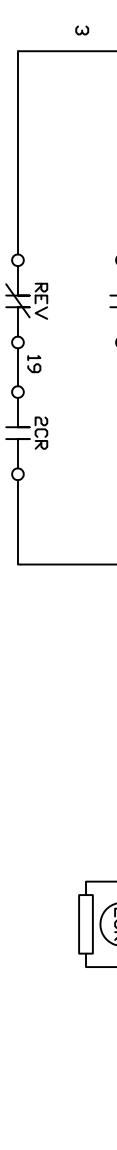
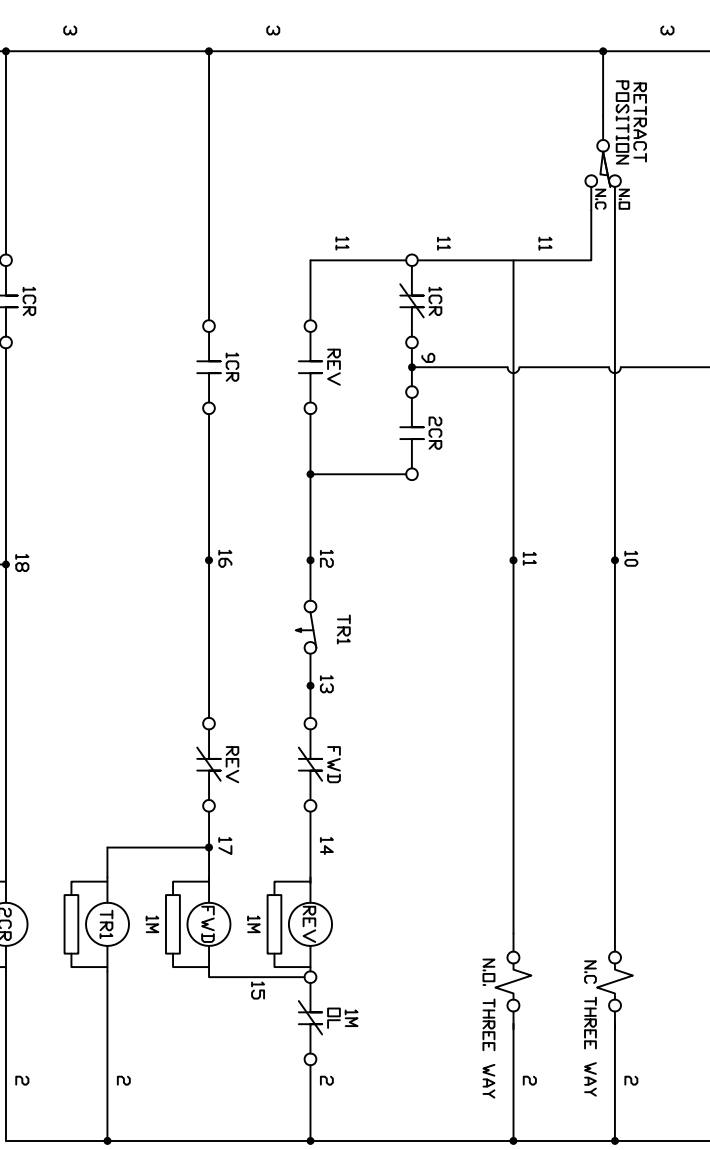
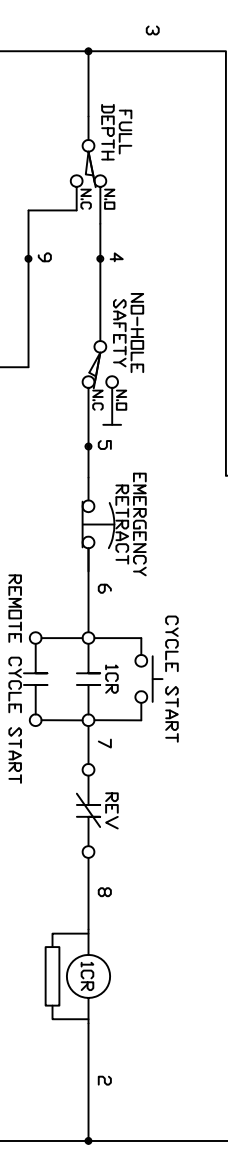
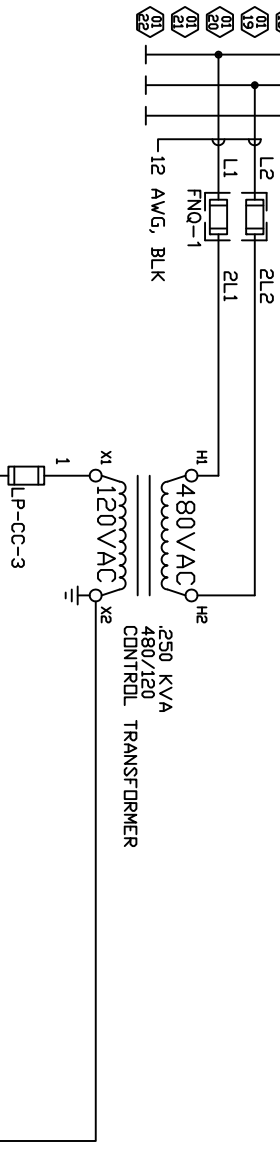
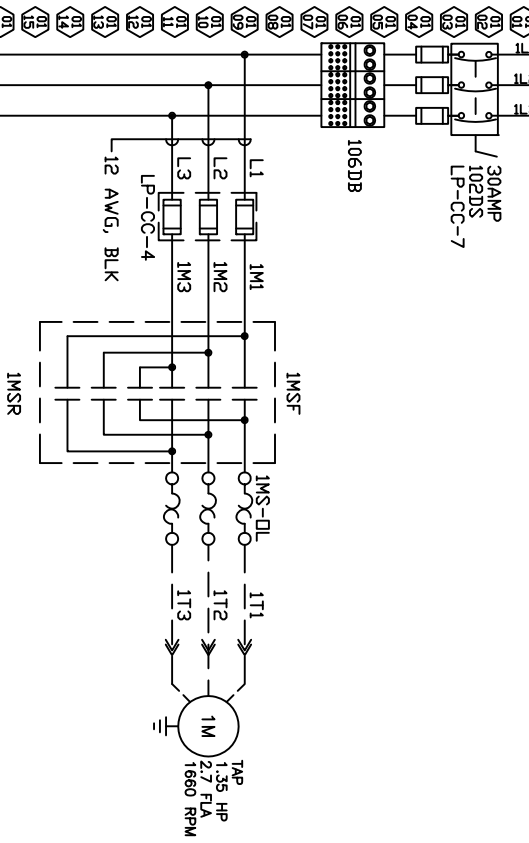


