

CMM-45 OPERATION PROCEDURES

While in automatic mode, the operator should back treadle to lift the presser foot so they can load the material. The border material is placed under the presser foot with the tick side up, under the folding blade, and under the reflector plate of the photo eye assembly. The non skid is then placed on top of the border under the presser foot with the edges aligned. The non skid is placed over the folding blade and in the slot of the photo eye assembly, on top of the reflector plate and below the photo eye window.

The operator may begin to sew the two work pieces together. When the non skid passes the first photo eye the system goes into a programmed mode that slows the head down. Once the second eye is made the system places a predetermined amount of stitches up to the corner, the amount of stitch may be changed with the touch screen. The operator then folds the material over the folding blade. The foot switch or the touch screen then needs to be pressed; this retracts the folding blade and engages the knife. The operator will then sew off of the edge while holding the folded corner. The material is then rotated forty-five degrees and the operator sews and cuts off the corner. The thread will need to be trimmed at this point. The material is then rotated another forty-five degrees to become square to the next unsown edge. Once the material is started and a few stitches are in the operator presses the foot switch this disengages the knife and returns the folding blade and the photo eye assembly. Once the material has been aligned in the proper fashion as mentioned above the operator may begin to sew down the length of the edge. The process repeats for each corner.

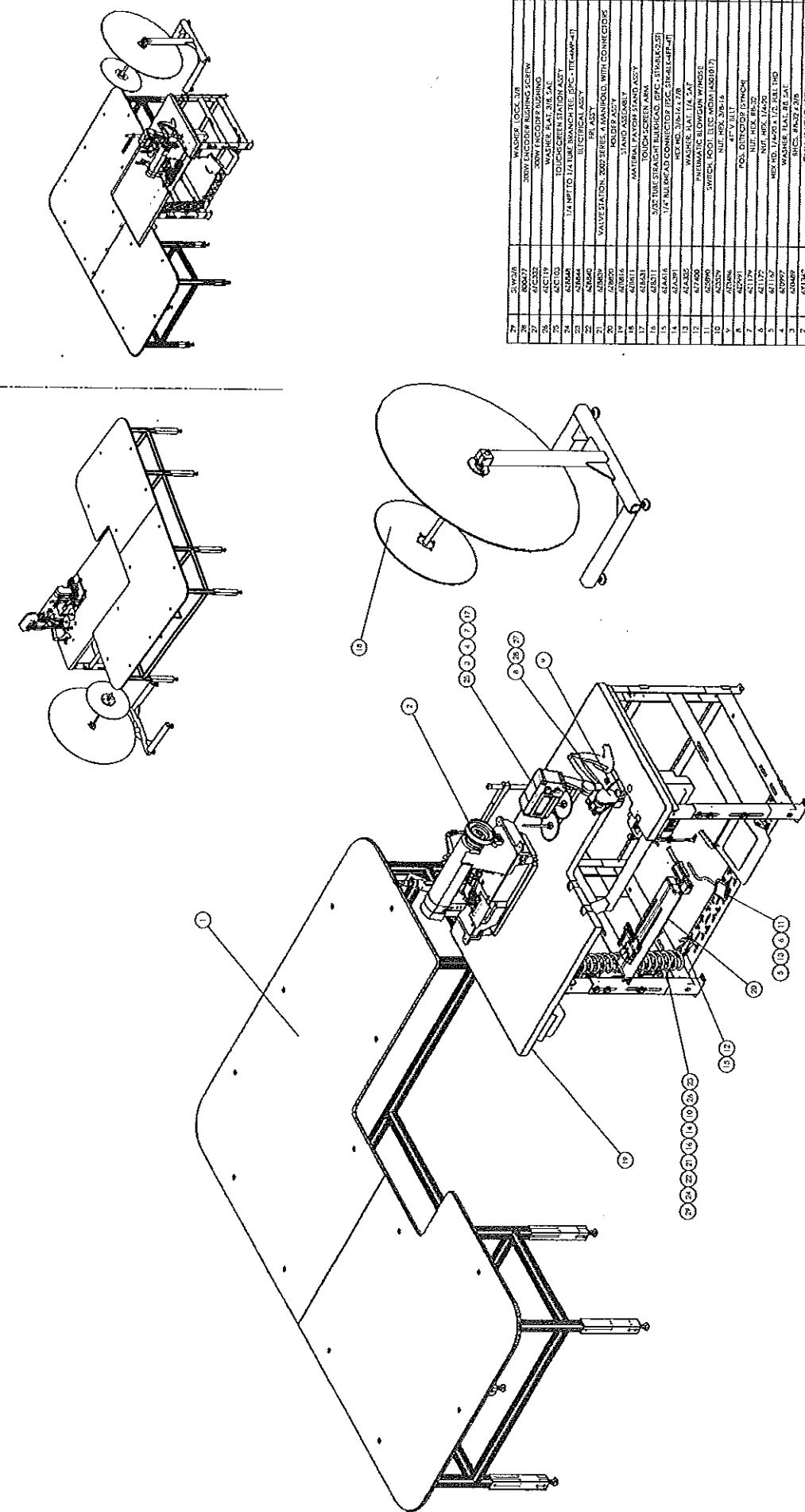
When all four corners are finished and the operator is approaching the beginning point, the foot pedal needs to be pressed for three seconds to initiate the sew off sequence. This retracts the folding blade and the photo eye assembly. The operator then sews off the edge of the material, then folds the edges of the border together to line up and sews across the width of the border. Once this is completed the operator can lift the presser foot and insert the material where they had sown off earlier and complete the union between the border and non skid. The operator then holds the foot switch down for three more seconds to make the machine go back to the operation mode.

AguilA ORANGE 23/160

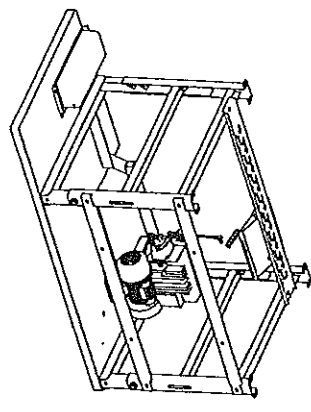
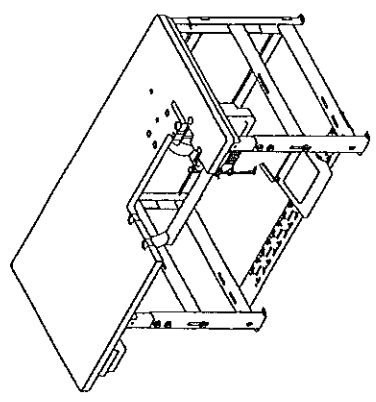
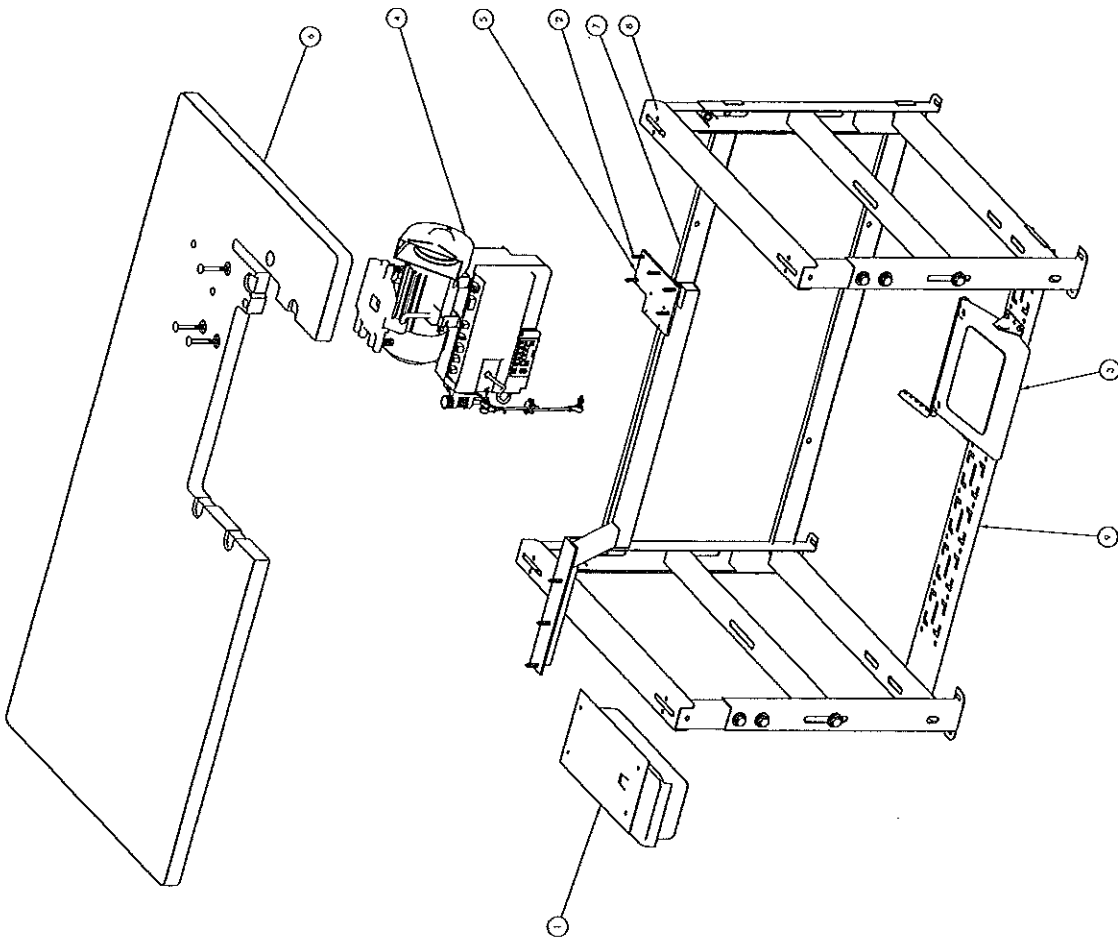
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62 x 59

