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Controller Reference

MilTouch-EX™ Washer-extractor with Integrated Door Chute

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Contents

Figures

Tables

1 Preface

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1.1 About MilTouch™ Machines, the MilTouch™ Controller, and This Manual

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NOTICE: MilTouch™, MilTouch-EX™, and MilTouch-EX™ WTB are variations of the same controller design, each of which applies to an exclusive family of washer-extractors. This manual applies to MilTouch-EX™ WTB software version 6.2.000. This manual also applies to all consecutively subsequent software versions that do not affect the user experience described herein.

- For the basic MilTouch™ controller, refer to manual MCCLJB01.
- For the MilTouch-EX™ controller without automated loading and discharge, see MCCLWB01.

In this manual:

- You will see the term MilTouch™ used to describe features that apply to all three controller variations.
- You will see the term MilTouch-EX™ used to describe features that apply only to the MilTouch-EX™ and MilTouch-EX™ WTB controller variations.
- You will see the term MilTouch-EX™ WTB used to describe features that apply only to the MilTouch-EX™ WTB controller variation.

The Milnor® MilTouch™ washer-extractor controller uses a touch-sensitive display screen to operate the machine. All the functions and information you need to configure, program, and run the machine appear on this screen.

CAUTION: **Excessive pressure** — can damage the display screen.

- ▶ Do not push hard on the glass.
- ▶ Use only a finger to touch the glass. Do not touch the screen with a tool.

Operators will use the MilTouch-EX™ WTB controller to initiate automatic loading, washing, and discharging. However, the MilTouch™ controller also has features that are accessible when the machine is idle. These features will interest specialists, such as service technicians and chemical suppliers who work with the machine. These features are the subject of this manual. Refer to the operator guide for operator instructions.

The MilTouch™ controller contains several displays organized into a hierarchy. Top-most is the **Home** display (Figure 1: The Home Display, page 8). Each display contains buttons that access lower-level displays.

The chapters in this manual are organized, not by display, but by types of specialist activity. Examples are given in the following table. For a hierarchal tour of the displays, see Section 1.1.4 : The MilTouch-EX™ WTB Display Hierarchy , page 9.

Table 1. Examples of Specialist Activity

Specialist	Type of Activity	Section & Page
Factory tester	Initial configuration	Section 2.1 : Machine Configuration, page 12
Chemical supplier	Create and modify wash formulas.	Section 3.1 : Formula Creation and Modification, page 27
	Test a wash formula.	Section 4.6 : Formula Intervention, page 62
	Transfer formulas to/from the machine.	Section 5.2 : Data Transfer with the MilTouch™ Controller, page 96
	Closely monitor machine operation.	Section 1.1.3 : When a Formula is in Progress (The Run Display), page 9, Section 4.7 : Troubleshooting Inputs and Outputs, page 66
Laundry management	View logs of machine operation.	Section 4.2 : Data Logs, page 42
	Change settings to accommodate regional preferences such as temperature units in Fahrenheit or Celsius.	Section 2.1 : Machine Configuration, page 12
	Set lockout passwords to prevent personnel from accessing certain functions.	Section 2.2.1 : Enable and Define Lockout Passwords, page 23
Service technician	Troubleshoot error conditions.	Section 4.3 : Errors, page 49
	Change settings to accommodate newly added hardware such as a reuse water valve.	Section 2.1 : Machine Configuration, page 12

1.1.1 When the Machine is Idle (The Home Display)

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The display pictured in the following figure, subsequently referred to as the **Home** display, is the top-most display in the hierarchy of MilTouch™ displays and is used to access all the other displays. It appears when no other display has been accessed, when you touch  from another display, or when you back up to the **Home** display with  or  .

The **Home** display cannot be accessed while the machine is in automatic mode. If you are in automatic mode, to access the **Home** display:

1. From the **Loading/Discharging State** windows (Figure 2: Example Loading State, page 9), touch  . The **Manual Override** display (Figure 26: Manual Override Display, page 57) appears.
2. From the **Manual Override** display, touch **Formula** (F6). The **Home** display appears.

Figure 1. The Home Display

Legend

A/M.	Select automatic or manual mode
C.	Access the **Configuration** display
D.	Access the **Diagnostics** displays
Dc.	Display the Pellerin Milnor Corporation contact information
Dt.	Access the **Data Transfer** display
Fn.	The wash formula names
F#.	The wash formula numbers
L.	Access the **Data Log** displays
M.	Activate manual mode
Mi.	Run a formula from the Mildata® computer (currently unavailable on WTB machines)
P.	Turn machine power OFF
S.	Run a formula
Sc.	Scroll between pages to view more formulas
Se.	Search for a formula
V.	The version data
Vd.	View the software build
W.	Access the **Wash Formula Maintenance** display

1.1.2 About Automatic Mode

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When you first power-on the machine for morning startup (after evening shutdown, after a power loss, after a safety circuit error, etc.) the controller prompts the operator to put the machine in automatic or manual mode, as shown in Figure 1: The Home Display, page 8 .

Automatic mode is the normal mode of operation for MilTouch-EX™ WTB washer-extractors. In automatic mode, the controller uses inputs from the Miltrac™ controller system to automatically load the machine with goods using the loading chute, and automatically unload the machine using tilt functions.

During operation, the controller advances through **Loading/Discharging State** windows, which indicate the machine's progress. An example is shown in Figure 2, page 9.

Figure 2. Example Loading State

See the operator guide for instructions on how to use automatic mode to load and unload the machine.

1.1.3 When a Formula is in Progress (The Run Display)

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The **Run** display appears when you run a formula. From the **Run** display, you can monitor the wash formula progress and the machine status.

You can also use formula intervention to change the water temperature and level, the formula time, the drain type, and the cylinder speed for the formula in progress. See Section 4.6 : Formula Intervention, page 62 for instructions on how to use formula intervention.

Figure 3. The Run Display

See the operator guide for more information on how to interpret the **Run** display.

1.1.4 The MilTouch-EX™ WTB Display Hierarchy

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In Table 2: The MilTouch-EX™ WTB Display Hierarchy, page 10 :

- The **Home** display is the default display. It appears when no other display has been accessed, when you touch  from another display, or when you return to the **Home** display with  or  .
- Access a display from the less-indented (parent) display above it. The icon following the display name is the button on the parent display that accesses it. Example: Touch  on the **Home** display to access the **Data Transfer** display.
- Display names in parentheses are implied; that is, the name does not appear on the display.
- The term “display” refers to the view that remains active until you access another display. Many other windows and dialog boxes, not shown here, will appear only until you make a selection or complete an entry. Example: the User Password Window.

Table 2. The MilTouch-EX™ WTB Display Hierarchy

Display Name and Button	See
(Home) 	Figure 1: The Home Display, page 8
(Run)  or 	Section 1.1.3 : When a Formula is in Progress (The Run Display), page 9
Error Causes/Solutions 	Figure 25: Error Causes/Solutions Display, page 55 (only available when the machine encounters an error)
Manual Override 	Section 4.4 : Manual Mode, page 56
(The Recovery Display, Loading and Discharging States) 	Figure 2: Example Loading State, page 9 (see operator guide)
(Data Transfer) 	Section 5.2 : Data Transfer with the MilTouch™ Controller, page 96
(Wash Formula Maintenance) 	Section 3.1.1 : The Wash Formula Maintenance Display, page 27
(Steps in a Wash Formula) (touch the number of steps on the parent display)	Section 3.1.1.5 : To Change a Wash Formula, page 29
(Step Decisions) (touch the step type on the parent display)	Section 3.1.1.9 : To Modify a Step, page 32
Configuration 	Section 2.1 : Machine Configuration, page 12
SYSTEM SETTINGS 	Section 2.2 : System Settings, page 23

Table 2 The MilTouch-EX™ WTB Display Hierarchy (cont'd.)

Display Name and Button	See
Configure WTB 	Section 2.1.4 : WTB (Automated Chute) Configuration, page 19
Program Post Dry 	Section 3.2 : Post-wash Codes, page 37
(Date Selection) 	Section 4.2.1 : Date Selection, page 43
(Production History) 	Section 4.2.2 : Production History, page 44
(Configuration and Programming History) 	Section 4.2.3 : Configuration and Programming History, page 44
(Error History) 	Section 4.2.4 : Error History, page 45
DIAGNOSTICS 	Section 4.7 : Troubleshooting Inputs and Outputs, page 66
DIAGNOSTICS (Digital Inputs) 	Section 4.7.1.1 : Digital Inputs, page 67
DIAGNOSTICS (Digital Outputs) 	Section 4.7.1.2 : Digital Outputs, page 68
(DIAGNOSTICS) Analog Channels 	Section 4.7.1.5 : Analog Channels (A/D inputs and D/A outputs), page 69

2 Configuration

2.1 Machine Configuration

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Your machine was configured at the factory and the configuration values were recorded on the MilTouch™ Configuration form included with your machine. You will find a copy of this completed form in the packet of documentation shipped in the machine cylinder. The values set at the factory and recorded on the MilTouch™ Configuration form are the optimum or required settings for your machine.

Most configuration decisions are hardware-dependent. The only reason to modify hardware-dependent settings is to accommodate modifications to your machine's hardware.

CAUTION: **Careless modification of hardware-dependent settings —** Is likely to degrade machine performance and may cause damage or malfunction.

- ▶ Do not make unauthorized changes to hardware-dependent configuration settings.
- ▶ Consult Milnor® Technical Support before you change hardware-dependent settings.

2.1.1 The Main Configuration Display

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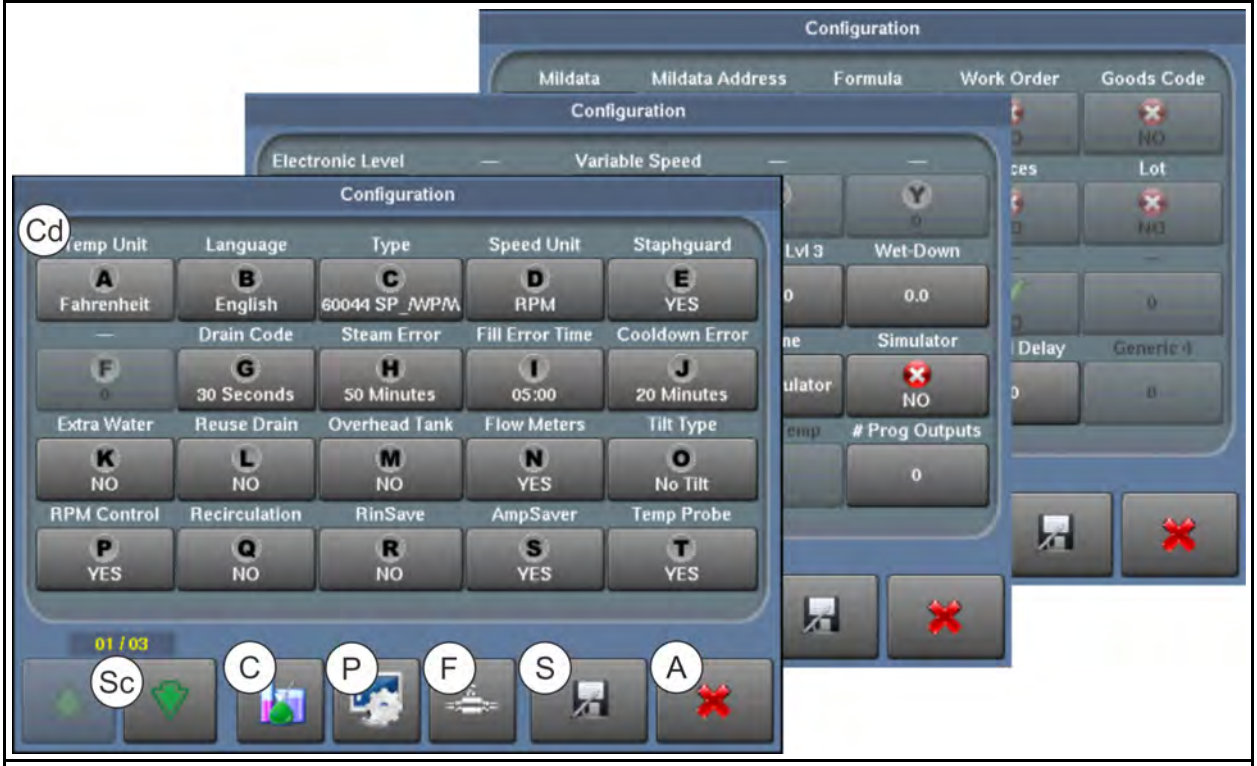
From the **Configuration** display, you can configure the MilTouch™ controller based on your machine's model, features, and capabilities.

Touch  on the **Home** display. A selection list with three options appears:

- Touch **Configuration** to access the (main) machine configuration decisions. The **Main Configuration** display is shown in Figure 4, page 13.
- Touch **Configure WTB** to configure the automated chute (see Section 2.1.4 : WTB (Automated Chute) Configuration, page 19).
- Touch **Program Post Dry** to create and edit post-wash codes (see Section 3.2 : Post-wash Codes, page 37).

Figure 4. The Main Configuration Display



Legend

A . . . Abandon changes and return to the **Home** display

C . . . **(Discontinued)** Access the **Chemical Valves** display. This feature is no longer available and will be removed in a future software update.

Cd . . . The configuration decisions

F . . . Calibrate the flow meter

P . . . Access the **System Settings** display

S . . . Save changes and return to the **Home** display

Sc . . . Scroll between pages

2.1.2 How to Make Configuration Changes

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Some configuration decisions present a list to select from, some permit you to enter a value, and some are either enabled or disabled. Touch a configuration decision to change it. One of two types of windows (not shown) appears.

- A selection list appears. Touch the value you want to use.
- A window with a text box and a keypad appears.
  - Touch the value in the text box. Use the backspace button to delete the current value.
  - Enter the new value on the keypad.
  - Touch  to save the new value.

- A window does not appear. Touch the decision to toggle between enabled (YES ) and disabled (NO ).
- Save or abandon your changes:
  - To abandon the most recent changes and return to the **Home** display, touch  .
  - To save the changes and return to the **Home** display, touch  .

NOTE: The configuration changes you make are recorded in the data logs. See Section 4.2.3 : Configuration and Programming History, page 44.

2.1.3 Main Configuration Decisions

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Use the following information to configure the controller based on your machine's features and specifications, as well as your laundry needs.

The configuration decisions that are hardware-dependent are marked "Avoid modification" in the following explanations. A few configuration decisions are not hardware-dependent, but it is important to understand the consequences of changing these values, as explained.

Temperature Unit — Select the unit, either degrees Fahrenheit or degrees Celsius, that the controller uses to measure and display the bath temperature.

This decision also determines the water unit for bath steps in which the water level is controlled by a pressure transducer.

- If the temperature unit is degrees Fahrenheit, the water unit is inches.
- If the temperature unit is degrees Celsius, the water unit is centimeters.

NOTICE: The numerical values for water levels do not automatically change to reflect a change in the temperature unit (and therefore a change in the water unit). For example, if water level 1 is set to 13.0 inches and you change the temperature unit to Celsius (thus changing the water unit to centimeters), the water level will be 13.0 centimeters, not 33.02 centimeters (the correct converted value). If you change the temperature unit, you must also manually change the water level 1, 2, and 3 values, as well as all user-defined levels, to reflect the unit change.

Language — Select the language that will appear on the displays. Currently, only the English language option is available.

Type (Avoid modification) — Select the machine model number. This information is on the name plate on the rear of the machine.

Speed Unit (Avoid modification) — Select the unit, either G's or RPM, that the controller uses to program and display cylinder speed.

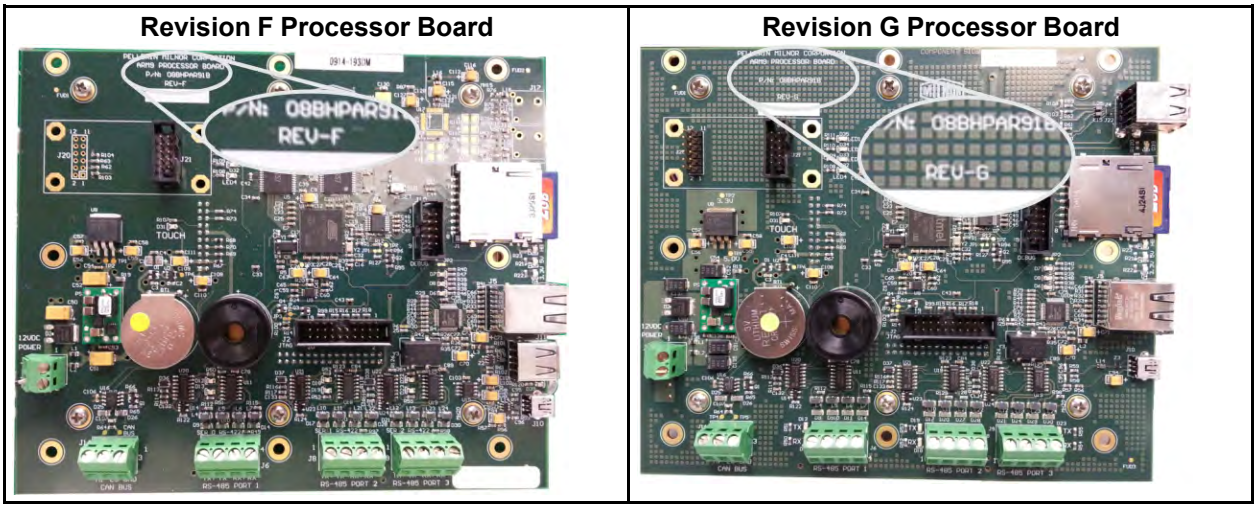
Staph Guard® (Avoid modification) — Select whether this machine is a Staph Guard® pass-through model.

Comm Port (Avoid modification and see note below) — Select the communications port used by the processor board to communicate with the peripheral boards.

Port 3—Choose this value if the processor board is earlier than "Rev G."

Port 1—Choose this value if the processor board is "Rev G" or later.

Figure 5. Processor Board Revisions



NOTE: This configure decision allows the Milnor® factory to support both new and old machines. Do not change this configure decision from the original factory setting unless instructed by the factory, if replacing the processor board.

Drain Code (Avoid modification) — Select the time for drain speed between two bath steps and between a bath step and an extract step.

CAUTION: **Inadequate drain time —** can cause unnecessary machine wear.

▶ Do not select a drain code that provides less time at drain speed than stated on the machine configuration nameplate.

Steam Error (Avoid modification) — Select the time allowed for the machine to use steam to achieve the programmed bath temperature before the controller issues an error. See Section 4.3 : Errors, page 49 for more information.

Fill Error (Avoid modification) — Select the time allowed for the machine to achieve the desired water level before the controller issues an error. See Section 4.3 : Errors, page 49 for more information.

Cooldown Error (Avoid modification) — Select the time allowed for the machine to complete a cooldown to a programmed bath temperature before the controller issues an error. See Section 4.3 : Errors, page 49 for more information.

Extra Water (Avoid modification) — Select whether this machine is attached to a reuse water source.

Reuse Drain (Avoid modification) — Select whether this machine has a second drain valve that discharges to a reuse water reservoir.

Overhead Tank (Avoid modification) — Select whether this machine has an overhead tank.

Flow Meters (Avoid modification) — Select whether this machine is equipped with flow meters to measure incoming water.

Tilt Type (Avoid modification) — Select whether this machine is a hydraulic-tilt, air-tilt, or non-tilting machine.

RPM Control (Avoid modification) — This decision must remain at the factory setting, except in the case of a retrofit. If this is the case, a Milnor® technician will advise you accordingly.

Recirculation (Avoid modification) — Select whether this machine has the equipment required to recirculate bath liquor.

RinSave® (Avoid modification) — Select whether this machine is provided with the RinSave® feature.

AmpSaver (Avoid modification) — Select whether this machine is part of a Milnor® AmpSaver system to help reduce peak electricity consumption.

Temperature Probe (Avoid modification) — Select whether this machine has a temperature sensor. A temperature sensor allows programming a specific temperature for each bath step.

NOTE: The machine must have a temperature sensor to use steam or cooldown.

Electronic Level (Avoid modification) — Select whether this machine has electronic level sensing capability (pressure transducer).

Variable Speed (Avoid modification) — Select whether this machine has variable speed abilities.

Water Levels (Avoid modification) — Enter the values for the water levels (in inches or centimeters) used in bath steps in which the water level is controlled by a pressure transducer. Water Level 1 must be less than or equal to Level 2. Level 2 must be less than or equal to Level 3.

NOTE: The temperature unit decision determines the water unit. If the temperature unit is degrees Fahrenheit, the water unit is inches. If the temperature unit is degrees Celsius, the water unit is centimeters.

Wet-Down (Avoid modification) — Enter the wet-down level (in inches or centimeters) for this machine.

NOTE: The temperature unit decision determines the water unit. If the temperature unit is degrees Fahrenheit, the water unit is inches. If the temperature unit is degrees Celsius, the water unit is centimeters.

Bath Level Offset (Avoid modification) — Enter the digital counts value required to correctly display the bath level on the **Run** display. The correct value (as set at the Milnor® factory) is extremely important to obtain the expected machine function.

Chemical Valves (Avoid modification) — Enter the number of chemical valves controlled by this machine.

Drain Washout (Avoid modification) — Enter the number of seconds for the drain washout time.

Name — Give this machine a name. If the machine is connected to a Mildata® network, the name of the machine appears on printed reports.

Simulator (Avoid modification) — Select YES if this software is running on a personal computer. Select NO if this is a washer-extractor.

Counts Per 100 — Currently not used on MilTouch-EX™ WTB machines.

Offset Valve Time — Currently not used on MilTouch-EX™ WTB machines.

Jog Speed (Avoid modification) — Enter the cylinder speed in RPMs when the operator is manually jogging the cylinder.

Tank Temperature — Not used on MilTouch-EX™ WTB machines.

Programmable Outputs — Currently not used on MilTouch-EX™ WTB machines.

Mildata® — Select whether this machine is part of a Mildata® network. This decision provides access to 10 optional decisions for additional Mildata® network communications.

Contact Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117 for more information on the Mildata® product.

- **Address**—Enter the machine address on the Mildata® network.
- **Formula**—Select whether this machine will pass formula data for each load to the Mildata® computer.
- **Work Order**—Select whether this machine will pass the work order for each load to the Mildata® computer.
- **Goods Code**—Select whether this machine will pass the goods code for each load to the Mildata® computer.
- **Customer**—Select whether this machine will pass the customer code for each load to the Mildata® computer.
- **Employee**—Select whether this machine will pass employee data for each load to the Mildata® computer.

- **Weight**—Select whether this machine will pass weight data for each load to the Mildata® computer.
- **Pieces**—Select whether this machine will pass the number of pieces for each load to the Mildata® computer.
- **Lot**—Select whether this machine will pass the lot number for each load to the Mildata® computer.
- **Group**—If this machine is part of a group of machines that will use the same formulas, enter the group number for this machine.

Digital-to-Analog Offset (Avoid modification) — Enter a value to calibrate the digital-to-analog board to the inverter for cylinder speed.

Staged RPM (Avoid modification) — Enter the maximum allowed speed in RPMs for the first phase of a staged extract step. See Section 3.5 : The Sequence of Actions in a Staged Extract (MilTouch-EX™), page 41 for more information.

Staged Delay (Avoid modification) — Enter the duration in seconds of the first phase of a staged extract step. See Section 3.5 : The Sequence of Actions in a Staged Extract (MilTouch-EX™), page 41 for more information.

2.1.4 WTB (Automated Chute) Configuration

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Use the following information to configure your machine for automatic loading and discharging.

1. Touch  on the **Home** display. A selection list appears.
2. From the selection list, touch **Configure WTB**. The **Configure WTB** display, shown in the following figure, appears.

Figure 6. Configure WTB Display

Legend

A . . . Abandon changes and return to the **Home . .** display

Cd . . The configuration decisions

S . . . Save changes and return to the **Home . .** display

Sc . . Scroll between pages

Miltrac™ Address — Enter the address this machine occupies on the Miltrac™ controller system. The valid range is 000 to 255.

Bytes in Network — This decision (also known as Baud Rate, Network String Length, and Number for Network) applies only to devices in a Milnet or Miltrac™ network.

NOTE: If you change the network string length (baud rate) on this machine (MilTouch™ press), you must also change the network string length of the Miltrac™ (or Milnet) computer and every machine on the Miltrac™/Milnet link to the same value.

(00) Miltrac 89100 or Later the system uses Miltrac™ software version 89100 or later, but before 21000

(11) Milnet System enter one of these numbers for systems with Milnet versions between 86088 and 86095. If the device does not communicate with the Milnet controller at the first setting chosen, select the other one.

(24) Miltrac 8624 and Earlier the system uses Miltrac™ software version 8624C and earlier

(30) Miltrac 89001 and Earlier enter this number for systems with Miltrac™ versions 89001 to 89018.

(96), (97), (98), (99) Enter 96, 97, 98, or 99 for Milnet or Miltrac™ software version 21000 and later. Differences in baud rate are a trade-off between communication speed, which can affect productivity, and protection against data corruption from electromagnetic interference, common in industrial processing settings. A technician familiar with Miltrac™ device communication may need to experiment with the baud rate setting.

96 = 9.6 kb/s; slowest, but most reliable communication rate

97 = 19.2 kb/s; somewhat favors reliability over speed

98 = 38.4 kb/s; average speed and reliability (recommended starting value)

99 = 57.6 kb/s; somewhat favors speed over reliability

NOTE: If your machine or system performance is poor at all available baud rates, consult your dealer or a Milnor® technician using the information in Section 6.4 : How to Contact Milnor®, page 117.

