

PLASTIC THERMOFORMING SYSTEMS

THE SHUMAN CO.
CHARLOTTE NC

PTS AUTOMATIC CONTROLS FOR 5TI SEQUENCER

LIST OF INPUTS

X0	START CYCLE
X1	HEAT SHIELD DOWN
X2	CARRIAGE IN
X3	HEAT SHIELD UP
X4	CARRIAGE OUT
X5	LOWER PLATEN UP
X6	HEAT TIMER OVERRIDE
X7	RESET
X8	BCD 1
X9	BCD 2
X10	BCD 4
X11	BCD 8
X12	BCD 10
X13	LOWER PLATEN DOWN
X14	UPPER PLATEN DOWN
X15	UPPER PLATEN UP
X16	SPARE

LIST OF OUTPUTS

Y0	HEAT SHIELD DOWN
Y1	CARRIAGE IN
Y2	HEAT SHIELD UP
Y3	HYDRAULIC PUMP
Y4	CARRIAGE OUT
Y5	LOWER PLATEN UP
Y6	SPARE
Y7	SPARE
Y8	FANS
Y9	LOWER AIR
Y10	LOWER PLATEN DOWN
Y11	UPPER PLATEN DOWN
Y12	UPPER VACUUM BLEED
Y13	UPPER AIR
Y14	UPPER PLATEN UP
Y15	LOWER VACUUM BLEED
Y16	SPARE

NOTE

OUTPUTS Y17 UP, ARE FOR HEAT ZONES. THE CHECK OF LED. LIGHTS ON LOAD-TRACK WILL ABLE YOU TO PIN POINT MACHINE MALFUCTIONS.