

PART I - DESCRIPTION

I-A GENERAL INFORMATION

Comptrol Series 36 Type B and C Tensioncells are force transducers especially designed to measure and control web tension on continuous strip processing lines. They are normally installed in matched pairs at each end of a measuring roll. (See Figure 1 & 2.)

A Tensioncell consists of a unique combination of two integral systems (one mechanical, the other electrical) for converting the mechanical force of strip tension into an electrical signal which is directly proportional to the strip tension .

Type B

Type "B" Tensioncells are designed for use in NON-ROTATING shaft installations. A self-aligning shaft clamp assures proper alignment of the measuring roll when the Tensioncells are bolted to the frame of the machine. Type "B" cells are supplied in matched pairs, one to be mounted at each end of the measuring roll. Note that the cell marked "W2" is a mirror image of "W1". "W2" allows for thermal expansion of the shaft. (See Figure 1.)

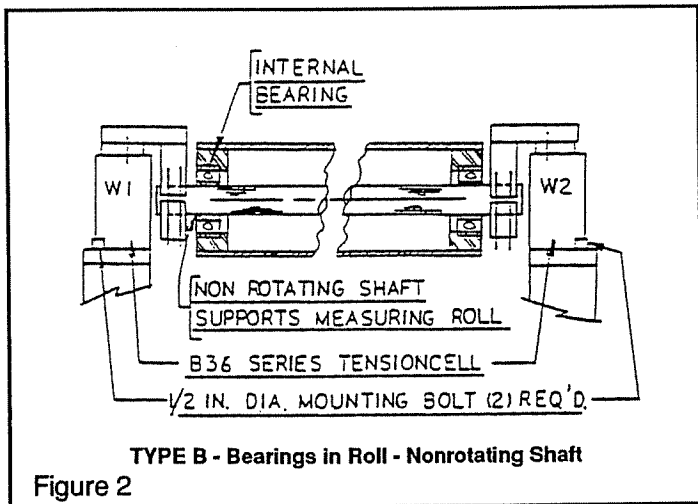


Figure 2

Type C

Type "C" Tensioncells are intended for ROTATING shaft installations. They are supplied with self-aligning ball bearings to assure positive alignment of the measuring roll. Type "C" Tensioncells are supplied in matched pairs, one to be mounted at each end of the tension measuring roll. Note that the cell marked "W2" is a mirror image of "W1". The "W2" cell allows for thermal expansion of the rotating shaft. (See Figure 2.)

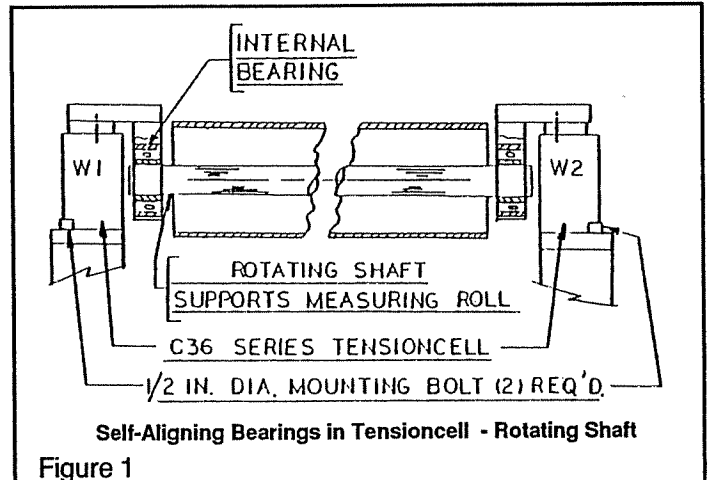


Figure 1

I-B THE MECHANICAL SYSTEM

The mechanical system consists of a Patented "C-Flexure Pivot Assembly" which incorporates a mounting Base Block, frictionless elastic pivot (or hinge), and Load Plate. (See Figure 3.) When a mechanical force is applied to the Load Plate, the pivot permits its deflection toward or away from the Base Block.

(continued on Page 2)

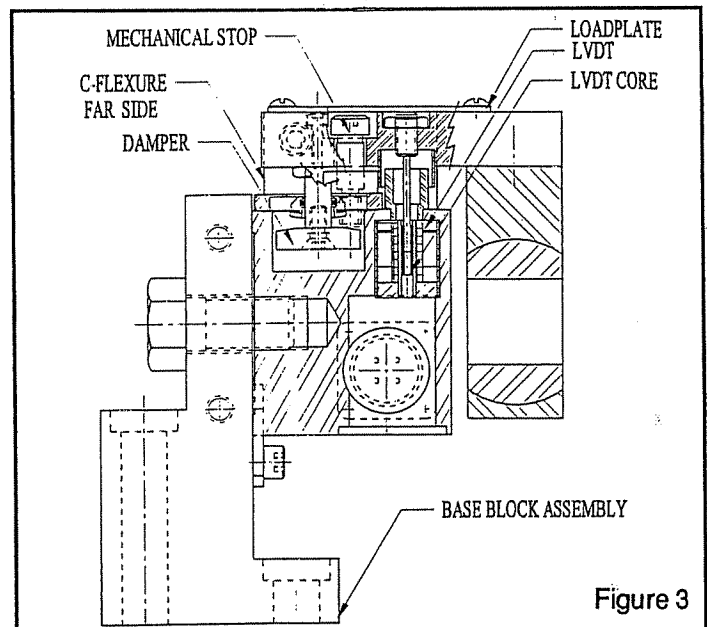


Figure 3

Table of Contents

	BASE BLOCK
General Information	1
Installation and Operation	4
Adjustments	6
Troubleshooting	7
Dimension Drawing	8
How To Order	10
FAXALOG LIT REQUEST	11



For our discussion here, deflection of the Load Plate toward the Base Block is defined as the "Compression Mode", while the opposite is defined as the "Tension Mode". Tensioncells are designed to operate equally well in either mode.

The Base Block contains an integral Mechanical Stop to limit the amount of deflection in either direction, and a Viscous Damper to allow control of the tensioncell response to rapid changes in apparent tension loads. (See Page 1, Figure 3)

I-C THE ELECTRICAL SYSTEM

The electrical system consists of a Linear Variable Differential Transformer (LVDT) which converts the mechanical deflection of the Load Plate into a useful electrical output signal. (See Figure 4.) The movable core of the LVDT is mechanically coupled to the Load Plate by means of the Core Adjust Assembly. (See Figure 4.) This adjustment is factory set and is not accessible.

I-D TYPE "K" DcLVDT

As illustrated in Figure 4, a DcLVDT consists of the following components:

- An oscillator network, which converts the Dc input voltage into a high frequency alternating current for exciting the primary coil (P_1).
- A Primary Coil (P_1).
- A movable, permeable metallic core.
- Two Secondary Coils (S_1 and S_2).
- A demodulator and summing network to rectify and integrate the currents from the Secondary Coils.

