

Service Bulletin

Machinery Affected: *Cyber*® A/T Saw
Document: SB184
Title: Adding a Start/Enable Button to the Carriage-
End Enclosure or Touch Screen Enclosure
Applies To: All *Cyber* A/T Saws Shipped Before
12 March 2008
Distribution: All Customers



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Date Created	28 March 2008
Created By	R. Widder
Reviewed By	R. Tucker
Approved By	G. McNeelege
Manuf. Eng.	G. Balke
Revision	A
Revision Date	1 July 2008
Revised By	R. Widder
Applicability	60000-530-xxxV
Effectivity	Machines shipped before 12 March 2008

Purpose and Scope

If an operator pushes an E-stop while the saw blades are in a collision position, the saw will immediately attempt to correct the blade position when the E-stop is reset.

Installing a Start/Enable button will prevent the saw from automatically moving. Before the saw will move, the operator must reset the E-stop and press the Start/Enable button.

Overview

The parts included in this kit are shown in Table 1. Please ensure all parts are present before starting this procedure.

Table 1: Parts in SB184KIT

Qty.	Part Description	Part #
1	Surge suppressor	509249
1	Pushbutton, illuminated, yellow	513494
1	Light, incandescent	513652
1	Contact block, NO	513649
8	Terminal blocks	518223
1	Nameplate holder	513676
1	Nameplate insert	513149
1	Terminal jumper bar, 10 poles	518143
1	Control relay, 3 NO/1NC	514197
1	Wire, 16 AWG, red, 30 ft	508006
1	Wire, 16 AWG, white, 12 ft	508006
1	Marker card kit	518831
1	Wire label	694060
1	Safety label for stationary-end enclosure	691539
1	Safety label for the Start/Enable button	691540

Before beginning the procedure, gather the supplies listed in Table 2.

Table 2: Customer-Supplied Items

Qty.	Item Description
1	Standard screwdriver set
1	Phillips screwdriver set
1	Wire strippers
1	Wire cutters
1	Thin-tipped permanent marker
1	Drill with metal cutting bits
1	7/8-in diameter knockout punch

Table 2: Customer-Supplied Items (Continued)

Qty.	Item Description
1	File
1	Tape measure
1	Grease pencil

Table 3 lists the drawings included at the end of this Service Bulletin.

Table 3: Drawings Included


Drawing Number	Description
90502-502	<i>Cyber A/T</i> carriage electrical panel, 230V
90504	<i>Cyber A/T</i> enclosure with swingarm
90507	<i>Cyber A/T</i> electrical schematic, 230V

If you have any questions, call MiTek Machinery Division Customer Service at 800-523-3380.

Procedure



Electrical Lockout/Tagout Procedures

WARNING	
	<p>ELECTROCUTION HAZARD!</p> <p>Verify that all power to the machine has been turned off and follow approved lockout/tagout safety procedures before performing any maintenance.</p> <p>All electrical work must be performed by a qualified electrician.</p> <p>If it is absolutely necessary to troubleshoot an energized machine, follow NFPA 70E for proper procedures and personal protective equipment.</p>

Before opening the main electrical enclosure, or attempting to repair or replace an electrical transmission line to the machine, lockout/tagout the machine properly. Follow your company’s approved lockout/tagout procedures which should include, but are not limited to the steps here.


1. Engage an E-stop on the machine.
2. Turn the machine’s disconnect switch to the “off” position. This is usually required to open the main electrical enclosure’s door. On the *Cyber A/T* Saw, the main disconnect switch is located on the machine’s stationary-end enclosure.


3. Shut the power to the machine off at the machine’s power source which is usually an electrical service entry panel on the facility wall. One example of a locked-out power source panel is shown in Figure 1.
4. Attach a lock and tag that meets OSHA requirements for lockout/tagout to the electrical service entry panel.
5. Open the door to the enclosure in which you need access, and using a multimeter, verify that the power is off.

Figure 1: Lockout/Tagout on the Power Source Panel



Pneumatic System Lockout/Tagout Procedure

WARNING	
	<p>MOVING PARTS CAN CRUSH AND CUT.</p> <p>Always verify that power to the machine has been turned off and follow approved lockout/tagout procedures.</p> <p>Turn off the air switch before performing any maintenance on the equipment.</p>

WARNING	
	<p>HIGH PRESSURE HAZARD.</p> <p>Bleed pneumatic before performing any maintenance on the pneumatic system.</p>

Installing the Start/Enable Button

The Start/Enable button can be installed on either the carriage-end electrical enclosure or the touch screen enclosure. Instructions for both locations are included.

Installing the Start/Enable Button on the Carriage-End Electrical Enclosure

1. Mark the location of the cutout for the new button on the left side of the carriage-end electrical enclosure. See Drawing 90502 and Figure 2.
2. Cover all electrical components near the marked location with a clean cloth to protect them from metal shavings and debris.
3. From the inside of the enclosure, drilling toward the outside, drill and use a knockout punch to create a 7/8-in diameter hole.
4. Remove any burrs using the file. Make sure the edge are smooth.
5. Insert the Start/Enable pushbutton into the hole from the inside of the enclosure, with the button facing outward.
6. Put the nameplate insert into the nameplate holder. Attach the nameplate holder for the Start/Enable pushbutton to the button.
7. Secure the button and nameplate in place by screwing the retaining ring onto the button.
8. Screw the light bulb into the NO contact block, and snap the contact block onto the back of the pushbutton.

Figure 2: Button Location



Installing the Start/Enable Button on the Touch Screen Enclosure

1. Mark the location of the cutout for the new button on the front of the touch screen enclosure. See Drawing 90504.
2. Cover all electrical components near the marked location with a clean cloth to protect them from metal shavings and debris.
3. From the outside of the enclosure, drilling toward the inside, drill and use a knockout punch to create a 7/8-in diameter hole.

4. Remove any burrs using the file. Make sure the edge are smooth.
5. Insert the Start Enable pushbutton into the hole from the inside of the enclosure, with the button facing outward.
6. Put the nameplate insert into the nameplate holder. Attach the nameplate holder for the Start/Enable pushbutton to the button.
7. Secure the button and nameplate in place by screwing the retaining ring onto the button.
8. Screw the light bulb into the NO contact block, and snap the contact block onto the back of the pushbutton.

Wiring the Stop/Enable Button

Adding Terminal Blocks and Relay CR-3

Add terminal blocks to the din rail in the carriage-end electrical enclosure. Complete this procedure regardless of where the button is located.

1. Snap the new terminal blocks into the din rail at the appropriate locations. The terminal blocks should be added in sequential order. The blocks should be labeled 9SA (2), 9SB, 9SC, and 1TA.
2. Using the marker card kit and a permanent marker, label the new terminal blocks according to Drawing 90502-502.
3. Cut two (2) jumpers off the jumper bar and insert them into the 9SA terminal blocks.

Add relay CR-3 to the din rail in the carriage-end electrical enclosure.

1. Snap the new relay into the din rail at the appropriate location. Refer to Drawing 90502-502.
2. Using a permanent marker, label the new relay CR-3.

Wiring Relay CR-3

Complete this procedure regardless of where the button is located. Refer to Drawing 90507 throughout this process.

In the carriage-end electrical enclosure:

1. Mount the surge suppressor on top of relay CR-3 between A1 and A2.

2. Wire 9S and 9SA.



The wire on terminal 13 of CR-2 should be wire 2T. If the wire on terminal 13 of CR-2 is not wire 2T but is wire 8S, switch the connection of wire 8S with wire 2T. If you move wire 8S, you must also move wire 9S to terminal 44 of CR-2. Wires 8S and 9S must be across from each other.

- a) Locate wire 9S that runs from CR-2 terminal 44 to the 9S terminal block.
 - 1) Remove the end of the wire from CR-2 terminal 44.
 - 2) Attach the wire to CR-3 terminal 13. The wire should now run from 9S to CR-3 terminal 13.
- b) Add a new red wire from CR-2 terminal 44 to terminal 9SA. Label the wire 9SA.
- c) Add a new red wire from 9SA to CR-3 terminal 14. Label the wire 9SA.

3. Wire 1T and 1TA.

- a) Locate wire 1T that runs from CR-2 terminal 14 to the 1T terminal block.
 - 1) Remove the end of the wire that runs from CR-2 terminal 14.
 - 2) Attach the wire to CR-3 terminal 33. The wire should now run from 1T to CR-3 terminal 33.
 - b) Add a new red wire from CR-2 terminal 14 to 1TA. Label the wire 1TA.
 - c) Add a new red wire from 1TA to CR-3 terminal 33. Label the wire 1TA.
4. Add a new red wire from the 9SA terminal block to CR-3 terminal 43. Label the wire 9SA.
 5. Add a new red wire from CR-3 terminal 44 to 9SB. Label the wire 9SB.
 6. Add a new red wire from CR-3 terminal 44 to CR-3 A1. Label the wire 9SB.
 7. Add a new red wire from CR-3 terminal 43 to CR-3 terminal 21. Label the wire 9SA.
 8. Add a red wire from CR-3 terminal 22 to the 9SC terminal. Label the wire 9SC.
 9. Add a white wire from CR-3 terminal A2 to X2.

Connecting Wiring to a Button Installed on the Carriage-End Enclosure

1. Add and connect a new red wire labeled 9SA between terminal 9SA and button terminal 3.
2. Add and connect a new red wire labeled 9SB between terminal 9SB and button terminal 4.
3. Add and connect a new red wire labeled 9SC between terminal 9SC and button terminal X1 on the light.
4. Add a new white wire from terminal X2 to the light terminal X2.

Connecting Wiring to a Button Installed on the Touch Screen Enclosure

If you have chosen to install the Start/Enable Button on the touch screen enclosure, you must run the wires through the swingarm into the carriage-end electrical enclosure.

1. Snap the contact block into the din rail at the appropriate location.
2. Run wires 9SA, 9SB, and 9SC from the touch screen enclosure through the swingarm into the carriage-end electrical enclosure.
3. Connect the red wire labeled 9SA to terminal 9SA in the carriage-end enclosure to terminal 3 of the switch.
4. Connect the red wire labeled 9SB to terminal 9SB in the carriage-end enclosure to terminal 4 of the switch.
5. Connect the red wire labeled 9SC to terminal 9SC in the carriage-end enclosure and light X1 in the touch screen enclosure.
6. In the touch screen enclosure, add a new white wire from terminal X2 to the light terminal X2.

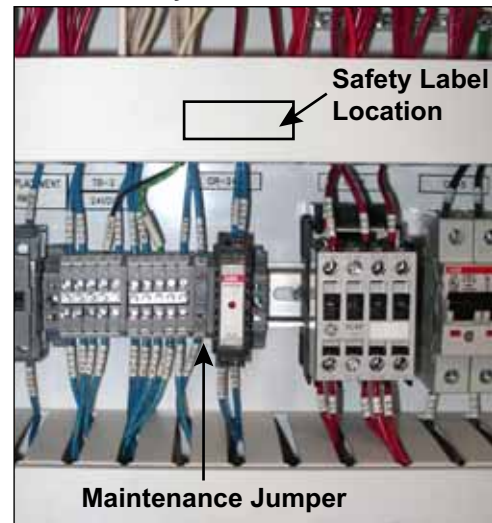
Adding Safety Labels

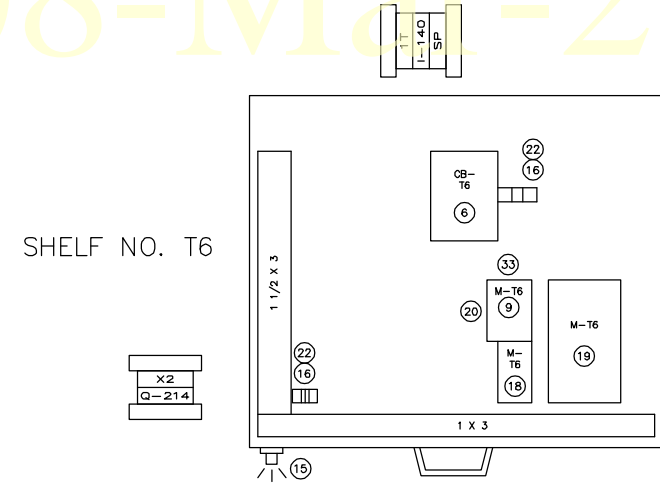
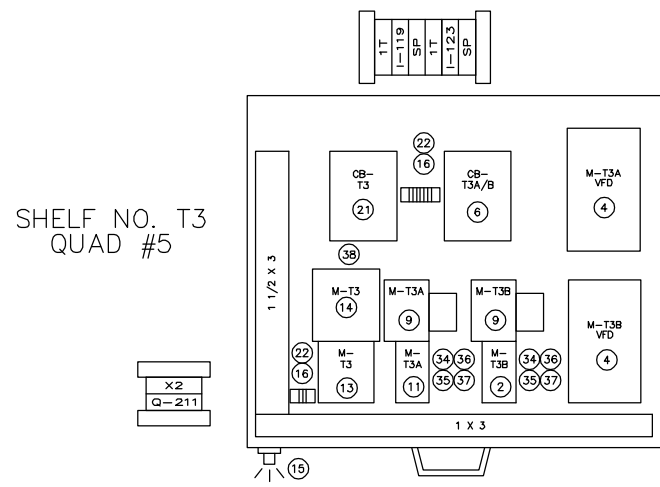
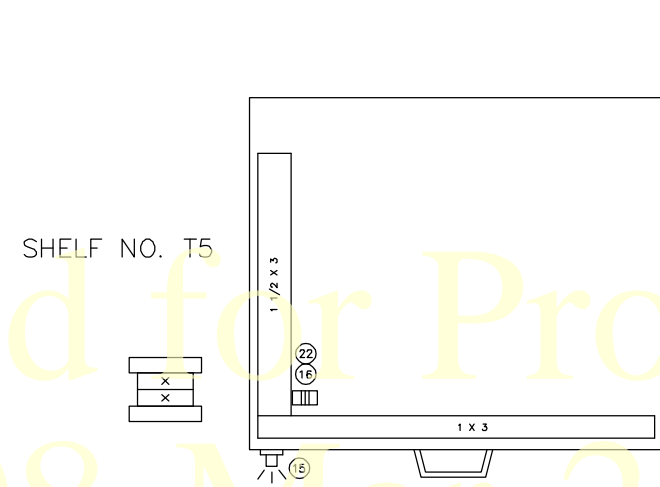
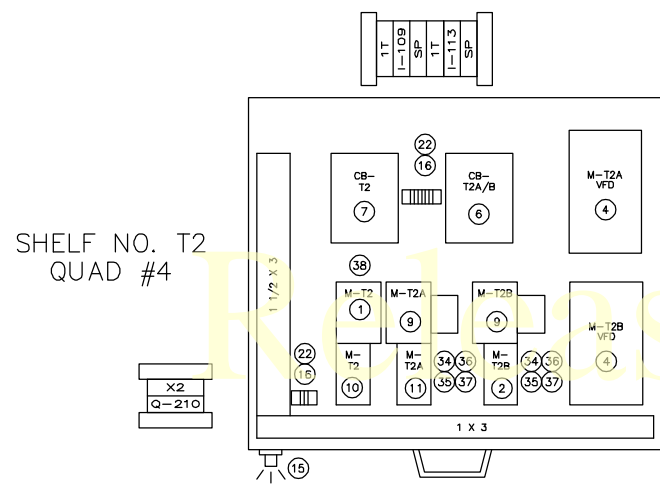
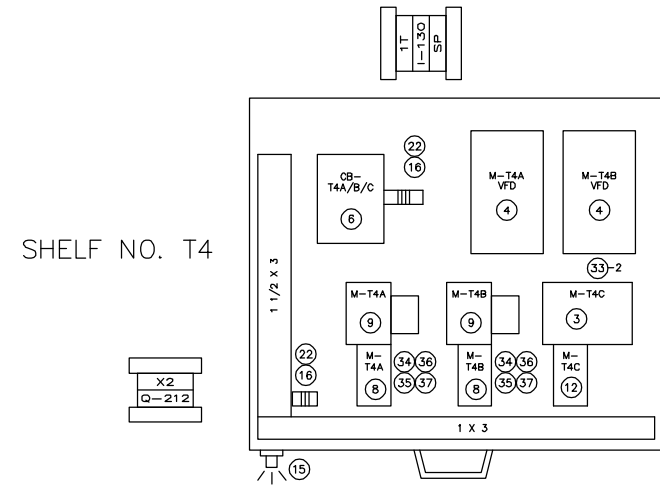
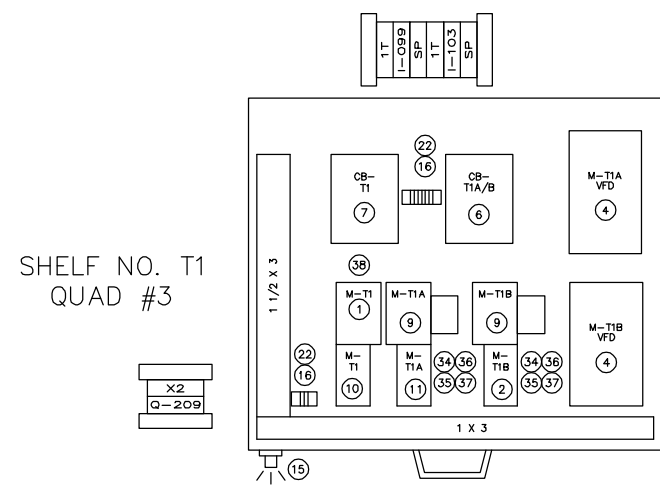
After installing the Start/Enable Button, add a safety label (PN 691539) above the maintenance jumper in the stationary-end electrical enclosure. Place the label as indicated in Figure 3.

Add the other safety label (PN 691540) to the right of the Start/Enable pushbutton.

END OF SERVICE BULLETIN

Figure 3: Safety Label Location on the Stationary-End Enclosure





ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
38	3 EA	SUPPRESSOR,SURGE	AB #100-FSC280		X P	504271
37	8 EA	RETAIN,RELAY	ABB #440565910		X P	514133
36	8 EA	DIODE,MODULE	ABB #240565210		X P	514132
35	8 EA	SOCKET,RELAY	ABB #240565130		X P	514131
34	8 EA	RELAY,24VDC,SPDT	ABB #240561310		X P	514130
33	3 EA	SURGE,SUPR,VARISTOR,50-127V	GE #BSLV3K	SEE PG 1.52	P	509249
32	6 EA	LATCH,DRAWER	MWA #DAMIT		X P	511747
31	6 EA	SLAM,ACTION,STRIKE,DRAWER	MWA #AH561P6		X P	511746
30						
29	6 EA	SLIDE,DRAWER	GRANT #8400B16		X P	511745
28	6 EA	HANDLE,DRAWER	MWA #AE7-10669		X P	511744
27	9 FT	DUCT,COVER,PVC,1"	PANDUIT #C1LG6		X P	510151
26	9 FT	DUCT,WIRE,PVC,1X3"	PANDUIT #E1X3LG6		X P	510141
25	9 FT	DUCT,COVER,PVC,1.5"	PANDUIT #C1.5LG6	SEE PG 1.43	P	510153
24	9 FT	DUCT,WIRE,PVC,1.5X3"	PANDUIT #E1.5X3LG6		X P	511743
23	8.5 FT	RAIL,DIN,FLAT	IDEC #BNDN-1000	SEE PG 1.39	P	146122
22	22 EA	END,STOP	ENTR #199408.02	SEE PG 1.33	P	518192
21	1 EA	BRKR,60A,3P	ABB #T1N060TLA		X P	516419
20	1 EA	CNTCT,BLK,NO,FRONT-MTD	GE #BCLF10		X P	513823
19	1 EA	VFD,2HP,230VAC,7.0A,	AF-300,MINI,(GE)		X P	509764
18	1 EA	OVERLOAD,5.5-8.5A,AUTO/MAN	GE #RT1M		X P	514152
17						
16	36 EA	TERM,BLCK,FLD-FLD	ENTRELEC #115116.07	SEE PG 1.2	P	518223
15	6 EA	PILOT,LIGHT,AMBER,NEON	IND-DEV #IDI1030D3		X P	513488
14	1 EA	CONTACTOR,43A,1NO	AB #100-C43D10		X P	509221
13	1 EA	OVERLOAD,30A-45A	AB #193-TBC45		X P	513007
12	1 EA	OVERLOAD,.65-1.1A,AUTO/MAN	GE #RT1F		X P	509316
11	3 EA	OVERLOAD,1.8-2.7A,AUTO/MAN	GE #RT1J		X P	514146
10	2 EA	OVERLOAD,16A-24A	AB #193-TAC24		X P	513006
9	9 EA	MTR,STARTR,17.5A,3P,NONRE	GE #CL02A310TJ		X P	509215
8	2 EA	OVERLOAD,1.0-1.5A,AUTO/MAN	GE #RT1G		X P	514142
7	2 EA	BRKR,30A,3P	ABB #T1N030TLA		X P	516420
6	5 EA	BRKR,15A,3P	ABB #T1N015TLA		X P	516409
5	10 EA	COVER,CONTACTOR,CL02,W/1N.O.	GE #CTPCL0210		X P	511586
4	8 EA	VFD,1HP,230VAC,7.0A,	AF-300,MINI,(GE)		X P	509765
3	1 EA	MTR,STARTR,17.5A,3-P,REV	GE #LAR02AJ		X P	509214
2	3 EA	OVERLOAD,1.3-1.9A,AUTO/MAN	GE #RT1H		X P	514144
1	2 EA	CNTCTR,30A,120V,1NO	AB #100-C30D10		X P	477070

Released for Production
08-Mar-28

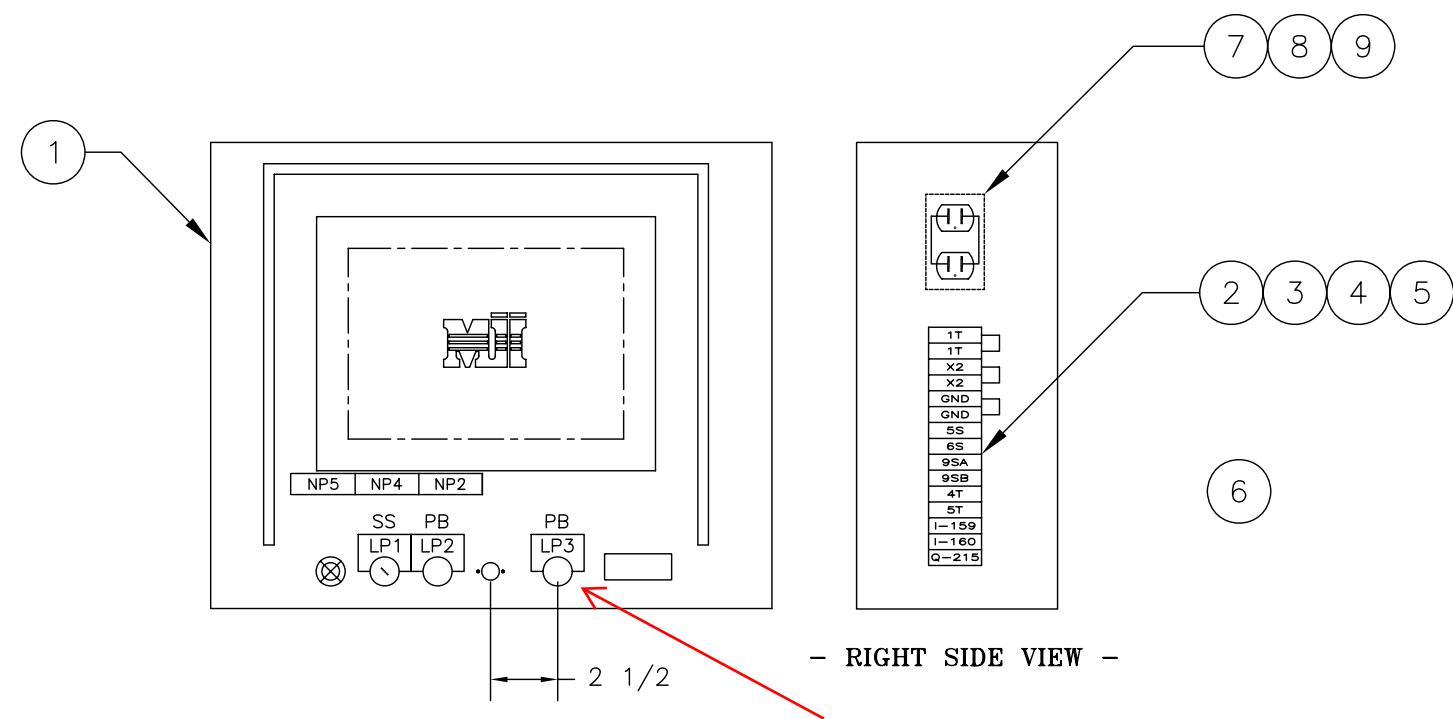
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FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°]
TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [25°]