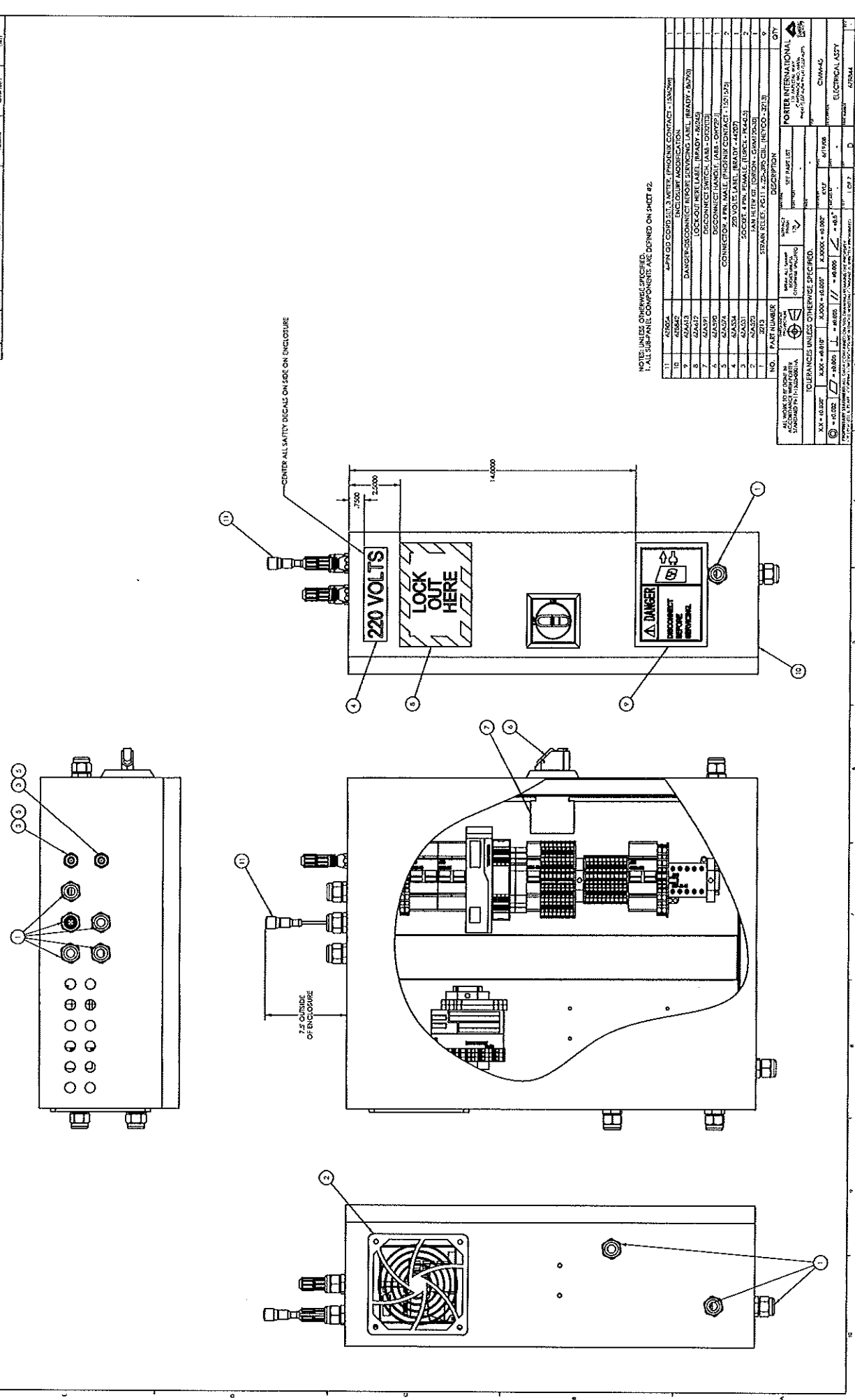
Mientras en modo automático, el operador debe mover hacia atrás el pedal para levantar el pie (presser foot) así pueden cargar el material. El borde del material se pone bajo del pie (presser foot) con el lado de diseño para arriba, debajo de la lámina que dobla, y debajo de la placa del reflector del montaje del ojo del censor. El antideslizante entonces se coloca encima de la borde bajo del pie (presser foot) con los bordes alineados. El antideslizante debe ser colocado arriba de la lámina que dobla y en el espacio del ojo del censor, encima de la placa del reflector y debajo de la ventana del ojo del censor. El operador puede comenzar a coser las dos piezas de material. Cuando el antideslizante pase el primer el ojo, el sistema entran un modo programado que retarde la cabeza. Una vez que se haga el segundo ojo, el sistema pone una cantidad predeterminada de puntadas hasta la esquina, la cantidad de puntadas se puede cambiar con la pantalla de tacto. El operador entonces dobla el material sobre la lámina que dobla. Se necesita oprimir el pedal o en la pantalla; esto contrae la lámina que dobla y contrata el navaja a cortar el material. El operador entonces coserá los bordes mientras que levanta la esquina doblada. Entonces, dar vuelta al material de 45 grados y el operador cose y corta la esquina. El hilo de necesitará ser cortado corto en este punto. El material entonces le da vuelta otra vez mas (45 grados) hasta llegar a ser cuadrado al borde de la siguiente pieza de material. Una vez que se comience el material y al tener algunas puntadas, el operador oprime el pedal del pie, esto para desunir la navaja y regresar el censor y la lámina que dobla. Una vez que el material se haya alineado en la manera apropiada (mencionado arriba), el operador puede comenzar a coser la longitud del borde. Este proceso se repite para cada esquina. Cuando se acaban las cuatro esquinas y el operador está acercando al punto que en cual comenzó, el pedal debe ser oprimido por tres segundos para iniciar la costura de secuencia. Esto contrae la lámina que dobla y el censor. El operador después cose el borde del material, después dobla y alinea los bordes junto y cose a través de la anchura de borde. Una vez que se termine esto el operador puede levantar el pie (presser foot) y insertar el material donde se acaba de coser y terminar la unión del borde y el antideslizante. El operador entonces oprime el pedal por tres segundos mas para devolver la máquina de nuevo al modo de operación.



QTY	PART NUMBER	DESCRIPTION	DATE
1	79	WASHER LOCK 3/16	
4	80A17	300W ENCODER MOUNTING SCREW	
1	81C3B2	300W ENCODER MOUNTING	
6	82C11P	WASHER P-1/4, 3/8, 5/8	
1	83	1000-GREEN STATION ASST	
1	84	1/4" NPT 1/8" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	85A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	86A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	87A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	88A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	89A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	90A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	91A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
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1	93A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
1	94A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	
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1	130A4	1/8" NPT 1/2" LUB BRANCH TEE, BPC - 2" SWAMP-11	



QTY	TRAC	PART NUMBER	DESCRIPTION	LOT#
1	5	81427	BOTTOM TRICASTE PALE	
1	5	81428	ANGLE, 3/8" PAK SANDALWOOD	
1	7	81429	BLACK PALE, 1/2" X 1/2"	
1	5	81430	TABLE TOP	
1	5	81431	TABLE BRACE	
1	4	81432	UNDERPAID PART, 1/2" X 1/2" X 1/2" X 1/2"	
1	3	81433	TRICASTE W/LOCK, 1/2" X 1/2"	
1	7	81434	TAPPING SCREW, #14	
1	8	81435	DRAWER TAN	
1	1	81436	20" MAG	
1	1	81437	SEALING	
1	1	81438	STY PANEL KIT	
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1	1	81600	STY PANEL KIT	



NOTES: UNLESS OTHERWISE SPECIFIED, ALL SUB-PANEL COMPONENTS ARE DEFINED ON SHEET #2.

