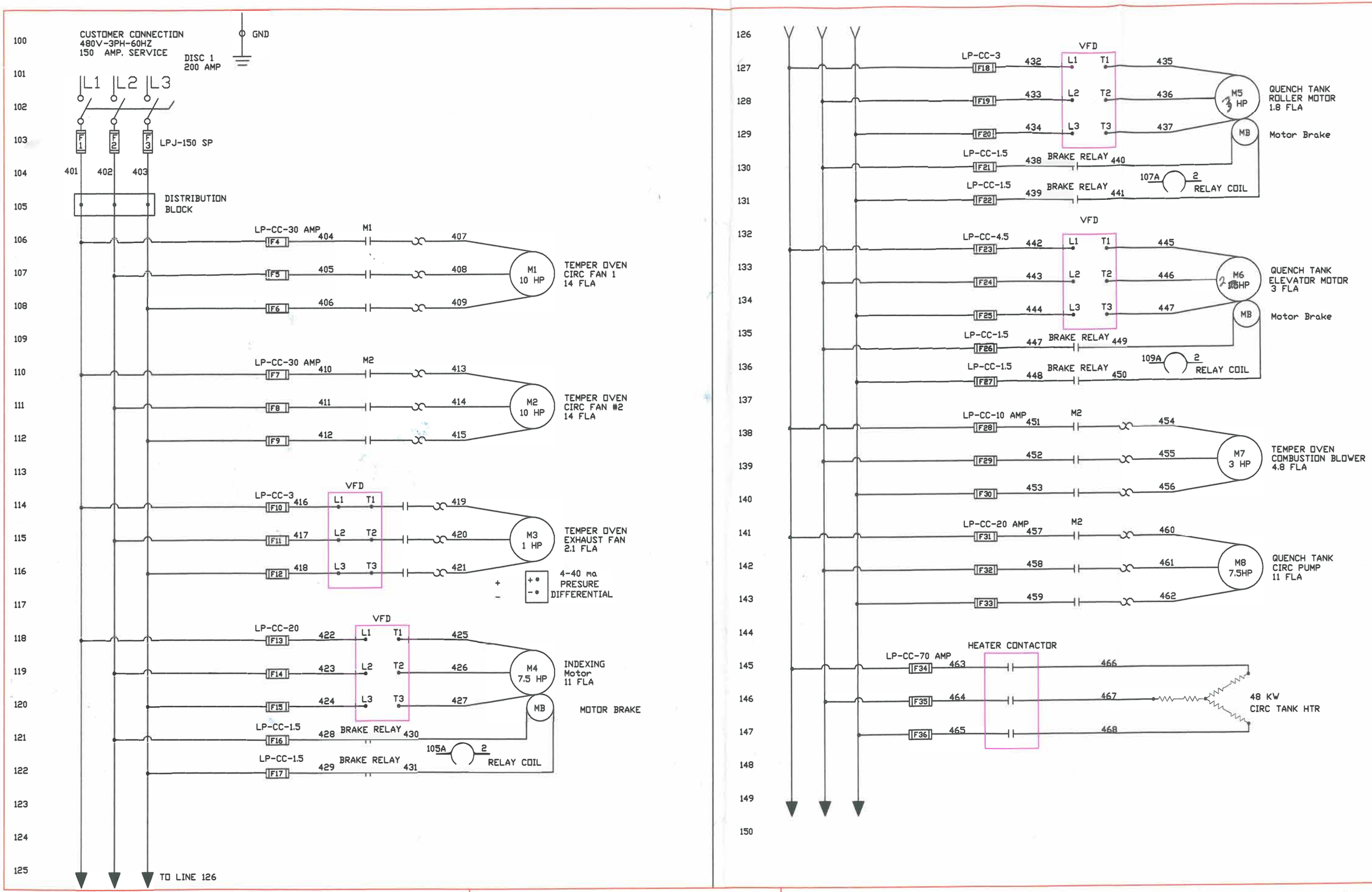
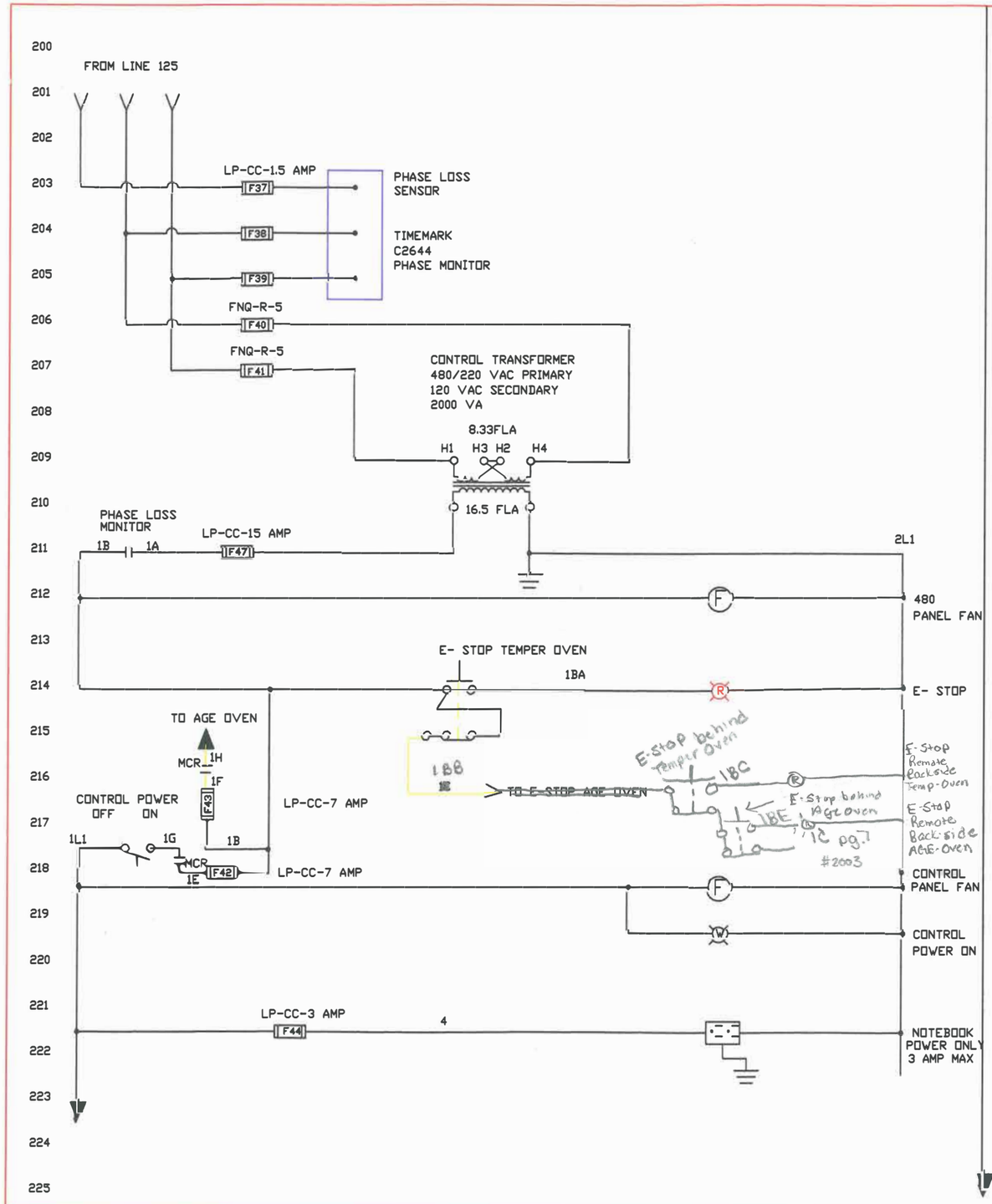
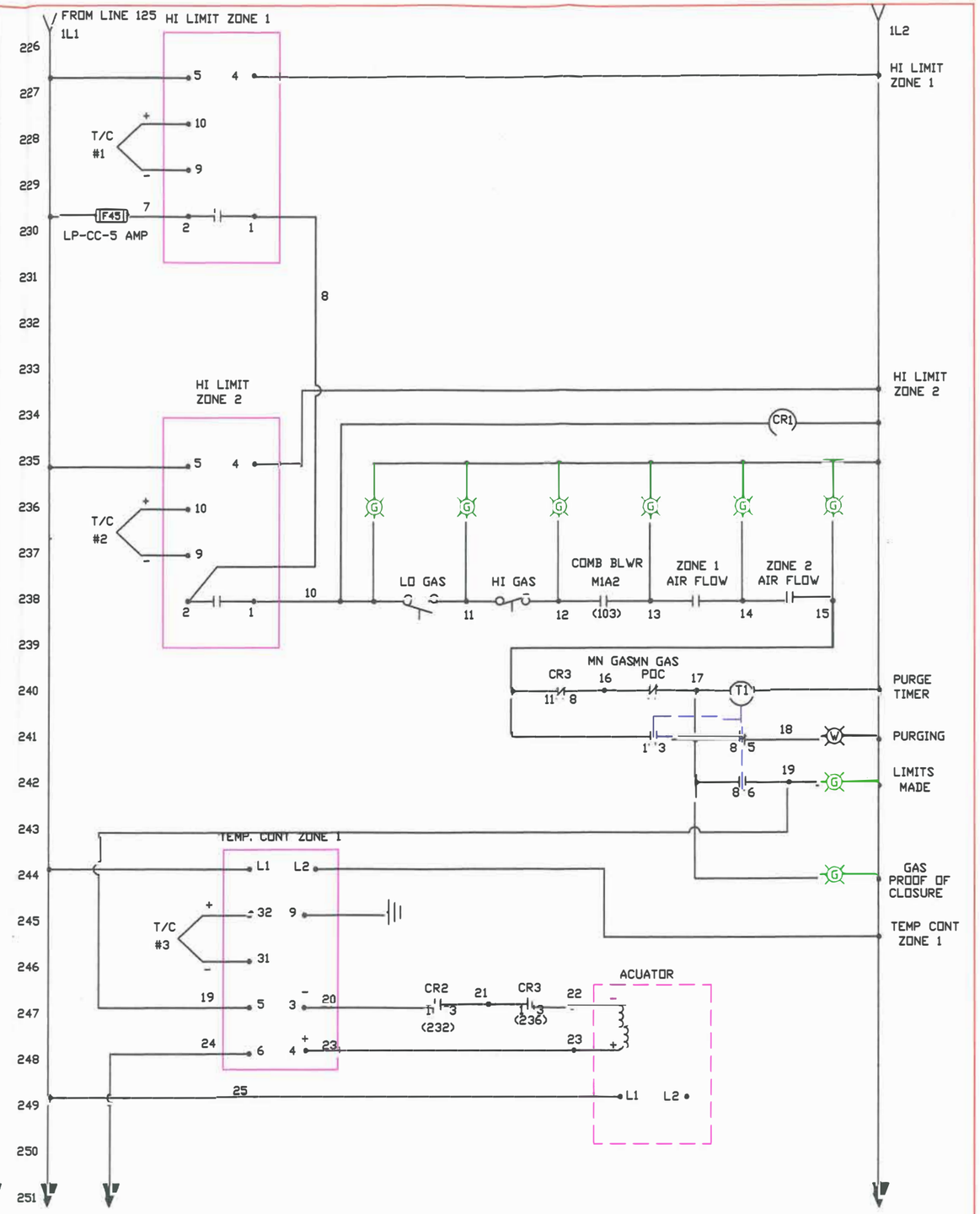
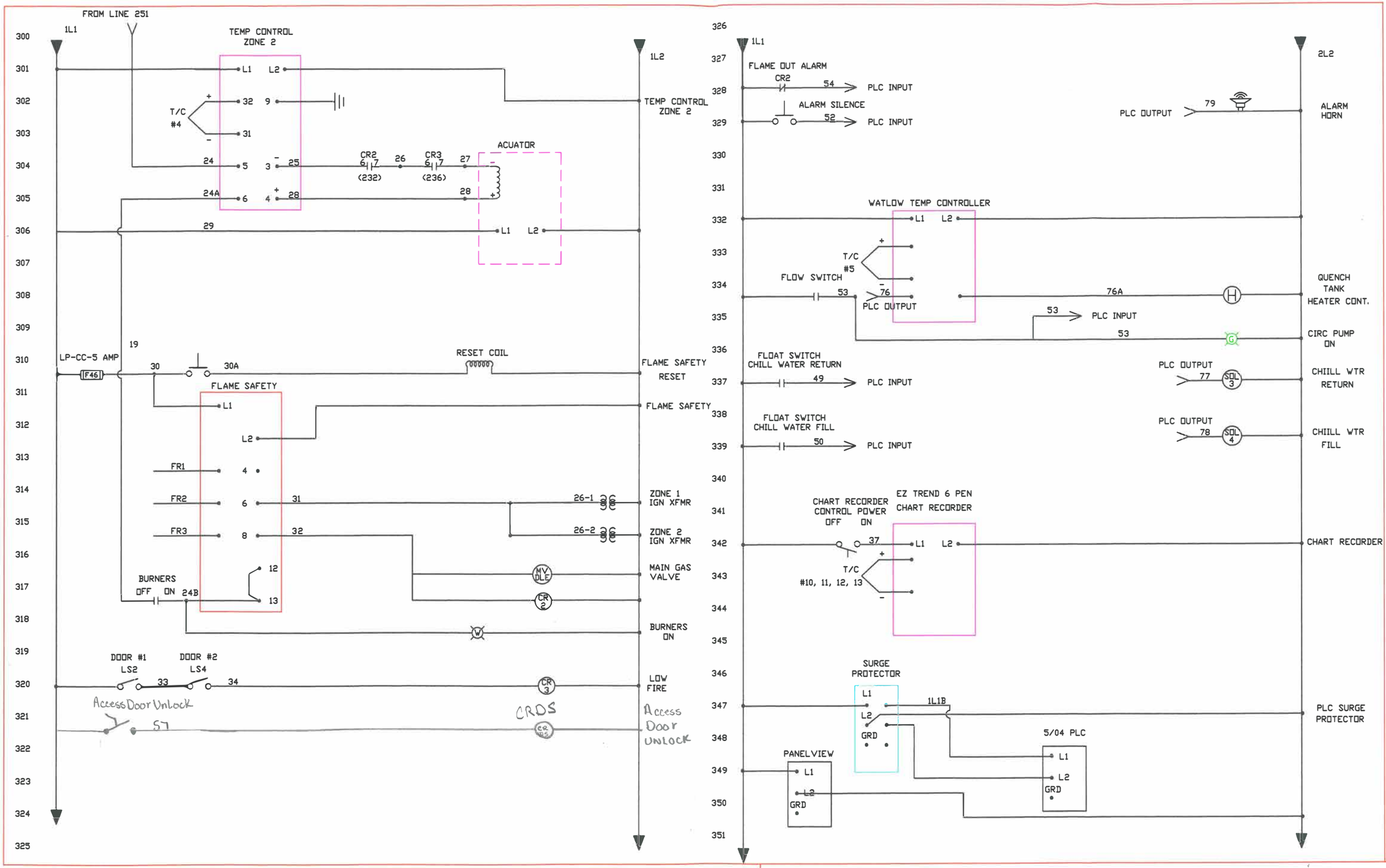