480 VAC, 3 PHASE, 60HZ



NORMAL OPERATING SEQUENCE

1. TURN ON MAIN DISSCONNECT.
2. MOMENTARILY PRESS "CYCLE START" BUTTON.
3. *ICR* AND *ZCR* WILL PICK UP AND HOLD. *TR* AND *FOR* WILL PICK UP. SIMULTANOUSLY, THE DEMAG MOTOR WILL RELEASE ITS INTERNAL BRAKE, AND RUN FORWARD.
4. AS THE SPINDLE TRAVELS FORWARD, THE RETRACT POSITION SWITCH IS RELEASED, ESTABLISHING CIRCUIT TO *ICR* AND *REV* CONTACTS. AS SPINDLE TRAVELS TO DEPTH SETTING, THE DEPTH SWITCH IS RELEASED.
5. *ICR*, *TR*, AND *FOR* CONTACTOR DROP OUT. THE DEMAG STOPS BY INTERNAL BRAKE.
6. WHEN *TR* TIMES OUT, *REV* CONTACTOR PICKS UP AND *ZCR* DROPS OUT. THE DEMAG MOTOR WILL RELEASE ITS INTERNAL BRAKE, AND RUN REVERSE.
7. THE DEPTH SWITCH RETURNS TO ITS ORIGINAL POSITION TO DROP OUT *REV* CONTACTOR. THE DEMAG WILL STOP BY INTERNAL BRAKE.

EMERGENCY RETRACT

MOMENTARILY PRESS "EMERGENCY RETRACT" BUTTON. SPINDLE WILL RETURN TO STARTING POINT AND STOP.

NO HOLE SAFETY

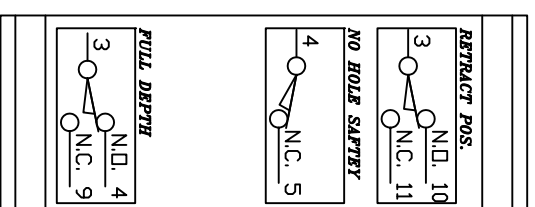
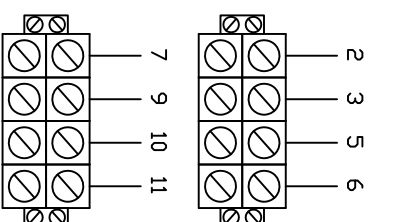
SAFETY TRIPS IF A "NO HOLE" CONDITION OR AN OBSTRUCTION TO FORWARD TRAVEL OCCURS. THE MOTOR WILL AUTOMATICALLY REVERSE, AND SPINDLE RETURNS TO STARTING POSITION. SWITCH IS READY TO START A NEW CYCLE.

FUNCTION OF ZCR

ZCR PREVENTS THE MOTOR REVERSING IF SPINDLE IS ROTATED BY HAND TO CHECK LIMIT SWITCH OPERATION.

TO ROTATE THE SPINDLE MANUALLY, SHUT OFF MAIN DISSCONNECT. USE MANUAL BRAKE RELEASE FURNISHED WITH YOUR MOTOR. ALWAYS REMOVE LEVER AND REPLACE PROTECTIVE CAP.

SEE TRANSFORMER CONNECTION DIAGRAM WHEN CHANGING SUPPLY VOLTAGE.



SWITCH BOX PIN OUT	PIN LETTER	WIRE NUMBER	WIRE COLOR
	A	3	RED
	B	5	GREEN
	C	6	BLACK
	D	7	ORANGE
	E	9	BLUE
	F	10	WHT/BLK
	G	11	RED/BLK
	H	2	WHITE
	I	N/A	N/A
	J	N/A	N/A

MOTOR PIN OUT	PIN LETTER	WIRE NUMBER	WIRE COLOR
	A	1T1	BLACK
	B	1T2	RED
	C	1T3	WHITE
	D	GROUND	GREEN

NOTE:

This panel was sized for a 1.35 HP motor 480 VAC 3 phase drawing 2.7 amps at full load. If a different motor is being used please check fuse size and overload setting. YOU MUST CHECK MOTOR ROTATION BEFORE CYCLING THE UNIT WITH THIS PANEL!

TITLE		MOTOR REVERSING CONTROL FOR HAUSE A7 LEAD SCREW WITH DEMAG MOTOR		STAMP HAUSE PART NUMBER ON ALL PARTS REMOVE ALL BURRS & BREAK ALL CORNERS	
TOLERANCES UNLESS OTHERWISE SPECIFIED		MACHINES		PLOT DATE:	
DRAWN		SCALE		DATE	
CHECKED		DATE		FINISH	
3/17/08		3/17/08		21913-09	