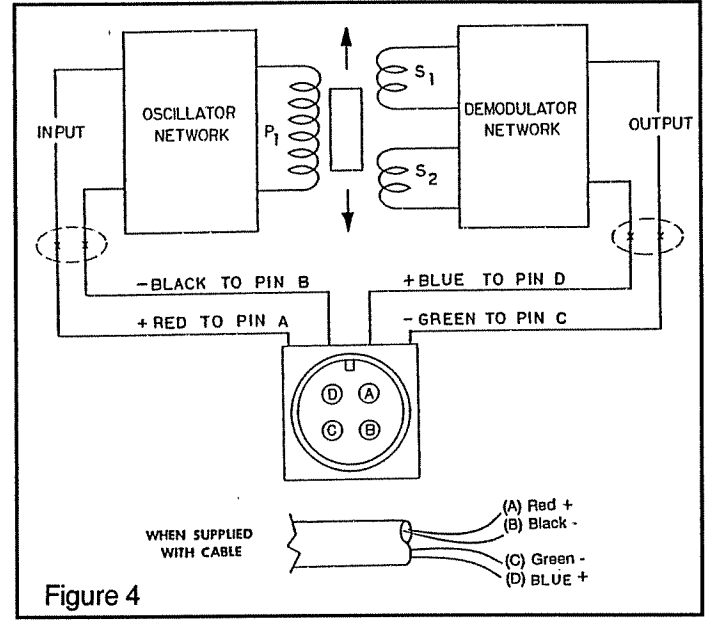


Figure 4

With Comptrol LVDTs, the input and output circuits are electrically isolated from each other and from the mechanical structure of the tensioncell. Thus, they may be used in "floating ground" or "ground return" systems. This eliminates the need for extra circuit boards which are required for most strainage loadcells.

Tensioncells are factory adjusted to provide an offset voltage with no load applied (no deflection). Using an input of 24 volts Dc, the LVDT is set to provide an output of 3.5 volts into a resistive load of not less than 100,000 ohms. The voltage resulting from the maximum rated deflection then adds to or subtracts from the 3.5 volt offset. This results in an output voltage of 3.5 to 6.5 volts in the Compression Mode and 3.5 to 0.5 volts in the Tension Mode. (See Figure 5.)

While acceptable performance may be obtained over an input voltage range of 6.0 to 30.0 volts Dc, the output voltage will vary in direct proportion to the input voltage. Because of this, the use of a well regulated constant voltage power supply is essential for accurate and repeatable tension measurement.

In standard applications, where two Tensioncells are used, the inputs may be connected in parallel allowing the Tensioncells to be excited from the same power supply. The LVDT outputs are then summed to obtain a signal representing the strip tension and tare loads distributed across the roll

Comptrol Tensioncell Controls supply 24 volt Dc and integrate the output signals in a summing amplifier. This permits incorporation of additional circuitry for offset and tare adjustments, as well as adjustments for balance and gain.

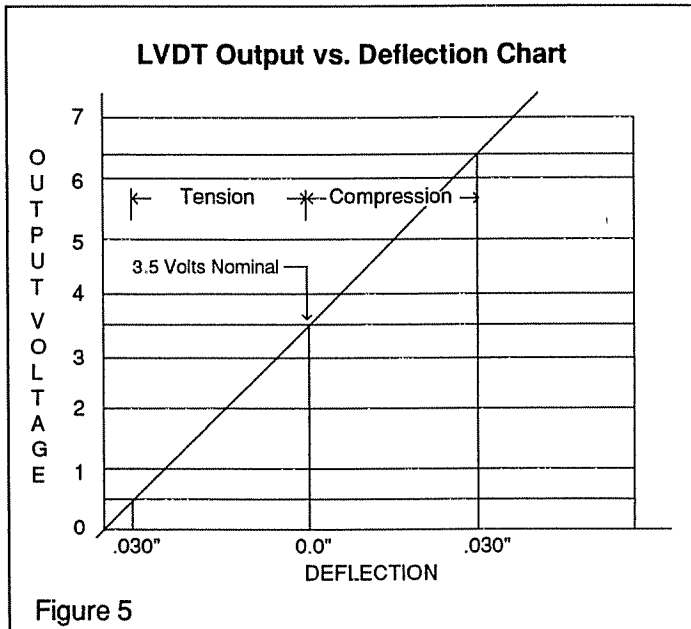


Figure 5

I-E DESCRIPTION OF OPERATION

The total resultant load per cell (JT) is calculated by resolving all force vectors acting upon the Tensioncell, with respect to the Loading Line (OX). (JT) is the resultant of both TENSION and TARE loads, PER CELL!!!

The intrinsic design of Comptrol Tensioncells allows the location of the Resultant Load of Strip Tension (H) on any angle with respect to the Load Line (OX). Note, however, that the Total Force vector (JT) must always be calculated on the line (OX).

Any force vector falling on the line (OR) (through the pivot point of the C-Flexure) will produce no deflection, and thus no electrical output.

Rotating the Tensioncell on its mounting bolt changes the force vectors on the cell. This feature makes it possible to minimize the tare component and maximize the load signal output.

The resultant tare is minimized by mounting the Tensioncell so that (N) is 149° (see Figure 7A and 7B) or so that (N) is 329° (see Figure 8A and 8B).