HTF, Inc. STURGEON BAY, WI. 54235 | HONDA | DATE: 03/08/06 | DR.NO. 06-01-23 1 of 9 TEMPER OVEN


FROM LINE 125
LP-CC-1.5 AMP
F37
F38
F39
PHASE LOSS SENSOR
TIMEMARK C2644 PHASE MONITOR
FNQ-R-5
F40
FNQ-R-5
F41
CONTROL TRANSFORMER
480/220 VAC PRIMARY
120 VAC SECONDARY
2000 VA
8.33FLA
H1 H3 H2 H4
16.5 FLA
PHASE LOSS MONITOR
1B 1A
LP-CC-15 AMP
F47
2L1
480 PANEL FAN
E- STOP TEMPER OVEN
1BA
E- STOP
TO AGE OVEN
MCR 1H
1F
F43
CONTROL POWER OFF ON
LP-CC-7 AMP
1L1 1G 1B
MCR 1E
F42
LP-CC-7 AMP
CONTROL PANEL FAN
CONTROL POWER ON
LP-CC-3 AMP
F44
4
NOTEBOOK POWER ONLY 3 AMP MAX
1BB
TO E-STOP AGE OVEN
E-stop behind Temper Oven
1BC
E-Stop Remote Backside Temp-Oven
E-Stop behind AGE oven
1BE
12 pg.1
#2003
E-Stop Remote Back-side AGE-Oven


FROM LINE 125
1L1
HI LIMIT ZONE 1
1L2
HI LIMIT ZONE 1
T/C #1
F45
LP-CC-5 AMP
HI LIMIT ZONE 2
HI LIMIT ZONE 2
CR1
T/C #2
LO GAS
HI GAS
COMB BLWR M1A2
ZONE 1 AIR FLOW
ZONE 2 AIR FLOW
MN GASMN GAS
CR3
POC
PURGE TIMER
PURGING
LIMITS MADE
GAS PROOF OF CLOSURE
TEMP. CONT ZONE 1
TEMP CONT ZONE 1
T/C #3
ACUATOR
CR2
CR3
(232)
(236)
(103)


FROM LINE 251
1L1
TEMP CONTROL ZONE 2
L1
L2
T/C #4
32
9
31
24
5
3
25
CR2
6
7
(232)
26
CR3
6
7
(236)
27
ACUATOR
24A
6
4
28
28
29
L1
L2
1L2
TEMP CONTROL ZONE 2
LP-CC-5 AMP
F46
19
30
30A
RESET COIL
FLAME SAFETY RESET
FLAME SAFETY
L1
L2
FLAME SAFETY
FR1
4
FR2
6
31
26-1
ZONE 1 IGN XFMR
FR3
8
32
26-2
ZONE 2 IGN XFMR
BURNERS OFF ON 24B
12
13
MV DLE
CR 2
MAIN GAS VALVE
W
BURNERS ON
DOOR #1 LS2
DOOR #2 LS4
33
34
CR 3
LOW FIRE
Access Door Unlock
57
CR DS
Access Door Unlock
1L1
FLAME OUT ALARM
CR2
54
PLC INPUT
ALARM SILENCE
52
PLC INPUT
PLC OUTPUT
79
2L2
ALARM HORN
WATLOW TEMP CONTROLLER
L1
L2
T/C #5
FLOW SWITCH
53
76
PLC OUTPUT
76A
H
QUENCH TANK HEATER CONT.
53
PLC INPUT
53
G
CIRC PUMP ON
FLOAT SWITCH CHILL WATER RETURN
49
PLC INPUT
PLC OUTPUT
77
SOL 3
CHIILL WTR RETURN
FLOAT SWITCH CHILL WATER FILL
50
PLC INPUT
PLC OUTPUT
78
SOL 4
CHIILL WTR FILL
CHART RECORDER CONTROL POWER OFF ON
37
EZ TREND 6 PEN CHART RECORDER
L1
L2
CHART RECORDER
T/C #10, 11, 12, 13
SURGE PROTECTOR
L1
L2
GRD
1L1B
PLC SURGE PROTECTOR
PANELVIEW
L1
L2
GRD
5/04 PLC
L1
L2
GRD

FROM LINE 351

1L1

1746-1A16 INPUT MODULE
I : 2/0 SLOT 2

400					
401					
402	SEN 1 ULTRASOUND	LOAD SENSOR	38	I : 2/0	
403	LS 1	DOOR # 1 OPEN	39	I : 2/1	
404	LS 2	DOOR #1 CLOSED	40	I : 2/2	
405	LS 3	DOOR # 2 OPEN	41	I : 2/3	
406	LS 4	DOOR #2 CLOSED	42	I : 2/4	
407			43	I : 2/5	
408	LS 6	ROLLER STOP LIMIT 1	44	I : 2/6	
409	LS7	ELEVATOR DOWN LIMIT	45	I : 2/7	
410	LS8	ELEVATOR UP LIMIT	46	I : 2/8	
411	LS9	ROLLER STOP LIMIT 2	47	I : 2/9	
412	LS10	2' DOWN & AGE OVEN DOORS OPEN	48	I : 2/10	
413	FLTSW 1	CHILL WATER RETURN	49	I : 2/11	
414	FLTSW 2	CHILL WATER FILL	50	I : 2/12	
415	CR 1	HI TEMP. ALARM	51	I : 2/13	
416	PB1	ALARM SILENCE	52	I : 2/14	
417	FLOW SWITCH	CIRC TANK FLOW SW	53	I : 2/15	
418					
419				120 V	
420					
421					
422					
423					
424					
425					

1L1 TO LINE 426

FROM LINE 351

1L2

1L2 TO LINE 426

FROM LINE 351

1L1

1746-1A16 INPUT MODULE
I : 3 SLOT 3

426					
427					
428	CR2	11,8	FLAMEOUT ALARM	54	I : 3/0
429		Access Door Open (Temper Oven)		55	I : 3/1
430	Access door open (Command)	Access Door Open (AGE Oven)		56	I : 3/2
431				57	I : 3/3
432				58	I : 3/4
433				59	I : 3/5
434				60	I : 3/6
435				61	I : 3/7
436				62	I : 3/8
437				63	I : 3/9
438				64	I : 3/10
439				65	I : 3/11
440				66	I : 3/12
441				67	I : 3/13
442				68	I : 3/14
443				69	I : 3/15
444					
445					120 V
446					
447					
448					
449					
450					
451					

