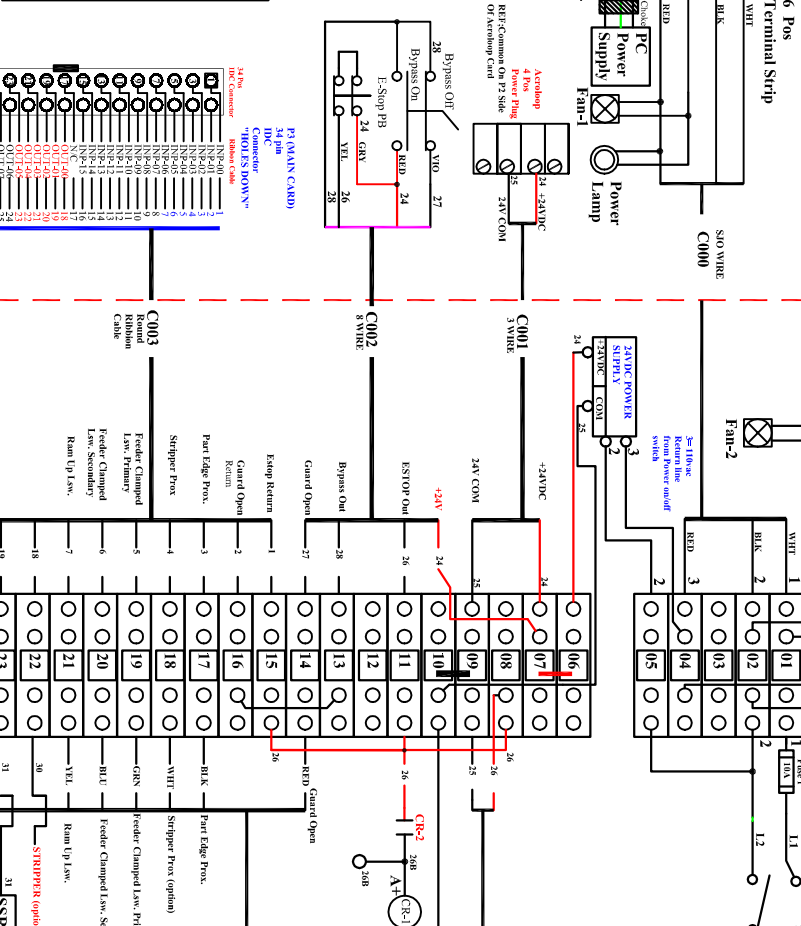
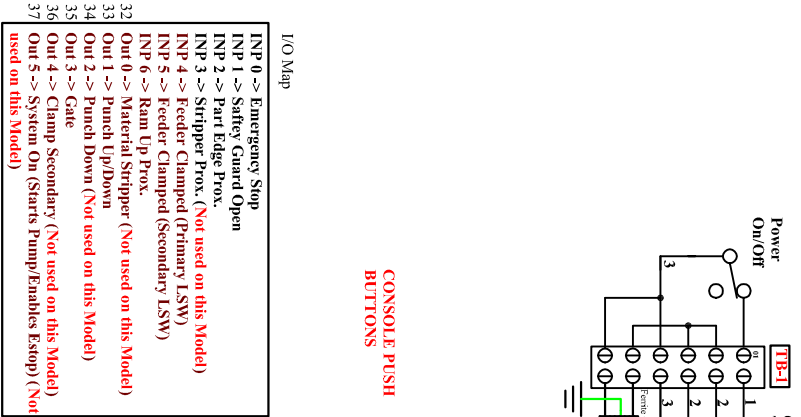