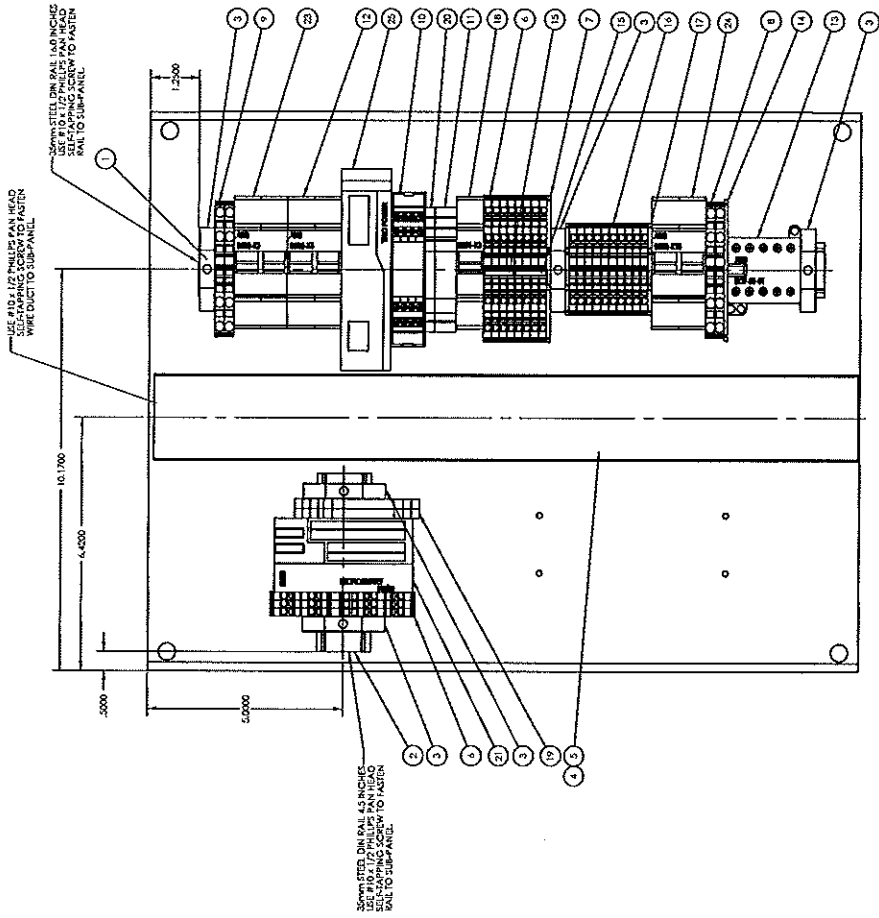
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2	42053	APR 1000S 20A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
3	42054	APR 1000S 30A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
4	42055	APR 1000S 40A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
5	42056	APR 1000S 50A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
6	42057	APR 1000S 60A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
7	42058	APR 1000S 75A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
8	42059	APR 1000S 90A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
9	42060	APR 1000S 100A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
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11	42062	APR 1000S 150A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
12	42063	APR 1000S 200A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
13	42064	APR 1000S 250A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
14	42065	APR 1000S 300A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
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16	42067	APR 1000S 500A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
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19	42070	APR 1000S 900A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
20	42071	APR 1000S 1000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
21	42072	APR 1000S 1200A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
22	42073	APR 1000S 1500A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
23	42074	APR 1000S 2000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
24	42075	APR 1000S 2500A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
25	42076	APR 1000S 3000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
26	42077	APR 1000S 4000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
27	42078	APR 1000S 5000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
28	42079	APR 1000S 6000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
29	42080	APR 1000S 7500A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
30	42081	APR 1000S 9000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
31	42082	APR 1000S 10000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
32	42083	APR 1000S 12000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
33	42084	APR 1000S 15000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
34	42085	APR 1000S 20000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
35	42086	APR 1000S 25000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
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37	42088	APR 1000S 40000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
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40	42091	APR 1000S 75000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
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44	42095	APR 1000S 150000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
45	42096	APR 1000S 200000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
46	42097	APR 1000S 250000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
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48	42099	APR 1000S 400000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
49	42100	APR 1000S 500000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
50	42101	APR 1000S 600000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
51	42102	APR 1000S 750000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
52	42103	APR 1000S 900000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
53	42104	APR 1000S 1000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
54	42105	APR 1000S 1200000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
55	42106	APR 1000S 1500000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
56	42107	APR 1000S 2000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
57	42108	APR 1000S 2500000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
58	42109	APR 1000S 3000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
59	42110	APR 1000S 4000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
60	42111	APR 1000S 5000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
61	42112	APR 1000S 6000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
62	42113	APR 1000S 7500000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
63	42114	APR 1000S 9000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
64	42115	APR 1000S 10000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
65	42116	APR 1000S 12000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
66	42117	APR 1000S 15000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
67	42118	APR 1000S 20000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
68	42119	APR 1000S 25000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
69	42120	APR 1000S 30000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
70	42121	APR 1000S 40000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
71	42122	APR 1000S 50000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
72	42123	APR 1000S 60000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
73	42124	APR 1000S 75000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
74	42125	APR 1000S 90000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
75	42126	APR 1000S 100000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
76	42127	APR 1000S 120000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
77	42128	APR 1000S 150000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
78	42129	APR 1000S 200000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
79	42130	APR 1000S 250000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
80	42131	APR 1000S 300000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
81	42132	APR 1000S 400000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
82	42133	APR 1000S 500000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
83	42134	APR 1000S 600000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
84	42135	APR 1000S 750000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
85	42136	APR 1000S 900000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
86	42137	APR 1000S 1000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
87	42138	APR 1000S 1200000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
88	42139	APR 1000S 1500000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
89	42140	APR 1000S 2000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
90	42141	APR 1000S 2500000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
91	42142	APR 1000S 3000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
92	42143	APR 1000S 4000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
93	42144	APR 1000S 5000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
94	42145	APR 1000S 6000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
95	42146	APR 1000S 7500000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
96	42147	APR 1000S 9000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
97	42148	APR 1000S 10000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
98	42149	APR 1000S 12000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
99	42150	APR 1000S 15000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1
100	42151	APR 1000S 20000000000A 120V/250V (INDUSTRIAL CONTACT - 15912S)	1

PORTER INTERNATIONAL
 14000 W. 140th St.
 Aurora, IL 60504
 TEL: 815/495-0300 FAX: 815/495-0301
 WWW: www.porterintl.com

ALL WORK TO BE DONE IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE (NEC) AND THE NATIONAL FIRE ALARM AND SIGNAL CODE (NFPA 72).

ALL WORK TO BE DONE IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE (NEC) AND THE NATIONAL FIRE ALARM AND SIGNAL CODE (NFPA 72).

ALL WORK TO BE DONE IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE (NEC) AND THE NATIONAL FIRE ALARM AND SIGNAL CODE (NFPA 72).



ITEM NO.	PART NUMBER	DESCRIPTION	QTY
26	A2C106	INVERTER MODULE (PHOENIX CONTACT - 29A23V)	1
25	A2A501	POWER SUPPLY 24V (PHOENIX CONTACT - 29A450A)	1
24	A2F100000	CIRCUIT BREAKER 2P 10A (ABB - 5590-410)	1
23	A2B945	CIRCUIT BREAKER 1P 30A (ABB - 5592-45)	1
22	A2B945	CIRCUIT BREAKER 1P 30A (ABB - 5592-45)	1
21	A2B945	PLC 16 PT IO (PHOENIX CONTACT - 29A21601)	1
20	A2B945	RELAY 24VDC (PHOENIX CONTACT - 29A21601)	1
19	A2B945	OPTO COUPLER INPUT/OUTPUT (PHOENIX CONTACT - 29A21601)	1
18	A2B945	CIRCUIT BREAKER 1P 30A (ABB - 5590-45)	1
17	A2B945	TERMINAL BLOCK END COVER (PHOENIX CONTACT - 29A21601)	2
16	A2B945	TERMINAL BLOCK 4 POS (PHOENIX CONTACT - 29A21601)	10
15	A2B945	TERMINAL BLOCK 4 POS (PHOENIX CONTACT - 29A21601)	7
14	A2B945	PARTITION PLATE (PHOENIX CONTACT - 29A21601)	1
13	A2B945	MINI CONTACTOR 24V COIL 3NO, 1 NC (ABB - 5570-01)	1
12	A2B945	CIRCUIT BREAKER 2P 10A (ABB - 5590-41)	1
11	A2B945	RELAY 24VDC NO (PHOENIX CONTACT - 29A21601)	1
10	A2B945	COUPLING TERMINAL BLOCK (PHOENIX CONTACT - 29A21601)	1
9	A2B945	COUPLING TERMINAL BLOCK (PHOENIX CONTACT - 29A21601)	1
8	A2B945	TERMINAL BLOCK (PHOENIX CONTACT - 29A21601)	2
7	A2A501	TERMINAL BLOCK END COVER (PHOENIX CONTACT - 29A450A)	1
6	A2F1000	TERMINAL BLOCK (PHOENIX CONTACT - 29A450A)	1
5	A2F1000	COVER W/MP DUCT 2 X 2	1
4	A2B945	WIRE DUCT 2 X 2	1
3	A2B945	30mm DIN MOUNTING RAIL 18.5"	1
2	A2B945	30mm DIN MOUNTING RAIL 18.5"	1
1	A2B945	30mm DIN MOUNTING RAIL 18.5"	1

ALL WORK TO BE DONE IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE (NEC) AND ALL OTHER APPLICABLE CODES AND REGULATIONS.

