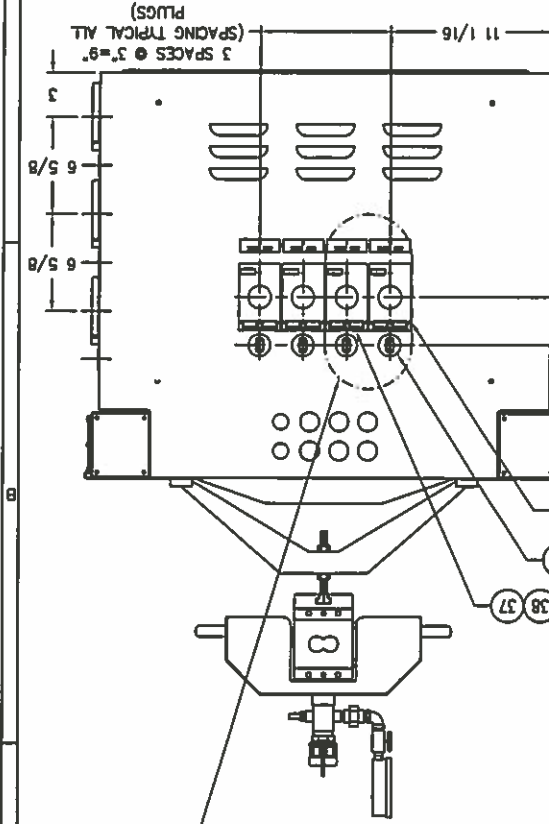
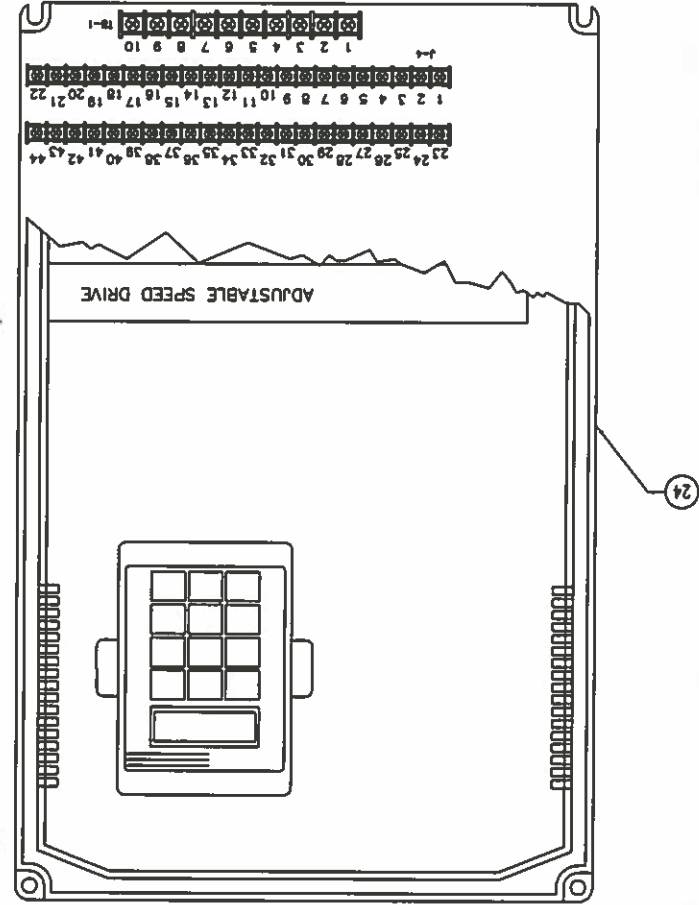
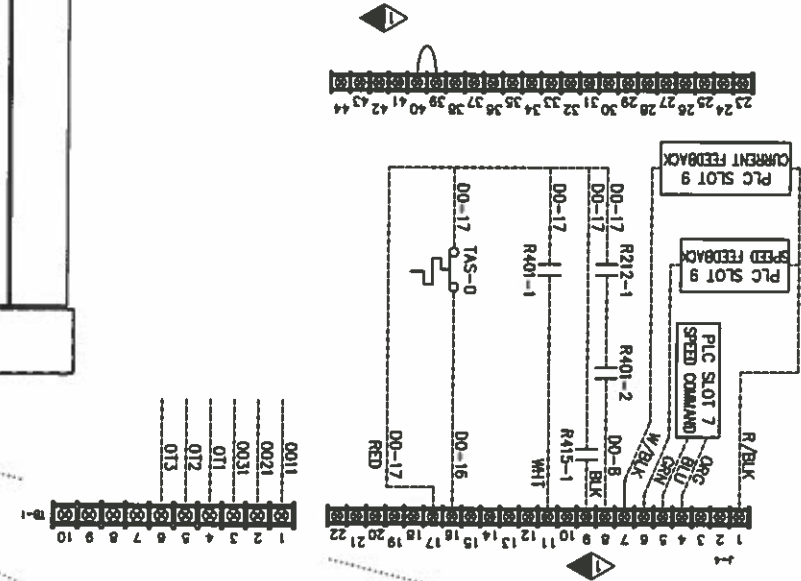
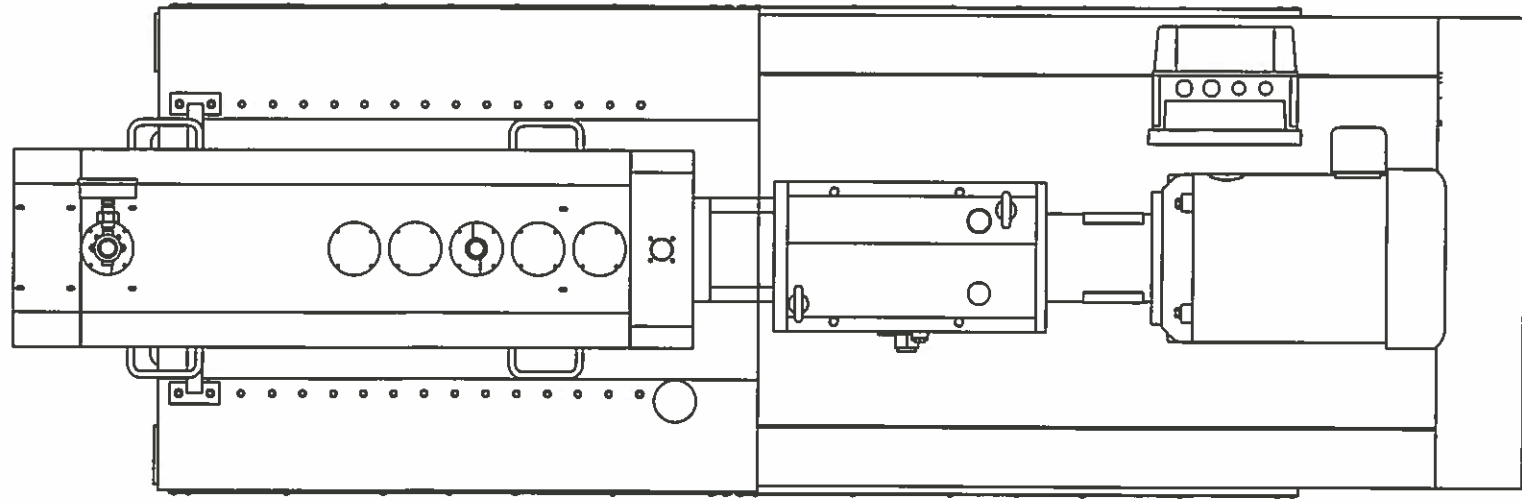
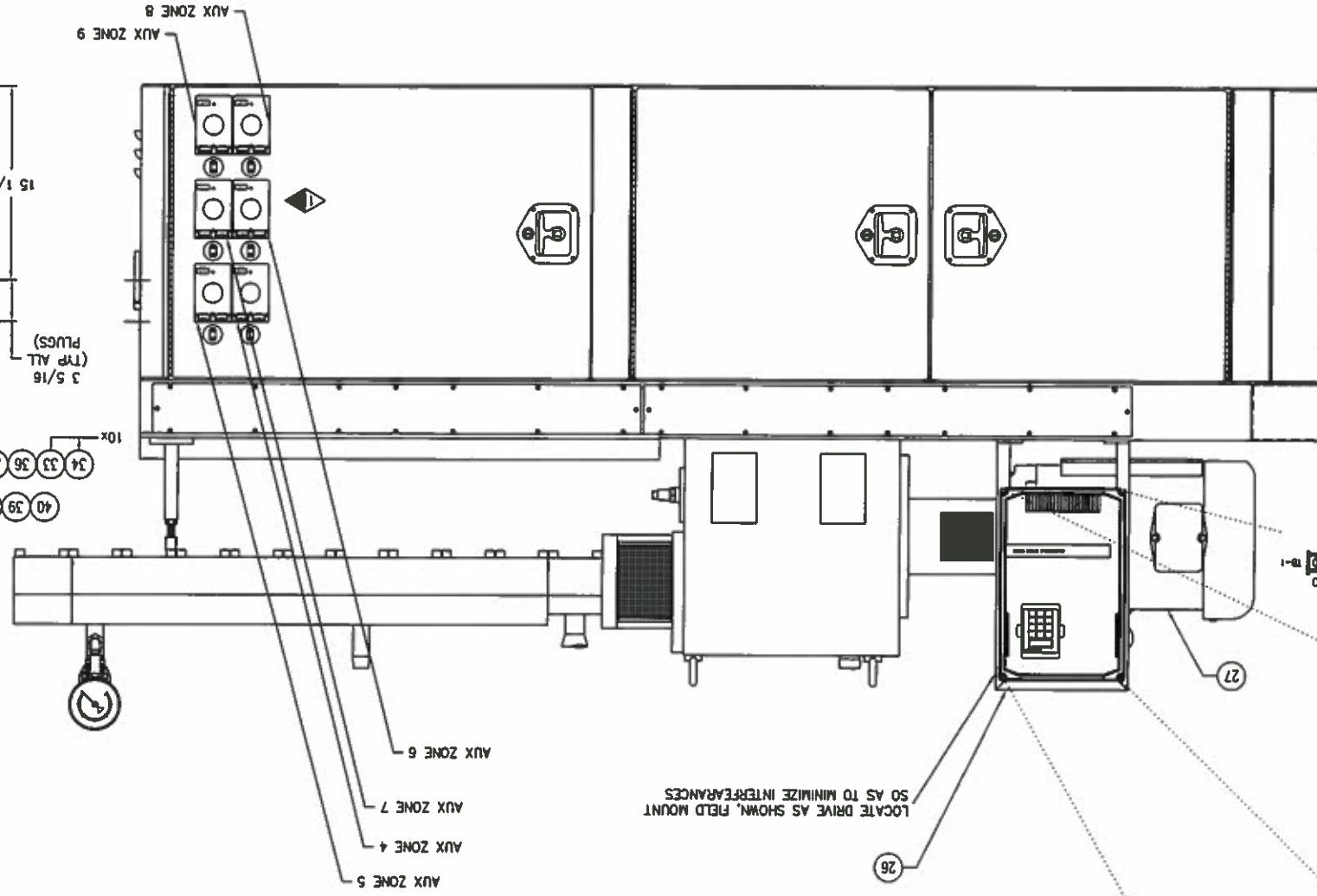


PLST SCALE AND DETAIL 1/4" = 1" DATE 10/15/88 BY J. HANSSARD	PROJECT NUMBER 5801	SHEET : OF : 1
	1" = 6" D	1
27MM E-MAX 15846 MAIN DRIVE LAYOUT MOTOR/HEATER ENCLOSURE		
MANUFACTURING INC. 250 N. HANSSARD LEBANON, OR 97355 PHONE 258-3901		

NOTE: ITEM NUMBERS REFERENCE TO THE BOM FOR DRAWING #5802A

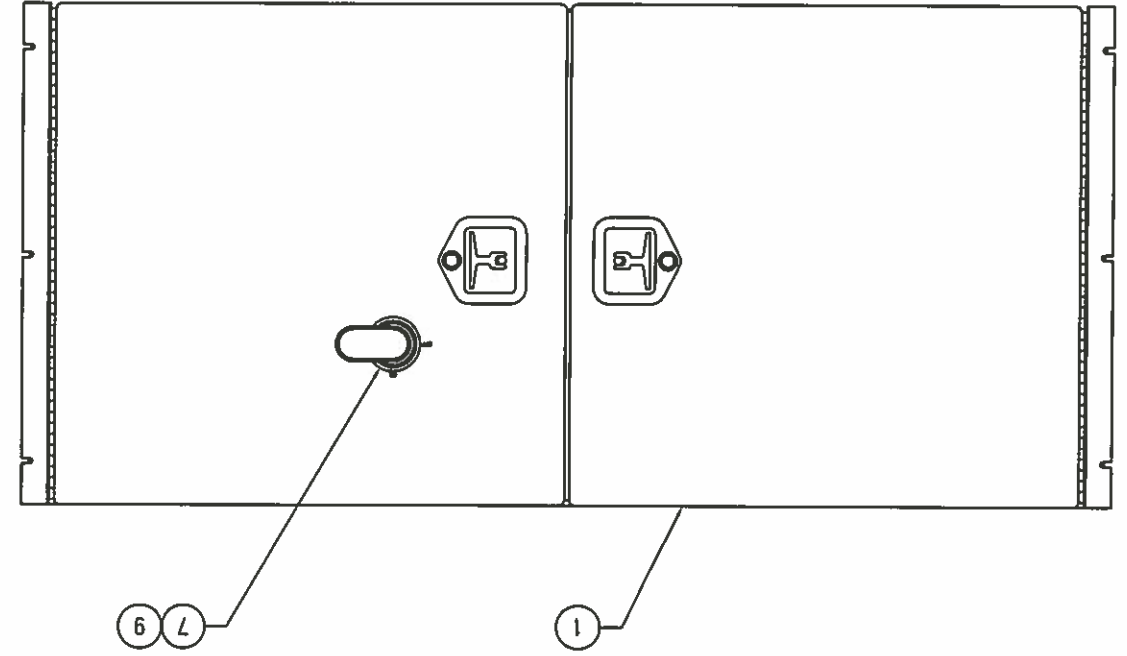
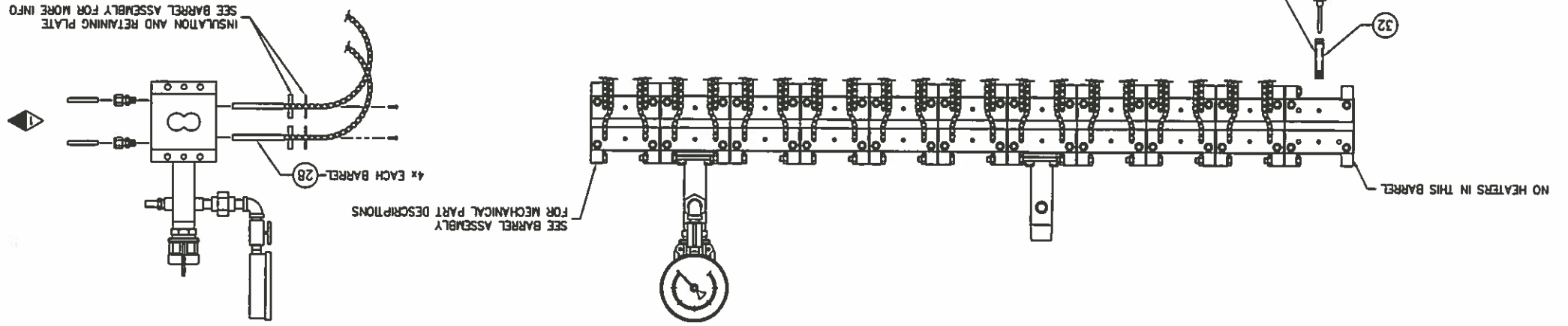


ALTERNATING PLUG ARRANGEMENT
LEFT 480 SINGLE PHASE, RIGHT
480 3 PHASE. REPEAT PATTERN FOR
ALL PLUG ARRANGEMENTS



REV	DESCRIPTION	DATE	BY
1	REWORK COILING PLATE WITH NUTS	03/01/02	DLM
2	NO NUTS BARE TO THIS SHEET	03/01/02	DLM

5802



NOTE:
ITEM #S 24-27, 33-40 CAN BE FOUND ON DRAWING #5801

RELEASED
SEP 19 2002

PROJECT: 15846 SHEET: 1 OF 3 DATE: 03/01/02 DRAWN BY: DLM CHECKED BY: DLM APPROVED BY: DLM	
TITLE: MOTOR/HEATER ENCLOSURE PANEL LAYOUT 27MM E-MAX 15846	
MANUFACTURING INC. 250 N. HANSHARD LEBANON, OR 97355 PHONE: 258-3901	
DO NOT SCALE DLM 03/01/02 DLM 03/01/02 DLM 03/01/02	



