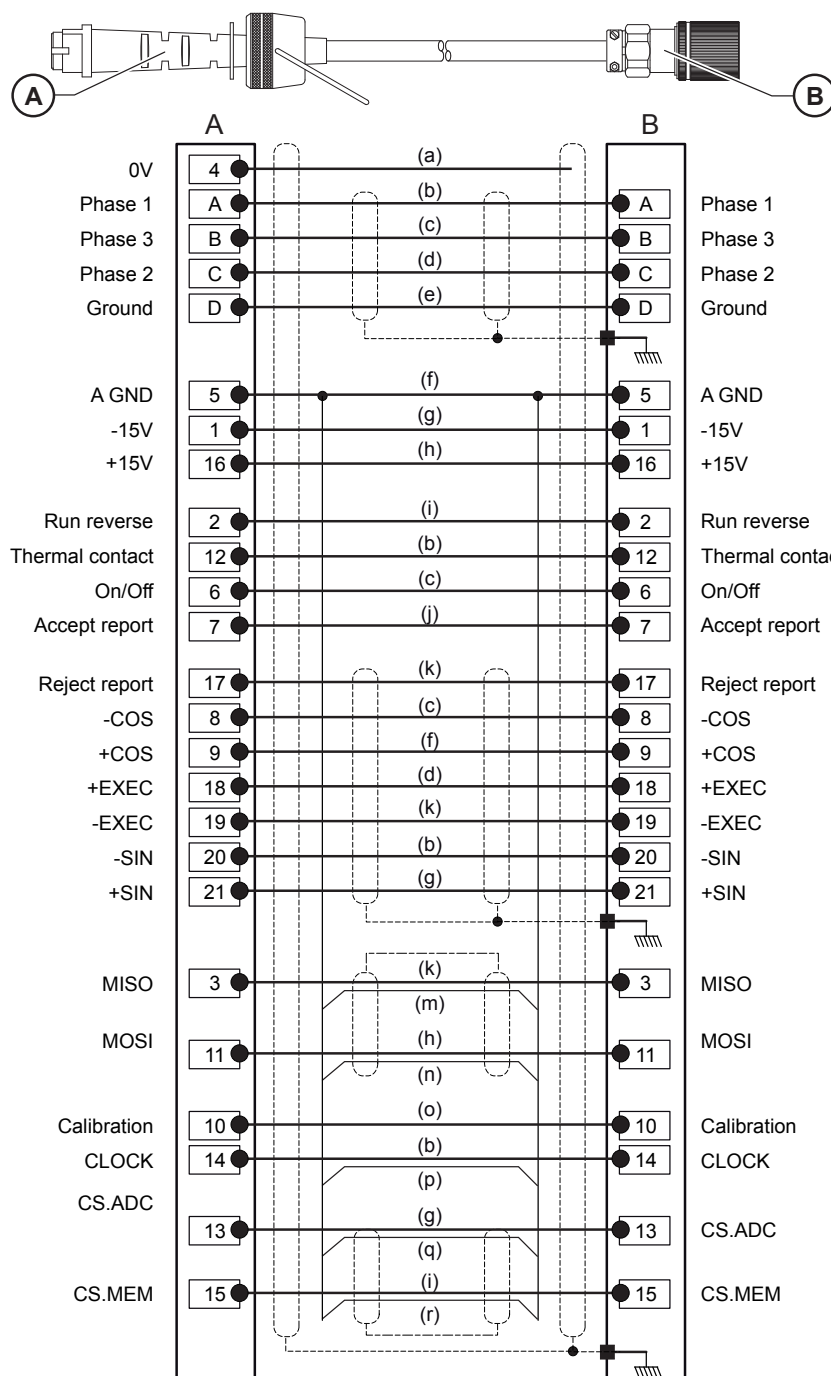


It is necessary to wire a diode 1N4148 in serial with each synchro out signal.

