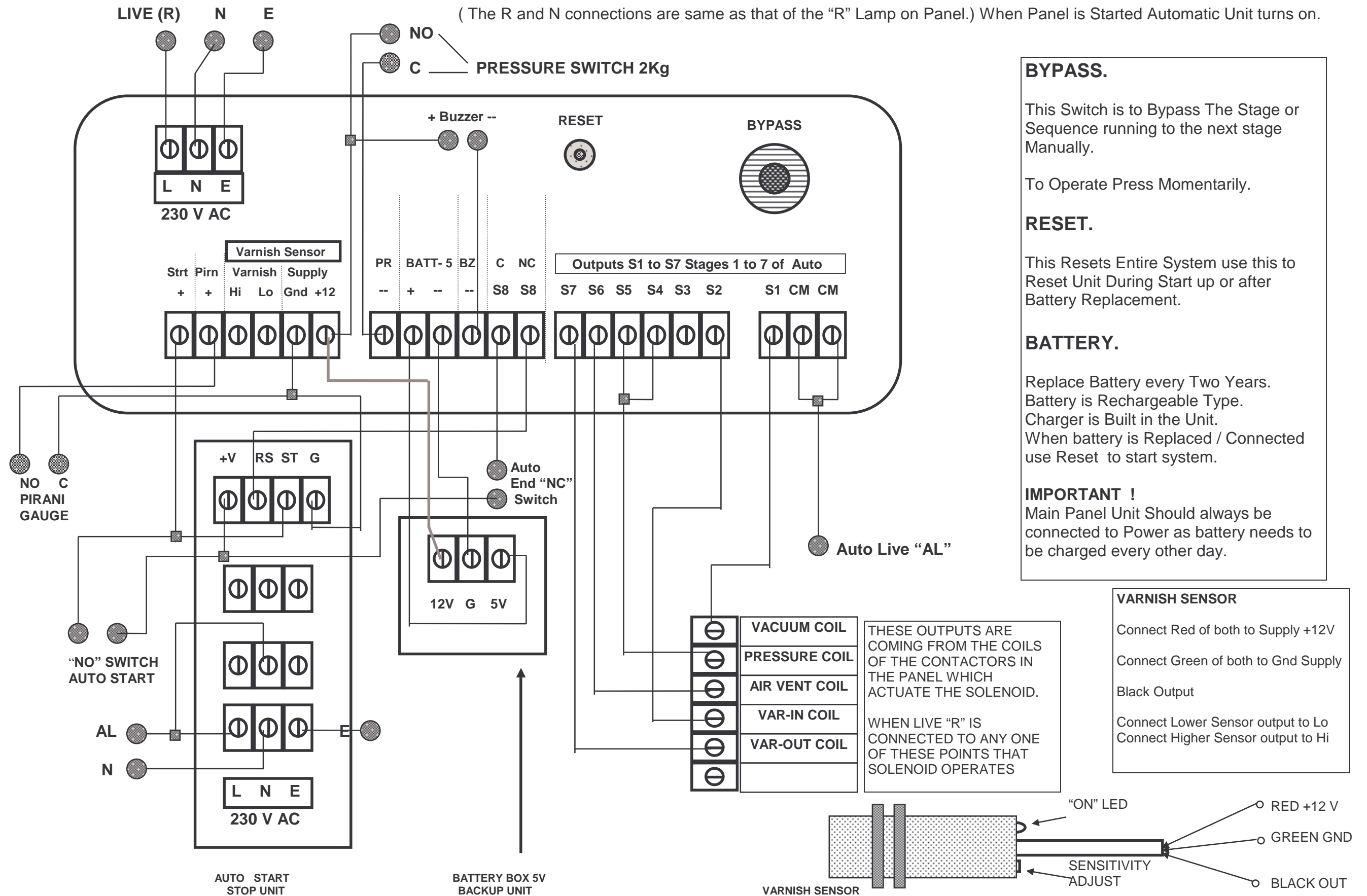


A. Wiring of Automatic Control Unit to the Panel Unit.



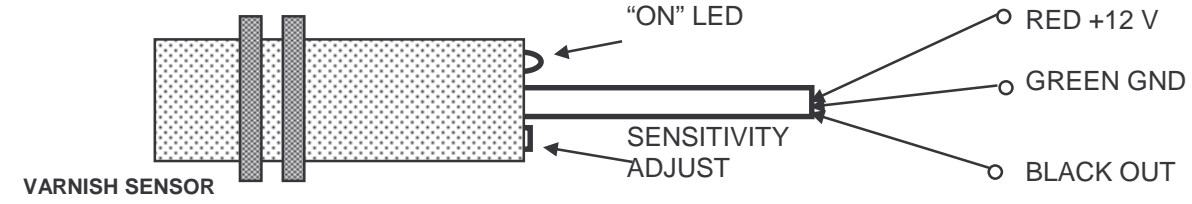
BYPASS.
 This Switch is to Bypass The Stage or Sequence running to the next stage Manually.
 To Operate Press Momentarily.

RESET.
 This Resets Entire System use this to Reset Unit During Start up or after Battery Replacement.

BATTERY.
 Replace Battery every Two Years. Battery is Rechargeable Type. Charger is Built in the Unit. When battery is Replaced / Connected use Reset to start system.

VARNISH SENSOR
 Connect Red of both to Supply +12V
 Connect Green of both to Gnd Supply
 Black Output
 Connect Lower Sensor output to Lo
 Connect Higher Sensor output to Hi

THESE OUTPUTS ARE COMING FROM THE COILS OF THE CONTACTORS IN THE PANEL WHICH ACTUATE THE SOLENOID.
 WHEN LIVE "R" IS CONNECTED TO ANY ONE OF THESE POINTS THAT SOLENOID OPERATES



B. Sequence of Auto Operation and related data.

Stage	Function	Thumbwheel Timing Set in Mts.	Action of The Process	Solenoid or Output Device	Bypass to Next Stage
0	Start or Wait.	01 mts Default	Cushion Stage of 5 Seconds in-between two consecutive stages.	All Solenoids off, No action, Wait Stage.	After 1 Mt. on start of a cycle. and after "5" Seconds between every cycle.
1	Vacuum On. T1	20 mts (99 max.)	Vacuum Solenoid creates Vacuum in chamber till Pirani Gauge Shuts off Solenoid.	Vacuum Solenoid is on till Vacuum in chamber reaches Setpoint.	Pirani Gauge O/P Relay closes Vacuum valve and promotes unit to next stage.
