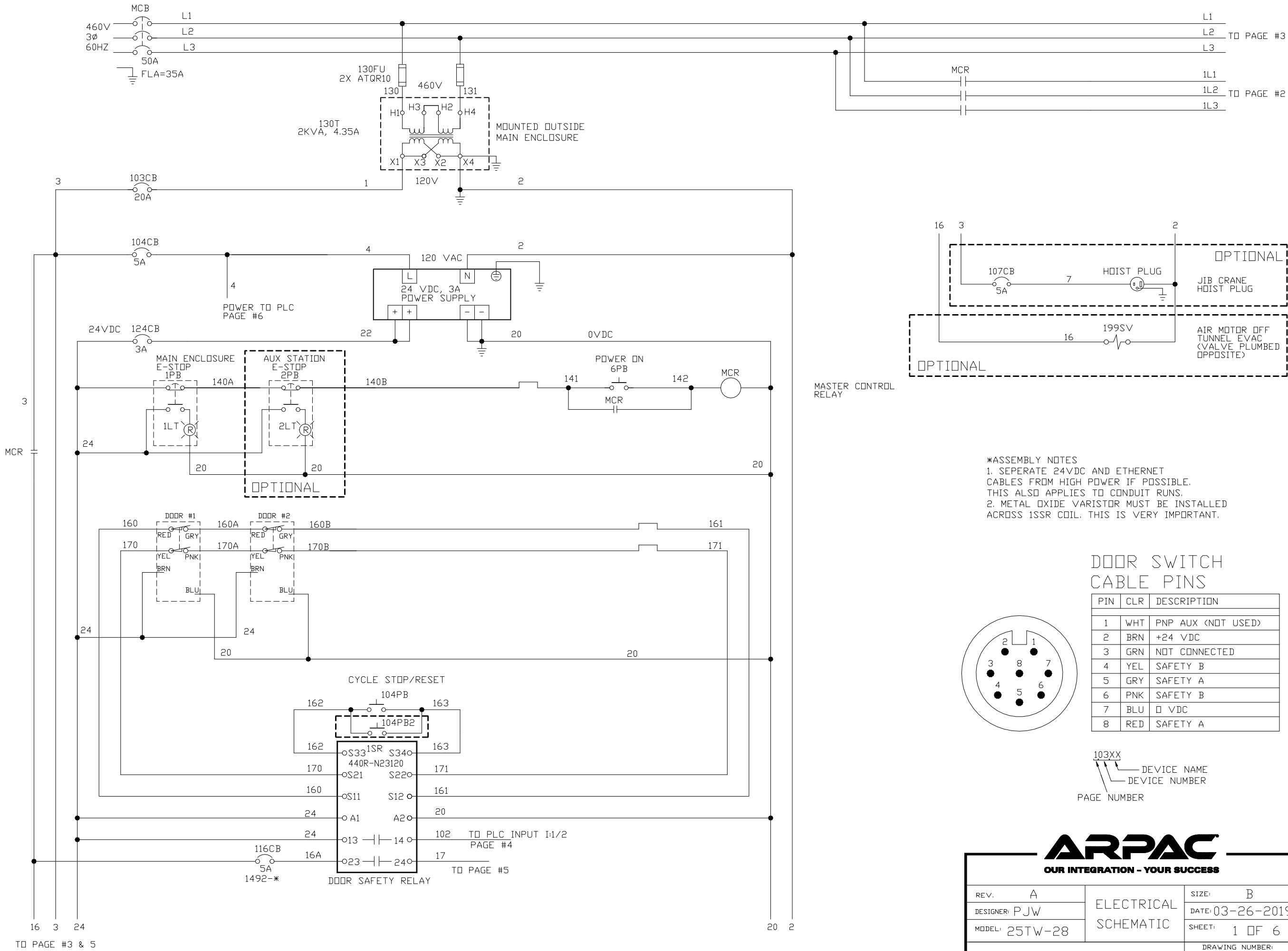




1L1
1L2
1L3

FROM PAGE #1

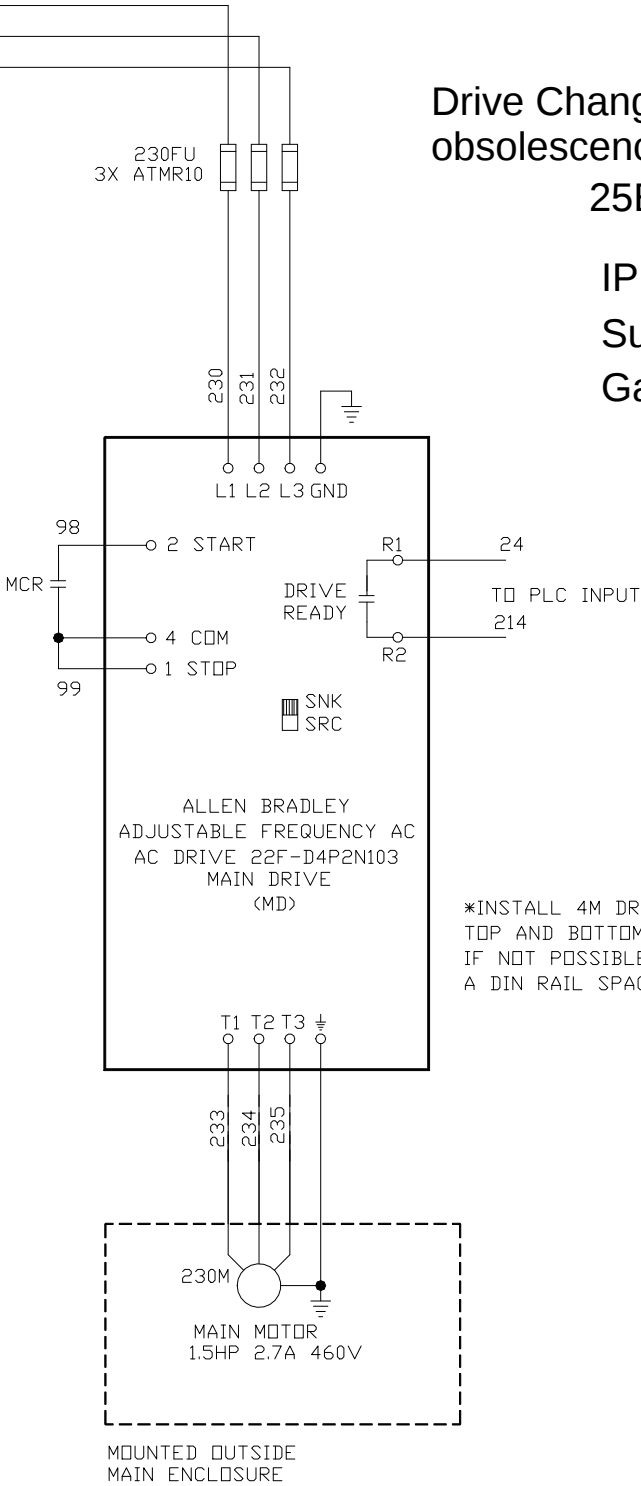
POWERFLEX 4M VFD
DRIVE PARAMETER SETTINGS

ID	DESCRIPTION	VALUE
P101	MOTOR NAMEPLATE VOLTS	460
P102	MOTOR NAMEPLATE HERTZ	60
P103	MOTOR OL CURRENT	*
P104	MINIMUM FREQUENCY	0
P105	MAXIMUM FREQUENCY	60
P106	START SOURCE	2
P107	STOP MODE	0
P108	SPEED REFERENCE	1
P109	ACCEL TIME 1	2.0
P110	DECEL TIME 1	2.0
A409	INTERNAL FREQUENCY	**
A433	START AT POWER UP	1
A451	AUTO RESTART TRIES	4
A452	AUTO RESTART DELAY	1.0

* SET TO MOTOR NAMEPLATE VALUE
** SET TO PRODUCT RATE

Power Flex 525 VFD
Drive Parameter Settings

P031 - Motor Nameplate Volts -----	460	C128 - EN Addr Sel -----	1
P032 - Motor Nameplate Hertz -----	60	C129 - EN IP Addr Cfg1 -----	10
P033 - Motor Nameplate OL Current --	2.3	C130 - EN IP Addr Cfg2 ----	255
P041 - Accel Time 1 -----	2.0	C131 - EN IP Addr Cfg3 ----	255
