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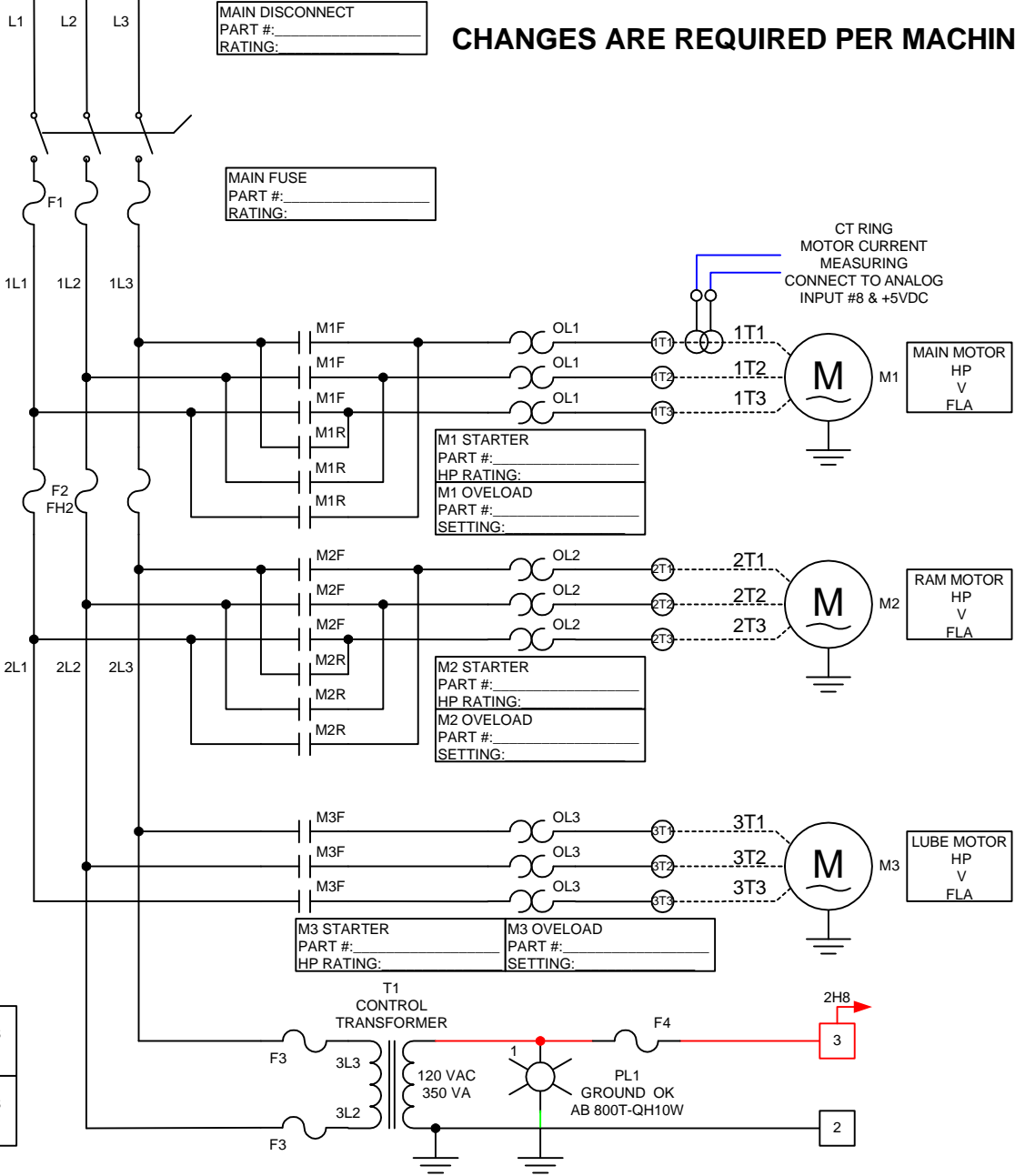
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600VAC

DRAFT SAMPLE DRAWING ONLY:

CHANGES ARE REQUIRED PER MACHINE



MAIN DISCONNECT
PART #:
RATING:

MAIN FUSE
PART #:
RATING:

F2
CC FUSES
____ Amp

F3
CC FUSES
2Amp

F4
CC FUSES
4Amp

M1 STARTER
PART #:
HP RATING:
M1 OVELOAD
PART #:
SETTING:

M2 STARTER
PART #:
HP RATING:
M2 OVELOAD
PART #:
SETTING:

M3 STARTER
PART #:
HP RATING:

M3 OVELOAD
PART #:
SETTING:

MAIN MOTOR
HP
V
FLA

RAM MOTOR
HP
V
FLA

LUBE MOTOR
HP
V
FLA

CT RING
MOTOR CURRENT
MEASURING
CONNECT TO ANALOG
INPUT #8 & +5VDC

Metal Form Products Co. Ltd.
8-1734 Orangebrook Court
Pickering ON L1W 3G8
888-285-8885

INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	GROUND	NEUTRAL WHITE	TERMINAL STRIP ITEM No. XXX
DRAWING S/N:		FILE NAME		REV		
DRAWN TT		pm1.5_master_2stn_rev1.vsd				

ISSUED 30/06/2004	LAST EDIT 27/10/2004	C:\Documents and Settings\Tom.METALFORM\Desktop\	SHEET 1 OF 25
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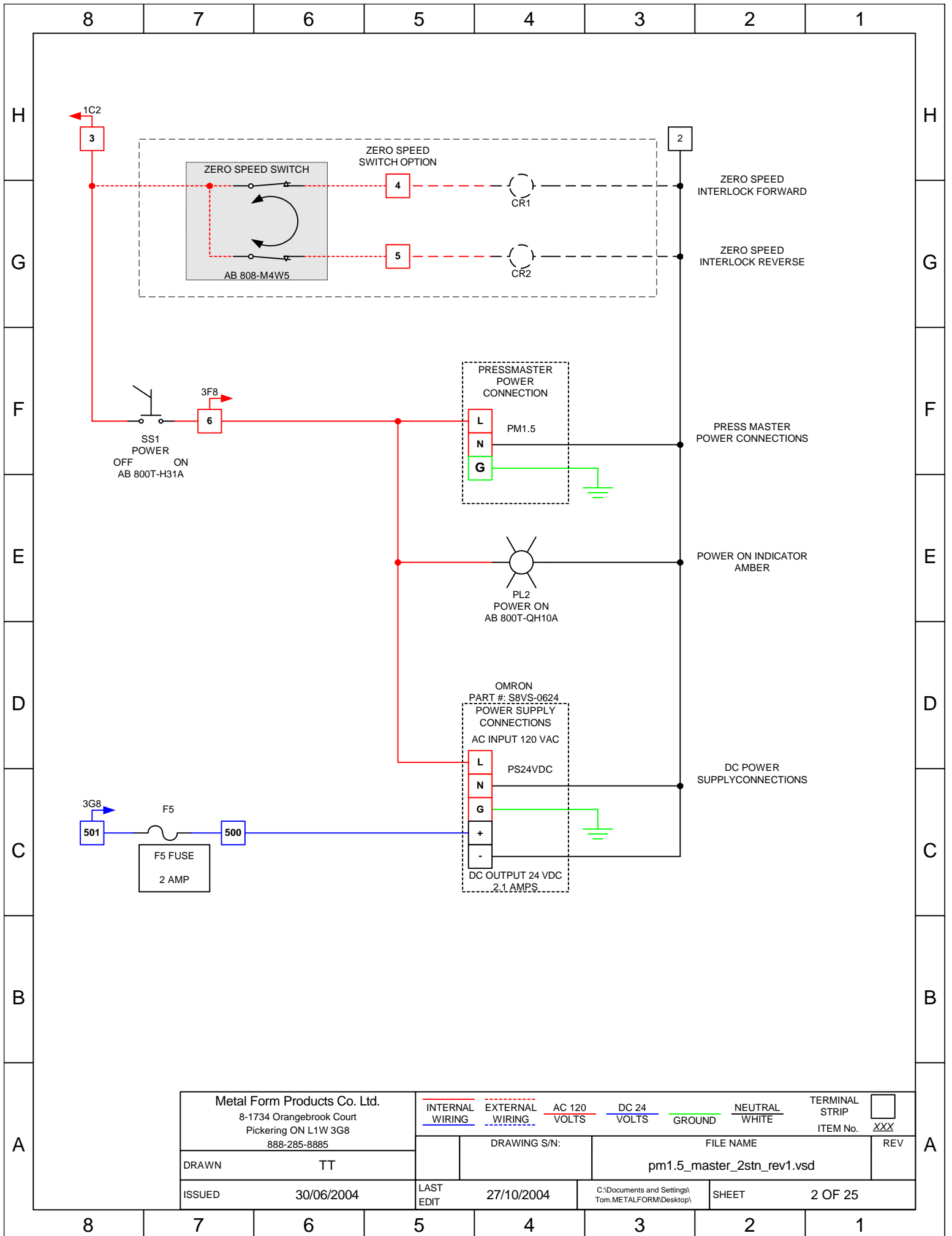
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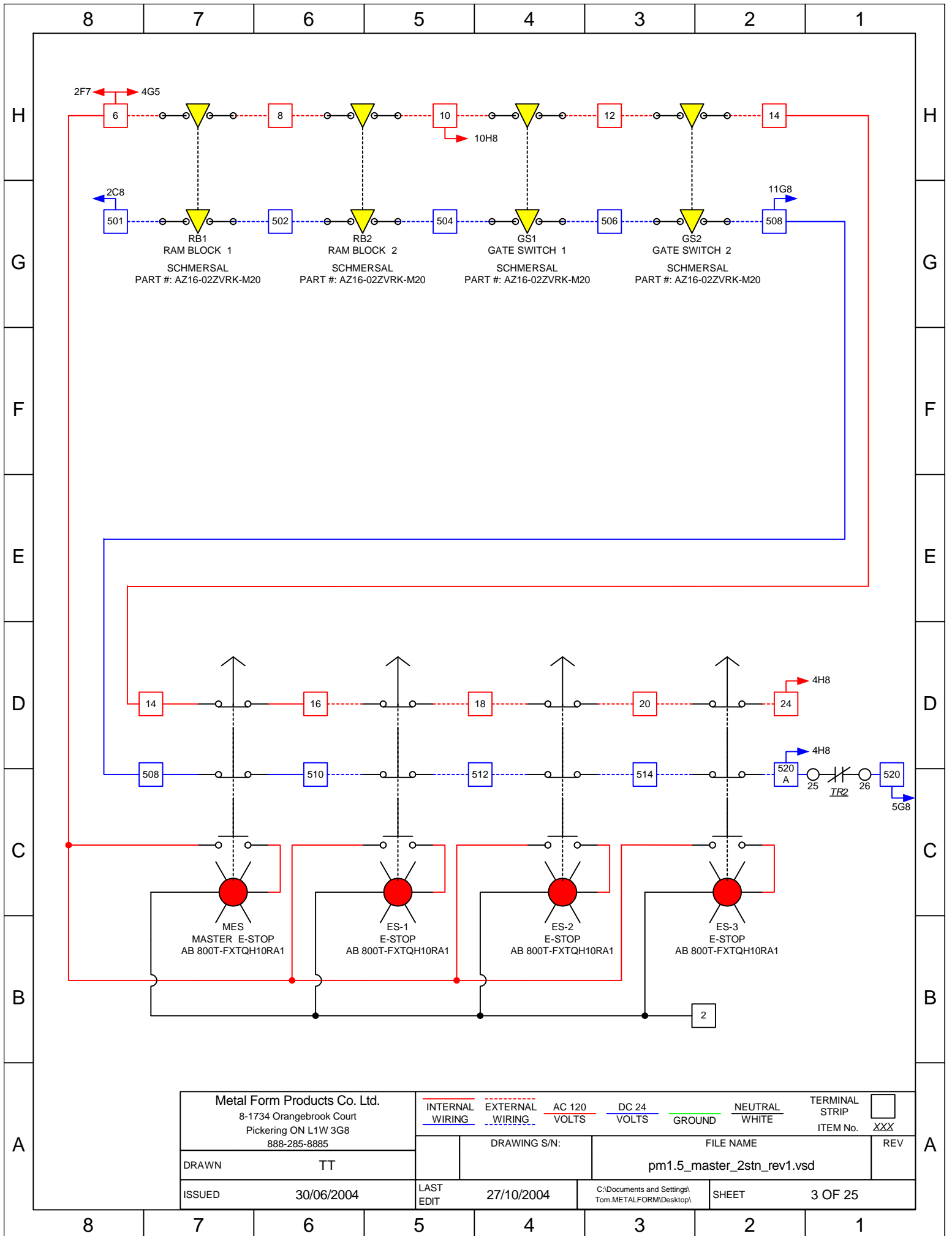
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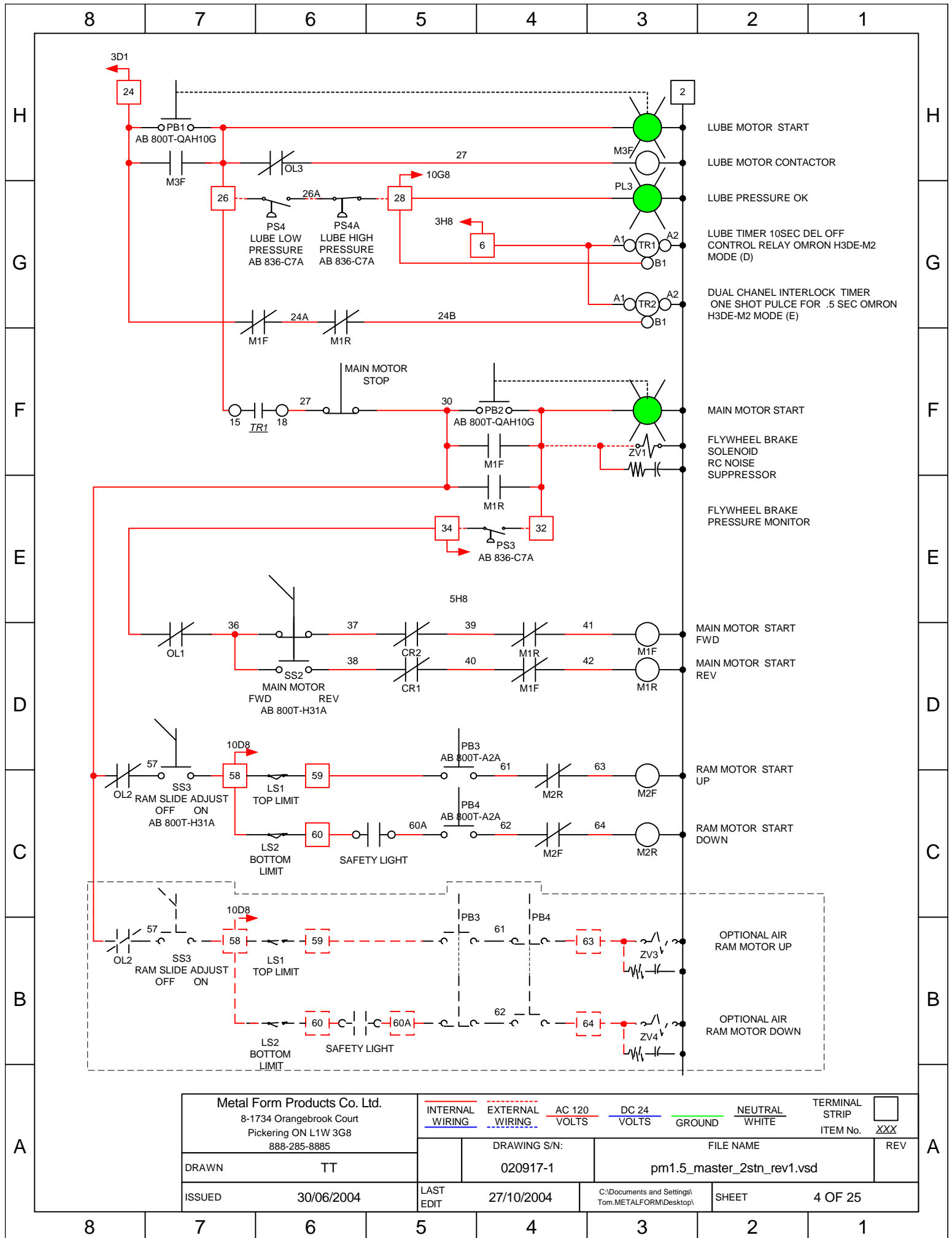
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Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	DRAWING S/N: FILE NAME pm1.5_master_2stn_rev1.vsd	REV
DRAWN	TT	LAST EDIT	27/10/2004	C:\Documents and Settings\Tom.METALFORM\Desktop\
ISSUED	30/06/2004	SHEET	2 OF 25	



Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS NEUTRAL WHITE GROUND	TERMINAL STRIP ITEM No. XXX
DRAWN TT		DRAWING S/N:	FILE NAME
ISSUED 30/06/2004		LAST EDIT 27/10/2004	pm1.5_master_2stn_rev1.vsd
		C:\Documents and Settings\Tom.METALFORM\Desktop\	SHEET 3 OF 25

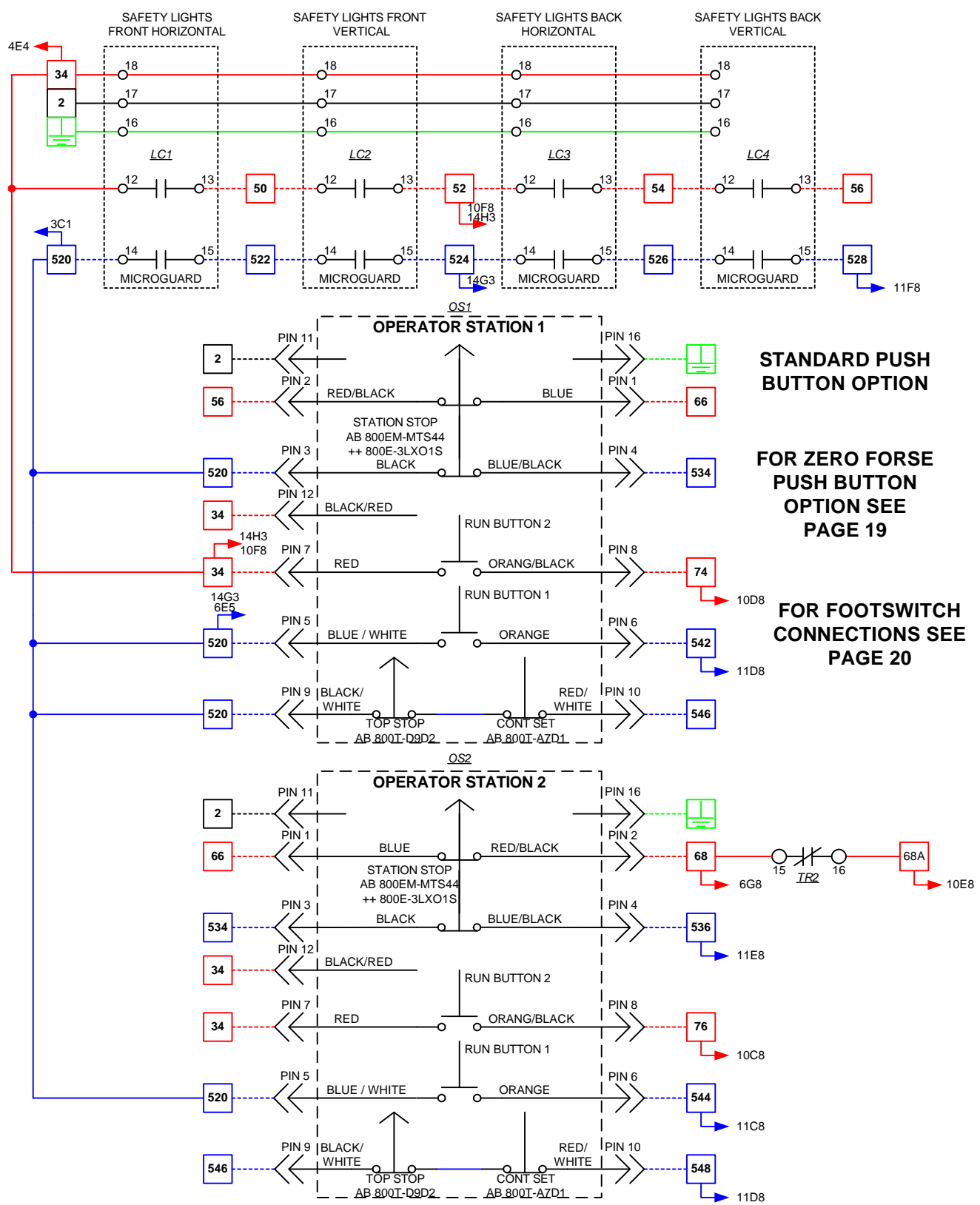


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	NEUTRAL WHITE	TERMINAL STRIP ITEM No.	XXX
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ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\		SHEET 4 OF 25		

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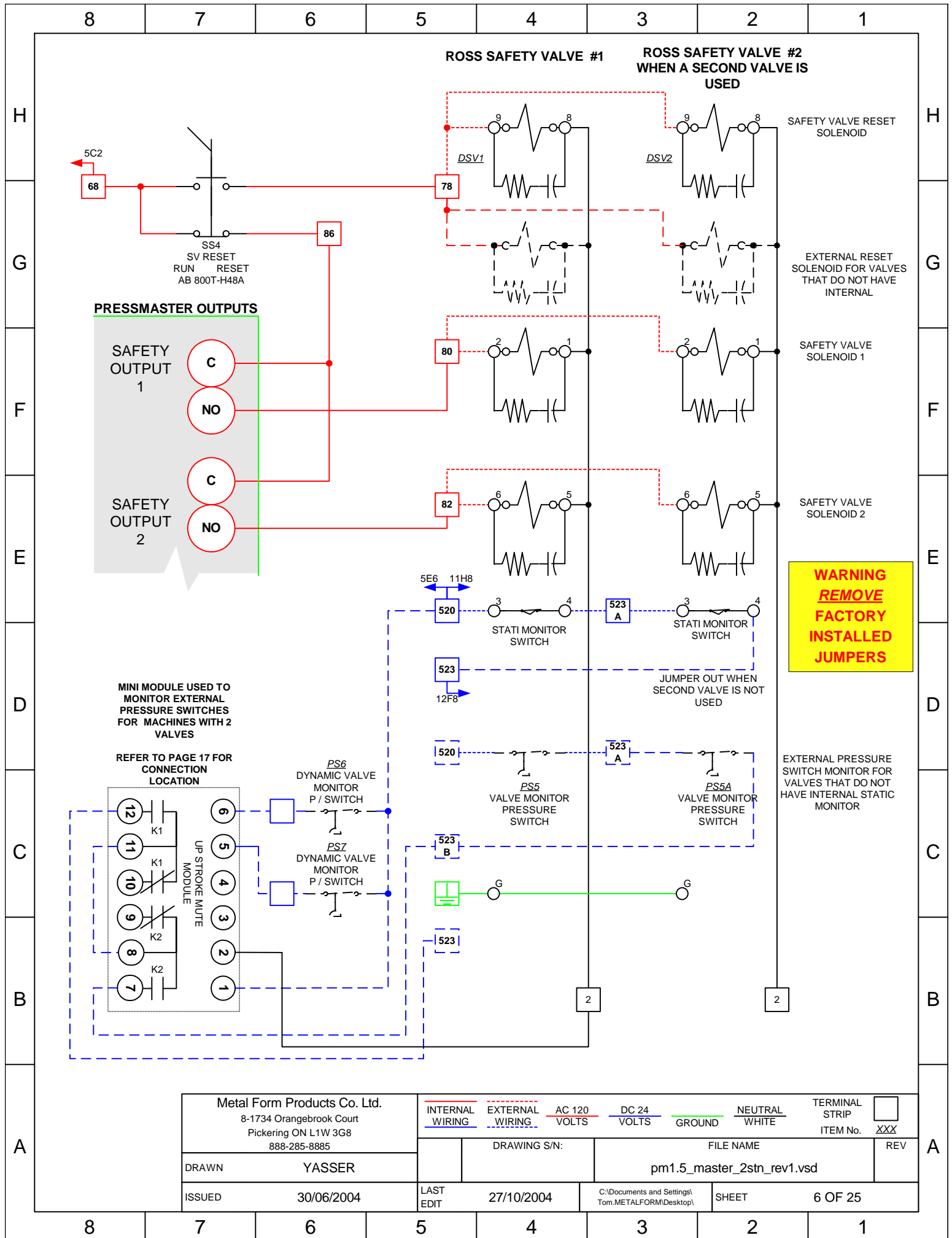
**STANDARD PUSH
BUTTON OPTION**

