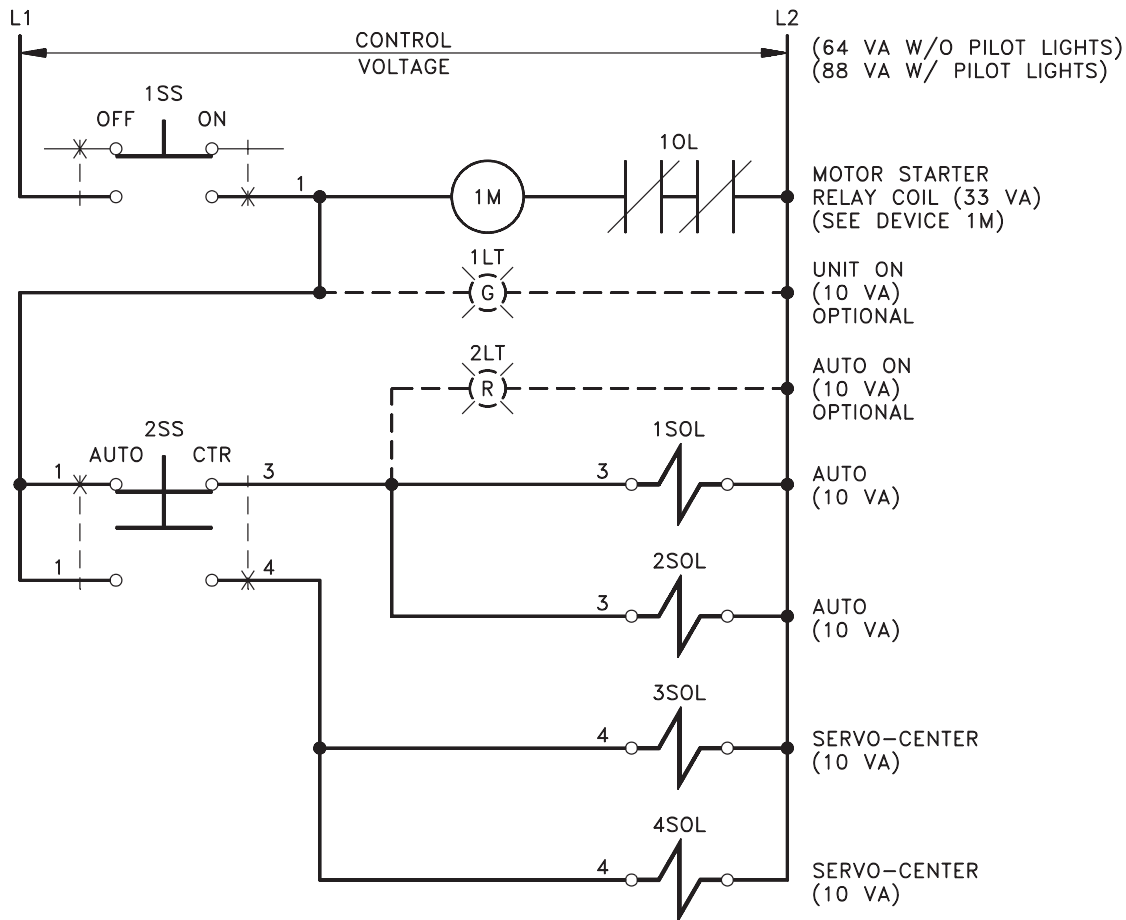


NOTES-

- CAREFULLY PRE-SET THE DISTANCE BETWEEN THE SENSOR "REFERENCE" MARKS TO THE "NOMINAL" WEB WIDTH. THE WORKING WEB WIDTH RANGE IS ± 0.25 INCH BEYOND THIS SETTING.
- SIGNAL AND PRESSURE LINES TO BE AS SHORT AS POSSIBLE WITH A MAXIMUM LENGTH OF 144 INCHES (3,655 MM). THE LINES SHOULD BE CUT IN PAIRS (TWO SIGNAL LINES AND TWO PRESSURE LINES) SO THEY WILL BE THE SAME LENGTH.
- REVERSE SIGNAL LINE CONNECTIONS BETWEEN "S1" AND "S2" TO CHANGE POLARITY BETWEEN SIGNALS AND HYDRAULIC CYLINDER.
- REVERSE LINE CONNECTIONS BETWEEN "S3" AND "S4" TO CHANGE POLARITY BETWEEN SERVO-CENTER VALVE AND HYDRAULIC CYLINDER.

LINE LEGEND	
	HYDRAULIC PRESSURE
	PNEUMATIC SUPPLY
	PNEUMATIC SIGNAL

MODELS PC1-11 AND PC1-11-L



FUNCTION OF CONTROLS

1. "OFF — ON" (1SS)

OFF POSITION THE COMPLETE CONTROL CIRCUIT IS DE-ENERGIZED.

ON POSITION THE POWER UNIT, CONTROL CIRCUIT, AND 1LT ARE ENER-GIZED.

2. "AUTO — CTR" (2SS)

AUTO POSITION 1SOL, 2SOL, AND 2LT ARE ENER-GIZED. 3SOL AND 4SOL ARE DE-ENERGIZED. THE GUIDE MECHANISM IS POSI-TIONED BY THE SERVO VALVE IN RESPONSE TO SIG-NALS FROM THE SENSORS.

CTR POSITION 3SOL AND 4SOL ARE ENER-GIZED. 1SOL, 2SOL, AND 2LT ARE DE-ENERGIZED. THE GUIDE MECHANISM IS POSI-TIONED BY THE SERVO VALVE IN RESPONSE TO SIG-NALS FROM THE SERVO-CENTER VALVE.

DEVICES

- 1SS MAINTAINED CONTACT SELECTOR SWITCH
- 2SS MAINTAINED CONTACT SELECTOR SWITCH WITH OVERLAPPING CONTACTS
- 1SOL SOLENOID
- 2SOL SOLENOID
- 3SOL SOLENOID
- 4SOL SOLENOID

NOTE: ALL SWITCHES, PILOT LIGHTS, AND MOTOR STARTERS TO BE SUPPLIED BY CUSTOMER OR FIFE CORPORATION AS REQUESTED ON CUSTOMER PURCHASE ORDER.

CONTROL STATIONS