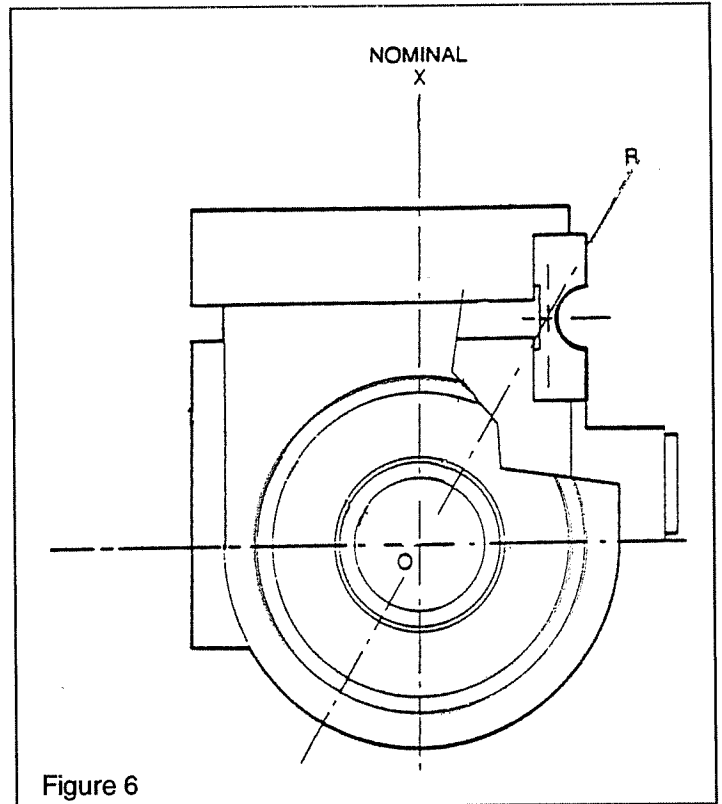


Figure 6

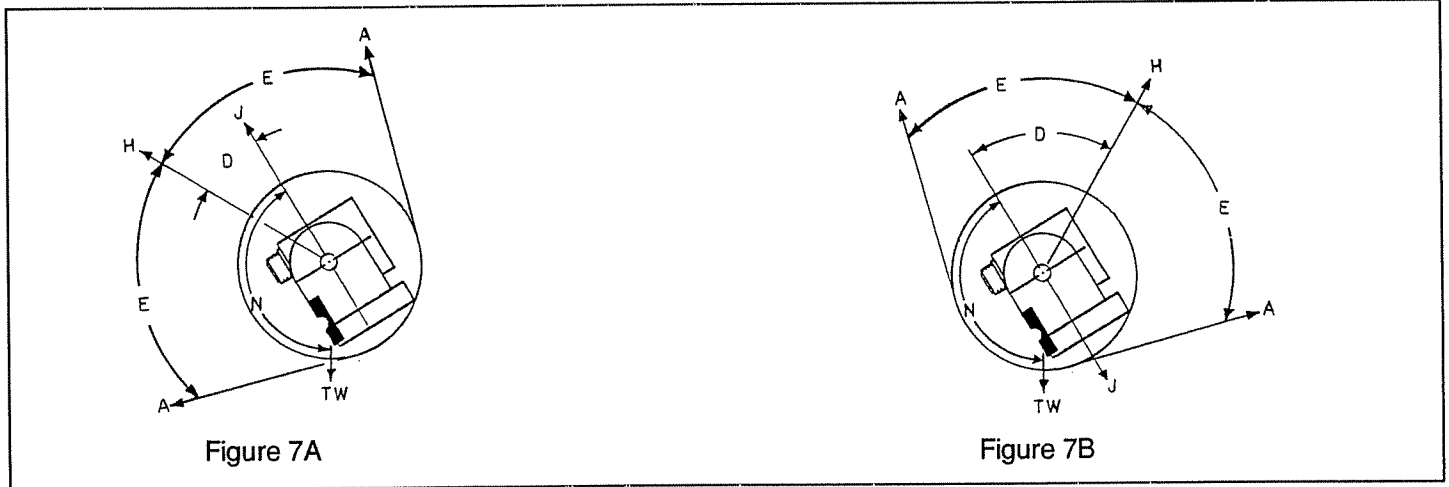


Figure 7A

Figure 7B

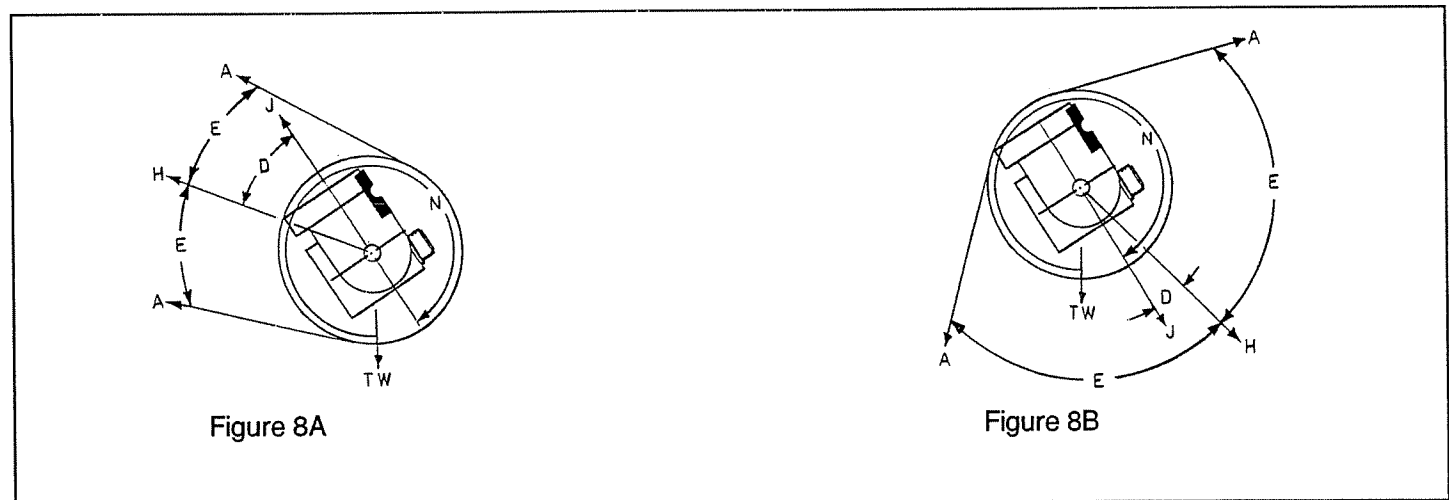


Figure 8A

Figure 8B



PART II - INSTALLATION AND OPERATION

II-A INSPECTION UPON DELIVERY

Comptrol tensioncells are carefully packaged in sturdy reinforced cartons or wooden boxes and are securely blocked or bolted in place.

1. Upon receipt, examine the exterior of the container for obvious damage or tampering.
2. Check the contents against the packing list.
3. Promptly report any damage or shortage to both the carrier and Comptrol Incorporated.

II-B HANDLING

Tensioncells can be handled manually.