NOTE:
ITEM #S 24-27, 33-40 CAN BE FOUND ON DRAWING #5801

NO.	DESCRIPTION	DATE	BY	AMOUNT
1	GLASS LABELING TO HAWAII ZONES AND ITEM #2	05/25/00	PLD	0
2	ADD IN OVER SPOTS FOR HAWAII ZONES	07/18/00	PLD	0



5803	DATE	BY	CHK
1	DATE	BY	CHK
2	DATE	BY	CHK

5803

DO NOT WRITE IN THESE AREAS

WIRING AND PLUG WIRING EXAMPLE

WIRING AND PLUG WIRING EXAMPLE

WIRING AND PLUG WIRING EXAMPLE

WIRING AND PLUG WIRING EXAMPLE

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WIRING AND PLUG WIRING EXAMPLE

RELEASED
SEP 19 2002

27MM EXTRUDER TERMINAL LEGEND
ENCLOSURE
HEATER/MOTOR ENCLOSURE
PLC ENCLOSURE
OPERATOR INTERFACE

27MM E-MAX 15846
MOTOR/HEATER ENCLOSURE
POWER DISTRIBUTION
250 N. HANSAARD
LEBANON, OR 97355
PHONE 228-3901
DO NOT SCALE
03/05/02
03/05/02
DLM
DLM
5803

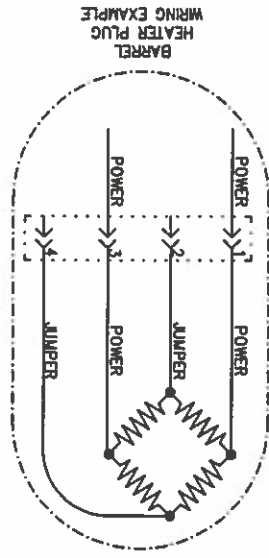
AUX ZONE 0 / ADAPTER
600W CAPACITY

AUX ZONE #1 / SCREEN CHANGER
2400W

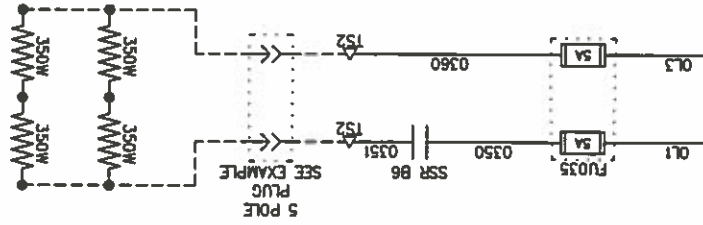
AUX ZONE #2 / ADAPTER
400W CAPACITY

AUX ZONE #3 / MELT PUMP
1000W CAPACITY

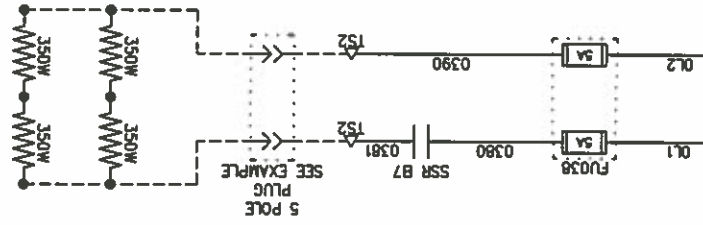
AUX ZONE #4 / ADAPTER
600W CAPACITY



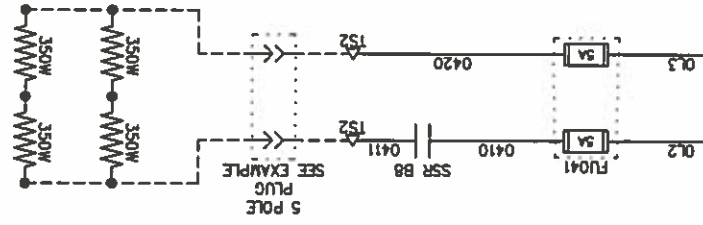
BARREL ZONE 6
1400W CAPACITY



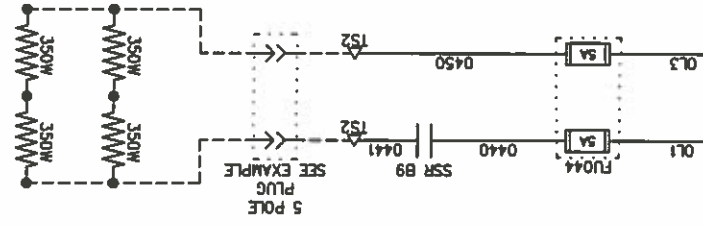
BARREL ZONE 7
1400W CAPACITY



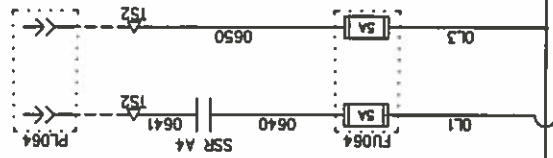
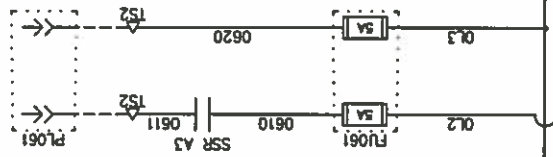
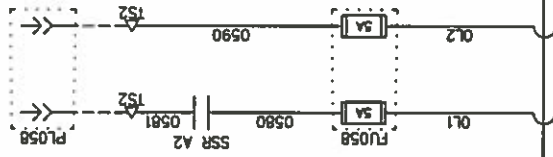
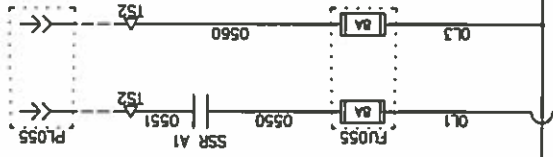
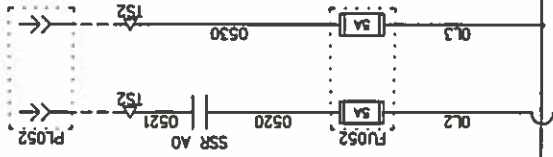
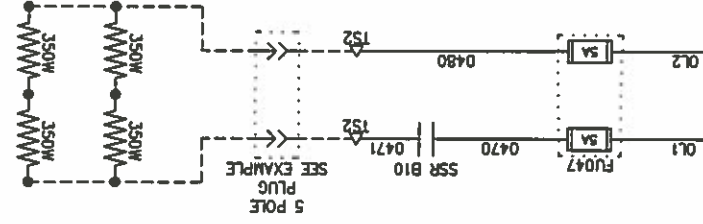
BARREL ZONE 8
1400W CAPACITY



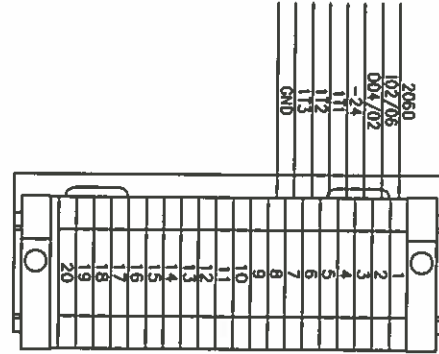
BARREL ZONE 9
1400W CAPACITY



BARREL ZONE 10
1400W CAPACITY



TS1
MOTORS / MOTOR I/O



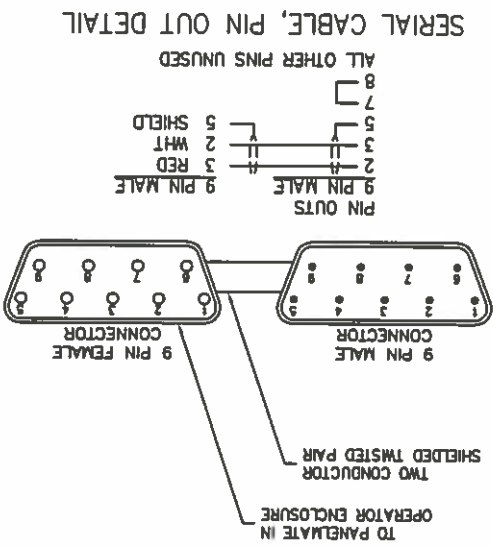
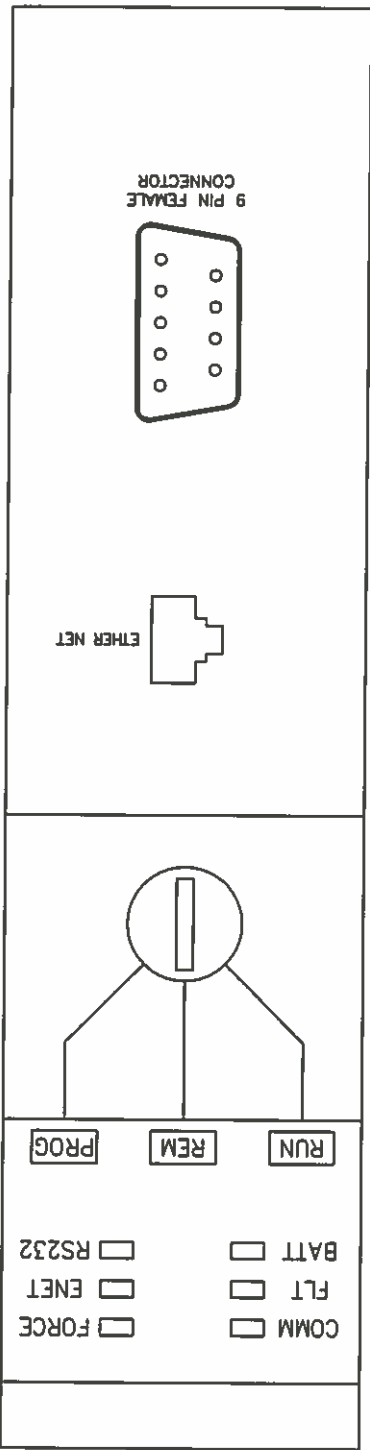




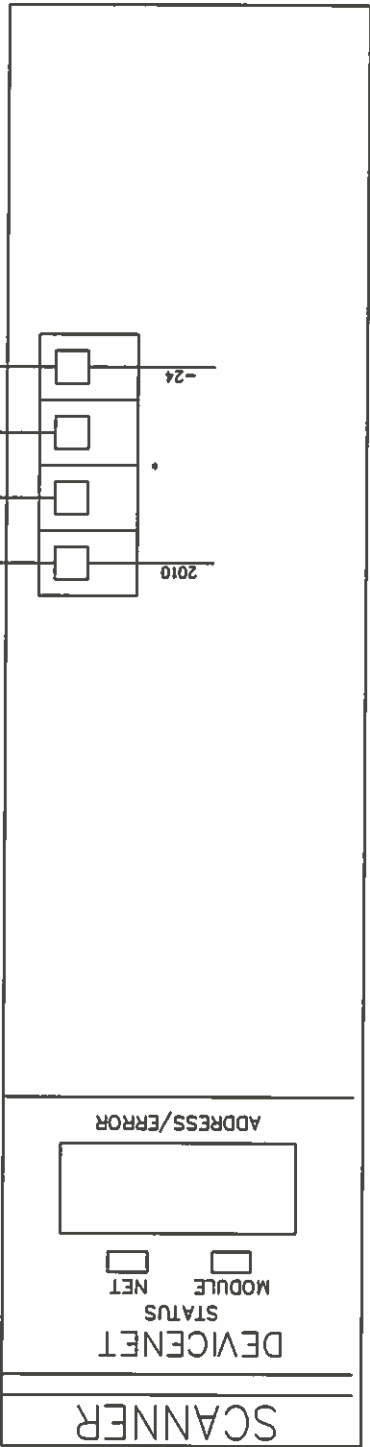
RELEASED
SEP 19 2002

0	NYO	29/09/90	3345 SHL OL 2077 5436 CM	1
EDWARDS	ALL	29/09	10000000	TM
5085				

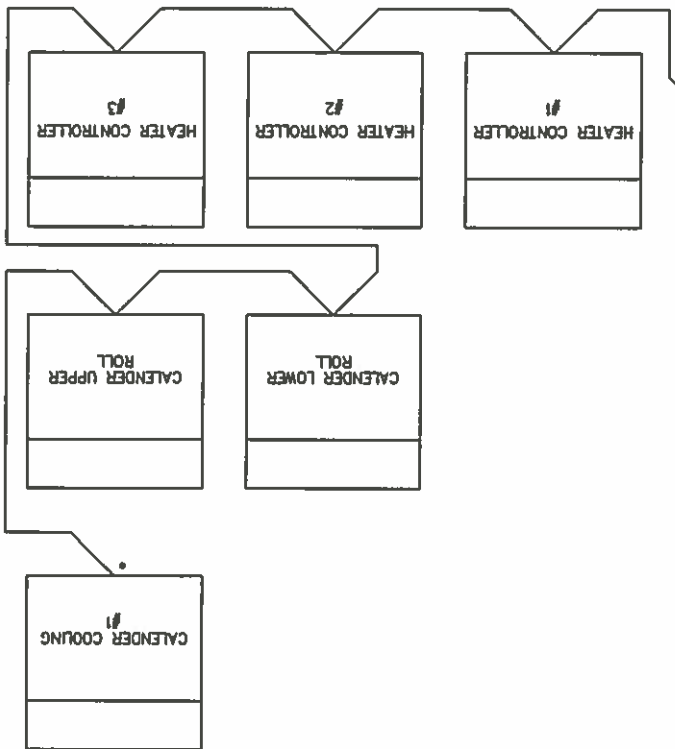
E0062-PLC-HARDWARE
PLC
SLOT 0



E0304-PLC-HARDWARE
DEVICENET MODULE
SLOT 1



RELEASED
SEP 19 2002



* = INSTALL A 121 OHM RESISTOR BETWEEN BLUE AND WHITE

27MM EXTRUDER TERMINAL LEGEND
ENCLOSURE
HEATER/MOTOR ENCLOSURE
PLC ENCLOSURE
OPERATOR INTERFACE
CALENDER J-BOX
CALENDER ENCLOSURE

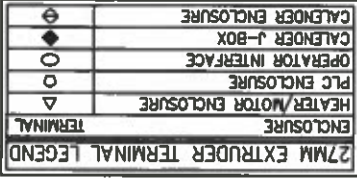
27MM E-MAX 15846
PLC ENCLOSURE
I/O CARD WIRING
27MM E-MAX 15846
CALENDER J-BOX
CALENDER ENCLOSURE

27MM E-MAX 15846
PLC ENCLOSURE
I/O CARD WIRING
27MM E-MAX 15846
CALENDER J-BOX
CALENDER ENCLOSURE

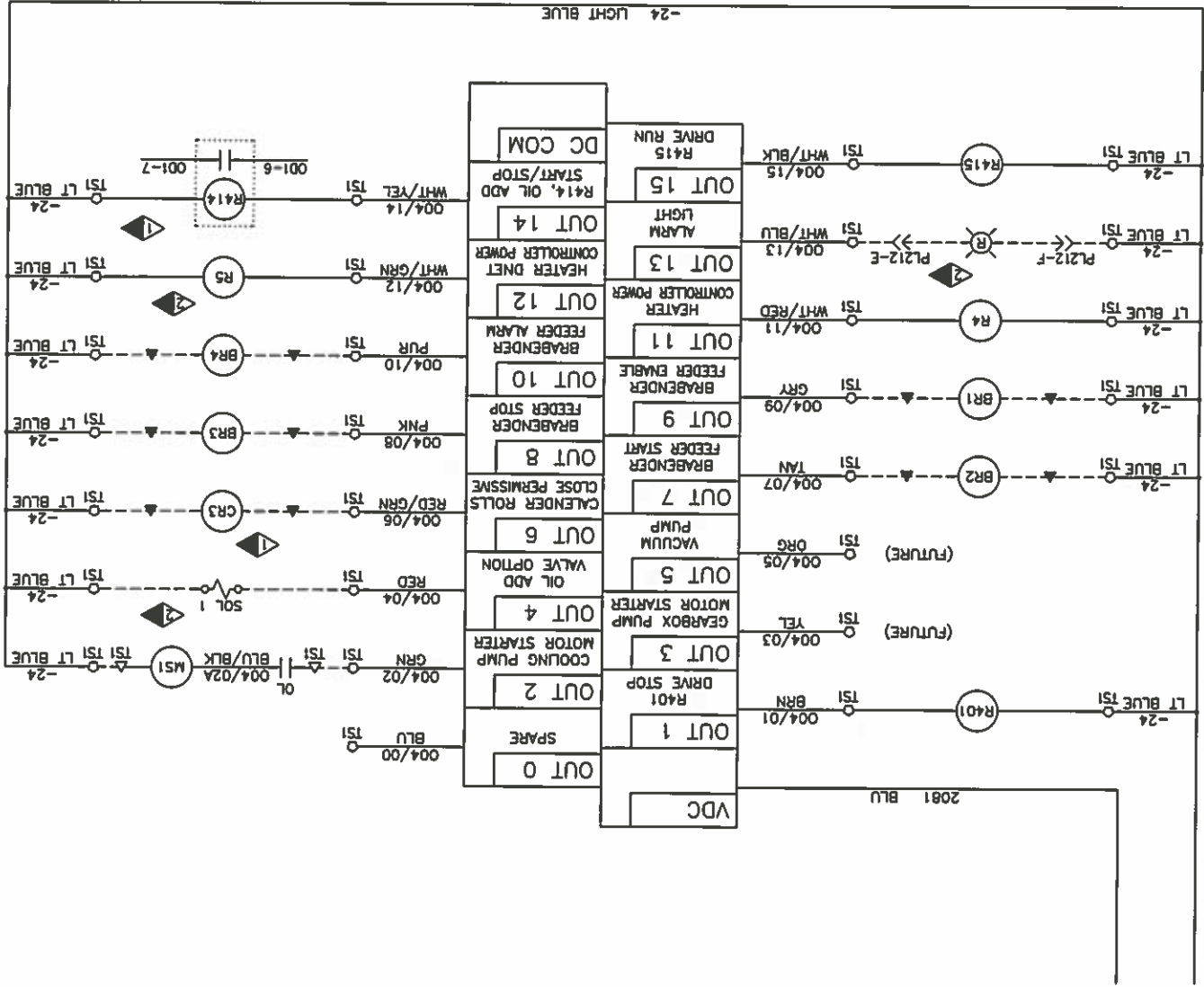
5807
1.000 CALIBER TO LENGTHENING STAMP
2.000 CALIBER TO LENGTHENING STAMP
3.000 CALIBER TO LENGTHENING STAMP
4.000 CALIBER TO LENGTHENING STAMP
5.000 CALIBER TO LENGTHENING STAMP
6.000 CALIBER TO LENGTHENING STAMP
7.000 CALIBER TO LENGTHENING STAMP
8.000 CALIBER TO LENGTHENING STAMP
9.000 CALIBER TO LENGTHENING STAMP
10.000 CALIBER TO LENGTHENING STAMP

