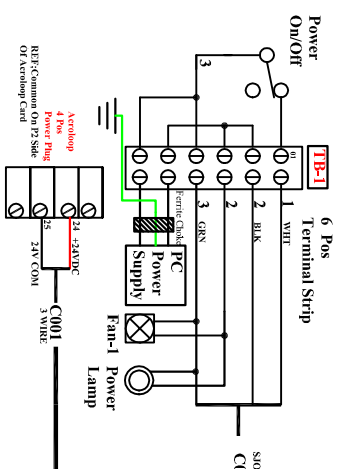


Inside Console

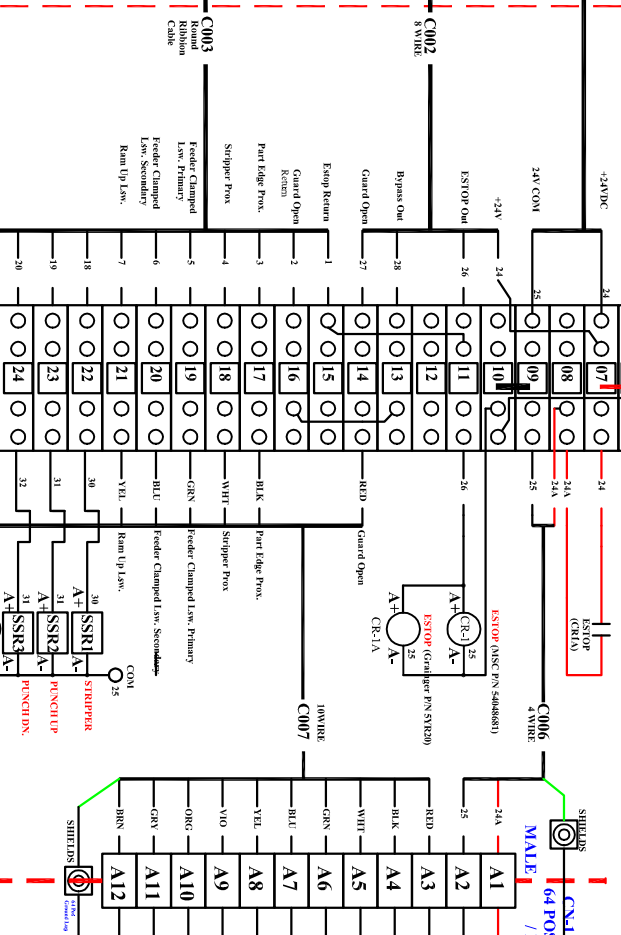
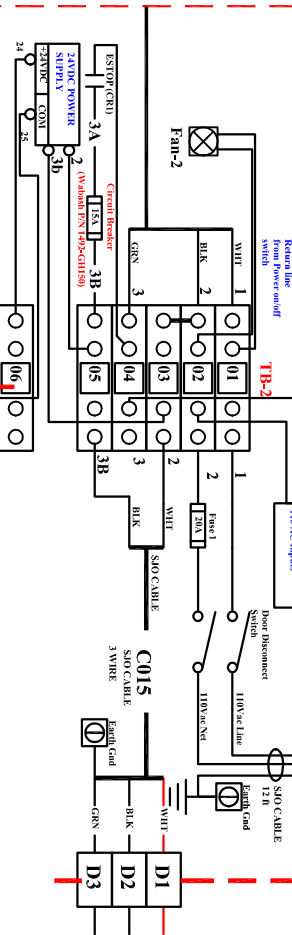


CONSOLE PUSH BUTTONS

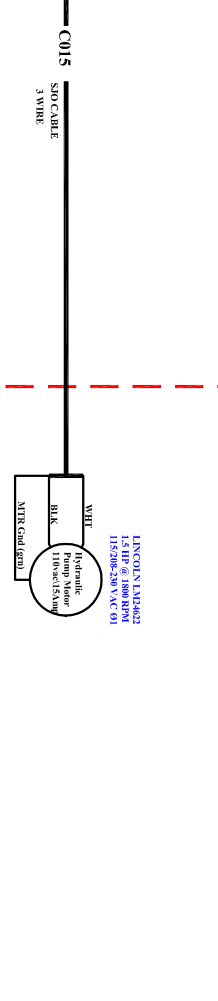


- I/O Map
- INP 0 -> Emergency Stop
 - INP 1 -> Safety Guard Open
 - INP 2 -> Part Edge Prox.
 - INP 3 -> Stripper Prox.
 - INP 4 -> Feeder Clamped (Primary LSW)
 - INP 5 -> Feeder Clamped (Secondary LSW)
 - INP 6 -> Ram Up Prox.
 - Out 1 -> Material Stripper
 - Out 2 -> Gate Up/Dn
 - Out 3 -> Press Punch
 - Out 4 -> Feeder Clamp Secondary