**FOR ZERO FORSE
PUSH BUTTON
OPTION SEE
PAGE 19**

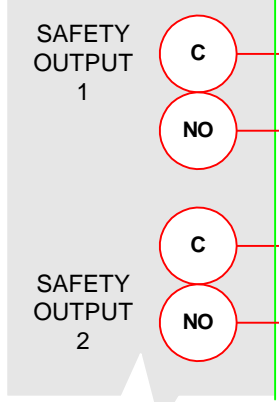
**FOR FOOTSWITCH
CONNECTIONS SEE
PAGE 20**

Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	GROUND NEUTRAL WHITE	TERMINAL STRIP ITEM No.	XXX
DRAWN TT		DRAWING S/N:		FILE NAME pm1.5_master_2stn_rev1.vsd		REV		
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\		SHEET 5 OF 25		

8 7 6 5 4 3 2 1



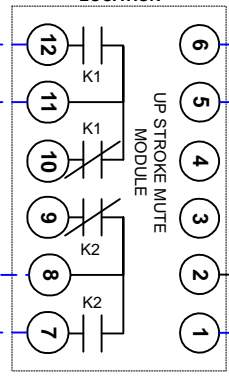
PRESSMASTER OUTPUTS



**WARNING
REMOVE
FACTORY
INSTALLED
JUMPERS**

MINI MODULE USED TO MONITOR EXTERNAL PRESSURE SWITCHES FOR MACHINES WITH 2 VALVES

REFER TO PAGE 17 FOR CONNECTION LOCATION

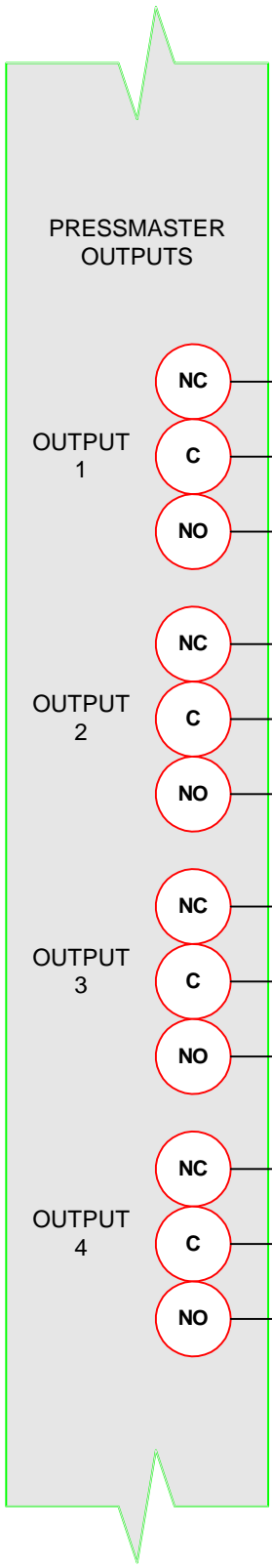


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	GROUND	NEUTRAL WHITE	TERMINAL STRIP ITEM No.	<input type="checkbox"/> XXX
DRAWN YASSER		DRAWING S/N:		FILE NAME			REV		
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\			SHEET 6 OF 25		
8	7	6	5	4	3	2	1		

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Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	GROUND	NEUTRAL WHITE	TERMINAL STRIP ITEM No.	<input type="checkbox"/>
DRAWN TT		DRAWING S/N:		FILE NAME			REV		
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\pm1.5_master_2stn_rev1.vsd			SHEET 7 OF 25		

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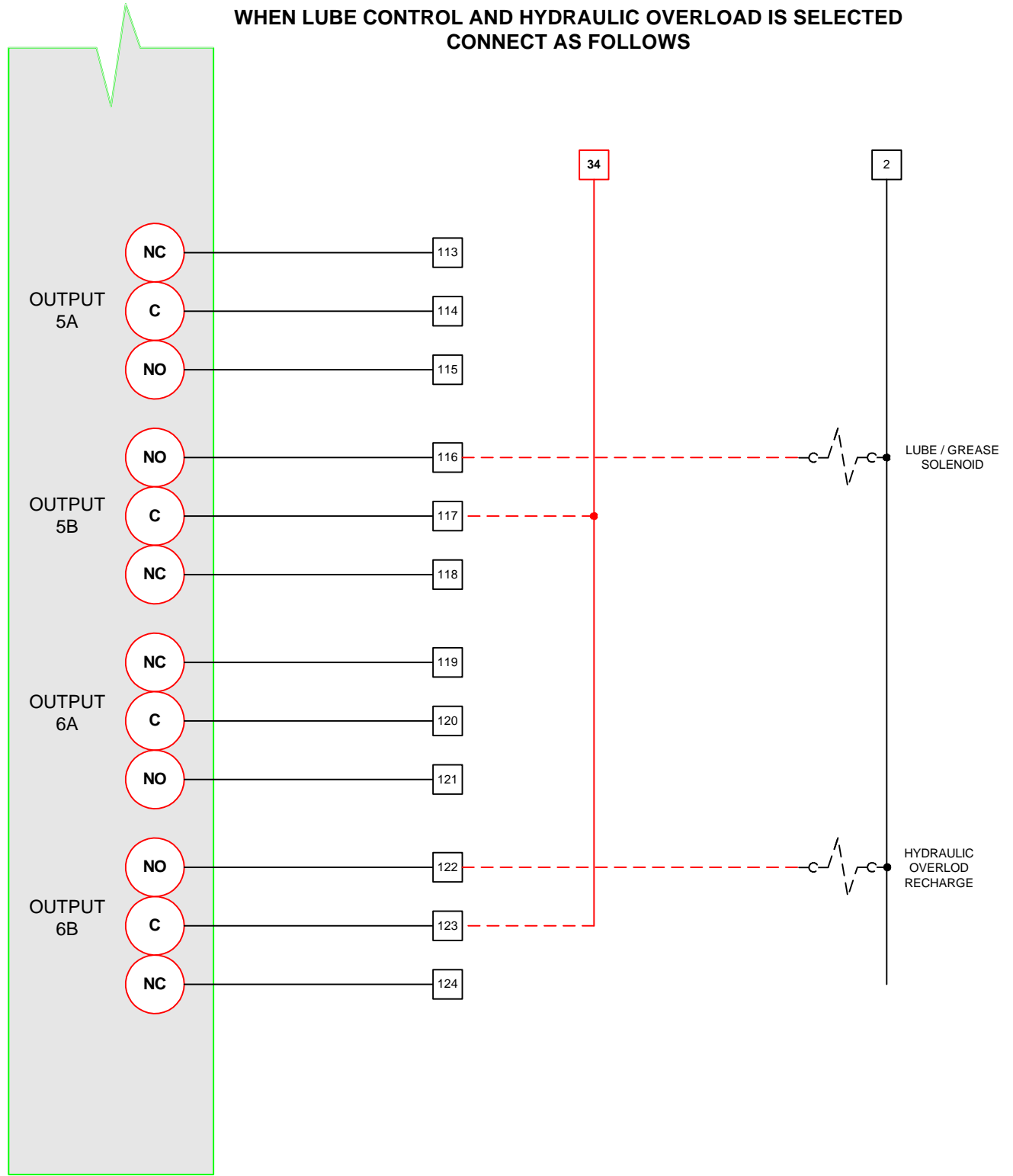
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SAMPLE DRAWING FOR OPTIONAL CONNECTONS

WHEN LUBE CONTROL AND HYDRAULIC OVERLOAD IS SELECTED
CONNECT AS FOLLOWS



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Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	DRAWING S/N: FILE NAME pm1.5_master_2stn_rev1.vsd	REV
DRAWN	TT	LAST EDIT	27/10/2004	C:\Documents and Settings\Tom.METALFORM\Desktop\ SHEET 8 OF 25
ISSUED	30/06/2004			

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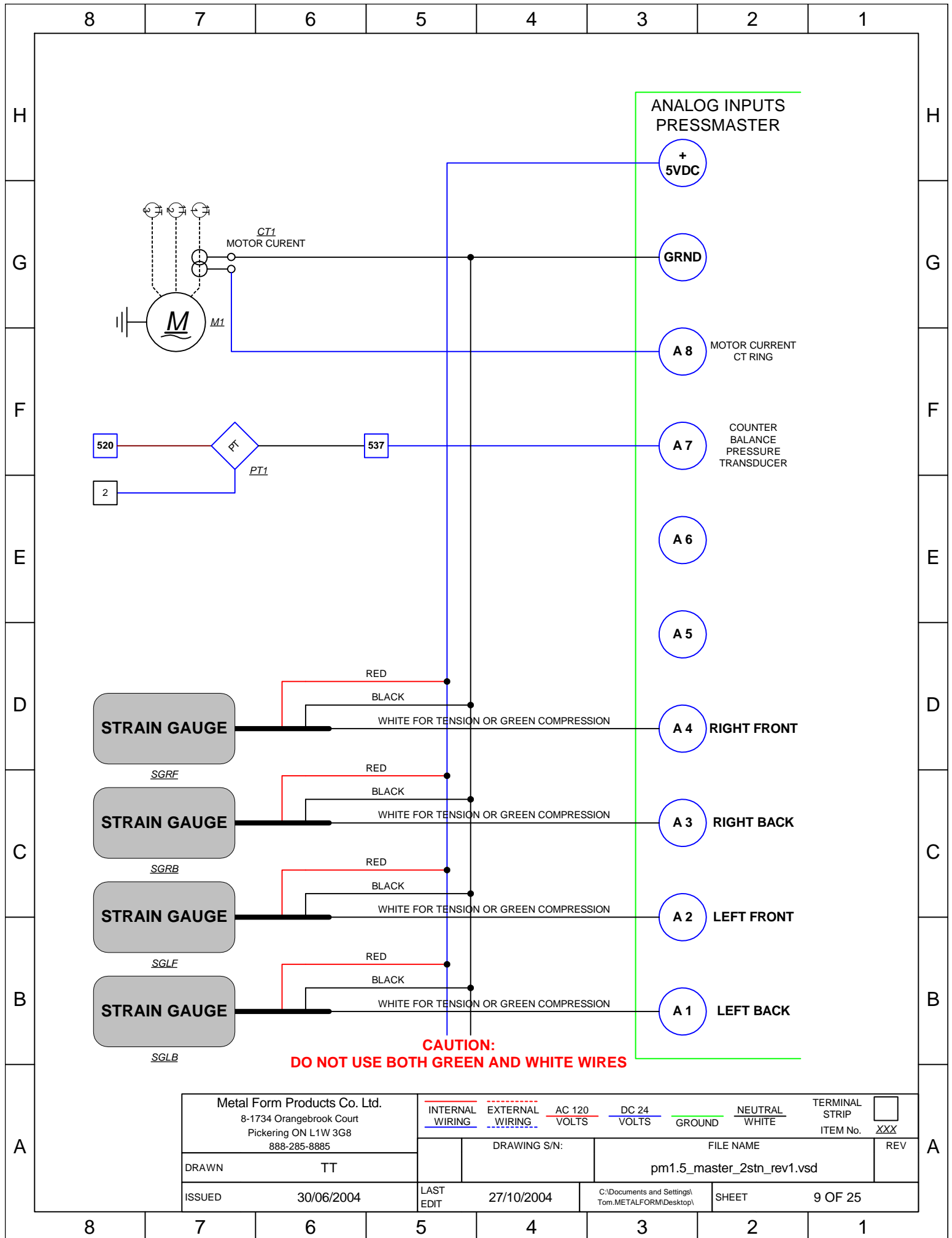
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**ANALOG INPUTS
PRESSMASTER**

