

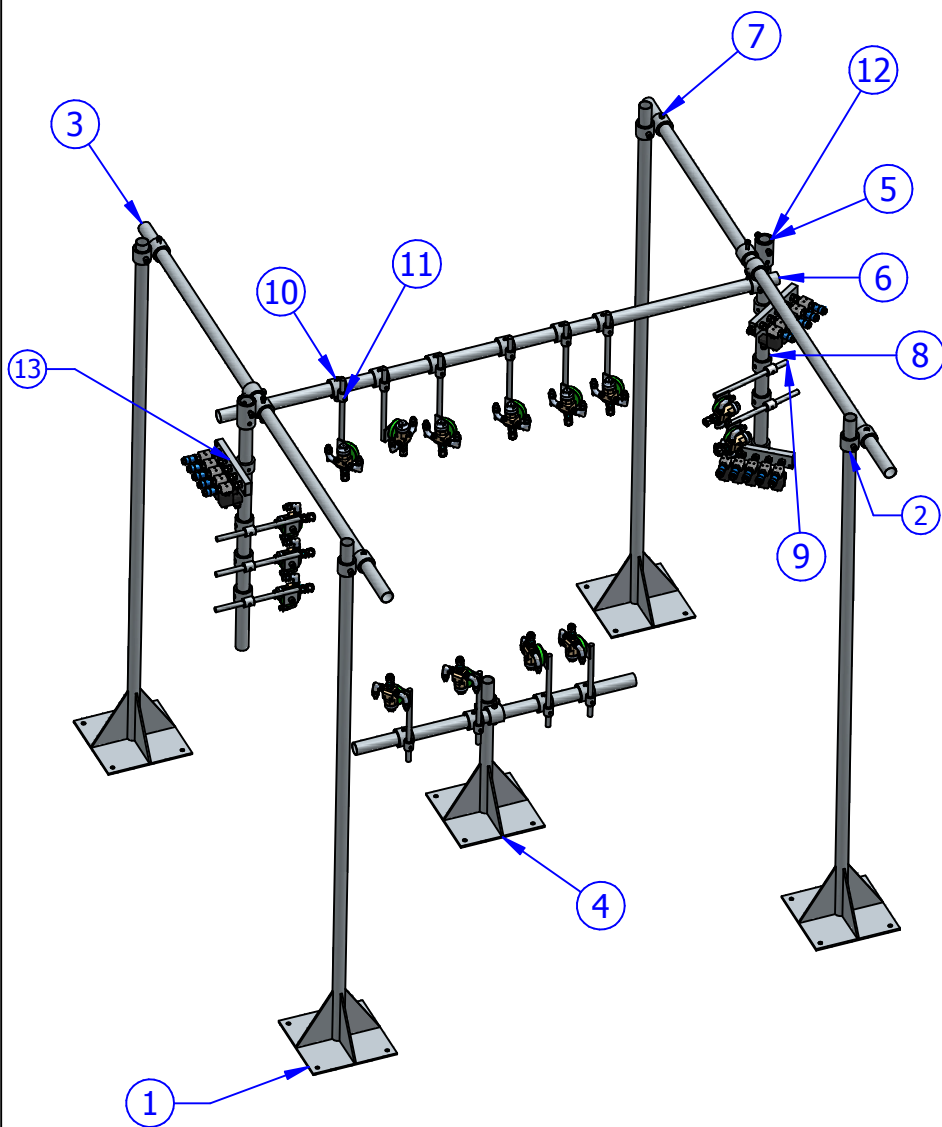
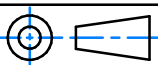



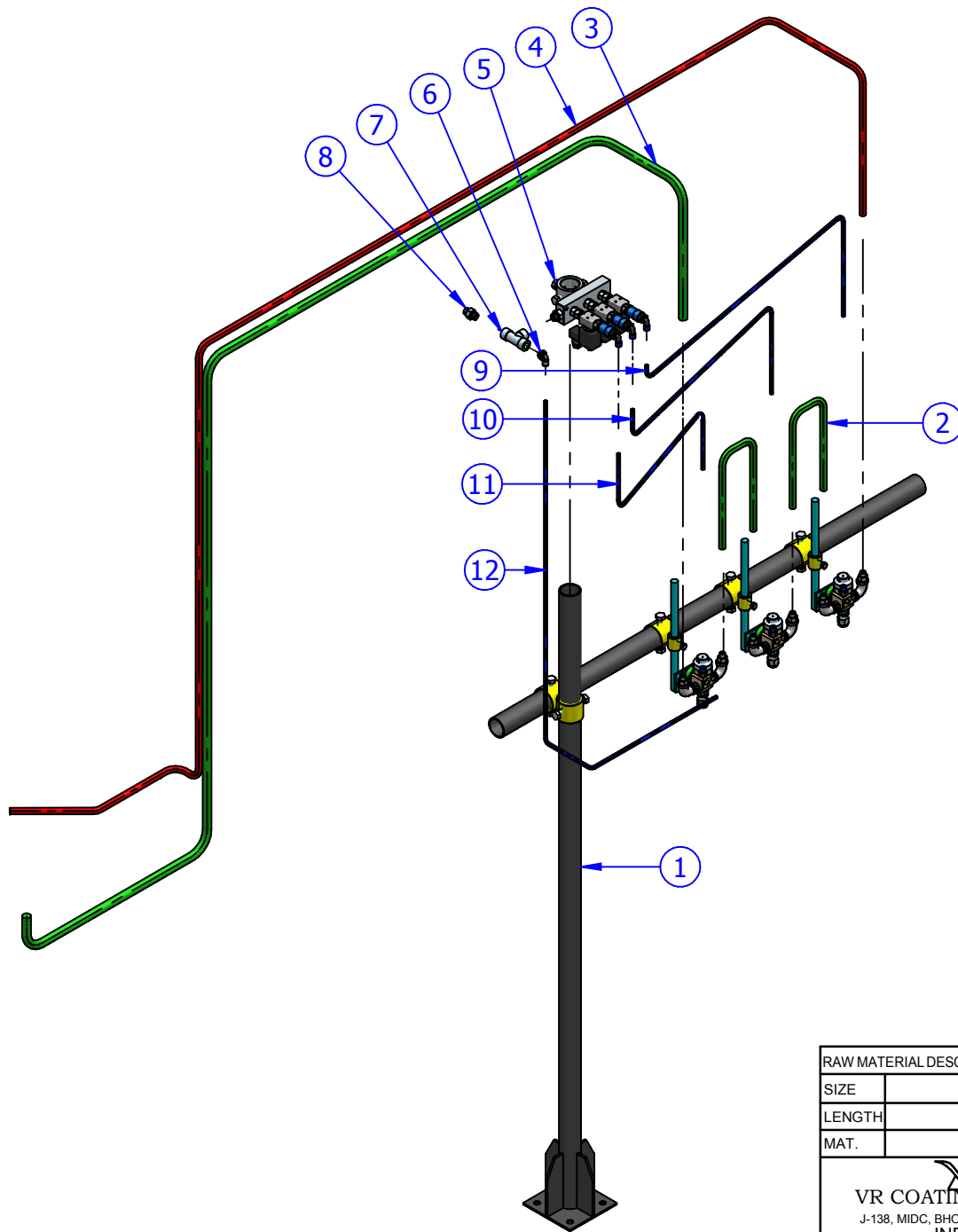
6	03 024 001 00	1/4" SLIDE VALVE	5	
5	03 015 001 00 JAN	SOLENOID VALVE 3/2 1/4" BSP (C-309)	5	
4	14 002 002 07	CONNECTOR 3/8"X3/8"	1	
3	51 101 000 01	SWIVEL 1/4" BSP	5	
2	14 001 001 19	CONNECTOR (1/4"X1/4")	10	
1	50 004 041 07	SOLENOID MOUNTING BLOCK	1	
SR.NOS.	PART NO.	PART NAME	QTY	W&T

RAW MATERIAL DESCRIPTION		NOTE:			
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.			
LENGTH					
MAT.					
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA		DRN.	CKD.	APPD.	PART NAME
		SIGN	richard	ALBERT	N/D
		DATE			PART NO.
		SCALE	NOT TO SCALE		50 004 022 00

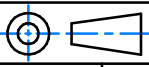



13	50 004 022 00	SOLENOID MOUNTING BLOCK ASSLY	3	
12	50 004 074 07	BUSH	2	
11	24 002 041 19	ALLEN BOLT M8	1	
10	15 330 015 07	ALLEN BOLT M12X30	2	
9	50 004 015 00	ROTATING GUN ASSLY	15	
8	50 004 002 07	ROD HOLDER	15	
7	15 325 014 07	ALLEN BOLT (M10 x 25 L)	36	
6	50 004 062 07	PIPE OD 43	1	
5	50 004 008 07	PIPE OD 43	3	
4	50 004 065 07	BOTTOM SIDE LEG	1	
3	50 004 063 07	PIPE 43 OD	2	
2	50 004 061 07	BUSH	7	
1	50 004 060 07	LEG OF GUN MOUNTING STAND	4	
SR.NOS.	PART NO.	PART NAME	QTY	W&T

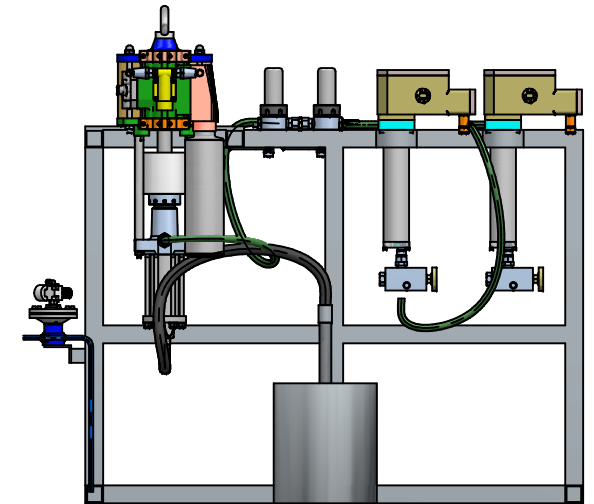
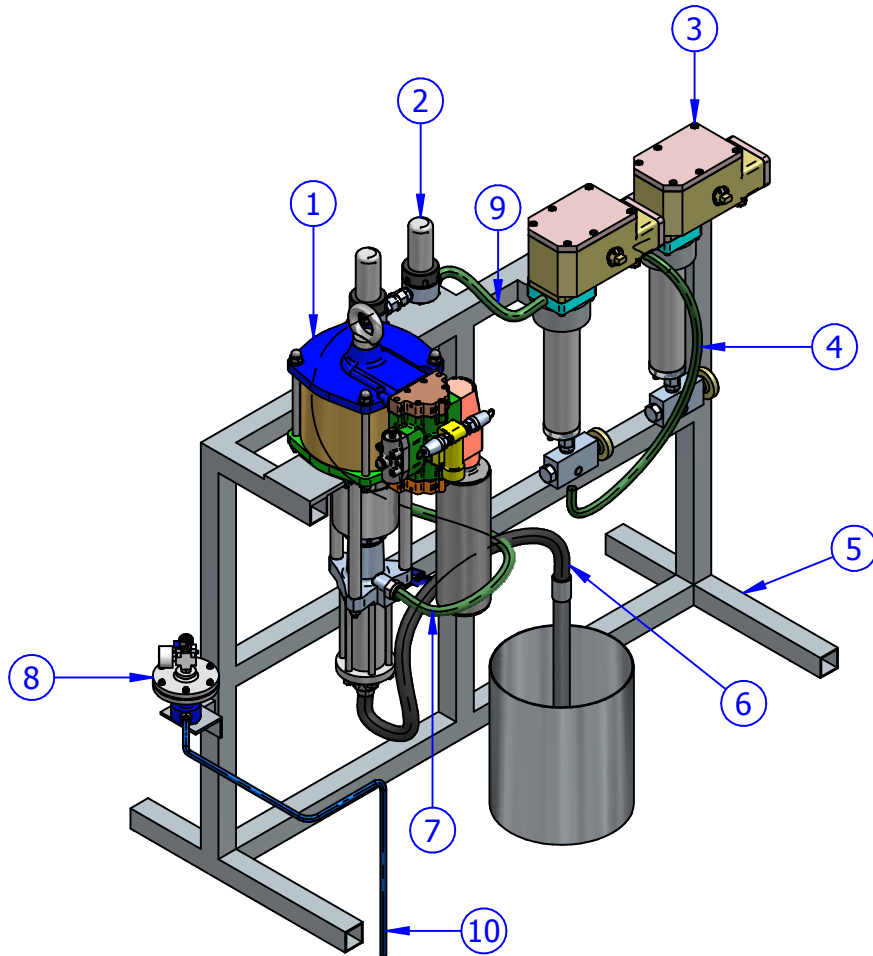
RAW MATERIAL DESCRIPTION		NOTE: HORIZONTAL BARREL					
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.					
LENGTH							
MAT.							
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA			DRN.	CKD.	APPD.	PART NAME	BARREL PAINTING FRAMING
		SIGN	omkar	ALBERT	NVD		
		DATE				PART NO.	50 004 064 00
		SCALE	NOT TO SCALE				





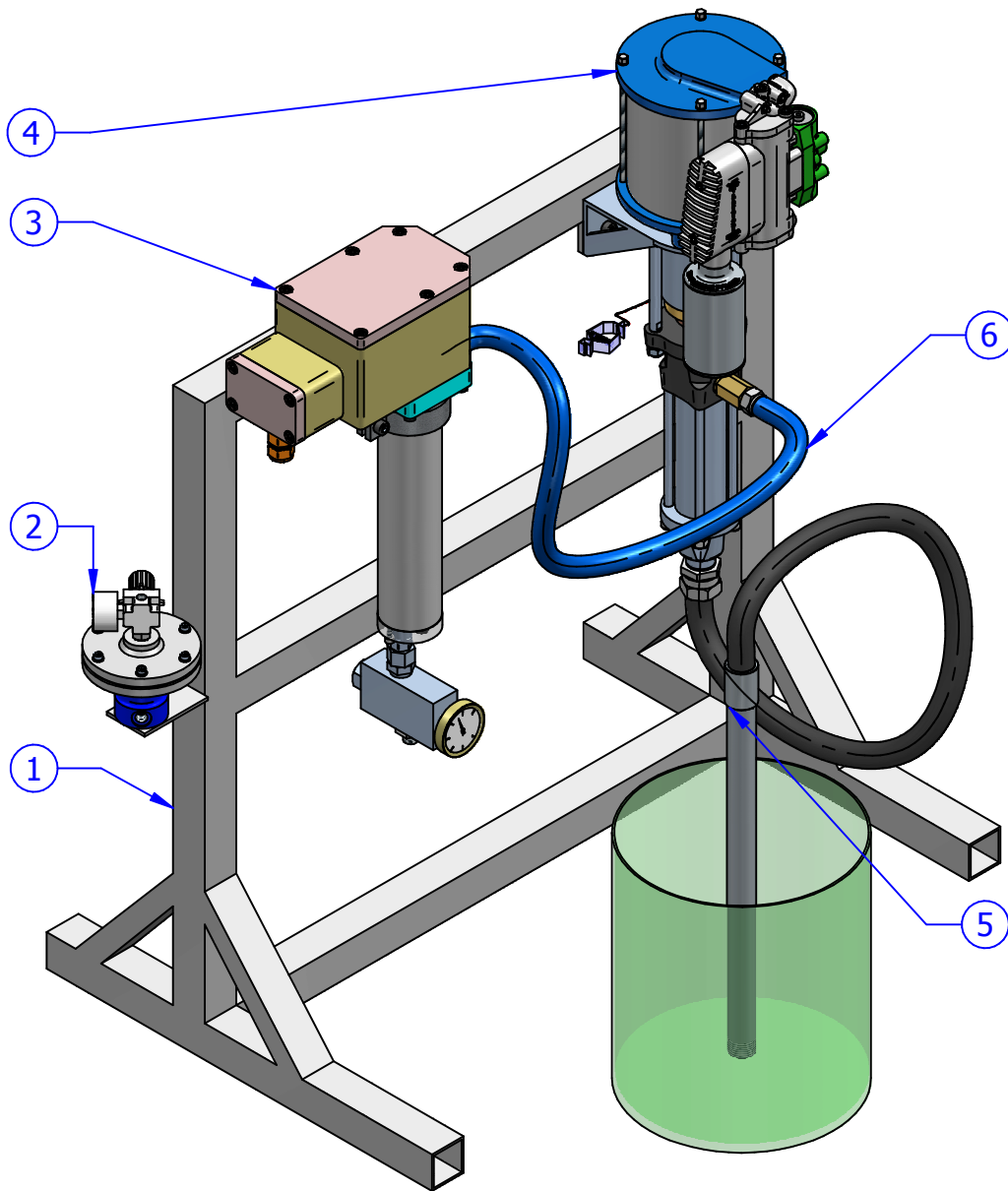
12	03 111 006 08	PU TUBE (8x6) 2.5MTR. LONG	1	
11	03 111 006 08	PU TUBE (8x6) 1.5MTR. LONG	1	
10	03 111 006 08	PU TUBE (8x6) 2MTR. LONG	1	
9	03 111 006 08	PU TUBE (8x6) 2MTR. LONG	1	
8	14 002 002 07	CONNECTOR 3/8"X3/8"	1	
7	34 001 002 07	TEE 3/8"	1	
6	03 102 318 08.	MALE STUD ELBOW	1	
5	50 004 024 00	3-SOLENOID MOUNTING BLOCK ASSLY	1	
4	11 081 007 00	1/4" BSF HP PTFE HOSE 7MTR. LONG	1	
3	11 083 007 00	3/8" BSF HP PTFE HOSE 7MTR. LONG	1	
2	11 081 001 00	1/4" BSF HP PTFE HOSE 1MTR. LONG	2	
1	50 071 092 00	GUN MOUNTING STAND FOR COVER PAINTING SYSTEM	1	
Sr.Nos.	PART NUMBER	PART NAME	Qty.	W&T

RAW MATERIAL DESCRIPTION		NOTE:					
SIZE							
LENGTH							
MAT.							
		ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.					
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA			DRN.	CKD.	APPD.	PART NAME	COVER PAINTING GUN,STAND, VALVE,HOSES&TUBES
		SIGN	ntin	ALBERT	NVD		
		DATE				PART NO.	50 071 129 00
		SCALE	NOT TO SCALE				

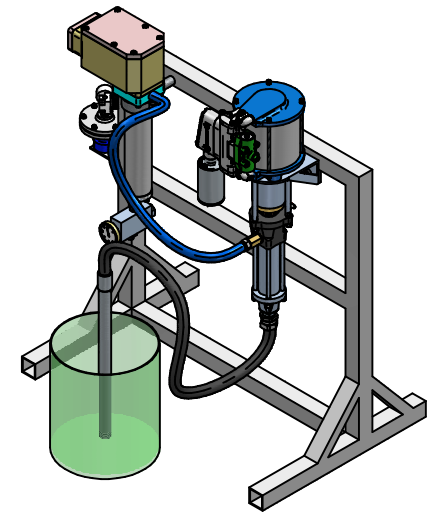
1	25 035 275 04	RHINO PUMP 35.275	1
2	50 085 430 00	TWIN FILTERS ASSEMBLY	1
3	41 005 000 00	INLINE HEATER 3 KW	2
4	11 083 001 00	3/8" PTFE HOSE 1M LONG	1
5	08 001 160 68	MOUNTING STAND	1
6	10 011 000 00	1" SUCTION HOSE, 1 M LONG	1
7	11 083 001 00	3/8" PTFE HOSE 1M LONG	1
8	20 034 000 00	HP BACK PR. VALVE PNEUMATICALLY OPERATED	1
9	11 083 500 00	3/8" PTFE HOSE 0.5M LONG	1
10	50 085 263 00	RETURN ASSEMBLY 1/4"	1
SR. NO.	PART NO.	PART NAME	QTY.

