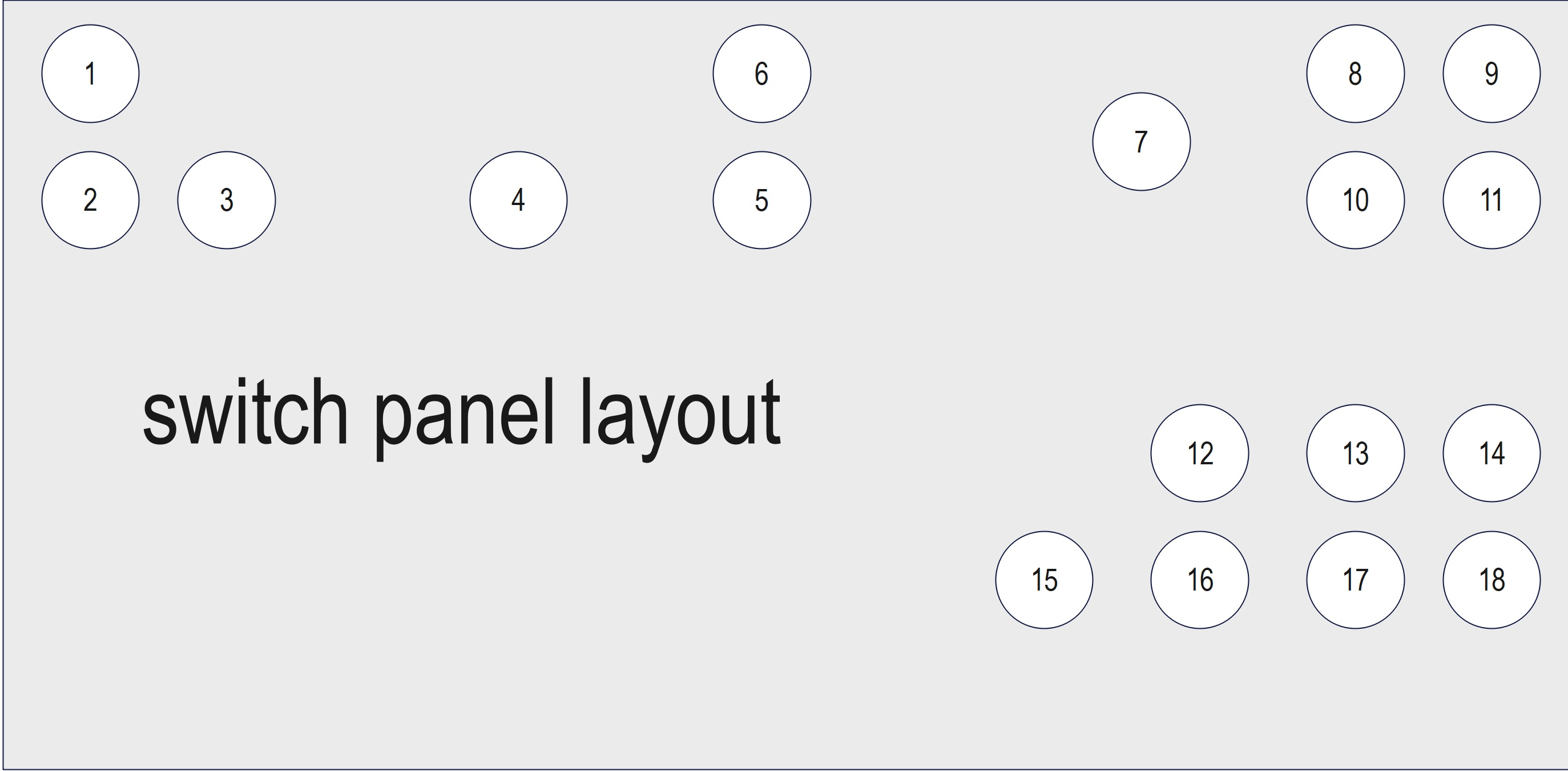


switch diagram

Caution

This switch diagram and run instructions are not from the manufactuer, it was created by AW machinery to help the user understand machine run funtion and operation of the controle panel, keep in mind this is our understanding of the machine



- 1 E-stop

2 Power

3 Moulder light

4 Setup mode, switch to left / run mode, switch to right

5 Feed wheels down

6 Feed wheels up

7 Auto feed wheels adjustment, left switch position / manual feed wheels adjustment, right switch position

8 Stop feed wheels

9 Start feed wheels

10 Feed wheels jog fwd

11 Feed wheels jog back

12 Heads free indicator light

13 Heads locked / heads free left switch position, heads locked ready for startup / right switch position heads free

14 Stop all heads

15 Last bottom head

16 Top heads

17 Side heads

18 Fist top heads
- MACHINE STARTUP GUIDE

Make sure the moulder has air connected to the machine.
Connect 480V power to the disconnect. If rotation is incorrect, you will not be able to start the machine.

HOW TO CHECK ROTATION

1. First, make sure the safety hood is properly closed and all E-stops are released.
2. At the electrical cabinet of the machine, find the device labeled* ****11P1***at the top left corner of the cabinet.
3. If the hood is properly closed, E-stops are released, and rotation is correct, the red indicator light on the device ****11P1**** should be illuminated. by ****RST****This is a phase detector.
4. If ****RST**** is not illuminated, disconnect the main power source and change the phase orientation.
5. Once the phase orientation is changed, ****RST**** should be illuminated.

STARTING THE MACHINE

1. Turn ****switch 4**** to the right position.
2. Turn ****switch 13**** to the right position.
3. Press ****switch 2****—it should illuminate. If not, an E-stop is tripped, the safety hood is not properly latched, or the phase is incorrect.
4. ****Switch 12**** should illuminate after about ****15 seconds****. upon power up
5. Once ****switch 2**** and ****switch 12**** are illuminated, turn **switch 13**** to the left position, **switch 12**** will no longer be illuminated and you can start the heads ****one at a time****.
6. Once a head reaches full speed, its corresponding switch will illuminate.
7. Once ****all heads**** are started and ****all switches**** are illuminated, you can start the feed (****switch 9****).

FEED WHEELS ADJUSTMENT

- If ****switch 7**** is in the ****right**** position, you can manually move the feed wheels with ****switches 5 and 6****.
- If you move ****switch 7**** to the ****left**** position, it will automatically adjust the feed wheels according to the head's position.

NOTES:

- You can ****only start feed wheels forward**** once ****all heads**** are running.
- You can ****only jog**** the feed wheels ****backward**** if ****all heads**** are stopped.
- ****Switch 14**** stops all heads.