

General characteristics

Operating fluid

- Compressed air or inert gas

Conditions of use

- Operating pressure 30 to 120 PSI (2 to 8 bars).
- Fluid: Filtered air to 50 microns - non lubricated.
- Operating temperature from 20 to 120° F (-5 to 50° C) under 20° F (5° C) the dew point must be below 5° F (10° C) for the application).
- For optimum performance, the elements should be inter-connected by air supply tubing with an internal diameter of ≥ 0.106 " (25mm).

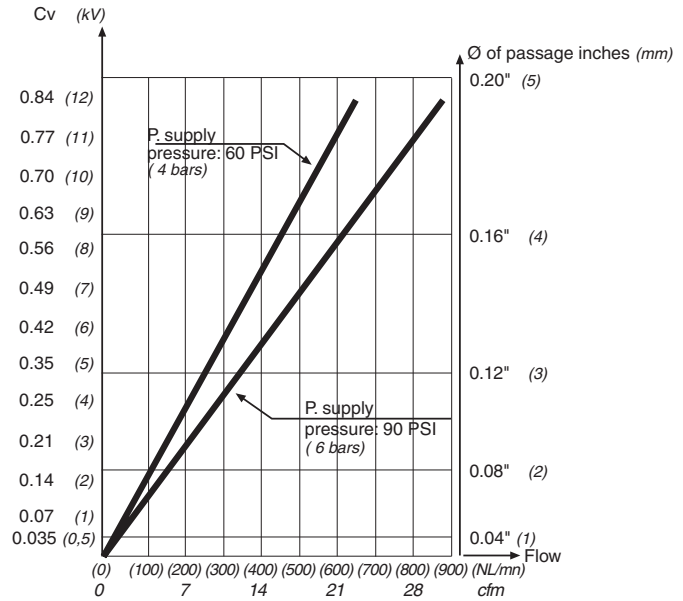
Mounting recommendations

- The elements should be mounted and piped in a clean atmosphere in order to prevent any form of pollution entering the system.
- Minimum torque for element fixing screws: 16"oz (5 cm/kg).
- Maximum torque for element fixing screws: 32"oz (10 cm/kg).

Characteristics common to all elements in the modular system.

- The characteristics have been obtained with a supply pressure at 90 psi (6 bars).
- The flow in cfm (NL/min) is the number of cubic feet (litres) of air at normal atmospheric pressure obtained with the output open to atmosphere and the supply pressure at 60 psi (4 bars).
- The consumption in cfm (NL/min) is the number of cubic feet (litres) of free air necessary for the unit to function.
- Cv (kV) = the flow coefficient of the equipment.
- Mechanical life 10 million and greater.

Flow graphs

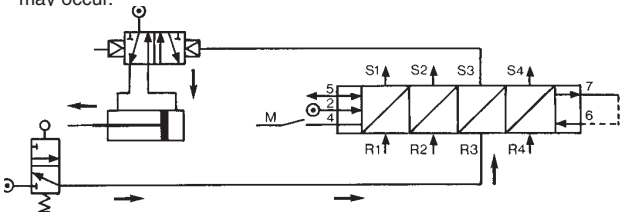


PAC Modules

The principle is to ensure the step by step operation of a sequential cycle.

A system comprises of individual modules which are joined together by means of a sub-base. Each module has a memory which delivers an output signal and receives an input signal.

An indicator on each module allows the operator to monitor the progress of the cycle and identify quickly and easily any faults which may occur.



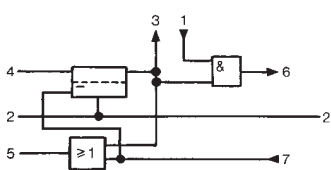
Operation results from the combination of three functions (memory, AND and OR) which constitute each module.

The memory activates the output and gives priority to the reset signal.

The AND element ensures the transition to the next module but only if an input signal is present.

The OR element ensures the resetting of all previously operated modules.

Function diagram

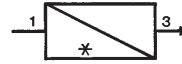
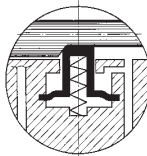


Sequencer module with maintained reset

Brake

This maintains the memory spool in position only when the supply is lost.

Module with auto reset



Brake

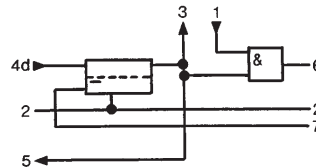
This returns the memory spool to the reset condition only when the supply is lost.

Shift register modules

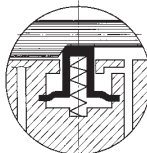
The general principle is to advance the sequencer step by step by command impulses to the inputs of the even steps, alternating with the command impulses to the inputs of the odd steps.

