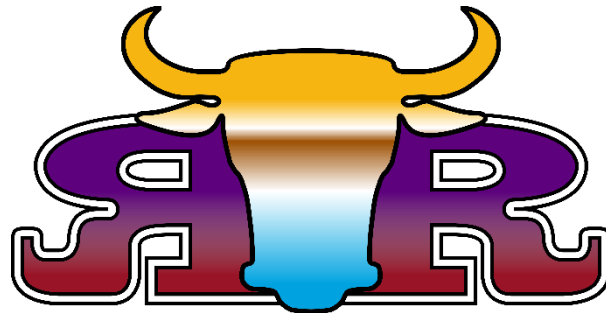


R & R Machine Works Inc.



RR1000 Manual

We really appreciate you making this purchase from us and we hope the equipment meets your expectations. We strive to sell equipment that will make your business as well as ours, prosper. When you have future equipment or service needs please think of us first!

If we can be of further services to you or your company,
please call us at (806) 244-5686.

Sincerely,

Owners and Management

Dalhart R&R Machine Works, Inc. .

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Limited Warranty

The manufacturer warrants this equipment to the original user against material or workmanship for a period of 30 days from the date of purchase on repair parts and labor. The manufacturer's responsibility under this warranty is limited to the repair or replacement of defective part or parts.

The manufacturer reserves the right to determine whether the part or parts failed because of material, workmanship, or other causes. Failure caused by accident, alteration, or misuse is not covered by this warranty.

A DALHART R&R MACHINE WORKS, INC. representative must perform all warranty repairs. Any repair to the equipment other than by this authorized facility voids this warranty. The rights under this warranty are limited to the original user and may not be transferred to subsequent owners.

The warranty is in lieu of all other warranties, expressed or implied, including warranties for a specific purpose.

Purchaser, Representative

Yard or Company Name

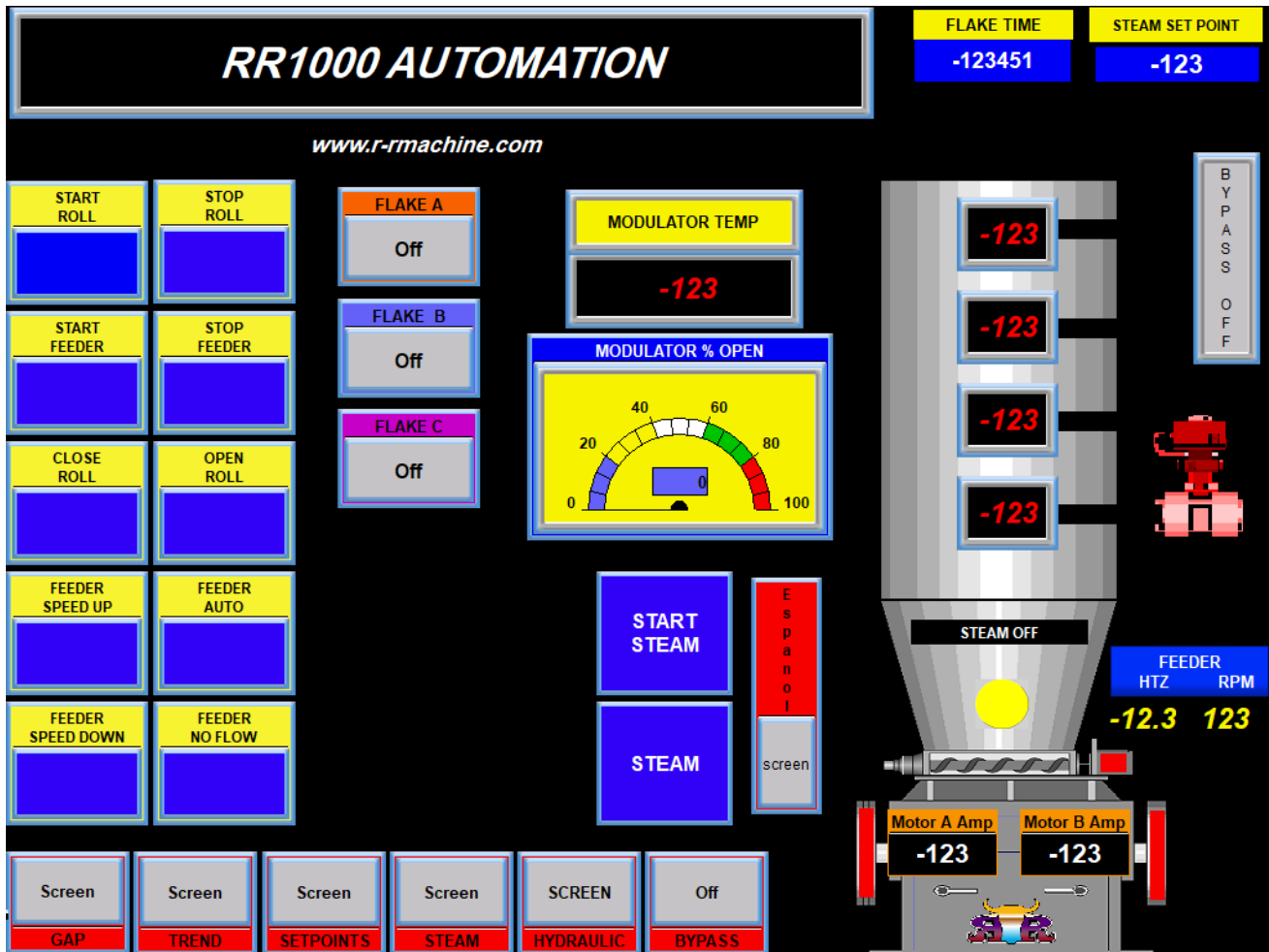
If You Are Doing Sub-Contract Work, Write In The Feed Yards Name Here.

