



**Amplitude Controller  
Model 6006 Series  
OPEN FRAME**



**MODEL 6006.2**

**FLUSH MOUNT**

Circuit Board P/N 24-211



**Input: 240 VAC, 50/60 HZ.**

**Output: 0-240 VAC**

**Single Unit Fuse Size: 8 AMPS**

**80% Duty Cycle at Rated AMPS**

**Note: Mount Open Frame controls within an enclosure.**

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**ADJUSTMENTS  
AND SET UP**

**1. SELECTING OUTPUT PULSE  
MODE**

Choose an output mode of 120 or 60 by sliding the OUTPUT PULSE DIPswitch (S1) to the appropriate position.

Other names for "120 Pulses Per Second" are AC or 7200 VPM (Vibrations Per Minute). "60" is the same as DC or 3600 VPM or Rectified.

**Note: Readjust MAX pot after changing pulse mode setting.**

**2. LIMITING THE MAXIMUM  
OUTPUT OF CONTROL**

Adjust the **MAX** Output trimpot so that the output to the feeder reaches its desired maximum level when the **MAIN CONTROL DIAL** is turned fully clockwise. The **MAX** Output trimpot should be adjusted to keep the vibratory feeder from hammering when the control is turned up to full power.

**NOTE: Output to feeder must be connected and the control set for proper output frequency (60 or 120 pulse) setting. The Run Jumper must be connected as shown on the wiring diagram.**

- A. Power input should be **OFF** or disconnected.
- B. Rotate **MAIN CONTROL DIAL** on front cover to 0 or its minimum setting.
- C. Open cover to allow access to printed circuit card.
- D. Using **CAUTION**, turn power **ON** (no output should be present).
- E. Rotate the **MAIN CONTROL DIAL** on front cover slowly to its highest setting.
- F. Adjust the **MAX** output trimpot so that the output to the feeder reaches its desired maximum level when the **MAIN CONTROL DIAL** is turned fully clockwise. Turning the **MAX** output trimpot clockwise increases the maximum output level.

**3. REMOTE OFF/ON CONTROL**

A Run Jumper has been installed at the factory as shown on the enclosed wiring diagram.

Note: TB2 terminals 5-7 are referenced to the line voltage circuit. Therefore any switch or contact connected to them must be isolated from other circuits.

Remote OFF/ON operation of the control can be configured to operate in one of the following ways.

- A. A low current switch such as a paddle switch can replace the factory-installed Run Jumper "J1." The "Run Contact" connects across terminals 6 and 7. The contact must be able to switch 5VDC and 2mA. The control will then run only when the contact is closed. Refer to Section A of the OFF/ON CONTROL GUIDE.
- B. Feeder Bowl/Hopper Interlock allows the Hopper control to operate only when the Bowl is running and the paddle switch contact is closed. The **interlock input** on terminals 11 and 12 of TB2 is controlled by the **interlock output** of a "Parts Sensing Feeder Bowl Control" such as a 6800 Series control.

Remove jumper "J1" of this control from terminals 6 and 7. Connect the Hopper Paddle switch to alternate terminals 5 and 6. Connect TB2 terminals 11 and 12 of this control to the "Parts Sensing Control". Refer to Section B of the OFF/ON CONTROL GUIDE. Check specific instructions for the "Parts Sensing Control" wiring.

Note: Two 6040 Series controls will not interlock to each other since neither one has an **interlock output**.

- C. Low Voltage DC can be used to turn the control **ON** and **OFF**. Move jumper "J1" from terminal 7, to terminal 5, (6 remains the same). Then connect the positive signal (+10 to 30VDC @ 10mA) to terminal 12 and the negative to terminal 11 of TB2. The control will now turn **ON** when the DC signal is present at terminals 11 and 12 of TB2. This input is optically isolated. Refer to Sect. C of the OFF/ON CONTROL GUIDE. TB-2 terminals 5-7 are transformer isolated from the line voltage circuit.

#### **4. SETTING THE MINIMUM OUTPUT LEVEL OF CONTROL**

When the vibratory feeder is nearly empty, turn the **MAIN CONTROL DIAL** to “1” and adjust the **MIN** trimpot to just below the slowest speed that provides the proper feed rate. The **MIN** trimpot also serves as the “low speed” trimpot for 2-speed operation. See “S1 Programming Chart” for feature selection details.

#### **5. MAIN CONTROL DIAL**

The output power is controlled by the **MAIN CONTROL DIAL**. It is a logarithmic-tapered power out curve (non-linear) that spreads the power broadly across the **MAIN CONTROL DIAL**. The logarithmic taper power curve helps to give maximum “Fine Control” over the output speed of the vibratory feeder. When very precise adjustment of the **MAIN CONTROL DIAL** is needed, increase the **MIN** trimpot setting and/or decrease the **MAX** trimpot setting. For precise scaling at low amplitudes, use the linear POT taper or reduce the Max pot setting. To select a linear pot taper for the Main Control Dial, see the “S1 Programming Chart.”

