

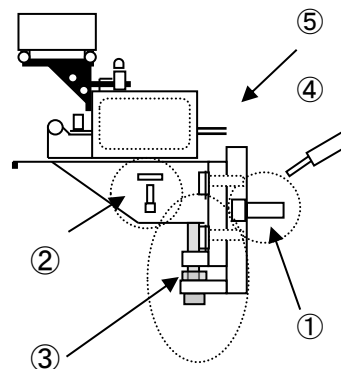
Model J06

Installation Manual

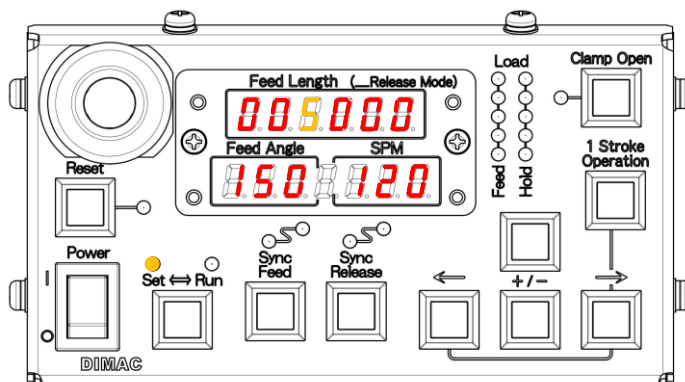
DIMAC

❖ Accessories

Description of good	J06
Bracket for machine	Exclusive type
Electrical cable	P6:8M
Emergency cable	8M
Air hose	8*5:6M
Air regulator	With air filter
Bolts	
①for the bracket	2-M12*30
②for the machine	4-M8*15
③pass line adjusting	1-M12*120
Fixture for the air regulator	2-M6*12
④Bonding	Net 4ml
Mark tube, Terminal	Assortment
Sticker	Signal(Feed/Release), Scale for pass line(on the bracket)
Air connector	1-TS8-03, 2-NTS8-02
⑤Apron plate	Exclusive type



❖ Method of Input








- ① **Power** Turn on "Power" switch
- ② **Set ↔ Run** You can input a set value when "Set" lamp is lit. Numeric value that can be changed item or number will be blink.
- ③ **← →** Using the switches, you can move the cursor position.
- ④ **+/-** Using the switches, you can change the value.

If you need to continue inputting, repeat the ③, ④.

After setting

- ⑤ **Set ↔ Run** Push "Set ↔ Run" switch, when "Run" lamp is lit, the setting

⑥	 Sync Feed 	 Sync Release 	Press the both switches of Sync Feed and Sync Release switches, then the controller will be able to receive the sync press cam signals.
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 Usually, the Release mode does not display. Only when changing settings item, the Release mode is supposed to display on the "Feed Length" after displaying digit of lowest of "Feed Length"

❖ J06 Pass line

The pass line height is decided by combination a plate and a holder.

CAUTION The plate-center equals the feeding rolls -center.

It is necessary to tighten 4 points with a bolt to fix the holder on the plate.

