

Instruction Sheet – Op Station Wire Harness Field Upgrade

This instruction sheet provides the procedure for adding the third set of contacts to an APEX Operator Station configuration. The update modifies the left-hand Run button wiring to provide compatibility with legacy WPC 2000 systems.

Follow the steps and wiring diagram provided to complete the update.

Verify You Have the Following Parts and Tools:

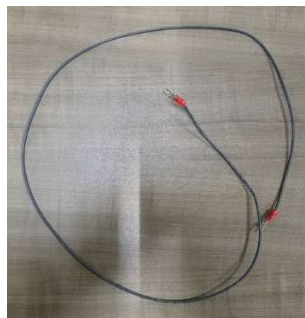
- 1x 2297202 CONTACT BLOCK 1NO/1NC SQUARE D



- 27x DA45517 TY RAP .14 X 5-1/2 LG NATURAL



- 35" DA47115 WIRE PVC/ 80 18AWG GRAY with 2x DA41475 TERMINAL CRIMP SPADE #6-R INS



- 6" DA47118 WIRE PVC/ 80 18AWG WHT/RED with 2x DA41475 TERMINAL CRIMP SPADE #6-R INS



- 2.5" DA67268 TUBING HS PVC IRD.500/.250 BLK



Tool List:

- Phillips heads screwdriver



- Micro wire cutter



- Heat shrink gun

**Contactor Installation and Connection:**

1. Remove power to the Press

CAUTION

Verify Power Has Been Removed from the Press

Failure to comply with these instructions could result in property damage or injury.

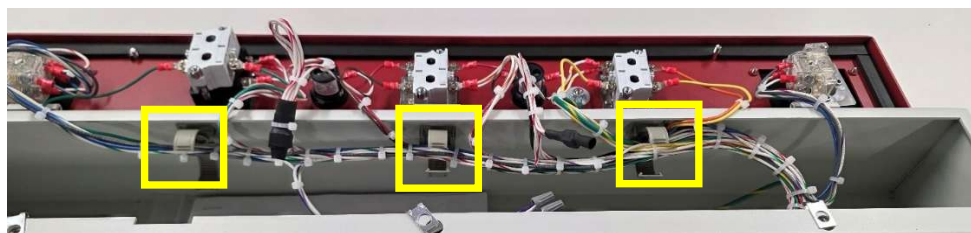
2. Open the Operator station using the Phillips head screwdriver