Dryell (Integrated Door Chute) — Select whether this machine is equipped with a Milnor® Integrated Door Chute.

Clockwise Discharge — Enter the duration (in 1/10 seconds) of clockwise rotation while discharging. Valid range is 01 to 99 (0.1 to 9.9 seconds). The cylinder rotates at jog speed, as defined in Jog Speed (Avoid modification).

Counter-clockwise Discharge — Enter the duration (in 1/10 seconds) of counter-clockwise rotation while discharging. Valid range is 01 to 99 (0.1 to 9.9 seconds). The cylinder rotates at jog speed, as defined in Jog Speed (Avoid modification).

Dwell Discharge — Enter the duration (in 1/10 seconds) of dwell (off time) between clockwise and counter-clockwise rotation when the cylinder turns in both directions while discharging. Valid range is 00 to 50 (0 to 5 seconds).

Number of Sequences — Enter the number of times to repeat the discharging sequence of cylinder rotation and dwell. The valid range is 02 to 20.

End Time — Enter the duration (in minutes) that the machine will run in **End** mode (see How to End) in Section 3.1.1.10 : MilTouch-EX™ Wash Formula Decisions, page 33) before it desires to discharge. Valid range is 0 to 850.

Post-wash — Select whether the controller uses post-wash codes (see Section 3.2 : Post-wash Codes, page 37).

Dryell Delay — Enter the desired time (in seconds) between when the loading process ends and the controller commands the washer to tilt to the loading position. Valid range is 000 to 255.

Dryell Flush — Enter the desired time (in seconds) for the controller to flush the Integrated Door Chute during the loading process. The “Dryell Flush” timer resets to this value each time the load eye is blocked. Valid range is 000 to 255.

Allied Load — Select whether the controller receives “Start Loading” (3MTA4-13), “Load Complete” (3MTA4-16), and batch data in binary format from a non-Milnor® loading device.

Allied Discharge — Select whether the controller receives a “Start Discharging” command (3MTA4-17) and sends batch data in binary format to a non-Milnor® receiving device.

Early Call — Select whether this machine can prepare to receive new loads while it discharges loads.

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2.2 System Settings

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From the **System Settings** display, you can set a password to restrict access to formula modification, configuration settings, and manual functions. You can also set the date and time for the controller, recalibrate the touchscreen, and enable an Ethernet connection.

Touch  on the **Configuration** display to access the **System Settings** display, shown in the following figure.

Figure 7. System Settings Display

Legend

- **D . . .** Enter the current date
- **E . . .** Set up an Ethernet connection
- **Ex . .** Exit (return to the **Configuration** display)
- **P . . .** Password Area. See Section 2.2.1 , page 23.
- **R . . .** Recalibrate the touchscreen, as explained in Section 2.2.2 : Recalibrate the Touchscreen, page 25
- **Sc . .** Scroll pages if there is more than one page
- **T . . .** Enter the current time

2.2.1 Enable and Define Lockout Passwords

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When a lockout password is enabled (YES), the lockout password will be necessary to access certain functions. You can enable and define a lockout password from the password area (Figure 8, page 23) on the **System Settings** display.

Figure 8. Password Area of the System Settings Display

Legend

- **C . . .** Define a configuration password
- **F . . .** Define a formulas password
- **M . . .** Define a manual functions password
- **Pc . .** Enable a configuration password
- **Pf . .** Enable a formulas password
- **Pm . .** Enable a manual functions password

1. Touch a button in the left column of the password area, labelled **Lockout Password**, to enable (YES) or disable (NO) a lockout password.
   - **Configuration** (Pc) controls access to the **Configuration** display, the **System Settings** display, and the **Data Transfer** display.
   - **Formulas** (Pf) controls access to the **Wash Formula Maintenance** display.
   - **Manual** (Pm) controls access to **Formula Intervention** on the **Run** display.
2. Touch a button in the right column of the password area to define a lockout password.
3. The **User Password** window (shown in the following figure) appears.

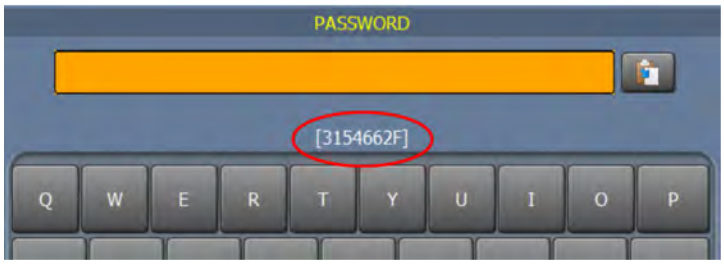
Figure 9. User Password Window

   a. In the **User Password** window, touch the **New Password** box.
   b. Enter the same password in both the **New Password** box and the **Verify Password** box. The lockout passwords are not case-sensitive.
   c. Touch to save the password and return to the **System Settings** display.

4. A dialog box (not shown) will appear, which indicates the password was saved. Touch to dismiss the dialog box.

NOTICE: To recover a lost password, contact Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117. Call or e-mail during normal business hours and provide the encrypted password below the Password Entry box (shown in the following figure). The Milnor® staff can decode the password for you.

Figure 10. Sample Encrypted Password



2.2.2 Recalibrate the Touchscreen

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If the touchscreen becomes less responsive to touch, you can recalibrate it to improve touch input accuracy.

NOTE: If you cannot access the recalibration screen because your touchscreen inputs are too inaccurate, visit the milnor.com Technical Knowledge Base under "Support and Safety" and search "force recalibration," or contact Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117.

1. Touch the button labelled **Recalibrate Touchscreen** (R) on the **System Settings** display.
2. A dialog box (not shown) appears, which prompts you to confirm your decision. In the dialog box, touch ✓ to recalibrate the touchscreen.
3. The controller restarts, and the calibration screen appears.
4. Use a stylus or the end of a pen to touch each of the five crosshair symbols only one time as they appear.

   NOTICE: You can use your finger to calibrate the touchscreen, but it is less accurate than a stylus and may generate multiple inputs with one touch. If you touch a crosshair symbol more than one time, you must repeat the calibration procedure.
5. A timed dialog box (not shown) prompts you to confirm or reset your calibration. In the dialog box:
   - Touch ✓ before the timer expires to confirm the calibration. You have 12 seconds.
   - Do not touch ✓ and allow the dialog box timer to expire to calibrate the screen again. Repeat steps 3 through 5.
6. The controller restarts after you confirm the calibration.

2.2.3 Set the System Date and System Time

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The date and time fields are displayed on the **Home** display and used when data is collected.

1. Touch the button labelled **Date** on the **System Settings** display. The **System Date** window (not shown) appears. In the **System Date** window:

a. Enter today's month, day, and year.

b. Touch  to save your changes and return to the **System Settings** display.

2. Touch the button labelled **Time** on the **System Settings** display. The **System Time** window (not shown) appears. In the **System Time** window:

   a. Enter the current time in 24-hour format.

   b. Touch  to save your changes and return to the **System Settings** display.

2.2.4 Enable an Ethernet Connection

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If your MilTouch™ machine is part of a Mildata® network, the MilTouch™ controller must have a Cat 5 Ethernet connection with the Mildata® computer and you must enable this connection in order for the machine to communicate with the Mildata® computer.

To enable the connection, touch the button labelled **DHCP** on the **System Settings** display so that it displays  YES to enable DHCP or  NO to disable DHCP.

- Enable DHCP and the server will automatically assign an IP address to your machine.
- Disable DHCP to manually assign a static IP address to your machine.
  - If the Mildata® network is tied to your wireless network, your network administrator must provide the static IP information.
  - If the Mildata® network is isolated to your Milnor® equipment, a Milnor® technician must provide the static IP information.

3 Formula Maintenance

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3.1 Formula Creation and Modification

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Wash formulas consist of steps, which consist of decisions. Add, change, and delete formulas, steps, and decisions from the **Wash Formula Maintenance** display.

NOTE: The formula changes you make (add a new formula, delete a step, change a step decision, etc.) are recorded in the data logs. See Section 4.2.3 : Configuration and Programming History, page 44.

3.1.1 The Wash Formula Maintenance Display

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Touch  on the **Home** display to view the display shown in the following figure. This display is subsequently referred to as the **Wash Formula Maintenance** display.

Figure 11. The Wash Formula Maintenance Display

Legend

A.	Add a new formula
B.	Go back one level, to the **Home** display
C.	Copy a formula
Dl.	Delete a formula
F#.	Change a formula number
Fe.	Enable/disable a formula
Fn.	The wash formula names
H.	Return to the **Home** display
R.	Rename a formula
Sc.	Scroll between pages
Se.	Search for a formula
S.	Access the **Steps in a Wash Formula** display

3.1.1.1 To Add a New Wash Formula

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Create a new, empty wash formula without any steps (you must add steps).

1. On the **Wash Formula Maintenance** display, touch  to add a new wash formula. The controller gives the new wash formula a name similar to `[N] Formula xxx`, where *xxx* is a number.
2. Touch  to change the wash formula name. The **Formula Name** window (not shown) appears. On the **Formula Name** window:
   a. Touch the **[Clear All]** button to delete the formula name that the controller provided.
   b. Use the keypad to enter a new formula name.
   c. Touch  to save the new formula name.

3.1.1.2 To Copy a Wash Formula

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Make a copy of a wash formula.

1. Use  and  on the **Wash Formula Maintenance** display if necessary to scroll between pages and show the wash formula you want, or use  to search for the wash formula by its formula number.
2. Touch the button that displays the wash formula name (Fn).
3. Touch  to copy the formula. The controller gives the new formula a name similar to `(Copy) F-xxx`, where *xxx* is the number of the formula that you copied.
4. Touch  to change the wash formula name. The **Formula Name** window (not shown) appears. On the **Formula Name** window:
   a. Touch the **[Clear All]** button to delete the formula name that the controller provided.
   b. Use the keypad to enter a new formula name.
   c. Touch  to save the new formula name.

3.1.1.3 To Delete a Wash Formula

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Delete a wash formula from the controller's memory.

1. Use  and  on the **Wash Formula Maintenance** display if necessary to scroll between pages and show the wash formula you want, or use  to search for the wash formula by its formula number.

2. Touch the button that displays the wash formula name (Fn).
3. Touch  to delete the formula.
4. A dialog box (not shown) appears, which prompts you to confirm your decision. On the dialog box, touch  to delete the formula.

NOTE: Formula numbers are not sequential. For example, if you delete formula #2, formula #3 will remain #3 and there will be no formula #2.

3.1.1.4 To Change the Number of a Wash Formula

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Change the number assigned to a wash formula.

1. Use  and  on the **Wash Formula Maintenance** display if necessary to scroll between pages and show the wash formula you want, or use  to search for the wash formula by its formula number.
2. Touch the button that displays the formula number (F#). The **Change Formula Number** window (not shown) appears. In the **Change Formula Number** window:
   a. Touch the backspace button to delete the formula number that the controller provided.
   b. Use the keypad to enter a new formula number. The controller will not accept a formula number that is already in use.
   c. Touch  to save the new formula number.

3.1.1.5 To Change a Wash Formula

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Change the step decisions or the number of steps in a wash formula.

1. Use  and  on the **Wash Formula Maintenance** display if necessary to scroll between pages and show the wash formula you want, or use  to search for the wash formula by its formula number.
2. Touch the button that displays the wash formula name (Fn).
3. Touch the button that displays the number of steps (S) to the right of the wash formula name to view the display shown in the following figure. This display is subsequently referred to as the **Steps in a Wash Formula** display.

Figure 12. The Steps in a Wash Formula Display

Legend

A. Add a step
B. Go back one level, to the **Wash Formula Maintenance** display
C. Copy a step
Dl. Delete a step
H. Return to the **Home** display
R. Rename a step
Sc. Scroll between pages
S#. The Step numbers
Sn. The Step names
St. Change the step decisions

3.1.1.6 To Add a Step

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Create a new step in the wash formula.

1. Touch  on the **Steps in a Wash Formula** display to add a new step to the wash formula.
   - If you have a step selected, the controller prompts you to choose where it will insert the new step— before the selected step, after the selected step, or at the end of the formula.
   - If you do not have a step selected, the controller will insert the new step at the end of the formula.

   A new step appears with a step type of **End Formula** (00:00). The controller gives the new step a name similar to `[N] Step xxx`, where *xxx* is a number.

2. Touch  to change the step name. The **Step Name** window (not shown) appears. In the **Step Name** window:
   a. Touch the **[Clear All]** button to delete the step name that the controller provided.
   b. Use the keypad to enter a new step name.
   c. Touch  to save the new step name.

3.1.1.7 To Copy a Step

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Make a copy of a step in a wash formula.

NOTE: The controller prevents the duplication of an extract step. This prevents two consecutive extract steps.

1. Use  and  on the **Steps in a Wash Formula** display if necessary to scroll between pages and show the step you want.
2. Touch the button that displays the step name (Sn).
3. Touch  to copy the step. The controller prompts you to choose where it will insert the copy of the step:
   - before the original step
   - after the original step
   - at the end of the formula

   The controller gives the copy of the step a name similar to `(Copy) Step xxx`, where *Step xxx* is the name of the step you copied.
4. Touch  to change the step name. The **Step Name** window (not shown) appears. In the **Step Name** window:
   a. Touch the **[Clear All]** button to delete the step name that the controller provided.
   b. Use the keypad to enter a new step name.
   c. Touch  to save the new step name.

3.1.1.8 To Delete a Step

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Delete a step from a wash formula.

NOTE: The controller prevents the deletion of a step if the result would be two consecutive extract steps.

1. Use  and  on the **Steps in a Wash Formula** display if necessary to scroll between pages and show the step you want.
2. Touch the button that displays the step name (Sn).
3. Touch  to delete the step.
4. A dialog box (not shown) appears, which prompts you to confirm your decision. On the dialog box, touch  to delete the step.

3.1.1.9 To Modify a Step

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Change the step decisions for a step in a wash formula, such as the step type, the step time (duration), etc.

1. Use  and  on the **Steps in a Wash Formula** display if necessary to scroll between pages and show the step you want.
2. Touch the button that displays the step name (Sn).
3. Touch the button that displays the step type (St) next to the step name (Sn). The controller will display the decisions, as shown in Figure 13, page 32. See the next section for a description of all the step decisions.
4. Touch the step decision you want to change. One of two types of windows (not shown) appears.
   - A selection list appears. Touch the value you want to use.
   - A window with a text box and a keypad appears.
     a. Touch the value in the text box. Use the backspace button to delete the current value.
     b. Touch the desired numbers or letters to enter the new value.
     c. Touch  to save the new value.

Figure 13. The Step Decisions Display

Legend

A.	Abandon changes
S.	Save changes
Sd.	The step decisions

5. Save or abandon your changes:
   - To abandon the most recent changes and return to the **Steps in a Wash Formula** display, touch  .
   - To save the changes and return to the **Steps in a Wash Formula** display, touch  .

3.1.1.10 MilTouch-EX™ Wash Formula Decisions

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Type

End Formula The formula is completed and causes the controller to query for how to end the formula.
1-Way Wash a bath step in which the cylinder turns in one direction
2-Way Wash a bath step in which the cylinder turns in the two directions. A wash step can be used to cool down the previous bath. See Section 3.3 : How to Use Cooldown, page 38.
Soak Wash a bath step in which the cylinder does not turn
Staged Extract an extract step specifically applicable to goods such as cotton towels and rubber mats. SeeSection 3.5 : The Sequence of Actions in a Staged Extract (MilTouch-EX™), page 41 for more information.
Standard Extract an extract step which accelerates cylinder rotation to the speed entered in the speed decision and maintains that speed for the time entered in the time decision.

Time — Set the hours, minutes, and seconds that the step timer will run before it declares that this step is complete.

TIP: Some step types start the step timer only after requirements are met, such as water level. The time required to meet these requirements will increase the total time of the step and the formula.

Temperature — Set the temperature desired for a bath step. Units are Fahrenheit or Celsius degrees, as configured. The valid range is 50 to 205 degrees Fahrenheit (10 to 96 degrees Celsius).

NOTE: The following three step decisions control the temperature of incoming bath water. You can use the techniques described in Section 3.4 : How to Modulate Water Valves to Regulate Incoming Water Temperature, page 40 to achieve the fastest possible fill that also achieves the desired bath temperature.

Hot Water

OFF Do not open the hot water inlet valve while the machine is filling.
ON Use hot water while the machine is filling.
Raise Fill Temperature The hot water valve opens only to increase the bath temperature to the desired temperature while the machine is filling.

Cold Water

OFF Do not open the cold water inlet valve while the machine is filling.
ON Use cold water while the machine is filling.
Lower Fill Temperature The cold water valve opens only to decrease the bath temperature to the desired temperature while the machine is filling.

3rd Water

OFF Do not open the 3rd water inlet valve while the machine is filling.
ON Use 3rd water while the machine is filling.
Raise Fill Temperature The 3rd water valve opens only to increase the bath temperature to the desired temperature while the machine is filling.

Lower Fill Temperature The 3rd water valve opens only to decrease the bath temperature to the desired temperature while the machine is filling.

Water Level

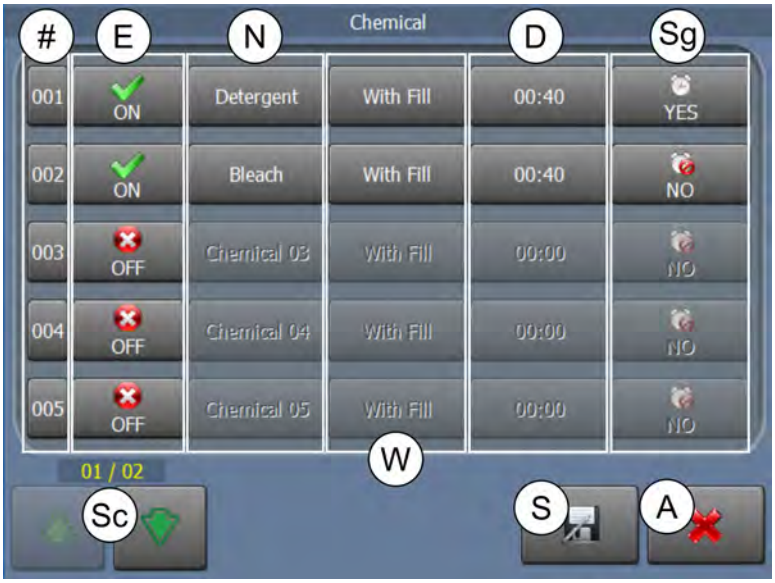
Level 1, 2, and 3 Fill to the level that was configured for Level 1, 2, or 3.
User Defined Fill to a level you input using the keypad, for this step only.

Steam

NO Steam Do not use steam in this step to achieve or to restore the bath temperature.
After, Runs After the desired bath level is achieved, run the step timer, and use steam to achieve and to maintain the bath temperature.
Stops After the desired bath level is achieved, use steam to achieve the bath temperature with the step timer stopped. Do not use steam to maintain the temperature.
After, Stops After the desired bath level is achieved, use steam to achieve the bath temperature with the step timer stopped. If necessary, use steam to maintain the temperature.
Early, After, Runs At the lowest safe bath level, use steam to achieve the bath temperature. Start the step timer when the desired level is achieved. If necessary, use steam to maintain the temperature.
Early, Stops At the lowest safe bath level, use steam to achieve the bath temperature. Start the step timer when the desired level and temperature are achieved. Do not use steam to maintain the temperature.
Early, After, Stops At the lowest safe bath level, use steam to achieve the bath temperature. Start the step timer when the desired level and temperature are achieved. If necessary, use steam to maintain the temperature.

Chemical — Touch this decision to access the **Chemical** display, shown in the following figure.

Figure 14. The Chemical Display



Legend

#. The fixed display of the chemical number.
A. Abandon changes and return to the **Wash Formula Maintenance** display.
D. The duration, in seconds, of the chemical injection. Touch to edit the number of seconds the injection will last.
E. Enable (use) the chemical in this step.
N. The name of the chemical. Touch to rename it.
S. Save changes and return to the **Wash Formula Maintenance** display.
Sc. Scroll between pages to view more chemicals
Sg. Select whether to sound the operator signal and require the operator to press (which silences the signal) before the injection begins
W. Choose the **With Fill** option to start the chemical injection when the water valves open to fill the cylinder. Choose the **Level OK** option to start the chemical injection when the water level in the cylinder is achieved. Choose the **Level + Temp** option to start the chemical injection when the water level in the cylinder is achieved and the desired temperature is achieved.

Speed

Wash Speed (RPM) Range varies by model.
Extract Speed (RPM) Range varies by model.

Drain Type

Standard The cylinder rotates at slightly above 1 G-force for the drain duration. Actual speed is determined by the configured machine type. The drain valve opens after a distribution delay.

2-Way Wash The cylinder rotates in both directions at wash speed while draining. The drain valve opens when the step timer expires.

Do Not Drain The drain valve remains closed to keep the bath liquor for the next step. The next bath step determines how the cylinder rotates.
Stop with Fill The cylinder does not rotate while the machine is filling. The drain valve opens after a distribution delay.
Stop with Drain The cylinder does not rotate while the machine is draining. The drain valve opens when the step timer expires.
Stop with Fill and Drain The cylinder does not rotate while the machine is draining. The drain valve opens when the step timer expires.
RinSave® The cylinder rotates according to a specific sequence, described in the following section. The drain valve opens 10 to 15 seconds after the step timer expires.

The RinSave® Drain Sequence

1. When the bath ends, the cylinder turns clockwise at wash speed for 8 seconds.
2. Before the drain valve opens, the cylinder accelerates to the standard drain speed for 4 seconds.
3. The drain valve opens and the cylinder turns at standard drain speed for a time determined by the configured machine type.
4. The cylinder accelerates to RinSave® speed for the remainder of the drain sequence.
5. If the next step is an extract step, the cylinder accelerates to the programmed speed. If the next step is a bath step, the cylinder decelerates to a stop.

Reuse Drain

To Sewer Drain this extract step to the sewer.
Reuse Tank Drain this extract step to a reuse tank through a secondary drain valve.

How to End

Stop The operator signal sounds, and the cylinder coasts to a stop.
Reversing The operator signal sounds, and the cylinder reverses for 20 seconds in each direction with 3 seconds of dwell time between reversals.
Rotating The operator signal sounds, and the cylinder rotates clockwise at wash speed.
Tumble The operator signal sounds, and the cylinder reverses at wash speed.
Stop + Signal The operator signal sounds and the cylinder coasts to a stop. The operator signal stops sounding after 2 minutes.
Reversing + Signal The operator signal sounds, and the cylinder reverses for 20 seconds in each direction with 3 seconds of dwell time between reversals. The operator signal stops sounding after 2 minutes.
Rotating + Signal The operator signal sounds, and the cylinder rotates clockwise at wash speed. The operator signal stops sounding after 2 minutes.
Tumble + Signal The operator signal sounds, and the cylinder reverses at wash speed. The operator signal stops sounding after 2 minutes.

On Time — When a bath step turns in two directions, this is the number of seconds the motor is ON, turning the cylinder.

Off Time — When a bath step turns in two directions, this is the number of seconds the motor is OFF, letting the cylinder coast.

Fill from Tank — If the machine is equipped with an overhead tank, fill from the tank for this step.

Recirculate Water — If the machine is equipped with recirculation piping, circulate the bath liquor out of the machine, through other devices, and back into the machine.

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3.2 Post-wash Codes

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Post-wash codes are used during automatic operation to pass dry codes and destination codes to allied (non-Miltrac™) drying or conditioning equipment.

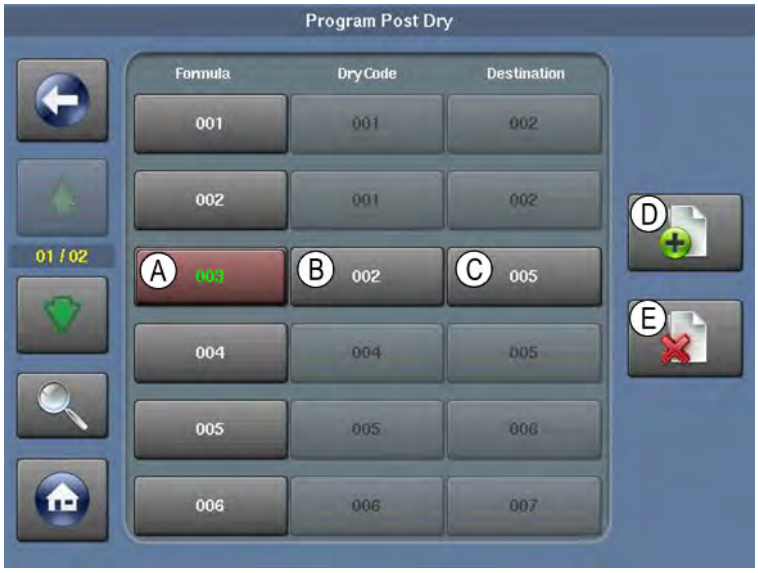
Dry code the drying formula to be used in the drying or conditioning equipment.
Destination the storage location within the laundry to send the load.

NOTE: Your machine must be configured **Post-wash** = YES to use post-wash codes. See Post-wash.

Touch on the **Home** display and choose **Program Post Dry** from the selection list to access the **Program Post Dry** display, shown in the following figure.

Figure 15. Program Post-Post Dry Display

Window



Legend

A . . . The formula associated with the post-wash code
B . . . Enter dry code
C . . . Enter the destination code
D . . . Add a new post-wash code
E . . . Delete the selected post-wash code

3.2.1 How to Add a New Post-Wash Code

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1. On the **Program Post Dry** display, touch  . The **Add Post Dry** window (not shown) appears.
   a. In the **Add Post Dry** window, enter the formula that will use the post-wash code. The controller will send the post-wash code to the dryer every time the machine runs this formula.
   b. Touch  to create the post-wash code for that formula.