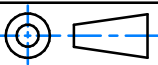



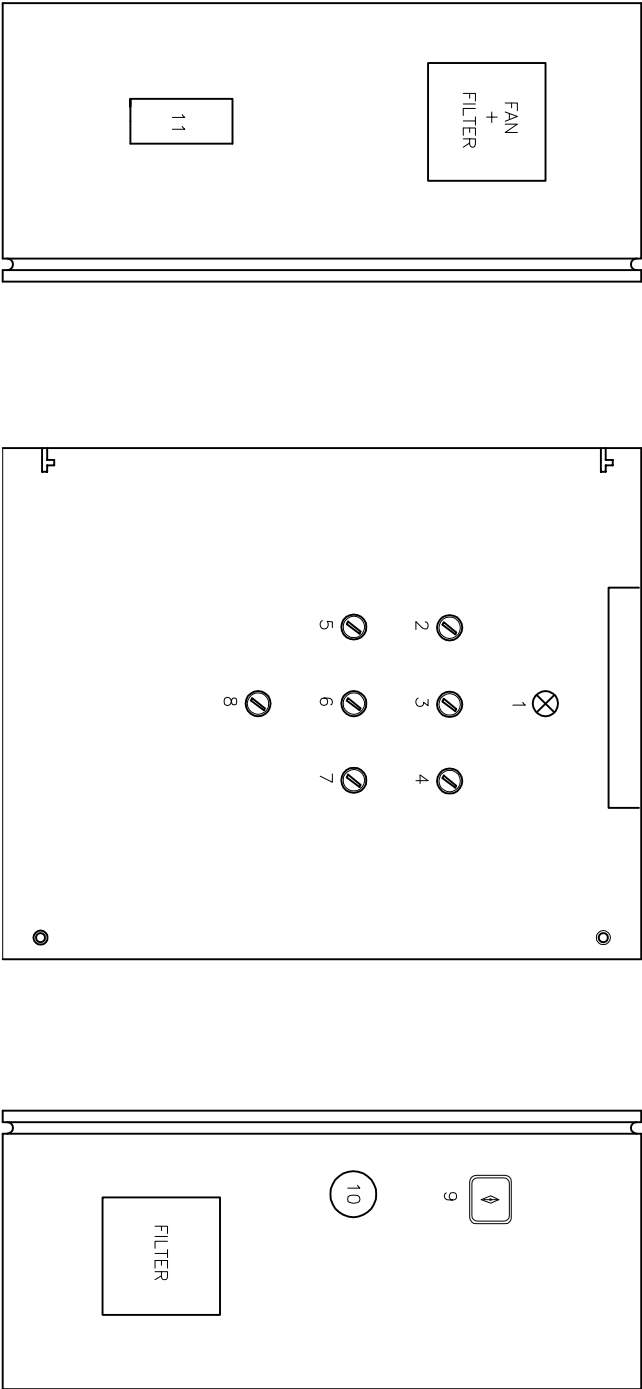
RAW MATERIAL DESCRIPTION		NOTE:						
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.						
LENGTH								
MAT.	ASSEMBLY							
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA			DRN.	CKD.	APPD.	PART NAME	PUMP AND ACCESSORIES ASSEMBLY	
		SIGN	Chetan	ALBERT	NVD			
		DATE					PART NO.	50 085 236 00
		SCALE	NOT TO SCALE					



1	08 001 239 68	STAND FOR PUMP & HEATER	1
2	20 034 000 00	HP BACK PR. VALVE PNEUMATICALLY OPERATED	1
3	41 005 000 00	INLINE HEATER 3 KW	1
4	25 030 150 03	PUMP TIGER 30.150 WITHOUT FILTER N-2	1
5	10 007 000 00	1" SUCTION HOSE	1
6	11 083 007 00	3/8" PTFE HOSE 1 M LONG	1
SR. NO.	PART NO.	PART NAME	QTY.



RAW MATERIAL DESCRIPTION		NOTE:					
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.					
LENGTH							
MAT.	Assembly						
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA		SIGN	Chetan	ALBERT	NVD	PART NAME	TIGER PUMP, STAND AND ACCESSORIES ASSEMBLY
		DATE				PART NO.	50 085 237 00
		SCALE	NOT TO SCALE				



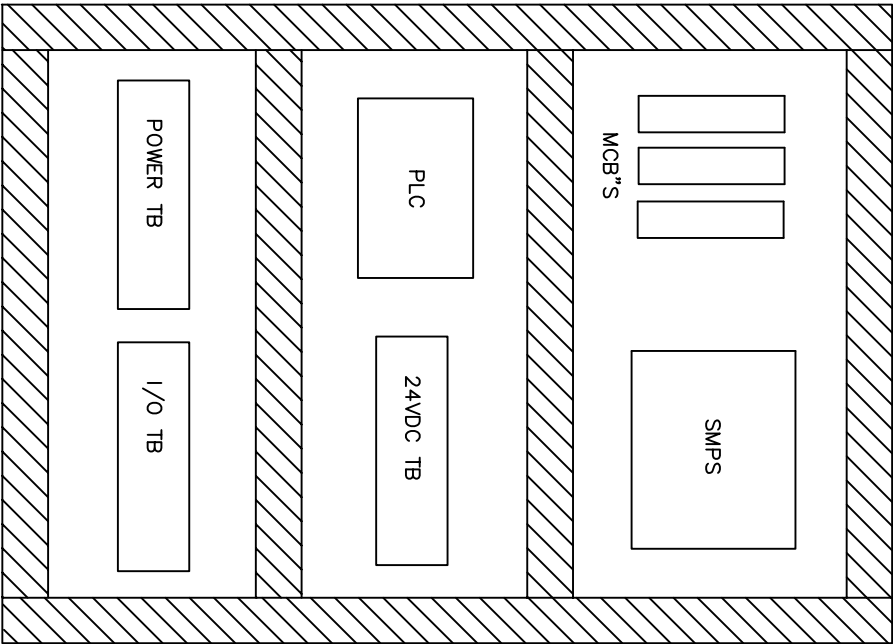
- LEGENDS:**
- 1:POWER ON LAMP
 - 2:SPRAY GUN.1 AUTO/MAN-SS4
 - 3:SPRAY GUN.2 AUTO/MAN-SS5
 - 4:SPRAY GUN.3 AUTO/MAN-SS5
 - 5:AUTO/MANUAL SEL S/W-SS1
 - 6:CYCLE START P.B
 - 7:COUNTER RESET P.B
 - 8:EMERGENCY STOP P.B
 - 9:MAINS SWITCH
 - 10:INLINE HEATER O/P 3 PIN
 - 11:INPUT OUTPUT CONNECTOR 10 PIN

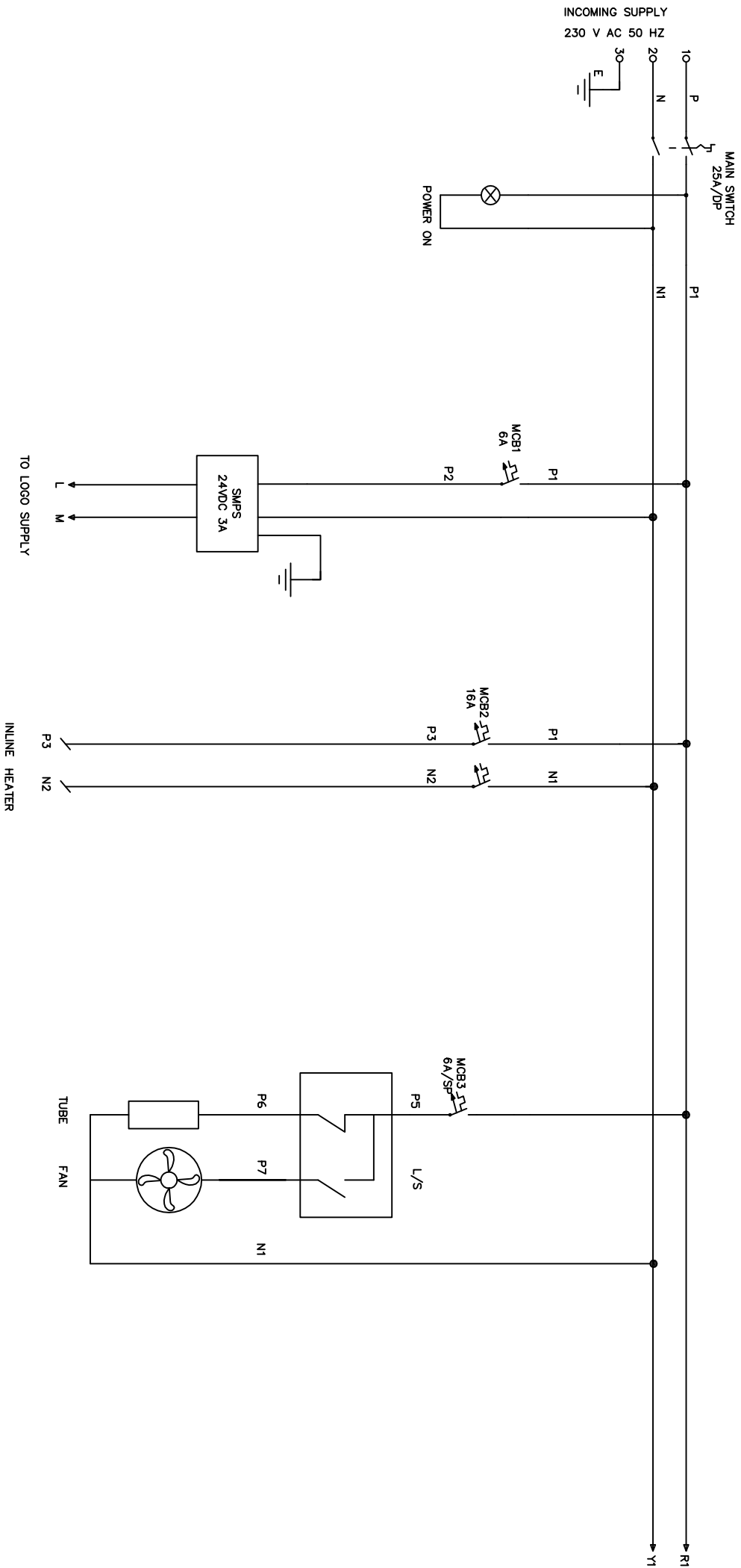
L.H.S. VIEW

FRONT VIEW

R.H.S. VIEW

DRAWN BY:	CUSTOMER : M/S. VR COATINGS PVT.LTD.		TITLE: G.A. DRAWING	V.R.COATINGS PVT LTD, PUNE	
PRINT DATE:	END USER :		PROJECT: COVER PAINTING WITH 3 GUN	PAGE NO. = 1/5	





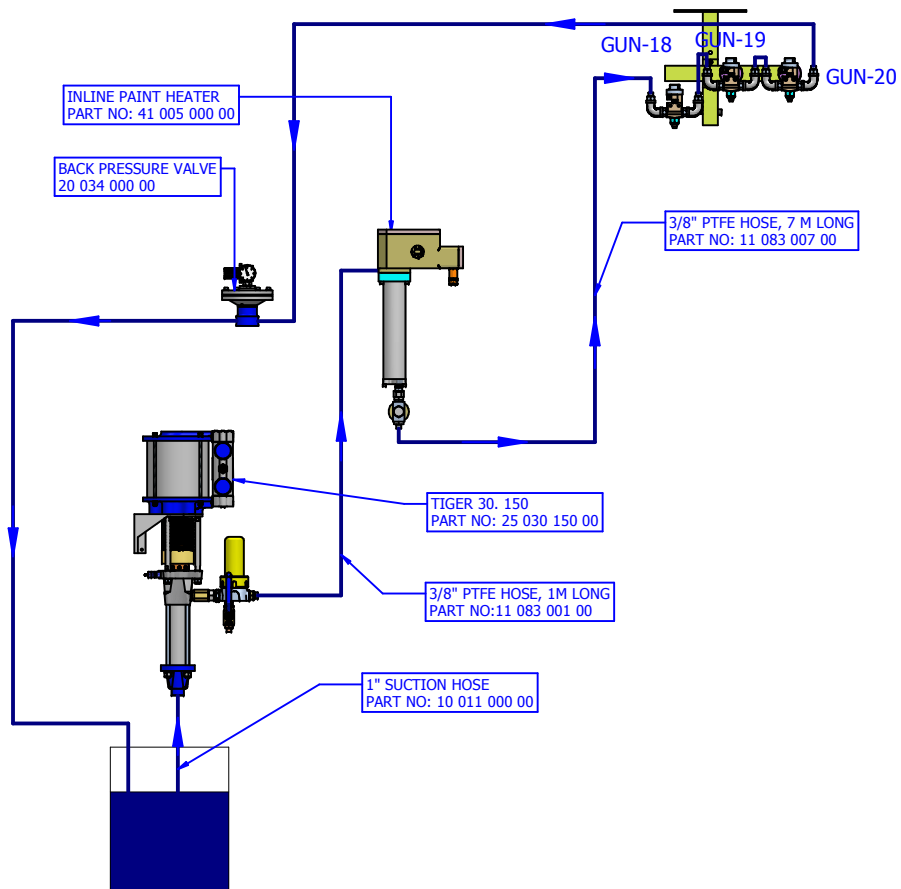
10 PIN INPUT/OUTPUT CONNECTOR

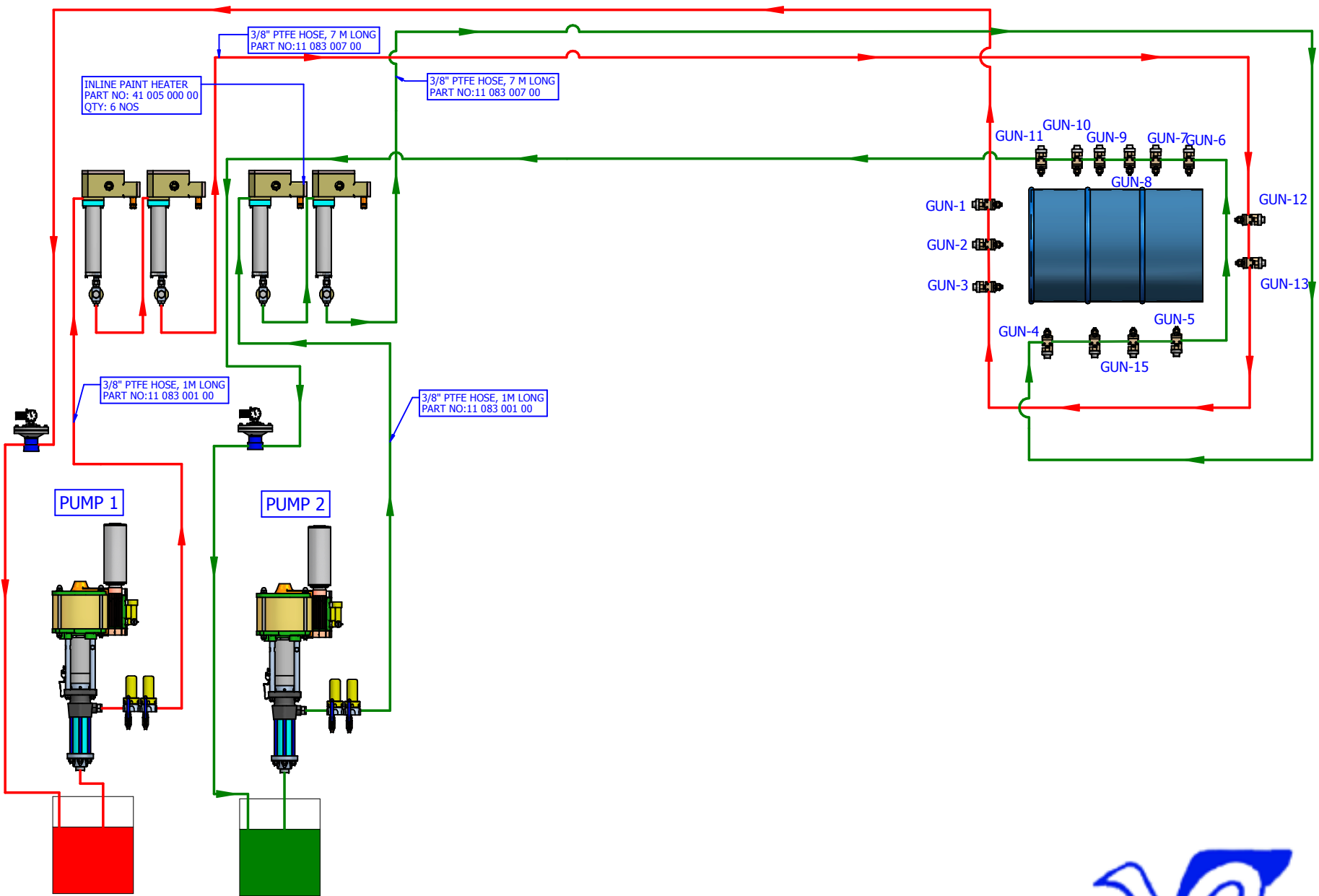
1	L1
2	M
3	I1
4	I3
5	I4
6	Q1
7	Q2
8	Q3
9	Q4
10	--

