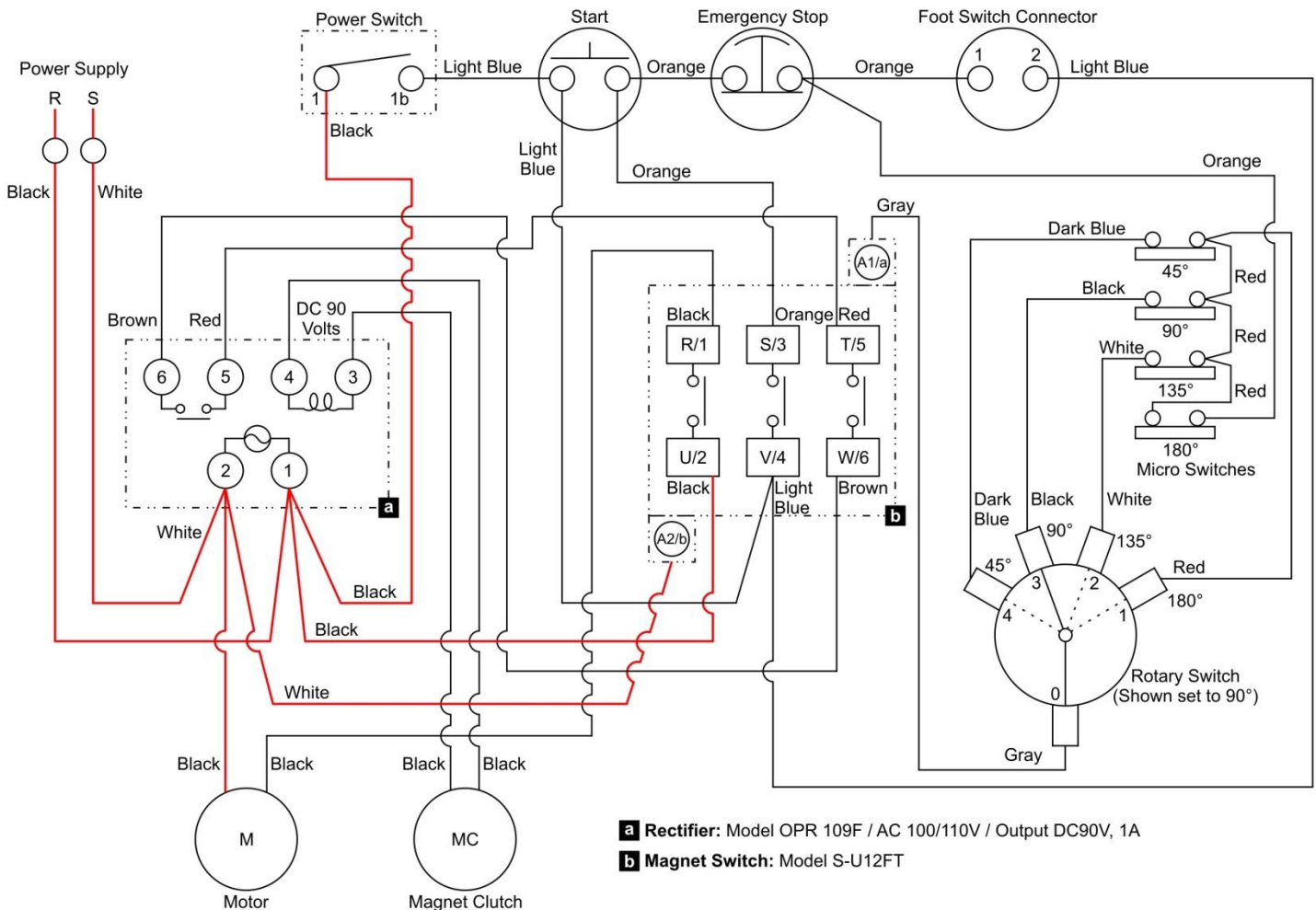


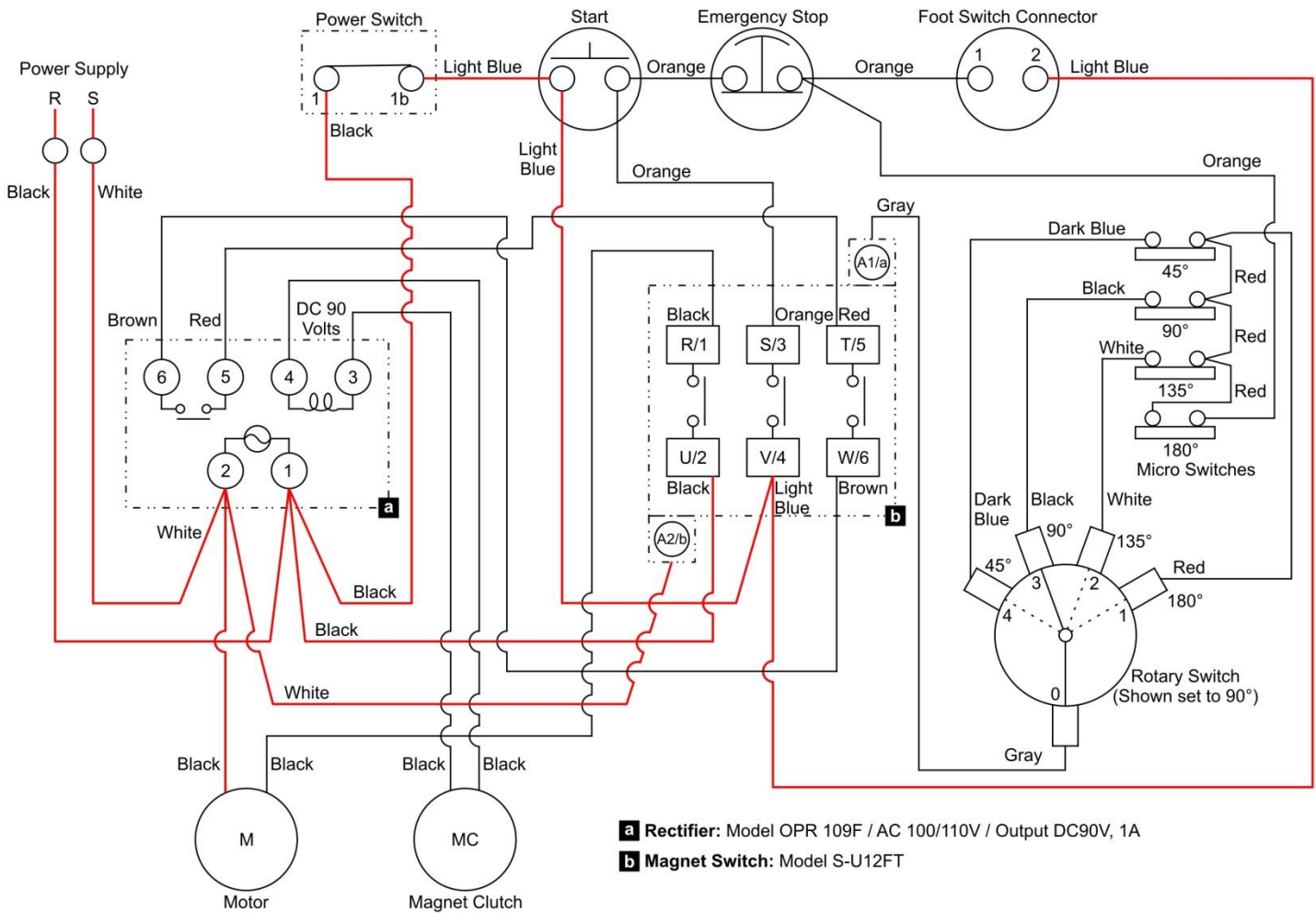
## ELECTRICAL FUNCTION SEQUENCE

- 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.



