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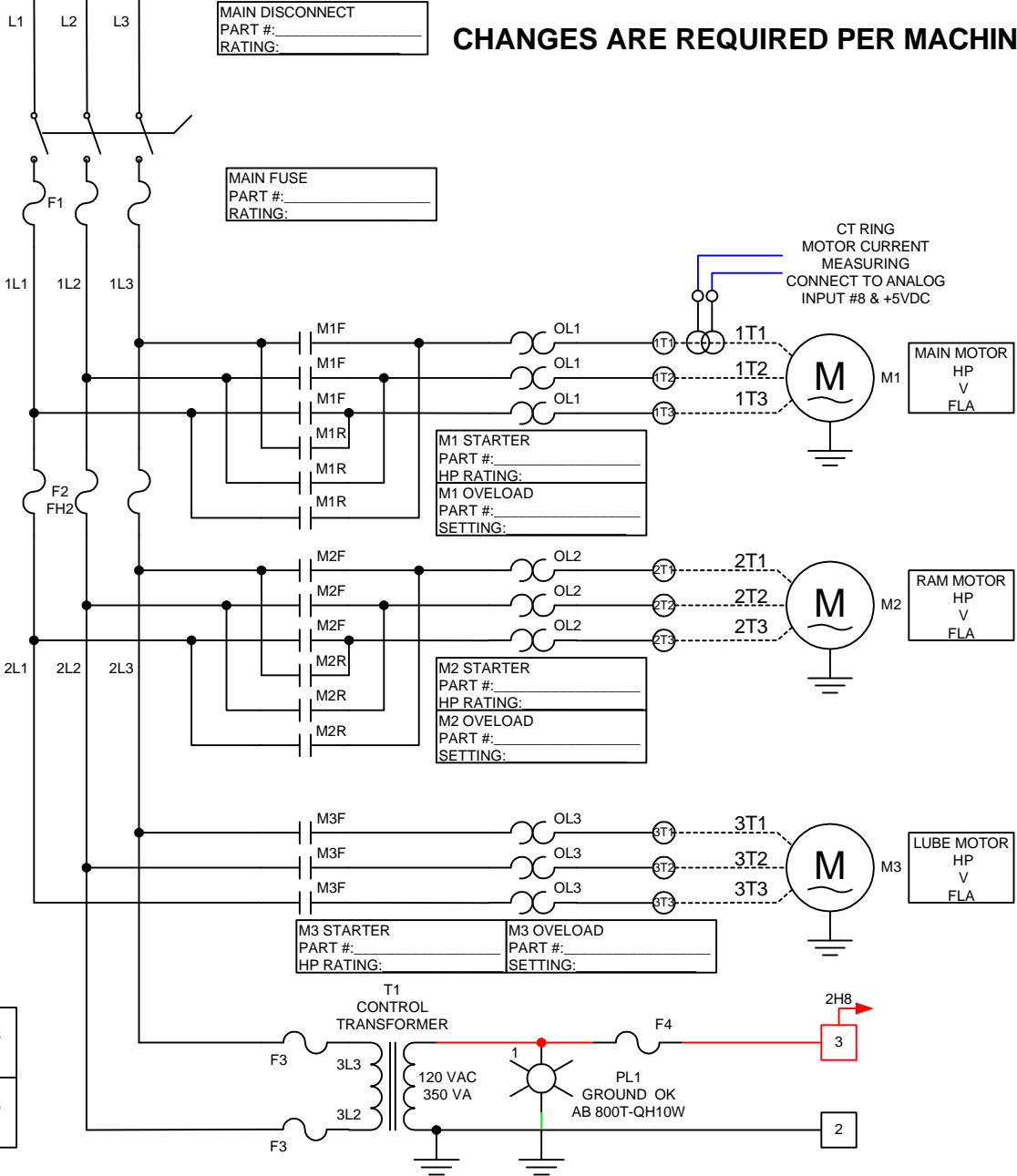
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600VAC

DRAFT SAMPLE DRAWING ONLY:

CHANGES ARE REQUIRED PER MACHINE



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	DRAWING S/N:		FILE NAME		REV
ISSUED	30/06/2004	LAST EDIT	18/11/2004	X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\	SHEET	1 OF 25