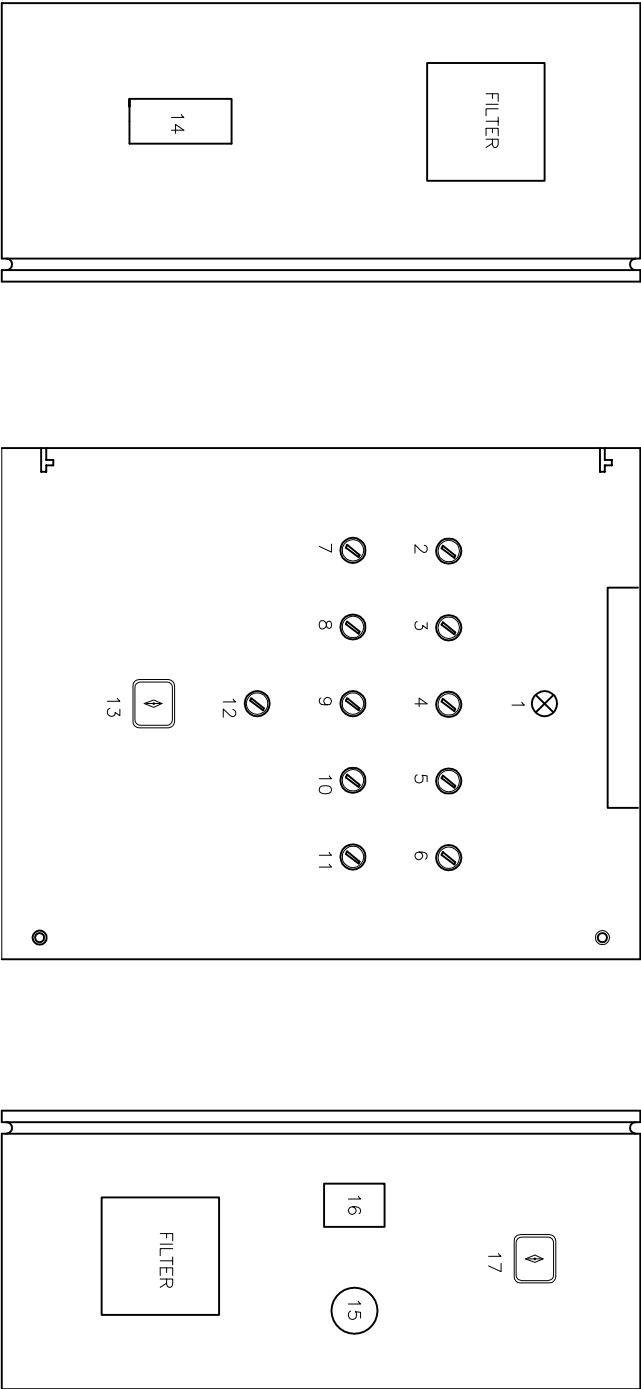
3 PIN FOR INLINE HEATER

1	P4
2	N3
3	E

INTERNAL BARREL PAINTING





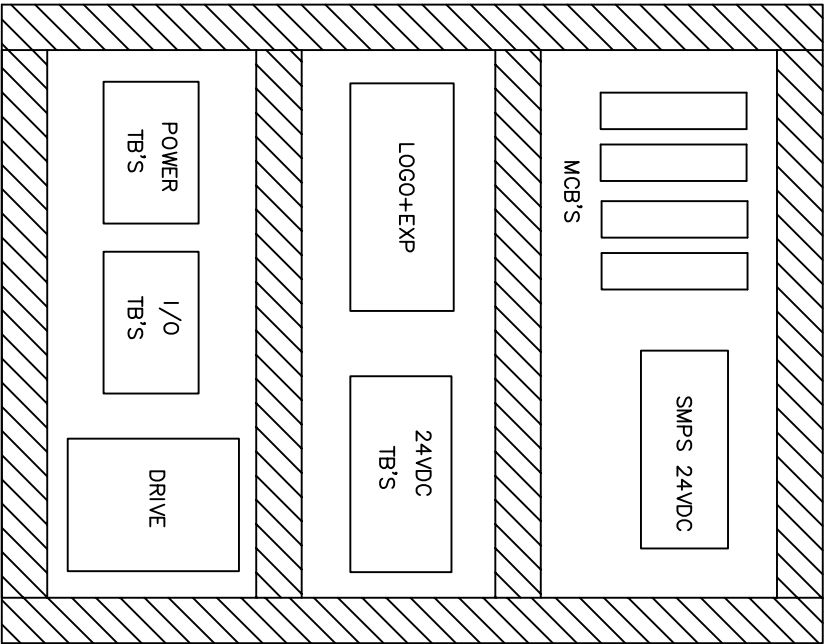


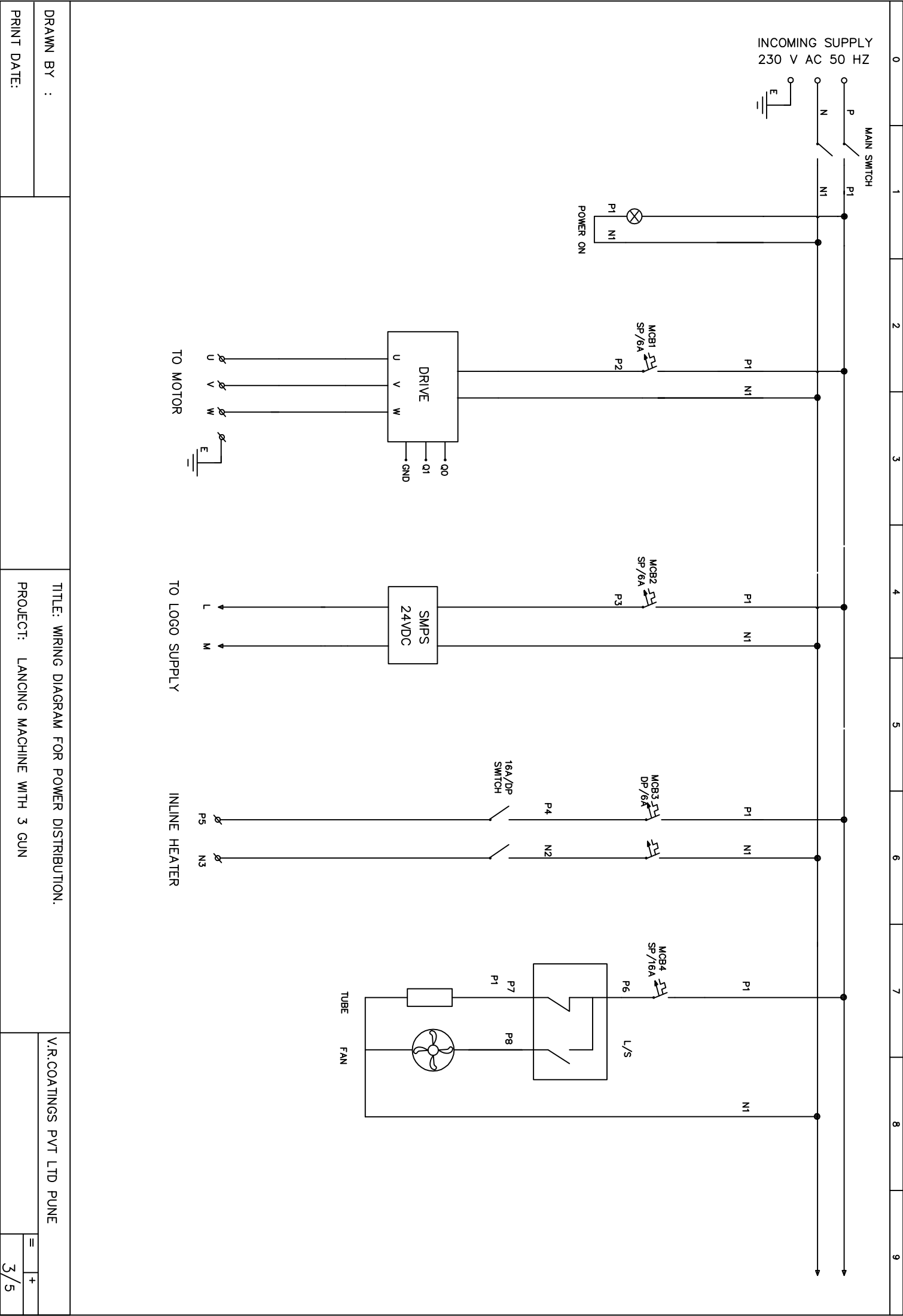
- LEGENDS:
- 1:POWER ON LAMP
 - 2:AUTO/MANUAL SEL S/W
 - 3:CYCLE START P.B
 - 4:CYCLE STOP P.B
 - 5:DRIVE FORWARD/REVERSE SW
 - 6:SPARE
 - 7:SPRAY GUN.1
 - 8:SPRAY GUN.2
 - 9:SPRAY GUN.3
 - 10:CYCLE TERMINATE P.B
 - 11:COUNTER RESET P.B
 - 12:EMERGENCY STOP P.B
 - 13:16A/DP INLINE HEATER SW
 - 14:INPUT & OUTPUT CONNECTOR
 - 15:INLINE HEATER CONNECTOR
 - 16:MOTOR CONNECTOR
 - 17:MANS SWITCH

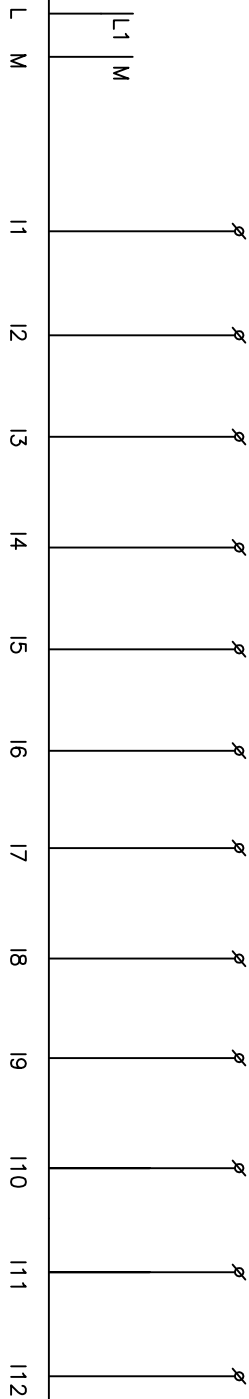
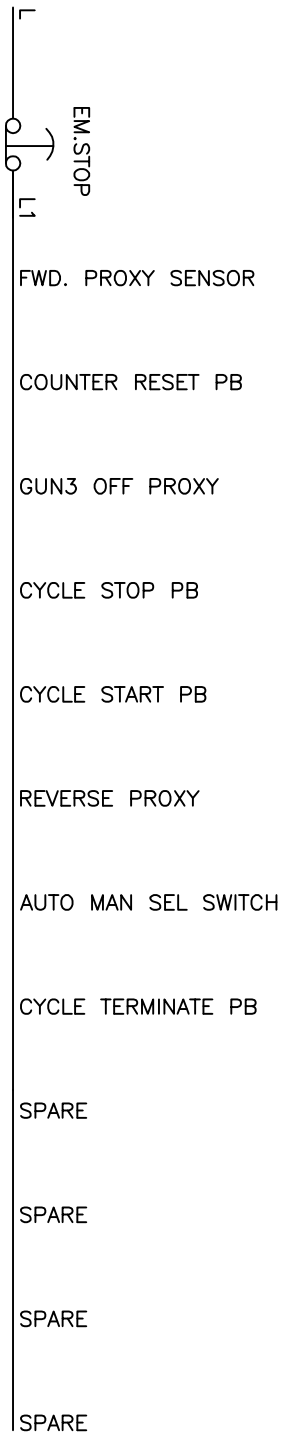
L.H.S. VIEW

FRONT VIEW

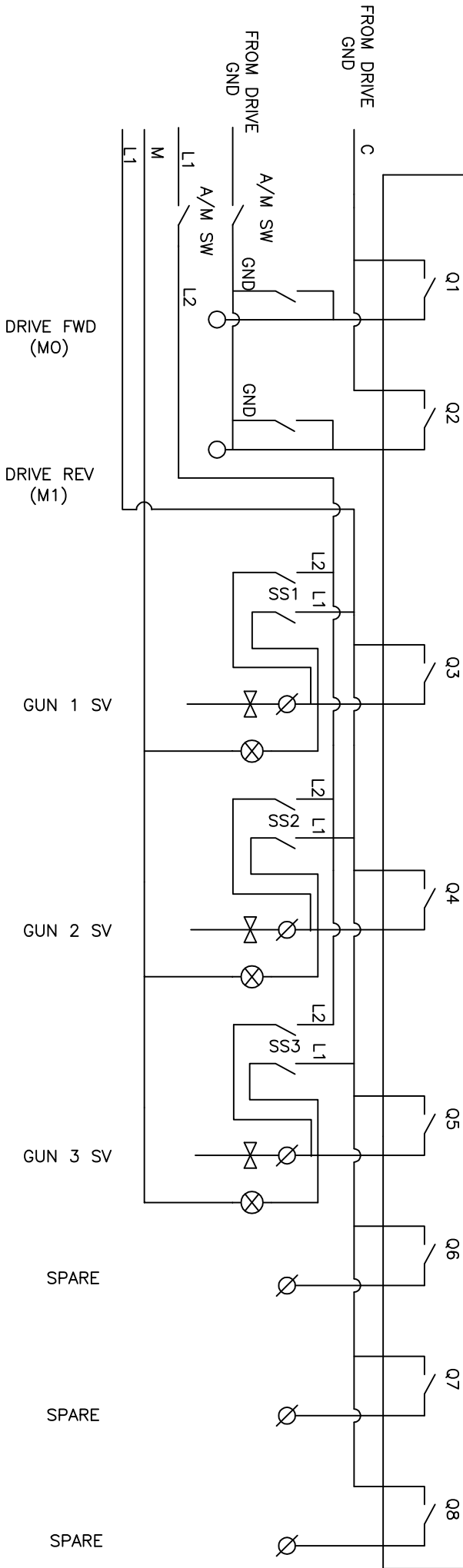
R.H.S. VIEW







SIEMENS LOGO+EXPANSION MODULE



10 PIN INPUT/OUTPUT CONNECTOR

1	L1
2	M
3	I1
4	I3
5	I6
6	I5
7	Q3
8	Q4
9	Q5
10	Q6

6 PIN CONNECTOR FOR MOTOR

1	U
2	V
3	W
4	E
5	--
6	--

3 PIN CONNECTOR FOR HEATER

1	Y4
2	N2
3	E

BARREL PAINTING SYSTEM OPERATIONAL SEQUENCE

Power ON the main switch. Electrical Control Panel starts. Plc and HMI initializes.

AUTO MODE:

- 1) Before starting the auto cycle check the ready conditions as given below:
 - a) Auto/Manual switch to Auto Mode
 - b) Emergency pushbutton must be released.
 - c) Start selector switch is ON.
 - d) If all above conditions satisfies, yellow lamp becomes ON.
- 2) Check that timer settings are done at HMI for each required recipe. Recipe parameter setting procedure is explained in “parameter setting manual”.
- 3) Let’s assume that user has set timer settings for all 10 Nos. of recipes.
- 4) To operate the auto cycle for “Recipe 1”; select the program selector switch to “Position-1”. Press “LOAD” pushbutton. Hooter sounds (Indicates that recipe has been loaded).
- 5) After this, when job sensor becomes ON, each of the gun becomes ON and OFF as per timer setting done in recipe -1. Cycle over lamp becomes ON at the completion of auto cycle.
- 6) Same cycle repeats when job sensor again becomes ON.
- 7) If user wants to change recipe from 1 to 3, select the program selector switch to position-3 and press “LOAD” pushbutton. Hooter sounds (Indicates that recipe 3 is loaded).
- 8) Now if job sensor becomes ON, auto cycle operates as per timing set in recipe-3.

MANUAL MODE:

1) Select Auto/Manual selector switch to Manual Mode.

2) On control panel,

Make Gun1 switch to ON mode ----- Gun1 becomes ON

Make Gun2 switch to ON mode ----- Gun2 becomes ON

Make Gun3 switch to ON mode ----- Gun3 becomes ON

Make Gun4 switch to ON mode ----- Gun4 becomes ON

Make Gun5 switch to ON mode ----- Gun5 becomes ON

Make Gun6 switch to ON mode ----- Gun6 becomes ON

Make Gun7 switch to ON mode ----- Gun7 becomes ON

Make Gun8 switch to ON mode ----- Gun8 becomes ON

Make Gun9 switch to ON mode ----- Gun9 becomes ON

Make Gun10 switch to ON mode ---- Gun10 becomes ON

Make Gun11 switch to ON mode ---- Gun11 becomes ON

Make Gun12 switch to ON mode ---- Gun12 becomes ON

Make Gun13 switch to ON mode ---- Gun13 becomes ON

Make Gun14 switch to ON mode ---- Gun14 becomes ON

Make Gun15 switch to ON mode ---- Gun15 becomes ON

Make Gun16 switch to ON mode ---- Gun16 becomes ON

OPERATING INSTRUCTIONS

AUTO MODE :

1)	SELECT AUTO/MAN SWITCH TO AUTO MODE.
2)	DURING AUTO CYCLE, HANDSHAKE SIGNAL SHOULD BE ALWAYS ON. PRESS THE CYCLE START PUSHBUTTON. AS SOON AS START COMMAND IS GIVEN, ON DELAY TIMER FOR ALL THREE GUNS GET START. "GUN1, GUN2 AND GUN3" BECOMES ON AFTER THE COMPLETION OF RESPECTIVE ON DELAY TIMERS.
3)	AS GUNS BECOME ON, THEIR RESPECTIVE OFF DELAY TIMERS TRIGGER IMMEDIATELY.
	AND THE GUNS BECOME OFF AFTER THE COMPLETION OF THESE OFF DELAY TIMERS.
4)	ALL THE TIMERS USED ARE USER SETTABLE.
5)	FOR EACH AUTO CYCLE, JOB COUNTER GETS INCREMENTED BY ONE.
6)	PRESS "COUNTER RESET" PB FOR 3 SECONDS, TO RESET THE JOB COUNTER.

MANUAL MODE :

1)	SELECT AUTO/MAN SWITCH TO MANUAL MODE.
2)	SELECT GUN1 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 1 BECOMES "ON".
3)	SELECT GUN2 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 2 BECOMES "ON".
4)	SELECT GUN3 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 3 BECOMES "ON".

OPERATING INSTRUCTIONS

AUTO MODE :

1)	SELECT AUTO/MAN SWITCH TO AUTO MODE.
2)	IF FORWARD PROXY (HOME) IS "ON" AND CYCLE START GIVEN, THEN,AFTER FORWARD ON DELAY,MOTOR STARTS FORWARD ROTATION. WHEN REVERSE PROXY IS SENSED,FORWARD ROTATION STOPS.GUN1 AND GUN2 ON DELAY TIMER STARTS, GUN1 AND GUN 2 STARTS. AND REMAINS "ON" FOR RESPECTIVE OFF DELAY TIMER. AT ITS COMPLETION,REVERSE ON DELAY TIMER STARTS. ON DELAY STARTS,. AT THE COMPLETION OF WHICH,REVERSE ROTATION OF MOTOR STARTS.
3)	AT THE SAME TIME GUN3 ON DELAY STARTS. GUN3 GETS ON AND REMAINS ON TILL Gun3 OFF Proxy(Input 'I3') DOES NOT GET SENSED.
4)	JOB COUNTER INCREMENTS AT THE COMPLETION OF EACH CYCLE.
5)	WHEN CNT RESET PB IS PRESSED FOR 3 SECONDS, THE COUNTER GETS RESET..

MANUAL MODE :

1)	SELECT AUTO/MAN SWITCH TO MANUAL MODE.
2)	SELECT GUN1 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 1 BECOMES "ON".
3)	SELECT GUN2 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 2 BECOMES "ON".
4)	SELECT GUN3 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 3 BECOMES "ON".

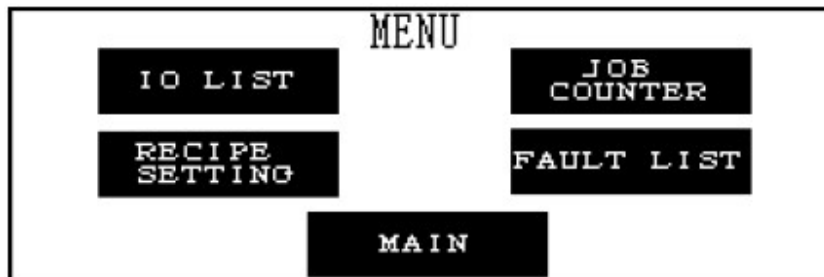


OPERATIONAL SEQUENCE

MAIN SCREEN:-



This is the "Power On screen". It shows the system name and address of manufacturer Press "MAIN" key, following screen appears.



This is the menu screen. It gives access to different functions of the machine.

System. It includes,

- 1) IO LIST
- 2) RECIPE SETTING
- 3) JOB COUNTER
- 4) FAULT LIST

Press "MAIN" key to return back to main screen.

1) IO LIST :-

The following screen displays the input list of the system along with actual status as ON or OFF on the display.

INPUT LIST		
X0	JOB SENSOR	
X1	EMG STOP PB	
X2	START SW	
OUTPUT LIST		NEXT MAIN

Press “Output List” key to jump to output list screen.

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Output List” key to access output list used.

When NEXT key is pressed, following screen appears.

INPUT LIST		
X3	AUTO/MAN SW	
X4	SAVE RECIPE PB	
X5	LOAD RECIPE PB	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

INPUT LIST		
X6	RECIPE SW-1	
X7	RECIPE SW-2	
X10	RECIPE SW-3	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

INPUT LIST		
X11	RECIPE SW-4	
X12	RECIPE SW-5	
X13	RECIPE SW-6	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

INPUT LIST		
X14	RECIPE SW-7	
X15	RECIPE SW-8	
X16	RECIPE SW-9	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

INPUT LIST		
X17	RECIPE SW-10	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears i.e. "Output List".

OUTPUT LIST		
Y0	GUN SV-1	
Y1	GUN SV-2	
Y2	GUN SV-3	
INPUT LIST		NEXT MAIN

Press "Input List" key to jump to input list screen.

Press "Next" key to go to next screen and "MAIN" key to jump to menu screen.

Press "Back" key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y3	GUN SV-4	
Y4	GUN SV-5	
Y5	GUN SV-6	
MAIN		BACK NEXT

Press "Next" key to go to next screen and "MAIN" key to jump to menu screen.

Press "Back" key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y6	GUN SV-7	
Y7	GUN SV-8	
Y10	GUN SV-9	
MAIN		BACK NEXT

Press "Next" key to go to next screen and "MAIN" key to jump to menu screen.

