



**3-Channel Thyristor Controller for Vibratory Feeder**

A Compact control unit for a typical parts-feeding station comprising Bowl, Linear and Hopper Feeder.

- With integral functions for track control, solenoid valve and warning signals
- Touch panel with Text/Graphic display for all settings and adjustments
- Control Inputs and Outputs
- 3 Sensor Inputs for Track and Air Jet Control
- 2 x 24 VDC outputs for Air Valve or level sensor
- 2 x Status for 'READY' Mains ON and 'ENABLE ON' conditions
- 1 x Enable input, 24 VDC or volt-free contacts
- 3 x 0..210 V Feeder Outputs

**General:**

The interlocking of channels is predetermined and cannot be altered. The unit enable also enables the linear feeder and all other feeders. If the bowl feeder is inhibited then the hopper feeder also stops.

**Sensors 1 and 3** can be configured for Track control, Sensor 3 can also be configured for an Air-Jet reject output.

**Sensor 2** is always used to control the hopper feeder

**24V Output 1** switches ON as the bowl feeder starts and switches OFF after a 0...60 secs delay. Should an air-valve be required to operate before the bowlfeeder starts then the soft start time should be increased

**24 V Output 2** can be used to indicate that components are present on a transfer section at the end of the linear feeder or for controlling an airjet. The output can then be controlled from sensor 3 and ON/OFF time delays can be adjusted in the program under 'AIR JET'

In the **LOGIC** menu Sensors 1 and 3 can be configured for track control (MIN/MAX), OR AND or twin track/air operation

**Overview of Functions:**

**Feeder**

- Feeder Throughput
- Invert Enable
- Ramp up time
- Ramp down time
- Maximum limit
- Vibrating Frequency Full/Half Wave

**Track Control**

- Sensor 1 Invert
- Switch ON delay
- Switch OFF delay
- Empty warning

**Hopper Control**

- Sensor 3 Invert
- Switch ON delay
- Switch OFF delay
- Empty warning

**Solenoid Output**

- Output 1: ON with bowlfeeder/ delayed OFF
- Output 2: Using sensor 3
- Airjet or 'Present' signal
- Switch ON delay
- Switch OFF delay

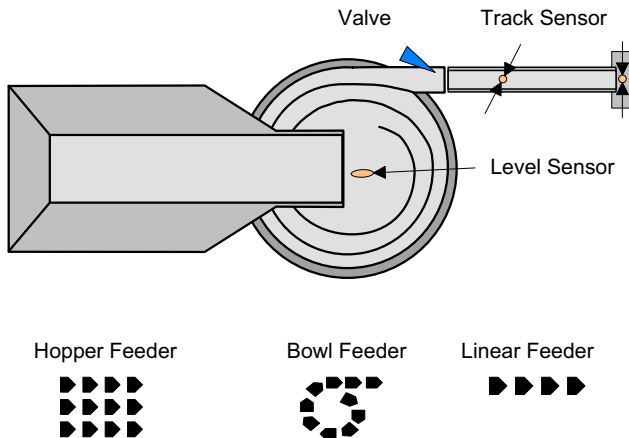
**Air Jet / Present**

- Sensor 3 Invert
- Switch ON delay
- Switch OFF delay

**Logic**

- Sensor 1 / Sensor 3
- MIN-MAX Vibration levels
- AND
- OR
- Twin Track / Air

**Feed Station with Bowl, Linear and Hopper feeders**



Hopper Feeder

Bowl Feeder

Linear Feeder

**Technical Data:****MTS 443/10A****MTS 443/15A**

Supply Voltage: 110 / 240 V, 50/60 Hz  
 Supply Current: max 10 A, RMS  
 Output Voltage per channel: 0...100 / 0...210 V  
**Output Current:** **max. 10 A , RMS**  
 Output Current Chan 1: max. 8 A, RMS  
 Output Current Chan 2: max. 6 A, RMS  
 Output Current Chan 3: max. 6 A, RMS

max. 15 A, RMS

**max. 15 A, RMS**  
 max. 10 A, RMS  
 max. 8 A, RMS  
 max. 6 A, RMS

Sensor type: PNP, 24 V  
 Output Status: 24 V, DC, 20 mA  
 Control Output 1: 24 V, 200 mA  
 Control Output 2: 24 V, 200 mA  
 Time out Status - Track: 24 V, 200 mA  
 Time out Status - Hopper: 24 V, 200 mA  
 Enable Input: 24 V, 10 mA

