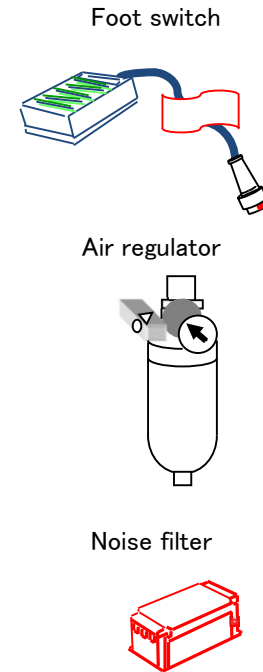
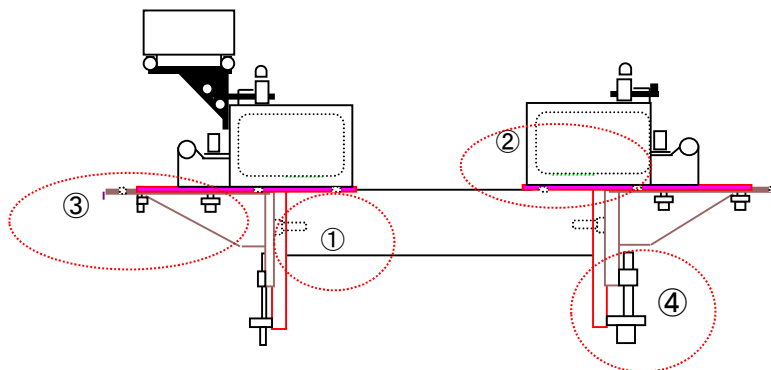


Description of goods	TJ06 · TJ15
Bracket for machine	Exclusive type : 2 sets
Slide plate	Exclusive plate : 2 sets
Electrical cable	Power, Signal, Emergency
Relay cable for Motor & Solenoid	1-6M
Foot switch	1
Air hose	8*5:6M
Air regulator	Standard
Bolts	
① Fixtyre bolts for bracket	4-M12*30
② Fixture 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
Bonding	Net 4ml
Mark tube, Terminal	Assortment
Sticker	Signal, Scale for pass line
Noise filter	4-M4, Spring washer, Washer
Fixing bolt, spring washer, washer	4-M4*15+nut / 4-M10
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.
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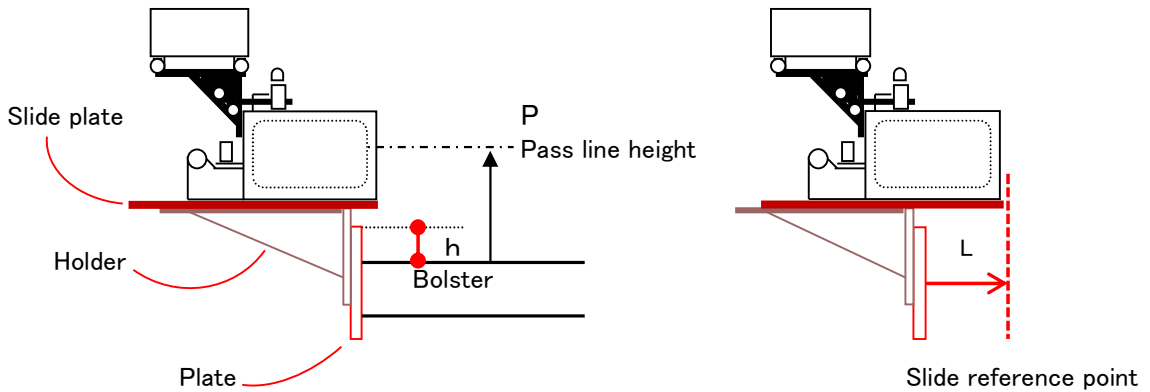
❖ Code

Feed Lengh (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

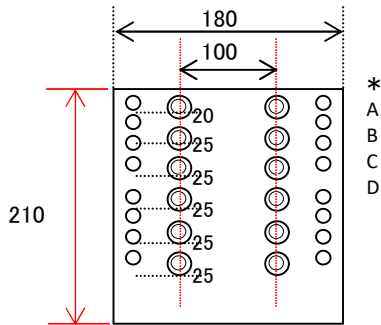
The pass line height is decided by combination a plate and a holder.


	NOTE	The slide plate and the bracket for main machine are common specification on the left and right.
---	------	--



The plate-center equals the feeding roll-center.

