

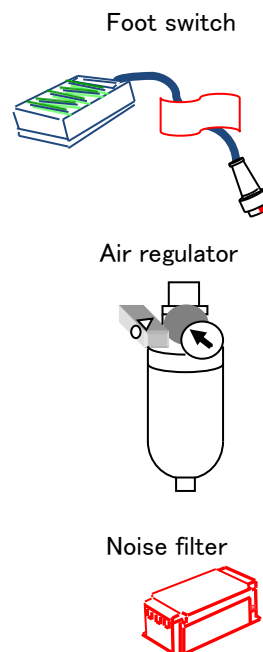
# Model T20 · T30

# DIMAC

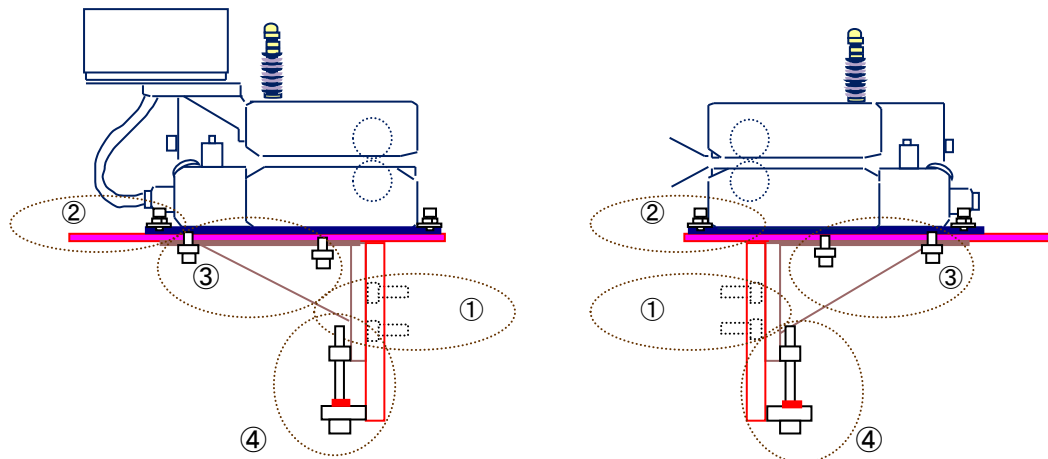
Installation Manual

❖ Accessories of Installation

Description of good	T20·T30
Bracket for machine	Exclusive type : 2 sets
Slide plate	Exclusive plate : 2
Electrical cable	Power, Signal, Emergency
Relay cable for Motor & Solenoid	1-6M
Foot switch	1
Air hose	8*5:6M
Air regulator	Standard
Bolts	
① Fixture bolts for bracket	8-M14*30
② Foxture bolts for machine	8-M8*15, Spring washer, Washer
③ Fixture bolts for slide plate	8-M10*25, Washer
④ Pass line adjusting	2-M12*120
Fixture bolts for air regulator	2-M6*12
④ Bonding	Net 4ml
Mark tube, Terminal	Assortment
Sticker	Signal, Scale for pass line
Air connector	1-3/8B, 1-UT-8, 2-2/8B



❖ Bolt-positions for the machine setting



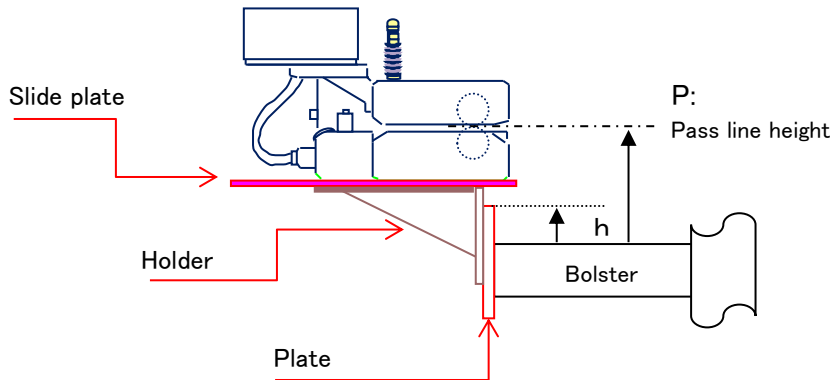
**CAUTION** Please note whether T throttle nuts are inserted because of closing the grooves by the bracket for feeder.