Total current  
 of ALL control outputs  
 400 mA

Operating temp: 0... 45°C  
 Storage temp: -10...80 °C  
 Recommended Fusing: 16 A

**Declaration of Conformity**

We declare that this product conforms with the following standards:-

EN 50081-2 and EN 50082-2 in accordance with directive 89/336/EWD

REO ELEKTRONIK AG, D-42657 Solingen

**Specified Use**

The units described in this document are electrical goods for use in an industrial environment. They designed for the control of electromagnetic vibratory feeders

**Settings:**

	Range	Default		Range	Default		Range	Default
<b>Linear Feeder:</b>			<b>Hopper Feeder:</b>			<b>Hopper Feed Control:</b>		
Feeder Speed:	0...100 %	0 %	Feeder Speed:	0...100%	0 %	Enable invert :	0 / 1	0
Enable Invert:	0 / 1	1	Enable Invert:	0 / 1	1	Switch ON delay:	0...60 Sec.	5 Sec.
Ramp up time:	0...60 Sec.	5 Sec.	Ramp up time:	0...60 Sec.	5 Sec.	Switch OFF delay:	0...60 Sec.	5 Sec.
Ramp down time:	0...60 Sec.	5 Sec.	Ramp down time:	0...60 Sec.	5 Sec.	Time-out activate:	0 / 1	0
Max Output:	5...100 %	90 %	Max Output:	5...100 %	90 %	Time-out time:	30...180 Sec.	30 Sec.
Half Wave:	0 / 1	0	AC-Motor for Hopper:	0 / 1	0	<b>24V Output 1:</b>		
<b>Bowl Feeder:</b>			Half Wave:	0 / 1	0	ON Time:	0...60 Sec.	5 Sec.
Feeder Speed:	0...100 %	0 %	Hopper Pulse Feed ON Time:	0... 60 Sek.		<b>24V Output 2:</b>		
Enable Invert:	0 / 1	1	Hopper Pulse Feed OFF Time:	0... 60 Sek.		Switch ON delay:	0...60 Sec.	1 Sec.
Ramp up time:	0...60 Sek.	5 Sek.	<b>Track Control:</b>			Switch OFF delay:	0...60 Sec.	1 Sec.
Ramp down time:	0...60 Sek.	5 Sek.	Invert Enable:	0 / 1	0	<b>Sensor Logic:</b>		
Max Output:	5...100 %	90 %	Switch ON delay:	0...60 Sec.	5 Sec.	MIN-MAX:	0 / 1	0
Half Wave:	0 / 1	0	Switch OFF delay:	0...60 Sec.	5 Sec.	AND:	0 / 1	0
			2nd Setpoint activate:	0 / 1	0:	OR:	0 / 1	0
			Time-out activate	0 / 1	0	Twin Track:	0 / 1	0
			Time-out time:	30...180 Sec		Any Channel:	0 / 1	0

## Safety Instructions

This description contains the necessary information for the correct application of the product described below. It is intended for use by technically qualified personnel.

