



# Retrofit Installation Instructions for the CrimplIQ™ Controller

PC200

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### SAFETY PRECAUTIONS



- Read and familiarize yourself with these instructions and identify all component parts before installation.
- PC200 crimper can produce 340 tons of crimping force, keep both hands away from pinch points.
- Turn off the crimper and disconnect from power source, during the disassembly process.
- Consult the Continental Crimp Specifications Manual for correct crimper setting and crimp measurements.
- Always wear eye protection.

## Safety Precautions

Retrofit Installation Instructions for the CrimplQ™ Controller

# Continental Retrofit Kit Instructions for PC200 Model



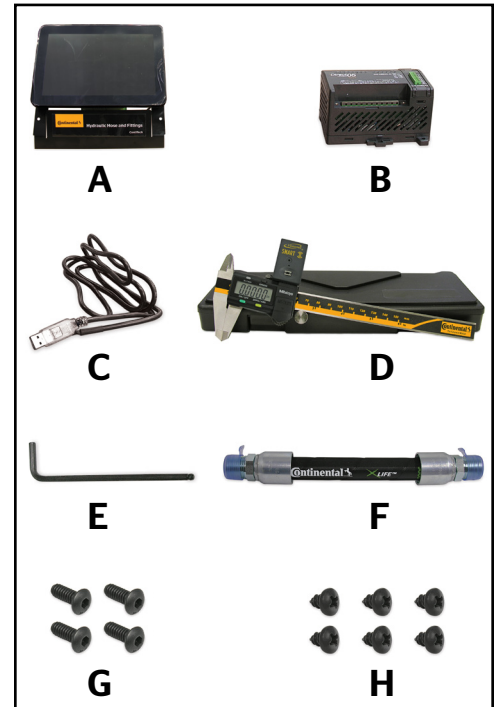
## Before You Begin:

What you will need:

### 1. Continental Retrofit Kit:

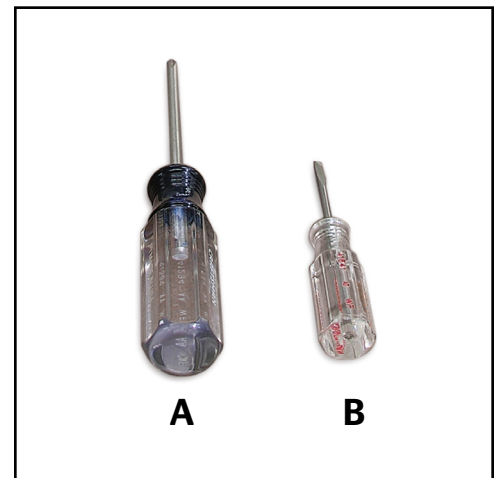
Includes:

- A. Tablet Panel
- B. PLC
- C. Connection Cable
- D. Bluetooth Calipers
- E. 1/8 inch hex key
- F. (2) Test Crimp Fittings
- G. (4) Front Panel Bolts
- H. (6) Tablet Panel Screws



### 2. Tools Needed:

- A. Philips head screw driver
- B. Small flat head screw driver



# Calibration Procedure:

**Step 1:** Make sure potentiometer (Shown on item number 1) is straight out “horizontally” aligned with the Potentiometer bracket flange (Shown on item number 2) and the Potentiometer Mounting Plate attached on the face plate. Check that the Alignment Pin (Shown on item number 3) is in the correct position and that all the bolts are tight.

**Step 2:** Perform a test crimp with your desired hose and fitting using the 23mm die set and entering a final crimp diameter of 0.945" (24.00 mm).

**Step 3:** Measure the test crimp diameter to be certain that it is within your required crimp diameter.

**Step 4:** If the test crimp diameter is not within your required crimp diameter follow the steps below to change calibration.  
A). To adjust potentiometer loosen jam nut at the end of potentiometer as shown on photo 1. **Do not turn the potentiometer shaft unnecessarily.**

**Note:**

- Adjustments are made from the back of the machine.

B). If the test crimp is too big (under-crimping), turn shaft counter-clockwise.

C). If the test crimp is too small (over-crimping), turn shaft clockwise.

**Notes:**

- Use a black marker to make a reference point on the shaft as shown on the photo 1.

- One full revolution will change crimp diameter 0.010"

**Step 5:** Perform another test crimp, and measure the test crimp diameter to be certain that it is within your required crimp diameter.

**Note:**

- If it is necessary, continue to make adjustments to the potentiometer until the test crimp is within your required crimp diameter.

**Step 6:** Once you have the correct crimp diameter, tighten the jam nut, as shown on photo 2.

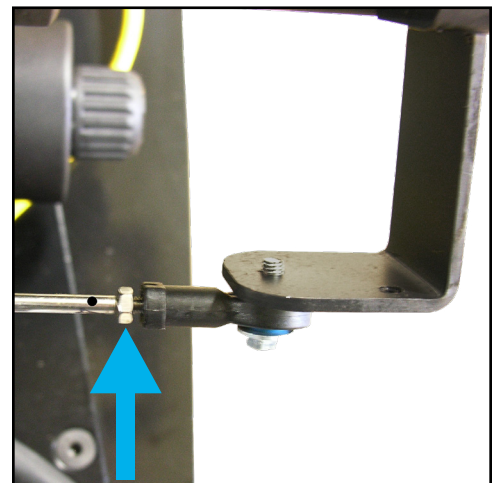
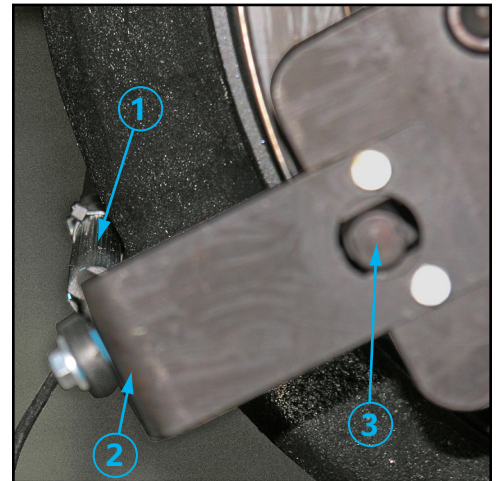


Photo 1

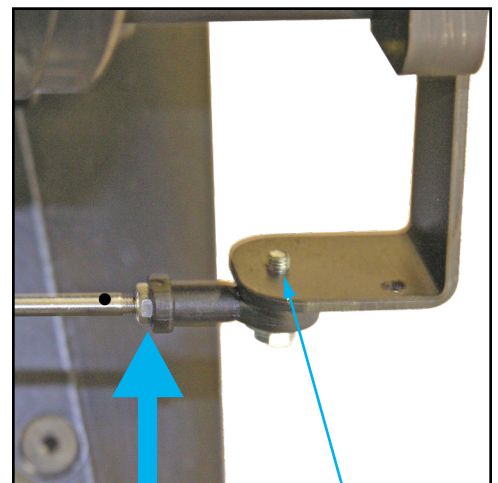
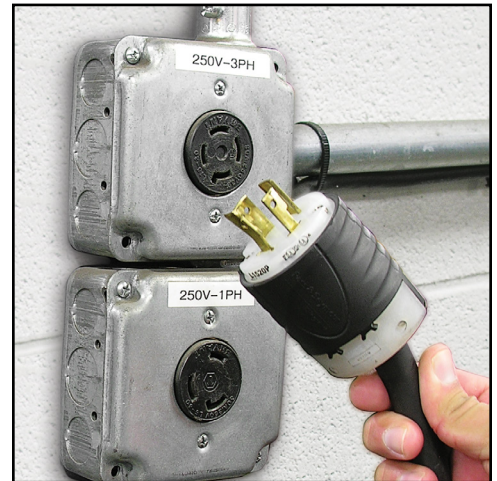
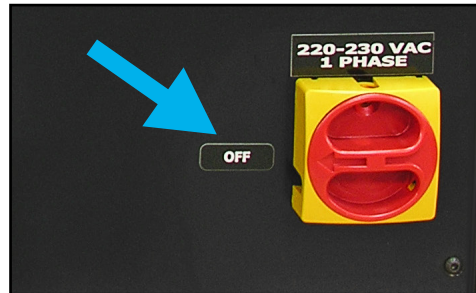


Photo 2

Only for PC200 Crimper the potentiometer must be attached in the first hole.