Plate thickness : 20mm



	CAUTION	Valid hole: A only. (B,C,D-hole is not available.)
---	---------	--

TJ06	
h	P
Plate height	Pass line
h=0	90~140
h=25	148~203
h=50	178~233
h=75	208~263
h=100	238~293

TJ15	
h	P
Plate height	Pass line
h=0	110~160
h=25	135~185
h=50	160~210
h=75	185~235
h=100	210~260

Use the B hole in the holder stop position for the minimum pass line in the bolster installation.

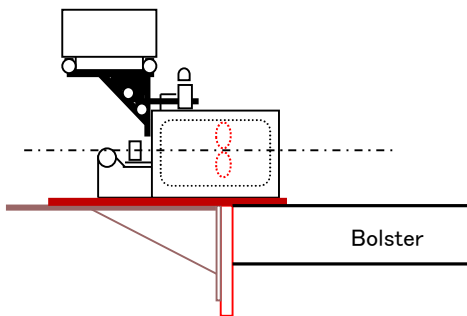


Plate height	Mounting position	Pass line	
		J15	J06
h=0	A	110~160	90~140
	B	103~145	83~125
	C	*	
	D	*	

❖ Slide plate

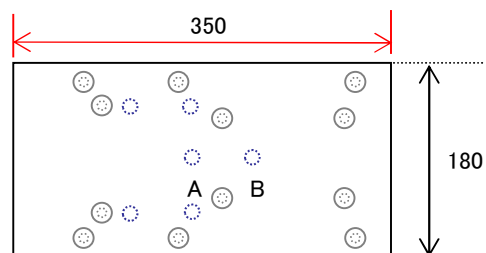
TJ06•TJ15 : The standard product is equipped with a slide plate.

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

TJ06•TJ15

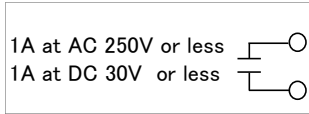
Plate fixing bolt : 3-M8*15

Slide plate hole position	Slide position L
A	-10~120
B	-70~60

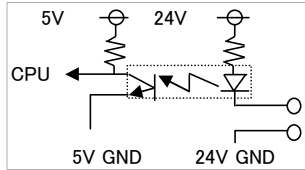


There are three of circuit relay which are listed A,B,C below and an electrical power.

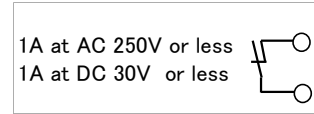
Circuit relay A




Circuit relay B



Circuit relay C



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


PC-A Power cable AWG12 (H Series : AWG18)

Electric power: 3 phase 200V.

Maximum power consumption: 12.5KW (200V / 37A)


The electrical noise filter is required when the feeder occurs an error by a servo press, etc.

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

 **WARNING** Power supply requires primary connection.

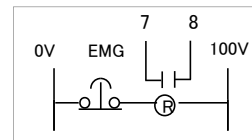
PC-B Signal cable AWG20


1	Press stop output	To the drive stop circuit	Circuit relay A
2			
3	Work shortage sensor output	To the work shortage stop circuit	Circuit relay A
4			

 T series is using as circle stop .


5	Continuous drive stop output	To the continuous drive stop circuit	Circuit relay A
6			
7	Stop feeder input	To external stop output	Circuit relay B
8	24V GND		

For Example 7,8 wiring Press Emergency stop circuit




 **WARNING** Need to short, if not using.

9	Feed input	To press cam signal	Circuit relay B
10	24V GND		
11	Release input	To press cam signal	Circuit relay B
12	24V GND		

 H, A-A, G series are using the exclusive rotation sensor, by using cam signal, available in detecting the disconnection of timing belt for the rotation sensor.

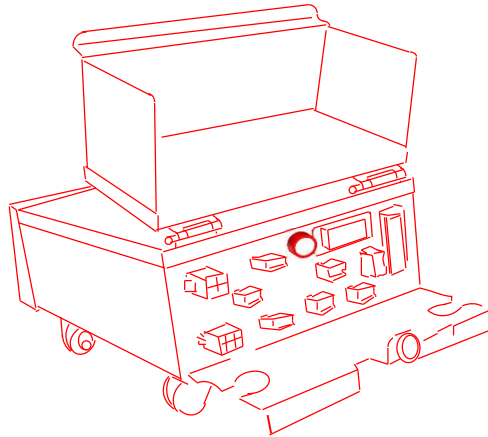
PC-C Emergency stop and press processing select AWG20