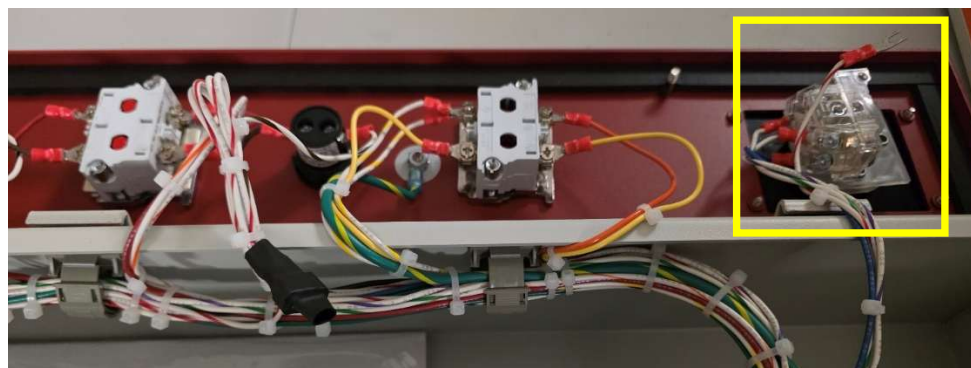
3. Unplug the op station wire harness



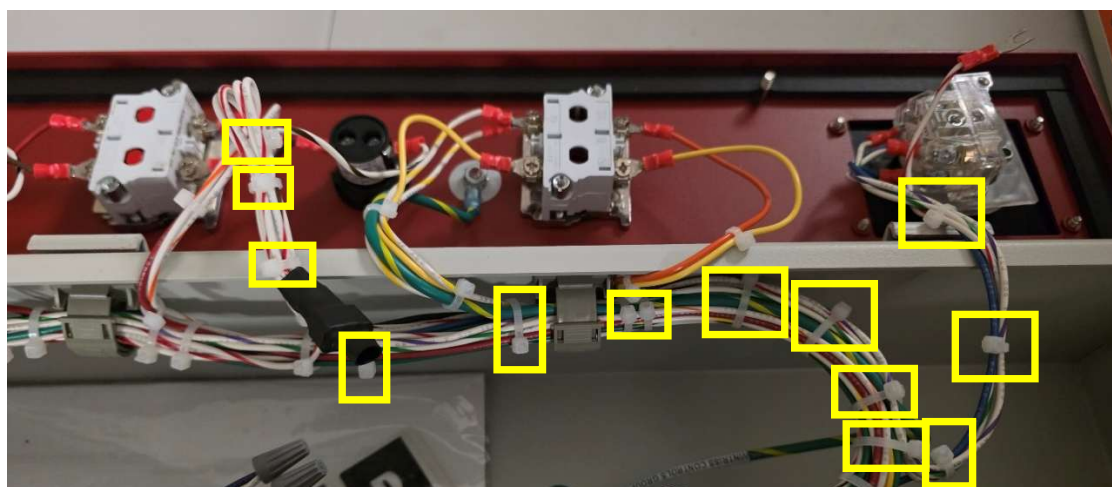
4. Open the wire clamps on the side of the op station



5. Remove the red/white power wire from the right run button using the Phillips head screwdriver



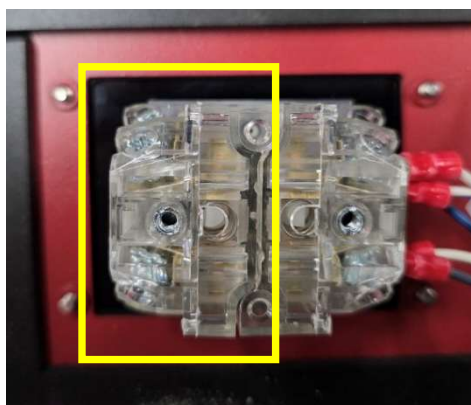
6. Cut the yellow highlighted zip ties using the micro wire cutter to free the red/white power wire from the right run button



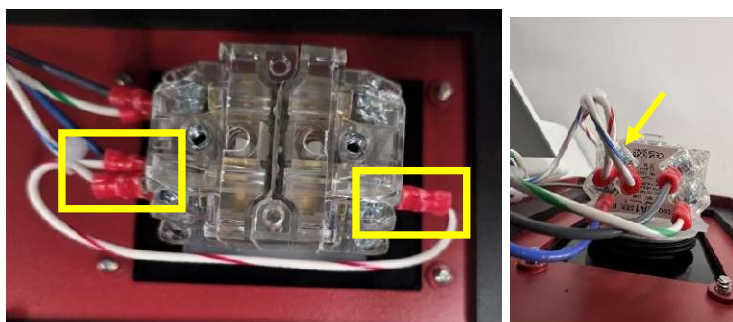
7. Cut the heat shrink bundle using the micro wire cutter and remove the red/white power wire from the right run button from the 24v bundle



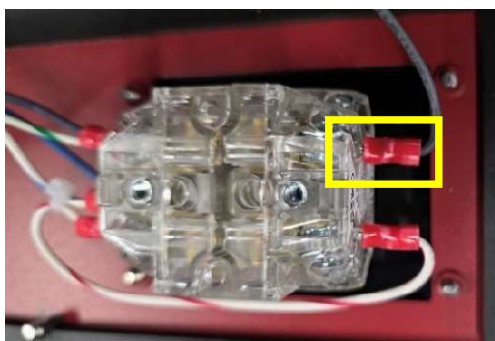
8. Install the provided extra Contact block (2297202) to the left run button



9. Add the provided red/white power jumper wire between the provided connector block to the existing connector block on the left run button, putting the provided (new) red/white power jumper wire into the same terminal as the blue/white wire on the existing connector block



