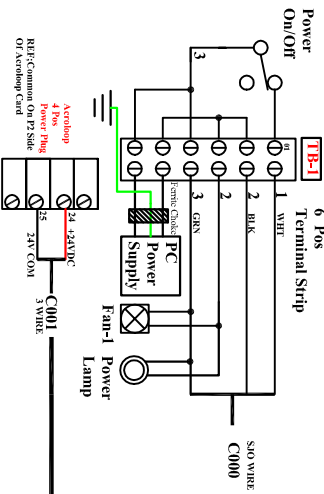


# Inside Console



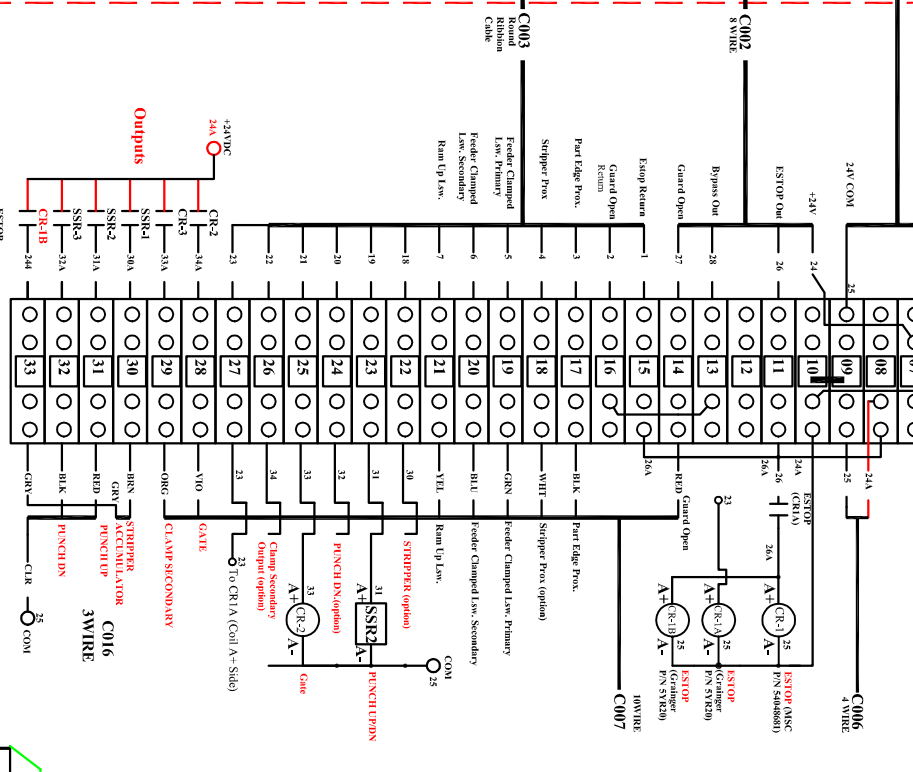
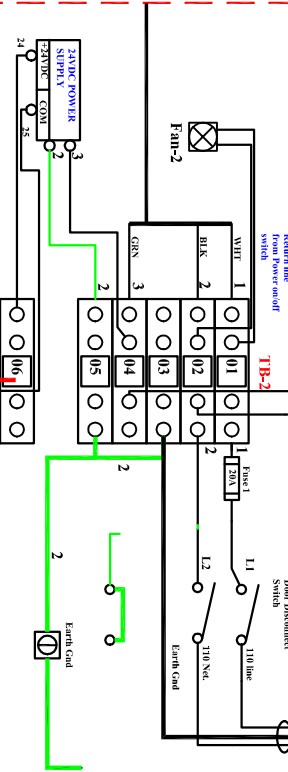
## CONSOLE PUSH BUTTONS



100V AC  
24 pin  
DC  
24VDC  
"HOLD IN DOWN"

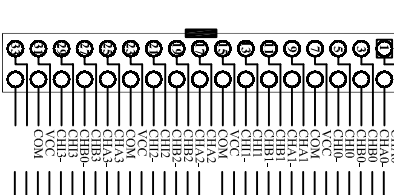
- I/O Map
- INP 0 -> Emergency Stop
  - INP 1 -> Safety Guard Open
  - INP 2 -> Part Edge Prox.
  - INP 3 -> Stripper Prox.
  - INP 4 -> Feeder Clamped (Primary LSW)
  - INP 5 -> Feeder Clamped (Secondary LSW)
  - INP 6 -> Ram Up Prox.
  - Out 0 -> Material Stripper
  - Out 1 -> Punch Up
  - Out 2 ->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

