

OPERATIONS MANUAL

**BERRIDGE MODEL MP-465
BATCH CONTROL
COMPUTER**



BERRIDGE
MANUFACTURING COMPANY

(800) 669-0009 | WWW.BERRIDGE.COM

FOR TECHNICAL ASSISTANCE CALL:
(830) 401-5200

LEASED TO: _____

DATE: _____

SERIAL NUMBER: _____

OPERATION INSTRUCTIONS

NOTE: TO BEGIN RUNNING PANELS WITHOUT CLEARING MEMORY AND RECONFIGURING COMPUTER, SKIP DOWN TO SECTION 2. COMPUTERS SHIPPED WITH BERRIDGE PORTABLE ROLL FORMERS HAVE ALREADY BEEN CONFIGURED AS DESCRIBED IN SECTION 1 - SECTION 1 CAN BE SKIPPED FOR MOST OPERATORS.

SECTION 1: TO CLEAR COMPUTER MEMORY AND RECONFIGURE UNITS, ENCODER SPIN DIRECTION, AND SHEAR MODE:

- A. With computer turned off, press and hold 5 key on keypad while turning power on. Continue holding 5 key until "MEMORY CLEARED" message shows on screen.
- B. At "UNITS" option, press any number key on the keypad to select "FEET" or "INCHES". When desired unit is highlighted press the "ENTER" key (horizontal arrow) on keypad.
- C. At "ENCODER DIRECTION" option, press any number key to select "CCW" (counterclockwise) or "CW" (clockwise). (**NOTE:** standard Berridge roll formers require the "CCW" selection). Press "ENTER" key when desired option is highlighted.
- D. At "SHEAR" option, select one of the following options:
 - a. "HAND": Machine has a manual shear. Machine runs panel to length, then stops and waits for operator to shear the panel manually and press the SHEAR button on the controller;
 - b. "AUTO ST": Machine has a powered shear. Machine runs panel to length, then stops and shears the panel automatically, then restarts automatically to run the next panel;
 - c. "AUTO NS": THE "AUTO NS" OPTION IS NOT AVAILABLE ON BERRIDGE PORTABLE ROLL FORMERS.
 - d. Press any number key on the keypad to select the correct option, then press the "ENTER" key when desired option is highlighted.



SECTION 2: TO BEGIN PRODUCTION OF PANELS:

- A. Press "PROGRAM" key (sheet of paper with horizontal lines).
- B. Enter "JOB NUMBER" (1, 2, 3, etc.) to program and press "ENTER".
- C. Enter "PANEL QUANTITY" and press "ENTER".
- D. Enter length in feet and press "ENTER".
- E. Enter length in inches and press "ENTER".
- F. Use any number key on keypad to select "PAUSE YES" or "PAUSE NO" after batch is run.
- G. Enter next batch of panels following steps above, if desired.
- H. When all batches are programmed, press the * key on the keypad and enter the batch number you wish to start with.
- I. After entering the batch number, press "ENTER".

OPERATION INSTRUCTIONS CONTINUED

SECTION 3: AT THIS POINT THE COMPUTER IS PROGRAMMED AND READY TO FABRICATE PANELS. WITH MATERIAL LOADED IN THE MACHINE AND AT THE SHEAR, FOLLOW THE STEPS BELOW.

- A. Make sure the drum switch (forward/reverse switch) is in the FORWARD direction.
- B. Press the "SHEAR" button on the computer to clear the footage.
- C. Press the "RUN" button on the computer to begin fabricating panels.
- D. IF MACHINE HAS MANUAL SHEAR: Material will stop when programmed length is reached, and "SHEAR" button will light up. Shear the material using the manual shear, then press "SHEAR" button to restart and run the next panel.
- E. IF MACHINE HAS A POWERED SHEAR: Material will stop when programmed length is reached, shear will cycle automatically, and material will restart with no input from operator.

IMPORTANT: TO STOP MACHINE AT ANYTIME DURING PANEL FABRICATION, PRESS THE "HALT" BUTTON ON THE COMPUTER. TO RE-START FABRICATION, PRESS THE "RUN" BUTTON ON THE COMPUTER.

CALIBRATION

CALIBRATION: THE MP465 CONTROLLER DOES NOT REQUIRE THAT YOU RUN A SEPARATE PANEL FOR CALIBRATING. TO CALIBRATE THE CONTROLLER, FOLLOW THESE STEPS:

- A. Select the last panel that was produced using the controller.
- B. Press the key with the "Tool" icon on the keypad.
- C. Press "X" to select the calibration function.
- D. Enter the length the selected panel was programmed to be.
- E. Enter the actual measured length of the panel.
- F. Press "Enter" to return to the programming mode and continue panel production.

BATCH CONTROL COMPUTER RETURN INFORMATION

DATE RETURNED: _____

MODEL NUMBER: _____

SERIAL NUMBER: _____

COMPUTER NUMBER: _____

COIL HOOK CRATE TARP

MISCELLANEOUS (LIST) _____

COMMENTS _____

REPAIRS: _____

LABOR COST: _____

PARTS COST: _____

FILL OUT & MAIL OR FAX TO:

BERRIDGE MANUFACTURING COMPANY
ROLL FORMER OPERATIONS
2201 Rudeloff Road
Seguin, TX 78155
Fax: (830) 303-0530

NOTE TO LESSEES:

The Berridge Model MP-465 Batch Control Computer is shipped in good working condition and must be returned in the same condition. The cost of any required repairs for damage or deterioration caused by misuse or negligence will be charged to lessee.

CORPORATE HEADQUARTERS

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* Berridge California and Florida Sales
Corporations are separate entities from
Berridge Manufacturing Company.