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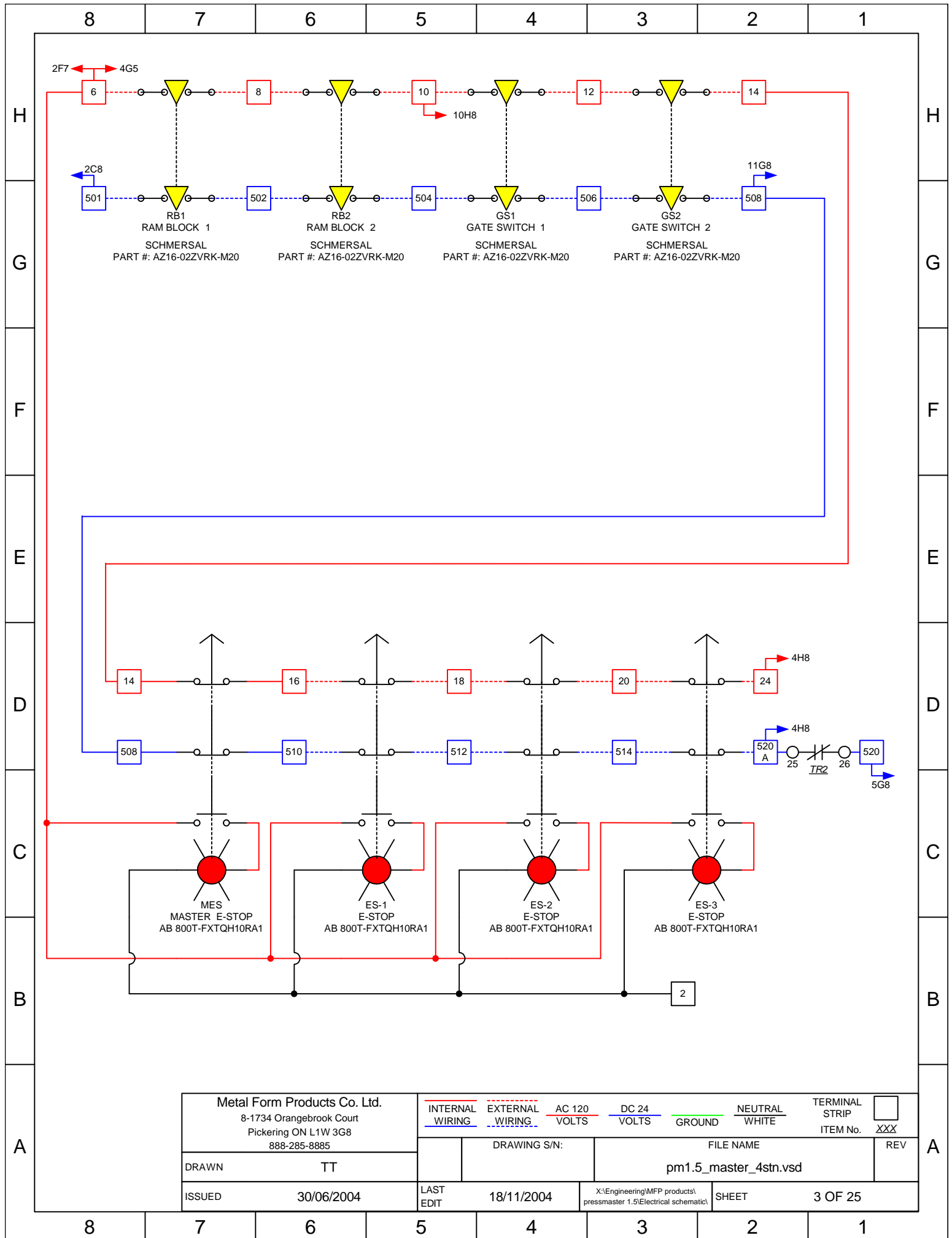
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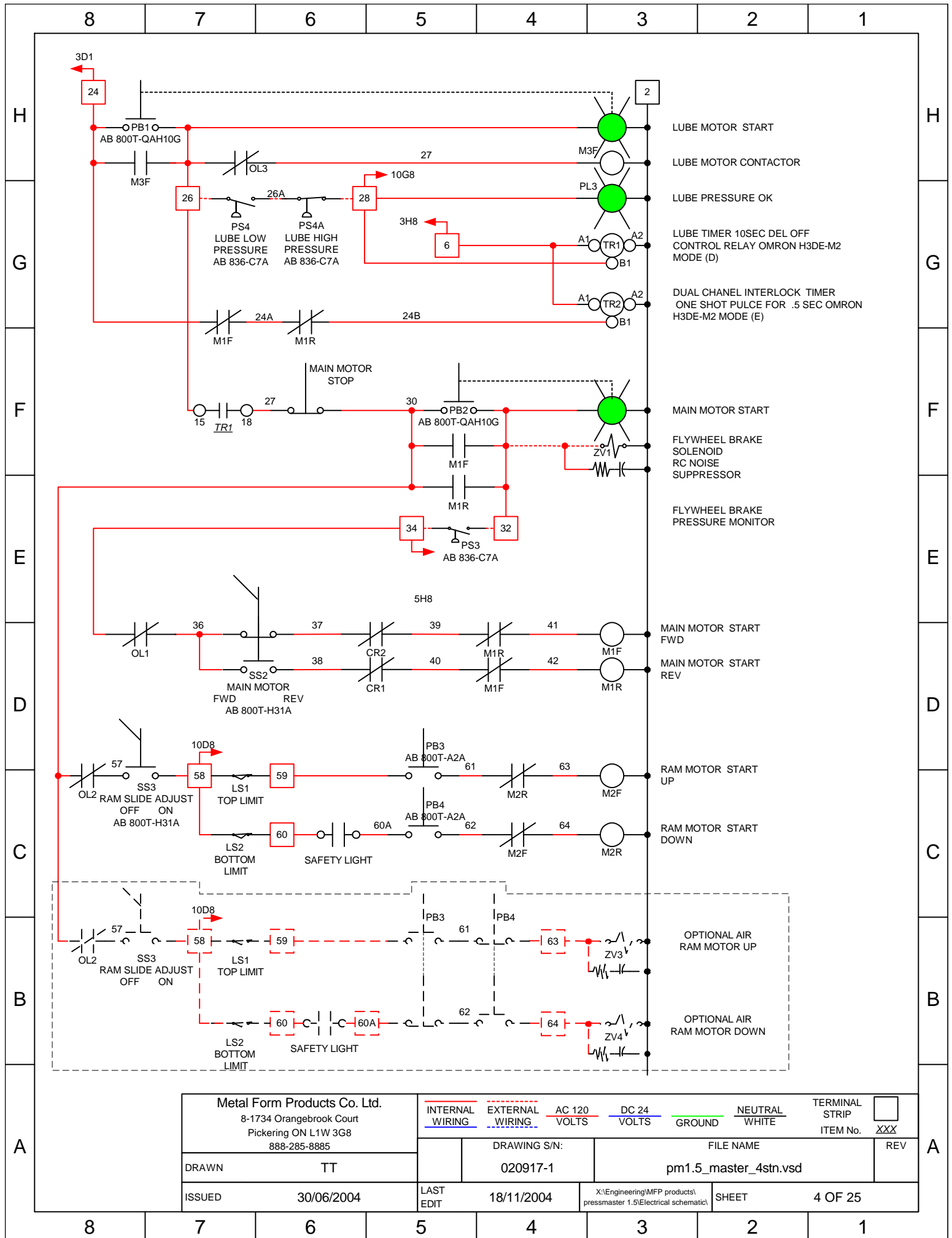
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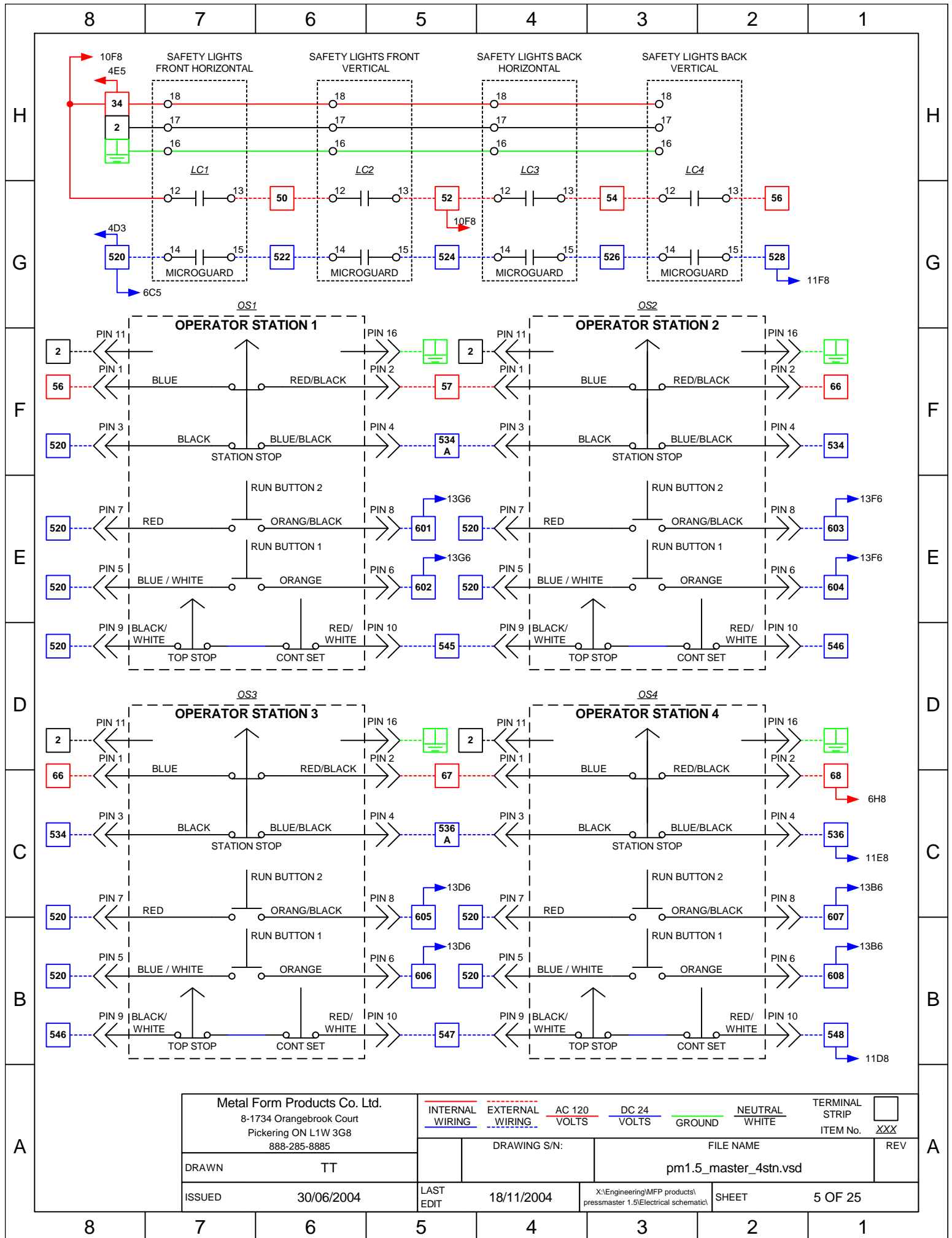
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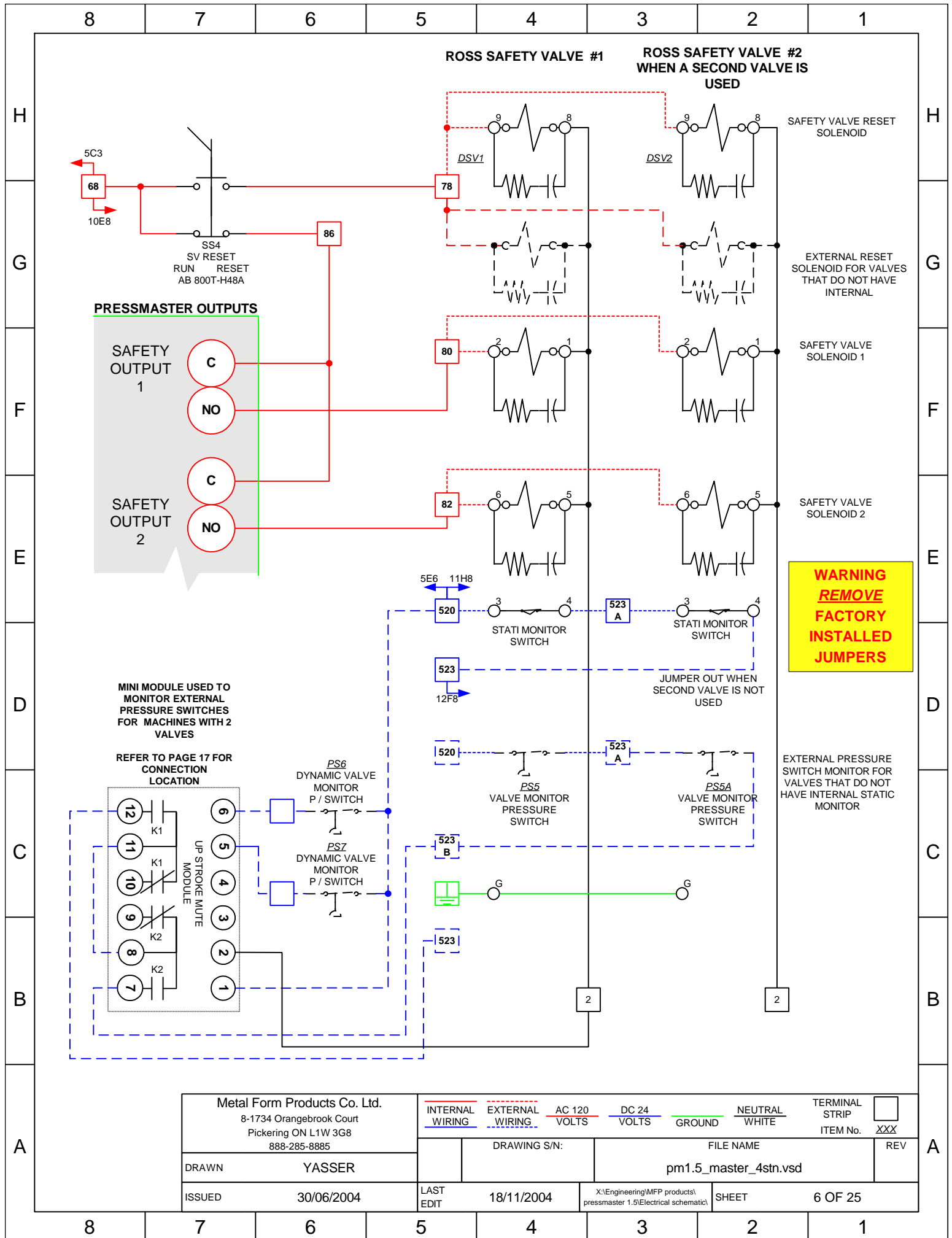


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	DRAWING S/N: FILE NAME pm1.5_master_4stn.vsd	REV
DRAWN	TT	LAST EDIT	18/11/2004	X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\
ISSUED	30/06/2004	SHEET	3 OF 25	

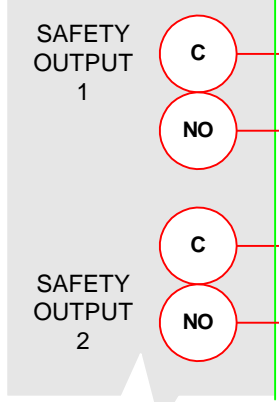




Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	NEUTRAL WHITE	TERMINAL STRIP ITEM No. XXX
		DRAWING S/N:		FILE NAME		REV	
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ISSUED 30/06/2004		LAST EDIT 18/11/2004		X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\ SHEET		5 OF 25	