❖ Code

Feed Length ( L )	Feed Length ( R )	Contents	Method of reset
ENG	444444	Emergency stop switch ON	After releasing the Emergency stop switch, turn off the power
	444444	Emergency stop switch OFF	
STOP	10 10 10	Input stop signal during driving press	Turn on Reset switch after input stop signal release
	10 10 10	Input stop signal release	Turn on Reset switch
	111111	Input stop signal	Automatic reset after clear
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	

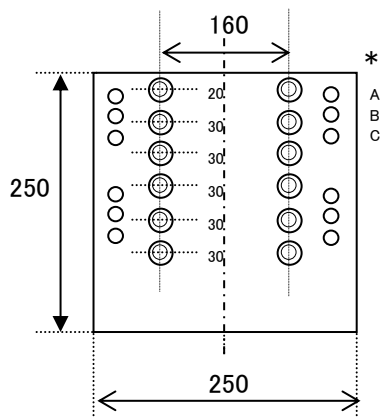
❖ Installation of main machine

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



The plate-center equals the feeding rolls-center.

Plate thickness: 22mm



Pass line

Plate height	P: Pass line
	T20,30
h=0	118~173
h=30	148~203
h=60	178~233
h=90	208~263
h=120	238~293

In case of using slide plate, the tap hole on the plate fixed the holder is A only.

	<b>CAUTION</b>	Not available in B, C.
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❖ Slide plate

By using the slide plate, you will be able to slide the machine mounted to left and right.

The slide plate has 6 steps the fixture holes for fixing the holder.

Slide plate

Top view, example Left side

Thickness =13mm

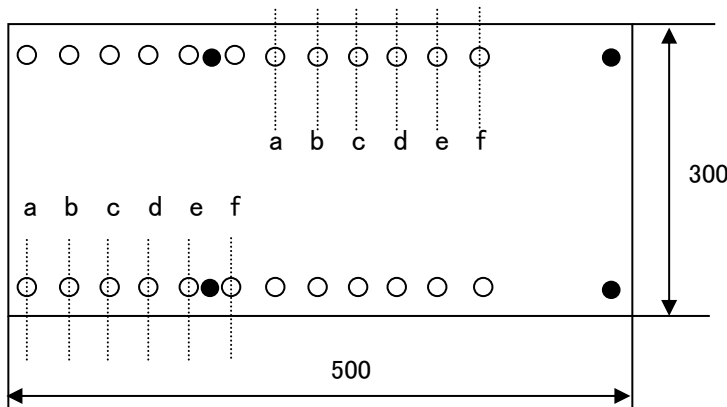


Plate tap position	Slide length L	Roll position R
a	240~ 80	155~ -5
b	210~ 50	125~ -35
c	180~ 20	95~ -65
d	150~-10	65~ -95
e	120~-40	35~-125
f	90~-70	5~-155

	<b>CAUTION</b>
● 4-M8	For main machine

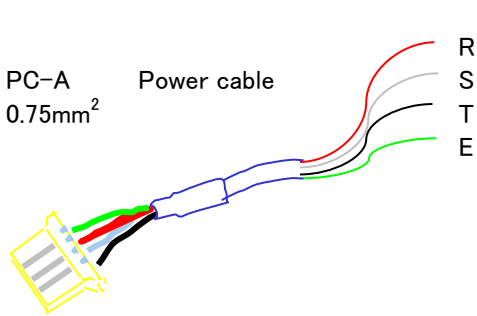
	<b>NOTE</b>	The slide plate and the bracket for main machine are common specification on the left and right.
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	<b>CAUTION</b>	Do not remove the slide fixing bolt when adjusting the slide position. After adjustment, be sure to tighten loosened bolts.
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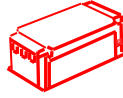
❖Wiring

The electrical power supply is available in 3 phase or 1 phase 200 voltage.  
We recommend 3 phase 200 voltage because of power supply stabilization.

