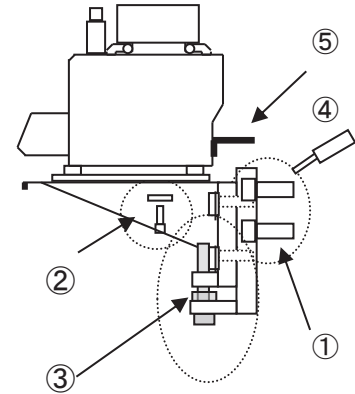


Installation Manual

❖ Accessories of Installation

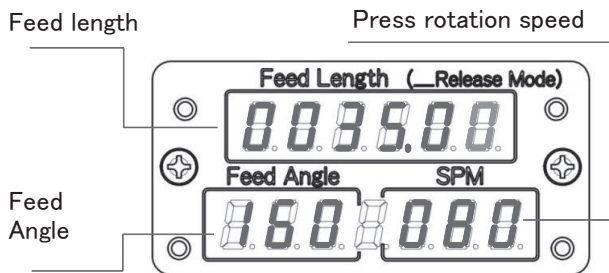
Description of good	R30, R40, R50
Bracket for machine	Exclusive type
Electrical cable	P6: 8M
Emergency cable	8M
Air hose	8*5: 6M
Air regulator	With air filter
Bolts	
① for the bracket	4-M14*30
② for the machine	4-M8*25
③ pass line adjusting	1-M12*120
Fixture for the air regulator	2-M6*12
④ Bonding	Net 4ml
Mark tube, Terminal	Assortment
Sticker	Signal(Feed/Release), Scale for pass line (on the plate)
Air connector	1-3/8B, 2-2/8B
⑤ Apron plate	Exclusive type



❖ Setting Items

Feed Length, Feed Angle, SPM

Changeable main screen in "Set" state.



Setting method of table screen

- ① **Power** Turn ON "Power switch"
Numeric value that can be changed item or number will be blink.
- ② ← → Setting items can be changed.
- ③ + / - The value can be Changed.

If you need to continue inputting, repeat ②,③.

After setting

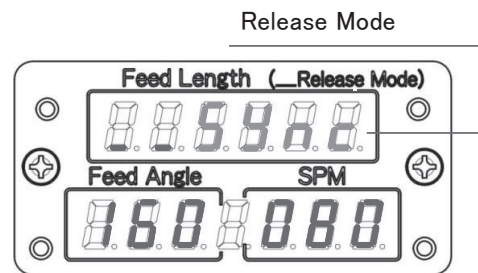
- ④ **Set ⇌ Run** Push "Set ⇌ Run" switch, when "Run" lamp is lit, the setting finishes.

Synchronous operation

- ⑤ **Sync Feed** **Sync Release**

Release Mode

"Release Mode" is not displayed in "Set" state. To display "Release Mode", push on "Sync Release" switch in "Set" state.



Setting method of "Release Mode"

- ① **Power** Turn ON "Power switch"
Numeric value that can be changed item or number will be blink.
- ② First, push on "Sync Release" switch, keep it.
- ③ + / - The value can be Changed.
When "Sync Release" is turned off, the display returns the main screen.

Press the both switches of Sync-Feed, -Release switches, then the feeder will be able to operate automatically.

❖ R30, R40, R50 Pass line

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

	CAUTION	The plate-center equals the feeding rolls -center.
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It is necessary to tighten 4 points with a bolt to fix the holder on the plate.