	250 N. HANSAARD LEBANON, OH 97355 PHONE 259-3901
PIC ENCLOSURE I/O CARD WIRING 27MM E-MAX 15846	
5807 NONTE	D 3
15846	

RELEASED
SEP 19 2002



E0228-PLC-HARDWARE
OUTPUT MODULE
SLOT 4



E0166-PLC-HARDWARE
SPARE
SLOT 5

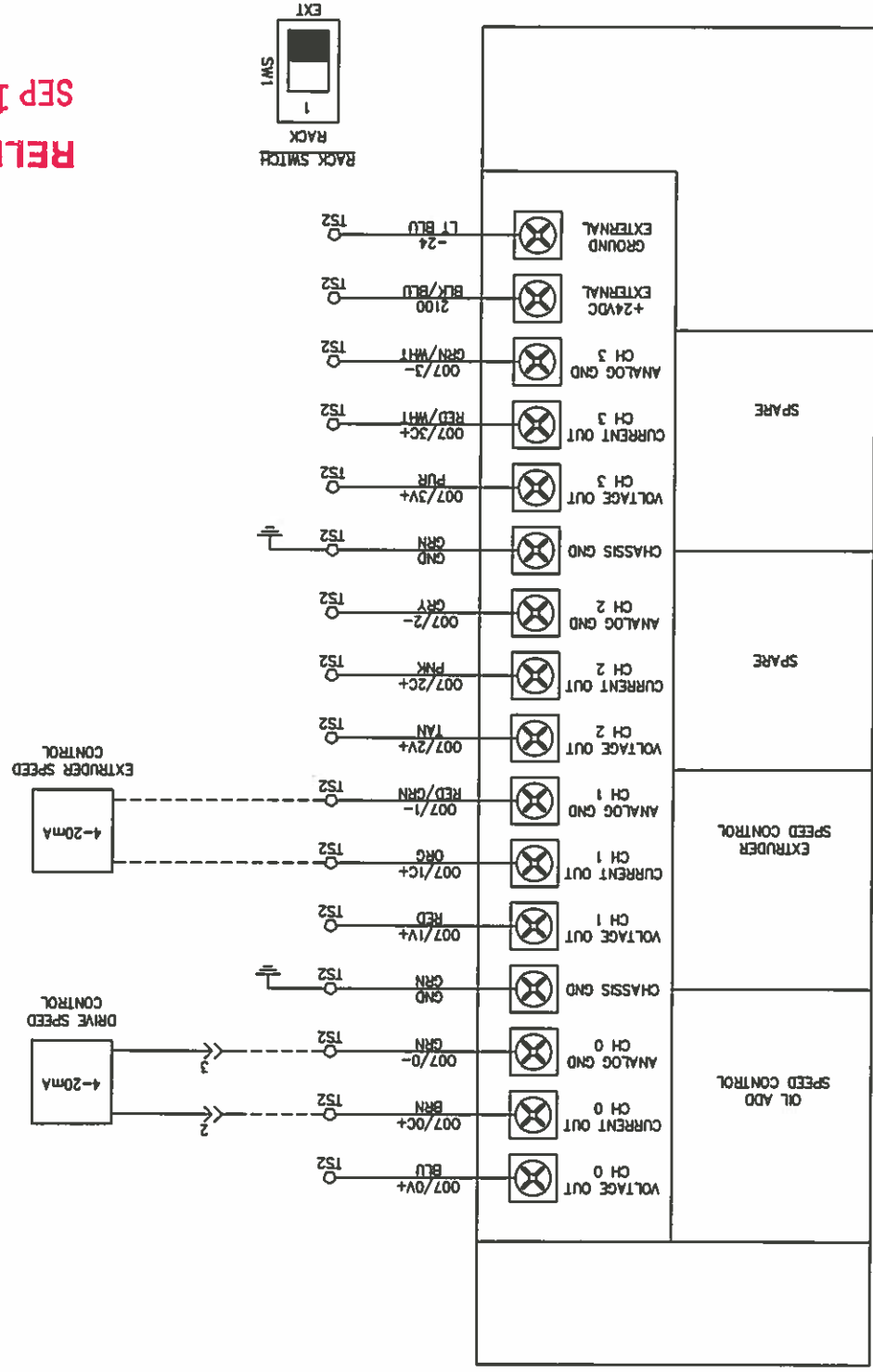
ENCLOSURE	27MM EXTRUDER TERMINAL LEGEND
ENCLOSURE	ENCLOSURE
HEATER/MOTOR ENCLOSURE	HEATER/MOTOR ENCLOSURE
PLC ENCLOSURE	PLC ENCLOSURE
OPERATOR INTERFACE	OPERATOR INTERFACE
CALENDER J-BOX	CALENDER J-BOX
CALENDER ENCLOSURE	CALENDER ENCLOSURE
BRAENDER ENCLOSURE	BRAENDER ENCLOSURE

DATE	03/07/02
TIME	03/07/02
BY	DO NOT SCALE
SCALE	DO NOT SCALE
SCALE	DO NOT SCALE
SCALE	DO NOT SCALE

DATE	03/07/02
TIME	03/07/02
BY	DO NOT SCALE
SCALE	DO NOT SCALE
SCALE	DO NOT SCALE
SCALE	DO NOT SCALE

RELEASED
SEP 19 2002

DATE	03/07/02
TIME	03/07/02
BY	DO NOT SCALE
SCALE	DO NOT SCALE
SCALE	DO NOT SCALE
SCALE	DO NOT SCALE

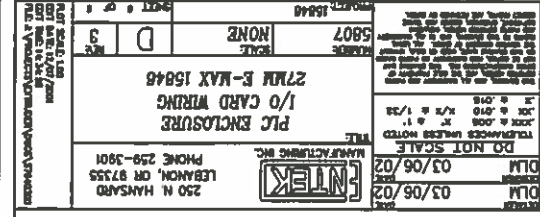
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RELEASED
SEP 19 2002

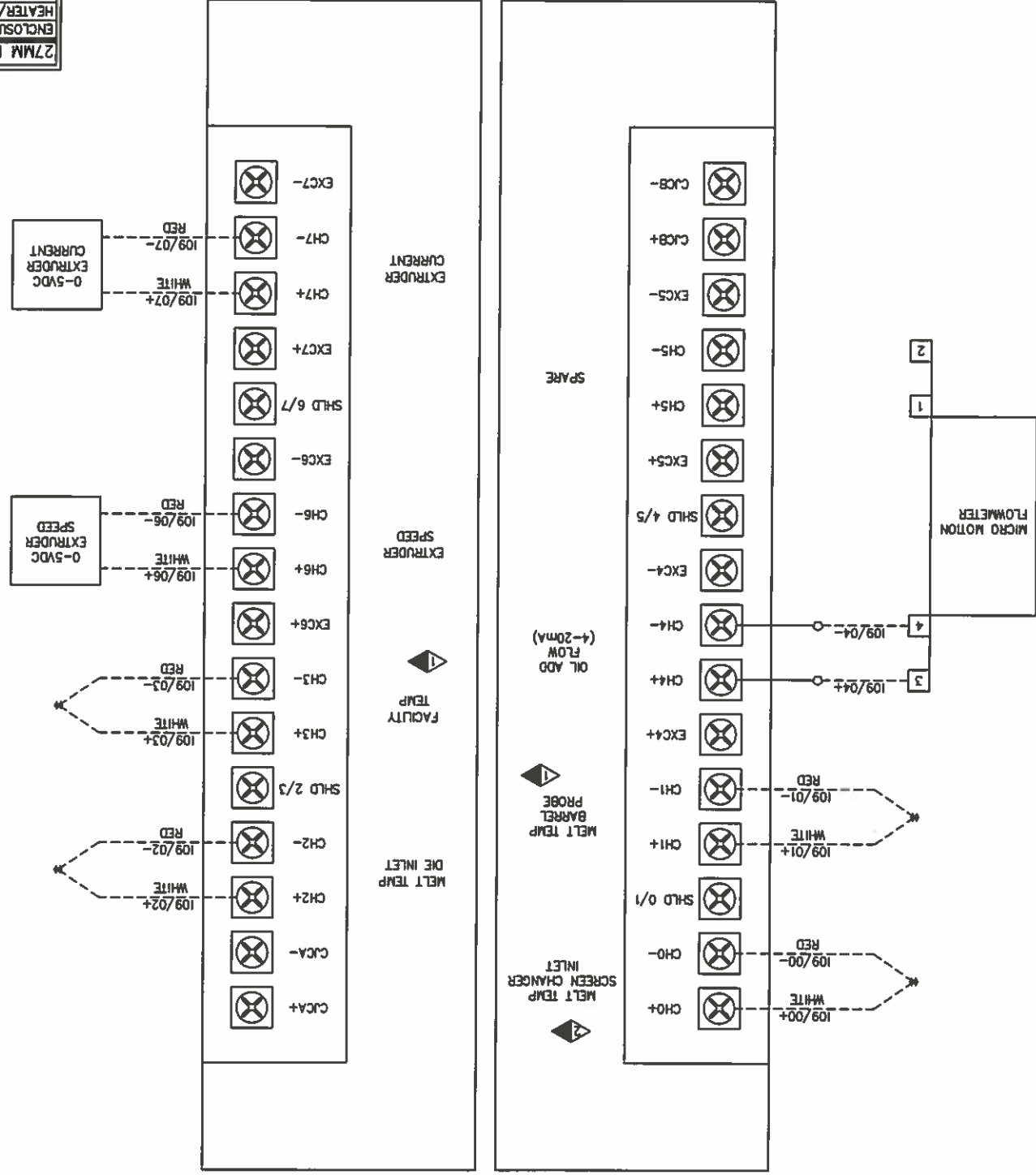
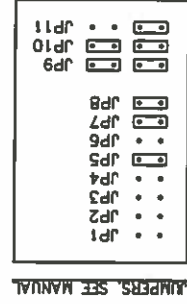
27MM EXTRUDER TERMINAL LEGEND	
ENCLOSURE	TERMINAL
HEATER/MOTOR ENCLOSURE	△
PLC ENCLOSURE	○
OPERATOR INTERFACE	○
CALENDER J-BOX	◆
CALENDER ENCLOSURE	◇

03/07/02
 03/07/02
 DO NOT SCALE
 TOLUANCES UNLESS NOTED
 JOCK # 008
 K # 1
 K # 018
 K # 019
 03/07/02

DATE	5807	SCALE	NONE	D	INCH	2

[illegible]

E0148-PLC-HARDWARE
ANALOG INPUT
SLOT 9



ENCLOSURE	27MM EXTRUDER TERMINAL LEGEND
HEATER/MOTOR ENCLOSURE	TERMINAL
PLC ENCLOSURE	TERMINAL
OPERATOR INTERFACE	TERMINAL
CALENDER J-BOX	TERMINAL
CALENDER ENCLOSURE	TERMINAL

DATE: 03/07/02
TIME: 03/07/02
BY: JLM
REVISION: 1.0
DESCRIPTION: 27MM EXTRUDER TERMINAL LEGEND

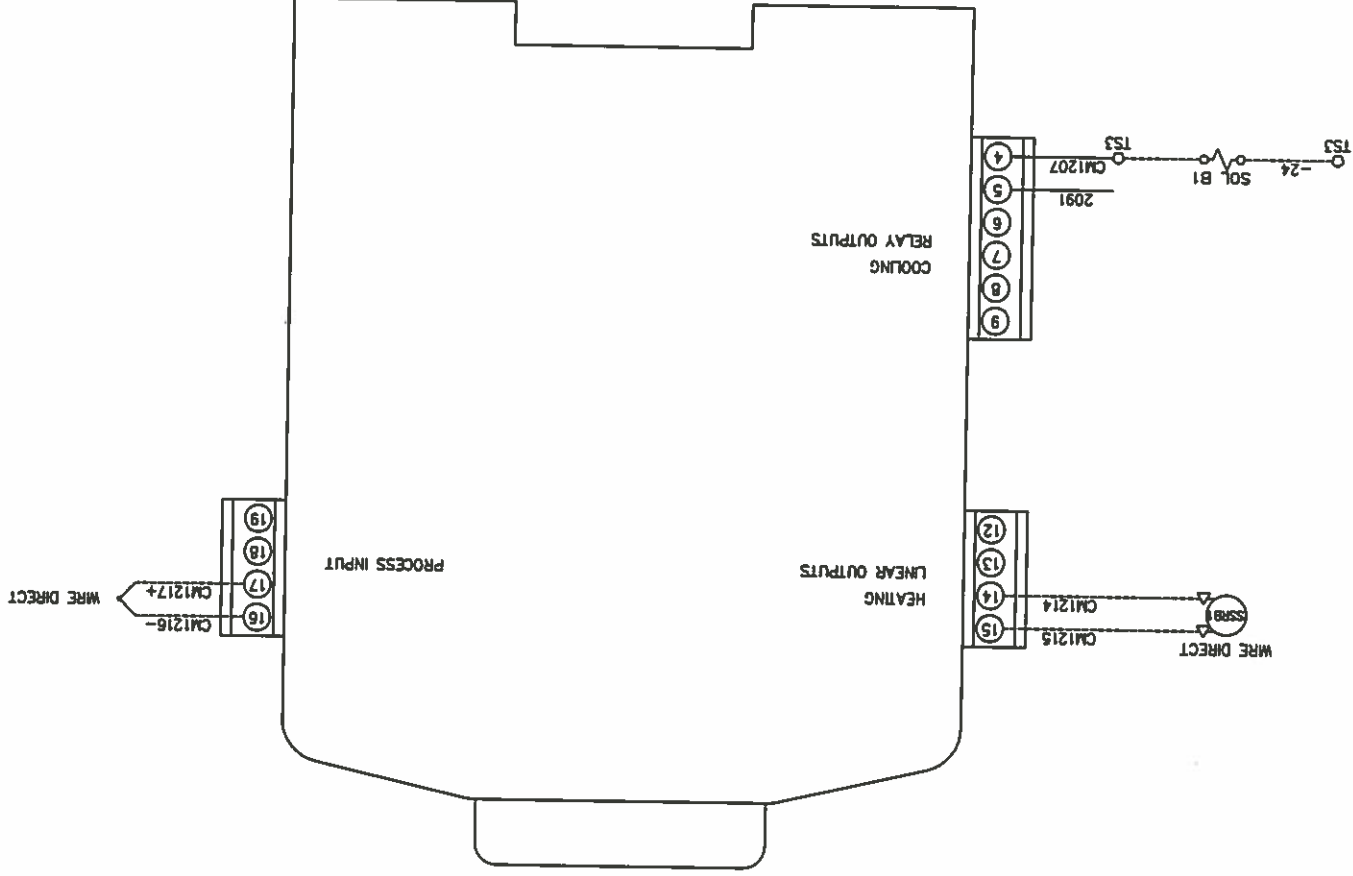
DATE: 03/07/02
TIME: 03/07/02
BY: JLM
REVISION: 1.0
DESCRIPTION: 27MM EXTRUDER TERMINAL LEGEND