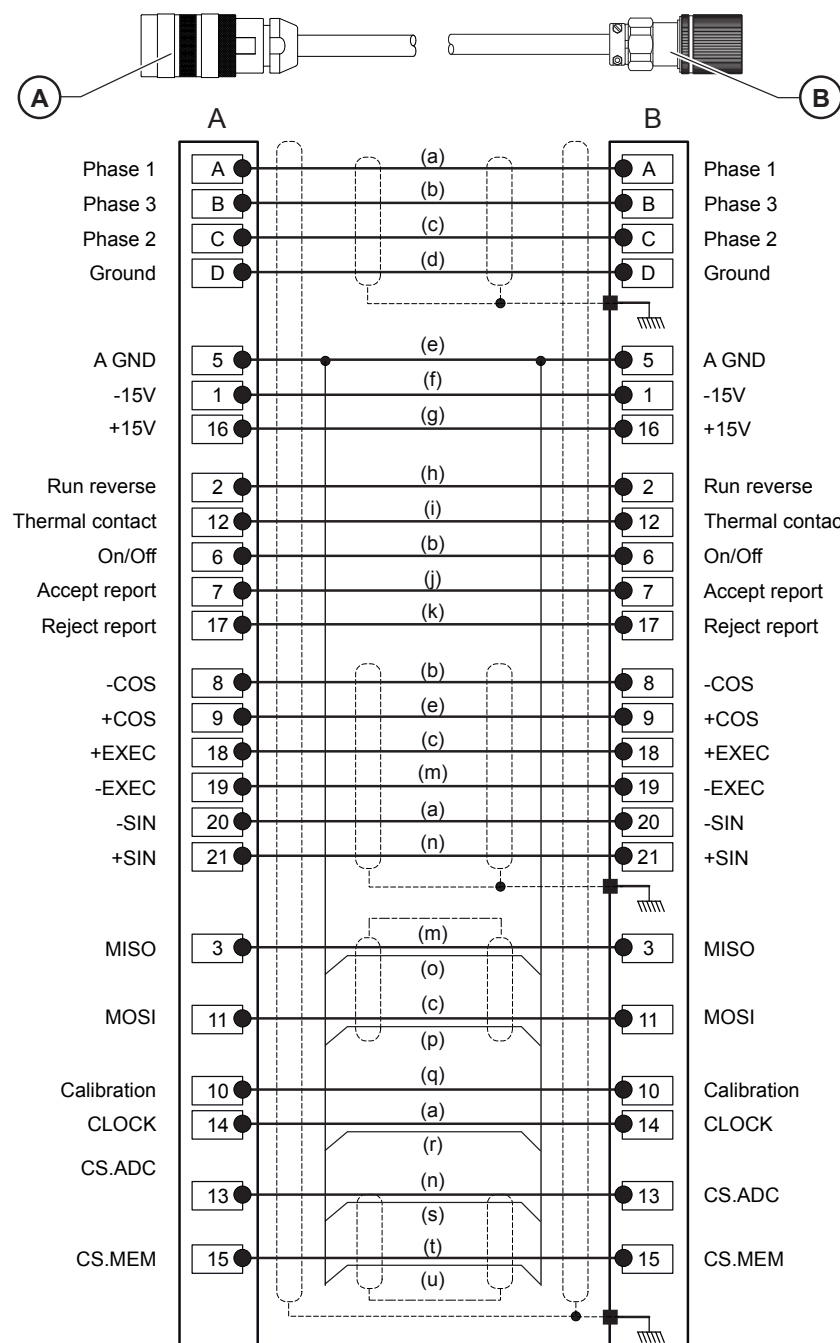


9.3 - Tool cables

9.3.1 - ER cable



9.3.2 - EME cable

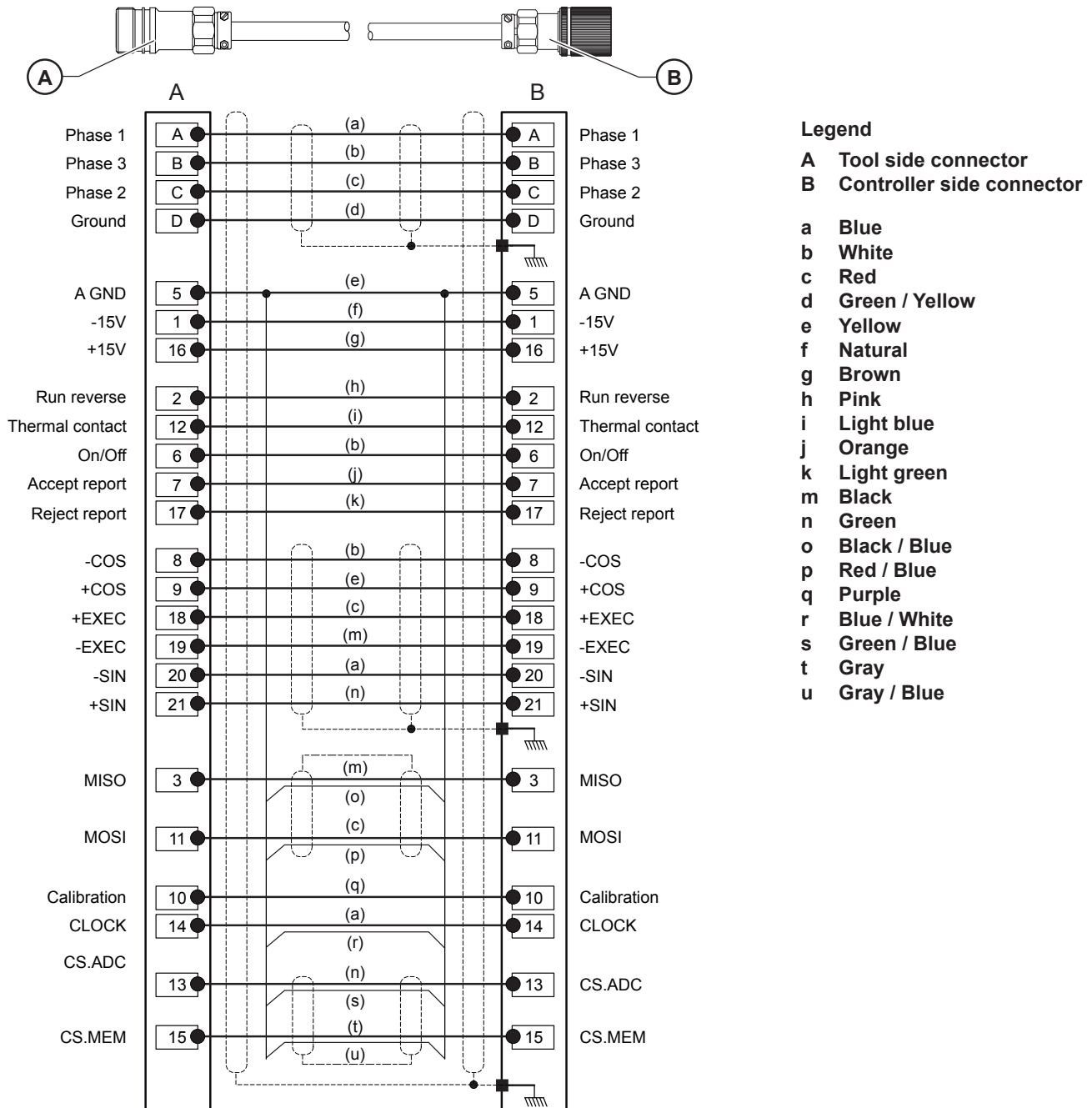


Legend

A Tool side connector
B Controller side connector

a Blue
b White
c Red
d Green / Yellow
e Yellow
f Natural
g Brown
h Pink
i Light blue
j Orange
k Light green
m Black
n Green
o Black / Blue
p Red / Blue
q Purple
r Blue / White
s Green / Blue
t Gray
u Gray / Blue

9.3.3 - ER / EME extension cable



10 - PRINTING FORMAT FOR TIGHTENING RESULTS

10.1 - PC2 format

Char number	Designation
1	char. <CR>
2	range or cycle number
2	fastener number
3	«T=+»
5	torque in 1/10 of Nm
1	<LF>
1	" "
1	<CR>
2	range or cycle number
2	fastener number
3	«A=+»
5	angle in 1/10 of degree
1	<LF>
1	" "
1	<CR>
2	range or cycle number
2	fastener number
3	«TR=+»
5	torque rate in 1/1000 Nm/dg
1	<LF>
1	" "

Example of result:

<CR>0109T=+00400<LF> <CR>0109A=+01200<LF>
<CR>0109TR=+00580<LF>

The last result in the list ends with <LF><LF> instead of <LF>""

10.2 - PC3 format

Char number	Designation
1	char. A (frame type)
3	station number (1 to 250)
3	port number (1 to 32)
1	configuration (A to O correspond to configurations 1 to 15)
1	Z (system identifier)
1	char. A (frame type)
1	report code (see chart below)
6	date (year, month, day)
6	time (hour, minute, second)
8	torque
5	angle
1	<CR>
1	Checksum (modulo sum 256 of the previous characters) not calculated for the moment
1	<LF>

The last result in the list ends with <LF><LF> instead of <LF>

Report code: ASCII code 0100 :

①	②	③	④
X	X	X	X

Legend

- 1 1 = max. angle
- 2 1 = min. angle
- 3 1 = max. torque
- 4 1 = min. torque

According to the various combinations, the following characters will be obtained:

@	accept torque	accept angle	If "NOK:SCY=0" is set to "Yes"
O	accept torque	accept angle	If "NOK:SCY=0" is set to "No"
A	min. torque	accept angle	
B	max. torque	accept angle	
D	accept torque	min. angle	
E	min. torque	min. angle	
F	max. torque	min. angle	
H	accept torque	max. angle	
I	min. torque	max. angle	
J	max. torque	max. angle	
0x00	on servodrive fault or spindle belonging to reject group or cycle start drop or cycle not completed for spindle or transducer fault		

Example of result:

A001001BZ@92120811021500041.7500121<CR>
<CS><LF>

10.3 - PC4 format

10.3.1 - Title

Char number	Designation (*)
XXXX	Rdg N°
XX	Sp
XX	Cy
XX	Ph
XX/XX/XX	Date
XX:XX:XX	Time
XXXXXX	Torque (Nm)
XXXXXX	Angle (dg)
XXXXXX	Torque rate (Nm/dg)
XXXXXX	Standby characters
XXXX	CR

(*) depending on the language.

Example of result:

<CR>1223 01 03 01 18/04/03 09:03:45 0030.2
0120.50.5680 B <LF>

10.3.2 - Result

Char number	Designation
1	char. <CR>
4	Reading number
1	" "
2	Spindle number
1	" "
2	Cycle number
1	" "
2	Phase number (= 2 blanks if cycle result)
1	" "
8	Date in DD/MM/YY format
1	" "
8	Time in hh:mm:ss format
2	" "
6	Torque
2	" "
6	Angle
2	" "
6	Torque rate
2	" "
6	Stanby characters
2	" "
3	Report code in 3 letters
1	<LF>

In "Print at end of cycle" mode, the reading number is replaced by blanks.

If one of the values is missing in the unit (eg: torque rate), it is replaced by blanks.

Example of result:

<CR>1223 02 03 00 18/04/03 09:03:45 0030.2 0120.5
0.5680 B <LF>

10.3.2.1 - Report code

(See "Report codes", page 67).

The codes emitted on letters are used for digital report outputs or printouts.

All these codes correspond to specific displays.

The table below shows the corresponding codes displayed.

On the contrary, if some messages on the screen do not correspond to a letter, it means that they are not emitted.

Code emitted on 3 letters			Code displayed on the screen
1st Letter	2nd Letter	3rd Letter	
"A"			"Accept"
"R"			"R"
	"t"		"Tmin"
	"T"		"TMAX"
	"a"		"Amin"
	"A"		"AMAX"
	"r"		"Rmin"
	"R"		"RMAX"
	"m"		"Mmin"
	"M"		"MMAX"
	"G"		"Grou"
	"E"		"Time-Time"
		"V"	"Srv"
		"P"	"Prg"
		"S"	"Dcy"
		"i"	"Imax"
		"t"	"Time"
		"e"	"Ext"
		"_"	"_ _ _"

10.4 - PC5-A format**10.4.1 - Report per spindle: torque rate, torque, angle**

Char	Designation
F0	start of frame character
01	
xx	report (in hexadecimal notation)
02	
xx	00
03	TR torque rate report (*)
xx	AA angle report (*)
04	TT torque report (*)
xx	where TR, AA or TT =01 if low report
05	11 if accept report
xx	10 if high report
06	on servodrive fault
xx	spindle belonging to reject group
07	cycle start drop
xx	cycle not completed for spindle
08	transducer fault

(*) in binary notation.

e.g.: if accept report for all the spindles:

F0 01 3F 02 3F 03 3F 04 3F 05 3F 06 3F 07 3F 08 3F**10.4.2 - Reading results of spindle 1
(x times the number of spindles)**

Char	Designation
01	spindle number
xx	
xx	applied torque (ASCII notation)
xx	e.g.:100.1 Nm
xx	30 31 30 30 31
xx	
xx	angle (ASCII notation)
xx	e.g.:40.0 °
xx	30 30 34 30 30
xx	
xx	
xx	torque rate (ASCII notation)
xx	e.g.:0.900 Nm/°
xx	30 30 39 30 30
xx	
xx	
FF	end of frame character