P042 - Decel Time 1 -----	2.0	C132 - EN IP Addr Cfg4 -----	44
P043 - Min Frequency -----	0	C133 - EN Subnet Cfg1 ----	255
P044 - Max Frequency -----	60	C134 - EN Subnet Cfg2 ----	255
P045 - Stop Mode -----	0	C135 - EN Subnet Cfg3 ----	255
P046 - Start Source 1 -----	5	C136 - EN Subnet Cfg4 -----	0
P047 - Speed Reference 1 -----	15	C137 - EN Gateway Cfg1 ----	10
A541 - Auto Restart Tries -----	4	C138 - EN Gateway Cfg2 ---	255
A542 - Auto Restart Delay -----	1.0	C139 - EN Gateway Cfg3 ---	255
A543 - Start at Powerup -----	1	C140 - EN Gateway Cfg4 ---	100



Drive Changed to Allen Bradley 525 due to
obsolescence and functionality on 06/15/2025
25B - D4P0N104 Series A

IP Addr: 10.255.255.4
Subnet: 255.255.255.0
Gateway: 10.255.255.100

*INSTALL 4M DRIVE WITH 4.7" CLEARANCE
TOP AND BOTTOM. 1" LEFT AND RIGHT.
IF NOT POSSIBLE, BRING THE DRIVE OUT WITH
A DIN RAIL SPACER.

