



BLOCK MACHINE TUBE AND RELAY TO PLC CONVERSION

For Pit Model Machines

This conversion is a direct replacement for your older Columbia Block Machine tube and relay control panels. It will update your block machine controls with state-of-the-art Allen Bradley Controls.

This new system **increases product quality** by improving the operator's ability to fine tune all stages of the machine cycle. The operator will now have access to many additional timers and counters not available with relay controls. The new system also provides new functions such as double start, pallet bypass, and a slump mode. It allows the operator to monitor variables such as pallet count, actual compression time, time in auto and last cycle time.



(existing control unit)



(new Allen Bradley Conversion with PV400+)

The **safety features** of the new system include a six-second delay before the block cycle starts when the machine is put in automatic mode. Outputs for a warning horn and beacon are enabled when the automatic mode has been selected.

Ease of installation allows replacement time for most customers to be less than two days.

While this conversion kit is ready to install and use immediately, Columbia Machine strongly recommends that your equipment be updated to current safety standards which may include: Warning decals, horns, beacons, and guarding with safety interlocks.

For more information on the benefits of our relay control conversions or safety features, please contact your local representative or call Columbia direct at (800) 628-4065.



(Typical PV400+ Screen)

Screens

- Main Menu
- Setup – Machine
- Setup – Options
- Setup – Hopper Probe
- Setup – Vibrator
- Setup – Oscillations
- Production Data

Benefits

- More Production
- Saves Money
- Able to Produce greater diversity of products.
- Better Quality
- Safety Feature, 6 sec. startup Delay, warning horn & beacon

Kit Includes:

Machine Wiring Diagrams

Wire Schedule

Instruction manual

New Control Panel-consisting of;

Allen Bradley PLC

Power Supply

I/O Base

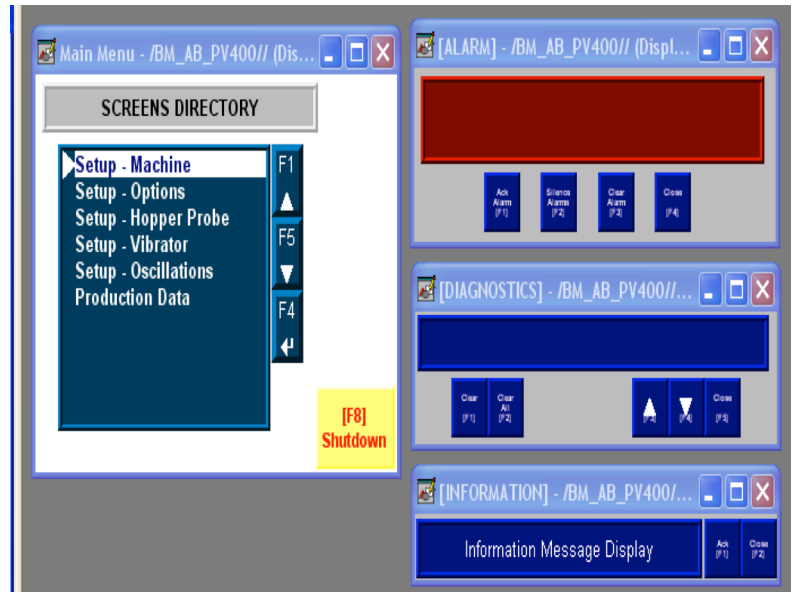
Required I/O modules

Cable, prewired to panel

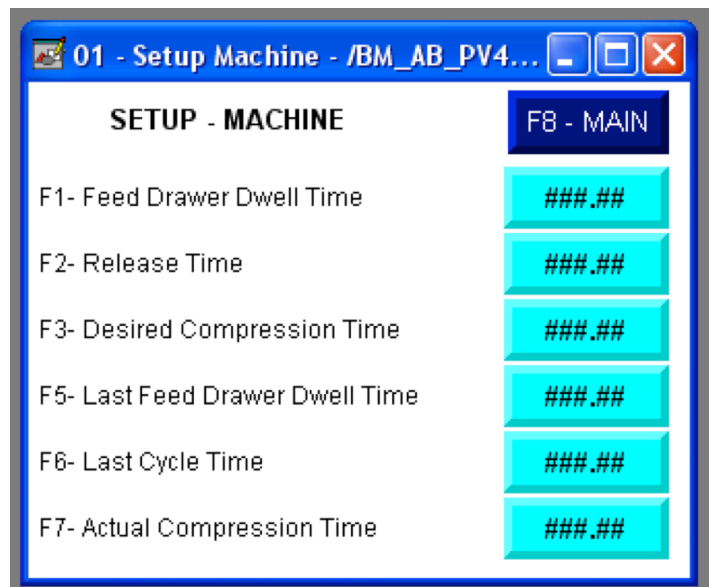
Operator Interface (PV400+

Warning Beacon and Horn

90vdc Brake Supply



(Main Menu, Screen)



(Setup – Machine, Screen)