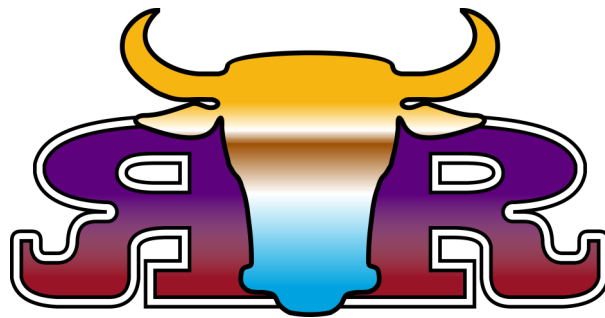


# Dalhart R & R Machine Works Inc.



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.



## 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. Failure caused by shavings, dust, or any foreign material that shortens out or damages in any way, any product inside the control box, during installation, or during any maintenance work being done, by anyone other than an employee of Dalhart R&R Machine Works, Inc., will not be covered under this warranty.*

*A DALHART R&R MACHINE WORKS, INC. representative must do 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 particular purpose.*

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Purchaser, Representative

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Yard or Company Name

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

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Date



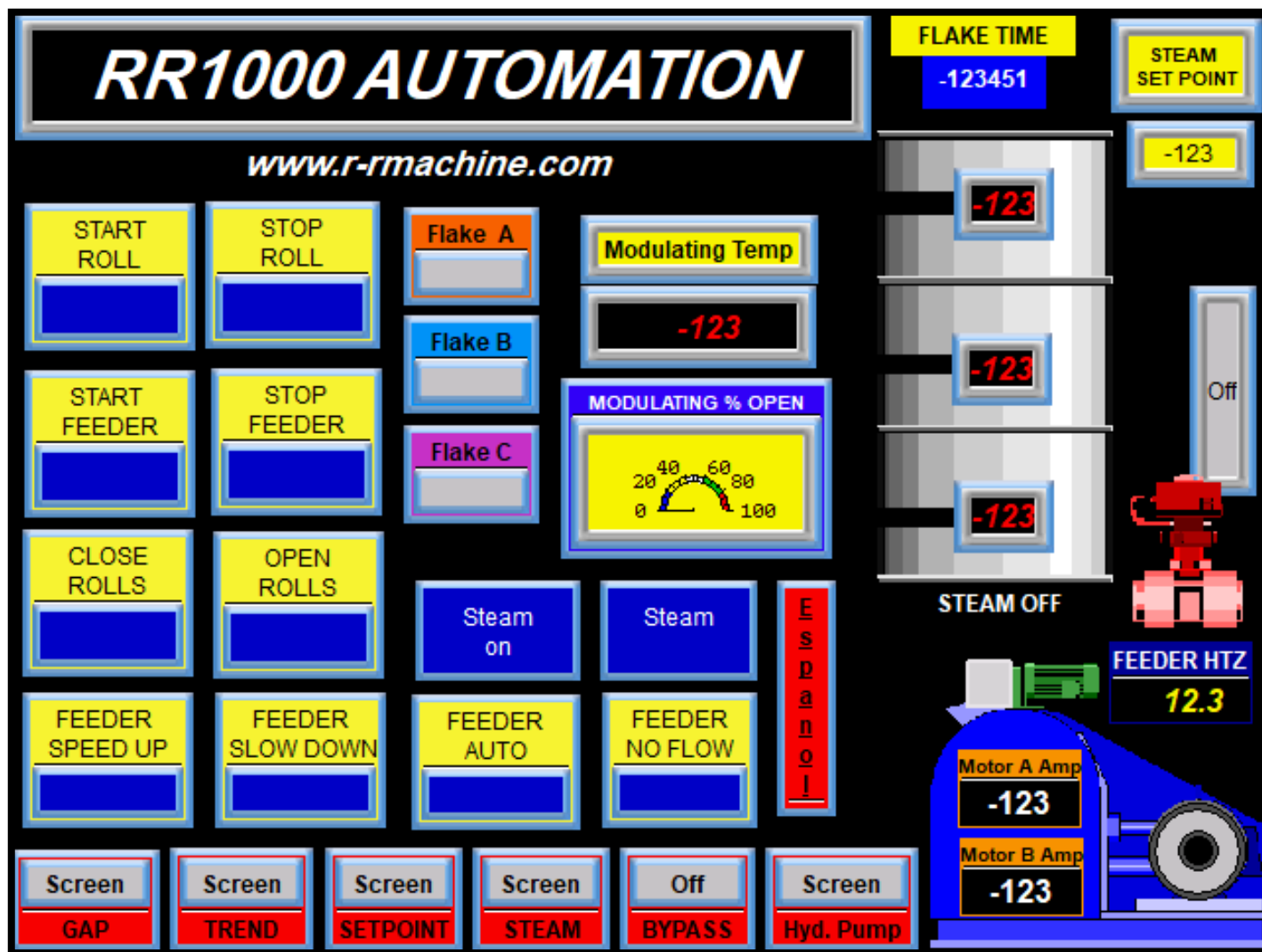
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# Mill Start Up Procedure

(New Mill & 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.