103XX
DEVICE NAME
DEVICE NUMBER
PAGE NUMBER

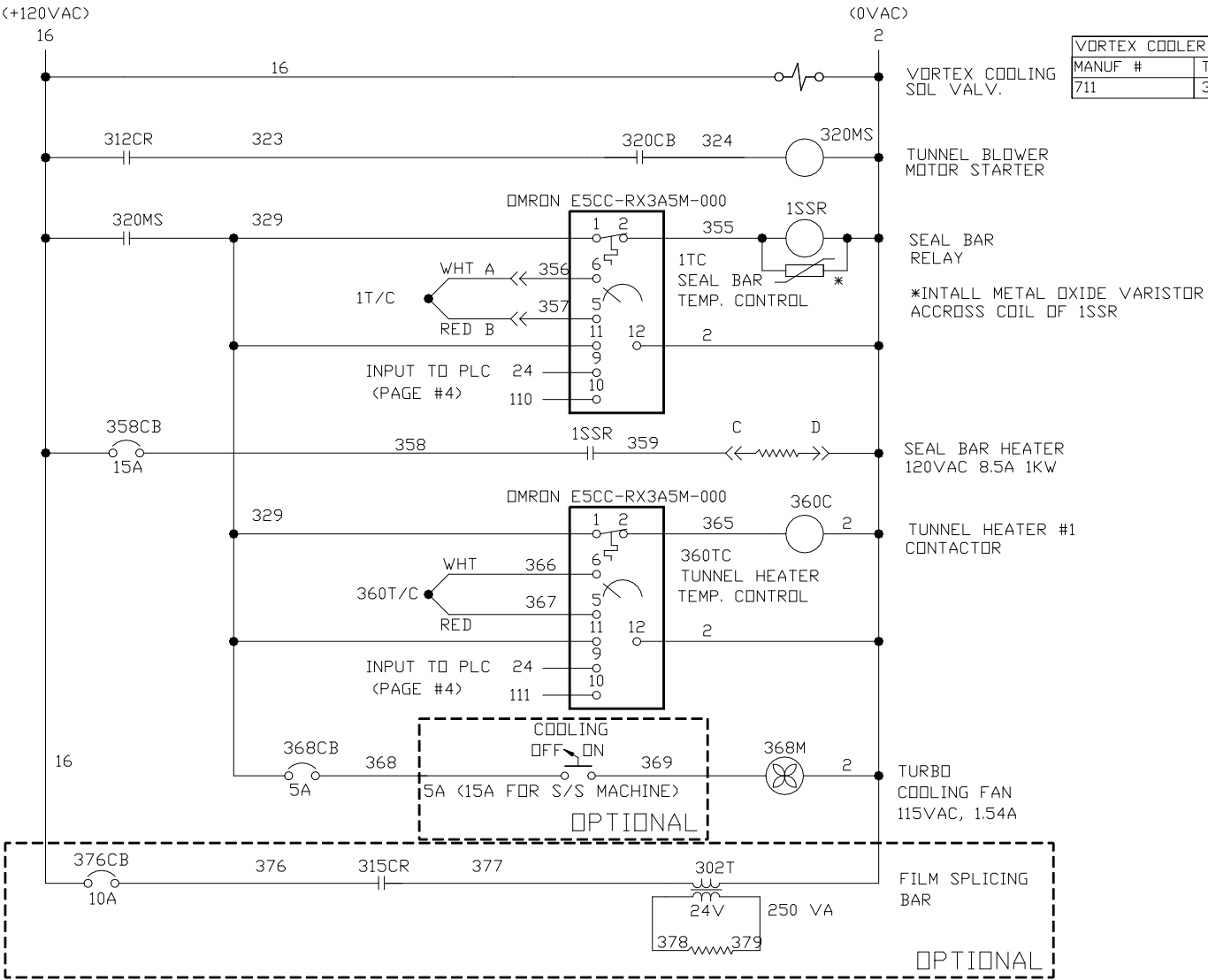
- NOTES:
1. USE BELDON #8761 OR EQUIVALENT 18GA WIRE
 2. CONNECT SHIELD ONLY AT DRIVE END (TERMINAL GND) STUB AND INSULATE OTHER END.