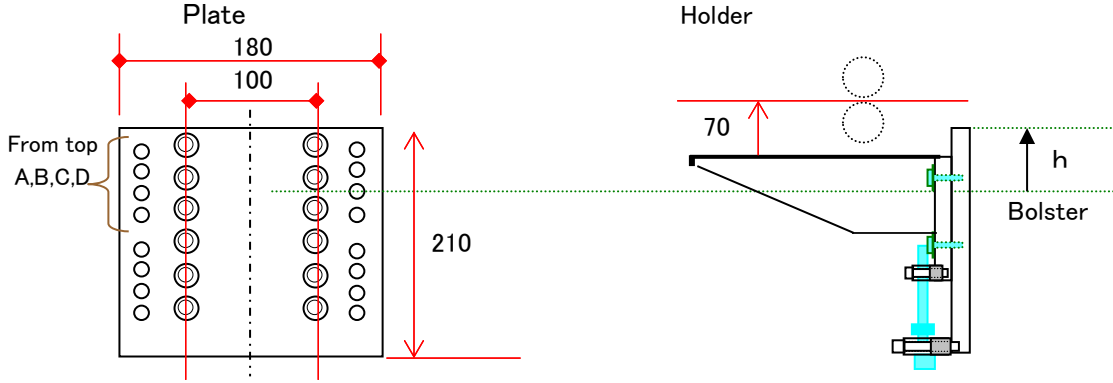
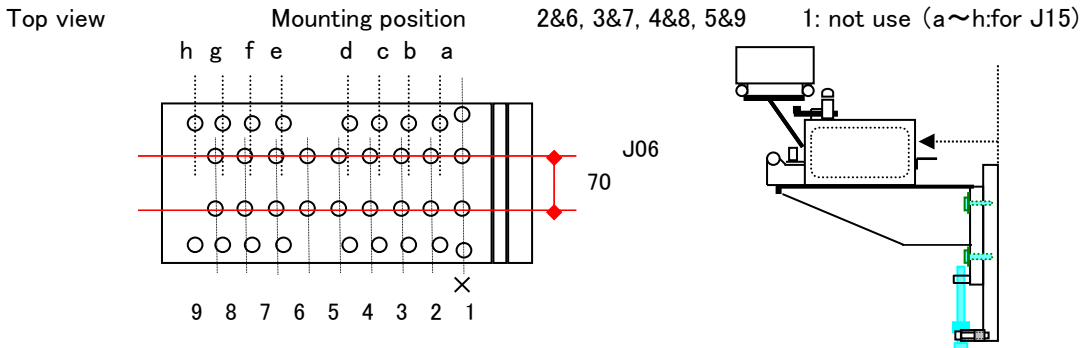
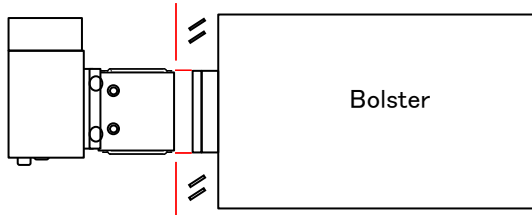


Plate height	Hole position	Pass line (mm)	Plate height	Hole position	Pass line (mm)
h=0	A	78~128	h=75	A	153~203
	B	63~113		B	138~188
	C	48~98		C	123~173
	D	33~83		D	108~158
h=25	A	103~153	h=100	A	178~228
	B	88~138		B	163~213
	C	73~123		C	148~198
	D	58~108		D	133~183
h=50	A	128~178	h=125	A	203~253
	B	113~163		B	188~238
	C	98~148		C	173~223
	D	83~133		D	158~208

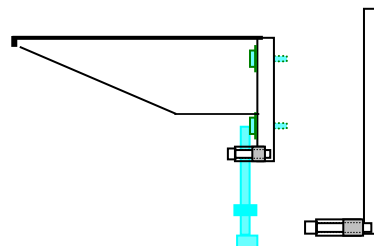
❖ Mounting position



❖ Balance of confirmation



❖ Assembly drawing of the bracket

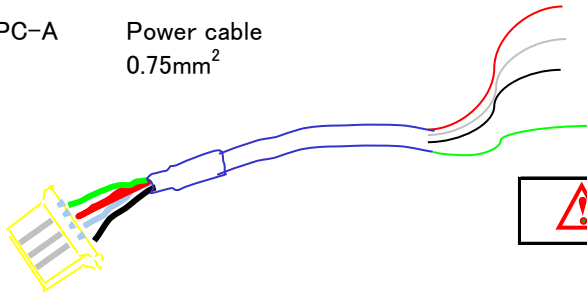


❖ Wiring

You can select which 3 phase or single phase. If it's single phase, you don't have to connect the black wire.