# Mill Start Up Procedure

The screenshot displays a control panel with the following elements:

- Control Buttons:** "CLOSE ROLLS" (yellow), "OPEN ROLLS" (yellow), "Enable Transducers" (grey, Off), "Enable Proportional" (grey, Off), "BYPASS" (red, Off), "Main" (green), "Espanol" (red), "Screen" (grey), and "Pantalla" (grey).
- Gap Set Points:** A section titled "Gap Set Points 'A' 'B' 'C' Lower # Thicker Flake" containing three rows: "Flake A" (orange), "Flake B" (blue), and "Flake C" (purple). Each row has a corresponding "Gap Set Point" box (e.g., "Gap Set Point A", "B", "C") all displaying the value "-12345".
- Parameter Settings:** "Gain" (orange, -12345), "Reset Time" (orange, -12345), "Rate" (orange, -12345), "Scale Cyl. 'A' Left" (yellow, -12345), "Scale Cyl. 'B' Right" (purple, -12345), and "Rolls Open Set" (cyan, -12345).
- Gauges:** Two horizontal gauges at the bottom right, titled "Scale Cyl. 'A' Left Side" (yellow) and "Scale Cyl. 'B' Right Side" (purple). Both gauges have a scale from 0 to 32767 with intermediate markers at 6553, 13106, 19660, and 26213. The current value is 0.

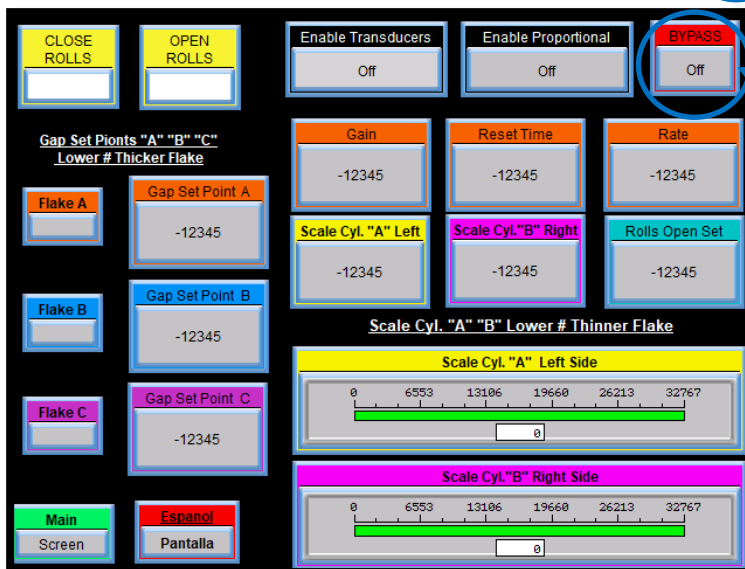
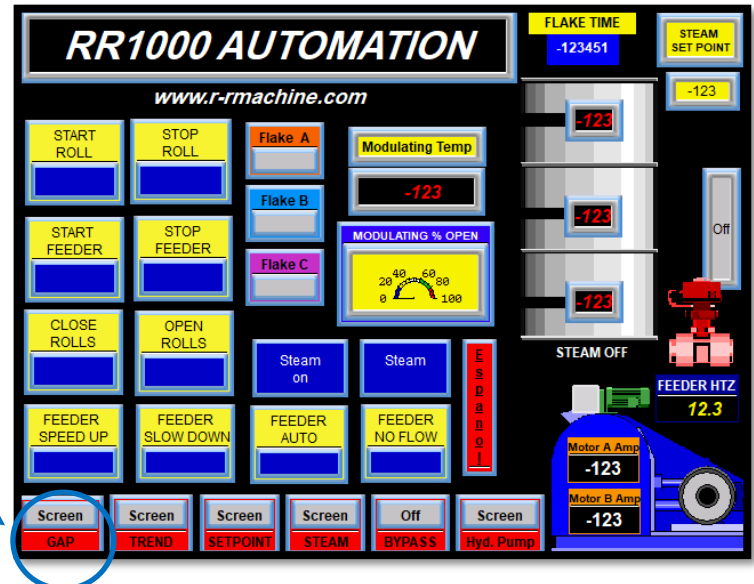
Increasing the "Gain" will increase the reaction time. Be sure to have a preset "Gap Set Point" for Flake A, Flake B, and Flake C before using any flake settings.