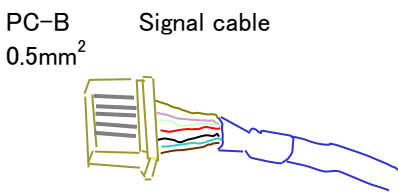
**WARNING** Noise filter is required due to using extension cable.



Noise Filter

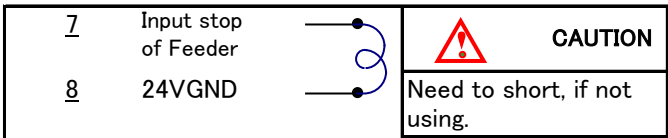
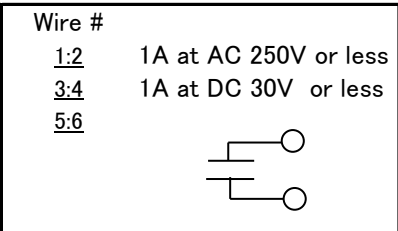


Red R(200V 50/60Hz)  
White S(200V 50/60Hz)  
Black T(200V 50/60Hz)  
Green / Yellow E(Earth)

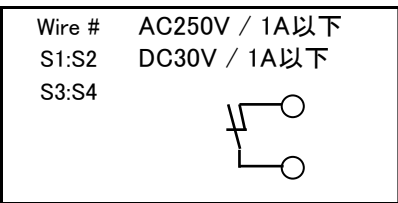
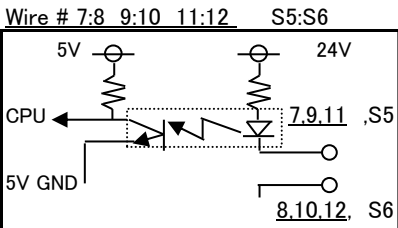
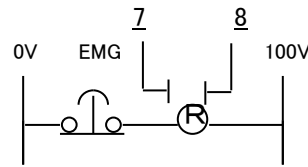


**DANGER** Connect to the primary side

- 1 Drive stop signal output } To the stop continuous on the press circuit
- 2
- 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 }

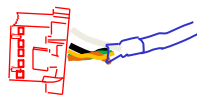


Example for circuit

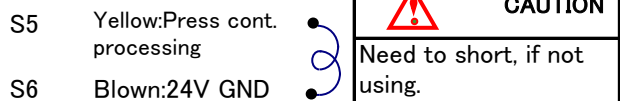


Option		
<u>9</u>	(Feed)	
<u>10</u>	24V GND	Press cam signal
<u>11</u>	(Release)	
<u>12</u>	24V GND	Press cam signal