S1	White	Emergency stop output	To press emergency stop circuit	Circuit relay C
S2	Black			
S3	Red	Emergency stop output	To press emergency stop circuit	Circuit relay C
S4	Green			
S5	Yellow	Press processing input	To press continuous circuit	Circuit relay B
S6	Blown	24V GND		

 **WARNING** Need to short, if not using.

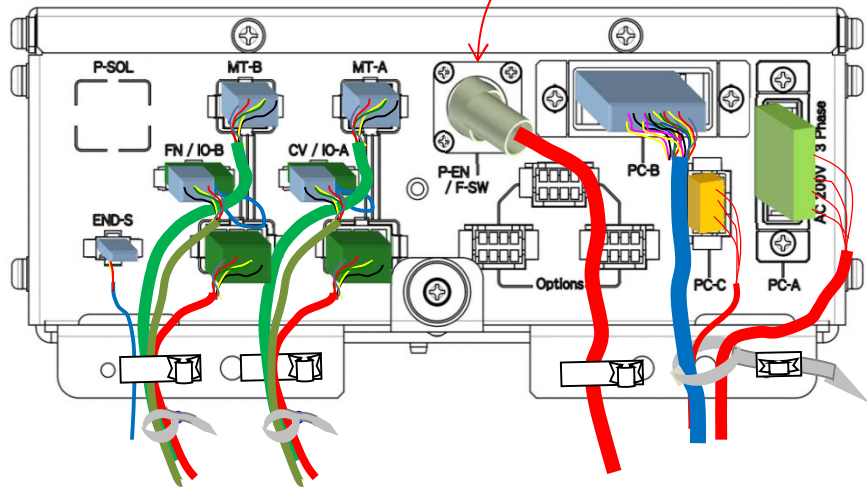
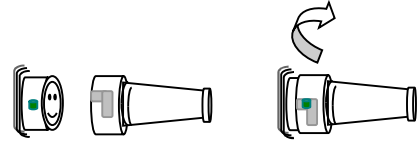
❖ cable connecting

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



Foot switch connecting

You can lock the foot switch -plug by rotating the screw-cap after inserting to the receptacle on the controller.

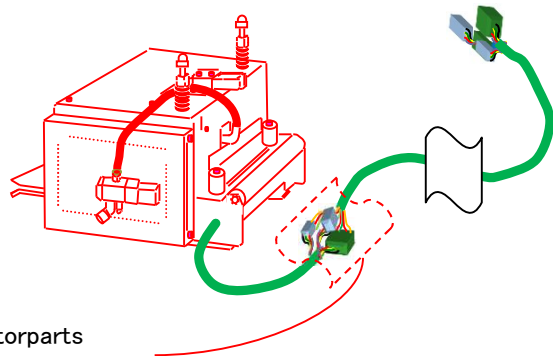


	DANGER	Need to fix all connecting cables by using some prepared clampers and Nylon band.
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❖ Relay cable connecting

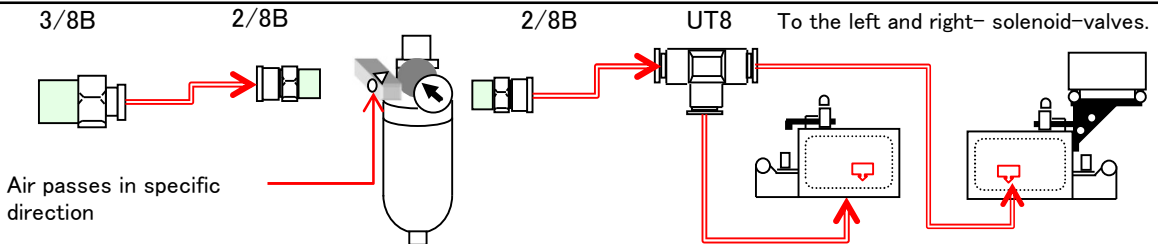
TJ06, TJ15

The relay-cables are connected outside of the feeder.



Covered connectorparts

❖ Air piping

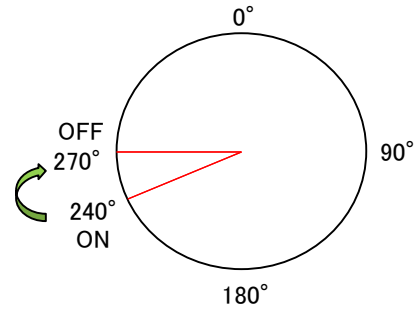


	CAUTION	Approximate air pressure : 0.3~0.5 Mpa Maximum air pressure: 0.5 Mpa
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❖ Press synchronous operation