# Mill Start Up Procedure

**Set flake weight with Machine in Bypass mode.  
 (New Mill & After Roll Change).**

**Select “Gap Set Screen”**



Gap Screen

Note: 0.060” = 125 pts

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

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.

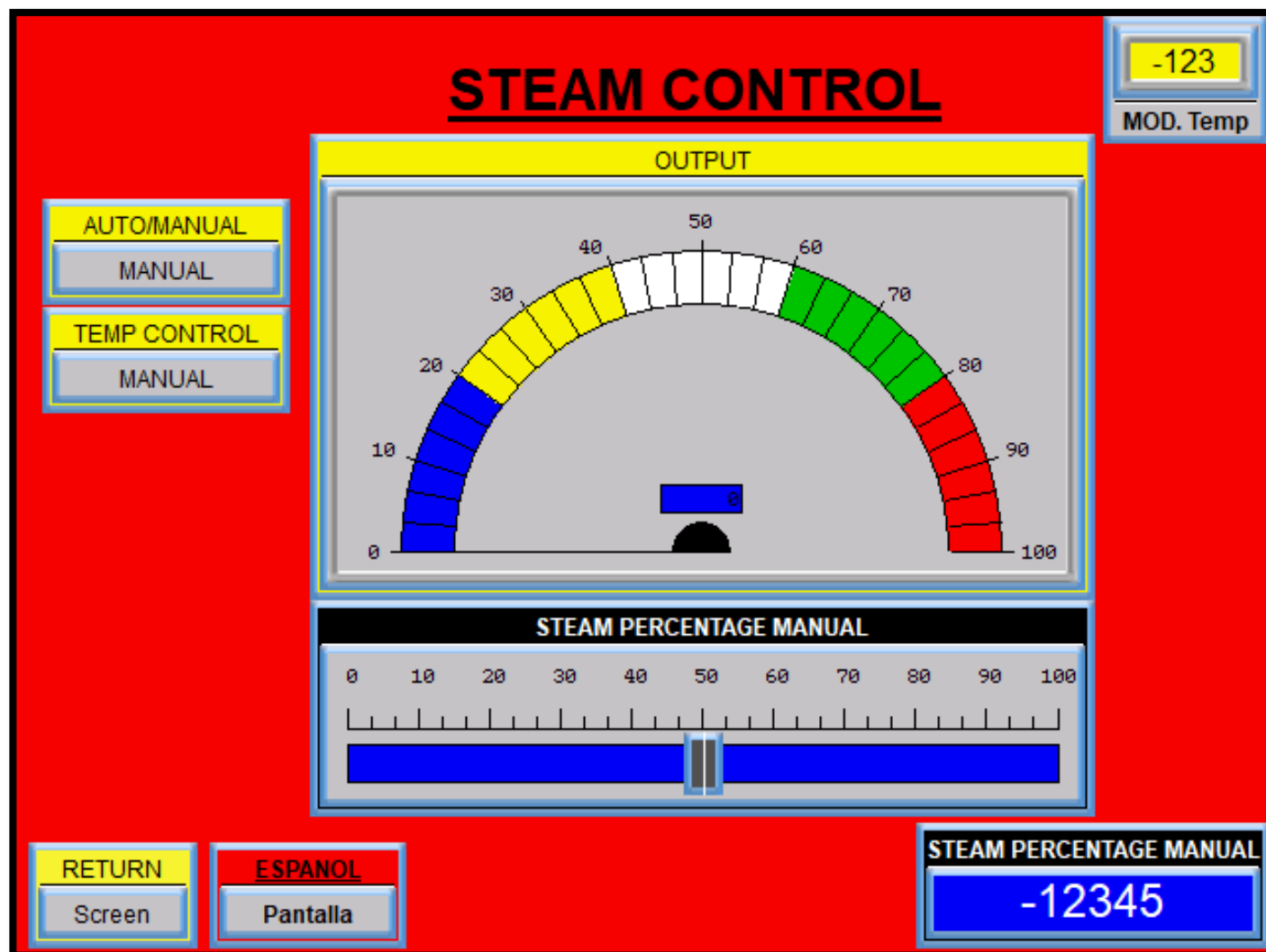
**\*Notice the graph numbers displayed under Cylinders A & B. (Circled in BLUE).**