Press "Back" key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y11	GUN SV-10	
Y12	GUN SV-11	
Y13	GUN SV-12	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y14	GUN SV-13	
Y15	GUN SV-14	
Y16	GUN SV-15	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y17	GUN SV-16	
Y20	READ/WRITE LAMP	
Y21	FAULT LAMP	
MAIN		BACK NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y22	CYCLE OVER LAMP	
Y23	READY LAMP	
Y24	HOOTER	

MAIN

BACK

NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y25	SPARE	
Y26	SPARE	
Y27	SPARE	

MAIN

BACK

NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y30	SPARE	
Y31	SPARE	
Y32	SPARE	

MAIN

BACK

NEXT

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y33	SPARE	
Y34	SPARE	
Y35	SPARE	
<div> <div>MAIN</div> <div>BACK</div> <div>NEXT</div> </div>		

Press “Next” key to go to next screen and “MAIN” key to jump to menu screen.

Press “Back” key to access previous screen.

When NEXT key is pressed, following screen appears.

OUTPUT LIST		
Y36	SPARE	
Y37	SPARE	
<div> <div>MAIN</div> <div>BACK</div> <div>NEXT</div> </div>		

Press “Next” key to go to next screen and “Back” key to access previous screen.

Press “MAIN” key to jump to menu screen.

2) RECIPE SETTING :-

Press “RECIPE SETTING” key to access timer settings for different parameters.
Following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
1	GUN-1 ON DELAY	012.4 Sec
2	GUN-1 OFF DELAY	012.4 Sec
<div> <div>MAIN</div> <div>SAVE</div> <div>LOAD</div> <div>NEXT</div> </div>		

“Gun1 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
3	GUN-2 ON DELAY	012.4 Sec
4	GUN-2 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun2 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
5	GUN-3 ON DELAY	012.4 Sec
6	GUN-3 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun3 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
7	GUN-4 ON DELAY	012.4 Sec
8	GUN-4 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun4 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
9	GUN-5 ON DELAY	012.4 Sec
10	GUN-5 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun5 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
11	GUN-6 ON DELAY	012.4 Sec
12	GUN-6 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun6 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
13	GUN-7 ON DELAY	012.4 Sec
14	GUN-7 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun7 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
15	GUN-8 ON DELAY	012.4 Sec
16	GUN-8 OFF DELAY	012.4 Sec
MAIN SETTING BACK NEXT		

“Gun8 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
17	GUN-9 ON DELAY	012.4 Sec
18	GUN-9 OFF DELAY	012.4 Sec
MAIN SETTING BACK NEXT		

“Gun9 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
19	GUN-10 ON DELAY	012.4 Sec
20	GUN-10 OFF DELAY	012.4 Sec
MAIN SETTING BACK NEXT		

“Gun10 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
21	GUN-11 ON DELAY	012.4 Sec
22	GUN-11 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun11 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
23	GUN-12 ON DELAY	012.4 Sec
24	GUN-12 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun12 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
25	GUN-13 ON DELAY	012.4 Sec
26	GUN-13 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun13 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
27	GUN-14 ON DELAY	012.4 Sec
28	GUN-14 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun14 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
29	GUN-15 ON DELAY	012.4 Sec
30	GUN-15 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun15 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When NEXT key is pressed, following screen appears.

SETTINGS		
SRN	DESCRIPTION	SET
31	GUN-16 ON DELAY	012.4 Sec
32	GUN-16 OFF DELAY	012.4 Sec
MAIN	SETTING	BACK NEXT

“Gun16 on delay and off delay” time can be set at respective parameter. All the timers are in “seconds” and are user settable.

Press “Next” key to go to next screen and “Main” key to jump to menu screen.

When “Next” key pressed, it returns back to “gun1 Delay setting screen”. At this screen press “SAVE” key for 3 seconds to save the timer settings that have done.

Press “LOAD” key to load the selected recipe.

3) JOB COUNTER:-

Following screens shows the job counters for each of the 10 recipes independently. Press reset key for 5 sec, counter get reset.

JOB COUNTER					
RCP			RCP		
1	0123456	RESET	3	0123456	RESET
2	0123456	RESET	4	0123456	RESET
MAIN			NEXT		

The screen shows the job counters for “Recipe 1,2,3 & 4”. To reset the job counter, select the recipe selector switch to required recipe number and press “RESET” key for 5 seconds. Job counter gets reset.

Press “Next” key, following screen appears.

JOB COUNTER					
RCP			RCP		
5	0123456	RESET	7	0123456	RESET
6	0123456	RESET	8	0123456	RESET
MAIN			NEXT		

The screen shows the job counters for “Recipe 5,6,7 & 8”. To reset the job counter, select the recipe selector switch to required recipe number and press “RESET” key for 5 seconds. Job counter gets reset.

Press “Next” key, following screen appears.

JOB COUNTER			
RCP			
9	0123456	RESET	
10	0123456	RESET	
MAIN		NEXT	

The screen shows the job counters for “Recipe 9 & 10”. To reset the job counter, select the recipe selector switch to required recipe number and press “RESET” key for 5 seconds. Job counter gets reset.

4) FAULT LIST:-

The faults that can occur during operation, will be displayed at this screen.
Ex:- “Emergency Stop Fault”.

FAULT LIST
EMERGENCY STOP FAULT

MAIN

FAULT ACK

To Reset fault, released emg stop pb on control panel & press fault ack key on above screen.

PARAMETER SETTING

The different parameters used and their function is stated below.
All the parameters are Timers which are user settable and Retentive.

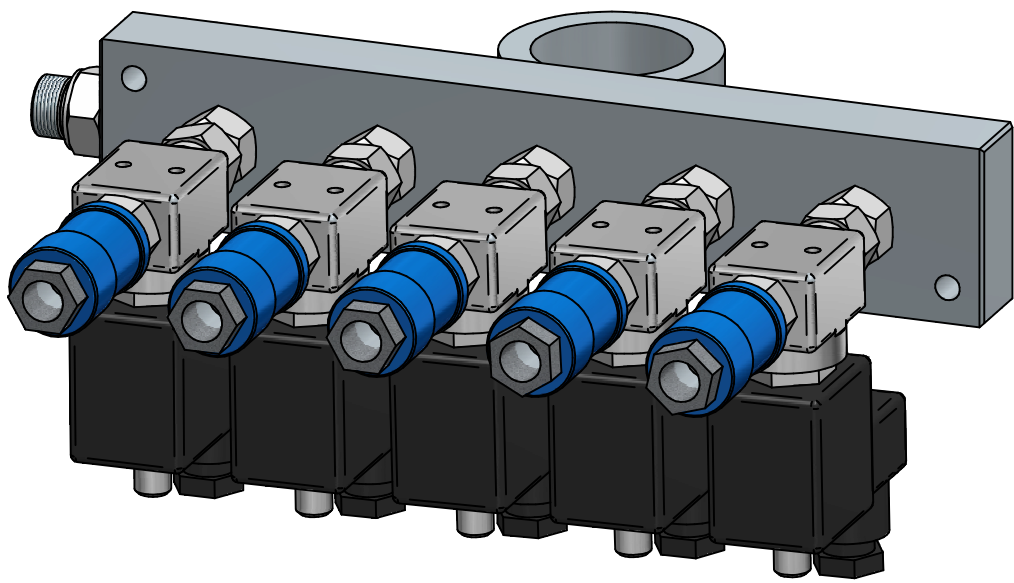
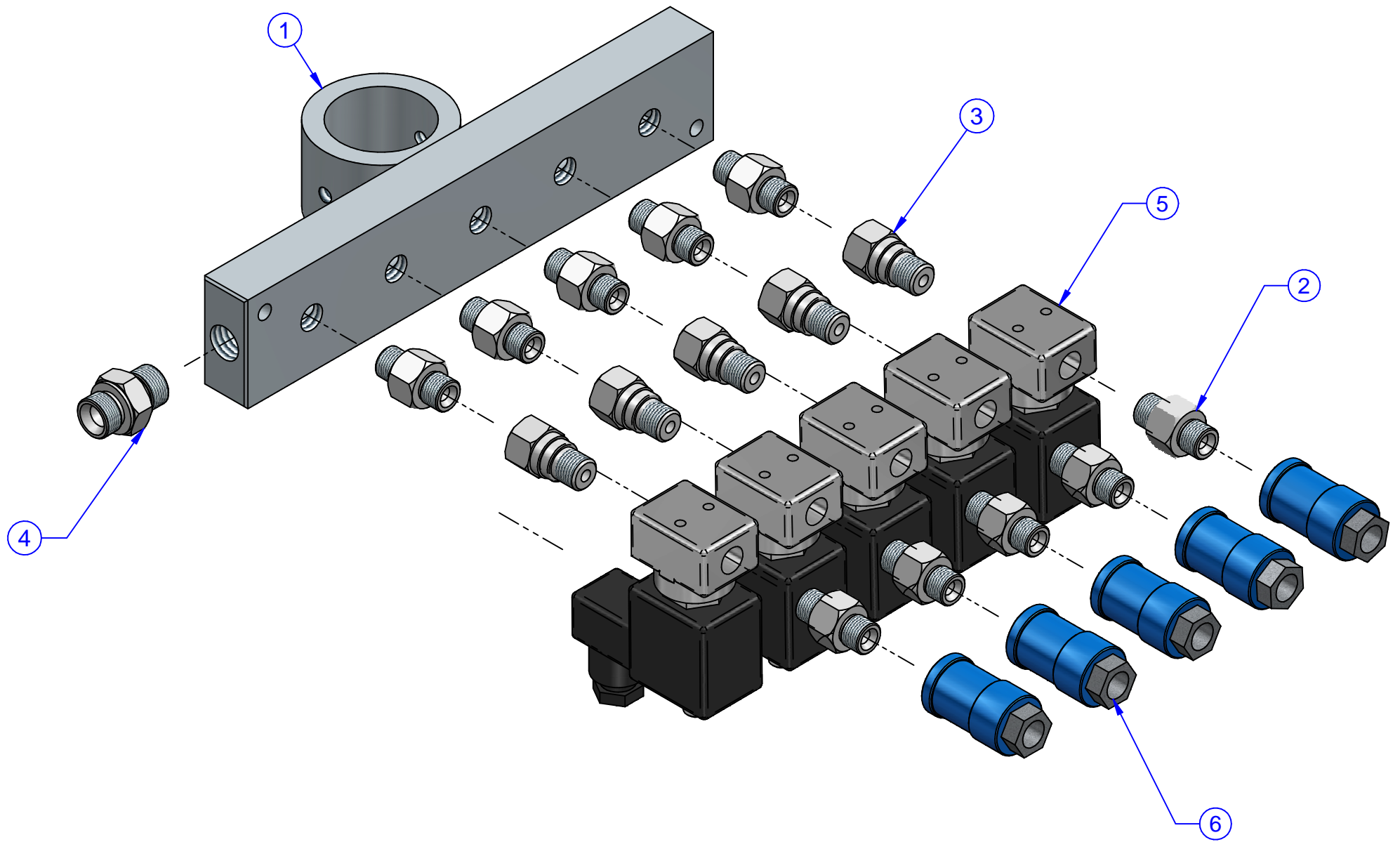
Sr.No.	Parameters	Description
1	GUN1 ON	It is "On Delay Timer" for gun1. When cycle start command is given, this timer gets start. Gun1 becomes on at the completion of this timer.
2	GUN2 ON	It is "On Delay Timer" for gun2. When cycle start command is given, this timer gets start. Gun2 becomes on at the completion of this timer.
3	GUN3 ON	It is "On Delay Timer" for gun3. When cycle start command is given, this timer gets start. Gun3 becomes on at the completion of this timer.
4	GUN1 OFF	It is "Off Delay Timer" for gun1. It starts after the completion of 'Gun1 On' delay timer. Gun1 becomes off at the completion of this timer.
5	GUN2 OFF	It is "Off Delay Timer" for gun2. It starts after the completion of 'Gun2 On' delay timer. Gun2 becomes off at the completion of this timer.
6	GUN3 OFF	It is "Off Delay Timer" for gun3. It starts after the completion of 'Gun3 On' delay timer. Gun3 becomes off at the completion of this timer.
7	JOB_CONT	This parameter represents the job counter. The counter gets incremented by 1 for each auto cycle. Press Counter reset for 3 seconds to reset the counter.

PARAMETER SETTING



The different parameters used and their function is stated below.
All the parameters are Timers which are user settable and Retentive.

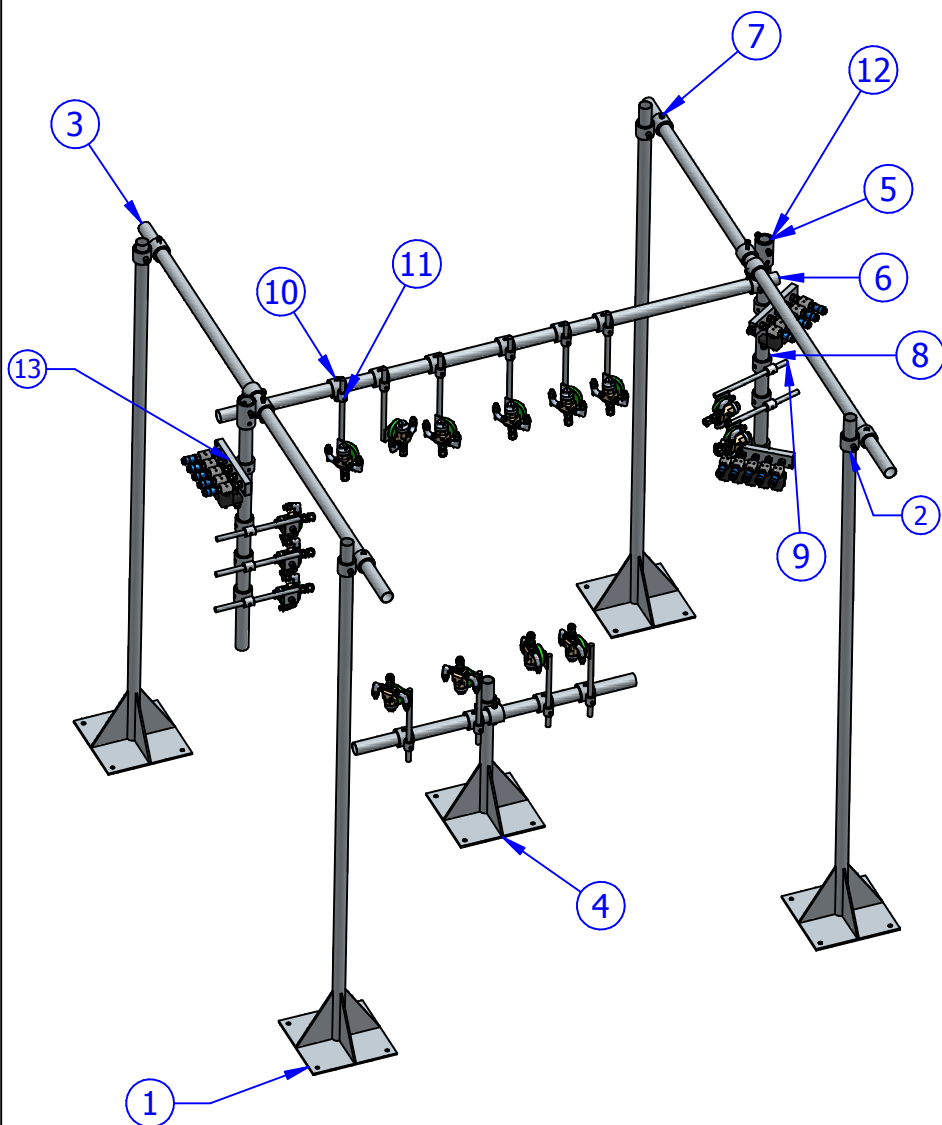
Sr.No.	Parameters	Description
1	FWD_ON_D	When home proxy is ON,Auto Mode is selected and cycle start pb pressed,this timer delay starts. At the completion of forward on delay timer,motor starts its Forward rotation.
2	REV_ON_D	When reverse proxy is sensed and Gun2,Gun3 Off delay timer is over,reverse on delay timer starts.At the completion of reverse on delay timer,motor starts its Reverse rotation.
3	G1_ON_D	When reverse proxy gets ON,Gun1 On delay timer starts.At the completion of this timer, Gun1 becomes ON.
4	G2_ON_D	When reverse proxy gets ON,Gun2 On delay timer starts.At the completion of this timer, Gun2 becomes ON.
5	G1_OFF_D	It is Gun1 Off delay timer.It starts at the completion of Gun1 On delay timer.At the completion of Gun1 Off delay timer, Gun1 becomes OFF.
6	G2_OFF_D	It is Gun2 Off delay timer.It starts at the completion of Gun2 On delay timer.At the completion of Gun2 Off delay timer, Gun2 becomes OFF.

7	G3_ON_D	When reverse proxy is ON and both Gun1 and Gun2 becomes OFF, Gun3 On delay timer starts. At the completion of this timer, Gun3 becomes ON.
8	JOB_CONT	This parameter represents the job counter. The counter gets incremented by 1 for each auto cycle. Press Counter reset for 3 seconds to reset the counter.

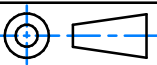



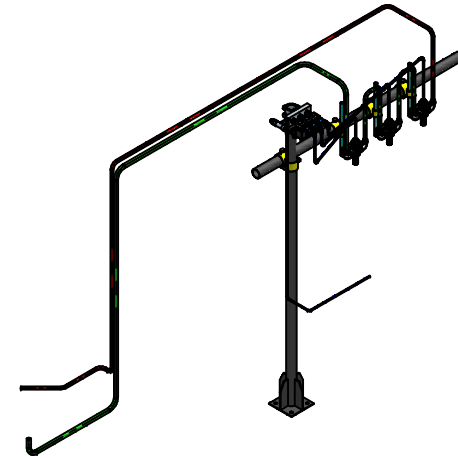
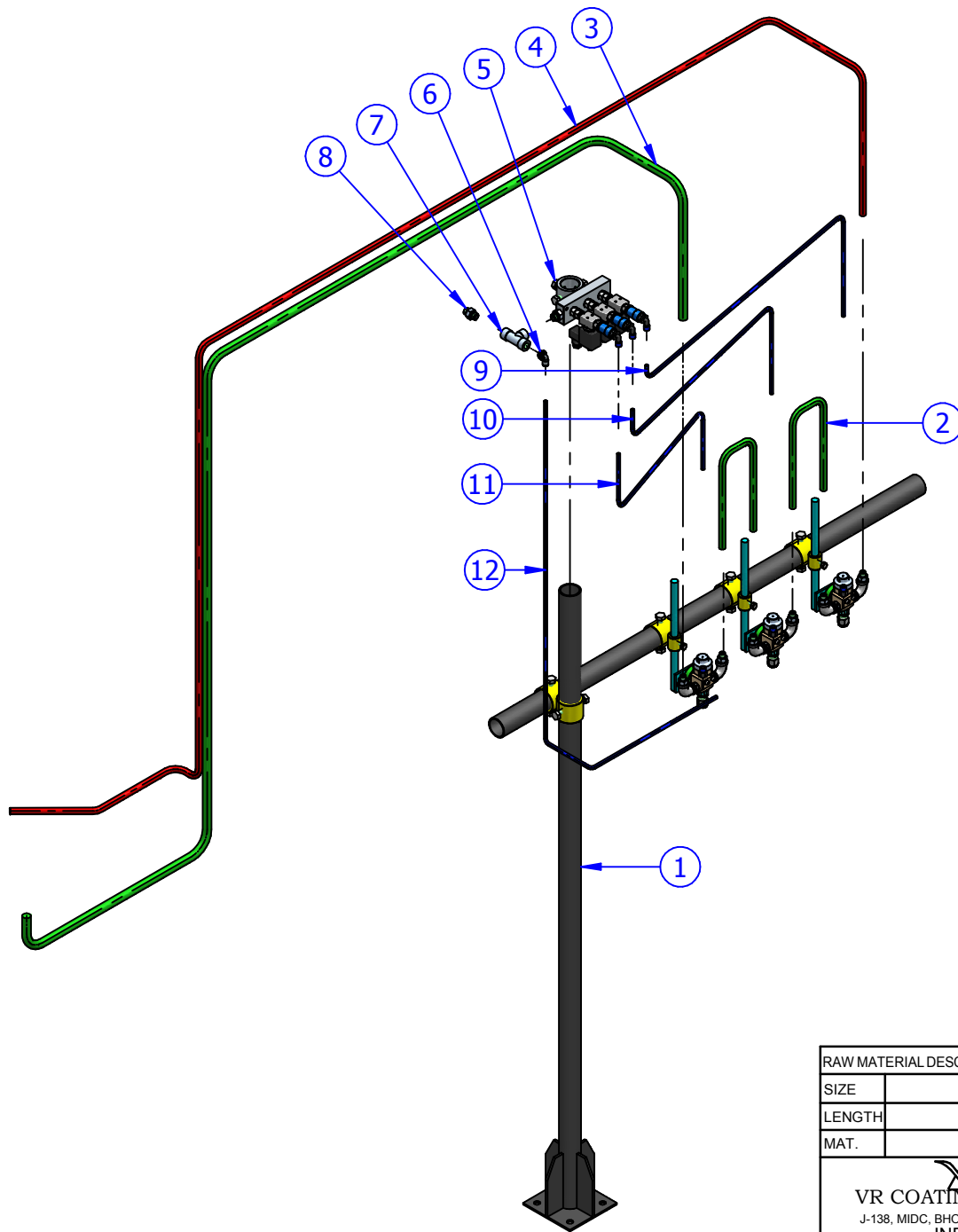
6	03 024 001 00	1/4" SLIDE VALVE	5	
5	03 015 001 00 JAN	SOLENOID VALVE 3/2 1/4" BSP (C-309)	5	
4	14 002 002 07	CONNECTOR 3/8"X3/8"	1	
3	51 101 000 01	SWIVEL 1/4" BSP	5	
2	14 001 001 19	CONNECTOR (1/4"X1/4")	10	
1	50 004 041 07	SOLENOID MOUNTING BLOCK	1	
SR.NOS.	PART NO.	PART NAME	QTY	W&T

