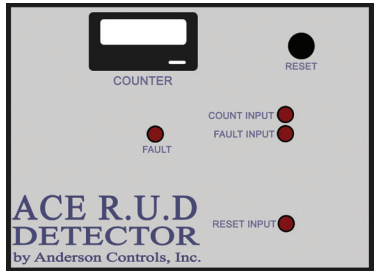
OPERATION OF THE ACE R.U.D.

To operate the ACE R.U.D. unit you will need to make some adjustments from time to time. First the unit will turn on once the power to the machine is turned on. You will need to reset the parts counter, by pressing the reset button on the counter, this is not the reset button on the ACE R.U.D. unit itself. You will need to adjust the counting probe by moving it up or down so that the counter changes for every part that goes past the dies. The second probe, the fault input will need to be set just above the part but **NOT** touching the part as it goes by. If the fault input gets hit the machine will **STOP**.

As the machine runs the parts counter will increase by one count with every part that passes and hits the count probe. When the Fault probe is hit the ACE R.U.D. by a part the machine will **STOP**, or both relays will turn on.

Press the reset button on the ACE R.U.D., fix the problem that caused the run up or bad part, start the machine and make parts. When a bad part is made again the ACE R.U.D. will stop again.

Testing the unit by using a metal pointer such as a screw driver, and touch the counter probe to the metal part of the machine. The counter will change or increase. Also do the same to the fault input, the relays will stop the machine or turn on the relays. As you look at the front panel you will see 4 lights, (see fig. 3). When the count probe is shorted to the machine, the count light on the front panel will light, when the reset is pressed the reset light will light, when the fault probe is shorted to the machine the fault light will turn on, and the same with the Fault light this will turn on when the machine |sees a run up.



(fig. 3)

ACE R.U.D.

INSTALLATION & OPERATORS GUIDE

The ACE R.U.D. is designed with simplicity in mind by placing 2 spring probes above the rolling part as it moves above the die. If the first probe is hit the **ACE R.U.D.** will increase the parts counter by 1 count, and the second probe should not be hit unless there is a run up or bad blank. When the second probe is hit by a run up or bad part the **ACE R.U.D.** will engage to relays in the **ACE R.U.D.** and stopping the machine, turning on a light, or diverting the bad part.

- SIMPLE
- OPERATOR FRIENDLY
- EASY INSTALLATION
- RELIABLE

Anderson Controls, Inc.

Innovative solutions for Quality Control!

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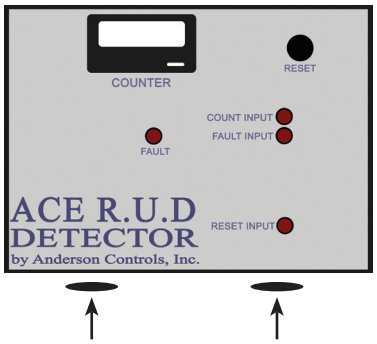
MOUNTING THE CONTROL BOX.

To mount the ACE R.U.D. Control Box you will need to remove the back cover. There is a screw on the bottom of the back of the box, do not remove it, just loosen. You may want to mount the control box near to the machine control panel, and the operator's control station. There are 2 holes on the bottom of the control box, **DO NOT BLOCK** these holes. You can mount the box from the sides (fig. 1), top, or back cover. The holes on the bottom are used for probe hookup, relay output and power input. (see fig. 1)



(fig. 1)

Holes in the bottom used for electrical connections, and probe

MOUNTING THE PROBES.

The probes will need to be mounted above the moving dies on the roller. The first probe will count the part and the second will check for the run up of a bad part. The first probe wire on the probe will need to be **GREEN** for good part, the second probe will be **RED** for bad part. The **BLACK** wire will be used for ground.

Note you might need to move the green and red wire to keep the green wire for the counts and the red wire for the fault, or bad parts. Green wire probe must be hit first by the parts as they are rolled.

To mount the probe fixture you will need to drill and tap a 1/4" x 20 threaded hole to mount the pin that holds the probe fixture. You might need to make a bracket to mount the probe fixture. (See fig. 1)

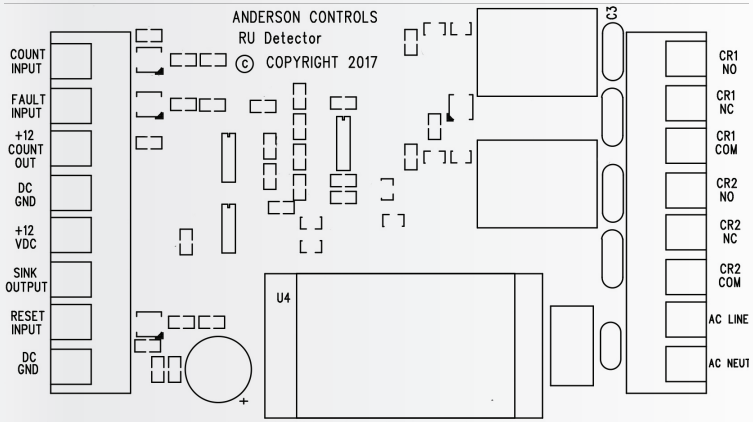
WIRING THE CONTROL BOX.

Once you have mounted the probe fixture and the Control Box you will need to wire the Control Box to the electrical system of your machine. You can see on the lower right hand side of the print (fig. 2) that you will need to supply 120 volts AC to the ACE R.U.D. unit. On the same terminal strip you have 2 relays, both are single pull double through. This means that you can turn off some thing or turn on something. Check your local electrical code for information on wiring.

You will need to also connect the probe fixture to this board. The **GREEN** wire will need to be connected to the count input, the **RED** wire will need to be connected to the fault input, and the **BLACK** wire will need to be connected to the ground.

(fig. 2)

To Probes on Roller



TECHNICAL SUPPORT

If you need additional information connecting the ACE R.U.D., or have questions, please call Anderson Controls, Inc at 1-800-835-0391 or e-mail us at service@andersoncontrolsinc.com.