PORTER INTERNATIONAL
 12000 W. 116th Street, Overland Park, MO 66213
 PHONE: 913-666-1100 FAX: 913-666-1101
 WWW.PORTERINTERNATIONAL.COM

TOLERANCES UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS: ±0.005 / ±0.010 / ±0.015 / ±0.020 / ±0.025 / ±0.030 / ±0.035 / ±0.040 / ±0.050 / ±0.060 / ±0.070 / ±0.080 / ±0.090 / ±0.100

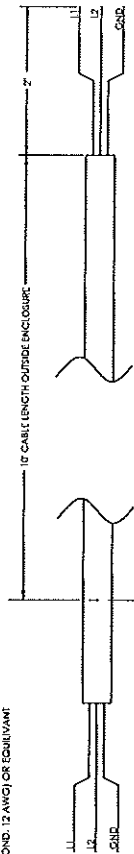
DATE: 2017
 DRAWN: [Name]
 CHECKED: [Name]
 APPROVED: [Name]

ELECTRICAL LIST

PORTER INTERNATIONAL

CABLE #1 (MAIN POWER)

CABLE DATA:
SAB-1250412003 (3 COND., 12 AWG) OR EQUIVALENT



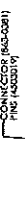
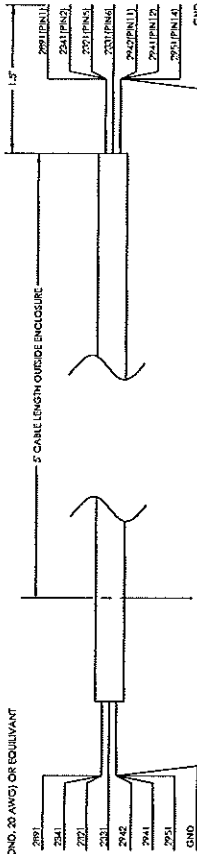
CABLE #2 (MOTOR CABLE)

CABLE DATA:
SAB-125041603 (3 COND., 18 AWG) OR EQUIVALENT



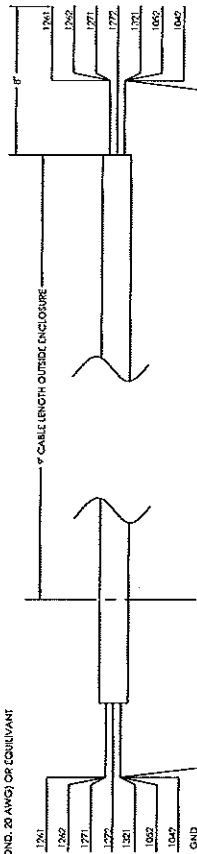
CABLE #3 (OPTION B CABLE)

CABLE DATA:
SAB-1250420008 (8 COND., 20 AWG) OR EQUIVALENT



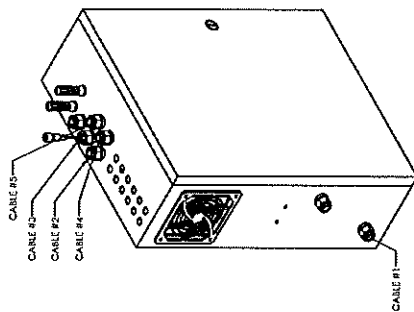
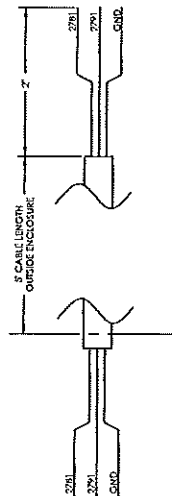
CABLE #4 (OPERATOR STATION CABLE)

CABLE DATA:
SAB-1250420008 (8 COND., 20 AWG) OR EQUIVALENT

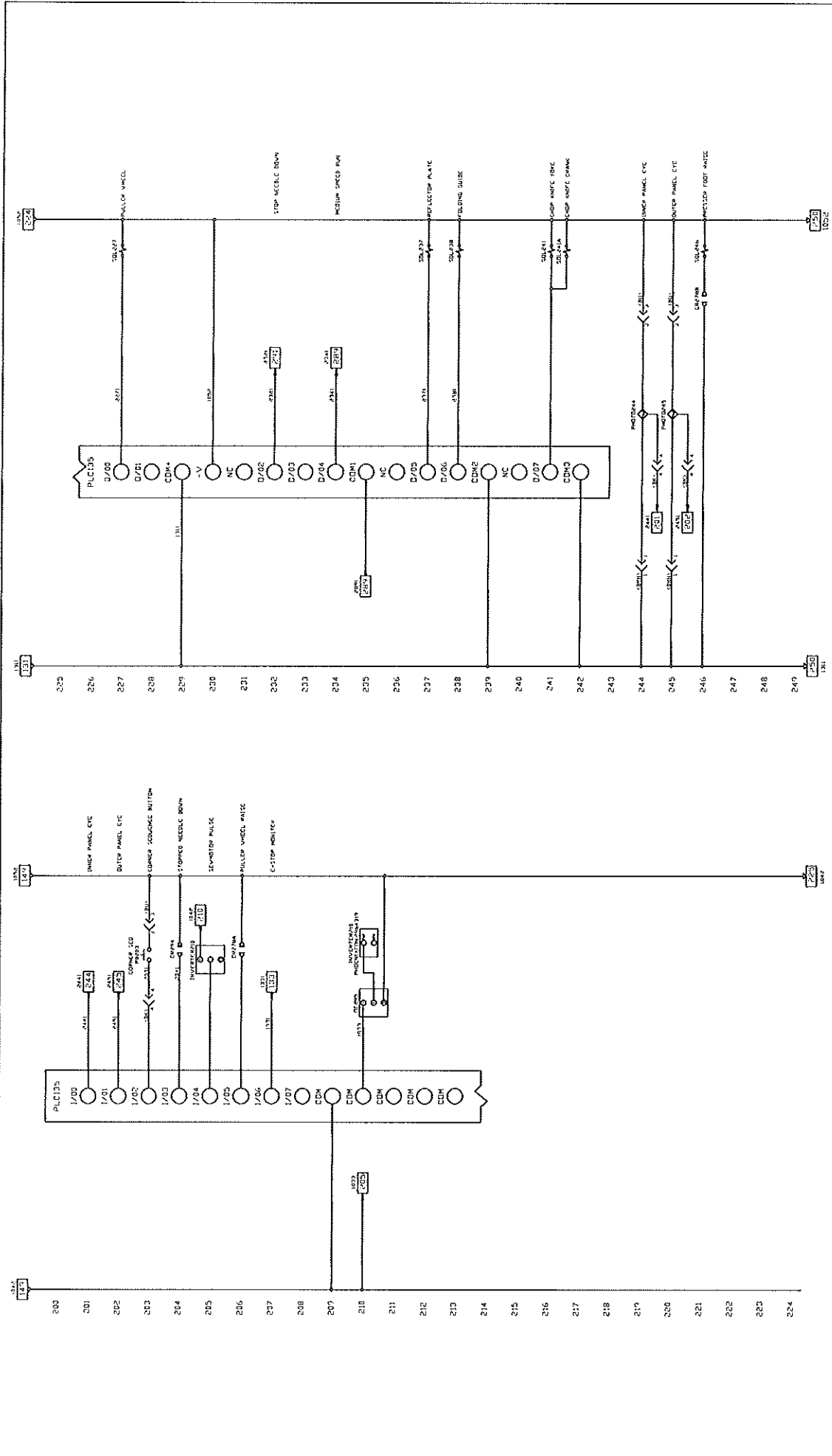


CABLE #5 (FOOT LIFT CABLE)

CABLE DATA:
SAB-1250412003 (3 COND., 12 AWG) OR EQUIVALENT

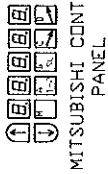


<p>ALL WORK IS TO BE DONE IN ACCORDANCE WITH THE SPECIFICATIONS AND REQUIREMENTS OF THE NATIONAL ELECTRICAL CONTRACTORS ASSOCIATION (NECA) AND THE INTERNATIONAL BROTHERHOOD OF ELECTRICAL WORKERS (IBEW).</p> <p>NECA-IBEW CONTRACTORS</p> <p>CONFORMANCE WITH THE NATIONAL ELECTRICAL CONTRACTORS ASSOCIATION (NECA) AND THE INTERNATIONAL BROTHERHOOD OF ELECTRICAL WORKERS (IBEW) STANDARDS AND PRACTICES.</p>	<p>CONDUCTOR (secondary) (PIN #005801)</p>
<p>APPROVAL NAME: []</p> <p>DATE: []</p> <p>ISSUE NO: []</p>	<p>1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16</p>
<p>TOLEANCES UNLESS OTHERWISE SPECIFIED:</p> <p>S.A. ± 0.000" X.XX ± 0.001" X.XXXX ± 0.002"</p>	<p>3 OF 3</p>
<p>POWER INTERNATIONAL</p> <p>CHAMAS</p>	<p>ELECTRICAL COST</p>



