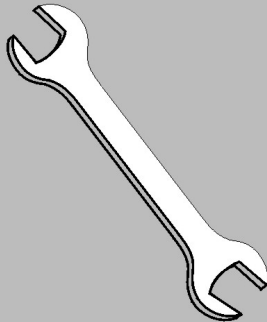


Published Manual Number/ECN: H000000008/2000413N

- Publishing System: TPAS
- Access date: 1/17/01
- Document ECN's: Exact



# Kit Instruction— KHA STM TF8J



# Please Read

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# ADD STEAM/30022F8J

## DIRECTIONS FOR ADDING STEAM TO 30022F8J MACHINES

- 1) Turn off power to machine.
- 2) Remove left side panel.
- 3) Remove the pipe plugs marked steam inlet and temp probe. See figure 3.
- 4) Install the steam piping assembly as shown in figures 1 & 2
- 5) Remove the processor board, and install the temperature board to the processor using the plastic nuts, bolts, and tubular shims provided. See figure 5 for this step.
- 6) Install the 10 pin plug marked MTA-9 to the processor board. On the other end is a 9 pin Molex plug. It should be inserted into the square hole in the left side of the processor compartment.
- 7) Install the ribbon cable from the processor board to the temperature board. The side of the ribbon cable with the dark stripe will line up with the pin 34 marking on the processor board. This will also be true on the temperature board.
- 8) Install the temp probe (see figures 3 & 5). Run wires up to processor compartment. Plug MTA-41 on to temperature board. Connect pins 1 & 2 to wires from temp probe.
- 9) Remove the 8 self-tapping screws from the right side of the rear control box. Mount the 6 output board and the snubber board using the plastic clips provided. The output board goes at the bottom and the snubber board at the top. (See figure 4)
- 10) Carefully plug in 2MTA-29, 2MTA30 and 2MTA-31 to the output board. Each plug of the harness will be marked to match the MTA's mentioned above.
- 11) There is a nine-pin Molex plug marked WCO in the upper right corner of the rear cabinet. Plug it into its mate coming from the output board.
- 12) Install TBX terminal block on the right side of TB1 using the screws provided. (See figure 4)
- 13) Make the following connections:

<u>WIRE</u>	<u>CONNECTION</u>
006	from 2MTA-1 pin 10 to TBX-8
TCD	2MTA-1 pin 4 to TBX-7
WVX	2MTA-1 pin 3 to TBX-5
DRR	2MTA-1 pin 2 to TBX-3
STM	2MTA-1 pin 1 to TBX-1
11B	2MTA-30 pin 1 to TBB2
11C	2MTA-31 pin 2 to TBB2
11D	2MTA-31 pin 5 to TBB2
11E	2MTA-31 pin 8 to TBB2

- 14) Install the 006 jumper with 5 connections as follows:  
TBX-8, 6, 4, 2, topside. The spade connector goes to TBB4.
- 15) Jumper 11A goes from TBD3 to TBB2.
- 16) Run the wires from the steam valve inside the rear control compartment. Connect the wires to TBX1 & 2.
- 17) Use cable ties to secure all wires neatly.
- 18) Turn on power. Reconfigure machine for temperature control and steam.
- 19) Test mutual outputs before running machine in automatic.
- 20) If you have any problems, check all connections before calling MILNOR Technical Support.