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.**



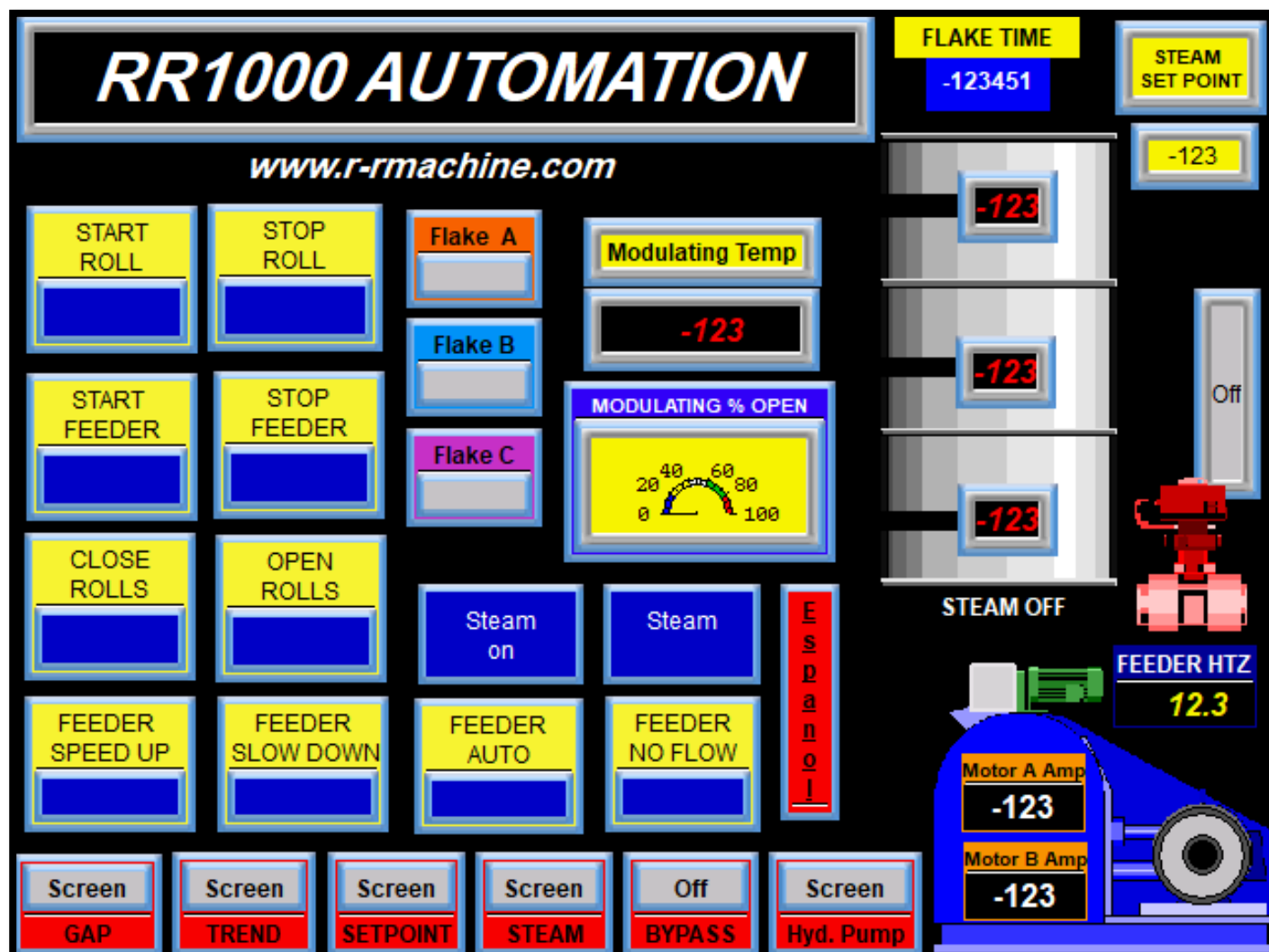
# Steam Start Up Procedure



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.  
(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
0.01	Motor name plate Amps	0 to 7amps
0.04	Motor max Rpm	1750-2500
1.00	Coast to Stop	01
1.01	Acceleration Time	5.0
1.02	Deceleration Time	15
2.00	High Starting Torque	01
2.02	Manuel Torque Boost	10
3.00	Source of Operation Command	02
3.01	Multi-Function Input Terminals	01
3.02	Multi-Function Input (D13)	14
3.03	Multi-Function Input(D14)	15
3.11	Multi-Function Output Terminal	00
4.00	Source of Frequency Command	01
6.00	Thermal Overload Relay	00
6.15	Upper Bound of Output Frequency	60.0
6.16	Lower Bound of Output Frequency	10.0
9.08	Restore all Parameter to Default	99
	<b>Otherwise Leave On 0.0</b>	
9.00	Command	01
9.01	Command	02
9.02	Command	05

Program: Changes Series of Command

Enter: Change parameters & enters in same Series

3.00 Change to 0.0  
 4.00 Change to 0.0

Runs Inverter on Manual