PC-C Emergency and press processing select  
0.5mm<sup>2</sup>



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

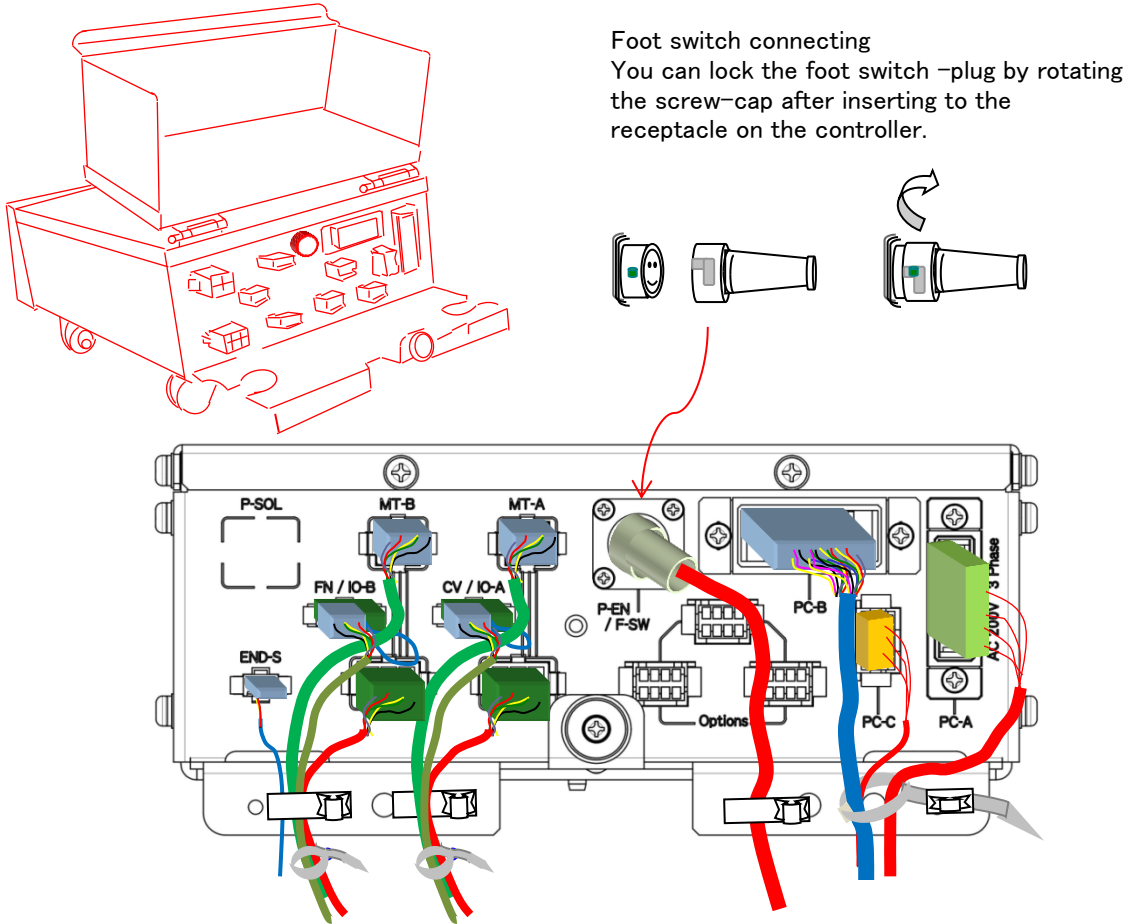


**CAUTION** Need to short the circuit of press processing select(S5, S6), if you don't use the circuit.

**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.

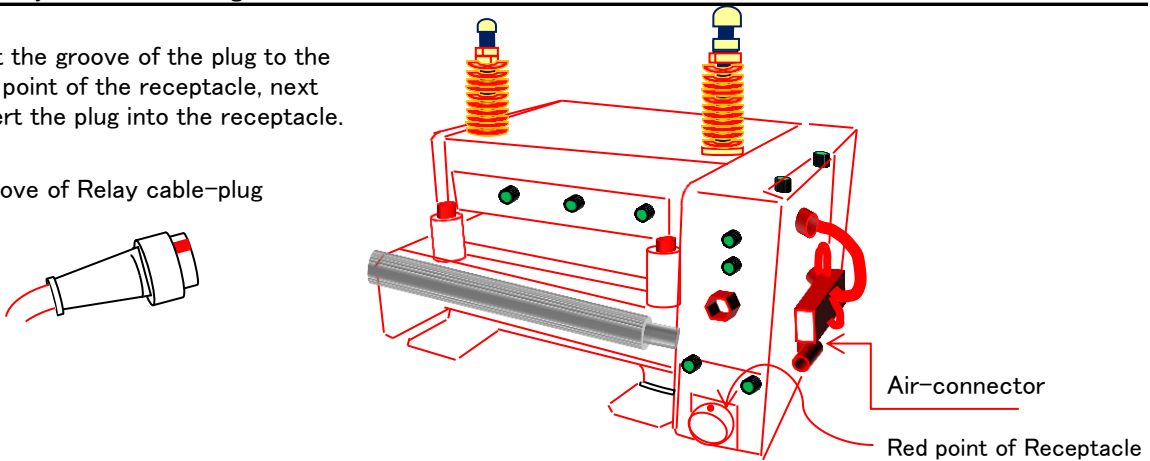


**⚠ DANGER** Need to fix all connecting cables by using some prepared clampers and Nylon band.

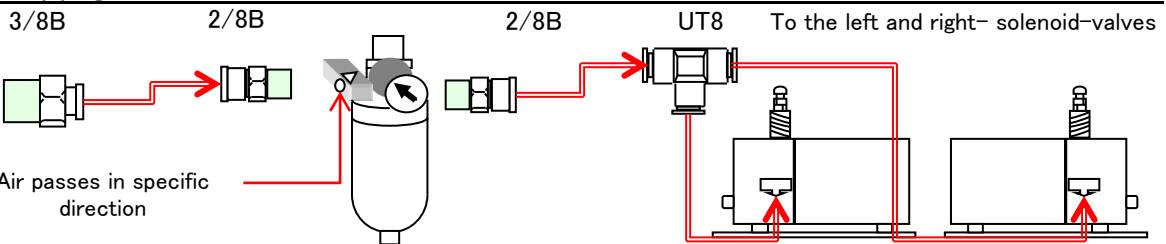
❖ Relay cable connecting

Suit the groove of the plug to the red point of the receptacle, next insert the plug into the receptacle.

Groove of Relay cable-plug



❖ Air piping

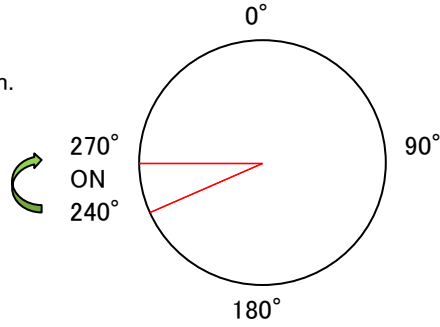


**⚠ CAUTION** Approximate air pressure : 0.3~0.5 Mpa  
Maximum air pressure: 0.5 Mpa

❖ Press synchronous operation

Setting press cam signal for feed

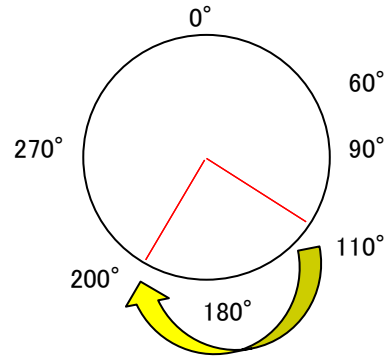
Set the feed start position to feed signal OFF position.  
 When you make the feed starts on 270° ,  
 Set the ON angle of feed to 240° , and set  
 the OFF angle to 270°



When using optional overrun function, the setting of the press cam signal is different.

Setting press cam signal for release

When the release start angles is at 110 degrees,  
 Set on 110 degrees the release signal.  