    **NOTE:** You cannot change the formula assigned to the post-wash code after you touch  .
2. Touch the button labelled “DryCode” (item B in Figure 15, page 37). The **Post Dry Drycode** window (now shown) appears.
   a. In the **Post Dry Drycode** window, enter the dry code.
   b. Touch  to confirm your entry and close the window.
3. Touch the button labelled “Destination” (item C in Figure 15, page 37). The **Post Dry Destination** window (not shown) appears.
   a. In the **Post Dry Drycode** window, enter the destination.
   b. Touch  to confirm your entry and close the window.

3.3 How to Use Cooldown

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A cooldown bath is used to gradually lower the temperature of goods (usually synthetics and blended fabrics) to reduce the chance of setting wrinkles.

3.3.1 Configure your Machine for Cooldown

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To use cooldown, your machine must be equipped with and configured for:

- A separate cooldown water valve.
- A temperature probe/sensor (Temp Probe = YES).
- Cooldown enabled (Cooldown Error = 05 Minutes, 10 Minutes, or 20 Minutes).

See Section 2.1 : Machine Configuration, page 12.

3.3.2 Program a Cooldown

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A cooldown is programmed as a separate bath step following the bath in which the cooldown is desired. There is no explicit step decision for a cooldown. A cooldown occurs automatically in a step if the formula meets the following criteria:

- The cooldown step follows a high-temperature step, usually a steam step; the cooldown step cannot be the first step.
- The high-temperature bath step before the cooldown step is programmed with:
  - A step type = **1-Way Wash** or **2-Way Wash**
  - A non-zero temperature
  - A drain type = **Do Not Drain**
  - A bath level lower than Level 3
- The cooldown step after the previous (high-temperature) bath step is programmed with:
  - A step type = **1-Way Wash** or **2-Way Wash**
  - A non-zero temperature lower (cooler) than the temperature of the previous (high-temperature) bath step
  - All water valves (HOT, COLD, 3rd) set to **OFF**
  - A Level 3 bath level, or a bath level higher than the bath level of the previous step

NOTE: The programmed cooldown temperature must always be at least 15 degrees Fahrenheit (8 degrees Celsius) hotter than the hottest ambient temperature or the hottest cold water temperature that will be encountered. If this rule is not followed, it may take a long time to achieve the desired cooler temperature, or even be impossible.

3.3.3 The Cooldown Sequence

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The cooldown step begins after the high-temperature bath step in which the cooldown is desired. It performs the following sequence of actions:

1. The cooldown valve opens. On the **Run** display, the  icon illuminates in the **Machine Status** area.

   NOTE: See the operator guide for instructions on how to interpret and use the **Run** display.

2. The water temperature falls and the water level rises, as indicated on the **Machine Status** area.
3. When the high water level is achieved, the cooldown valve closes. The  icon extinguishes in the **Machine Status** area.
4. The drain valve opens.
   - The water drains to the sewer and the  icon illuminates in the **Machine Status** area.

- If your machine is equipped with, and configured for, an optional reuse tank, the  icon illuminates in the **Machine Status** area.

5. The water level falls.
6. When the water level falls below high level, the drain closes.
   - If the drain valve to the sewer closes, the  icon extinguishes in the **Machine Status** area.
   - If the drain valve to the reuse tank closes, the  icon extinguishes in the **Machine Status** area.
7. The cooldown valve re-opens. The  icon illuminates in the **Machine Status** area.
8. The drain and cooldown valves continue to open and close as needed to reach the desired water level and temperature.
9. The step timer starts 15 seconds after the desired cooldown temperature is achieved. The timer runs for one minute.
10. When the step time expires, the cooldown valve closes and the drain opens. The drain remains closed only if the machine was programmed to not drain, as to prolong the cooldown or allow the injection of chemicals into the cooler bath.

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3.4 How to Modulate Water Valves to Regulate Incoming Water Temperature

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When using both hot and cold water valves to achieve a programmed temperature, you can achieve a more constant and accurate fill temperature more quickly if you understand the relationship between the desired temperature and the temperature of a split fill (hot and cold valves open simultaneously).

- If the desired temperature is hotter than the normal split temperature, program the hot water valve open (HOT Water =  ON) and the cold water valve to open only to lower the fill temperature (COLD Water =  Lower Fill Temp).
- If the desired temperature is colder than the normal split temperature, program the hot water valve to open only to raise the fill temperature (HOT Water =  Raise Fill Temp) and the cold water valve to remain open constantly (COLD Water =  ON).

NOTE: To program a bath step with a specific temperature, your machine must be equipped with, and configured for, a temperature probe/sensor (Temp Probe = YES). See Section 2.1 : Machine Configuration, page 12.

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3.5 The Sequence of Actions in a Staged Extract (Mil-Touch-EX™)

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A staged extract can reduce the tendency for cotton goods to adhere to the sides of the cylinder during extraction. A staged extract can also improve extraction with impermeable goods (such as rubber mats). A staged extract performs the following sequence of actions:

1. The cylinder rotation speed increases from drain speed to the speed entered in the **Staged RPM** configuration decision for the duration of time entered in the **Staged Delay** configuration decision. The staged RPM and staged delay time are set at the factory based on your machine's model number and should not be modified.
   - If the cylinder rotation speed increases to the set speed before the staged delay time expires, the controller holds the speed until the staged delay time expires.
   - If the cylinder does not accelerate to the set speed, acceleration continues until the staged delay time expires.
2. After the staged delay time expires, the step timer stops.
3. The cylinder performs a preemptive recycle. In a recycle, the machine will decelerate to a stop, reverse a few times in wash speed, then redistribute in drain speed and attempt to achieve the set extract speed.
4. The step timer runs while the cylinder accelerates to the staged RPM.
5. The controller monitors the vibration switch or the excursion switch and performs a recycle if the vibration switch or the excursion switch trips. See Section 6.1 : Out-of-balance Detection and Balancing for Washer-extractors, page 109 for more information.
6. The step ends when the step timer reaches 0.

4 Troubleshooting

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4.1 Types of Troubleshooting and Analysis Information

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Most troubleshooting and analysis procedures are explained here. Some procedures are explained in other parts of the manual.

If you need to…

- recalibrate your touchscreen, see Section 2.2.2 : Recalibrate the Touchscreen, page 25
- recover a lost password, see Section 2.2.1 : Enable and Define Lockout Passwords, page 23
- view production records, changes made to configuration decisions and wash formulas, and records of the errors encountered, see Section 4.2 : Data Logs, page 42
- resolve an error, see Section 4.3 : Errors, page 49
- test a formula or troubleshoot a formula in production , see Section 4.6 : Formula Intervention, page 62
- troubleshoot inputs and outputs, see Section 4.7 : Troubleshooting Inputs and Outputs, page 66
- troubleshoot the balancing system, see Section 6.1 : Out-of-balance Detection and Balancing for Washer-extractors, page 109
- update software, see Section 6.3 : Software Update Procedure, page 112

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4.2 Data Logs

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The controller records certain actions you perform and events that occur— such as when you start a formula, change the machine configuration, or encounter an error— in data logs. Each data log displays a short description of the action that took place, what date and time it took place, and how many actions took place that day.

You can also generate cumulative reports of a machine's production history, which you can then export to a USB flash drive to print or keep as backup data.

NOTE: If the machine is connected to a Mildata® network, the Mildata® product automatically accumulates production and error data, which can be viewed on the Mildata® computer. The product also provides sophisticated tools to analyze this data.

Touch  on the **Home** display to access data logs. Choose a log date using the calendar that appears (see Section 4.2.1 , page 43).

The controller records three categories of data:

- production history
- configuration and programming history
- error history

Touch  ,  , and  to cycle among the three types of data logs.

4.2.1 Date Selection

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Touch  to access the calendar. Touch a date to view the log files for that date. You can use the arrow buttons (M and Y) to change the month and the year.

Figure 16. Calendar

Legend

C . . . View configuration and programming history
D . . . View the calendar and choose a log date
E . . . View error history
Ex . . . Exit (return to the **Home** display)
M . . . Change the log month
P . . . View production history
R . . . Generate production reports
Sc . . . Scroll between data history pages
Y . . . Change the log year

4.2.2 Production History

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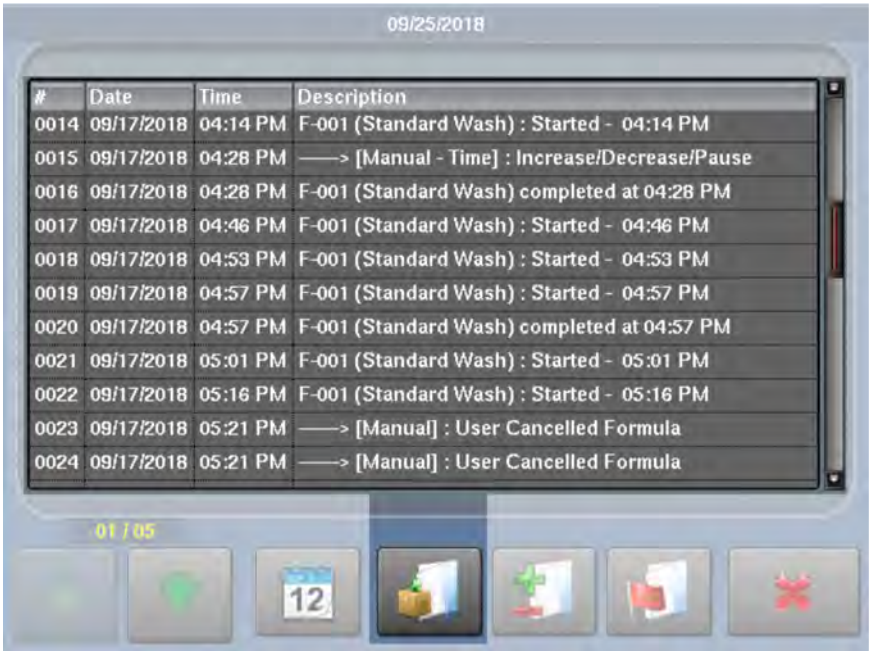
Touch  to view the machine's production history for the date you selected. The production history records:

- what formulas you run
- when formulas start
- when formulas finish
- when you make manual changes to the step timer
- when you cancel formulas

Figure 17. Production History



4.2.3 Configuration and Programming History

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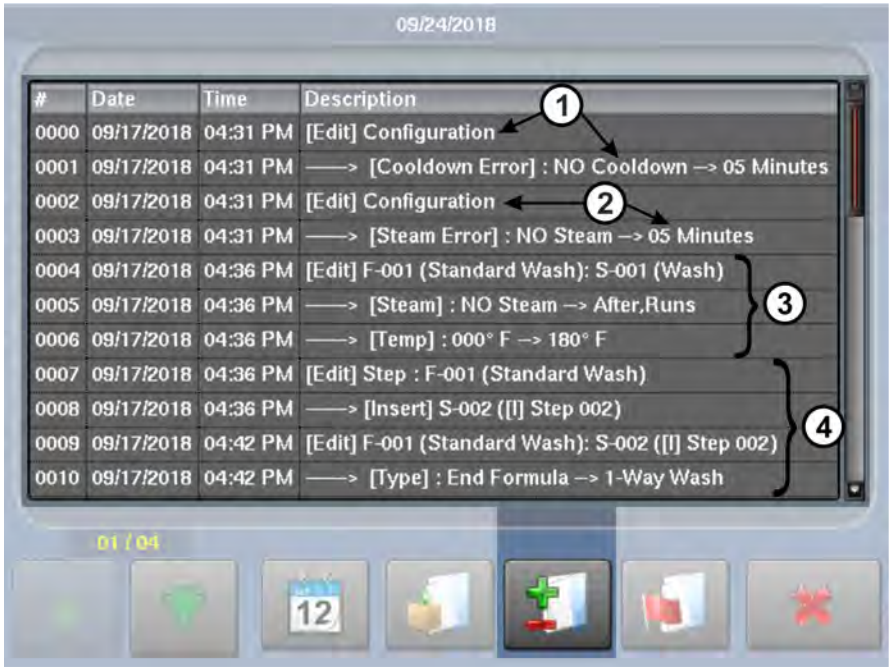
Touch  to view the machine's configuration and programming history for the date you selected. The configuration and programming history records what changes you make to the configuration settings and wash formulas.

Figure 18. Configuration and Programming Changes



Legend

1 . . . Example: In the configuration decisions, changed Cooldown Error from NO Cooldown to 5 minutes

2 . . . Example: In the configuration decisions, changed Steam Error from NO Steam to 5 minutes

3 . . . Example: In Formula 001, Step 001, changed the Steam step decision from NO Steam to After, Runs

4 . . . Example: In Formula 001, inserted new Step 002 and set the Step Type decision to 1–Way Wash

4.2.4 Error History

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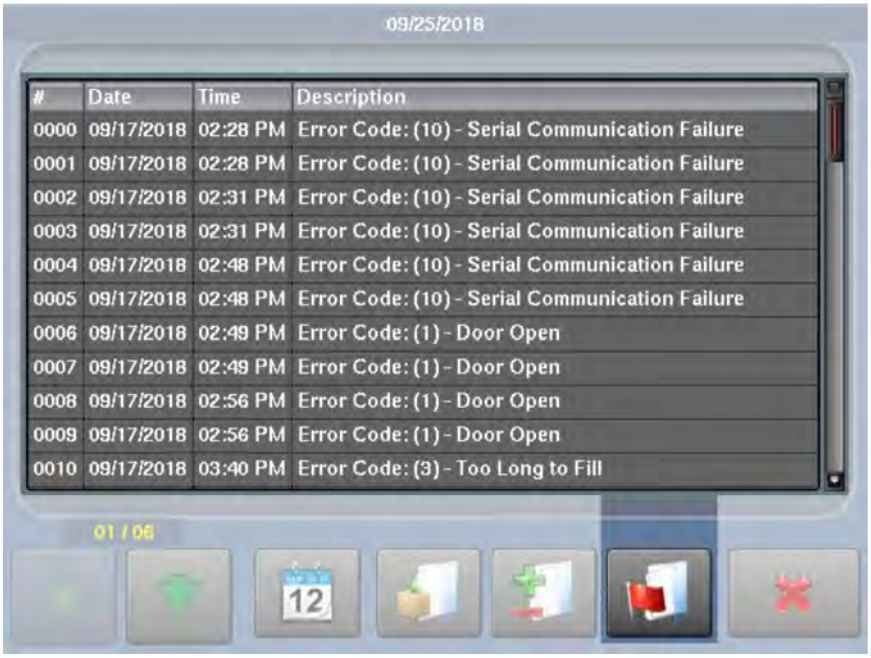
Touch  to view the machine's error history for the date you selected. The error history records the error conditions that the machine encounters.

Figure 19. Errors History



4.2.5 Production Reports

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You can generate cumulative reports of the machine's production history for a given day, month, or year. You can then export these reports as text (.txt) files to a USB flash drive to print or keep as backup data.

Each report contains the following information:

- Which formulas were processed
- How many times each formula was processed
- The total number of formulas processed
- The total run time for all the times a formula was processed
- The total run time of all the formulas processed
- Which formulas were cancelled
- How many times each formula was cancelled
- The total number of formulas cancelled
- The total run time for all the times a formula was processed before it was cancelled
- The total run time of all cancelled formulas before they were cancelled
- Which fault codes were encountered
- The number of times each fault code was encountered
- The total number of fault codes encountered

4.2.5.1 How to Generate a Production Report

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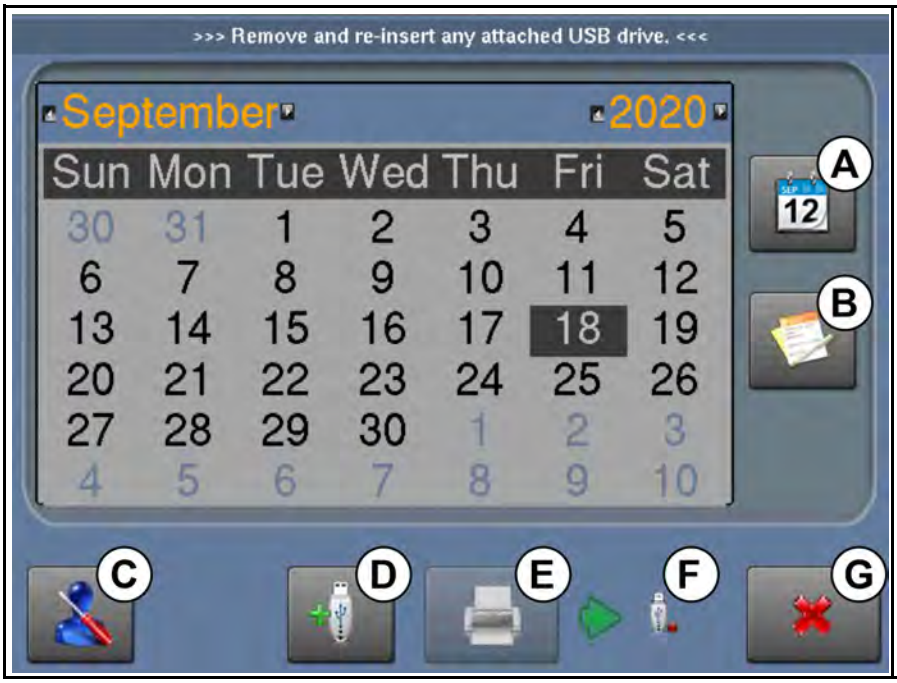
To generate a production report:

1. Touch  . The **Production Reports** display, shown in the following figure, appears.

Figure 20. Production Reports Display



Legend

A . . . Display the calender to choose a date

B . . . Generate a production report for the selected day, month, or year

C . . . Display the Pellerin Milnor Corporation contact information

D . . . Mount or unmount a USB flash drive

E . . . Export the production report as a .txt file to a USB flash drive

F . . . Available media indicator

G . . . Return to the **Home** display

2. On the calendar (like the one in Figure 16: Calendar, page 43), touch a date to view the production report for that date. You can use the arrow buttons to change the month and the year.
3. On the **Production Reports** display, touch  . A selection list appears.
4. Make a selection from the list:
   - Select “Day” to view the production report for only the date you selected (Ex. September 18th 2020).
   - Select “Month” to view the production report for the month of the date you selected (Ex. September 2020).
   - Select “Year” to view the production report for the year of the date you selected (Ex. 2020).

A production report, such as the one in the following figure, appears on the **Production Reports** display. Use the scroll bar on the right to scroll up and down and view the whole report.

Figure 21. Example Production Report

Touch  to choose a different date and view a new production report.

4.2.5.2 How to Export Production Reports as Text Files

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To export a production report as a text (.txt) file:

1. Mount a flash drive to the MilTouch™ controller as described in Section 5.2.1 : How to Mount a USB Flash Drive to the MilTouch™ Controller, page 97.
2. Touch  to export the production report as a .txt file.
3. The controller prompts you to name the file. The File Name window (not shown) appears. In the File Name window:
   a. Use the keypad to enter a file name.
   b. Touch  to confirm the file name and export the file.
4. A dialog box (not shown) appears, which indicates the file was exported to the root of the USB flash drive. Touch  to dismiss the dialog box.
5. Touch  to unmount the flash drive. The available media indicator changes from green to red (), which indicates the controller no longer recognizes a connected USB device.
6. Remove the USB flash drive.

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4.3 Errors

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If your machine encounters an error, an error code dialog box (Figure 22, page 49) appears on the controller.

There are two types of errors your machine can encounter:

- Formula Errors
- Loading and Discharging Errors

See the next section for a list of all the error codes and the possible causes/solutions.

Figure 22. Sample Error Code Dialog Box

4.3.1 Error Messages for MilTouch-EX™ Controller with Automated Loading and Discharge

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The following are error messages the controller can issue, possible causes, and solutions. Operation stops and cannot be resumed until the cause of the error is corrected. This can require a maintenance or chemical technician.

Formula Errors — These errors can occur when the machine runs a formula.

Too Long to Fill — The water in the machine did not reach the specified level within the configured **Fill Error Time**. The controller closes all water valves and turns off all chemical injections. The **Fill Error** timer resets after you correct the error.

Fill Time Configured too Short: Do a check of the configured fill time in your machine's configuration decisions. It may be necessary to increase the fill time.

Low Water Pressure: Do a check of the water pressure and volume to the machine.

Water Valve Malfunctioned: Use the electrical schematic manual to do a check of the water valves and the circuits that control the valves.

Too Long to Drain — The water in the machine did not drop to the specified level within the allotted drain time. The controller issues an error but the drain remains open. If a slow drain caused the error, the error clears and the formula resumes when the transducer senses that the water level has dropped to the desired level.

Drain Blocked: The drain pipe from the machine to the sewer may be blocked. Check the drain pipe and remove any obstruction.

Transducer Tube Blocked: The tube from the shell to the pressure transducer (Figure 23, page 50) may be blocked. Check the tube and remove lint or other obstructions.

Drain Valve Malfunctioned: The drain valve or drain valve solenoid may have malfunctioned. Electrical troubleshooting is required (see Figure 24, page 50).

Figure 23. Transducer Tube

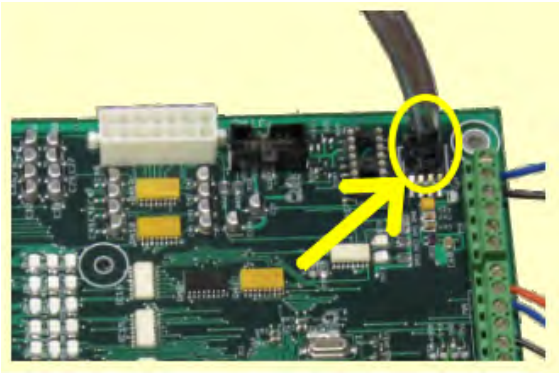
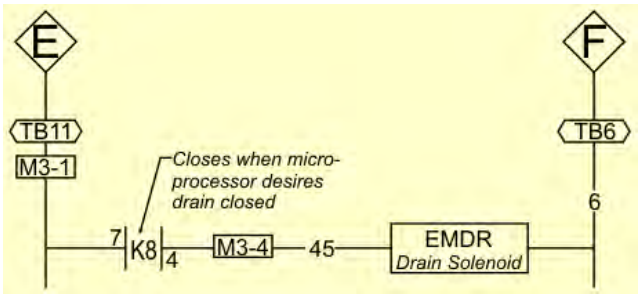


Figure 24. Schematic of Typical Drain Circuit



3-Wire Circuit Disabled — The controller cannot confirm that all 3-wire safeties are satisfied. The controller stops the wash program and turns off all outputs.

Too Long to Steam — The temperature in the machine did not reach the specified temperature within the configured **Steam Error** time. The controller issues an error but the steam valve remains open. If the temperature probe senses that the machine has reached its target temperature, the error clears and the formula resumes.

Low Steam Pressure: Do a check of the steam pressure from the boiler to the machine.

Steam Time Configured too Short: Do a check of the configured steam time in your machine's configuration decisions. This value represents the time required to apply steam to cold water at high level to achieve the hottest temperature used.

Steam Valve Malfunctioned: Use formula intervention to turn the steam valve on to confirm proper operation.

Too Long to Cool — The temperature in the machine did not drop to the specified temperature within the configured **Cooldown Error** time. The controller issues an error but continues to perform the cooldown. If the temperature probe senses that the machine has dropped to its target temperature, the error clears and the formula resumes.

Cooldown Time Configured too Short: Do a check of the configured cooldown time in your machine's configuration decisions. It may be necessary to increase the cooldown error time.

Low Water Pressure: Do a check of the cold water pressure and volume to the machine.

Cooldown Valve Malfunctioned: Do a check of the cooldown valve for proper operation.

Temperature Circuit Malfunctioned: Do a check of the temperature probe and the analog-to-digital board for proper operation.

Check Temperature Probe — The temperature probe detected a temperature below 32° F (0° C) or above 230°F (110°C). The controller turns off all outputs, cancels the wash formula, and returns to the **Home** display.

The Probe is Disconnected: Electrical troubleshooting is required. Check for an open circuit.

The Probe Malfunctioned: If the probe connections are found good, disconnect the probe and measure the resistance between the leads. The resistance between the leads should be between 2K and 35K Ohms. The resistance between either lead and the ground should be infinite.

Level Still Made — The water level in the cylinder is at or above the configured low water level at the start of the formula, before the first bath step. The controller issues an error but the drain remains open. If a slow drain caused the error, the error clears when the transducer senses that the water level in the cylinder is less than the configured low water level.

Drain Blocked: Do a check that the drain valve and drain outlet are clear of debris.

Transducer Tube Blocked: The tube from the shell to the pressure transducer may be blocked. Check the tube and remove lint or other obstructions.

Drain Valve Malfunctioned: The drain valve or drain valve solenoid may have malfunctioned. Electrical troubleshooting is required.

Serial Communication Failure — A peripheral board in the control box has lost communication with the processor board. The controller stops cylinder rotation and waits for serial communication to resume. This error dialog box closes when serial communication resumes.

Board Failure: A peripheral board in the control box cannot communicate with the processor board. Electrical troubleshooting is required.

Failed Speed Sensor — The controller cannot verify that the cylinder is turning. If the speed sensor fails at extract speed, the machine cancels the extract sequence and coasts for the default coast time. The default coast time must expire before the door will unlock.

Speed Sensor Failure: The cylinder speed sensor has stopped working. Electrical troubleshooting is required.

Inverter Tripped — The inverter that controls the motor had an error. The controller turns off all outputs, cancels the wash formula, and returns to the **Home** display.