PORTER INTERNATIONAL 3000 S. GARDEN AVENUE GAITHERSBURG, MD 20878	
ALL WORK IS TO BE DONE BY LICENSED ELECTRICAL CONTRACTORS	TOLERANCES UNLESS OTHERWISE SPECIFIED: .125" = .0005" .0005" = .0002" .0002" = .0001"
.0001" = .00005" .00005" = .00002" .00002" = .00001"	.00001" = .000005" .000005" = .000002" .000002" = .000001"
.000001" = .0000005" .0000005" = .0000002" .0000002" = .0000001"	.0000001" = .00000005" .00000005" = .00000002" .00000002" = .00000001"
.00000001" = .000000005" .000000005" = .000000002" .000000002" = .000000001"	.000000001" = .0000000005" .0000000005" = .0000000002" .0000000002" = .0000000001"
.0000000001" = .00000000005" .00000000005" = .00000000002" .00000000002" = .00000000001"	.00000000001" = .000000000005" .000000000005" = .000000000002" .000000000002" = .000000000001"
.000000000001" = .0000000000005" .0000000000005" = .0000000000002" .0000000000002" = .0000000000001"	.0000000000001" = .00000000000005" .00000000000005" = .00000000000002" .00000000000002" = .00000000000001"
.00000000000001" = .000000000000005" .000000000000005" = .000000000000002" .000000000000002" = .000000000000001"	.000000000000001" = .0000000000000005" .0000000000000005" = .0000000000000002" .0000000000000002" = .0000000000000001"
.0000000000000001" = .00000000000000005" .00000000000000005" = .00000000000000002" .00000000000000002" = .00000000000000001"	.00000000000000001" = .000000000000000005" .000000000000000005" = .000000000000000002" .000000000000000002" = .000000000000000001"
.000000000000000001" = .0000000000000000005" .0000000000000000005" = .0000000000000000002" .0000000000000000002" = .0000000000000000001"	.0000000000000000001" = .00000000000000000005" .00000000000000000005" = .00000000000000000002" .00000000000000000002" = .00000000000000000001"
.00000000000000000001" = .000000000000000000005" .000000000000000000005" = .000000000000000000002" .000000000000000000002" = .000000000000000000001"	.000000000000000000001" = .0000000000000000000005" .0000000000000000000005" = .0000000000000000000002" .0000000000000000000002" = .0000000000000000000001"

.0000000000000000000001" = .00000000000000000000005" .00000000000000000000005" = .00000000000000000000002" .00000000000000000000002" = .00000000000000000000001"	.000000000000000000000001" = .0000000000000000000000005" .0000000000000000000000005" = .0000000000000000000000002" .0000000000000000000000002" = .0000000000000000000000001"
.00000000000000000000000001" = .000000000000000000000000005" .000000000000000000000000005" = .000000000000000000000000002" .000000000000000000000000002" = .000000000000000000000000001"	.0000000000000000000000000001" = .00000000000000000000000000005" .00000000000000000000000000005" = .00000000000000000000000000002" .00000000000000000000000000002" = .00000000000000000000000000001"
.000000000000000000000000000001" = .0000000000000000000000000000005" .0000000000000000000000000000005" = .0000000000000000000000000000002" .0000000000000000000000000000002" = .0000000000000000000000000000001"	.00000000000000000000000000000001" = .000000000000000000000000000000005" .000000000000000000000000000000005" = .000000000000000000000000000000002" .000000000000000000000000000000002" = .000000000000000000000000000000001"
.0000000000000000000000000000000001" = .00000000000000000000000000000000005" .00000000000000000000000000000000005" = .00000000000000000000000000000000002" .00000000000000000000000000000000002" = .00000000000000000000000000000000001"	.000000000000000000000000000000000001" = .0000000000000000000000000000000000005" .0000000000000000000000000000000000005" = .0000000000000000000000000000000000002" .0000000000000000000000000000000000002" = .0000000000000000000000000000000000001"
.00000000000000000000000000000000000001" = .000000000000000000000000000000000000005" .000000000000000000000000000000000000005" = .000000000000000000000000000000000000002" .000000000000000000000000000000000000002" = .000000000000000000000000000000000000001"	.0001" = .005" .005" = .002" .002" = .001"
.0001" = .005" .005" = .002" .002" = .0001"	.001" = .0005" .0005" = .0002" .0002" = .001"
.001" = .0005" .0005" = .0002" .0002" = .0001"	.001" = .0005" .0005" = .0002" .0002" = .001"
.001" = .0005" .0005" = .0002" .002" = .0001"	.0001" = .0005" .005" = .0002" .002" = .001"



MITSUBISHI CONTROL PANEL

THE PROGRAM PARAMETERS ARE TO THE RIGHT OF THE DOT,
AND THE SETTINGS ARE TO THE LEFT OF THE DOT.
TO ADVANCE THROUGH THE PROGRAM PARAMETERS, PRESS **▶** OR **▶**
TO CHANGE THE SETTINGS, PRESS **◀**
FOR ANY NUMERICAL SETTINGS, PRESS THE KEY BELOW THE NUMBER TO BE SET.

EDIT PROGRAM AS FOLLOWS USING DIRECT CALL FEATURE

DIRECT CALL NUMBER	FUNCTION NAME	FUNCTION SETTING
0000	R000	R2000
0001	L000	L2250
0005	R100	R1600
0070	L400	L4500
0081	L500	L5250
0421	0200	02451
0520	CP00	CP000
0521	CP00	CP010
0522	CP00	CP000
1501	S990	S9500
1503	S750	S7005
1506	S700	S7000
1579	E770	E7700
1520	E720	E7200

MITSUBISHI PROGRAM
TO SAVE THE PROGRAM TO ANY NEW SETTINGS,
THEN TURN THE POWER ON WHILE PRESSING **▶**
THEN PRESS **▶** UNTIL THE DISPLAY FLASHES **▶▶▶▶**
THEN PRESS **▶** UNTIL THE DISPLAY READS **▶▶▶▶** THEN PRESS **▶**
TO RESET THE PROGRAM TO THE DEFAULT SETTINGS, TURN THE POWER OFF.
PRESS AND HOLD **▶▶** UNTIL THE DISPLAY STOPS FLASHING.
PRESS AND HOLD **▶▶** UNTIL THE DISPLAY STOPS FLASHING.

ALL WORKS TO BE DONE IN ACCORDANCE WITH THE MITSUBISHI CONTROL PANEL INSTRUCTIONS. TOLERANCES UNLESS OTHERWISE SPECIFIED.