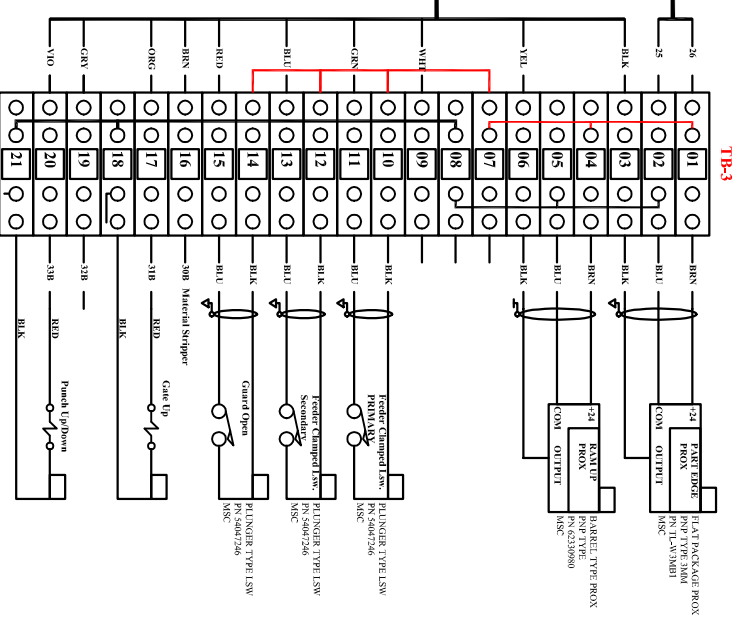
## Inside Console

## Main Electrical Enclosure

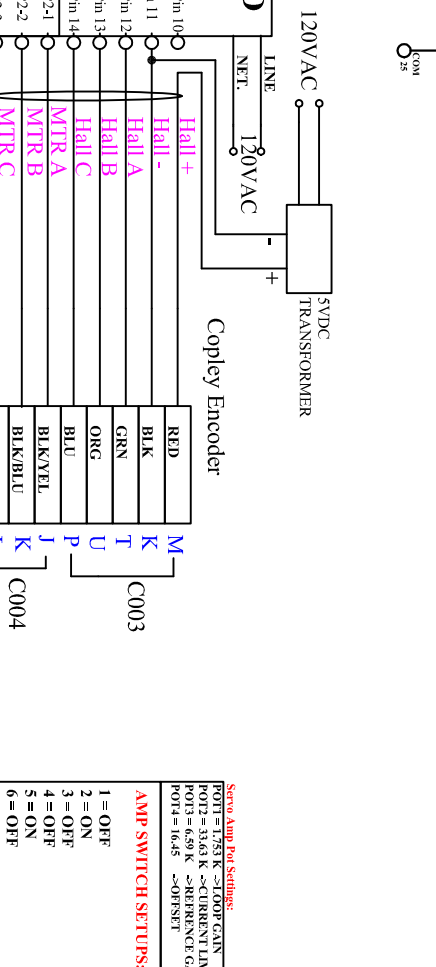
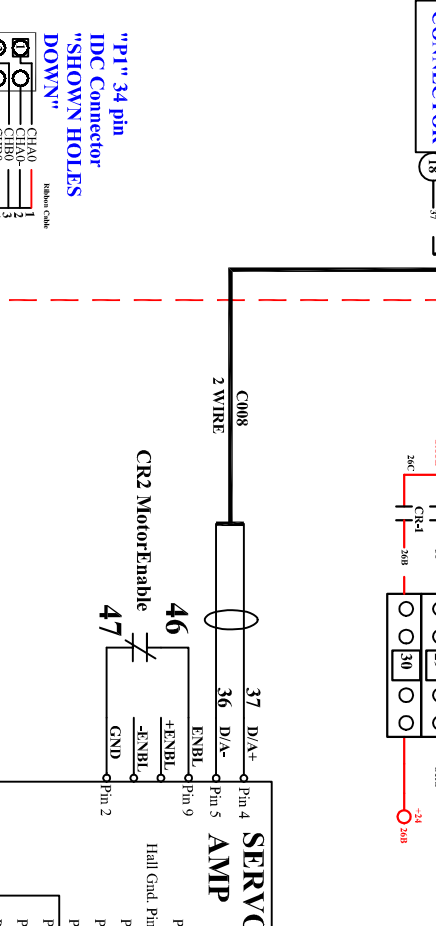
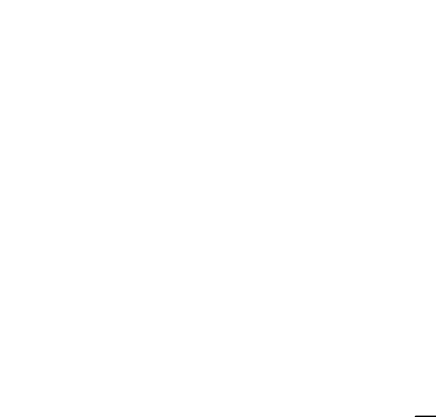
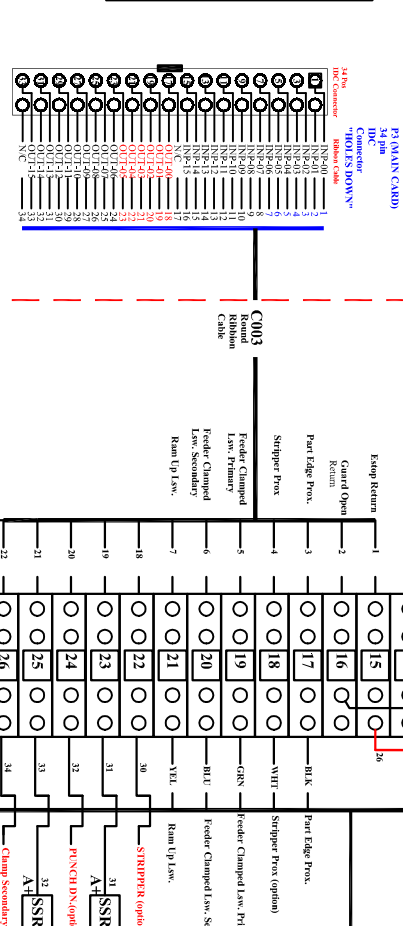