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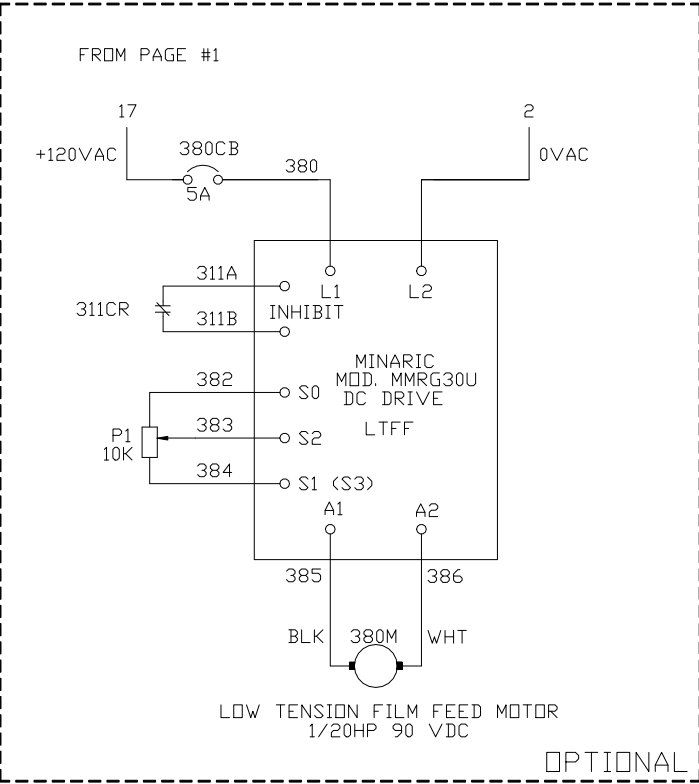
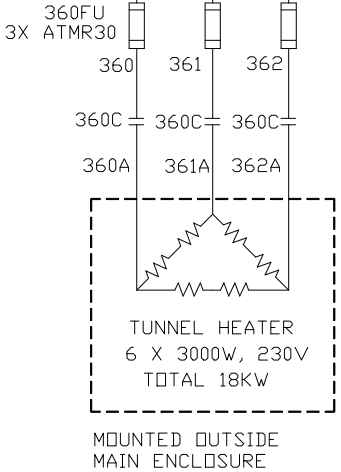
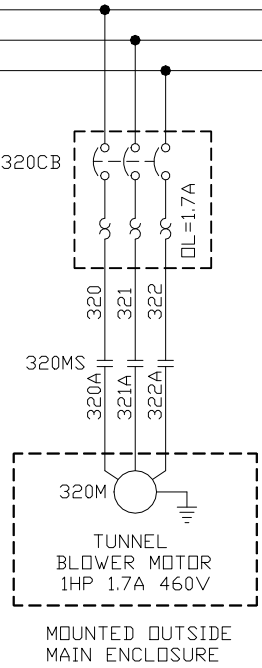
REV. A	ELECTRICAL SCHEMATIC	SIZE: B
DESIGNER: PJW		DATE: 03-26-2019
MODEL: 25TW-28		SHEET: 2 OF 6
BLUE MARBLE		DRAWING NUMBER: 16423-02

460VAC
FROM PAGE #1

L1
L2
L3



VORTEX COOLER TUBE CHART	
MANUF #	TUBE SIZE
711	3/8"



OMRON E5CC TEMPERATURE CONTROLLER SET UP
(DIFFERENT THAN DEFAULT)

INITIAL SETTING GROUP		
DISPLAY	PARAMETER DESCRIPTIONS	SETTING
CN-t	INPUT TYPE	7
d-U	C/F SELECTION	F
SL-H	SET POINT UPPER LIMIT	500
SL-L	SET POINT LOWER LIMIT	0
ALt1	ALARM 1 TYPE	3
ALt2	ALARM 2 TYPE	0
ALt3	ALARM 3 TYPE	0

OPERATION LEVEL		
DISPLAY	PARAMETER DESCRIPTIONS	SETTING
	TEMPERATURE SETTING	*
AL-1	ALARM VALUE	40**

* VARIES FOR TUNNEL, SEAL BAR, ETC.
** 40 FOR TUNNEL, 25 FOR SEAL BAR
STEP #2: GO BACK TO THE MAIN OPERATOR SCREEN. SET THE TEMPERATURE USING THE ARROWS. USE THE BUTTON TO FIND THE PARAMETER(S) ABOVE.