Date



Mill Start Up Procedure

(New Mill and After Roll Changes)



1. Touch Screen and Select "Start Roll".
2. Select Start Feeder and select Approx. 20 Hz.
3. Select "Flake A".
4. Touch "Close Rolls".
5. Check flake weight



Gap Adjustment

The screenshot displays a control panel for gap adjustment. At the top left are 'CLOSE ROLLS' and 'OPEN ROLLS' buttons. At the top right is a 'BYPASS' button set to 'Off'. The main area contains several parameter boxes: 'Gain', 'Reset Time', and 'Rate', all set to -12345. Below these are 'Scale Cyl. "A" Left' and 'Scale Cyl. "B" Right', also set to -12345. A 'Rolls Open Set Point' is set to -12345. On the left side, there are three 'Flake' settings (A, B, C) all set to 'Off', each with a corresponding 'Gap Set Point' box set to -12345. At the bottom left are 'Principal' and 'Espanol' language selection buttons, both set to 'Pantalla'. At the bottom right are two scale displays: 'Scale Cyl. "A" Left Side' and 'Scale Cyl. "B" Right Side', both showing a scale from 0 to 32767 with a green bar and a '0' value.

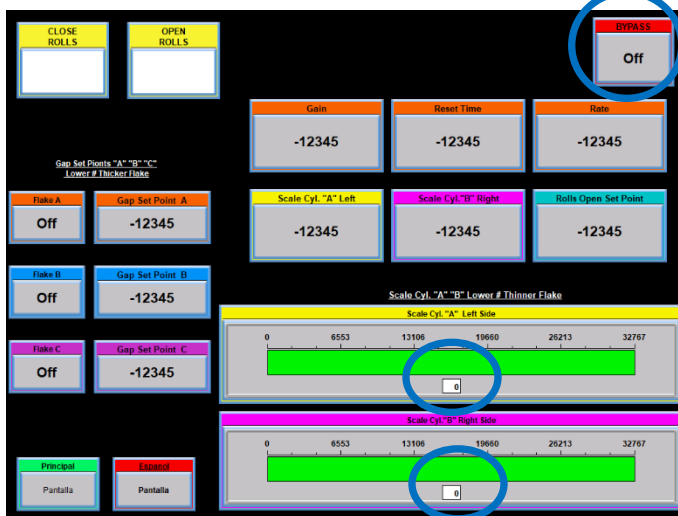
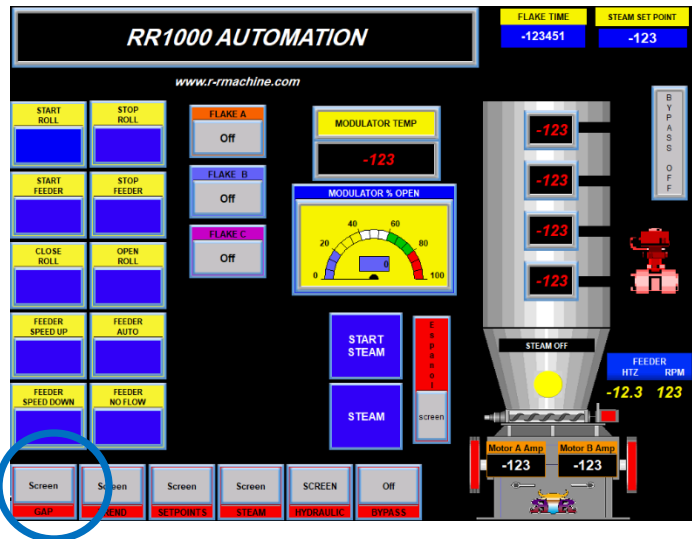
Increasing the “Gain” will increase the reaction time. Be sure to have a preset “Gap Set Point” for Flake A, Flake B, and Flake C before using any flake settings.