1L1 TO LINE 500

FROM LINE 351

1L2

1L2 TO LINE 500

FROM LINE 351

FROM LINE 351

FROM LINE 525

FROM LINE 425

500	1L1	O : 4			1L2	526
501		120 V				527
502	O : 4/0	70	SOL 1	DOORS OPEN TEMPER OVEN		528
503	O : 4/1	71	SOL 2	DOORS CLOSED TEMPER OVEN		529
504	O : 4/2	72	M1	CIRC FAN #1 TEMPER OVEN		530
505	O : 4/3	73	M2	CIRC FAN #2 TEMPER OVEN		531
506	O : 4/4	74	M7	COMB BLOWER		532
507	O : 4/5	75	M8	QUENCH CIRC PUMP		533
508	O : 4/6	76	H	HEATER CONTACTOR		534
509	O : 4/7	77	SOL 3	CHILL WTR RETURN		535
510		120 V				536
511	O : 4/8	78	SOL 4	CHILL WTR FILL		537
512	O : 4/9	79		ALARM BUZZER		538
513	O : 4/10	80	P	ALARM SILENCE		539
514	O : 4/11	81	Y	MOVEMENT LT		540
515	O : 4/12	82	G	PROGRESS LT		541
516	O : 4/13	83	R	OVERTEMP/ FLAMEOUT BEACON		542
517	O : 4/14	84	R	HI LIMIT LT		543
518	O : 4/15	85	A	10 MINUTE BEFORE DONE		544
519						545
520						546
512						547
522						548
523						549
524						550
525	1L1				2L2	551
526						

