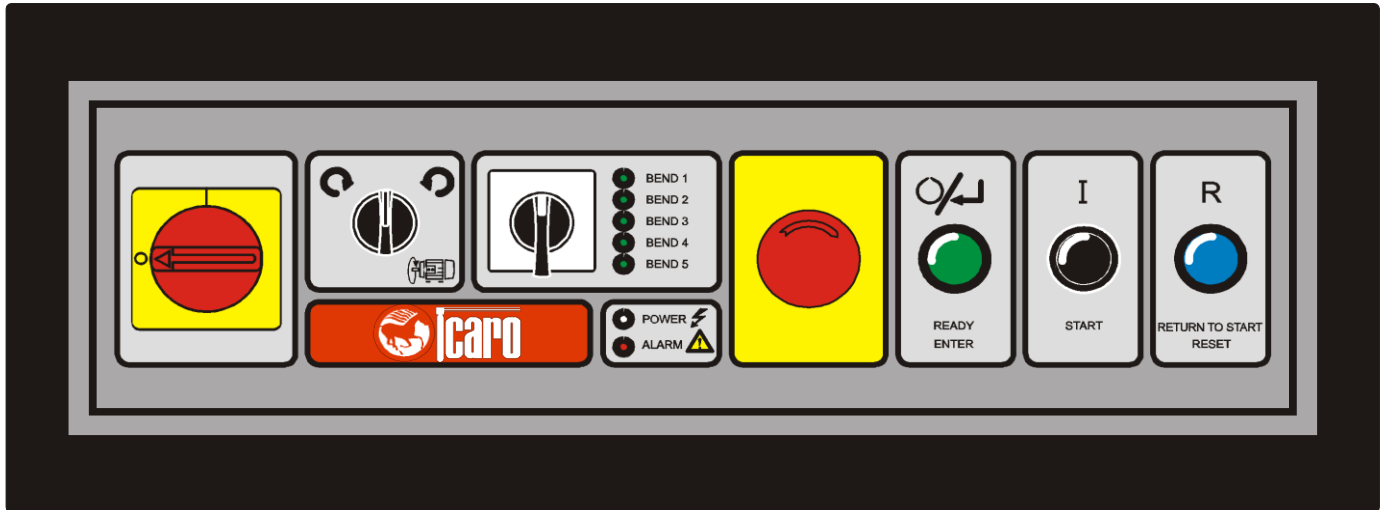# ICARO 5 BEND CONTROLLER
OPERATOR'S MANUAL

OPERATION GV153 "BENDING DRIVE"

This board fed 24VAC, manages the working and the check of the limit switches of the machine, moreover through a simple function it allows the storage of five times, maximum, to realize bending sequence.

Bending times settings:
After the on-switch and the machine in 0 position, select by the selector (0-1-2-3-4-5) the bending to set, so that both the associated lamp and the running machine lamp will blink. Put in the pin for the desired measure and by the start button make the plate turn till the stop point indicated by the pin, then bring back the plate to the 0 position by the return button. Now pressing the bright button you can store the bending, the fast blinking of the led signals the bending successful storage.
Go on in this way for the following bending. Finished the storage operation bring back the selector to the 0 position.
To zero a bending time previously stored, choose the associated bending and keep the "RESET" button pressed for 4 sec., the zero setting of the measure is signalized by a quick on-switch of the leds that point out the bending times.
The program remains stored even after switching off the machine.
To reset all the bending times switch on the machine keeping the "RESET" button pressed.
It is possible also to store an anticlockwise bending with the proper selector during the programming cycle phase (verify that the equipment allows that).

Bending cycle stored:
When at least one time is stored, bringing back the bending selector to the 0 position the machine carries out the bending in sequence. This function is indicated by a on-switch sequence of the lamps as follows:

-blinking led= bending time you are carrying out
-fixed lit led= current bending time
During the cycle also the start machine lamp is blinking.

Various warning signals:
Warning signals managed by the board are pointed out by a blinking/pauses code on the warning led as follows:

Alarm 1 – fixed on-switch= carter limit switch or cutter intervening
Alarm 2 – non-stop blinking= warning machine not in zero position
Alarm 3 – 1 blink, 1 pause= warning breakdown zero limit switch
Alarm 4 – 2 blinks, 1 pause= warning breakdown reversal limit switch
Alarm 5 – 3 blinks, 1 pause= warning timeout on-switch command contactor
Alarm 6 – 4 blinks, 1 pause= warning breakdown command contactor
Alarm 7 – 5 blinks, 1 pause= warning breakdown reversal or zero limit switch

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