Rev.SDAD00413

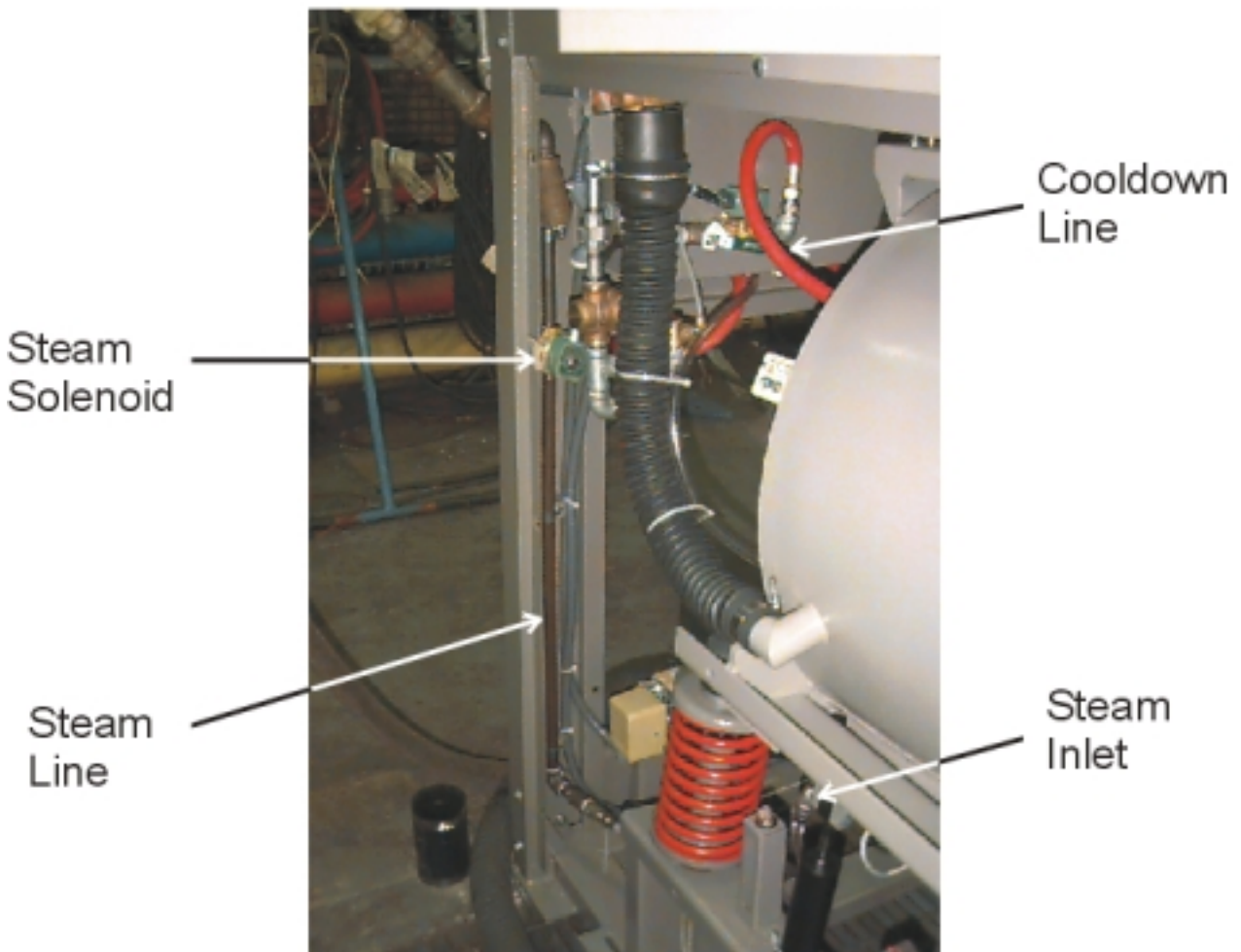
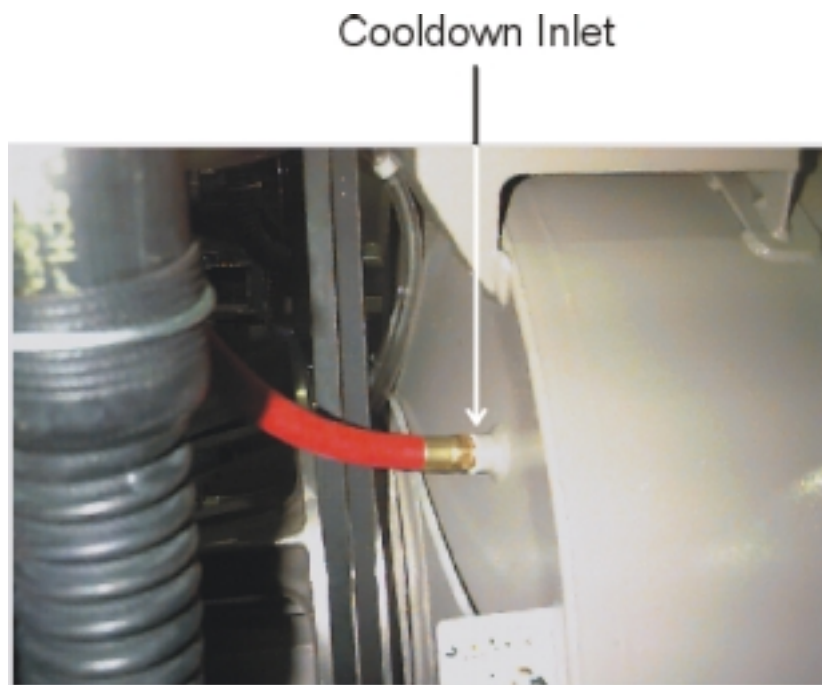