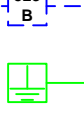
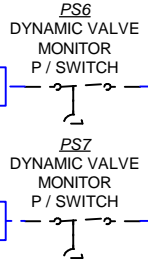
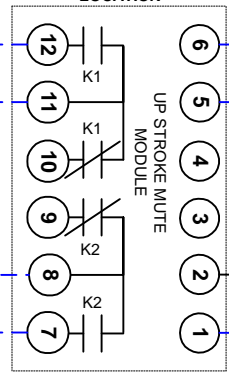


PRESSMASTER OUTPUTS



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

REFER TO PAGE 17 FOR CONNECTION LOCATION



WARNING REMOVE FACTORY INSTALLED JUMPERS

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
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ISSUED 30/06/2004		LAST EDIT 18/11/2004		X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\		SHEET 6 OF 25	

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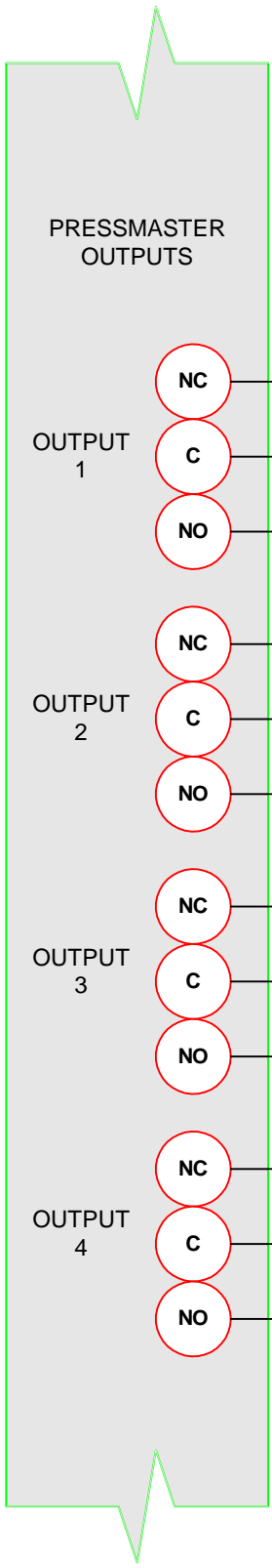
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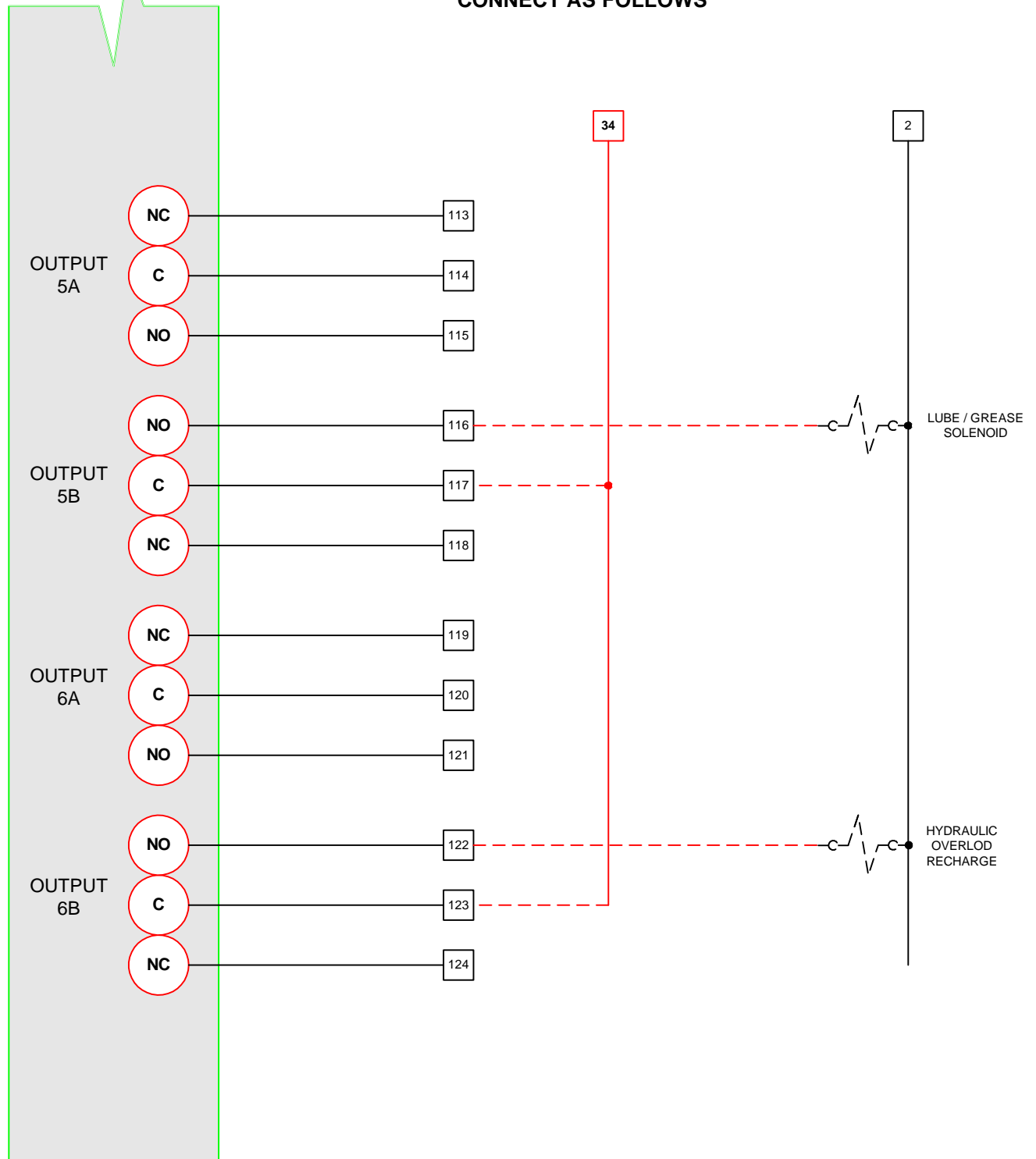


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING ----- EXTERNAL WIRING - - - - - AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. <input type="checkbox"/> XXX	DRAWING S/N: FILE NAME pm1.5_master_4stn.vsd	REV
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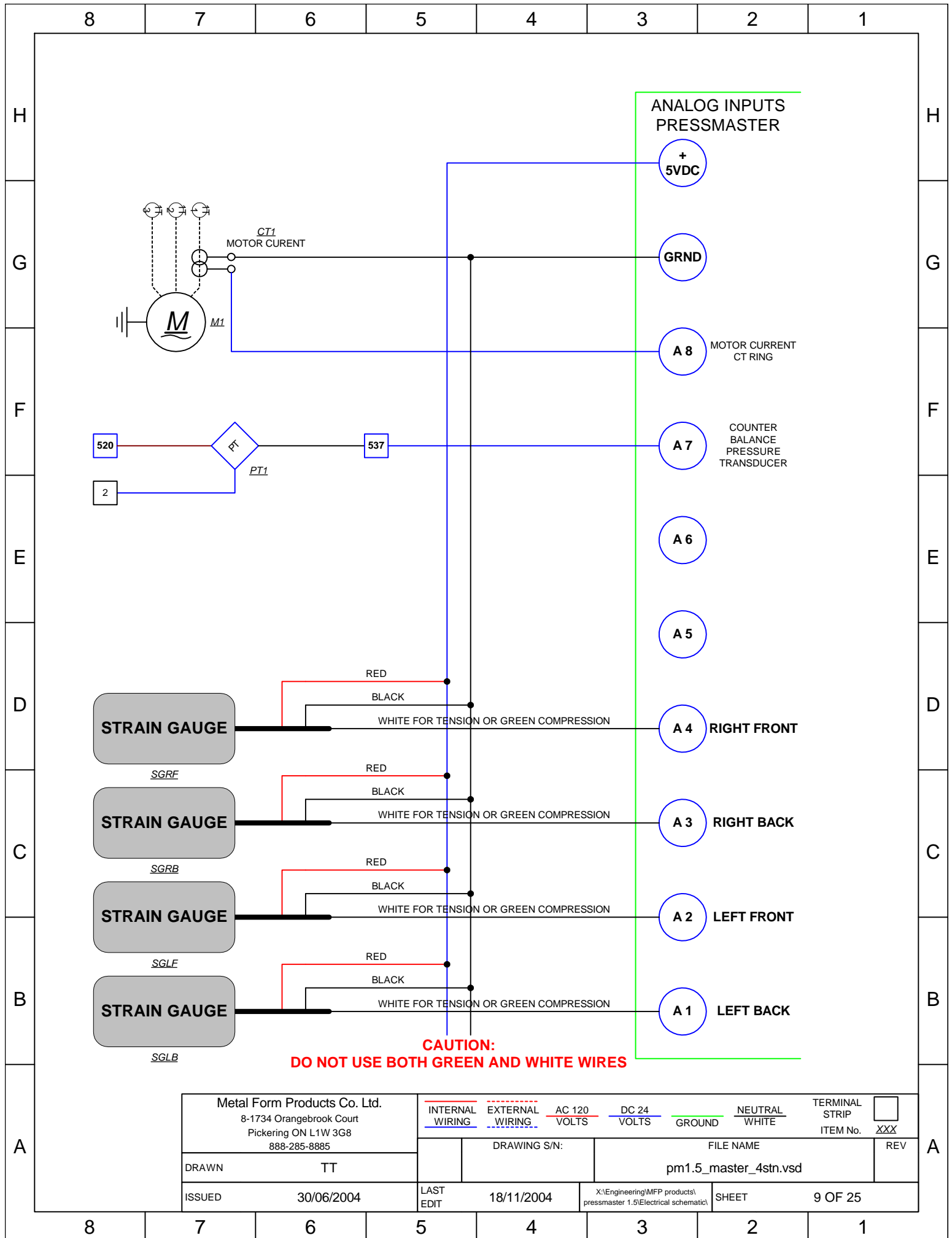
8 7 6 5 4 3 2 1

