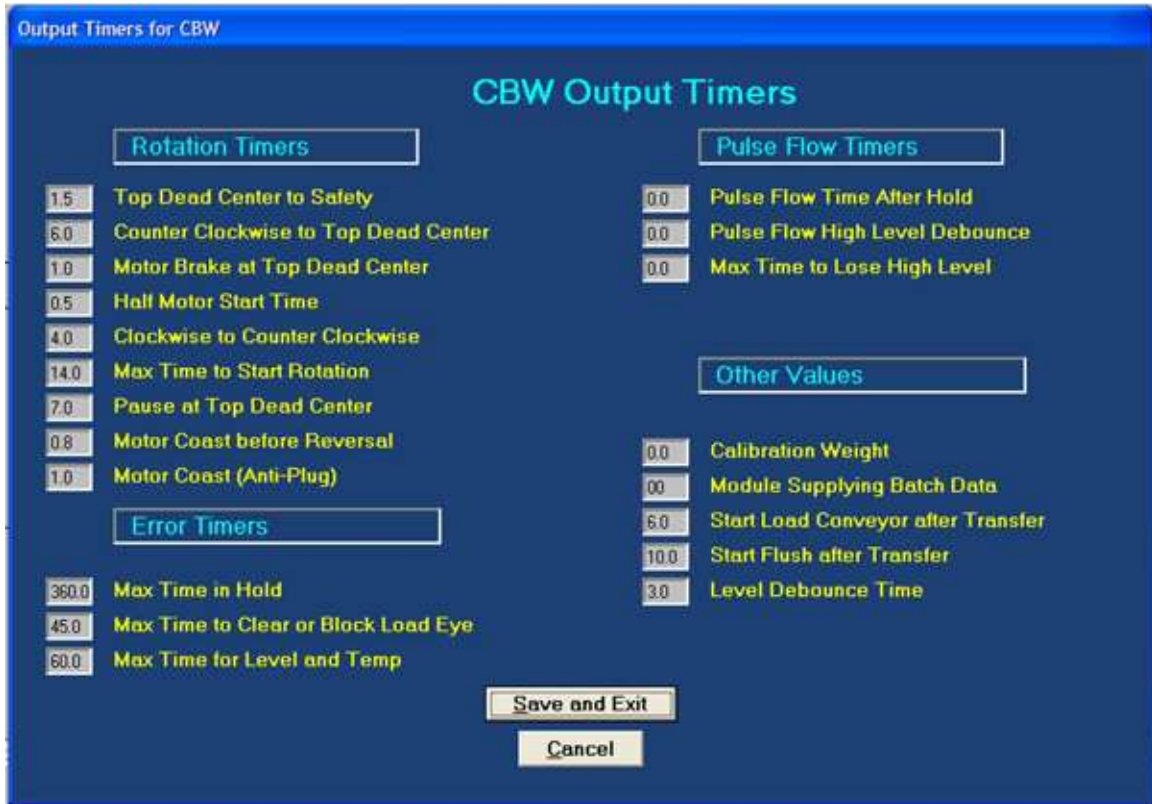


Figure 4: CBW Output Timers Page



2.1. Rotation Timers

2.1.7. **Pause at Top Dead Center**—This is the time, in tenths of a second, that the tunnel should pause at top dead center to allow the goods to slide down the transfer scoop to the next module or out of the tunnel.

Tip: If the tunnel discharges to a Milnor single station press, the tunnel must stay stationary until the bottom of the press diaphragm is below the top of the press can or until the press *Ram in Can* input is not made. Choosing a time less than this may allow water to splash out of the tunnel and cause a *Scoop Blocked* fault at the press. The sensors that detect goods on the press load scoop are monitored only while the *Ram in Can* input is present. The Mentor *Pause at Top Dead Center* timer must be long enough to pause the tunnel while the press load scoop sensors are being monitored. Start with a value of 70 tenths and adjust the value as necessary. **The ideal value is the total of the press *Loading Time* plus the time required for the press ram to descend until the diaphragm just enters the can.** The reference manual for the single station press describes the press *Loading Time* configure decision.