Figure 1



Figure 2



# Adding Steam to a 30022F8J

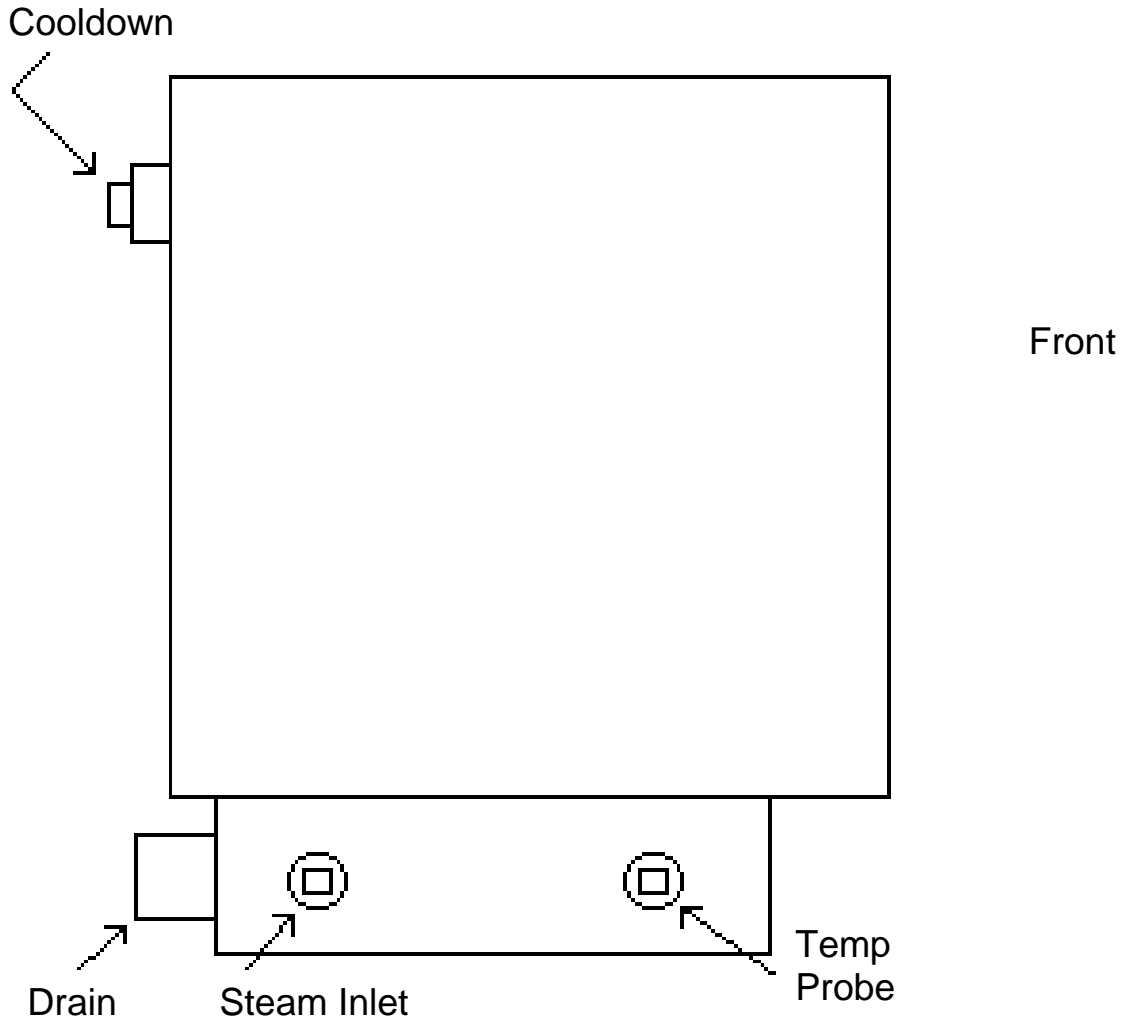
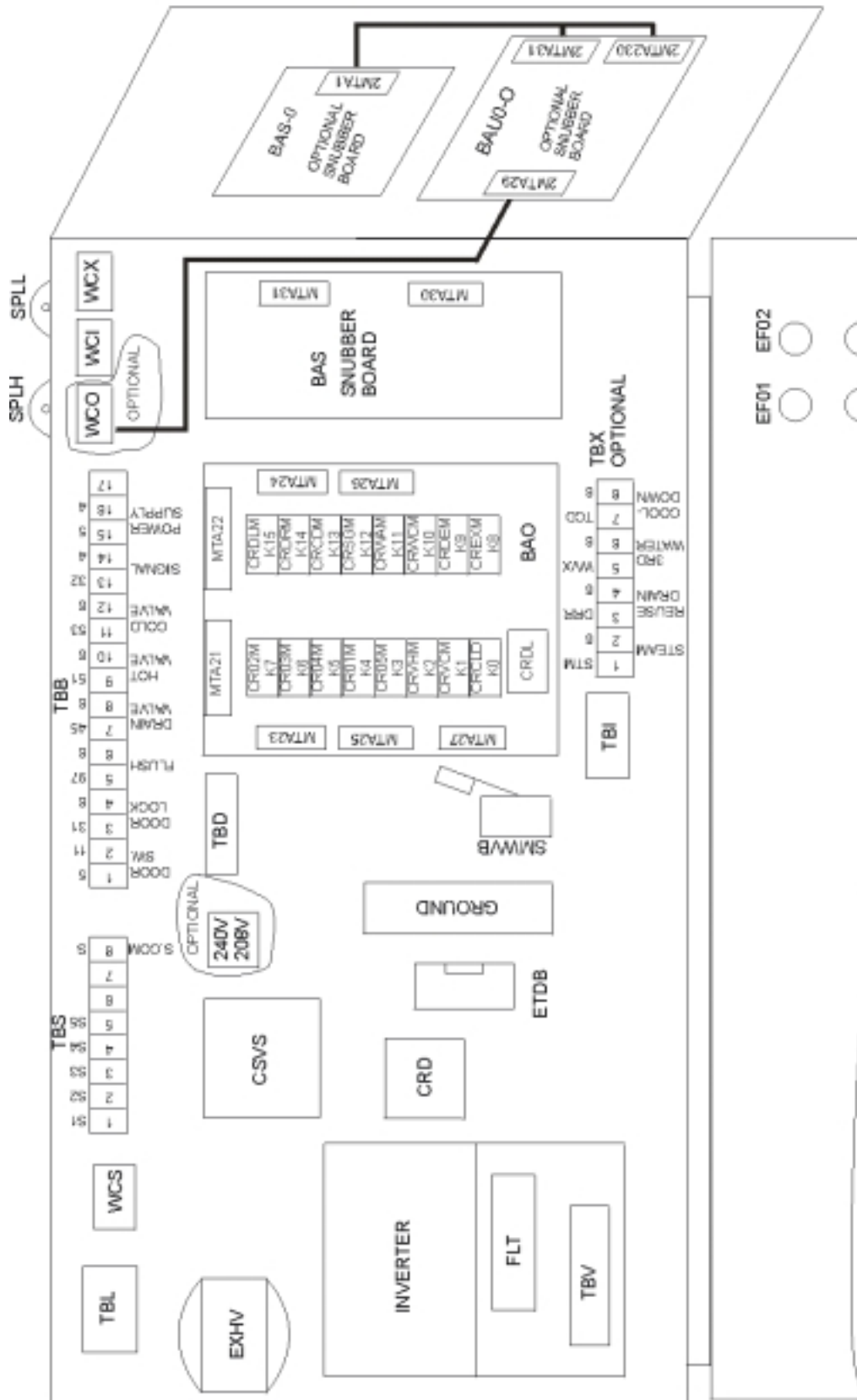