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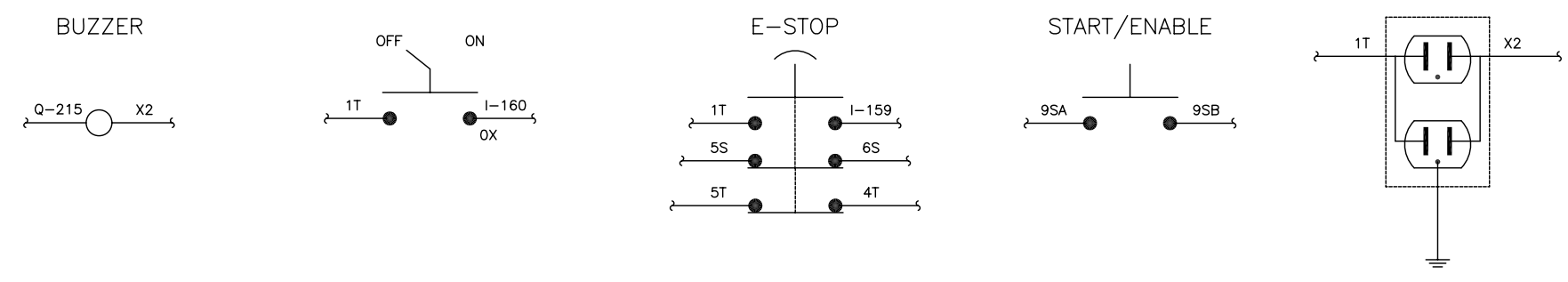
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CHECKED	DATE	DRAWN	DATE	FINISH PAINT	SCALE
				X	NONE
PAGE 2 of 2				DASH NO. B90502-502	
REV. K					

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS

REV.	DATE	DESCRIPTION	BY	CHK'D	APP'D	DATE
-	11/28/01	INITIAL RELEASE	D.KIM			
A	6/27/03	NEW SWINGARM, SEE ECDN 5142	IL			
B	8/14/03	NEW TOUCHSCREEN, SEE ECDN 5147	IL			
C	8/23/04	SEE ECDR #5195, REMOVED FLOPPY DRIVE HOUSING	GI			
D	3/7/08	ADDED "START/ENABLE" PUSH BUTTON SEE ECD #8613	DKM			



Recommended location for the "Start/Enable PB"



- WIRING QUICK VIEW -

NAME PLATE SCHEDULE	
NAME PLATE	DESCRIPTION
NP1	MAINTENANCE LIGHTING
NP2	EMERGENCY STOP
NP3	CARRIAGE IN MOVEMENT
NP4	CALIBRATION
NP5	BOARD COUNT
LP1	OFF - ON
LP2	EMERGENCY STOP
LP3	START/ENABLE

NAMEPLATES - BLACK WITH WHITE CORE

ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
20	1 EA	SAFETY WARNING LABEL			X P	691540
19	1 EA	NAMEPLATE, HOLDER	GE #P9ARTBS		X P	513676
18	1 EA	NAMEPLATE, "START/ENABLE"	GE #P9ARTBSEN		X P	513149
17	1 EA	CNTCT, BLK, 1NO	GE #P9B10VN		X P	513649
16	1 EA	LIGHT, AC	GE #P9PTNWJ		X P	513652
15	1 EA	PB, ILLUMINATED, FLUSH, YEL	GE #P9CPLGGD		X P	513494
14	3 EA	CNTCT, BLK, 1NO/1NC	GE #P9B11VN		X P	513651
13	1 EA	OPER, SS, 2-POS, KEY	GE #P9CSCDOK95		X P	513660
12	1 EA	NAMEPLATE, E-STOP, RD, YEL	GE #080XTGRN2		X P	513829
11	1 EA	OPER, PB, MSHRM-HD, RED	GE #P9CET4RN1		X P	513656
10	1 EA	SONALERT	GE #P9XBM		X P	513655
9	1 EA	COVER, BOX	STELLCITY #58C7		X P	519205
8	1 EA	RECEPTACLE	LEVITON #5320		X P	511592
7	1 EA	BOX, 2X4	STELLCITY #583715		X P	519101
6	1 EA	UPS, 500VA, w/RS-232 PORT	PULSAR #ELSP500		X P	509111
5	1 FT	RAIL, DIN, FLAT	ENTRELEC #BNDN-1000		X P	146122
4	1 EA	TERM, JUMPER, BAR, 10-POLE	ENTRELEC #168.973.07		X P	518143
3	2 EA	END, STOP	ENTRELEC #199408.02		X P	518192
2	15 EA	TERM, BLK, FLD-FLD	ENTRELEC #115116.07		X P	518223
1	1 EA	SWINGARM, ENCLOSURE, ASSY	SEE DWG		X M	60184-501

DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED:
 FRACTIONS ± [1/32] DECIMALS ± [0.10] ANGLES ± [1°]
 TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [29°]

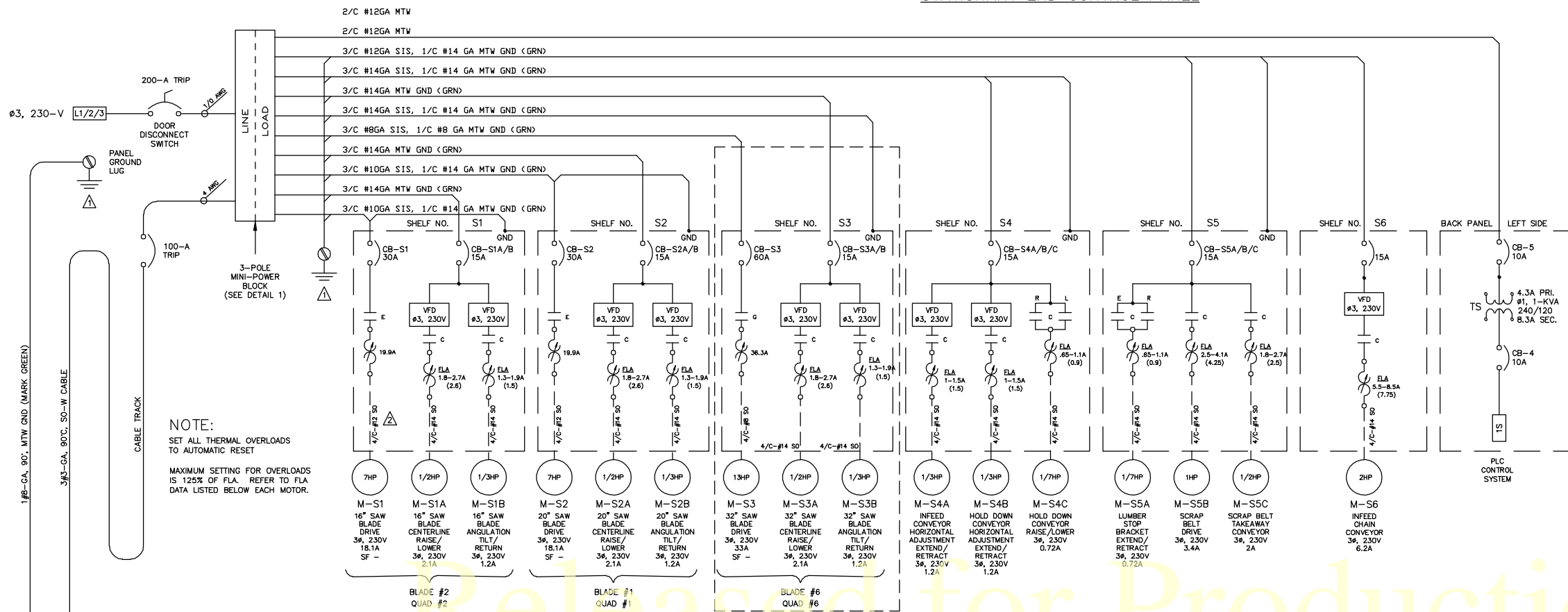
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KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	

APPROVED		DATE	MFG.	CYBER, AT, TM, ENCL, ASSY, W/SWINGARM	
CHECKED	DATE	DRAWN	DATE	FINISH PAINT	SCALE
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PAGE 1 OF 1			B90504		DASH NO. REV. 501 D

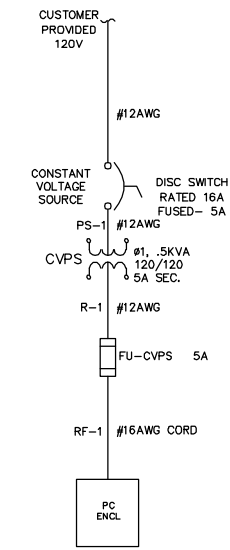
MiTek Industries, Inc.
 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045

STATIONARY END CONTROL PANEL

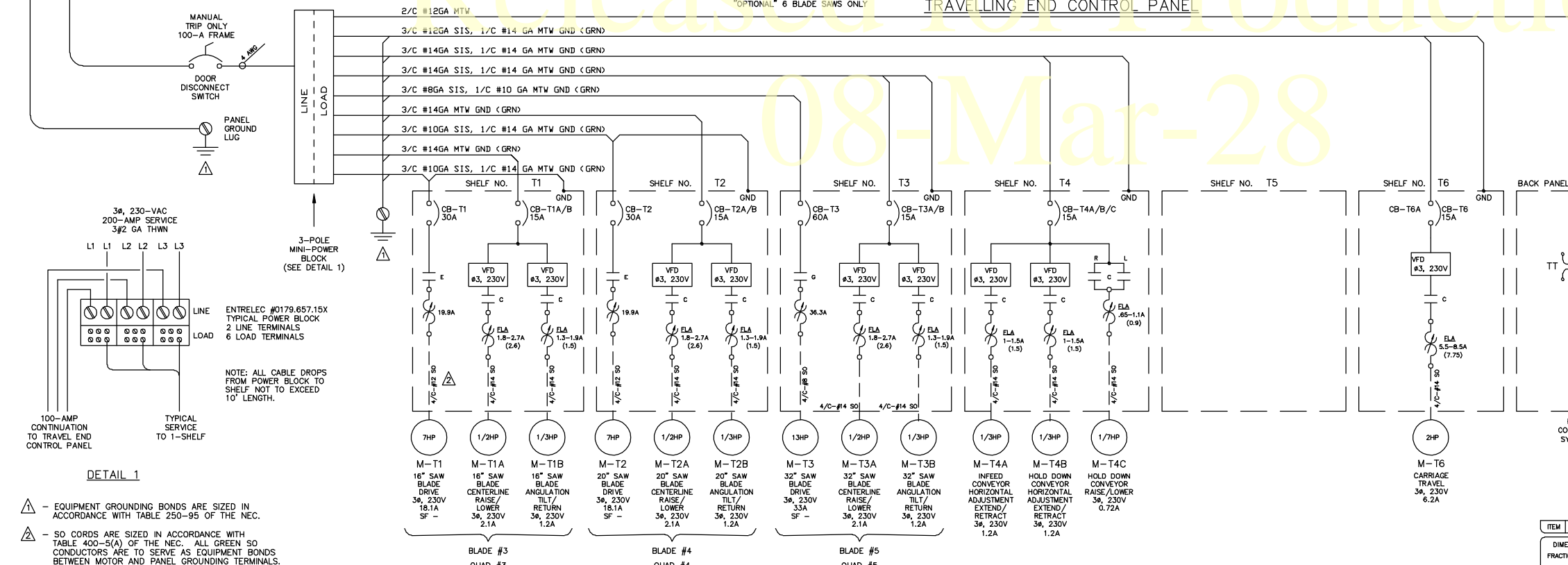


NOTE:
SET ALL THERMAL OVERLOADS TO AUTOMATIC RESET
MAXIMUM SETTING FOR OVERLOADS IS 125% OF FLA. REFER TO FLA DATA LISTED BELOW EACH MOTOR.

REV.	DATE	DESCRIPTION	BY	CHK'D	APP'D	DATE
-	06/13/01	INITIAL RELEASE	DJM			
A	11/27/01	SEE ECD 3247-3	DJM			
B	1/8/02	SEE ECD 5008	DJM			
C	3/28/02	SEE ECD 5017	DJM			
D	4/9/03	SEE ECD 5119	IL			
E	8/14/03	SEE ECD 5147	IL			
F	2/4/04	CHANGED TEXT FOR JUMPER	GI			
G	6/01/04	CHANGED BRAKE RELAY	DJM			
H	7/07/04	SEE ECD #5186	DJM			
I	8/23/04	CPU CHANGE, ADDED IWC	GI			
J	1/28/05	CHANGE OVERLOAD SETTING	DJM			
K	6/07/05	CHANGE 2HP VFD SETTING	BB			
L	6/7/06	SWITCHED ENCODERS SEE ECO 6089	LN			
M	6/7/06	CHANGING TERMINALS, SEE ECO 6508	LN			
N	11/08/07	MOVED PARAMETERS SEE ECO 6563	GB			
O	3/6/08	ADDED "START ENABLE" PB CIRCUIT. SEE ECO #6613	DK			



TRAVELLING END CONTROL PANEL



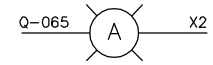
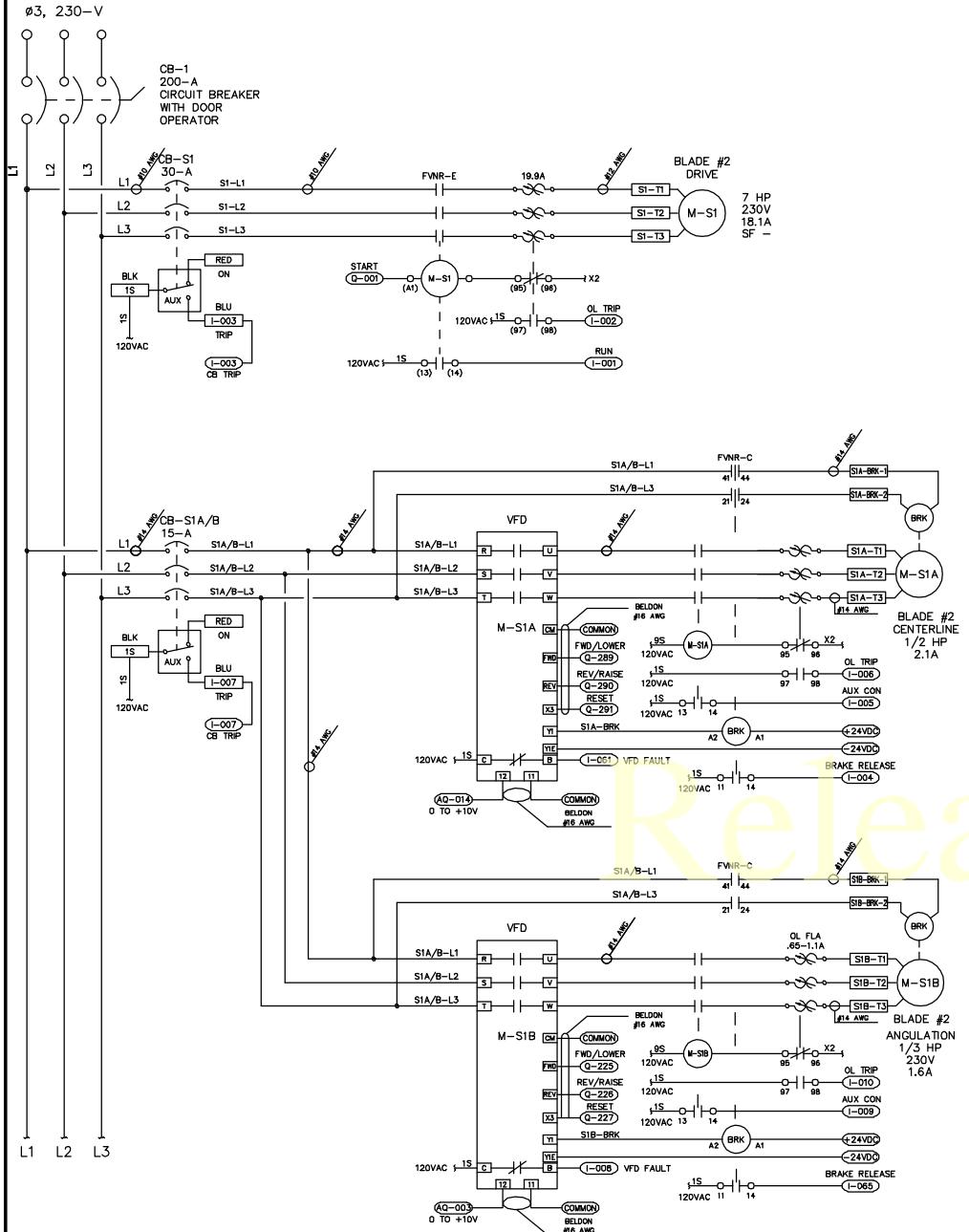
NOTE: ALL CABLE DROPS FROM POWER BLOCK TO SHELF NOT TO EXCEED 10' LENGTH.

DETAIL 1

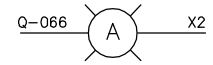
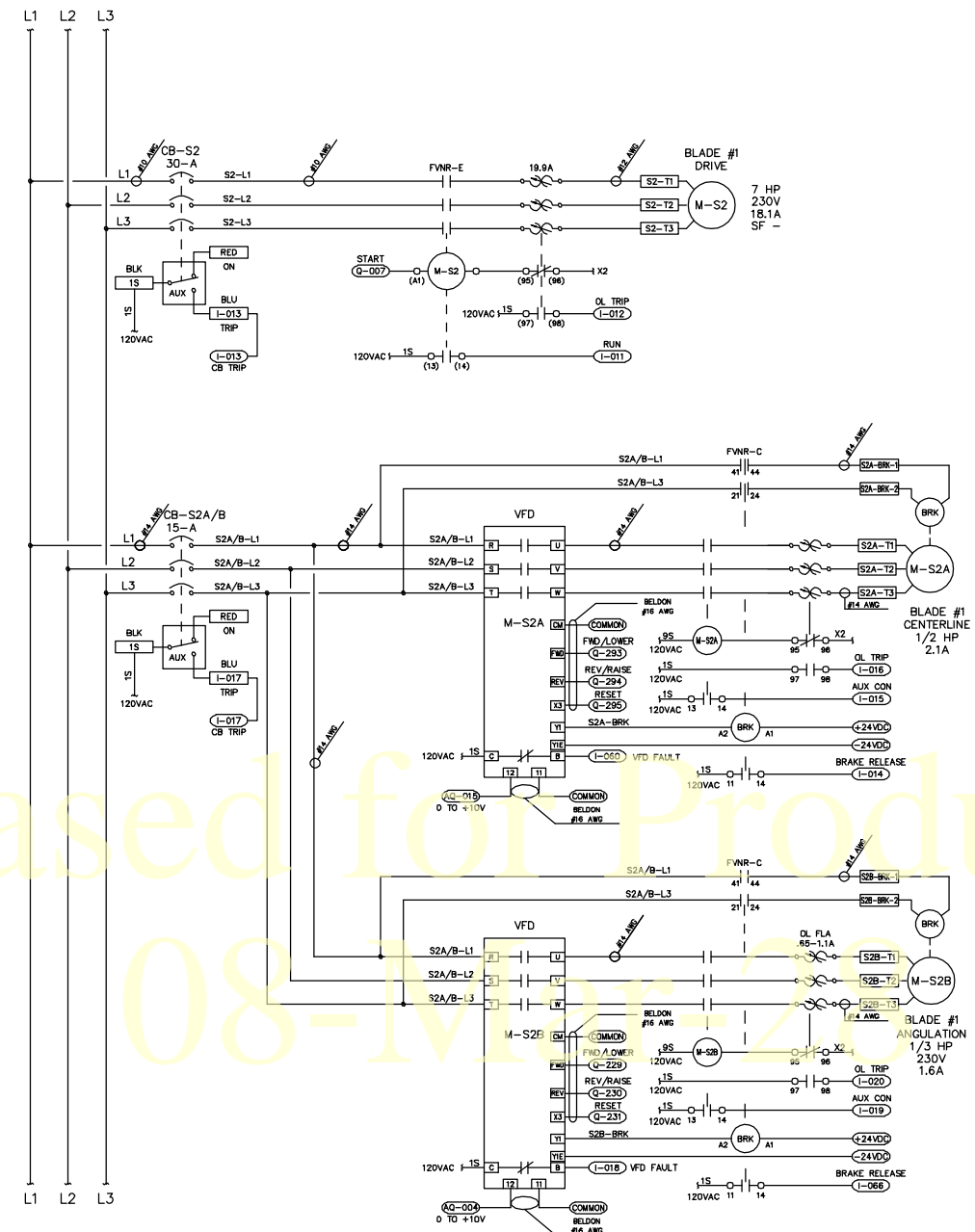
- EQUIPMENT GROUNDING BONDS ARE SIZED IN ACCORDANCE WITH TABLE 250-95 OF THE NEC.
- SO CORDS ARE SIZED IN ACCORDANCE WITH TABLE 400-5(A) OF THE NEC. ALL GREEN SO CONDUCTORS ARE TO SERVE AS EQUIPMENT BONDS BETWEEN MOTOR AND PANEL GROUNDING TERMINALS.

ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°]						
TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED []						
FEATURES: X						
APPROVED: VDC DATE: DATE DRAWN: G.Bowers DATE: 10/30/00 FINISH PAINT: X SCALE: NONE PAGE: 1 of 21						
MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045						
CYBER, AT, ELE, SCHEM, 230V, US						
90507 DASH NO. REV. 0						

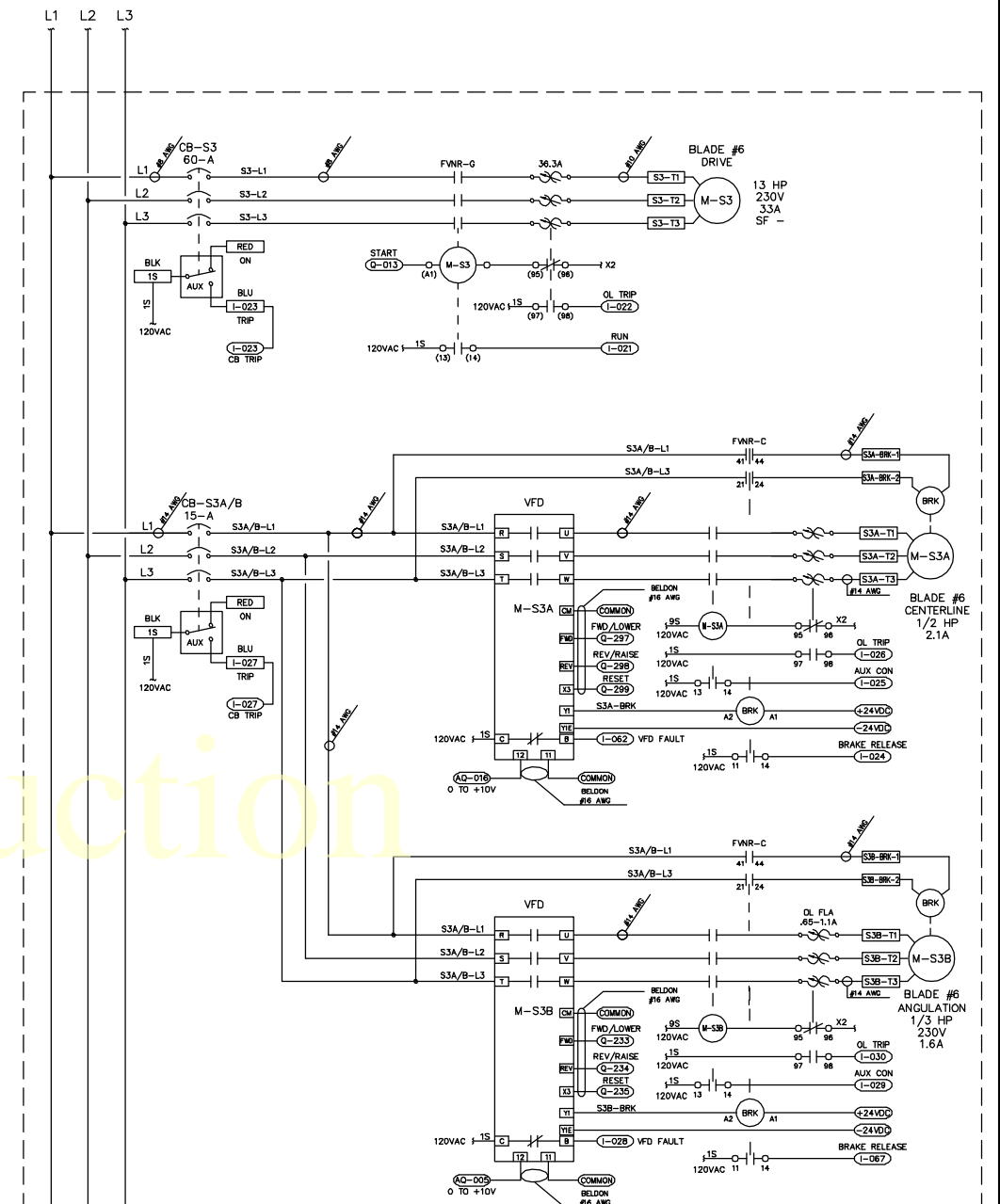
KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS



SHELF NO. S1
QUAD NO. 2



SHELF NO. S2
QUAD NO. 1



"OPTIONAL" 6 BLADE SAWS ONLY

SHELF NO. S3
QUAD NO. 6

(CONTINUED ON Pg.3)

AUXILIARY CONTACT
DETAIL

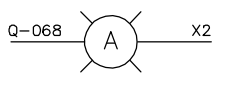
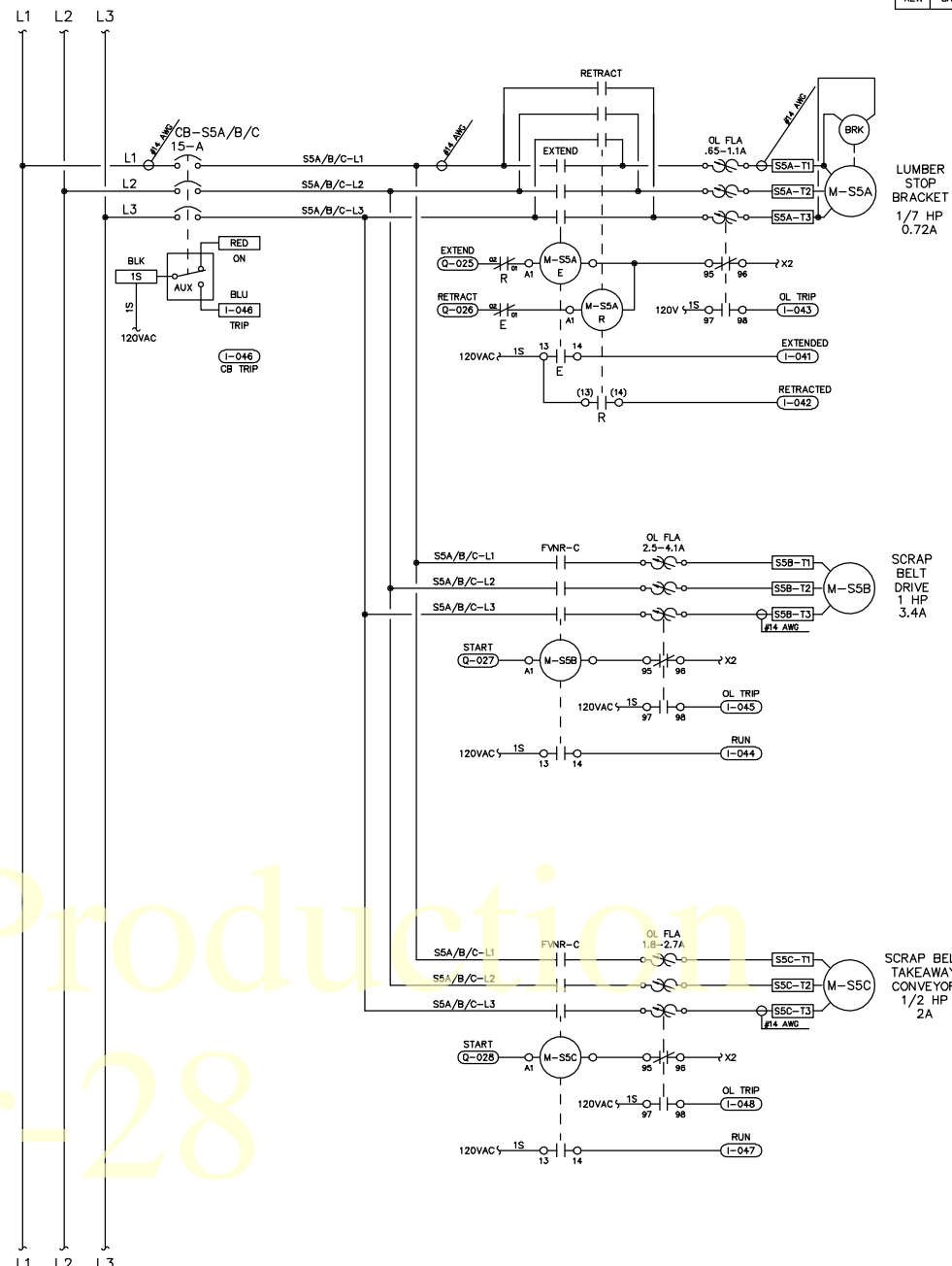
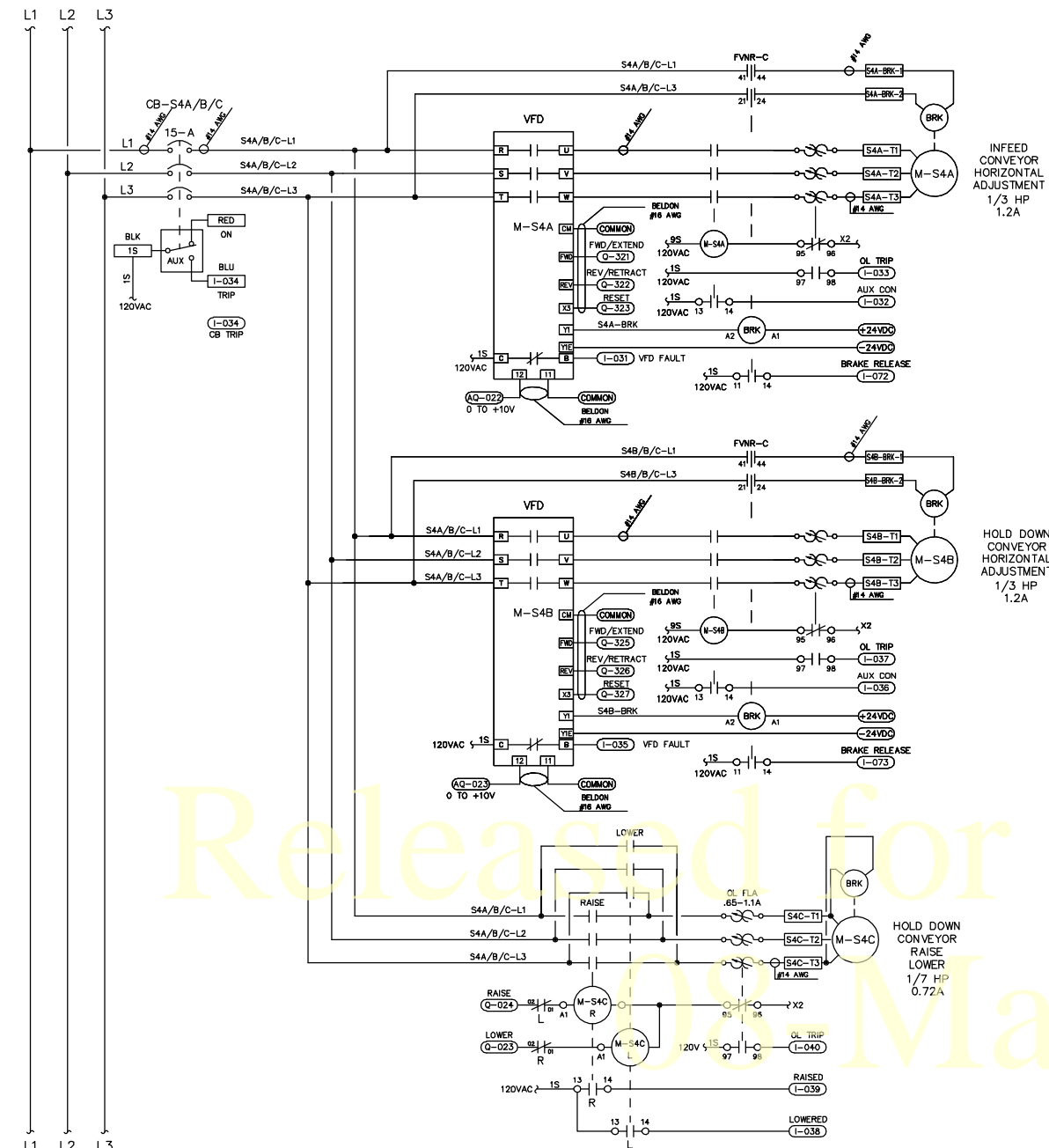
STATIONARY END CONTROL PANEL

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	

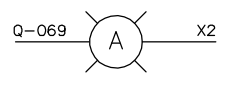
ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1]						
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MITEX INDUSTRIES, INC. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			MANUFACTURED BY: X DRAWN BY: X CHECKED BY: X DATE: X			
APPROVED: VDC DATE:		MFG. G.Bowers DATE: 10/30/00		FINISH PAINT: X SCALE: NONE		PAGE: 2 of 21 DASH NO.: 90507 REV.: 0

(CONT. FROM Pg.2)

REV.	DATE	DESCRIPTION	BY	CHK'D	APP'D	DATE



SHELF NO. 4S



SHELF NO. 5S

STATIONARY END CONTROL PANEL

AUXILIARY CONTACT DETAIL



ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.

DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED:
 FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°]
 TOTAL RUNOUT ± [0.004] MACHINED SURFACES NOT SPECIFIED [250]

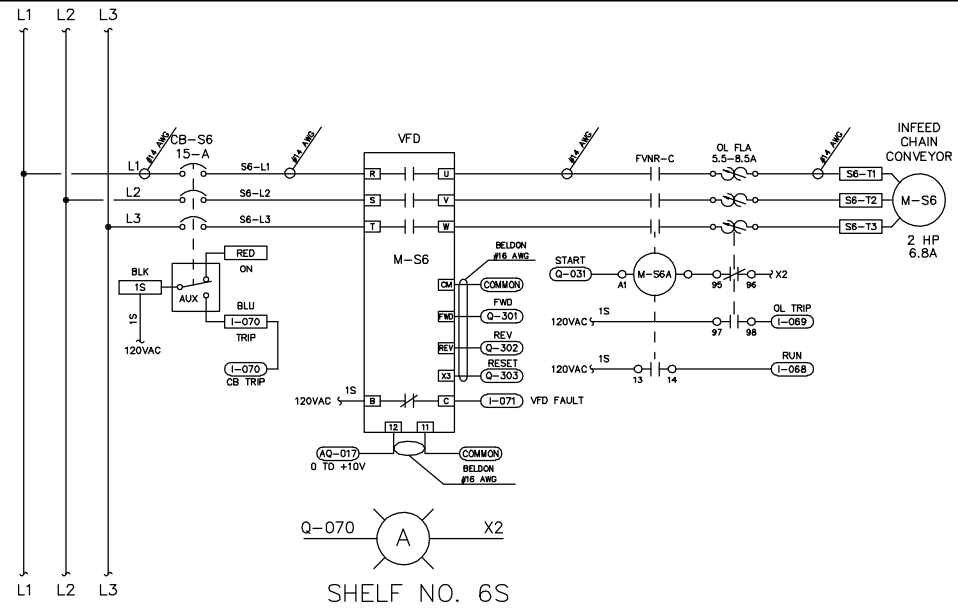
APPROVED: [Signature] DATE: [Date] MFG. [Mfg. Name]
 CHECKED: VDC DATE: [Date] DRAWN: G.Bowers DATE: [Date] FINISH PAINT: [Finish Paint] SCALE: NONE PAGE: 3 of 21

DATE: 10/30/00 FINISH PAINT: X SCALE: NONE PAGE: 3 of 21 90507 DASH NO. REV. 0

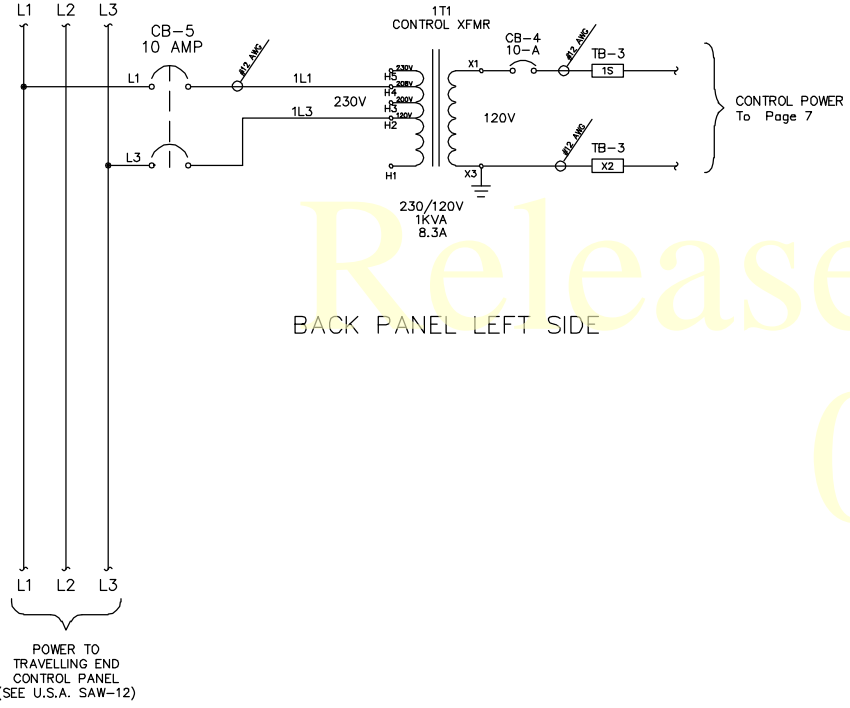
KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	

MiTek Industries, Inc.
 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045

CYBER, AT, ELE, SCHEM, 230V, US

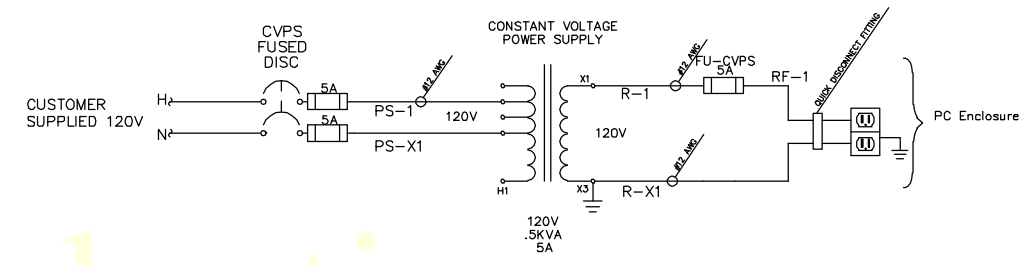


SHELF NO. 6S



BACK PANEL LEFT SIDE

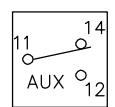
STATIONARY END CONTROL PANEL



120V POWER TO PC ENCLOSURE

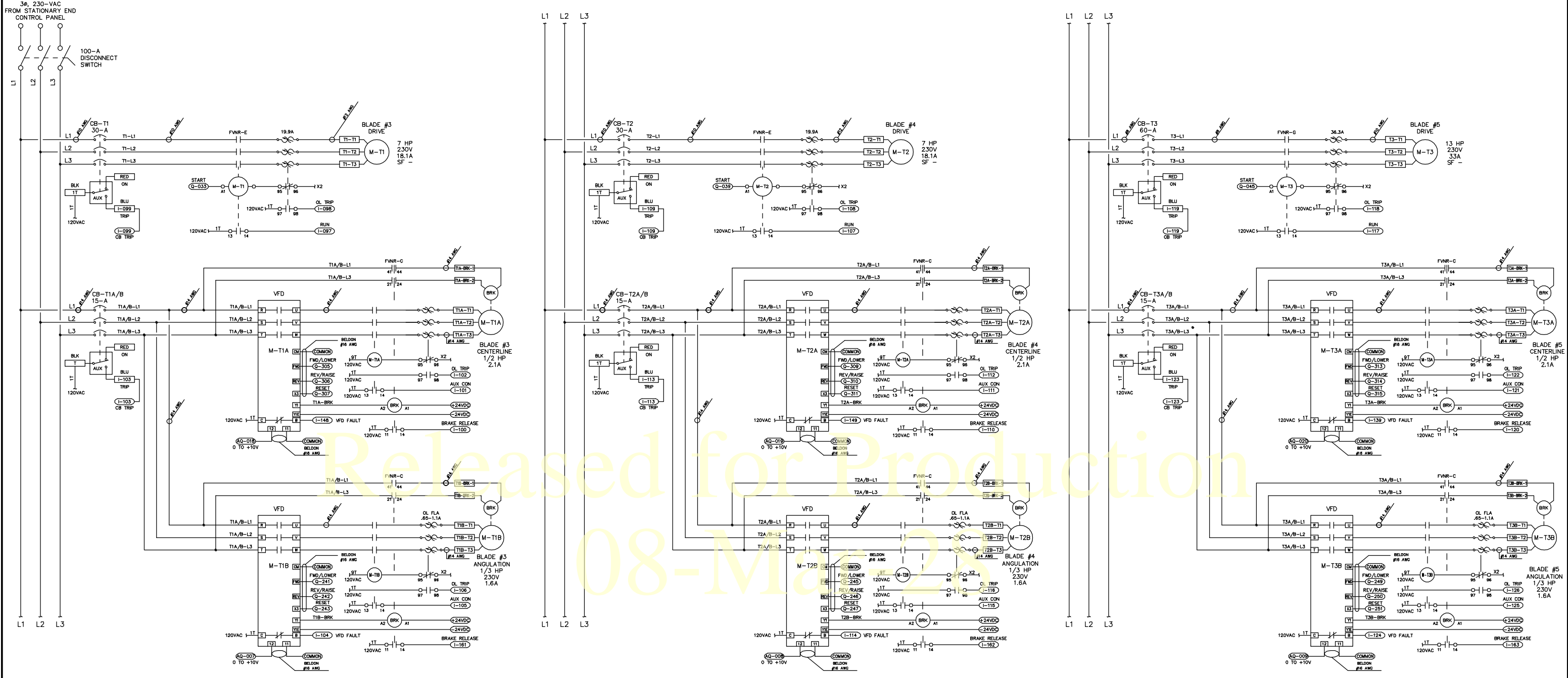
Released for Production
08-Mar-28

AUXILIARY CONTACT
DETAIL



ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
<small>DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]</small>						
<small>THIS DRAWING AND/OR DATA SHEET, AND THE CONFIDENTIAL PROPRIETARY INFORMATION THEREON, IS PROPERTY OF MITEK INDUSTRIES, INC. AND IS NOT TO BE REPRODUCED OR COPIED IN WHOLE OR IN PART, OR USED FOR UNAUTHORIZED MANUFACTURING OR ANY OTHER EXPLOITATION OF THE ITEM DISCLOSED THEREIN, OR IN ANY OTHER WAY DISCLOSED OR USED FOR FURNISHING INFORMATION.</small>						
FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED VDC		DATE 10/30/00	MFG. G.Bowers	CYBER, AT, ELE, SCHEM, 230V, US		
CHECKED VDC	DATE 10/30/00	DRAWN G.Bowers	DATE 10/30/00	FINISH PAINT X	SCALE NONE	PAGE 4 of 21
90507						DASH NO. 0

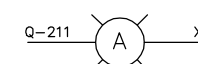
KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		