PROTECT GROUP		
DISPLAY	PARAMETER DESCRIPTIONS	SETTING
oAPt	OPERATION/ADJUSTMENT	1
CPt	INITIAL/COMMUNICATION	2

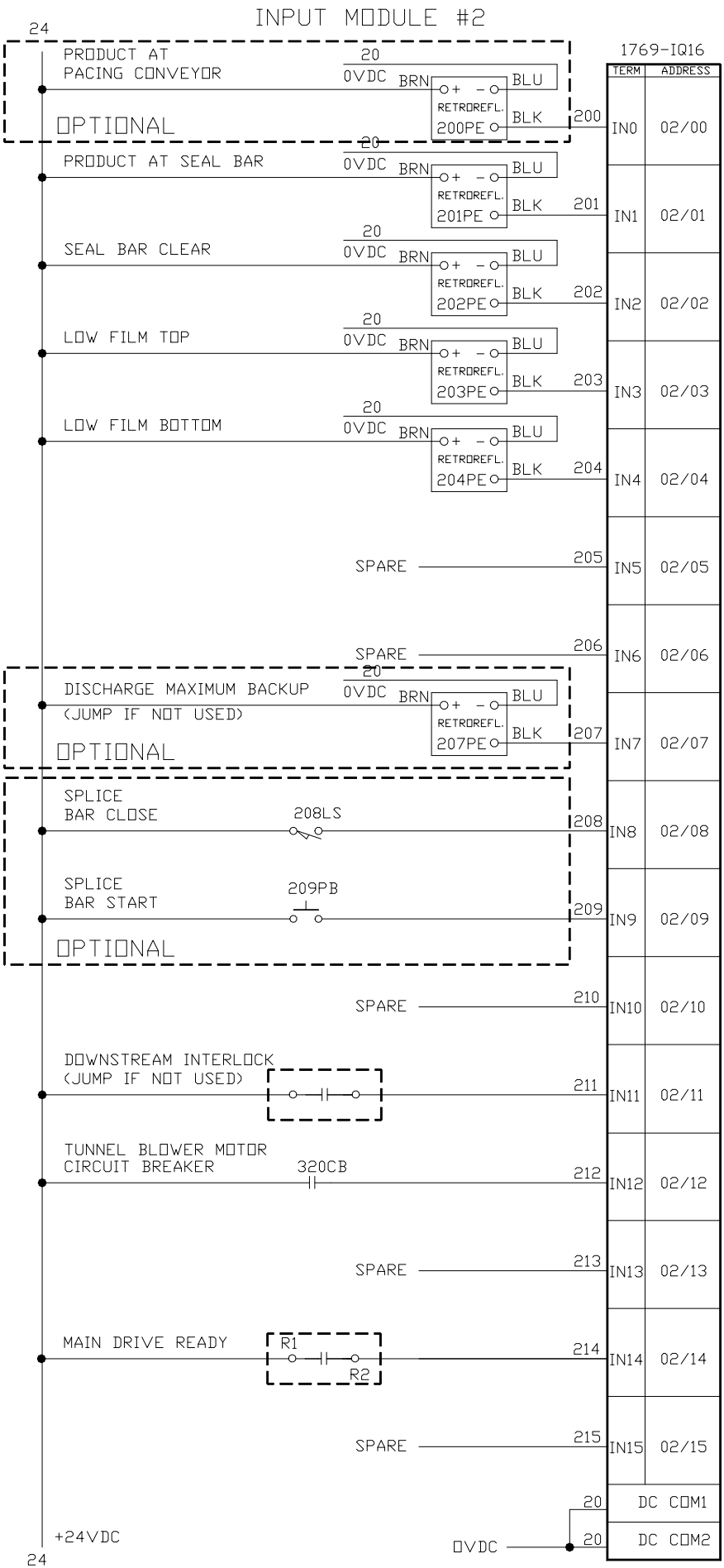
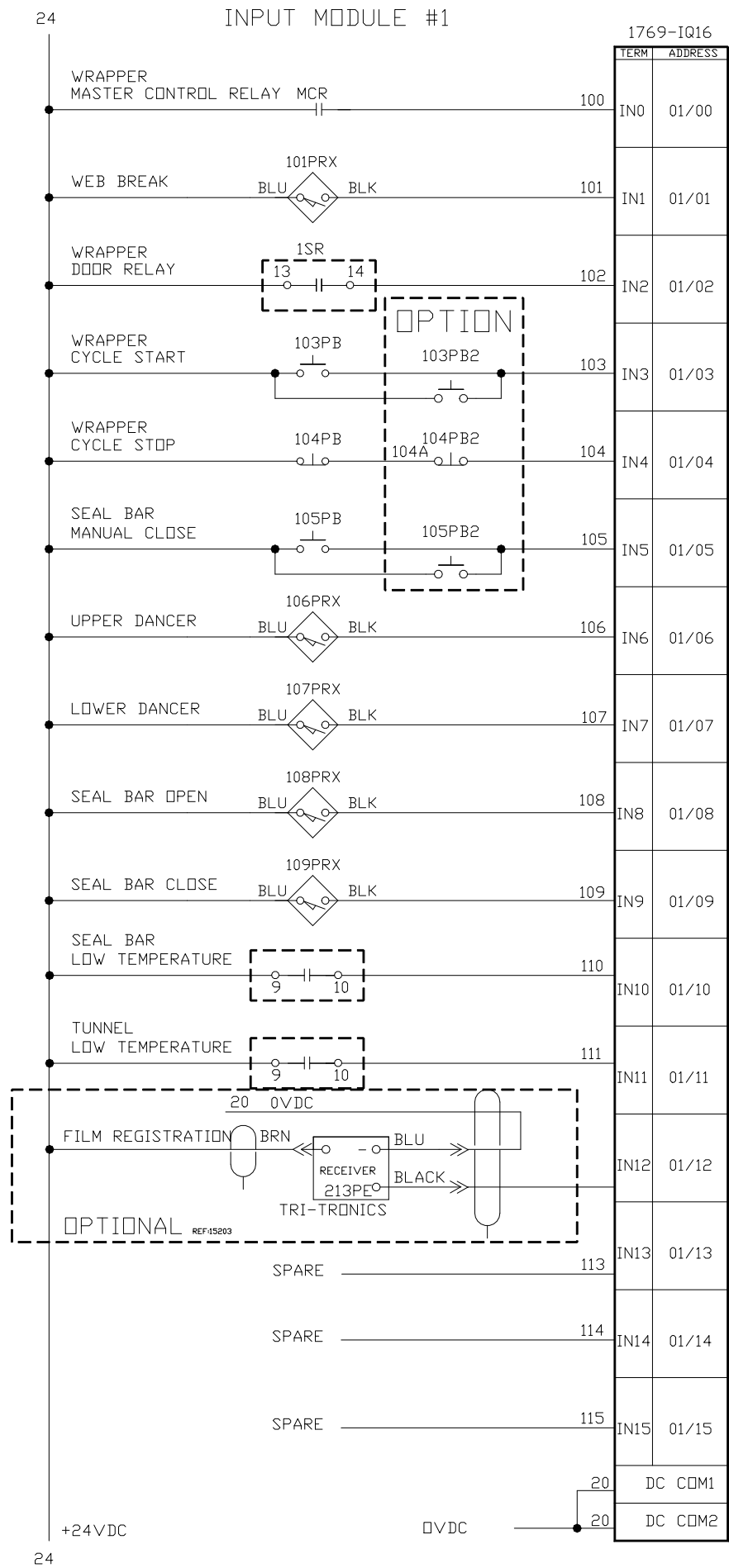
STEP #3: HOLD AND FOR 3 SECONDS. SET THE PARAMTERS ABOVE.

