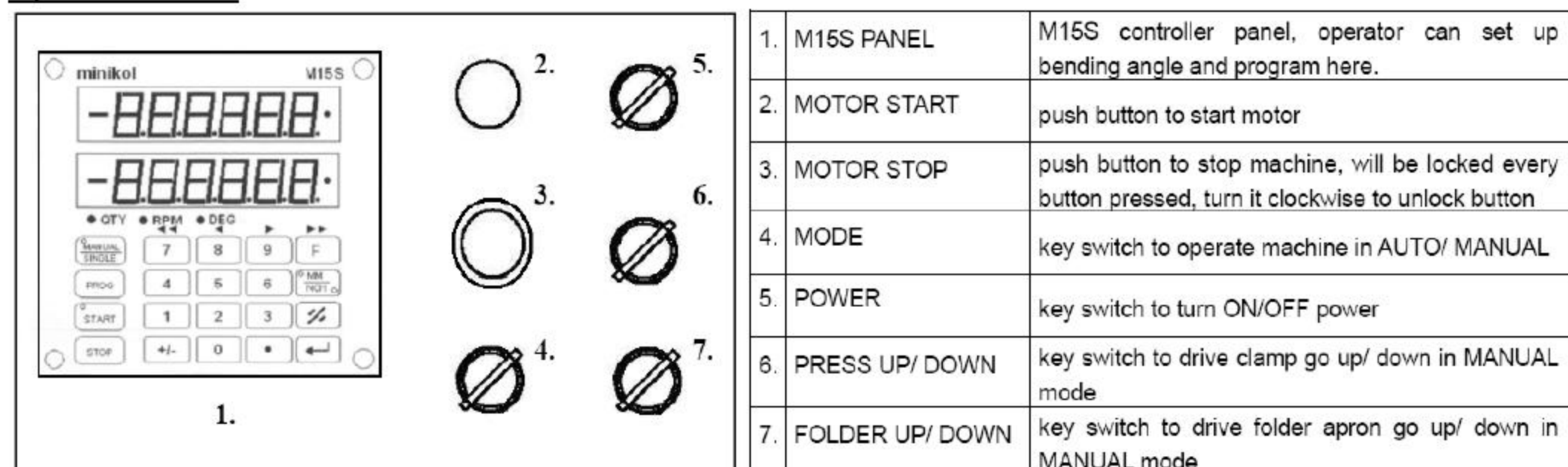


※ Safety Note:

1. Do not stretch hand into the gap between folder and lower seat, and the opening between clamp and lower seat.
2. Do not be too close to machine as folder apron activated.
3. Feed grease lubricant periodically. (Three to four times a year)
4. Regularly change hydraulic oil and clean filter.

**Operation Panel**



**Foot Pedal**



#1	Left	to enable Folder Apron movement
#2	Middle	to enable Clamp Down movement
#3	Right	to enable Clamp Up movement



**Manual Mode**

In manual mode, machine can be operated by both-the key switches on control panel and foot pedal. Clamp and folder apron are activated when key switch turned or foot pedal pressed; as key switch or foot pedal released, clamp and folder apron will stop and stay still(jogging movement).

1. PRESS UP/ DOWN: clamp goes down by key switch clockwise turning  
/ by middle foot pedal pressed  
/ by right foot pedal pressed
2. FOLDER UP/ DOWN: folder goes down by clockwise turning  
/ by left foot pedal pressed  
folder goes up by anti-clockwise turning  
/ by left foot pedal pressed

**Auto Mode**












**1) Single Bending Step**

1. Toggle key switch to Auto
2. Set up bending angle by keying in number keys on M15 controller panel, upper LED will display "tArGEt", and push , the upper LED shows "STOP", then push  once again, machine is ready.
3. Step on foot pedal #2, clamp goes down and fix material.
4. Step on foot pedal #1, folder apron goes up and bends material to the setting angle, then goes down back its zero automatically.
5. Clamp goes up automatically, one circle operation finished.





※ Note:

1. When Auto/ Manual mode switched, clamp and folder will go back their own zero position.(clamp stays at its TDC, folder apron stays at its BDC)
2. In auto mode, clamp and folder apron can go with jogging movement when foot pedal or key switch enabled.
3. 6 programs the most can be stored in M15S controller, 16 steps the most can be set up per program.
4. If the upper LED displays "nodAtA", it means no any data in this program
5. Folder apron can be activated only after clamp finishes its movement, stays at its BDC.

**2) Multi-angle Bending Step**

1. Toggle to key switch to Auto.
2. Push , then push  upper LED will display "P1".
3. Push  once again, "01" on the upper LED flashing, that accesses step 1 programming.
4. The upper LED shows "trG", that is for bending angle setting, please set up desired bending angle by keying in number keys, and push .
5. The upper LED shows "Cnt", that is for how many times you want to repeat this step 1, please set up it by keying in number keys, and push .
6. After step 1 setting, it will automatically access step 2 programming, the upper LED shows flashing "02", please repeat abovemention step 1 programming to set up step 2, or step 3, 4..., if required.
7. Please push ,  and  to finish and save the program.
8. Push  and  to select the program(e.g.: P1, P2, P3...), and push  to execute the selected program.


**3) Delete Program**

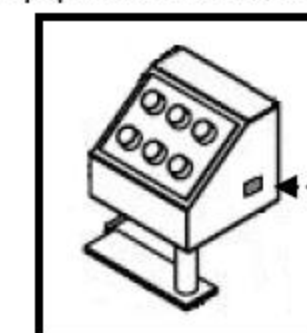
1. Push .
2. Push  to select the program you want to delete, then push  once again.
3. Push  to select the step you want to delete.
4. Please note, all the steps which following the deleted step will be deleted automatically, e.g.: if there is 6 steps in one program, when you delete step 3, the following step 4, step 5 and step 6 will be deleted automatically.
5. Push  and  to finish program delete

**Normal Operation**

1. Turn Power Switch to ON, the key switch lights up.
2. Push Motor Start button, motor starts and clamp goes up to automatically TDC.
3. Turn key switch to manual mode.
4. Set up bending angle.
5. Feed material in, and to align its expected bending line. .
6. Clamp going down by manual with jogging movement, step by step, please keep small clearance between material and clamp, after make sure of the bending line is aligned, drive clamp go down to press material until fixed.
7. Folder apron going up by manual with jogging movement, step by step until it reaches TDC, then going back to its zero by manual.
8. If trial bending goes well with manual mode, turn it to Auto mode, after material placement, press foot pedal to start machine operation.

**Angle Correction**

If there is a discrepancy between setting angle and real bending angle, please correct it by following instruction.  
e.g.: if the setting angle is 90°, but after bending, the measured angle is 88°, there is -2° difference. Please toggle machine to MANUAL mode, and key in the measured angle "88" to the M15S controller, then press  twice, after the 88 shows on the LED, please keep press the RESET button for 1 second, and the correction is done.



RESET Button