RAW MATERIAL DESCRIPTION		NOTE:			
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.			
LENGTH					
MAT.					
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA		DRN.	CKD.	APPD.	PART NAME
		SIGN	richard	ALBERT	N/D
		DATE			
		SCALE		NOT TO SCALE	PART NO.
					50 004 022 00

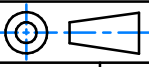



13	50 004 022 00	SOLENOID MOUNTING BLOCK ASSLY	3	
12	50 004 074 07	BUSH	2	
11	24 002 041 19	ALLEN BOLT M8	1	
10	15 330 015 07	ALLEN BOLT M12X30	2	
9	50 004 015 00	ROTATING GUN ASSLY	15	
8	50 004 002 07	ROD HOLDER	15	
7	15 325 014 07	ALLEN BOLT (M10 x 25 L)	36	
6	50 004 062 07	PIPE OD 43	1	
5	50 004 008 07	PIPE OD 43	3	
4	50 004 065 07	BOTTOM SIDE LEG	1	
3	50 004 063 07	PIPE 43 OD	2	
2	50 004 061 07	BUSH	7	
1	50 004 060 07	LEG OF GUN MOUNTING STAND	4	
SR.NOS.	PART NO.	PART NAME	QTY	W&T

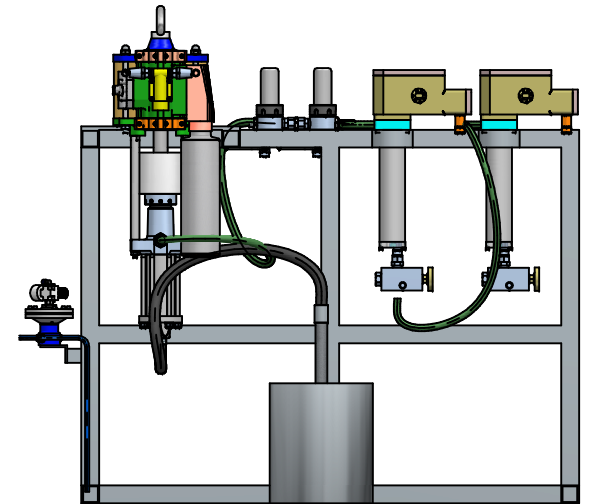
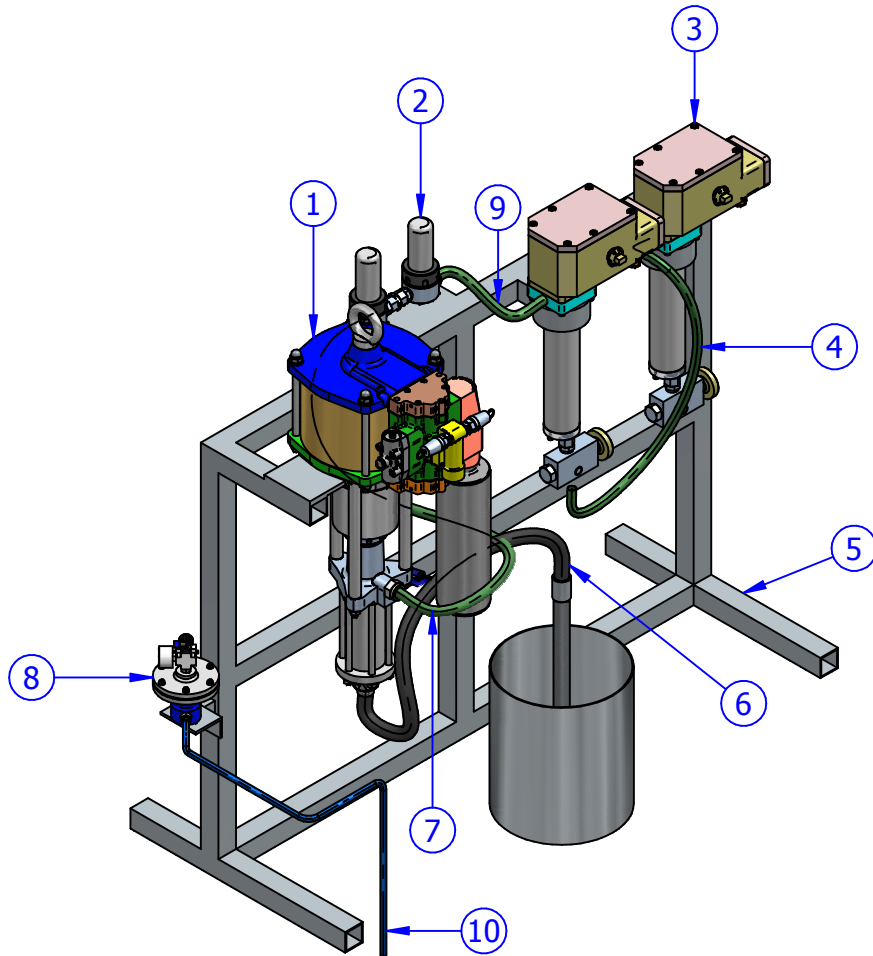
RAW MATERIAL DESCRIPTION		NOTE: HORIZONTAL BARREL		
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.		
LENGTH				
MAT.				
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA		DRN.	CKD.	APPD.
		SIGN	omkarl	ALBERT NVD
		DATE		
		SCALE	NOT TO SCALE	
		PART NAME	BARREL PAINTING FRAMING	
		PART NO.	50 004 064 00	





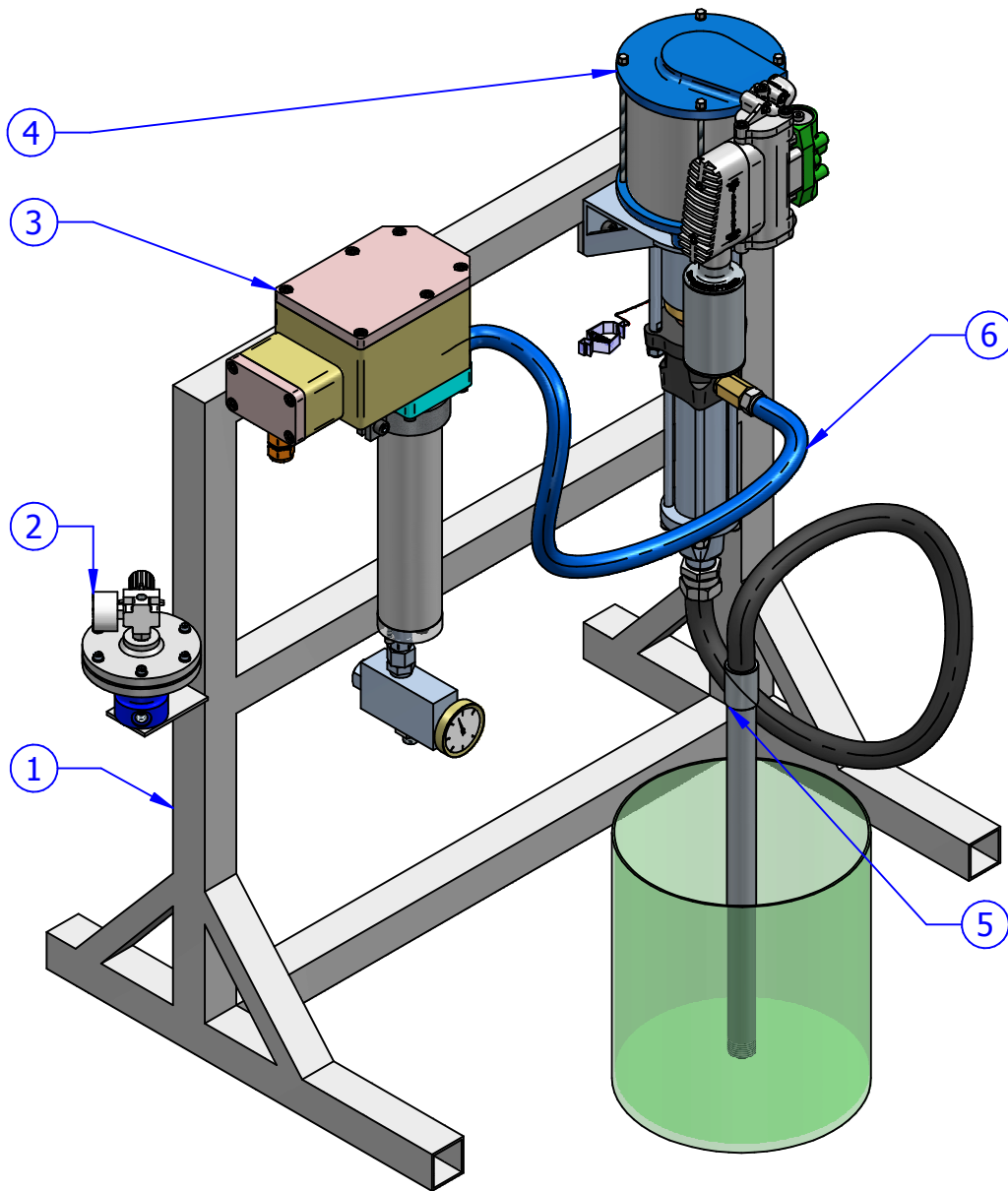
12	03 111 006 08	PU TUBE (8x6) 2.5MTR. LONG	1	
11	03 111 006 08	PU TUBE (8x6) 1.5MTR. LONG	1	
10	03 111 006 08	PU TUBE (8x6) 2MTR. LONG	1	
9	03 111 006 08	PU TUBE (8x6) 2MTR. LONG	1	
8	14 002 002 07	CONNECTOR 3/8"X3/8"	1	
7	34 001 002 07	TEE 3/8"	1	
6	03 102 318 08.	MALE STUD ELBOW	1	
5	50 004 024 00	3-SOLENOID MOUNTING BLOCK ASSLY	1	
4	11 081 007 00	1/4" BSF HP PTFE HOSE 7MTR. LONG	1	
3	11 083 007 00	3/8" BSF HP PTFE HOSE 7MTR. LONG	1	
2	11 081 001 00	1/4" BSF HP PTFE HOSE 1MTR. LONG	2	
1	50 071 092 00	GUN MOUNTING STAND FOR COVER PAINTING SYSTEM	1	
Sr.Nos.	PART NUMBER	PART NAME	Qty.	W&T

RAW MATERIAL DESCRIPTION		NOTE:	
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.	
LENGTH			
MAT.			
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA		DRN. CKD. APPD. SIGN <u>ntm</u> ALBERT NVD DATE SCALE NOT TO SCALE	PART NAME COVER PAINTING GUN,STAND, VALVE,HOSES&TUBES PART NO. 50 071 129 00

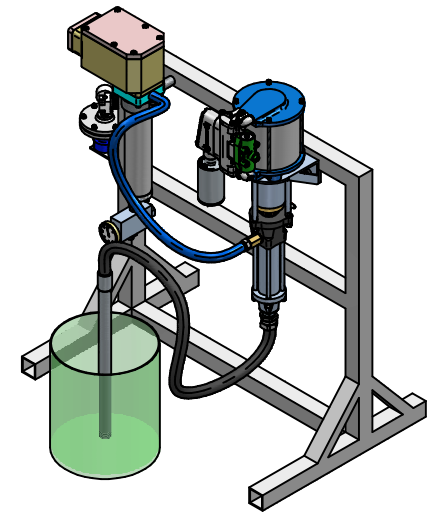
1	25 035 275 04	RHINO PUMP 35.275	1
2	50 085 430 00	TWIN FILTERS ASSEMBLY	1
3	41 005 000 00	INLINE HEATER 3 KW	2
4	11 083 001 00	3/8" PTFE HOSE 1M LONG	1
5	08 001 160 68	MOUNTING STAND	1
6	10 011 000 00	1" SUCTION HOSE, 1 M LONG	1
7	11 083 001 00	3/8" PTFE HOSE 1M LONG	1
8	20 034 000 00	HP BACK PR. VALVE PNEUMATICALLY OPERATED	1
9	11 083 500 00	3/8" PTFE HOSE 0.5M LONG	1
10	50 085 263 00	RETURN ASSEMBLY 1/4"	1
SR. NO.	PART NO.	PART NAME	QTY.

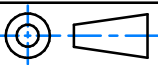



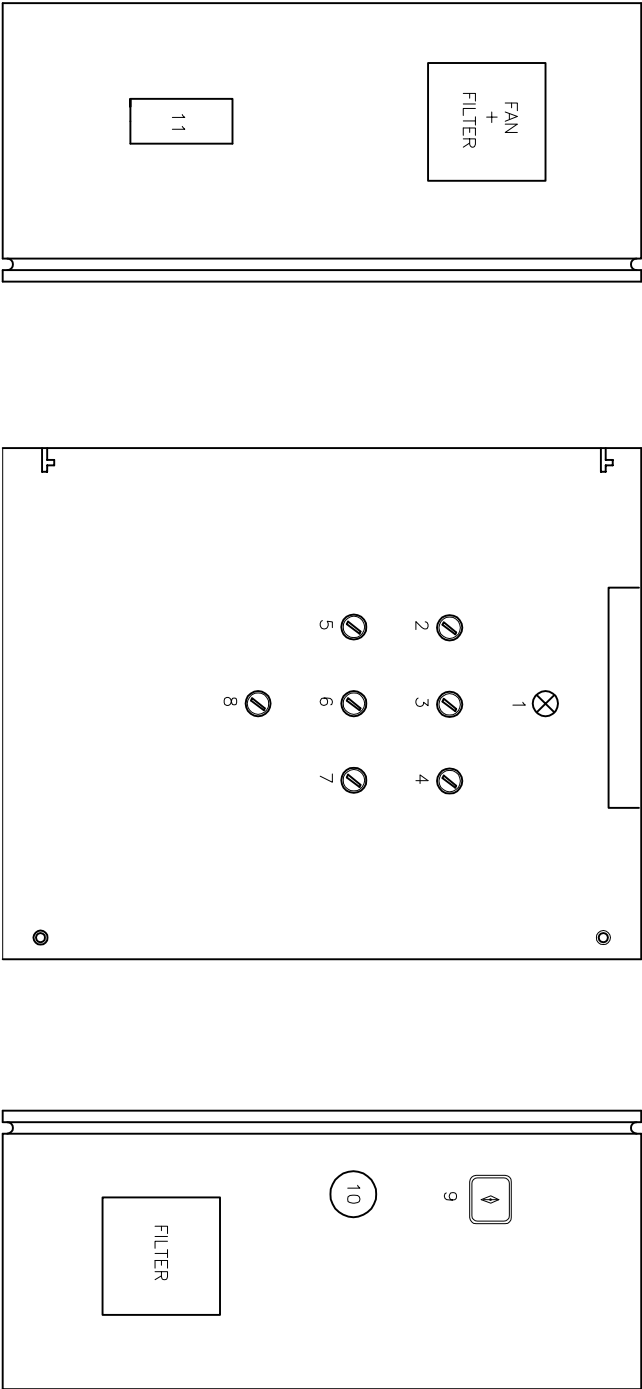
RAW MATERIAL DESCRIPTION		NOTE:					
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.					
LENGTH							
MAT.	ASSEMBLY						
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA			DRN.	CKD.	APPD.	PART NAME	PUMP AND ACCESSORIES ASSEMBLY
		SIGN	Chetan	ALBERT	NVD		
		DATE				PART NO.	50 085 236 00
		SCALE	NOT TO SCALE				



1	08 001 239 68	STAND FOR PUMP & HEATER	1
2	20 034 000 00	HP BACK PR. VALVE PNEUMATICALLY OPERATED	1
3	41 005 000 00	INLINE HEATER 3 KW	1
4	25 030 150 03	PUMP TIGER 30.150 WITHOUT FILTER N-2	1
5	10 007 000 00	1" SUCTION HOSE	1
6	11 083 007 00	3/8" PTFE HOSE 1 M LONG	1
SR. NO.	PART NO.	PART NAME	QTY.