SHELF NO. 1T
QUAD #3



SHELF NO. 2T
QUAD #4



SHELF NO. 3T
QUAD #5

CARRIAGE END CONTROL PANEL

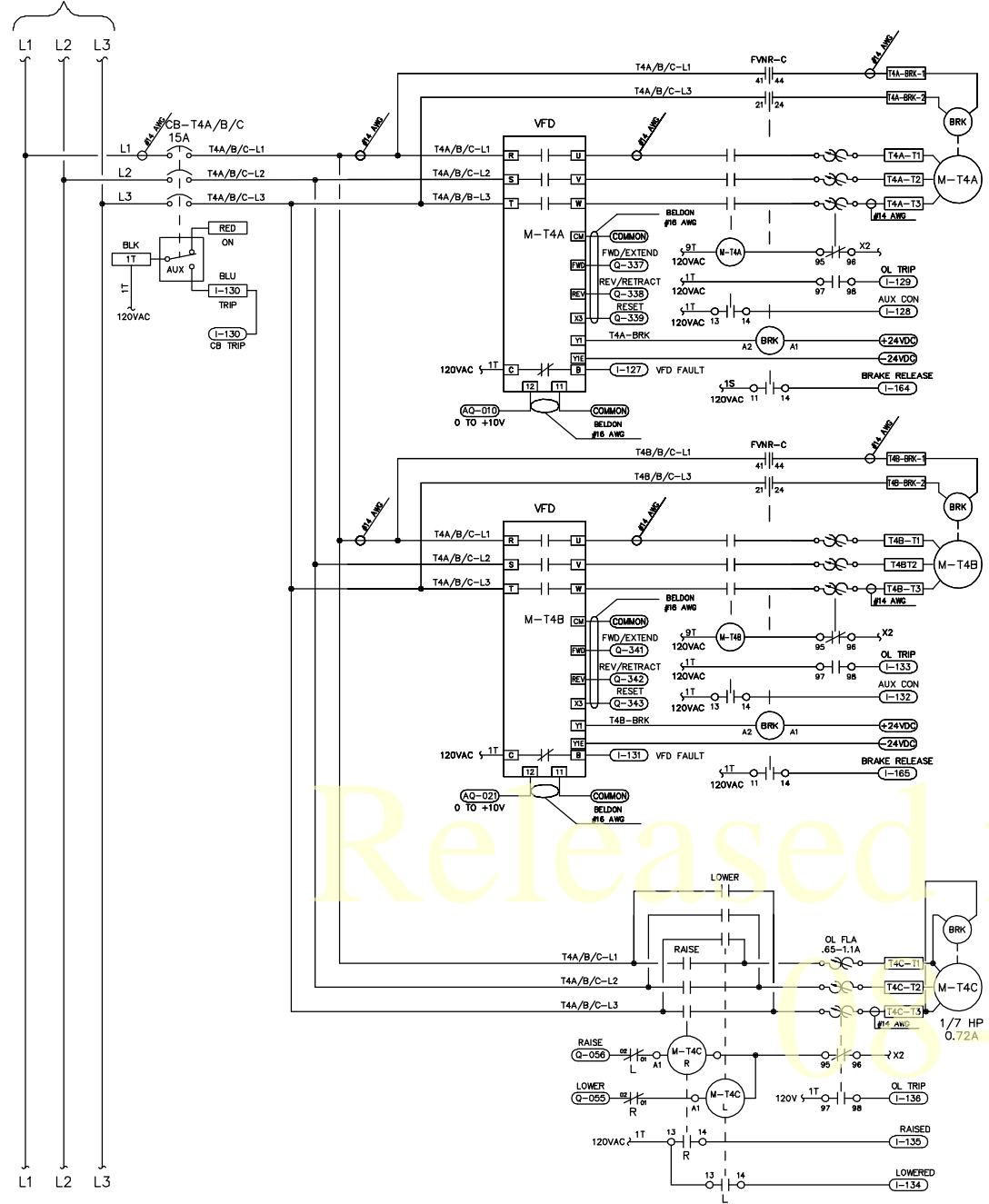
AUXILIARY CONTACT
DETAIL



ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG. NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]						
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FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED VDC		DATE 10/30/00	MFG. G.Bowers	CYBER, AT, ELE, SCHEM, 230V, US		
CHECKED VDC	DATE 10/30/00	DRAWN G.Bowers	SCALE NONE	PAGE 5 of 21	REV. 90507	DASH NO. 0

KEY	NO. OF HOLES	HOLE	TAP	REMARKS
A	X	X	X	X

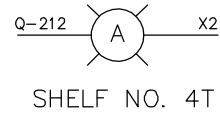
CONTINUED FROM
DWG. U.S.A. SAW-12



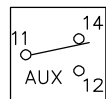
INFEED CONVEYOR
HORIZONTAL ADJUSTMENT
1/3 HP
1.2A

HOLD DOWN CONVEYOR
HORIZONTAL ADJUSTMENT
1/3 HP
1.2A

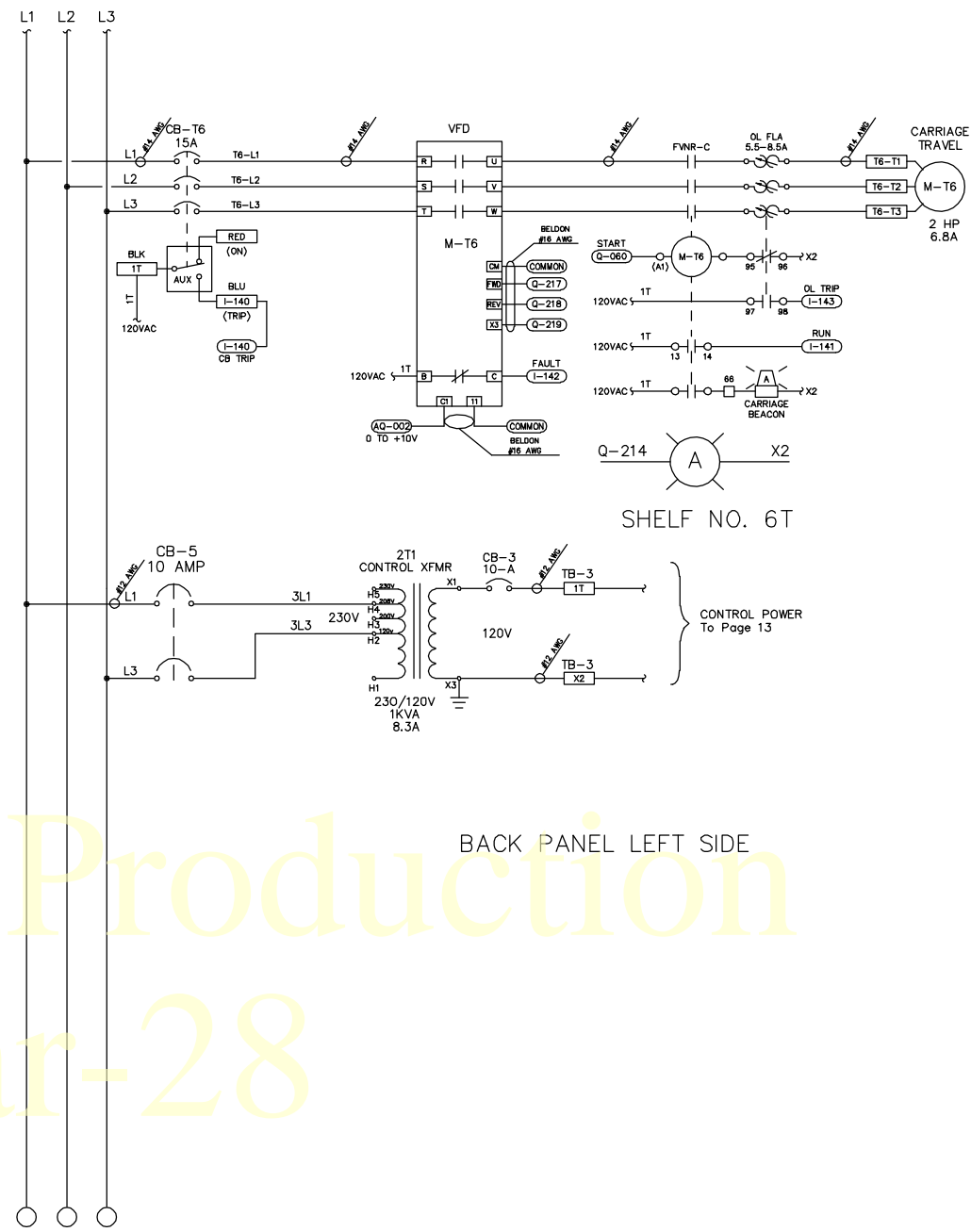
HOLD DOWN CONVEYOR
RAISE-
LOWER
1/7 HP
0.72A



AUXILIARY CONTACT
DETAIL



TRAVELLING END CONTROL PANEL



CARRIAGE
TRAVEL
2 HP
6.8A

SHELF NO. 6T

CONTROL POWER
To Page 13

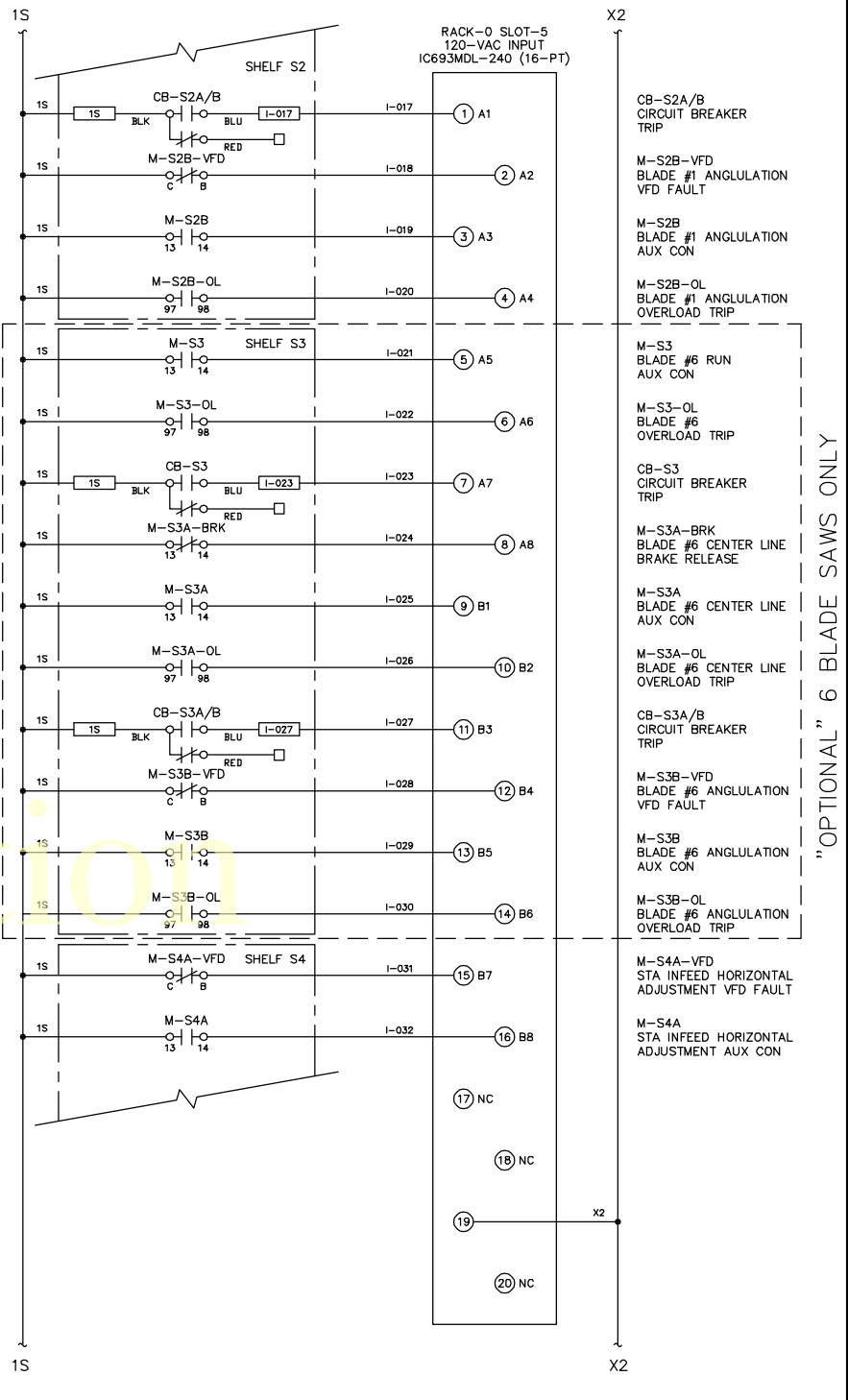
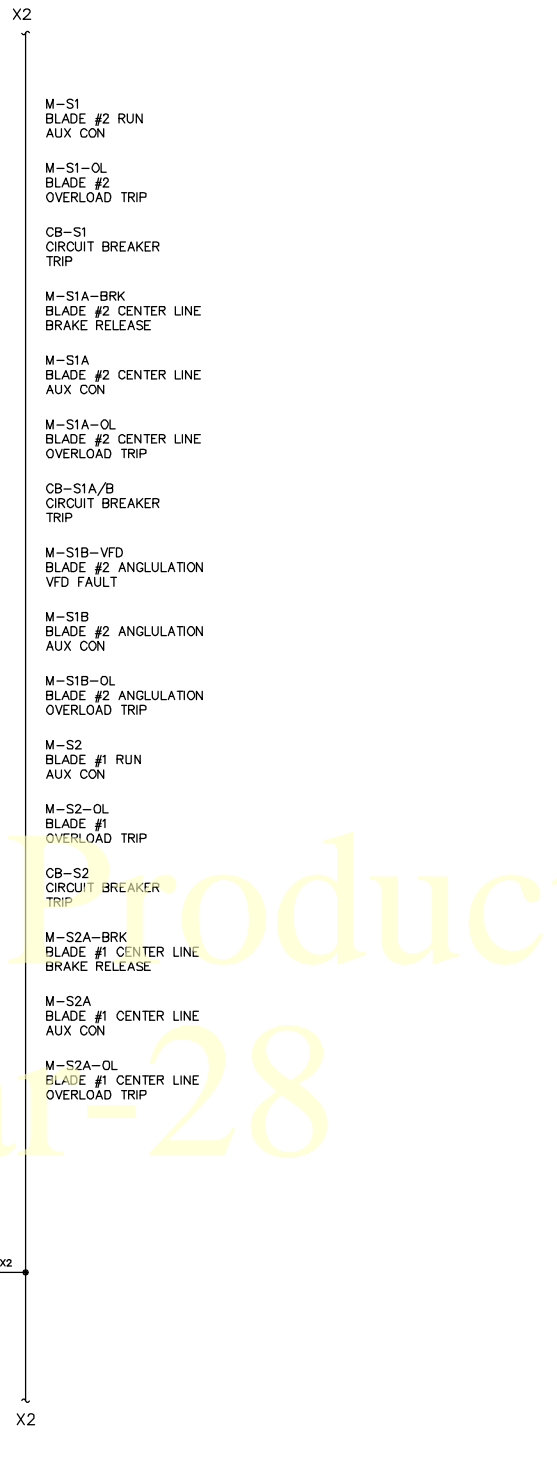
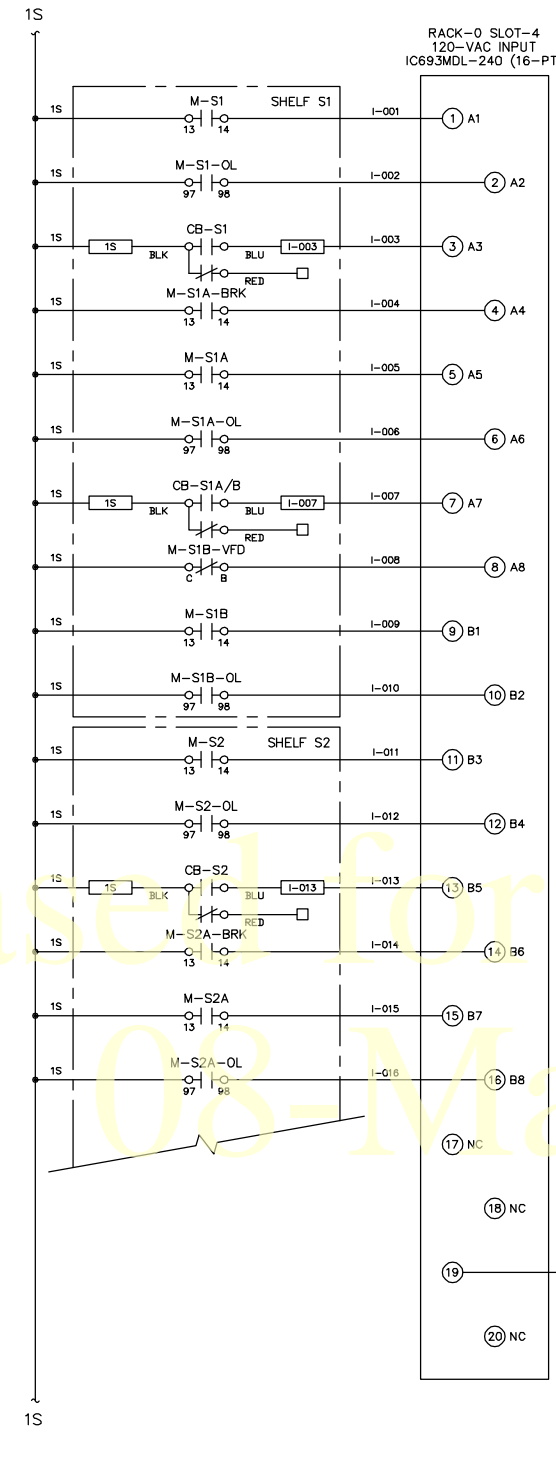
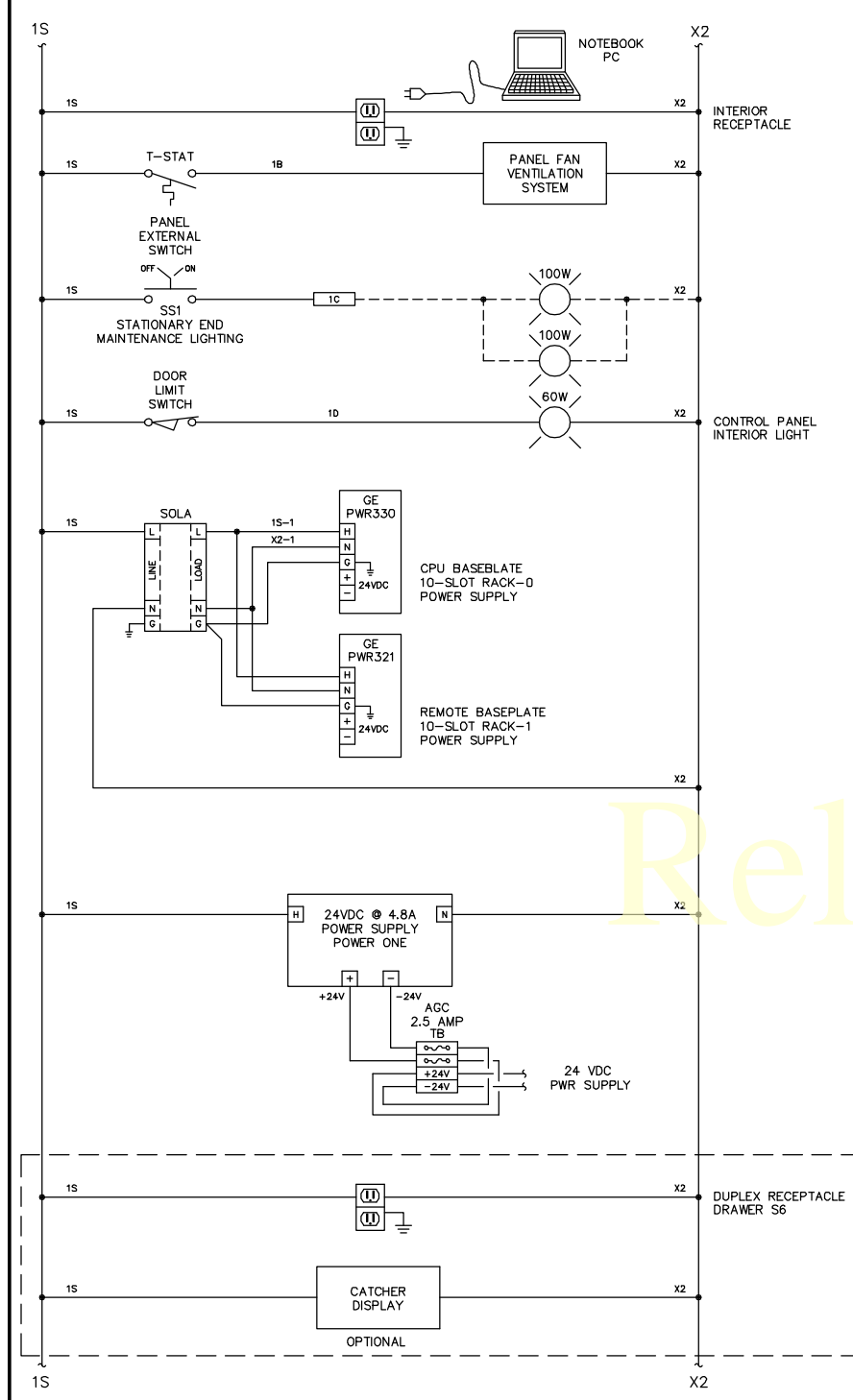
BACK PANEL LEFT SIDE

ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°]						
TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [25]						
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FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED	DATE	MFG.	CYBER, AT, ELE, SCHEM, 230V, US			
CHECKED	VDC	DATE	DRAWN	G.Bowers	DATE	10/30/00
FINISH PAINT SCALE NONE			PAGE 6 of 21			
DASH NO. 90507			REV. 0			