DATE: 03/07/02
TIME: 03/07/02
BY: JLM
REVISION: 1.0
DESCRIPTION: 27MM EXTRUDER TERMINAL LEGEND

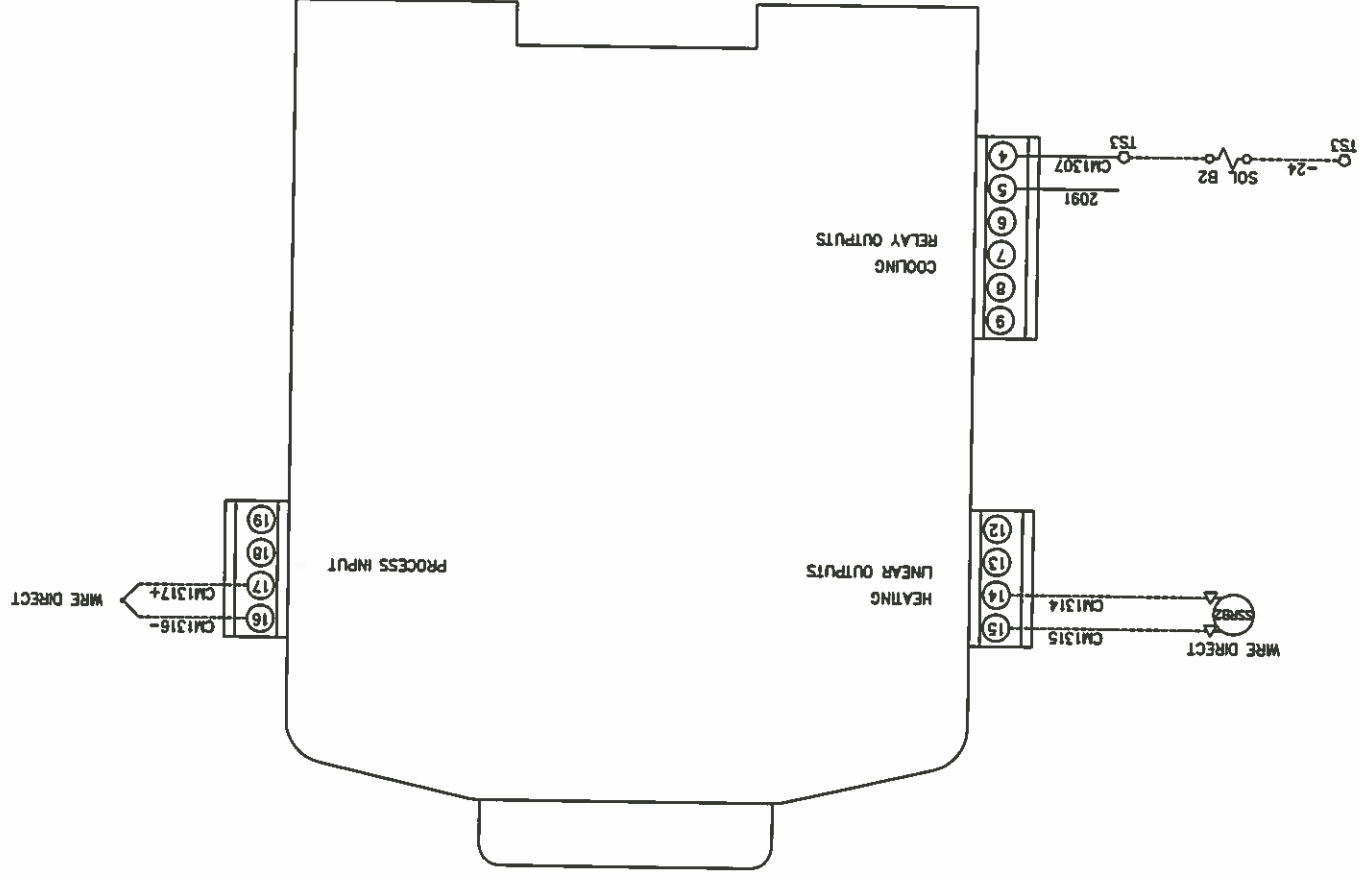
RELEASED
SEP 19 2002

5807	DATE	TIME	BY	REVISION
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5807	03/07/02	03/07/02	JLM	1.0
5807	03/07/02	03/07/02	JLM	1.0
5807	03/07/02	03/07/02	JLM	1.0

TEMPERATURE CONTROL MODULE
RACK 1, MODULE 2
BARREL ZONE #1



TEMPERATURE CONTROL MODULE
RACK 1, MODULE 3
BARREL ZONE #2



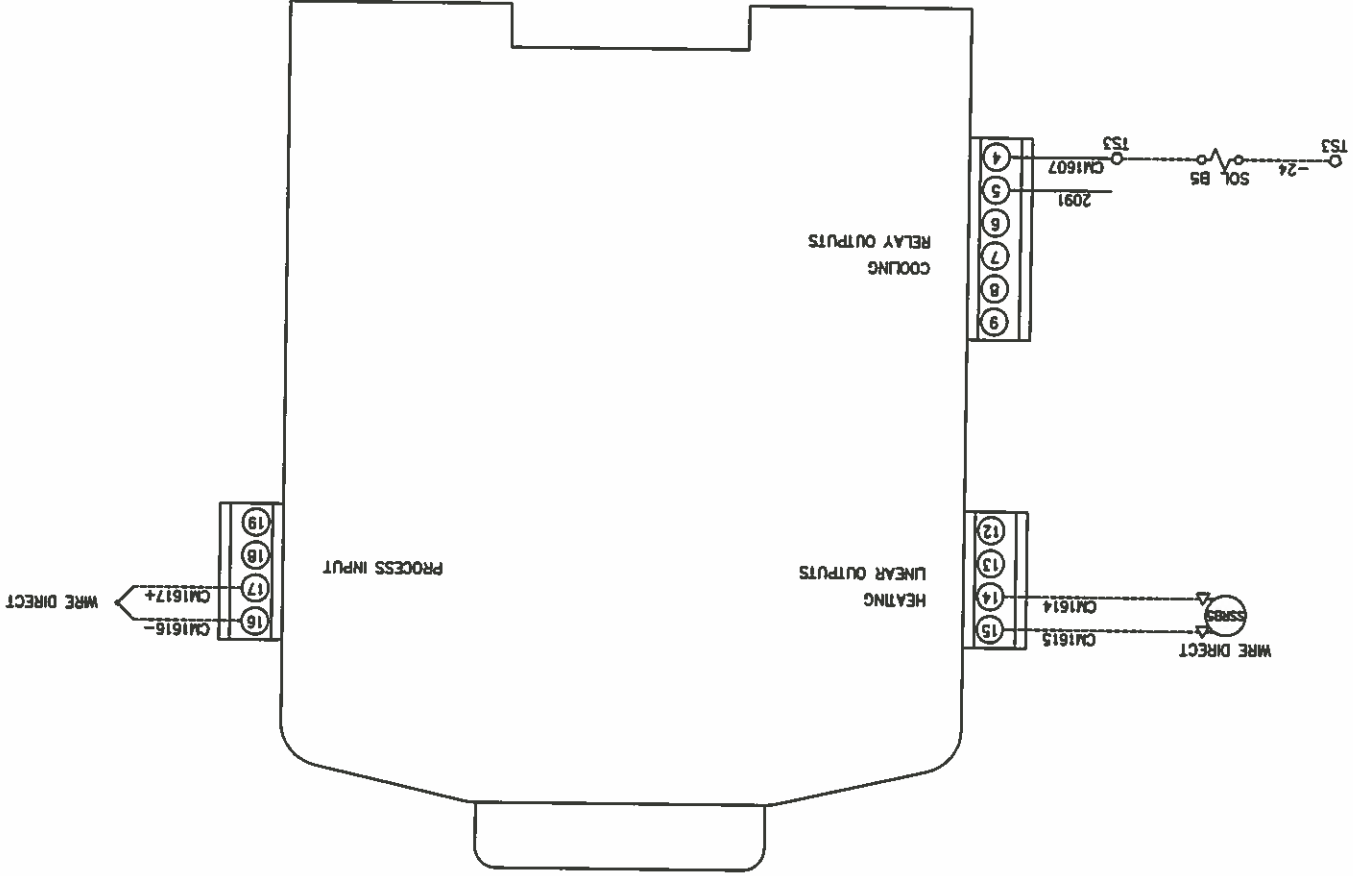
RELEASED
JUL 15 2002

27MM EXTRUDER TERMINAL LEGEND	TERMINAL
ENCLOSURE	Δ
HEATER/MOTOR ENCLOSURE	Δ
PLC ENCLOSURE	Δ
OPERATOR INTERFACE	○

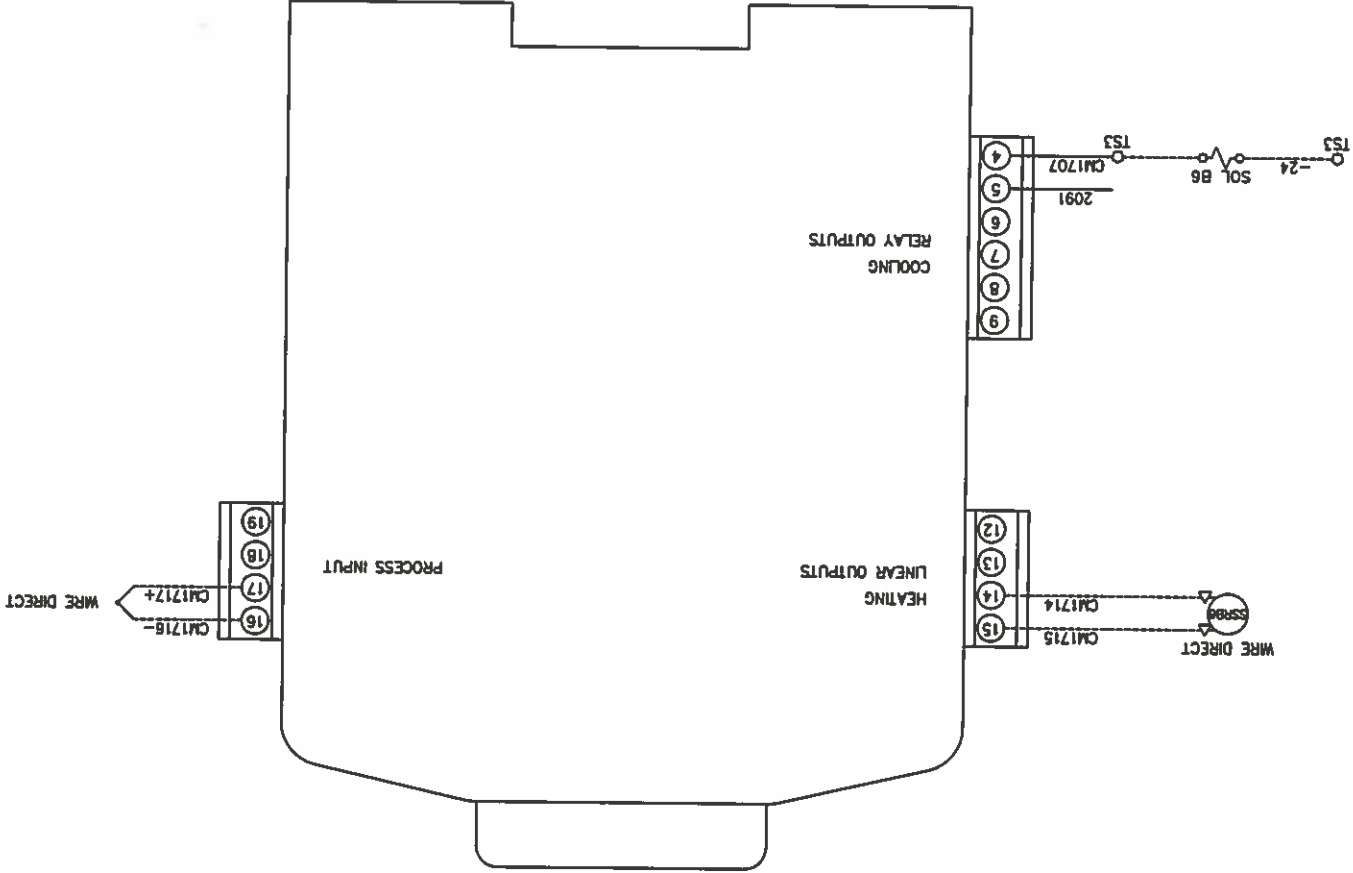
PLC ENCLOSURE MIC 8000 WIRING 27MM E-MAX 15846	
DLM 02/14/02 DLM 02/14/02 DO NOT SCALE TOLERANCES UNLESS NOTED 1/8" = 0.005" 1/16" = 0.001" 1/32" = 0.0005"	5808 NONE 2 D 2
250 N. HANSAARD LEBANON, OH 47035 PHONE 259-3901	

5808	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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TEMPERATURE CONTROL MODULE
RACK 1, MODULE 6
BARREL ZONE #5



TEMPERATURE CONTROL MODULE
RACK 1, MODULE 7
BARREL ZONE #6



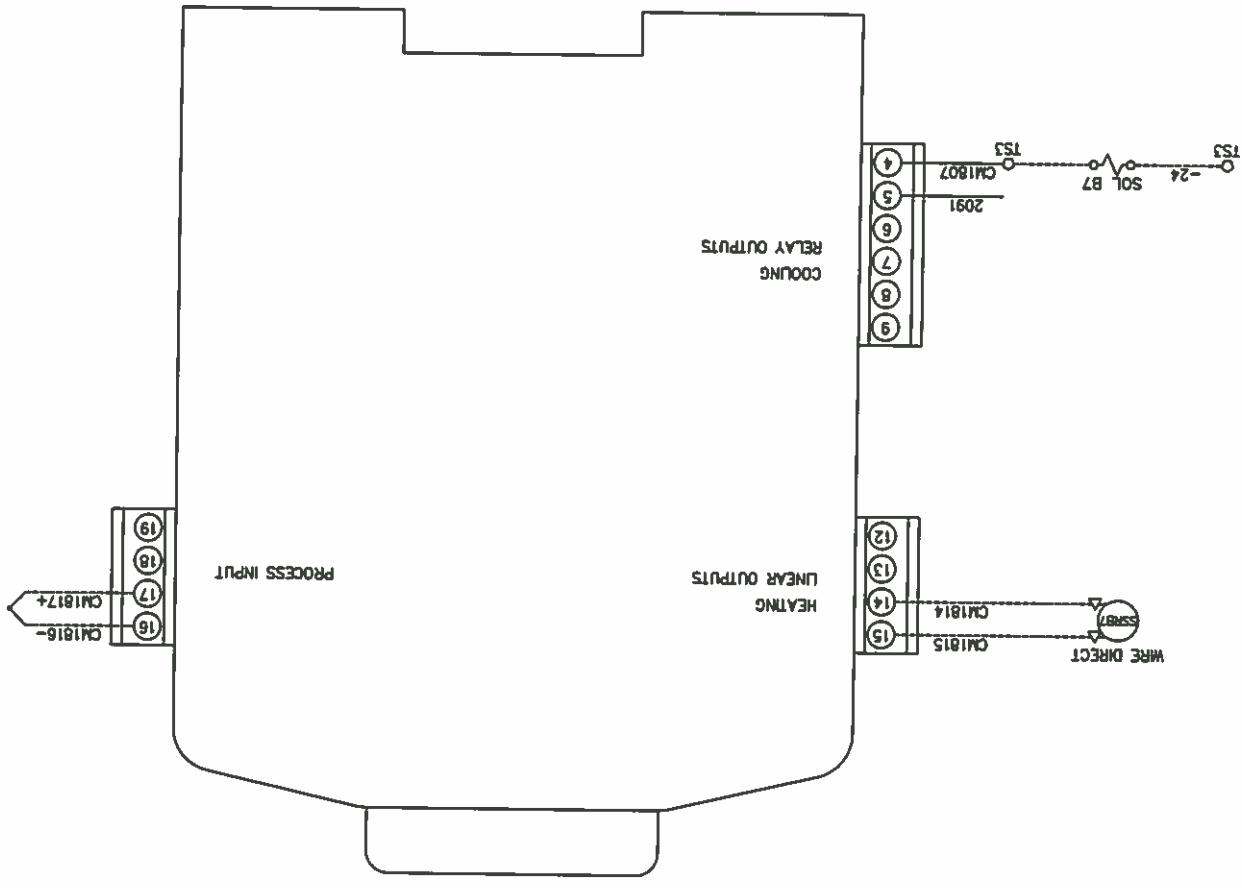
RELEASED
JUL 15 2002

27MM EXTRUDER TERMINAL LEGEND	ENCLOSURE	HEATER/MOTOR ENCLOSURE	PLC ENCLOSURE	OPERATOR INTERFACE
○	○	○	○	○
△	△	△	△	△

27MM E-MAX 15846		PLC ENCLOSURE		27MM E-MAX 15846	
WIRE 8000 WIRING		WIRE 8000 WIRING		WIRE 8000 WIRING	
250 N. HANSAARD		LEBANON, OH 43036		PHONE 256-2801	
DO NOT SCALE		02/14/02		02/14/02	
DATE		02/14/02		02/14/02	
DRAWN		02/14/02		02/14/02	
CHECKED		02/14/02		02/14/02	
APPROVED		02/14/02		02/14/02	
SCALE		02/14/02		02/14/02	
SHEET		02/14/02		02/14/02	
OF		02/14/02		02/14/02	
2		02/14/02		02/14/02	