2	Varnish in. T2	30 mts (99 max.)	Varnish inlet Solenoid turns on and varnish fills the chamber.	Varnish inlet Solenoid on till Varnish reaches Hi Level / Time T2 Elapses.	Hi Varnish Sensor or Bypass Switch on Panel or time set gets over.
3	Soak. T3	45 mts (99 max.)	Soak Mode. This stage no action is taken.	All Solenoids are off Long Wait stage.	Time T3 or Manual Bypass will promote to next stage.
4	Pressure On. T4	10 mts (99 max.)	Pressure inlet solenoid is on upto 2 kg pressure it is on.	Buzzer is on, Pressure inlet solenoid on.	External Pres. SW at 2 kg trips unit to next stage or it goes after time T4.
5	Pressure Soak. T5	15 mts (99 max.)	Pressure Soak, external pressure switch maintains pressure level.	Buzzer is on, Pressure inlet solenoid is on cure stage.	When Time set gets elapsed it goes to next stage.
6	Air Vent Out. T6	08 mts	Vent out, allows high pressure air to leave chamber.	Solenoid for air vent turns on for set time.	When Time set gets elapsed it goes to next stage.
7	Varnish Out. T7	30 mts	Varnish Out		Varnish lo
8	Reset and End.	01 mts Default	Auto end trips auto start unit resets sequencer to 0		Auto start unit turns off now unit is ready for next sat

- A. All the stages at any time can be Bypassed to next stage by pressing bypass switch the unit will go to "0" stage and then go to next stage.
- B. All Thumbwheel time setting are in minutes and Minimum setting is 01 setting 00 will result is the system halting in that stage till manually bypassed.
- C. Minimum Setting in all the timers should be 2 mts it may work at 1mt but may not be reliable in noisy environments.
- D. Do not press Increment (bypass) switch very fast as system may hang.