Inverter error: The machine controller cannot tell about the specific error. See the inverter manual for details. The inverter manual was shipped in an electric box on your machine or with the packet of documentation inside the machine cylinder.

External Fault Error — This message is triggered by a device external to the MilTouch™ machine. This error usually originates with the chemical supply system.

Brake Pressure Fault — If the air pressure in the brake system is less than the required pressure 8 seconds after the beginning of the step, the controller stops the wash program and turns off all the outputs. The 8-second timer resets after you correct the error.

Low Air Pressure: The air pressure inside the brake release cylinder is too low. This can be caused by a leaking air cylinder piston cup, leaking/pinched air lines, leaking quick-release air valves, or a faulty pressure switch or pilot air valve.

Bearing Pressure Fault — If the main bearing pressure is less than the required pressure 8 seconds after the beginning of the step, the controller stops the wash program and turns off all the outputs. The 8-second timer resets after you correct the error.

Injecting less than 5 PSI (34.5 kPa): The machine is injecting less than 5 PSI (34.5 kPa) behind the excluder seal to protect the bearings. Do a check of the air supply and the sensor circuit.

Brake Pads Worn — The brake pads used to slow the cylinder after an extract are worn. Replace the pads.

Too Many Recycles — Due to an unbalanced load, the machine has performed the maximum of three extract cycles. The current extract step will be completed at a speed lower than programmed.

Check Balance System/Excursion Switch — The balance system or the excursion switch tripped.

Loading and Discharging Errors — These errors can occur during automated loading and discharge. When these errors occur, it may be necessary to use manual mode to reposition the machine.

Loading Aborted — This error occurs when the loading device or another external device sends a signal to the MilTouch™ machine to abort the loading process.

Discharge Aborted — This error occurs when the discharge device or another external device sends a signal to the MilTouch™ machine to abort the discharging process.

Invalid Formula — The operator programmed the MilTouch™ machine to use a wash formula that does not exist in the Mildata® computer.

Load Eye Blocked — This error indicates that the load chute photoeye is blocked, which suggests there is a jam in the load chute.

Up Lock Not Made — The controller cannot confirm that the chute is in the up and locked position.

Invalid Work Order — The operator entered a work order that does not exist in the Mildata® computer.

Invalid Goods Code — The operator entered a goods code that does not exist in the Mildata® computer.

Invalid Customer Code — The operator entered a customer code that does not exist in the Mildata® computer.

Invalid Employee Code — The operator entered an employee code that does not exist in the Mildata® computer.

Can't Find Data — This error appears only on machines connected to a Mildata® computer. The MilTouch™ machine requested a wash formula that was not found on the Mildata® computer.

Chute Door Not Closed — This error appears only on machines equipped with a separate load chute and door. The machine controller cannot confirm that the load chute door is completely closed.

Bifold Door Not Closed — The machine controller cannot confirm that the bifold door is completely closed (the “Bifold Door Closed” input did not actuate when the machine expected it).

Bifold Door Not Open — The machine controller cannot confirm that the bifold door is fully open for loading (the “Bifold Door Full Open” input did not actuate when the controller expected it).

Can't Find Load Position — The "Load Position" input was not actuated within the required time limit.

Can't Find Wash Position — The “Wash Position” input was not actuated within the required time limit. This error also occurs when the machine attempts to tilt to the discharge position (instead of the wash position) before an extract.

Can't Find Unload Position — The "Rear Full Up" input was not actuated within the required time limit.

Chute Locked Up — Indicates the automatic loading chute is locked in the up position.

Chute Locked Down — Indicates the automatic loading chute is locked in the down position.

Load Eye Not Blocked — Goods did not block the load chute photoeye when the machine controller expected a load.

Door Opened — Indicates the chute is not completely against the machine and sealed.

4.3.2 Error Correction

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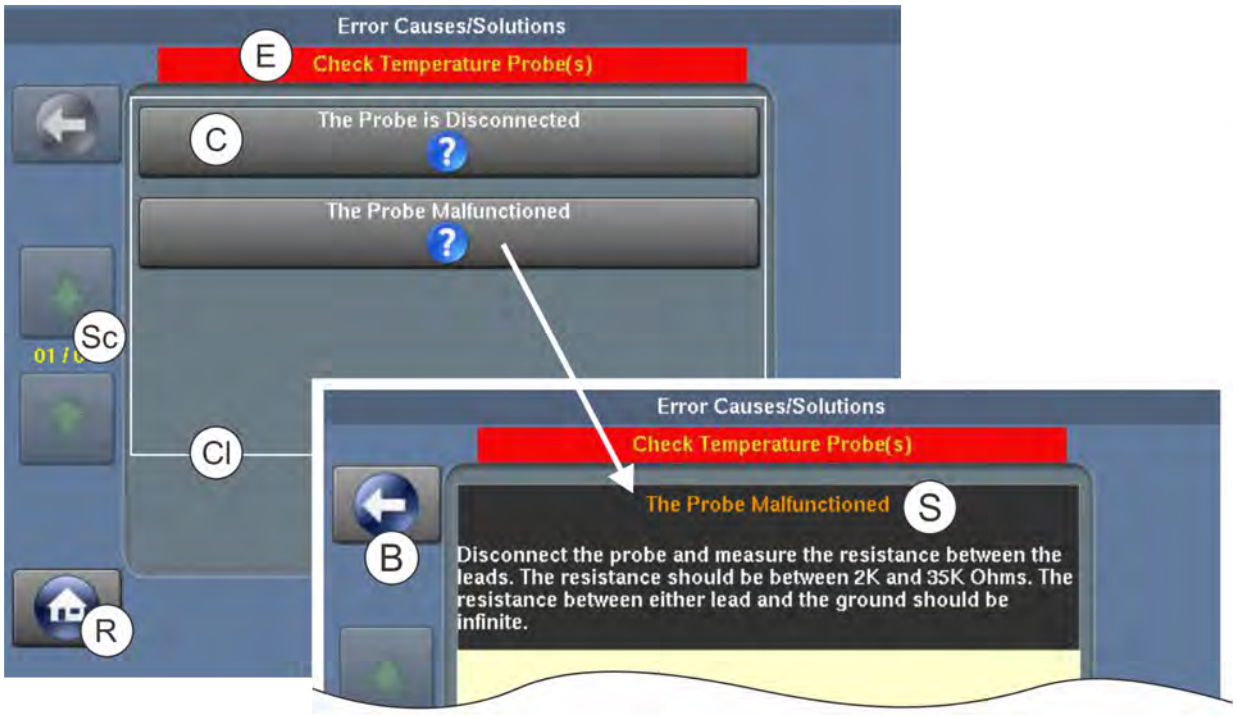
Touch  (in the error code dialog box, Figure 22: Sample Error Code Dialog Box, page 49) to view the **Error Causes/Solutions** display (shown in the following figure).

The **Error Causes/Solutions** display gives a list of possible causes for the error. Touch one of the error causes in the list for an explanation of how to correct it.

Some errors do not have additional details on how to solve them.

Figure 25. Error Causes/Solutions Display



Legend

B. . . Return to the list of possible error causes
Cl. . . A list of possible error causes
C. . . Touch to view the solution for this cause
E. . . The error description
R. . . Return to the **Run** display
S. . . A possible solution to the error
Sc. . . Scroll pages if there is more than one page.

WARNING: High voltage and/or moving parts — are present inside the machine when troubleshooting.

- Qualified technicians only
- Use care to avoid contact with live or moving parts
- Keep bystanders away.

If your machine encountered an error while it was running a formula:

1. Follow the instructions on the **Error Causes/Solutions** display for how to correct the error.
2. Touch  to return to the **Run** display.
3. In the error code dialog box, touch  to silence the operator signal, close the error code dialog box, and resume the wash formula at the current step. Some error code dialog boxes close automatically when you resolve the error.

If your machine encountered an error while it was receiving or discharging a load:

1. Activate manual mode.
2. Use the functions on the **Manual Override** display to reposition the machine, if necessary.
3. On the **Manual Override** display, use the Load or Discharge function (the fault recovery sequences) to return the machine to automatic operation.

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4.4 Manual Mode

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In manual mode, the operator controls the washer-extractor with the outputs on the **Manual Override** display. Manual mode can be used to re-position the machine after a fault occurs, troubleshoot error conditions, or perform maintenance tasks according to the service and maintenance manual.

The **Manual Override** display, shown in the following figure, appears when you activate manual mode. The **Manual Override** display also appears when an error occurs during automatic operation.

To activate manual mode:

- From the **Home** display, touch  , or touch **Manual Mode** from the selection list shown in Figure 1: The Home Display, page 8 .
- From the Automatic **Loading/Discharging State** windows (see Figure 2: Example Loading State, page 9), touch  .
- From the error code dialog box (if your machine has encountered an error), touch  .

Figure 26. Manual Override Display

Legend

F1–6. . Manual functions. See descriptions in Section 4.4.1 , page 57 (tilt function selected)

A. . . Switch to automatic operation

B. . . Up direction button (selected), used with F1–6 and the **Hydraulic Pump Enabled** button on the control panel to perform manual functions.

C. . . Down direction button, used with F1–6 and the **Hydraulic Pump Enabled** button to perform manual functions.

Hydraulic Pump Enabled button

4.4.1 Manual Functions

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To use a function:

1. Touch a function button (F1–6) to select it. The light on the button illuminates to indicate it is actuated, as illustrated by F2 in the previous figure. The **Hydraulic Pump Enabled** button on the controller, when held, will operate the selected function.
2. Touch  or  , depending on the action you want to perform. The button illuminates to indicate it is actuated. The actions vary by function.
3. Press or hold the **Hydraulic Pump Enabled** button, as indicated for each function. The selected function occurs (Ex. The bifold door opens).

NOTE: The MilTouch™ controller prevents the activation of a manual control when its activation would be inappropriate.

Bifold Door (F1) — This function opens or closes the bifold door. The chute must be down. Hold the **Hydraulic Pump Enabled** button to operate the door.

Opens the bifold door. The door is fully open when the “Bifold Door Full Open” input is actuated.

Closes the bifold door. The door is fully closed when the “Bifold Door Closed” input is actuated.

Tilt (F2) — This function tilts the rear up or down. Hold the **Hydraulic Pump Enabled** button to tilt the machine.

Raises the machine rear. The “Rear Full Up” input actuates when the rear is fully raised (when the machine is in the discharge position).

Lowers the machine rear. The “Load Position” input actuates when the rear is fully down (when the machine is in the load position).

Chute (F3) — This function moves the loading chute up or down. The bifold door must be closed. Hold the **Hydraulic Pump Enabled** button to move the chute.

Raises the load chute. The “Chute Up Left Lock” and “Chute Up Right Lock” inputs actuate when the chute is fully raised and locked into the up position.

Lowers the load chute. The “Chute Down Left Lock” and “Chute Down Right Lock” inputs actuate when the chute is fully lowered and locked into the down position.

Load (F4) — This function allows the machine to recover from faults that occur during loading. The machine must be in the load position: rear down, bifold door open, and chute down. Push the **Hydraulic Pump Enabled** button to start/stop the sequence.

Starts the loading recovery sequence, described in Section 4.5.1 : The Loading Recovery Sequence, page 59.

Stops the loading recovery sequence.

Discharge (F5) — This function allows the machine to recover from faults that occur during discharge. The machine must be in the discharge position: rear up, bifold door closed, chute up and locked. Push the **Hydraulic Pump Enabled** button to start/stop the sequence.

Starts the discharging recovery sequence, described in Section 4.5.2 : The Discharging Recovery Sequence, page 60.

Stops the discharging recovery sequence.

Formula (F6) — Touch the **Formula** button to exit the **Manual Override** window and return to the **Home** display. The bifold door must be closed, and the chute must be down.

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4.5 Fault Recovery

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If the machine lost power or an error occurred while the machine was receiving a load, running a formula, or discharging a load, follow these instructions to return the machine to automatic operation after you resolve the error.

4.5.1 The Loading Recovery Sequence

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If the machine lost power or an error occurred while the machine was receiving goods, follow these steps.

1. On the **Manual Override** display, touch **Load** (F4).

   NOTE: The machine must be in the load position (rear down, bifold door open, and chute down) to use this function.

2. Touch  . The loading sequence will start when you push the **Hydraulic Pump Enabled** button.
3. Push the **Hydraulic Pump Enabled** button to start the loading sequence.
   a. The cold water valve opens.
   b. The cylinder turns at drain speed.
   c. The water valve closes when the water level reaches the level entered in the **Wet-Down** configuration decision.
4. Load the machine.
5. When the machine is fully loaded, touch  . The loading sequence will end when you push the **Hydraulic Pump Enabled** button.
6. Push the **Hydraulic Pump Enabled** button to end the loading sequence.
   a. The water valves close.
   b. Cylinder rotation stops after the time entered in the **End Time** configuration decision expires.
   c. The sewer remains closed.
7. Use the **Bifold Door** function (F1) to close the bifold door.
8. Continue to Section 4.5.3 , page 60.

4.5.2 The Discharging Recovery Sequence

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If the machine lost power or an error occurred while the machine was discharging goods, follow these steps.

1. On the **Manual Override** display, touch **Discharge** (F5).

   NOTE: The machine must be in the discharge position (rear up, bifold door closed, and chute up and locked) to use this function.

2. Touch  . The discharging sequence will start when you push the **Hydraulic Pump Enabled** button.
3. Push the **Hydraulic Pump Enabled** button to start the discharging sequence.

   The cylinder turns in both directions and stops between rotations, as configured in the **Clockwise Discharge**, **Counter-clockwise Discharge**, and **Dwell Discharge** WTB configuration decisions.
4. Unload the machine.
5. When the machine has fully discharged its load, touch  . The discharging sequence will end when you push the **Hydraulic Pump Enabled** button.
6. Push the **Hydraulic Pump Enabled** button to end the discharging sequence.

   Cylinder rotation stops after the time entered in the **End Time** WTB configuration decision expires.
7. Continue to Section 4.5.3 , page 60.

4.5.3 To Return the Machine to Automatic Operation

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After you have resolved the error and fully loaded the machine, or fully discharged the load, follow these steps to return the machine to automatic operation.

1. From the **Manual Override** display, touch  to activate automatic mode.

   The machine moves to the default position.
2. The **Recovery** display (shown in the following figure) appears. The controller prompts, "Is there a load in the machine?" Touch the yes/no button (item A in the following figure) so that it displays  **YES**.

Figure 27. The Recovery Display

Legend

A . . . Toggle between "yes" and "no" to answer the prompt, "Is there a load in the machine?"

B . . . Toggle between "loading" and "discharging" to answer the prompt, "Was the machine loading or discharging when automatic operation was interrupted?"

C . . . The batch data for the goods in the machine (see Section 4.5.3.1 , page 61).

D . . . Start automatic operation based on the batch data and your answers to the prompts.

3. Enter the batch data for the goods in the machine. See Section 4.5.3.1 , page 61.
4. Choose whether the machine was loading or discharging when automatic operation was interrupted.
   - Touch the loading/discharging button (item B in the figure) so that it displays **Loading** if an error occurred or the machine lost power while it was receiving goods.
   - Touch the loading/discharging button (item B in the figure) so that it displays **Discharging** if an error occurred or the machine lost power while it was discharging goods.
5. Touch  to start automatic operation.

4.5.3.1 Batch Data

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As goods are transferred between devices in a laundry (loading device, washer-extractor, discharge device, press, etc.), each device passes batch data and post-wash codes for those goods to the other devices. Batch data and post-wash codes are passed either through the Miltrac™ controller system or through allied data inputs and are used for two purposes:

- instructing the washer-extractor and other equipment (such as drying equipment) how to process the goods
- accounting and record-keeping

In automatic operation, the washer-extractor processes goods using the batch data it receives from the loading device. If the washer-extractor lost power or an error occurred while it was processing goods, the operator must re-enter the batch data into the **Recovery** display.

The machine also reports production data to the Mildata® computer as well as error info.

Formula identifies the wash formula used in the tunnel. Goods Code can be used instead.

Work Order identifies the wash formula and other batch data bundled together in a pre-set code. No other batch data is necessary if this code is used.
Goods Code identifies the wash formula based on the goods-type in the tunnel. Formula can be used instead.
Customer identifies the customer (commercial laundry) or department (institutional laundry) the batch belongs to.
Employee identifies the employee who processed the batch. This information can be used to generate a report of which batches or how many batches each employee processed.
Weight the dry, soiled weight of a batch, as measured by a weighing device, such as a weighing type load conveyor.
Pieces the number of pieces in the batch.
Lot identifies an individual batch with a unique number assigned by the user.

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4.6 Formula Intervention

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Formula intervention allows you to manually alter a wash formula in production (while it runs). You can adjust the:

- step timer
- water valves
- drain and reuse valves
- steam and cooldown controls
- cylinder speed
- bath temperature and level

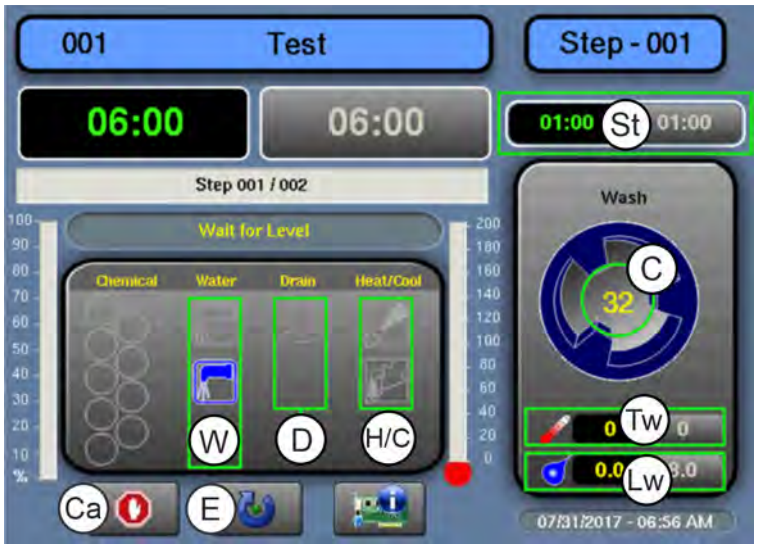
The changes you make while in formula intervention mode do not alter the programming of the formula (the step decisions). Formulas proceed normally in formula intervention mode aside from the changes you make.

Chemical suppliers and service technicians can use formula intervention to test formulas and confirm proper operation of the machine components. For example, a service technician may want to turn the steam valve on to confirm proper operation.

Operators might also use formula intervention if it is necessary to make a temporary, or one-time change to a wash formula. For example, the operator may want to stop the timer to slowly add a chemical through the soap chute.

Touch  on the **Run** display to start formula intervention. Controls in the **Names and Timers** area and the **Machine Status** area of the **Run** display become active so that you can change the formula in progress. Green boxes on the display identify the formula control areas, or the settings that can be changed, as shown in Figure 28, page 63.

Figure 28. Formula Control Areas



Legend

C.	Cylinder speed controls
Ca.	Cancel the formula
D.	Drain and reuse controls
E.	End formula intervention
H/C.	Heat and cool (steam and cooldown) controls
Lw.	Bath level controls
St.	Step timer controls
Tw.	Bath temperature controls
W.	Water valve controls

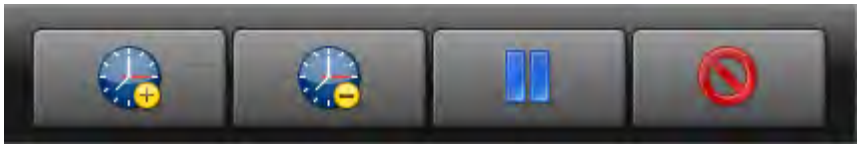
NOTE: A password may be required to use formula intervention.

In formula intervention mode, touch a box to display the pop-up controls for that setting. The pop-up controls available correspond with your machine's equipment and your configuration decisions.

NOTICE: The MilTouch™ controller prevents the activation of certain controls when their activation would be inappropriate. For example, the controls for the water valves are not available when the bath water is at its maximum level.

Modify Step Timer — Touch the box identified by item St on Figure 28, page 63.

Figure 29. Pop-up Controls for Step Timer



 Add 1 minute to the remaining step time.

 Subtract 1 minute from the remaining step time. If there is less than 1 minute remaining on the step timer, the timer is reduced to 00:00 and the controller moves on to the next phase in the current step, or the next step if there are no more phases.


Pause the current step timer. The formula will remain on the current step, which prevents formula resumption, until this button is touched again.


NOTE: Outputs that the controller actuates during a step remain actuated even when the step timer is paused (unless the actuation of the output is inappropriate). For example, if the cylinder is turning when you touch  , the cylinder will continue to turn even while the step timer is paused.


Close the window.

Modify Water Valves — Touch the box labeled “Water” on the display.

Figure 30. Pop-up Controls for Water Valves


Open the hot water inlet valve. If the hot water inlet valve is open, touch to close it.


Open the cold water inlet valve. If the cold water inlet valve is open, touch to close it.


Open the 3rd water inlet valve. If the 3rd water inlet valve is open, touch to close it.


Close the window.

Modify Drain Valves — Touch the box labelled “Drain” on the display.

Figure 31. Pop-up Controls for Drain Valves

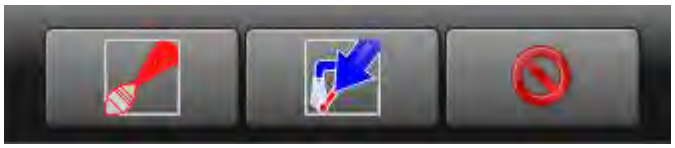

Open the drain valve to the sewer. If the drain valve to the sewer is open, touch to close it.


Open a secondary drain valve to a reuse tank. If the secondary drain valve is open, touch to close it.


Close the window.

Modify Steam and Cooldown — Touch the box labelled “Heat/Cool” on the display.

Figure 32. Pop-up Controls for Steam and Cooldown Valves



 Inject steam to raise or maintain the bath temperature. If the steam inlet valve is open, touch to close it.

 Inject cool water to gradually lower the bath temperature (perform a cooldown). If the cooldown inlet valve is open, touch to close it.

 Close the window.

Modify Cylinder Speed — Touch the box identified by item C on Figure 28, page 63.

Figure 33. Pop-up Controls for Cylinder Speed

 Increase the rotation speed of the cylinder by 1 RPM.

 Decrease the rotation speed of the cylinder by 1 RPM.

 Close the window.

Modify Water Temperature — Touch the box identified by item Tw on Figure 28, page 63.

Figure 34. Pop-up Controls for Water Temperature

 Increase the desired bath temperature by 1 degree (Celsius or Fahrenheit).

 Decrease the desired bath water temperature by 1 degree (Celsius or Fahrenheit).

Close the window.

Modify Water Level — Touch the box identified by item Lw on Figure 28, page 63.

Figure 35. Pop-up Controls for Water Level

Increase the desired bath water level by 1 unit (centimeters or inches).

Decrease the desired bath water level by 1 unit (centimeters or inches).

Close the window.

When you are finished making changes to the wash formula, touch to end formula intervention.

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4.7 Troubleshooting Inputs and Outputs

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WARNING: **High voltage —** Is present in electric boxes even when power switches on the machine are off.

- Qualified technicians only.
- Lockout power at the external disconnect box before you make repairs.

If your machine displays an error message or exhibits any abnormal behavior, this document, along with the diagnostic tools on the machine, can help you resolve the problem.

The diagnostic tools include the **Diagnostics** display, on which you select from three types of information, and the status lights on the input/output (I/O) board.

4.7.1 The Diagnostics Display and Available Views

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The **Diagnostics** display allows technicians to monitor inputs and outputs from the MilTouch™ controller.

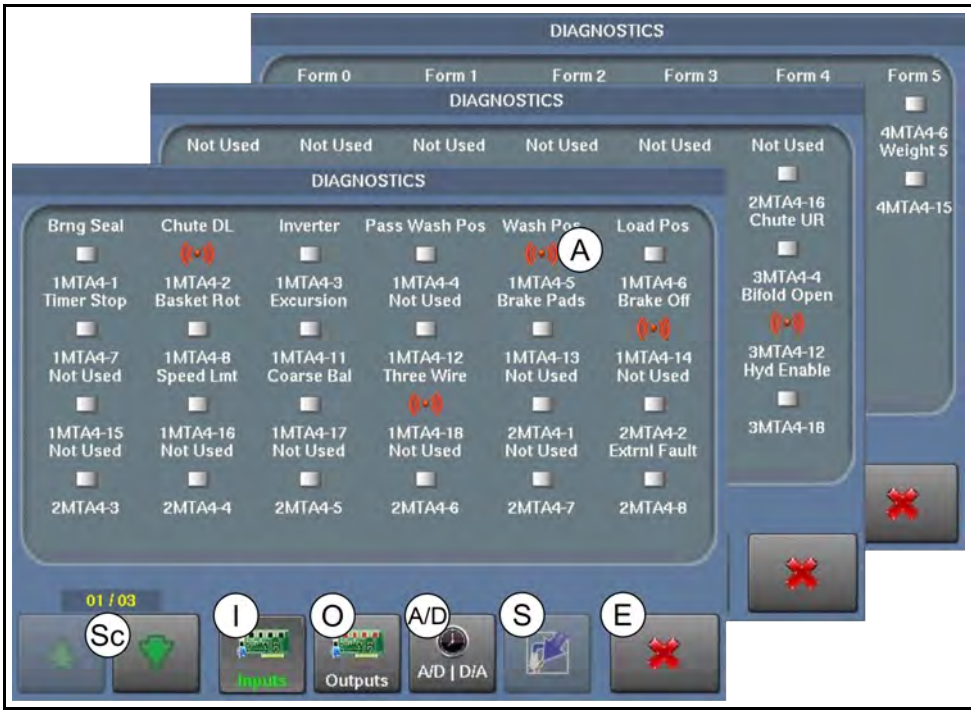
You can select any of three views on the **Diagnostics** display:

- **Inputs**—view the status of digital inputs in real time (the default view)
- **Outputs**—view and actuate digital outputs

- **A/D | D/A** (Analog Channels)—view the status of analog inputs and outputs in real time

Touch  on the **Home** display to access the **Diagnostics** display. This display defaults to digital inputs. Buttons at the bottom of the display provide access to the other views, as shown in the following figure.