II-C LONG TERM STORAGE

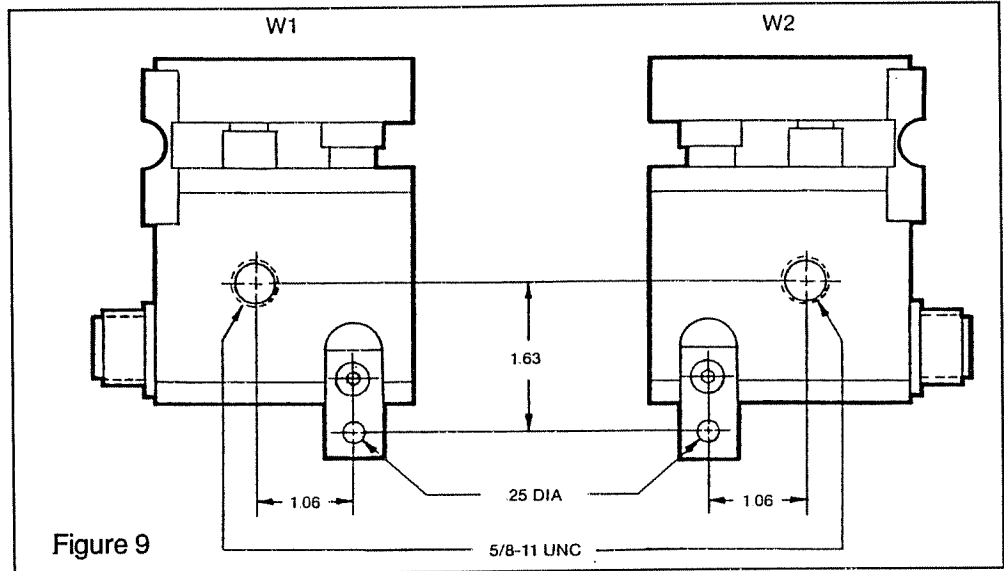
While Comptrol loadcells are plated, exposure to weather, dirt, or moisture should be avoided when they are stored.

II-D MECHANICAL INSTALLATION

NOTE: Refer to the Dimension Drawing on Page 9 of this manual for detailed identification of all parts.

Tensioncells are designated as W1 and W2, one being the mirror image of the other to provide for mounting on each end of the roll.

Comptrol Wall Mounted Tensioncells are mounted to a Base Assembly by a 5/8-11 UNC bolt, which is in line with the centerline of the measuring roll shaft. This allows the Tensioncell to be rotated around the centers of the measuring roll and mounting bolt to achieve the proper mounting angle. (Description of Operation on Page 3.)



A locating tab prevents the Tensioncell from rotating and secures it in a permanent location. It also provides a means of repeating rotatory position when the Tensioncell needs replacement. (See Figure 9.)

TO INSTALL TENSIONCELLS:

1. Check that mounting surfaces to which the Tensioncells are to be mounted are flat to within .002 inch T.I.R.
2. Refer to Figure 10 for the size, location and orientation of the Tensioncell Base Assembly mounting holes to be drilled and tapped in the stands or base structures.
3. Drill and tap the holes in the stand or base mounting structure to accept the Tensioncell Base Assembly.
4. Mount the Tensioncell Base Assembly to the stand or base mounting structure.
5. Fasten the Tensioncell to the Base Assembly with a 5/8-11 x 1-1/4 Hex Head Cap Screw.
6. Rotate the Tensioncell to the proper mounting angle and tighten the mounting bolt. (Refer to N on the calibration sheet for the proper mounting angle.)

Type "K" 24 volt DcLVDT Specifications

Input: 6-30 volts Dc
 Output: 0.5-6.5 volts Dc (nominal, open circuit)
 Output Impedence: 2.5K ohms
 Recommended Load: 100K ohms or greater
 Operating Temp. Range: -65°F to 250°F
 (-53°C to 121°C)

Note: Comptrol loadcells are calibrated for 24 volt Dc input voltage to provide a 0.5 to 6.5 volts Dc output signal. Output voltage will vary proportionally to input voltage.

7. Drill a #6 (.204) hole concentric with the 1/4" hole in the locating tab.
8. Remove the Tensioncell and tap the hole for a 1/4-20 thread.
9. Repeat steps 1 through 8 for the Tensioncell to be mounted at the other end of the measuring roll.
10. Assemble the Tensioncells on to the ends of the measuring roll shaft.
11. Position the roll with the Tensioncells on the machine and fasten with the mounting bolt.
12. Rotate the Tensioncells to the proper mounting angle and tighten the mounting bolts.
13. Lock the locating pad for each Tensioncell against the machine frame using the 1/4-20 x 1/2" socket head cap screw.
14. Tighten the shaft in the mounting block on the W1 unit. (The shaft end at W2 is left free to allow it to move as the shaft expands with temperature changes.)

II-E MECHANICAL ALIGNMENT

Align the sectional measuring roll to avoid any mechanical binding or friction. The measuring roll must be level and perpendicular to the path of the strip material for accurate measurement.

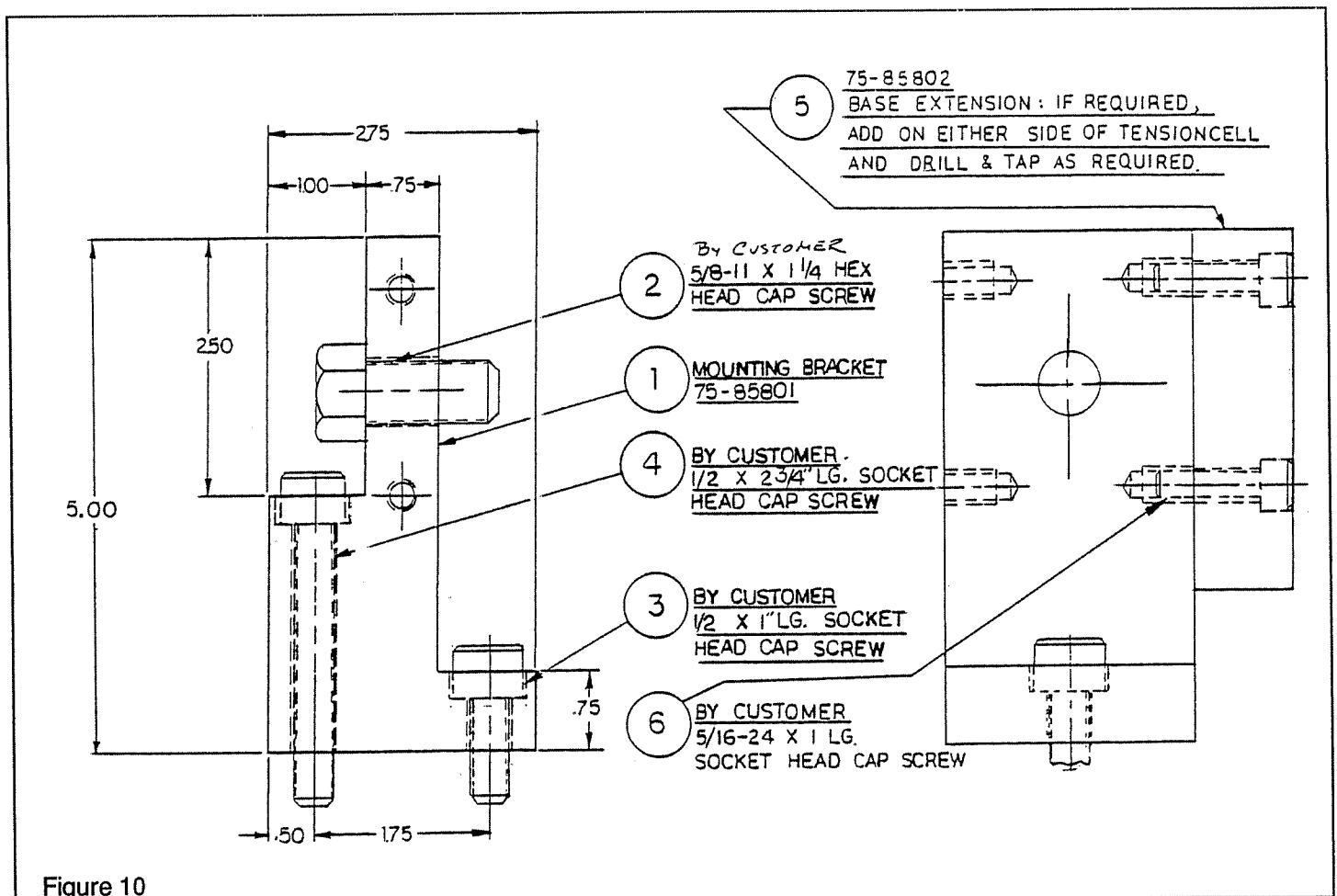
The Mechanical Stops are fixed for the required travel of the Load Table.