AX ±0.007	AX ±0.010	AX ±0.005	AX ±0.002
AX ±0.005	AX ±0.008	AX ±0.005	AX ±0.002
AX ±0.005	AX ±0.008	AX ±0.005	AX ±0.002

PORTER INTERNATIONAL
CORPORATION
10000 W. 10TH AVE.
DENVER, CO 80201
CMM-43

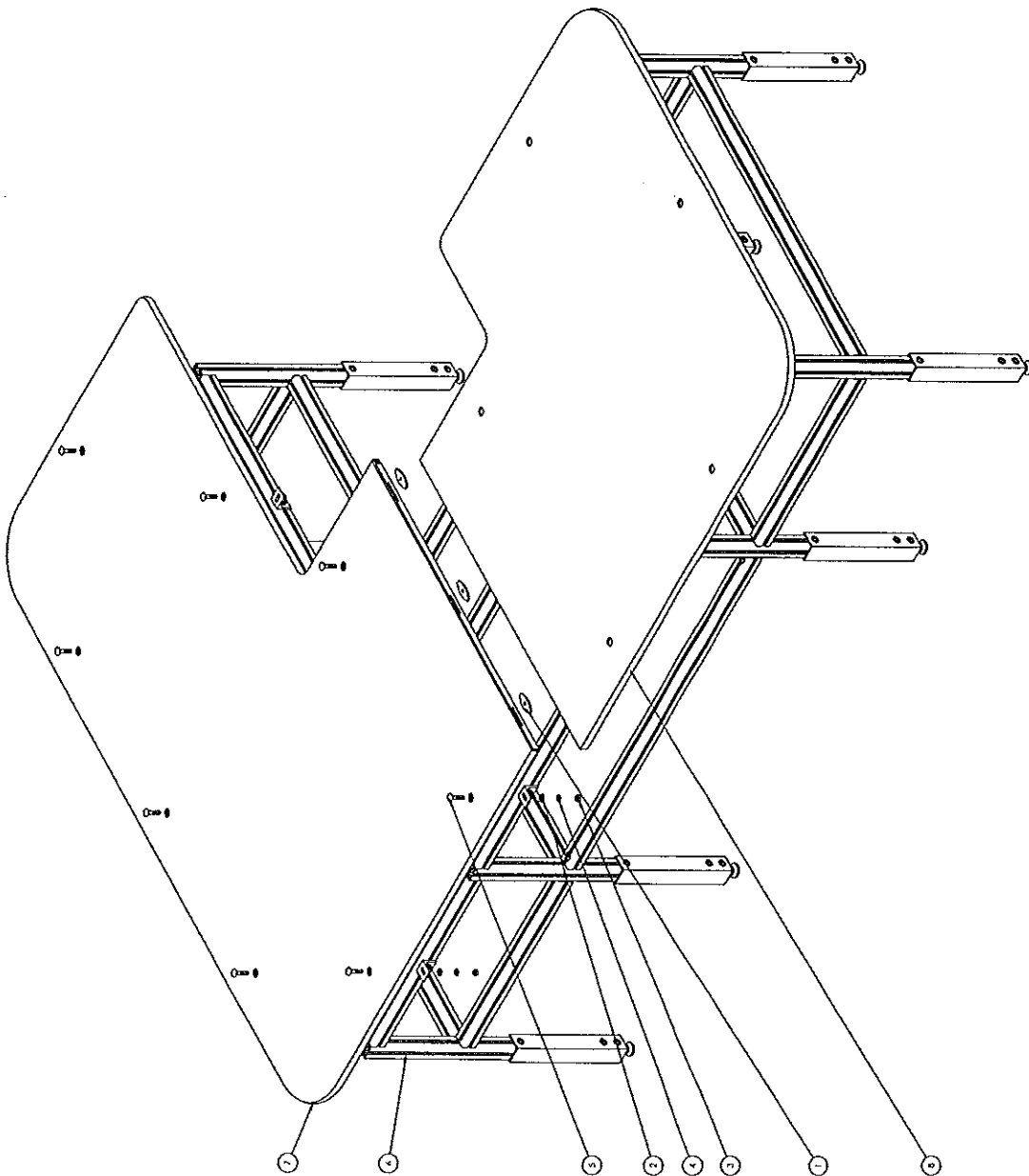
REVISIONS
REV. 1
DATE 1/20/77

WORK CENTER
MACHINING CENTER 4

DATE
1/20/77

BY
D

FIG. NO.
67844

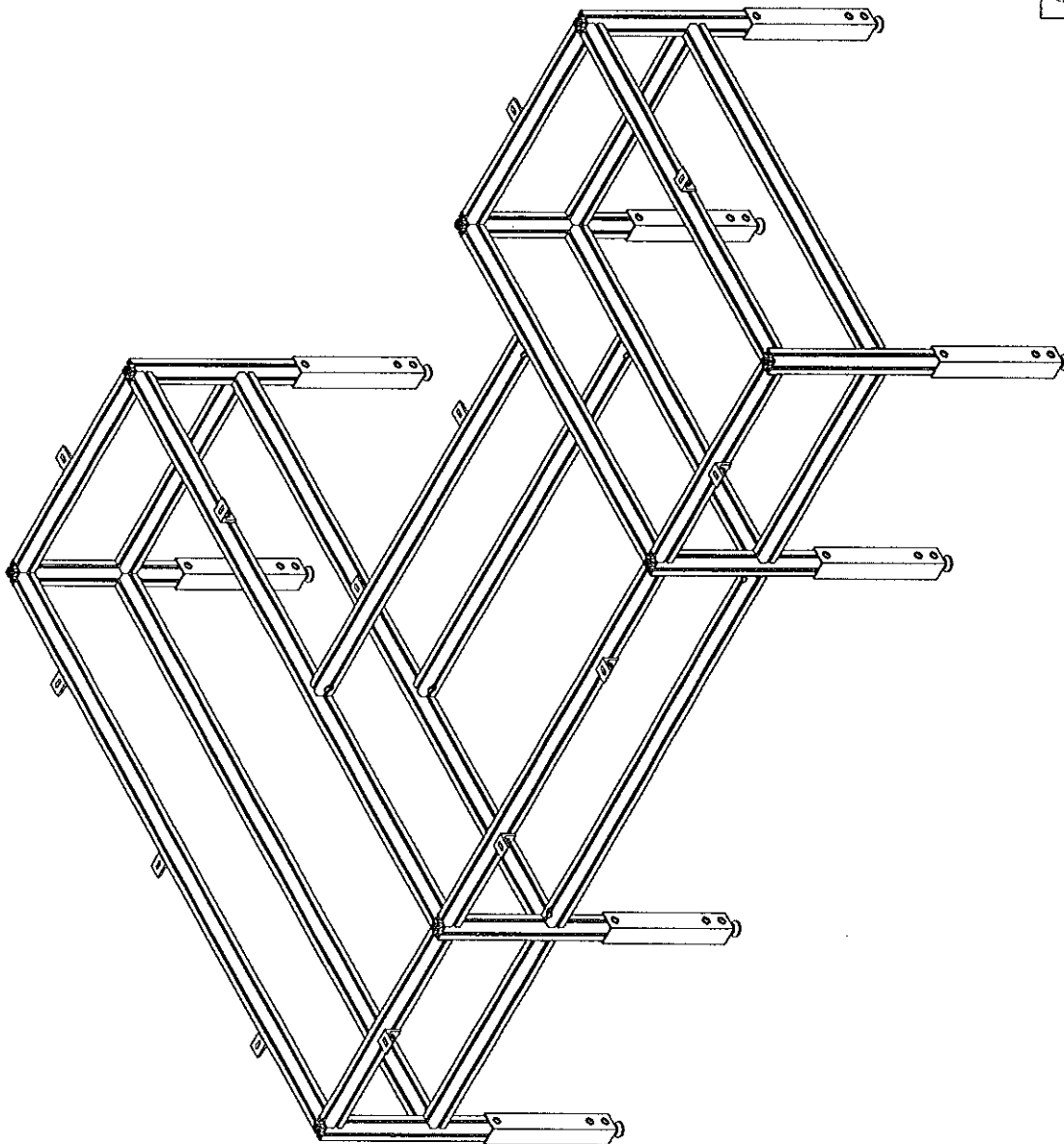


ITEM NO.	DESCRIPTION	QTY.
1	PANEL TOP	1
2	PANEL LEG	1
3	STATIC TABLE FRAME	1
4	ROTT. CARBON 3/16" DIA. 1 1/2"	13
5	ROTT. CARBON 3/16"	13
6	ROTT. CARBON 3/16"	13
7	WASHER 1/4" DIA. 3/16"	13
8	ROTT. CARBON 3/16"	13

ITEM NO.	DESCRIPTION	QTY.
1	STATIC TABLE ASY	1

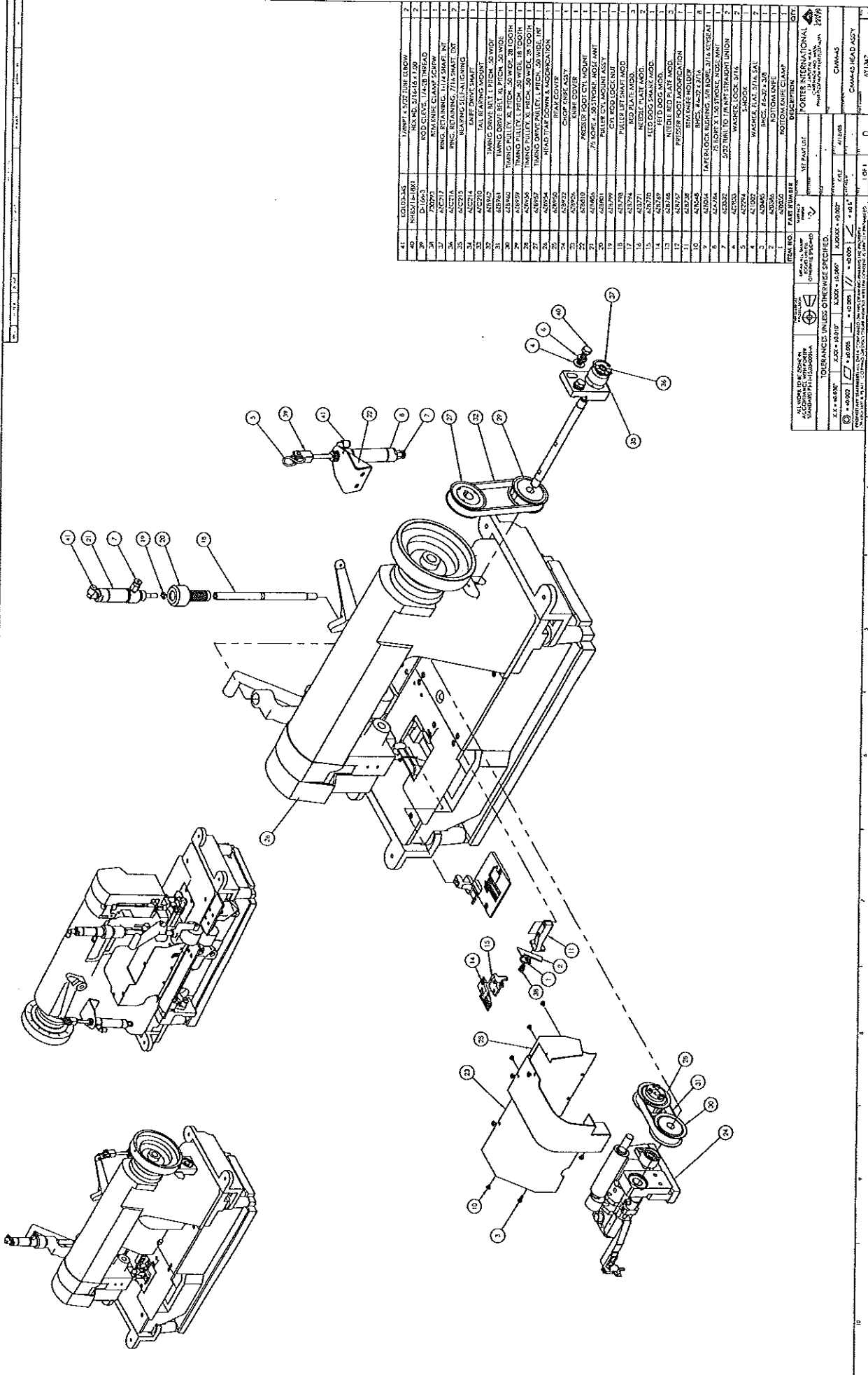
ITEM NO.	DESCRIPTION	QTY.
1	STATIC TABLE ASY	1

