

YAI-F26-6-PLC Operations Manual



Corrective Notice

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Power Specs

Feeder Breaker Size	50 AMPS Max
Wire Size	10 Gauge Stranded
Number Of Wires	4
Ground Wire	Required
Hertz	60/hrz
Voltage	480/460 ±10%
Power Cord	10-4 12-0" from Machine Supplied
Color Code For Wire	Red = 277 VAC White = 277 VAC Black = 277 VAC Green = Ground

Power Cord Location

Machine is shipped from our factory with 10-4 600 Volt rated cable. Standard length is 12'-0" long measured from the point it exits the machine from the cord grip. Should you require a longer length, please call our office. The cord exits out of the machine in the area shown in the picture below.



Figure 3: Power Cord Entry

Main Breaker

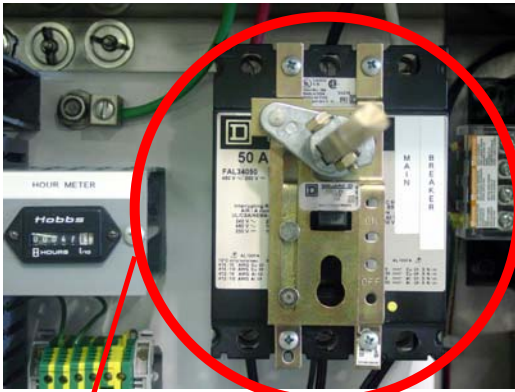


Figure 1: Main Breaker 50 AMP

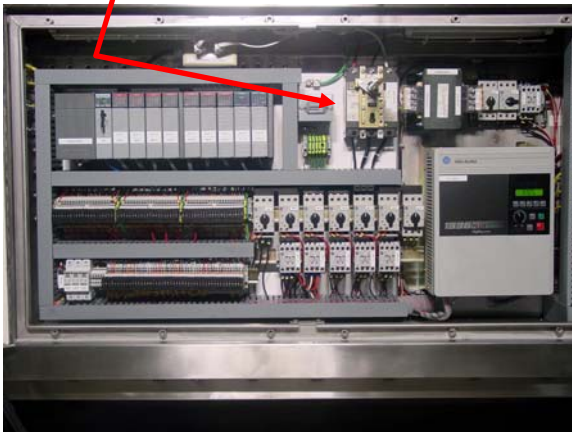


Figure 2: Main Breaker Panel Location

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Electrical Grounding

Power cord is wired to the top side of our breaker. Ground is secured to the sub-panel of the machine as shown in picture below. It is important that the other end of this ground cable is secured to grounded building system.

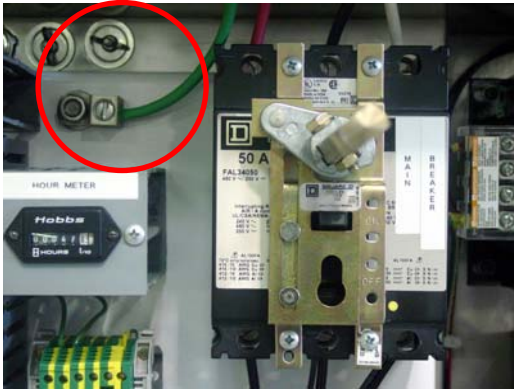


Figure 4: Ground Lug

WARNING!

A separate earth ground wire of the same conductor size as the input power is required to be connected to the chassis of the machine. This ground wire is required for operator safety and for proper operation. This ground must be supplied from the main plant ground at the service entrance, and should be routed in the same conduit as the input power to the machine. A local water pipe or ground rod adjacent to the machine cannot be used for this purpose.

Input power to machine must be grounded. For wye power, the neutral must be grounded. For delta power, central leg ground or one leg ground should be used. Machine will not function properly on ungrounded power.

The rate horsepower of the machine may not be achieved if imbalance of incoming voltage is beyond an acceptable limit. Machine may function properly, yet not deliver the advertised power.

Maximum leg-to-leg or leg-to-ground should not exceed 504 volts.

Amperage requirements for machines main circuit breaker are rated for the internals of the machine. It may be necessary to size the external service breaker up 20-25%, as indicated by power supply for proper operation.