**+
5VDC**

GRND

A 8 MOTOR CURRENT
CT RING

A 7 COUNTER
BALANCE
PRESSURE
TRANSDUCER

A 6

A 5

A 4 RIGHT FRONT

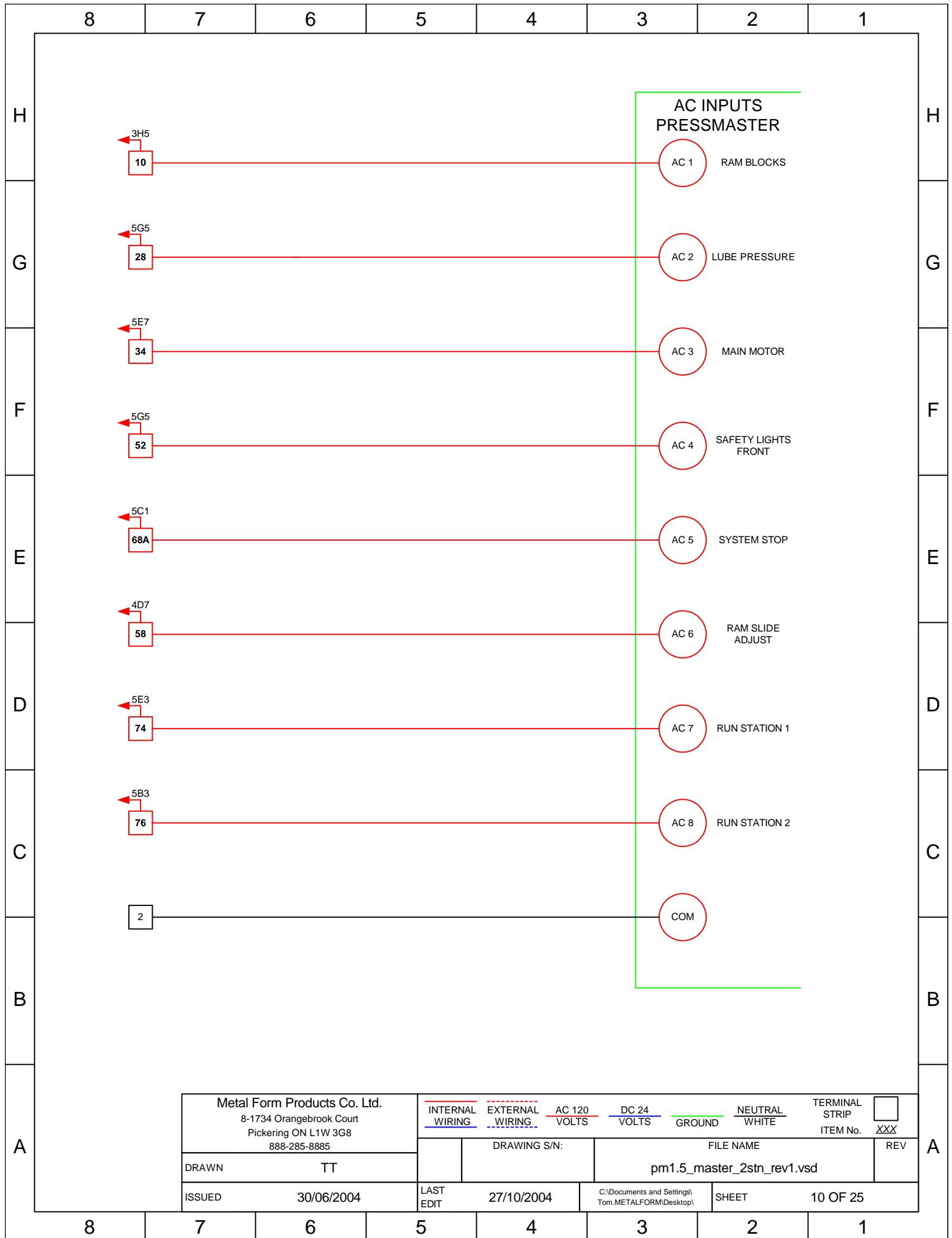
A 3 RIGHT BACK

A 2 LEFT FRONT

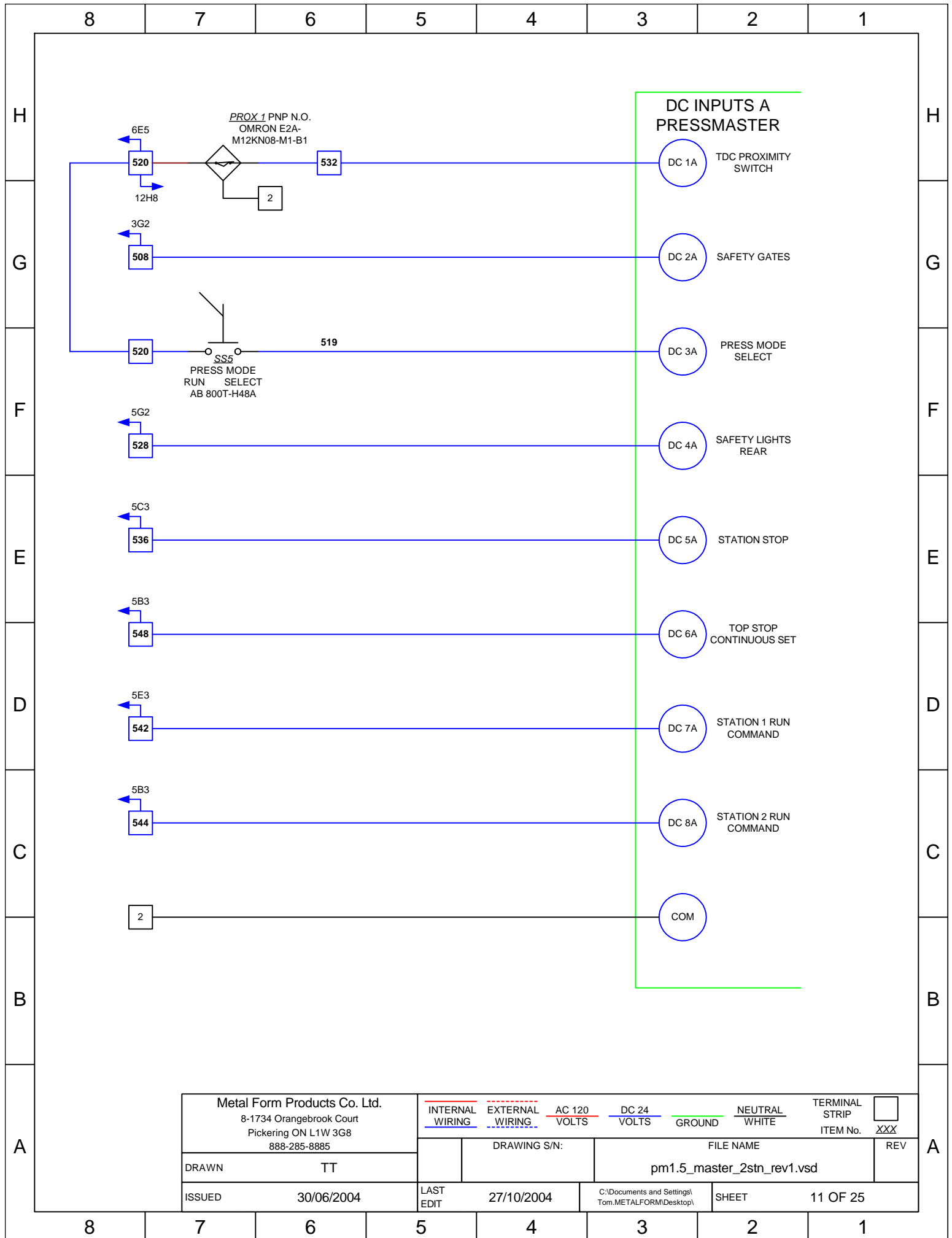
A 1 LEFT BACK

**CAUTION:
DO NOT USE BOTH GREEN AND WHITE WIRES**

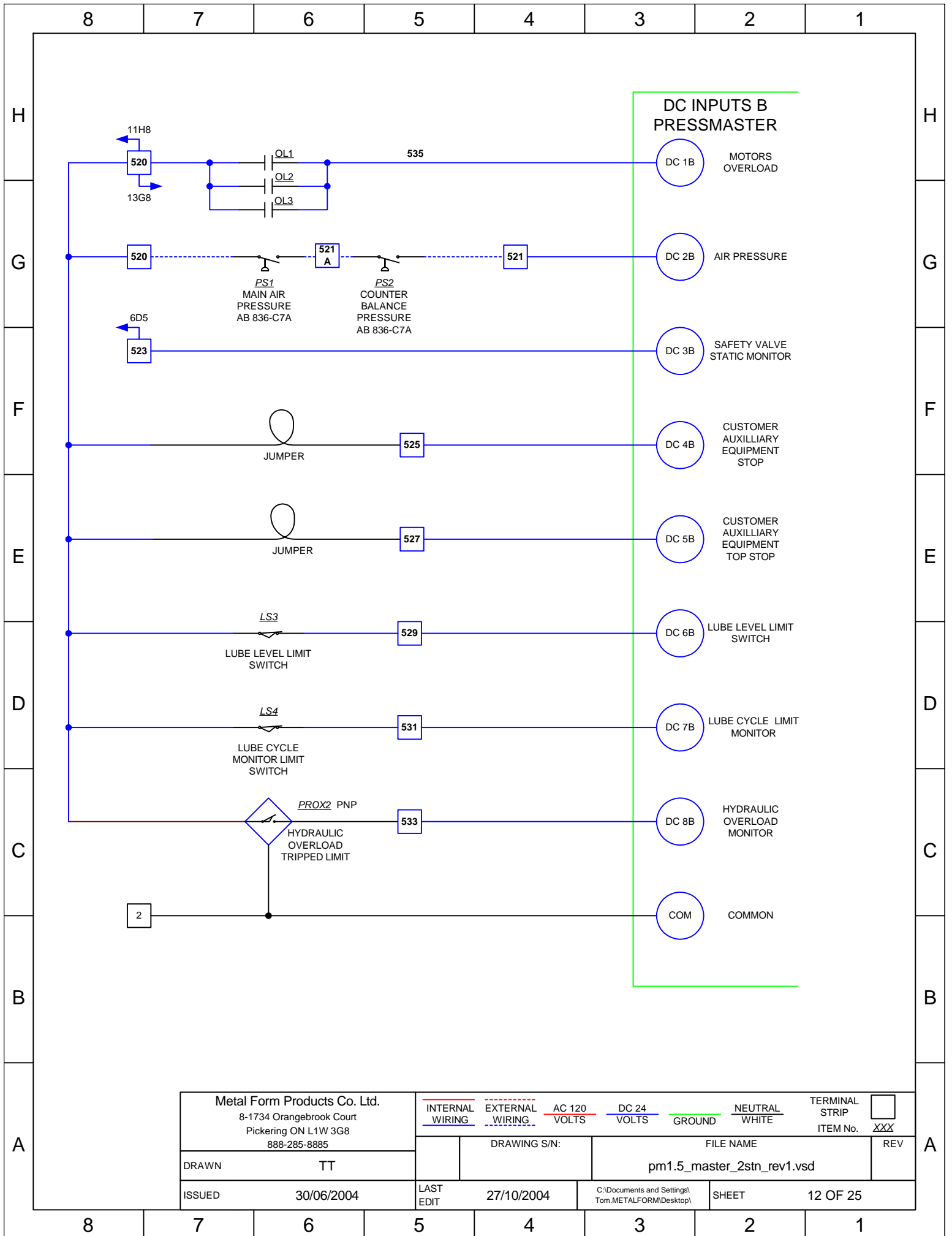
Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	GROUND NEUTRAL WHITE	TERMINAL STRIP ITEM No.	<input type="checkbox"/> REV
DRAWN TT		DRAWING S/N:		FILE NAME pm1.5_master_2stn_rev1.vsd		SHEET 9 OF 25		
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\		SHEET 9 OF 25		