## ELECTRICAL FUNCTION SEQUENCE

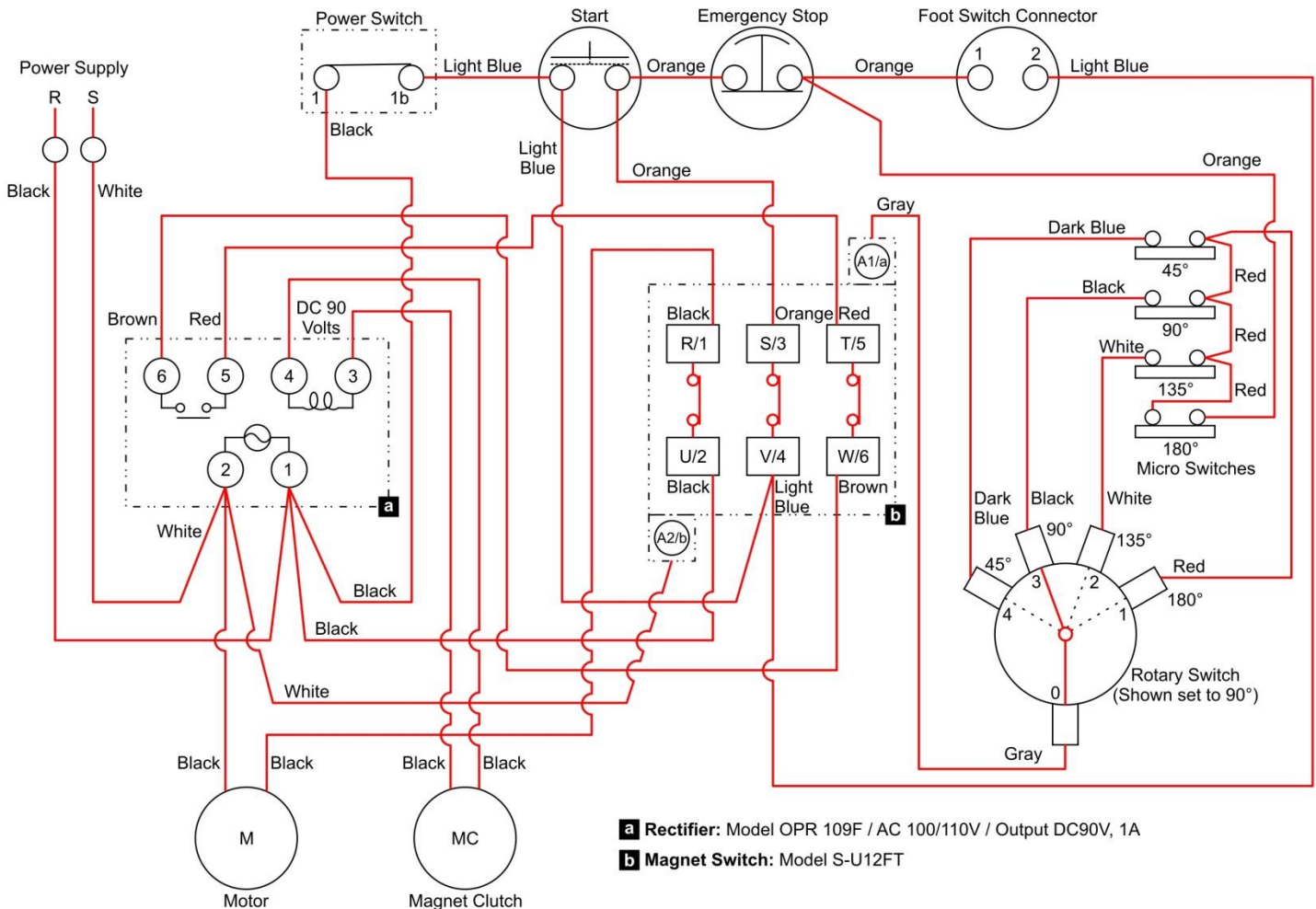
- Power Switch is now in the ON position.
- Power is now present at the Magnet Switch (V/4) and Foot Switch Connector “2”.
- The unit is currently in standby mode, it will start to make a bend as soon as the momentary Start button is depressed.



## 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 2<sup>nd</sup> 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.*



## ELECTRICAL FUNCTION SEQUENCE

- 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.