The plate has 4 bolts. The plate thickness: 22mm

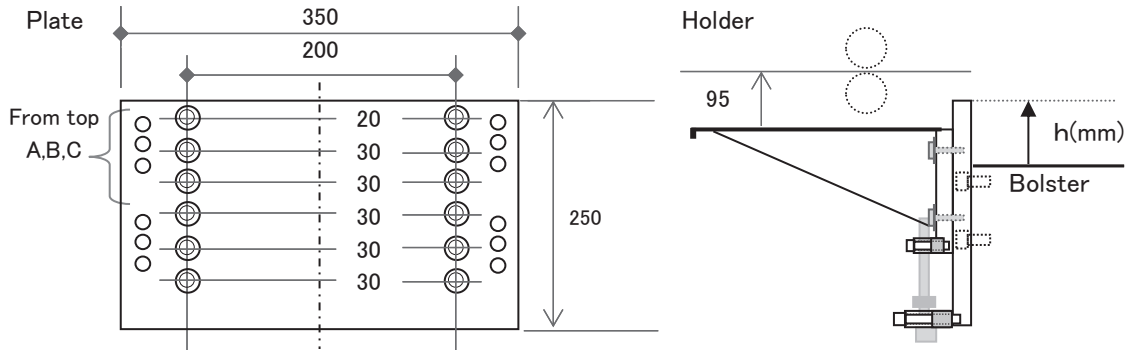
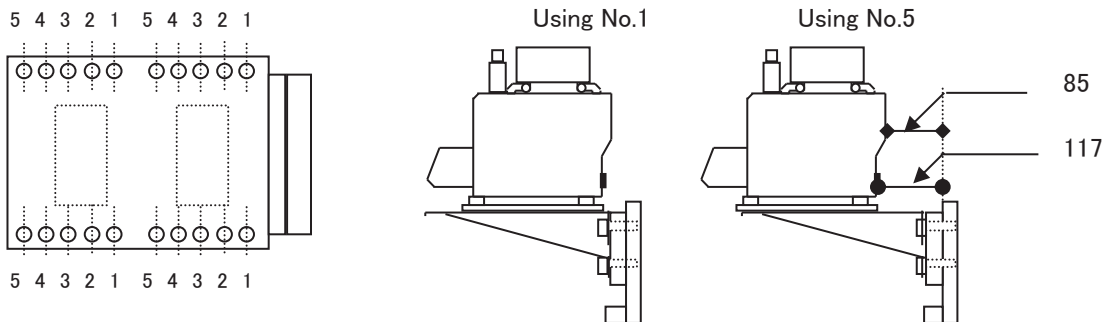


Plate height	Hole position	Pass line (mm)	Plate height	Hole position	Pass line (mm)
h=0	A	110~165	h=90	A	200~255
	B	90~145		B	180~235
	C	70~125		C	160~215
h=30	A	140~195	h=120	A	230~285
	B	120~175		B	210~265
	C	100~155		C	190~245
h=60	A	170~225	h=150	A	260~315
	B	150~205		B	240~295
	C	130~185		C	220~275

	CAUTION	In case of the pass line over 285mm, Need to add processing holes for fixing bolts.
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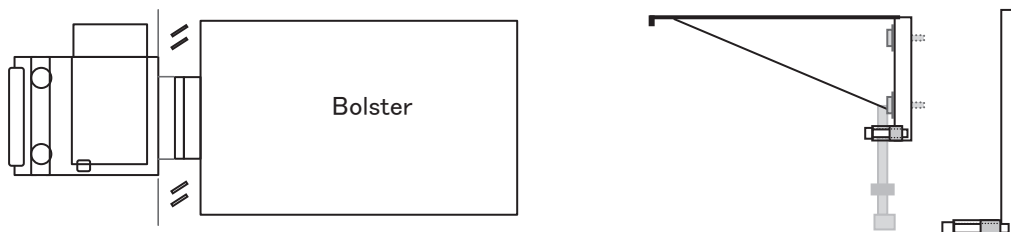
❖ Mounting position