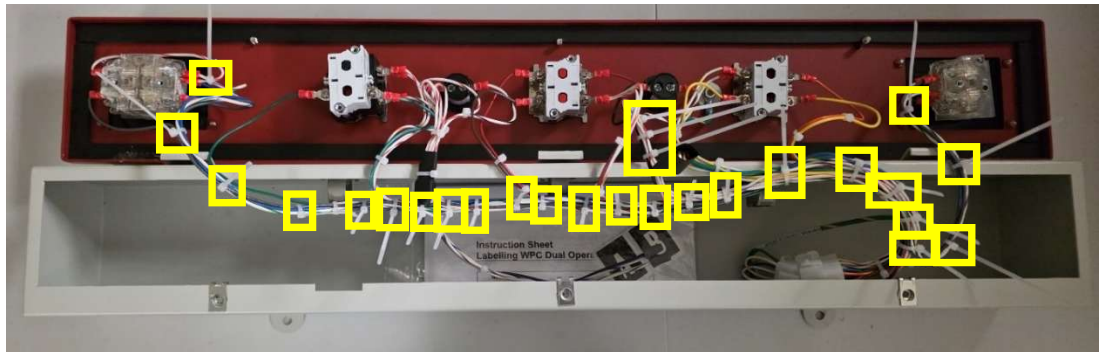
10. Install the provided gray wire to the N/O contact terminal on the provided (new) Contact block on the left run button next to the provided red/white power jumper wire



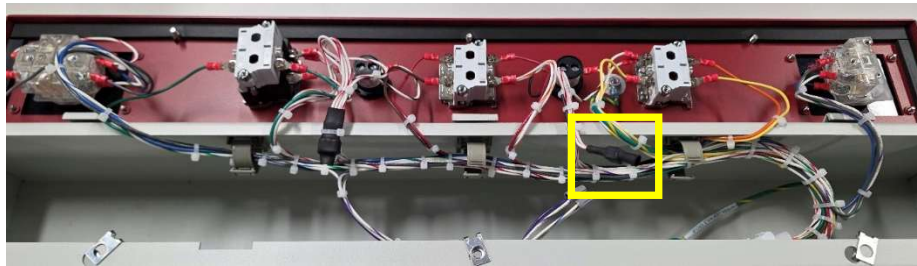
11. Route the provided gray wire between the left and right run button switches, connecting it to the provided additional connector block on the left run button and connecting to the terminal below the green/white wire on the right run button connector block



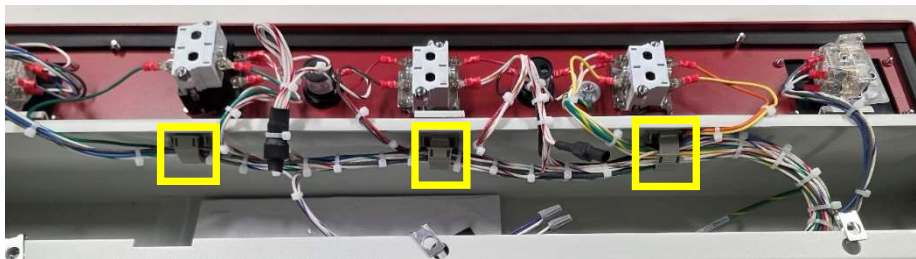
12. Use the provided zip-ties (DA45517) to put the wire harness back together clipping off the excessive zip-tie using the micro wire cutter



13. Put the provided heat shrink (DA67268) back on the 24v bundle and shrink using the heat gun



14. Put the wire harness back into the clamps and close the clamps ensuring that they snap tightly against the harness



15. Plug the wire harness connector back in



16. Close the op station and secure using the Phillips head screwdriver



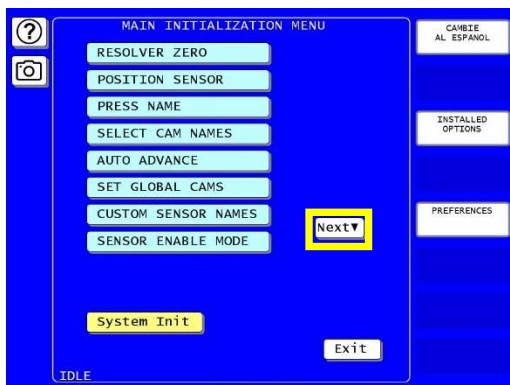
17. Power up the press and switch the PRO/APEX display to PROG using the PROG/RUN switch



