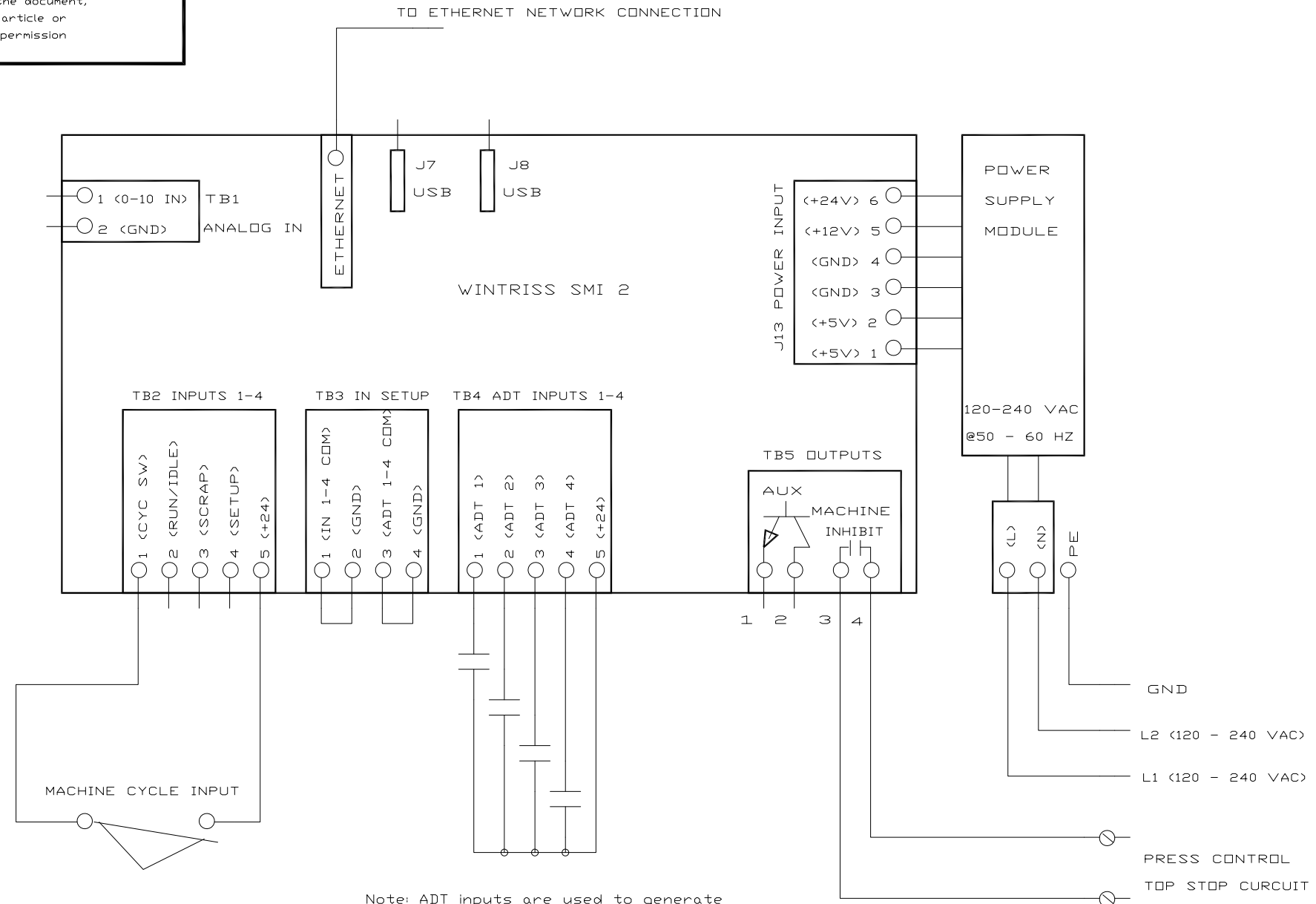


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Note: ADT inputs are used to generate Automatic Downtime Reasons.

All inputs are shown connected as PNP type. To change to NPN move the jumper on TB3/1 or TB3/3 to +24 VDC.

**MACHINE INHIBIT OUTPUT**  
 The machine inhibit output is closed for normal press operation. It opens when the machine operation needs to be inhibited to force the operator to enter downtime reasons.  
 This output is a dry contact relay rated at 2 amps. This is normally connected to the top stop circuit of the press control.

**MACHINE CYCLE INPUT**

This input must go on at aprox. 90 degrees and off at aprox. 270 degrees each rotation of the press. The SMI uses this input to count press strokes and determine when the press is running.  
 To turn this input on you must apply +24 VDC. This voltage can come from internal SMI 24 VDC supply or an external voltage source as long as the Com (Grounds) are connected together to provide a current return path.  
 The machine cycle input is shown connected to a cam switch and using the internal +24 VDC supply.

TITLE			
SFC Machine Interface 2			
Press Wiring Diagram			
DRAWN	SIZE	DRAWING NUMBER	REV
ADB	A+	FIG 2	
DATE	7/26/16	SHEET	OF