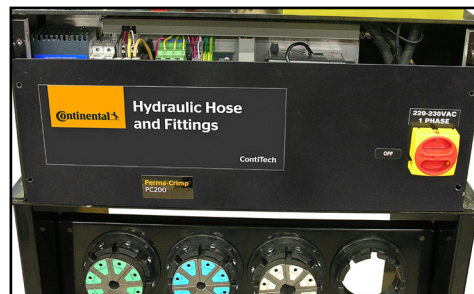
# Begin Crimper Disassembly

**Step 1:** **IMPORTANT:** Turn off crimper and disconnect from power source.



**Step 2:** **Remove front cover:** Use the 1/8 inch hex key to remove the (4) screws from the front panel. **On the last screw, hold the panel with one hand to prevent it from falling.**

**Step 3:** After the screws are out, rest the panel on the frame.



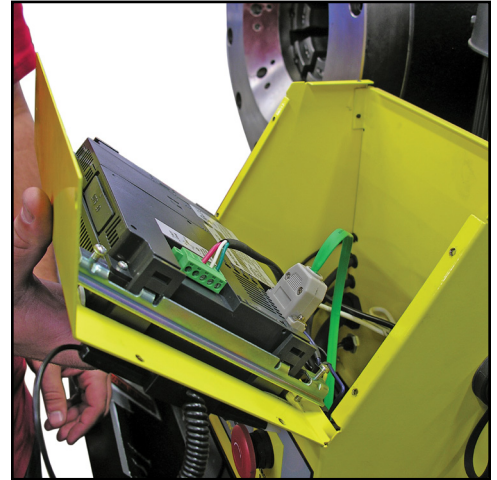
**Step 4:** **Remove control panel:** Use the philips head screw driver to remove the (6) screws from control head front panel. **You can leave the original screen mounted in the panel.**



**Step 5:** Gently pull front cover off the control head.

**Note:**

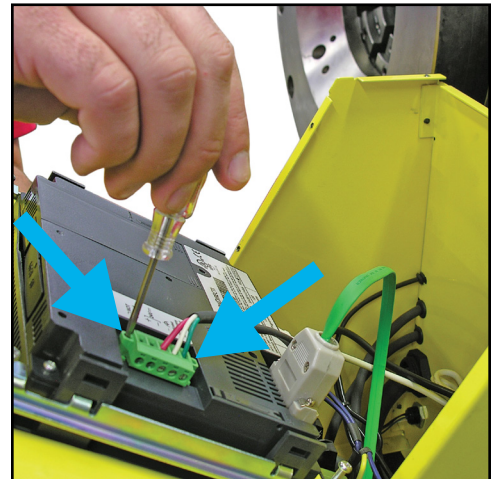
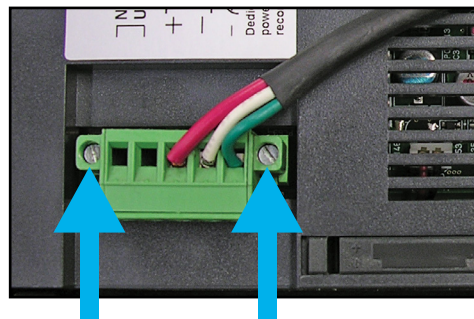
- You can balance on lip if needed.



**Step 6:** Disconnect the power cable from the control screen. Use the small flat head screw driver to unscrew the 2 screws on both sides of the connector. Then gently pull the connector out from the side of the control screen.

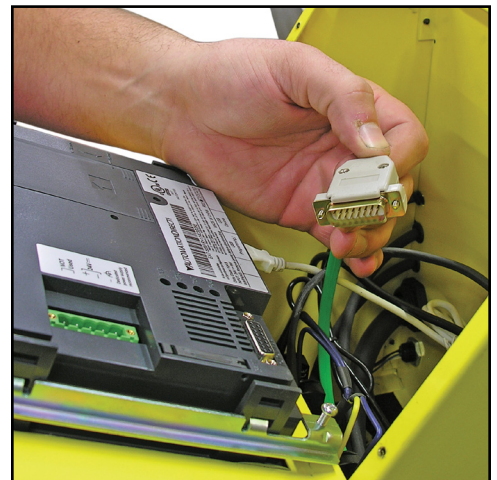
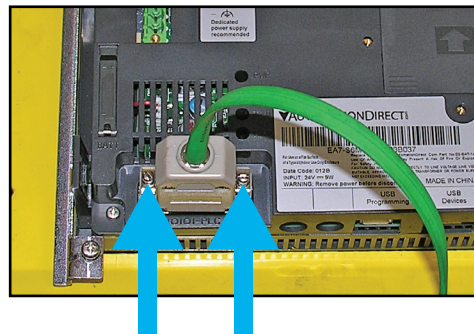
**Note:**

- Do not remove wires from connector at this point.



**Step 7:** Disconnect the control cable (flat phone cable) from the control screen. Use the small flat head screw driver to unscrew the 2 screws on both sides of the connector and pull the connector off.

**Step 8:** Push the control cable down through the hole in the top of the frame.



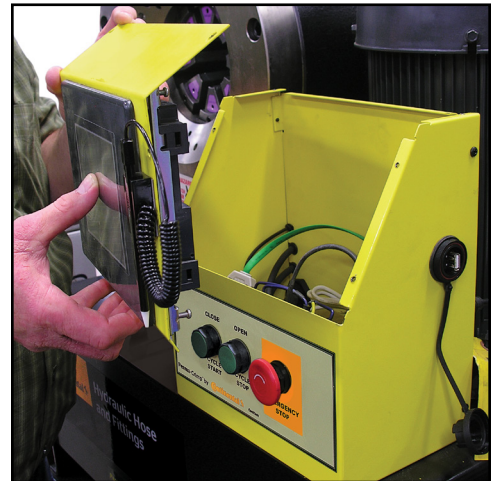
## Begin Crimper Disassembly

Retrofit Installation Instructions for the CrimpIQ™ Controller

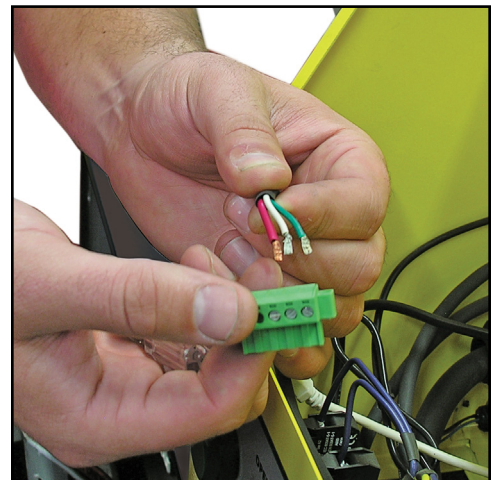
**Step 9:** Gently pull out the USB cable connector from the bottom of the control screen.



**Step 10:** Pull the head unit off the control block and put aside.

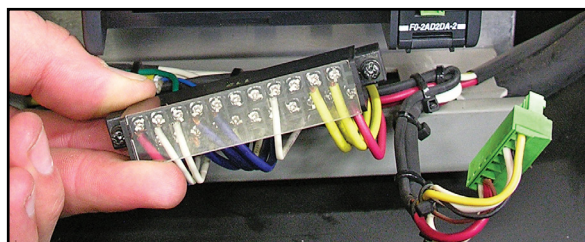
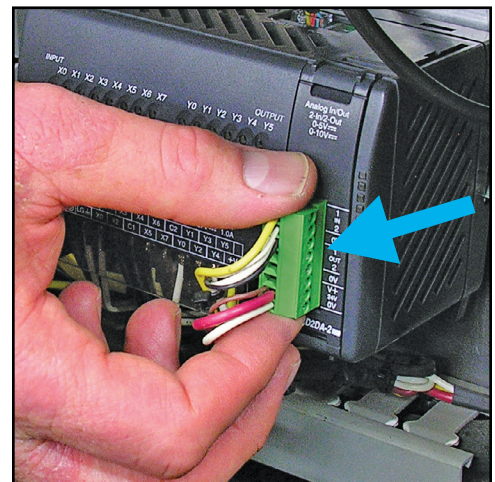
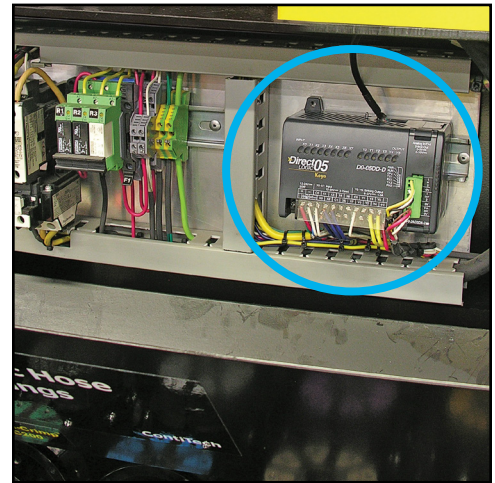


**Step 11:** Disconnect the control screen power plug from its cable. Using a small flat head screw driver, loosen the terminal screw at the top of the power connector for each wire. Pull each wire out from the connector. There should be three individual wires: red, white and green at the end of the power cable.