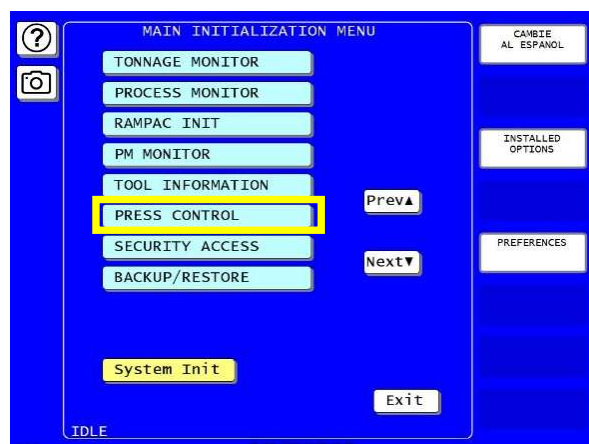
18. Press the "INITIALIZATION MENU"



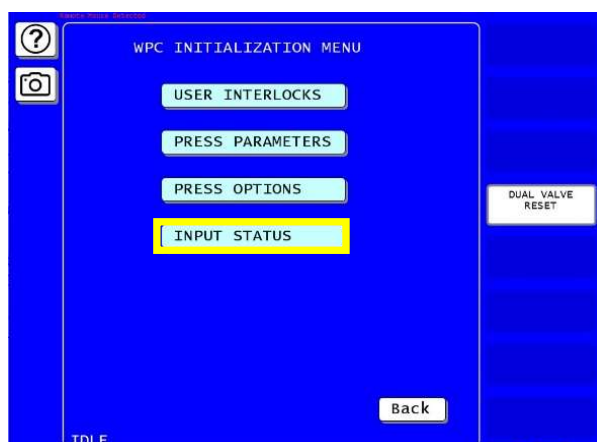
19. If you don't see "PRESS CONTROL" press "NEXT"



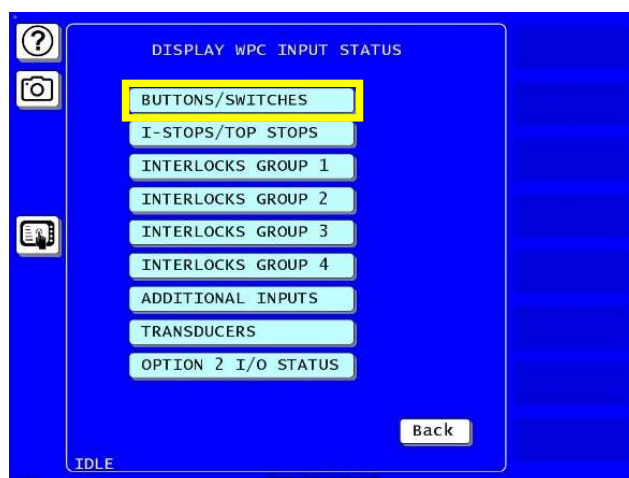
20. Select "PRESS CONTROL"



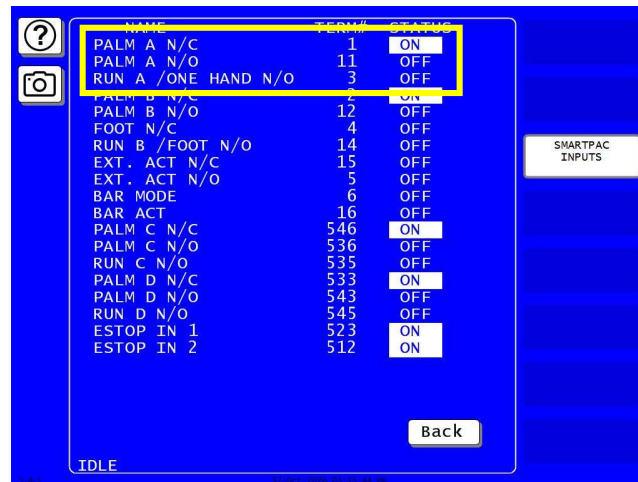
21. Select "INPUT STATUS"