Main machine-Mounting position: 5



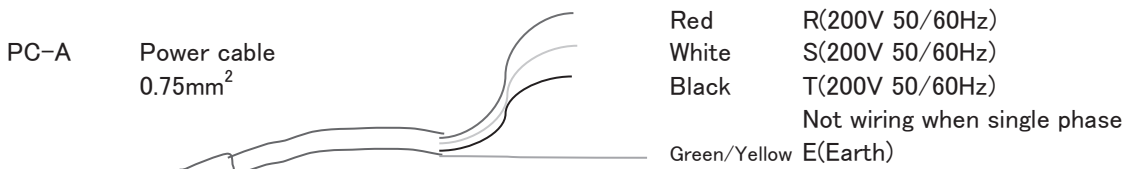
❖ Confirmation of balance

❖ Assembly drawing of the bracket

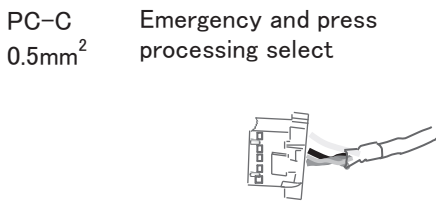
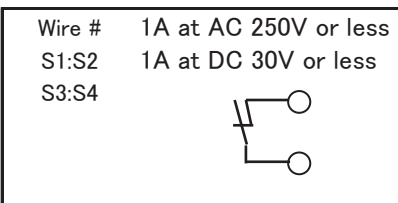
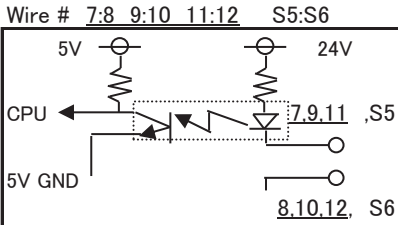
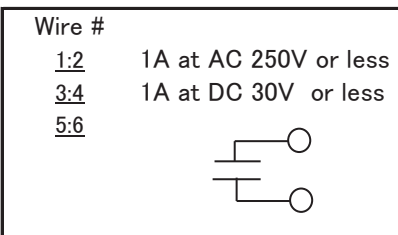
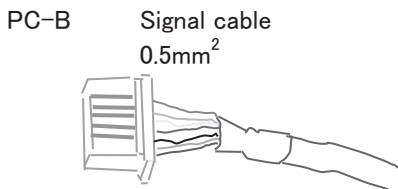


❖ Wiring

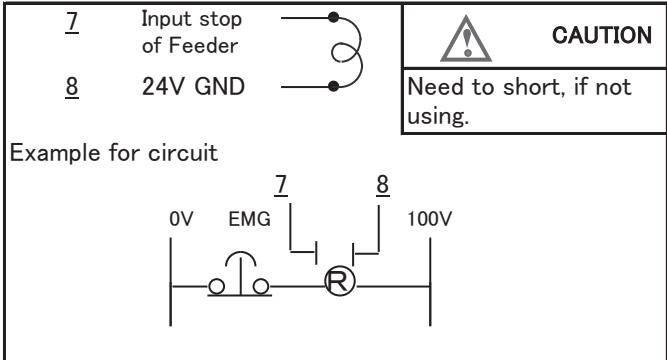
You can select which 3 phase or single phase. If it's single phase, you don't have to connect the black wire.



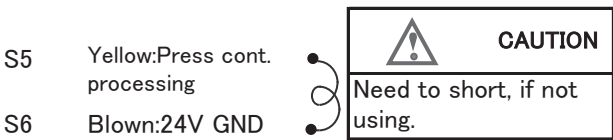
⚠ DANGER Connect to the primary side



- 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 }



- 9 Feed input
 - 10 24V GND
 - 11 Release input
 - 12 24V GND
- S1 White:Emergency stop To Emergency stop circuit
- S2 Black:Emergency stop To Emergency stop circuit
- S3 Red:Emergency stop To Emergency stop circuit
- S4 Green:Emergency stop To Emergency stop circuit