STEP #1: HOLD FOR AT LEAST 3 SECONDS AND INPUT THE PARAMETERS ABOVE. CYCLE THROUGH THE PARAMETERS USING THE BUTTON.

103XX
— DEVICE NAME
— DEVICE NUMBER
PAGE NUMBER

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REV. A	ELECTRICAL SCHEMATIC	SIZE: B
DESIGNER: PJW		DATE: 03-26-2019
MODEL: 25TW-28		SHEET: 3 OF 6
BLUE MARBLE		DRAWING NUMBER: 16423-03



103XX

DEVICE NAME

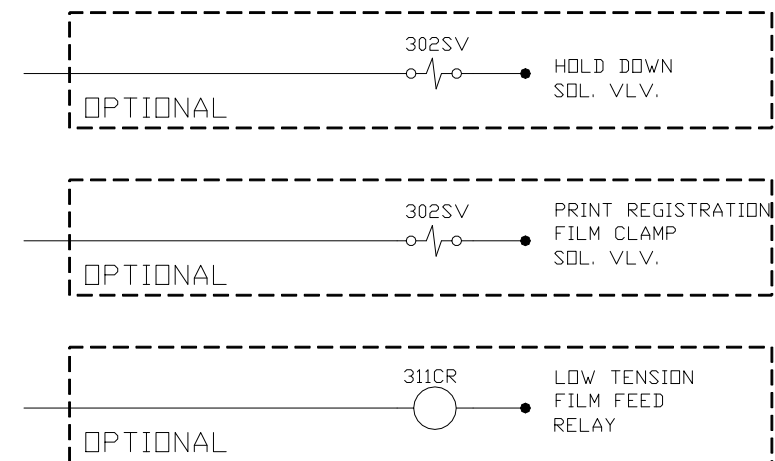
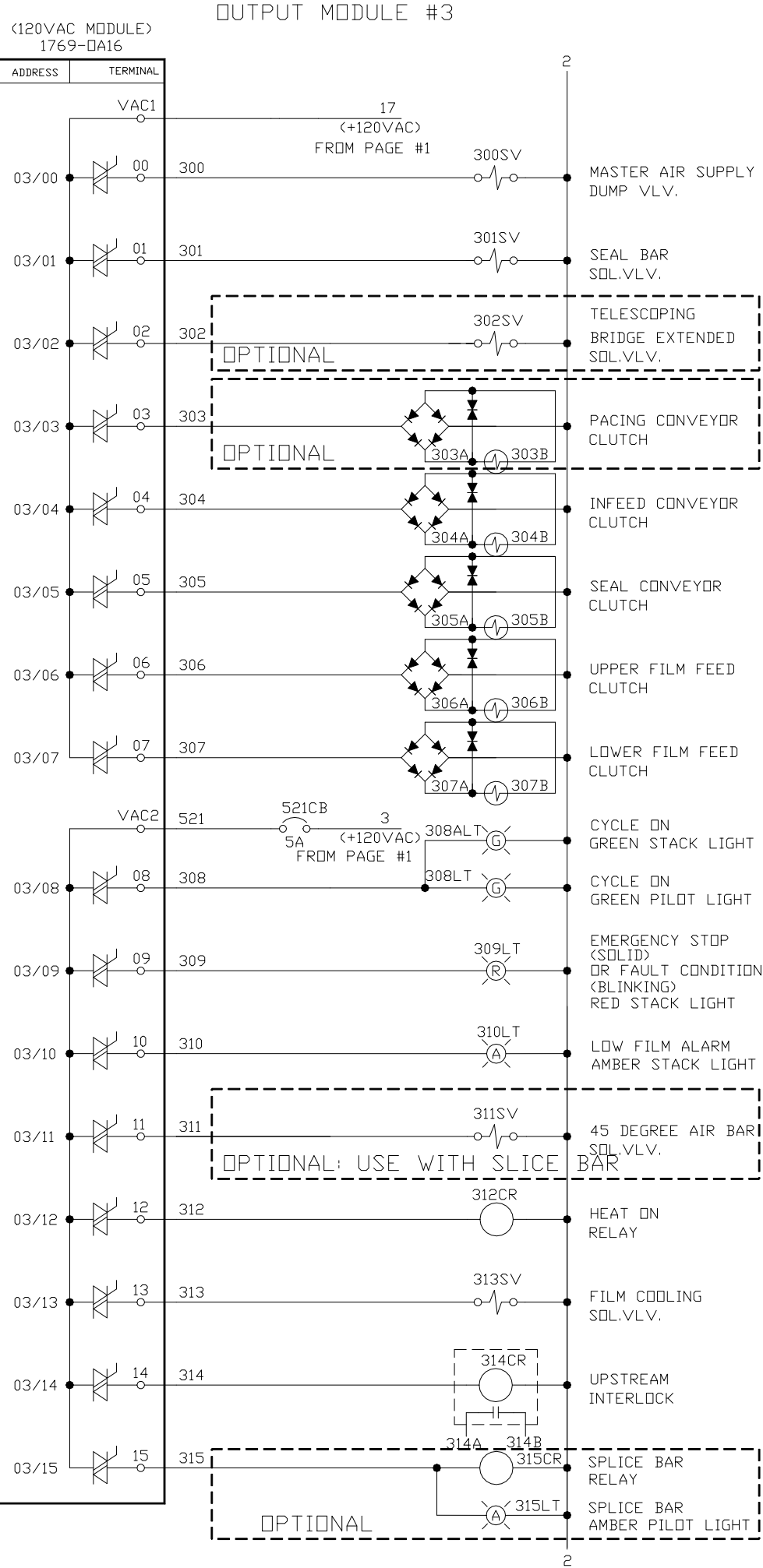
DEVICE NUMBER