SAMPLE DRAWING FOR OPTIONAL CONNECTONS

**WHEN LUBE CONTROL AND HYDRAULIC OVERLOAD IS SELECTED
CONNECT AS FOLLOWS**



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.	REV
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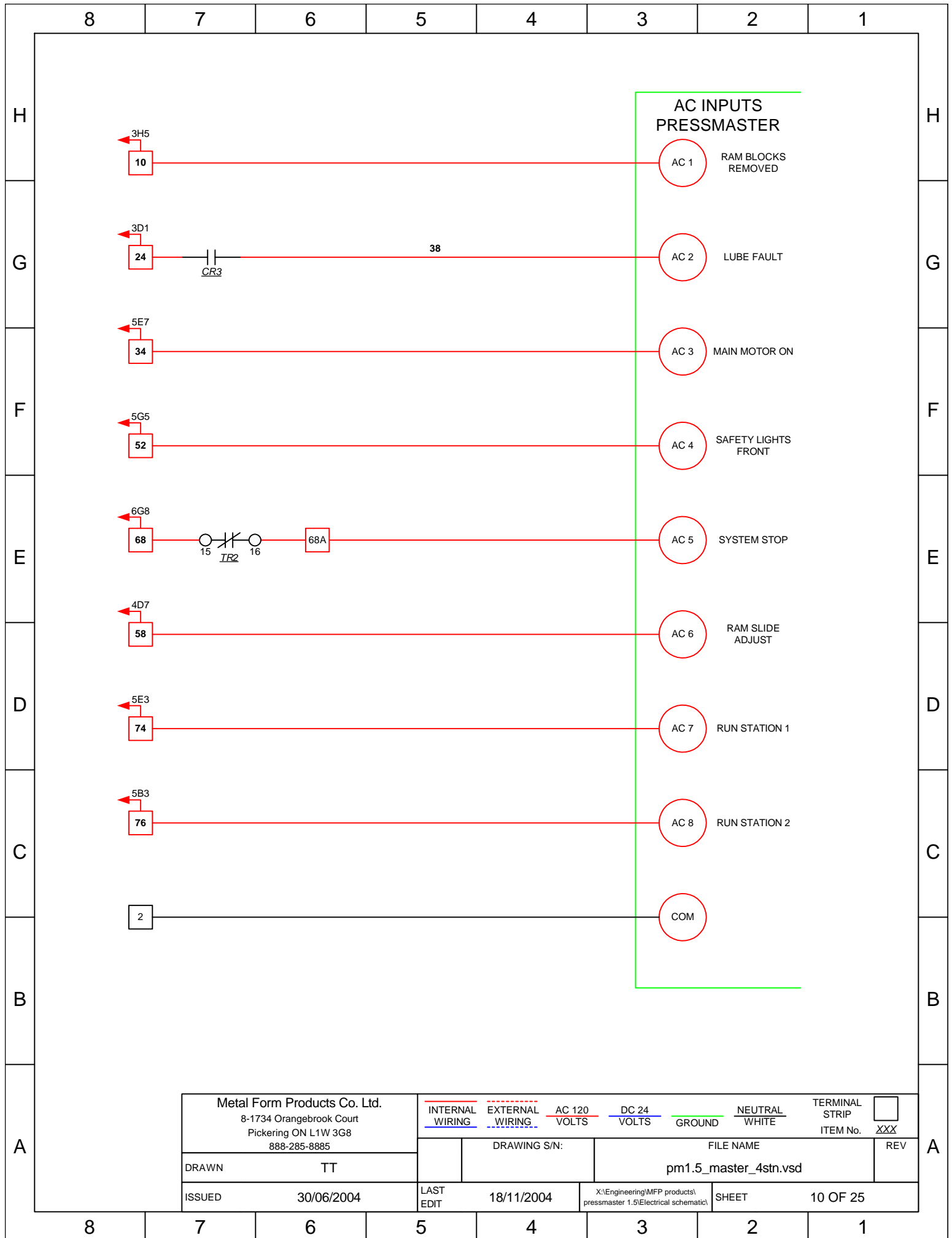


**ANALOG INPUTS
PRESSMASTER**

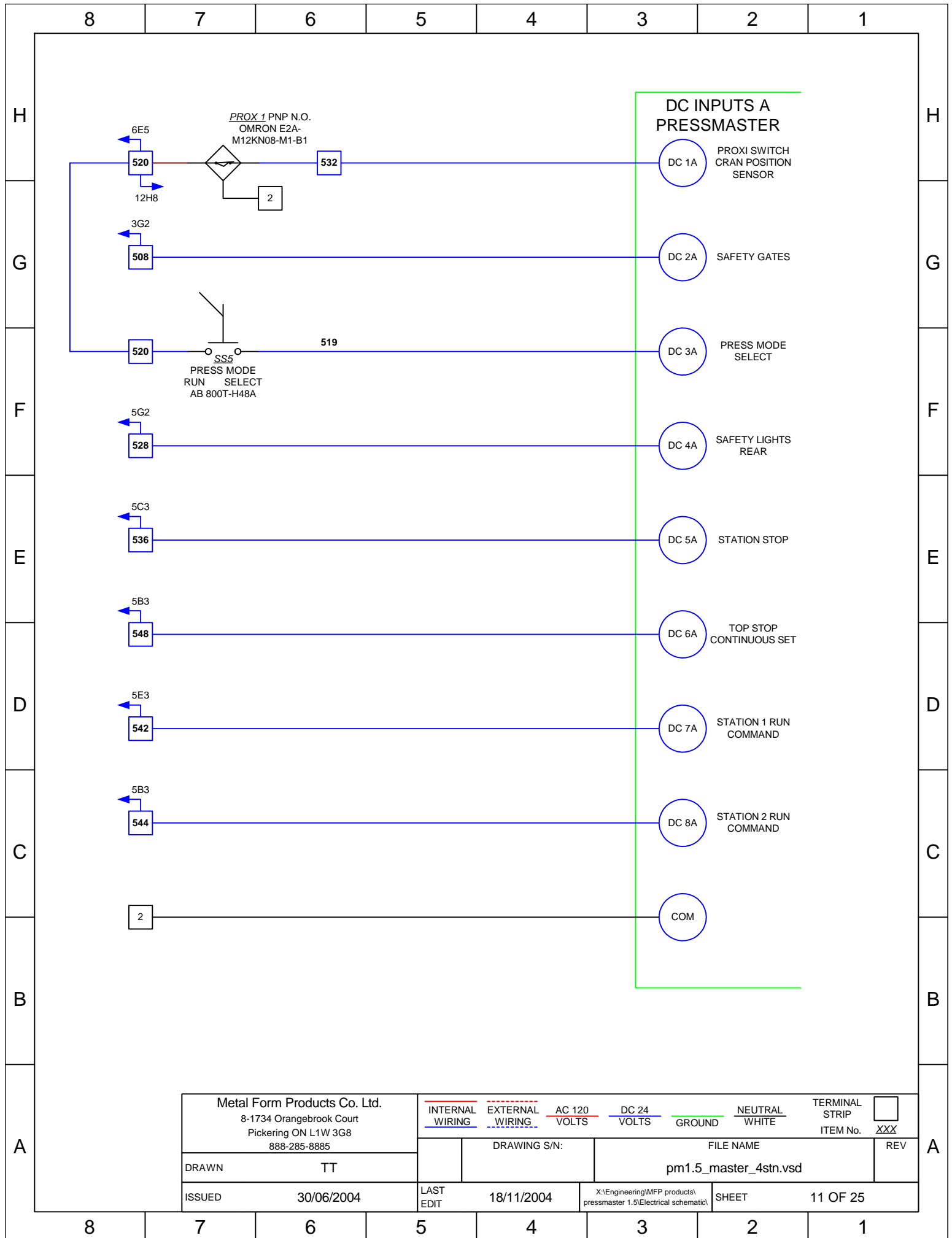
- + 5VDC**
- GRND**
- A 8** MOTOR CURRENT CT RING
- A 7** COUNTER BALANCE PRESSURE TRANSDUCER
- A 6**
- A 5**
- A 4** **RIGHT FRONT**
- A 3** **RIGHT BACK**
- A 2** **LEFT FRONT**
- A 1** **LEFT BACK**

