

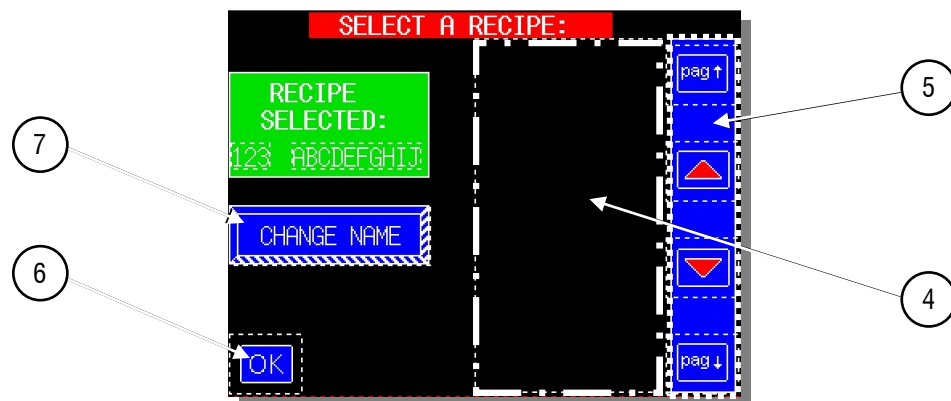
10.2 - NEW PROGRAM/RICIPE

It is possible to edit a new program/recipe working as following:

- ▶ by modifying an existing program/recipe (as described in chapter 10.1 and 10.3);
- ▶ from "STOP CYCLE" screen-page as described in this procedure:

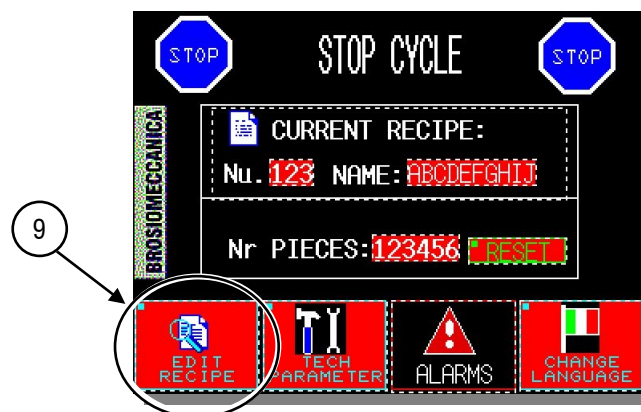
È By selecting the "number" [2] or "name" [3] icon in "Current Recipe" of screen-page "STOP CYCLE" the display will show following screen-page:

picture 39 - SELECT A RECIPE



- È scroll the memorised recipes list [4] by using the controls at the right side of screen-page [5] until you reach an "EMPTY" position;
- ì press the "CHANGE NAME" icon [7] and digit the proper name for the program/recipe that must be created by acting as described in paragraph 10.1
- í press "OK" [6] to confirm the program/recipe to be used. The "STOP CYCLE" screen page will appear again;

picture 40 - EDIT RECIPE



- î press the "EDIT RECIPE" icon [9] in order to set the recipe parameters. Act as described in following paragraph (10.3).

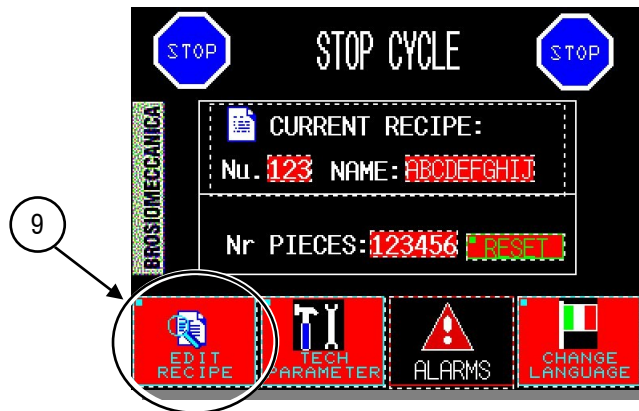
10.3 - PROGRAM/RECIPE MODIFICATION

To modify a program/recipe use "EDIT RECIPE" function.