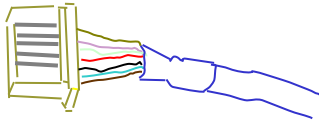
PC-A Power cable 0.75mm²

Red R(200V 50/60Hz)
 White S(200V 50/60Hz)
 Black T(200V 50/60Hz)
 Not wiring when single phase
 Green/Yellow E(Earth)

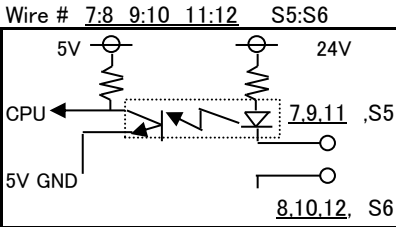


⚠ DANGER Connect to the primary side

PC-B Signal cable 0.5mm²

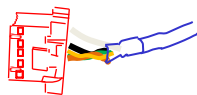


Wire #
1:2 1A at AC 250V or less
3:4 1A at DC 30V or less
5:6



Wire # 1A at AC 250V or less
S1:S2 1A at DC 30V or less
S3:S4

PC-C Emergency and press processing select 0.5mm²

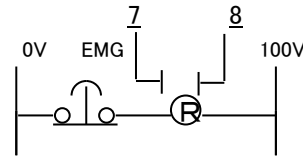


1 Drive stop signal output } To the stop continuous on the press circuit
2
 Option
3 Work shortage sensor } To the stop continuous on the press circuit
4 output
5 Continuous stop signal } To the stop continuous on the press circuit
6 output

7 Input stop of Feeder
8 24V GND

⚠ CAUTION
 Need to short, if not using.

Example for circuit



9 Feed input
10 24V GND Press cam signal
11 Release input Press cam signal
12 24V GND

S1 White: Emergency stop To Emergency stop circuit
 S2 Black: Emergency stop
 S3 Red: Emergency stop To Emergency stop circuit
 S4 Green: Emergency stop

Option
 S5 Yellow: Press cont. processing
 S6 Blown: 24V GND

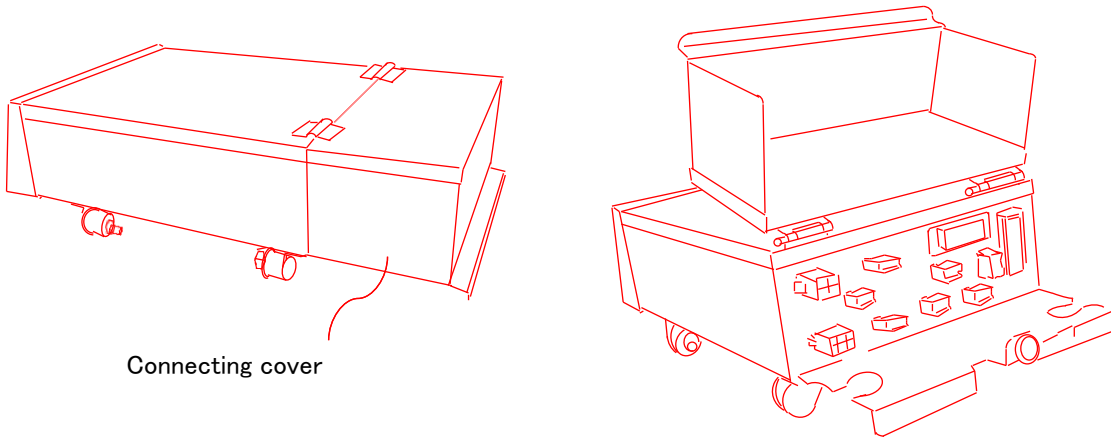
⚠ CAUTION
 Need to short, if not using.

i Need to short the circuit of press processing select(S5, S6), if you don't use the circuit.