10.5 - PC5-B format**10.5.1 - Report per spindle: torque, angle, torque rate**

Char	Designation
F0	start of frame character
01	
xx	report (in hexadecimal notation)
02	
xx	00
03	TT torque report (*)
xx	AA angle report (*)
04	TR torque rate report(*)
xx	where TR, AA or TT =01 if low report
05	11 if accept report
xx	10 if high report
06	on servodrive fault
xx	spindle belonging to reject group
07	cycle start drop
xx	cycle not completed for spindle
08	transducer fault

(*) in binary notation.

e.g.: if accept report for all the spindles:

F0 01 3F 02 3F 03 3F 04 3F 05 3F 06 3F 07 3F 08 3F

10.5.2 - Available parameters programmed for 1 spindle (x times the number of spindles)

Char	Designation
01	spindle number in BCD
xx	
xx	minimum torque in 1/10th of Nm (ASCII notation)
xx	e.g.: 90.0 Nm
xx	30 30 39 30 30
xx	
xx	target torque in 1/10th of Nm (ASCII notation)
xx	e.g.: 100.0 Nm
xx	30 31 30 30 30
xx	
xx	maximum torque in 1/10th of Nm (ASCII notation)
xx	e.g.: 110.0 Nm
xx	30 31 31 30 30
xx	
xx	
xx	minimum angle in 1/10th of degree (ASCII notation)
xx	e.g.: 100.0 °
xx	30 31 30 30 30
xx	
xx	
xx	target angle in 1/10th of degree (ASCII notation)
xx	e.g.: 105.0 °
xx	30 31 30 35 30
xx	
xx	
xx	maximum angle in 1/10th of degree (ASCII notation)
xx	e.g.: 110.0 °
xx	30 31 31 30 30
xx	
xx	
xx	minimum torque rate in 1/100th of Nm/degree (ASCII notation)
xx	e.g.: 1.22 Nm/°
xx	30 30 31 32 32
xx	
xx	
xx	target torque rate in 1/100th of Nm/degree (ASCII notation)
xx	e.g.: 0.98 Nm/°
xx	30 30 30 39 38
xx	
xx	
xx	maximum torque rate in 1/100th of Nm/degree (ASCII notation)
xx	e.g.: 1.30 Nm/°
xx	30 30 31 33 30

10.5.3 - Results of spindle 1 (x times the number of spindles)

Char	Designation
01	spindle number
xx	
xx	
xx	applied torque (ASCII notation)
xx	e.g.:100.1 Nm
xx	30 31 30 30 31
xx	
xx	angle (ASCII notation)
xx	e.g.:40.0 °
xx	30 30 34 30 30
xx	
xx	
xx	torque rate (ASCII notation)
xx	e.g.:0.900 Nm/°
xx	30 30 39 30 30
xx	
FF	end of frame character

11 - TIGHTENING STRATEGY GUIDE

11.1 - Torque control

11.1.1 - Normal mode (continuous)

Torque control strategy is the most common use.

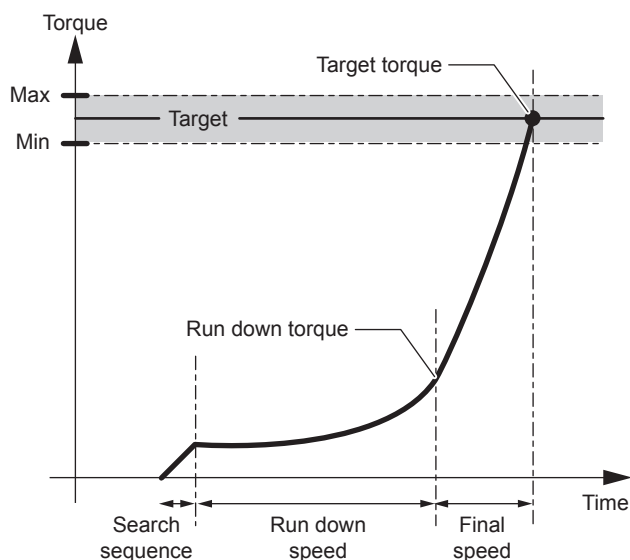
It offers the insurance that the torque has really been applied to the assembly but doesn't give the complete insurance that the assembly is correctly done.

For example the parts could be not tighten enough or not tighten at all when there are joint issues, i.e. "cross threads", missing washer, broken bolt, larger size of bolt; low quality bolt (even if the torque has been applied by the tool).

This strategy is selected when there is a wide angle dispersion and consequently it is not possible to detect the joint issues.

Some examples of joints:

- Drum washing machine
- Seat mechanism
- Outside rear mirrors
- Cooling/heating components



The recorded value is: peak torque

Spindle stop

- IF torque \geq target torque

Accept report

- IF min. torque \leq peak torque \leq max. torque

Accept report with current monitoring (optional)

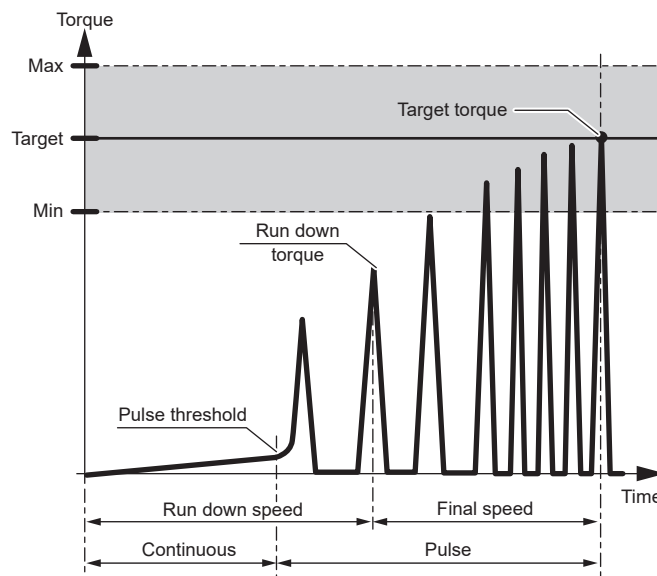
- IF min. torque \leq peak torque \leq max. torque
- AND min. current \leq final current \leq max. current

11.1.2 - Pulse mode (hybrid)

The "Torque control" strategy is effective only with joint from 0° to 200°.

It offers the insurance that the torque has really been applied to the assembly but does not give the complete insurance that the assembly is correctly done.

For example, the parts could be not tighten enough or not tighten at all when there are joint issues, i.e. "cross threads", missing washer, broken bolt, larger size of bolt; low quality bolt (even if the torque has been applied by the tool).



The recorded value is: peak torque

Spindle stop

- IF torque \geq target torque

Accept report

- IF min. torque \leq peak torque \leq max. torque

11.2 - Torque control and angle monitoring

11.2.1 - Normal mode (continuous)

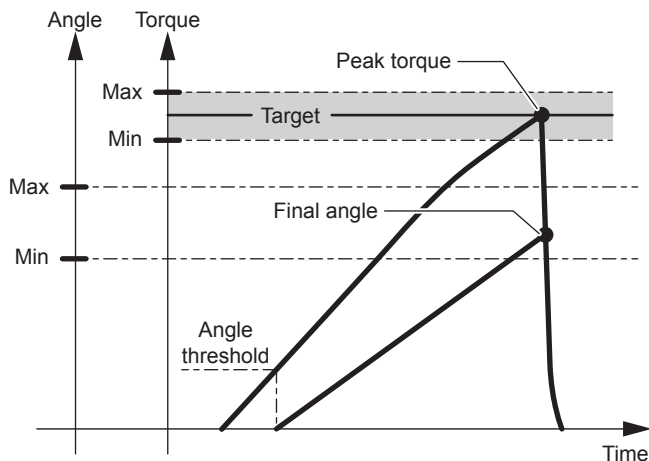
Torque control strategy coupled with a torque and angle monitoring is adapted for most assemblies.

It offers:

- The insurance that the tightening operation is correctly done,
- A regular joint quality.

To reach this performance, we monitor the angle to detect joint issues, i.e. "cross threads", missing washer, broken bolt, larger size of bolt; low quality bolt.

In case of batch count, this strategy will detect any re-tightening of the bolt.



The start of the angle threshold counting should be within the linear area of the torque increase.

The angle measurement takes into account the torsion / back torsion of the spindle by measuring the angle during the torque drop phase, until the threshold value of the angle counting start is overstepped.