It is possible to select this function from:

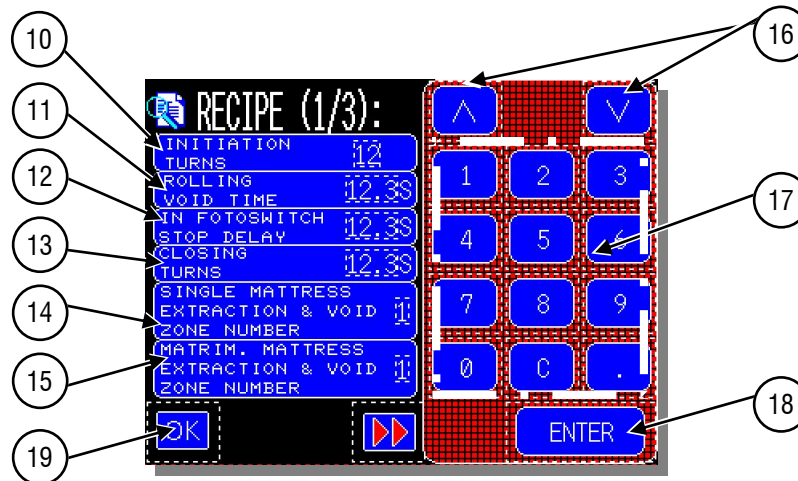
- ▶ "CYCLE IN PROGRESS" screen-page (see chapter 9)
- ▶ "STOP CICLO" screen-page (see chapter 9)

picture 41 - EDIT RECIPE



By selecting "EDIT RECIPE" [9] the display will show following screen-page.

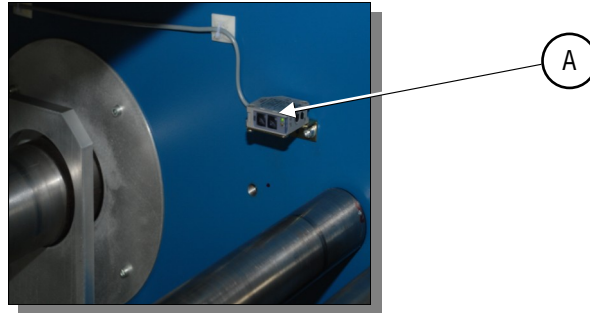
picture 42 - RECIPE PARAMETERS 1



This parameters allows to program:

- ▶ mandrel turning speed during the "feeding" initial phase [10];
- ▶ vacuum duration time during the "feeding" initial phase [11];
- ▶ mandrel stop delay after entrance photocell (A) stops detecting the mattress [12];

picture 43 - ENTRANCE PHOTOCELL




- ▶ mandrel rotation time during the "closing" phase [13];
- ▶ number of mandrel-zones used for single mattress rolling-up [14];
- ▶ number of mandrel-zones used for double mattress rolling-up [15].

To program the parameters operate as follow:

- select with the arrows the data to be modified [16];
- ⌂ by using the numeric keyboard [17] write the desiderated value;
- ⏎ press "ENTER" [18] to confirm the value.

To return to "STOP CYCLE" initial screen-page push OK (19).

To proceed to next page of "edit recipe" 



NOTE

In order to confirm the modification of one data after its digiting, it is necessary to press "ENTER" , otherwise the data will not be modified.

picture 44 - RECIPE PARAMETERS 2



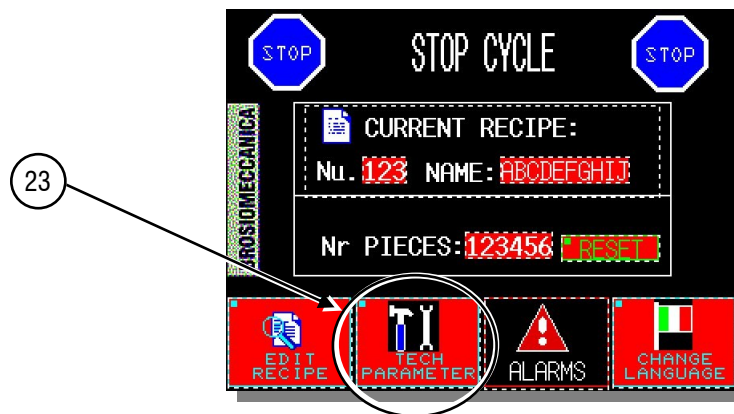
These parameters allows to program:

- ▶ the single mattress compressing pressure value (20);
- ▶ he double mattress compressing pressure value (21);
- ▶ the calender compressing delay (22).