II-F ELECTRICAL INSTALLATION

(Read the entire electrical wiring procedure before proceeding.)

1. Turn off all electrical power to the loadcell.
2. Use twisted two conductor signal cable, Belden 9402 or equivalent, in conduit from the LVDTs to the control panel.
3. Observing correct polarity, connect the positive (+) input lead to Pin A and the negative (-) input lead to Pin B. (See Figure 4.)

(continued on Page 6)





4. Connect the positive (+) output lead to Pin D and the negative (-) output lead to Pin C. (See Figure 4.)
5. Repeat Steps 1 through 4 of the electrical wiring procedure for the Tensioncells mounted on the other end of the measuring roll.

II-G ELECTRICAL ZERO ADJUSTMENT

(Read the complete Electrical Zero Adjustment procedure before proceeding with the adjustment.)

1. Disengage strip from the measuring roll so that no tension force is applied to the loadcell.
2. Connect a voltmeter to Pins C and D (See Figure 4.)
3. Apply 24 volt Dc electrical power to the loadcell observing the correct polarity. [Plus (+) to Pin D and minus (-) to Pin C.] Do not exceed the maximum rated input voltage.

NOTE: Allow 20 minutes for the loadcell to warmup before taking first readings to insure accurate readings.

4. Measure the output voltage of the LVDT between the Green and Blue leads for each tensioncell with a voltmeter with a sensitivity of at least 100,000 ohms per volt. The output voltage should be between .5 and 6.5 volts.
5. Since Comptrol Tensioncells cannot be mechanically zeroed, refer to the Control Manual for zeroing out the tare weight voltage.

II-H FULL LOAD ADJUSTMENT

After the loadcell has been zeroed, a pull test can be made to check the output voltage of the loadcell at full load. (See calibration sheet for voltage output.)

1. Run a non-stretchable rope over the center of the tension roll simulating the web path. (NOTE: the rolls should be free to turn.)
2. With one end of the rope secured, hang a known weight, equally over the roll so that the total tension is equal to the maximum strip tension specified on the calibration sheet, at the other end. (See Figure 6.)
3. With a voltmeter connected to Pins C and D of the connector, an output voltage will be observed.

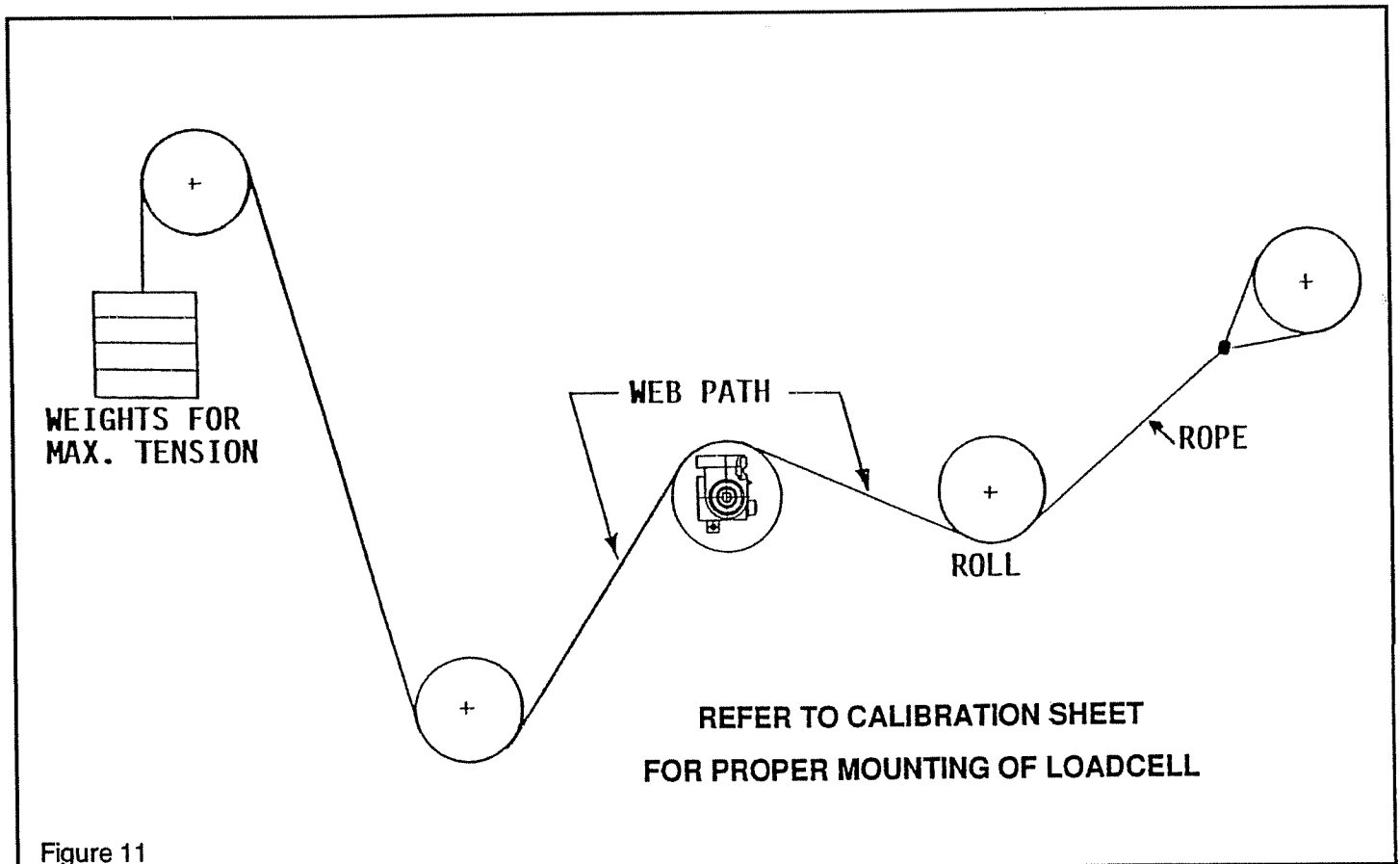


Figure 11



4. Repeat Step 3 for the Tensioncell mounted on the opposite end of the measuring roll.

Comptrol loadcells instrumentation provides the required signal conditioning and a reliable high level output signal for use as feedback control of a tension drive system. The feedback signal is directly proportional to the strip tension applied. If a Comptrol control is used, refer to the control manual for further calibration.