# Replace PLC:

- Step 1:** **IMPORTANT:** DO NOT UNSCREW ANY INDIVIDUAL WIRES FROM THE PLC WIRING HARNESS. KEEP THE WIRES ATTACHED IN THEIR WIRING BLOCKS AND CONNECTION TERMINALS!
- Step 2:** **Disconnect the PLC:** Locate the PLC in the electrical cabinet that is behind the front cover. It will be a small black plastic box, about 4 x 6 inches with wires attached to it. The PLC will have the words "Direct Logic 05" written on it.
- Step 3:** Locate the connection terminal to the Analog In/Out card on the PLC. It will be a small green block toward the right side and front of the PLC and have five or six wires attached. Gently lift up on the connector pull the connector out toward you. **Leave the wires intact.**
- Step 4:** Locate the PLC wiring block at the bottom of the PLC. On either side (left and right) of the wiring block, there are two small Philips head screws. You will unscrew these until the wiring terminal is loosened. **These two screws will not come out of the wiring harness block, just unscrew the screws until you feel no more resistance. DO NOT UNSCREW OR REMOVE THE WIRES.**
- Step 5:** Being careful not to damage or loosen any wiring, gently pull the wiring block up and out of the PLC by the base of wiring block.



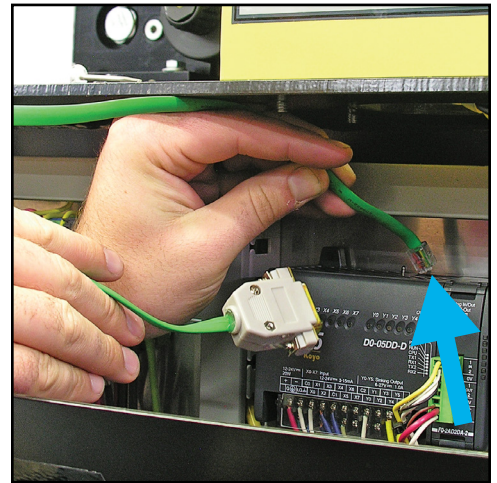
## Replace PLC

Retrofit Installation Instructions for the CrimplQ™ Controller

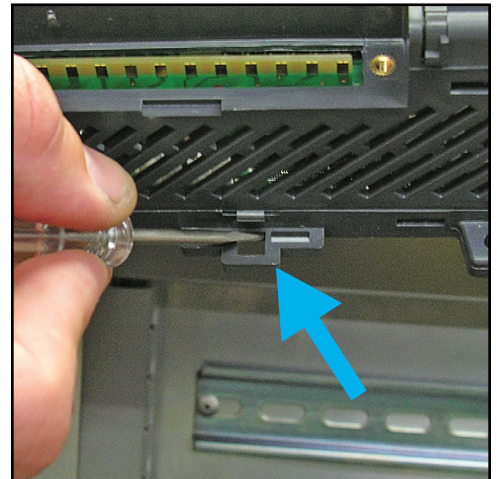
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**Step 6:** Remove the old control cable (flat ribbon cable, similar to a phone cable) from port 1 of the PLC. Gently push down and in on the connector key and pull the connector up and out.

**Step 7:** Pull the old connector cable out from the control panel enclosure. Take the old connector cable and put it aside.



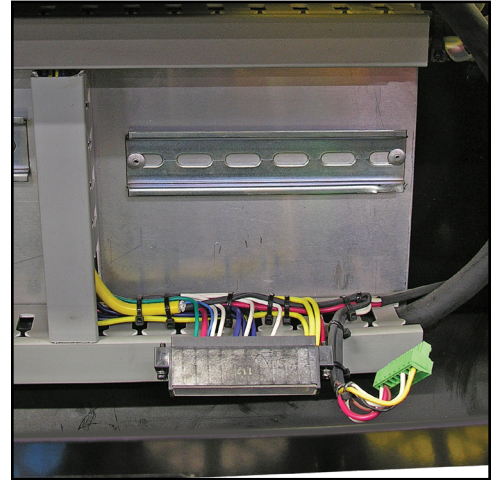
**Step 8:** **Remove the PLC:** Reach underneath the PLC toward the center of the PLC. Feel for a small plastic clip that feels like a bump along the bottom of the PLC. Use the small flat head screw driver to reach underneath the PLC and insert it into the gap of the clip and pull downward to release the clip. **Be careful not to pull the clip out of the PLC or break it.**



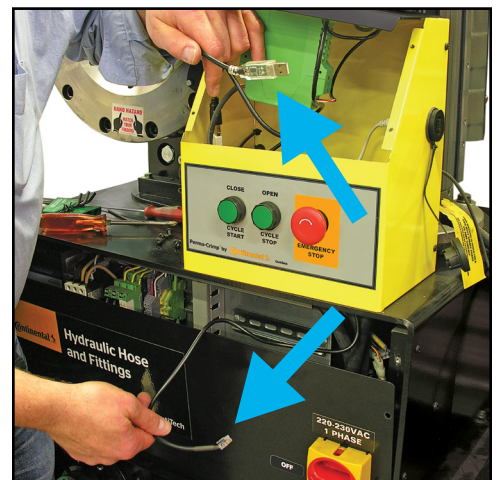
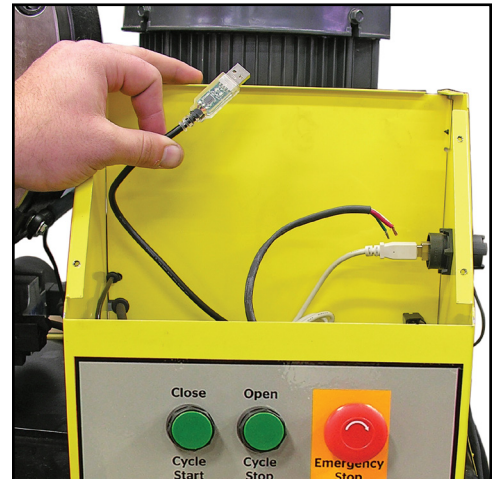
**Step 9:** Tilt the PLC up and toward you to lift it off the mounting rail.



**Step 10:** Your old PLC is now removed and can be put aside so it will not be confused with the new PLC.



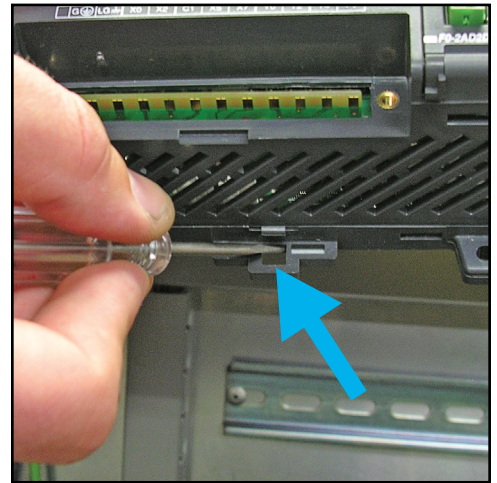
**Step 11:** **Attach the New PLC:** Take the USB/RS232 cable from the retrofit kit. Feed the USB (fat end) up into the control head through the connecting hole in the frame. Leave enough cable to reach the PLC.



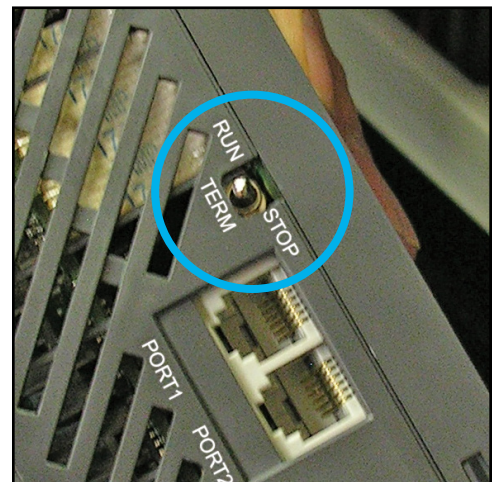
## Replace PLC

Retrofit Installation Instructions for the CrimplQ™ Controller

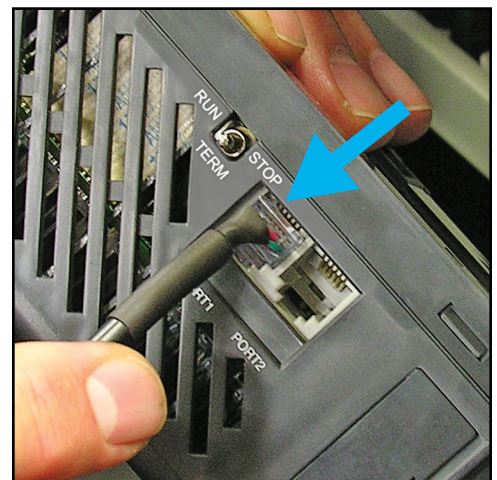
**Step 12:** Take the new PLC from the retrofit kit. At the bottom of the PLC locate the sliding mounting clip and pull it gently down until it wants to stop, no more than a 1/4 inch. **Be careful not to pull the clip out of the PLC or break it.**



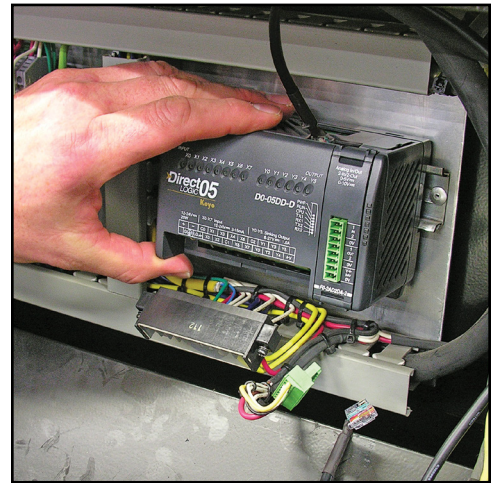
**Step 13:** Verify the PLC is set to the proper mode. Locate the small slide switch at the top of the PLC and to the left of port 1. If it is not in the middle position, switch it to the middle position (TERM).