ITEM NO.	DESCRIPTION	QTY.
1	STATIC TABLE ASY	1

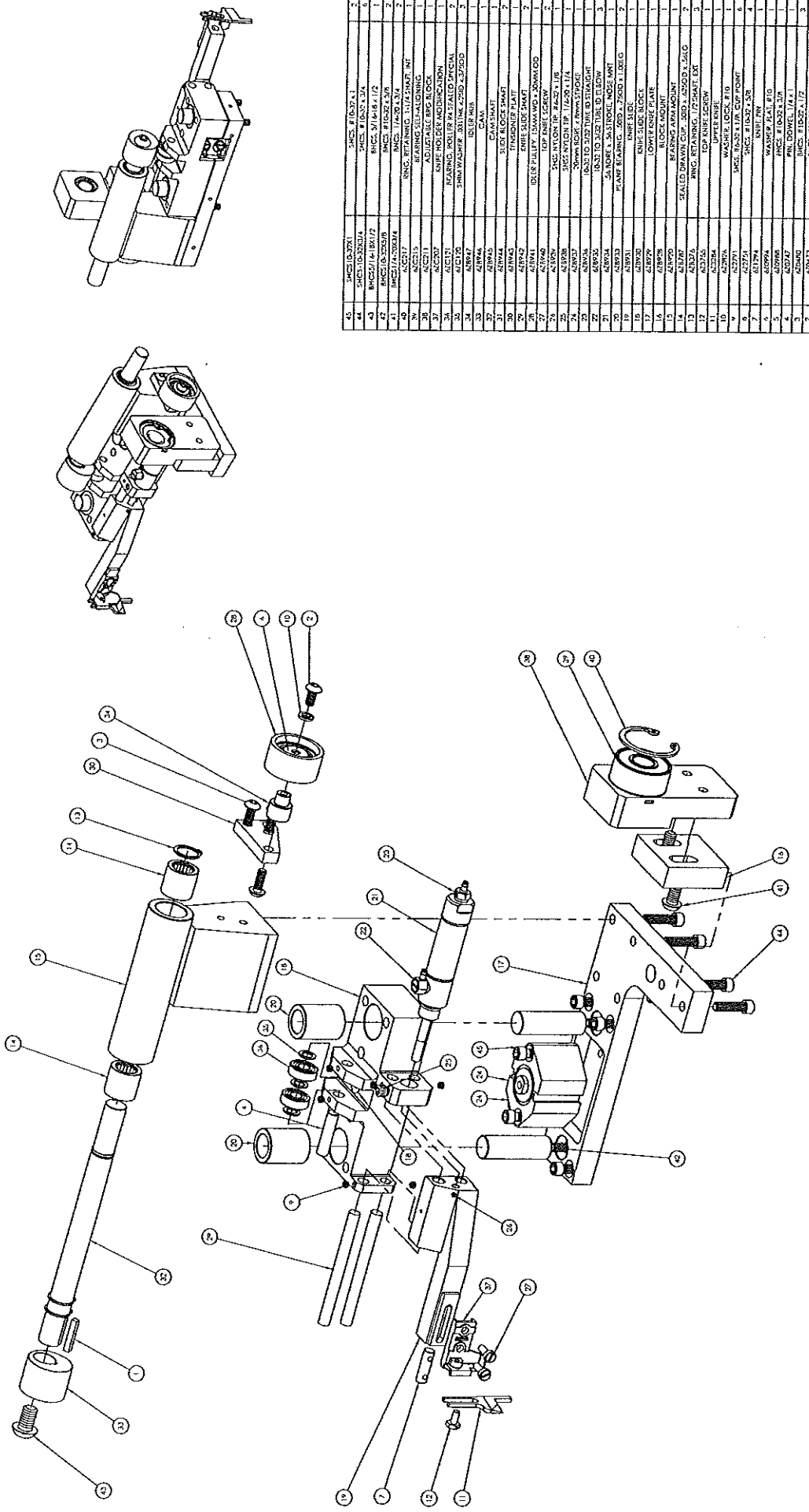


NOTE: THIS ASSEMBLY IS PURCHASED AS A COMPLETE UNIT.

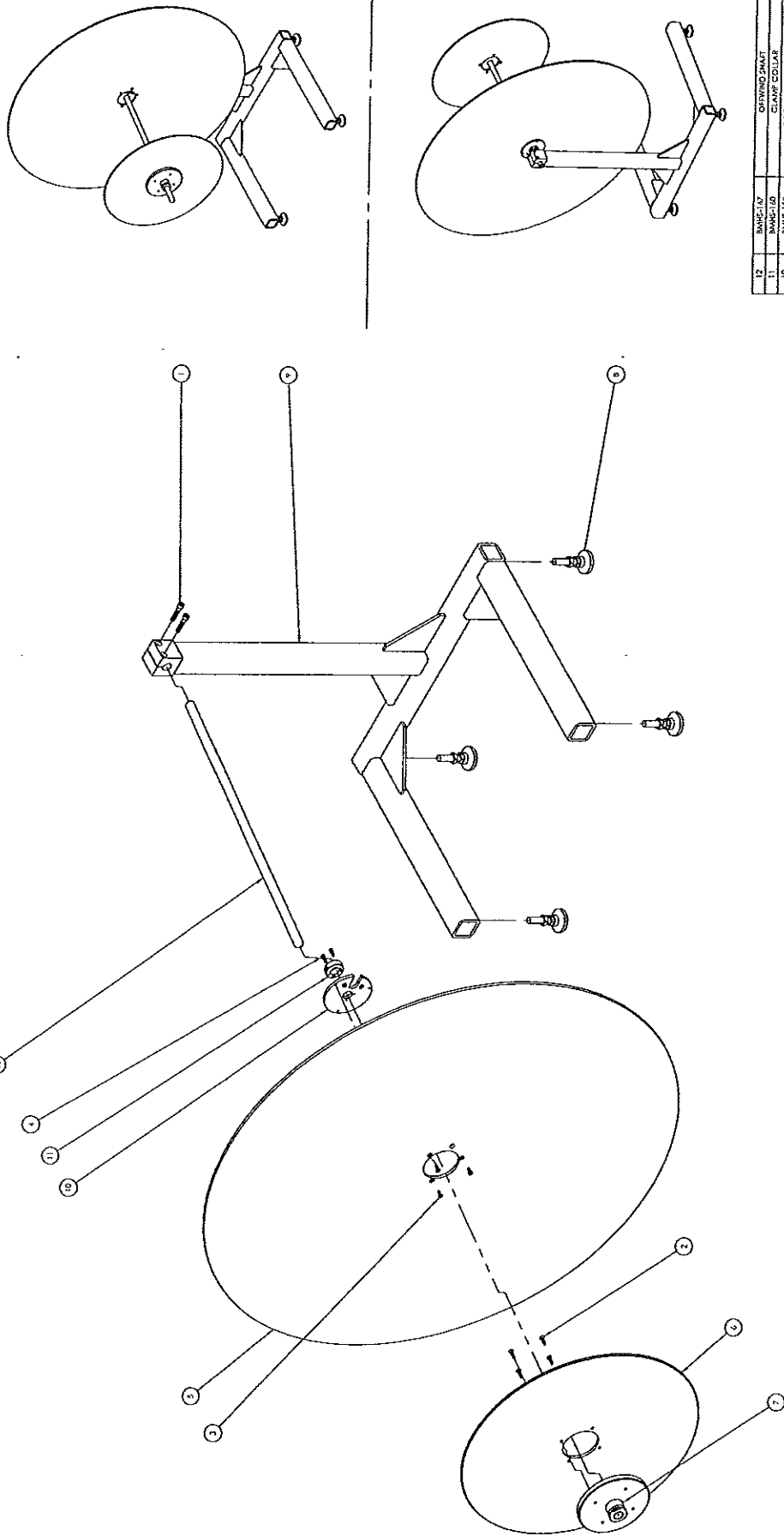
AN AMERICAN SOCIETY OF MECHANICAL ENGINEERS 220 N. 4TH ST. NEW YORK, N.Y. 10010 1-800-486-8989	PORTER INTERNATIONAL 1000 W. 15TH ST. SUITE 200 DENVER, CO 80202	MODEL NO. 1000 SERIAL NO. 1000	DATE: 10/1/80	DRAWN BY: J.M.	CHECKED BY: J.M.	APPROVED BY: J.M.	PART NO. 1000	QUANTITY 1	UNIT OF MEASURE 1	MATERIAL 1000	FINISH 1000	TOLERANCES UNLESS OTHERWISE SPECIFIED: FRACTIONS DECIMALS ANGLES 1/16" ± .005 0.005" ± .002 1/16° ± .1°	PORTER INTERNATIONAL 1000 W. 15TH ST. SUITE 200 DENVER, CO 80202	PORTER INTERNATIONAL 1000 W. 15TH ST. SUITE 200 DENVER, CO 80202
--	--	-----------------------------------	---------------	----------------	------------------	-------------------	---------------	------------	-------------------	---------------	-------------	---	--	--



