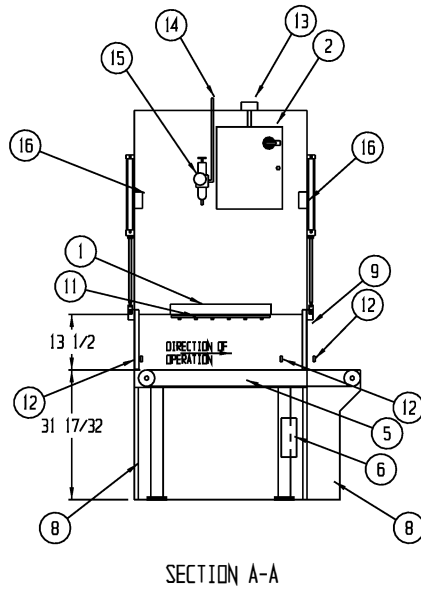
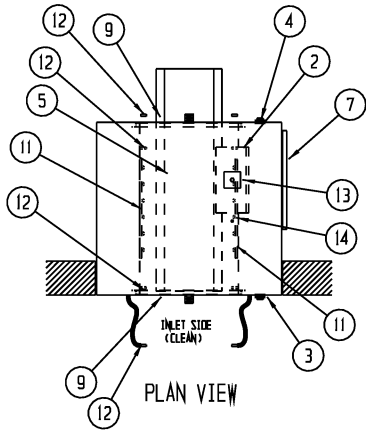


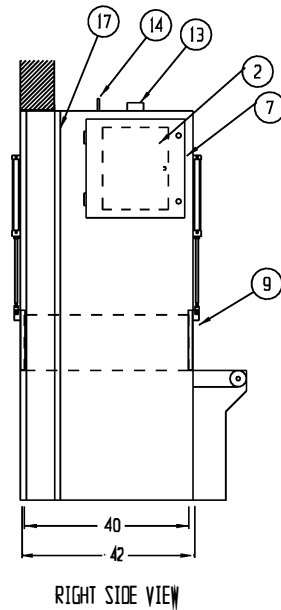
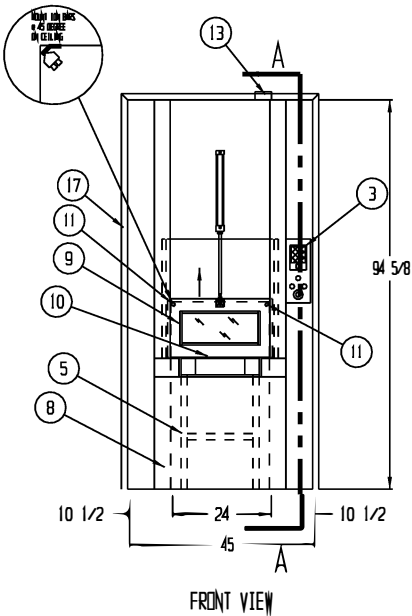
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



GENERAL NOTES:

- CONSTRUCTION TO BE 16 GA. TYPE 304 STAINLESS STEEL WITH #4 FINISH
- SINGLE CUSTOMER ELECTRICAL CONNECTION, 480 VOLT, 3 PHASE, 60 HZ, 2.0FLA
- PASS-THRU TO SHIP IN ONE PIECE COMPLETELY ASSEMBLED, CONVEYOR LOOSE
- ELECTRICAL TO MEET LATEST NEC CODES
- PASS THRU TO BE PROVIDED WITH AN ALLEN BRADLEY MICRO 820 PLC
- UPON POWER LOSS DOORS WILL FAIL CLOSED
- PLC CONTROL TO PROVIDE A RELAY OUTPUT TO CUSTOMER CONVEYOR CONTROL WHEN INLET DOOR IS OPEN (INLET PERMISSIVE)

