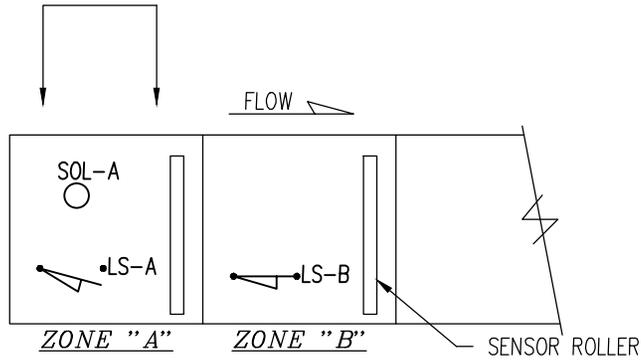


PALLET LOAD ZONE

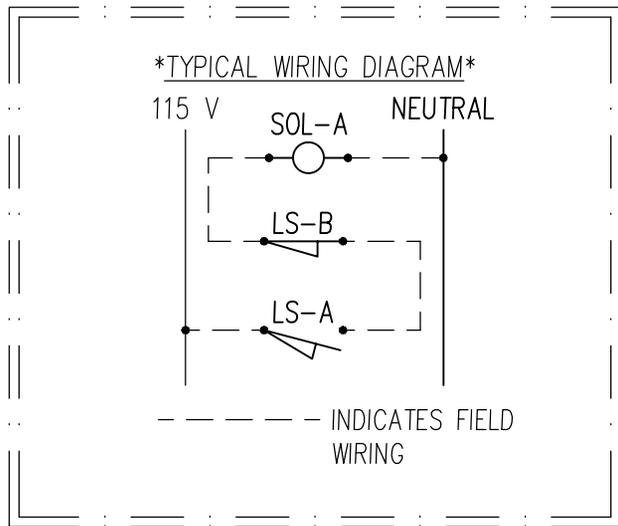


COMPONENTS FURNISHED:

SOL-A.....ELEC. SOL. 110V-1ph-60cy 5A. 19-054

LS-A.....ROLLER ACTIVATED TIME DELAY L.S. - NORMALLY OPEN. (18-103) 802T-R1TD, LEVER ARM (18-035)

LS-B.....ROLLER ACTIVATED LIMIT SWITCH - NORMALLY CLOSED. (18-033) 802T-AP. (LEVER ARM. 18-035).



SEQUENCE OF OPERATION

- (A) ZONE "A" IS NOT RUNNING (LS-A IS OPEN).
ZONE "B" IS RUNNING AND IS EMPTY (LS-B IS CLOSED).
- (B) FORK LIFT OPERATOR PLACES A PALLET IN ZONE "A"
AND ACTIVATES SENSOR ROLLER THEREBY CLOSING LS-A.
- (C) LS-A "TIMES OUT" (ALLOWING TIME FOR THE FORK LIFT
TO BACK OUT) AND STARTS ZONE "A."
- (D) WHEN PALLET CLEARS SENSOR ROLLER IN ZONE "A",
ZONE "A" ROLLERS STOP.
- (E) REPEAT STEPS A THRU D.

NOTES:

- (1) PALLETS MUST BE PLACED DIRECTLY ONTO SENSOR
ROLLER IN ZONE "A" IN ORDER TO START THE SEQUENCE
- (2) IF A PALLET IS IN ZONE "B", LS-B WILL BE OPEN
AND SOL-A WILL NOT BE ENERGIZED; THEREFORE,
ZONE "A" WILL NOT RUN.

NOTE: FAD DRAWING IS GENERATED BY MODEL

A	TS	7/19/07	ISSUED	8739
REV.	INT.	DATE	CHANGES	ECO#
FO No.	STANDARD	TITLE 251CDA		UNIT
DIST.	WIRING DIAGRAM W/FORKLIFT LOADING			
USER	SNSR RLR ACTIVATED			
 AUTOMATED CONVEYOR SYSTEMS, INC. WEST MEMPHIS, ARKANSAS	TOLERANCES: DECIMAL $\pm 0.03125"$, ANGULAR $\pm 1'$ UNLESS OTHERWISE SPECIFIED		DATE 7/19/07	NEXT ASSEMBLY
	DESIGNED BY:	CHECKED BY:	DATE	SCALE
DRAWN BY:	APPROVED BY:	DATE	REV.	DRAWING NUMBER
T. STOREY			A	FAD-146