Set flake weight with Machine in Bypass mode.

(New Mill & After Roll Change)

Select “Gap Set Screen”



Gap Screen

1. Select Bypass—ON
2. “Roll Open Set” input 4500
3. Scale A & B input 30000
4. Gap Set Point A input 30000
5. “Gain” input 15.
6. “Reset Time” input 3.
7. “Rate” input 0. - 0

Note: 0.060” = 125 points

Gap Set Point = Greater the number the **thinner** the flake.
 Scale = Greater the number the **thicker** the flake.

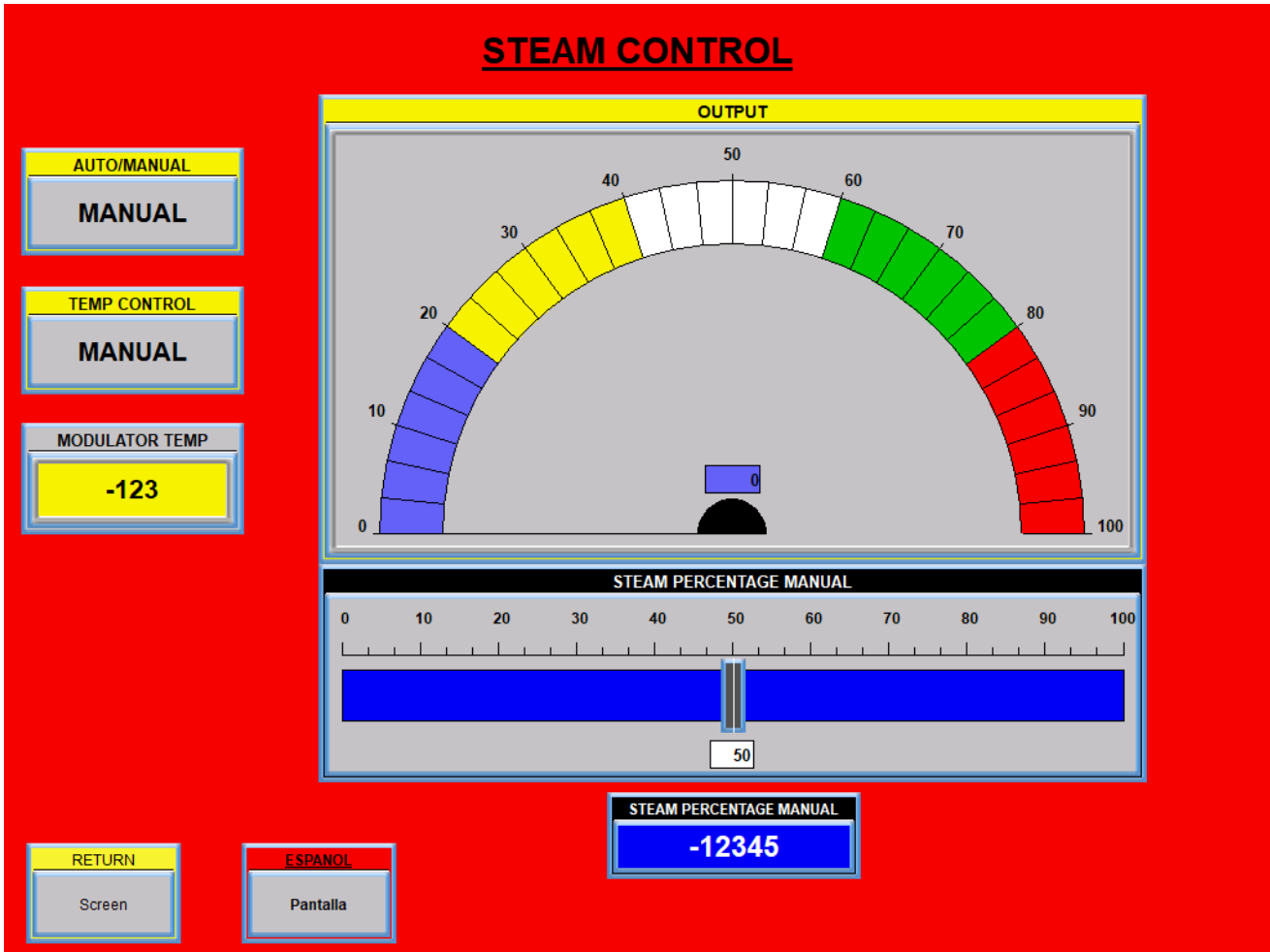
*Notice the graph numbers displayed under Cylinders A & B. (Circled in BLUE).