Water Requirements Oil Cooler

Young & Associates high speed forming machine is supplied with shell and tube oil cooler. This oil cooler must be plumbed, and water flowing prior to starting machine.

This feature is required to maintain hydraulic oil temperature at 150°F. Machine has been tested at the factory and thermostat control has already been set.

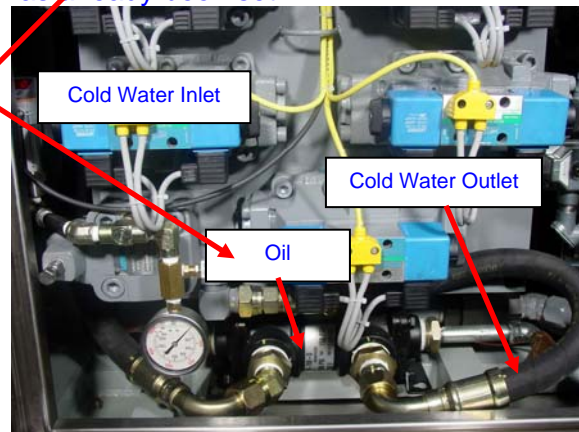


Figure 5: Oil Cooler

Customer supplied 65°F 10 GPM cold water line from a potable water supply, pressure shall not exceed 70PSI. A shut-off valve provided in-line will allow you to service the heat exchanger. Inlet / outlet will accept 1/2" NPT male fitting.

Customer will need to plumb 1/2" drain line to carry water from heat exchanger. Drain line should run directly into floor drain. Do not allow water to drain directly onto the floor. May cause injury by allowing someone to slip and fall while working around machine.

Air Requirements

Only machines that have the paper feed option purchased.

Paper feed system requires minimum of 100 PSI at 4 SCFM at the input to the pressure regulator.

WARNING!

Paper bar blowback system needs only 10 PSI of clean filtered air to work correctly. Do not regulate pressure more than 10 PSI during operation of this machine. Will cause o-ring seals for bar to fail.

NOTE!

Excessive oil and water in air supply will cause machine to malfunction. Air filter regulator should be drained 2X (times) during an 8 (eight) hour shift. Excessive contaminants in the air line may clog vacuum valves or damage vacuum pumps. Remove air supply from machine. Place small container under drain of filter and allow water to run off. Latch the door and return machine to service.

This filter/regulator is accessed by opening door #3 on the vacuum box.

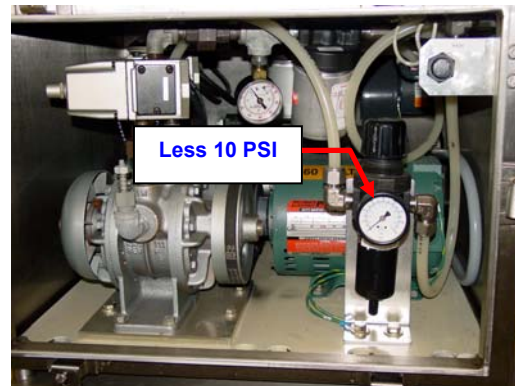


Figure 7: Air Regulator

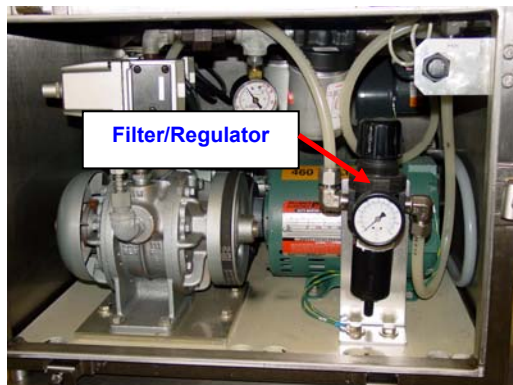


Figure 6: Paper Feed Blowback Regulator

Air Hookup Location

Customer is to supply flex line to vacuum box as shown. Air line shall have female quick disconnect type fitting installed on air line. Control panel will have fittings in which customer may install male fittings to mate with hose supplying air.



Figure 8: Paper Bar Blowback Air Line Hookup