Figure 36. The Diagnostics Display with Inputs (the default view) Selected



Legend

- **A . . .** Example of an actuated input
- **A/D .** View analog inputs and outputs
- **E . . .** Exit (return to the **Home** display)
- **I . . .** View the digital inputs (pictured)
- **O . . .** View the digital outputs
- **S . . .** Spraydown, currently unavailable on WTB machines
- **Sc . .** Scroll between pages to see more inputs

4.7.1.1 Digital Inputs

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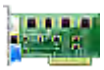
If you previously selected a different view, touch  **Inputs** to view the digital inputs (Figure 36, page 67) in real time. For example, you can use this display to verify that the door is locked or that the vibration switch has not tripped.

4.7.1.2 Digital Outputs

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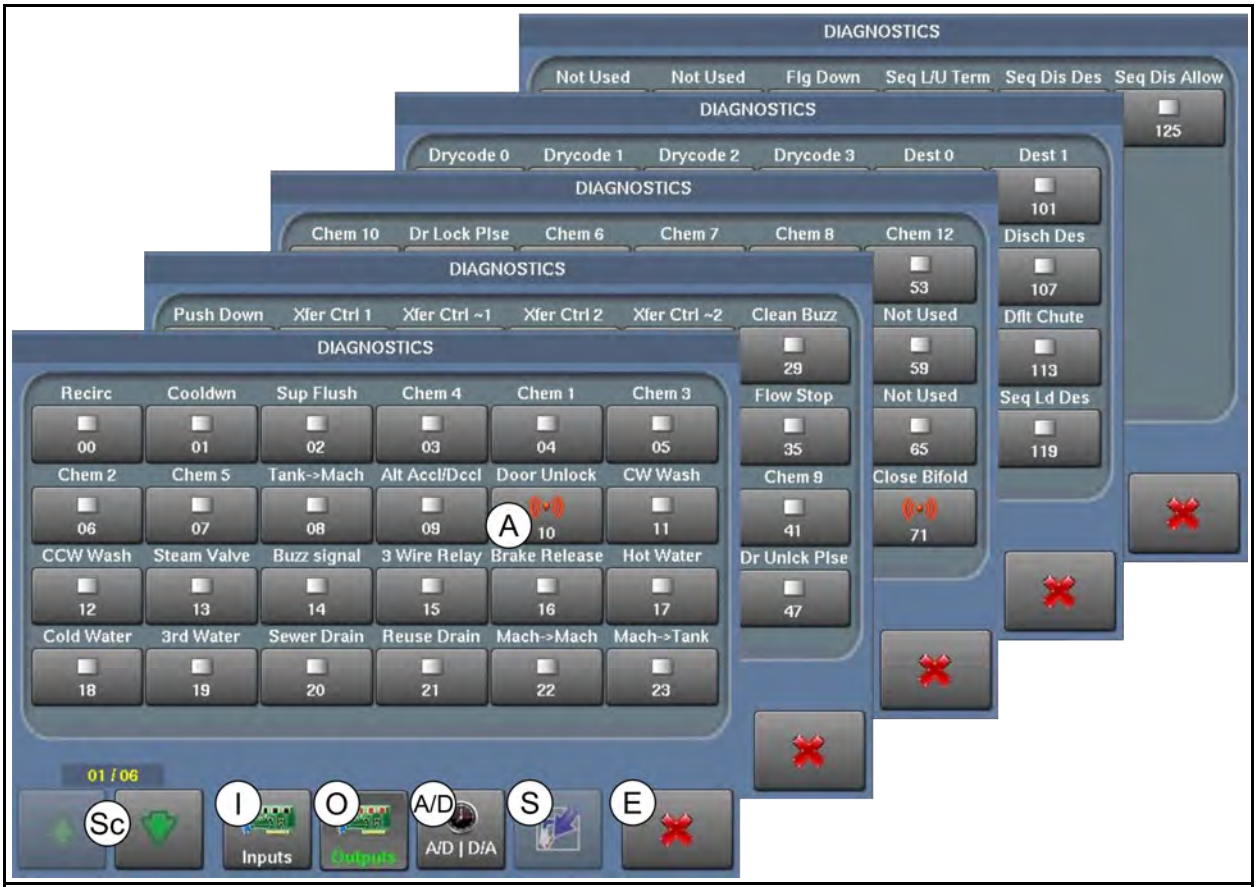
Figure 37. The Outputs Display



Legend

A . . . Example of an actuated output
A/D . View analog inputs and outputs
E . . . Exit (return to the **Home** display)
I . . . View the digital inputs
O . . . View the digital outputs (pictured)
S . . . Spraydown, currently unavailable on WTB machines
Sc . . Scroll between pages to see more outputs

There are two ways to use digital outputs:

- When a formula is in progress, view the status of outputs in real time.
- When the machine is idle, manually actuate outputs to test them.

Touch  **Outputs** to view the digital outputs on the **Diagnostics** display (Figure 37, page 68).

4.7.1.3 Digital Outputs— Machine Idle

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When the machine is idle, you can actuate outputs to verify that the machine responds correctly.

Touch an output button to actuate the output. The actuated output displays  . Touch the button again to turn the output OFF. All outputs turn OFF when you exit the **Diagnostics** display with  and return to the **Home** display.

4.7.1.4 Digital Outputs— Formula in Progress

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Diagnostic control of outputs is disabled while the machine runs a formula. However, when a formula is in progress, you can monitor the outputs to observe certain events as they occur in a wash formula cycle. For example, you can monitor when the water valves open and close.

4.7.1.5 Analog Channels (A/D inputs and D/A outputs)

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Touch  to view analog inputs and outputs (shown in the following figure) to monitor the bath temperature and level, the board voltage, and other conditions.

Figure 38. The Analog-Digital Values Display

Legend

A . . . The actual (current) value for the output for the input
A/D . View analog inputs and outputs (pictured)
C . . . (A/D) The digital counts value from the A/D converter used by the microprocessor to calculate the actual/desired units; (D/A) The digital counts value sent from the microprocessor to the D/A converter that allows the proper voltage to be sent to the inverter for motor control
Ch . . The input/output circuit board and the input's connection on that board
D . . . The desired value for the input
Ex . . Exit (return to the **Home** display)
I . . . View the digital inputs
O . . . View the digital outputs
S . . . Spraydown, currently unavailable on WTB machines
Sc . . Scroll between pages, if a view has more than one page
U . . . The units that quantify the values given in the "Actual" (A) and "Desired" (D) columns

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4.8 The MilTouch-EX™ WTB Input/Output Boards

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The input/output boards are typically located in the machine's low-voltage control cabinet. Every MilTouch-EX™ WTB machine can have a maximum of four 8-output 16-input boards and four 24-output boards. The machine will have whatever combination of boards is needed to handle all digital outputs and inputs. Tags inside the cabinet door identify each board and the circuit functions assigned to the numbered outputs and inputs (numbers printed next to the LEDs) on each

board. The machine pictured in the following figure uses three 8-output 16-input boards and two 24-output boards.

Figure 39. I/O Boards on a MilTouch-EX™ Machine

When an input is actuated, the LED for that input illuminates green. When an output is actuated, the LED for that output illuminates red. You can use the LEDs on the I/O boards to confirm that an input signal from a component on the machine reaches the board or that an input is not seen at the wrong time.

4.8.1 Status Lights on Boards

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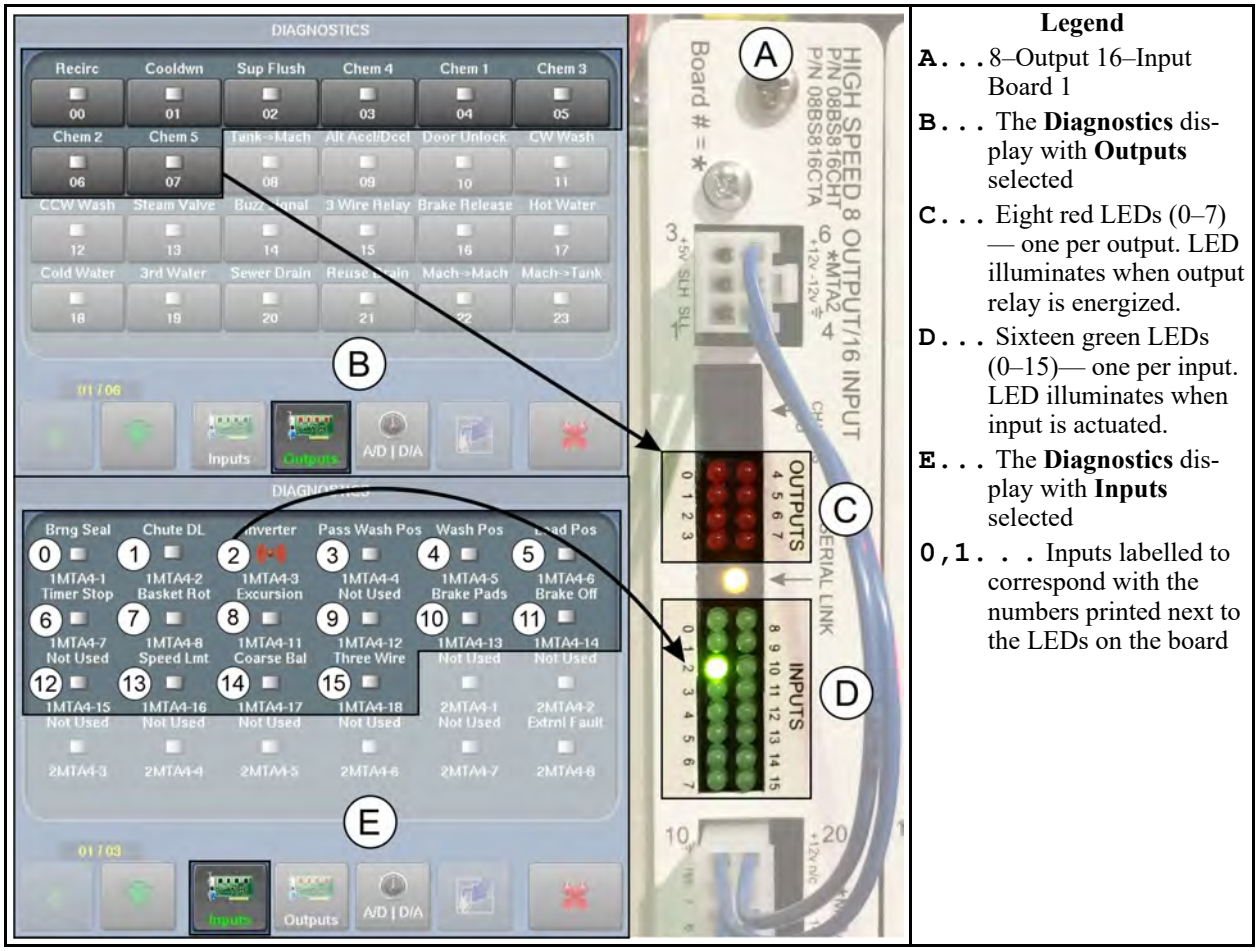
Each status light on the boards has a corresponding indicator on the **Diagnostics** display. When an input or output is actuated, the LED on the I/O board will illuminate, and the  symbol on the corresponding indicator on the **Diagnostics** display will appear, as illustrated by input 2 (1MTA4-3, Inverter Input) in the following figure.

Figure 40. Input/Output Status Lights on the I/O Board and Corresponding Indicators on the Diagnostics Display



Legend

A . . . 8–Output 16–Input Board 1

B . . . The **Diagnostics** display with **Outputs** selected

C . . . Eight red LEDs (0–7) — one per output. LED illuminates when output relay is energized.

D . . . Sixteen green LEDs (0–15)— one per input. LED illuminates when input is actuated.

E . . . The **Diagnostics** display with **Inputs** selected

0,1. . . Inputs labelled to correspond with the numbers printed next to the LEDs on the board

NOTE: In the unlikely event that these indicators do not agree, there is a problem with the controller. Contact Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117.

4.8.2 How to Determine the Position of an Output or Input

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You cannot determine the position of an output or input on an I/O board from its position on the **Diagnostics** display, or the reverse. Use the following information to determine which page/position and board/LED the circuit to be checked corresponds to.

- The tables in Section 4.9 : List of Inputs and Outputs, page 74 are organized by board and list the number (position) of each output and input on the boards and on the **Diagnostics** displays.
- The location of each board in the card cage is shown on a tag inside the electric box door (tag also shown in schematic manual).
- Circuit logic, connector and pin numbers, wire numbers, etc. are provided in the schematic manual.

The following information may also be useful to determine the position of an output or input on an I/O board from its label on the **Diagnostics** display:

- The digital inputs are labelled 0–63.
  - Digital inputs 0–15 correspond to inputs 0–15 on 8/16 Board 1
  - Digital inputs 16–31 correspond to inputs 0–15 on 8/16 Board 2
  - Digital inputs 32–47 correspond to inputs 0–15 on 8/16 Board 3 (WTB only)
  - Digital inputs 48–63 correspond to inputs 0–15 on 8/16 Board 4 (WTB only)
- The digital outputs are labelled 0–127.
  - Digital outputs 0–7 correspond to outputs 0–7 on 8/16 Board 1
  - Digital outputs 8–31 correspond to outputs 0–23 on 24 Output Board 1
  - Digital outputs 32–39 correspond to outputs 0–7 on 8/16 Board 2
  - Digital outputs 40–63 correspond to outputs 0–23 on 24 Output Board 2
  - Digital outputs 64–71 correspond to outputs 0–7 on 8/16 Board 3 (WTB only)
  - Digital outputs 72–95 correspond to outputs 0–23 on 24 Output Board 3 (WTB only, currently unused)
  - Digital outputs 96–103 correspond to outputs 0–7 on 8/16 Board 4 (WTB only)
  - Digital outputs 104–127 correspond to outputs 0–23 on 24 Output Board 4 (WTB only)

4.8.3 About the Yellow Light and Serial Communication

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Each board has a yellow serial link light, as shown in Figure 41, page 73.

Figure 41. Serial Link Light

This light tells much about the status of serial communication and the related hardware. Consider three possible conditions:

1. the light blinks
2. the light remains off
3. the light is steady on

blinks serial data is passing between this board and its central processor. This board is functional. However, this condition says nothing about the quality of the serial data. It does not ensure that the data is uncorrupted by, for example, electromagnetic interference (EMI).

steady off the board has lost serial communication with the processor. If the machine contains at least two boards of this type, make a note of the board addresses, as set on the rotary switches on the boards. Then swap the boards and give each board the address of the board it replaces. If the light that was not blinking is still not blinking (if the problem moved with the board), the board is dysfunctional. If the light on the board that now occupies the problem position is not blinking, it is likely that there is an open in the serial link wiring.

steady on this board is dysfunctional and the board is interfering with serial communication throughout the serial link. Replace the board.

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4.9 List of Inputs and Outputs

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4.9.1 Inputs

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Table 3. Inputs on 8-output 16-input Board #1

Input # (Board)	Input # (Display)	Connection on Board	Function	Description
0	0	1MTA4-1	Bearing Seal Deflated	On machines with a positive pressure (pressure greater than that of the atmosphere) in the bearing housing, this circuit closes when the pressure drops.
1	1	1MTA4-2	Chute Down Left Lock	This circuit closes when the lower-left chute lock actuates (one of two inputs actuated when the chute is in the down and locked position). The chute must be fully down for loading.
2	2	1MTA4-3	Inverter Input	This circuit opens when the inverter is enabled and closes if an inverter fault occurs.
3	3	1MTA4-4	Passed Wash Position	This circuit closes when the machine attempts to tilt to the discharge position before an extract, which triggers the “Can’t Find Wash Position” error (see Can't Find Wash Position).
4	4	1MTA4-5	Wash Position	On machines that tilt, this circuit closes when the machine is in the wash position.
5	5	1MTA4-6	Load Position	On machines that tilt, this circuit closes when the machine is in the load position.
6	6	1MTA4-7	Do Not Allow Chemicals (ChemSaver); Timer Stop	If the input is grounded and the machine still has chemicals to inject for the step, this input is “Do Not Allow Chemicals.” If all chemicals have been delivered or no chemicals are programmed, this input is “Timer Stop.” Note: Once a chemical signal starts it will not stop.

Table 3 Inputs on 8-output 16-input Board #1 (cont'd.)

Input # (Board)	Input # (Display)	Connection on Board	Function	Description
7	7	1MTA4-8	Basket (Cylinder) Rotating	This circuit closes when the machine cylinder is turning.
8	8	1MTA4-11	Excursion	This normally closed circuit opens when the excursion switch actuates due to imbalance during high-speed extraction.
9	9	1MTA4-12	Can’t Close Bifold	The loading device sends this signal to the machine to indicate it is not safe to close the bifold door.
10	10	1MTA4-13	Brake Pads Worn	On machines with a mechanical brake, this circuit closes to signify that the brake pads need to be changed.
11	11	1MTA4-14	Brake is Off	On machines that have a brake, this circuit closes when the brake is released. This occurs when the cylinder can turn safely.
12	12	1MTA4-15	Door Open Desired	This circuit closes when the operator presses the door open button.
13	13	1MTA4-16	Speed Limit Desired	On older machines with the “Exact Extract” option, this circuit closes when the machine is out-of-balance. When this system opens the circuit, the extract step resumes at the speed the cylinder was turning when the circuit closed.
14	14	1MTA4-17	Coarse Balance	On balancing machines, this circuit closes when the machine is out of balance after low extract, which causes a recycle.
15	15	1MTA4-18	Three Wire	This circuit closes when all 3-wire safeties are satisfied and the circuit is engaged.

Table 4. Inputs on 8-output 16-input Board #2

Input # (Board)	Input # (Display)	Connection on Board	Function	Description
0	16	2MTA4-1	not used	—
1	17	2MTA4-2	not used	—
2	18	2MTA4-3	not used	—
3	19	2MTA4-4	not used	—
4	20	2MTA4-5	Transfer Control back to Soil Side	On Staph Guard® machines, this circuit closes after you unload from the clean side to transfer control back to the soil side for loading.
5	21	2MTA4-6	Tank is Full	This circuit closes when the optional overhead tank is full.
6	22	2MTA4-7	not used	—
7	23	2MTA4-8	External Fault	This normally open circuit is closed by an external device, such as a chemical system, to indicate that device had a fault.
8	24	2MTA4-11	not used	—
9	25	2MTA4-12	OK to Steam Tank	On machines with an overhead tank and steam option, this circuit closes when the controller is heating the tank water.
10	26	2MTA4-13	Recirc Pump Overload	not used
11	27	2MTA4-14	Tank Pump Overload	not used
12	28	2MTA4-15	Signal Cancel	not used
13	29	2MTA4-16	Fresh Meter	not used
14	30	2MTA4-17	not used	—
15	31	2MTA4-18	not used	—

Table 5. Inputs on 8-output 16-input Board #3 (WTB+ only)

Input # (Board)	Input # (Display)	Connection on Board	Function	Description
0	32	3MTA4-1	Chute Up Left Lock	This circuit closes when the upper-left chute lock actuates (one of two inputs actuated when the chute is in the up and locked position). The chute must be fully raised for discharging.
1	33	3MTA4-2	OoBD Enabled	This normally-closed circuit must be grounded to allow Out-of-balance Detection (see Section 6.1 : Out-of-balance

Table 5 Inputs on 8-output 16-input Board #3 (WTB+ only) (cont'd.)

Input # (Board)	Input # (Display)	Connection on Board	Function	Description
				Detection and Balancing for Washer-extractors, page 109). **CAUTION:** Allowing the machine to extract without OoBD enabled can cause machine damage.
2	34	3MTA4-3	Bifold Door Closed	This circuit closes when the bi-fold door is closed.
3	35	3MTA4-4	Chute Up Right Lock	This circuit closes when the upper-right chute lock actuates (one of two inputs actuated when the chute is in the up and locked position). The chute must be fully raised for discharging.
4	36	3MTA4-5	Discharge Allowed	This normally-closed circuit must be grounded to allow automatic discharging.
5	37	3MTA4-6	Load Allowed	This normally-closed circuit must be grounded to allow automatic loading.
6	38	3MTA4-7	Load Abort	The loading device can send this signal to the machine to abort the loading process, which triggers the “Loading Aborted” error (see Loading and Discharging Errors).
7	39	3MTA4-8	Chute Eye Blocked	This circuit closes when the load chute photoeye is blocked, which indicates the chute is receiving goods. This circuit remains closed if a jam blocks the load chute eye, which triggers the “Load Eye Blocked” error (see Load Eye Blocked).
8	40	3MTA4-11	Chute Down Right Lock	This circuit closes when the lower-right chute lock actuates (one of two inputs actuated when the chute is in the down and locked position). The chute must be fully down for loading.

Table 5 Inputs on 8-output 16-input Board #3 (WTB+ only) (cont'd.)

Input # (Board)	Input # (Display)	Connection on Board	Function	Description
9	41	3MTA4-12	Bifold Door Full Open	This circuit closes when the bi-fold door is open to receive a load.
10	42	3MTA4-13	Allied Start Loading	The allied (non-Miltrac™) loading device sends this signal to the machine to initialize the loading sequence. Also known as “Start Receiving.”
11	43	3MTA4-14	Rear Full Up	This circuit closes when the machine is in the discharge (rear fully-raised) position.
12	44	3MTA4-15	Allied Discharge Terminate	This circuit closes when the machine finishes discharging its load, and the allied (non-Miltrac™) discharge device signals to the machine that it has successfully received the load.
13	45	3MTA4-16	Allied Load Terminate	This circuit closes when the machine finishes receiving a load, and the allied (non-Miltrac™) loading device signals to the machine that it has successfully transferred its load.
14	46	3MTA4-17	Allied Start Discharge	This circuit closes when the machine is ready to discharge its load, and the allied (non-Miltrac™) discharge device signals to the machine that it can receive the load.
15	47	3MTA4-18	Hydraulic Enable	This circuit closes when you press the **Hydraulic Pump Enabled** button on the control panel (see Figure 26: Manual Override Display, page 57), which allows the operator to perform manual functions.

Table 6. Inputs on 8-output 16-input Board #4 (WTB+ only)

Input # (Board)	Input # (Display)	Connection on Board	Function	Description
0	48	4MTA4-1	Formula Bit 0	Formula bits received from an adjacent allied (non-Miltrac™) machine for the load entering the washer.
1	49	4MTA4-2	Formula Bit 1	
2	50	4MTA4-3	Formula Bit 2	
3	51	4MTA4-4	Formula Bit 3	
4	52	4MTA4-5	Formula Bit 4	
5	53	4MTA4-6	Formula Bit 5	
6	54	4MTA4-7	Allied Weight Bit 0	Allied weight bits received from an adjacent allied (non-Miltrac™) machine for the load entering the washer.
7	55	4MTA4-8	Allied Weight Bit 1	
8	56	4MTA4-11	Allied Weight Bit 2	
9	57	4MTA4-12	Allied Weight Bit 3	
10	58	4MTA4-13	Allied Weight Bit 4	
11	59	4MTA4-14	Allied Weight Bit 5	
12	60	4MTA4-15	Allied Weight Bit 6	
13	61	4MTA4-16	Allied Weight Bit 7	
14	62	4MTA4-17	not used	—
15	63	4MTA4-18	not used	—

4.9.2 Outputs

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Table 7. Outputs on 8-output 16-input Boards #1 and #2

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
8/16 Board 1				
0	0	1MTA5-10 & 5-19	Recirculation Pump	On machines with the optional recirculation feature, actuate to flow bath water through the door.
1	1	1MTA5-9 & 5-18	Cooldown	Actuate to open the optional cooldown valve.
2	2	1MTA5-8 & 5-17	Flush	Actuate to open the flush valve for chemicals.
3	3	1MTA5-7 & 5-16	Chemical 4	Actuate to inject chemical 4, usually softener.
4	4	1MTA5-4 & 5-14	Chemical 1	Actuate to inject chemical 1, usually alkali or detergent
5	5	1MTA5-3 & 5-13	Chemical 3	Actuate to inject chemical 3, usually bleach for 36-inch or larger models; sour for other models.

Table 7 Outputs on 8-output 16-input Boards #1 and #2 (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
6	6	1MTA5-2 & 5-12	Chemical 2	Actuate to inject chemical 2, usually detergent or bleach
7	7	1MTA5-1 & 5-11	Chemical 5	Actuate to inject chemical 5, usually starch; also used to signal that a chemical delivery system desires to inject chemical.
8/16 Board 2				
0	32	2MTA5-10 & 5-19	Fresh to Machine	Actuate to fill the machine from the fresh water inlets.
1	33	2MTA5-9 & 5-18	Tank to Sewer	Actuate to drain bath water from the overhead tank to the sewer.
2	34	2MTA5-8 & 5-17	Fresh to Tank	Actuate to fill the overhead tank from the fresh water inlets.
3	35	2MTA5-7 & 5-16	Brake Safety	The controller automatically actuates this output on boot up to protect the inverter from power failure.
4	36	2MTA5-4 & 5-14	Door Lock	Actuate to lock the door.
5	37	2MTA5-3 & 5-13	Steam in Tank	On machines with the overhead tank option and tank-steam, actuate to heat the tank water.
6	38	2MTA5-2 & 5-12	Speed Limited; Balance	On 72046M5K models, this output enables the balancing system. On non-72046M5K MilTouch-EX™ models with OoB detection, this output limits the extract speed based on the amount of imbalance.
7	39	2MTA5-1 & 5-11	3-wire Pulse	Simulates a start button to engage 3-wire ciruit.