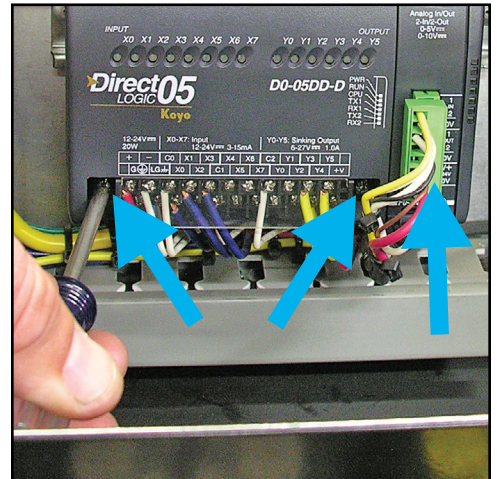
**Step 14:** Take the small phone jack of the USB/RS232 cable and plug it firmly into Port 1. **Do not overly force the connector, it will snap into place.**



**Step 15:** Take the PLC, tilt the bottom end of the PLC upward, lift the PLC over the mounting rail and gently push the PLC downward until the PLC mounting slot catches the mounting rail. Swing the bottom end of the PLC downward over the rail. The PLC should feel like it firmly caught the mounting rail. Push up on the clip on the bottom of the PLC to secure the PLC to the rail.



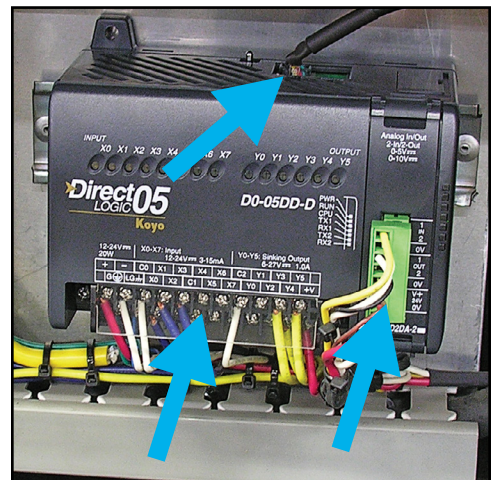
**Step 16:** Push the PLC wiring harness into the wiring harness socket on the mounted PLC. Gently push it downward until it is seated firmly in place. Use the philips head screw driver to tighten both left and right screws on either side of the wiring block. **Be careful not to damage or remove any of the wires. Do not overtighten screws on either side of the wiring harness block.**



**Step 17:** Push the green connector block back gently but firmly into the Analog In/Out card.

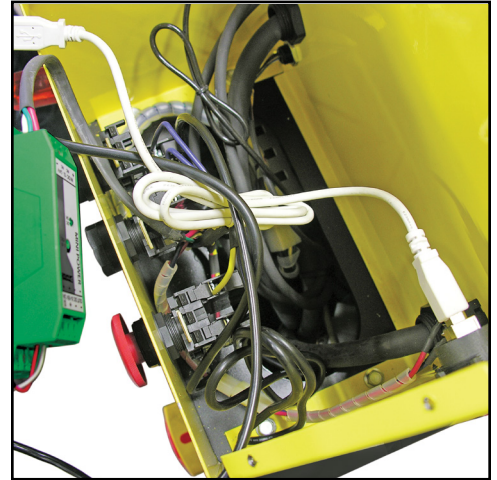
**Step 18:** Double check the PLC wiring. All connectors should be firmly in place with no loose wires:

- RS232/USB cable into port 1 of the PLC.
- The wiring block firmly attached at the bottom of the PLC.
- The green connector block attached firmly in the Analog In/Out card of the PLC.



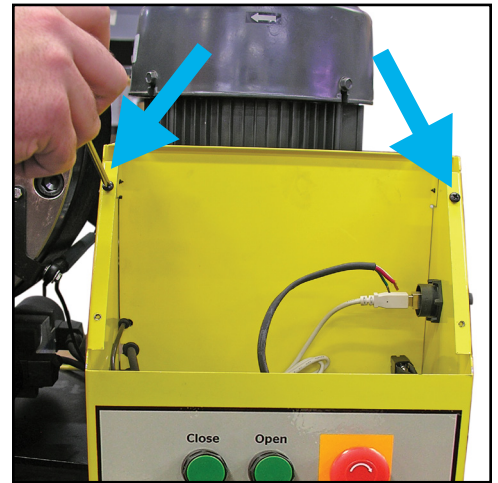
**Step 19:** Pull any remaining slack from the RS232/USB cable up neatly through the electrical box up into the control block.

**Step 20:** The PLC is now replaced. You are ready to finish the second half of the replacement.

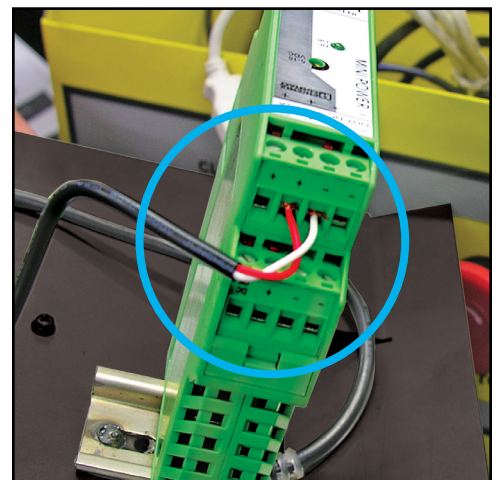


# Replace Control Screen

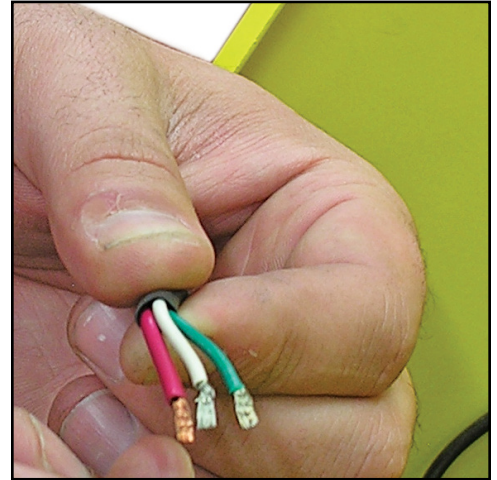
**Step 1:** **Wire New Head Unit to the Tablet:** Attach (partially screw in) two of the original control head screws into the middle two screw slots of the control head. These are positioned at the top of the slanted surface, not the top horizontal surface. Do not screw these screws completely in. Leave about 1/16 inch space to allow the tablet frame to slide between the control box surface and the head of the screw. These will act as guide screws when you attach the tablet frame to the control head.



**Step 2:** Take the tablet and its mounting frame from the retrofit kit. Verify both ends of the power connection: the barrel connector in the side of the tablet and the wiring into the green power supply are firmly and securely attached. Tighten any loose wires or push in on the barrel connector if they became loose in shipping.

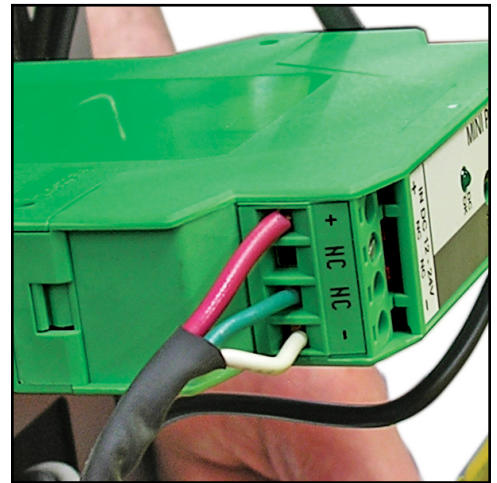
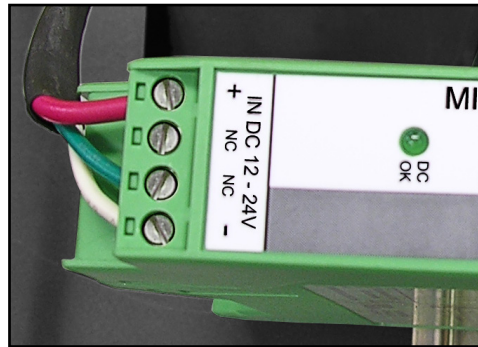


**Step 3:** Locate the original power cable for the ACT screen. This cable should be running up through the hole in the frame from the electrical panel below and be terminated by three wires (red, white and green) from the previous disassembly step. Take each of the three individual wires and carefully attach to the green power supply on the back end of the tablet frame. The red wire goes to the positive (+) slot. The white wire goes to the negative (-) slot. The green wire goes to one of the not connected slots (NC). Start with one wire. Insert the stripped end of each cable into its respective receptacle slot in the power supply. Firmly tighten the terminal screw at the top of the receptacle slot with a small flat head screw driver. Repeat for the other two wires. Double check the correct voltage polarity and wiring.

