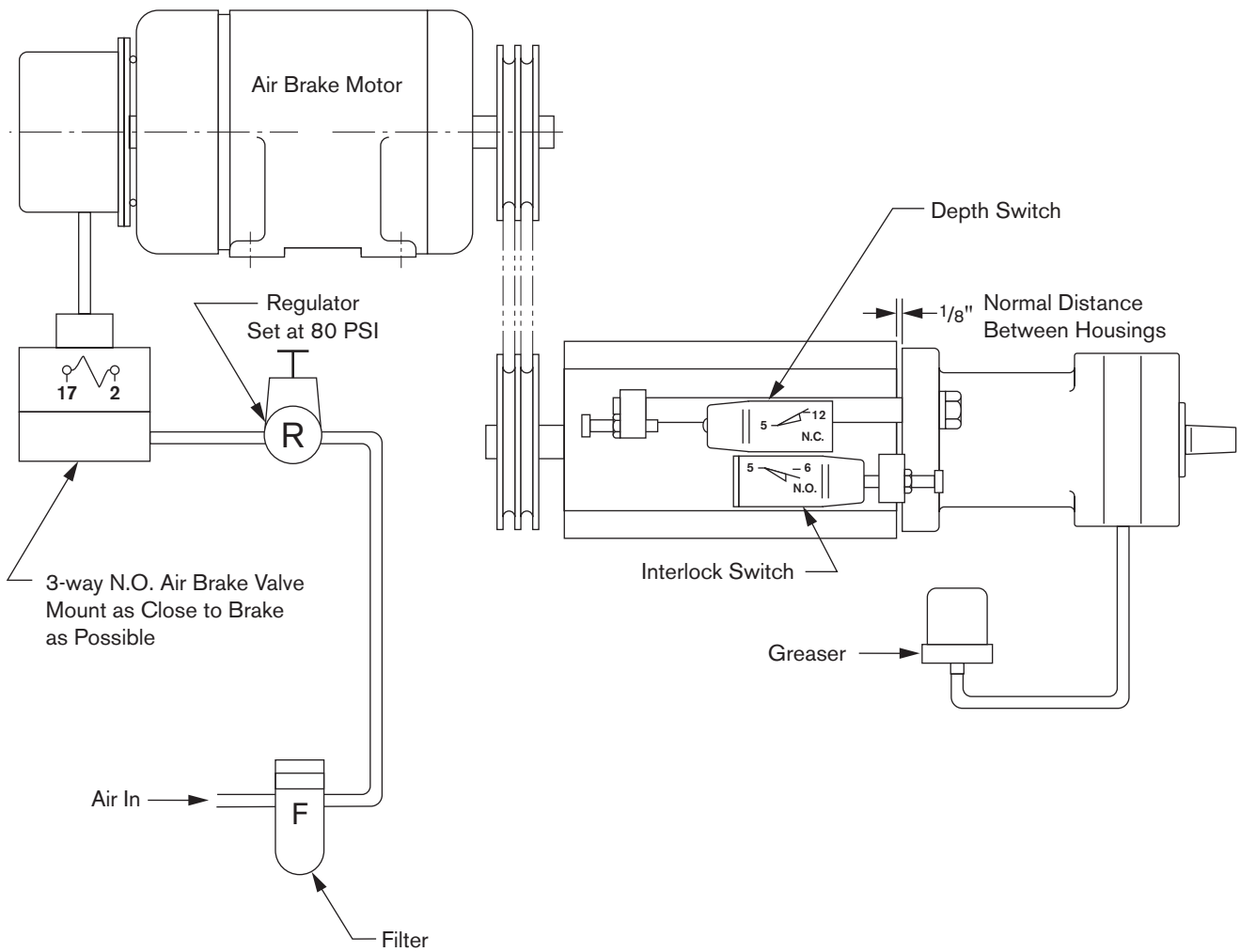
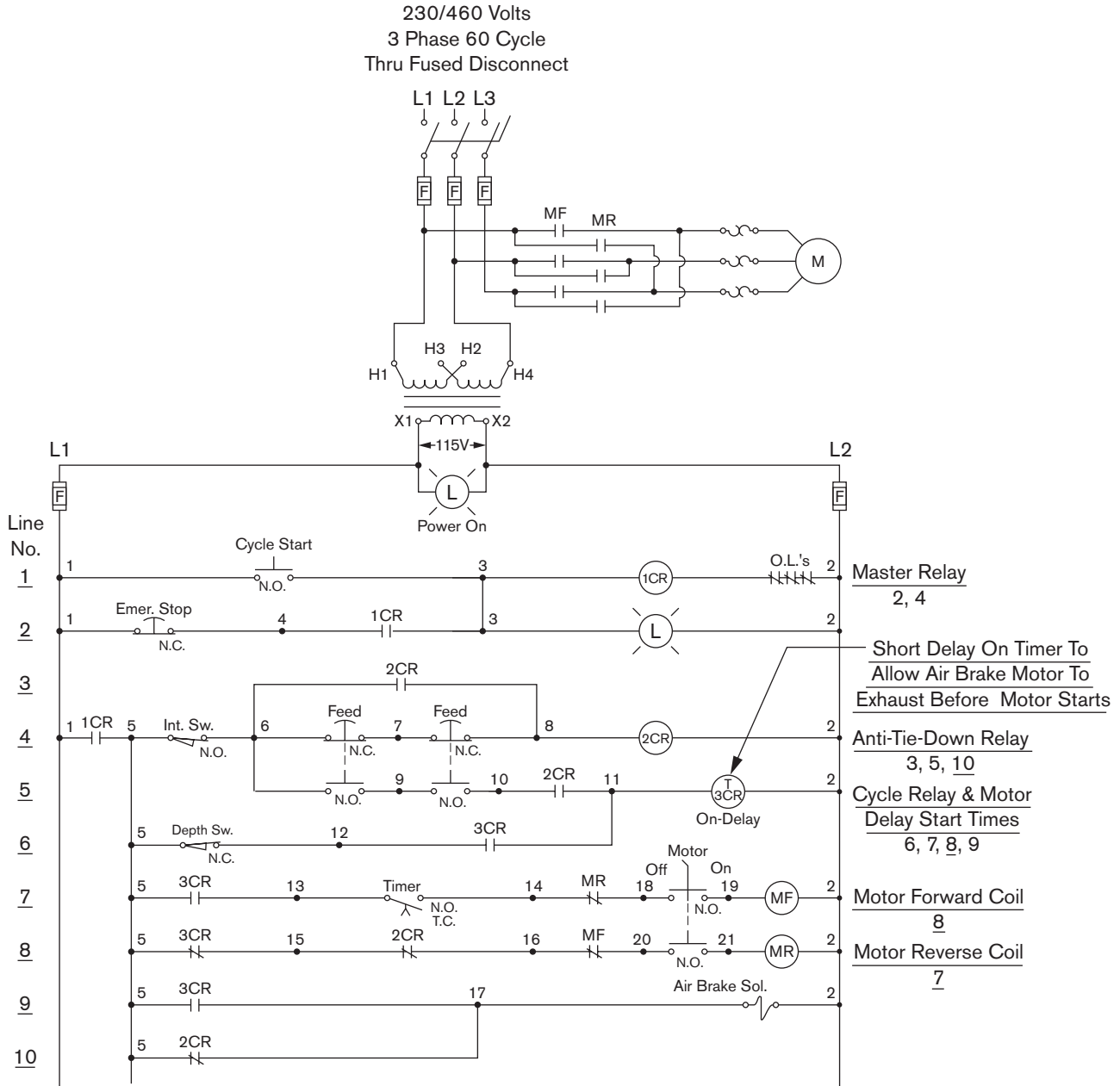


HYPNEUMAT INC.
AUTOMATIC DRILLING & TAPPING UNITS

LS-175
PIPING FOR BASIC LEAD SCREW TAPPING CIRCUIT
WITH AIR BRAKE MOTOR



**LS-175
 BASIC LEAD SCREW TAPPING CIRCUIT
 WITH AIR BRAKE MOTOR**



IMPORTANT

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

**CYCLE SEQUENCE FOR LEAD SCREW TAPPING CIRCUIT
WITH AIR 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
 - b. Motor delay start timer (T) is energized and begins timing out

NOTE: Time delay should be just long enough for Air Brake to exhaust

3. Motor delay start timer (T) times out
 - a. 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
 - b. Air Brake Valve is energized and unit stops

EMERGENCY STOP

1. Push Emergency Stop Button
 - a. Power to motor shuts off
 - b. Air Brake is actuated and Spindle rotation stops immediately
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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