The recorded values are the following: peak torque and final angle.

Spindle stop

- IF torque \geq target torque
- OR angle $>$ safety angle

Accept report

- IF min. torque \leq peak torque \leq max. torque
- AND min. angle \leq final angle \leq max. angle.

11.2.2 - Pulse mode (hybrid)

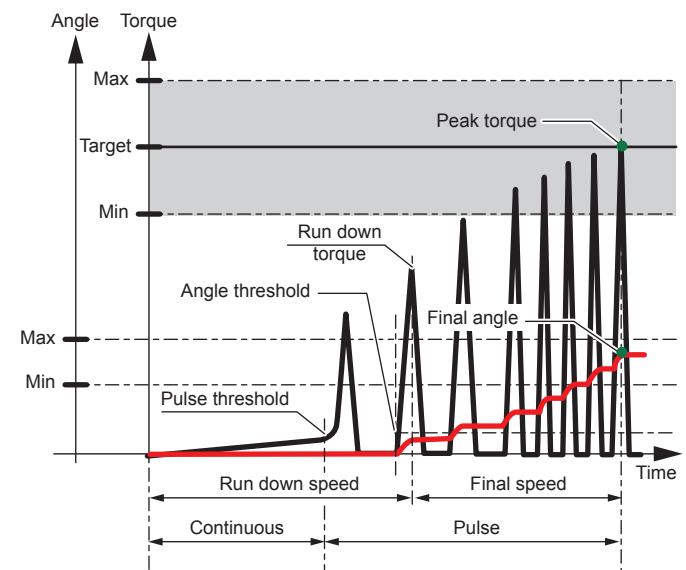
Torque control strategy coupled with a torque and angle monitoring is adapted for most assemblies in pulse mode.

It offers:

- The insurance that the tightening operation is correctly done.
- A regular joint quality.

To reach this performance, the angle is monitored to detect joint issues, i.e. "cross threads", missing washer, broken bolt, larger size of bolt; low quality bolt.

In case of batch count, this strategy will detect any re-tightening of the bolt.



The start of the angle threshold counting should be between the run down torque and the first peak torque.

The recorded values are the following: peak torque and final angle.

Spindle stop

- IF torque \geq target torque
- OR angle $>$ safety angle

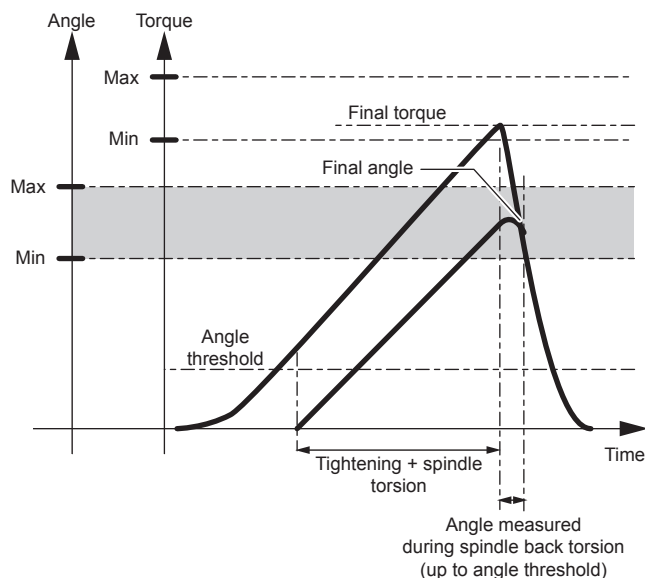
Accept report

- IF min. torque \leq peak torque \leq max. torque.
- AND min. angle \leq final angle \leq max. angle.

11.3 - Angle control and torque monitoring

For CVIL II this strategy allows to rotate by N degrees a bolt over the angle threshold.

This strategy improves the tension control into the bolt compare to torque control strategy.



The recorded values are the following:
final torque and final angle.

Spindle stop

- IF angle \geq target angle
- OR torque > max. torque

Accept report

- IF min. torque < final torque < max. torque
- IF min. angle < final angle < max. angle

11.4 - Seating detection

Seating detection is used to tighten fastener until head arrives at surface independent on the torque needed with high speed.

On this point we can reduce speed and apply a final delta torque or angle - depending what is better for the application.

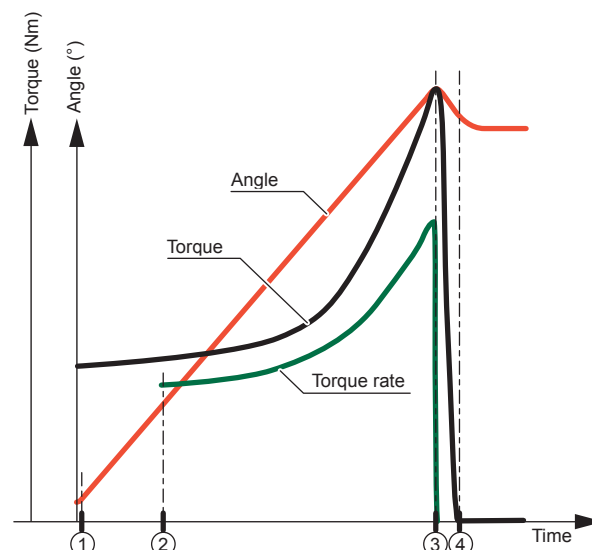
Benefits :

- Faster run down until seating - before the prevailing had to be stopped with a safety distance before seating in order not to overshoot.
 - Faster assembly, time saving.
- Monitoring covering the full run down - so we see all torques until seating.
 - Full monitoring of the curve.
- Ability to add even an angle after (was much better for tightening into wood as far we have seen).
 - More flexibility to solve assembly problems.
- Only with this strategy we have been able to solve some difficult tightening where run down (due to self tapping) was very different from one tightening to the next.
 - Fit to much more applications.

This strategy is divided into 2 phases:

- Seating detection.
- Post seating.

11.4.1 - Main phase: Seating detection



1. Wait for the threshold detection. A peak (e.g.: nylstop nut) can lead to a disturbance (a shock). In the aim to avoid this disturbance (shock) an angular delay can be programmed.
2. Next to the detection of the threshold, calculation of the torque rate according to the "Nb.Sampl" parameter.
3. Wait for the "end slope" (parameter "End Slop").
4. Motor stop in progress.

The output report is estimated by Min Torque, Max Torque, Min Angle, Max Angle.

11.4.2 - Second phase: Post-seating

This phase allows adding either an extra torque and/or an extra angle after the main phase "Seating detection".

The angle stop has a higher priority than the torque stop.

This phase differs from Angle + Torque and Torque + Angle by saving the torque value while the previous phase is ending.

Add 1N.m to a previous torque value, e.g. 5N.m, is not too tight at 1N.m but at 6 N.m.

11.5 - Stall torque controlled tightening

This tightening strategy is used to check the tuning of a tightening unit in static mode with the possibility of monitoring the linearity of its torque transducer.

The stall torque tightening is also used when you want to keep a constant torque on a joint, either to compensate a creep in a seal, or to keep a load on a joint during a complex operation.

During this phase, as long as the motor has not reached its torque value, the motor is controlled on the speed loop.

When the stall torque is reached, the torque control and stall are performed on the current loop.

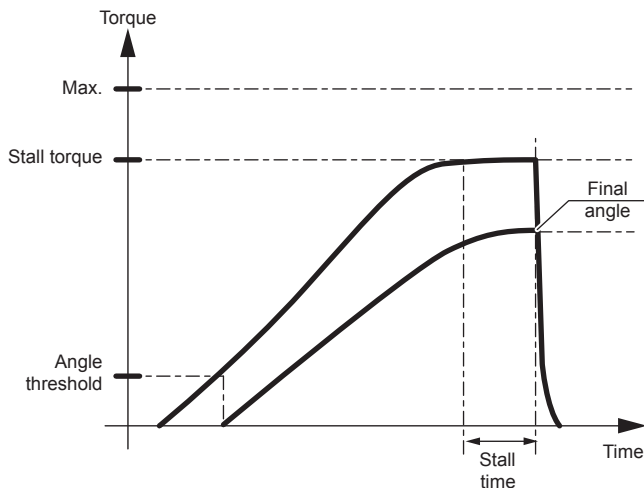
The stall time can be set between 0.1 and 10 seconds.

To avoid the overheating of the motor, in this type of application it is recommended to oversize the tightening unit.

The thermal contact located in the motor provides protection in case of overheating.

The max. torque must be programmed to a value higher than the desired stall torque.

The recorded values are the following: final torque in bolt and final angle.