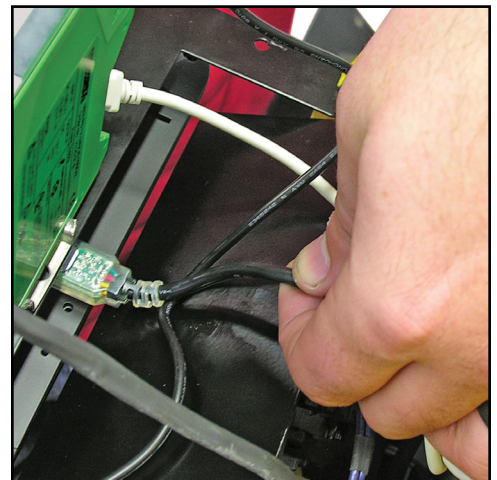


**Note:**

- If you experience difficulty orienting the power supply to the cable, you can slide the green power supply off of the rail. This makes it easier to position the cables into the sockets if the wire is short. The power supply can be pushed back onto the rail. It is a spring mechanism that locks the power supply to the rail.

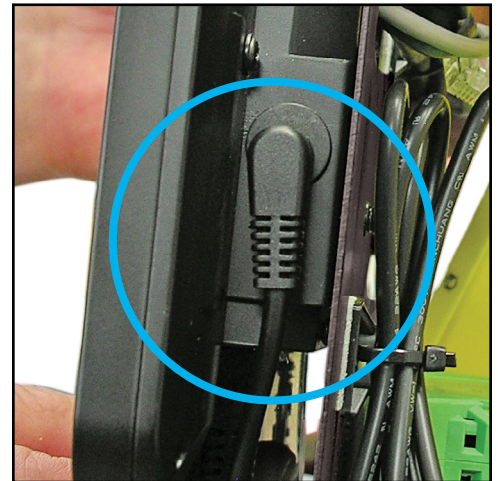
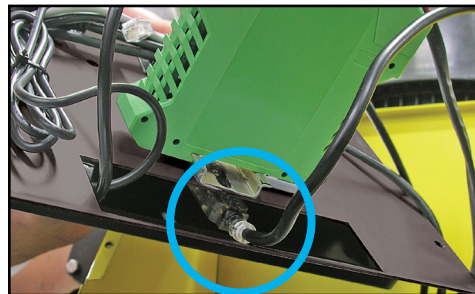
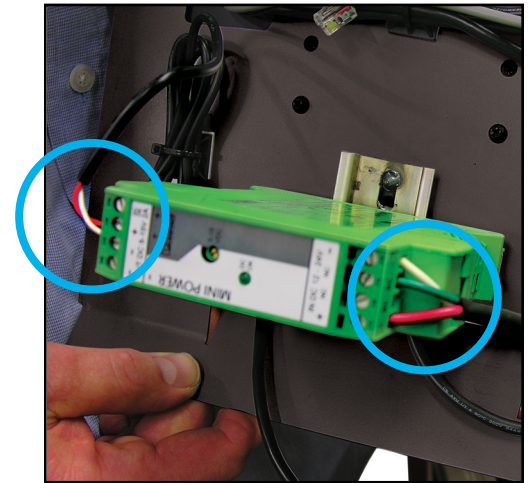


**Step 4:** Pull the remainder of the slack from the RS232/USB cable through the hole in the frame through the control head. Take the USB end and gently but securely plug that into the bottom USB socket of the tablet.

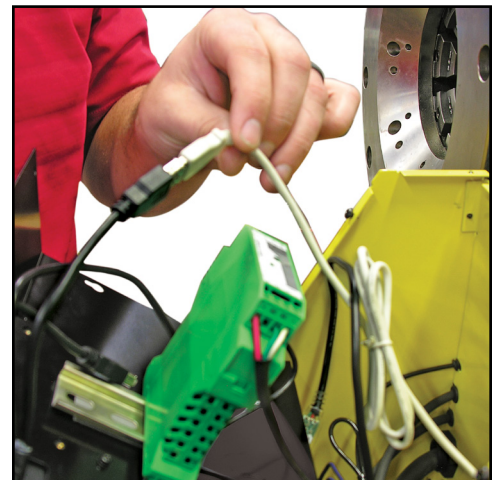


**Step 5:** Verify the four connections to the tablet control head are securely attached:

- Power from the electrical panel to the green power supply (right).
- Power from the green power supply (left) is attached to the tablet.
- Power barrel plug is inserted firmly into its socket on the side of the tablet.
- USB cable is attached to the bottom of the tablet.



**Step 6:** Connect the existing USB connection port to one of the free USB cables from the tablet.



## Replace Control Screen

Retrofit Installation Instructions for the CrimpIQ™ Controller

**Step 7:** **Attach the Tablet to the Control Head:** Gather up any slack from the cabling inside the control head and neatly secure and tuck the excess cabling inside the control head unit.



**Step 8:** Take the tablet frame and line it up over the screw holes. Line the middle two tear dropped shaped holes, over the middle two screws from step 3 above. Put the fat end of those screw holes over the screw heads and slide the frame down over the control head. Line up the other screw holes.



**Step 9:** Use the philips head screw driver to tighten the remaining screws. **It is helpful to halfway tighten the screws until the final testing is complete in case you need to pull the cover off for troubleshooting.**



# Finishing Up

**Step 1:** **Power On Unit:** Attach power to the crimper.



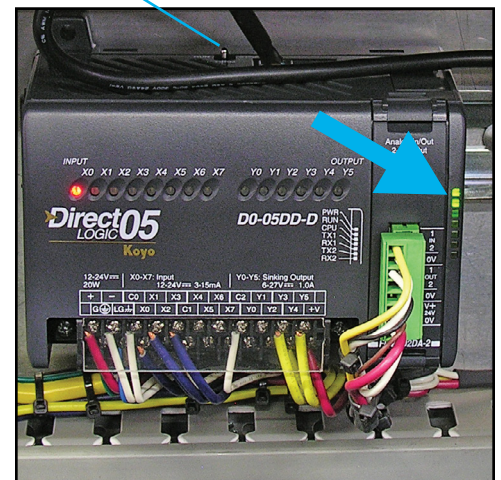
**Step 2:** Turn the power switch on the crimper to on position.



**Step 3:** **Perform Initial Checks:** Check the PLC and verify the power light is on.

**Note:** Two small green lights on the upper right side of the PLC indicate power is on and it is in run mode. If the second green light is not turned on, locate the toggle switch at the top of the PLC and to the left of the cable on port 1. Move the switch right - left - center. The second green light should now appear.

toggle switch



## Finishing Up

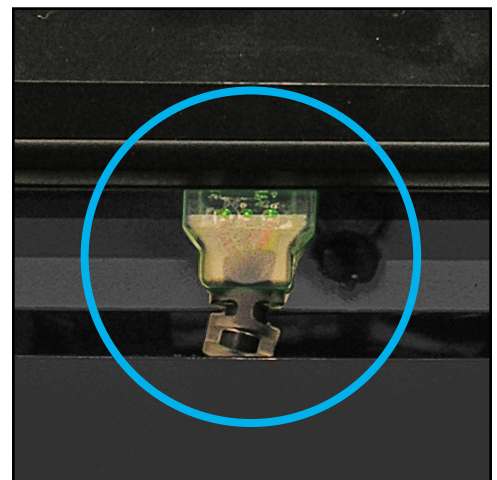
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**Step 4:** Verify the tablet has power by watching it boot up.

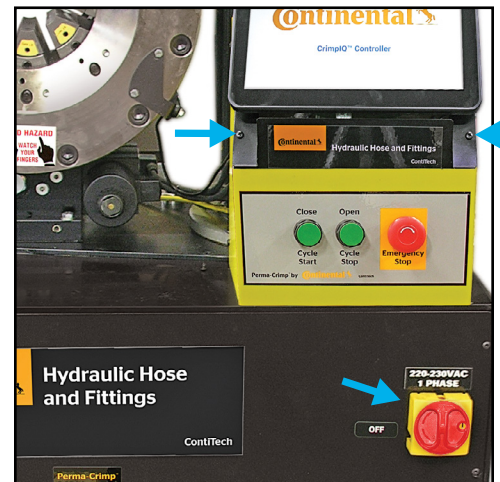


**Step 5:** After the tablet boots up (about one minute), look at the bottom of the tablet from the side of the tablet. Verify that the USB cable end is flickering with green and red lights. It is helpful to look at the tablet from the side if the bottom cover plate is covering the USB connector.