## 10 X 10 JIC Enclosure

## External Limit Switches Solenoids/Servo Motor



- ### I/O Map
- NP 0 -> Emergency Stop
  - NP 1 -> Safety Guard Open
  - NP 2 -> Stripper Prox. (Not used on this Model)
  - NP 3 -> Stripper Prox. (Not used on this Model)
  - NP 4 -> Feeder Clamped (Primary LSW)
  - NP 5 -> Feeder Clamped (Secondary LSW)
  - NP 6 -> Ram Up Prox.
  - Out 0 -> Material Stripper (Not used on this Model)
  - Out 1 -> Punch Up/Down
  - Out 2 -> Punch Down (Not used on this Model)
  - Out 3 -> Gate
  - Out 4 -> Clamp Secondary (Not used on this Model)
  - Out 5 -> System On (Starts Pump/Enables Estop) (Not used on this Model)



**Servo Amp Pot Settings:**

- PO1 = 175K -> 200% GAIN
- PO2 = 100K -> 100% GAIN
- PO3 = 65K -> REFERENCE GAIN
- PO14 = 16.45 -> OFFSET

**AMP SWITCH SETTINGS:**

- 1 = OFF
- 2 = ON
- 3 = OFF
- 4 = OFF
- 5 = ON
- 6 = OFF
- 7 = OFF
- 8 = ON
- 9 = ON
- 10 = ON

DATE	DESCRIPTION OF CHANGES	CHKD BY/DATE
07-17-04	Rewired for 24v Servo Card	

**REVISIONS**

NO.	DESCRIPTION	DATE
1	Initial Release	07/17/04
2	Revised for 24v Servo Card	07/17/04

**PROPERTY**

19801 M42015 (6x5 Ports) (M4) REV. 06/20/04 (REV. 06/20/04)

EDWARDS & KELCEY, INC. (REV. 06/20/04)

(503) 625-7998 FAX (503) 625-7993

**CUSTOMER NAME:** Mindland Machine Inc.

**REVISED BY:** None

**DATE:** 07/17/04

**SCALE:** 1

**TITLE:** 3002 PunchMachine (Seg1 Retrofit) 110 MODEL