



CONTROLS & FUNCTIONS:

- 1 Mains power ISOLATOR. Turn 1/4 turn clockwise to switch on.
- 2 Indicates MAINS POWER connected
- 3 Indicates "READY" to run. Will NOT light up if AIR PRESSURE indicator not lit (see 4 below)
- 4 Indicates by lighting up when AIR PRESSURE is okay. If not lit then "READY" will not light either.
- 5 "RESET" - press once to engage main functions. It is necessary to press RESET if the air pressure was low when first switched on (4 above), or a red EMERGENCY stop button was pressed (18, 19 & 20 below). The PLC screen will read "UNSAFE" until RESET is pressed; after RESET is pressed it will read "READY"
- 6 "Manual Automatic" selects mode of operation. Use Manual mode for loading, unloading and making trimming cuts & cutting out bad material.
- 7 "RUN" - in Manual mode only - depress to move conveyor belts to feed material
- 8 "FORWARD or REVERSE" - selects conveyor belt direction in Manual mode
- 9 "CUT" - press once in Manual mode to make a trimming cut
- 10 "AUTO" mode indicator - auto is ready to run
- 11 AUTO Go (green button) - press once to start auto mode running
- 12 AUTO Stop (red btn) - press once to stop auto mode The cycle will be completed before stopping.
- 13 "Cloth Finish" - if used the machine will stop if there is no more cloth
- 14 "STACKER" switch: (in auto mode) - allows the stacker unit to operate automatically after each cut. If switched off (0), then cut panels will simply fall to the floor or in to a bin.
- 15 "BATCH COUNTER" - when selected automatic mode will stop when the pre-set number have been cut. Deselecting (ie. "AUTO 0") enables a "one shot" cut without counting.
- 16 PLC control panel - explained in greater detail later in this booklet
- 17 "UNLOAD STACKER" - in manual mode- press **hold** to unload cut panel bar.
Release to complete cycle & load new bar from magazine
- 18 EMERGENCY STOP - on control panel. Immediately stops all functions.
- 19 & 20 EMERGENCY STOPS - located each side of the CUT OFF BOX on Guards
- 21 *If hot wire fitted:* Blade / Hot wire selector switch
- 22 " Indicator (white) - when lit the BLADE is available to be used
- 23 " Indicator (orange) - when lit the HOT WIRE is available to be used