Spindle stop

- IF stall time elapsed
- OR torque > max. torque
- OR angle > max. angle

Accept report

- IF min. torque \leq final torque \leq max. torque
- IF min. angle \leq final angle \leq max. angle



Bandwidth has to be set to 128Hz.

11.6 - Prevailing torque control



In the Pulse mode, the prevailing torque parameter cannot be higher than the tool max torque continuous.

This phase allows you to check the residual torque (prevailing torque) that results, for instance from the thread formed with tapping screws.

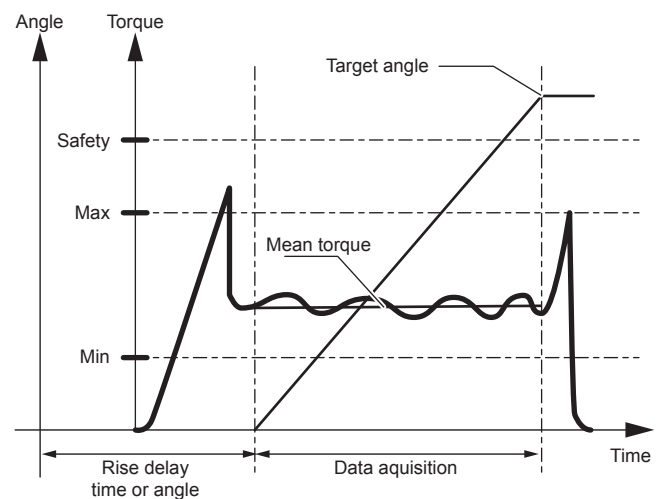
It is useful to know if the thread is formed correctly during the desired number of rotations without untimely locking or tapping deficiency.

The initial time out allows you to start the readings when the tool speed is stabilised.

The memorised result is the mean of the torque readings during the acquisition phase.

The system stops the acquisition of the torque and angle when the motor stops.

The torque pulse at the motor stop is not taken into account.



Spindle stop

- IF angle \geq target angle
- OR torque > safety torque

Accept report

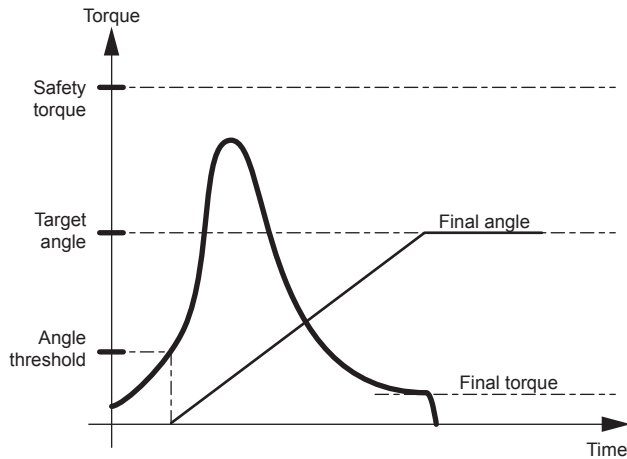
- IF min. torque \leq torque \leq max. torque

11.7 - Loosening - torque control and angle monitoring

Loosening with torque control is used when you want to maintain small constraints in the assembly.

The un-tightening operation is not complete.

In addition to monitoring the untightening of the fastener, the system monitors the number of degrees reached while maintaining a residual torque in the fastener.



Spindle stop

- IF torque \leq target torque
- OR torque $>$ safety torque
- OR angle $>$ max. angle

Accept report

- IF torque $<$ safety torque
- AND min. torque \leq final torque \leq max. torque
- AND min. angle \leq final angle \leq max. angle

11.8 - Loosening - angle control and torque monitoring

Loosening with angle control is mainly used to release the constraints in the assembly completely.

The recorded values are the following:

final torque and final angle.

Spindle stop

- IF angle \geq target angle
- OR torque $>$ safety torque

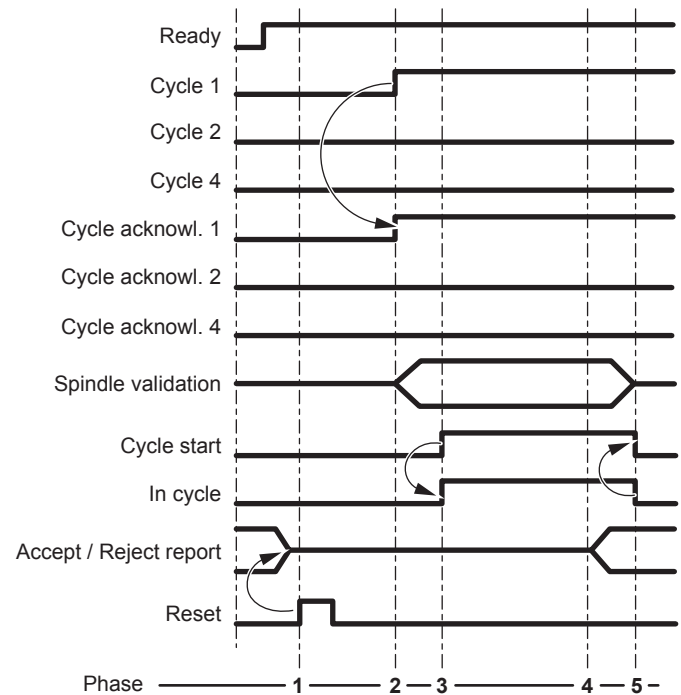
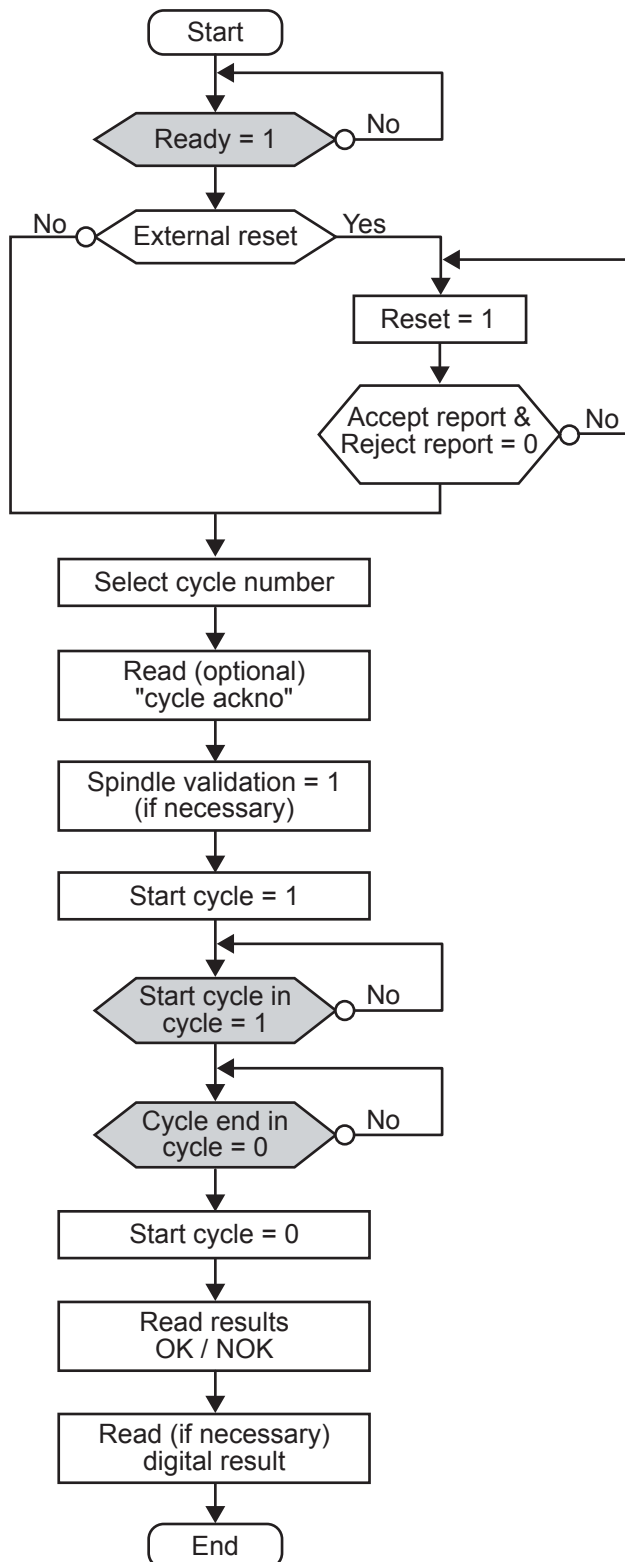
Accept report

