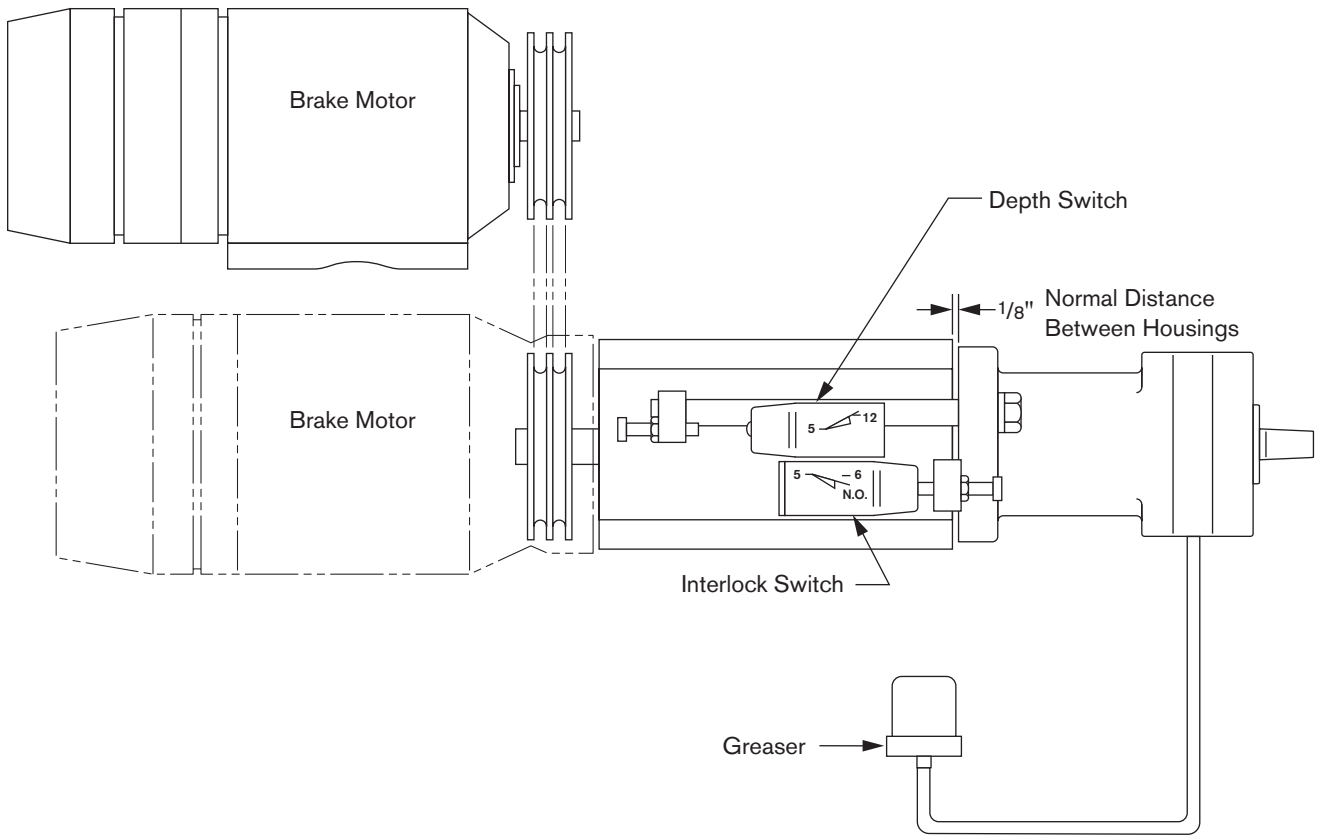


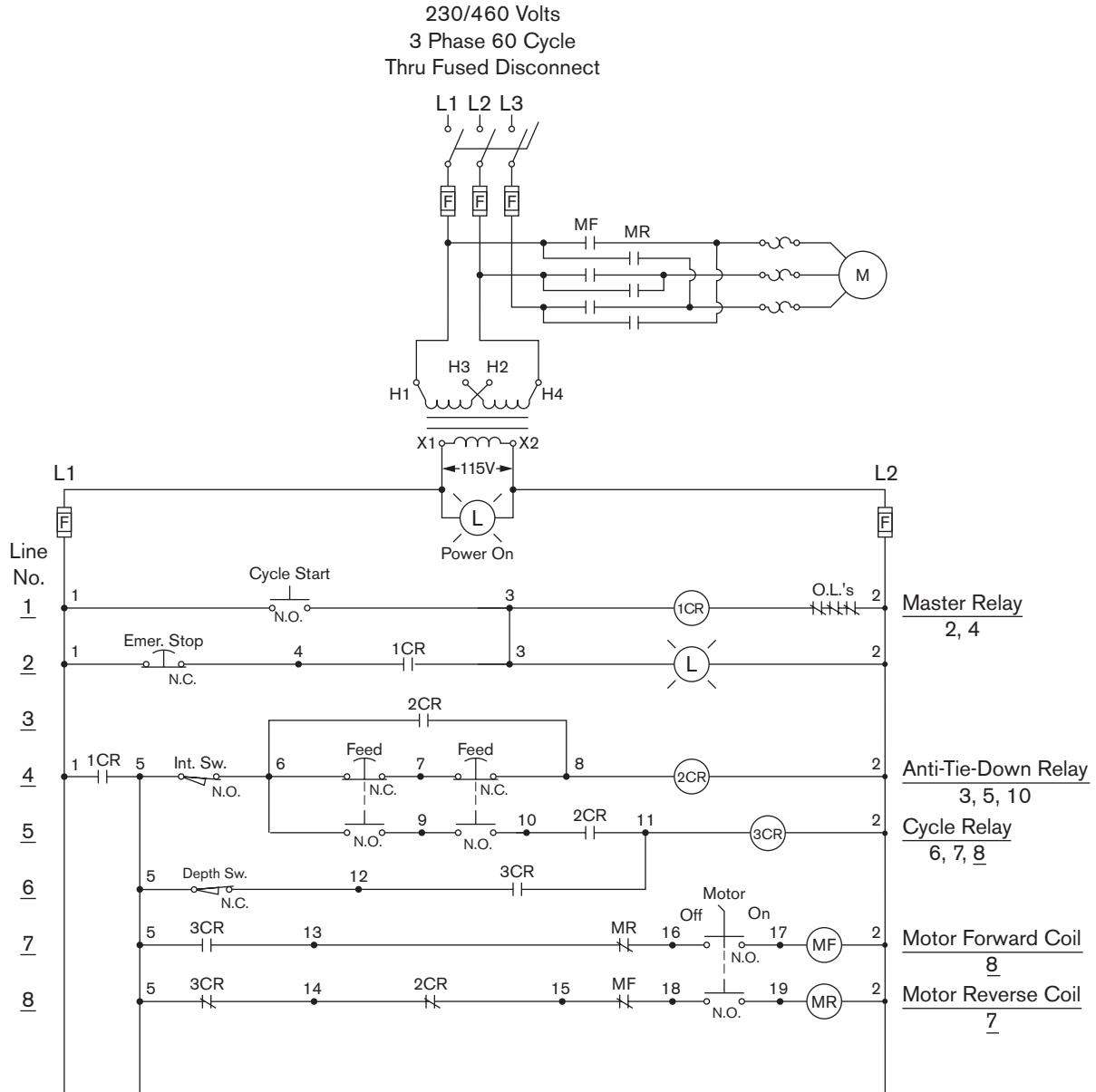
HYPNEUMAT INC.

AUTOMATIC DRILLING & TAPPING UNITS

LS-175 & MLS-175 PIPING FOR BASIC LEAD SCREW TAPPING CIRCUIT WITH ELECTRIC BRAKE MOTOR



**LS-175 & MLS-175
 BASIC LEAD SCREW TAPPING CIRCUIT
 WITH ELECTRIC BRAKE MOTOR**



IMPORTANT

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

**LS-175 & MLS-175
CYCLE SEQUENCE FOR LEAD SCREW TAPPING CIRCUIT
WITH ELECTRIC BRAKE MOTOR**

1. Push Cycle Start Button
 - a. Supplies power to Circuit (1CR)
2. Push Twin Palm Feed Buttons
 - a. Cycle relay (3CR) is energized and is held
3. Motor Forward Coil (MF) starts Motor in a clockwise rotation and unit feeds forward
4. Depth Switch is actuated
 - a. Cycle relay (3CR) is dropped out
 - b. Motor Forward Coil (MF) is dropped out
 - c. Motor Reverse Coil (MR) starts motor in a counterclockwise rotation
5. Unit returns to retract position and actuates Interlock Switch
 - a. Motor Reverse Coil (MR) is dropped out and unit stops

EMERGENCY STOP

1. Push Emergency Stop Button
 - a. Power to motor shuts off and unit stops
2. To return unit to retract position, push "Cycle Start" button.

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

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