Table 8. Outputs on 24-Output Board #1

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
0	8	1MTA13-1 & 13-11	Tank to Machine	Actuate to fill the machine from the overhead tank.
1	9	1MTA13-2 & 13-12	Alt. Accel/Decel	Used to change the accel/decal rate of the cylinder motor during extract and coast down.

Table 8 Outputs on 24-Output Board #1 (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
2	10	1MTA13-3 & 13-13	Door Unlock	Actuate to unlock the door.
3	11	1MTA13-4 & 13-14	Clockwise	Actuate to rotate the cylinder clockwise at wash, drain, or extract speed.
4	12	1MTA13-5 & 13-15	C-clockwise Wash	Actuate to rotate the cylinder counterclockwise at wash speed.
5	13	1MTA13-6 & 13-16	Steam Valve	Actuate to open the steam valve.
6	14	1MTA13-7 & 13-17	Operator Signal	Actuate to sound the operator signal.
7	15	1MTA13-8 & 13-18	3-wire Relay	Actuate to enable the 3-wire circuit. Must also pulse the 3-wire pulse output to complete circuit.
8	16	1MTA13-9 & 13-19	Brake Release	On machines equipped with a mechanical brake, actuate this output to release the brake during the wash cycle.
9	17	1MTA13-10 & 14-1	Hot Water	Actuate to open the hot water inlet valve.
10	18	1MTA14-11 & 14-2	Cold Water	Actuate to open the cold water inlet valve.
11	19	1MTA14-12 & 14-3	Third Water	Actuate to open the optional third water inlet valve.
12	20	1MTA14-4 & 14-13	Drain Solenoid	Actuate to open the drain valve to the sewer.
13	21	1MTA14-4 & 14-14	Reuse Drain	Actuate to open the optional reuse drain valve.
14	22	1MTA14-10 & 14-5	Machine to Machine	Actuate to recirculate drained bath water back into the machine.
15	23	1MTA14-10 & 14-15	Machine to Tank	Actuate to drain bath water from the machine to the overhead tank.
16	24	1MTA14-10 & 14-6	Push-down	Actuate to secure hydro cushion machines in the wash/drain position.

Table 8 Outputs on 24-Output Board #1 (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
17	25	1MTA14-10 & 14-16	T'fer Control #1	Used to transfer control of Staph Guard® machines.
18	26	1MTA14-10 & 14-7	T'fer Control Not #1	Used to transfer control of Staph Guard® machines.
19	27	1MTA14-10 & 14-17	T'fer Control #2	Used to transfer control of Staph Guard® machines.
20	28	1MTA14-10 & 14-8	T'fer Control Not #2	Used to transfer control of Staph Guard® machines.
21	29	1MTA14-10 & 14-18	Clean Signal	Actuate to sound the operator signal on clean side of Staph Guard® machines.
22	30	1MTA14-10 & 14-9	Wash Clutch	On multi-motor machines, this output engages the wash motor to the cylinder drive.
23	31	1MTA14-10 & 14-19	Spraydown	On divided-cylinder machines, actuate this output to activate spraydown and wet the goods during loading.

Table 9. Outputs on 24-Output Board #2

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
0	40	2MTA13-1 & 13-11	Chemical 14	Actuate to inject chemical 14.
1	41	2MTA13-2 & 13-12	Chemical 9	Actuate to inject chemical 9.
2	42	2MTA13-3 & 13-13	Chemical 13	Actuate to inject chemical 13.
3	43	2MTA13-4 & 13-14	Chemical Flush	Actuate to open the flush valve for chemicals.
4	44	2MTA13-5 & 13-15	Chemical 15	Actuate to inject chemical 15.
5	45	2MTA13-6 & 13-16	Chemical 11	Actuate to inject chemical 11.
6	46	2MTA13-7 & 13-17	ChemSave	Used to interface with chemical dispenser systems to control which machines get chemicals delivered.

Table 9 Outputs on 24-Output Board #2 (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
7	47	2MTA13-8 & 13-18	Door Unlock Pulse; Alt Decel Safety	On 72046M5K models, this output is used for alt. decel safety. On non-72046M5K MilTouch-EX™ models with a pulsing door interlock, this output unlocks the door.
8	48	2MTA13-9 & 13-19	Chemical 10	Actuate to inject chemical 10.
9	49	2MTA13-10 & 14-1	Door Lock Pulse	Actuate to lock the door.
10	50	2MTA14-11 & 14-2	Chemical 6	Actuate to inject chemical 6.
11	51	2MTA14-12 & 14-3	Chemical 7	Actuate to inject chemical 7.
12	52	2MTA14-4 & 14-13	Chemical 8	Actuate to inject chemical 8.
13	53	2MTA14-4 & 14-14	Chemical 12	Actuate to inject chemical 12.
14	54	2MTA14-10 & 14-5	Auto Recirculation	On machines with auto recirculation, the controller automatically actuates this output when the desired water level is satisfied.
15	55	2MTA14-10 & 14-15	Drain Motor	Actuate to run Drain motor on multi-motor machines.
16	56	2MTA14-10 & 14-6	Low Extract Speed	Actuate to run Low Extract motor on multi-motor machines.
17	57	2MTA14-10 & 14-16	High Extract Speed	Actuated to run High Extract motor on multi-motor machines.
18	58	2MTA14-10 & 14-7	MilTrench	Prevents multiple machines from draining at the same time when doing so would overflow the trench.
19	59	2MTA14-10 & 14-17	Move to Load Posi.	On hydraulic tilting machines, actuate to bring the machine to the load position.
20	60	2MTA14-10 & 14-8	AmpSaver	No longer supported. Prevents multiple machines from extracting at the same time if doing so would overload the circuit.
21	61	2MTA14-10 & 14-18	Move to Wash or Load	On hydraulic tilting machines, actuate this output to enable the tilting circuit.

Table 9 Outputs on 24-Output Board #2 (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
22	62	2MTA14-10 & 14-9	Alt. Decel Safety	Actuate to send a signal to the inverter that indicates it is safe to decelerate the motor. This output is actuated whenever the machine is fully powered on.
23	63	2MTA14-10 & 14-19	Move to Wash Posi.	On hydraulic tilting machines, actuate to bring the machine to the wash position.

Table 10. Outputs on 8-output 16-input Boards #3 and #4 (for WTB+ only)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
8/16 Board 3				
0	64	3MTA5-10 & 5-19	Dryell Blow	This output is used to dry the chute after a “Dryell Flush” on older machines with a separate chute and door.
1	65	3MTA5-9 & 5-18	Brake Safety	The controller automatically actuates this output on boot up to protect the inverter from power failure.
2	66	3MTA5-8 & 5-17	not used	—
3	67	3MTA5-7 & 5-16	Load Desired	This output signals an allied (non-Miltrac™) loading device that the washer is ready to accept a load.
4	68	3MTA5-4 & 5-14	Dryell Flush	Flush the Integrated Door Chute with water. This output is automatically actuated during the loading process to help goods slide down the chute.
5	69	3MTA5-3 & 5-13	Discharge Terminated	This output signals an allied (non-Miltrac™) discharge device that the washer has finished discharging its goods.
6	70	3MTA5-2 & 5-12	Open Bifold Door	Opens the bifold door if all safety conditions are met.
7	71	3MTA5-1 & 5-11	Close Bifold Door	Closes the bifold door if all safety conditions are met.
8/16 Board 4				
0	96	4MTA5-10 & 5-19	Dry Code Bit 0	Dry codes passed to an adjacent allied (non-Miltrac™)

Table 10 Outputs on 8-output 16-input Boards #3 and #4 (for WTB+ only) (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
1	97	4MTA5-9 & 5-18	Dry Code Bit 1	machine for the load exiting the washer-extractor.
2	98	4MTA5-8 & 5-17	Dry Code Bit 2	
3	99	4MTA5-7 & 5-16	Dry Code Bit 3	
4	100	4MTA5-4 & 5-14	Destination Code Bit 0	Destination codes passed to an adjacent allied (non-Miltrac™) machine for the load exiting the washer-extractor.
5	101	4MTA5-3 & 5-13	Destination Code Bit 1	
6	102	4MTA5-2 & 5-12	Destination Code Bit 2	
7	103	4MTA5-1 & 5-11	Destination Code Bit 3	

Table 11. Outputs on 24-Output Board #4 (WTB+ only)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
0	104	4MTA13-1 & 2MTA13-11	Hydraulic Pump	Activates the hydraulic pump used to tilt the machine and move the chute.
1	105	4MTA13-2 & 13-12	Chute Up	Raises the load chute if all safety conditions are met.
2	106	4MTA13-3 & 13-13	Chute Down	Lowers the load chute if all safety conditions are met.
3	107	4MTA13-4 & 13-14	Discharge Desired	This output signals an allied (non-Miltrac™) discharge device that the washer is ready to discharge.
4	108	4MTA13-5 & 13-15	Load Unload Terminate	This output signals an allied (non-Miltrac™) loading device that the washer has received the goods and returned to the wash position.
5	109	4MTA13-6 & 13-16	Tilt Up	Raises the machine rear if all safety conditions are met.
6	110	4MTA13-7 & 13-17	Tilt Down	Lowers the machine rear if all safety conditions are met.
7	111	4MTA13-8 & 13-18	Speed Limited; Balance	On 72046M5K models, this output enables the balancing system. On non-72046M5K

Table 11 Outputs on 24-Output Board #4 (WTB+ only) (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
				MilTouch-EX™ models with OoB detection, this output limits the extract speed based on the amount of imbalance.
8	112	4MTA13-9 & 13-19	Washer Clear	This output signals allied (non-Miltrac™) loading and discharging devices when the washer is in a safe position and the devices can freely move around it.
9	113	4MTA13-10 & 14-1	Deflate Chute Seal	Deflates the chute seal if all safety conditions are met.
10	114	4MTA14-11 & 14-2	Start Loading	Initializes the loading sequence when the machine receives the "Allied Start Loading" input from the allied loading device, or the load command from the Miltrac™ system. This output remains actuated for the duration of the loading process.
11	115	4MTA14-12 & 14-3	Start Discharging	Initializes the discharging sequence when the machine receives the "Allied Start Discharge" input from the allied discharge device, or the discharge command from the Miltrac™ system. This output remains actuated for the duration of the discharge process.
12	116	4MTA14-4 & 14-13	Tilt Door Latch	not used
13	117	4MTA14-4 & 14-14	Chute Unlatch	Retracts all the chute locks.
14	118	4MTA14-10 & 14-5	Sequencer Load Allowed	These outputs determine the sequence in which groups of machines will load and discharge in multi-machine laundries.
15	119	4MTA14-10 & 14-15	Sequencer Load Desired	
16	120	4MTA14-10 & 14-6	not used	—
17	121	4MTA14-10 & 14-16	not used	—

Table 11 Outputs on 24-Output Board #4 (WTB+ only) (cont'd.)

Output # (Board)	Output # (Display)	Connections on Board	Function	Description
18	122	4MTA14-10 & 14-7	Flag Down	This output is used to align loading and discharge devices (usually devices that do not traverse on a rail) with the machine.
19	123	4MTA14-10 & 14-17	Sequencer Load Unload Term	These outputs determine the sequence in which groups of machines will load and discharge in multi-machine laundries.
20	124	4MTA14-10 & 14-8	Sequencer Discharge Desired	
21	125	4MTA14-10 & 14-18	Sequencer Discharge Allowed	
22	126	4MTA14-10 & 14-9	Sequencer Flag Down Discharge	
23	127	4MTA14-10 & 14-19	not used	—

4.9.3 External Use Input and Output Specifications

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Two inputs are available for the customer's use. These are:

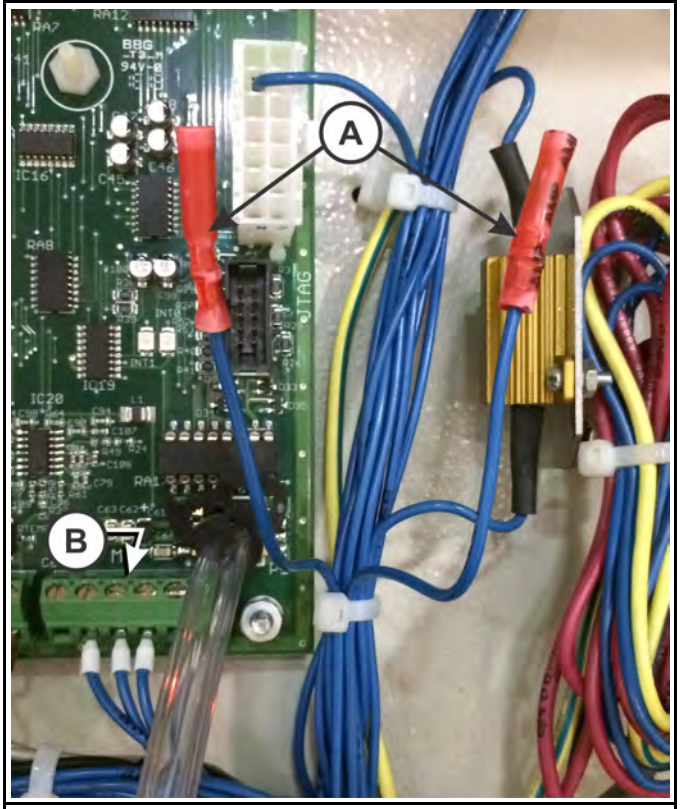
- Timer Stop (timer halt), which suspends the formula timer when the input is actuated.
- External Fault, which causes the controller to issue the External fault error when the input is actuated.

Item A in Figure 42, page 88 identifies the Timer Stop and External Fault butt connectors. The Timer Stop input is connected between the butt connector with wire number 138 and a ground terminal at Item B. The External Fault input is connected between the butt connector with wire number 139 and a ground terminal at Item B.

The controller applies 12 VDC to digital inputs. The customer must connect the input to a potential-free (dry) contact.

Chemical signal outputs are intended for the customer's use. The terminal blocks shown in Figure 43: Types of Pre-Wired Chemical Supply Terminal Blocks, page 89 provide the connection points for chemical signals. The type of terminal block varies by machine model. The controller applies 220 VAC – 240 VAC to digital outputs. The customer is advised to use these output signals to operate a relay and connect the load to potential-free (dry) relay contacts.

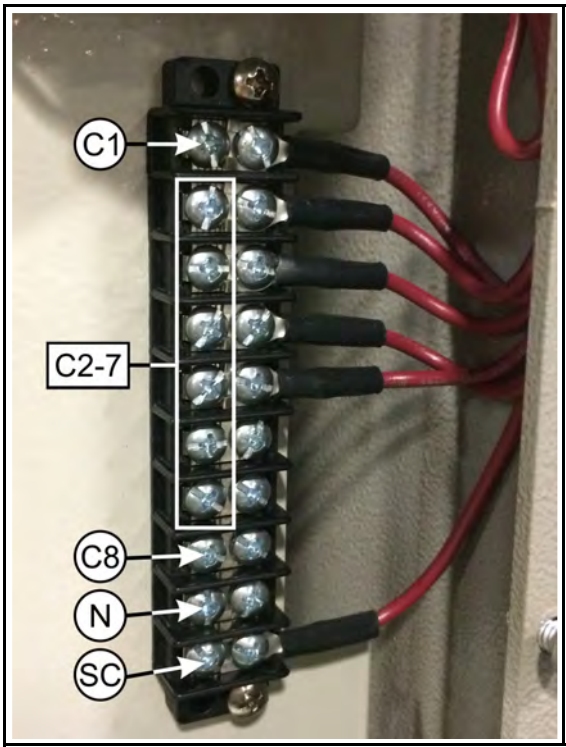
Figure 42. Butt Connectors for External Use Inputs

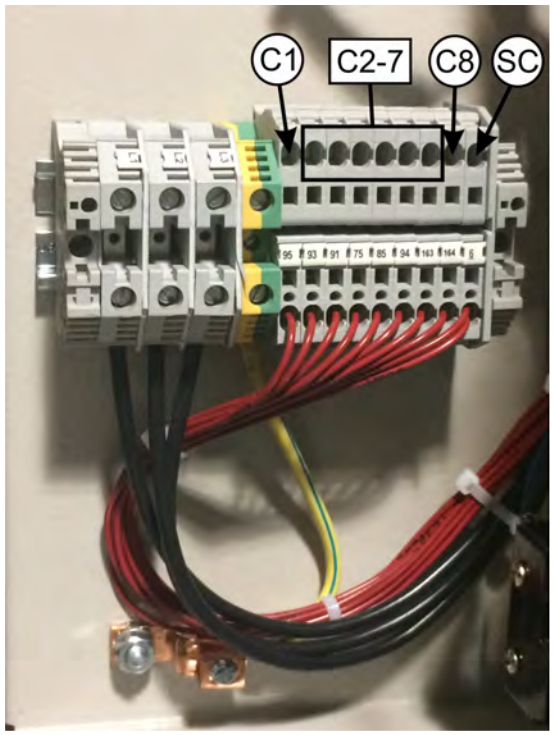


Legend

A . . . Butt connectors
B . . . DC ground terminal for inputs

Figure 43. Types of Pre-Wired Chemical Supply Terminal Blocks





Legend

C1. . . Chemical #1
C2–7. . . Chemical #2–7 connection points
C8. . . Chemical #8
N. . . Not used
SC. . . Supply common

NOTE: On some models, only chemicals 1 through 5 are pre-wired between the terminal block and the Input/Output board. On these models, inputs are available for chemicals 6, 7, and 8, but are not pre-wired.

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4.10 Troubleshooting Examples

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The following examples illustrate how to use the troubleshooting tools.

4.10.1 Example: The machine will not extract.

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The machine will not accelerate to extract speed and the “Recycling” messages (Recycle Coast, Recycle CCW, etc.) persist on the **Run** display until the controller displays the error “Too Many Recycles.”

1. You look for mechanical causes and find none. Examples of mechanical causes: the machine was under-loaded and the goods cannot distribute evenly around the cylinder, anchor bolts

have come loose causing the excursion switch to trip, the shipping restraint on the excursion switch was not removed after installation.

2. You review the list of inputs for any inputs that may be related to this condition. The **Excursion** input (1MTA4–11) is a likely candidate.
3. You view the **Diagnostics** display with **Inputs** selected (Section 4.7.1.1 : Digital Inputs, page 67) and you see that input 1MTA4–11 is not actuated. This input must be actuated; otherwise, the controller senses that the excursion switch is tripped. This input is **not** actuated, therefore this input is the likely reason that the machine will not extract.
4. You view the status light for this input on the input/output (I/O) board (Section 4.8.1 : Status Lights on Boards, page 71).
   - If the corresponding input status light (Section 4.8.2 : How to Determine the Position of an Output or Input, page 72) is not illuminated, both the status light and the display show that the input is not actuated (the status light agrees with the information on the display). This indicates the problem is external to the controller.
   - You suspect an open in the wiring between the excursion switch and the controller or a faulty switch. Refer to the electrical schematic manual for your machine to troubleshoot the excursion switch circuit. The schematic manual identifies connection points, wire numbers, and electrical component part numbers. Some common causes of electrical problems are corroded connections, a lightning strike, a chemical spill.
   - If the excursion switch circuit is not faulty, you review the Section 6.1 : Out-of-balance Detection and Balancing for Washer-extractors, page 109 and contact Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117 for further assistance.
   - If the status light is illuminated, the light does not agree with the information on the display. This should never occur. Consult Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117 to further troubleshoot the controller.

4.10.2 Example: Desired temperature is not achieved.

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The bath does not achieve the desired temperature on a machine not equipped with steam.

A machine not equipped with steam injection uses modulation, as explained in Section 3.4 : How to Modulate Water Valves to Regulate Incoming Water Temperature, page 40, to achieve the programmed bath temperature. With modulation, the machine is dependent on the laundry facility to provide sufficiently hot water to achieve the desired temperature in the time required to fill the cylinder to the programmed level.

1. The operator reports that the wash doesn't seem hot enough. To confirm this, you monitor the Diagnostic display with **A/D | D/A** selected, as shown in Section 4.7.1.5 : Analog Channels (A/D inputs and D/A outputs), page 69 while a formula runs. You see that the temperature achieved remains significantly below the temperature desired when the machine stops filling.
   - If the temperature achieved does not rise at all, you suspect that the hot water valve does not open during modulation. You will test this further, in the next steps.

- If the temperature achieved rises, but not to the temperature desired, you suspect that a problem external to the machine prevents sufficiently hot water from reaching the machine (see note below). Some possible causes are a clogged water filter in the hot water line, a shutoff valve in the hot water line not fully open, water heater temperature not adjusted hotter for winter conditions, water line break, a temporary increase in hot water demand by other devices.

NOTE: If you observe the actual temperature rise, but not fast enough to reach the desired temperature in time, this can also be because an inefficient method was used to program modulation of the hot and cold water valves (see Section 3.4 : How to Modulate Water Valves to Regulate Incoming Water Temperature, page 40).

2. You suspect that the hot water valve is not functional. With the machine idle, you use the Diagnostics display with **Outputs** (Section 4.7.1.2 : Digital Outputs, page 68) selected to view or actuate outputs. You actuate the Hot Water output (output O-8) and observe that the hot water valve does not open.
3. With the output actuated, you observe the corresponding light on the Input/Output (I/O) board (Section 4.8.1 : Status Lights on Boards, page 71).
   - If the Output O-8 status light is illuminated, both the status light and the display show that the output is actuated (the light agrees with the information on the display). You suspect an open in the wiring between the I/O board and the electrically operated hot water valve or a faulty valve. Refer to the electrical schematic manual for your machine to troubleshoot the hot water valve circuit. The schematic manual identifies connection points, wire numbers, and electrical component part numbers.
   - If the status light is illuminated, the light does not agree with the information on the display. This should never occur. Consult Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117 to further troubleshoot the controller.

5 Data Transfer

5.1 Data Transfer Purposes, Components, and Best Use

All wash formulas and configuration settings can be exported to external storage devices. It is also possible to import wash formulas and configuration settings from an external storage device to a MilTouch™ machine. We refer to this flow of data as “data transfer.”

Data transfer has three purposes:

- creating backups
- sharing formulas with similar or identical machines
- formula development on a PC

5.1.1 Data Backup

Your machine's wash formulas and configuration settings can be lost due to data corruption, unauthorized changes, tampering, or controller hardware failure. If backup files were correctly maintained, you can restore the data and return the machine to production quickly.

You can select from either of the following two media on which to store backup files:

- **Internal SD card**—This card, which should never be removed from the machine unless it becomes damaged, stores all of a MilTouch™ machine controller’s internal memory. The active wash formulas and configuration data currently used by the machine are stored in one (small) partition of this card that only the controller can access. The other (large) partition, approximately 1.8 gigabytes of available memory, is available as a convenient location to store backup files. Although the SD card is located inside the machine controller, the storage partition of the controller’s SD card is considered an external storage location for the sake of this manual.
- **USB drive (memory stick)**—A USB flash drive can be used with or instead of the internal SD card. As a removable medium, a USB drive can keep your data safe in case your SD card becomes damaged. Every time wash formulas and/or configuration settings are changed and finalized, transfer a backup copy of this data to a USB drive. Use only a blank flash drive or a flash drive you previously set aside for data backup (see Section 5.1.4 : The USB Flash Drive Formatting Requirement, page 95). If you plan to use the USB drive as the final storage location, clearly label it and place it in a secure location. A USB drive of good quality is more important than one with a large memory size.

There are four recommended ways to store data for backup:

- MilTouch™ machine —> SD card
- MilTouch™ machine —> USB flash drive
- MilTouch™ PC programmer application —> computer hard drive
- MilTouch™ PC programmer application —> USB flash drive

5.1.2 Formula Sharing

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After you have developed a wash formula or set of wash formulas, you can transfer the formulas (a single set) to one or multiple other MilTouch™ machines with a USB flash drive. Hence you can share formulas among a group of MilTouch™ machines without repeating the development process on each machine.

There are two recommended ways to share formulas between MilTouch™ machines:

- MilTouch™ machine —> USB flash drive —> similar or identical MilTouch™ machine (one or more)
- MilTouch™ PC programmer application —> USB flash drive —> MilTouch™ machine (one or more similar or identical machines)

If you import wash formulas to a new machine with either method, you must ensure that the formula step decisions that are hardware-specific align with the target (receiving) machine's hardware, including its model, capabilities, and configuration settings. A machine's hardware has a major effect on wash formula programming. For example, machines with different cylinder diameters and depths have different extract speed ranges and maximum water levels.

CAUTION: **Incorrect configuration data —** Can cause formula errors.

▶ Never attempt to import configuration settings to a machine from any source other than that machine's backup data.

CAUTION: **Incorrect formula data —** Can cause machine malfunctions or damage to goods.

▶ Ensure that the formula step decisions that are hardware-specific align with the target (receiving) machine's hardware.

▶ Only transfer wash formulas between machines with similar or identical models and equipment.

5.1.3 About the MilTouch™ Programmer Application for Windows PCs

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The free MilTouch™ PC programmer application lets you create and edit wash formulas on a Windows-based computer, and transfer them to your MilTouch™ machines with a USB flash drive. This capability lets you:

- learn how to use the MilTouch™ interface away from the production environment
- do formula development work for a machine while it's in operation
- apply the same formulas to multiple machines

Each machine controller variation (MilTouch™, MilTouch-EX™, and MilTouch-EX™ WTB) has its own version of the PC programmer application. All versions of the PC programmer application are available for download at `milnor.com/controls`.

