ELECTRICAL FUNCTION SEQUENCE

- Unit is plugged into a power source, R & S wires.
- Power is present at the Rectifier AC terminals 1 & 2 – rectifier is currently OFF/not activated.
- One leg of the Motor and Magnet Switch coil (A2/b) is powered.
- Power is present at the Power Switch and is currently in the OFF position.

Rectifier: Model OPR 109F / AC 100/110V / Output DC90V, 1A
Magnet Switch: Model S-U12FT
ELECTRICAL FUNCTION SEQUENCE

- Power Switch is now in the ON position.
- Power is now present at the Magnet Switch (V/4) and Foot Switch Connector “2”.
- The unit is currently in standby mode, it will start to make a bend as soon as the momentary Start button is depressed.
ELECTRICAL FUNCTION SEQUENCE

The following happens simultaneously:

- The momentary Start button is depressed powering the Magnet Switch coil (A1/a) terminal via the 90° Micro Switch & Rotary Switch (currently set to 90°) causing all the Magnet Switch contacts to close.
- The Magnet Switch is latched in the ON position when contacts S/3 & V/4 are closed diverting and maintaining power to the Magnet Switch coil (A1/a).
- The Magnet Switch contacts R/1 & U/2 are closed powering the 2nd leg of the Motor, it’s now rotating.
- The Magnet Switch contacts T/5 & W/6 are closed activating the Rectifier which now outputs DC90V to the Magnet Clutch transmitting the Motor rotation to the reduction box and external gears moving the bending arm. The unit is currently making a bend.
The 90° Micro Switch opens momentarily as the mechanical Carrier arm passes over it disrupting power to the Magnet Switch (A1/a) terminal causing all the contacts to open returning the unit to the standby mode.

- Rectifier: Model OPR 109F / AC 100/110V / Output DC90V, 1A
- Magnet Switch: Model S-U12FT