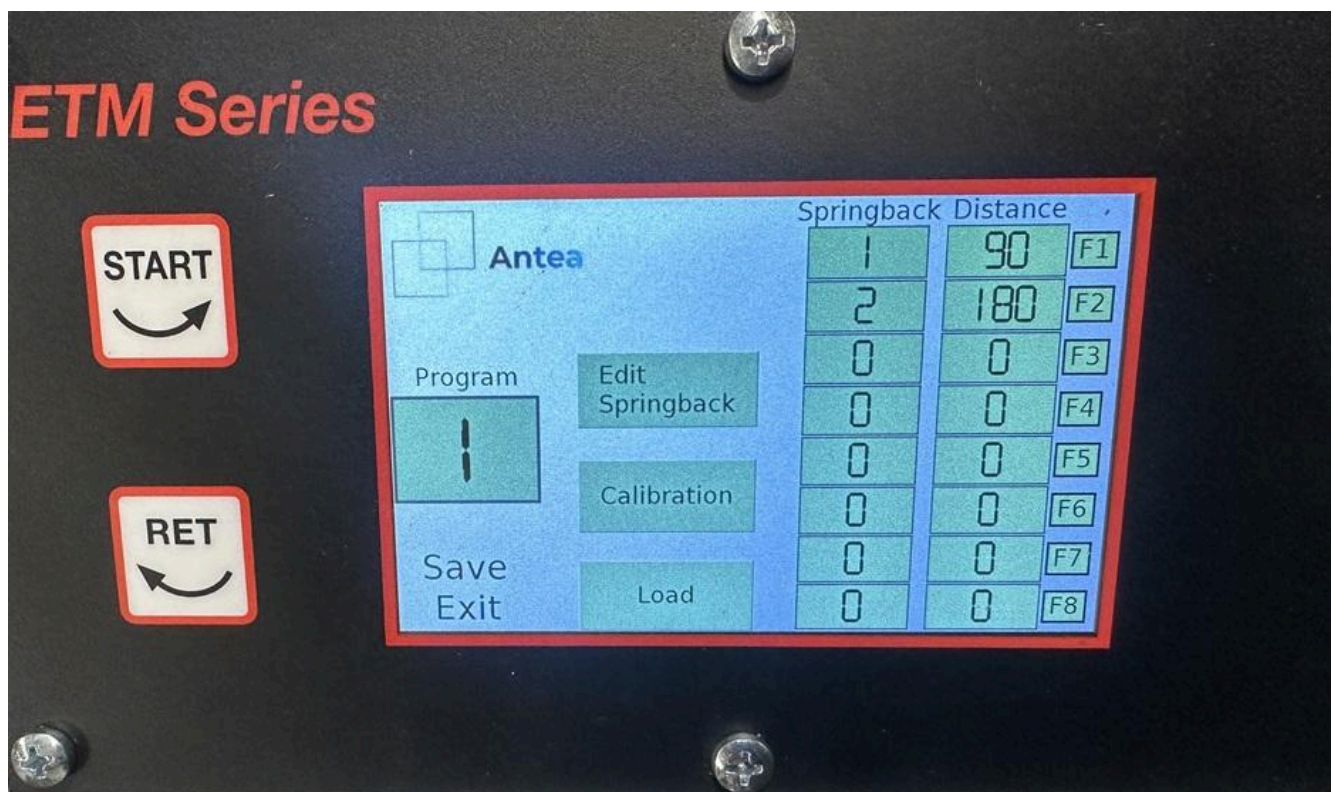




# NEW ICARO Digital Angle Controller

## Operation Manual

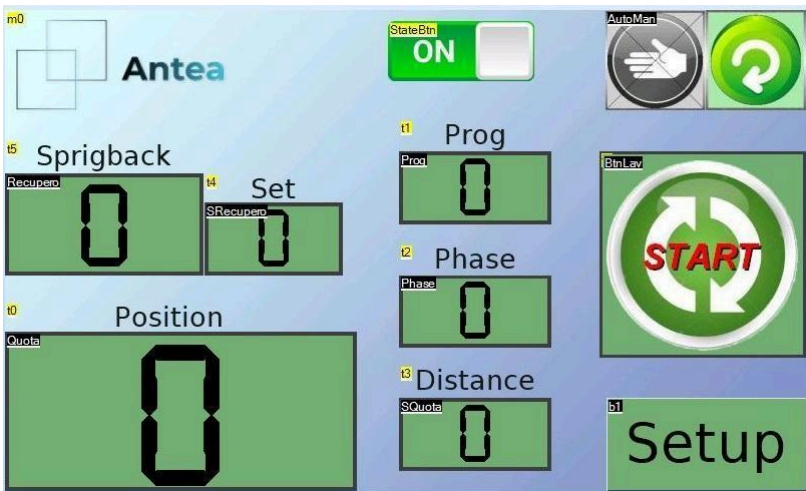


# MAIN SCREEN

When the control system is switched on, the following screen appears with a customer logo if applicable:



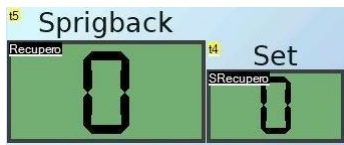
After a few seconds, the screen changes and the main screen appears



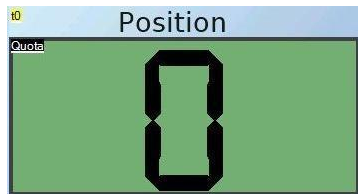
With these two buttons you can choose the type of work:  
**MANUAL** where the bend angle is determined by the position of the pegs placed in the perforated wheel.  
**AUTOMATIC** where the bend angle is determined by the measurement set in the running program and measured by the encoder



The **'Prog'** box indicates the number of the programme in execution.  
The **'Phase'** box indicates the number of the phase being execution  