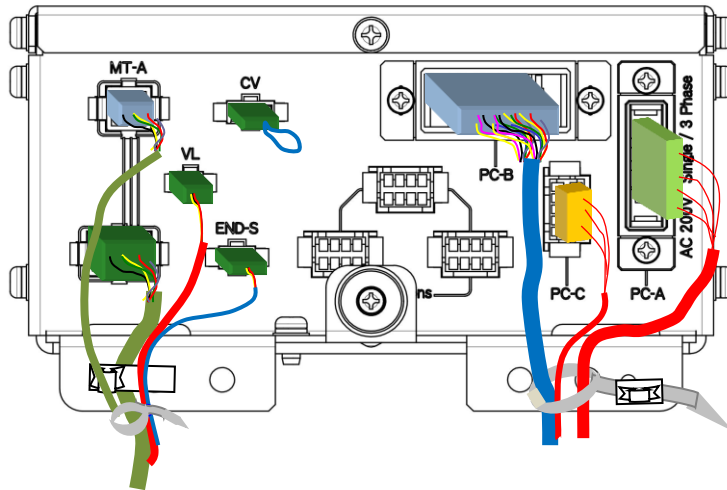
⚠ DANGER To cover each cable which is not using connection.

❖ Cable connecting

The receptacles of PC-A, PC-B, PC-C are placed inside the connecting cover.

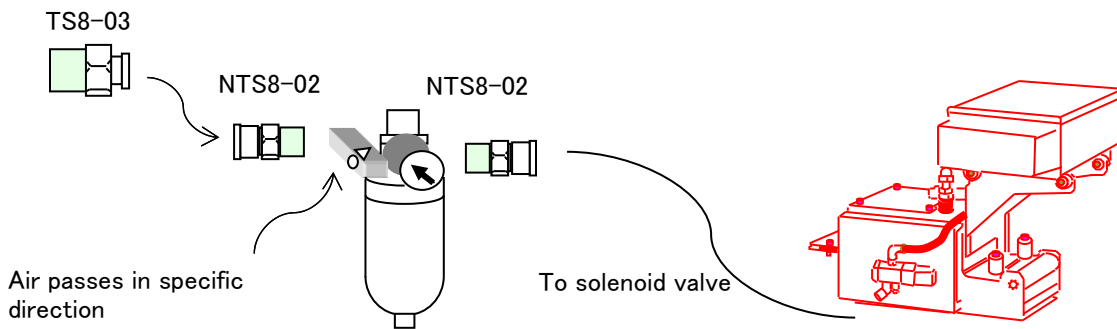


Connecting cover



	DANGER	Need to fix three external cables in prepared nylon band.
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❖ Air piping




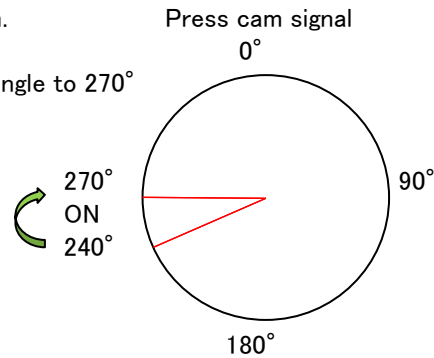
	CAUTION	*Approximate air pressure : 0.3~0.5 MPa *Maximum air pressure: 0.5 MPa
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❖ Adjusting Press cam signals

Feed signal adjusting

Set the feed start position to feed signal OFF position.
 When you make the feed starts on 270° ,
 Set the ON angle of feed to 240° , and set the OFF angle to 270°

	NOTE
Need to set the ON of the feed signal to the feed completed angles when using option "Overrun-Function".	

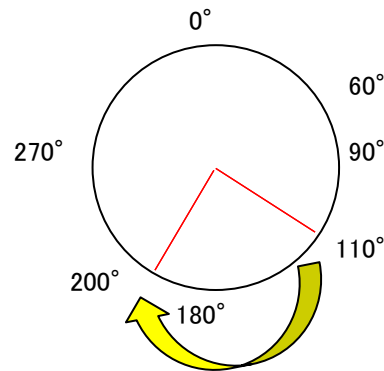


Release signal adjusting

Set the ON to the release start angle, and set the OFF to the finish.
 When the release angle is assumed to 200° from 200° ,
 you turn on the press cam signal in 110 degrees,
 and turn off in 200 degrees.