Although the electrical output of Comptrol tensioncells are sufficient to drive most electrical indicators, substantial signal conditioning is normally required for effective tension instrumentation system control. Refer to the documentation available from the instrumentation supplier for more information.

PART III - TROUBLE SHOOTING

When properly installed in accordance with the original design specifications, Comptrol tensioncells should require little or no regular maintenance or service.

Certain conditions, however, can impair their inherently accurate and reliable performance. Therefore, if trouble should arise, the following conditions should be checked.

III-A MECHANICAL

1. Has the tension measuring system been changed?
 - a. An increase or decrease in strip tension (Refer to A on the calibration sheet for specified strip tension.)
 - b. An increase or decrease in the wrap angle. (Refer to B on the calibration sheet for the specified wrap angle.)

If the above parameters have been changed enough to prevent the unit from operating within the limits of the fixed Mechanical Stops, replacement of the Flexure will be required. For this modification, the Tensioncell should be returned to the factory with complete specifications.

2. Are the loadcells mounted securely?
3. Is tension measuring roll in proper alignment and does it turn freely?
4. Are bearings and seals free of all binding and stickiness?
Are they worn?

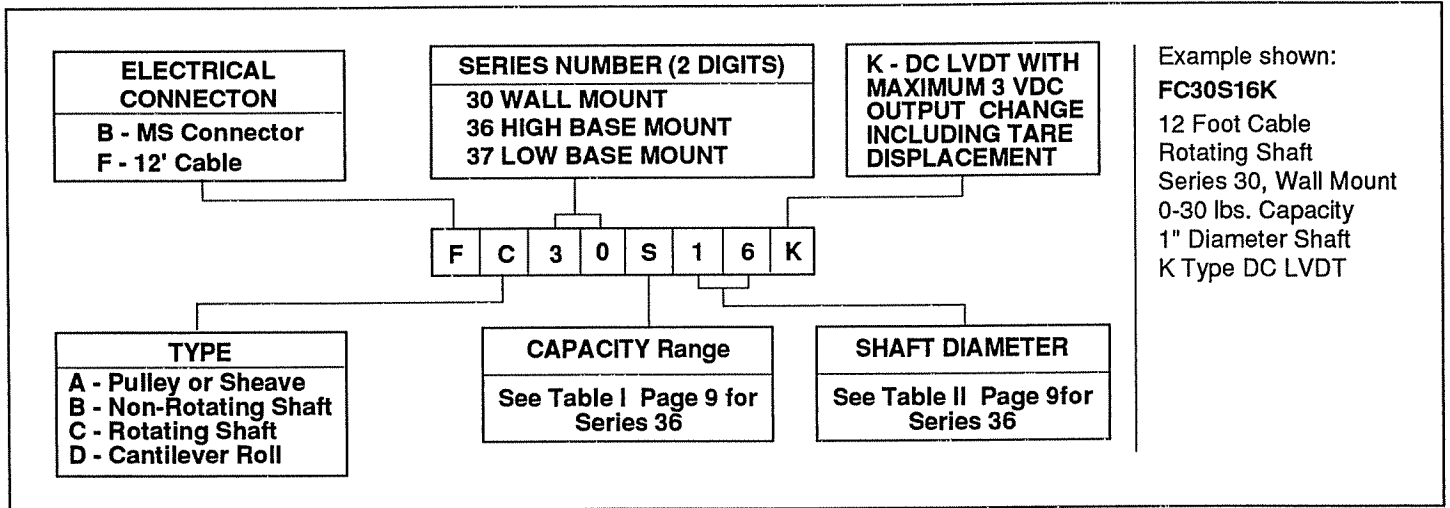
III-B ELECTRICAL

1. Are LVDTs receiving correct input voltage?
Check line voltage, fuses or circuit breakers, and power switches. Check power supply output and voltage to LVDTs.
2. Are all connections secure?
Check for continuity. Retighten all connections. Recheck operation.
3. Are LVDTs open or shorted.
To check, turn off power and disconnect the input and output leads. Check coil continuity and resistance. (Refer to Figure 4.)
 - a. Pin A to Pin B (Primary Coil) should be in excess of 2 megohms.
 - b. Pin A or Pin B to LVDT shell should be in excess of 5 megohms.
 - c. Pin C to Pin D (Secondary Coil) should be approximately 20,000 ohms.
 - d. Pin C or Pin D to LVDT shell should be in excess of 5 megohms.