- IF torque $<$ safety torque
- AND min. torque \leq final torque \leq max. torque
- AND min. angle \leq final angle \leq max. angle

12 - CYCLE FLOW CHART AND TIMING CHART

12.2 - Cycle timing chart

12.1 - Cycle flow chart

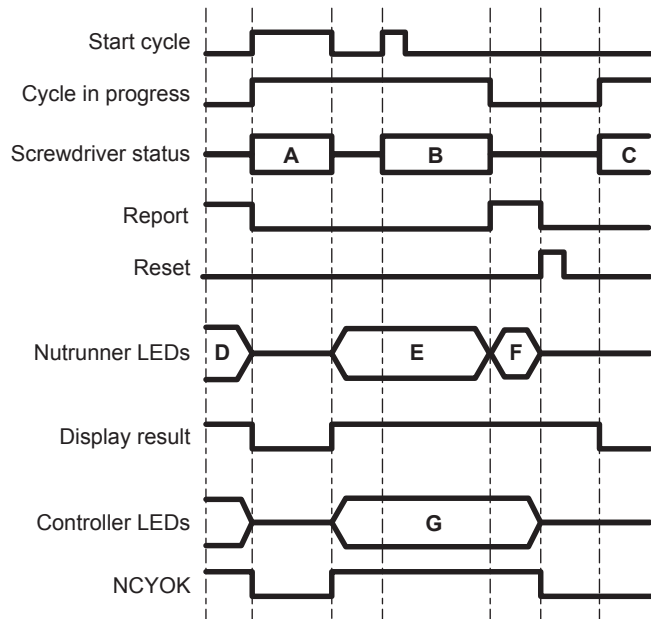


Phase	Designation
1	The Reset signal is sent by the PLC => resets the report (this PLC command is not compulsory).
2	The controller receives cycle n°1 => cycle acknowledgement n°1 is validated (if the cycle is programmed).
3	The controller receives the "Start cycle" => validates the "in cycle" signal.
4	At the end of the cycle, the controller validates an "accept" or "reject" report which is sent to the PLC.
5	The "in cycle" signal returns to zero when all the operations of the system are over.



To optimise cycle time, the PLC or digital control can be synchronised with the "accept report" or "reject report" signal, but the tightening system is ready to receive new commands (reset, etc.) only once the "in cycle" signal has been reset.

12.3 - Timing chart when using a crowfoot tool



A : Tightening (n)
B : Indexing (n)
C : Tightening (n+1)
D : Accept / Reject
E : Blinking Accept or Reject
F : Accept or Reject
G : Torque & Angle OK / Max / Min

13 - TROUBLE SHOOTING HELP

13.1 - Warning

Choose one of these 2 methods to look for information in this document:

- Locate the error message(s) displayed on the screen of the controller among the messages listed in the document. A detailed explanation helps you understand the message(s). Cross-references leading to the error causes are suggested whenever this is possible.
- Select the relevant symptom among those listed. Each possible cause is numbered to make the search easier when cross-references are used.

13.2 - Report codes

Text	Comments
Accept	Accept report
Reject	Reject report
Tmin	The final torque at the end of the cycle is lower than minimum torque tolerance.
Tmax	The final torque at the end of the cycle is higher than the maximum torque tolerance.
Amin	The final angle at the end of the cycle is lower than the minimum angle tolerance.
Amax	The final angle at the end of the cycle is higher than maximum angle tolerance.
Rmin	The final torque rate at the end of the cycle is lower than the minimum torque rate tolerance.
Rmax	The final torque rate at the end of the cycle is higher than the maximum torque rate tolerance.
Mmin	The final current monitoring at the end of the cycle is lower than the minimum current monitoring tolerance.
Mmax	The final current monitoring at the end of the cycle is higher than maximum current monitoring tolerance.
Scy	Cycle was aborted because the trigger switch was released prematurely. If it happens only just before reaching the target torque, torque and angle results may be within the programmed tolerances.
Time	Cycle was stopped after the time allocated for this phase or this cycle is elapsed and not by the target parameter. The programmed time out has to be modified to fit the application.
Err	<p>EITHER the tool or the programmed cycles are not consistent with the station mode. You can try the following:</p> <ul style="list-style-type: none"> • Make sure the station mode is set correctly, according to the tool. • Go back to the cycle parameters and save it again, so that the station mode used for the cycle is the current running one. <p>OR the speed is not constant when the torque is reached. Torque measurement is cancelled during speed transitions. This message mainly appears in case of hard joints. You can try the following adjustments:</p> <ul style="list-style-type: none"> • Reduce the final speed to increase the phase time (remain > 3%). • Reduce final speed phase acceleration time to minimum (0.01 s) to reach the tightening speed as quickly as possible. • Reduce the run down speed phase to avoid high over torque when clamping and to limit the speed gap between the run down and final speed phase. <p>If the Err message remains, it means that the joint is too hard to change the speed after clamping. Try to program a new strategy: Angle run down + Final speed phase. As the run down phase must end before clamping, the speed transition between the 2 phases no longer needs to be rapid (0.3 s is sufficient).</p>

Text	Comments
NOT READY	<p>List of errors preventing the controller from being ready:</p> <ul style="list-style-type: none"> • Over-current: Maximum servo drive current is reached. • Differential: Earth ground connection opened (the controller does not check earth linkage). This error is often due to a cable problem. • Thermal contact: Maximum motor temperature is reached (100°C). This error remains activated until the motor temperature falls below 80°C. • SPI link error: The cycle was aborted due to a digital communication problem (SPI) between the controller and the tool. • FLEX version error • Maximum current (Imax) • Resolver: Position change or non zero speed detected when the motor start is not activated. • Temperature: Power components over temperature.
QuickStop 1	<ul style="list-style-type: none"> • Inform that the input Emergency STOP1 is activated. To run the tool, the controller needs both Emergency STOP1 & Emergency STOP2 inactive.
QuickStop 2	<ul style="list-style-type: none"> • Inform that the input Emergency STOP2 is activated. To run the tool, the controller needs both Emergency STOP1 & Emergency STOP2 inactive.
Stop incoherence	<ul style="list-style-type: none"> • Inform that only one Emergency STOP is activated. This is an abnormal situation meaning that there is a fault in one of the 2 channels of the Emergency STOP. The tool cannot run. Need to repair.
Svr	<p>The cycle was aborted following a Servo drive error:</p> <ul style="list-style-type: none"> • Over-current: The maximum servo drive current is reached. • Differential: The earth ground connection is opened (the CVIL does not check earth linkage). This problem is often due to a cable problem. • Thermal contact: The maximum motor temperature is reached (100°C). The error is activated as long as the motor temperature does not fall below 80°C. • SPI link error: The cycle was aborted due to a communication problem through the digital link (SPI) between the controller and the tool. • FLEX version error (FLEX) • Maximum current (Imax) • Resolver: Position change or non zero speed detected when the motor start is not activated. • Temperature: Power components over temperature. <p><i>NOTE: All these errors deactivate the READY signal as long as the error exists.</i></p>
Over current	<p>Maximum servo drive current is reached. In this case, the motor cannot start again. Overall, it induces a Servo drive error, then a detailed Over-current error.</p>
Differential	<p>Earth tool connection fault (the CVIL doesn't check earth linkage). This error is often due to a cable problem. Overall, it induces a Servo drive error, then a detailed Differential error.</p>
Thermal contact	<p>Maximum motor temperature reached (100°C). The fault is activated as long as the motor temperature doesn't fall below 80°C again. Overall, it induces a Servo drive error, then a detailed Thermal contact error.</p> <div style="display: flex; align-items: center;"> <div> <p>WARNING: When in MAINTENANCE \ TEST \ START SPINDLE mode, this error does not prevent the motor from working.</p> </div> </div>
General	<ul style="list-style-type: none"> • Over-current: The maximum servo drive current is reached OR • Differential: The earth ground connection is opened (the CVIL does not check earth linkage). This problem is often due to a cable problem OR • Thermal contact: The maximum motor temperature is reached (100°C). The error is activated as long as the motor temperature does not fall below 80°C.