#### **6. SETTING THE SOFT-START**

The start-up rate of the control output can be adjusted to ramp up to the desired output level instead of starting abruptly. Soft-start keeps parts from falling off the tooling, reduces spring shock, and hammering when the control turns ON. Turn the **SOFT** Start trimpot clockwise for the gentlest start (about a 6 sec. ramp up to full output). Turn the trimpot fully counter-clockwise for no soft start.

#### **7. LINE VOLTAGE COMPENSATION**

Fluctuations in the line voltage can cause a feeder bowl to vary its feed rate. The line voltage compensation feature adjusts the control's output to help compensate for fluctuations in the supply voltage. If it becomes necessary to disable this feature, set “Disable LVC” from the S1 programming chart

#### **8. REMOTE SPEED CONTROL**

Remote control of the power level can be accomplished by the following methods:

- A. 4-20mA signal from a PLC can be used to remotely vary the output of the control instead of the Main Control Dial. The 4-20mA input is automatically in control whenever a 4-20mA signal is applied to the control (terminals TB2-8 & 9). The Main Control

dial setting is ignored whenever there is a 4-20mA signal. The 4-20mA input is transformer isolated from the power line. In an environment with high electrical noise, use a shielded cable for the 4-20mA signal. The “S1 Programming Chart” shows how change to 0-20mA speed control instead of the default of 4-20mA.

- B. A 0-5VDC Analog input signal may be applied in place of the Main Control Dial at H1. The 0-5VDC input is transformer isolated from the power line.

#### **9. SUPPLEMENTARY FEATURES**

Special supplementary software features can be enabled on the 24-210/24-211 circuit boards. The features include: *linear pot taper, 0-20mA control, empty bowl timer, low pulse rates, and two speed pots*. See the S1 Switch Programming Chart. Contact the manufacturer for more information.

#### **10. STATUS LEDs**

When any of the inputs are active, the associated LED will turn ON. When the RUN input conditions are met, the RUN LED will turn ON. See section 3 and the wiring diagram's ON/OFF Control Guide for more information on how to satisfy the RUN conditions.

#### **WARNING:**

**Fuses should be replaced with a Bussman ABC or Littelfuse 3AB "Fast Acting" type or equivalent of manufacturer's original value.**

**Mounting this control directly to a vibrating device will void the warranty.**

#### **TROUBLESHOOTING**

Basic Procedure – To ascertain whether the problem lies in the controller, take the following steps:

- A. Check for good fuses. Disconnect the input power and tighten the screw terminals.
- B. For the control output to be on: Make sure that the proper input power is present. The **MAIN CONTROL DIAL** must be turned up or if the 4-20mA input is used, it must have over 5mA. Either the **DIRECT** LED must be lit or both the **INTERLOCK** and **EXT VOLTS** LEDs must be lit. Anytime the output is turned on, the **RUN** LED will be ON. To light the **DIRECT** LED, a Run Jumper must be connected at

TB2-6 & TB2-7. To light the **INTERLOCK** LED, a Run Jumper must connect TB2-5 to TB2-6. To illuminate the **EXT VOLTS** LED, a 10-30 VDC signal has to be present at TB2-11 & 12. See the section titled “**Remote OFF/ON control**” for more information.

- C. Connect an AC voltmeter across the **LOAD** terminals (with the **LOAD** connected) and vary the **MAIN CONTROL DIAL** from minimum to maximum. In 120 pulse mode, the output should vary from approximately 30% to 98% of the input voltage depending on the setting of the **MIN** and **MAX** trimpots. In 60 pulse mode the output should vary from 20% to around 85% of the input voltage.
- D. On new installations: If the Feeder only hums but it doesn't feed any parts, try changing the **60/120** DIP switch (S1) to the opposite position.

When neither a humming sound nor any vibration can be detected in the vibratory feeder, the problem may be in the controller.