1L1 1746-HESC2 HIGH SPEED COUNTER

TEMPER ENCODER
A1+ WHITE
A1- BLACK

TEMPER ENCODER
A2+ WHITE
A2- BLACK

NO OTHER COLORS USED

1L1

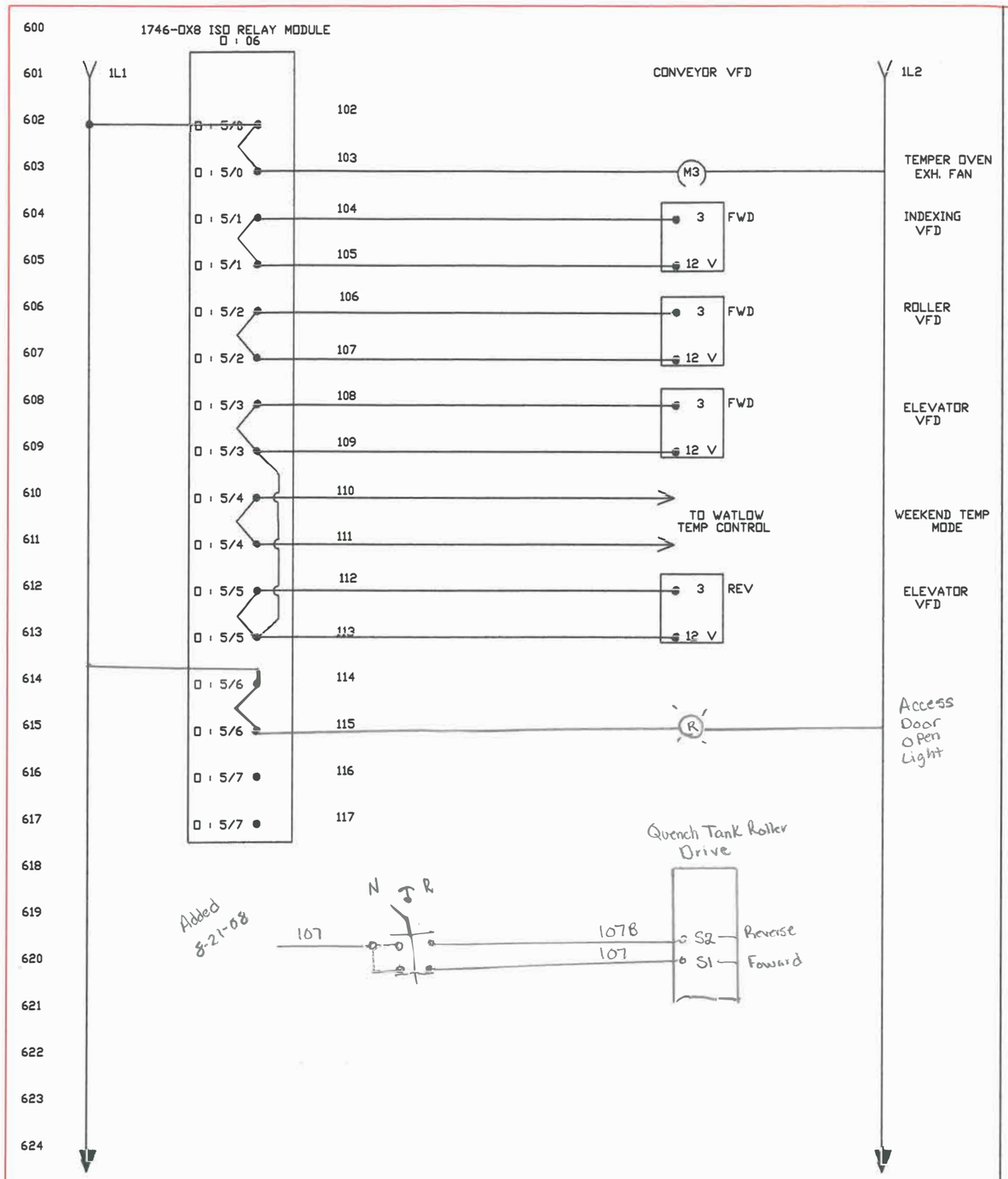
1L2

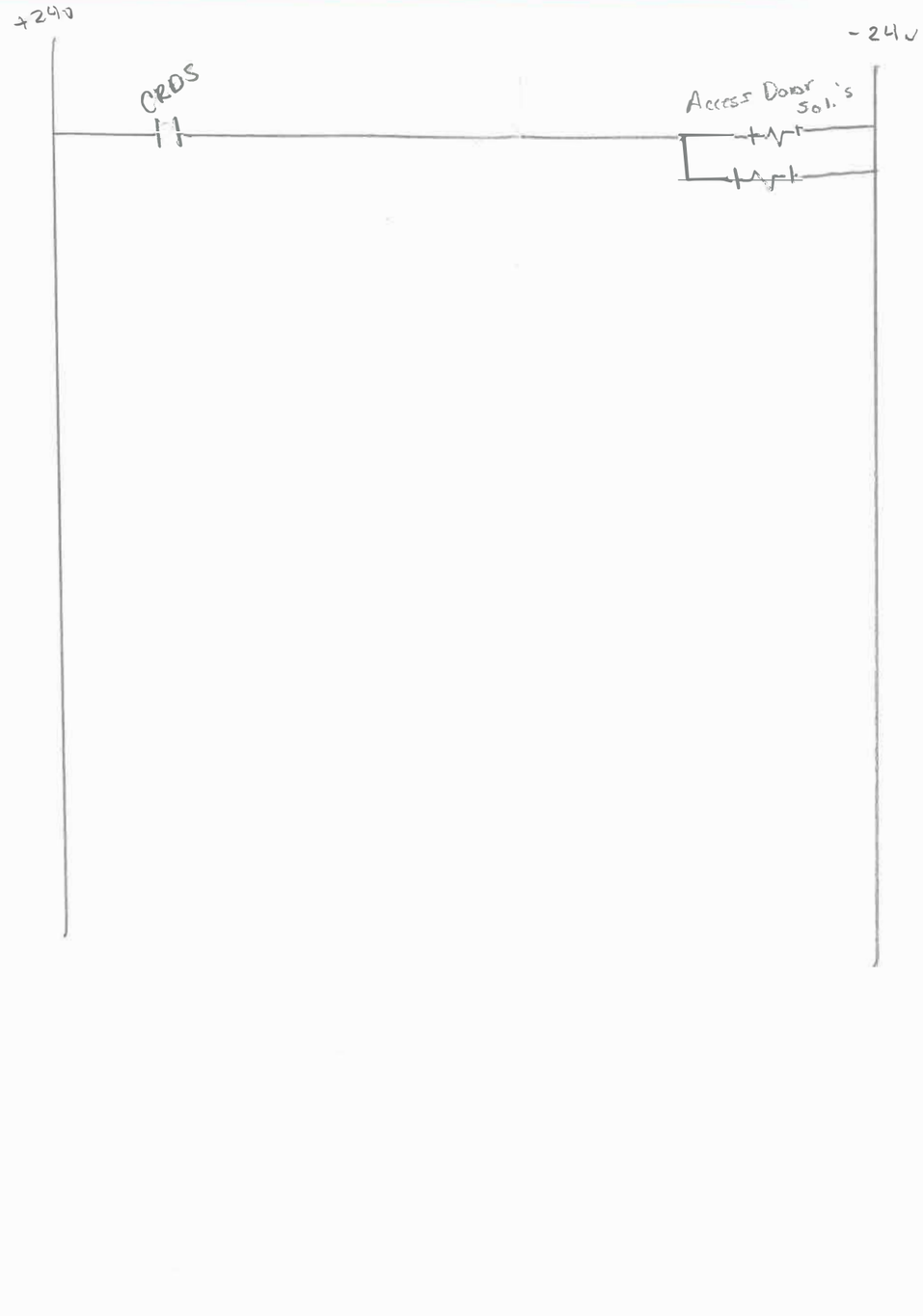
TO LINE 426

TO LINE 600

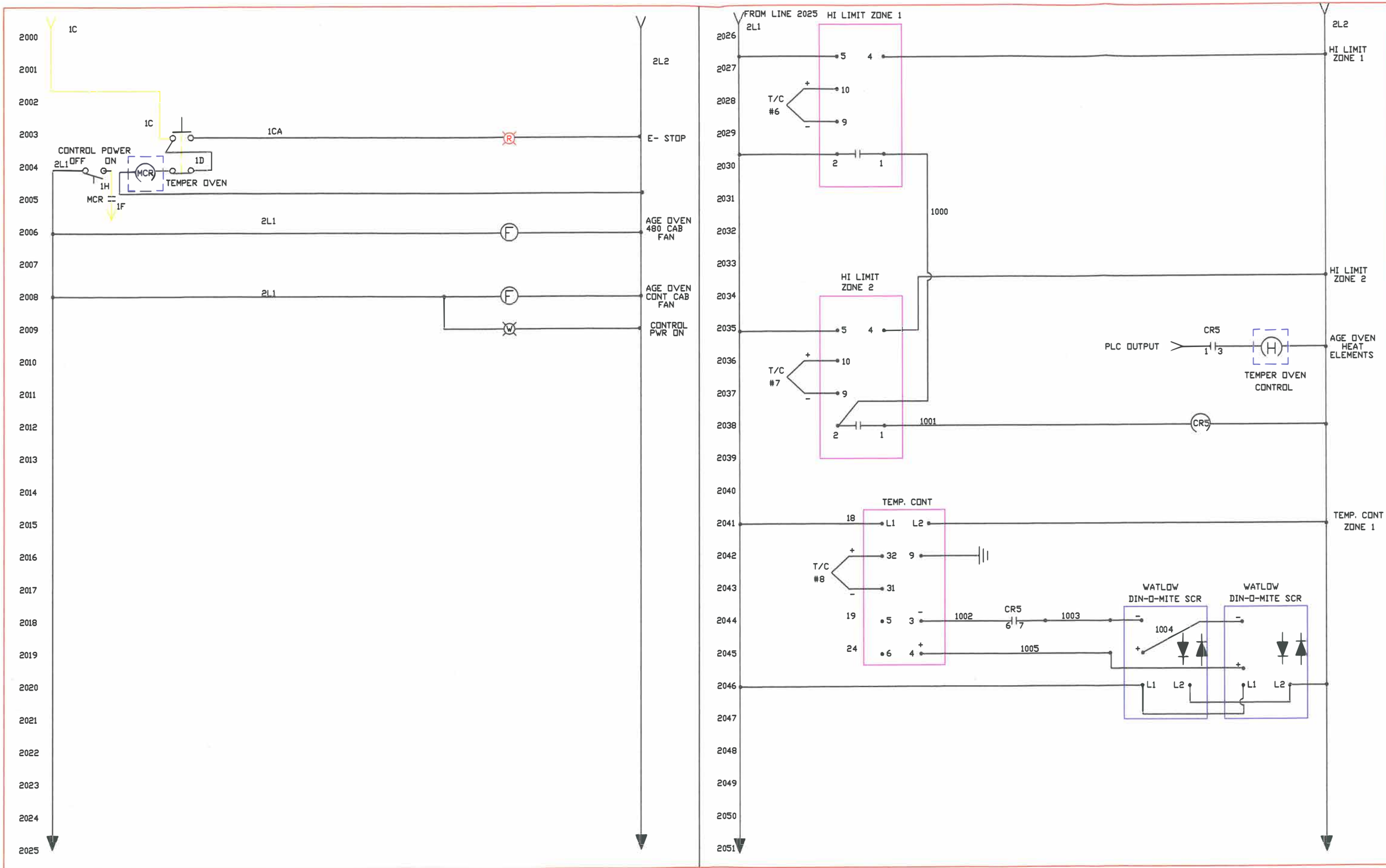
TO LINE 600

HTF, Inc. STURGEON BAY, WI. 54235 | HONDA | DATE: 03/08/06 | DR.NO. 06-01-23 5 OF 9 TEMPER OVEN

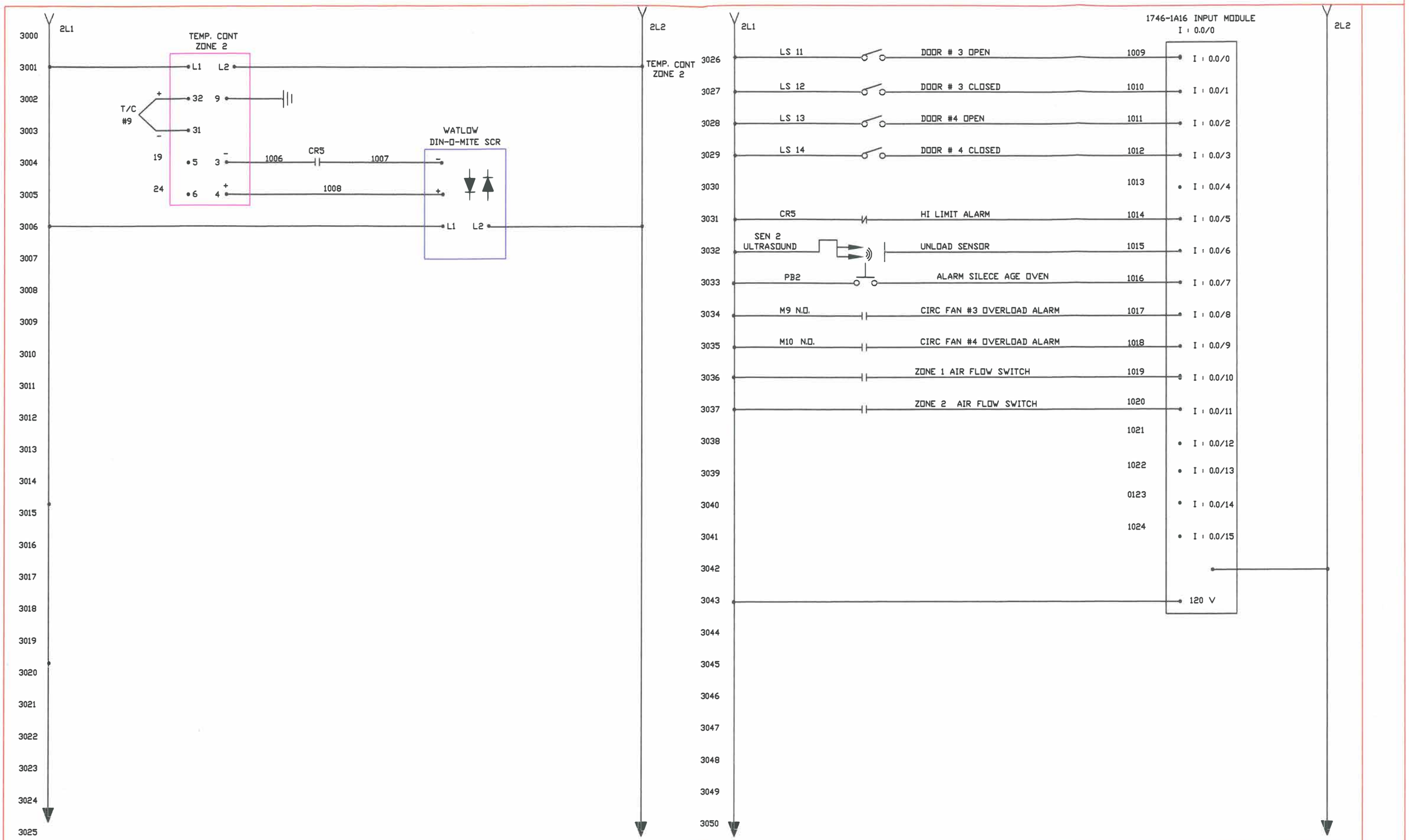




HTF, Inc. STURGEON BAY, WI. 54235	HONDA	DATE: 03/08/06	DR.NO. 06-01-23 6 OF 9 TEMPER OVEN



HTF, Inc. STURGEON BAY, WI. 54235 HONDA DATE: 02/23/06 DR.NO. 06-01-23 7 OF 9 TEMPER OVEN


2L1
TEMP. CONT ZONE 2
L1
L2
T/C #9
32
9
31
19
5
3
24
6
4
1006
CR5
1007
1008
WATLOW DIN-O-MITE SCR
L1
L2
2L2
TEMP. CONT ZONE 2
2L1
1746-1A16 INPUT MODULE
I : 0.0/0
LS 11
DOOR # 3 OPEN
1009
I : 0.0/0
LS 12
DOOR # 3 CLOSED
1010
I : 0.0/1
LS 13
DOOR #4 OPEN
1011
I : 0.0/2
LS 14
DOOR # 4 CLOSED
1012
I : 0.0/3
1013
I : 0.0/4
CR5
HI LIMIT ALARM
1014
I : 0.0/5
SEN 2 ULTRASOUND
UNLOAD SENSOR
1015
I : 0.0/6
PB2
ALARM SILECE AGE OVEN
1016
I : 0.0/7
M9 N.O.
CIRC FAN #3 OVERLOAD ALARM
1017
I : 0.0/8
M10 N.O.
CIRC FAN #4 OVERLOAD ALARM
1018
I : 0.0/9
ZONE 1 AIR FLOW SWITCH
1019
I : 0.0/10
ZONE 2 AIR FLOW SWITCH
1020
I : 0.0/11
1021
I : 0.0/12
1022
I : 0.0/13
0123
I : 0.0/14
1024
I : 0.0/15
120 V
2L2

1746-OX8 ISO RELAY MODULE
O : 4.0

2L1

1000 120 V
1001 O : 2.0/0 — 1025 — SOL 5 — DOORS #3,4 OPEN AGE OVEN
1002 O : 2.0/1 — 1026 — SOL 6 — DOORS #3,4 CLOSED AGE OVEN
1003 O : 2.0/2 — 1027 — M11 — CIRC FAN #3 AGE OVEN
1004 O : 2.0/3 — 1028 — M12 — CIRC FAN #2 AGE OVEN
1005 O : 2.0/4 — 1029 — ALARM BUZZER
1006 O : 2.0/5 — 1030 — MOVEMENT LIGHT
1007 O : 2.0/6 — 1031 — R — HIGH TEMP ALARM LT
1008 O : 2.0/7 — 1032 — A — 10 MINUTE BEFORE DONE
1009 120 V
1010 O : 2.0/8 — 1033 — G — PROGRESS LIGHT
1011 O : 2.0/9 — 1034 — Y — ALARM SILENCE
1012 O : 2.0/10 — 1035 — R — BEACON
1013 O : 2.0/11 — 1036 — G — HEAT ON
1014 O : 2.0/12
1015 O : 2.0/13
1016 O : 2.0/14
1017 O : 2.0/15
1018
1019
1020
1021
1022
1023
1024 2L1
1025

LEGEND
TEMPER OVEN CONTROL TO AGE OVEN

2L2

1026
1027
1028
1029
1030
1031
1032
1033
1034
1035
1036
1037
1038
1039
1040
1041
1042
1043
1044
1045
1046
1047
1048
1049
1050 2L2