5808	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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TEMPERATURE CONTROL MODULE
RACK 1, MODULE 8
BARREL ZONE #7



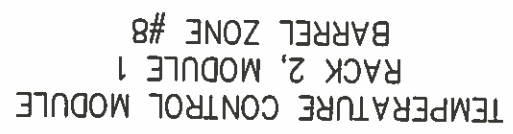
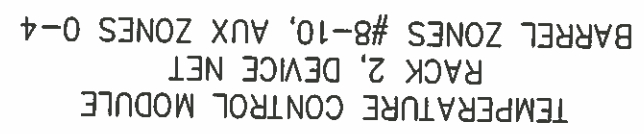
RELEASED
JUL 15 2002

PROJECT 15046	
DATE	02/14/02
BY	DLM
DO NOT SCALE	
250 N. HANSAARD LEBANON, OR 97339 PHONE 258-2801	
PLC ENCLOSURE MTC 8000 WIRING 27MM E-MAX 15046	
SCALE	NONE
REV	2
REV	D

5808

27MM EXTRUDER TERMINAL LEGEND	
ENCLOSURE	△
HEATER/MOTOR ENCLOSURE	△
PLC ENCLOSURE	○
OPERATOR INTERFACE	○

5808	DATE	02/14/02	BY	DLM
1	DATE	02/14/02	BY	DLM
2	DATE	02/14/02	BY	DLM



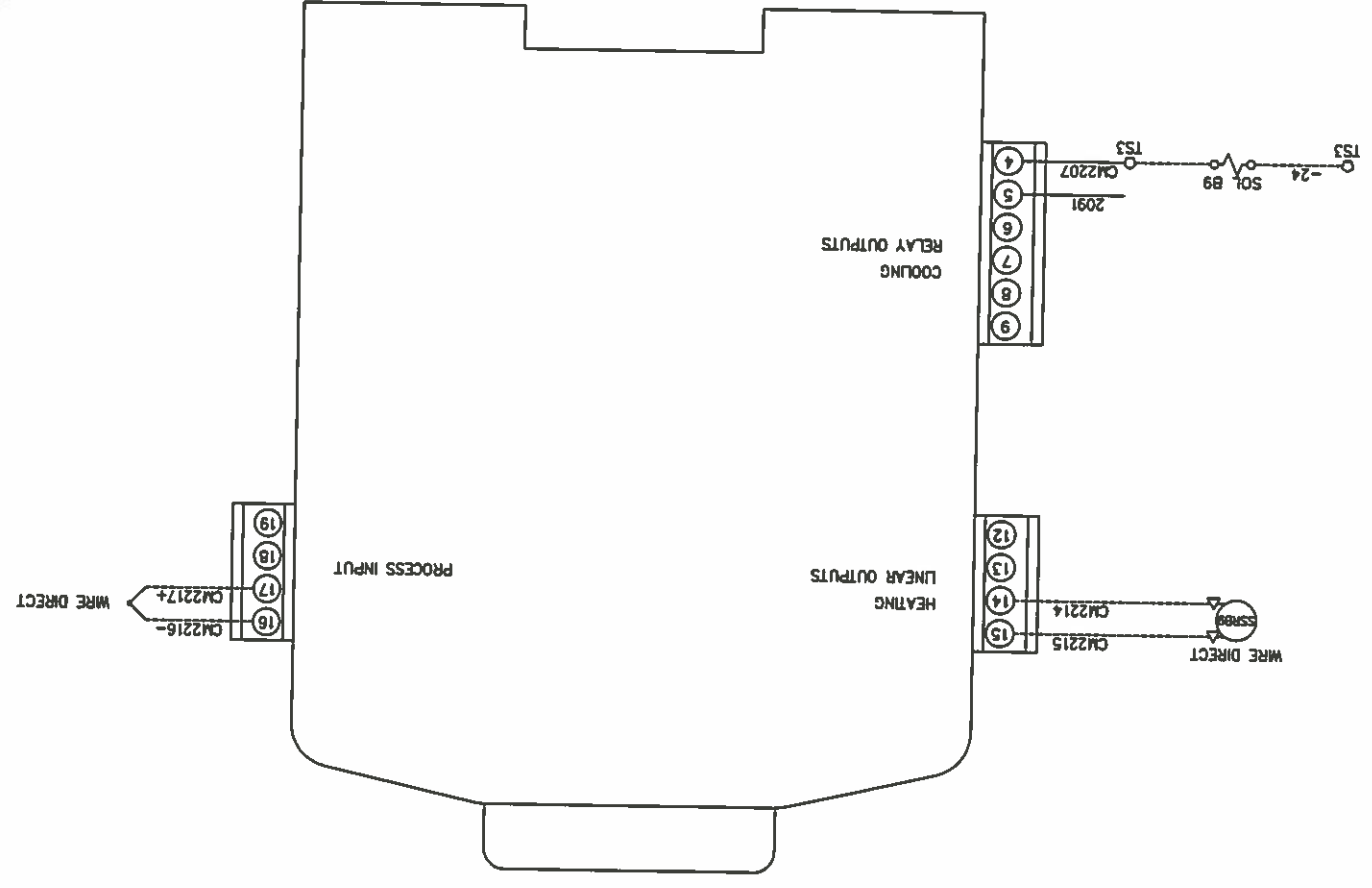
RELEASED
JUL 15 2002

 250 N. HANSAARD LEAHORN, OR 97335 PHONE 259-3901	PLC ENCLOSURE MTC 9000 WTRNG 2710A E-MAX 15848 DATE 15848	6908 NONE 15848	DATE 02/14/02 TIME 02/14/02
250 N. HANSAARD LEAHORN, OR 97335 PHONE 259-3901 PLC ENCLOSURE MTC 9000 WTRNG 2710A E-MAX 15848	DATE 15848 TIME 02/14/02	6908 NONE 15848	DATE 02/14/02 TIME 02/14/02

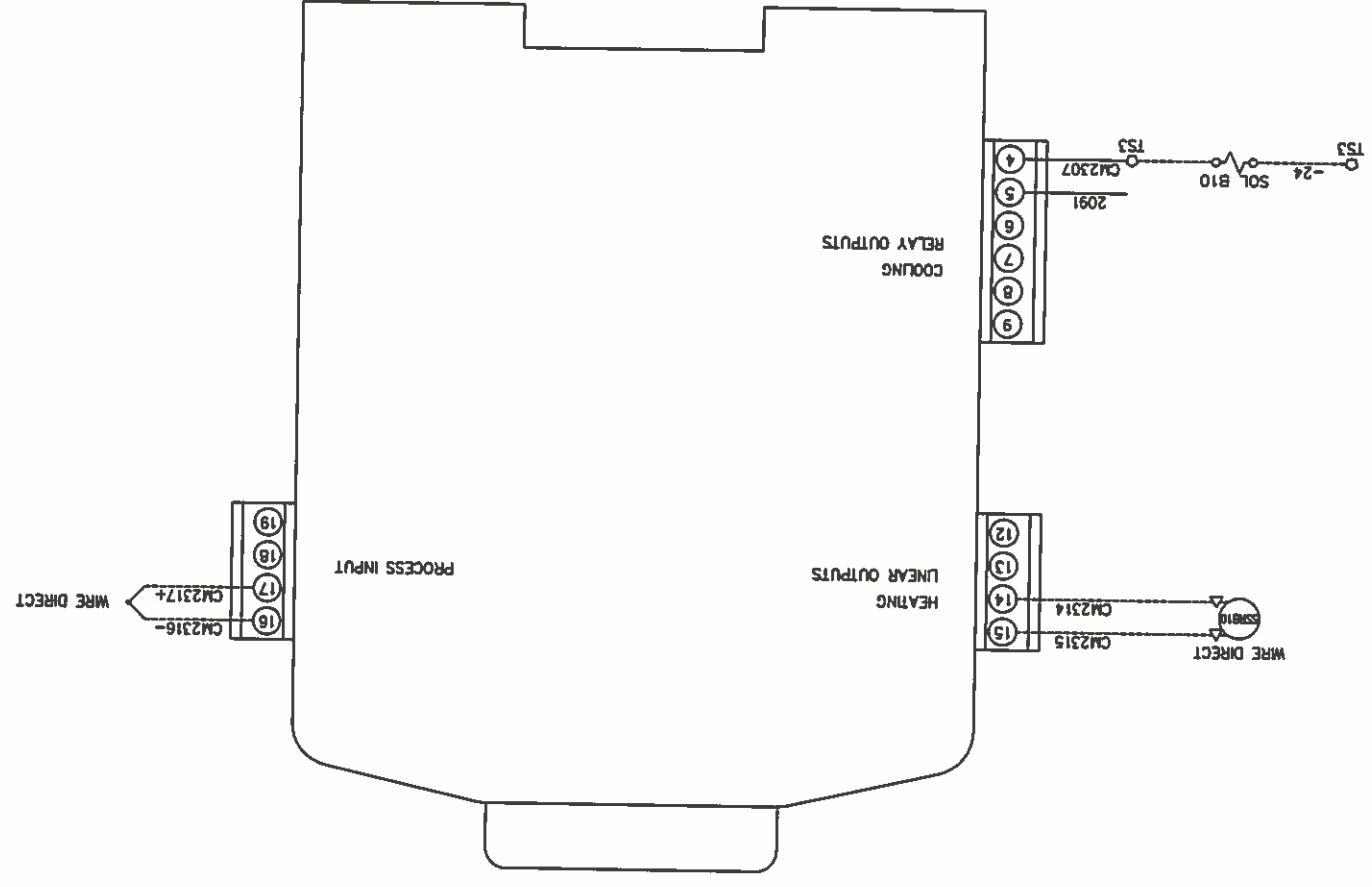
27MM EXTRUDER TERMINAL LEGEND	ENCLOSURE	TERMINAL
	HEATER/MOTOR ENCLOSURE	△
	PLC ENCLOSURE	○
	OPERATOR INTERFACE	○

[illegible]

TEMPERATURE CONTROL MODULE
RACK 2, MODULE 2
BARREL ZONE #9



TEMPERATURE CONTROL MODULE
RACK 2, MODULE 3
BARREL ZONE #10



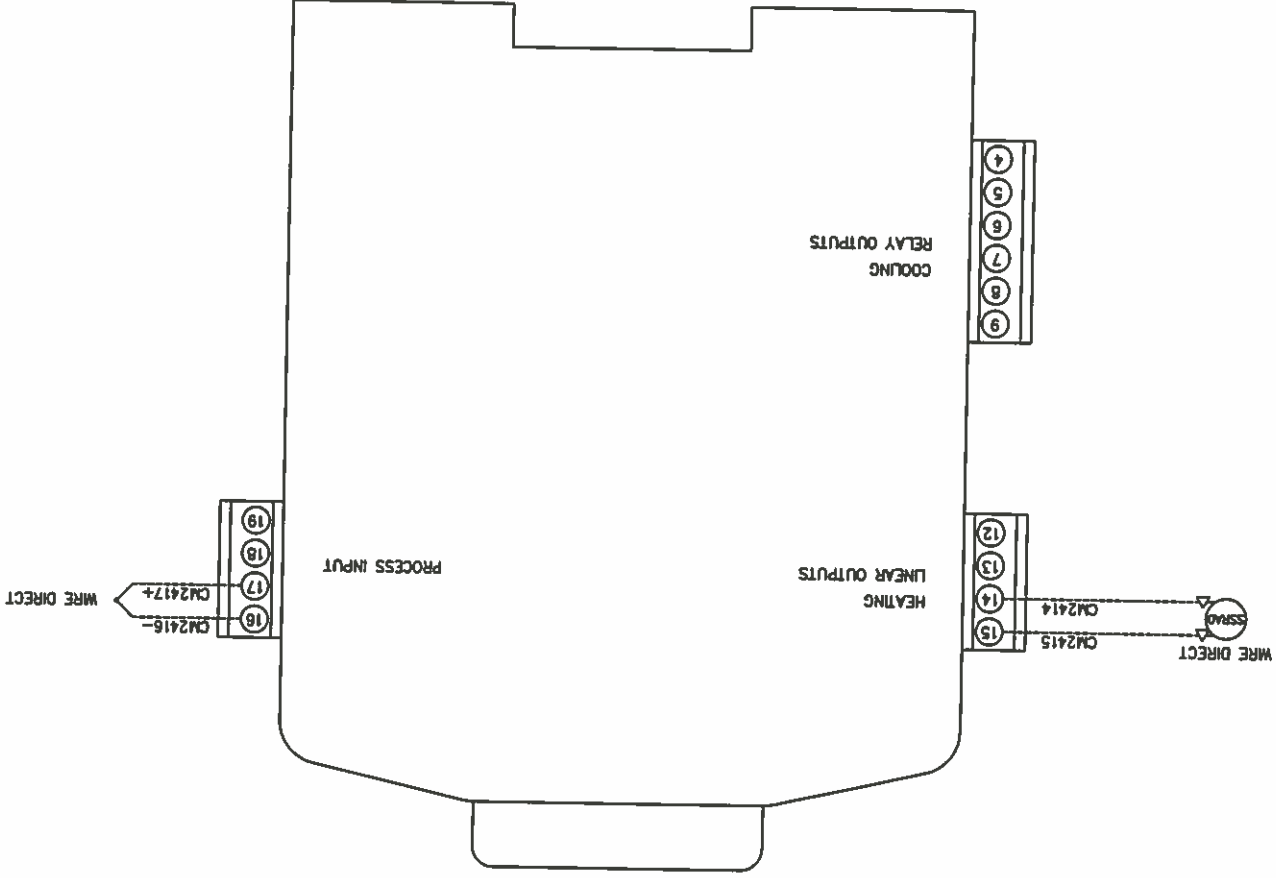
RELEASED
JUL 15 2002

27MM EXTRUDER TERMINAL LEGEND	
ENCLOSURE	△
HEATER/MOTOR ENCLOSURE	○
PLC ENCLOSURE	○
OPERATOR INTERFACE	○

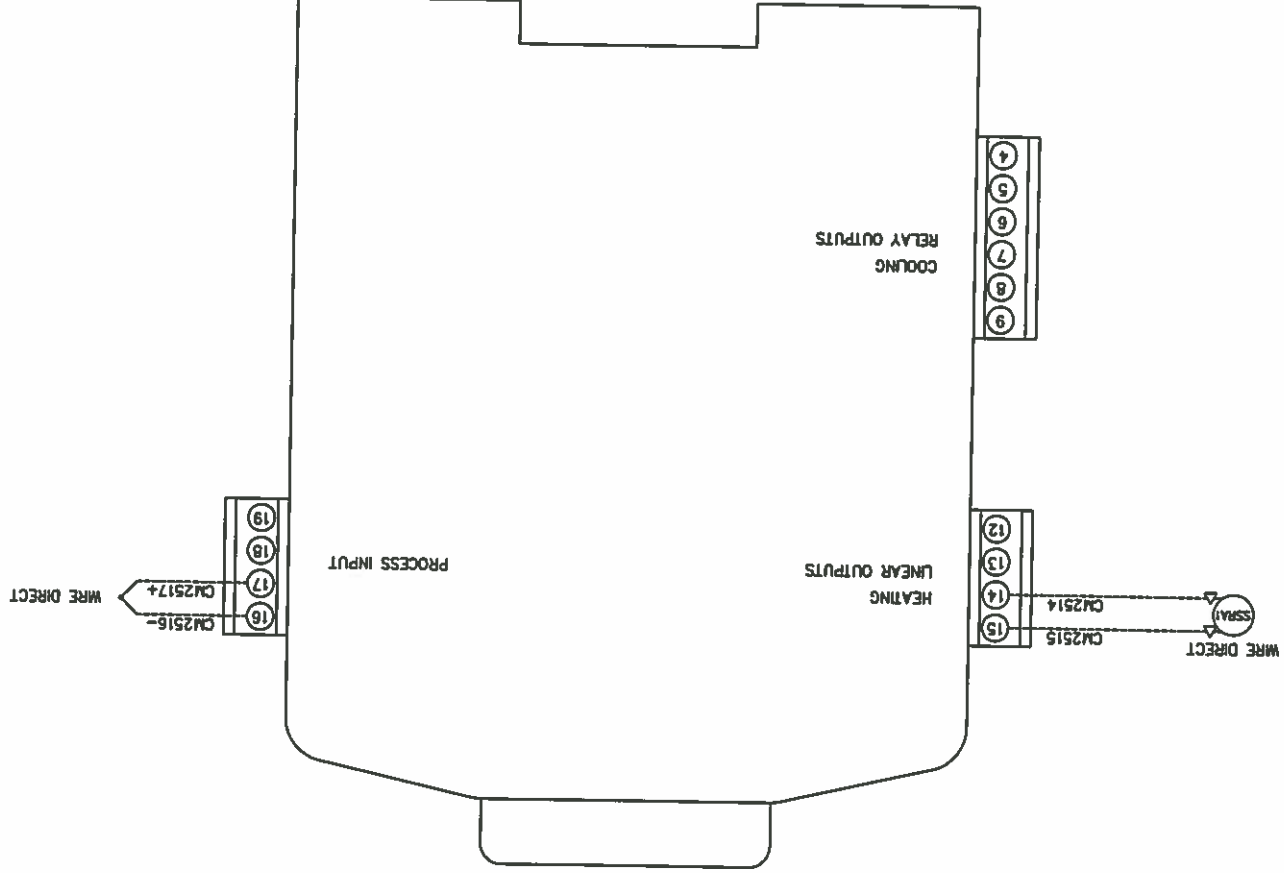
DATE	02/14/02
BY	02/14/02
DO NOT SCALE	
TOLERANCES UNLESS NOTED	
1" = 6" 0.008	1/8" = 1/2"
1/16" = 1/8"	1/32" = 1/16"
ALL DIMENSIONS ARE TO CENTER UNLESS NOTED	
5808	
NONE	
27MM E-MAX 15846	
PLC ENCLOSURE	
MIC 8000 WIRING	
250 N. HANSAARD	
LEBANON, OH 47355	
PHONE 229-3901	