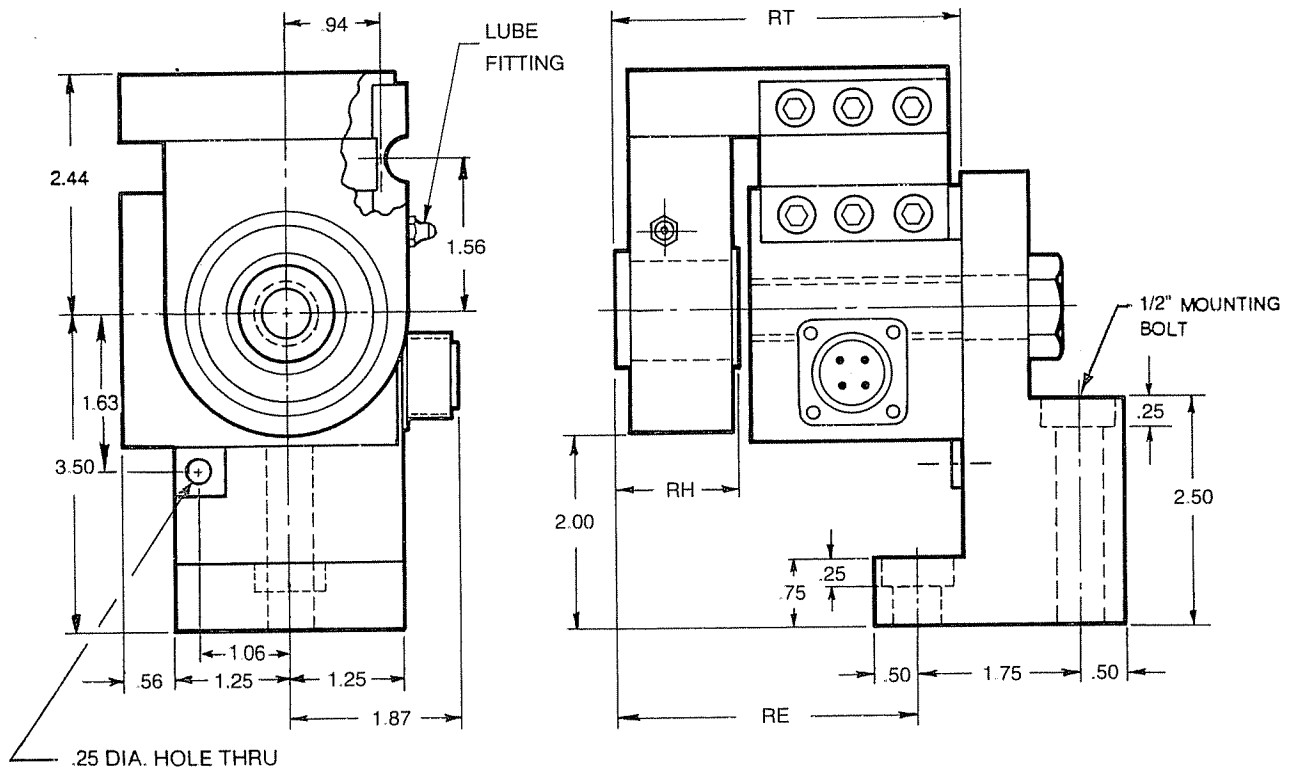
If LVDT circuits are open or shorted, replace LVDT. Contact Comptrol with tensioncell model number and serial number.



MODEL NUMBER NOMENCLATURE EXAMPLE



DIMENSION DRAWING SERIES 36, TYPE B & C



W1 unit shown here.
W2 unit is applied at the opposite end of roll.

W1 unit clamps the shaft while
W2 unit allows for temperature expansion of the shaft.
Both units have self-aligning features

Fifteen standard shaft diameters.
For rotating shaft see Table III C.



TABLE I											
NOMINAL CAPACITY RANGES											
CODE	L*	M*	N	P	S	T	U	W	X	Y	Z
POUNDS	0-4	0-8	0-13	0-20	0-30	0-50	0-90	0-140	0-200	0-300	0-500

* Tensioncells in this range supplied for shaft sizes up to maximum 3/4" diameter unless approved by factory.

TABLE II - B									
TYPE B SHAFT DIAMETER									
CODE	08	10	12	14	16	18	20	22	24
INCHES	1/2	5/8	3/4	7/8	1.0	1-1/8	1-1/4	1-3/8	1-1/2
RH	1.00			1.13					
RT	3.63								
RE	3.13								

TABLE II - C															
TYPE C - SHAFT DIAMETER															
INCHES	1/2	9/16	5/8	11/16	3/4	7/8	15/16	1.0	1-1/16	1-1/8	1-3/16	1-1/4	1-5/16	1-3/8	1-7/16
CODE	08	09	10	11	12	14	15	16	17	18	19	20	21	22	23
RE	3.31						3.53				3.63				
RH	1.31				1.38				1.53				1.69		
RT	3.81								4.03				4.13		

HOW TO ORDER TENSIONCELLS AND CONTROLS

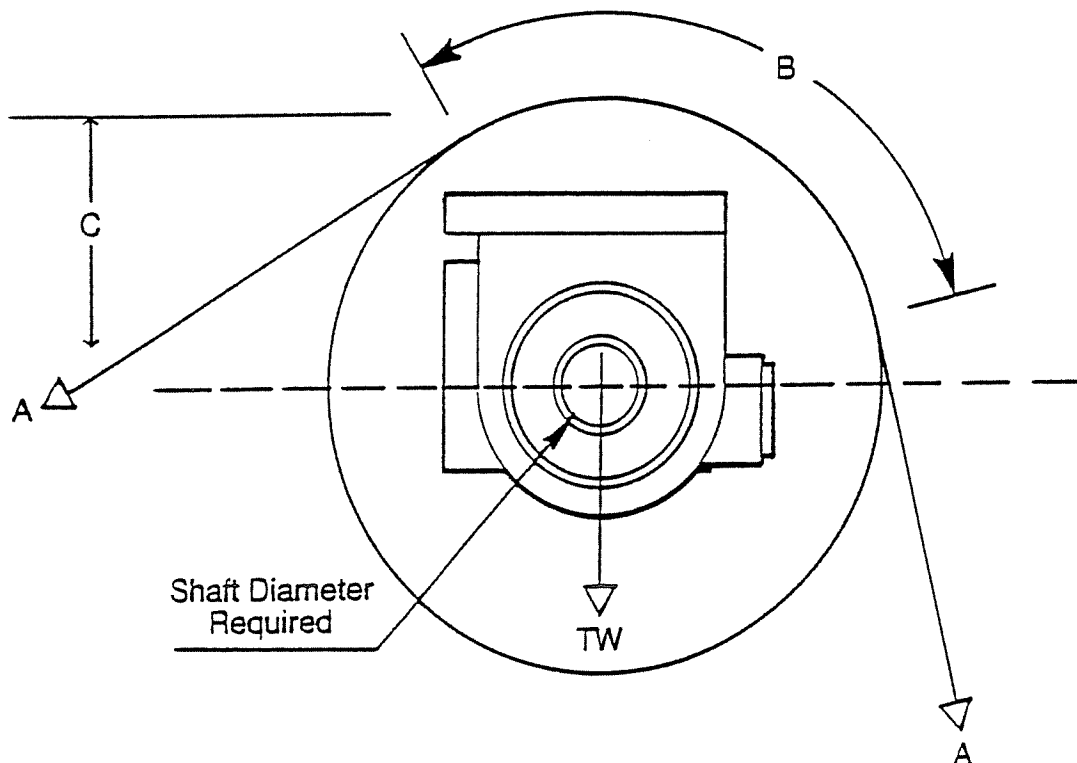
Our Application Engineering Department will make all calculations and offer installation suggestions as part of our formal quotation. To help us provide these services, we request that you furnish us with complete information about your requirements. If possible include a drawing or sketch of your application, noting the preferred position of the electrical conduit box. The information listed below is the MINIMUM we require: (Refer to illustration below.)