# Main Electrical Enclosure

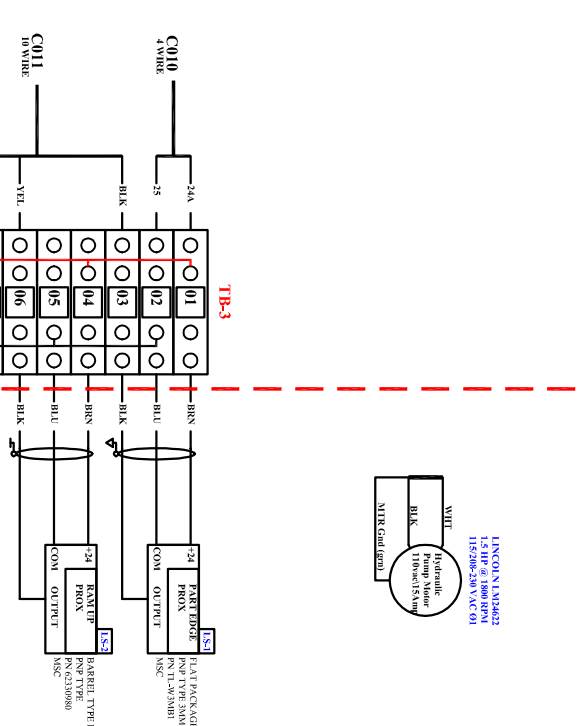


DIGITAL TO ANALOG OUTPUT ANS80

(P2) DB-44 CONNECTOR (18) (3) (36) (37)

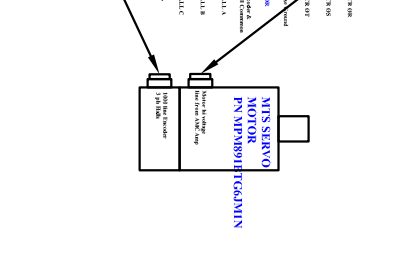
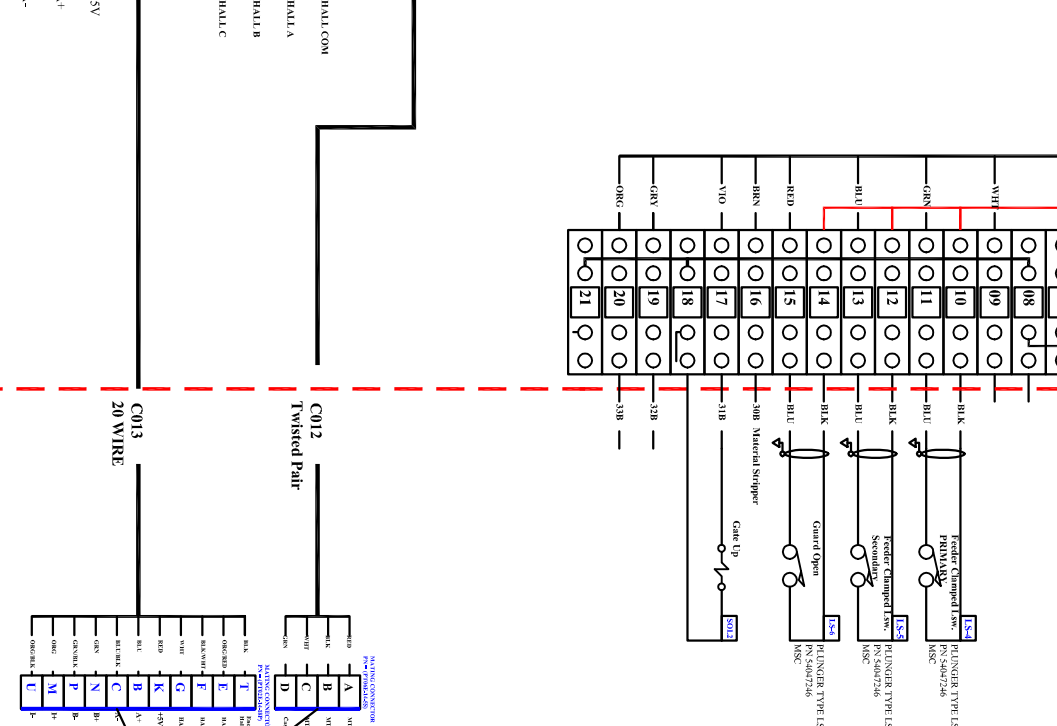


# 10 X 10 JIC Enclosure



# External Limit Switches Solenoids/Servo Motor

- Servo Amp Pot Settings:
- PO1 = 84 Ohms -> 100% GAIN
  - PO2 = 34 Ohms -> 50% GAIN
  - PO3 = 6 K -> REFERENCE GAIN
  - PO14 = 1 L1 -> OFFSET
  - PO14 = 1 L1 -> 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	CREATED BY DATE
02-20-04	Added CR-1B for 220 Model	
03-29-04	Revised CRI A for Software Estop (Uses Output 5) bit 37	
03-30-04	Added wiring for UPS	

TITLE	DESIGNER NAME
2005 PunchMachine (HYD TYPE) 220 MODEL	Mirland Machine Inc.

SCALE	DRAWN	CHECKED	DATE
None	DRB		04/17/04