5808	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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TEMPERATURE CONTROL MODULE
RACK 2, MODULE 4
AUX ZONE #0



TEMPERATURE CONTROL MODULE
RACK 2, MODULE 5
AUX ZONE #1



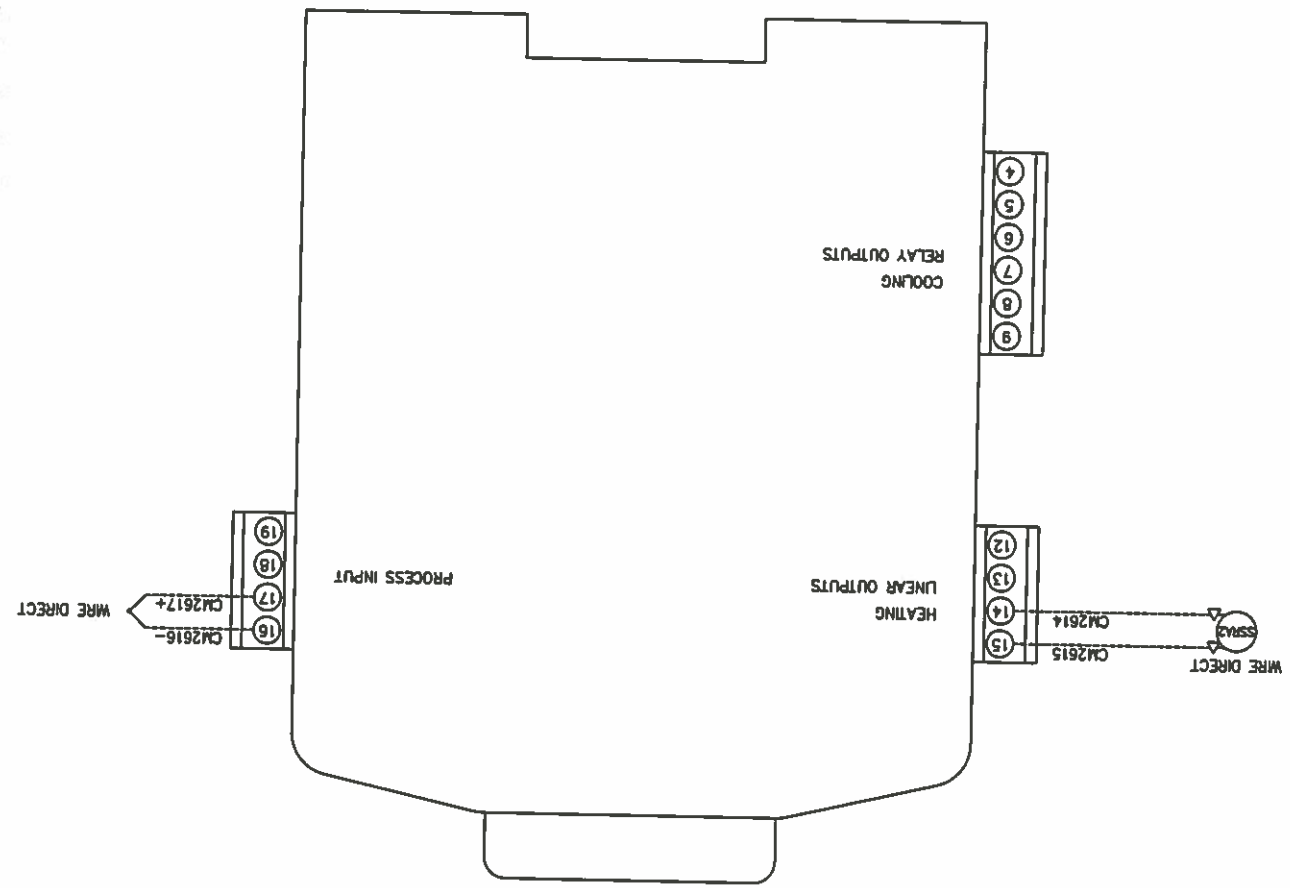
RELEASED
JUL 15 2002

27MM EXTRUDER TERMINAL LEGEND	
TERMINAL	
HEATER/MOTOR ENCLOSURE	Δ
PLC ENCLOSURE	○
OPERATOR INTERFACE	○

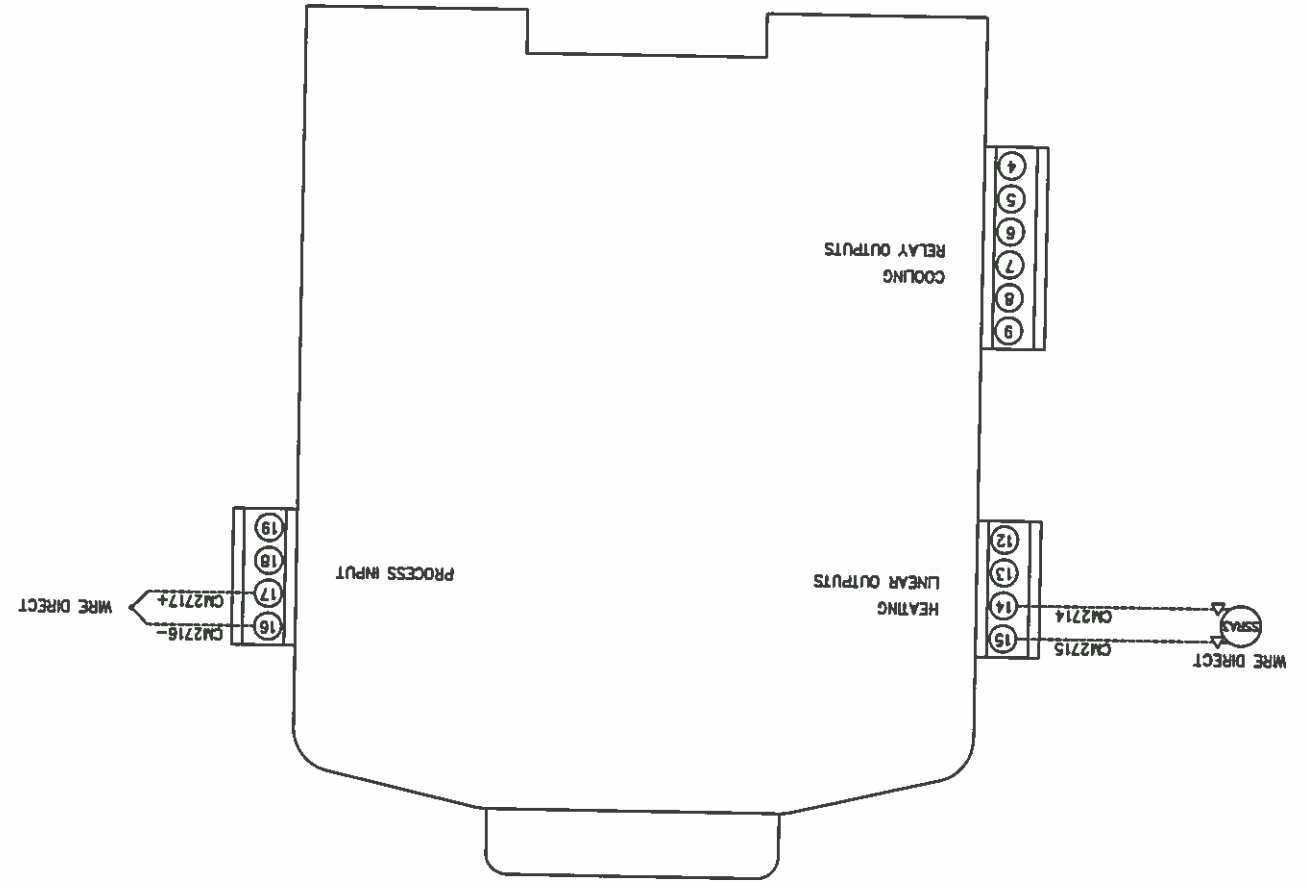
INTER 250 N. HANSAARD LEBANON, OH 47036 PHONE 229-3901		DO NOT SCALE DATE 02/14/02 DLM
27MM E-MAX 15846 PLC ENCLOSURE MLC 8000 WIRING		5808 NONE D 2

5808	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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TEMPERATURE CONTROL MODULE
RACK 2, MODULE 6
AUX ZONE #2



TEMPERATURE CONTROL MODULE
RACK 2, MODULE 7
AUX ZONE #3



RELEASED
JUL 15 2002

27MM EXTRUDER TERMINAL LEGEND

TERMINAL	ENCLOSURE	HEATER/MOTOR ENCLOSURE	PLC ENCLOSURE	OPERATOR INTERFACE
○	○	△	○	○

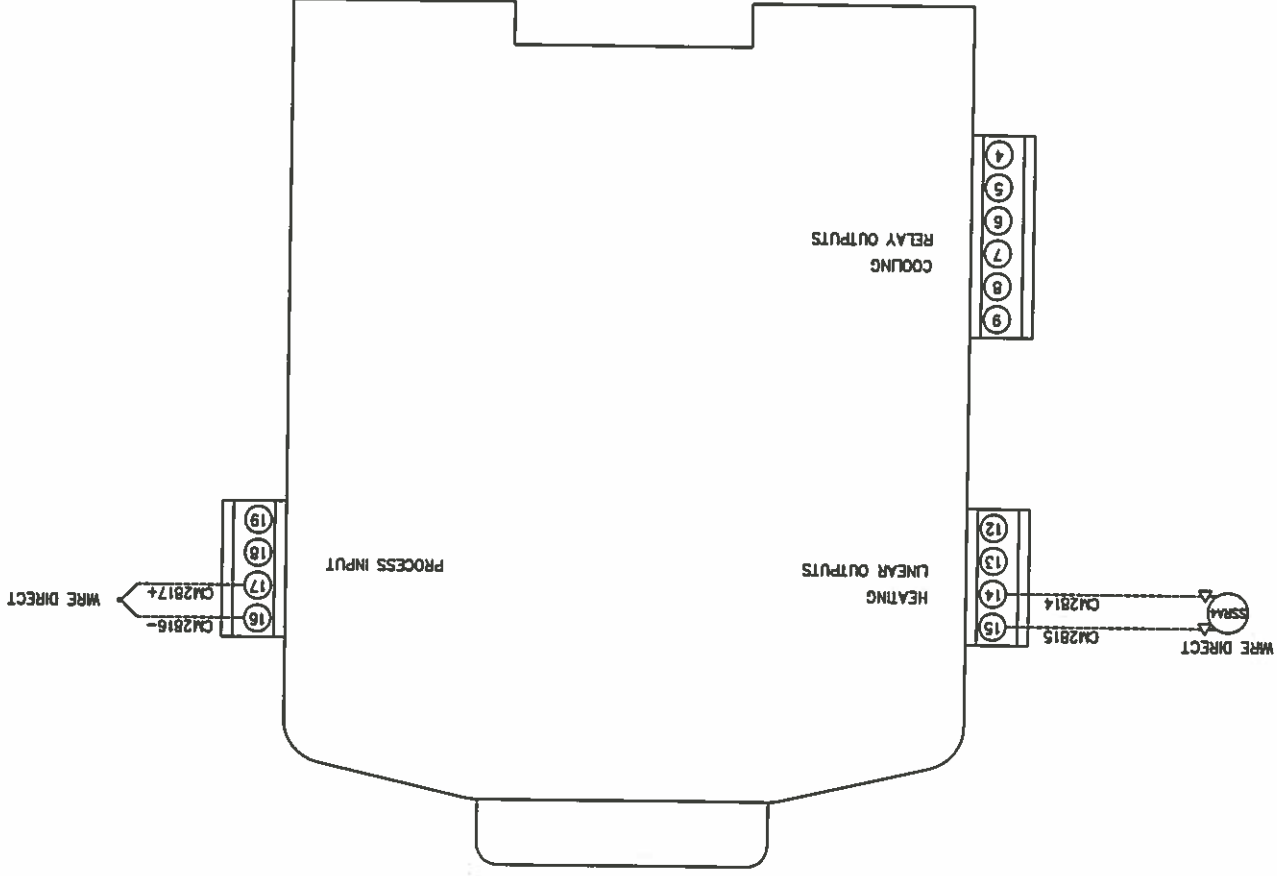
27MM E-MAX 15846
PLC 8000 WIRING
250 N. HANSAARD
LEBANON, OR 97355
PHONE 258-3901

DO NOT SCALE
02/14/02
DLM

DATE 12/02/00
SCALE 1:100
PROJECT 15846

5808	DATE	BY	REV	DESCRIPTION
1	12/15/00	WJS	1	INITIAL WIRE TO THIS SHEET
2	07/15/02	WJS	2	WIRE RELEASED TO THIS SHEET

TEMPERATURE CONTROL MODULE
RACK 2, MODULE 8
AUX ZONE #4



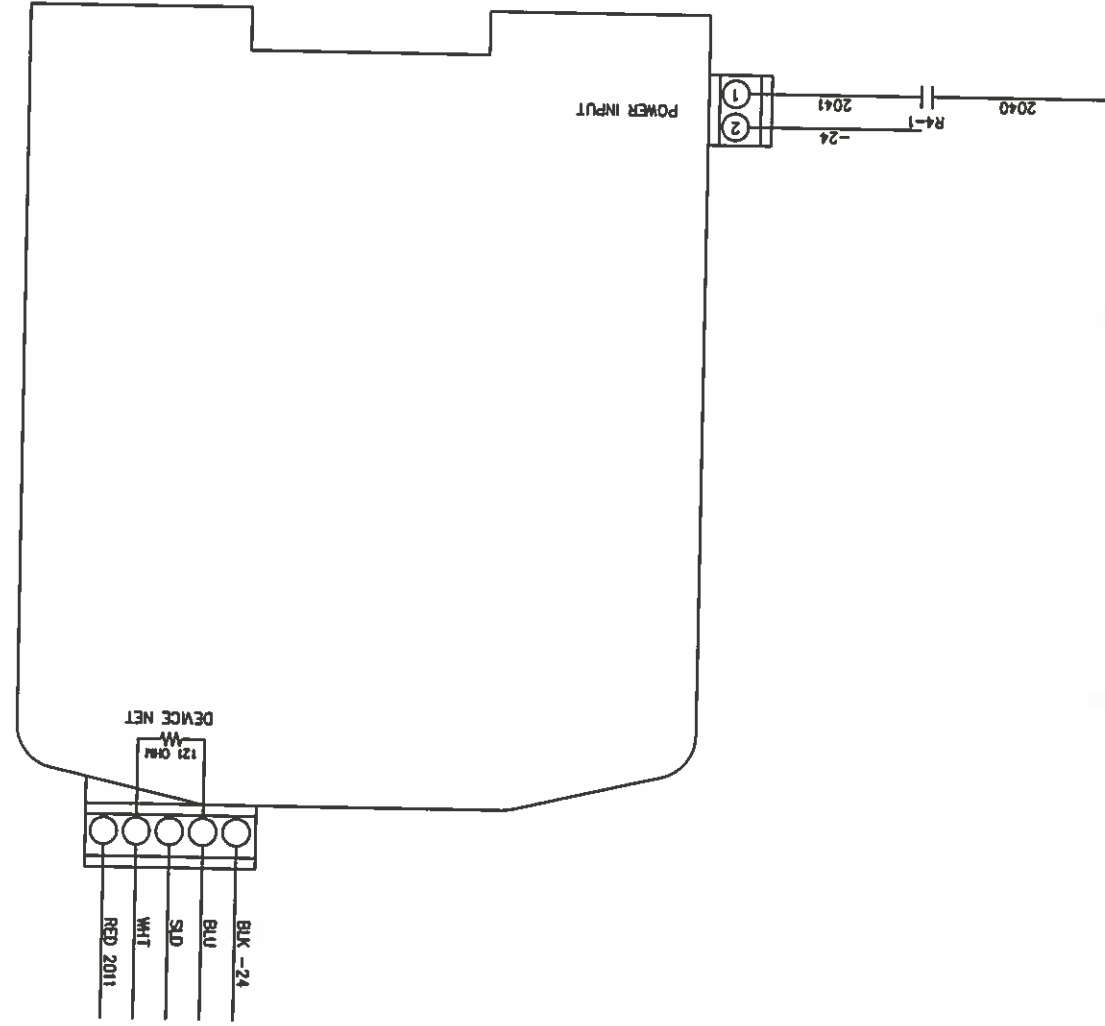
RELEASED
JUL 15 2002

[illegible]