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS

From Page 4

From Page 4

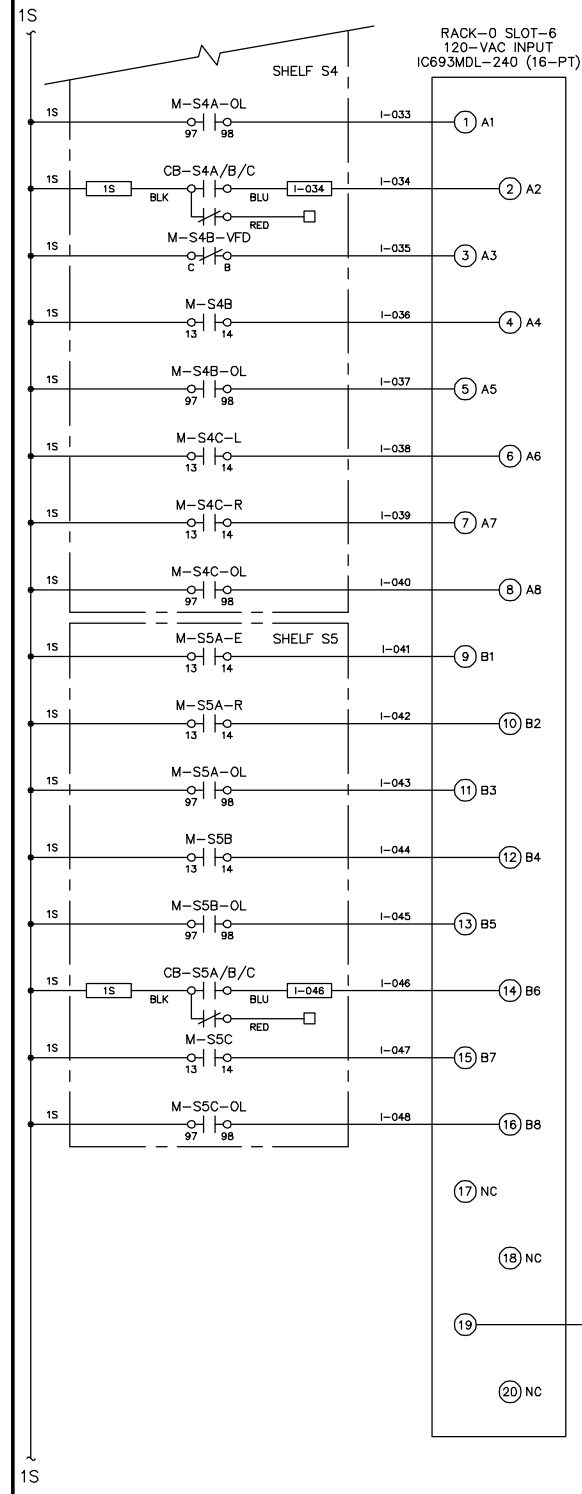


STATIONARY END CONTROL PANEL

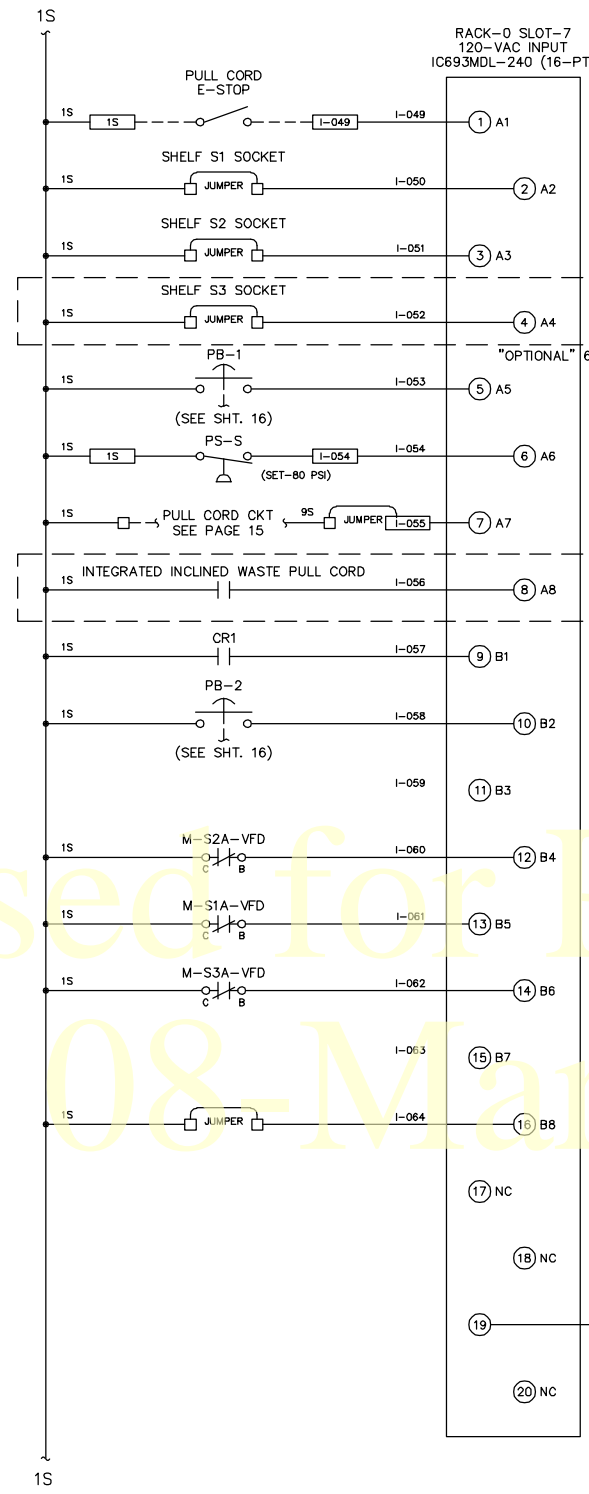
"OPTIONAL" 6 BLADE SAWS ONLY

ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]						
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APPROVED: VDC DATE: 10/30/00 DRAWN: G.Bowers			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
CYBER, AT, ELE, SCHEM. 230V, US			SCALE: NONE PAGE: 7 of 21 DASH NO.: 90507 REV.: 0			

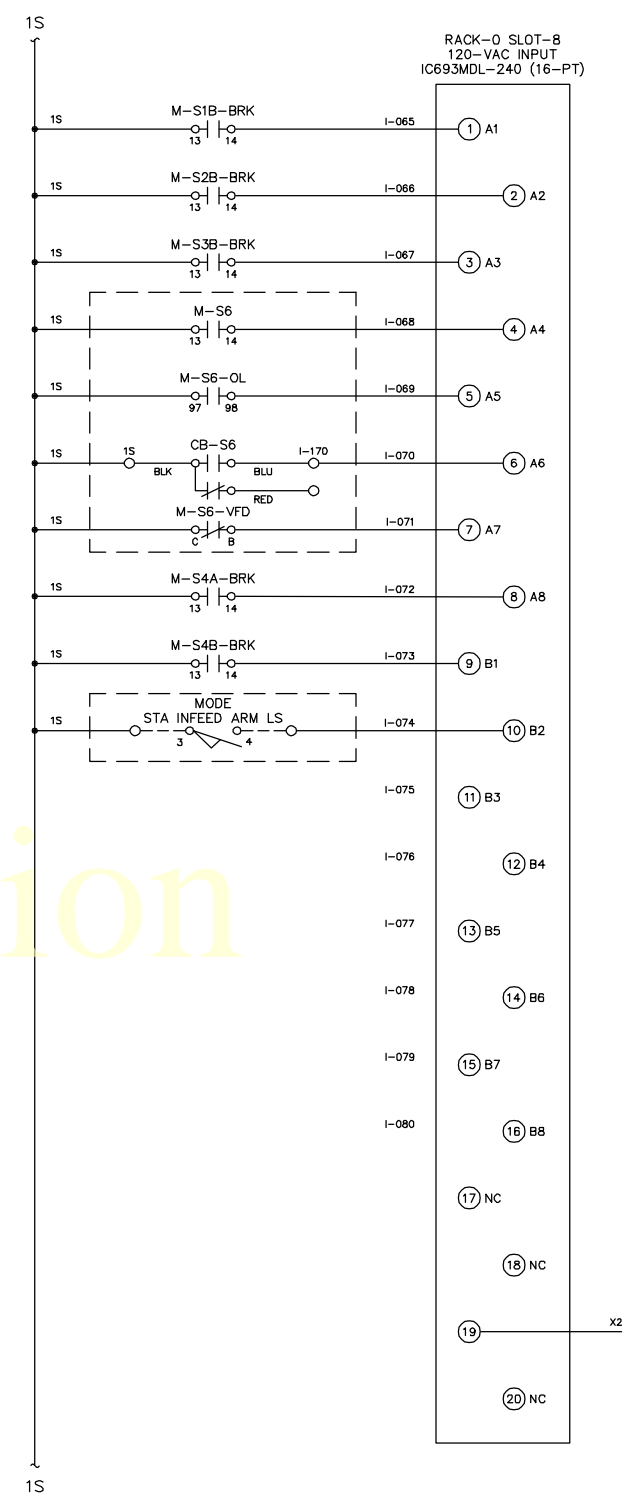
KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	



- M-S4A-OL
STA INFEEED HORIZONTAL
ADJUSTMENT OVERLOAD TRIP
- CB-S4A/B/C
CIRCUIT BREAKER
TRIP
- M-S4B-VFD
STA HOLD DOWN HORIZONTAL
ADJUSTMENT VFD FAULT
- M-S4B
STA HOLD DOWN HORIZONTAL
ADJUSTMENT AUX CON
- M-S4B-OL
STA HOLD DOWN HORIZONTAL
ADJUSTMENT OVERLOAD TRIP
- M-S4C-L
STA VERTICAL HOLD
DOWN LOWERED
- M-S4C-R
STA VERTICAL HOLD
DOWN RAISED
- M-S4C-OL
STA VERTICAL HOLD
DOWN OVERLOAD TRIP
- M-S5A-E
LUMBER STOP
EXTENDED
- M-S5A-R
LUMBER STOP
RETRACTED
- M-S5A-OL
LUMBER STOP
OVERLOAD TRIP
- M-S5B
SCRAP BELT CONVEYOR
RUN AUX CON
- M-S5B-OL
SCRAP BELT CONVEYOR
OVERLOAD TRIP
- CB-S5A/B/C
CIRCUIT BREAKER
TRIP
- M-S5C
SCRAP BELT TAKEAWAY
CONVEYOR RUN AUX CON
- M-S5C-OL
SCRAP BELT TAKEAWAY
CONVEYOR OVERLOAD TRIP



- EMERGENCY STOP
PULL CORD
SAFETY SWITCH
- BLADE NO. 2 (S1)
INSTALLED
- BLADE NO. 1 (S2)
INSTALLED
- BLADE NO. 6 (S3)
INSTALLED
- CONTROL PANEL
E-STOP
- INSUFFICIENT
AIR BRAKE
PRESSURE
- STATIONARY END
CONTROL POWER
VERIFY
- INTEGRATED INCLINED
WASTE CONVEYOR
E-STOP
- STATIONARY END
SYSTEM ENABLE
- STATIONARY END
CONTROL PANEL
SIDE MTD E-STOP
- M-S2A-VFD
BLADE 1 CENTER LINE
VFD FAULT
- M-S1A-VFD
BLADE 2 CENTER LINE
VFD FAULT
- M-S3A-VFD
BLADE 6 CENTER LINE
VFD FAULT
- METRIC (CE)
SAW



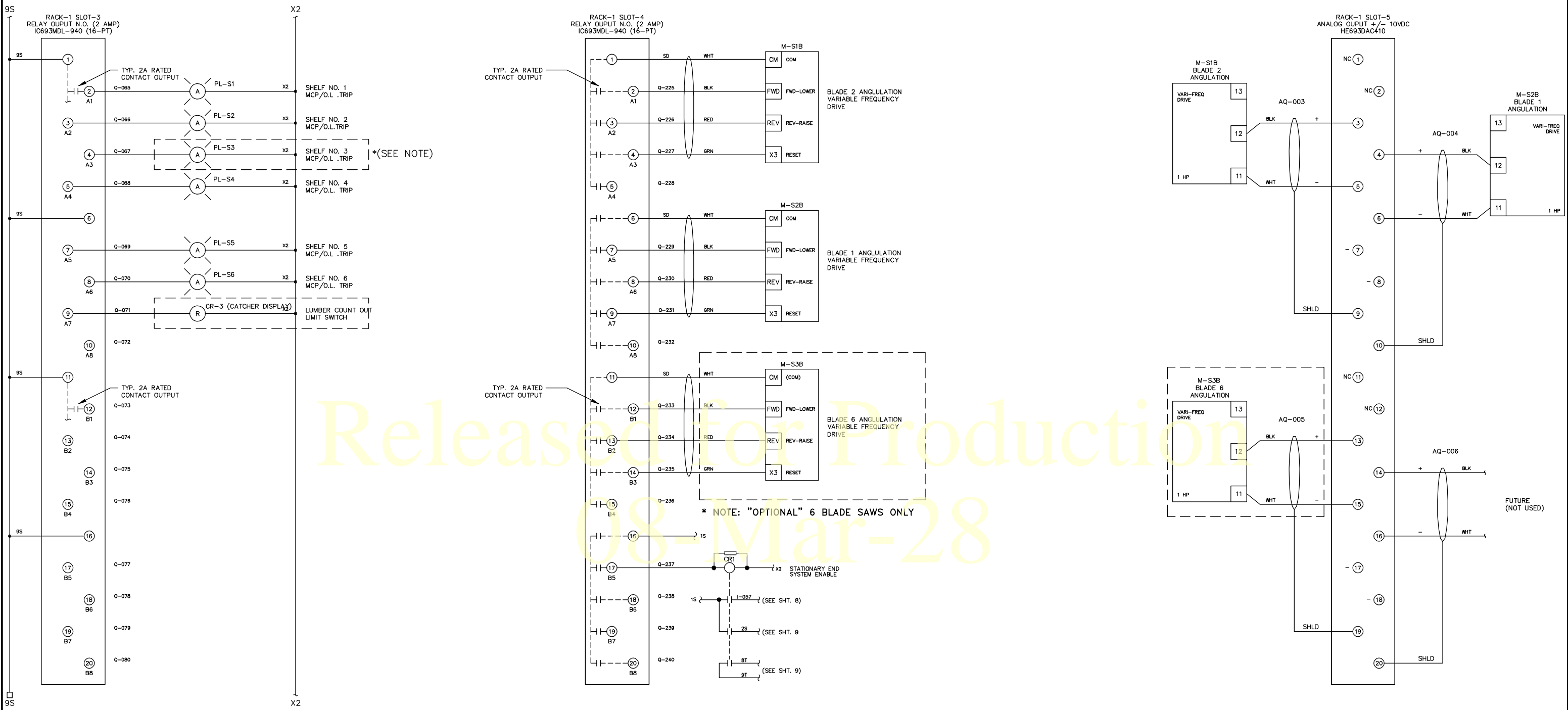
- M-S1B-BRK
BLADE 2 ANGLULATION
BRAKE RELEASE
- M-S2B-BRK
BLADE 1 ANGLULATION
BRAKE RELEASE
- M-S3B-BRK
BLADE 6 ANGLULATION
BRAKE RELEASE
- M-S6
INFEEED CHAIN CONVEYOR
RUN CONTACTOR
- M-S6
INFEEED CHAIN CONVEYOR
OVERLOAD TRIP
- CB-S6
CIRCUIT BREAKER
TRIP
- M-S6-VFD
INFEEED CHAIN CONVEYOR
VFD FAULT
- M-S4A-BRK
STA INFEEED CONVEYOR
BRAKE RELEASE
- M-S4B-BRK
STA HORIZONTAL HOLD DOWN
BRAKE RELEASE

STATIONARY END CONTROL PANEL

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	

ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1]						
TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]						
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FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED VDC		DATE 10/30/00	MFG. G.Bowers	CYBER, AT, ELE, SCHEMIC, 230V, US		
CHECKED VDC		DATE 10/30/00	SCALE NONE	PAGE 8 of 21	DASH NO. 90507	REV. 0

BELDEN CABLE (9418) EFFECTIVE
FRAME #358 FORWARD



Released for Production
08-Mar-28

STATIONARY END CONTROL PANEL

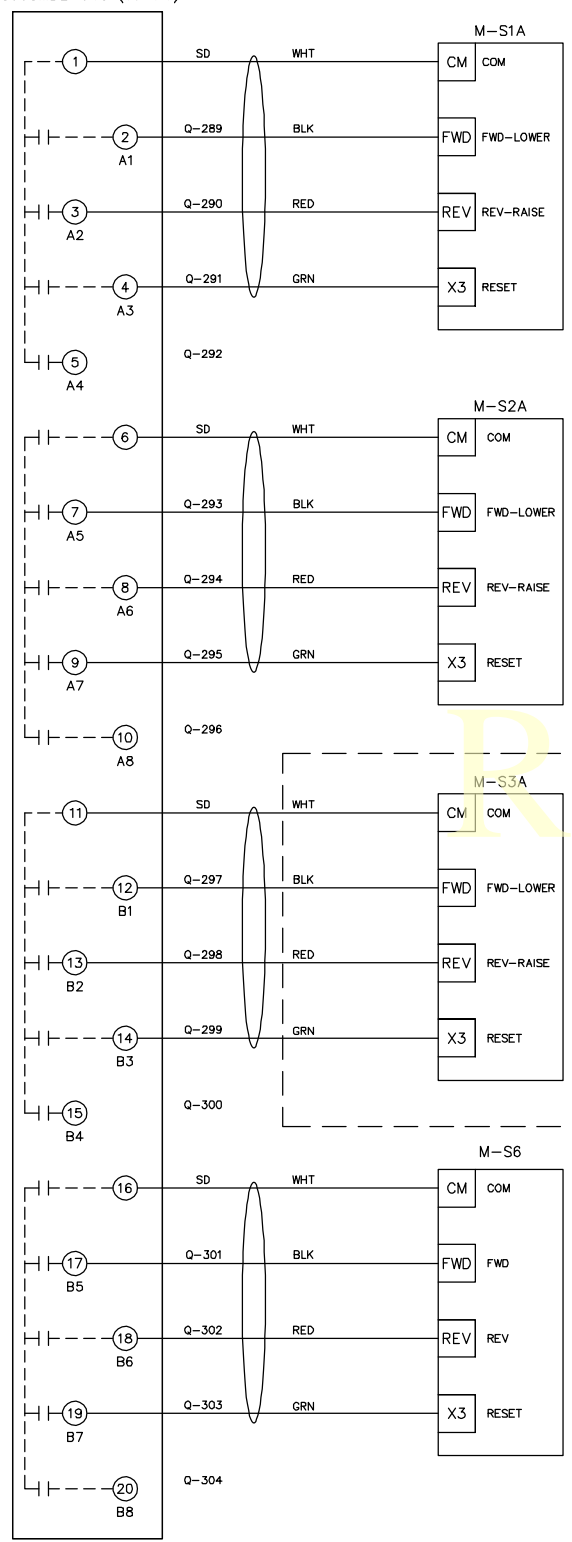
KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG. NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1]						
TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]						
FEATURES X						
APPROVED: VDC DATE: 10/30/00 MFG. G.Bowers DATE: 10/30/00 FINISH PAINT: X SCALE: NONE PAGE: 10 of 21 DASH NO.: 90507 REV.: 0						

MiTek Industries, Inc.
 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045

BELDEN CABLE (9418) EFFECTIVE
FRAME #358 FORWARD

RACK-1 SLOT-6
RELAY OUTPUT N.O. (2 AMP)
IC693MDL-940 (16-PT)



BLADE 2 CENTER LINE
VARIABLE FREQUENCY
DRIVE

BLADE 1 CENTER LINE
VARIABLE FREQUENCY
DRIVE

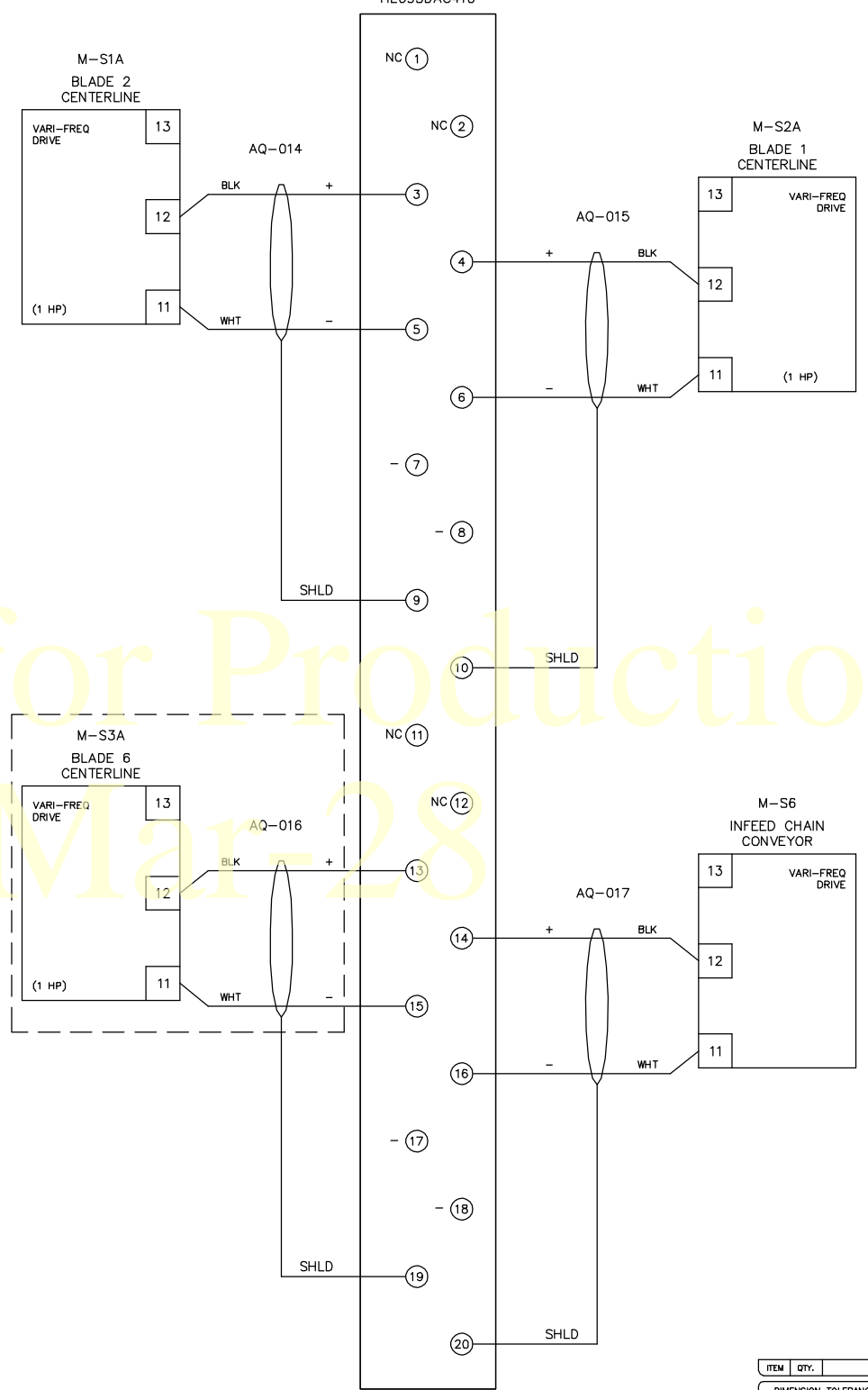
*"OPTIONAL" 6 BLADE SAWS ONLY

BLADE 6 CENTER LINE
VARIABLE FREQUENCY
DRIVE

INFEED CHAIN CONVEYOR

NOTE:
VFD IS FIXED AT 0-5VDC
INPUT. BIAS PLC ANALOG
PROGRAMMING OF 0-10VDC
TO SUPPORT VFD.