Figure 3



B2TAG93015  
86411G

# MICRO 7 SYSTEMS 30022 F8J CONTROL BOX

PELLERIN MILNOR CORPORATION

# Board layout for the new A/D board

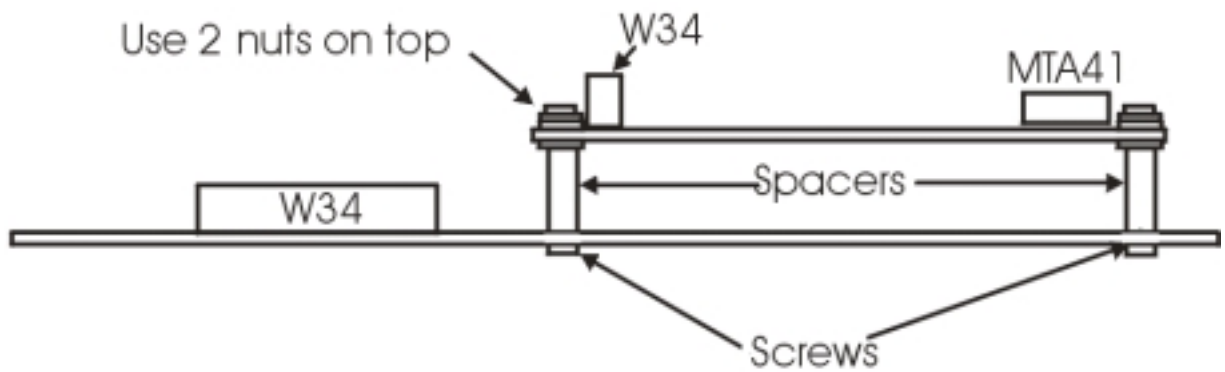
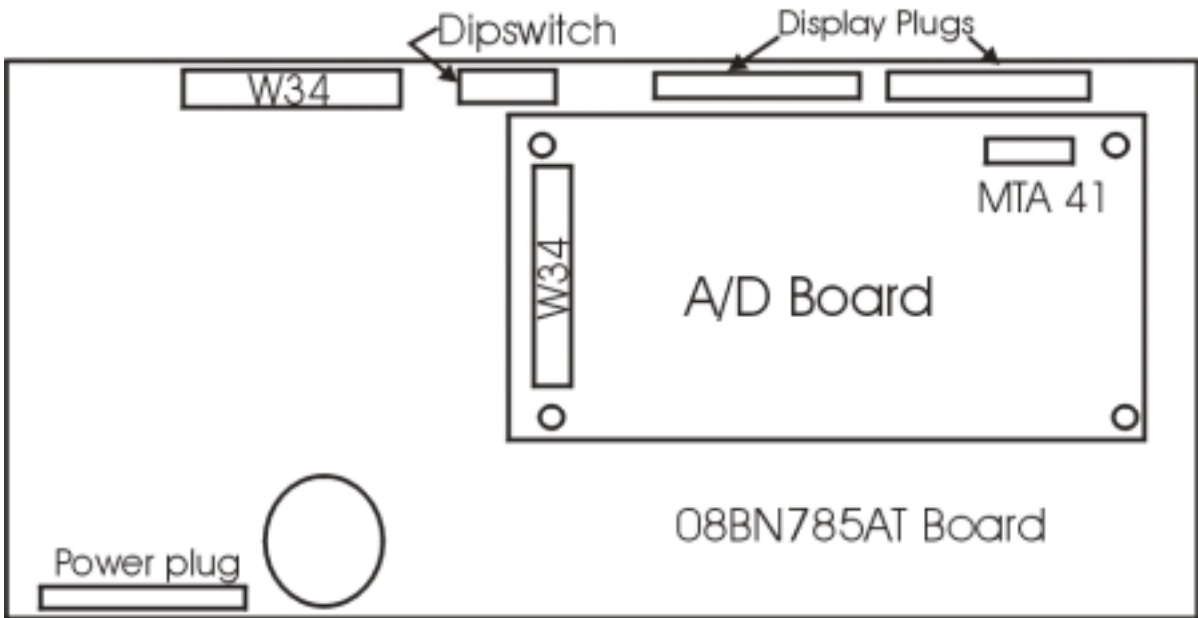


Figure 5