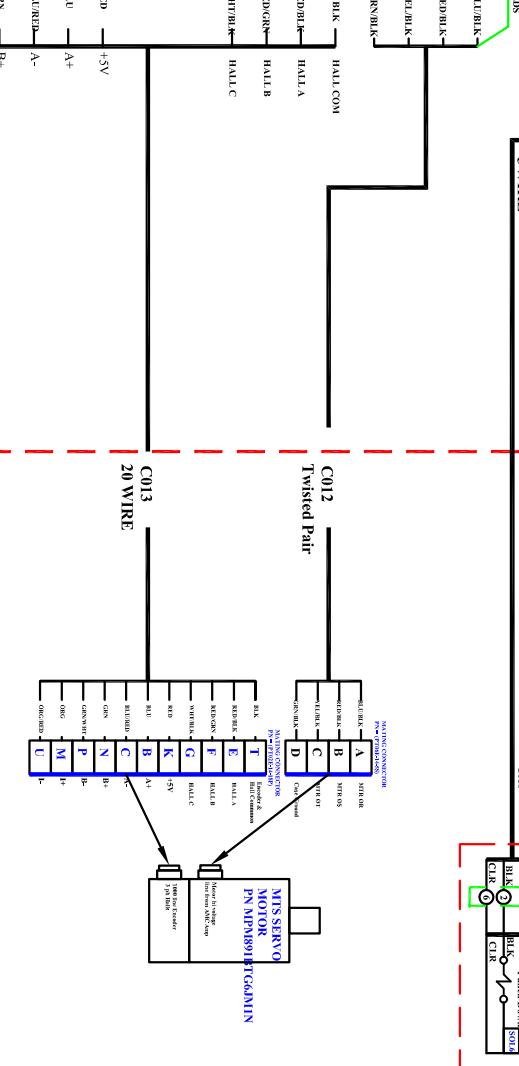
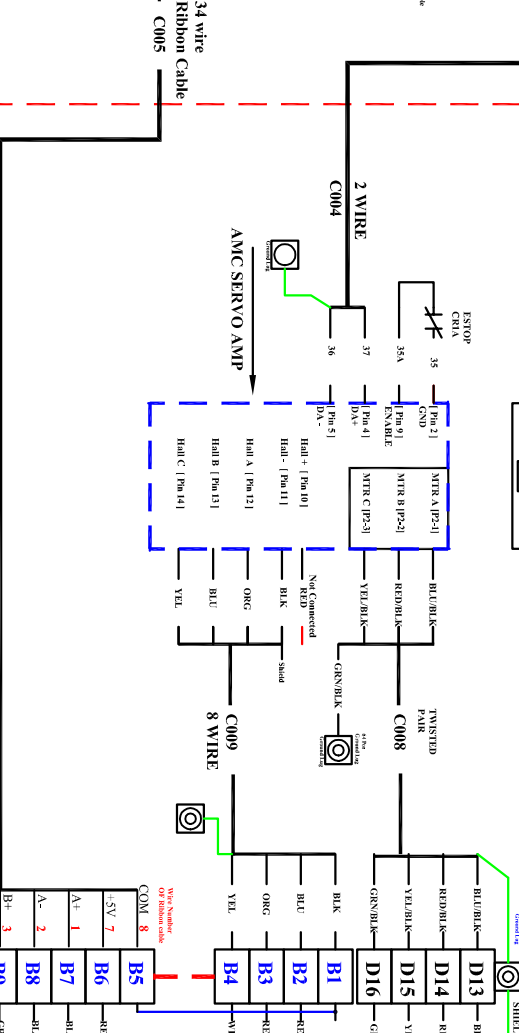
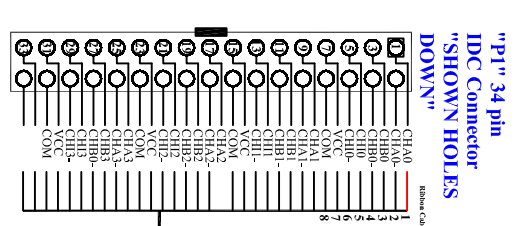
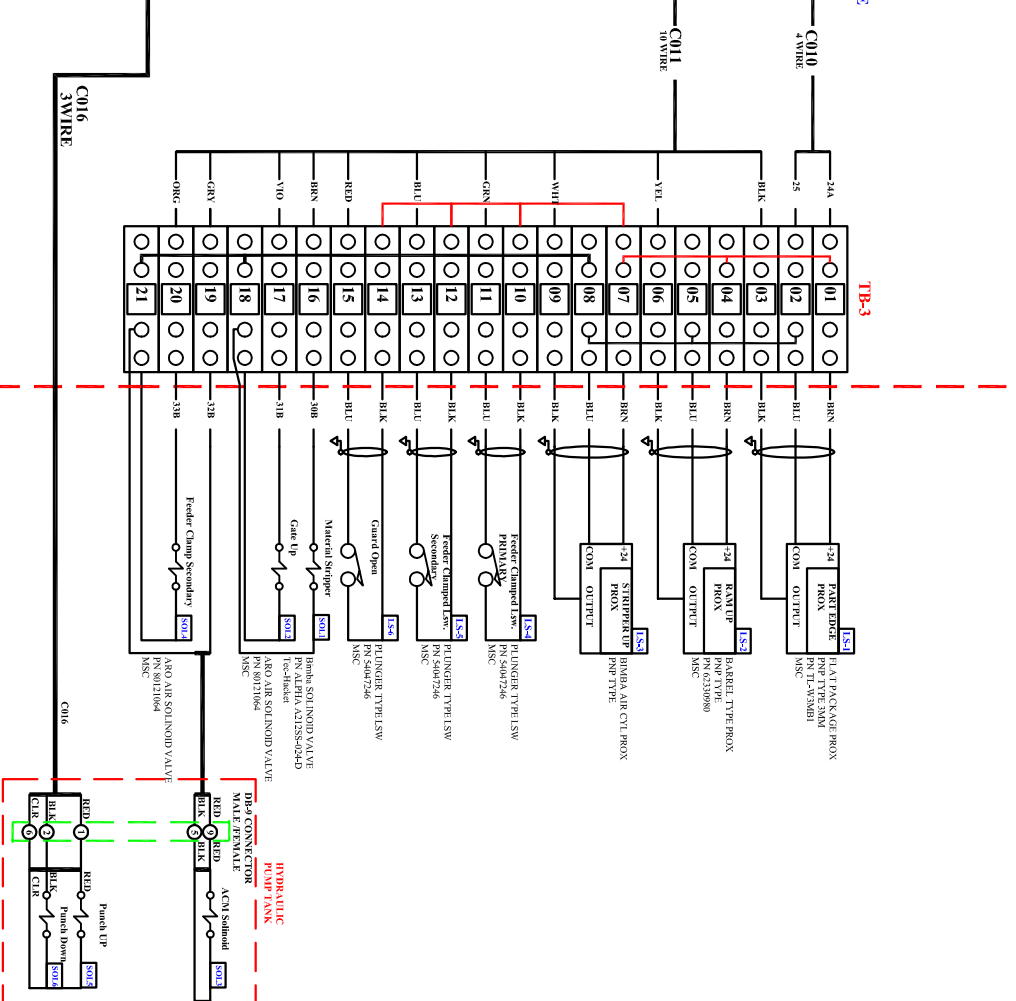
Main Electrical Enclosure



10 X 10 JIC Enclosure



External Limit Switches Solenoids/Servo Motor



DATE	DESCRIPTION OF CHANGES	CHANGED BY DATE

TITLE: 2004 PunchMachine (New Style) using Hydraulic Punching
 CUSTOMER NAME: Midland Machine Inc.
 DRAWING NO: DRB
 DATE: 1-08-04

- Notes:
- 1 = OFF
 - 2 = ON
 - 3 = OFF
 - 4 = OFF
 - 5 = ON
 - 6 = OFF
 - 7 = OFF
 - 8 = ON
 - 9 = ON
 - 10 = ON
- AMP SWITCH SETUPS:
 POT1 = 1.51K -> LOOP GAIN
 POT2 = 3.63K -> CURRENT LIMIT
 POT3 = 6.59K -> REFERENCE GAIN
 POT4 = 16.45 -> OFFSET