



- ★ To reset current counter value to 0, press **RST** button only when machine is stopped.
- ★ To enter in the TOTAL display mode, press **TOTAL** button. Now see the WHOLE TOTAL counter value or TOTAL valve of A, B & C shift by pressing **SHIFT** button again & again. If to reset the total value of A, B or C shift to 0, press **RST** button after displaying its value.
- ★ To come to the normal display mode, press **TOTAL** button. Note that WHOLE TOTAL counter can not be reset to 0.
- ★ To FLUSH the oil, when machine is stopped, press and hold **SET** & **TOTAL** buttons together.
- ★ To switch ON the FANS when machine is stopped, make the MOTOR button OFF, then press  button to start the FANS and press  button to stop them.
- ★ To display the no. of total FABRIC ROLLS produced, press **SET** & **SHIFT** buttons together. If to reset the ROLL value, press **RST** button. Press **SET** & **SHIFT** again to exit.

HOW TO ENTER VARIOUS DISPLAY & SETTING MODES :

- ★ Press & Hold **SET** button to enter the setting modes as SET, StP CAUSE, no/nc StoP, YES/no OPEn2, no/nc door and YES/no rStd.

NOTE : Leave the SET button when desired setting mode displayed, make changes as needed, then press **SET** button to exit the setting modes and to save the new setting.

Display Mode

Explanation of Display Modes

StP CAUSE

In this mode, controller will show the reason of last machine stop by glowing its led e.g TOP, BOTTOM or NEEDLE etc.

Setting Mode

Default Setting

Explanation of Setting Modes

SET	5	Set the desired Counter Value by pressing TOTAL & SHIFT buttons.
no/nc StoP	no	Change to 'nc' by pressing SHIFT button, if to use NC STOP push buttons.
YES/no OPEn2	YES	Change to 'no' by pressing SHIFT button if not to use OPEN 2 function at all.
no/nc door	nc	Change to 'no' by pressing SHIFT button if to use NO Safe Door Switches.
YES/no rStd	no	Change to 'YES' by pressing SHIFT button if to use RESET type needle detectors. Also change the jumper to YES (near the 1N5408 diodes in the back card), to activate the function.

JUMPER SETTINGS

DEFAULT JUMPER SETTING (Relay Card)

Oiler Coil	- Voltage Output	(Change both jumpers if relay output required)
Speed Change	- From Panel	(Change if Speed to be changed from AC DRIVE)

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PREMIUM FEATURES (Over All Other Panels)

AC Drive Error Handling : When there's an error in the AC Drive, machine stops suddenly and the AC Drive shuts off before you can see the error. With our panel, the machine stops quickly in case of an AC Drive error, but it waits 10 seconds before turning off the drive. This gives you time to read the error and arrange for repairs.

Power Saving Feature : Side lamps are automatically turned ON when the door is opened for fabric roll cutting and off when the door is closed, eliminating the need to keep them ON continuously.

Total Fabric Roll Counting : Now you don't have to count the fabric rolls manually, our panel will count the total number of fabric rolls produced and will display it to help you track production.

RESET Button Lock : The reset button is automatically locked while the machine is running or jogging to prevent accidental counter resets.

Displays The Reason of Machine Stoppage : Our panel shows the last reason of machine stoppage. Specially in case of vibrating IRO's, when machine stops again and again without any indication, the reason of stoppage can be displayed to quickly identify issues without wasting the time and boosting the production.

Push Button Indication on Display : If JOG, RUN, or STOP push button is pressed, stuck, or becomes direct, it will be displayed on the display. Unlike other panels that lack this feature, our display immediately alerts the machine operator or electrician about the issue. This saves time and increase production by eliminating the need to check every aspect of the machine to identify the problem.

Roll Completion Indication : Roll completion status is also displayed on the display.

Stop Buttons NO/NC Setting : STOP push buttons type (NO/NC) can be configured via the setting, eliminating the need to change machine's wiring. Simply go to settings and select the STOP push button type as NO or NC.

OPEN 2 Function Setting : If not needed at all, OPEN 2 function can be deactivated via the setting, Simply go to settings and select the OPEN 2 as no.

Safe Door NO/NC Setting : Safe Door type (NO/NC) can be configured via the setting, eliminating the need to change machine's wiring. Simply go to settings and select the Safe Door type as NO or NC.

Switch Protection : If TOP LAMP, FAB LAMP, or FAN switches were ON before a power failure, they will automatically be switched ON with a small delay upon power restoration, increasing the life span of switches.

Reset Switch Protection : When a fabric roll completes, the counter can be reset from the panel's reset switch or by pressing any STOP and RUN push buttons together, increasing the life span of the RST switch.
NOTE : Counter will not get reset from STOP and RUN push buttons, before the completion of the fabric roll.

OPEN 1 Option : The OPEN 1 function works from the COMPEL switch or by pressing the JOG and STOP push buttons together, while jogging.

PROTECTION FEATURES (Against Common Problems)

Protection against IRO Wire Short Circuit : Unlike China Panels, If TOP, BOTTOM, or NEEDLE DETECTOR wire directly touches the machine body, no internal circuit damage will happen to the panel board. Moreover panel board will show the IRO SHORT indication and also which IRO wire has touched the machine body.

Protection against Counting Sensor Short Circuit : Unlike China Panels, if the COUNTING or SAFE DOOR sensor's +VE and -VE wires are shorted together or the sensor itself gets short circuit, by any reason, no internal circuit damage will happen to the panel board.

Machine Speed Jerk Protection (Mechanically) : Panel board will gradually decrease the machine speed to 1/4 of the running speed in last 2 rounds before roll completion rather than suddenly turning the speed to JOG SPEED or stopping the machine with jerk, after roll completion, avoiding mechanical jerks.

AC Drive Protection : When the machine is running, the motor cannot be turned OFF directly even by pressing the motor switch to prevent damage to the AC drive caused by sudden voltage drop. Motor switch will work only when machine is stopped.

P.T.O.