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

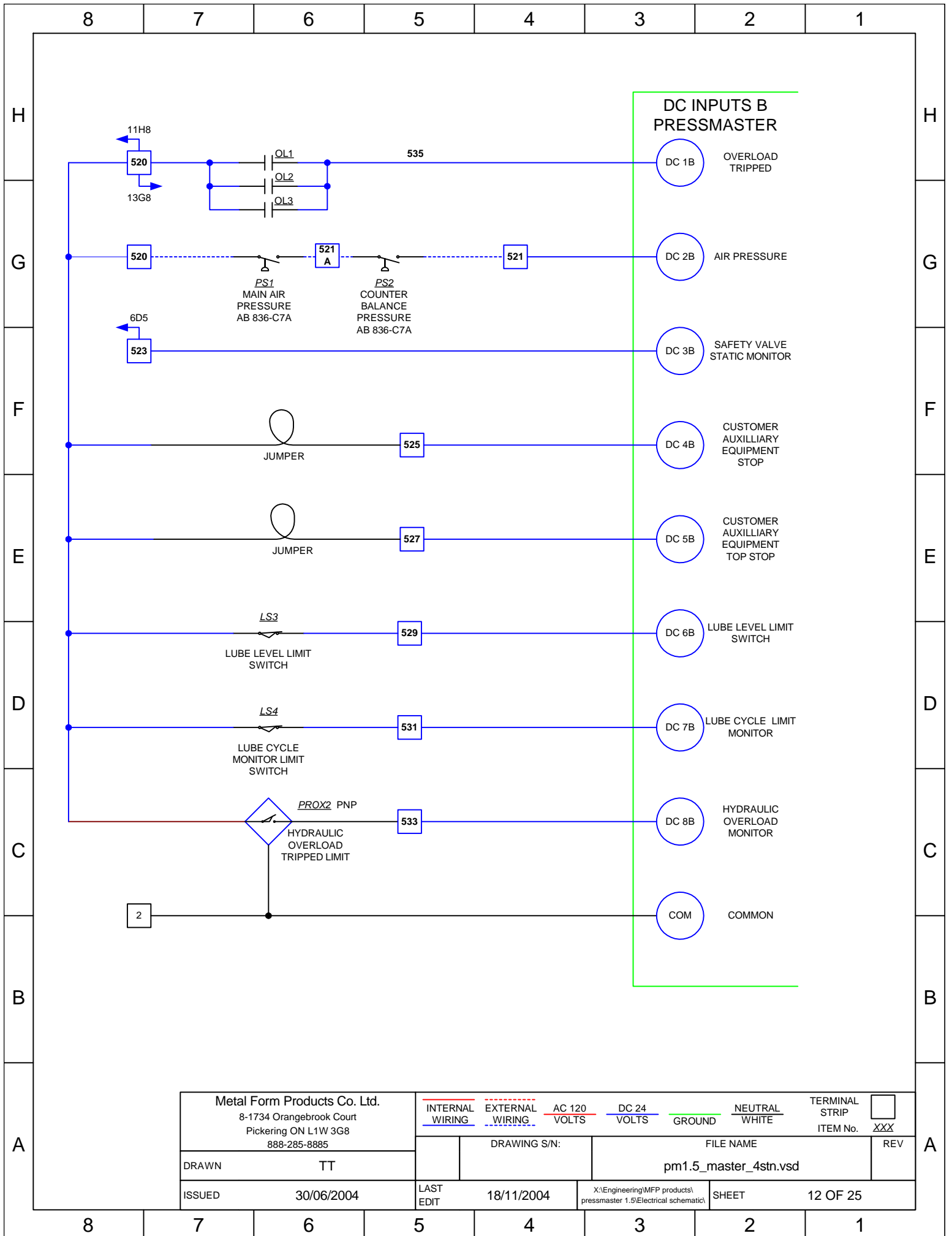
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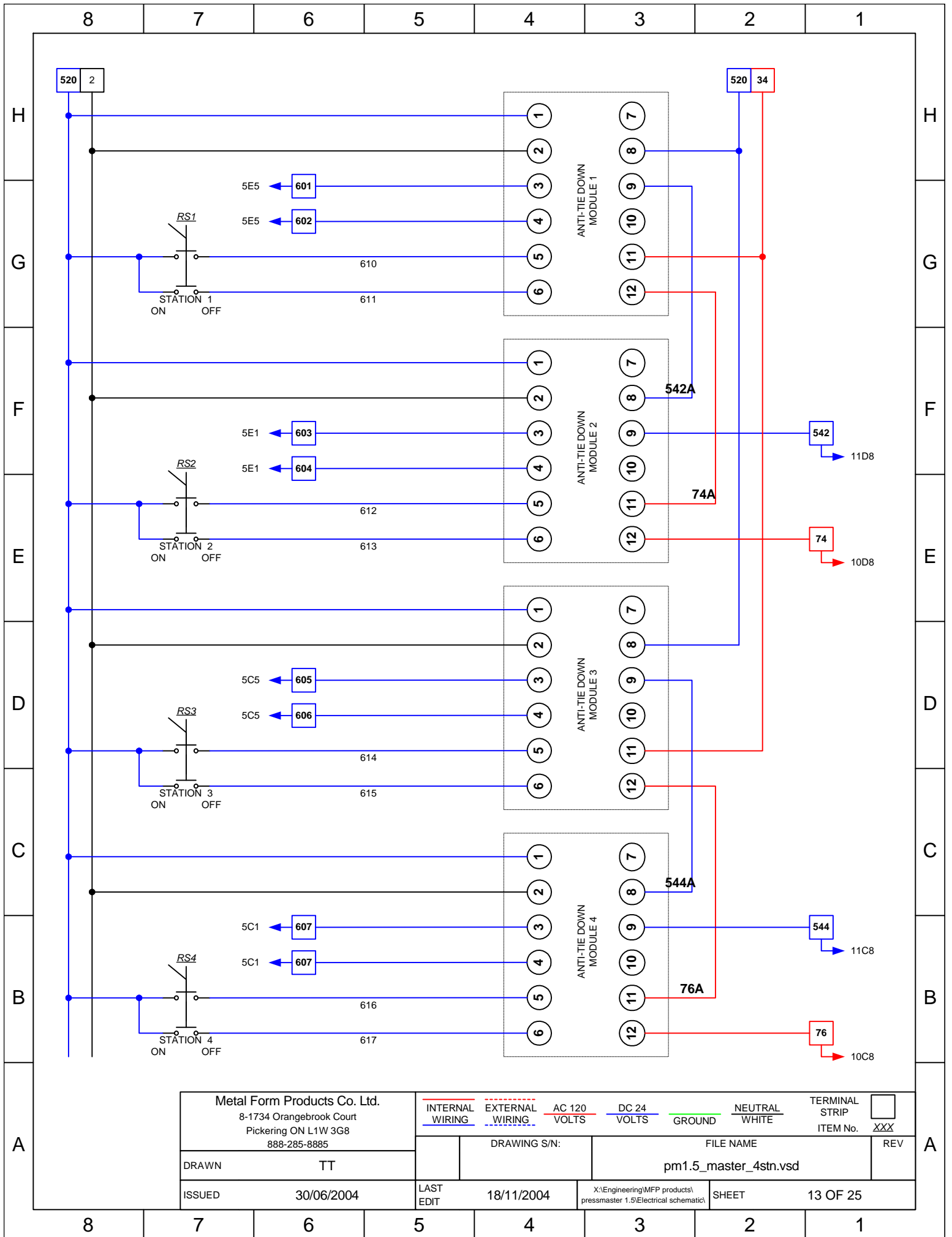
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ISSUED	30/06/2004	LAST EDIT	18/11/2004	X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\		SHEET	10 OF 25		



Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL <u>WIRING</u>	EXTERNAL <u>WIRING</u>	AC 120 <u>VOLTS</u>	DC 24 <u>VOLTS</u>	<u>GROUND</u>	NEUTRAL <u>WHITE</u>	TERMINAL STRIP ITEM No. <input type="checkbox"/>
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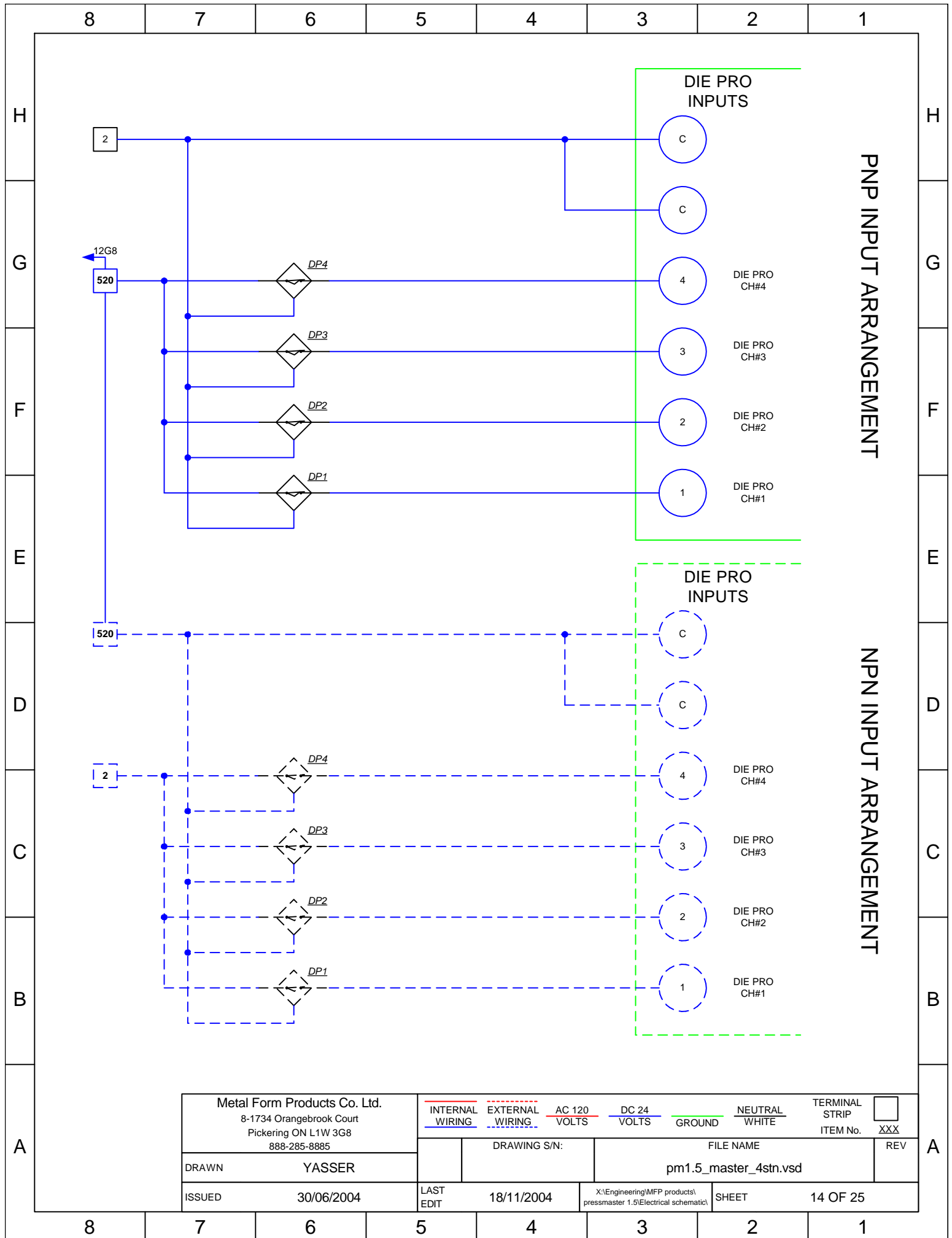