2L1

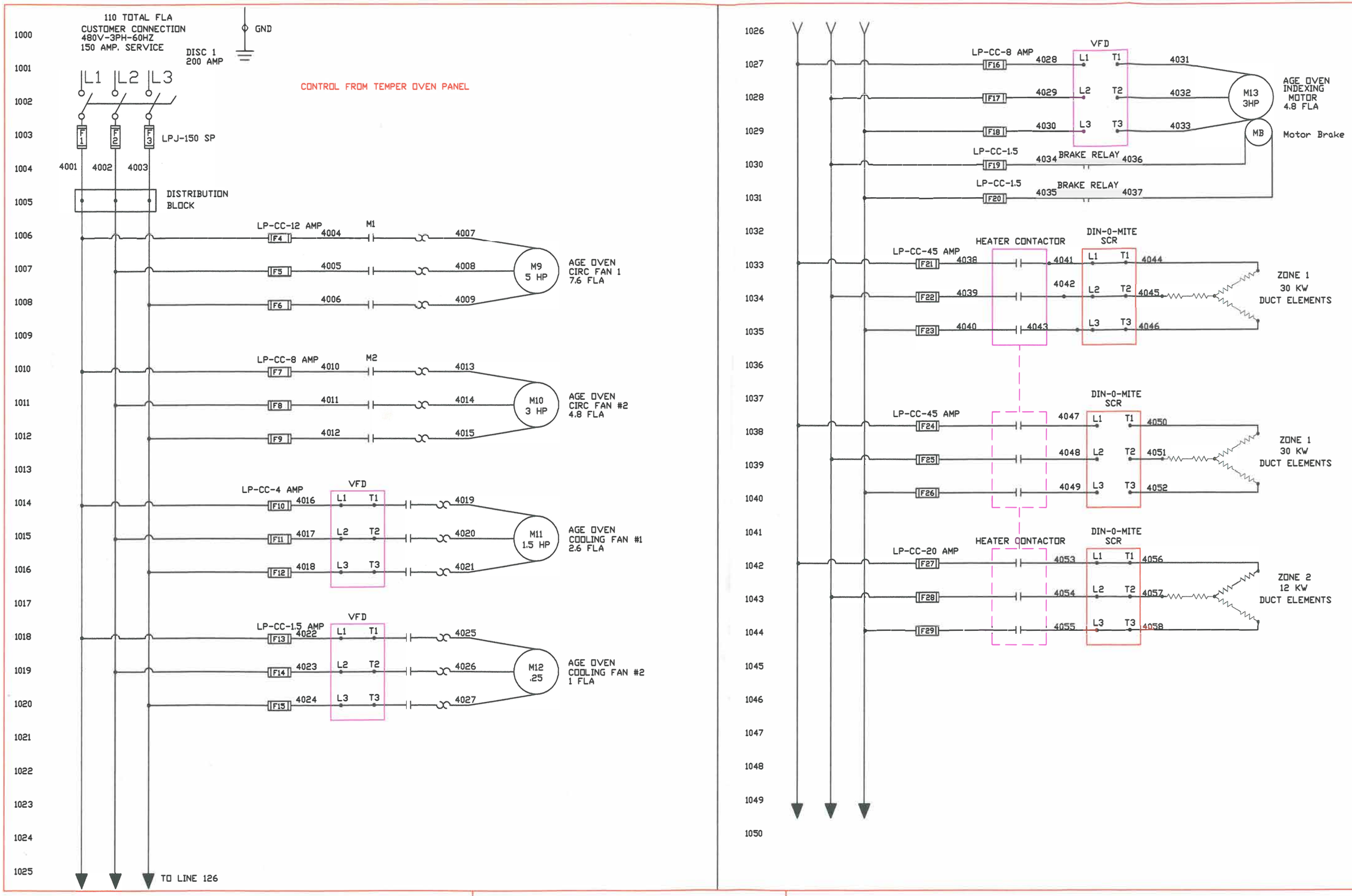
O : 4.0/0 — 1041
1042 — H — TEMPER OVEN CONTROL TO AGE OVEN
O : 4.0/1 — 1043 — 3 FWD
1044 — 12 V
O : 4.0/3 — 1045 — 3 FWD
1046 — 12 V
O : 4.0/4 — 1047 — 3 FWD
1048 — 12 V
O : 4.0/5 — 1049
1050
O : 4.0/6 — 1051
1052
O : 4.0/7 — 1053
1054
O : 4.0/8 — 1055
1056

CONTROL

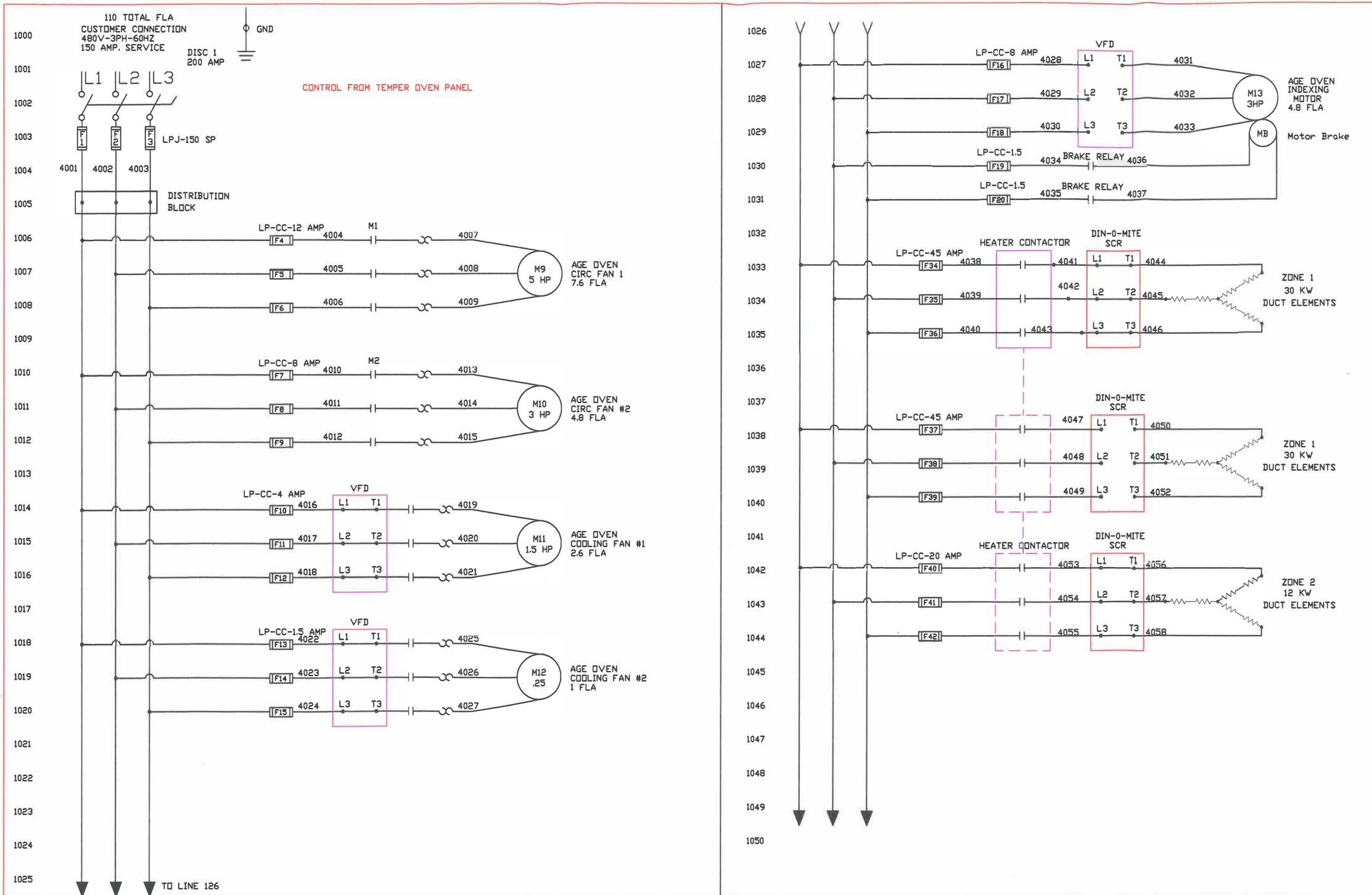
TEMPER OVEN CONTROL TO AGE OVEN

2L2

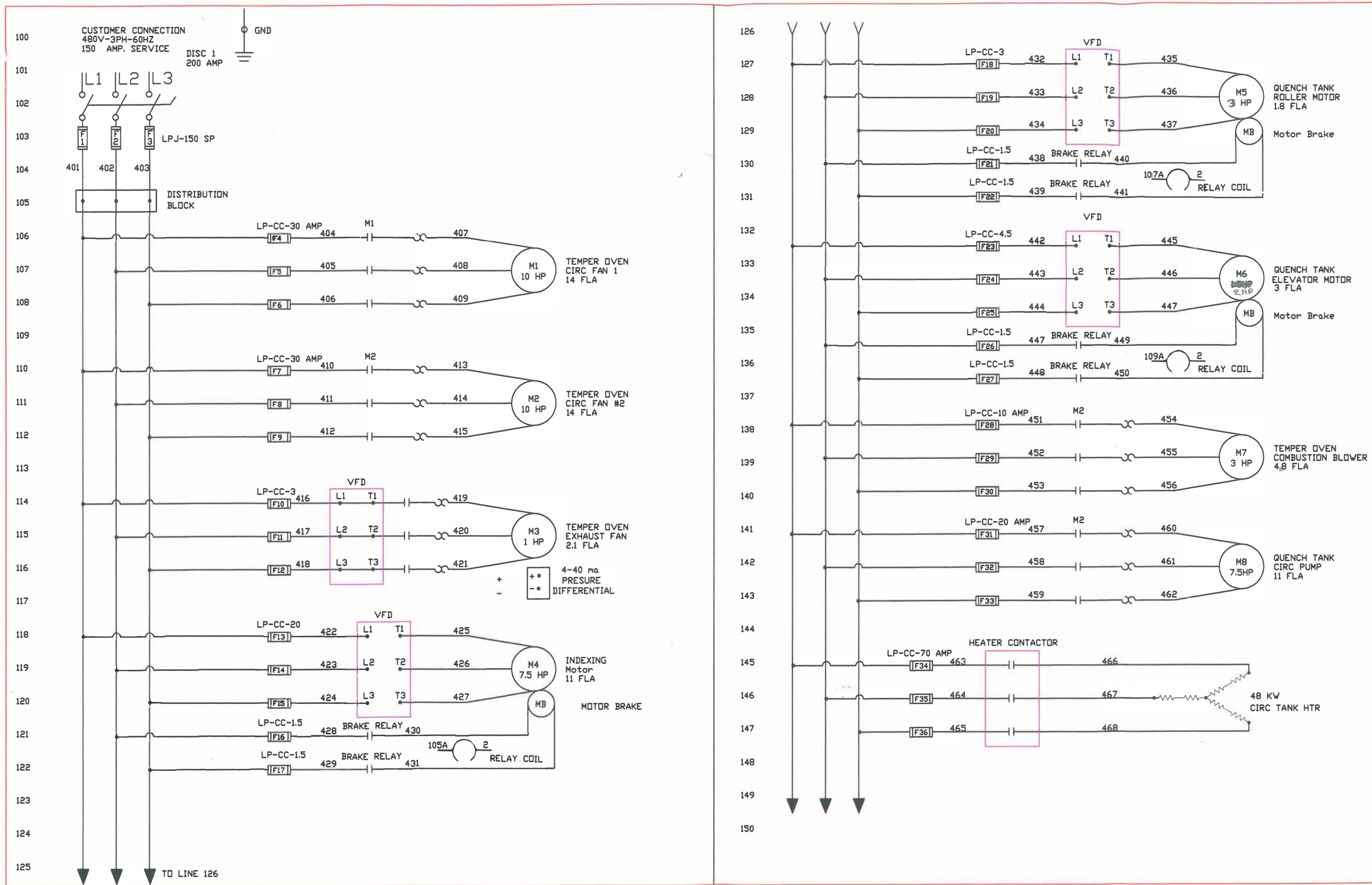
AGE OVEN HEATER CONTACTOR
AGE OVEN M11 COOLING FAN #1 VFD
AGE OVEN M12 COOLING FAN #2 VFD
AGE OVEN M13 INDEXING MOTOR



