

04. SWITCH ON THE MACHINE

04.1 TURN ON THE COMPUTER AND SERVO MOTORS

- 1) When the machine is off, the monitor is black and the "POWER ON" on the control panel is in an upright position.



Turn on the main switch in the back of the machine (or where it is located depending on the model) to the "ON" position. This will allow the machine and Decoiler attachment to receive power.

Off

On



- 2) Turn the "POWER ON" knob located on the control panel clockwise to turn on the computer system and auxiliary circuits for the servo drivers.



3) After the boot up sequence, the display will show the last program loaded prior to shutdown.



4) At this point, examine the bottom left hand corner of the screen. The Operating System is not reset, and all axes will display an error.



- a. OS: NOT RESET – indicates the system needs to be reset
- b. ERROR: -- indicates that servo drivers are disabled



Press the green button "SERVO ON" will start all servo motors. At this time, the Error display should dissipate.

04.2 SWITCH ON AND RESET DECOILER

Turning on the system by turning the "POWER ON" button clockwise will immediately activate the buzzer of the decoiler. Press the green "START" (4) button on the decoiler control panel to deactivate the buzzer (5) and turn off the alarm (2) indicator. If the alarm indicator remains active, it could be due to one of the following causes:

- (A) Electrical connection issue
- (B) The power switch is damaged
- (C) Fuses are missing or damaged
- (D) Indicator is damaged



04.3 DECOILER: ROTATION DIRECTION AND SPEED CONTROL

1. Turns the decoiler on and off.
3. The FUSE for the decoiler. It can be replaced should the fuse burn out.
6. The ROTATION button has 3 settings, CW (Clockwise), Neutral, and CCW (Counterclockwise). When the ROTATION button is in the Neutral position, the decoiler will not move in either direction. When the selector is set to CW, the plate rotates in a positive (CW) direction. When the selector is set to the right, the plate rotates in the opposite (CCW) direction.
7. The "MANUAL" control allows the user to change the speed of the wire feed after the automatic wire feed switch is in position ON. Turning it CCW will slow down the wire feed while turning it CW will accelerate the wire feed.
8. Indicates the decoiler is receiving power.