SEQUENCE OF OPERATION

MACHINE OPERATIONS:
A. PRESS "MOTOR START" PUSH-BUTTON "SPIF", WORKS START.
B. SELECT SPINDLE SPEED BY TURING SELECTOR SWITCH "VSD" TO "INC", ENERGIZING RELAY "TOR" WHICH ENERGIZES TOOL MOTOR, SPINDLE STARTS AND PRESSURE SWITCH "VPS" IS ACTIVATED. "VPS" ENERGIZES "VTR" AND AFTER A TIME DELAY "VTR" IS ENERGIZED, PERMITTING MOVEMENT OF MACHINE.
C. PRESSING "SPIF" STOP BUTTON "SBS" STOPS SPINDLE AND FEED MOVEMENTS SIMULTANEOUSLY.

LUBRICATION OPERATIONS:
A. PRESSURE SWITCH "VPS" IS CLOSED.
1. TIMER "VTR" COUNTER IS ENERGIZED WHEN MACHINES STARTS.
2. CONTACT "VTR" CLOSES AND ENERGIZES SPINDLE MOTOR "VSM".
3. CONTACT "VTR" CLOSES AND ENERGIZES SPINDLE MOTOR "VSM".
B. TIMER "VTR" TIMES OUT.
1. CONTACT "VTR" OPENS, DE-ENERGIZING SPINDLE MOTOR "VSM".
2. CONTACT "VTR" OPENS, DE-ENERGIZING SPINDLE MOTOR "VSM".
3. CONTACT "VTR" OPENS, DE-ENERGIZING SPINDLE MOTOR "VSM".
4. LUBRICATION PRESSURE ACTUATOR PREPARES PRESSURE SWITCH "VST" AND RELAYS "GCT", CONTACT "GCT" AND RELAYS "GCT" AND STOPS SPINDLE MOTOR "VSM".
5. CONTACT "VTR" OPENS, DE-ENERGIZING "VTR".
6. LUBRICATION PRESSURE DE-ACTIVATES PRESSURE SWITCH "VST" AND NO UNEADING OCCURS.

INITIAL OPERATIONS:
1. SWV樺 (VTR) ACTIVATED BY SPINDLE DIRECTION LEVER ENERGIZED "VPS" (VTR) OPERATES WHEN SPINDLE CLUTCH ENGAGED
2. "VPS" OPERATES BY NORMAL LUBE PRESSURE
3. "VST" OPERATES BY AUXILIARY LUBE SUPPLY

PRIORITY DRAWING

ADTS - ENGINEERING DIVISION
ENGINEERING STANDARDS MANUAL
MACHINE II SCHEMATIC DIAGRAM

DESIGNER
EDIT CONTROL, DIAGRAM TO BE PROJECT-SPECIFIC
AS REQUIRED PER LUAL DRAWING MANUAL