PIPING FOR BASIC LOW PRESSURE AIR TAPPING CIRCUIT

- Interlock Switch
- Depth Switch
- Flow Control Valves with controlled flow out
- Feed Sol.
- Retract Sol.
- 4-way Double Solenoid Momentary Contact 2-position Air Valve (5-10 PSI Operation)
- Lubricator
- Regulator
- Filter
- Air In
- 5-10 PSI Air Pressure
230/460 Volts
3 Phase 60 Cycle
Thru Fused Disconnect

**IMPORTANT**

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

Note!
This System Used For Vertical
Operation With Heavy Multiple
Spindle Heads. Separate Pressures
For Feed And Retract Strokes.

- Depth Switch
- Interlock Switch
- Flow Control Valves With Controlled Flow Out
- 4-way, 5-port Air Valve
  Double Solenoid
  Momentary Contact
  Normal Exhaust ports
  Used As Inlet Ports.
  Not All 4-way Valves
  Can Be Piped In This Manner.
- Feed Sol.
- Retract Sol.
- Feed Regulator
- Retract Regulator
- Air In
- Filter
- Lubricator


Hypneumat Inc.
5900 West Franklin Drive
Franklin, WI 53132-9178
Phone: (414) 423-7400
Fax: (414) 423-7414