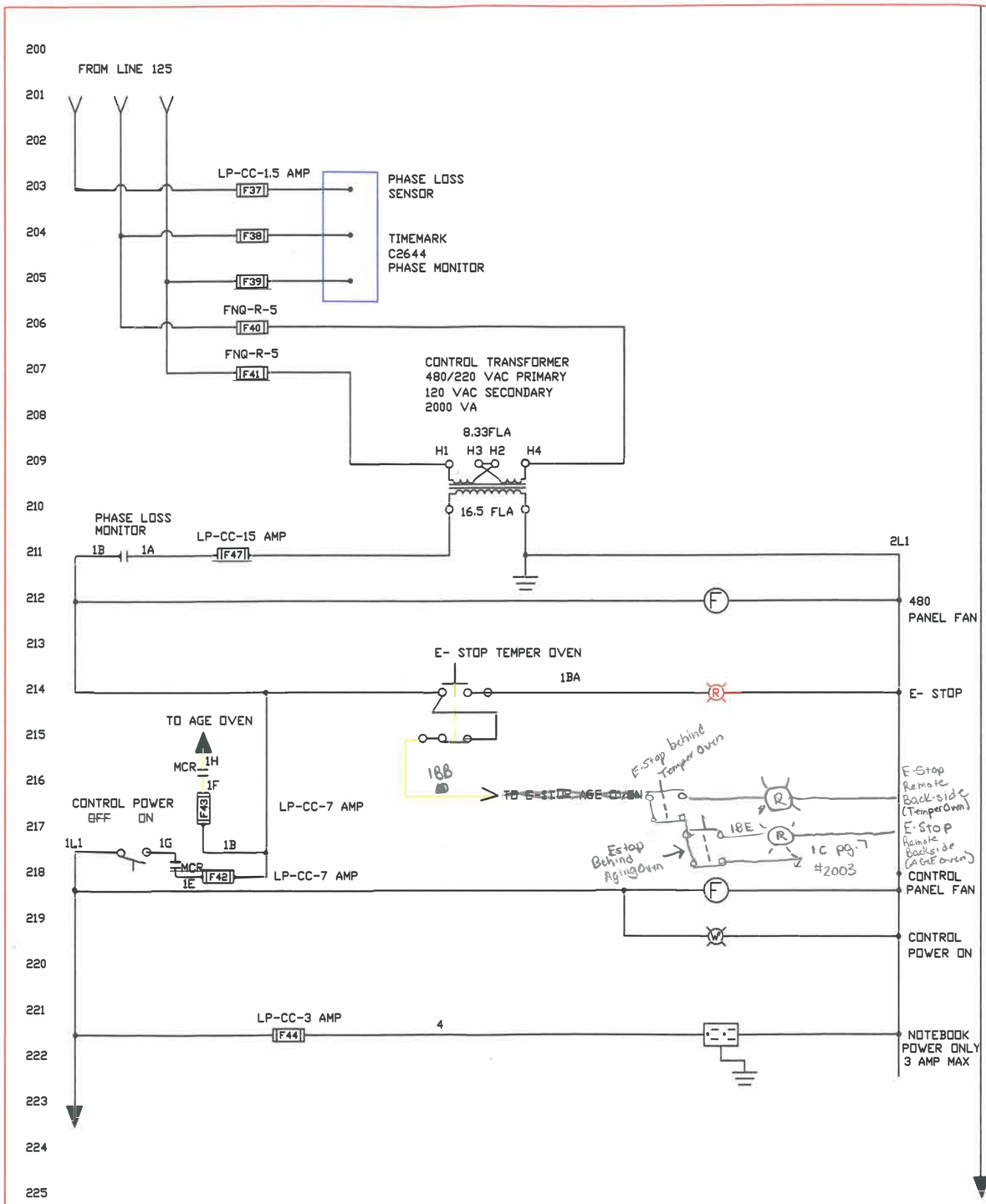
HTF, Inc. STURGEON BAY, WI. 54235 | HONDA | DATE: 03/08/06 | DR.NO. 06-01-23A 1 of 1 AGE OVEN