The retention angles of the release ON must be 25 degrees or more.

Need to adjust the signal of the release start even if the release system is used a time setting of timer or angles.



❖ Release setting in the controller 【 (_ Release Mode) 】


【 (_ Release Mode) 】 The display is the back screen of 【 Feed Length 】.
 The Release mode is supposed to display on the "Feed Length" after displaying digit of lowest of "Feed Length"

Using "+" or "-" switch, Set the release mode.

The Release mode are as follows, Release OFF, Synchronization press cam signal, Timer finish.

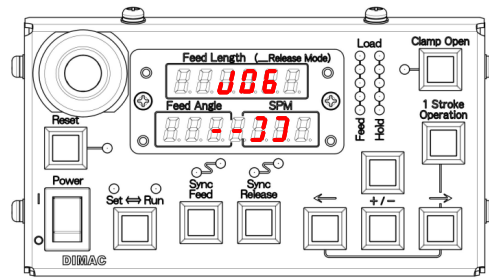
Display and contents

Feed Length (_Release Mode)	Contents
-- Sync	Synchronization press cam signal
--- OFF	Invalid the release signal, Release off state.
--- RO1 ~	Release angles setting. It can be input from 1° to 50° . the control calculates the release time from the setting SPM and the angles, the release will operate in the time range.
--- RSO	Input the release strat using the press cam signal.
--- FO1 ~	Release timer setting. It can be input from 0.001sec to 0.05 sec. Input time period, the release carry out.
--- FSO	Input the release strat using the press cam signal.

	NOTE	The release operation is delayed due to air cylinder. The delay time will vary depending in the springs pressure.
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❖ Message code

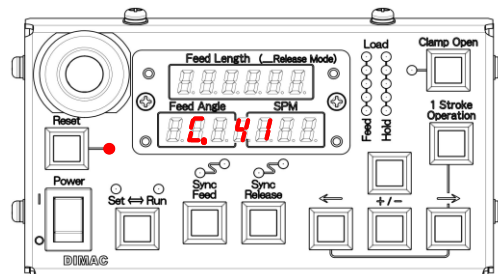
Contents display : 【 Feed Length (_Release Mode) 】, Code number : 【 Feed Angle SPM 】



Feed Length	Feed Angle	SPM	Contents	Method of reset
J06	- - } } - - } } [[- - [[- -		Ins. Left, Direction Push Model Ins.Right, Direction Pull number Ins. Left, Direction Pull Ins.Right, Direction Push	When turning on power only, the control panel displays the program
ENG	444444 444444		Emergency stop switch ON Emergency stop switch OFF	After releasing the Emergency stop switch, turn off the power.
SSTOP	10 10 10 10 10 10 111111		Input stop signal during driving press Input stop signal release Input stop signal	Turn on Reset switch after input stop signal release Turn on Reset switch Automatic reset
End	777777		Work shortage sensor ON	After setting a work pieces, turn on "Reset" switch
End_2	777777		Another work shortage sensor ON	
End	777777		Work shortage sensor release	Turning off "Sync Feed", the work shortage sensor will disabled.
End_2	777777		Another work shortage sensor release	
I - F	66 166 1		Interfere releasing	Turn on "Reset" switch
	662662		Input feed signal during feeding	
	663663		Input feed signal during releasing	
	664664		Input release signal during feeding	
0_run	666666		Overrun	Turn on "Sync Feed" and "Sync Release" after turn on "Reset" switch

❖ Caution display

This caution displays have a possibility which the feeder is reset. These displays are as the follows,
Reset : Blinking. Feed Angle SPM : [Number



Code	Number	State / Content	Note
[40	Open phase	Confirmation of the power supply
[41	Low voltage detection	Checking the voltage
[10 - 1	Setting mistake of the motor capacity	Initial setting mistake
[10 - 2		
[50 - 1	Motor connection anomaly	Contact failure
[50 - 2		
[50 - 3	Malfunction of Rotation sensor	Setting mistake