Qualified personnel are persons who, because of their training, experience and position as well as their knowledge of appropriate standards, regulations, health and safety requirements and working conditions are authorised to be responsible for the safety of the equipment at all times, whilst carrying out their normal duties and are therefore aware of and can report possible hazards (Definition of qualified employees according to IEC 364)



**WARNING !**  
**Hazardous Voltage!**



Failure to observe can kill, cause serious injury or damage  
Isolate from mains before installation or dismantling, as well as for fuse changes or post installation modifications  
Observe the prescribed accident prevention and safety rules for the specific application  
Before putting into operation check if the rated voltage for the unit conforms with the local supply voltage  
Emergency stop devices must be provided for all applications, operation of the emergency stop must inhibit any further uncontrolled operation  
Electrical connections must be covered  
The earth connection must be checked for correct function after installation and prior to operation
























## Installation

<p><b>Check !</b></p>	<p>Are the supply, feeder coil and controller input voltages correct ? Is the controller adequate for the rated power of the feeder? Is the vibrating frequency set to the correct value for the feeder ?</p>
<p>Connect the unit in accordance with the wiring instructions and ensure that the earthing is correct !</p>	
<p><b>Beware !</b></p>	<p>An incorrect feeder frequency setting can cause drive coil (magnet) damage. Ensure that the output frequency of the control unit matches the frequency of the connected coil</p>
<p><b>Important !</b></p>	<p>New units are factory set to the parameters shown in the setting table (Default) If there is any doubt with regard to the settings, the factory defaults can be re-instated from the service menu</p>

## User Menu:

- Throughput Power: 1. Hopper Feeder  
2. Bowl Feeder  
3. Linear Feeder
- Hopper Feeder: 1. Invert the enable input (only possible in 'Independent' operating mode)  
2. Ramp up time of the feeder after start signal.  
3. Ramp down time of the feeder after stop signal  
4. Maximum limit of the feeder throughput (Output Voltage)  
5. Output for switching a conveyor hopper with 1 ph motor (Output voltage = Supply voltage).  
6. Vibration frequency of the feeder Full/Half wave.  
7. Switch ON time for pulsed operation of hopper feed.  
8. Switch OFF time for pulsed operation of hopper feeder (switch OFF time = 0, corresponds to continuous duty)
- Bowl: 1. Invert the enable input (only possible in 'Independent' operating mode')  
2. Ramp up time of the feeder after start signal.  
3. Ramp down time of the feeder after stop signal  
4. Maximum limit of the feeder throughput (Output Voltage)  
5. Vibration frequency of the feeder Full/Half wave.  
6. ON Time for an air valve (24V Output 1)
- Linear Feeder 1. Invert the enable input (only possible in 'Independent' operating mode')  
2. Ramp up time of the feeder after start signal  
3. Ramp down time of the feeder after stop signal  
4. Maximum limit of the feeder throughput (Output Voltage)  
5. Vibration frequency of the feeder Full/Half wave
- Hopper Sensor: 1. Invert the input function  
2. Switch-ON time delay for Hopper Feeder  
3. Switch-OFF time delay for Hopper Feeder  
4. Activate Stop signal for the Hopper Feeder. (Feeder stops after Time-Out has elapsed, only when '1')  
5. Time out Delay
- Track Sensor: 1. Invert the input function  
2. Switch-ON time delay for Bowl Feeder  
3. Switch-OFF time delay for Hopper Feeder  
4. Activate operation with two feed levels. Regulates the track feed without time delays by switching between feed rate levels  
5. Activate Stop signal for the Hopper Feeder. (Feeder stops after Time-Out has elapsed, only when '1')  
6. Time out Delay
- Air Jet / Present: 1. Invert the input function  
2. Switch ON time delay for 24 V Output 2.  
3. Switch OFF time delay for 24 V Output 2.
- Logic: 1. Min-Max Track control using Sensors 1 and Sensor 3.  
2. OR-Interlock with Sensor 1 OR Sensor 3 (Use Track switching for interlock output)  
3. AND-Interlock with Sensor 1 AND Sensor 3 (Use Track switching for interlock output)  
4. Used with twin tracks on a linear feeder with an air-jet ejection of the filled track (Sensor 1 & Sensor 2)
- Info: Software version, date and configuration
- Service: 1. Fault Reset  
2. Reinstate Factory Settings  
3. Select User Settings (4 User Parameters 0...3)  
4. Reload selected User Parameter set  
5. Choose language  
6. Key number for locking