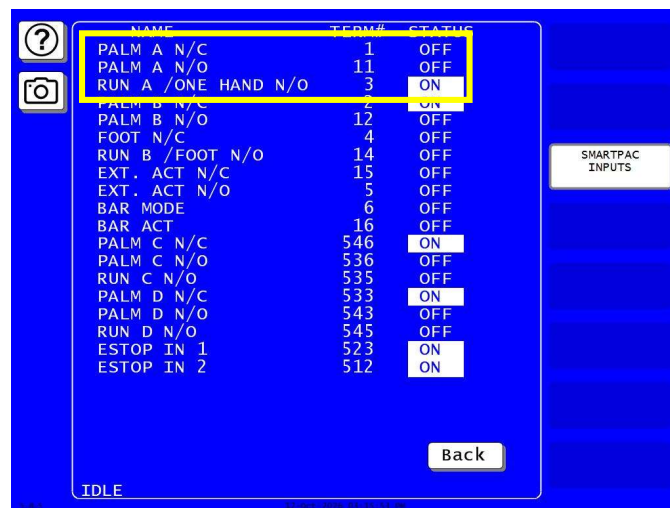
22. Select "BUTTONS/SWITCHES"



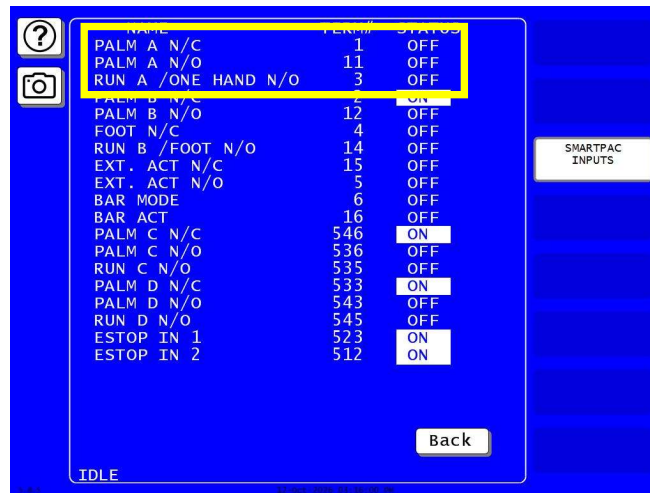
23. Verify that in the default state, when neither run button is pressed that "PALM A N/C" is "ON" and both "PALM A N/O" and "RUN A / ONE HAND N/O" are "OFF"



24. Verify that when the left run button is pressed:
- "PALM A N/C" switches from "ON" to "OFF"
 - "RUN A / ONE HAND N/O" switches from "OFF" to "ON"
 - "PALM A N/O" remains "OFF".

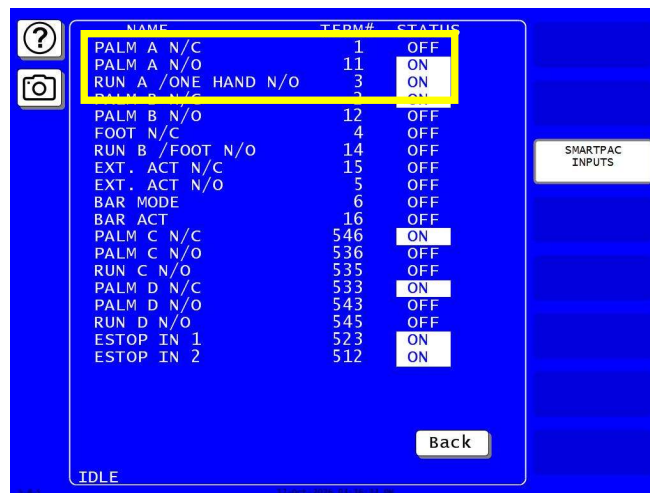


25. Verify that when the right run button is pressed:
- "PALM A N/C" switches from "ON" to "OFF"
 - "PALM A N/O" and "RUN A / ONE HAND N/O" both remain "OFF"



26. Verify that when both run buttons are pressed:

- "PALM A N/O" switches from "ON" to "OFF"
- "PALM A N/O" & "RUN A /ONE HAND N/O" switches from "OFF" to "ON"



27. Press the back/exit button until you exit to the Main Initialization Menu

28. Switch the PRO/APEX display to RUN using the PROG/RUN switch



29. Start the motor and clear the lockout message

30. Put the press into INCH mode



31. Press the left run button without pressing the right run button, verify that the press doesn't run
32. Press the right run button without pressing the left run button, verify that the press doesn't run
33. Press both the left and right run buttons at the same time, verify that the press does run
34. Contact Wintriss Technical Support with any questions or if any of the tests above do not function as specified. Call 1-800-586-TECH (8324) or email: techsupport@wintriss.com