The PC programmer application uses the same interface as the controller on the machine to help you program formulas and manage their deployment. The contents of this manual apply to both the controller and the PC programmer, with the following exceptions:

- In the PC programmer, the displays described in Section 4.7 : Troubleshooting Inputs and Outputs, page 66 do not reflect the state of any real hardware. The PC application does not simulate inputs and outputs.
- The PC programmer will not simulate the actions of a formula or the **Run** display (Section 1.1.3 : When a Formula is in Progress (The Run Display), page 9).
- The PC programmer can hold up to 5 different sets (groups) of formulas and 5 different sets of configuration data. See Section 5.1.3.1 , page 94.

When you develop formulas using the PC programmer application, be sure to configure the programmer application with the same configuration decisions as the target (receiving) machine. This practice allows you to see potential conflicts between formulas and configuration data before you transfer the formulas to the machine.

5.1.3.1 Formula Creation and Data Transfer with Formula Groups

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The MilTouch™ PC programmer application can store up to 5 different sets of formulas, called formula groups (numbered 0-4). The formula groups feature allows users to program or import more than one set of formulas without overwriting the existing data in the application's internal memory. Each formula group can have its own set of configuration settings as well.

On the **Home** display, touch a group number to select that formula group as the active group. The active group is displayed in green, as indicated by Group 0 in the following figure. Change wash formulas, configure your machine, and import data like you would on your machine's MilTouch™ controller. All the changes you make will be saved to the active group.

Figure 44. Formula Groups on the Home Display

NOTE: The formula groups feature is only available on machines running the software versions listed in Table 12, page 95, or later software versions, on both the machine controller and the PC programmer application. If you are running an older version of the PC programmer application, you must uninstall it, then re-install the latest version. Your formulas and configuration settings from the old version will be retained on the new version of the programmer application.

Table 12. Formula Group Software Versions

Controller Variation	Software Version
MilTouch™	WUMTGUIA / 3.2.100
MilTouch-EX™	WUMTGUIB / 4.2.000
MilTouch-EX™ WTB	WUMTGUIC / 6.2.000

5.1.4 The USB Flash Drive Formatting Requirement

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CAUTION: **An unreliable USB flash drive —** Can prevent data restoration.

- Use only good quality USB hardware.
- Dedicate a USB flash drive to a specific machine or group of machines.

Before you attach a USB flash drive to your MilTouch™ controller for the first time, format the drive to make it compatible with the MilTouch™ controller software. To format your USB flash drive, use the procedure in Section 6.3.1 : Format your USB Flash Drive, page 113.

5.1.5 Data Directory Structure and Files

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When you transfer data either to a personal computer or to a USB drive, a hierarchy of directories and files similar to that shown in the following table are created.

Table 13. Example of Directory and File Structure After Data Transfer

Directory or File	Description
USB Drive (D)	USB drive root directory (example). Alternatively, this could be the root of the large partition on the internal SD card.
36026V7Z-1.cfg temporary.cfg	Examples of configuration files that you transferred from the machine. The file names before the `.cfg` extension are the names you assigned to these configuration files. These files are proprietary. Only the controller and the PC programmer application can use these files.
L0_Commercial.set	The directory that contains the default formulas that you transferred from the machine. The structure under this directory is not shown.

Table 13 Example of Directory and File Structure After Data Transfer (cont'd.)

Directory or File	Description
Test_Formulas.set	An example directory that contains a formula set in development. The directory name before the `.set` extension is the name you assigned to this formula set.
f-001 ... f-010	Directories that hold the individual formula data—one per formula. Only directory f-010 is expanded to show its content.
s-001_chems.dat s-004_chems.dat steps.dat	Proprietary files that hold the data for the steps in this formula. These files are accessible only by the controller and the PC programmer application.
formulas.dat	A proprietary file that holds data for all formulas. This file is accessible only by the controller and the PC programmer application.

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5.2 Data Transfer with the MilTouch™ Controller

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NOTE: If you are using the MilTouch™ PC programmer application, see Section 5.3 : Data Transfer with the MilTouch™ PC Programmer Application, page 101.

From the **Data Transfer** display, you can export wash formula sets from the MilTouch™ machine controller to a USB flash drive for sharing. You can also export wash formula sets and configuration files to a USB device or SD card to keep as backup data.

Touch  on the **Home** display on the controller to show the **Data Transfer** display.

The following figure illustrates how the **Data Transfer** display appears on the MilTouch™ controller. In the following figure, these definitions apply:

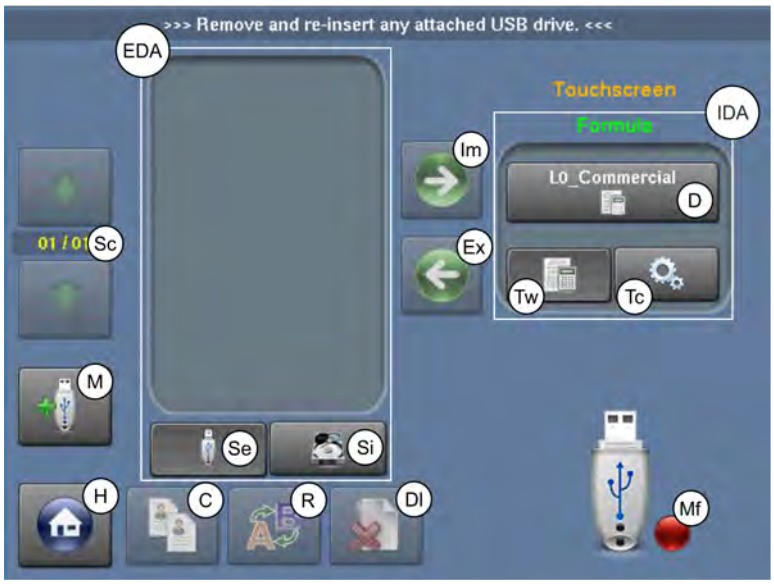
internal pertains to a data storage location that only the controller can use. Changes you make in the **Configuration** and **Wash Formula Maintenance** displays apply to the data at this location.

external pertains to the root of the USB flash drive or on the storage partition of the controller's SD card.

export copy data from the internal to an external data storage location.

import copy data from an external to the internal data storage location.

Figure 45. The Data Transfer Display on the Controller



Legend

C.	Copy a data set
D.	The name of the data set saved to the machine's internal memory
Dl.	Delete a data set
EDA.	External Data Area
Ex.	Export a data set
H.	Return to the **Home** display
IDA.	Internal Data Area
Im.	Import a data set
M.	Mount or umount a USB flash drive
Mf.	The available media indicator
R.	Rename a data set
Sc.	Scroll between pages
Se.	Transfer data in external storage area
Si.	Transfer data in internal storage area
Tc.	Transfer configuration files
Tw.	Transfer wash formulas

5.2.1 How to Mount a USB Flash Drive to the MilTouch™ Controller

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Follow these instructions to mount a USB flash drive to the machine, and troubleshoot the controller if it does not recognize a connected USB device after a few seconds.

1. Insert your USB flash drive to the machine's USB port.

   If the available media indicator in the bottom right of the display changes from red to green  , the controller recognizes a connected USB device and you have successfully mounted the USB flash drive to the machine.

2. If the available media indicator does not turn green after a few seconds, touch  to mount the USB flash drive to the controller.

3. If the available media indicator does not turn green after you touch  , remove the USB flash drive, wait 10 seconds, reinsert the flash drive into the USB port, and touch  again.

4. If the controller does not recognize the USB flash drive after your remove and re-insert it, you need to format your USB flash drive. To format your USB flash drive, follow the procedure in Section 6.3.1 : Format your USB Flash Drive, page 113.

5. If you format your USB flash drive and the controller still does not recognize the device, use a different USB flash drive.

5.2.2 How to Export Files from the MilTouch™ Controller

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To export wash formulas and configuration files from the MilTouch™ controller to an external storage device (USB flash drive or SD card):

1. Touch  on the **Home** display to access the **Data Transfer** display.
2. If you are exporting files to a USB flash drive, mount the flash drive to the MilTouch™ controller as described in Section 5.2.1 , page 97. If there is already a flash drive attached to the controller, remove and re-insert it.
3. Choose to export either wash formulas or configuration files. In the Internal Data Area:
   - Touch  to select the formula set as the data that will be exported.
   - Touch  to select the configuration file as the data that will be exported.
4. Touch the button that displays the data set name in the Internal Data Area. Based on your choice from the previous step, the Internal Data Area will appear in one of the two ways shown in the following figure.

Figure 46. The Two Alternative Internal Data Area Views

5. To change the name of the formula set or configuration file, if desired, touch  . The **File Name** window (not shown) appears. In the **File Name** window:
   a. Touch the **[Clear All]** button to delete the current file name.
   b. Use the keypad to enter a new file name.
   c. Touch  to save the new file name and close the window.
6. A dialog box (not shown) appears, which indicates the file was renamed. Touch  to dismiss the dialog box.
7. Choose to export the files to either the USB flash drive or the SD card. In the External Data Area:

- Touch  to select the root of the USB flash drive as the destination for the files.
- Touch  to select the SD card as the destination for the files.

8. Touch  to export the file. The file appears in the External Data Area.
9. A dialog box (not shown) appears, which indicates the file was exported. Touch  to dismiss the dialog box.
10. If you exported files to a USB flash drive, touch  to unmount the flash drive. The available media indicator in the bottom right of the **Data Transfer** display changes from green to red  , which indicates the controller no longer recognizes a connected USB device.
11. Remove the USB flash drive.

5.2.3 How to Import Files to the MilTouch™ Controller

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To import wash formulas and configuration files to the MilTouch™ machine controller from a USB flash drive or from the SD card:

NOTE: Wash formulas can be imported to one or more MilTouch™ machines, but you should only transfer wash formulas between machines with similar or identical model numbers, equipment, and configuration.

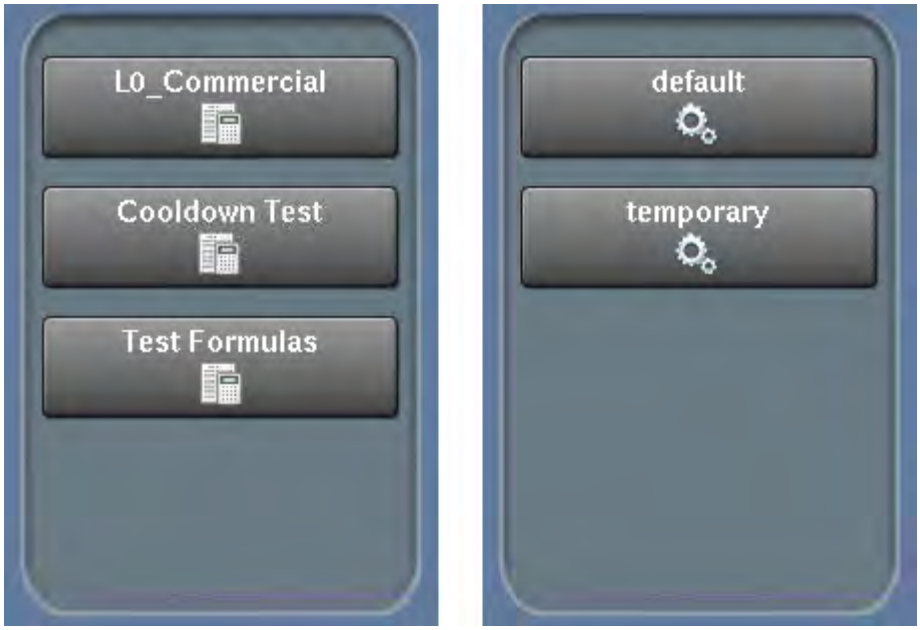
NOTE: Your machine was configured with the optimum or required settings at the factory. Configuration files can be imported to one or more MilTouch™ machines, but this is not recommended. Save a backup copy of each machine's configuration file for restoration to that machine only, if necessary in the future.

1. Touch  on the **Home** display to access the **Data Transfer** display.
2. If you are importing files from a USB flash drive, mount the flash drive to the MilTouch™ controller as described in Section 5.2.1 , page 97. If there is already a flash drive attached to the controller, remove and re-insert it.
3. Choose to import the files from either the USB flash drive or the SD card in the controller. In the External Data Area:
   - Touch  to select files from the root of the USB flash drive.
   - Touch  to select files from the SD card.
4. Choose to import either wash formulas or configuration files. In the Internal Data Area:

- Touch  to select the wash formulas as the files that will be imported.
- Touch  to select the configuration file as the file that will be imported.

5. A list of files available for import will appear in the External Data Area. Based on your choice from the previous step, the External Data Area will either display the available wash formula sets or the available configuration files. Touch the button that displays the data set name of the file you wish to import.

Figure 47. Example Wash Formulas and Configuration Files Available for Import



6. To change the name of the formula set or configuration file, if desired, touch  . The **File Name** window (not shown) appears. In the **File Name** window:
   a. Touch the **[Clear All]** button to delete the current file name.
   b. Use the keypad to enter a new file name.
   c. Touch  to save the new file name and close the window.
7. A dialog box (not shown) appears, which indicates the file was renamed. Touch  to dismiss the dialog box.
8. Touch  to import the file. The file appears in the Internal Data Area.
9. A dialog box (not shown) appears, which indicates the file was imported. Touch  to dismiss the dialog box.

10. If you imported files from a USB flash drive, touch  to unmount the flash drive. The available media indicator in the bottom right of the **Data Transfer** display changes from green to red  , which indicates the controller no longer recognizes a connected USB device.
11. Remove the USB flash drive.

5.3 Data Transfer with the MilTouch™ PC Programmer Application

NOTE: If you are not using the MilTouch™ PC programmer application, see Section 5.2 : Data Transfer with the MilTouch™ Controller, page 96.

From the **Data Transfer** display, you can export wash formulas prepared with the MilTouch™ PC programmer application to a USB flash drive for sharing. You can also export wash formula sets and configuration files to a USB device or the hard drive of the computer running the programmer application to keep as backup data.

To begin data transfer:

1. Touch  on the **Home** display on the MilTouch™ PC programmer application to show the **Data Transfer** display on the programmer application.
2. A dialog box (not shown) appears, which reminds you that only files saved in the root of the USB flash drive are available for import. In the dialog box, touch  to dismiss it.

The following figure shows how the **Data Transfer** display appears on the MilTouch™ programmer application.

In the following figure, these definitions apply:

internal pertains to a data storage location that only the programmer application can use. Changes you make to configuration and wash formula decisions with the programmer application apply to the data at this location.
external pertains to the root of the computer's hard drive or the root of the USB flash drive.
export copy data from the internal to an external data storage location.
import copy data from an external to the internal data storage location.

Figure 48. The Data Transfer Display on the PC Programmer Application

Legend

C.	Touch to copy a data set
Cp.	Current path to the external data sets
D.	Data set name
Dl.	Touch to delete a data set
EDS.	External Data Area
Ex.	Touch to export a data set
H.	Touch to return to the **Home** display
IDA.	Internal Data Area
Im.	Touch to import a data set
P.	Touch to print data to a text file
R.	Touch to rename a data set
S.	Touch to launch the file browser window
Sc.	Touch to scroll between pages
Tc.	Touch to work with configuration files
Tw.	Touch to work with wash formula sets

5.3.1 How to Export Files from the PC Programmer Application

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To export wash formulas and configuration files prepared with the MilTouch™ PC programmer application to a USB flash drive or to the hard drive of the computer running the programmer application:

1. Touch  on the **Home** display to access the **Data Transfer** display.
2. If you are exporting files to a USB flash drive, insert the blank flash drive into the personal computer running the MilTouch™ programmer application. If there is already a flash drive attached to the computer, remove and re-insert it.
3. Choose to export either wash formulas or configuration files. In the Internal Data Area:
   - Touch  to select the formula set as the data that will be exported.
   - Touch  to select the configuration file as the data that will be exported.

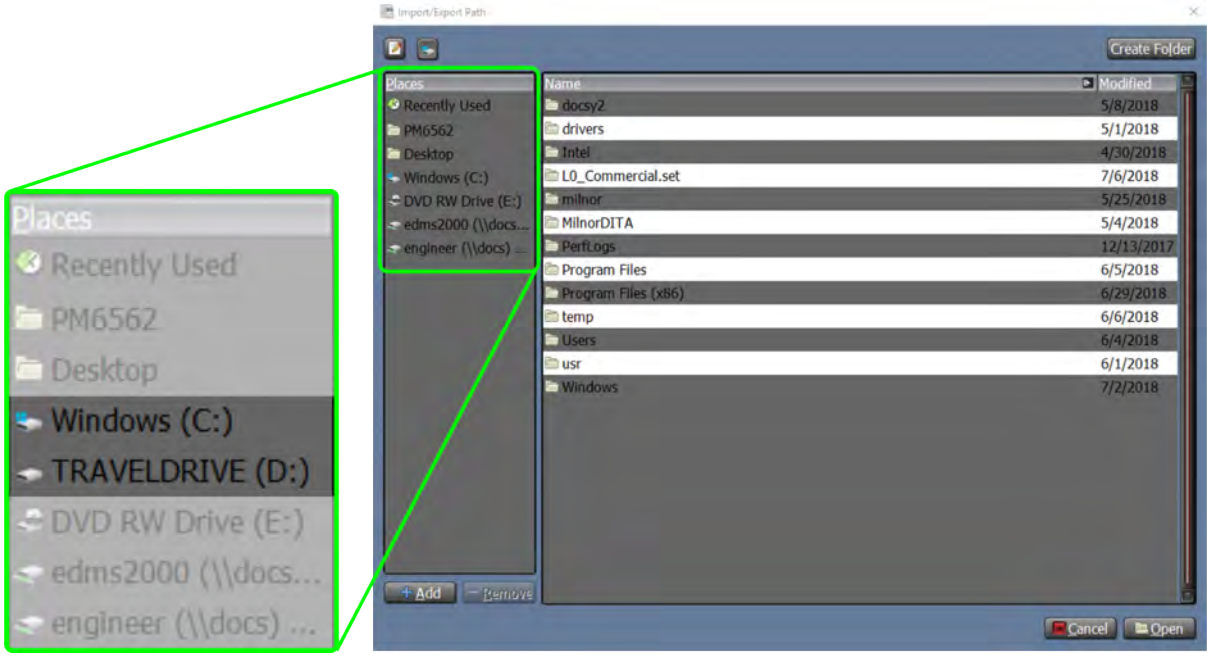
NOTE: If your programmer application uses the formula groups feature, ensure that you are exporting formulas from the correct formula group.

4. Touch the button that displays the data set name in the Internal Data Area. Based on your choice from the previous step, the Internal Data Area will appear in one of the two ways shown in the following figure.

Figure 49. The Two Alternative Internal Data Area Views

5. To change the name of the formula set or configuration file, if desired, touch  . The **File Name** window (not shown) appears. In the **File Name** window:
   a. Touch the **[Clear All]** button to delete the current file name.
   b. Use the keypad to enter a new file name.
   c. Touch  to save the new file name and close the window.
6. A dialog box (not shown) appears, which indicates the file was renamed. Touch  to dismiss the dialog box.
7. Touch  . The file browser window shown in the following figure appears.

Figure 50. File Browser Window



a. Choose to export files to either a USB flash drive or to the hard drive of the computer running the PC programmer application. In the left column of the file browser window:
   - Touch the drive letter of the USB flash drive (such as D:) to export the files to the root of the USB flash drive.
   - Touch the C: drive to export files to the hard drive of the computer running the programmer application.

b. Touch the button that displays **Open** in the bottom right corner of the window to confirm your selection.

8. Touch  to export the file. The file appears in the External Data Area.

9. A dialog box (not shown) appears, which indicates the file was exported. Touch  to dismiss the dialog box.

10. If you exported files to a USB flash drive, remove the flash drive.

5.3.2 How to Import Files to the PC Programmer Application

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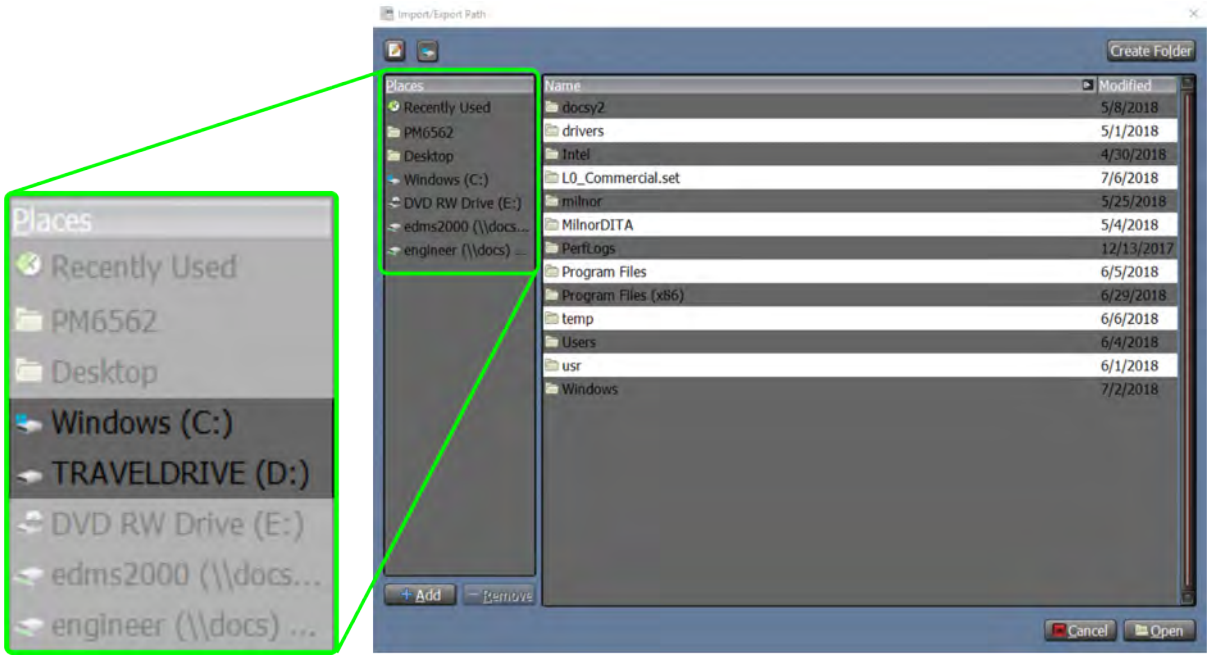
To import wash formulas and configuration files to the MilTouch™ PC programmer application from a USB flash drive or from the hard drive of the computer running the programmer application:

1. Touch  on the **Home** display to access the **Data Transfer** display.

2. If you are importing files from a USB flash drive, insert the blank flash drive into the personal computer running the MilTouch™ programmer application. If there is already a flash drive attached to the computer, remove and re-insert it.

3. Touch  . The file browser window shown in the following figure appears.

Figure 51. File Browser Window



   a. Choose to import files from either the USB flash drive or the hard drive of the computer running the PC programmer application. In the left column of the file browser window:

      - Touch the drive letter of the USB flash drive (such as D:) to import the files from the root of the USB flash drive.
      - Touch the C: drive to import files from the hard drive of the computer running the programmer application.

      NOTE: Although you can create and select folders from the file browser window, you can only import files from the root of a drive. Files located in a sub-folder are not available for import.

   b. Touch the button that displays **Open** in the bottom right corner of the window to confirm your selection.

4. Choose to import either wash formulas or configuration files. In the Internal Data Area:

   - Touch  to select the wash formulas as the files that will be imported.
   - Touch  to select the configuration file as the file that will be imported.

NOTE: If your programmer application uses the formula groups feature, ensure that you are importing formulas to the correct formula group.

5. A list of files available for import will appear in the External Data Area. Based on your choice from the previous step, the External Data Area will either display the available wash formula sets or the available configuration files. Touch the button that displays the data set name of the file you wish to import.

Figure 52. Example Wash Formulas and Configuration Files Available for Import

6. To change the name of the formula set or configuration file, if desired, touch . The **File Name** window (not shown) appears. In the **File Name** window:
   a. Touch the **[Clear All]** button to delete the current file name.
   b. Use the keypad to enter a new file name.
   c. Touch to save the new file name and close the window.
7. A dialog box (not shown) appears, which indicates the file was renamed. Touch to dismiss the dialog box.
8. Touch to import the file. The file appears in the Internal Data Area.
9. A dialog box (not shown) appears, which indicates the file was imported. Touch to dismiss the dialog box.
10. If you imported files from a USB flash drive, remove the flash drive.

