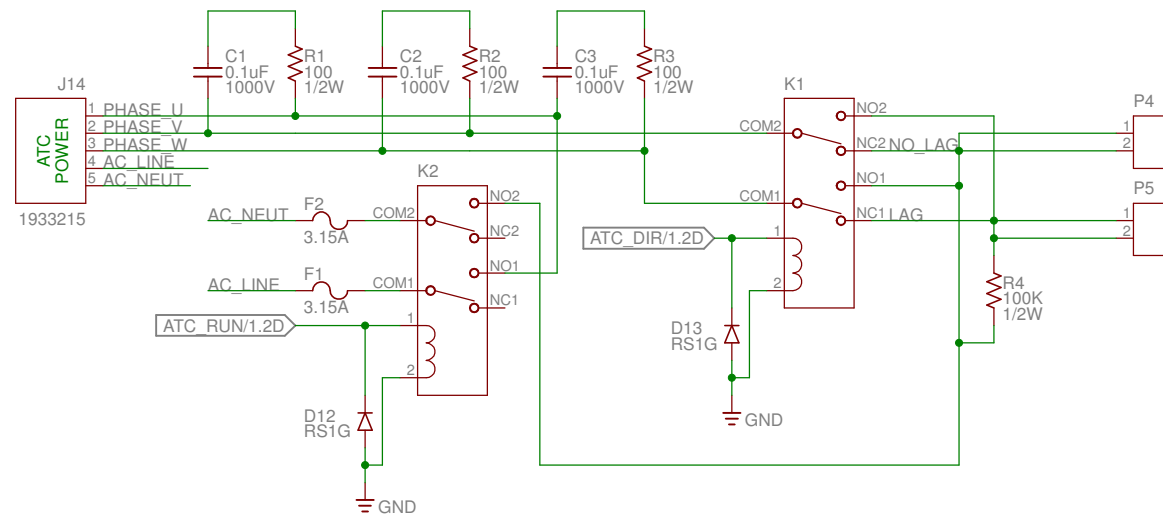


TITLE: Lathe Tool Changer V1R2	
DETAIL: SIGNAL CONDITIONING	
(C) 2013 TORMACH, LLC	
MOD: 3/28/2013 4:15:58 PM	SHEET: 1/2



DEFAULT DIRECTION FOR K1 IS FORWARD (NC). 24V ON ATC\_REV WILL SWITCH TO REVERSE DIRECTION (NO).

R1/C1, R2/C2, R3/C3 ARE AC SNUBBER CIRCUITS FOR SUPPRESSING INDUCTIVE SPIKES ESPECIALLY AT RELAY OPEN/CLOSE.

P4/P5 CONNECT TO EXTERNAL BULK CAPACITOR.

TITLE: Lathe Tool Changer V1R2	
DETAIL: AC MOTOR DRIVE	
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MOD: 3/28/2013 4:15:58 PM	SHEET: 2/2