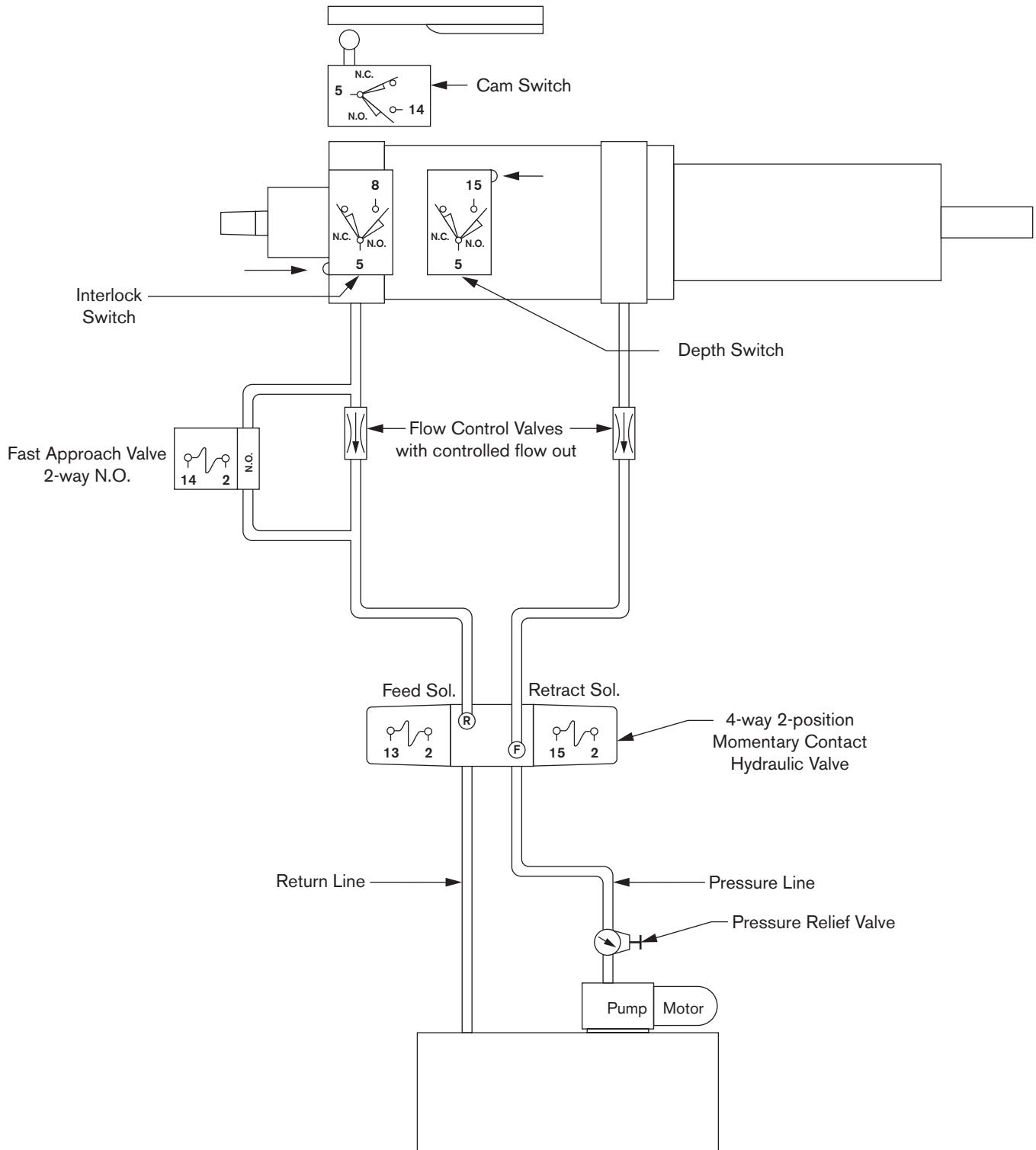


HYPNEUMAT INC.

AUTOMATIC DRILLING & TAPPING UNITS

PIPING FOR BASIC HYDRAULIC DRILLING CIRCUIT



CYCLE SEQUENCE FOR HYDRAULIC DRILL CIRCUIT

1. Turn Hydraulic Pump Selector Switch to “ON”
2. Turn Unit Motor Selector Switch to “ON”
3. Push Cycle Start Button
 - a. Supplies power to Circuit (1CR)
4. Push Twin Palm Feed Buttons
 - a. Valve shifts and unit feeds forward at rapid approach until Cam Switch is actuated
5. Cam Switch is actuated
 - a. 2-Way N.O. Valve is energized to a closed position
 - b. Feed rate is then controlled by flow control valve
6. Depth Switch is actuated at depth required
 - a. Valve shifts and unit rapid retracts

EMERGENCY STOP

1. Push Emergency Stop Button
 - a. 1CR Master Relay Drops Out
 - b. Hydraulic Pump shuts off
 - c. Unit Motor shuts off and coasts to stop
 - d. Valve shifts, but unit cannot retract
2. To return unit to retract position, “Cycle Start” Button must be pressed

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

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