Text	Comments
SPI link	<p>The cycle was aborted following a digital (SPI) link fault between the controller and the tool. This fault removes instantaneously the READY signal of the machine (it is checked every 10 ms). Overall, it induces a Servo drive error, then a detailed SPI error.</p> <ul style="list-style-type: none"> When in the Checking channel menu we get: <ul style="list-style-type: none"> Tool error : Tool link (EEPROM) Servo drive error When in START SPINDLE mode the motor is stopped. When in TEST and CURRENT CALIBRATION mode: no action.
FLEX version	<p>The FLEX software version is lower than the one necessary for the application version. This fault can only appear after a software upgrade. Nevertheless, the delivered software automatically upgrades the FLEX software version. When this fault occurs:</p> <ul style="list-style-type: none"> It is not possible to start the motor in Normal mode. It is possible to start the tool in Test mode. It is possible to calibrate the tool manually or automatically. It is possible to adjust the resolver offset. <p>Overall, it induces a Servo drive error, then a detailed FLEX version error.</p>
Imax	<p>The cycle was aborted because the maximum tool current is reached. This over consumption may also be due to short-circuit, a cable fault, a resolver fault or an offset resolver fault.</p>
Reading EEPROM	<p>Indicates an access error to the tool's EEPROM memory:</p> <p>Writing</p> <p>When one of the following operations is wrongly carried out:</p> <ul style="list-style-type: none"> Log out / Data writing / Data re-reading / Data recorded comparison <p>Reading</p> <p>When switched on, the CVIL carries out a complete memory check</p> <ul style="list-style-type: none"> CRC of the parameters: TOOL PROGRAMMING ERROR Parameter version: TOOL VERSION ERROR Parameter changing: CHANGE OF TOOL Counter CRC: TOOL PROGRAMMING ERROR Tool cycle CRC: TOOL PROGRAMMING ERROR Cycle 0 CRC: TOOL PROGRAMMING ERROR Torque/Current table CRC: TOOL PROGRAMMING ERROR Controller/Tool compatibility: CURRENT TRANSDUCER INCOMPATIBLE WITH TOOL
Resolver	<p>Position change or non zero speed detected when the motor start is not activated. Only checked in Test mode.</p>
Temperature	<p>Indicates power components (IGBT) over temperature. The temperature is measured on the power components' cooling radiator. When the temperature exceeds 70°C, the error is activated and remains until the temperature returns below 65°C. Note that this measure also starts the internal fan from 60°C onwards and stops the fan when the temperature returns below 50°C. Overall, it induces a Servo drive error, then a detailed Temperature error.</p>
Prg	<p>The cycle was aborted due to a programming fault. For example: the programmed torque is higher than the tool capacity.</p>
Ext	<p>The cycle was aborted due to activation of the EXTERNAL STOP signal (if this option is selected in the concerned phase).</p>
Tool programming	<p>Tool memory parameters are wrong.</p>
Tool version	<p>The tool memory parameter version is not compatible with the CVIL software version.</p>
Tool link	<p>Tool memory parameter reading is impossible.</p>
Current transducer incompatible with tool	<p>The connected tool is not compatible with the CVIL model (e.g.: ECA60 connected to CVIL).</p>
E01	<p>The tool cannot run because the emergency stop is activated. Press "Enter" to get more information.</p>
E02	<p>Controller busy (for example: down-loading or up-loading in progress).</p>

Text	Comments
E03	Batch of cycle complete (number of cycles OK) if the Lock on NCYOK box (lock after a batch of cycle complete) in the STATION menu is activated.
E04	No cycle number validated on controller OR non-existing cycle number requested on the I/O port. A question mark is displayed on the screen.
E05	Spindle is idle on a start signal. No Spindle validation signal on the I/O port if the Spindle validation box is activated in the STATION menu. Tool will run only if the Spindle validation signal is activated on the I/O port. The cycle is aborted during the cycle. The cycle is stopped when the "Spindle validation" is cleared during the cycle. Pre-requisite: the "Spindle validation" is enabled with the parameter "Stop sp En=0". Refer to the "Station" chapter for more information.
E06	Start cycle arrives when the controller is not ready (may be due to a tool change, a Servo drive error, etc. that has not been reset).
E07	Spindle is disabled after a Reject report. If the Stop on bad report box in the STATION menu is activated, then the tool will be disabled. To enable it, it is necessary to activate the Failure acknowledge input on the I/O port.
e09	CVINET FIFO is full. The cycle can start but there is no free memory space left in the FIFO. Problem with the Ethernet connection or configuration may be the cause.
E09	CVINET FIFO is full. The cycle can not start because the Locking on when FIFO is full option is validated and there is no free memory space left in the FIFO. Problem with the Ethernet connection or configuration may be the cause.
E10	Report acknowledgement. The tool does not start when this error is present. If the "Report acknowledgement" parameter of the station menu is activated, the cycle start is inhibited. To release the tool start, send a "rising edge" to the "Request Report" signal on the input port.
e12	ToolsNet FIFO is full. The cycle can start but there is no free memory space left in the FIFO. Problem with the Ethernet connection or configuration may be the cause.
E12	ToolsNet FIFO is full. The cycle can not start because the Locking on when FIFO is full option is validated and there is no free memory space left in the FIFO. Problem with the Ethernet connection or configuration may be the cause.

13.3 - Operating problems due to adjustment problems

Symptoms	Possible causes	N°	Check
The tool starts then stops immediately without running the rundown speed cycle.	The "stall torque" instruction is too low. The programmed current is too low. The acceleration time is too short compared to the maximum time. The maximum time is too short or null.	01	Check the values programmed for the run down and final speed sequences.
	A machine part impedes the rotation of the tool.	02	Please contact your local Customer Center.
The tool skips the rundown sequence.	The "current" instruction is too low. The acceleration time is too short. The rundown instruction is too low. The maximum rundown time is too short. The spindle is not validated in the sequence.	03	Check the values programmed for the run down sequence.
Seen from the controller side, the tool does not reach the programmed torque or hardly reaches it.	The power programmed during the relevant phase is not sufficient.	04	Check and increase the programmed value if necessary.
	The tool is not suited to the task.	05	Check that the tool performances are compatible with the required torque.
Dispersion or abnormal deviation in the tightening results.	The rundown torque is too high as compared to the final torque.	06	Check the torque rise curves. Reduce the speed of the tool in case of hard joints. Check the value of the rundown torque: The recommended value is close to a quarter of the final torque.
	The deceleration between the rundown phase and the final phase is too slow.	07	Reduce the transition interval between the rundown and tightening phases.
	The tightening speed is too high; the consequence of inertia is the significant overstepping of the set value.	08	Reduce the speed of the tightening phase. The technology of electric motors equipped with a "resolver" allows the speed reduction up to 1 % of the maximum speed of the tool. In most case, a rotation of 20rpm will be the best compromise.
The torque displayed by the controller is far from the actual torque.	The coefficient of the tool nominal load has been updated by mistake.	09	This coefficient should be equal to 1, except in the case of additional reduction gears. Check its value in the "Parameter/Tool" menu.
The torque value is constantly equal to 0; there is no error message.	The coefficient of the tool nominal load has been set to 0 by mistake.	10	This coefficient should be equal to 1, except in the case of additional reduction gears. Check its value in the "Parameter/Tool" menu.

Symptoms	Possible causes	N°	Check
The angle displayed by the controller is different from the actual angle.	The gear ratio coefficient of the tool has been updated by mistake.	X1	This coefficient should be equal to 1, except in the case of additional reduction gears. Check its value in the "Parameter/Tool" menu.
	The angle threshold programmed on the controller is different from the one programmed on the reference torquemeter	X2	Program the same angle threshold on both the controller and the reference torquemeter.
	In case of angle tightening strategy, the difference can be caused by the torsion of the shaft. It can cause an error of a few degrees	X3	With an Angle tightening strategy, it is possible to compensate the error due to the torsion of the shaft by modifying the torsion coefficient (by default: 0.00°/Nm).
	In case of angle tightening strategy, The torsion coefficient was modified by mistake	X4	Correct the torsion coefficient. See X3.