27MM EXTRUDER TERMINAL LEGEND	ENCLOSURE	HEATER/MOTOR ENCLOSURE	PLC ENCLOSURE	OPERATOR INTERFACE
	△	○	○	○

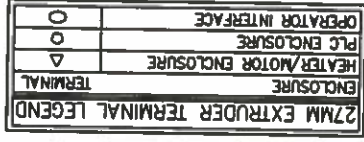
0	NO	00/00/00	1985 S&B 00 0000 0000 00	2
0	NO	00/00/00	1985 S&B 00 0000 0000 00	1
00000000	00	0000	00000000	0000

0808



The diagram shows the rear panel of the 3150 controller with the following connections:

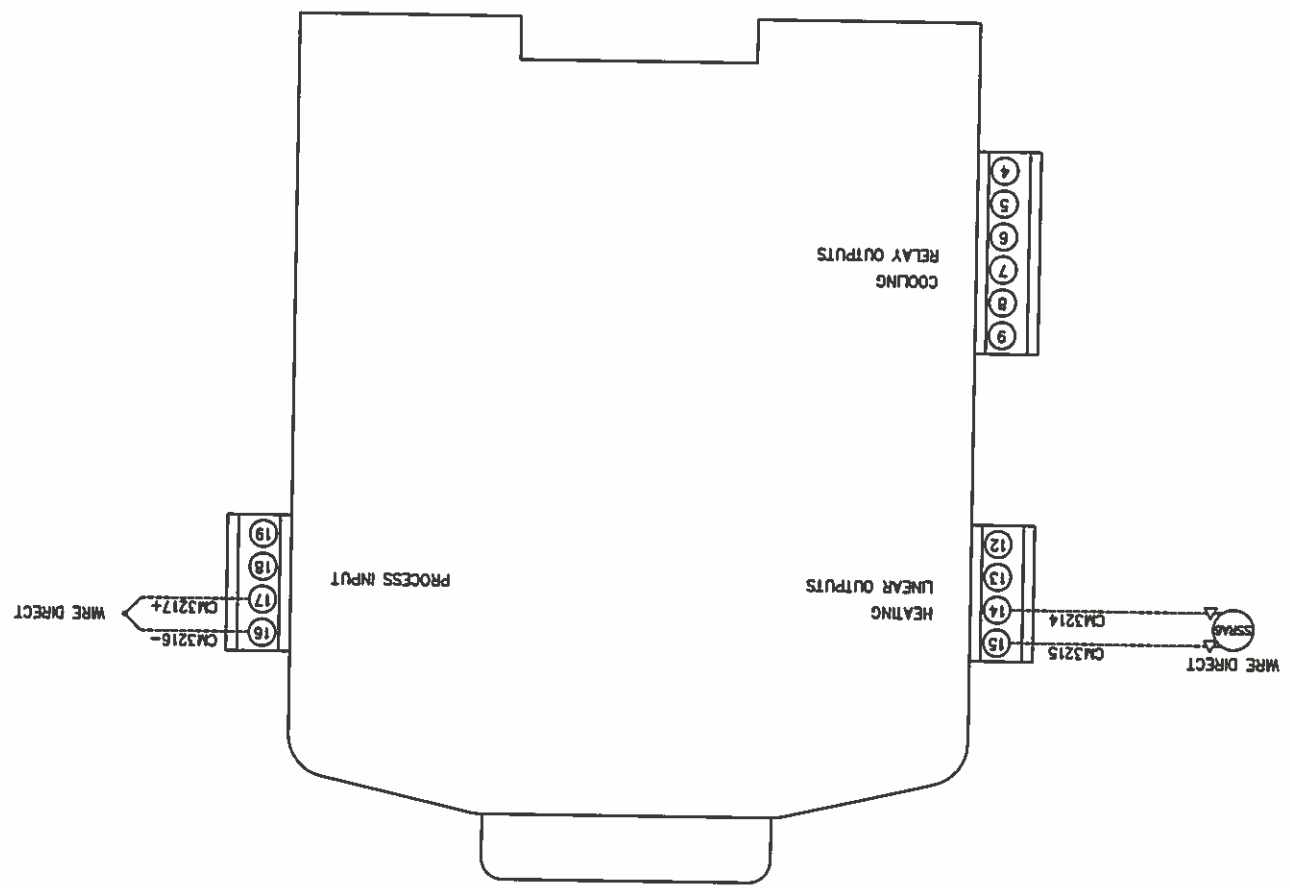
- PROCESS INPUT:** A single terminal on the left side.
- HEATING OUTPUTS:** A block of four terminals labeled 12, 13, 14, and 15.
 - Terminal 14 is connected to CM3114.
 - Terminal 15 is connected to CM3115.
 - Both CM3114 and CM3115 are connected to a common point labeled **WIRE DIRECT**.
- COOLING RELAY OUTPUTS:** A block of six terminals labeled 4, 5, 6, 7, 8, and 9.



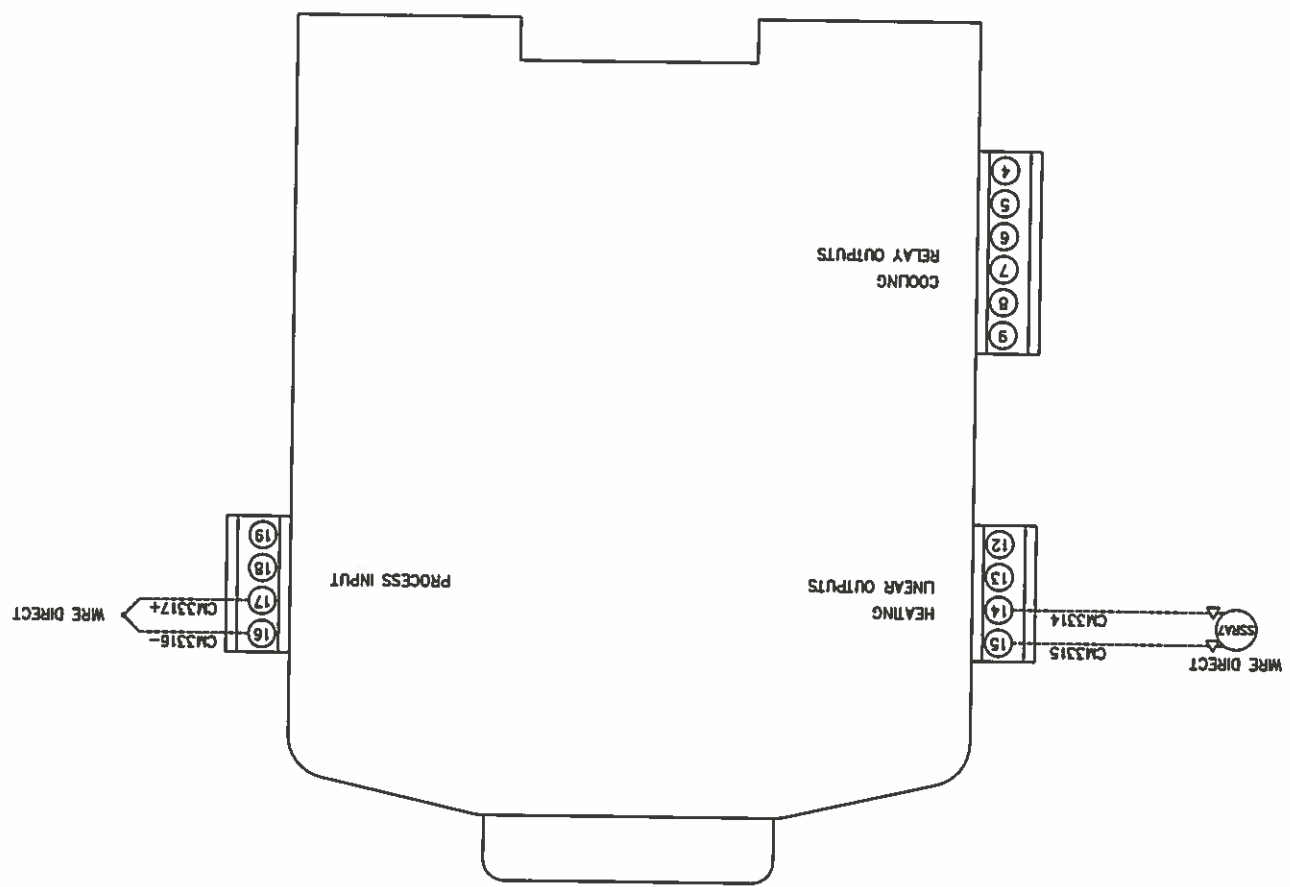
RELEASED
JUL 15 2002

[illegible]

TEMPERATURE CONTROL MODULE
RACK 3, MODULE 2
AUX ZONE #6



TEMPERATURE CONTROL MODULE
RACK 3, MODULE 3
AUX ZONE #7



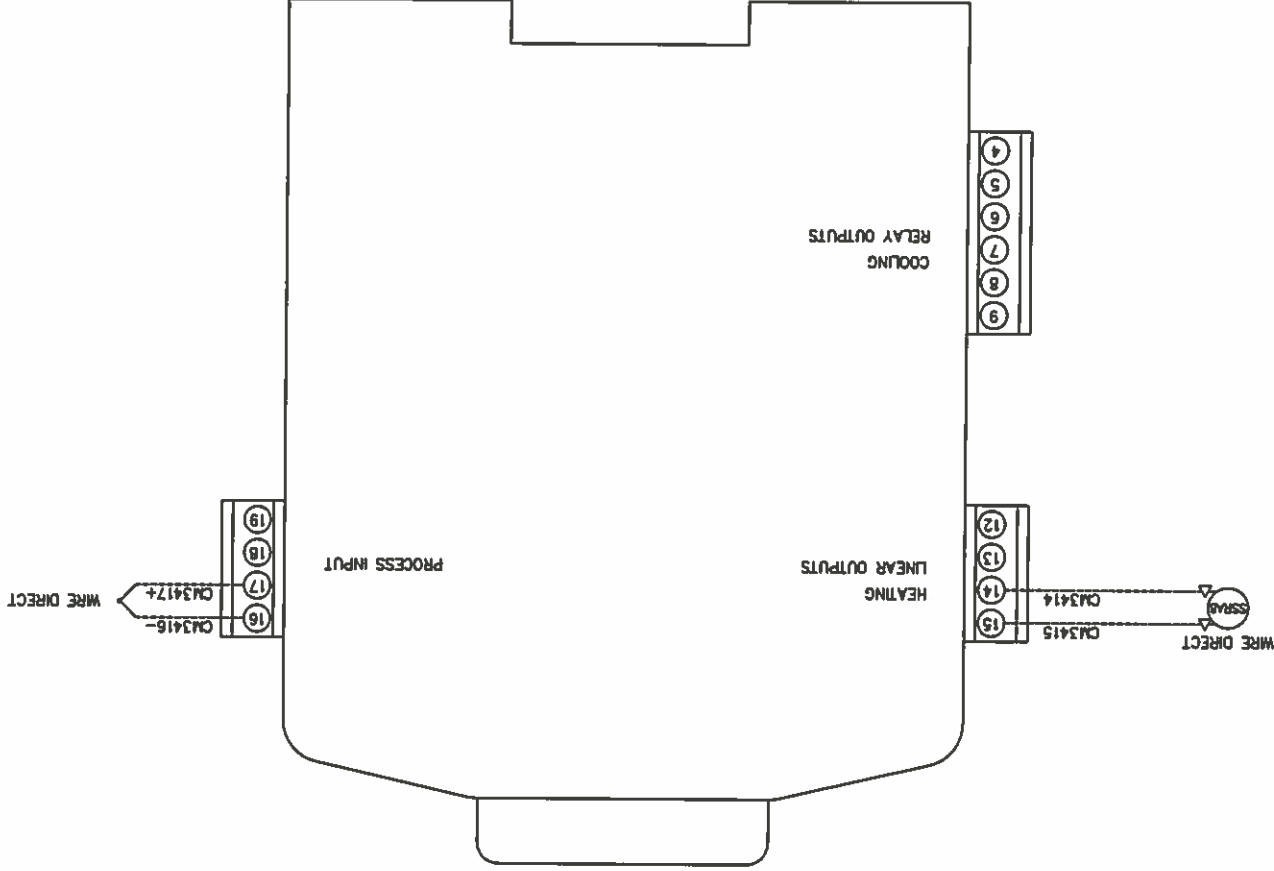
RELEASED
JUL 15 2002

PROJECT 15848		DATE 02/14/02	
5808	REVISION	02/14/02	02/14/02
27MM E-MAX 15848		DO NOT SCALE	
PLC ENCLOSURE		TOLERANCES UNLESS NOTED	
MILC 9000 WIRING		1" = 1'-0"	
27MM E-MAX 15848		1/4" = 1'-0"	
250 N. HAYWARD		1/8" = 1'-0"	
LEBANON, OR 97355		1/16" = 1'-0"	
PHONE 254-3901		1/32" = 1'-0"	
FAC 4 (Vandal-Resistant) Power Supply		1/64" = 1'-0"	

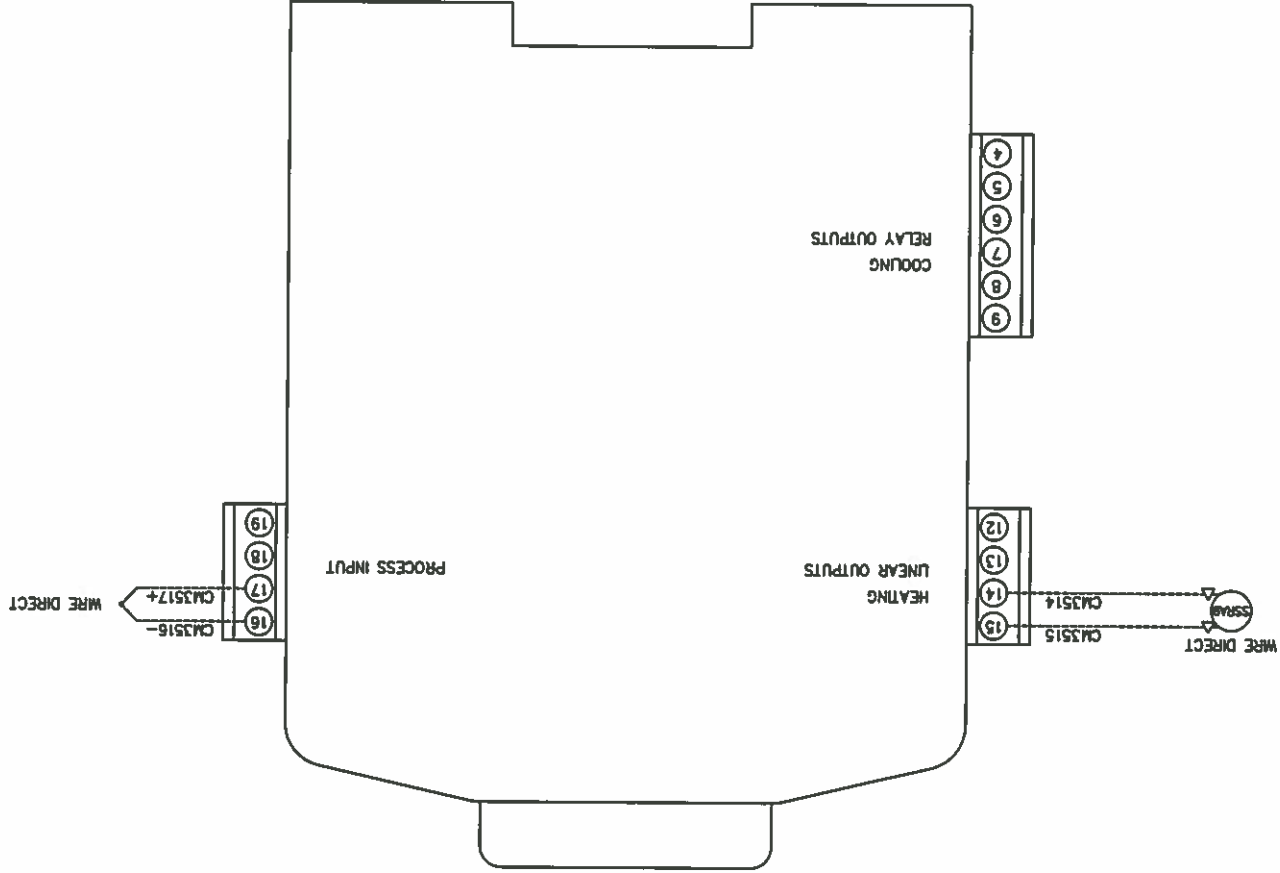
27MM EXTRUDER TERMINAL LEGEND	ENCLOSURE
HEATER/MOTOR ENCLOSURE	PLC ENCLOSURE
OPERATOR INTERFACE	