RACK-1 SLOT-7
ANALOG OUTPUT +/- 10VDC
HE693DAC410



Released for Production
08-Mar-28

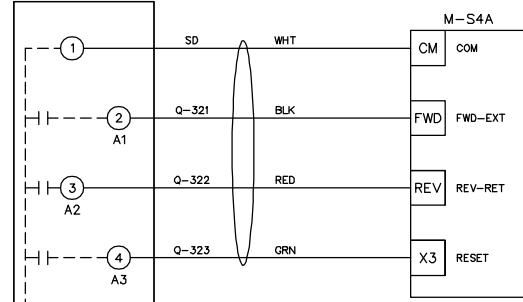
ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG. NO./PART NO.
<small>DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]</small>						
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FEATURES X			MiTek Industries, Inc. <small>4203 SHORELINE DRIVE, EARTH CITY, MO. 63045</small>			
APPROVED	DATE	MFG.	CYBER, AT, ELE, SCHEM, 230V, US			
CHECKED	VDC	DATE	DRAWN	G.Bowers	DATE	10/30/00
FINISH PAINT: X SCALE: NONE PAGE: 11 of 21			DASH NO.: 90507 REV.: 0			

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

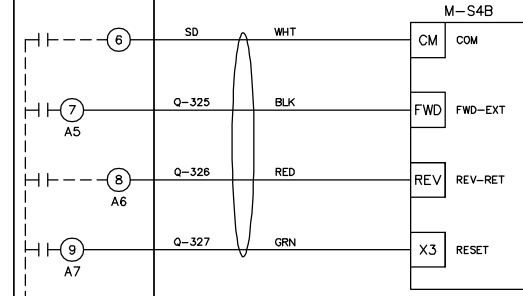
BELDEN CABLE (9418) EFFECTIVE
FRAME #358 FORWARD

REV.	DATE	DESCRIPTION	BY	CHK'D	APP'D	DATE
------	------	-------------	----	-------	-------	------

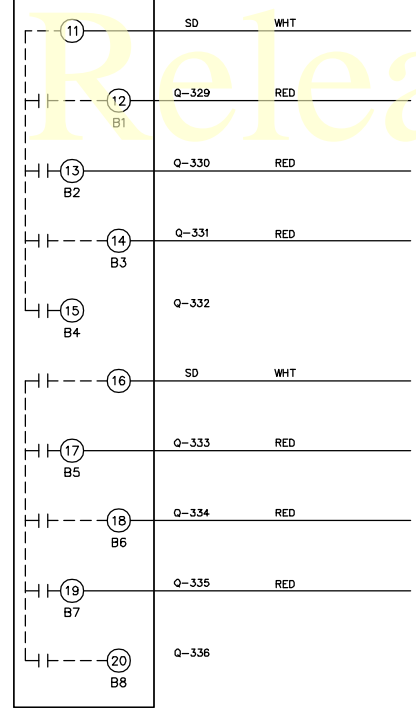
RACK-1 SLOT-8
RELAY OUTPUT N.O. (2 AMP)
IC693MDL-940 (16-PT)



STA INFFED CONVEYOR
HORIZONTAL ADJUSTMENT

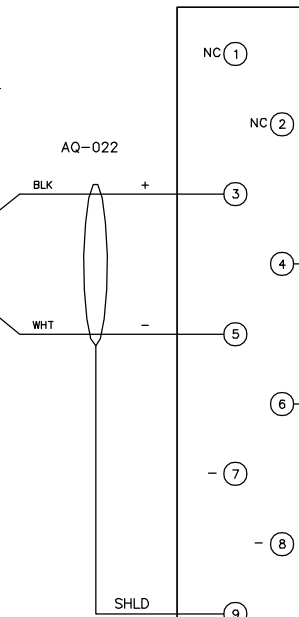
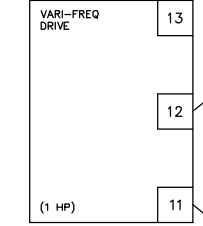


STA HOLD DOWN CONVEYOR
HORIZONTAL ADJUSTMENT

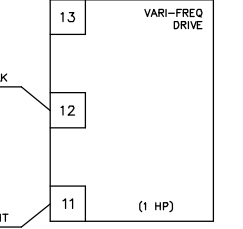


RACK-1 SLOT-9
ANALOG OUTPUT +/- 10VDC
HE693DAC410

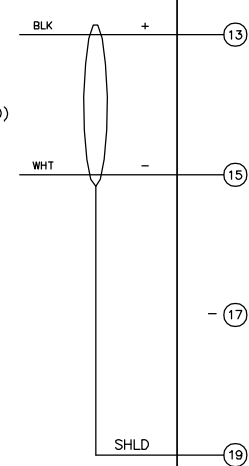
M-S4A
STA INFEED CONVEYOR
HORIZONTAL ADJUSTMENT



M-S4B
STA HOLD DOWN CONVEYOR
HORIZONTAL ADJUSTMENT

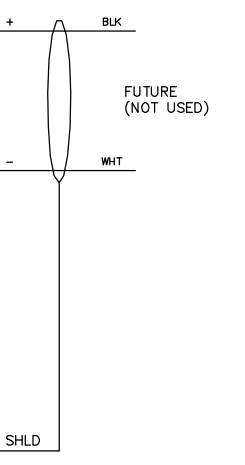


AQ-024



FUTURE
(NOT USED)

AQ-025



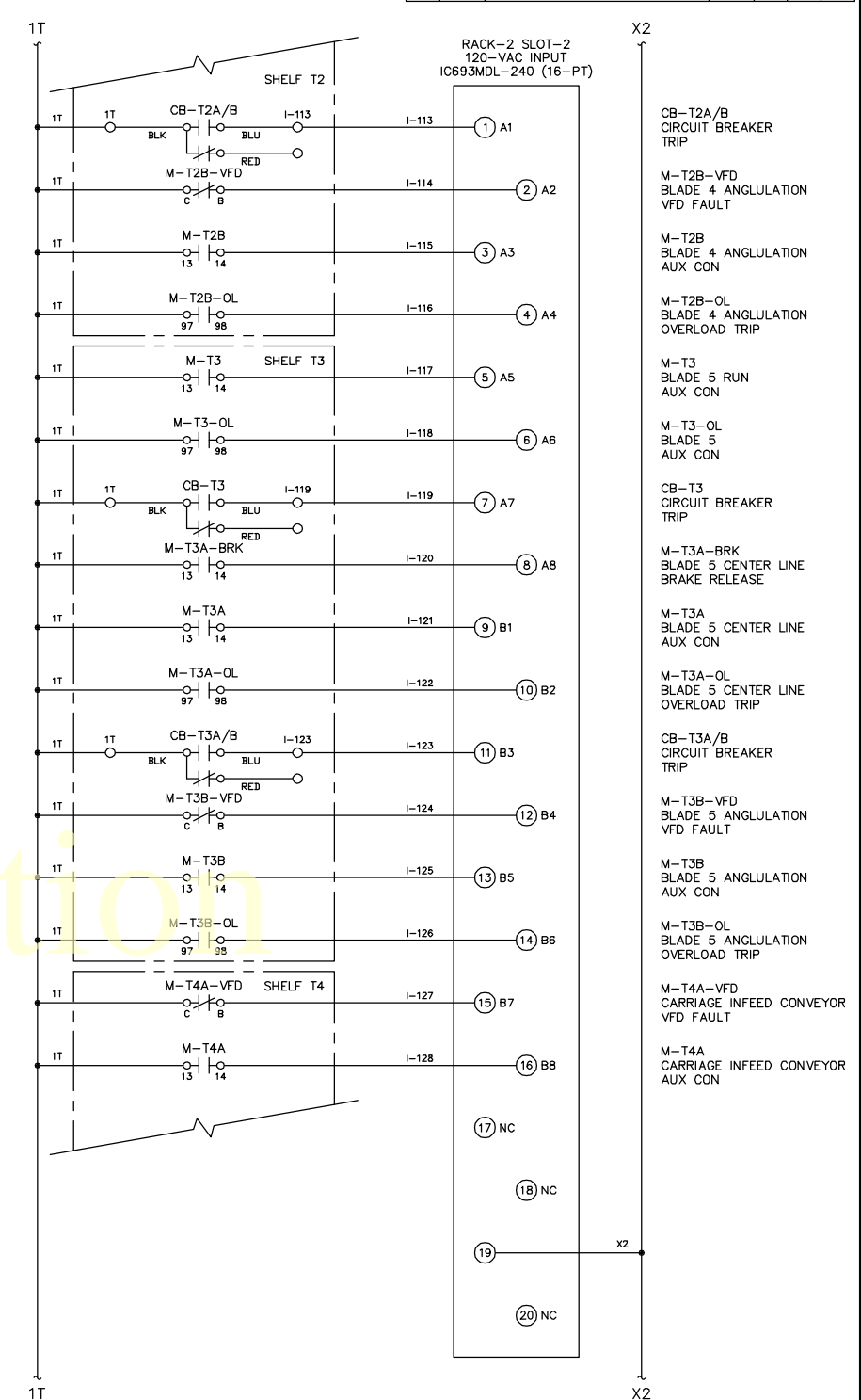
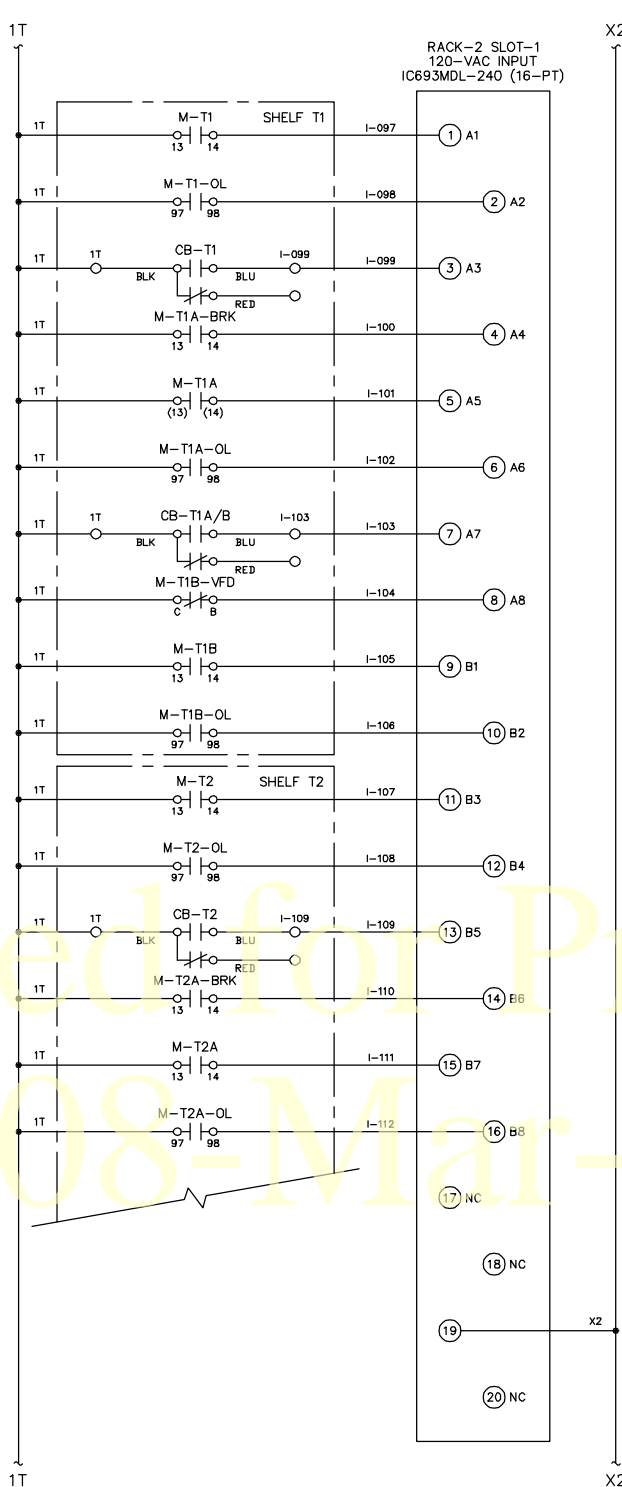
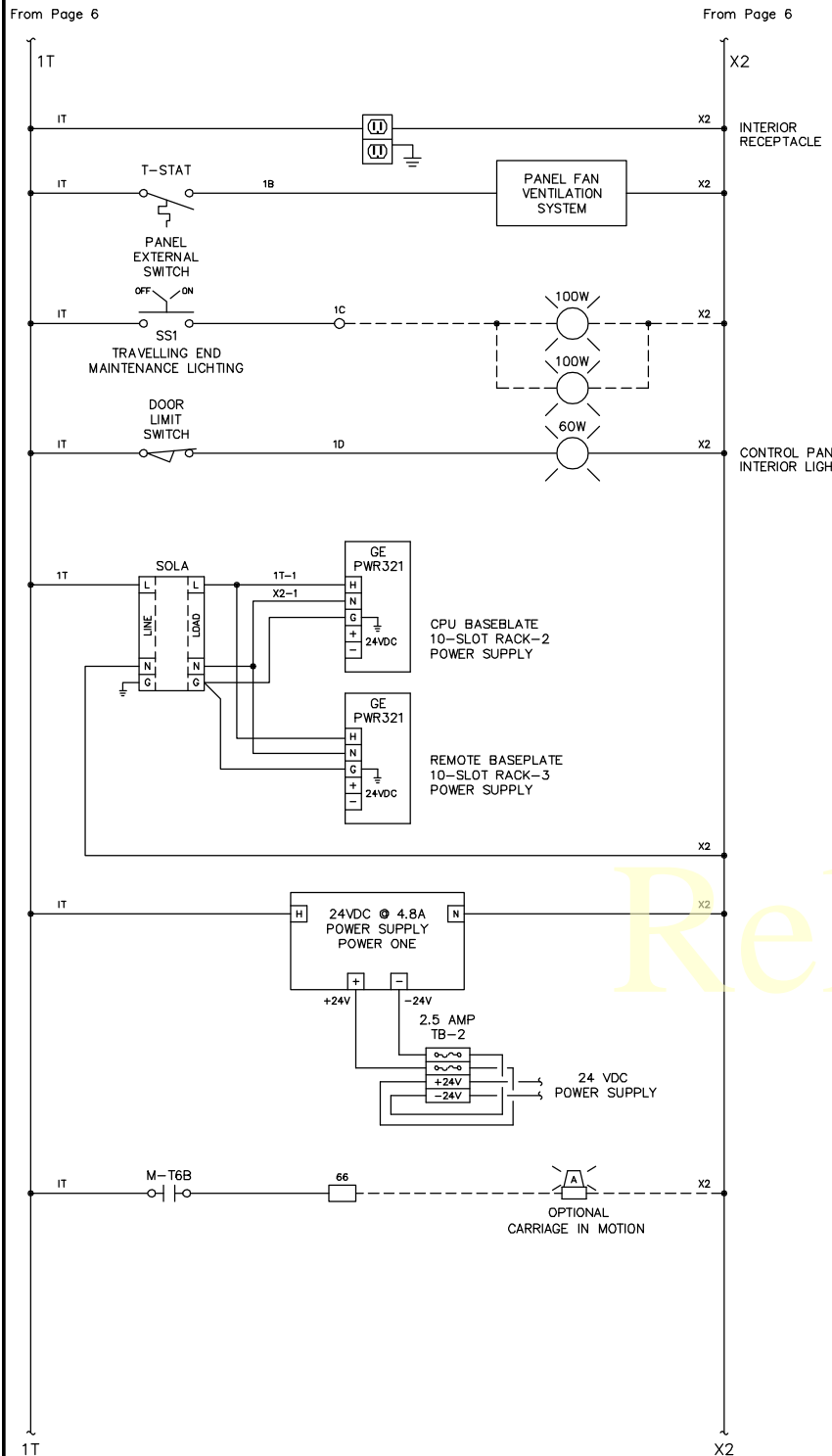
FUTURE
(NOT USED)

Released for Production
08-Mar-28

- TOUCHSCREEN PANEL
- TERMINALS LOCATED IN TRAVELING END CONTROL PANEL
- TERMINALS LOCATED IN STATIONARY END CONTROL PANEL

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG. NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]						
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APPROVED: VDC DATE: 10/30/00			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
CHECKED: G.Bowers DATE: 10/30/00		DRAWN: G.Bowers DATE: 10/30/00		FINISH PAINT: X SCALE: NONE PAGE: 12 of 21		
CYBER, AT, ELE, SCHEM, 230V, US			90507 DASH NO. REV. 0			

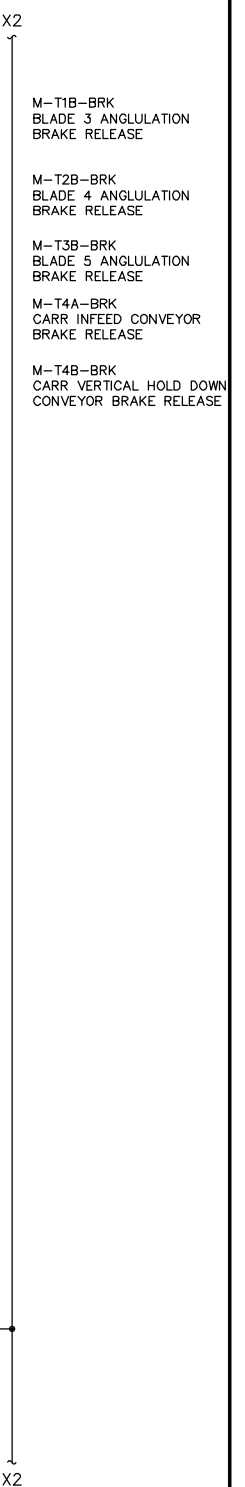
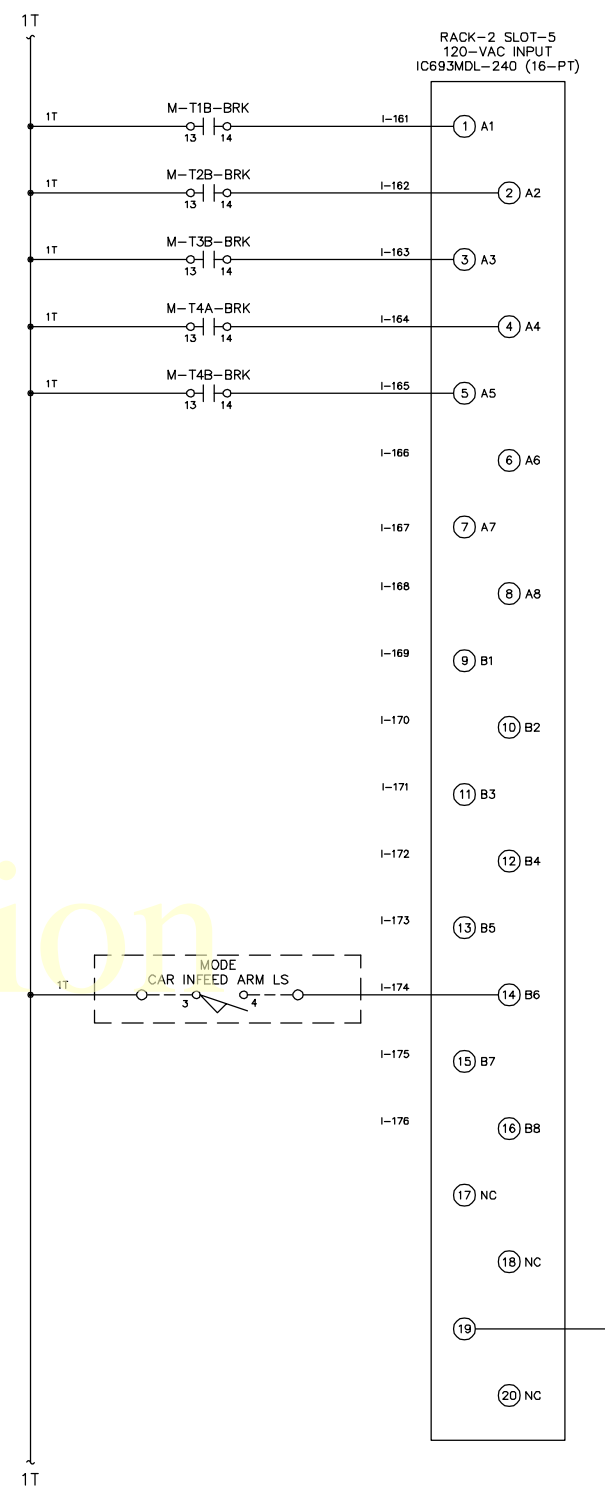
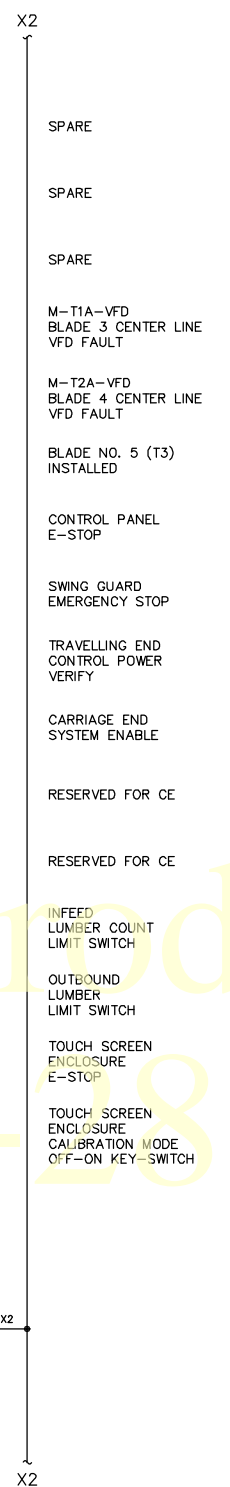
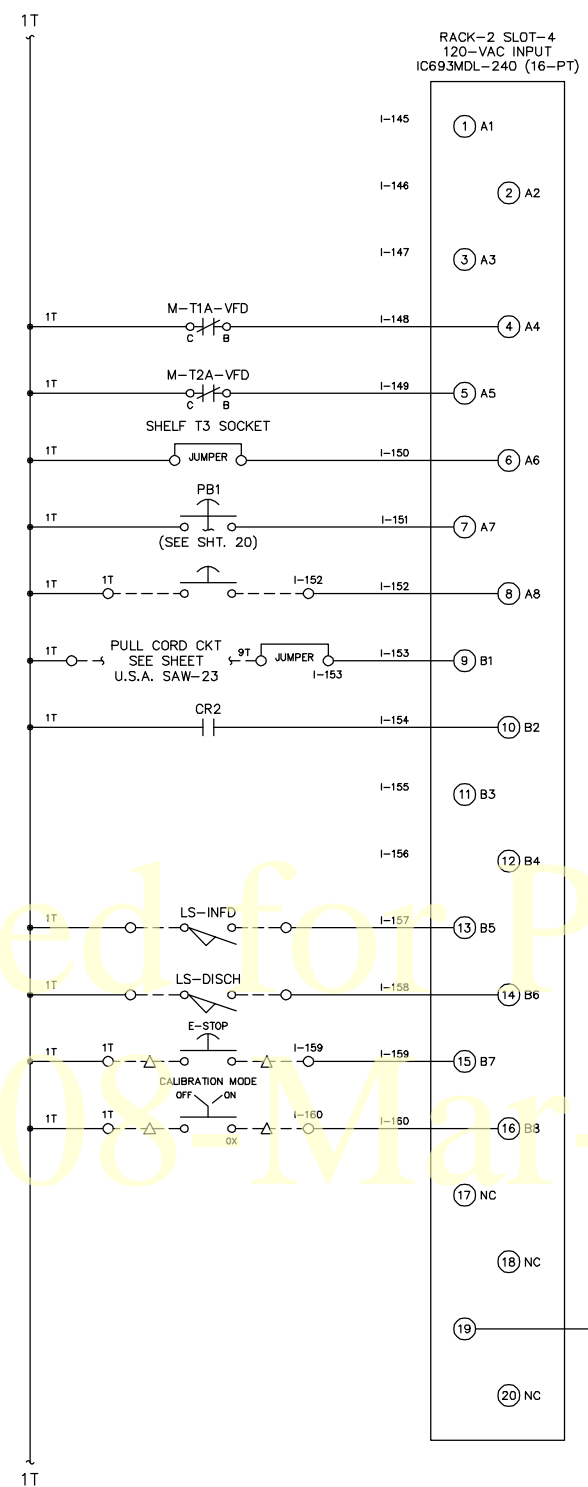
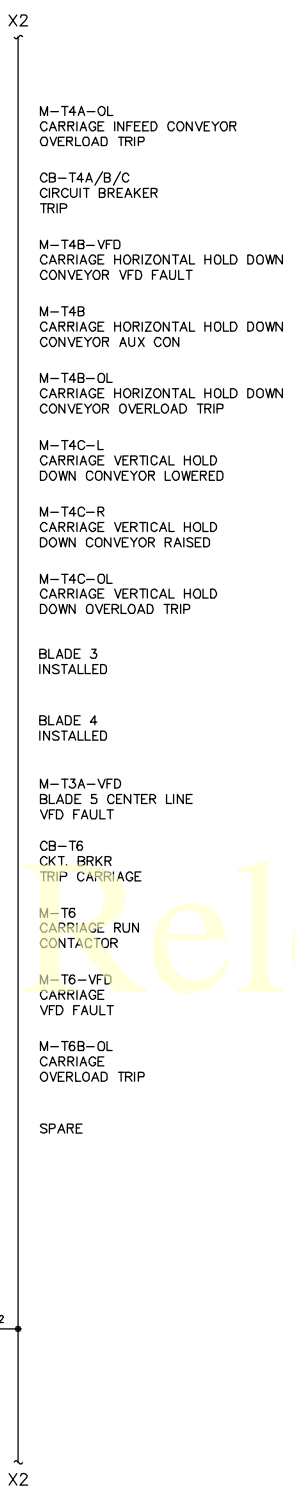
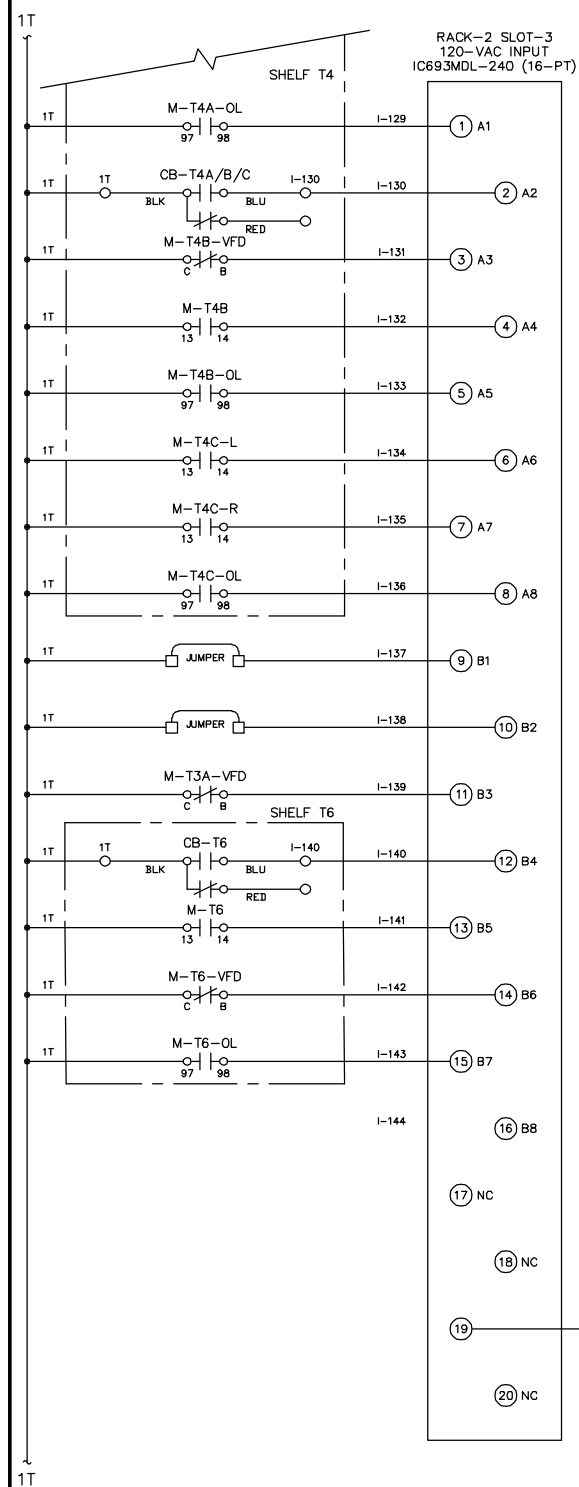


