**SR Furnace Machine**

**Auto Cycle Operation Sequence**

Step 1: - Home Condition OK

Door 1 Down LSW ON, Door 2 Down LSW ON, Pusher Rev LSW ON, OHE Rev LSW ON.

**Unloading Sequence**

Step 2: - Cycle Start, OHE move Forward till Middle Pos. LSW ON.

Step 3: - Door 2 Open till Up LSW ON then OHE Move Forward till FWD LSW ON.

Step 4: - OHE Move Up till OHE Up LSW ON and move Backward till Middle LSW ON.

Step 5: - Door 2 Close till Down LSW ON and OHE move down on trolley

Step 6: - After Door 2 close Door 1 will be Open till Up LSW

**Loading Sequence**

Step 7: - When Door 1 Open, Pusher will move forward till Fwd LSW ON only if Trolly

Step 8: - Pusher will move reverse after some delay till Rev LSW ON.

Step 9: - Door 1 Close till Down LSW when Pusher reached at Middle Pos LSW ON.

**Heating Sequence**

Heating operation will start after completion of loading sequence and internal heating cycle will control by dedicated controller.

**\*Note** - Trolley 1,2,3 sequence will be clear in the period of project execution on site because existing trolleys are operated manually by operator.

**Manual Operation**

Blower Motor, Trolley Motors, RC Fan Motors will operate for Operating Panel in any mode auto/manual

Trolley 1 Operate from Operating Box Zone 1

Trolley 2 Operate from Operating Box Zone 2

Trolley 3 Operate from both Zone 1 & 2

**Interlocks**

Pusher will operate only if Door 1 is Full Open.

Loading sequence will operate after unloading sequence only.