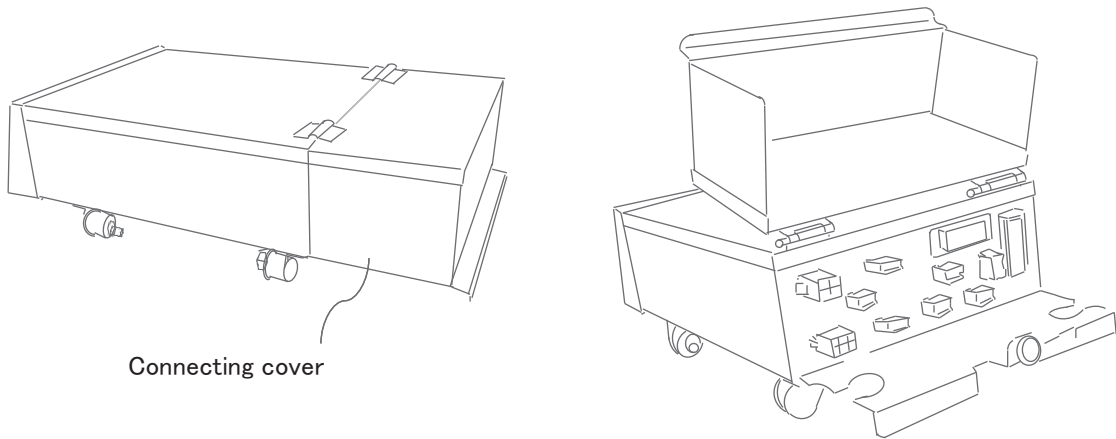
i Need to wire the release signal, Otherwise Not available in continuous feeding because of checking the movement of the press using two cam signals.

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

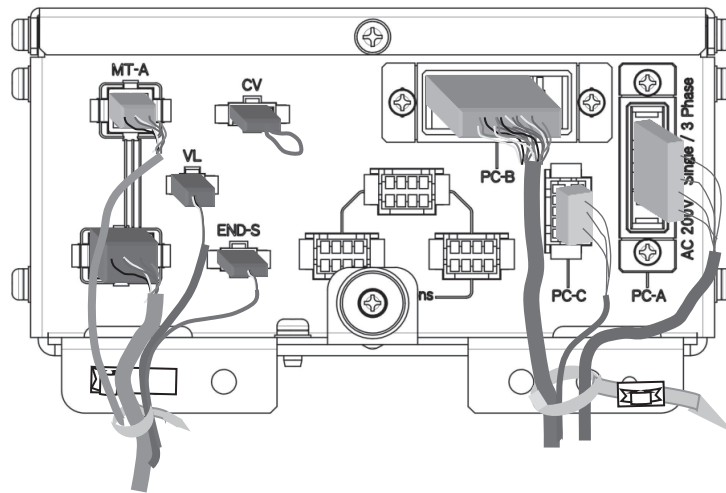
⚠ DANGER To cover each cable which is not using connection.

❖ Cable connecting

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

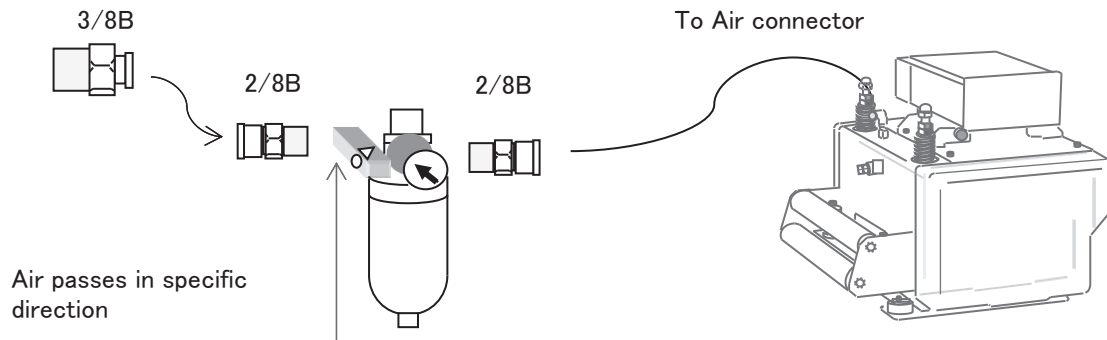


Connecting cover



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




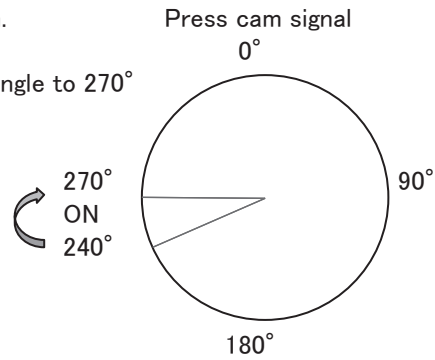
	CAUTION	*Approximate air pressure : 0.3~0.5 MPa *Maximum air pressure: 0.5 MPa
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❖ Adjusting Press cam signals

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".	