Released for Production
08-Mar-28

TRAVELLING END CONTROL PANEL

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	

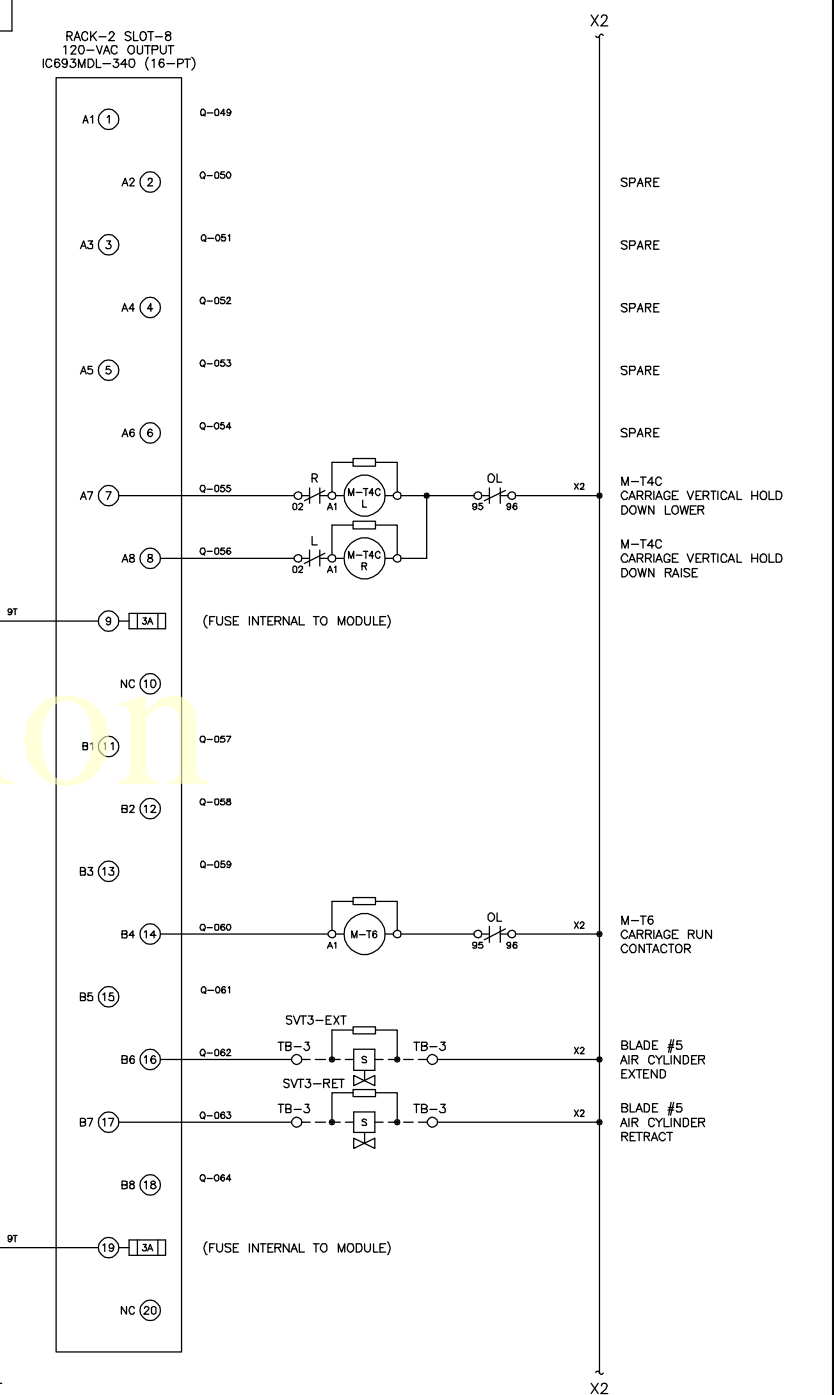
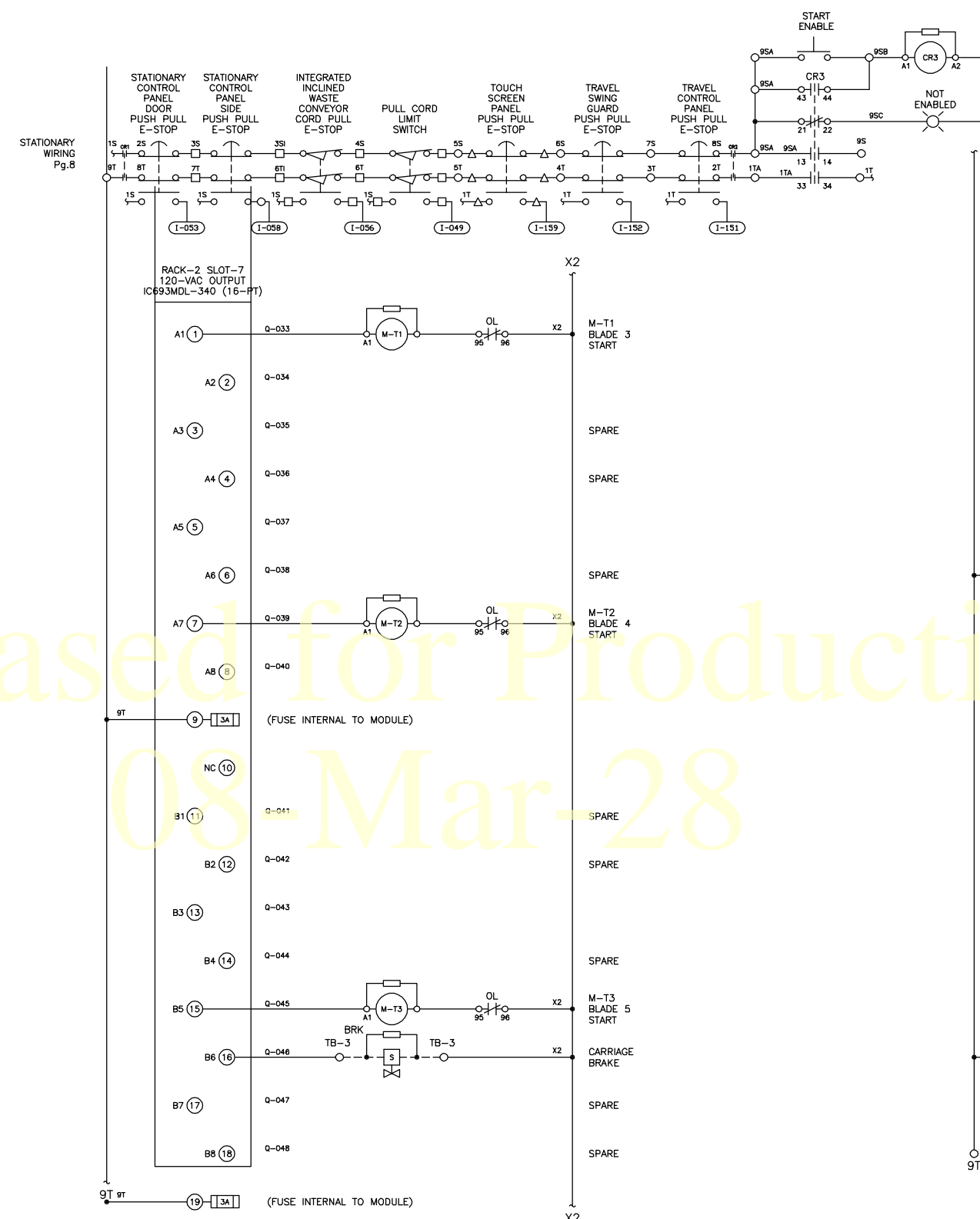
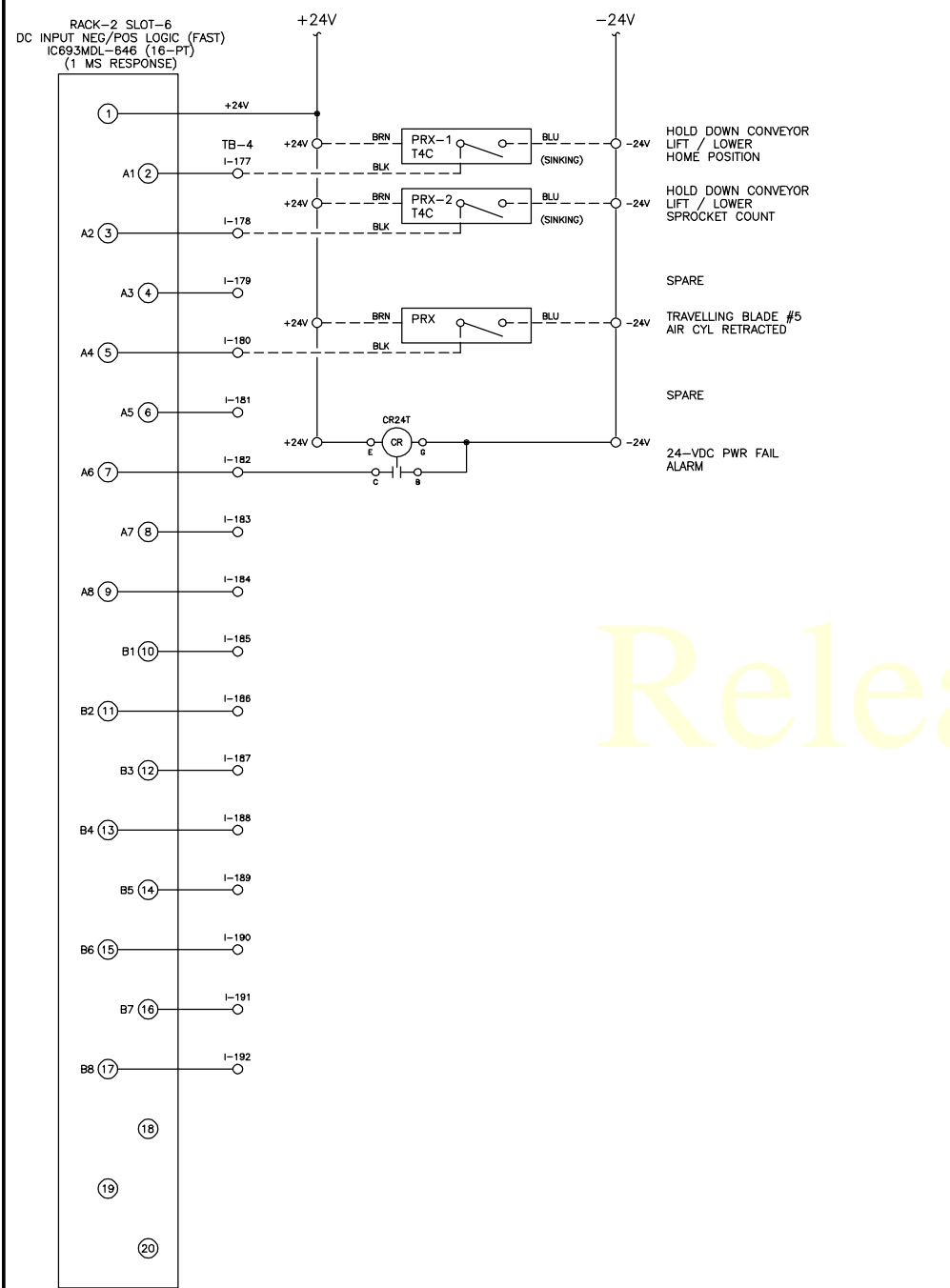
ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]						
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APPROVED: VDC DATE: 10/30/00 MFG. G.Bowers			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
CHECKED: VDC DATE: 10/30/00 DRAWN: G.Bowers			CYBER, AT, ELE, SCHEM, 230V, US SCALE: NONE PAGE: 13 of 21 90507 DASH NO. REV. 0			



TRAVELLING END CONTROL PANEL

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	

ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]						
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APPROVED: VDC DATE: 10/30/00 MFG. G.Bowers			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
CHECKED: VDC DATE: 10/30/00 DRAWN: G.Bowers			CYBER, AT, ELE, SCHEM, 230V, US SCALE: NONE PAGE: 14 of 21 DASH NO.: 90507 REV.: 0			

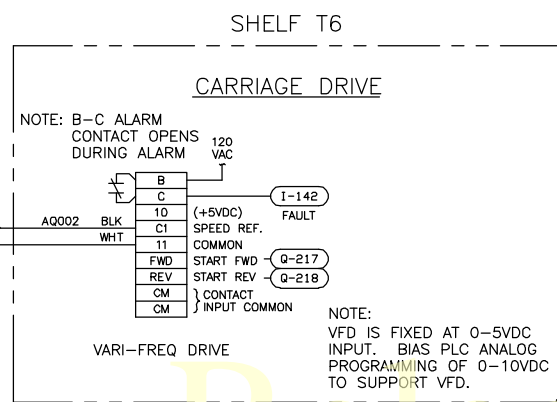
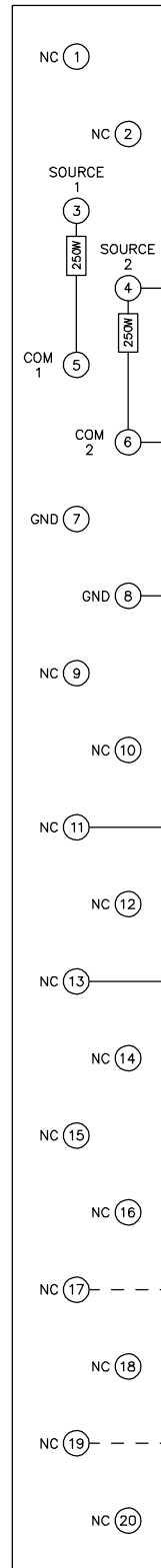


Released for Production
08-Mar-28

ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
<small>DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]</small>						
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FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED	DATE	MFG.	CYBER, AT, ELE, SCHEM, 230V, US			
CHECKED	VDC	DATE	DRAWN	G.Bowers	DATE	10/30/00
SCALE			PAGE		REV.	
NONE			15 of 21		90507	
DASH NO.			REV.		0	

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

ANALOG CURRENT
OUTPUT MODULE
ALG391
RACK 2 SLOT-10

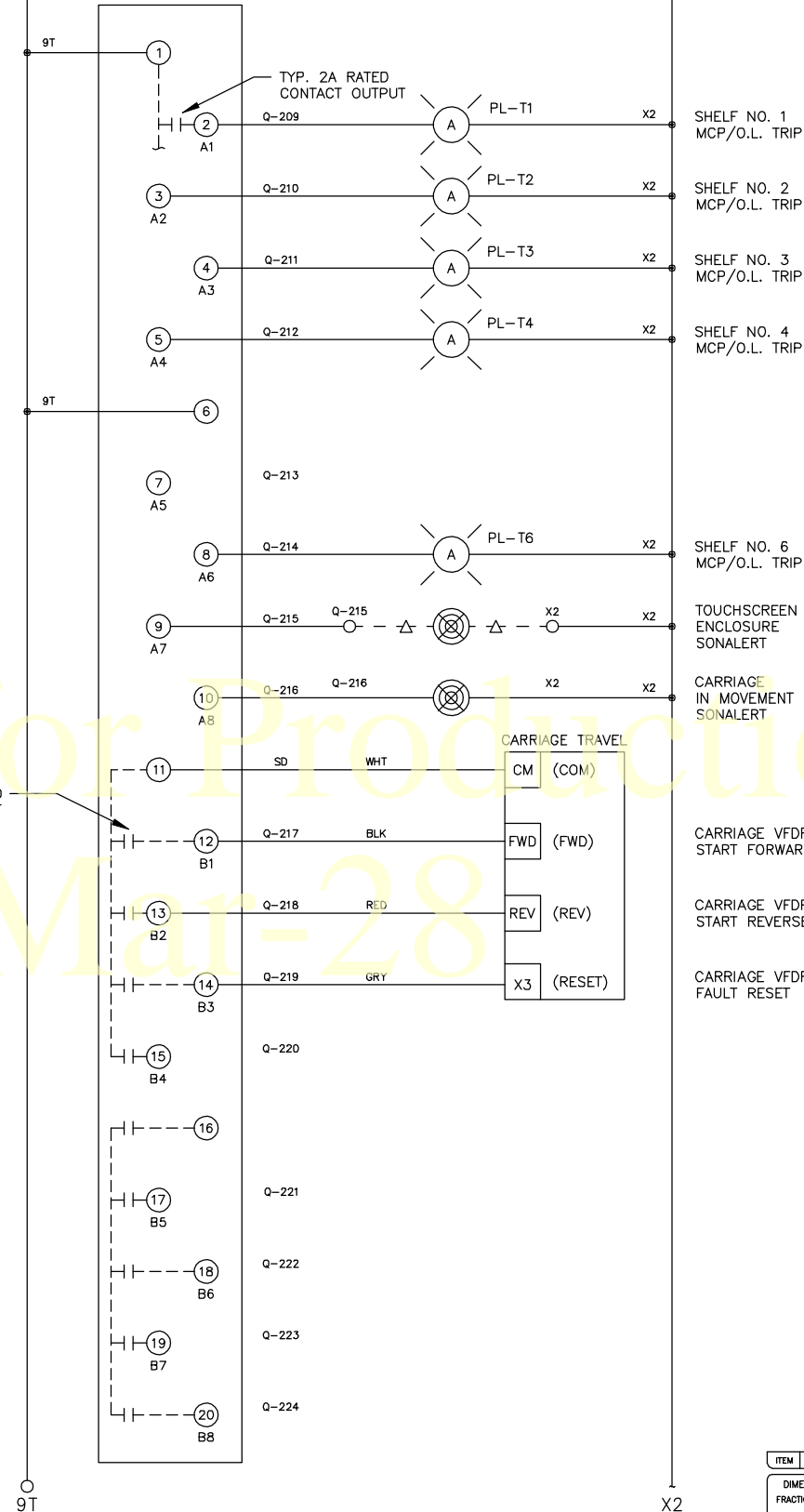


IF JUMPER IN PLACE
MODULE DEFAULTS 0-VOLT
OUTPUT ON ERROR
IF JUMPER NOT IN PLACE
MODULE WILL HOLD LAST
STATE ON ERROR

OPTION 24-VDC
MODULE POWER
ASSIST

SLOT ADDRESSES
A0001 & A0002
BINARY RANGE
0 - (+)32,000
4-20MA

RACK-3 SLOT-1
RELAY OUTPUT N.O. (2 AMP)
IC693MDL-940 (16-PT)