The **'Distance'** box indicates the angle measurement to be executed



The 'Set' box indicates the set point value for the angle of (Springback) of each individual phase.  
The 'Springback' box displays the value of the recovery angle in real time. of the recovery angle



In the ' Position ' box, the value of the bend angle is displayed in real time. of the bend angle.



Machine status indicator, if **GREEN** indicates that the machine is ready to start, if **RED** indicates that the machine is paused because the pause button has been pressed.



Indicates which button to press to start the process, ' START ' to start the fold ' RET ' to return the machine to the starting point.

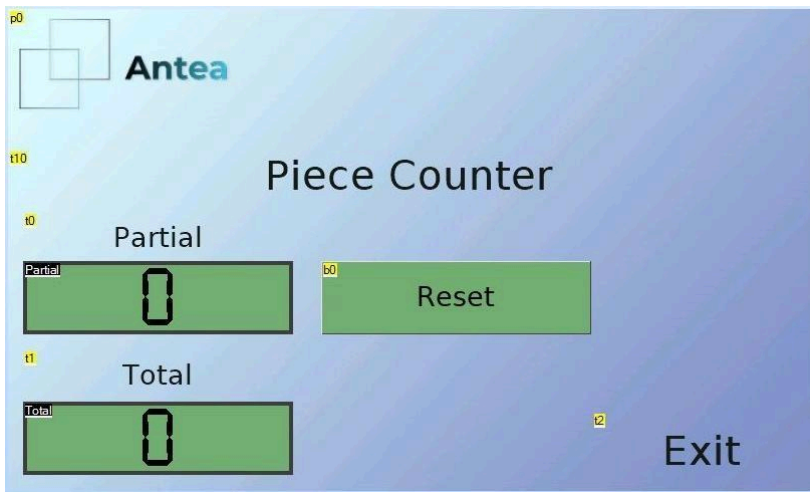


If you press the logo in the dot, you go to the Piece Counter page ' Piece Counter '.