## Symbol

	Bowl Feeder		Track Full
	Hopper Feeder		Inhibited, No Enable
	Linear Feeder		Time out exceeded
	Feeder Throughput		Logic
	Maximum Limit		Air Jet (Air Valve)
	Ramp up time		Lock
	Ramp down time		Information
	Switch ON Time Delay		Service
	Switch OFF Time Delay		Language
	Timer Running		Switch OFF Impulse
	Invert		Switch ON Impulse
	Vibrating Frequency		

## Time out Function:

The Time Out function can be used to warn that the hopper or bowl feeder have run out of product, but still allowing the feeder to run. If it is required that the feeder stops after the Time-Out delay has elapsed, the 'Time Out ON' must be set to '1' in the sensor menu.

When the Time-Out occurs the feeder stops, the corresponding output is energised and a clock symbol is displayed.

A Time-Out signal or shutdown can be reset with the green '1' key on the touchpanel or by operation of the associated sensor.

# Settings

Run Mode

80.0 %  
90.0 %  
70.0 %

- 1 Select Function Group
- 2 Select Function
- 3 Set Function
- 4 Further or END

Speed Speed Hopper: Speed Bowl: Speed LF:

0... 100 %    0... 100 %    0... 100 %

Hopper Feeder Hopper Feeder Inverted Enable: Hopper Feeder Soft Start: Hopper Feeder Soft Stop: Hopper Feeder Max: Hopper Feeder AC Motor: Hopper Feeder Half Sine: Hopper Feeder Time On: Hopper Feeder Time Off:

I / 0    0... 60 sec.    0... 60 sec.    5...100 %    I / 0    I / 0    0... 60 sec.    0... 60 sec.

Bowl Feeder Bowl Feeder Inverted Enable: Bowl Feeder Soft Start: Bowl Feeder Soft Stop: Bowl Feeder Max: Bowl Feeder Half Sine: Bowl Feeder Air delay:

I / 0    0... 60 sec.    0... 60 sec.    5...100 %    I / 0    0... 60 sec.

Linear Feeder Linear Feeder Inverted Enable: Linear Feeder Soft Start: Linear Feeder Soft Stop: Linear Feeder Max: Linear Feeder Half Sine:

I / 0    0... 60 sec.    0... 60 sec.    5...100 %    I / 0

Hopper Ctrl. Hopper Ctrl. Inverted Input: Hopper Ctrl. On Delay: Hopper Ctrl. Off Delay: Hopper Ctrl. Enable Time out: Hopper Ctrl. Time out:

I / 0    0... 60 sec.    0... 60 sec.    5...100 %    1... 180 sec.

Start (All Channels) / Reset Time Out

Stop (All Channels)

Unit reverts to Run Mode

If no keys are pressed for approx 5 secs

Function keys F1 & F2 are not used!

Track Ctrl. | Track Ctrl. Inverted Input: 0 / 1 | Track Ctrl. On Delay: 0... 60 sec. | Track Ctrl. Off Delay: 0... 60 sec. | Track Ctrl. Coarse / Fine: 0 / 1 | Track Ctrl. Enable Time out: 0 / 1 | Track Ctrl. Time out: 1... 180 sec.