10.4 - TECHNICAL PARAMETERS

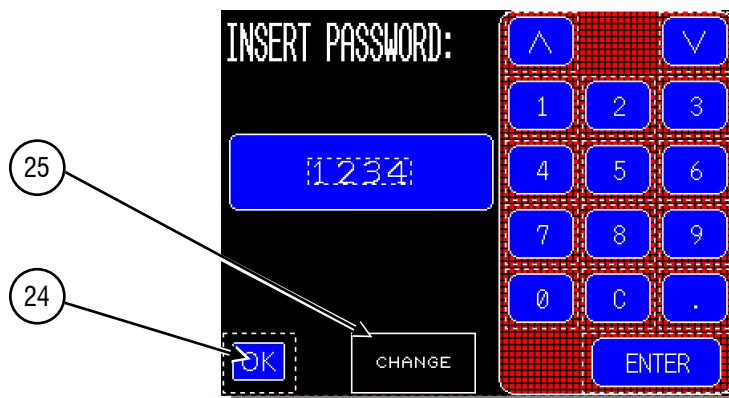
It is possible to proceed to this function from "STOP CYCLE" page (see chapter 9) by selection "TECHNICAL PARAMETER" screen-button [23].

picture 47- STOP CYCLE



To modify the technical parameters it is essential to digit the correct password.

picture 48 - TECHNICAL PARAMETERS PASSWORD



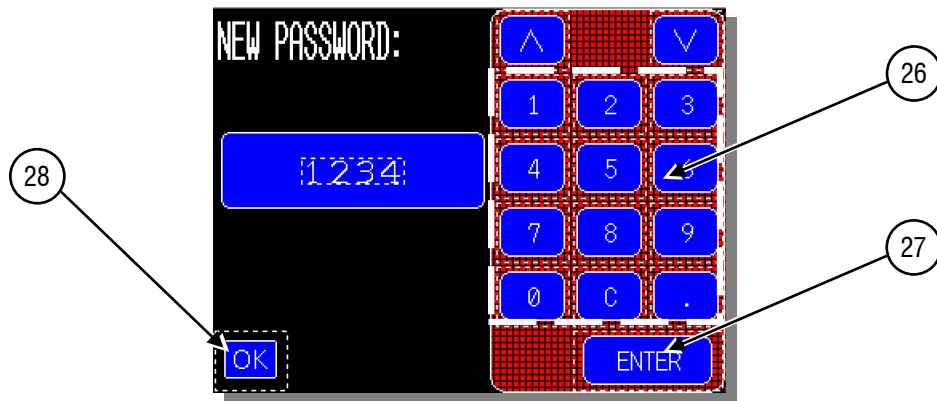
After correct digiting of the password, Figure 33, it is possible to proceed to

- ▶ modify the "TECHNICAL PARAMETERS" [24];
- ▶ "CHANGE PASSWORD" [25].

10.4.1 - Inserimento nuova password

After correct digiting of the password, Figure 33, it is possible to proceed to "CHANGE PASSWORD" screen-page:

picture 49 - TECHNICAL PARAMETER NEW PASSWORD



Write the new password by using the virtual keyboard [26] and confirm it with "ENTER" [27].

To return to "INSERT PASSWORD" initial screen-page push "OK" [28].

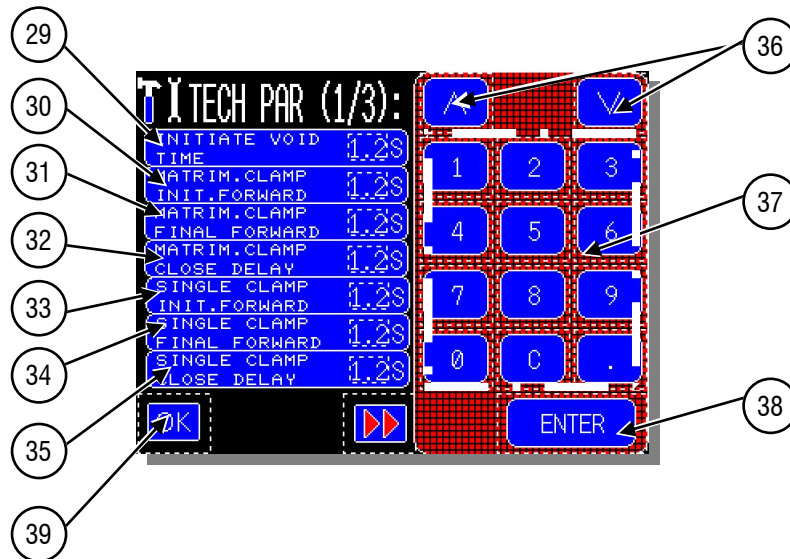
10.4.2 - Technical parameters modification



NOTE The setting/modification of technical parameters can be executed exclusively by qualified technical personnel, authorized by the Customer

After correct digiting of the password by pressing OK it is possible to proceed to "TECHNICAL PARAMETER" screen-page:

picture 50 - TECHNICAL PARAMETER PAGE 1



In this page it is possible to program:


- ▶ the vacuum duration time during the "feeding" initial phase [29];
- ▶ the double mattress film robot-hands initial advancing time [30];
- ▶ the double mattress film robot-hands final advancing time [31];
- ▶ the double mattress film robot-hands closing delay [32];
- ▶ the single mattress film robot-hands initial advancing time [33];
- ▶ the single mattress film robot-hands final advancing time [34];
- ▶ the single mattress film robot-hands closing delay [35].