Pressing the ' SETUP ' button takes you to the SETUP page where you set the programmes and work steps

PIECE COUNTER ‘ PIECE COUNTER ’ PAGE



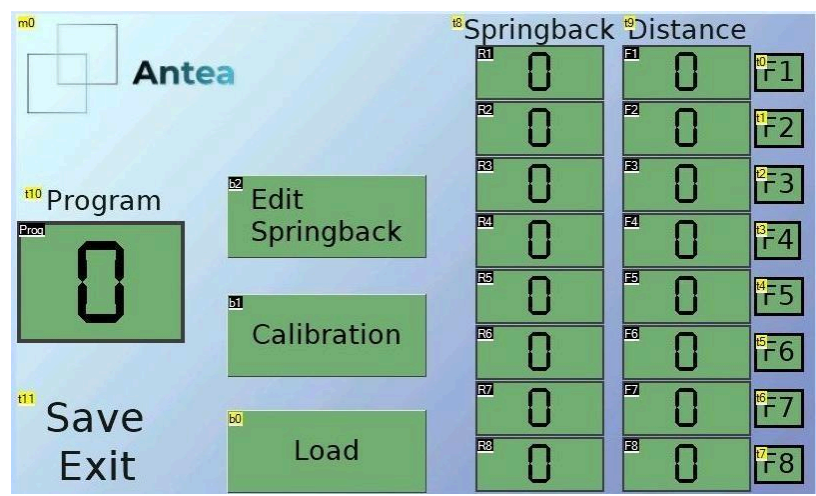
Partial piece counter, can be reset by pressing the RESET ' button



Total piece count

Press EXIT to return to the main page

# SETUP PAGE



By touching the ' Program ' button, a keyboard appears allowing you to load, modify or generate the chosen programme once selected by pressing the E button. To load the chosen programme, press the ' Load ' button.

**F1 F2 F3 F4 F5 F6 F7 F8** These are the number of folds (Distance) in angle recovery sequence (Springback) that can be made for each programme. To set the fold measurement and Springback if any, touch the corresponding button, a keyboard appears, type in the measurement to be made and press the E button. Repeat the operation for the other folds to be made and any Springback. Once all fold measurements and any springbacks have been entered, the remaining measurements up to **F8** must be set to ' 0 '.



Pressing this button takes you to the MACHINE PARAMETERS page

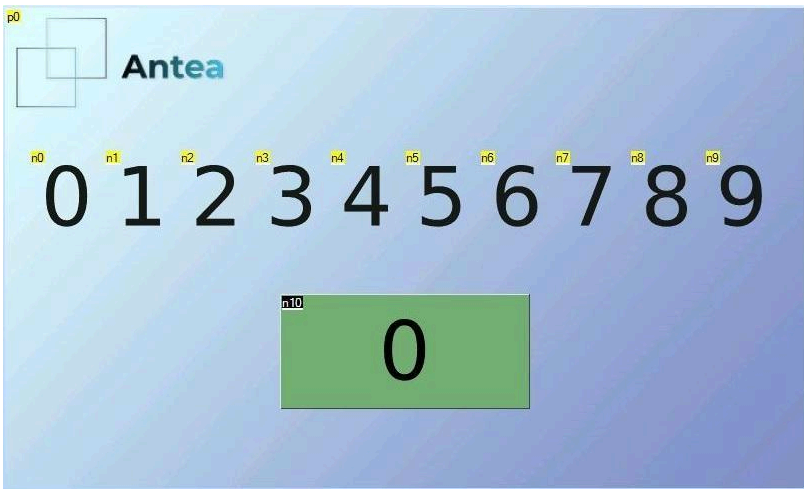


Pressing this button saves the generated programme and returns you to the main page