 If you finish the release at 200 degrees,  
 Set off 200 degrees the release signal.



Need to set ON the press cam signal for release signal even if you use the release angle setting or timer setting.

❖ Release mode setting 【 Release Mode 】

【 Release Mode 】 - - 54nc is standard setting.

Changing method : Push on " Sync Release " Keep on it,

Using +/- switch, you can change the release mode.

The available in the release mode is as the follows, Release OFF, Synchronization with press cam signal, Timer setting.

Display and Contents

Release Mode	Contents
- - 54nc	Synchronization press cam signal
- - - OFF	Invalid the release signal, Release off state.
- - - R01 ~	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.
- - - R50	Input the release start using the press cam signal.
- - - T01 ~	Release timer setting. It can be input from 0.001sec to 0.05 sec. Input time period, the release carry out.
- - - T50	Input the release start using the press cam signal.

	<b>NOTE</b>	The release operation is delayed due to air cylinder. The delay time will vary depending in the model.
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❖ Feed Angle Setting 【 Feed Angle 】

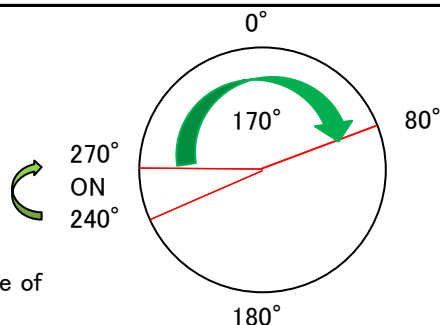
Input the available angles from feeding start to feeding end angles.

