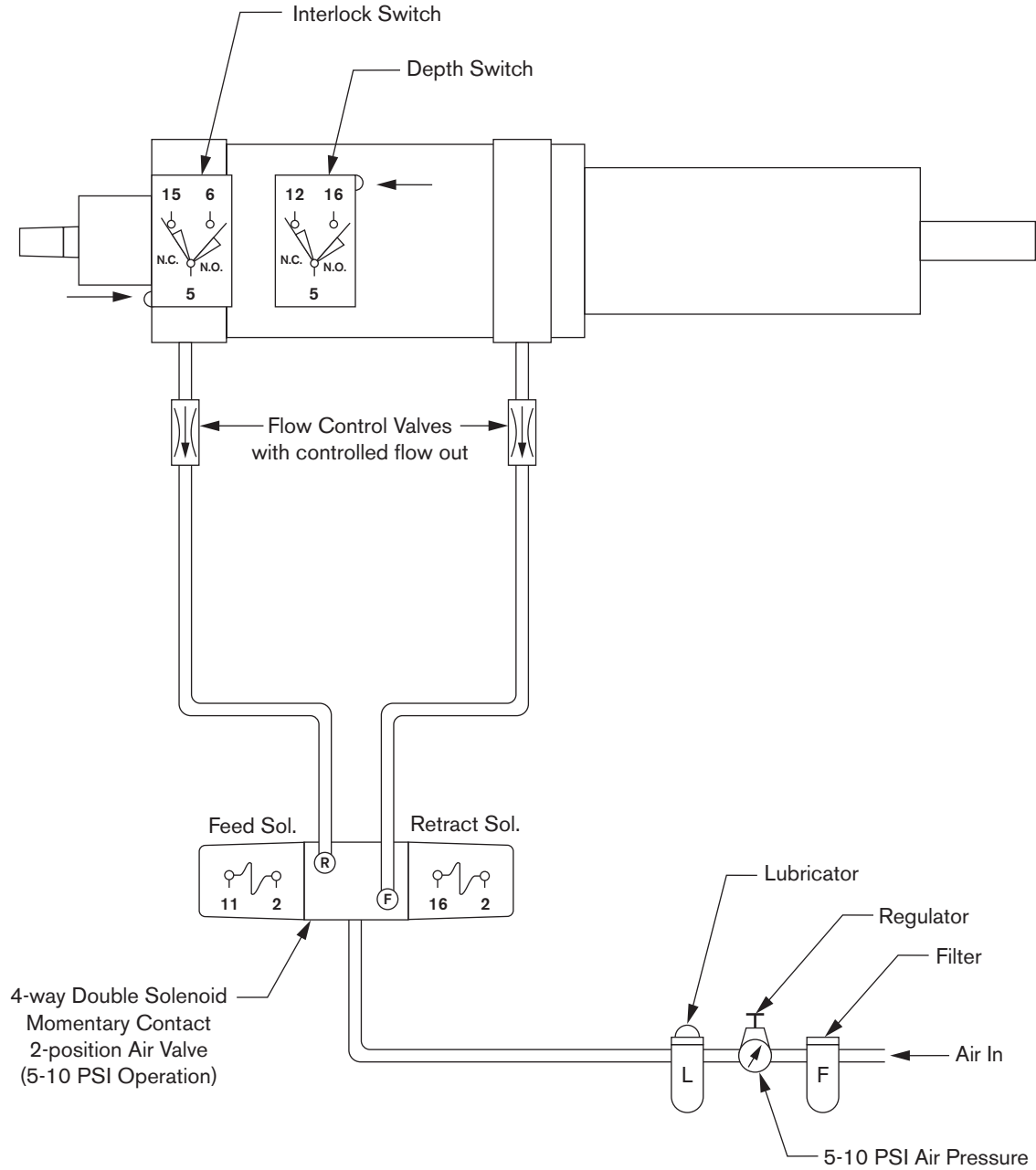


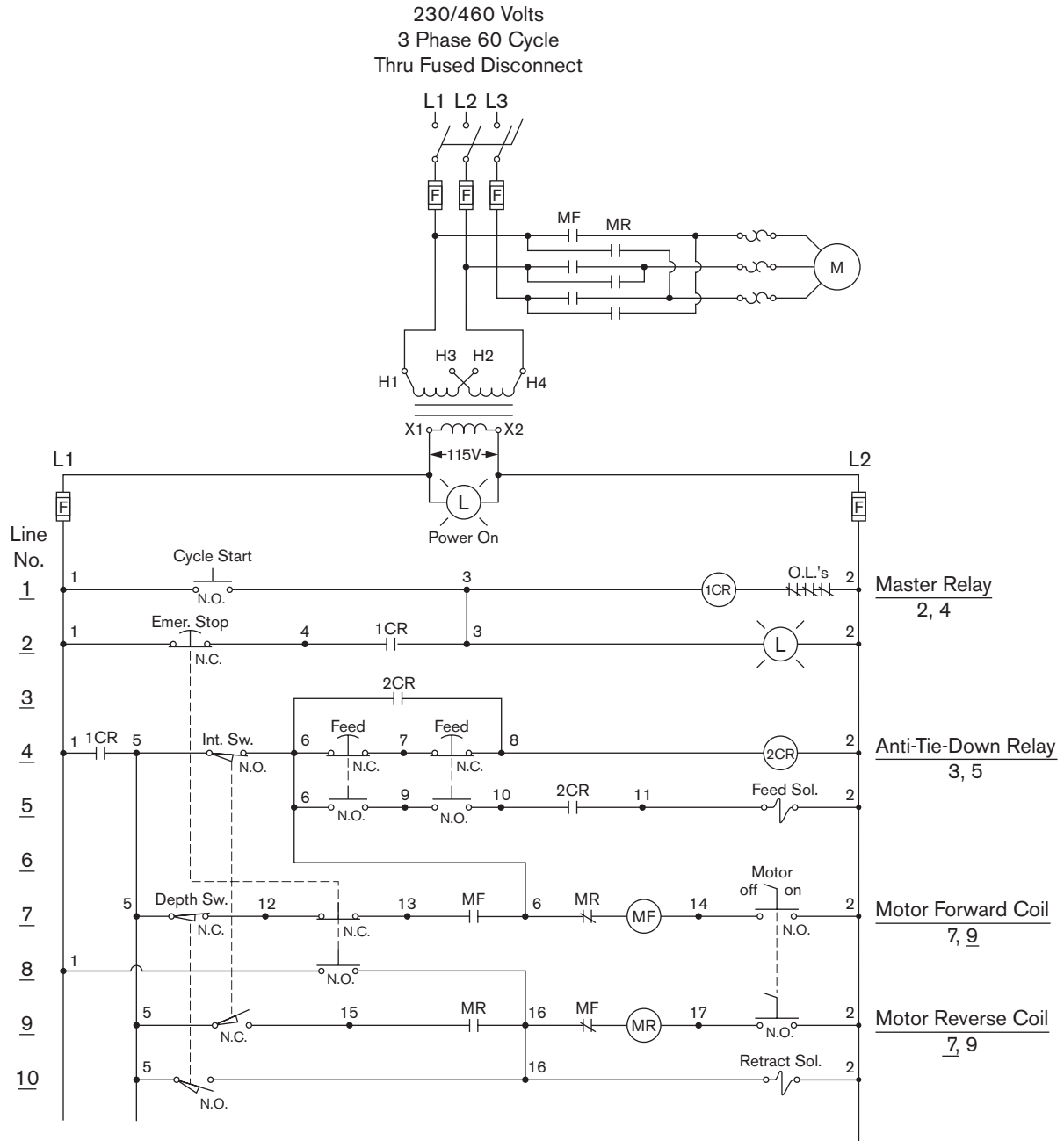
# HYPNEUMAT INC.

AUTOMATIC DRILLING & TAPPING UNITS

## PIPING FOR BASIC LOW PRESSURE AIR TAPPING CIRCUIT



**BASIC LOW PRESSURE AIR TAPPING CIRCUIT**



**IMPORTANT**

*THIS CIRCUIT IS A BASIC METHOD OF CONTROLLING HYPNEUMAT EQUIPMENT.  
 CHECK LOCAL, STATE, & OSHA REGULATIONS FOR SPECIFIC CIRCUIT REQUIREMENTS.*

**CYCLE SEQUENCE  
FOR LOW PRESSURE AIR TAPPING CIRCUIT**

1. Turn Motor Selector Switch to “ON”
2. Push Cycle Start Button
  - a. Supplies power to Circuit (1CR)
  - b. Motor forward coil (MF) starts motor in clockwise rotation
3. Push Twin Palm Feed Buttons
  - a. Valve shifts and unit feeds forward
4. Depth Switch is actuated
  - a. Motor forward coil (MF) is dropped out
  - b. Motor reverse coil (MR) is energized and starts motor in a counterclockwise rotation
  - c. Valve shifts and unit retracts
5. Unit Returns to Full Retract Position and Actuates Interlock Switch
  - a. Motor forward coil (MF) returns motor to clockwise rotation