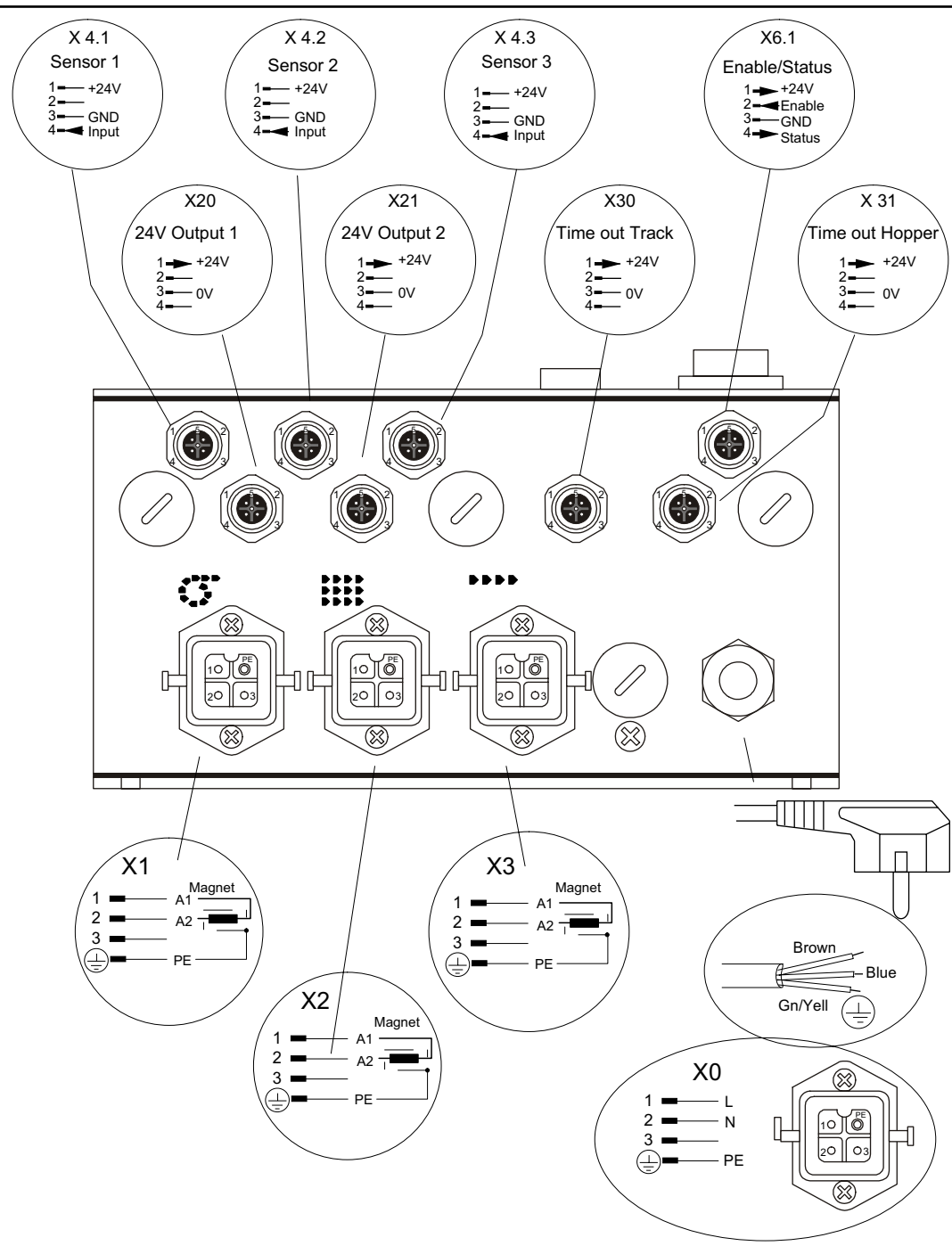
Air Jet / Present | Air Jet / Present Inverted Input: 0 / 1 | Air Jet / Present On Delay: 0... 60 sec. | Air Jet / Present Off Delay: 0... 60 sec.