5808	DATE	BY	CHKD	DATE	BY
1	02/14/02	02	02/14/02	02	02/14/02
2	02/14/02	02	02/14/02	02	02/14/02

TEMPERATURE CONTROL MODULE
RACK 3, MODULE 4
AUX ZONE #8



TEMPERATURE CONTROL MODULE
RACK 3, MODULE 5
AUX ZONE #9



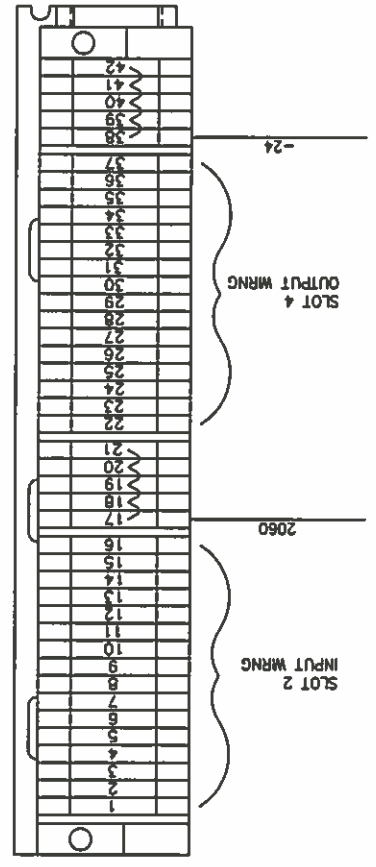
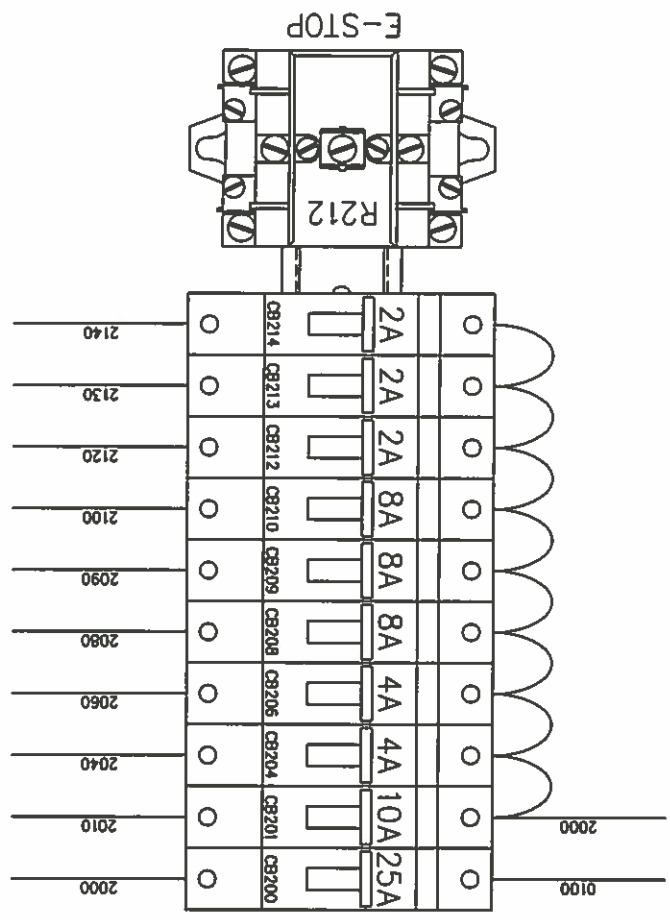
RELEASED
JUL 15 2002

PROJECT: 15846	
5808	NOHS
27MM E-MAX 15846	
PLC ENCLOSURE	
M/C 9000 WIRING	
250 N. HANSAARD	
LEBANON, OR 97355	
PHONE 259-3901	
INTER	
DO NOT SCALE	
02/14/02	02/14/02
02/14/02	02/14/02

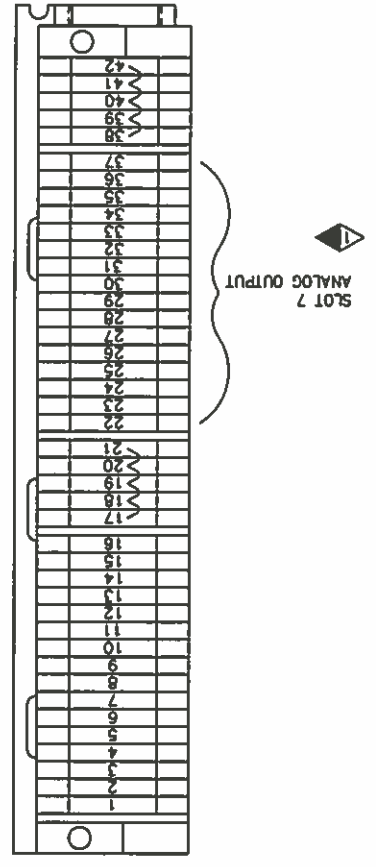
ENCLOSURE	TERMINAL
HEATER/MOTOR ENCLOSURE	△
PLC ENCLOSURE	□
OPERATOR INTERFACE	○

5808	NOHS	1	NOHS	2	NOHS
5808	NOHS	1	NOHS	2	NOHS
5808	NOHS	1	NOHS	2	NOHS

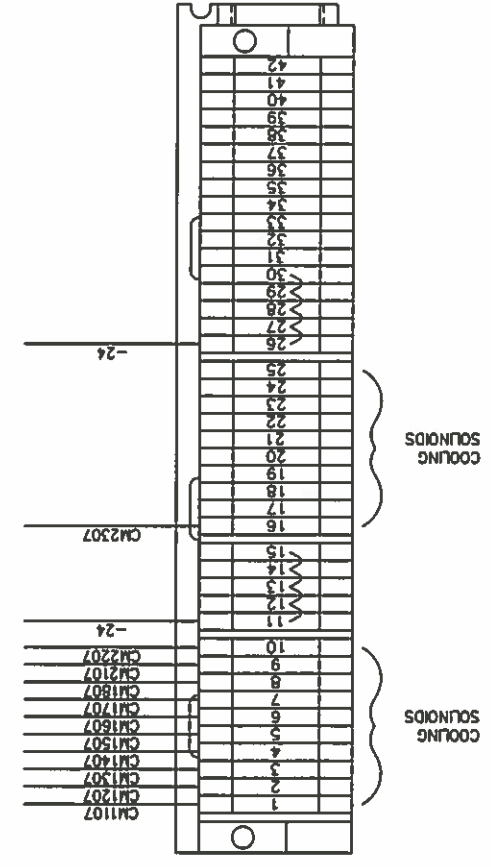
REV	DATE	BY	CHKD	APP'D
1	03/05/02	DA		
1.000 ANALOG OUTPUT I/O DESCRIPTION				
5809				



TS-1



TS-2



TS-3

REPLACED
MAY 01 2002

5809

PLC ENCLOSURE

27MM E-MAX 15846

TERMINAL STRIP LAYOUT

250 N. HANSAARD

LEBANON, OH 47335

PHONE 258-3901

03/05/02

03/05/02

DO NOT SCALE

TOLERANCES UNLESS NOTED

1" = 8" (1:8)

1/2" = 4" (1:8)

1/4" = 1" (1:4)

5809

PLC ENCLOSURE

27MM E-MAX 15846

TERMINAL STRIP LAYOUT

250 N. HANSAARD

LEBANON, OH 47335

PHONE 258-3901

03/05/02

03/05/02

DO NOT SCALE

TOLERANCES UNLESS NOTED

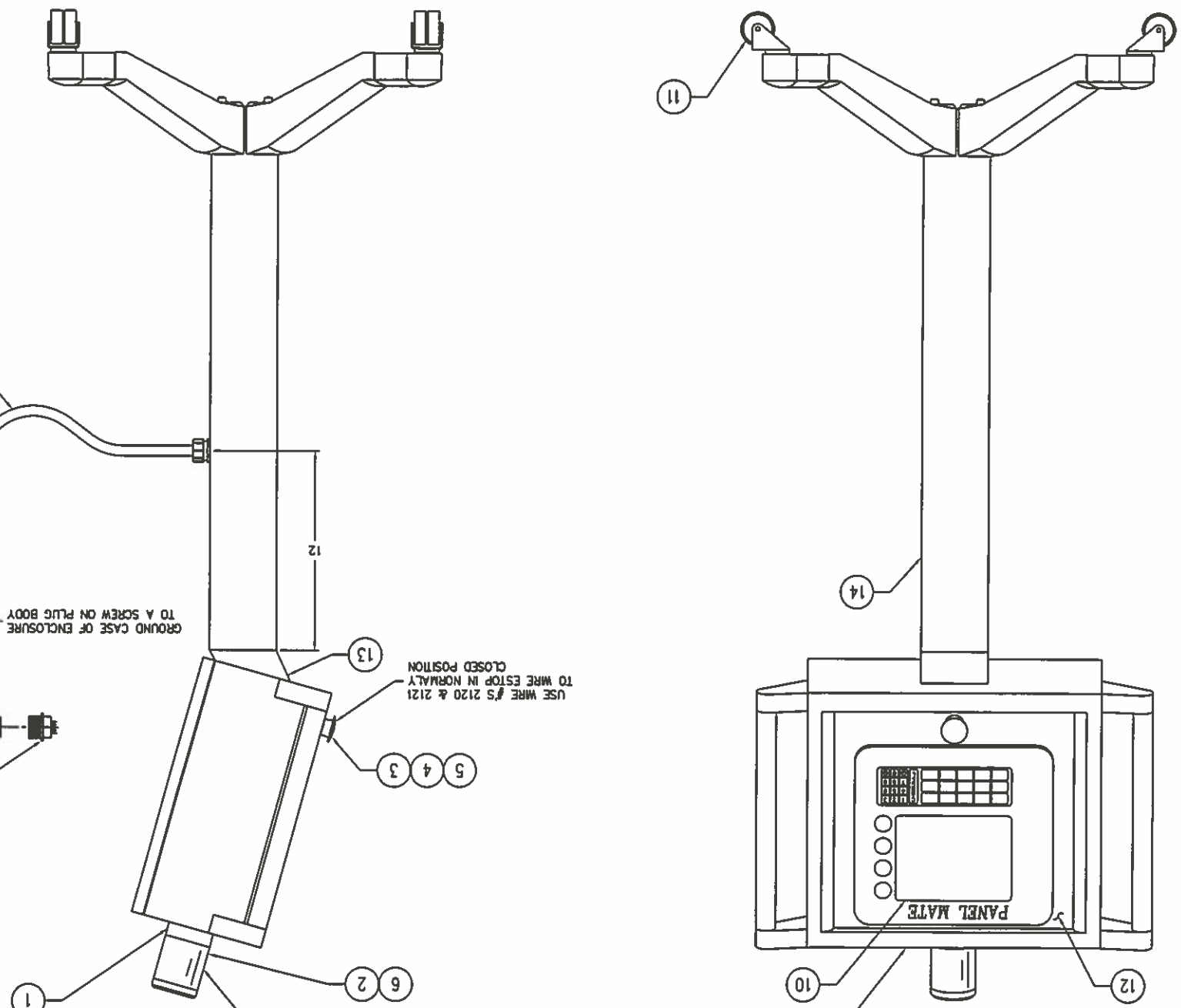
1" = 8" (1:8)

1/2" = 4" (1:8)

1/4" = 1" (1:4)

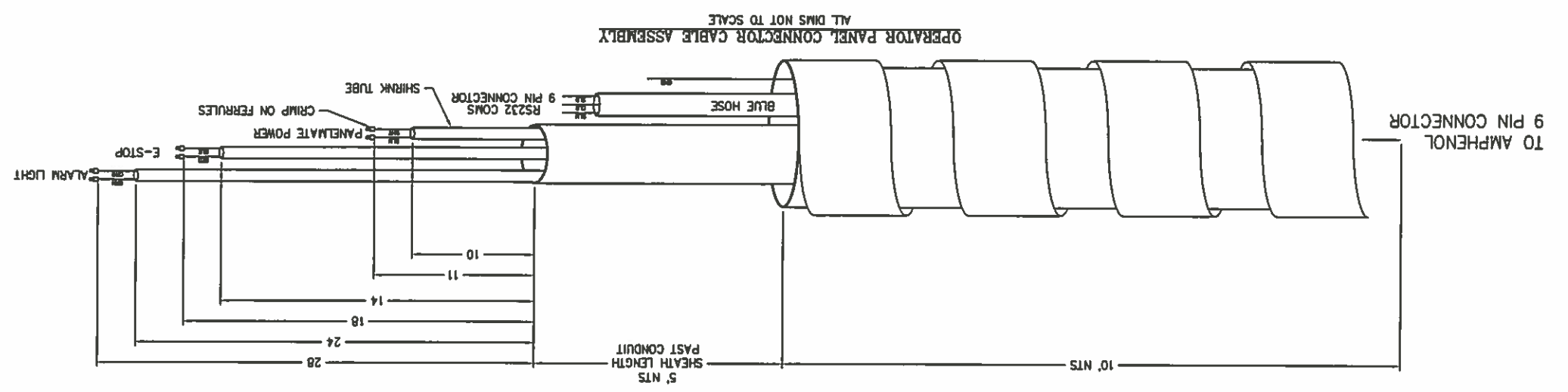
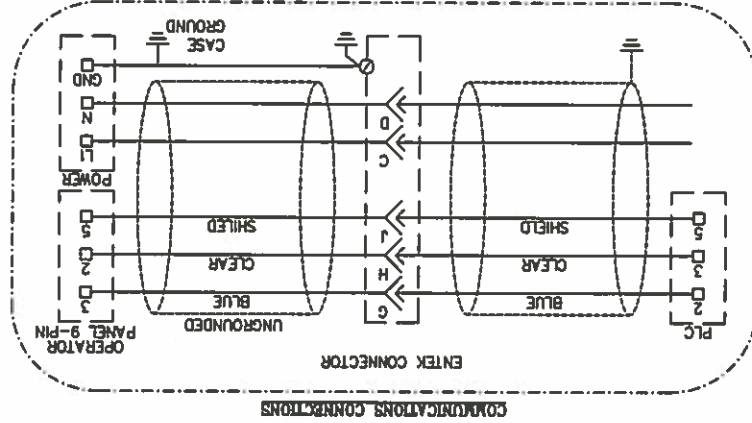
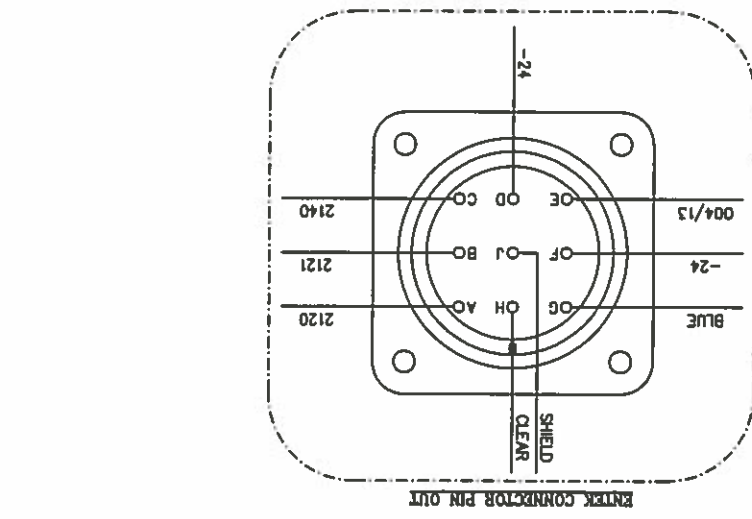
5810	REV	DATE	BY	APP'D
1	1	10/27/80	DLH	
1. WIRE MARKING				

CONNECT WIRE #004/13 TO PIN 1 ON BASE AND WIRE #24 TO PIN 0



SEE OPERATOR PANEL CONNECTOR CABLE ASSEMBLY
10' LONG
1/2" S.S. FLEX CONDUIT

USE WIRE #5 2120 & 2121 TO WIRE ESTOP IN NORMALLY CLOSED POSITION
GROUND CASE OF ENCLOSURE TO A SCREW ON PLUG BODY



PROJECT 15846
5810
ENCLOSURE INTERFACE
27MM E-MAX 15846
DO NOT SCALE
03/05/02
03/05/02
DLH
DLH
250 N. HANSAARD
LEBANON, OH 47335
PHONE 258-3901

RELEASED
OCT 07 2002