1. Subtract 100 from the smaller number of the graph and input that number in the “Gap Set Point (A)”.
2. Check the flake weight.
3. If flake weight is incorrect, touch “Scale B” and adjust according. Then press “Enter” to finish.
4. Check the flake weight again.

*Repeat if necessary.



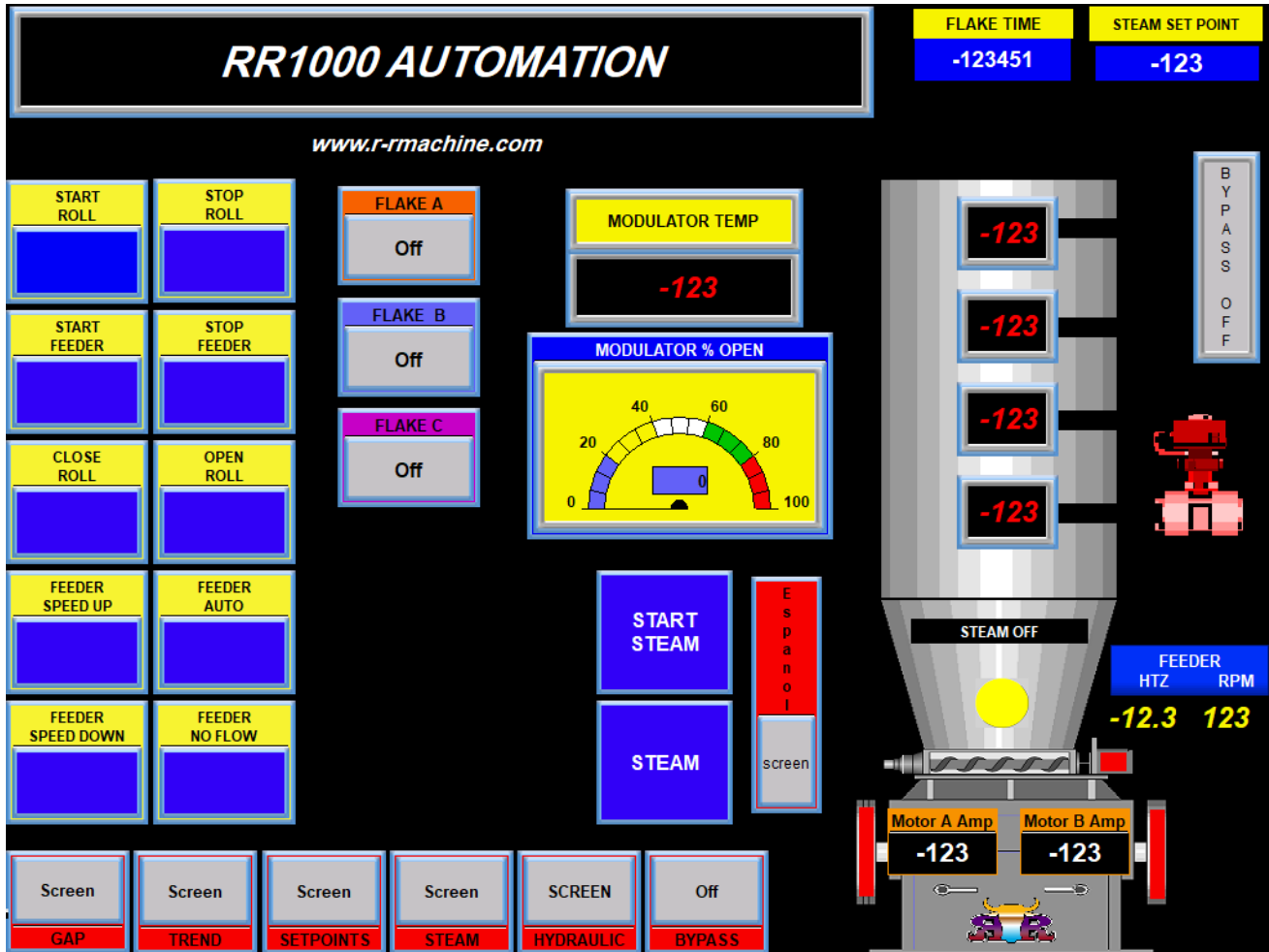
Steam Start Up Procedure



1. Slide bar to open position (100%), allow time for steam chest to completely heat up.
 - A. With all manual valves in the open position.
 - B. Turn manual valves off as temperature reaches (set point) temp.
2. Slide bar back to close position (0%).
 - A. Push automated steam on ("1" then "2" in order).



Mill Shut Down Procedure



1. Lower Feeder Speed to a minimum of 20 Hz.
 - a. (The control box will remember its last feeder speed).
2. Touch Stop Feeder — Feeder will stop and the rolls will open.
3. Touch Stop Rolls



GS2 Parameters for RR1000

PARAMETERS	DESCRIPTION	PARAMETER VALUES