Logic | Logic Min / Max: 0 / 1 | Logic Or: 0 / 1 | Logic And: 0 / 1 | Logic Air 2 Track: 0 / 1 | Logic Independent: 0 / 1

Info | Info soft 70700728 | Info Date: 04.09.2003 | Info No: nnnn-nnnn | Info Config: nnnn-nnnn | Info Config2: nnnn-nnnn | Info Config3: nnnn-nnnn

Service | Service Clear Error / Reset: RESET | Service Factory settings: RESTORE | Service User Index: 0... 3 | Service User Params: RESTORE | Service English: English, Deutsch, Francais | Service Code: 0000....FFFF

40.0 %  
80.0 %  
70.0 %



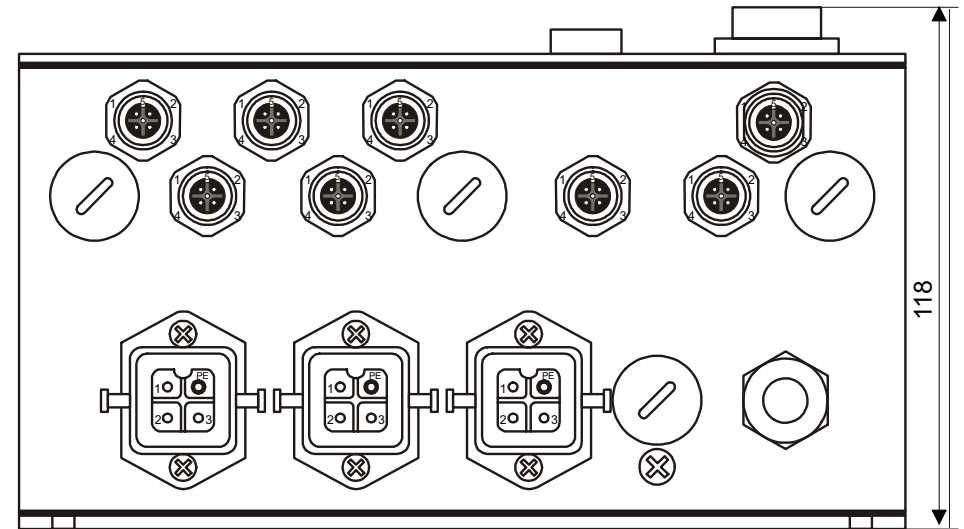
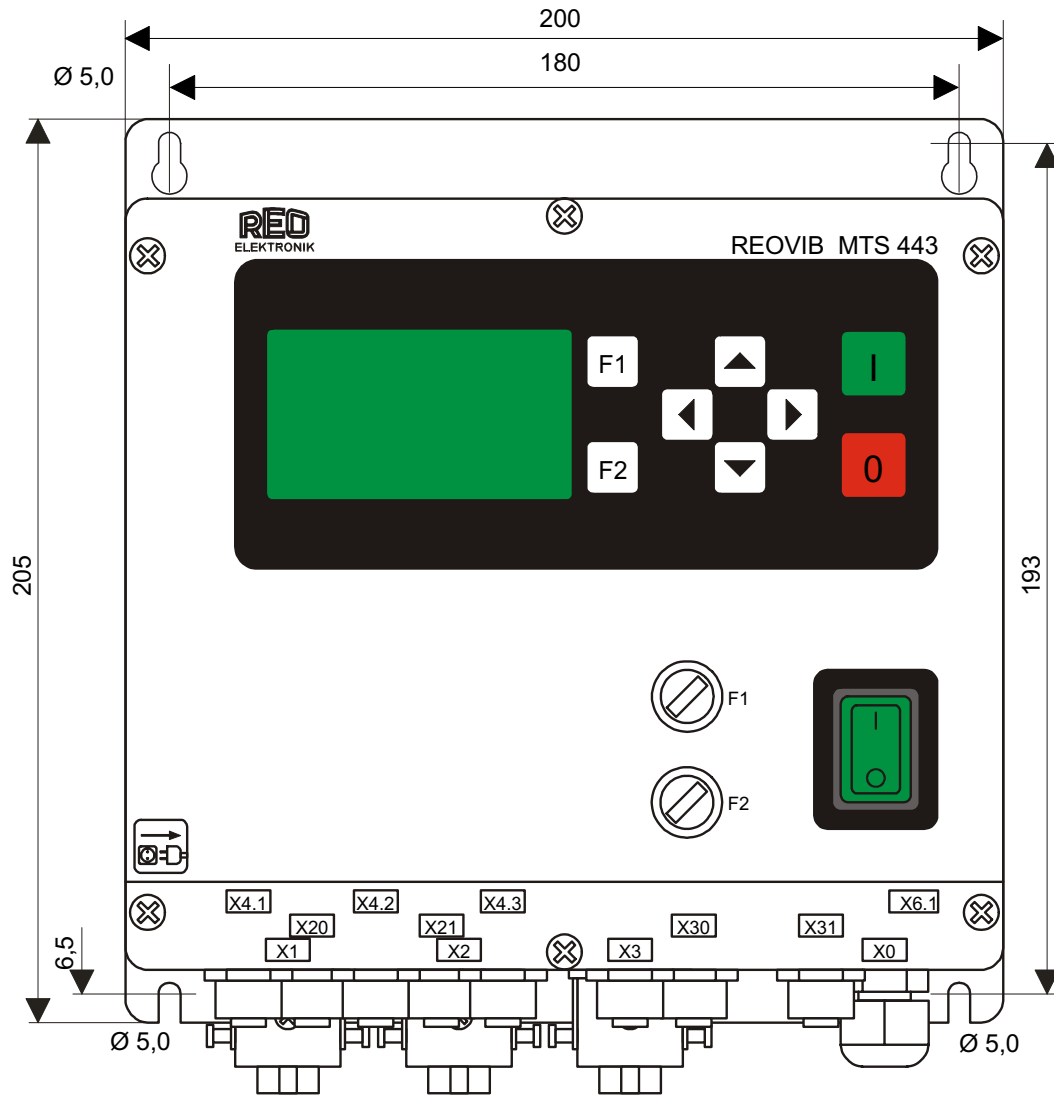
**Connections:**

