CONTROL UNIT INTRODUCTION

INDICATING LAMPS

LAMP	DESCRIPTION
ON	It indicates if the power source is connected to the machine or not.
READY	The crowing system is in position "0" and ready to start the crowning cycle.
FORWARD	The crowning system is started and in the first half of the cycle.
REVERSE	The crowning system is started and in the second half of the cycle. During crowning cycle, when the wheel reaches the center of the roller, the "FORWARD" lamp will turn off and "REVERSE" lamp will turn on.
INTTERUPT	It indicates that the system is in "interrupted position", the user needs to press the "HOME" button to make the system go back to position "0" and ready to start another cycle.

CONTROL BUTTONS

BUTTON	DESCRIPTION
MOTOR ON	Pressing it to start the main motor.
MOTOR OFF	Pressing it to stop the main motor.
FEED ON	Pressing it to start the crowning cycle.
FEED HOME	Under interrupted condition, pressing this button to re-set the system to ready condition.
FEED INTTERUPT	Pressing it to stop the system during crowning cycle.

FEED MOTOR CURRENT

The meter indicates the current of the feed stepping motor. If it indicates at zero, it means there is something wrong with the stepping motor.

TIMER

Its function is to assist the user in measuring the actual time of grinding a roller. The display is in "second" units.

BUTTON	DESCRIPTION
START	Pressing "START" to start the counting of the timer.
PAUSE	Pressing "PAUSE" to freeze the display figure for the users to read it. Attention: Pressing "PAUSE" does not stop the counting procedure, and the timer is still in work. It only pause the display figure.
RESET	Pressing "RESET" to terminate the counting and return the display to zero.

CONVEX & CONCAVE SWITCH

Convex = Grinding a roller to convex (crown) shape.
Concave= Grinding a roller to concave shape.

- Cylindrical is the basic function, users do not have to set anything with the control unit.