**EMERGENCY STOP**

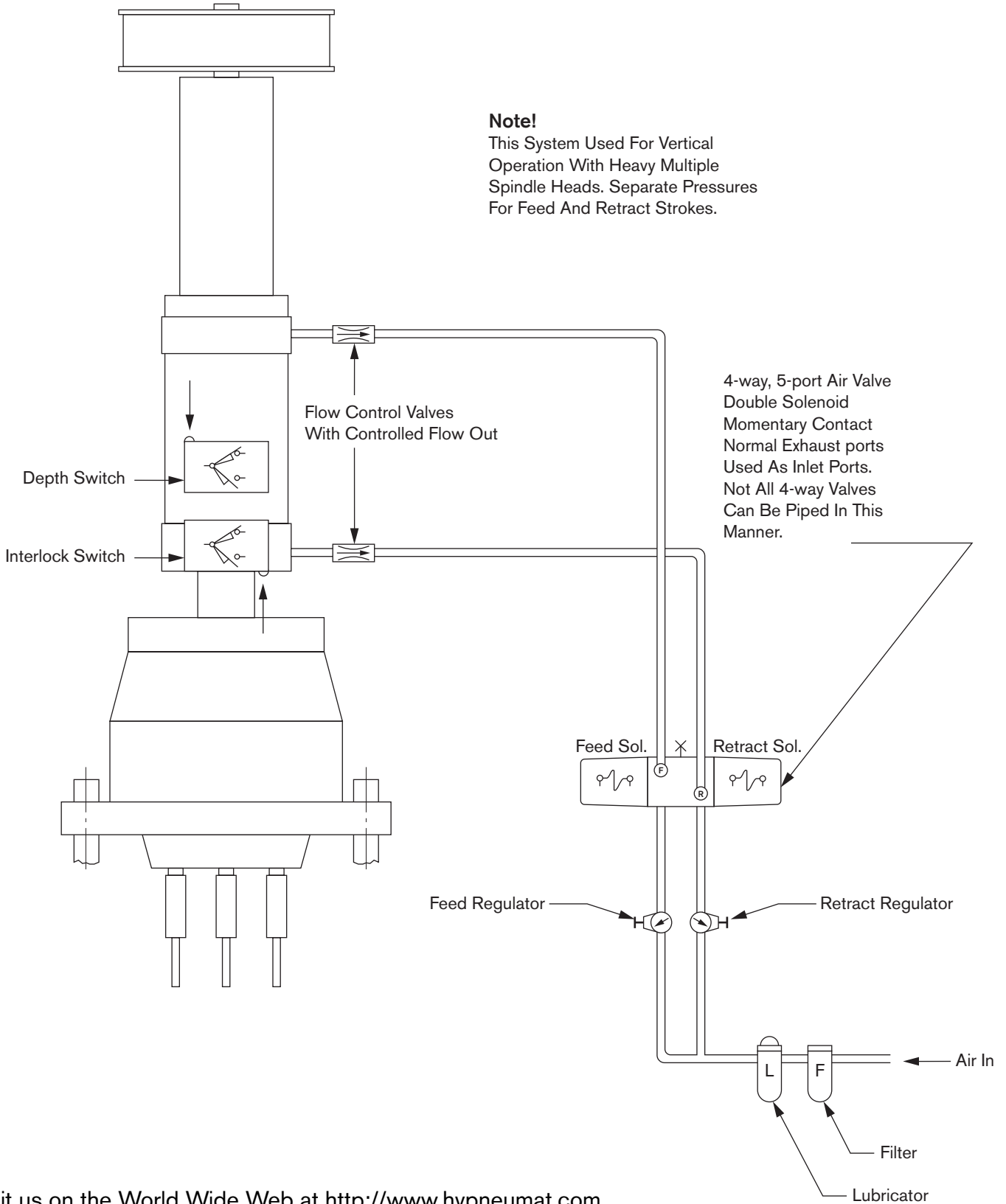
1. Push Emergency Stop Button
  - a. Motor forward coil (MF) is dropped out
  - b. 1CR Master Relay Drops Out
  - c. Valve shifts to retract position

NOTE: A. If tap is “NOT” in part, unit will rapid retract and motor will coast to stop

NOTE: B. If tap is “IN” part, motor will stop and unit will not rapid retract  
(see operation #2 for tap removal from part)

2. To return unit to full retract position, if tap is “IN” part
  - a. Push emergency stop button and hold down
  - b. Motor reverse coil (MR) is actuated and motor rotates counter clockwise
  - c. Tap leaves part and unit returns to full retract position
  - d. Release emergency stop button

## OPTIONAL PIPING FOR DUAL PRESSURE SYSTEM



Visit us on the World Wide Web at <http://www.hypneumat.com>

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