X 0	Mains Input	Cable or Socket, Type Han 3+PE
X 1	Bowl Feeder	Han 3+PE
X 2	Hopper Feeder	Han 3+PE
X 3	Linear Feeder	Han 3+PE
X 4.1	Sensor 1	M 12, 4 pin.
X 4.2	Sensor 2	M 12, 4 pin.
X 4.3	Sensor 3	M 12, 4 pin.
X 6.1	Enable / Status	M 12, 4 pin.
X 20	24 V Output 1	M 12, 4 pin.
X 21	24 V Output 2	M 12, 4 pin.
X 30	Time out Track	M 12, 4 pin.
X 31	Time out Hopper	M 12, 4 pin.

**Information for Connectors**

X 0	HA-4-M-F / 090218
X 1, X 2, X 3	HA-4-M / 090212
X 4.1, X 4.2, X 4.3	RSV-M-12-4 / 090131
X 6.1, X 20, X 21	
X 30, X 31	

Dimensions:[mm]



**Service:****Key Numbers for Special Settings:**

By using special 'Key' numbers the end user can be prevented from accessing functions

Hide Parameter Menus: 0117

Hide Setpoint: 0137

**0117 Hide Parameter Menu:**

Select "Service" function group

Select "Key" function group

Using the UP/DOWN cursor keys set 0117 (Characters are in Hex Code 0...F)

Next using the RIGHT cursor key set CLOSE to '1'

All menus relating to throughput, info and service are no longer available

**0137 Close setpoint:**

Select "Service" function group.

Select "Key" using the UP/DOWN cursor keys set 0137(Characters are in Hex Code 0...F)

Next using the RIGHT cursor key set CLOSE to '1'

The Throughput menu is no longer accessible

The Key numbers are independent of each other and so both keys must be used if all parameters and the setpoint are to be closed