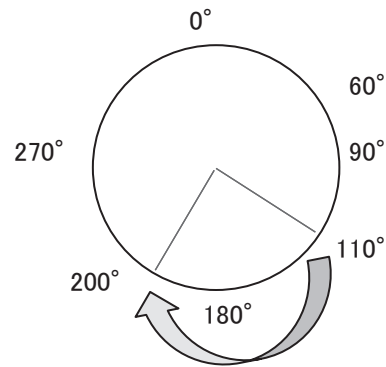


Release signal adjusting

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) 】

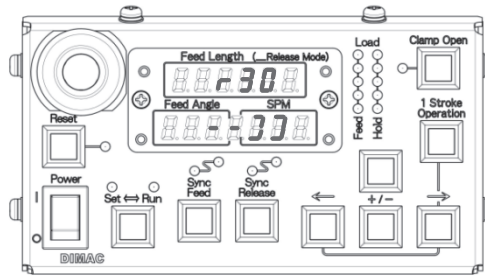
【 (_ Release Mode) 】 the display is the back screen of 【 Feed Length 】.
 Release Mode is not displayed in "Set" state only.
 To display " Release Mode", Push on "Sync Release" switch in "Set" state.
 To change the "Release Mode", Keep "Sync Release" switch ON, and using "+" or "-" switch,
 You can change the release mode.

Display and contents

Feed Length (_ Release Mode)	Contents
- - Sync	Synchronization press cam signal
- - - OFF	Invalid the release signal, Release off state.
- - - RD1 ~ - - - RSD	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. Input the release start using the press cam signal.
- - - RD1 ~ - - - RSD	Release timer setting. It can be input from 0.001sec to 0.05 sec. Input time period, the release carry out. Input the release start 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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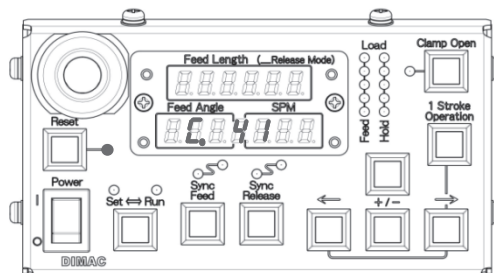
The code will display the operating state of the feeder to suit the operation state and setting disabled state.



Feed Length	Feed Angle	SPM	Contents	Method of reset
r 30	- - 3 3	Model number	Position: Left Direction: L to R	When turning on power only, the control panel displays the program
	- . 3 3		Position: Right Direction: L to R	
	∞ - -		Position: Left Direction: R to L	
	∞ . - .		Position: Right Direction: R to L	
ENG	444444	Emergency stop switch ON	After releasing the Emergency stop switch, turn off the power	
	444444	Emergency stop switch OFF		
STOP	∞ ∞ ∞	Input stop signal during driving press	Turn on Reset switch after input stop signal release	
	∞ ∞ ∞	Input stop signal release	Turn on Reset switch	
	∞ ∞ ∞	Input stop signal	Automatic reset after clear	
End	777777	Work shortage sensor ON	After setting a work pieces, turn on "Reset" switch	
End_2		Another work shortage sensor ON		
End	777777	Work shortage sensor release	Turning off "Sync Feed", the work shortage sensor will disabled.	
End_2		Another work shortage sensor release		
I - F	66 166 1	Interfere releasing	Turn on "Reset" switch	
	662662	Input feed signal during feeding	Turn on "Sync Feed" and "Sync Release" after turn on "Reset" switch	
	663663	Input feed signal during releasing		
	664664	Input release signal during feeding		
0_run	666666	Overrun		

❖ 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
∞	50 - 1	Motor connection anomaly	Contact failure
∞	50 - 2		