## Post installation work:

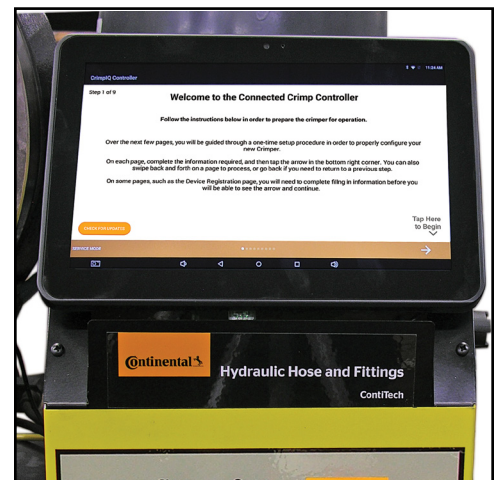
- Step 1:** Turn the power switch on the crimper to off.
- Step 2:** **Attach Front Cover:** Line up one of the top holes in the front panel to the frame.
- Step 3:** Screw in one of the machine screws. Do not overtighten, just screw in enough to hold the panel in place.
- Step 4:** Repeat the last two steps for the other top hole in the panel.
- Step 5:** Attach the bottom two screws to the front panel.
- Step 6:** Firmly tighten all (4) screws on the front panel.
- Step 7:** Firmly tighten the four outer screws (two top, two bottom) on the control head. The middle two screws are hidden behind the tablet and cannot be reached with a screw driver.
- Step 8:** Turn the power switch on the crimper to on.



## Tablet Controller Registration:

- Step 1:** After the tablet boots up from the post installation work, you should be at the **Machine Registration** screen.
- Step 2:** Follow the screen prompts to complete the registration process.
- Step 3:** After each step, you can tap the right arrow button on the lower right or use a finger swipe action from right to left to move to the next screen.

- Notes:**
- It is helpful to have access to the computer or device that your registered email address is used. You will be sent an email to that email address that you will need to respond to in order to complete the registration process.
  - You can view and accept the terms and conditions to continue. It is not necessary to email them to your email account unless you want to.



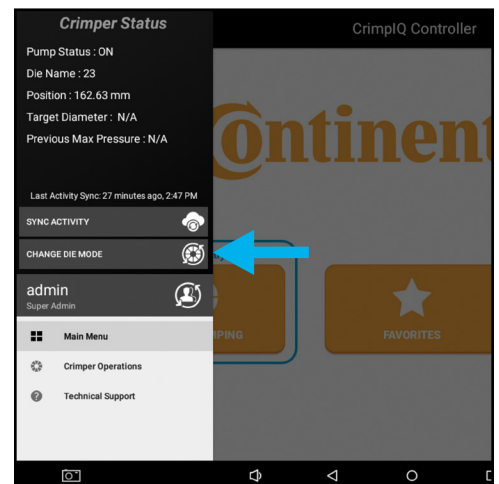
## Test Motor and Buttons:

**Step 1:** Pull out the left menu - tap the “Menu” button at lower left or swipe to the right.

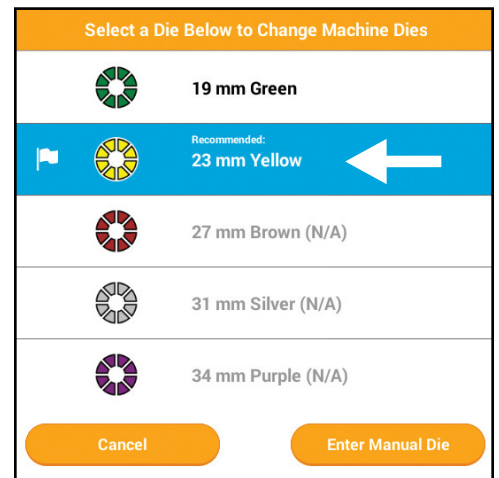
- Notes:**
- For testing the motor and buttons, it is assumed you have the crimper in a neutral position with the head not completely opened or closed.
  - If the head is completely closed, perform step 6 before step 5 (open then close).
  - If the head is completely open, perform step 5 before step 6 (close then open).



**Step 2:** Tap the “Change Die” option.



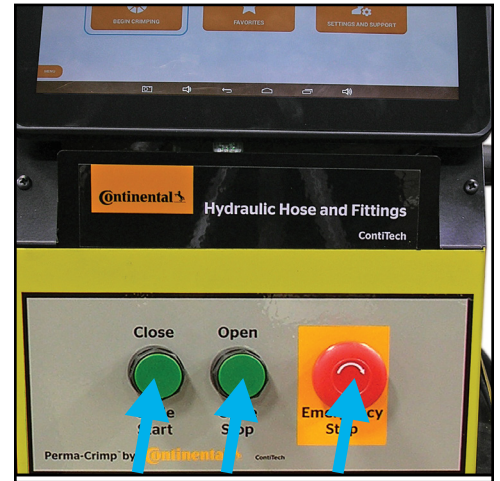
**Step 3:** Select any die size and tap the highlighted row.



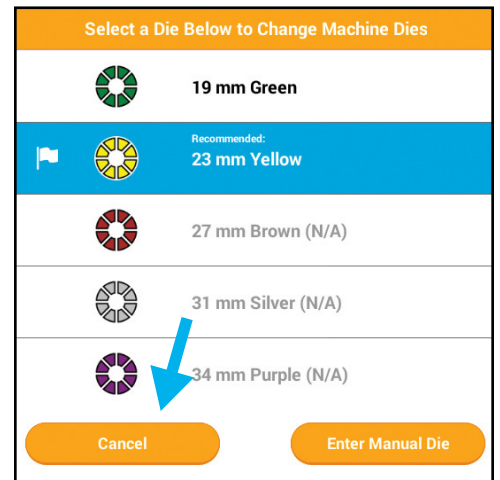
**Step 4:** The motor should start engaging.

**Step 5:** Press the **close** button on the panel for about a second, the crimp head should close.

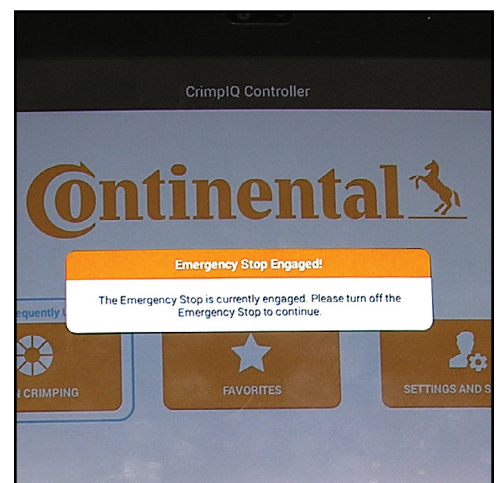
**Step 6:** Press the **open** button on the panel for about a second, the crimp head should open.



**Step 7:** Press the **cancel** button, the motor should stop.



**Step 8:** Press the **emergency stop** button on the panel. An emergency stop message should display on the tablet.



## Test your First Crimp:

**Step 1:** After completing the registration procedure and the initial motor and button test, go to the main menu. If you are not in the main menu, you can tap the “menu” button at the lower left and select “main menu”.

**Step 2:** Tap the “Begin Crimping” button.

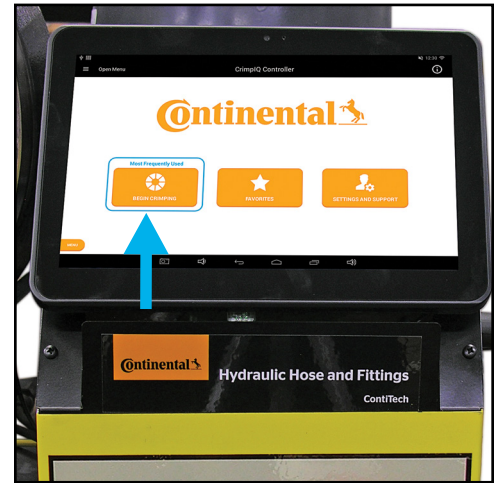
**Step 3:** Select your choice of crimping to a specific diameter for a hydraulic hose, crimping an industrial hose, or preselecting a specification from a MyCrimp® specification.

**Note:**

- Refer to the operators manual for crimping instructions.

**Step 4:** Follow the prompts to change dies, enter the hose and fitting parameters (if necessary) and crimp the assembly.

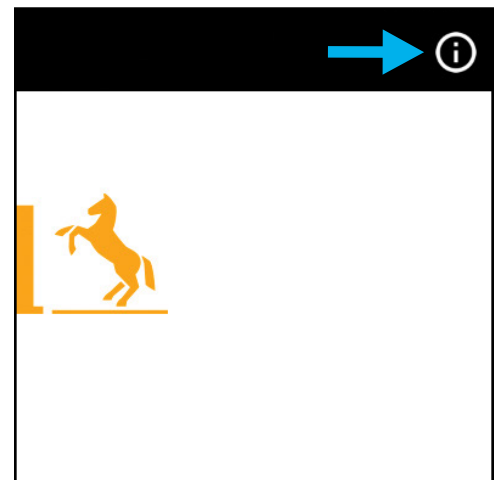
**Step 5:** If the measured crimp is significantly out of tolerance, your machine may require recalibration. Refer to the calibration instructions for your unit or contact customer support for assistance.