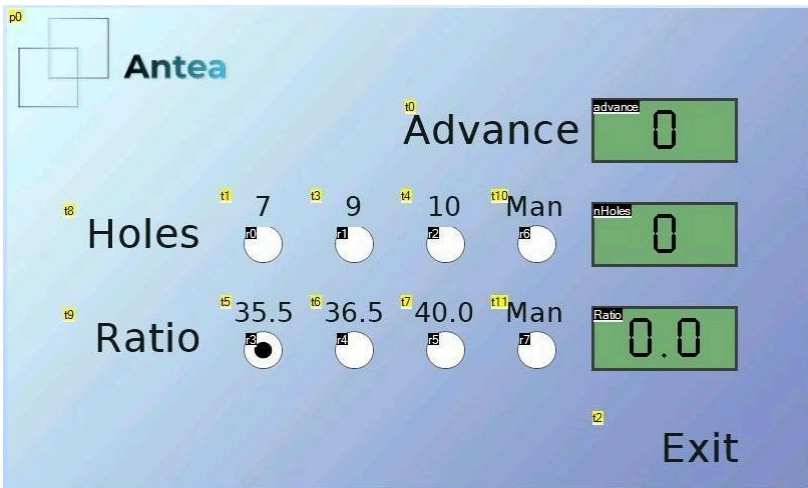


# MACHINE PARAMETERS PAGE

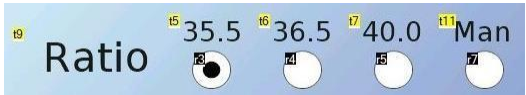
To enter the **MACHINE PARAMETERS** page you need the Password: 1409



In the green box '0' the password is written, press the box and the following page appears



Here, you can select the number of holes on the encoder wheel—7, 9, or 10. If you choose the "MAN" option, you can input a custom number instead of the default options. To do this, simply tap the green box on the right and enter the desired value using the keyboard.



Here you select the folding speed reduction ratio. If you select "MAN" you can put a different number from the basic ones, to do so touch the green box on the right and enter the figure using the keyboard.



With this parameter you can correct the starting position of the bend angle, to do so touch the green box on the right and enter the data using the keyboard.

**Press EXIT to return to the main page**

## WARNING

If this screen appears when the machine is switched on or after an EMERGENCY or alarm, it means that the machine was stopped while it was folding. To restart it, press the return button to bring the machine back to the starting point.

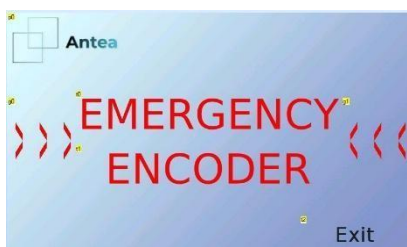


## ALARMS

Alarms or malfunctions may occur during work and are displayed like this :



Emergency button pressed



Encoder not responding or fault



Reverse limit switch not responding or defective



End-of-rotation microswitch not responding or defective

**Press EXIT to reset the error and return to the main page**

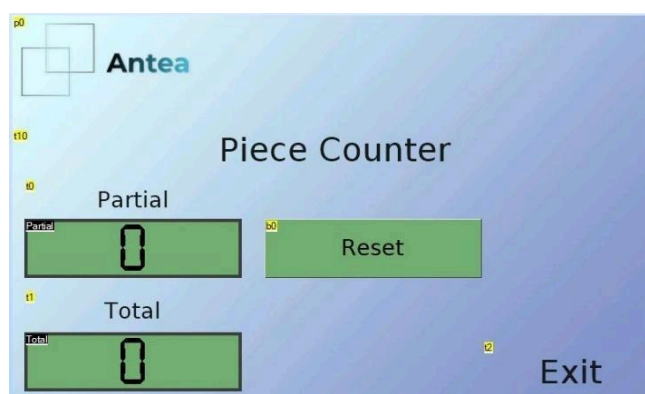
## INSTRUCTIONS RESERVED FOR THE MANUFACTURER

To change the logo of which is displayed when the machine is switched on or to delete the total number of parts made :

1. Enter the SETUP page, press the image, and enter the password 9041. This will take you to the LOGOS change page. Enter the numbers in the green boxes labelled Splash 1 and Splash 2 to update the logos.



2. Enter the SETUP page by pressing the image and entering the password 4091 you enter the product parts reset page, pressing the RESET button resets the part numbering to zero.



**Press EXIT to return to the main page**