PAGE NUMBER

ARPAC

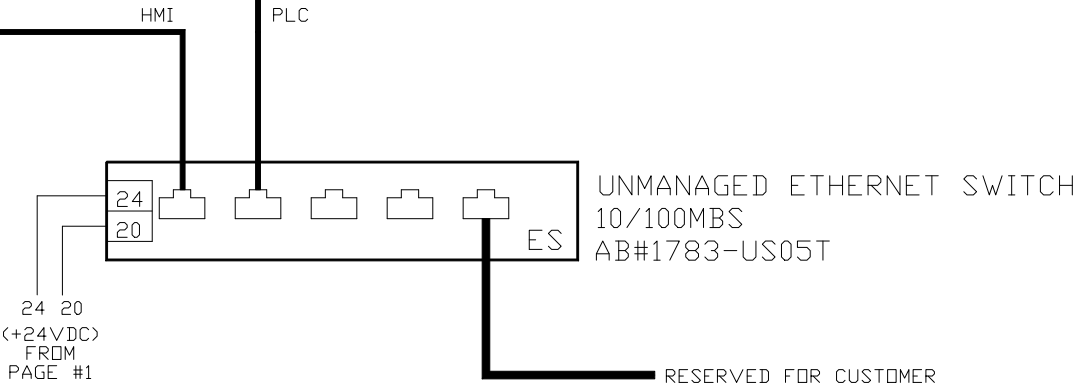
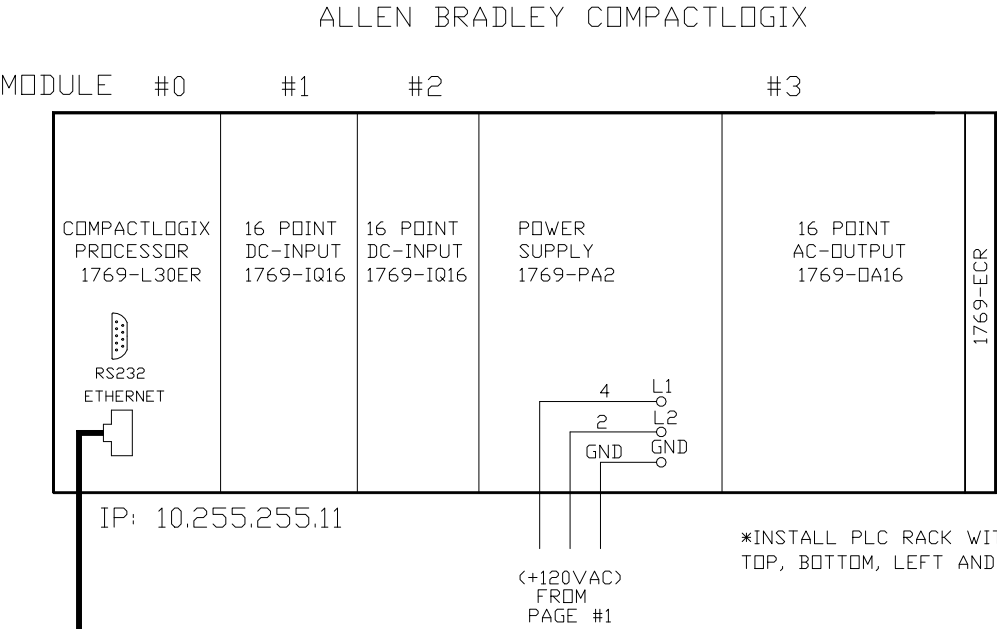
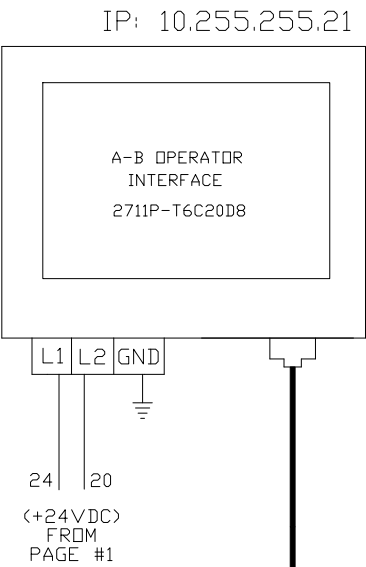
OUR INTEGRATION - YOUR SUCCESS