- Maximum Strip, Web, or Strand Tension (A)
- Total Wrap Angle (B)
- Inclination of the Passline with respect to horizontal (C)
- Total Weight of the roll and bearings (or sheave and bearing) (TW)
- Shaft Diameter
- Rotating or Non-Rotating Shaft
- Measuring Roll Diameter (in inches)
- Maximum Machine Speed (FPM)

Include the Model Number of the Loadcell Control Required.

When placing your order, please include instructions as to how the equipment and/or shipping containers are to be marked. Loadcells are assembled from stock parts for fast delivery.

When ordering spare, or replacement parts, please reference the Model and Serial Number of the original equipment. Comptrol maintains complete files and documentation on all loadcell equipment.





FAXALOG LIT REQUEST



**PHOTOCOPY
AND FAX TO:**

COMPTROL INCORPORATED
U.S.A. & CANADA TELEFAX: (800) 544-2268
INTERNATIONAL: (216) 587-5210

**S
E
N
D
E
R**

COMPANY: _____

DATE: _____

ADDRESS: _____

NUMBER OF PAGES TRANSMITTED
(Including cover page): _____

ATTENTION: _____

TELEFAX: _____

TITLE: _____

TELEPHONE: _____

Please send me the following literature I have checked below.

Technical Data

Maintenance Manuals

	Bulletin
<input type="checkbox"/> Loadcell Technical Handbook	75
<input type="checkbox"/> Superloadcell Technical Handbook	31
<input type="checkbox"/> Monocell Technical Handbook	50
<input type="checkbox"/> Series 20 Tensioncells	90
<input type="checkbox"/> Series 30 Wall Mounted Tensioncells	85
<input type="checkbox"/> Series 40 Base Mounted Tensioncell	79
<input type="checkbox"/> Dual Range Superloadcells	52
<input type="checkbox"/> High Tare/Low Deflection Monocell	46
<input type="checkbox"/> 570 Series Low Deflection Monocell	44
<input type="checkbox"/> Complete Loadcell Catalog	
Superloadcell Controls	
<input type="checkbox"/> Model M360-2	53
<input type="checkbox"/> Model M370-2	54
<input type="checkbox"/> Model M390-2	55
Tensioncell Controls	
<input type="checkbox"/> Model M360-4	61
<input type="checkbox"/> Model M370-4	62
<input type="checkbox"/> Model M390-4	63
Single Cell Controls	
<input type="checkbox"/> Model M365-6	58
<input type="checkbox"/> Model M375-6	59
<input type="checkbox"/> Model M395-6	60
Articles	
<input type="checkbox"/> Force Transducers Accurately Sense Process . Line Tension	
<input type="checkbox"/> Automatic Tension Adjustment	
<input type="checkbox"/> Retrofitting Tension Transducers	

	Manual
<input type="checkbox"/> DST 130/131 Superloadcells	100
<input type="checkbox"/> DST 206-C Superloadcells	101
<input type="checkbox"/> DST 226-C Superloadcells	102
<input type="checkbox"/> DST 535-C Superloadcells	103
<input type="checkbox"/> DST 585-C Superloadcells	104
<input type="checkbox"/> DST 600-C Superloadcells	105
<input type="checkbox"/> DST 601-C Superloadcells	106
<input type="checkbox"/> DST 602-C Superloadcells	107
<input type="checkbox"/> Model 20, Type B & C Tensioncells	203
<input type="checkbox"/> 30B & 30C Wall Mounted Tensioncells	151
<input type="checkbox"/> 30A & 30D Wall Mounted Tensioncells	152
<input type="checkbox"/> Model 40 Base Mounted Tensioncells	159
<input type="checkbox"/> Model 41 Base Mounted Tensioncells	160
<input type="checkbox"/> Model 42 Base Mounted Tensioncells	161
<input type="checkbox"/> Model 43 Base Mounted Tensioncells	162
<input type="checkbox"/> Series DH Monocells	158
<input type="checkbox"/> Model M360-2 Superloadcell Control	110
<input type="checkbox"/> Model M370-2 Superloadcell Control	111
<input type="checkbox"/> Model M390-2 Superloadcell Control	112
<input type="checkbox"/> Model M360-4 Tensioncell Control	121
<input type="checkbox"/> Model M370-4 Tensioncell Control	122
<input type="checkbox"/> Model M390-4 Tensioncell Control	123
<input type="checkbox"/> Model M365-6 Single Cell Control	126
<input type="checkbox"/> Model M395-6 Single Cell Control	128



COMPTROL INCORPORATED
9505 Midwest Avenue Cleveland, Ohio 44125
Phone: (216) 587-5200



COMPTROL MANUFACTURED PRODUCTS

BALLSCREW PRODUCTS

- Inch and metric rolled thread ballscrews
- Precision ground ballscrews
- Single and preloaded ballnuts for base, flange, cut-off flange, or trunnion mounting
- Base, flange, or cut-off flange mounted end bearing supports
- Custom and modified units also available

COMPLETE BALLSCREW PACKAGES

Comptrol complete ballscrew packages feature standard pre-engineered Comptrol products to provide ready-to-install ballscrew "package" consisting of the ballscrew, ballnut, and end mounting bearing supports. Custom and modified standard assemblies are also available.

HIGH SPEED LINEAR POSITIONERS

Comptrol industrial linear positioners for applications requiring stroke lengths up to 36 inches, load capacities up to 5,000 pounds, and speeds up to 50 inches per second.

QUALITY VERIFICATION SYSTEMS

Comptrol Rod and Piston Systems

An industry standard for over 20 years in reciprocating engine plants around the world, Comptrol Connecting Rod and Piston Balancing Systems provide an accurate, high speed method of weighing and balancing connecting rods and pistons on automatic engine transfer lines.

Comptrol Weighcells Systems

Ideal for automatic assembly and packaging systems, Comptrol weighcells provide a high speed, continuous method of monitoring of process quality. These systems can detect weight deviations within 0.1 gram of the ideal weight in 0.8 seconds.

TENSION MONITORING SYSTEMS

Comptrol tension monitoring systems are designed to measure and control strip or web tension of continuous process lines. Available in over 30 models with capacity ranges from 4 to 80,000 pounds, these units are ideal for new, replacement and retrofit applications.

COMPTROL TECHNICAL SUPPORT

ENGINEERING

- Application Assistance
- Mechanical Design
- Electrical Design
- Software Design

CUSTOMER SUPPORT

- Field Service Support
- Project Planning
- Installation Supervision and Assistance
- Installation Inspection
- Documentation

MANUFACTURING

- Electrical and Mechanical Assembly
- In-house Machining



COMPTROL INCORPORATED

9505 Midwest Avenue
Phone: (216) 587-5200

Cleveland, Ohio 44125
Fax: (216)587-5210