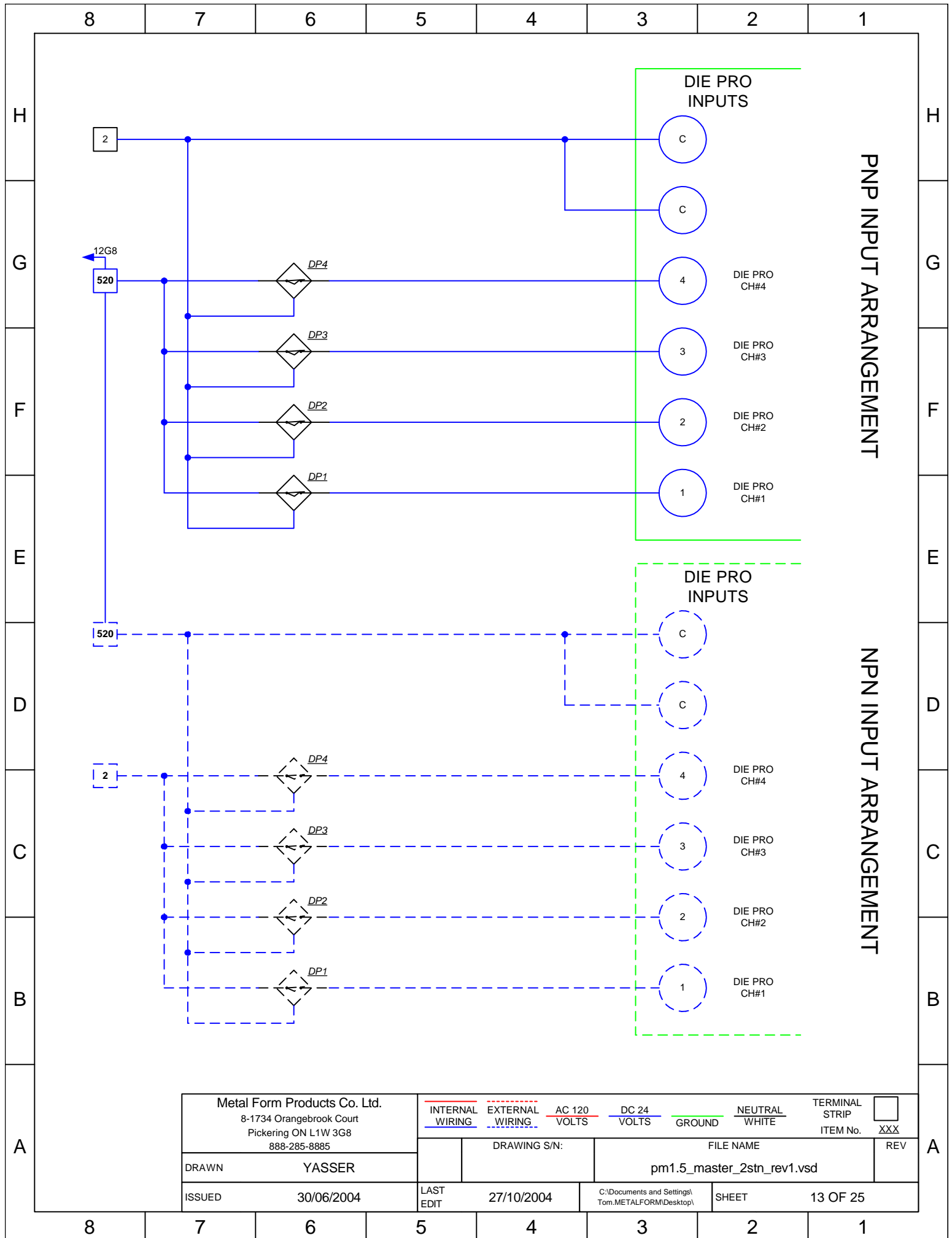
Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING <small>—</small>	EXTERNAL WIRING <small>- - -</small>	AC 120 VOLTS <small>—</small>	DC 24 VOLTS <small>—</small>	NEUTRAL WHITE <small>—</small>	TERMINAL STRIP ITEM No. <input type="checkbox"/>
DRAWN TT		DRAWING S/N:		FILE NAME		REV	
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\pm1.5_master_2stn_rev1.vsd		SHEET 10 OF 25	



Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS NEUTRAL WHITE GROUND	TERMINAL STRIP ITEM No. XXX
DRAWN	TT	DRAWING S/N:	FILE NAME
ISSUED	30/06/2004	LAST EDIT	27/10/2004
		C:\Documents and Settings\Tom.METALFORM\Desktop\	SHEET 11 OF 25
		pm1.5_master_2stn_rev1.vsd	REV



Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING <small>(Solid Blue Line)</small>	EXTERNAL WIRING <small>(Dashed Blue Line)</small>	AC 120 VOLTS <small>(Red Line)</small>	DC 24 VOLTS <small>(Blue Line)</small>	GROUND <small>(Green Line)</small>	NEUTRAL WHITE <small>(White Line)</small>	TERMINAL STRIP ITEM No. XXX	<input type="checkbox"/>
DRAWN TT		DRAWING S/N:		FILE NAME			REV		
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\			SHEET 12 OF 25		
		pm1.5_master_2stn_rev1.vsd							



PNP INPUT ARRANGEMENT

NPN INPUT ARRANGEMENT

Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING <small>(Solid Blue Line)</small>	EXTERNAL WIRING <small>(Dashed Blue Line)</small>	AC 120 VOLTS <small>(Red Line)</small>	DC 24 VOLTS <small>(Blue Line)</small>	GROUND <small>(Green Line)</small>	NEUTRAL WHITE <small>(White Line)</small>	TERMINAL STRIP ITEM No. <input type="checkbox"/> XXX
DRAWN	YASSER	DRAWING S/N:		FILE NAME		REV		
ISSUED	30/06/2004	LAST EDIT	27/10/2004	C:\Documents and Settings\Tom.METALFORM\Desktop\		SHEET	13 OF 25	

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DIE PRO INPUTS

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DIE PRO CH#4

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DIE PRO CH#3

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DIE PRO CH#2

1

DIE PRO CH#1

DIE PRO INPUTS

C

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DIE PRO CH#4

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DIE PRO CH#3

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DIE PRO CH#2

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DIE PRO CH#1

DP4

DP3

DP2

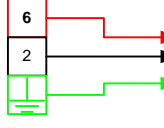
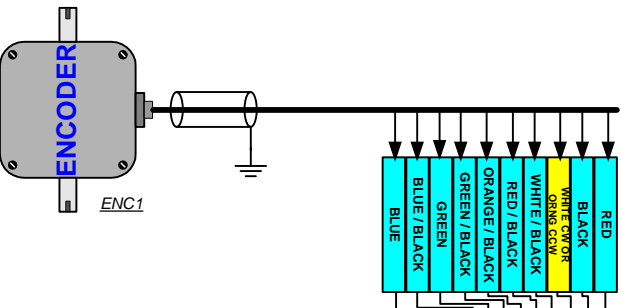
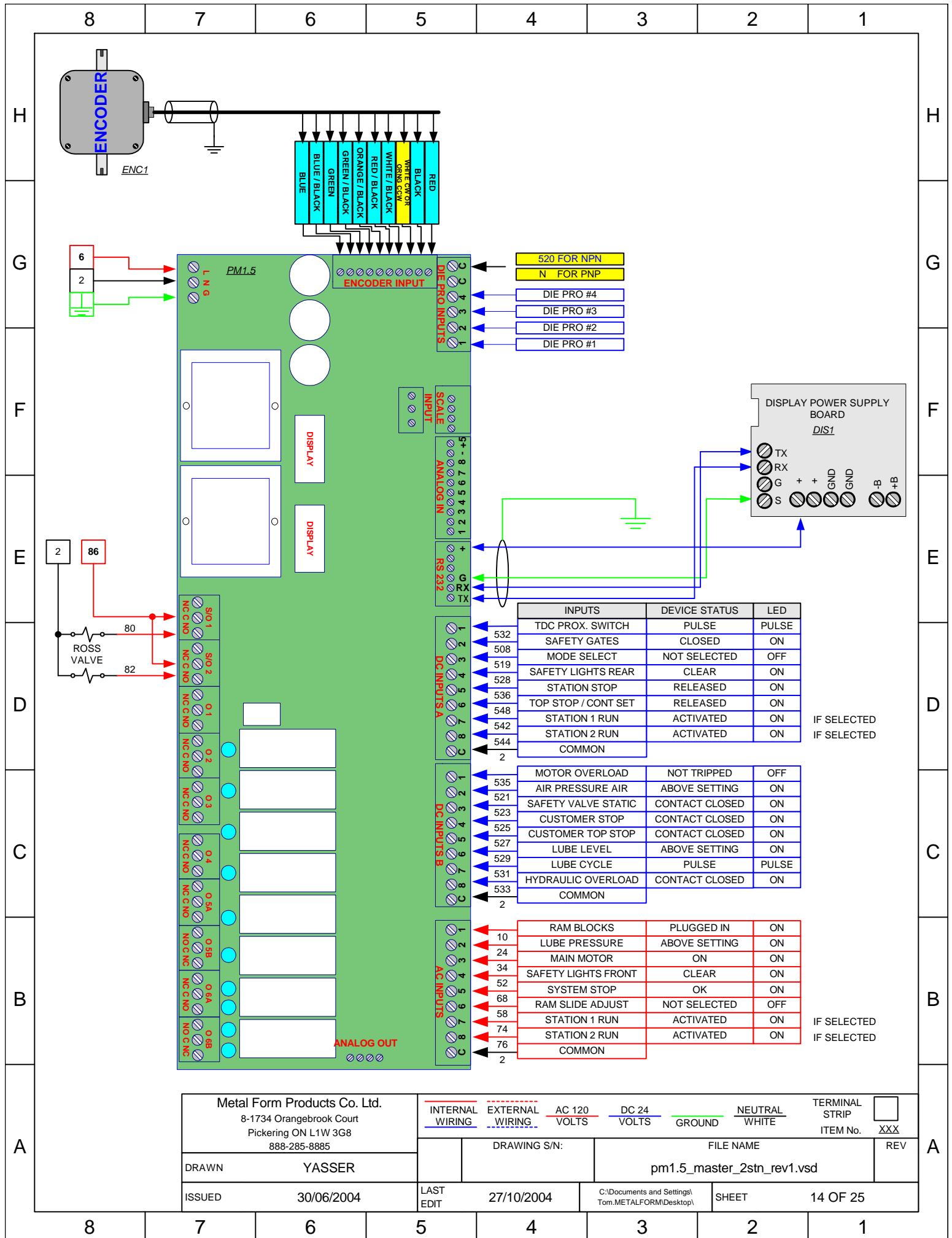
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DP4

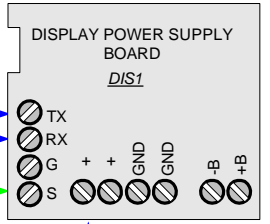
DP3

DP2

DP1



- 520 FOR NPN
- N FOR PNP
- DIE PRO #4
- DIE PRO #3
- DIE PRO #2
- DIE PRO #1



INPUTS	DEVICE STATUS	LED
532	TDC PROX. SWITCH	PULSE
508	SAFETY GATES	CLOSED
519	MODE SELECT	NOT SELECTED
528	SAFETY LIGHTS REAR	CLEAR
536	STATION STOP	RELEASED
548	TOP STOP / CONT SET	RELEASED
542	STATION 1 RUN	ACTIVATED
544	STATION 2 RUN	ACTIVATED
2	COMMON	