RAW MATERIAL DESCRIPTION		NOTE:	
SIZE		 ALL DIMN. ARE IN MM UNLESS OTHERWISE STATED. FOR OPEN TOLERANCE AND SURFACE ROUGHNESS SEE STANDARD CHART DD-01/CH-01. REMOVE SHARP CORNERS. INCASE OF DOUBT ASK.	
LENGTH			
MAT.	Assembly		
 VR COATINGS PVT.LTD. J-138, MIDC, BHOSARI, PUNE-411 026 INDIA		SIGN	DRN. CKD. APPD.
		Chetan	ALBERT NVD
		DATE	
SCALE		NOT TO SCALE	
		PART NAME	TIGER PUMP, STAND AND ACCESSORIES ASSEMBLY
		PART NO.	50 085 237 00



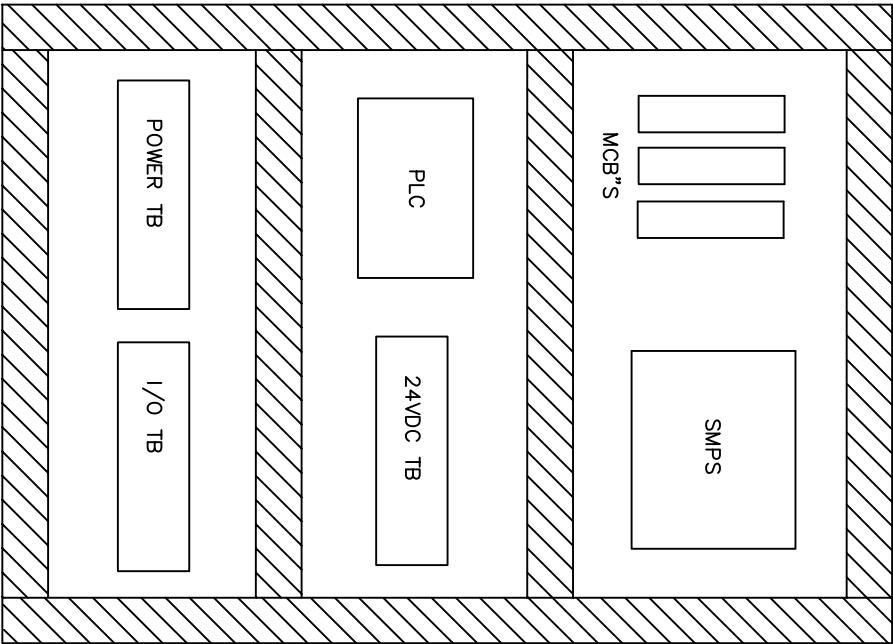
- LEGENDS:**
- 1:POWER ON LAMP
 - 2:SPRAY GUN.1 AUTO/MAN-SS4
 - 3:SPRAY GUN.2 AUTO/MAN-SS5
 - 4:SPRAY GUN.3 AUTO/MAN-SS5
 - 5:AUTO/MANUAL SEL S/W-SS1
 - 6:CYCLE START P.B
 - 7:COUNTER RESET P.B
 - 8:EMERGENCY STOP P.B
 - 9:MAINS SWITCH
 - 10:INLINE HEATER O/P 3 PIN
 - 11:INPUT OUTPUT CONNECTOR 10 PIN

L.H.S. VIEW

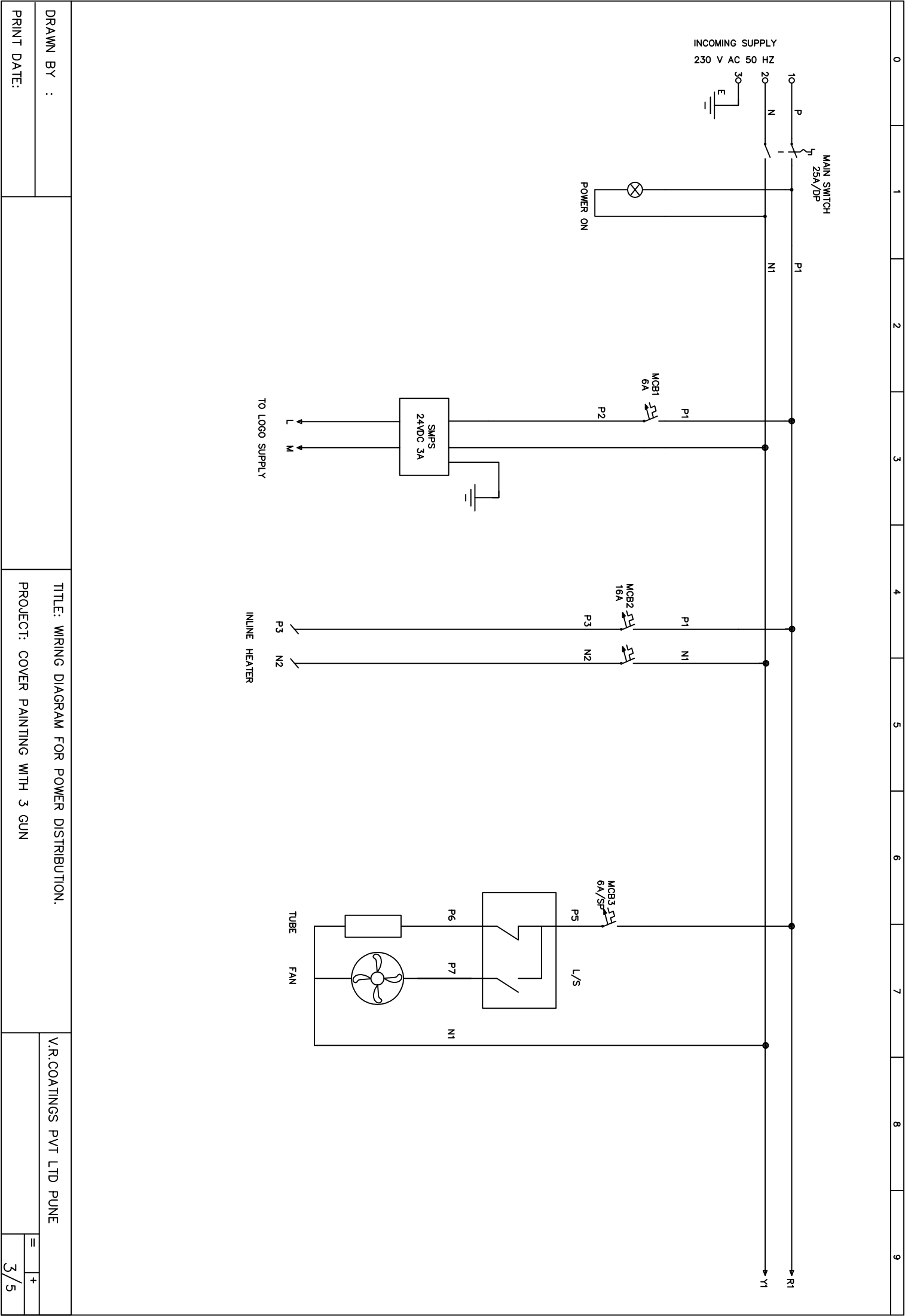
FRONT VIEW

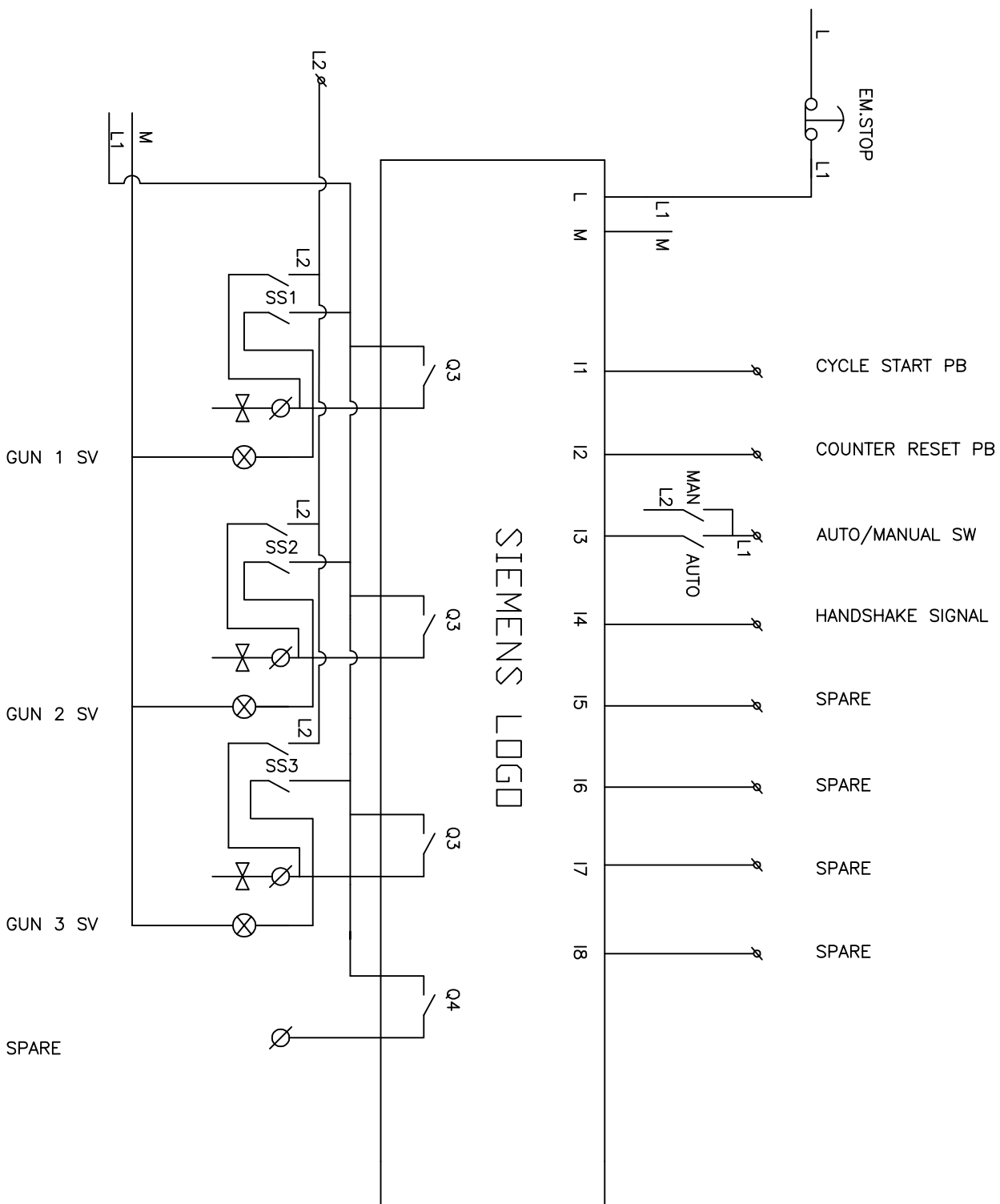
R.H.S. VIEW

DRAWN BY:	CUSTOMER : M/S. VR COATINGS PVT.LTD.		TITLE: G.A. DRAWING	V.R.COATINGS PVT LTD, PUNE	
PRINT DATE:	END USER :		PROJECT: COVER PAINTING WITH 3 GUN	PAGE NO. = 1/5	



DRAWN BY :	CUSTOMER : M/S. VR COATINGS PVT.LTD.		TITLE: INTERNAL LAYOUT		V.R.COATINGS PVT LTD, PUNE	
PRINT DATE:			PROJECT: COVER PAINTING WITH 3 GUN		PAGE NO. = 2/5	





EM.STOP

CYCLE START PB

COUNTER RESET PB

AUTO/MANUAL SW

HANDSHAKE SIGNAL

SPARE

SPARE

SPARE

SPARE

MAN / AUTO

SIEMENS LOGO

Q3

Q3

Q3

Q4

L28

12

2

2

SS

SS

SS

GUN 1 SV

GUN 2 SV

GUN 3 SV

SPARE

DRAWN BY :

PRINT DATE:

TITLE: CONTROL CIRCUIT.

PROJECT: COVER PAINTING WITH 3 GUN

V.R.COATINGS PVT LTD , PUNE

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$$\frac{4}{5}$$

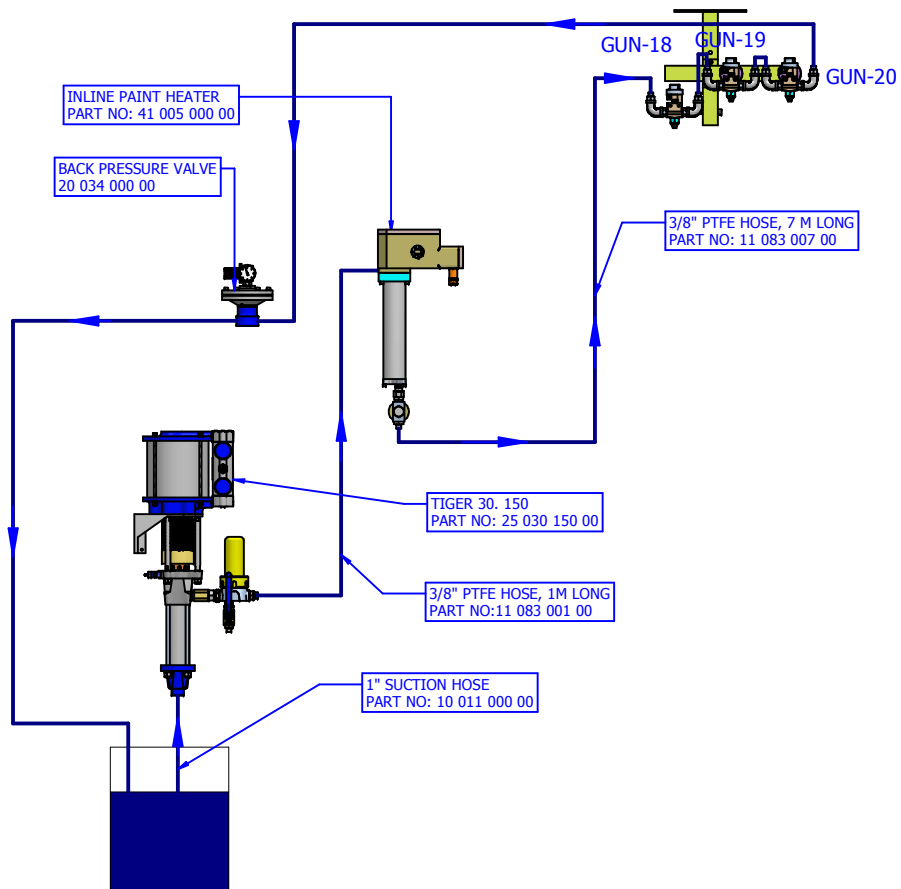
10 PIN INPUT/OUTPUT CONNECTOR

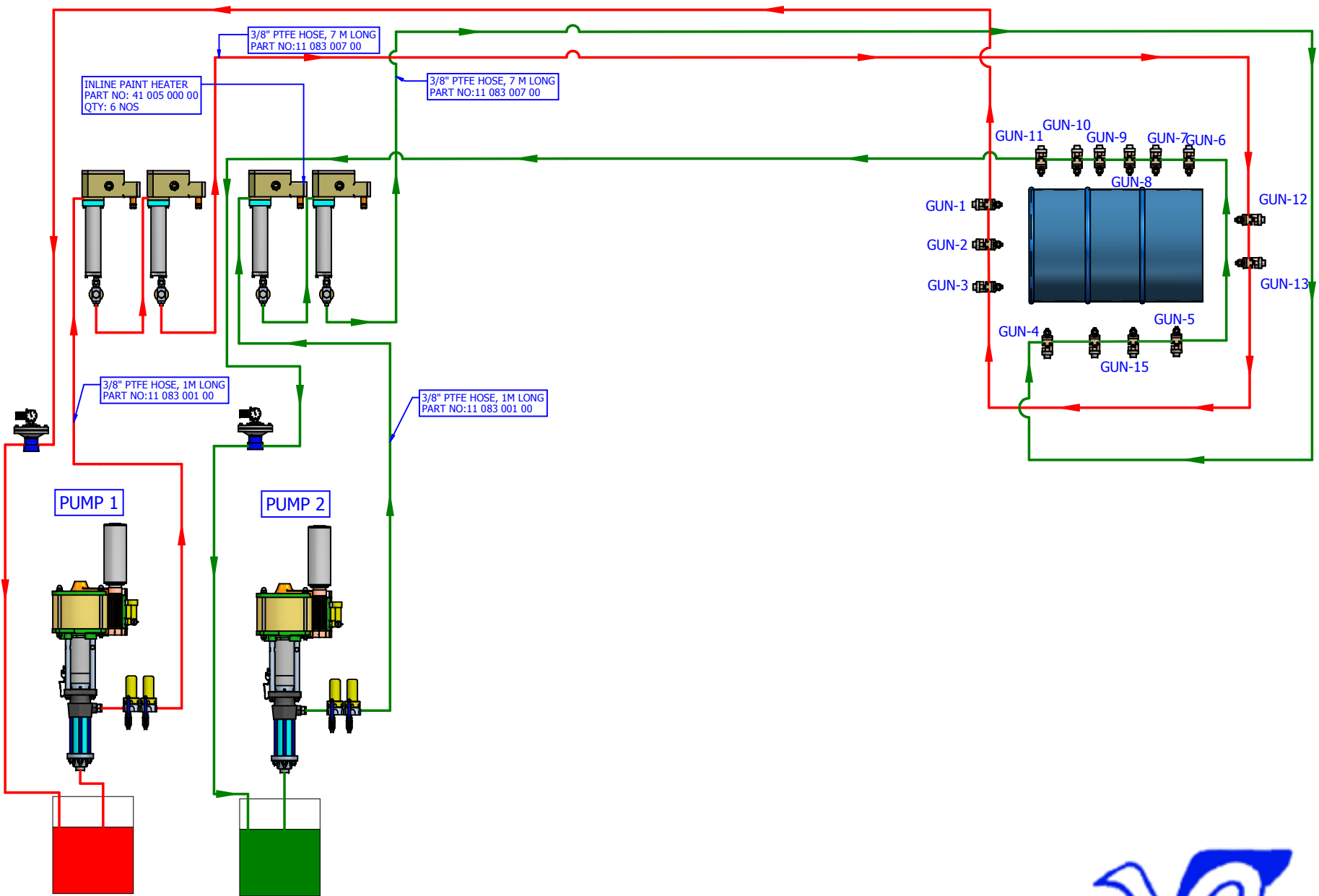
1	L1
2	M
3	I1
4	I3
5	I4
6	Q1
7	Q2
8	Q3
9	Q4
10	--

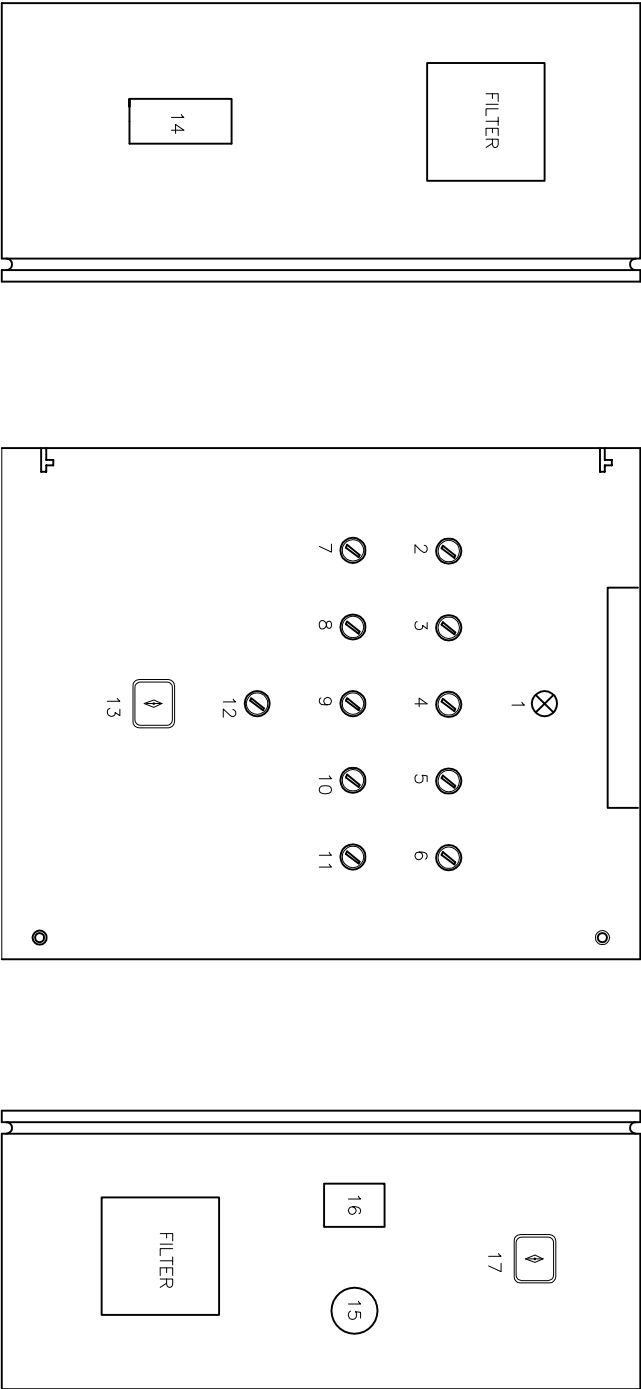
3 PIN FOR INLINE HEATER

1	P4
2	N3
3	E

INTERNAL BARREL PAINTING





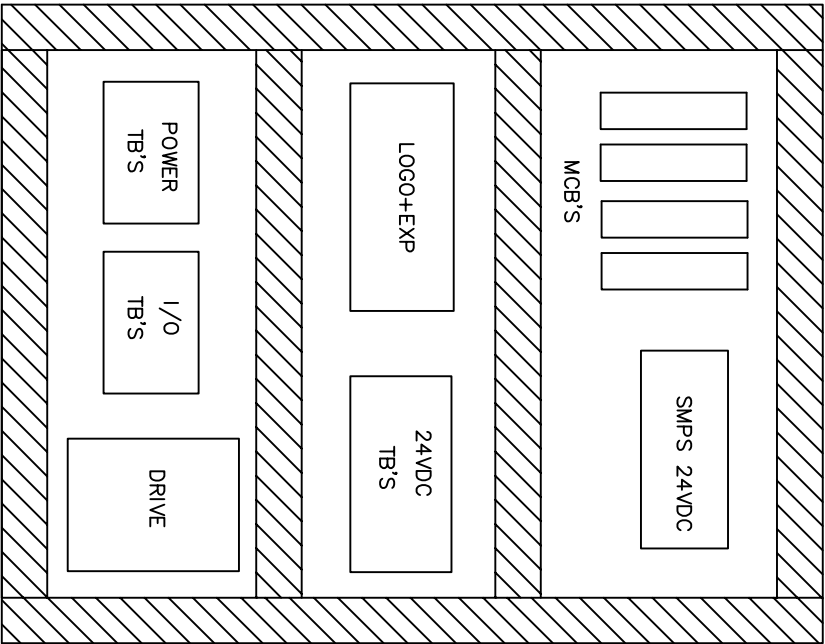


- LEGENDS:
- 1:POWER ON LAMP
 - 2:AUTO/MANUAL SEL S/W
 - 3:CYCLE START P.B
 - 4:CYCLE STOP P.B
 - 5:DRIVE FORWARD/REVERSE SW
 - 6:SPARE
 - 7:SPRAY GUN.1
 - 8:SPRAY GUN.2
 - 9:SPRAY GUN.3
 - 10:CYCLE TERMINATE P.B
 - 11:COUNTER RESET P.B
 - 12:EMERGENCY STOP P.B
 - 13:16A/DP INLINE HEATER SW
 - 14:INPUT & OUTPUT CONNECTOR
 - 15:INLINE HEATER CONNECTOR
 - 16:MOTOR CONNECTOR
 - 17:MANS SWITCH