Setting press cam signal for feed

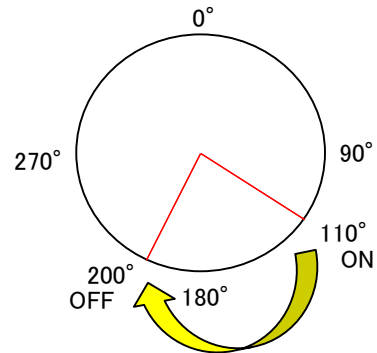
Set the feed start position to feed signal OFF position.
When you make the feed starts on 270° Set the ON angle of feed to 240° , and set the OFF angle to 270°



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

Feed Length (_ Release Mode	Contents
- - 54nc	Synchronization press cam signal
- - - 0FF	Invalid the release signal, Release off state.
- - - R0 I	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.
- - - T0 I	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

	NOTE	The release operation is delayed due to air cylinder. The delay time will vary depending in the model.
--	------	---

❖ Feed Angle Setting 【 Feed Angle 】

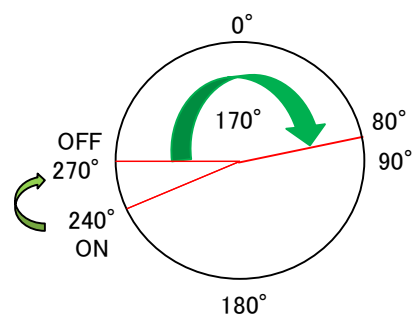
Input the available angles from feeding start to feeding end angles.

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.

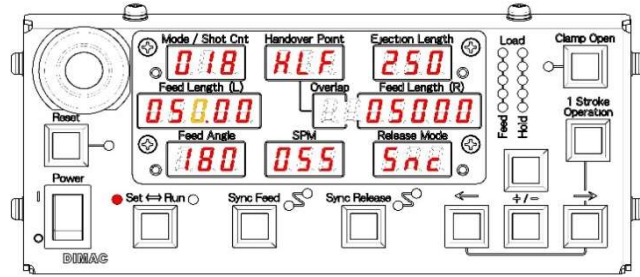
❖ Auto drive setting for Sheet Mode

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.

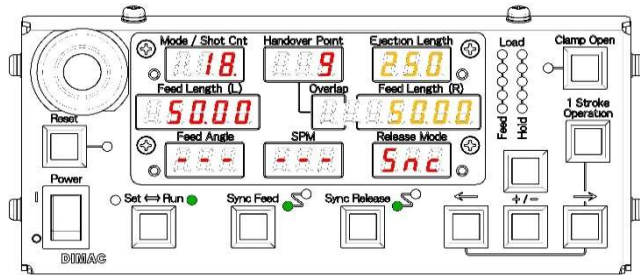


Items	Display contents	Contents
Mode / Shot Cnt.	Press shot count	Coil mode conditions are necessary from initial setting.
Ejection Length	000~999 (unit mm)	Valid only in the sheet mode
Feed Length (L)	Left side feeder	0~999.99mm. Minimum setting unit: 0.01mm Both feed lengths are interlocked within ±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 themoment, 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.



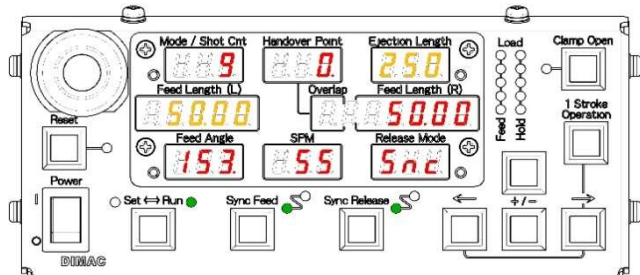
"Clamp Open" switch is not available when "Sync-Feed, release turn on with "Run" state.



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

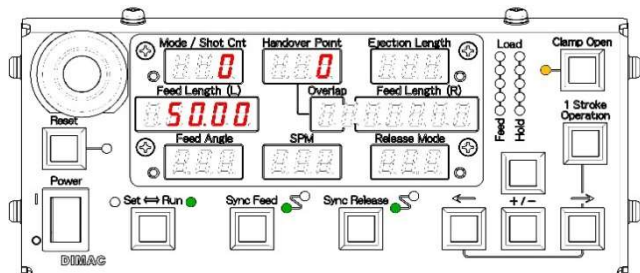
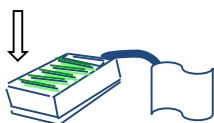
When the workpiece shifts to another feeder, Handover Point displays 0

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.