## Additional Troubleshooting and Help:

On the tablet, there are built in tutorials to help with specific actions for the crimp controller app. On the upper right corner of the tablet screen, there is a small letter “i” with a circle around it. Tap that to view a list of tutorial and help guides.

- For further technical support call at: (219) 462-6128



# Connecting Bluetooth Calipers

The CrimpIQ™ Controller supports the ability to integrate with Bluetooth Calipers, allowing for fast and easy wireless transfer of measured crimp diameter to the controller.

Bluetooth Calipers are included in the Continental Retrofit Kit, and should already be setup and paired with the CrimpIQ™ Controller. But if you have any issues, follow this guide in order to set up the accessory.



## Initial Setup:

**Step 1:** Verify that the batteries are installed into the calipers and into the Bluetooth dongle.

**Note:**

- To replace batteries when needed, use a SR44SW 1.55V battery for the calipers, and CR2032 3V battery for the Bluetooth dongle.



**Step 2:** If necessary, remove the standard port cover from the top of the calipers above the Mitutoyo logo with a paperclip. Insert dongle into port facing same direction as caliper screen.

**Note:**

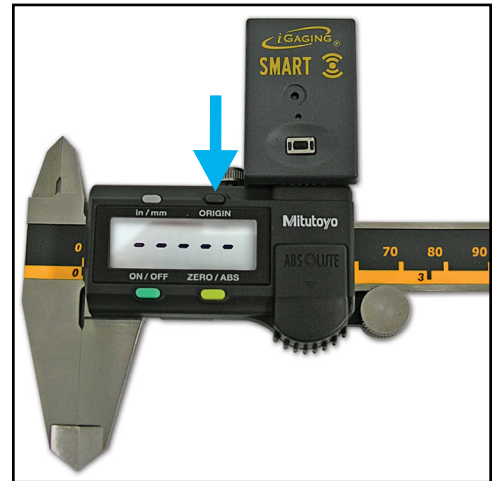
- There may be a cover installed over caliper accessory port. Remove with a paper clip. Then, insert the Bluetooth Accessory into the calipers, with the button facing toward the calipers screen and measurement panel.



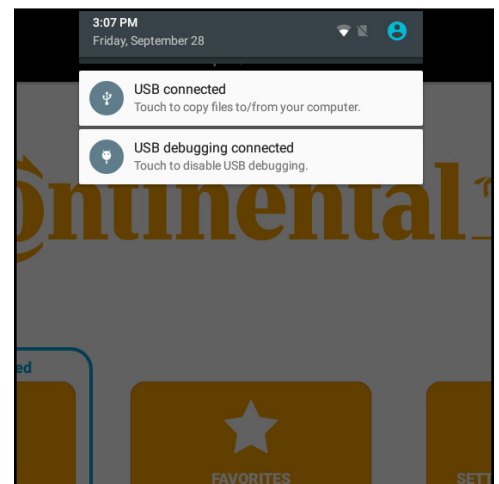
## Connecting Bluetooth Calipers

Retrofit Installation Instructions for the CrimpIQ™ Controller

**Step 3:** With the caliper fully closed, hold the origin button for 2 seconds. After this is complete, the caliper screen should show 0.00 inches/millimeters when at the zero position.

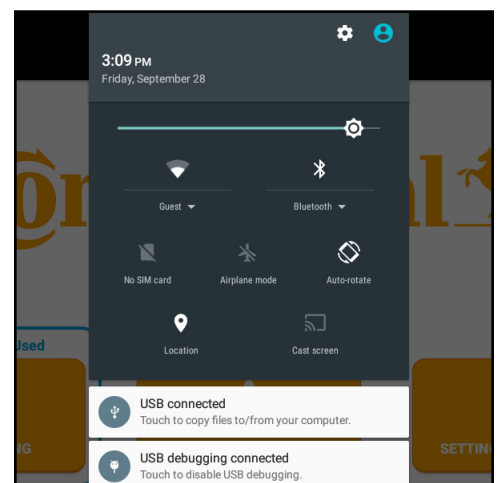


**Step 4:** **Access the device's Bluetooth Settings:** Swipe down from the upper right of the device screen, to reveal an options panel. Tap the Bluetooth button to open the Bluetooth management page.

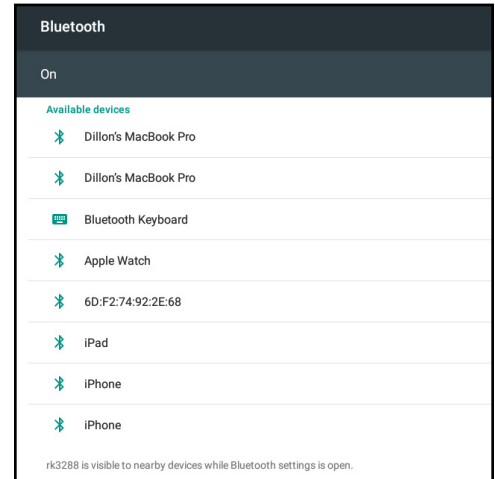


Android 5.1 Above

**Step 5:** Tap gray area in pull down menu and tap the Gear icon to show full settings menu.



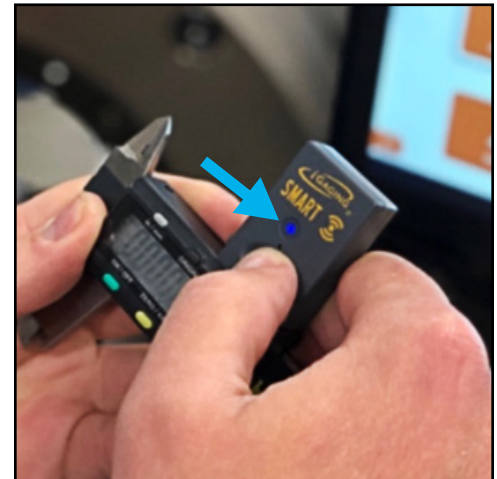
**Step 6:** Tap the Bluetooth Button and launch the Bluetooth Menu.



**Step 7:** Hold Bluetooth Accessory button, until the blue light blinks.

**Note:**

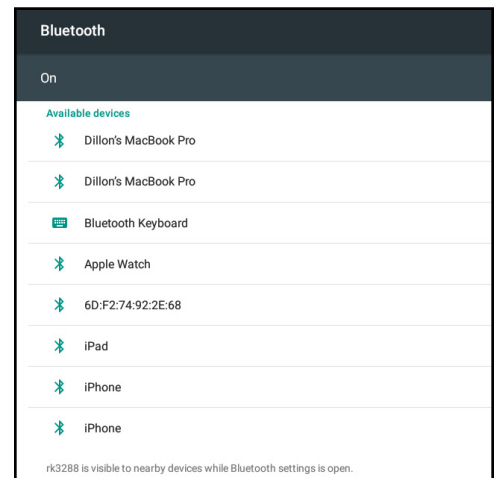
- Firmly press and hold on the Bluetooth accessory's click button for approximately 5 seconds, or until the blue light begins to flash.



**Step 8:** **Find the Bluetooth Accessory in the list of all available devices:** First, make sure that the Bluetooth feature switch is in the On position. When Bluetooth is enabled and the blue light on the adaptor is flashing, the device should appear on the list with the name "Bluetooth Keyboard", and you should see other devices available as well, for nearby phones or computers. It is possible that the device will appear with no name, or a name such as

OF : 5E : 12 : 9A : B4

, or any other group of letters and numbers. If a series of letters appears, you should still see the gray keyboard icon to the left of the device name. Tap on this item in the list while the blue light is still flashing on the calipers to begin the syncing process.



## Connecting Bluetooth Calipers

Retrofit Installation Instructions for the CrimplIQ™ Controller

**Step 9: Test Using the Caliper:** The calipers will still work in text entry fields in the app where a diameter needs to be entered. Just make your measurement and tap once on the silver entry button on the Bluetooth Accessory.

**Note:**

- The accessory automatically powers itself off when not in use (you still need to power the caliper screen off between each use), and will turn back on after pressing the button. With this behavior, it may take a second for the calipers to register a measurement when performing a first measurement of the day.

## Troubleshooting: Number Pad Not Showing

If you find testing the calipers that the number pad isn't displaying on screen to manually enter values or login as different Users it is because the **Show Input Method** setting is off. This should be turned ON during setup but if it is ever missed it can be fixed manually.

