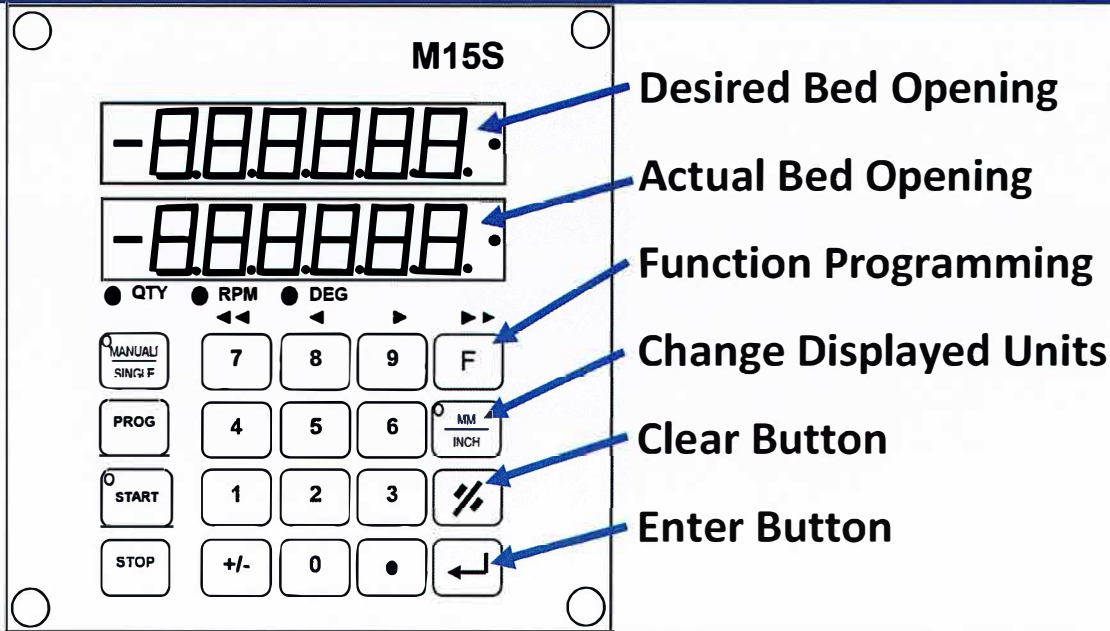




Technical Bulletin

Subject: M15 Operation Instructions
Revision: 2/25/2020

M15 Display



Instructions

Go-To Bed Opening: Press Yellow “PROG” Button > Red dot will flash on top display > Use **Number** keys to type in desired bed opening > Press **Enter** > “START” Button Light will flash > Press “START” Button > Machine will now Open/Close until the desired bed opening is achieved (The bottom number displayed will match the top number displayed).

Fast Key Programming: Press **F, 55, Enter** > Press the fast key (0-9) you would like to program > The current programmed number will display > Use number keys to type in desired value > Press **Enter** > Press the **Clear** button to return to the home screen. **To use a Fast Key: Press the desired key > The stored value will be loaded into the ‘Desired Bed Opening’ Display and the light on the “START” button will flash > Press “START” and the machine will now Open/Close until the desired bed opening is achieved.

Feed Speed: The M15 Controller will only allow you to view the current conveyor feed speed. Simply press the Enter button, and the Feed speed will be displayed on the numerical readout. The M15 is not capable of storing or changing the physical speed of the conveyor belt; this can be accomplished by using the Potentiometer mounted on the control panel. Press enter again to return to the bed opening display.

Display Re-Calibration: If the bottom number (Actual Bed Opening) needs to be adjusted/re-calibrated, then use the following instructions: Press **F, 2, Enter** > Use **Number** keys to type in bed opening value > Press **Enter** > Display will return to normal like nothing happened > Now, Press **F, 0** and then **Enter twice** > The Bottom Display should show the same number that was typed in during the second step of this process.