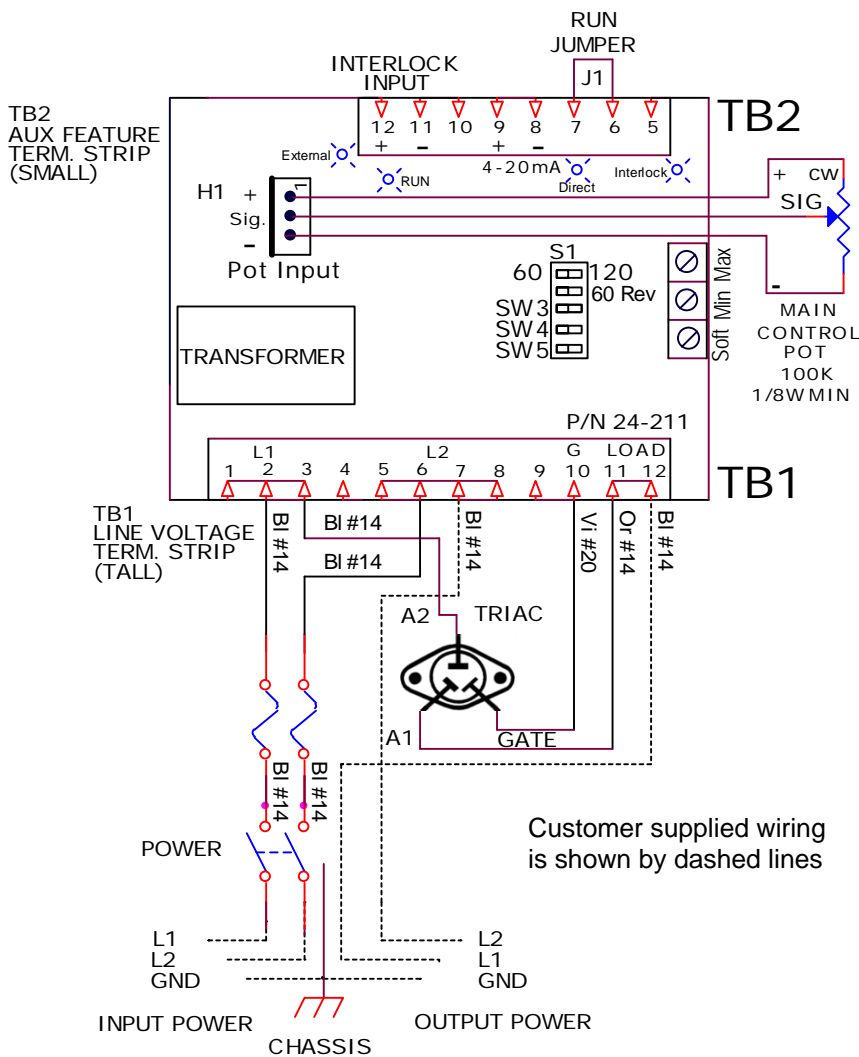
<b>S1 Programming Chart</b>			
<b>Program Description</b>	<b>S1 Switch Positions</b>		
	<b>SW3</b>	<b>SW4</b>	<b>SW5</b>
Standard Program	0	0	0
Linear Pot Taper	1	0	0
0-20mA option	0	1	0
Empty Bowl Timer	1	1	0
Disable LVC	0	0	1
2-Speed Operation	1	0	1
30/40 Pulse Operation	0	1	1
Low Voltage at “1”	1	1	1

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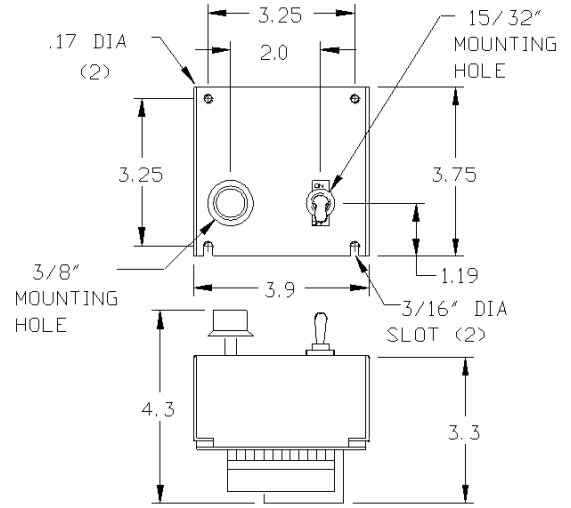
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### MODEL 6006.2 OPEN FRAME MODEL INSTRUCTIONS



MODEL	INPUT VAC	AMPS	OUTPUT
6006.2	240VAC	8A	0-240

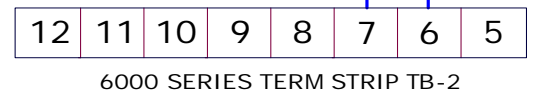
### DIMENSIONS



### OFF/ON CONTROL GUIDE

P/N 24-210/24-211  
 See section 3 of the Application Note for more details.

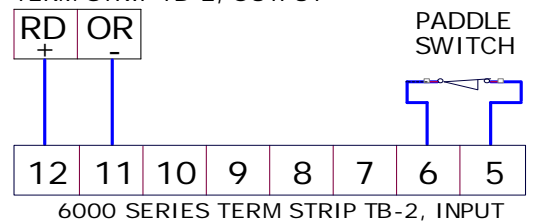
#### A) LOW CURRENT SWITCH



6000 SERIES TERM STRIP TB-2

#### B) FEEDER BOWL/HOPPER INTERLOCK

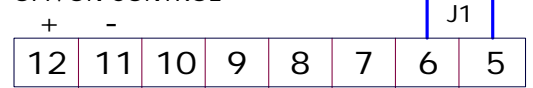
6800 SERIES  
 TERM STRIP TB-2, OUTPUT



6000 SERIES TERM STRIP TB-2, INPUT

#### C) LOW VOLTAGE INPUT SWITCHING (DC Voltage from PLC)

10-30 VDC INPUT VOLTAGE  
 OFF/ON CONTROL



6000 SERIES TERM STRIP TB-2