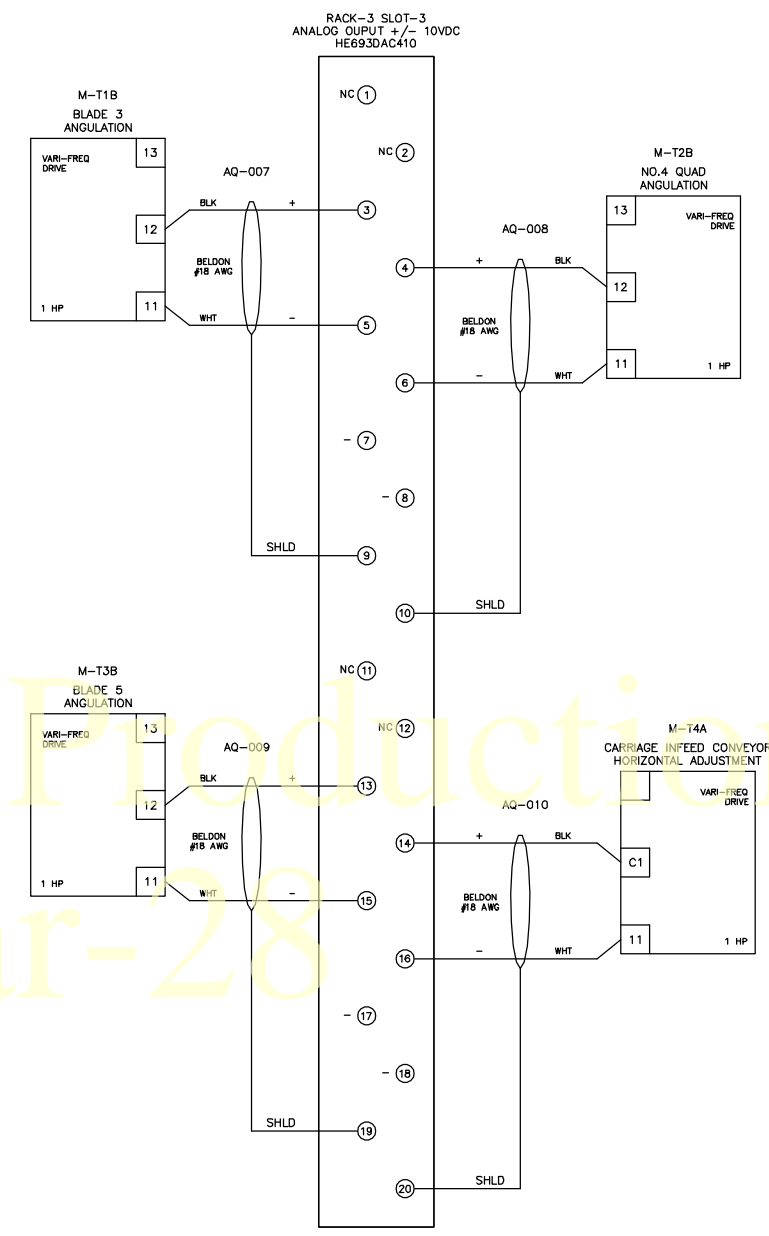
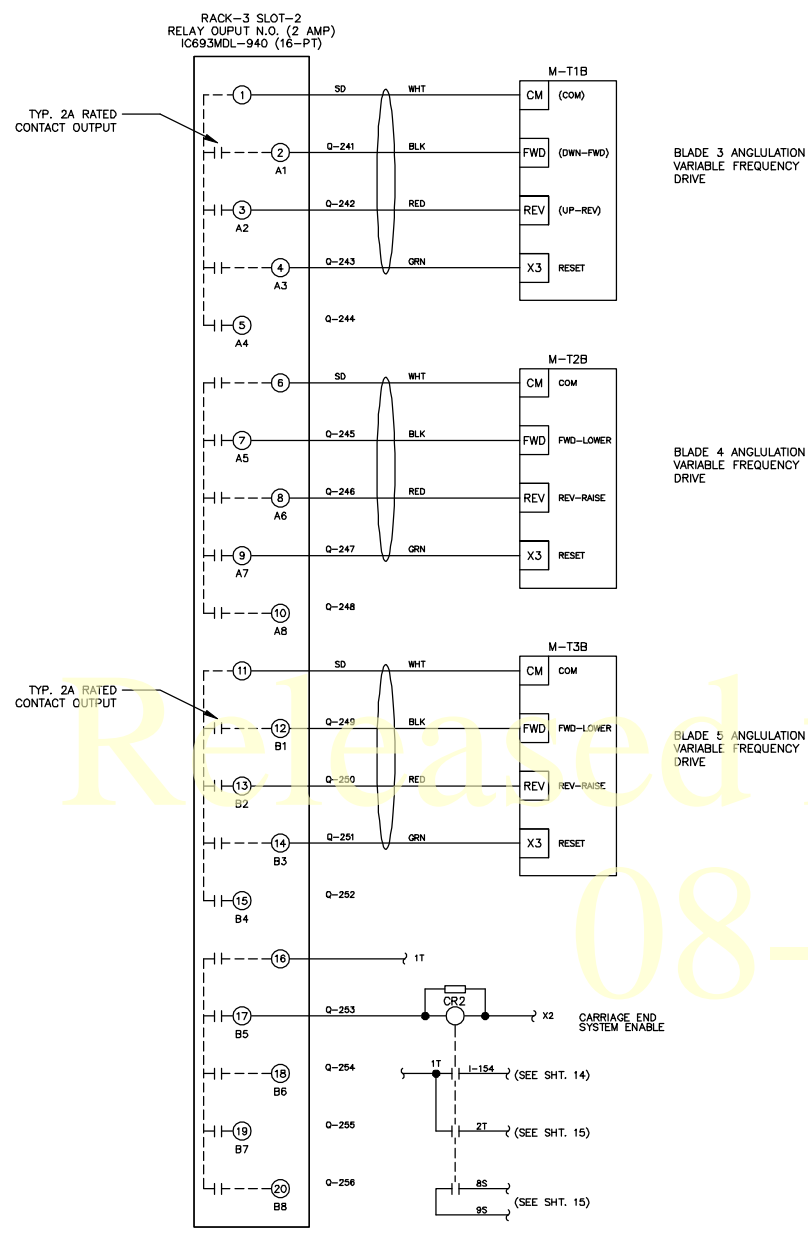


TYP. 2A RATED
CONTACT OUTPUT

ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [0.004] MACHINED SURFACES NOT SPECIFIED [250]						
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FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED	DATE	MFG.	CYBER, AT, ELE, SCHEM, 230V, US			
CHECKED	VDC	DATE	DRAWN	G.Bowers	DATE	10/30/00
FINISH PAINT			SCALE	NONE	PAGE	16 of 21
DASH NO.			90507		REV.	0

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

BELDEN CABLE (9418) EFFECTIVE
FRAME #358 FORWARD



TRAVELLING END CONTROL PANEL

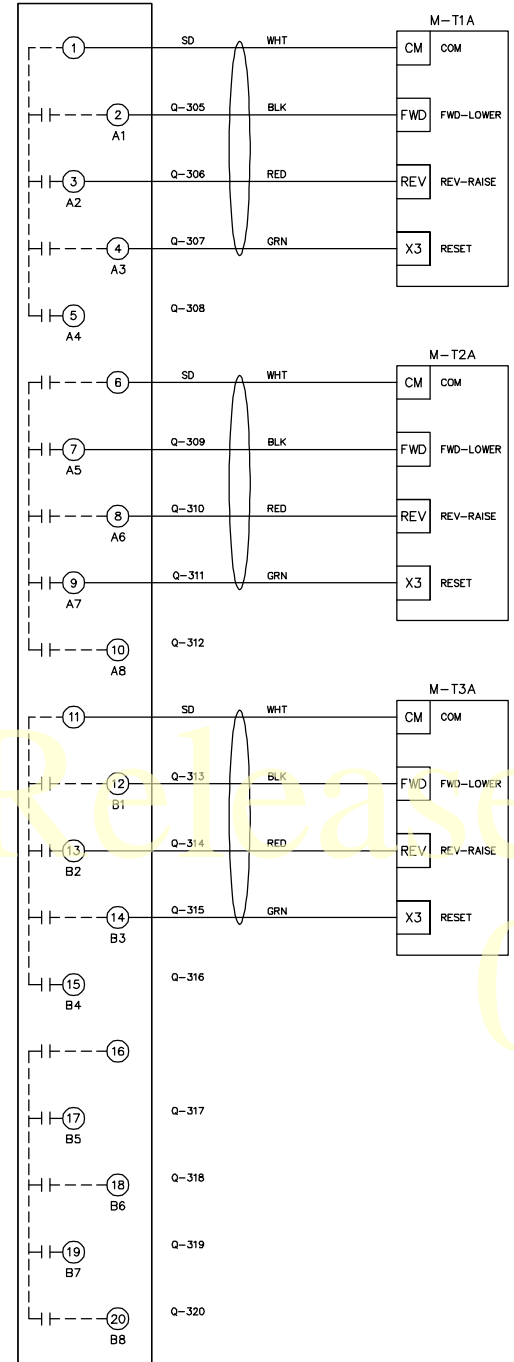
Released for Production
08-Mar-28

ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
<small>DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]</small>						
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FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED	DATE	MFG.	CYBER, AT, ELE, SCHEM, 230V, US			
CHECKED	VDC	DATE	DRAWN	G.Bowers	DATE	10/30/00
FINISH PAINT: X SCALE: NONE PAGE: 17 of 21			DASH NO.: 90507 REV.: 0			

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

BELDEN CABLE (9418) EFFECTIVE
FRAME #358 FORWARD

RACK-3 SLOT-4
RELAY OUTPUT N.O. (2 AMP)
IC693MDL-940 (16-PT)

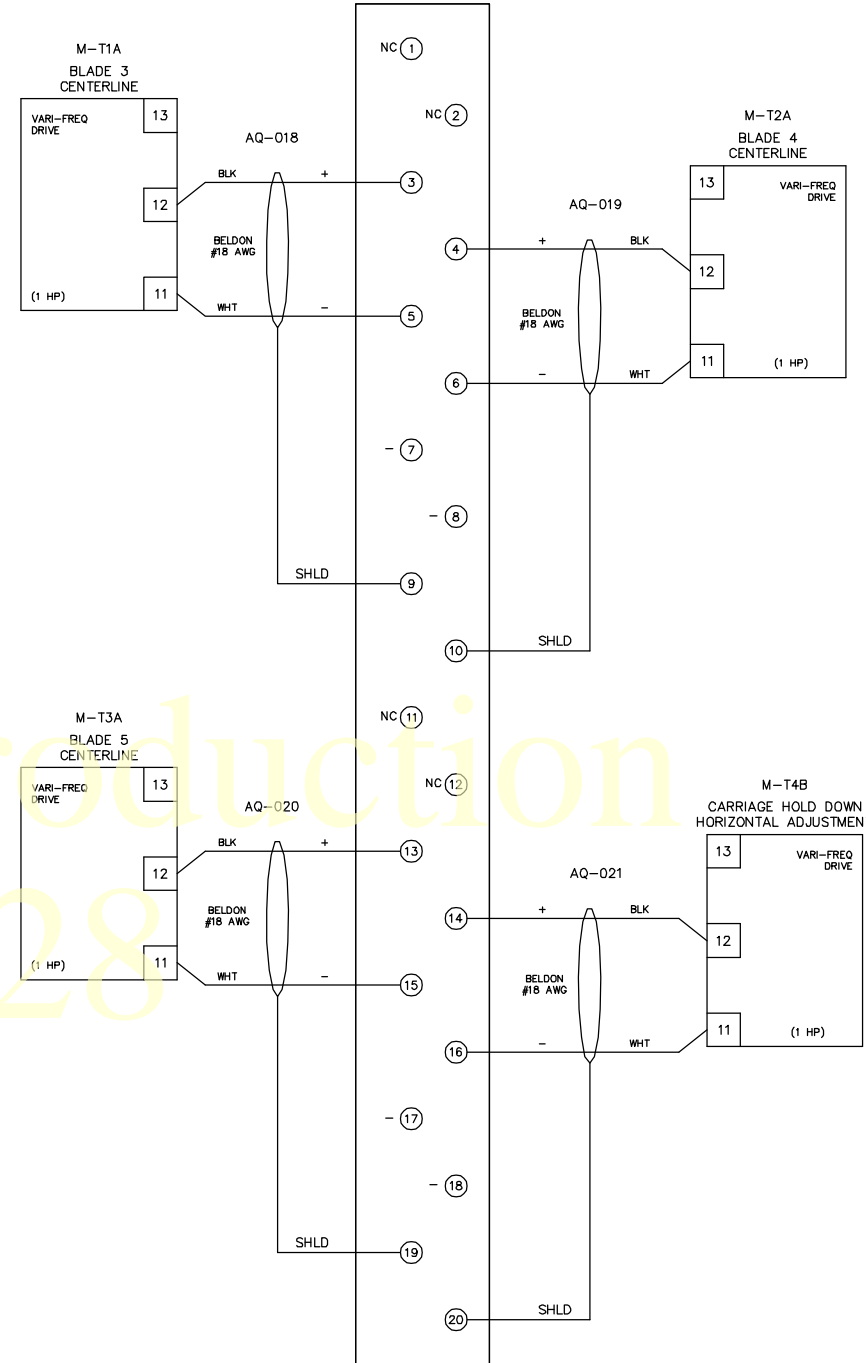


BLADE 3 CENTER LINE
VARIABLE FREQUENCY
DRIVE

BLADE 4 CENTER LINE
VARIABLE FREQUENCY
DRIVE

BLADE 5 CENTER LINE
VARIABLE FREQUENCY
DRIVE

RACK-3 SLOT-5
ANALOG OUTPUT +/- 10VDC
HE693DAC410



Released for Production
08-Mar-28

- TOUCHSCREEN PANEL
- TERMINALS LOCATED IN TRAVELING END CONTROL PANEL
 - TERMINALS LOCATED IN STATIONARY END CONTROL PANEL

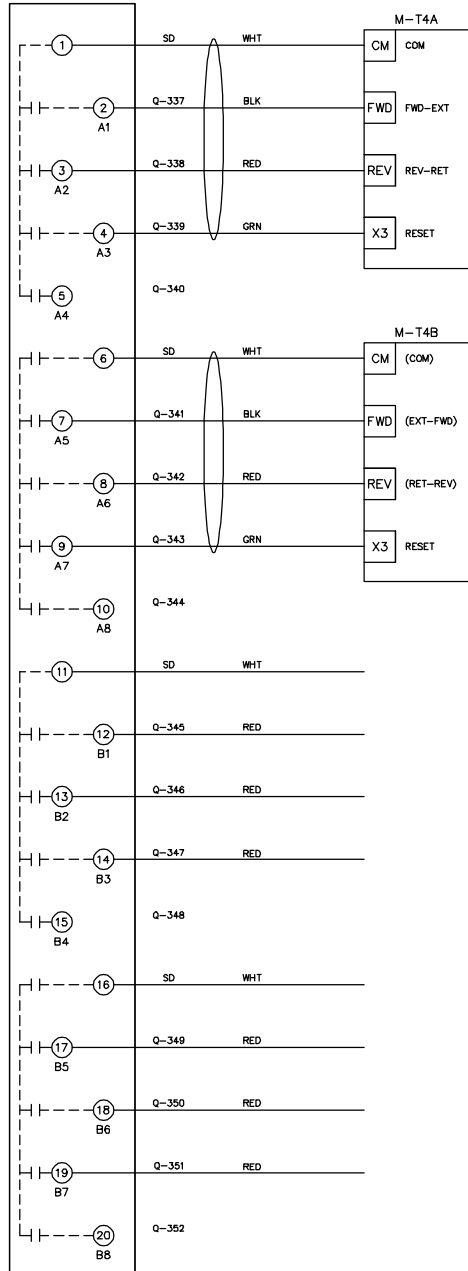
KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

ITEM QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1°] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [25°]					
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FEATURES		MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED	DATE	MFG.	CYBER, AT, ELE, SCHEM, 230V, US		
CHECKED	VDC	DATE	DRAWN	G.Bowers	DATE
FINISH PAINT		SCALE	PAGE		REV.
X		NONE	18 of 21		0
90507		DASH NO.			

VFD SETTINGS

BELDEN CABLE (9418) EFFECTIVE
FRAME #358 FORWARD

RACK-3 SLOT-6
RELAY OUTPUT N.O. (2 AMP)
IC693MDL-940 (16-PT)



CARRIAGE
INFEED CONVEYOR
HORIZONTAL ADJUSTMENTS

CARRIAGE
HOLD DOWN CONVEYOR
HORIZONTAL ADJUSTMENT

VFD SETTINGS FOR THE MODEL #AF-300 MINI
MUST BE FOUND ON DRAWING NUMBERS.

94001-CYBER AT ANGLE/CENTERLINE
94002-CYBER AT CARRIAGE
94003-CYBER AT INFEED

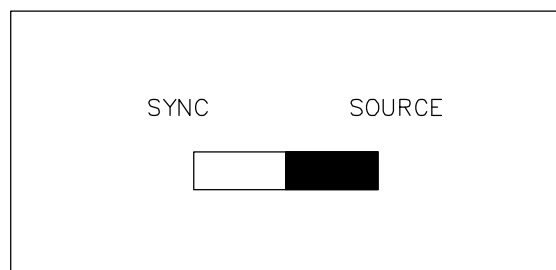
VFD SETTINGS FOR MODEL #6KE11 SERIES

Parameter	Description	Carriage	Infeed	All Others
F01	Frequency Command	2	1	1
F02	Operation Method	2	2	2
F07	Acceleration Time	1.00	1.00	1.00
F08	Deceleration Time	0.60	0.50	0.50
P03	Rated Current	7.75	7.75	Default

CHANGING PARAMETER SETTINGS

- 1) Press the PRG key to start the program mode
- 2) Press the Up/Down arrow keys to select the parameter to change.
- 3) Press the FUNC key to display the data
- 4) Use Up/Down arrow keys to change the data.
- 5) Press the FUNC key to store the data
- 6) Repeat step 2 thru 5 for all parameters that are to be changed.
- 7) After all settings have been made, press the PRG key to exit the program mode.

VFD SWITCHES



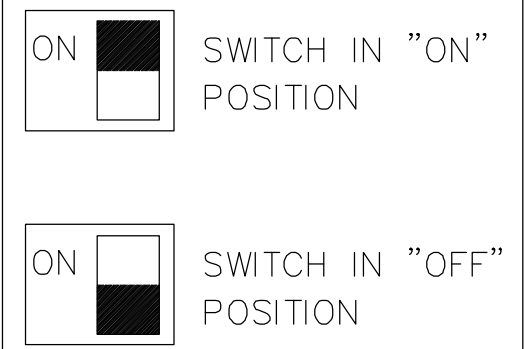
Released for Production
08-Mar-28

ITEM	QTY.	PART NAME	MATERIAL AND/ OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
<small>DIMENSION TOLERANCES, UNLESS OTHERWISE SPECIFIED: FRACTIONS ± [1/32] DECIMALS ± [0.01] ANGLES ± [1'] TOTAL RUNOUT ± [] MACHINED SURFACES NOT SPECIFIED [250]</small>						
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FEATURES X			MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			
APPROVED	DATE	MFG.	CYBER, AT, ELE, SCHEM, 230V, US			
CHECKED	VDC	DATE	DRAWN	G.Bowers	DATE	10/30/00
FINISH PAINT: X SCALE: NONE PAGE: 19 of 21			DASH NO.: 90507 REV.: 0			

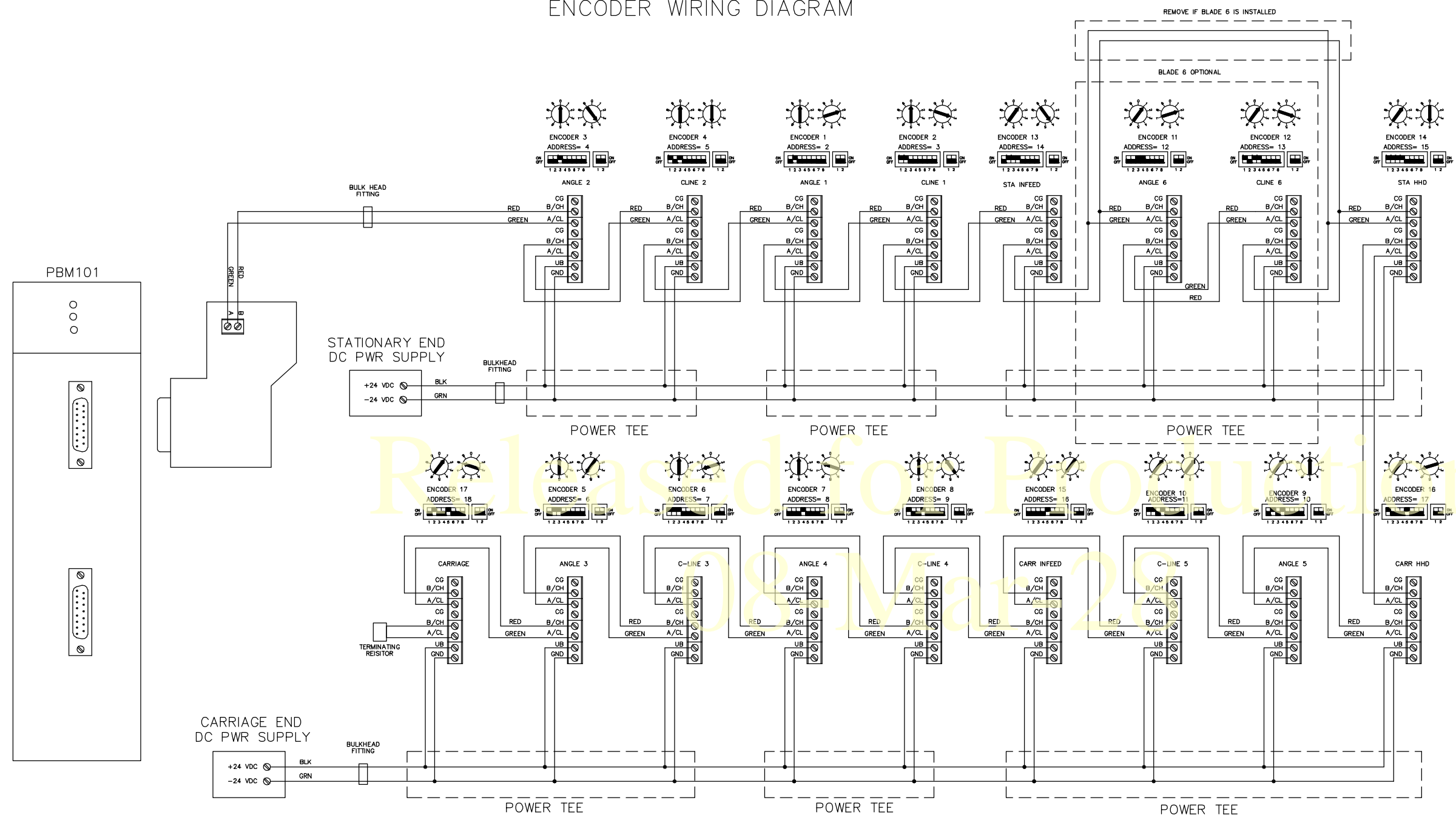
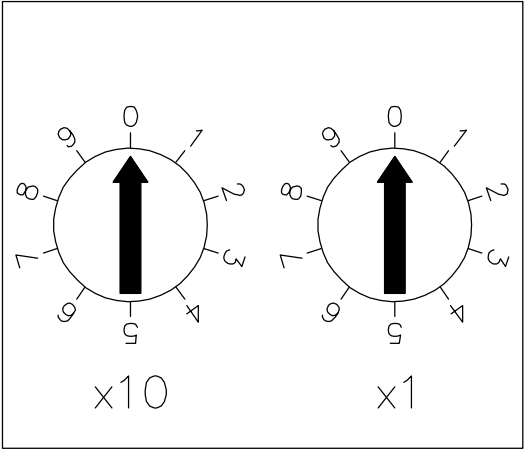
KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

ENCODER WIRING DIAGRAM

ENCODER (P/N 504518)
FRAME #269 THRU #384

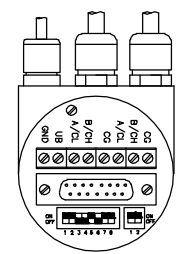


ENCODER (P/N 504460)
FRAME #385 ONWARD



ELECTRICAL CONNECTIONS

TERMINAL	DEFINITION
CG	NOT CONNECTED
B/CH	POSITIVE SERIAL TRANSMITTED/RECEIVED DATA (PAIR 1)
A/CL	NEGATIVE SERIAL TRANSMITTED/RECEIVED DATA (PAIR 1)
CG	NOT CONNECTED
B/CH	POSITIVE SERIAL TRANSMITTED/RECEIVED DATA (PAIR 2)
A/CL	NEGATIVE SERIAL TRANSMITTED/RECEIVED DATA (PAIR 2)
UB	VOLTAGE SUPPLY
GND	VOLTAGE SUPPLY



ITEM	QTY.	PART NAME	MATERIAL AND/OR DESCRIPTION	LENGTH	CODE	DWG.NO./PART NO.
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MiTek Industries, Inc. 4203 SHORELINE DRIVE, EARTH CITY, MO. 63045			MANUFACTURE X DRAWING X CHECKED X DATE X SCALE X FINISH PAINT X			
CYBER, AT, ELE, SCHEM, 230V, US		APPROVED: VDC DATE: 10/30/00 DRAWN: G.Bowers DATE: 10/30/00 SCALE: NONE PAGE: 20 of 21 DASH NO.: 90507 REV.: 0				

KEY	NO. OF HOLES	DIA.	DEPTH	DIA.	DEPTH	REMARKS
A	X	X	X	X	X	
		HOLE		TAP		