Used for example on a transfer machine to shift the information "bad component" collected at a test-station 'n' steps further along the machine to a reject station.

Function diagram



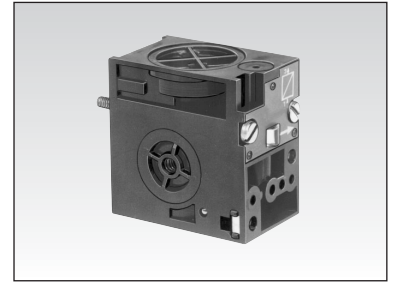
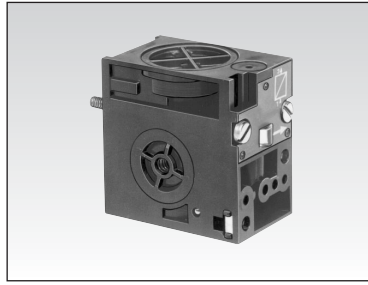
Auto reset sequencer module



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Sequencer modules

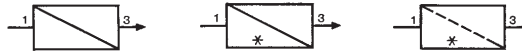


Part numbers

	81 550 001	81 550 201	81 550 601
Versions	PAC sequencer shift register	maintained	Auto Reset
Symbol	—	—	Auto Reset

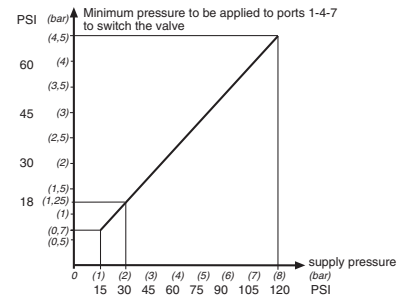
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Symbol



Characteristics

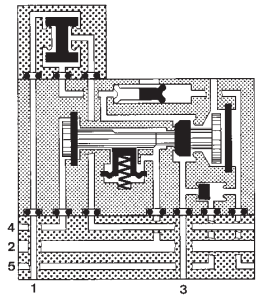
Operating pressure	psi (bar)	30 > 120 (2 > 8)	30 > 120 (2 > 8)	30 > 120 (2 > 8)
Orifice diameter	Inches (mm)	0.106" (2.7)	0.106" (2.7)	0.106" (2.7)
Flow at 90 PSI (6 bars)	cfm (Nl/min)	5.25 (150)	5.25 (150)	5.25 (150)
Connection - sub-base page 5/44 - 5/45		●	●	●
Weight	grams	(70)	(70)	(70)



Principle of operation

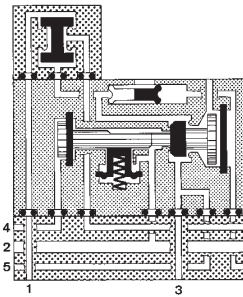
(supplied without logic element. For choice of units see page 5/36 - 5/37 - 5/39 - 5/40 - 5/42)

Programmable Air Controller (PAC) module with maintained reset



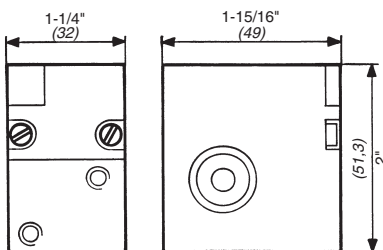
- 1 - Input signal
- 2 - Supply
- 3 - Output signal
- 4 - Start signal
- 5 - In cycle signal
- 6 - End of cycle signal
- 7 - Reset to zero signal

Shift register with maintained reset

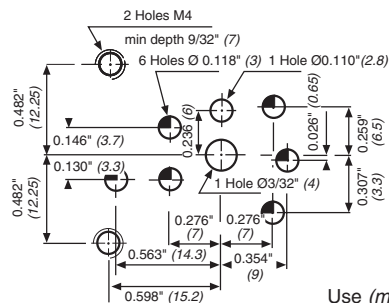


- 1 - Input signal
- 2 - Supply
- 3 - Port plugged
- 4 - Input signal
- 5 - Port plugged
- 6 - Output signal
- 7 - Reset to zero signal

Dimensions



Mounting plan for sequencer



Use (metric) dimensions for critical data.

Other information	To order, specify :				
	<table border="1"> <tr> <td>Standard products</td> <td>1 Part number</td> </tr> <tr> <td>Standard products, non stocked</td> <td>Example : Sequencer modules 81 550 001</td> </tr> </table>	Standard products	1 Part number	Standard products, non stocked	Example : Sequencer modules 81 550 001
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