QTY	ITEM NO.	PART NUMBER	DESCRIPTION	CITY
1	41	11011-1-100	1/8" DIA. X 3/16" LONG PIN	
2	42	M10X1.5-1.0	M10X1.5-1.0	
1	43	D-1000	NO. 10 DRUM	
1	44	1000	NO. 10 DRUM	
1	45	1000	NO. 10 DRUM	
1	46	1000	NO. 10 DRUM	
1	47	1000	NO. 10 DRUM	
1	48	1000	NO. 10 DRUM	
1	49	1000	NO. 10 DRUM	
1	50	1000	NO. 10 DRUM	
1	51	1000	NO. 10 DRUM	
1	52	1000	NO. 10 DRUM	
1	53	1000	NO. 10 DRUM	
1	54	1000	NO. 10 DRUM	
1	55	1000	NO. 10 DRUM	
1	56	1000	NO. 10 DRUM	
1	57	1000	NO. 10 DRUM	
1	58	1000	NO. 10 DRUM	
1	59	1000	NO. 10 DRUM	
1	60	1000	NO. 10 DRUM	
1	61	1000	NO. 10 DRUM	
1	62	1000	NO. 10 DRUM	
1	63	1000	NO. 10 DRUM	
1	64	1000	NO. 10 DRUM	
1	65	1000	NO. 10 DRUM	
1	66	1000	NO. 10 DRUM	
1	67	1000	NO. 10 DRUM	
1	68	1000	NO. 10 DRUM	
1	69	1000	NO. 10 DRUM	
1	70	1000	NO. 10 DRUM	
1	71	1000	NO. 10 DRUM	
1	72	1000	NO. 10 DRUM	
1	73	1000	NO. 10 DRUM	
1	74	1000	NO. 10 DRUM	
1	75	1000	NO. 10 DRUM	
1	76	1000	NO. 10 DRUM	
1	77	1000	NO. 10 DRUM	
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1	79	1000	NO. 10 DRUM	
1	80	1000	NO. 10 DRUM	
1	81	1000	NO. 10 DRUM	
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1	83	1000	NO. 10 DRUM	
1	84	1000	NO. 10 DRUM	
1	85	1000	NO. 10 DRUM	
1	86	1000	NO. 10 DRUM	
1	87	1000	NO. 10 DRUM	
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1	91	1000	NO. 10 DRUM	
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1	93	1000	NO. 10 DRUM	
1	94	1000	NO. 10 DRUM	
1	95	1000	NO. 10 DRUM	
1	96	1000	NO. 10 DRUM	
1	97	1000	NO. 10 DRUM	
1	98	1000	NO. 10 DRUM	
1	99	1000	NO. 10 DRUM	
1	100	1000	NO. 10 DRUM	



NO.	PART NUMBER	DESCRIPTION	QTY
1	8102000	RECYCLED 3/1620 X 3/16 LG	1
2	8102000	RECYCLED 3/1620 X 3/16 LG	1
3	8102000	RECYCLED 3/1620 X 3/16 LG	1
4	8102000	RECYCLED 3/1620 X 3/16 LG	1
5	8102000	RECYCLED 3/1620 X 3/16 LG	1
6	8102000	RECYCLED 3/1620 X 3/16 LG	1
7	8102000	RECYCLED 3/1620 X 3/16 LG	1
8	8102000	RECYCLED 3/1620 X 3/16 LG	1
9	8102000	RECYCLED 3/1620 X 3/16 LG	1
10	8102000	RECYCLED 3/1620 X 3/16 LG	1
11	8102000	RECYCLED 3/1620 X 3/16 LG	1
12	8102000	RECYCLED 3/1620 X 3/16 LG	1
13	8102000	RECYCLED 3/1620 X 3/16 LG	1
14	8102000	RECYCLED 3/1620 X 3/16 LG	1
15	8102000	RECYCLED 3/1620 X 3/16 LG	1
16	8102000	RECYCLED 3/1620 X 3/16 LG	1
17	8102000	RECYCLED 3/1620 X 3/16 LG	1
18	8102000	RECYCLED 3/1620 X 3/16 LG	1
19	8102000	RECYCLED 3/1620 X 3/16 LG	1
20	8102000	RECYCLED 3/1620 X 3/16 LG	1
21	8102000	RECYCLED 3/1620 X 3/16 LG	1
22	8102000	RECYCLED 3/1620 X 3/16 LG	1
23	8102000	RECYCLED 3/1620 X 3/16 LG	1
24	8102000	RECYCLED 3/1620 X 3/16 LG	1
25	8102000	RECYCLED 3/1620 X 3/16 LG	1
26	8102000	RECYCLED 3/1620 X 3/16 LG	1
27	8102000	RECYCLED 3/1620 X 3/16 LG	1
28	8102000	RECYCLED 3/1620 X 3/16 LG	1
29	8102000	RECYCLED 3/1620 X 3/16 LG	1
30	8102000	RECYCLED 3/1620 X 3/16 LG	1
31	8102000	RECYCLED 3/1620 X 3/16 LG	1
32	8102000	RECYCLED 3/1620 X 3/16 LG	1
33	8102000	RECYCLED 3/1620 X 3/16 LG	1
34	8102000	RECYCLED 3/1620 X 3/16 LG	1
35	8102000	RECYCLED 3/1620 X 3/16 LG	1
36	8102000	RECYCLED 3/1620 X 3/16 LG	1
37	8102000	RECYCLED 3/1620 X 3/16 LG	1
38	8102000	RECYCLED 3/1620 X 3/16 LG	1
39	8102000	RECYCLED 3/1620 X 3/16 LG	1
40	8102000	RECYCLED 3/1620 X 3/16 LG	1
41	8102000	RECYCLED 3/1620 X 3/16 LG	1
42	8102000	RECYCLED 3/1620 X 3/16 LG	1
43	8102000	RECYCLED 3/1620 X 3/16 LG	1
44	8102000	RECYCLED 3/1620 X 3/16 LG	1



QTY.	DESCRIPTION	REF. PART LIST	UNIT
1	DRIVING SHAFT	12	1
1	CLAMP COLLAR	11	1
1	DISC MOUNTING PLATE	10	1
1	MATERIAL PIVOTS STAND	9	1
4	1/2-13 LEVELING FOOT	8	4
1	MATERIAL CUP ASST	7	1
1	DISC MATERIAL COUPLER 20" DIA.	6	1
1	DISC MATERIAL COUPLER 18" DIA.	5	1
2	SHCS. #10-32 x 1 1/2	4	2
2	SHCS. #10-32 x 1 1/4	3	2
2	SHCS. #10-32 x 1 1/2	2	2
2	SHCS. #10-32 x 1 1/2	1	2
2	DISC MOUNTING PLATE	10	2
2	DRIVING SHAFT	12	2
2	CLAMP COLLAR	11	2
2	DISC MOUNTING PLATE	10	2
2	MATERIAL PIVOTS STAND	9	2
2	1/2-13 LEVELING FOOT	8	2
2	MATERIAL CUP ASST	7	2
2	DISC MATERIAL COUPLER 20" DIA.	6	2
2	DISC MATERIAL COUPLER 18" DIA.	5	2
2	SHCS. #10-32 x 1 1/2	4	2
2	SHCS. #10-32 x 1 1/4	3	2
2	SHCS. #10-32 x 1 1/2	2	2
2	SHCS. #10-32 x 1 1/2	1	2

MATERIAL		PORTER INTERNATIONAL	
SYMBOL	DESCRIPTION	SYMBOL	DESCRIPTION
	STEEL		STEEL
	ALUMINUM		ALUMINUM
	COPPER		COPPER
	BRASS		BRASS
	INCONEL		INCONEL
	TITANIUM		TITANIUM
	OTHER		OTHER