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING <small>(Solid Blue Line)</small>	EXTERNAL WIRING <small>(Dashed Blue Line)</small>	AC 120 VOLTS <small>(Red Line)</small>	DC 24 VOLTS <small>(Blue Line)</small>	GROUND <small>(Green Line)</small>	NEUTRAL WHITE <small>(Black Line)</small>	TERMINAL STRIP ITEM No. XXX	<input type="checkbox"/>
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Metal Form Products Co. Ltd.
 8-1734 Orangebrook Court
 Pickering ON L1W 3G8
 888-285-8885

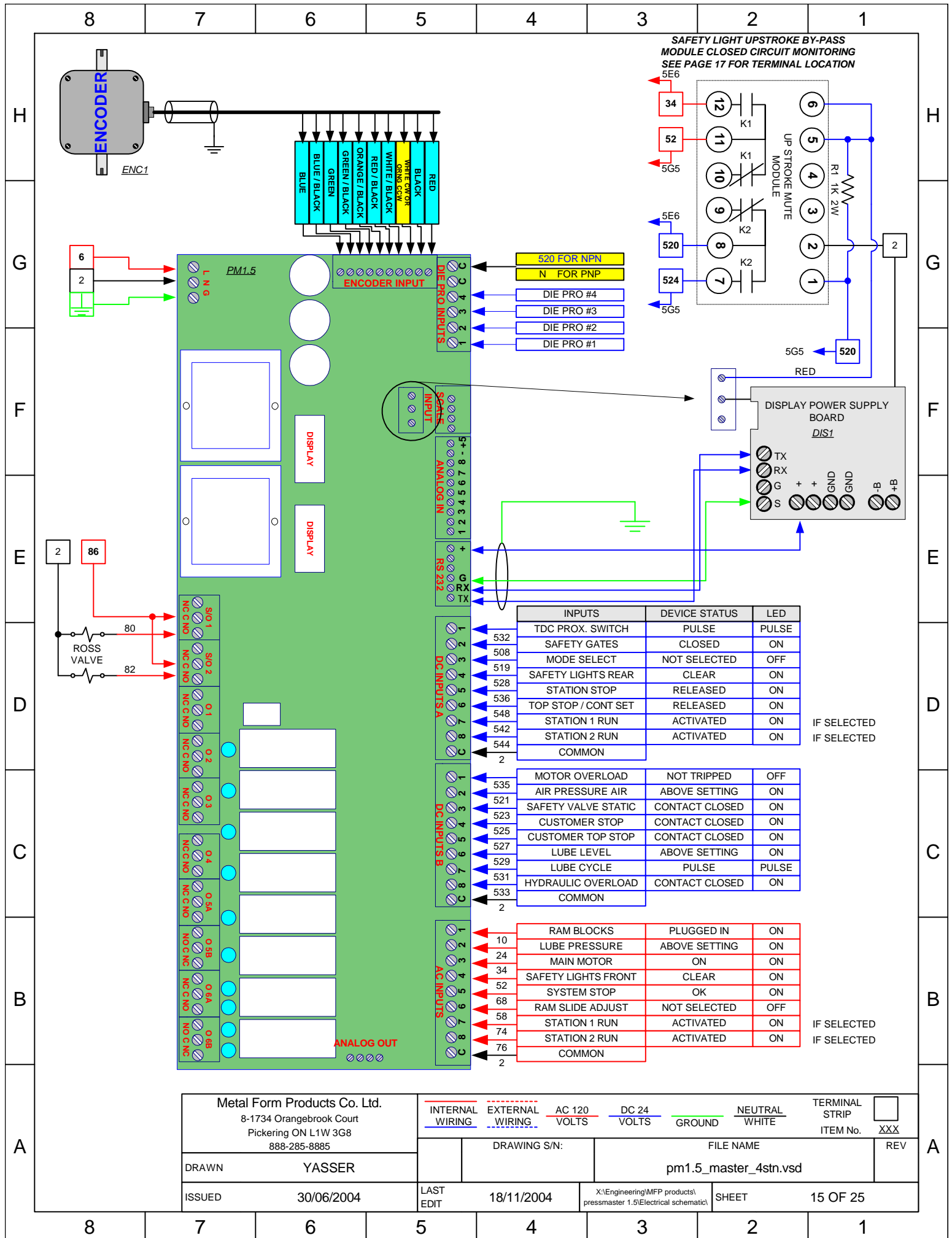
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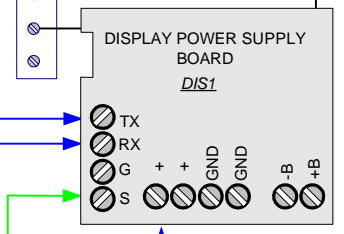
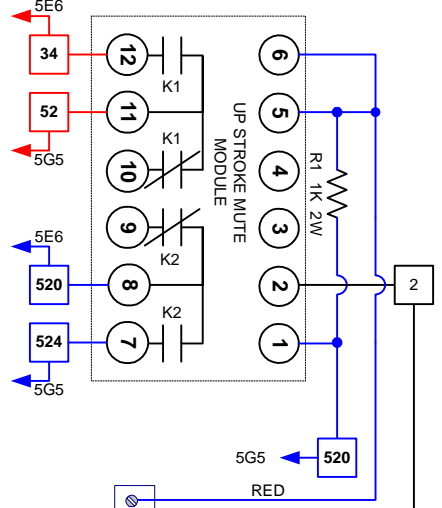
PNP INPUT ARRANGEMENT

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
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ISSUED	30/06/2004	LAST EDIT	18/11/2004	X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\		SHEET	14 OF 25	