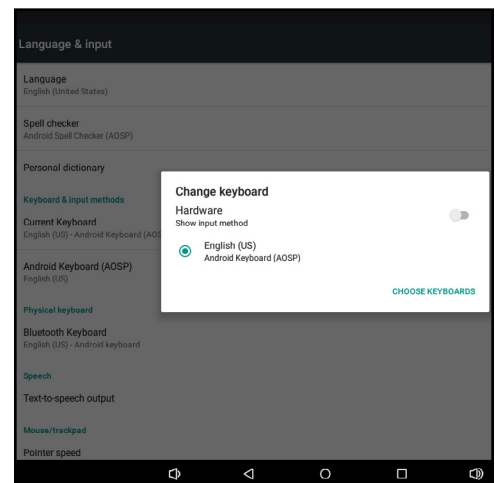
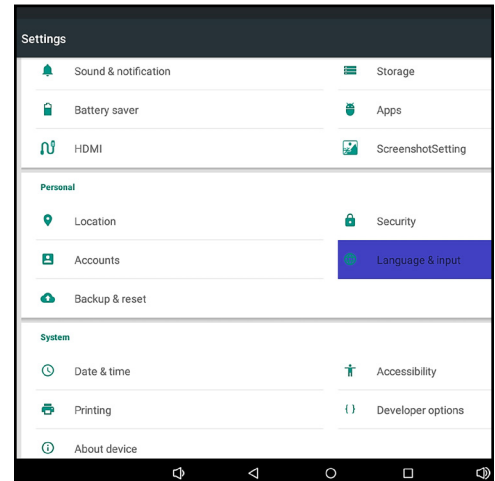
### **Solution:**

**Step 1:** First go to the Android Settings screen outlined in Step 1.

**Step 2:** Then scroll down, and in the **Personal** section, tap on **Language & Input**

**Step 3:** Once in Language & Input, tap **Current Keyboard** in the Keyboards & input methods section.

**Step 4:** A dialog will appear. Tap **Hardware: Show input method** to turn it's toggle to the ON position. The dialog should close automatically.



## **Additional Notes about the Bluetooth Caliper Accessory:**

- If power is lost to the Bluetooth Accessory (for example, if the battery dies) replace the battery and hold the send button on the module until it beeps and the blue light blinks. This should reconnect the module to the tablet. If the device does not connect automatically, follow the steps above to reconnect the accessory.

# Troubleshooting:

## Problem: Tablet does not power up but the crimper is powered on.

### Solution:

- Step 1:** Check the electrical cabinet and verify the power lights are on the power supplies and the PLC.
- Step 2:** Turn the machine off.
- Step 3:** Unscrew the control head and verify the power connections are attached securely.
- Step 4:** The power barrel connector to the PLC should be firmly plugged into the side of the tablet.
- Step 5:** Both sides of the green power supply module in the back of the tablet frame should have power leads securely attached and that the polarity on the wiring is correct.
- Step 6:** Correct any loose wiring and polarity problems.
- Step 7:** Repower the machine.
- Step 8:** Verify the power light on the green power supply is turned on. If it is not, check the input voltage with a voltmeter. If it is receiving the correct voltage, the power supply is bad. If no voltage is present, the problem is with the wiring or the power supply in the crimper electrical cabinet.
- Step 9:** If the input voltage to the green power supply is good and the power supply light is on, check the output voltage with a voltmeter. If the input voltage is correct but there is no output voltage or the output voltage is not correct (12 V), the power supply is faulty. If the output voltage is correct, the cable to the tablet is suspect or the tablet is broken.
- Step 10:** Fix any issues with the wiring or power to the green tablet power supply.

## Problem: Tablet reports PLC is not in run mode or the crimper does not appear to be responding correctly.

### Solution:

- Step 1:** Locate the PLC in the electrical cabinet.
- Step 2:** Find the small toggle switch on the top of the PLC.
- Step 3:** Move the toggle switch right, left and center positions.
- Step 4:** Check that the top two green LED lights on the PLC are lit up indicating the PLC is in run mode.

**Problem: Tablet reports the communication to the PLC is not working. The USB cable end to the tablet is not flickering red and green lights.**

**Solution:**

- Step 1:** Reboot the machine to see if this clears the problem.
- Step 2:** If the problem persists, locate the small toggle switch on the top of the PLC.
- Step 3:** Move the toggle switch right, left and center positions.
- Step 4:** Reboot the machine to see if this clears the problem.
- Step 5:** If the problem still persists, then there is a loose or faulty RS232/USB cable connection between the tablet and PLC. The RS232/USB cable must be connected completely between port 1 of the PLC and the bottom USB port of the tablet.
- Step 6:** Unscrew the control head.
- Step 7:** Unscrew the front panel.
- Step 8:** Pull the tablet and frame off the control head. Check that the USB cable end of the RS232/USB cable is firmly seated (pushed all the way in) into the bottom center USB socket of the tablet.
- Step 9:** Locate the PLC in the electrical cabinet.
- Step 10:** Lower the clip on the bottom center of the PLC. Carefully and gently swing the bottom of the PLC out and pull the PLC off the rail a couple of inches to inspect the wiring. **BE CAREFUL NOT TO PULL OUT, DAMAGE OR DISCONNECT ANY OF THE POWER AND CONTROL WIRING TO THE PLC.**
- Step 11:** Check the top of the PLC and verify the phone jack connector of the RS232/USB cable is firmly seated into port 1 of the PLC. Push in the key and pull the cable out. Push the cable back in firmly but carefully into port 1.
- Step 12:** Carefully put the PLC back onto the rail by pulling the top of the PLC over the mounting rail at an angle and then swinging the bottom of the PLC downward back into the cabinet. Push the clip on the bottom center of the PLC up to secure it. **Again, be mindful to not pull out or damage the wiring during this step.**
- Step 13:** Turn the power on, being careful since the panels are not securely attached.
- Step 14:** After the tablet boots, the USB end of the cable into the tablet should start flickering green and red lights. Also, the two lower green lights on the PLC should be flickering on and off very quickly.
- Step 15:** If you are still having issues, the cable is bad or damaged. Contact customer support.

## Problem: Problems with setting up tablet software for the first time.

### **Solution:**

**Step 1:** Most common problem is the four digit pass codes for the default account. They are usually supplied on a sheet of paper and again on a sticker on the tablet's wrapper during shipping. The default codes are: **operator = 1234** and **machine admin = 9876**.

**Note:**

- It is a good idea, for security purposes, to change these passcodes. You need to be machine admin to set these passcodes and user IDs. See the manual for instructions on how to change the passcodes or add/edit user information.

**Step 2:** Another common issue is the email verification. Having access to a computer or a mobile device that has the email account the crimper is registered to is helpful. During the initial setup, a confirmation email will be sent to that account and the recipient (user) will need to respond to that email to continue registration.

**Step 3:** Make sure there is a solid WIFI connection (strong WIFI signal level with Internet access) for the tablet to use. You will need to configure the WIFI on your tablet.

**Step 4:** Read the user manual for additional help.

## Problem: Buttons on the crimper are not responding or not responding correctly.

### **Solution:**

**Step 1:** Turn off power and pull the front cover off to get access to the electrical cabinet.

**Step 2:** Inspect wiring around the PLC to see if any wires were accidentally disconnected from the PLC.

**Step 3:** Turn the power on and press the open, close and emergency stop button. Look at the PLC and verify that corresponding lights are turning on and off with the buttons. Pressing a button on the panel should turn a corresponding PLC light on or off. The following input and output buttons and signals are listed below to help understand the connections.

- Notes:**
- Normally closed contacts should be lit and turned off when the corresponding button is pressed.
  - Normally open contacts should be off and turned on when the corresponding button is pressed.
  - inputs:
    - X0: estop - normally closed
    - X1: open button - normally open
    - X2: close button - normally open
    - X3: close foot switch - normally open

- outputs:  
Y3: motor power on  
Y4: open signal  
Y5: close signal

Examples:

1. When the close button is pressed, the X2, Y3 and Y5 lights on the PLC should be on.
2. When the open button is pressed, the X1, Y3 and Y4 lights on the PLC should be on.
3. When the emergency stop button is pressed, the X0, Y3, Y4 and Y5 lights on the PLC should be off.

**Step 4:** If you cannot find a loose wire at this point, contact customer support.

**Problem: PLC is not responding or the crimper is not responding to button inputs or the tablet is reporting communications issues to the PLC.**

**Solution:**

**Step 1:** Unscrew the front cover to the electrical cabinet.

**Step 2:** With the power on, check that there are two solid green LED lights showing on the PLC.

**Step 3:** If no lights are showing on the PLC, the PLC is not receiving power. Push in both connector blocks gently but firmly to the PLC.

**Step 4:** If one light on the PLC is showing, the PLC is not in run mode. Toggle the top switch of the PLC right-left-center.

**Step 5:** If the open, close or emergency stop buttons are not responding, check for corresponding lights showing on or off in the PLC inputs and output indicator LED lights. **See input and output assignment notes from the previous problem for clarification.** If a light on the PLC is not responding to an input button, look for any loose or disconnected control wiring. Push the control wiring header block gently but firmly into the PLC to make sure it is seated firmly in the PLC.

**Problem: Crimp head not closing and opening at the correct locations.**

**Solution:**

**Step 1:** Contact customer support. Your unit may have custom programming that may require non-standard configuration.

- For technical support call at: (219) 462-6128

## Industrial Fluid Solutions

Market segment  
Hydraulic Hose

Contact  
ContiTech  
703 S. Cleveland Massillon Road  
Fairlawn, OH 44333-3023 U.S.A.  
1-800-235-4632  
[www.contitech.us](http://www.contitech.us)

Your local contact  
[www.contitech.de/contactlocator](http://www.contitech.de/contactlocator)

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1-888-275-4397

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