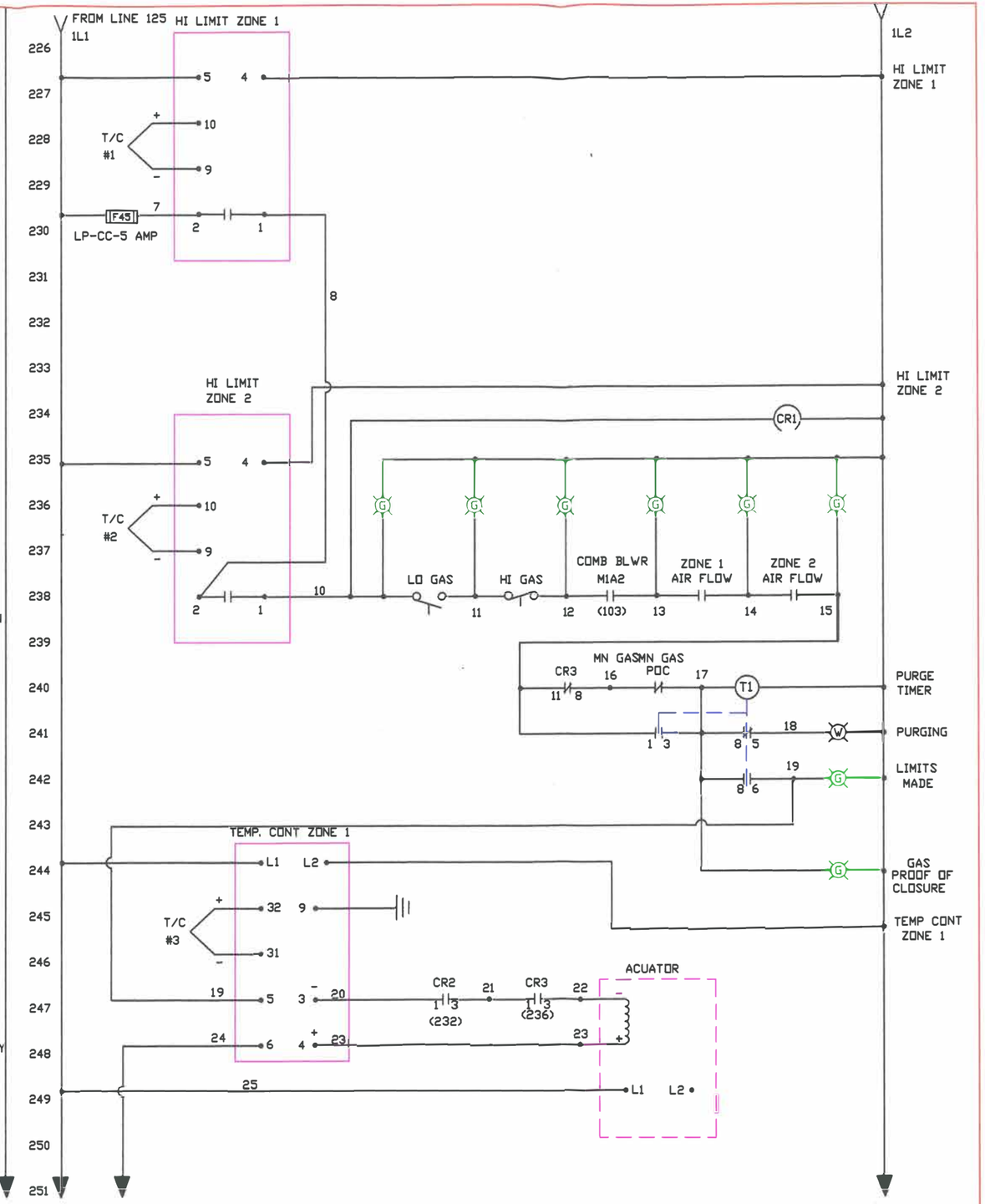


HTF, Inc. STURGEON BAY, WI. 54235 | HONDA | DATE: 03/08/06 | DR.NO. 06-01-23A 1 of 1 AGE OVEN

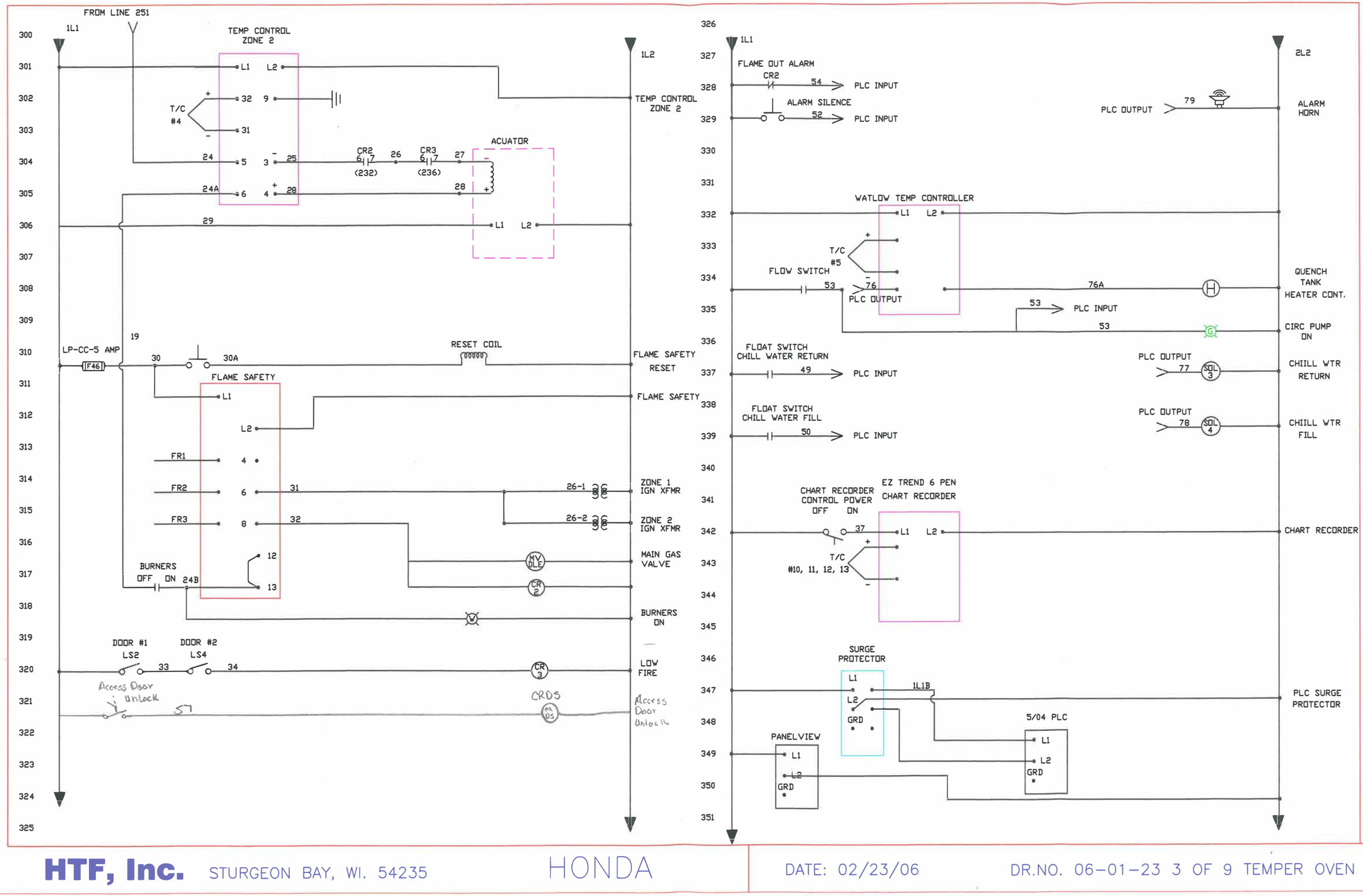


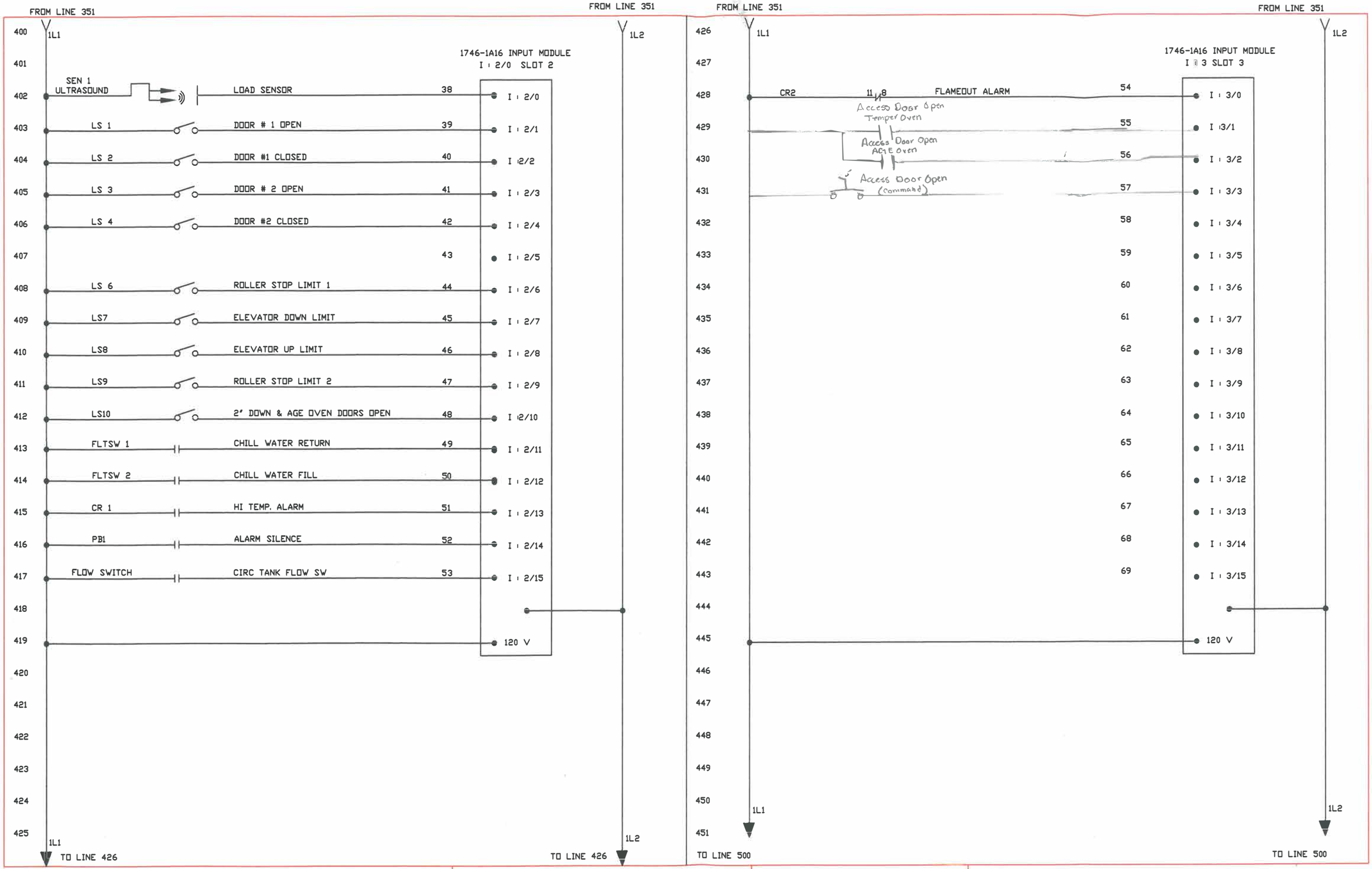
HTF, Inc. STURGEON BAY, WI. 54235 | HONDA | DATE: 03/08/06 | DR.NO. 06-01-23 1 of 9 TEMPER OVEN





HTF, Inc. STURGEON BAY, WI. 54235 HONDA DATE: 02/23/06 DR.NO. 06-01-23 2 OF 9 TEMPER OVEN


FROM LINE 251
1L1
TEMP CONTROL ZONE 2
L1
L2
T/C #4
32
9
31
24
5
3
25
CR2
6
7
(232)
26
CR3
6
7
(236)
27
ACUATOR
24A
6
4
28
29
1L2
TEMP CONTROL ZONE 2
L1
L2
19
LP-CC-5 AMP
F46
30
30A
RESET COIL
FLAME SAFETY RESET
FLAME SAFETY
L1
L2
FLAME SAFETY
FR1
4
FR2
6
31
26-1
ZONE 1 IGN XFMR
FR3
8
32
26-2
ZONE 2 IGN XFMR
BURNERS OFF ON 24B
12
13
MV DLE
MAIN GAS VALVE
CR 2
BURNERS ON
W
DOOR #1 LS2
DOOR #2 LS4
33
34
CR 3
LOW FIRE
Access Door Unlock
57
CR DS
Access Door Unlock
1L1
FLAME OUT ALARM
CR2
54
PLC INPUT
ALARM SILENCE
52
PLC INPUT
2L2
PLC OUTPUT
79
ALARM HORN
WATLOW TEMP CONTROLLER
L1
L2
T/C #5
FLOW SWITCH
53
76
PLC OUTPUT
76A
H
QUENCH TANK HEATER CONT.
53
PLC INPUT
53
G
CIRC PUMP ON
FLOAT SWITCH CHILL WATER RETURN
49
PLC INPUT
PLC OUTPUT
77
SOL 3
CHIILL WTR RETURN
FLOAT SWITCH CHILL WATER FILL
50
PLC INPUT
PLC OUTPUT
78
SOL 4
CHIILL WTR FILL
CHART RECORDER CONTROL POWER OFF ON
EZ TREND 6 PEN CHART RECORDER
37
L1
L2
CHART RECORDER
T/C #10, 11, 12, 13
SURGE PROTECTOR
L1
L2
GRD
1L1B
PLC SURGE PROTECTOR
PANELVIEW
L1
L2
GRD
5/04 PLC
L1
L2
GRD