**SAFETY LIGHT UPSTROKE BY-PASS
MODULE CLOSED CIRCUIT MONITORING
SEE PAGE 17 FOR TERMINAL LOCATION**



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

IF SELECTED
IF SELECTED

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

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

IF SELECTED
IF SELECTED

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

DRAWN **YASSER**

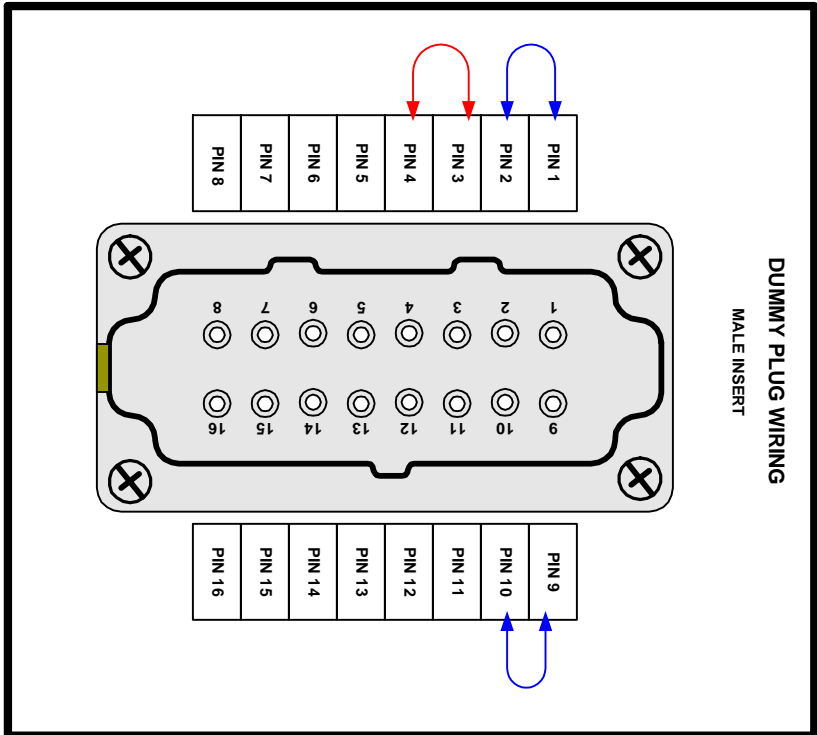
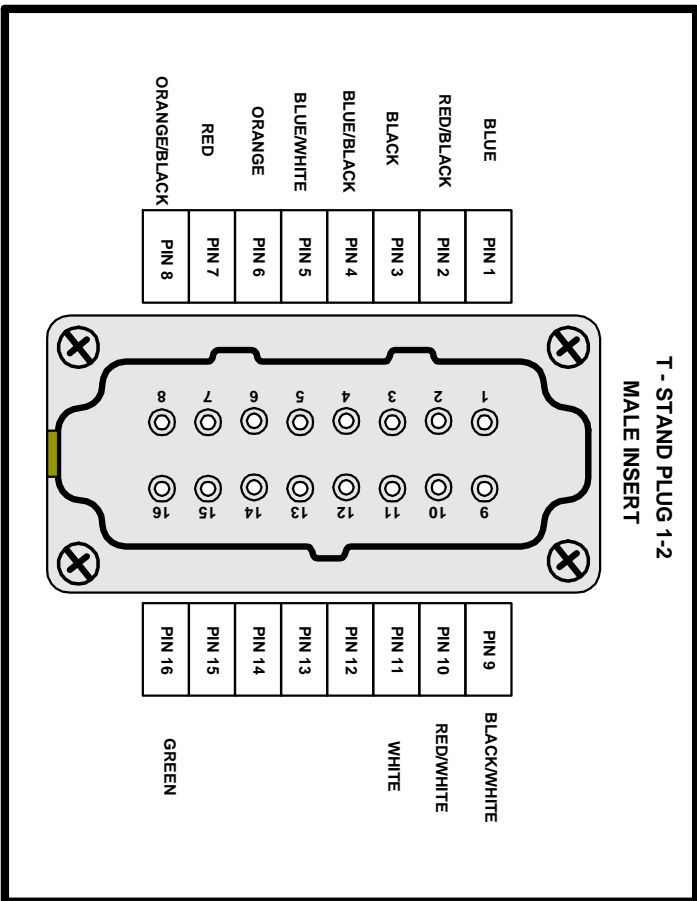
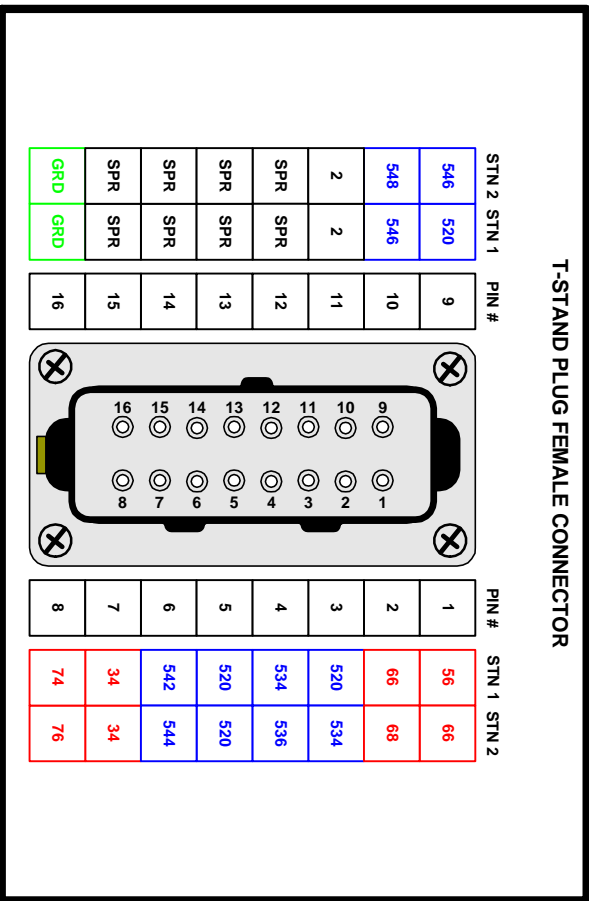
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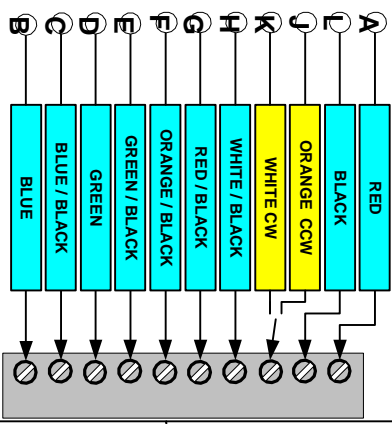
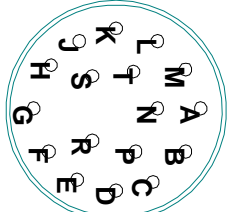
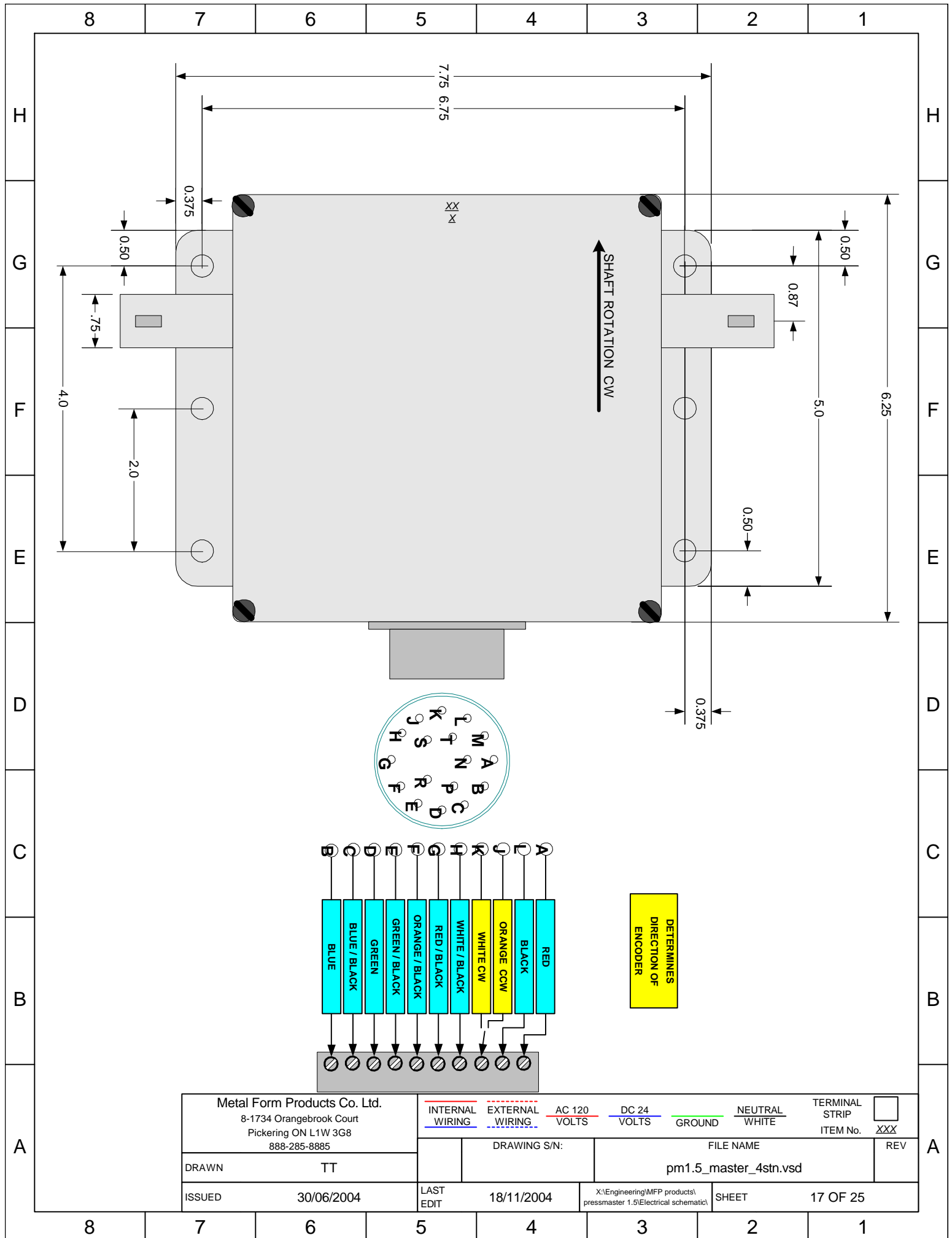
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H G L E D C B A



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
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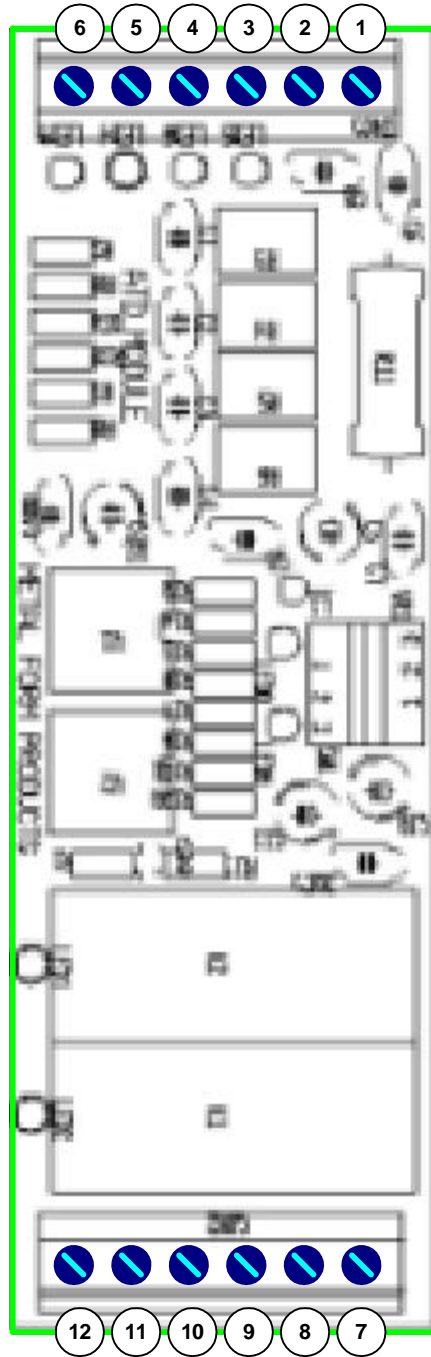