To program the parameters operate as follow:

- ➊ select with the arrows the data to be modified [36];
- ➋ by using the numeric keyboard [37] write the desiderated value;
- ➌ press "ENTER" [38] to confirm the value.

To return to "STOP CYCLE" initial screen-page push OK (39).

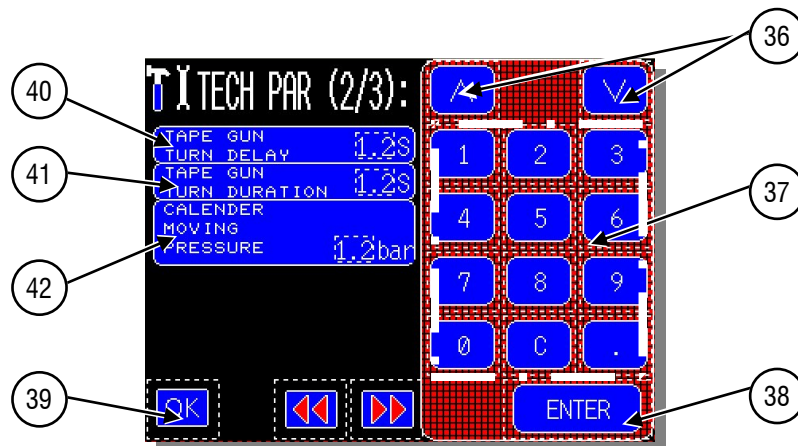
To proceed to next page of "TECHNICAL PARAMETER" 

 **NOTE** In order to confirm the modification of one data after its digiting, it is necessary to press "ENTER" , otherwise the data will not be modified.

 **NOTE** The robot-hands closing-delay time-adjusting, allows to modify the amount of plastic film that will be pushed forward.

The second page of technical parameter is the following:

picture 51 - TECHNICAL PARAMETER PAGE 2

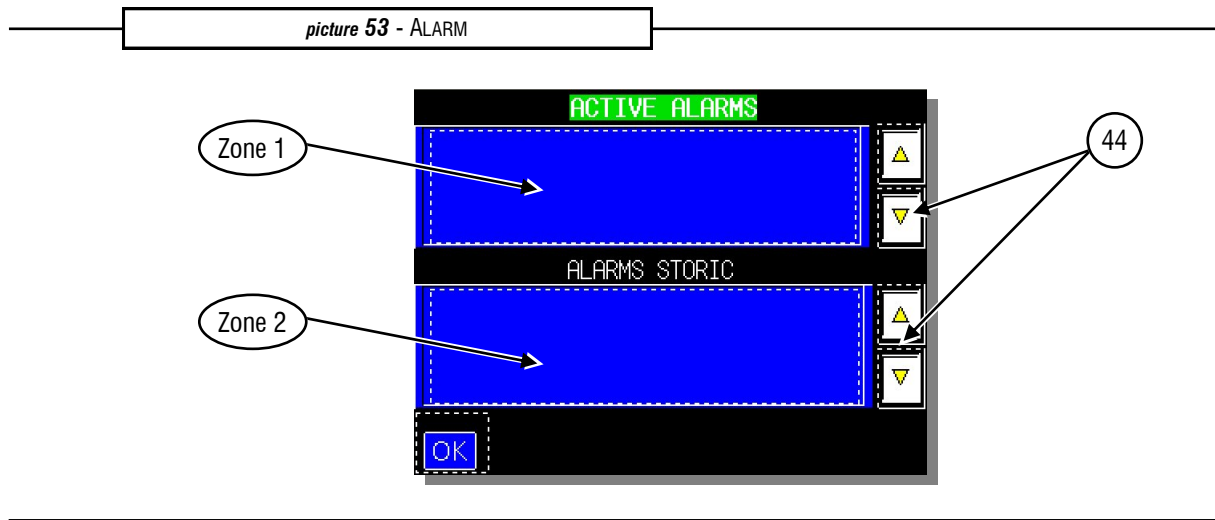


In this page it is possible to program:

- ▶ the scotch-tape holding-bar rotation delay after the mattress has been closed [40];
- ▶ the time between the scotch-tape guns rotation and their return to the initial condition [41];

10.5 - ALARM

In this paragraph, the possible machine alarm signals are described:



The **ALARM** page is divided in two parts:

- ▶ Zone 1: where the present alarms on the machine are described
- ▶ Zone 2: where the historic list of alarms happened to the machine are filed

In order to scroll the alarm list, use arrows [44]

10.5.1 - Alarm reset

TABLE 4 - Alarm list

alarm	description	solution
EMERGENCY STOP	Abrupt machine STOP after having pressed the emergency mushroom pushbutton.	<ul style="list-style-type: none"> • <i>turn lightly the depressed push-button and press the "auxiliaries insertion" pushbutton</i>
LACK OF AIR	Machine stop due to low compressed-air pressure	<ul style="list-style-type: none"> • <i>it resets automatically as soon as the air pressure value returns as set by pressure-regulator</i>
MOTORS THERMIC PROTECTION	Machine stop due to an overcharge in one or more electric motors	<ul style="list-style-type: none"> • <i>eliminate the reason for the motor overcharge and press the "auxiliaries insertion" pushbutton .</i> • <i>call a specialised technician.</i>



IMPORTANT

After having solved an anomaly on the machine, proceed to the "ALARMS RESET" by pressing the "AUXILIARIES INSERTION" pushbutton [7] that will set-back the machine in working position.

10.6 - SETTING

In this paragraph some particular settings are described that must be executed anytime a working phase with mattresses or materials of different type is started.

10.56.1 - Mattress diameter

It is possible to adjust the rolled-up mattress diameter:

- Ê **by increasing or reducing the calender compressing pressure in rolling-up phase**, acting on "SINGLE MATTRESS PRESS. PRESSURE" [45] and "MATRIM. MATTRESS PRESS. PRESSURE" [46] at page 2 of "EDIT RECIPE"

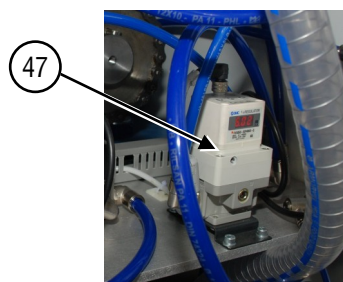
picture 54 - EDIT RECIPE PAGE 2



NOTE The calender air pressure should normally be set between 0,1 and 5 bar

NOTE Parameters (46) and (46) act on electropneumatic regulator (47)

picture 55 - ELECTROPNEUMATIC REGULATOR

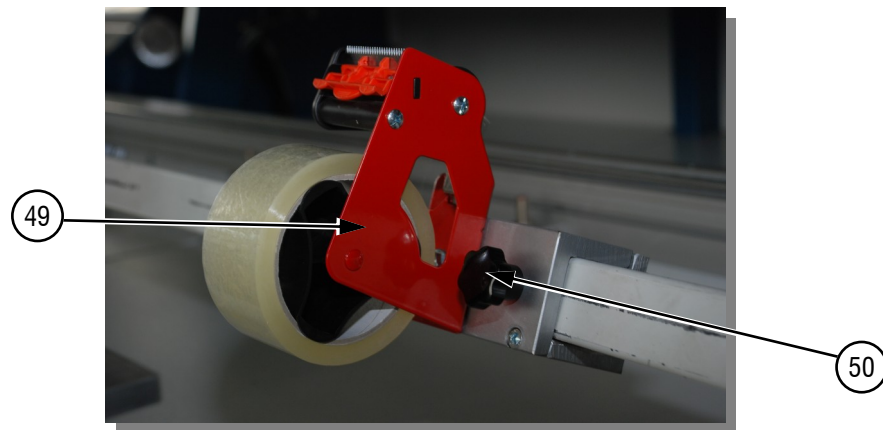


10.6.2 - Scotch-tape holding-bar

The scotch-tape holding-bar controls the mattress sealing after its rolling-up.
There are three parameters for its correct working:

È **mechanical**: it is possible to adjust the scotch-tape guns [49] position sliding them on the bar after loosening knob [50].

picture 57 - SCOTCH-TAPE GUNS



ATTENTION

LOCK KNOB [83] AFTER POSITIONING THE SCOTCH-TAPE GUN.

È **pneumatic**: by acting on descent [51] and lift [52] pressure regulators to adjust the scotch-tape guns pressure and working speed.

picture 58 - PRESSURE REGULATORS



NOTE

The working pressure must be set between 4 and 5 bar for lifting
and between 2 and 5 bar for descending.