13.4 - Operating problems due to wear or breakdown

Symptoms	Possible causes	N°	Check
The tool does not start whether in tightening, or run reverse mode. The screen is idle.	The controller is switched off	11	Check: <ul style="list-style-type: none"> The condition of the On/Off switch of the controller. That the mains voltage on the input side of the controller is not null. The condition of the controller fuses.
MESSAGE: E01	Missing Emergency stop connector or emergency stop button engaged.	13	Check for links in the emergency stop connector and check that the emergency stop button is not engaged.
MESSAGE: "Tool fault"	<p>The electrical links between the controller and the tool are faulty.</p> <p>The message "Tool fault" is displayed when an unsupported tool is connected at the start-up of the firmware.</p>	14	<p>The cable(s) is (are) not connected. The connectors are insufficiently screwed or inserted.</p> <p>There are twisted contacts or contacts pushed back in one of the connectors. Check the continuity and insulation of every electrical link in the cables; change them if necessary.</p> <p>Change the tool.</p>
Tightening report: "Srv"	Insulation defect, stop induced by the differential circuit-breaking	15	<p>Check that the "Differential" message is displayed correctly by pressing the Enter key twice.</p> <p>In that case, look for the insulation defect: it could be in the tool (motor), in the cable or in the controller.</p>
No error message, no rotation of the tool	The tool trigger is faulty	16	<p>Check that the cycle starts: a report is generated.</p> <p>In the "Maintenance - Inputs/Outputs" menu, check the switching of input no. 6. If there is a fault, test the switch between 6 and D in the tool connector ($\delta \sigma \lambda$).</p>
MESSAGE: "not ready" (blinking) (Control menu) or "servo-drive error" (Channel Test menu)	Servo-drive not ready: Open thermal contact. Could also result from a resolver fault or a resolver link fault	17	<p>Check the condition of the "thermal contact" LED on the front side of the servo-drive. If the LED is lit, check the motor temperature and the connections (if necessary).</p>
MESSAGE: "Trd"	<p>The transducer values measured are above the tolerances.</p> <p>This can be caused either by a failure of the memory board, the transducer or the connections.</p>	18	<p>Make sure that the cable and its connections are OK.</p> <p>Check that the pins of the tool connector are not pushed in or bent.</p> <p>From menu Maintenance, checking channels, transducer, press F10 to memorize the values.</p> <p>If the problem is not solved, please contact your local Customer Center.</p>
The tool does not start, but the tightening cycle is performed. Tightening report: "Scy" (if the operator releases the trigger before the end of the time delay).	Motor failure	19	Please contact your local customer center.
Tightening report: "Tmin Amin". If you look up the "information" entry, the cycle has been stopped by the "maximum current" instruction.	Motor failure	20	Please contact your local customer center.

Symptoms	Possible causes	N°	Check
The tool does not always start.	Faulty contact in the trigger switch.	21	In the "Maintenance - Inputs/Outputs" menu, check the switching of the concerned input. If there is a fault, please contact your local customer center.
Seen from the controller side, the tool does not reach the programmed torque or hardly reaches it. The motor overheats. The tool is stopped by the "maximum current" instruction.	The angle-head efficiency has deteriorated to a large extent.	23	If the wear of the angle head is low, a dynamic calibration could compensate the drift. If not, please contact your local Customer Center for a maintenance.
	The "memory" board is faulty.	24	Please contact your local Customer Center.
	Motor issue caused either by <ul style="list-style-type: none"> Damaged stator (motor failure). Faulty cable Faulty servo-driver. 	25	Check that the contacts of the motor connector or of the cable are neither twisted nor pushed back. Replace the servo driver. If the problem is not solved, please contact your local customer center.
	The tuning of the resolver is disturbed (motor failure)	26	No check is possible. Rule out every other possible cause. Please contact your local customer center for maintenance.
Dispersion or abnormal deviation in the tightening results.	The angle head is faulty.	27	This can be confirmed by checking the torque ripple of the "torque versus time" curve saved in the unit. If so, please contact your local Customer Center
	Transducer or internal connections damaged.	28	Please contact your local Customer Center.
The tool does not run in run reverse mode.	The Tightening / Untightening reversing gearbox is faulty. The run reverse speed is set to 0.	30	In the "Tests, Inputs/outputs" menu, check the switching of bit 7 when the reversing gearbox is activated. Check the "Spindle validation on run reverse" parameter. Test commutation between pins 2 and 5 of the tool connector. Check the value of the run reverse speed in the "Parameters/Station" menu. If the reversing gearbox is running correctly, the tool LEDs should blink.
The tool does not run in tightening mode, but runs in run reverse mode.	Loss of controller memory.	32	Check the presence of tightening cycles. Check that the selected cycle is programmed correctly.
	Transducer fault.	33	Refer to No. 18.
	The Tightening / Untightening reversing gearbox is stuck in run reverse mode.	34	Refer to No. 30.
Temperature.	-	37	Refer to the chapter "Control screen/ Controller temperature" to get the details.

14 - GLOSSARY

Acceleration rate	This is the time expressed in seconds for the tool to switch from the initial speed (the speed during the previous phase) to the speed requested in the next phase. The acceleration rate characterizes the acceleration or deceleration of the tool.
Angle reset	This is the action for resetting the angle value. It is usually performed at the beginning of the cycle for the whole cycle but it can also be performed at the beginning of any phase of the cycle. In the latter case, the final torque report takes the events into account from the latest Resetting action.
Angle threshold	This is the torque value from which the angle measurement is started in a phase which takes the screw angle as a basis. It is usually set to 50% of the final torque for a "Torque+Angle" tightening strategy. It is set as low as possible from the linear zone of the joint for an "Angle+ Torque" strategy.
Autotest cycle	It is possible to run an autotest cycle to regularly check the correct operation of the tool at free speed. This autotest cycle can be any cycle among the tightening cycles; only its programming is specific to check that the tool runs at a given angle and that the torque transducer provides correct indications. This function is recommended for automatic stations.
AZC	This is an Automatic Zero Control. This task consists in measuring the residual signal of the transducer (offset) when the latter is stress-free, to store it then to subtract it from the measurement. This allows you to display a torque equal to zero when no torque is applied.
Bandwidth	The bandwidth of a system is expressed in Hertz. This is the ability of a system to react more or less rapidly or to eliminate (filter) more or less interferences. For most tightening applications, a 128 Hz bandwidth is defined which allows finding a compromise between speed and filtering. When the bandwidth is reduced, the system filters to a higher extent (eliminates more interferences) but it is slower, which may result in a difference between the torque applied and the torque measured by the system.
Cycle	A cycle is a tightening program which consists of several concatenated phases, each phase being adapted to the various stages of the tightening cycle. Depending on the systems, it is possible to pre-program and select one or several tightening cycles. This allows the same tool to perform tightening with various adjustments.
Ergo-stop	When this functionality is enabled, the jerk felt by the operator at the end of the tightening operation is attenuated.
External stop	Generally speaking, the tool is stopped when the magnitude being monitored (torque, angle, torque rate) has been reached. It is an internal stop. It is possible to cause the tool to stop through an external event generated by a PLC for example. In this case, the "external stop" function must be enabled and the "external stop" input must be connected to the source of the event. The internal stops are no longer active.
Gear ratio coefficient	This coefficient is used when a mechanical subassembly is added to a standard tool and when it modifies the overall mechanical gear ratio of the tool. This is the case when an additional gear ratio stage is positioned on the tool output shaft. The angle value displayed is the angle value measured when the tool is of standard type, multiplied by this coefficient.
Nominal load	The "nominal load" is the value of the torque for which the transducer generates the "sensitivity" signal. This data is stored in the tool. The unit reads the nominal load each time it is switched on and each time there is a tool change in order to constantly compute the correct torque value. This data can be displayed but cannot be modified.
Nominal load coefficient	This coefficient is used when a mechanical subassembly is added to a standard tool and when it modifies the output torque of the tool. This is the case when an additional gear ratio stage is positioned after the torque transducer. The torque value displayed is the torque value measured by the tool transducer, multiplied by this coefficient.
Phase	A phase corresponds to a basic program step of the cycle. The program runs the phases one after another, from the first one to the last one. As an example: a typical cycle includes a runDown speed phase (D) then a final speed phase (F), each containing the data required for their execution. The maximum number of phases varies according to the systems.

Power	This is the word used to define the maximum current and therefore the maximum torque allowed in a phase. It is expressed as a percentage of the maximum current for a given tool. For instance, 100% corresponds to the full power available to run a phase. 50% indicates that the tool will not be able to supply more than 50% of its maximum torque. The Torque / Power correlation is given for information. There is no calibration between these magnitudes.
Safety angle	This is a torque value which causes the tool to stop when the said value is reached whereas all the other stop conditions have failed. This applies to the strategies where the stop magnitude is different from the torque. The safety torque allows you to protect the tool or the joint in the event of a fault.
Sensitivity	Sensitivity is a coefficient expressed in mV/V which indicates the value of the signal generated by the torque transducer when the said transducer is supplied with 1 V and for a torque equal to the "nominal load". This data is stored in the tool. The unit reads the sensitivity each time it is switched on and each time there is a tool change in order to constantly compute the correct torque value. This data can be displayed but cannot be modified.
Station	A station is a combination of tools operating together in a synchronous mode. The simplest station consists of one tool only. The maximum number of tools depends on the system. An overall report is produced for the station.
Torque reset	This is the action for resetting the torque value. It is usually performed at the beginning of the cycle for the whole cycle but it can also be performed at the beginning of any phase of the cycle. In the latter case, the final torque report takes the events into account from the latest Resetting action.

More Than Productivity