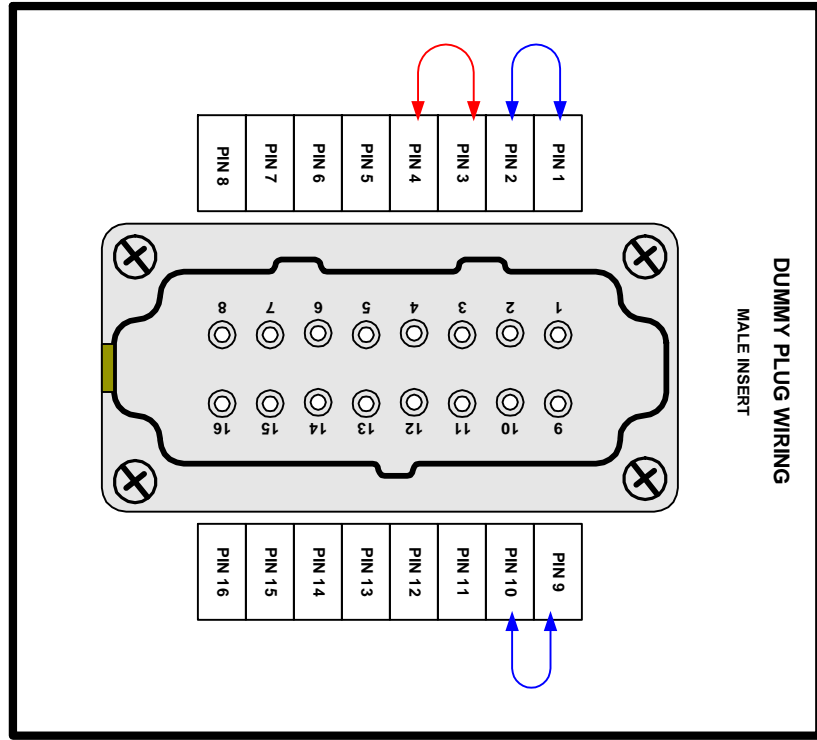
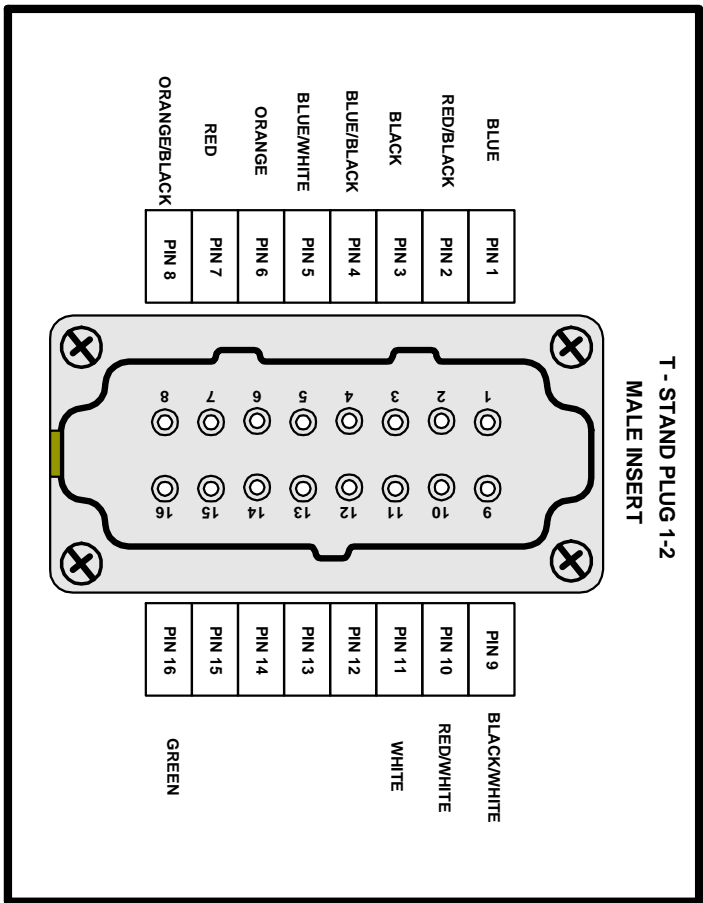
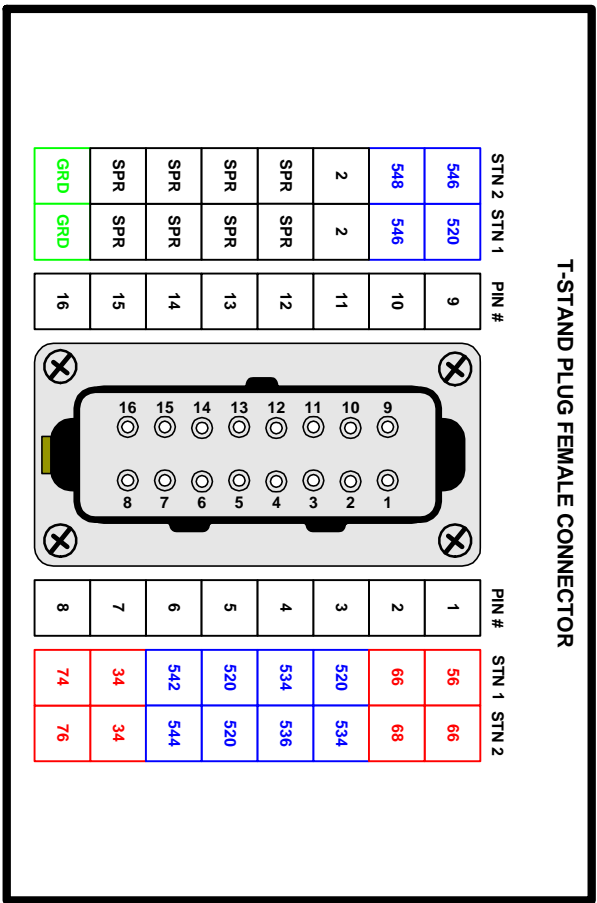
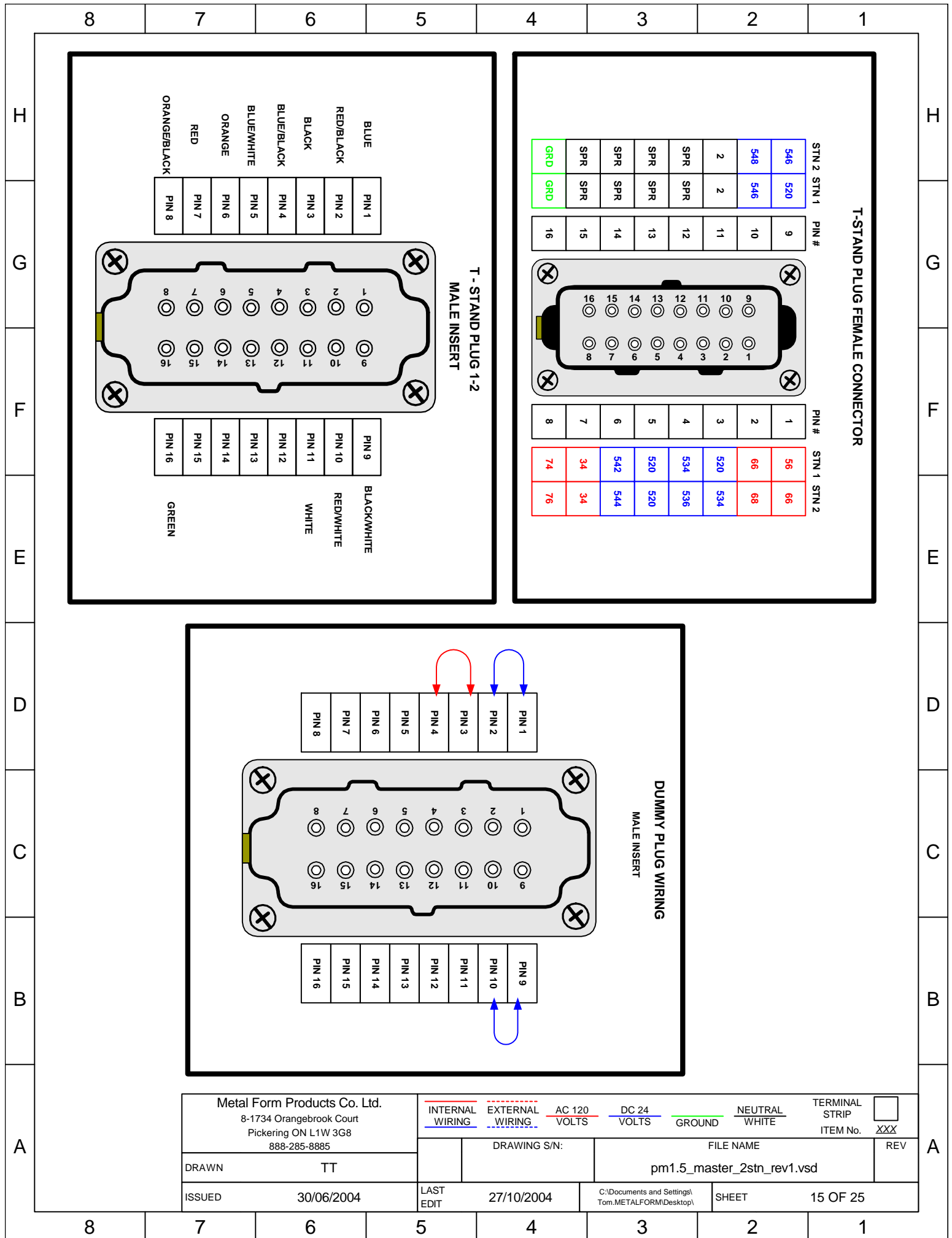
IF SELECTED
IF SELECTED

535	MOTOR OVERLOAD	NOT TRIPPED
521	AIR PRESSURE AIR	ABOVE SETTING
523	SAFETY VALVE STATIC	CONTACT CLOSED
525	CUSTOMER STOP	CONTACT CLOSED
527	CUSTOMER TOP STOP	CONTACT CLOSED
529	LUBE LEVEL	ABOVE SETTING
531	LUBE CYCLE	PULSE
533	HYDRAULIC OVERLOAD	CONTACT CLOSED
2	COMMON	

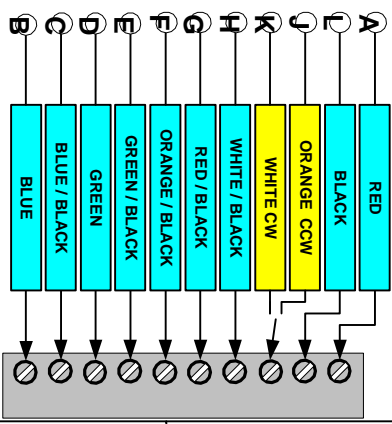
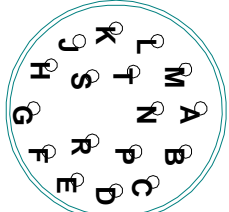
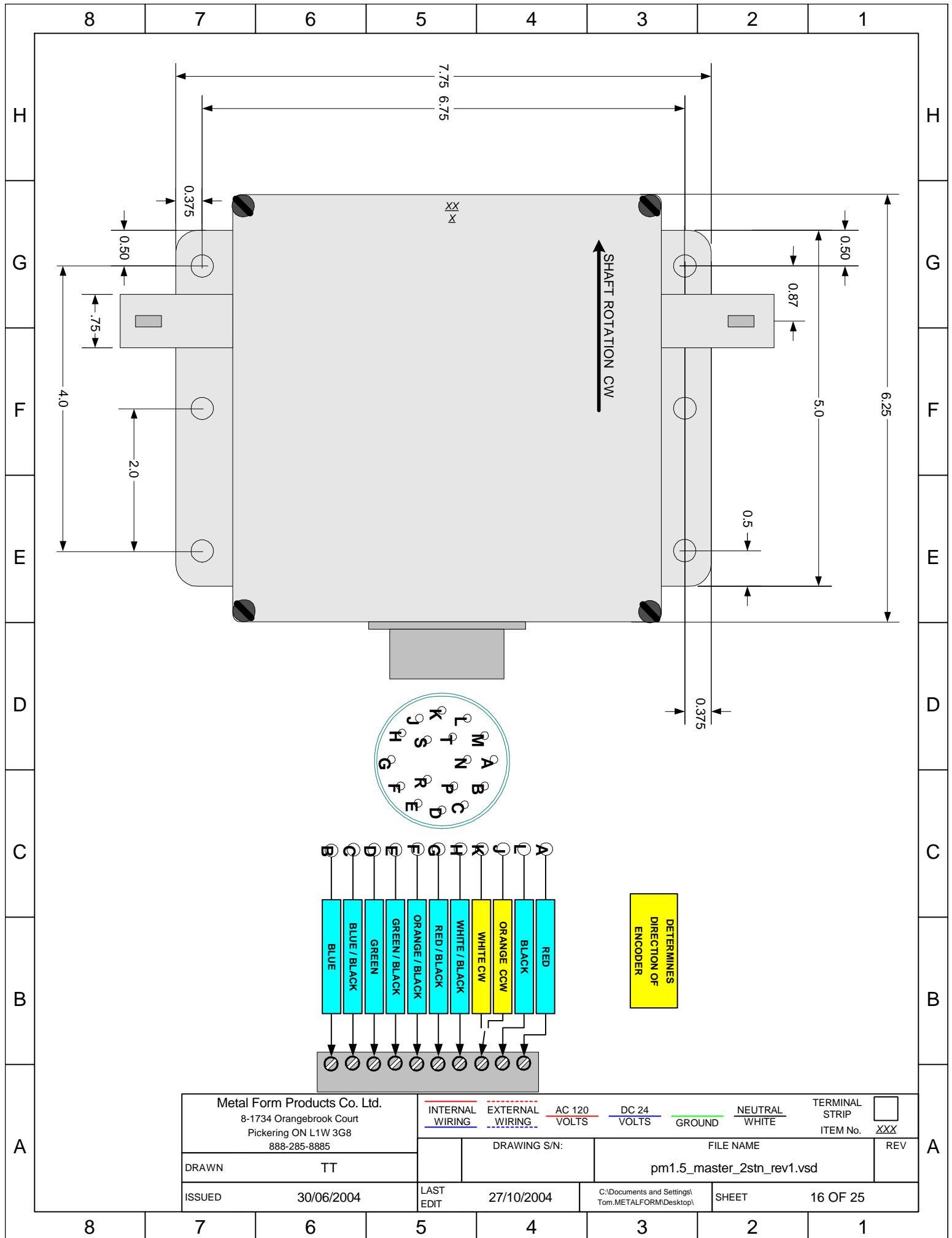
10	RAM BLOCKS	PLUGGED IN
24	LUBE PRESSURE	ABOVE SETTING
34	MAIN MOTOR	ON
52	SAFETY LIGHTS FRONT	CLEAR
68	SYSTEM STOP	OK
58	RAM SLIDE ADJUST	NOT SELECTED
74	STATION 1 RUN	ACTIVATED
76	STATION 2 RUN	ACTIVATED
2	COMMON	