- ① 1 EA. 2 FT LED LIGHT FIXTURE CAPABLE OF PRODUCING 100 FC AT THE CONVEYOR
- ② ELECTRICAL CONTROLS ENCLOSURE WITH NON FUSED DISCONNECT SWITCH
- ③ MAIN CONTROL PANEL WITH INTERCOM, DOOR STATUS LIGHTS, LIGHT SWITCH WITH PILOT LIGHT, CONTROL SWITCH WITH PILOT LIGHT AND EMERGENCY SHUT DOWN MUSHROOM SWITCH.
- ④ DIRTY SIDE ELECTRICAL PANEL WITH DOOR STATUS LIGHTS, INTERCOM, AND EMERGENCY SHUT DOWN MUSHROOM SWITCH.
- ⑤ 1 EA. LPB1612 X 4' -4" LIGHT DUTY SLIDER BED CONVEYOR WITH 12" WIDE BLACK PVC BELT. CONVEYOR CONTROLLED BY PLC (CONVEYOR TO EXTEND 12" OUT EXIT SIDE OF PASS-THRU)
- ⑥ CONVEYOR VARIABLE FREQUENCY DRIVE WITH SPEED POT ADJUSTMENT
- ⑦ HINGED SERVICE ACCESS DOOR
- ⑧ REMOVABLE CONVEYOR SERVICE PANELS (BOTH SIDES)
- ⑨ AUTOMATIC VERTICAL SLIDING DOOR FABRICATED OF 1" X 3" STAINLESS STEEL TUBING WITH 1/4" CLEAR ANTI STATIC PVC IN BLACK PVC SNAP TRIM. DOOR TO HAVE PNEUMATIC ACTUATOR WHICH WILL BE CONTROL BY PLC .
- ⑩ DOOR SAFETY TAPE SWITCH
- ⑪ 2 EA 2 FT ION PULSE BARS FOR STATIC CONTROL
- ⑫ 4 SETS PHOTOELECTRIC SENSORS FOR PRODUCT DETECTION (1 SET TO BE INSTALLED BY CUSTOMER)
- ⑬ ELECTRICAL JUNCTION BOX FOR CUSTOMER CONNECTION
- ⑭ 1/4 NPT COMPRESSED AIR CONNECTION
- ⑮ COMPRESSED AIR REGULATOR
- ⑯ 5 PORT 2-WAY PNEUMATIC VALVES WITH ELECTRIC SOLENOID
- ⑰ 1 1/2" X 1 1/2" X 16 GA TYPE 304 STAINLESS STEEL FINISHING TRIM



SEQUENCE OF OPERATION:

- AT REST BOTH DOORS WILL BE CLOSED, PASS-THRU CONVEYOR WILL BE RUNNING AND CUSTOMER CONVEYOR PERMISSIVE WILL BE ACTIVE
- WHEN PRODUCT REACHES THE INLET SENSOR, THE CUSTOMER CONVEYOR PERMISSIVE WILL DEACTIVATE AND THE INLET DOOR WILL OPEN
- ONCE THE INLET DOOR IS FULLY OPEN THE CUSTOMER CONVEYOR PERMISSIVE WILL ACTIVATE
- WHEN PRODUCT PASSES THE INTERIOR INLET DOOR SENSOR THE INLET DOOR WILL CLOSE.
- ONCE THE INLET DOOR IS FULLY CLOSED THE OUTLET DOOR WILL OPEN. IF PRODUCT REACHES THE OUTLET SIDE INTERIOR SENSOR BEFORE THE DOOR OPENS THE CONVEYOR WILL STOP
- WHEN THE OUTLET SIDE DOOR IS FULLY OPEN THE CONVEYOR WILL TRANSFER PRODUCT OUT OF THE PASS-THRU
- AFTER PRODUCT CLEARS THE EXTERIOR OUTLET DOOR SENSOR THE DOOR WILL CLOSE
- THE CUSTOMER CONVEYOR PERMISSIVE WILL REMAIN ACTIVE UNTIL PRODUCT REACHES THE INLET SENSOR
- IF THERE IS PRODUCT WAITING AFTER THE OUTLET DOOR CLOSES A NEW CYCLE WILL BEGIN.
- IF THERE IS NO PRODUCT WAITING THE UNIT WILL BE AT REST WITH CONVEYOR RUNNING

DRAWN FOR	Halco Products Co. 100 Gordon Street, Elk Grove, IL. 60007		
TITLE	PT2413-40/SS/PLC/ION/AD/SP		
DRAWN BY	SIZE	JOB NO. 13734	ENG. NO. 1519062BC
APPROVED BY	SCALE	DATE	SHEET