5.3.3 How to Export Formula and Configuration Data as Text Files

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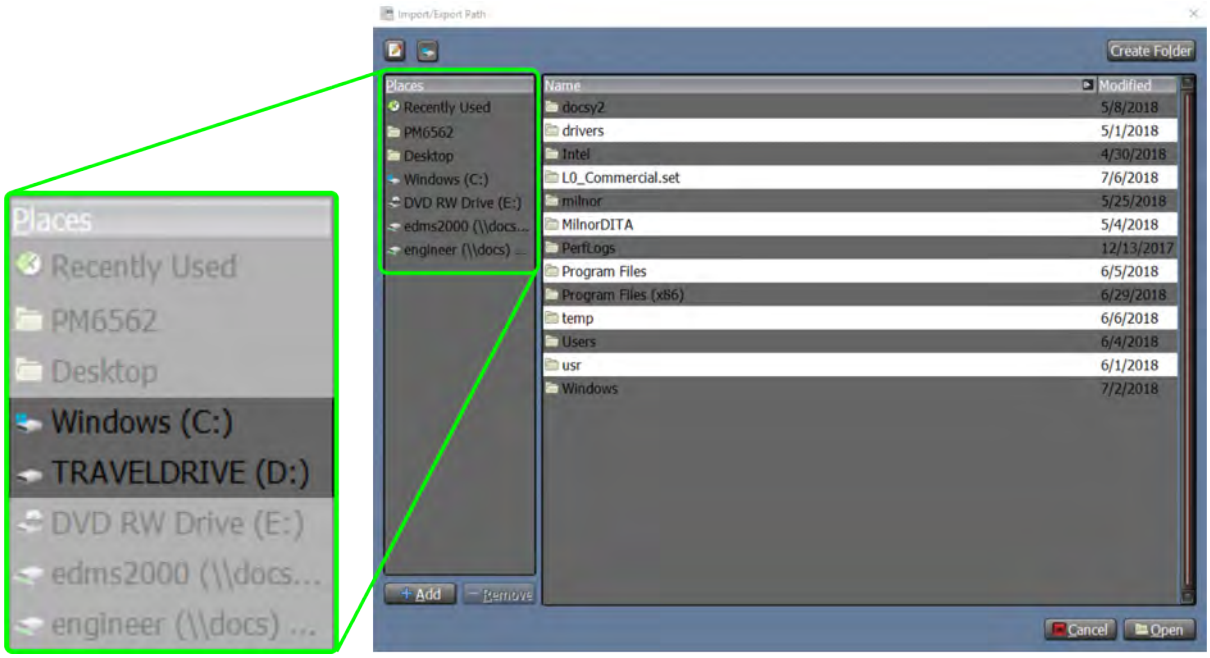
Use the function to export the formula or configuration data in the Internal Data Area as a text (.txt) file to an external storage location. This feature can be used to print formula and configuration data, or save formula and configuration data in a format your computer can read. This feature is only available on the MilTouch™ PC programmer application.

1. Touch to return to the **Home** display, then touch on the **Home** display to access the **Data Transfer** display.

   NOTE: If you touch any buttons other than , , and , the (export as text file) function will not work.

2. Touch . The file browser window shown in the following figure appears.

Figure 53. File Browser Window

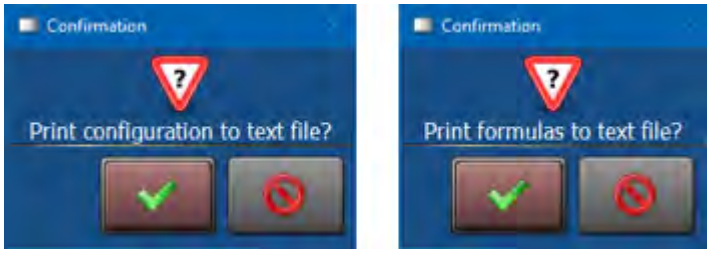


   a. Choose to export files to either a USB flash drive or to the hard drive of the computer running the PC programmer application. In the left column of the file browser window:

      - Touch the drive letter of the USB flash drive (such as D:) to export the files to the root of the USB flash drive.
      - Touch the C: drive to export files to the hard drive of the computer running the programmer application.

3. Touch the button that displays **Open** in the bottom right corner of the window to confirm your selection.
4. Choose to export either wash formulas or configuration files. In the Internal Data Area:
   - Touch  to select the formula set as the data that will be exported.
   - Touch  to select the configuration file as the data that will be exported.
5. On the Data Transfer display, touch  . One of the dialog boxes shown in the following figure appears. Touch  to export the data as a text file.

Figure 54. Confirmation Dialog Boxes



6 Supplemental Information

6.1 Out-of-balance Detection and Balancing for Washer-extractors

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This document describes how the out-of-balance (OoB) detection and machine balancing features work on MilTouch™ washer-extractors to mitigate vibration before and during extract steps in a wash formula. The OoB detection feature is provided only on certain machine models, as listed. The machine balancing feature is only available on 72046M5K models.

Consult this document if your washer-extractor:

- experiences persistent recycles, or
- consistently cannot reach the programmed extract speed.

6.1.1 Out-of-balance Detection with a Vibration or Excursion Switch

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Throughout an extract step, the machine monitors the vibration switch or the excursion switch and performs a recycle if the excursion or vibration switch trips due to imbalance. In a recycle, the machine will decelerate to a stop, reverse a few times in wash speed, then redistribute in drain speed to balance the load. After every recycle, the machine will attempt to achieve the programmed extract speed again.

6.1.1.1 MilTouch-EX™ and MilTouch-EX™ WTB Models without Balancing

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Applicable Models 68036M5K, 48040M7K , 48040M7K WTB

6.1.1.1.1 If the Extract Step is an Intermediate Extract

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The OoB detection process begins when the cylinder reaches drain speed.

1. The OoB detection system compares the amount of imbalance to a table of threshold values.
   - If the imbalance is less than the lowest threshold value, the machine completes the extract step at the programmed speed.
   - If the imbalance is greater than the lowest threshold value, the machine completes the extract step at a reduced speed that is proportional to the amount of imbalance.
2. The OoB detection system continues to monitor the imbalance until the end of the step.

6.1.1.1.2 If the Extract Step is a Final Extract

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1. The machine performs a preemptive recycle in drain speed.
2. After the recycle, the OoB detection system evaluates whether the amount of imbalance is within the allowed threshold for the machine.
   - If the imbalance is within the allowed threshold, the machine completes the extract step at the programmed speed.
   - If the imbalance exceeds the maximum allowed threshold value, the machine recycles the extract sequence up to three times.
     – If the imbalance falls within the allowed threshold before or by the third recycle attempt, the machine completes the extract step at the programmed speed.
     – If the imbalance remains above the maximum allowed threshold value after the third recycle attempt, the machine completes the extract step at a reduced speed that is proportional to the amount of imbalance.
3. The OoB detection system continues to monitor the imbalance until the end of the step.

6.1.1.1.3 If the Excursion Switch Trips

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If the excursion switch trips while the cylinder accelerates to the programmed extract speed, the following events occur:

1. The machine performs a recycle.
2. After the recycle, the OoB detection system recalculates the amount of imbalance.
   - If the new imbalance is less than the lowest threshold value, the machine completes the extract step at the programmed speed.
   - If the new imbalance is more than the maximum allowed threshold value, the machine performs up to three recycles. If the imbalance remains above the maximum allowed threshold value after the third recycle:
     – During an intermediate extract, the controller cancels the step, displays the error “Too Many Recycles,” and proceeds to the next bath step (non-extract step).
     – During a final extract, the controller cancels the formula and displays the error “Too Many Recycles.”

NOTE: If the controller cancels a formula because of an imbalance error, the goods will require more dryer time.

6.1.1.1.4 If the Excursion Switch Does not Trip

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If the excursion switch does not trip while the cylinder accelerates to the programmed speed, the machine completes the extract step at the programmed speed.

6.1.1.2 MilTouch-EX™ and MilTouch-EX™ WTB Models with Balancing

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Applicable Models 72046M5K, 72046M5K WTB

After a recycle, the OoB detection system evaluates if the amount of imbalance can be offset by the machine balancing system. If the amount of imbalance is below a certain threshold, the balancing system balances the load by injecting water in the cylinder ribs opposite the imbalance. The washer-extractor then attempts to complete the extract step at the programmed speed.

6.1.1.2.1 If the Extract Step is an Intermediate Extract

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The OoB detection process begins when the cylinder reaches drain speed.

1. The OoB detection system compares the amount of imbalance to a fixed threshold value.
   - If the imbalance is less than the fixed threshold value, the balancing system balances the load and the machine completes the extract step at the programmed speed.
   - If the imbalance is greater than the fixed threshold value, the machine completes the extract step at a reduced speed (210 RPMs).
2. The OoB detection system continues to monitor the imbalance until the end of the step.

6.1.1.2.2 If the Extract Step is a Final Extract

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1. The machine performs a preemptive recycle in drain speed.
2. After the recycle, the OoB detection system evaluates whether the amount of imbalance can be offset by the machine balancing system.
   - If the imbalance can be offset, the balancing system balances the load and completes the extract step at the programmed speed.
   - If the imbalance is too large to be offset by the balancing system, the machine performs up to three recycles.
     - If the imbalance falls within the allowed threshold before or by the third recycle, the balancing system balances the load and the machine completes the extract step at the programmed speed.
     - If the imbalance remains above the maximum allowed threshold value after the third recycle, the machine completes the extract step at a reduced speed (210 RPMs).
3. The OoB detection system continues to monitor the imbalance until the end of the step.

6.1.1.2.3 If the Excursion Switch Trips

BNCLUF01.C11 0000185929 E.2 G.5 G.7 4/15/21 9:42 AM Released

If the excursion switch trips while the cylinder accelerates to the programmed extract speed, the following events occur:

1. The machine performs a recycle.
2. After the recycle, the OoB detection system recalculates the amount of imbalance
   - If the new imbalance is less than the lowest threshold value, the machine completes the extract step at the programmed speed.
   - If the new amount of imbalance can be offset, the balancing system balances the load and the machine completes the extract step at the programmed speed.

- If the new imbalance is more than the maximum allowed threshold value, the machine performs up to three recycles. If the imbalance remains above the maximum allowed threshold value after the third recycle:
  - During an intermediate extract, the controller cancels the step, displays the error “Too Many Recycles,” and proceeds to the next bath step (non-extract step).
  - During a final extract, the controller cancels the formula and displays the error “Too Many Recycles.”

NOTE: If the controller cancels a formula because of an imbalance error, the goods will require more dryer time.

6.1.1.2.4 If the Excursion Switch Does not Trip

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If the excursion switch does not trip while the cylinder accelerates to the programmed speed, the machine completes the extract step at the programmed speed.

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6.2 About the Mildata® Product

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The Mildata® product allows a commercial laundry to associate customer data with each load of goods processed and automatically accumulate production data for analysis. The machine also reports error info to the Mildata® computer.

Your machine must be connected to the Mildata® network (see Section 2.2.4 : Enable an Ethernet Connection, page 26) and configured to use the Mildata® product (Mildata = YES, see Section 2.1 : Machine Configuration, page 12) for the machine to communicate with the Mildata® computer.

The Mildata® product is a laundry management tool with capabilities not explained here. Contact Milnor® Customer Service/Technical Support using the contact information in Section 6.4 : How to Contact Milnor®, page 117 for more information.

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6.3 Software Update Procedure

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The Milnor® factory occasionally makes changes to MilTouch™ software. In some cases, we recommend that the change is applied to all machines. For these updates, we notify dealers of the change in an e-mail, and provide the software update file as an attachment so that dealer technicians can install the update on any MilTouch™ machines in their territory. This document is for the technician who will install the update. In this procedure, the technician will save an update file to a computer, copy it to a USB flash drive, and apply the update to the machine controller.

NOTE: If a software update will affect formula programming, configuration decisions, or customer procedures, there will be an explanation in the update e-mail.

6.3.1 Format your USB Flash Drive

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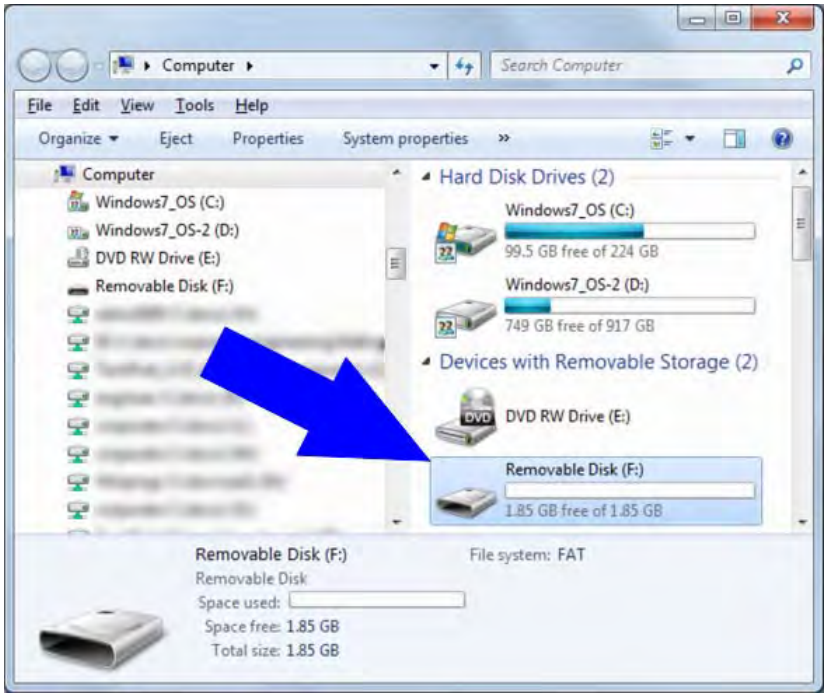
Format your USB flash drive to make it compatible with the MilTouch™ controller software. To complete this procedure, you must have a Windows™ computer with an available USB port and a blank USB flash drive with a capacity of at least 1 gigabyte (GB).

CAUTION: **Formatting —** removes all data from the USB device.

▶ Verify that the USB device you have selected to format is either unformatted or contains no data.

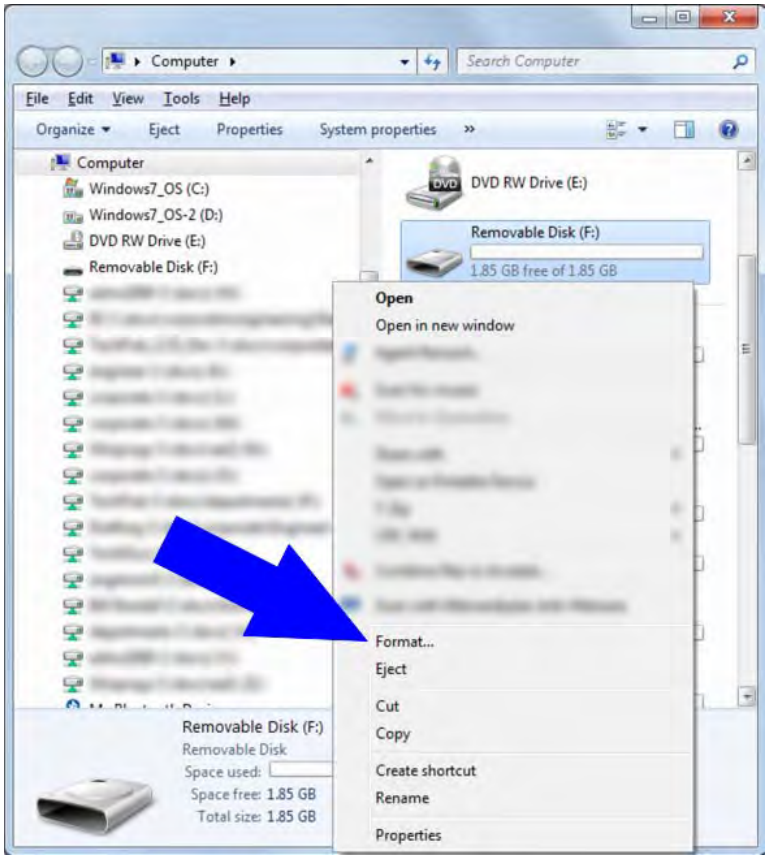
1. Insert the USB flash drive into an available USB port on your Windows™ computer.
2. Open File Explorer.

Figure 55. Typical View of USB Flash Drive in File Explorer



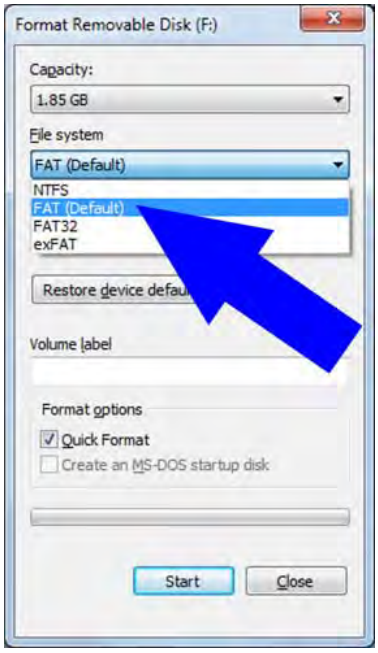
3. In Explorer, right-click on the USB flash drive to display the context menu.
4. Left-click on **Format...** in the context menu.

Figure 56. Typical File Explorer Context Menu



5. The **Format Removable Disk** window appears (shown in the figure below). In the **Format Removable Disk** window:

Figure 57. Format Removable Disk Main Window



a. Set the **File system** to **FAT** or **FAT32**

b. Click **Start** to format the device.

6. A confirmation window appears (not shown), which warns that the next action will erase all data on the device. Click **OK** to continue with the procedure.
7. When the computer formats the device, a confirmation window (not shown) will appear. Click **OK** to dismiss the window.
8. Click **Close** to close the **Format Removable Disk** window and return to File Explorer.

6.3.2 Save and Copy the Update File to the USB Flash Drive

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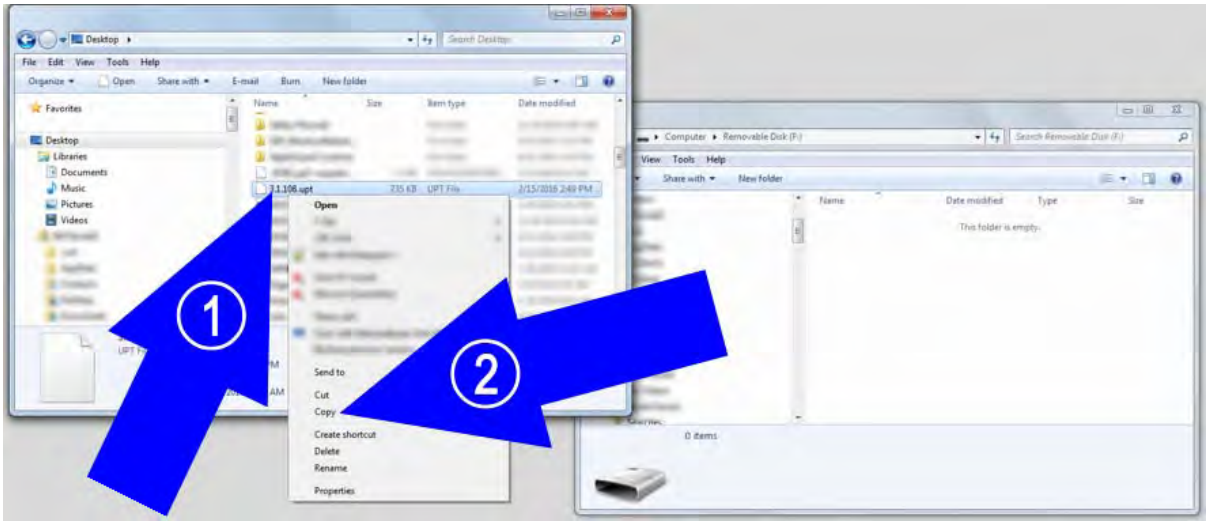
To save and copy the update file to the USB flash drive, you must have a Windows™ computer with an available USB port and the blank, formatted USB flash drive (as described in Section 6.3.1 , page 113) with a capacity of at least 1 gigabyte (GB).

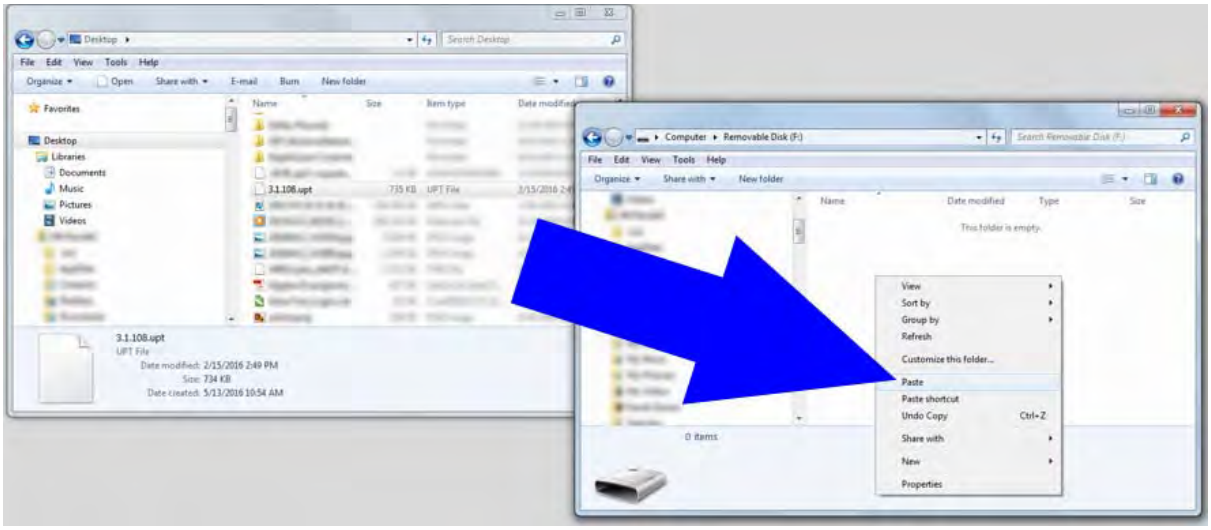
1. Identify and save the software update file to your computer.
2. Open File Explorer.
3. Locate and right-click on the saved update file on your computer (similar to Item 1 in the following figure). A context menu appears.

Figure 58. File Explorer Context Menu, Copy Command Indicated



4. In the context menu that appears, click on **Copy** (Item 2 in the previous figure).
5. Open a second File Explorer window and navigate to the USB flash drive.
6. Right click in the blank USB flash drive window to open the context menu.
7. In the context menu that appears, click on **Paste** (indicated by the arrow in the following figure). The update file will appear in the USB flash drive window.

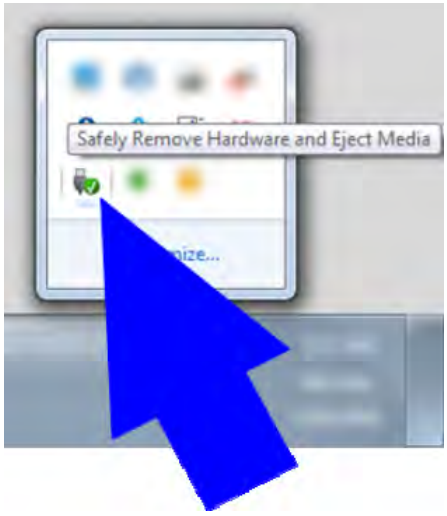
Figure 59. USB Flash Drive in File Explorer



NOTE: Make sure that you save the update file in the root of the USB flash drive (not inside of a folder on the USB drive).

8. Close the File Explorer windows.
9. In the Windows status area (bottom right of your screen), click the **Safely Remove Hardware** icon (shown in the following figure) to command the computer to release the USB flash drive.

Figure 60. Safely Remove Hardware Icon



10. Your computer notifies you when you can safely remove the USB flash drive. Remove the USB flash drive from the Windows computer.

6.3.3 Apply the Update File to the Machine Controller

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To apply the software update to a MilTouch™ or MilTouch-EX™ machine controller, you must have a USB flash drive prepared as described in Section 6.3.1 , page 113 and Section 6.3.2 , page 115. At the machine:

1. Touch  on the **Home** display to open the **Data Transfer** display.
2. Mount the flash drive that contains the update to the MilTouch™ controller as described in Section 5.2.1 : How to Mount a USB Flash Drive to the MilTouch™ Controller, page 97.
3. A confirmation window (not shown) appears, which prompts that a new version of the MilTouch™ controller software is available. Touch  to download the update. The controller signals when it begins initializing the update.
4. A second update window (not shown) appears.
   a. Touch the **Update MilTouch™** button to begin the download of the new software to the controller.
   b. The controller creates a restore point to prevent data loss if the update process is interrupted.
   c. A progress bar indicates the progress of the update.
5. When the update downloads, an information window (not shown) appears that prompts you to restart the controller. Touch the **Power Cycle Machine** button. The machine controller shuts down and restarts.
6. Remove the flash drive from the USB port when the **Home** display appears.

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6.4 How to Contact Milnor®

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Your authorized Milnor® dealer can assist you with your Milnor® machine and knows about the local conditions that may be pertinent to the installation, use, or maintenance of the machine. Contact your dealer first. For assistance from the Milnor® factory, refer to Table 14, page 117 for contact information.

Table 14. Pellerin Milnor® Corporation Contact Information

Purpose	Department	Telephone	FAX	E-mail/Web site
Order or ask about replacement parts	Parts	504–712–7775 or 800–299–1500	504–469–9777	parts@milnor.com
Get advice on installing, servicing, or using	Customer Service/ Technical Support	504–712–7780	504–469–9777	service@milnor.com www.milnor.com (Customer Service)

Table 14 Pellerin Milnor® Corporation Contact Information (cont'd.)

Purpose	Department	Telephone	FAX	E-mail/Web site
Learn about, request, or enroll in Milnor® service seminars	Training	504–712–7716	504–469–9777	training@milnor.com
Determine warranty eligibility or claim status	Warranty Administration	504–712–7735	504–469–9777	service@milnor.com (Attention: Warranty)
Ask about, comment on, or report an error in equipment manuals	Technical Publications	504–712–7636	504–469–1849	techpub@milnor.com
European contacts	Milnor® International	+ 32 2 720 5822	—	milnor@milnor.be
Ask about the shipping weight of your machine before it arrives at your facility	Logistics Department	504–712–7686	504–471–0273	—

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Pellerin Milnor Corporation
Post Office Box 400
Kenner, LA 70063-0400

Telephone: 504-467-9591
http://www.milnor.com
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