For example

Feed start: 270°

Feed end: 80°

The value for 【Feed Angle】: 170°



Please note that Set the angles which are the suitable of the die mold and other equipment.

❖ Auto drive setting for Sheet Mode

When input power, the feeder starts up in "Set" state.

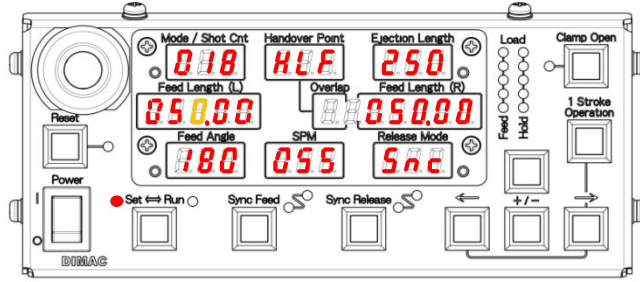
The blinking display is a changeable item.

Using ← → switch, you can change the position.

Change the setting value with + / - switch.



Changing "Release mode" method is that keep on push "Sync Release", then using + / - switch.



Items	Display contents	Contents
Mode / Shot Cnt.	Press shot count	Coil mode conditions are necessary from initial setting.
Ejection Length	000 ~ 999 (unit mm)	Valid only in the sheet mode
Feed Length (L)	Left side feeder	0~999.99mm. Minimum setting unit: 0.01mm Both feed lengths are interlocked within ±1% or ±1mm. After entering the feed length of one side, you can set the same value in another one by using "1 Stroke Operation"
Feed Length (R)	Right side feeder	
Feed Angle	Effective feed angle	Set according to the die mold and some peripheral equipment.
SPM	Press rotation speed	Input the using press rotation speed. If the press-start may overshoot at the moment, require to set large number than the actual condition.
Release Mode	Statement	Synchronize with press cam, Timer, Release OFF

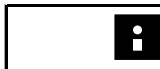
■ Press synchronous operation start setting

After setting "Run", using "Clamp Open" switch, insert workpiece into the feeder, push on "Sync-Feed, Release", then it's possible to synchronized driving.

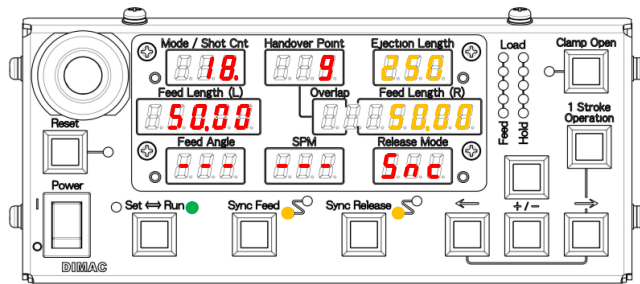
The driving side feeder is displayed with high brightness.



"Clamp Open" switch is not available when "Sync-Feed, release turn on with "Run" state.



If you open the roll by "Clamp Open" switch, need to turn off "Sync-Feed, Release".

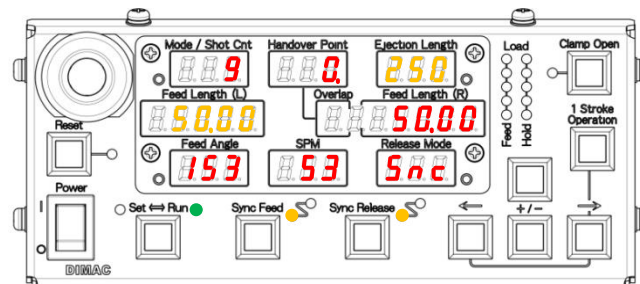
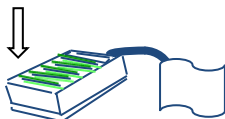


When the workpiece shifts to another feeder, Handover Point display: 0

When the press shot finishes, the feeder opens the roll with ejection the workpiece.

Continuous operation in the sheet mode

After inserting workpiece, you can operate the press driving by using the foot switch.



Need to set the press synchronous operation start setting when you return to state of set.