P0.01	Motor name plate Amps	0 to 7amps
P0.03	Motor Base RPM	From motor plate- 1200,1800,etc
P0.04	Motor max RPM	1750-2500
P1.00	Coast to Stop	01
P1.01	Acceleration Time	5.0
P1.02	Deceleration Time	15.0
P2.00	High Starting Torque	01
P2.02	Manuel Torque Boost	10
P3.00	Source of Operation Command	02
P3.01	Multi-Function Input Terminals	01
P3.02	Multi-Function Input (D13)	14
P3.03	Multi-Function Input(D14)	15
P3.11	Multi-Function Output Terminal	00
P4.00	Source of Frequency Command	01
P6.00	Thermal Overload Relay	00
P6.15	Upper Bound of Output Frequency	60.0
P6.16	Lower Bound of Output Frequency	10.0
P9.08	Restore all Parameter to Default	99
	Otherwise Leave On 0.0	
P9.00	Command	01
P9.01	Command	02
P9.02	Command	05

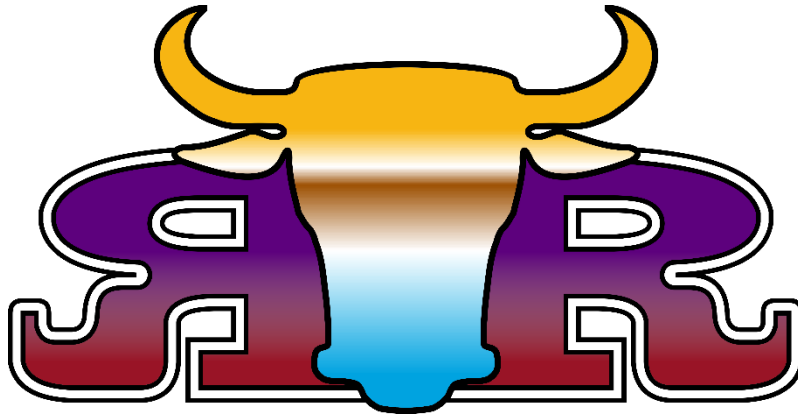
Program: Changes Series of Command

Enter: Change parameters & enters in same Series

P3.00 Change to
0.0
P4.00 Change to
0.0

Runs Inverter on Manual





RR1000 Manual

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