DETERMINES
DIRECTION OF
ENCODER

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"/>
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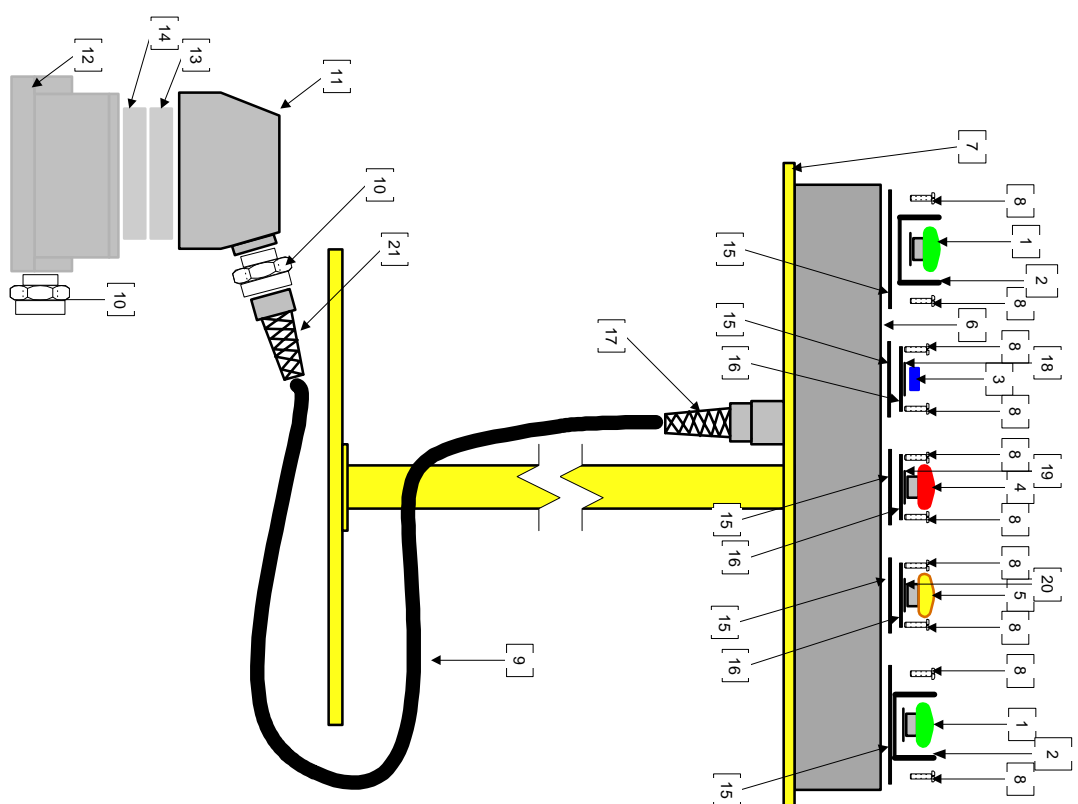
MINI MODULE TERMINAL LOCATIONS

ANTI-TIE DOWN
UPSTROKE BY-PASS

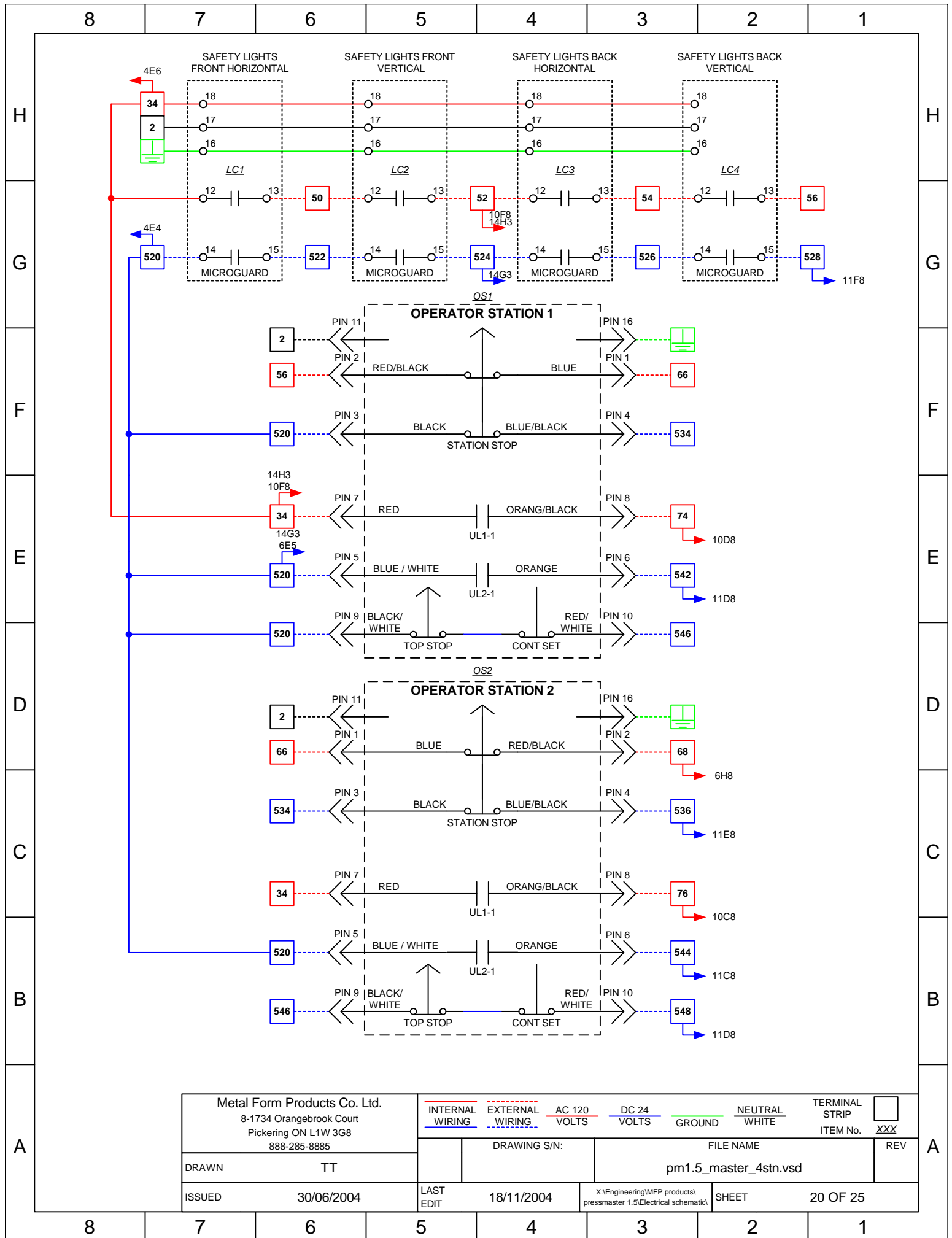


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885		INTERNAL WIRING	EXTERNAL WIRING	AC 120 VOLTS	DC 24 VOLTS	GROUND	NEUTRAL WHITE	TERMINAL STRIP ITEM No. <input type="checkbox"/> XXX
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ISSUED 30/06/2004		LAST EDIT 18/11/2004		X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\			SHEET 18 OF 25	
		pm1.5_master_4stn.vsd						

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			
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29			

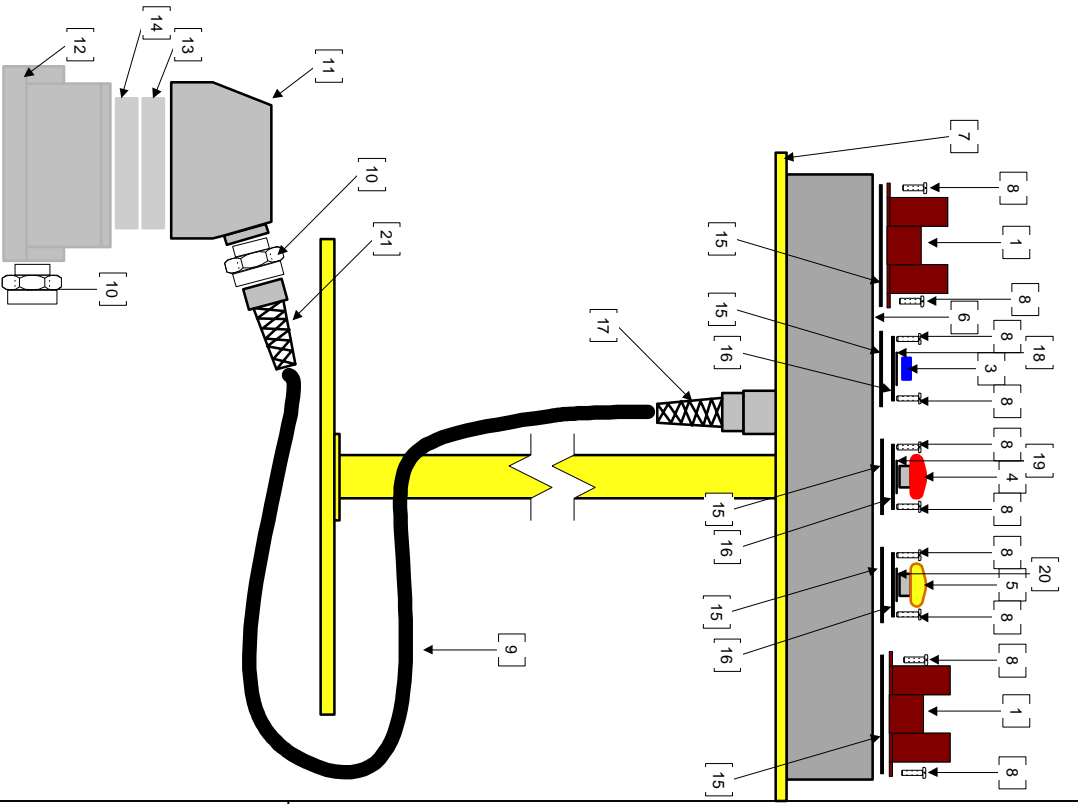


Metal Form Products Co. Ltd. 8-1734 Orangebrook Court Pickering ON L1W 3G8 888-285-8885	INTERNAL WIRING EXTERNAL WIRING AC 120 VOLTS DC 24 VOLTS GROUND NEUTRAL WHITE TERMINAL STRIP ITEM No. XXX	<input type="checkbox"/>
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ISSUED 30/06/2004	LAST EDIT 18/11/2004	X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\



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_4stn.vsd	REV
DRAWN	TT	LAST EDIT	18/11/2004	X:\Engineering\MFP products\pressmaster 1.5\Electrical schematic\
ISSUED	30/06/2004	SHEET	20 OF 25	

ITEM	QTY.	PART NO. and Price	DESCRIPTION
1	2	UL-101-2P	ULTRATOUCH 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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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. XXXX	DRAWING S/N: FILE NAME pm1.5_master_4stn.vsd	REV SHEET 21 OF 25
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ISSUED	30/06/2004			

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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_4stn.vsd

REV

ISSUED

30/06/2004

LAST
EDIT

18/11/2004

X:\Engineering\MFP products\
pressmaster 1.5\Electrical schematic\

SHEET

22 OF 25

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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
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