HTF, Inc. STURGEON BAY, WI. 54235	HONDA	DATE: 03/08/06	DR.NO.06-01-23 4 OF 9 TEMPER OVEN

FROM LINE 351

FROM LINE 351

FROM LINE 525

FROM LINE 425

500 1L1 — O : 4 — 1L2

501 120 V

502 O : 4/0 — 70 — SOL 1 — DOORS OPEN TEMPER OVEN

503 O : 4/1 — 71 — SOL 2 — DOORS CLOSED TEMPER OVEN

504 O : 4/2 — 72 — M1 — CIRC FAN #1 TEMPER OVEN

505 O : 4/3 — 73 — M2 — CIRC FAN #2 TEMPER OVEN

506 O : 4/4 — 74 — M7 — COMB BLOWER

507 O : 4/5 — 75 — M8 — QUENCH CIRC PUMP

508 O : 4/6 — 76 — H — HEATER CONTACTOR

509 O : 4/7 — 77 — SOL 3 — CHILL WTR RETURN

510 120 V

511 O : 4/8 — 78 — SOL 4 — CHILL WTR FILL

512 O : 4/9 — 79 — ALARM BUZZER

513 O : 4/10 — 80 — (Y) — ALARM SILENCE

514 O : 4/11 — 81 — (Y) — MOVEMENT LT

515 O : 4/12 — 82 — (G) — PROGRESS LT

516 O : 4/13 — 83 — (R) — OVERTEMP/ FLAMEOUT BEACON

517 O : 4/14 — 84 — (R) — HI LIMIT LT

518 O : 4/15 — 85 — (A) — 10 MINUTE BEFORE DONE

519

520

512

522

523

524

525 1L1

526

TO LINE 426

526 1L1 — 1746-HESC2 HIGH SPEED COUNTER — 1L2

527

TEMPER ENCODER A1+ WHITE, A1- BLACK

528 NO OTHER COLORS USED

TEMPER ENCODER A2+ WHITE, A2- BLACK

529

530

531

532

533

534

535

536

537

538

539

540

541

542

543

544

545

546

547

548

549

550 1L1

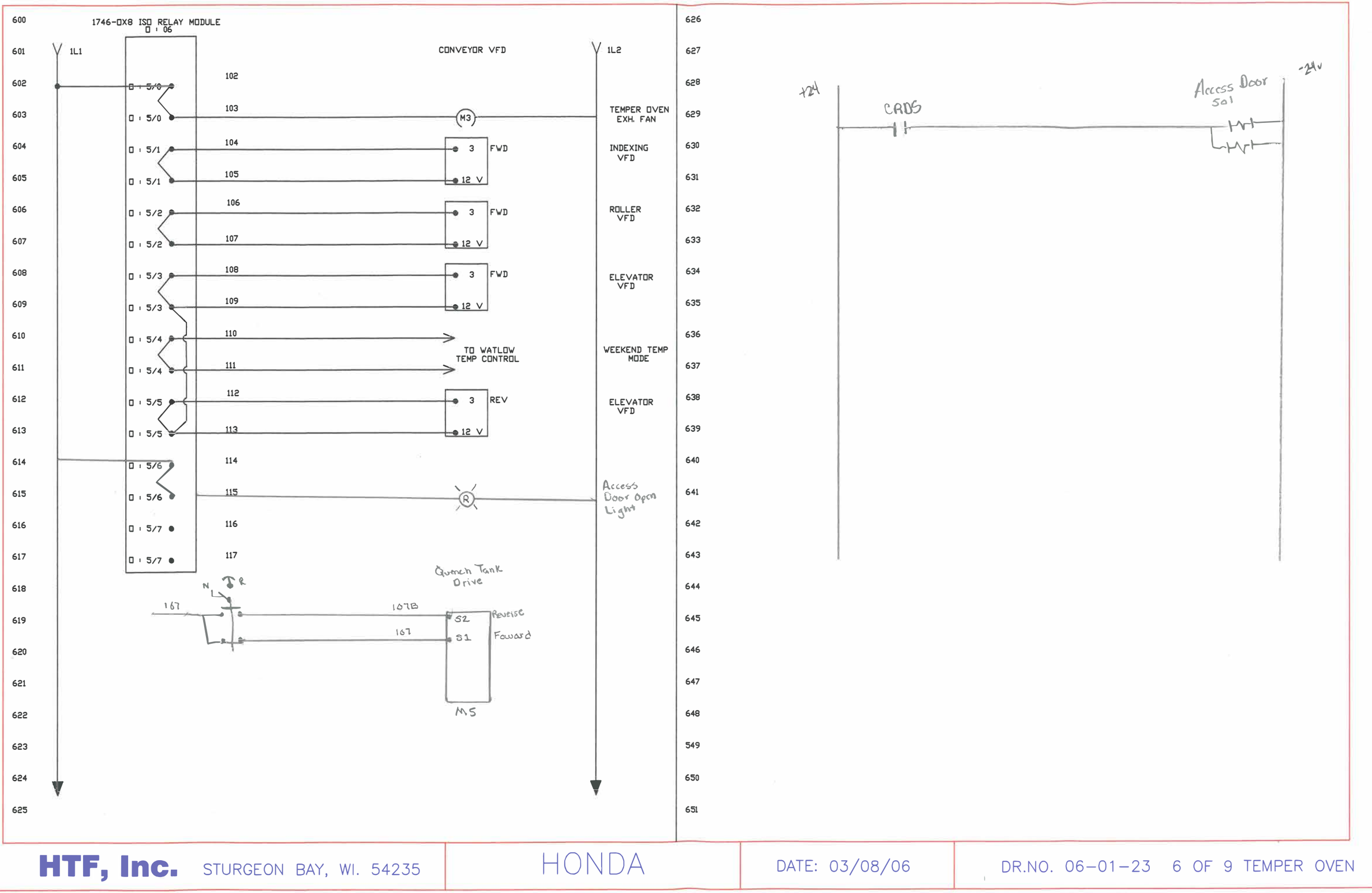
551

TO LINE 600

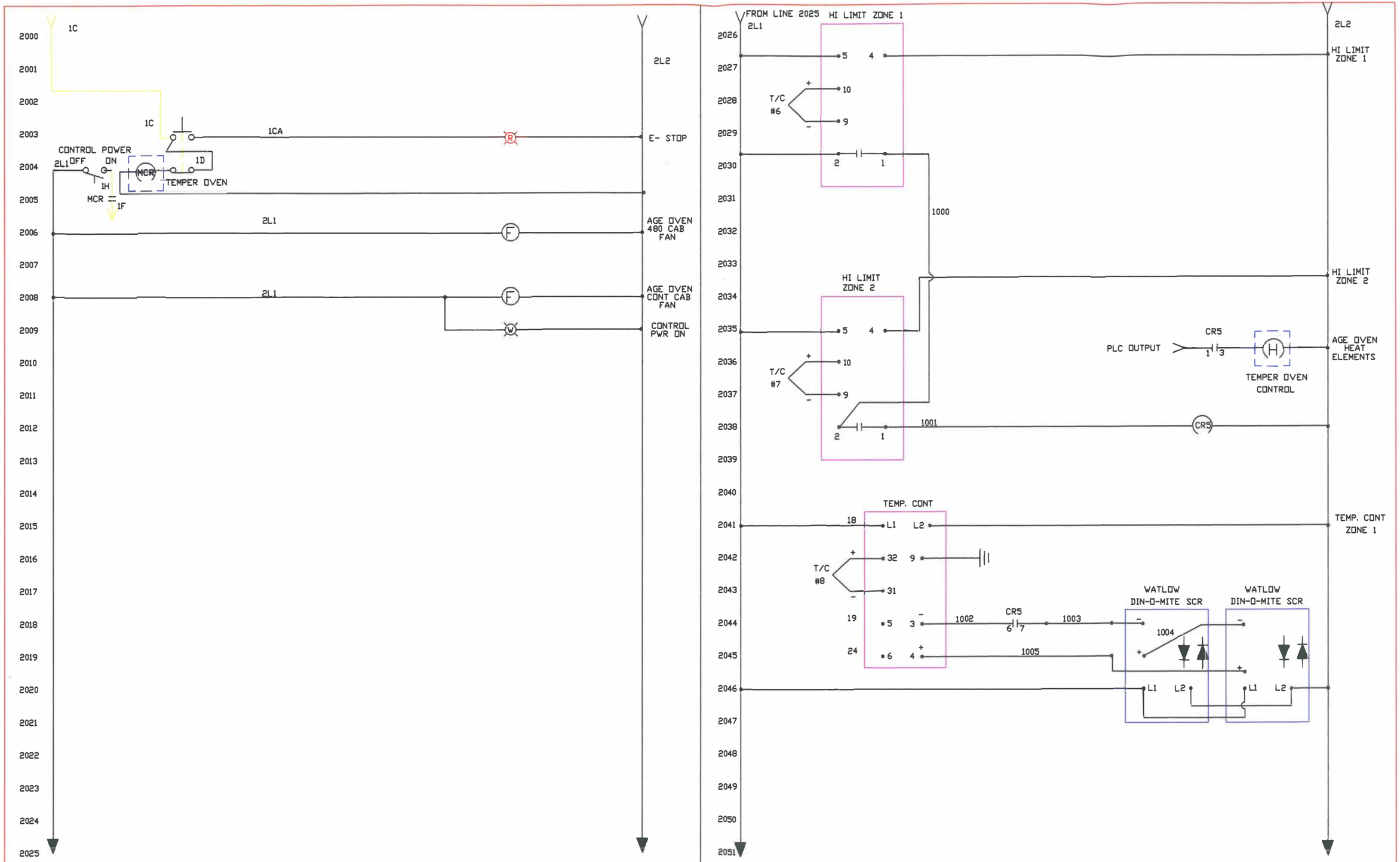
1L2

TO LINE 600

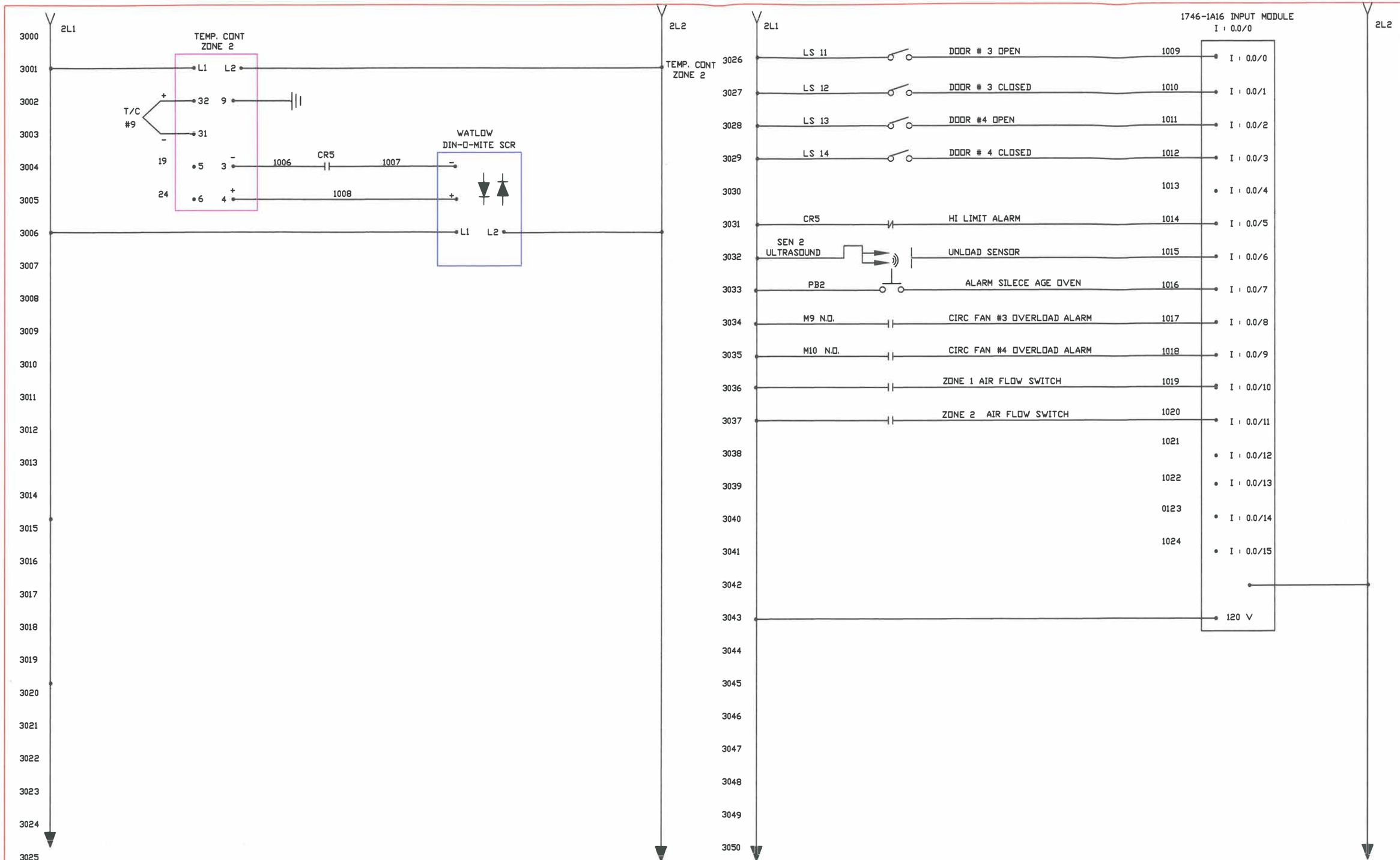
HTF, Inc. STURGEON BAY, WI. 54235 | HONDA | DATE: 03/08/06 | DR.NO. 06-01-23 5 OF 9 TEMPER OVEN



HTF, Inc. STURGEON BAY, WI. 54235	HONDA	DATE: 03/08/06	DR.NO. 06-01-23 6 OF 9 TEMPER OVEN



HTF, Inc. STURGEON BAY, WI. 54235 HONDA DATE: 02/23/06 DR.NO. 06-01-23 7 OF 9 TEMPER OVEN


2L1
TEMP. CONT ZONE 2
L1
L2
T/C #9
+
-
32
9
31
19
5
3
24
6
4
1006
CR5
1007
1008
WATLOW DIN-O-MITE SCR
L1
L2
2L2
TEMP. CONT ZONE 2
2L1
1746-1A16 INPUT MODULE I : 0.0/0
LS 11
DOOR # 3 OPEN
1009
I : 0.0/0
LS 12
DOOR # 3 CLOSED
1010
I : 0.0/1
LS 13
DOOR #4 OPEN
1011
I : 0.0/2
LS 14
DOOR # 4 CLOSED
1012
I : 0.0/3
1013
I : 0.0/4
CR5
HI LIMIT ALARM
1014
I : 0.0/5
SEN 2 ULTRASOUND
UNLOAD SENSOR
1015
I : 0.0/6
PB2
ALARM SILECE AGE OVEN
1016
I : 0.0/7
M9 N.O.
CIRC FAN #3 OVERLOAD ALARM
1017
I : 0.0/8
M10 N.O.
CIRC FAN #4 OVERLOAD ALARM
1018
I : 0.0/9
ZONE 1 AIR FLOW SWITCH
1019
I : 0.0/10
ZONE 2 AIR FLOW SWITCH
1020
I : 0.0/11
1021
I : 0.0/12
1022
I : 0.0/13
0123
I : 0.0/14
1024
I : 0.0/15
120 V
2L2

1746-OX8 ISO RELAY MODULE
O : 4.0