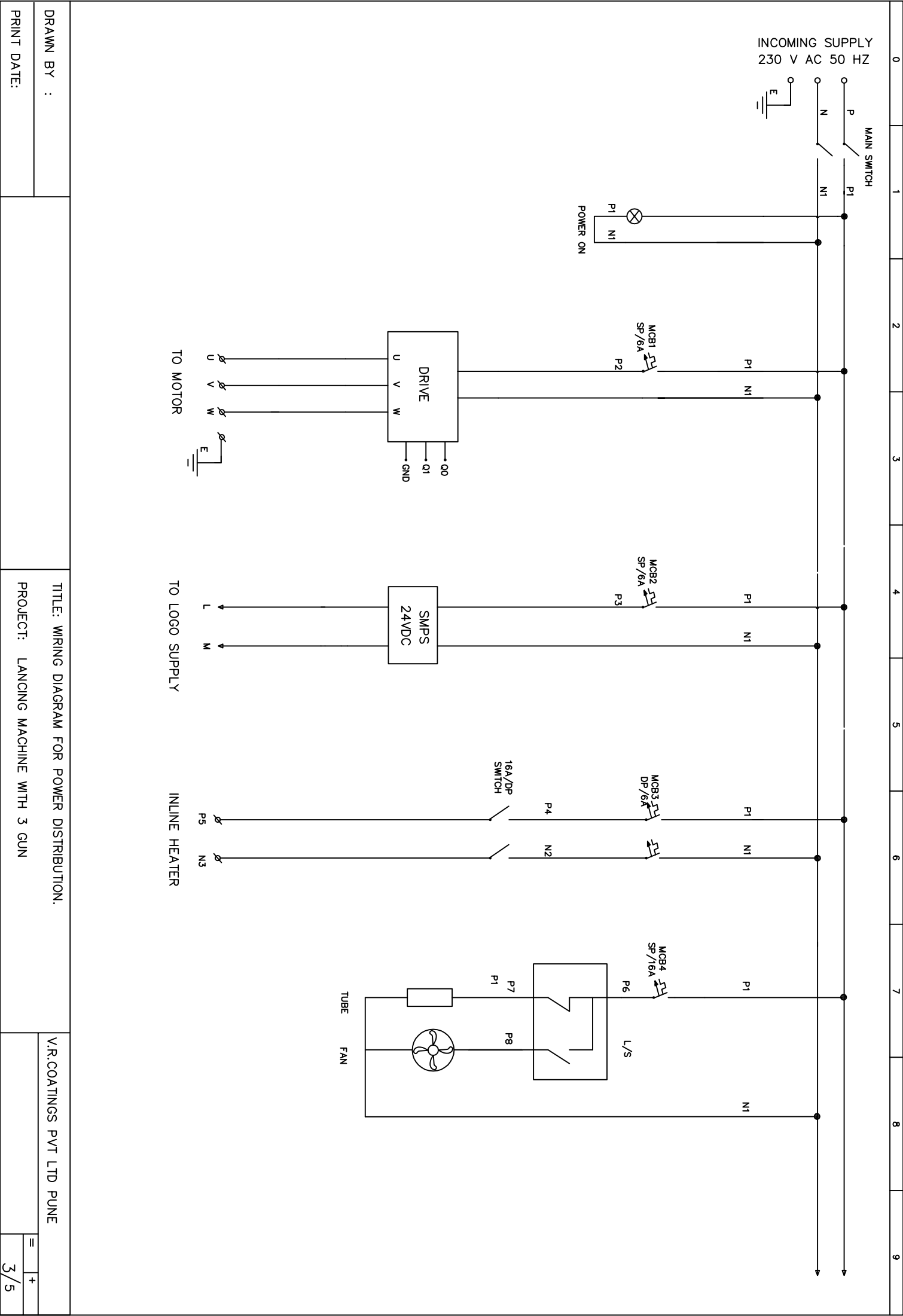
L.H.S. VIEW

FRONT VIEW

R.H.S. VIEW



DRAWN BY :			TITLE: INTERNAL LAYOUT		V.R.COATINGS PVT LTD					
PRINT DATE:			PROJECT: LANCING MACHINE WITH 3 GUN		<table><tr><td>=</td><td>+</td></tr><tr><td colspan="2">2/5</td></tr></table>		=	+	2/5	
=	+									
2/5										



DRAWN BY :

TITLE: WIRING DIAGRAM FOR POWER DISTRIBUTION.

V.R.COATINGS PVT LTD PUNE

PRINT DATE:

PROJECT: LANCING MACHINE WITH 3 GUN

=

+

3/5

24 PIN INPUT/OUTPUT CONNECTOR

1	L	13	Y12R
2	M	14	Y13R
3	Y0R	15	Y14R
4	Y1R	16	Y15R
5	Y2R	17	Y16R
6	Y3R	18	Y17R
7	Y4R	19	X0
8	Y5R	20	--
9	Y6R	21	--
10	Y7R	22	--
11	Y10R	23	--
12	Y11R	24	--

3 PIN HEATER CONNECTOR

1	P3
2	N1
3	E

10 PIN INPUT/OUTPUT CONNECTOR

1	L1
2	M
3	I1
4	I3
5	I6
6	I5
7	Q3
8	Q4
9	Q5
10	Q6

6 PIN CONNECTOR FOR MOTOR

1	U
2	V
3	W
4	E
5	--
6	--

3 PIN CONNECTOR FOR HEATER

1	Y4
2	N2
3	E

OPERATING INSTRUCTIONS

AUTO MODE :

1)	SELECT AUTO/MAN SWITCH TO AUTO MODE.
2)	DURING AUTO CYCLE, HANDSHAKE SIGNAL SHOULD BE ALWAYS ON. PRESS THE CYCLE START PUSHBUTTON. AS SOON AS START COMMAND IS GIVEN, ON DELAY TIMER FOR ALL THREE GUNS GET START. "GUN1, GUN2 AND GUN3" BECOMES ON AFTER THE COMPLETION OF RESPECTIVE ON DELAY TIMERS.
3)	AS GUNS BECOME ON, THEIR RESPECTIVE OFF DELAY TIMERS TRIGGER IMMEDIATELY.
	AND THE GUNS BECOME OFF AFTER THE COMPLETION OF THESE OFF DELAY TIMERS.
4)	ALL THE TIMERS USED ARE USER SETTABLE.
5)	FOR EACH AUTO CYCLE, JOB COUNTER GETS INCREMENTED BY ONE.
6)	PRESS "COUNTER RESET" PB FOR 3 SECONDS, TO RESET THE JOB COUNTER.

MANUAL MODE :

1)	SELECT AUTO/MAN SWITCH TO MANUAL MODE.
2)	SELECT GUN1 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 1 BECOMES "ON".
3)	SELECT GUN2 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 2 BECOMES "ON".
4)	SELECT GUN3 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 3 BECOMES "ON".

OPERATING INSTRUCTIONS

AUTO MODE :

1)	SELECT AUTO/MAN SWITCH TO AUTO MODE.
2)	IF FORWARD PROXY (HOME) IS "ON" AND CYCLE START GIVEN, THEN,AFTER FORWARD ON DELAY,MOTOR STARTS FORWARD ROTATION. WHEN REVERSE PROXY IS SENSED,FORWARD ROTATION STOPS.GUN1 AND GUN2 ON DELAY TIMER STARTS, GUN1 AND GUN 2 STARTS. AND REMAINS "ON" FOR RESPECTIVE OFF DELAY TIMER. AT ITS COMPLETION,REVERSE ON DELAY TIMER STARTS. ON DELAY STARTS,. AT THE COMPLETION OF WHICH,REVERSE ROTATION OF MOTOR STARTS.
3)	AT THE SAME TIME GUN3 ON DELAY STARTS. GUN3 GETS ON AND REMAINS ON TILL Gun3 OFF Proxy(Input 'I3') DOES NOT GET SENSED.
4)	JOB COUNTER INCREMENTS AT THE COMPLETION OF EACH CYCLE.
5)	WHEN CNT RESET PB IS PRESSED FOR 3 SECONDS, THE COUNTER GETS RESET..

MANUAL MODE :

1)	SELECT AUTO/MAN SWITCH TO MANUAL MODE.
2)	SELECT GUN1 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 1 BECOMES "ON".
3)	SELECT GUN2 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 2 BECOMES "ON".
4)	SELECT GUN3 ILLUMINATING SELECTOR SWITCH TO "ON" POSITION. GUN 3 BECOMES "ON".



PARAMETER SETTING

The different parameters used and their function is stated below.
All the parameters are Timers which are user settable and Retentive.

Sr.No.	Parameters	Description
1	GUN1 ON	It is "On Delay Timer" for gun1. When cycle start command is given, this timer gets start. Gun1 becomes on at the completion of this timer.
2	GUN2 ON	It is "On Delay Timer" for gun2. When cycle start command is given, this timer gets start. Gun2 becomes on at the completion of this timer.
3	GUN3 ON	It is "On Delay Timer" for gun3. When cycle start command is given, this timer gets start. Gun3 becomes on at the completion of this timer.
4	GUN1 OFF	It is "Off Delay Timer" for gun1. It starts after the completion of 'Gun1 On' delay timer. Gun1 becomes off at the completion of this timer.
5	GUN2 OFF	It is "Off Delay Timer" for gun2. It starts after the completion of 'Gun2 On' delay timer. Gun2 becomes off at the completion of this timer.
6	GUN3 OFF	It is "Off Delay Timer" for gun3. It starts after the completion of 'Gun3 On' delay timer. Gun3 becomes off at the completion of this timer.
7	JOB_CONT	This parameter represents the job counter. The counter gets incremented by 1 for each auto cycle. Press Counter reset for 3 seconds to reset the counter.

PARAMETER SETTING

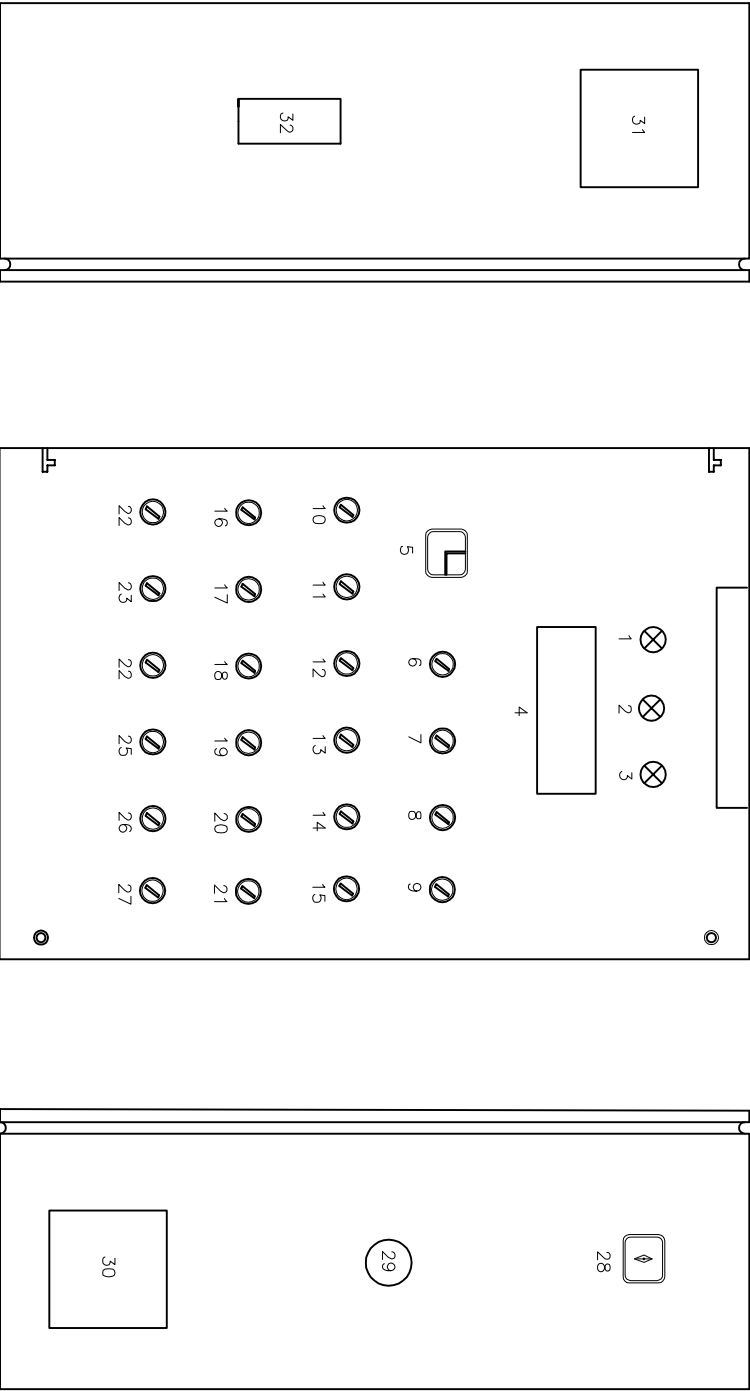
The different parameters used and their function is stated below.
All the parameters are Timers which are user settable and Retentive.

Sr.No.	Parameters	Description
1	FWD_ON_D	When home proxy is ON,Auto Mode is selected and cycle start pb pressed,this timer delay starts. At the completion of forward on delay timer,motor starts its Forward rotation.
2	REV_ON_D	When reverse proxy is sensed and Gun2,Gun3 Off delay timer is over,reverse on delay timer starts.At the completion of reverse on delay timer,motor starts its Reverse rotation.
3	G1_ON_D	When reverse proxy gets ON,Gun1 On delay timer starts.At the completion of this timer, Gun1 becomes ON.
4	G2_ON_D	When reverse proxy gets ON,Gun2 On delay timer starts.At the completion of this timer, Gun2 becomes ON.
5	G1_OFF_D	It is Gun1 Off delay timer.It starts at the completion of Gun1 On delay timer.At the completion of Gun1 Off delay timer, Gun1 becomes OFF.
6	G2_OFF_D	It is Gun2 Off delay timer.It starts at the completion of Gun2 On delay timer.At the completion of Gun2 Off delay timer, Gun2 becomes OFF.

7	G3_ON_D	When reverse proxy is ON and both Gun1 and Gun2 becomes OFF, Gun3 On delay timer starts. At the completion of this timer, Gun3 becomes ON.
8	JOB_CONT	This parameter represents the job counter. The counter gets incremented by 1 for each auto cycle. Press Counter reset for 3 seconds to reset the counter.

LEGENDS:

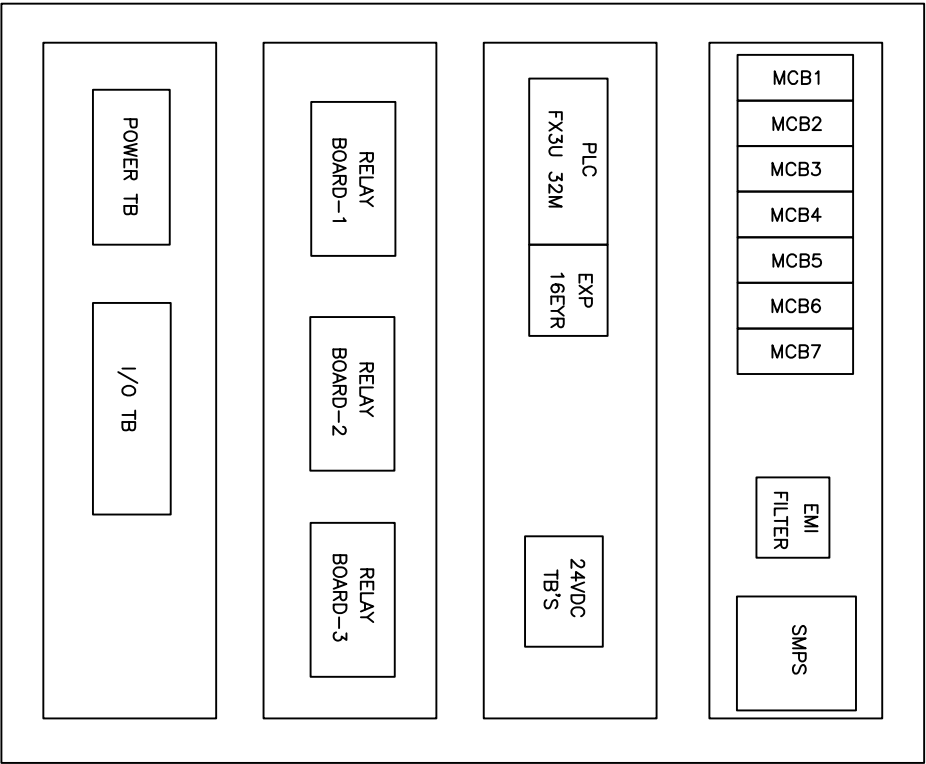
- 1:R-PHASE LAMP
- 2:Y-PHASE LAMP
- 3:B-PHASE LAMP
- 4:HMI
- 5:RECIPE SELECTOR SW
- 6:AUTO / MANUAL SW
- 7:START SW
- 8:SAVE PB
- 9:LOAD PB
- 10:GUN-1 ON/OFF SW
- 11:GUN-2 ON/OFF SW
- 12:GUN-3 ON/OFF SW
- 13:GUN-4 ON/OFF SW
- 14:GUN-5 ON/OFF SW
- 15:GUN-6 ON/OFF SW
- 16:GUN-7 ON/OFF SW
- 17:GUN-8 ON/OFF SW
- 18:GUN-9 ON/OFF SW
- 19:GUN-10 ON/OFF SW
- 20:GUN-11 ON/OFF SW
- 21:GUN-12 ON/OFF SW
- 22:GUN-13 ON/OFF SW
- 23:GUN-14 ON/OFF SW
- 24:GUN-15 ON/OFF SW
- 25:GUN-16 ON/OFF SW
- 26:SPARE
- 27:EMG STOP PB
- 28:MAINS ON/OFF SW
- 29:HEATER CONNECTOR
- 30:FILTER
- 31:FAN+FILTER
- 32:24 PIN I/O CONNECTOR