IF SELECTED
IF SELECTED

Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	DRAWING S/N: FILE NAME REV
DRAWN	YASSER		pm1.5_master_2stn_rev1.vsd
ISSUED	30/06/2004	LAST EDIT	27/10/2004
		C:\Documents and Settings\Tom.METALFORM\Desktop\	SHEET 14 OF 25



Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	<input type="checkbox"/> REV
DRAWING S/N:		FILE NAME	
DRAWN TT		pm1.5_master_2stn_rev1.vsd	
ISSUED 30/06/2004		LAST EDIT 27/10/2004	SHEET 15 OF 25



DETERMINES
DIRECTION OF
ENCODER

Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	GROUND	NEUTRAL WHITE	TERMINAL STRIP ITEM No. XXX	<input type="checkbox"/>
DRAWN TT		DRAWING S/N:		FILE NAME			REV		
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\			SHEET 16 OF 25		
		pm1.5_master_2stn_rev1.vsd							

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MINI MODULE TERMINAL LOCATIONS

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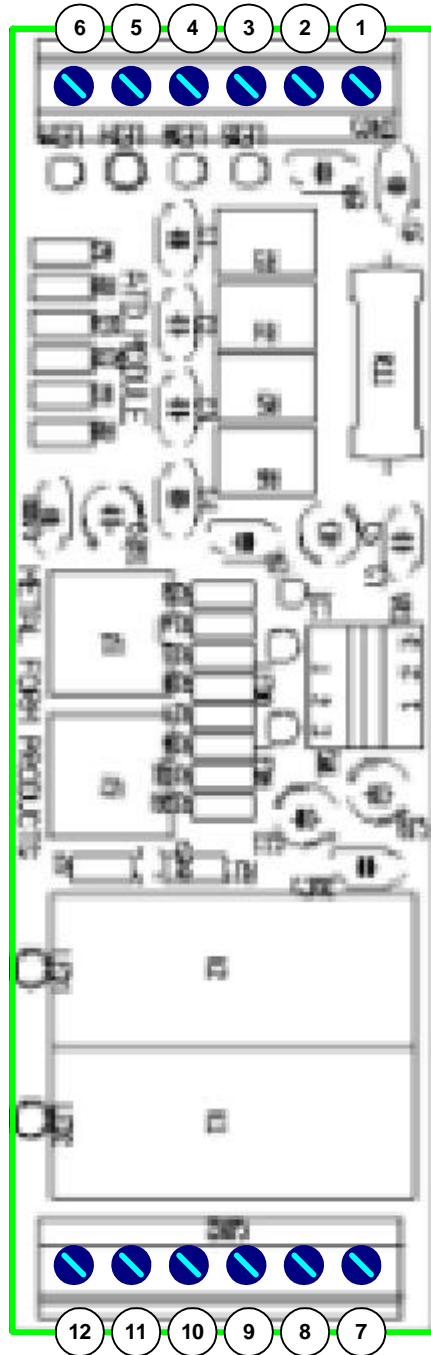
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Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		<u>INTERNAL WIRING</u>	<u>EXTERNAL WIRING</u>	<u>AC 120 VOLTS</u>	<u>DC 24 VOLTS</u>	<u>GROUND</u>	<u>NEUTRAL WHITE</u>	TERMINAL STRIP ITEM No. <u>XXX</u>	<input type="checkbox"/>
DRAWN TT		DRAWING S/N:		FILE NAME			REV		
ISSUED 30/06/2004		LAST EDIT 27/10/2004		C:\Documents and Settings\Tom.METALFORM\Desktop\pm1.5_master_2stn_rev1.vsd			SHEET 17 OF 25		

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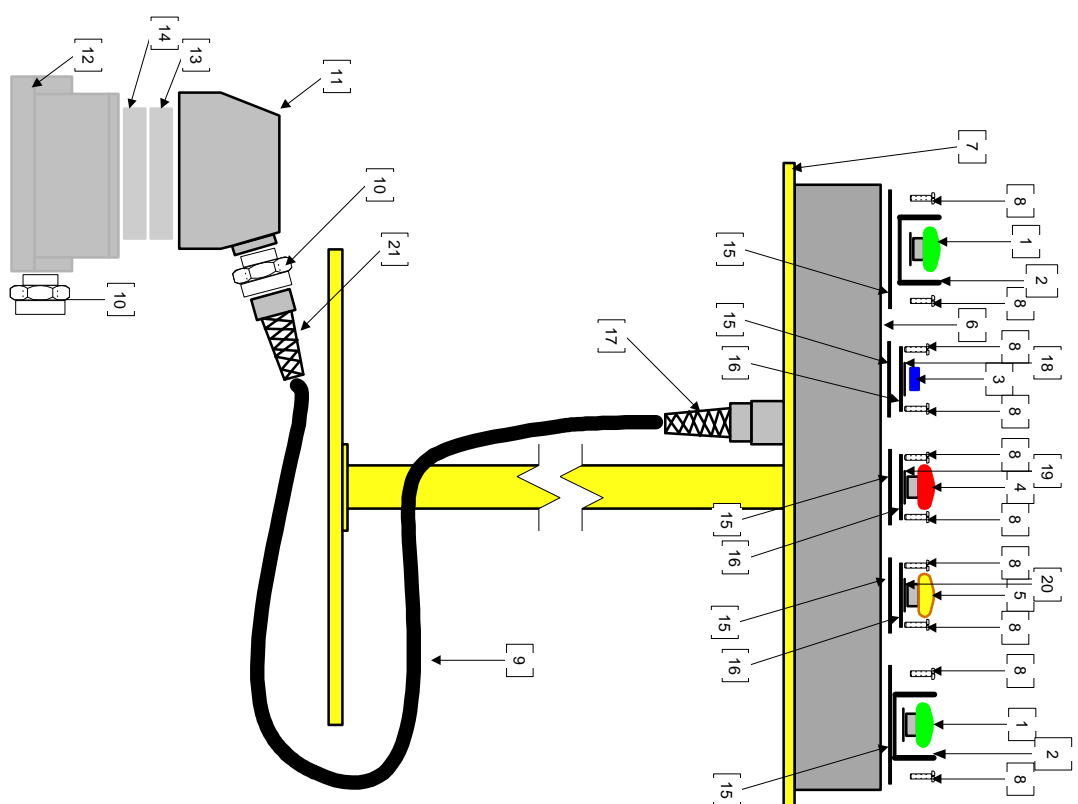
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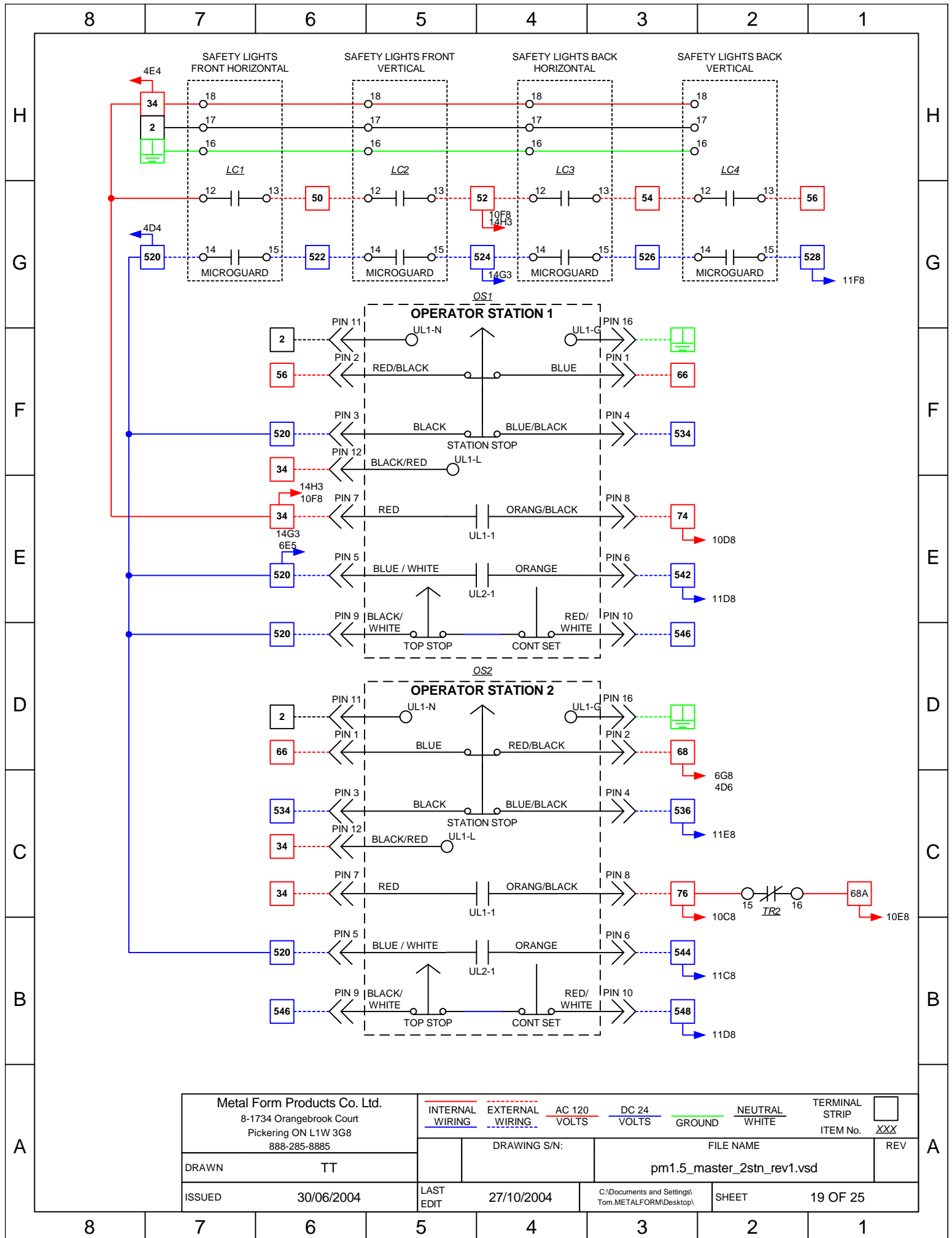
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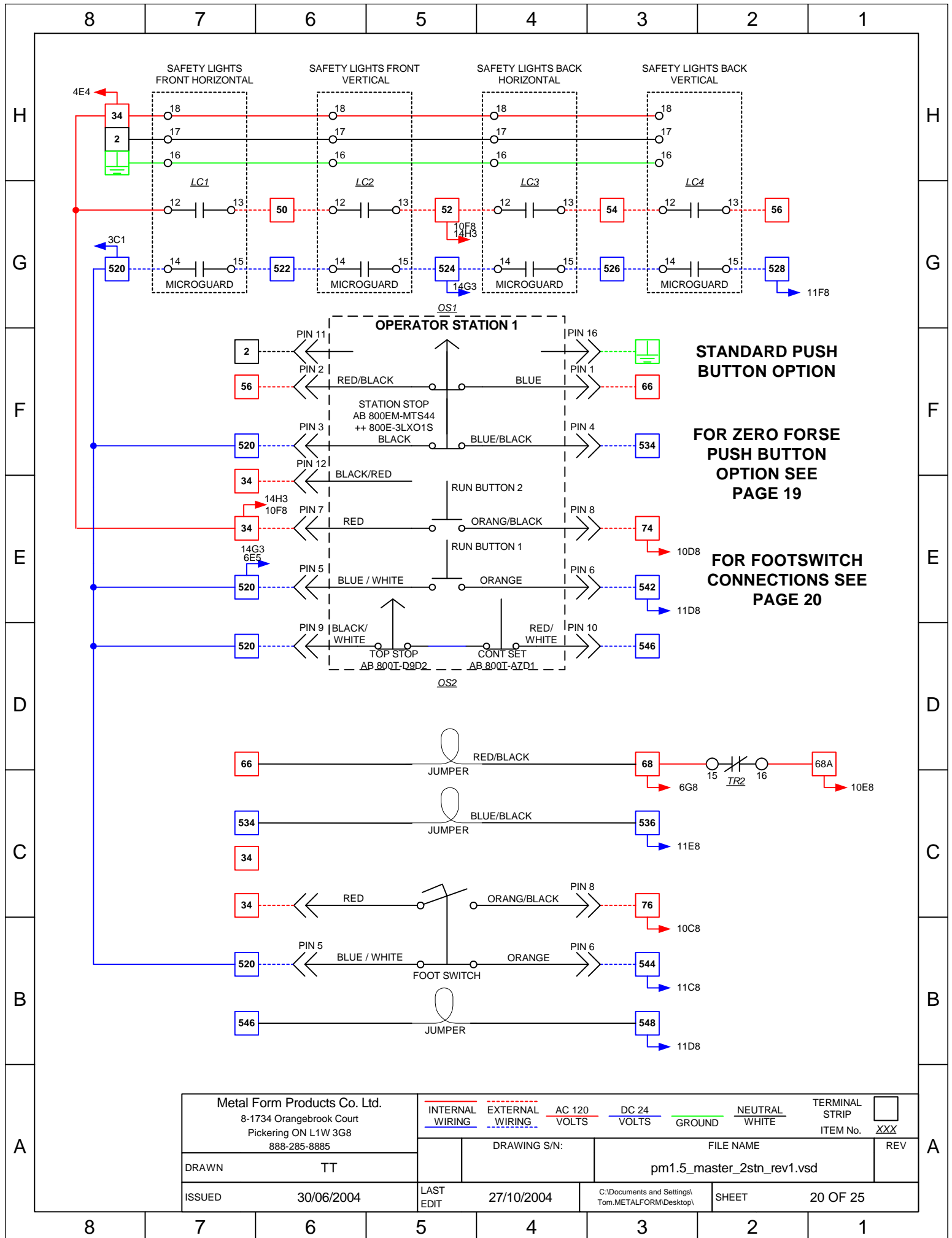
ITEM	QTY.	PART NO. and Price	DESCRIPTION
1	2	800T-D1LA	AB GREEN JUMBO OPERATOR
2	2	800T-N310J	AB JUMBO OPERATOR GUARD
3	1	800T-ADY1	PUSH BUTTON BLUE (CONT. SET)
4	1	800E-3LX01S	PUSH BUTTON RED MUSHROOM (STATION STOP)
5	1	800-D9D2	PUSH BUTTON YELLOW MUSHROOM (TOP STOP)
6	1	MFP-T-5HRB	5 HOLE RUN BAR
7	1	MFP-8000P	T-STAND ADJUSTABLE
8	20	6/32 1/2"	BOLTS
9	1	16/16 SOW	WIRE RUBBER COATED OIL RESISTANT
10	2	73000005314	NPT ADAPTER TO 3/4"
11	1	09300160520	HOOD
12	1	09300161230	HOUSING
13	1	09330162801	MALE INSERT
14	1	09330162701	FEMALE INSERT
15	5	MFP-GSKT	GASKETS RUBBER OR FOAM
16	3	MFP-AB-30.5MM	ADAPTER PLATE 30.5 MM HOLE
17	1	1"	KELLEEM
18	1	MFP-L-CS-F	LABEL (CONT. SET)
19	1	MFP-L-ST-F	LABEL (STATION STOP)
20	1	MFP-L-TS-F	LABEL (TOP STOP)
21	1	3/4"	KELLEEM
22			
23			
24			
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27			
28			
29			



Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885	INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	<input type="checkbox"/> REV
	DRAWING S/N: FILE NAME pm1.5_master_2stn_rev1.vsd	<input type="checkbox"/>
	DRAWN TT ISSUED 30/06/2004 LAST EDIT 27/10/2004 C:\Documents and Settings\Tom.METALFORM\Desktop\	SHEET 18 OF 25

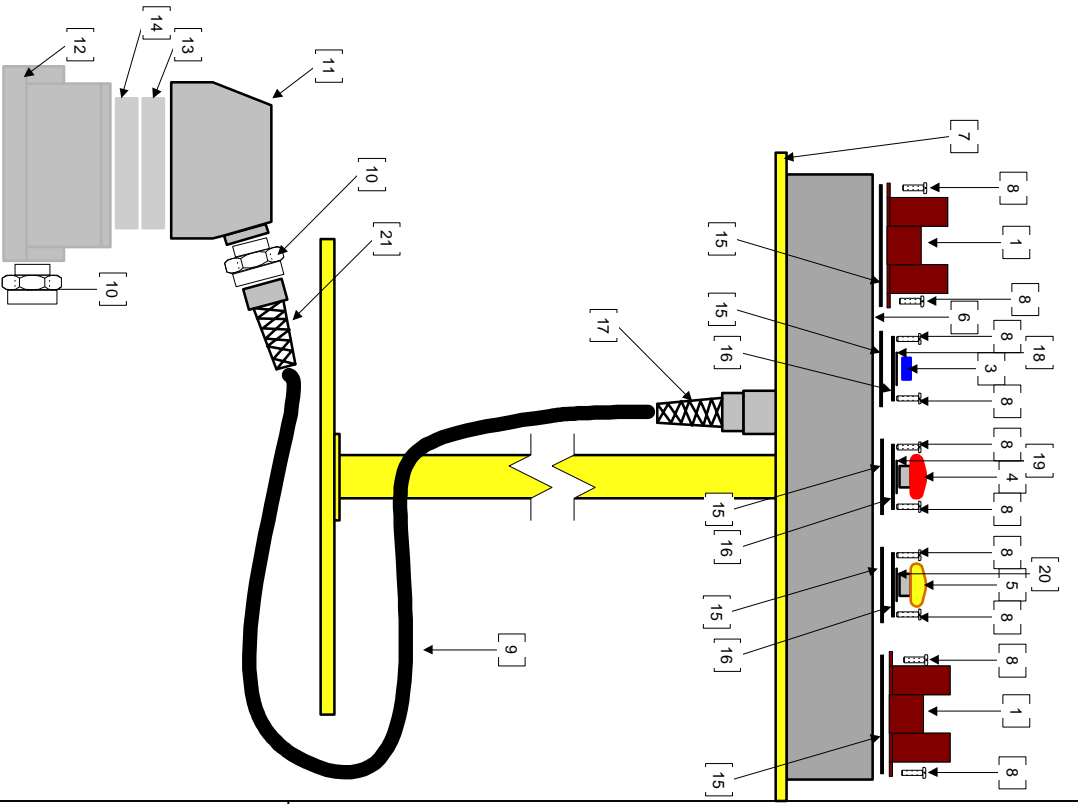


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	DRAWING S/N: FILE NAME REV
DRAWN TT		pm1.5_master_2stn_rev1.vsd	
ISSUED 30/06/2004		LAST EDIT 27/10/2004	C:\Documents and Settings\Tom.METALFORM\Desktop\ SHEET 19 OF 25



Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	DRAWING S/N: FILE NAME pm1.5_master_2stn_rev1.vsd	REV
DRAWN	TT			
ISSUED	30/06/2004	LAST EDIT	27/10/2004	C:\Documents and Settings\Tom.METALFORM\Desktop\ SHEET 20 OF 25

ITEM	QTY.	PART NO. and Price	DESCRIPTION
1	2	UL-101-2P	ULTRATOUGH PALM BUTTON
2	2		
3	1	800T-AZD1	PUSH BUTTON BLUE (CONT. SET)
4	1	800E-3LX01S	PUSH BUTTON RED MUSHROOM (STATION STOP)
5	1	800-D9D2	PUSH BUTTON YELLOW MUSHROOM (TOP STOP)
6	1	MFP-1-5HRB	5 HOLE RUN BAR
7	1	MFP-8000P	T-STAND ADJUSTABLE
8	20	6/32 1/2	BOLTS
9	1	16/16 SOW	WIRE RUBBER COATED OIL RESISTANT
10	2	73000005314	NPT ADAPTER TO 3/4"
11	1	09300160520	HOOD
12	1	09300161230	HOUSING
13	1	09330162801	MALE INSERT
14	1	09330162701	FEMALE INSERT
15	5	MFP-GSKT	GASKETS RUBBER OR FOAM
16	3	MFP-AB-30.5MM	ADAPTER PLATE 30.5 MM HOLE
17	1	1"	KELLEEM
18	1	MFP-L-CS-F	LABEL (CONT. SET)
19	1	MFP-L-ST-F	LABEL (STATION STOP)
20	1	MFP-L-TSF	LABEL (TOP STOP)
21	1	3/4"	KELLEEM
22			
23			
24			
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Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXXX	<input type="checkbox"/> REV
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START UP PROCEDURES AND SYSTEM VERIFICATION

STEP	PROCEDURE	RECORDED DATA
1	REMOVE MAIN FUSES	
2	MEASURE INCOMMING VOLAGE	
3	CONFIRM MOTOR VOLAGES AND AMP RATING	
	Main Motor	
	Ram Motor	
	Lube motor	
	Aux Motor 1	
	Aux Motor 2	
	Aux Motor 3	
4	Set overload to proper range	
	Main motor O/L	
	Ram Motor O/L	
	Lube motor O/L	
	Aux Motor 1 O/L	
	Aux Motor 2 O/L	
	Aux Motor 3 O/L	
5	Replace Main Fuses	
6	Turn on main disconnect switch	
7	Turn on Power off on switch	
8	Press Master stop	
	Message sould read (Master Stop Open)	
9	Twist to release Master Stop Button	
	Start main Motor and Stop imidiatly and check for rotation	
10	If rotation is OK then restart main motor	
11	Inch the press to the mechanical ZERO (O) and stop	
12	Confirm that the proxi for ZERO is ON at mechanical zero	
13	enter program mode and zero the encoder	
14	enter all parameters as per the manual provided	
15	Confirm all external devices are functioning.	

Metal Form Products Co. Ltd.
8-1734 Orangebrook Court
Pickering ON L1W 3G8
888-285-8885

INTERNAL
WIRING

EXTERNAL
WIRING

AC 120
VOLTS

DC 24
VOLTS

GROUND

NEUTRAL
WHITE

TERMINAL
STRIP
ITEM No. XXX

DRAWN

TT

DRAWING S/N:

FILE NAME

pm1.5_master_2stn_rev1.vsd

REV

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Device Confirmation

Device	Checked		Notes / SETTINGS
	Yes	No	
MAIN DISC RATING			
MAIN DISC FUSE RATING			
MAIN MOTOR RATINGS			
MAIN MOTOR OVERLOAD SET			
RAM MOTOR RATINGS			
RAM MOTOR OVERLOAD SET			
LUBE MOTOR RATINGS			
LUBE MOTOR OVERLOAD SET			
AUX1 MOTOR RATINGS			
AUX1 MOTOR OVERLOAD SET			
AUX2 MOTOR RATINGS			
AUX2 MOTOR OVERLOAD SET			
AUX3 MOTOR RATINGS			
AUX3 MOTOR OVERLOAD SET			
RAM BLOCK 1			
RAM BLOCK 2			
RAM BLOCK 3			
RAM BLOCK 4			
GATE SWITCH 1			
GATE SWITCH 2			
GATE SWITCH 3			
GATE SWITCH 4			
MASTER STOP			
E-STOP 1			
E-STOP 2			
E-STOP 3			
MAIN MOTOR ROTATION			
LUBE MOTOR ROTATION			
RAM MOTOR ROTATION			
LUBE PRESSURE			
FLYWHEEL BRAKE			
M1 FORWARD REVERS SWITCH			
M2 RAM ADJUST OFF ON SWITCH			
RAM UP LIMIT SWITCH			
RAM DOWN LIMIT SWITCH			

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A

Metal Form Products Co. Ltd.
8-1734 Orangebrook Court
Pickering ON L1W 3G8
888-285-8885

INTERNAL
WIRINGEXTERNAL
WIRINGAC 120
VOLTSDC 24
VOLTS

GROUND

NEUTRAL
WHITE

TERMINAL
STRIP
ITEM No.

REV
XXX

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