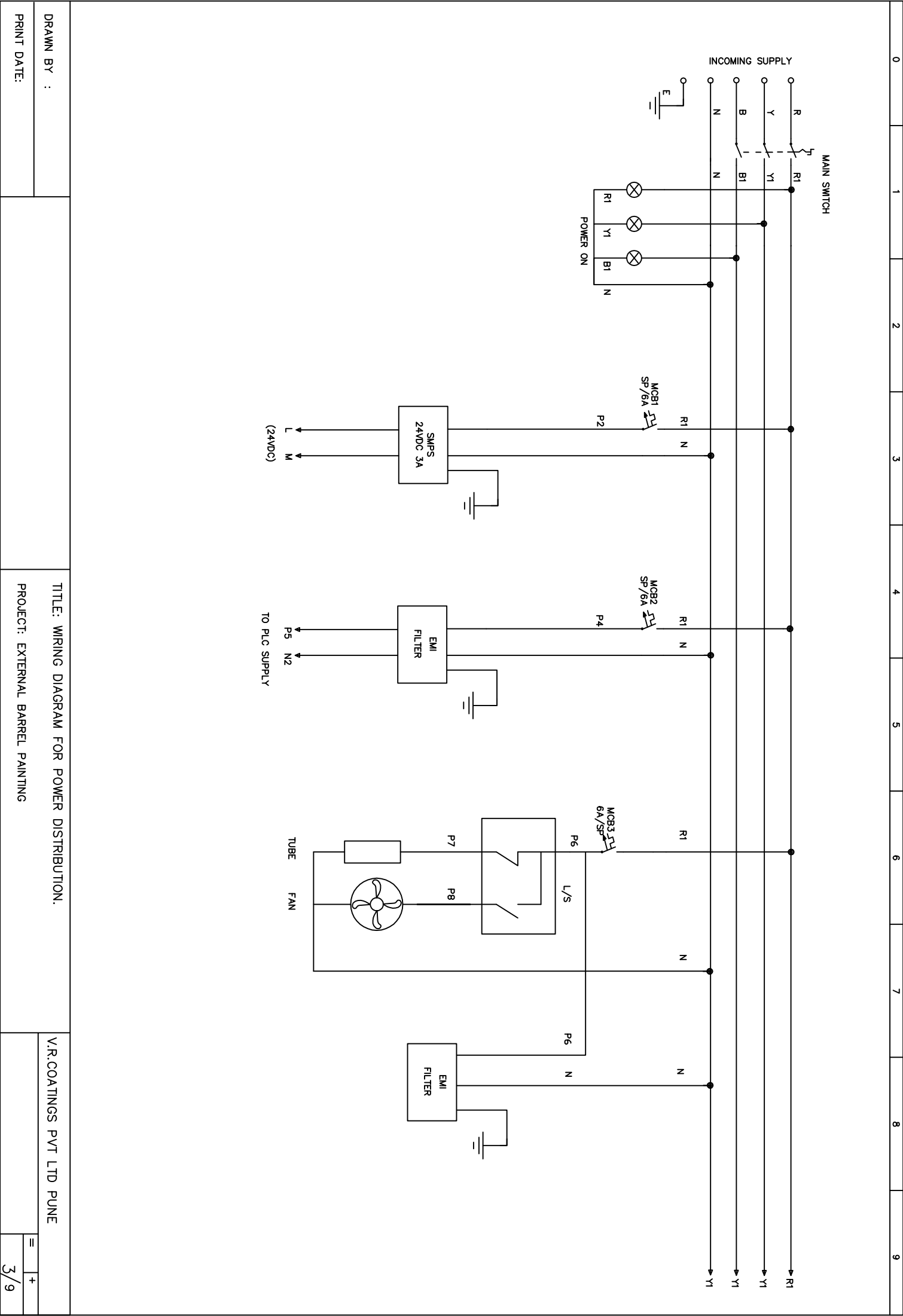
L.H.S. VIEW

FRONT VIEW

R.H.S. VIEW



0	1	2	3	4	5	6	7	8	9
DRAWN BY :				TITLE: INTERNAL LAYOUT			V.R.COATINGS PVT LTD, PUNE		
PRINT DATE:				PROJECT: EXTERNAL BARREL PAINTING			= +		
							2/10		

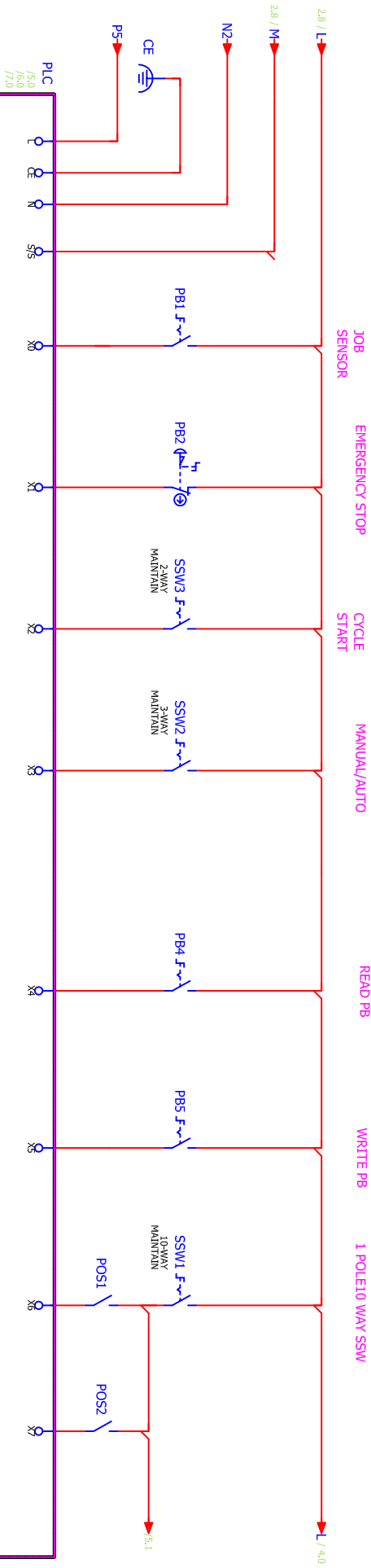


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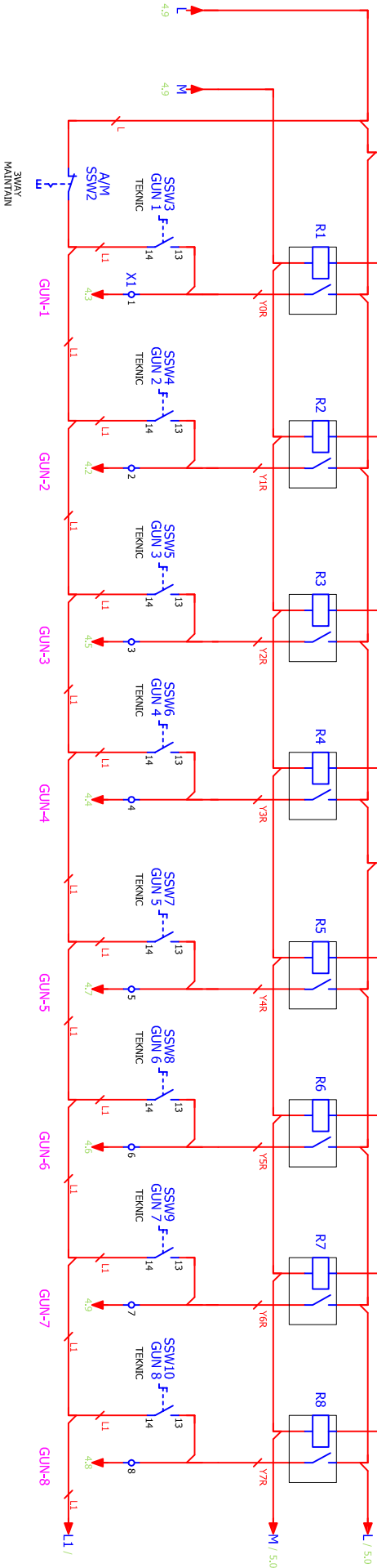
PRINT DATE:

PROJECT: EXTERNAL BARREL PAINTING



MITSUBISHI MELSEC PLC CPU

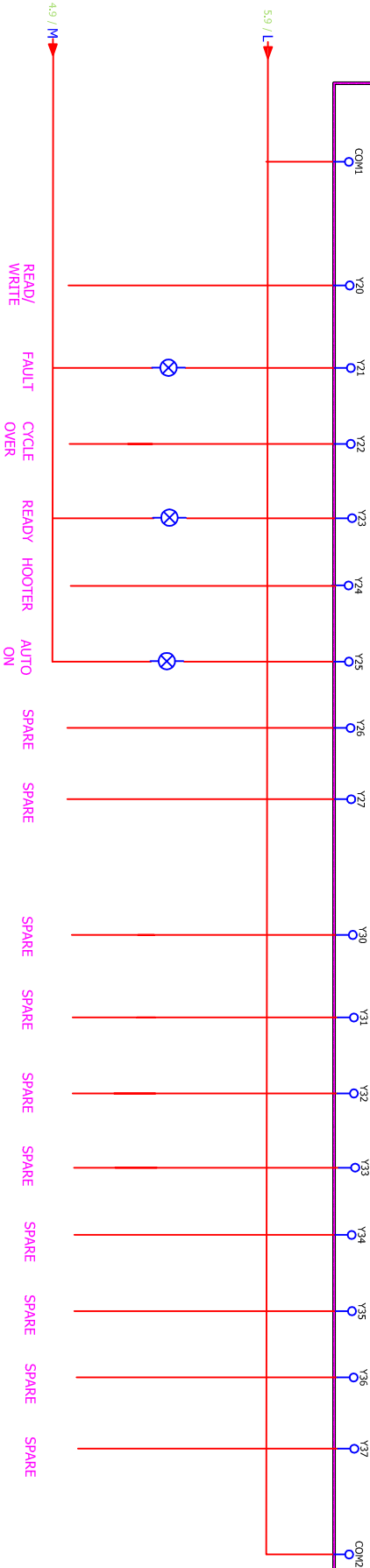
FX3U-32M



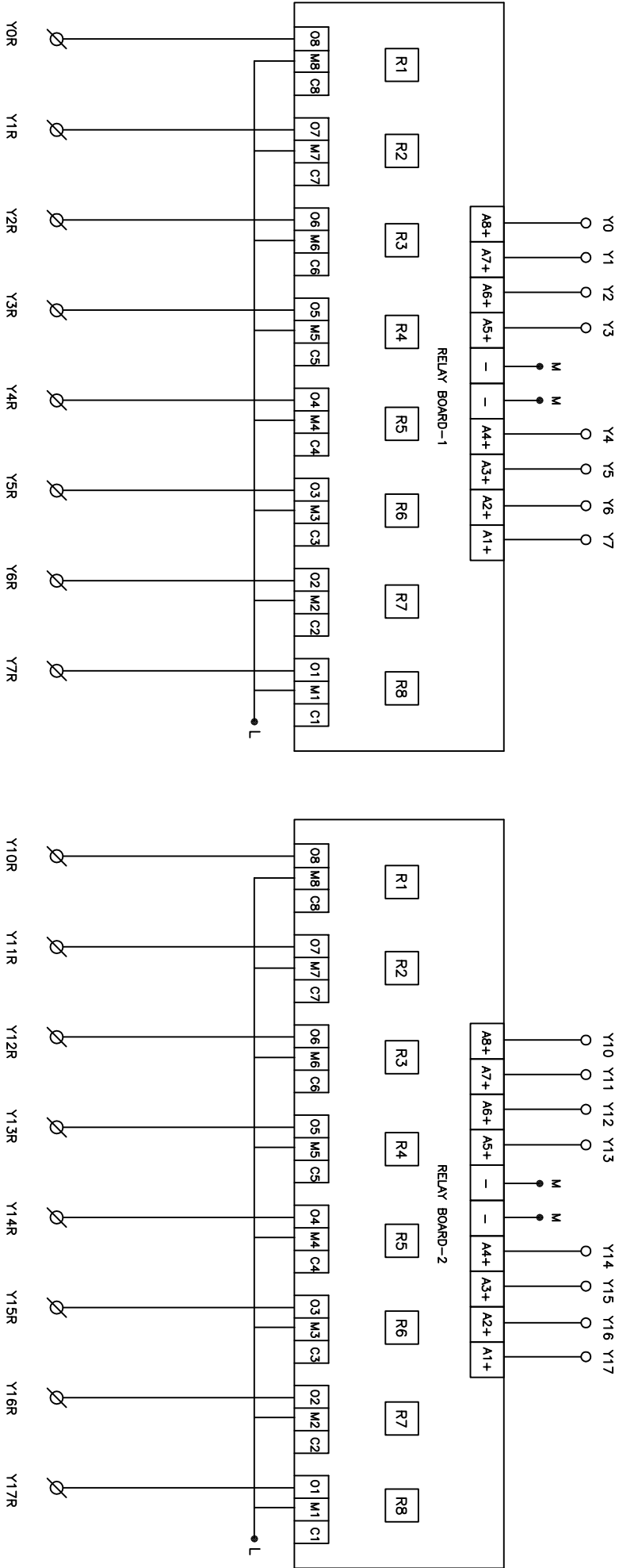
PLC
/4/2
/5/2
/7/2

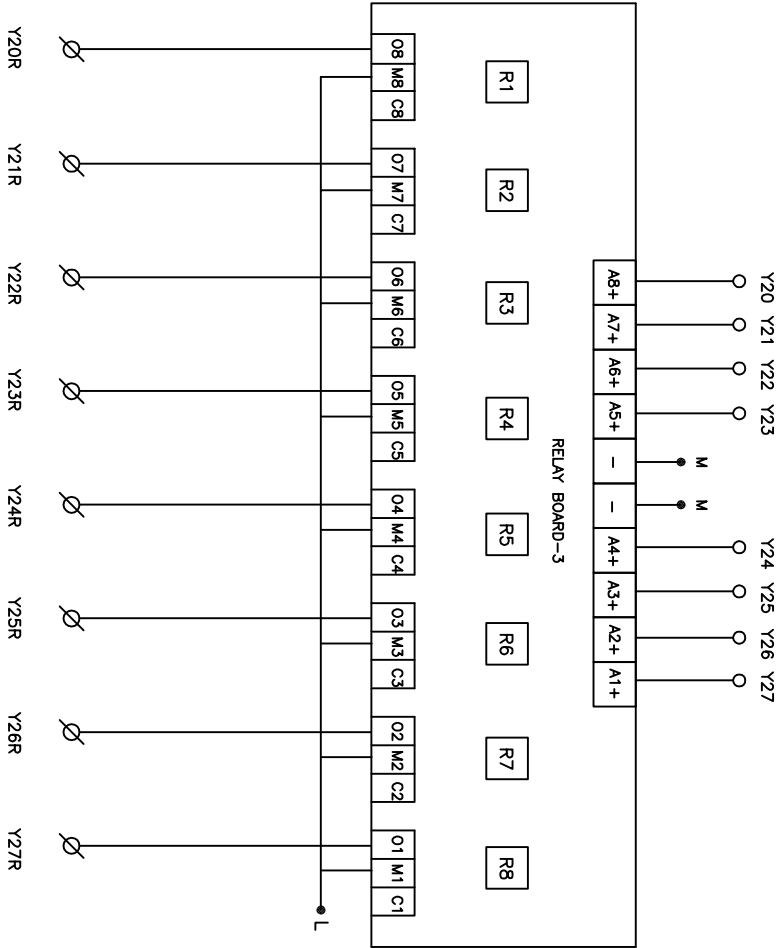
MITSUBISHI PLC O/P CARD

FX2N-16EYR



DRAWN BY :		TITLE: PLC WIRING DIAGRAM		V.R. COATINGS PVT LTD PUNE	
PRINT DATE:		PROJECT: EXTERNAL BARREL PAINTING SYSTEM		DWG. NO:	
				= + 7 / 10	

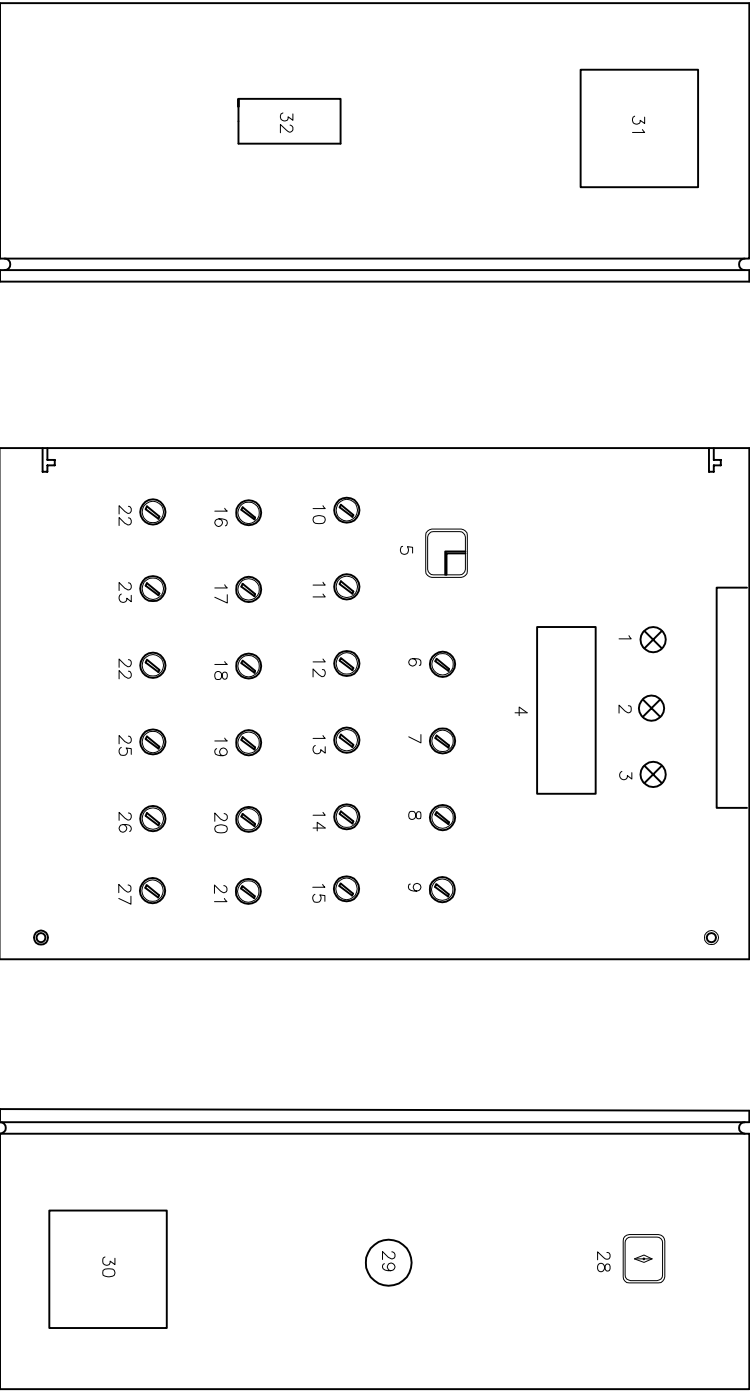




DRAWN BY :		TITLE: RELAY BOARD WIRING		VR COATINGS PVT LTD	
PRINT DATE:		PROJECT: EXTERNAL BARREL PAINTING PANEL		DWG. NO:	
				= +	
				9/10	

LEGENDS:

- 1:R-PHASE LAMP
- 2:Y-PHASE LAMP
- 3:B-PHASE LAMP
- 4:HMI
- 5:RECIPE SELECTOR SW
- 6:AUTO / MANUAL SW
- 7:START SW
- 8:SAVE PB
- 9:LOAD PB
- 10:GUN-1 ON/OFF SW
- 11:GUN-2 ON/OFF SW
- 12:GUN-3 ON/OFF SW
- 13:GUN-4 ON/OFF SW
- 14:GUN-5 ON/OFF SW
- 15:GUN-6 ON/OFF SW
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- 22:GUN-13 ON/OFF SW
- 23:GUN-14 ON/OFF SW
- 24:GUN-15 ON/OFF SW
- 25:GUN-16 ON/OFF SW
- 26:SPARE
- 27:EMG STOP PB
- 28:MAINS ON/OFF SW
- 29:HEATER CONNECTOR
- 30:FILTER
- 31:FAN+FILTER
- 32:24 PIN I/O CONNECTOR



L.H.S. VIEW

FRONT VIEW

R.H.S. VIEW