REV. A	ELECTRICAL SCHEMATIC	SIZE: B
DESIGNER: PJW		DATE: 03-26-2019
MODEL: 25TW-28		SHEET: 4 OF 6
BLUE MARBLE		DRAWING NUMBER: 16423-04



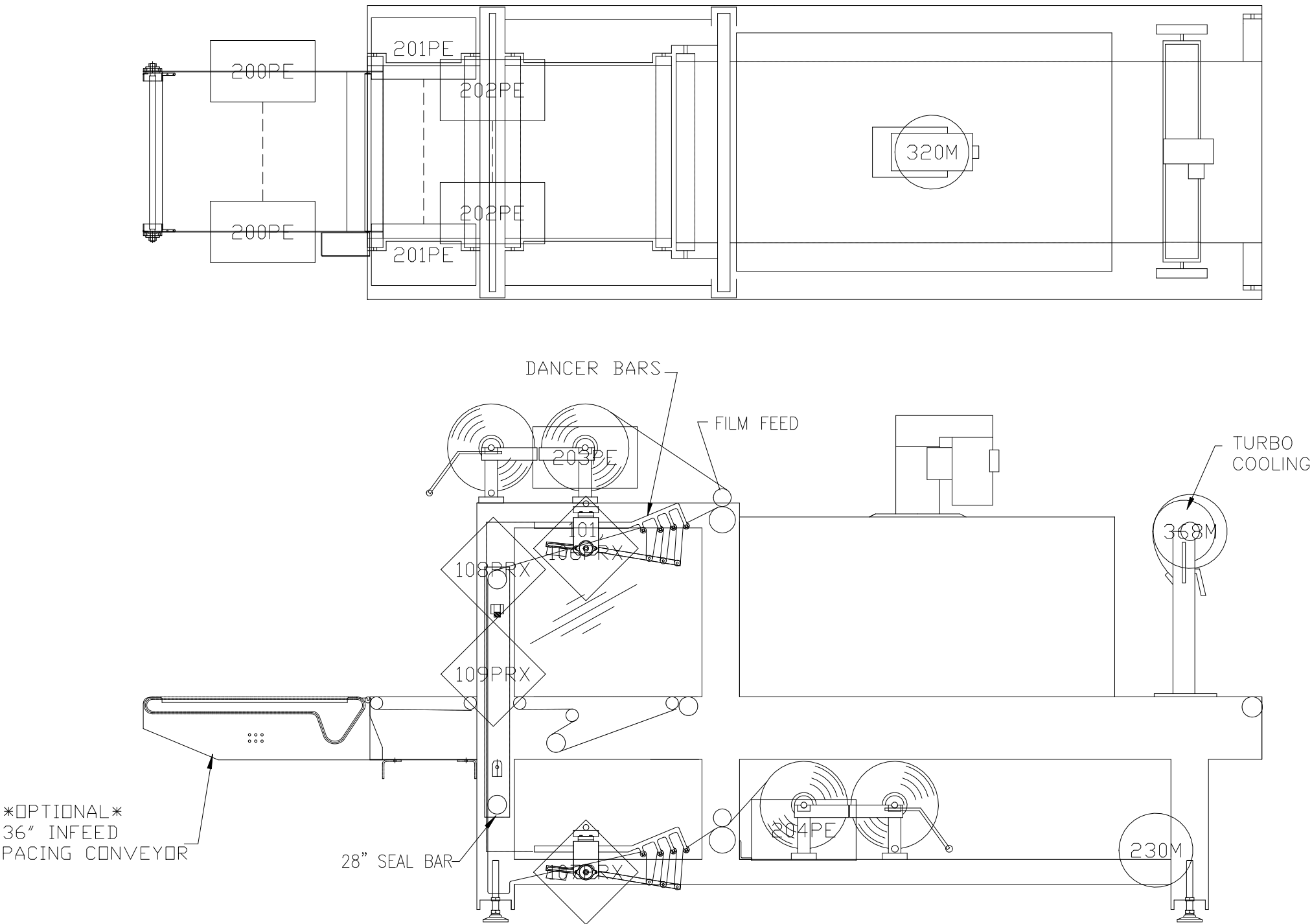
103XX
— DEVICE NAME
— DEVICE NUMBER
PAGE NUMBER

ARPAC		
OUR INTEGRATION - YOUR SUCCESS		
REV. A	ELECTRICAL SCHEMATIC	SIZE: B
DESIGNER: PJW		DATE: 03-26-2019
MODEL: 25TW-28		SHEET: 5 OF 6
BLUE MARBLE		DRAWING NUMBER: 16423-05



ARPAC			
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REV. A	ELECTRICAL SCHEMATIC	SIZE: B	
DESIGNER: PJW		DATE: 03-26-2019	
MODEL: 25TW-28		SHEET: 6 OF 6	
BLUE MARBLE		DRAWING NUMBER: 16423-06	

25TW DEVICE LOCATION LAYOUT

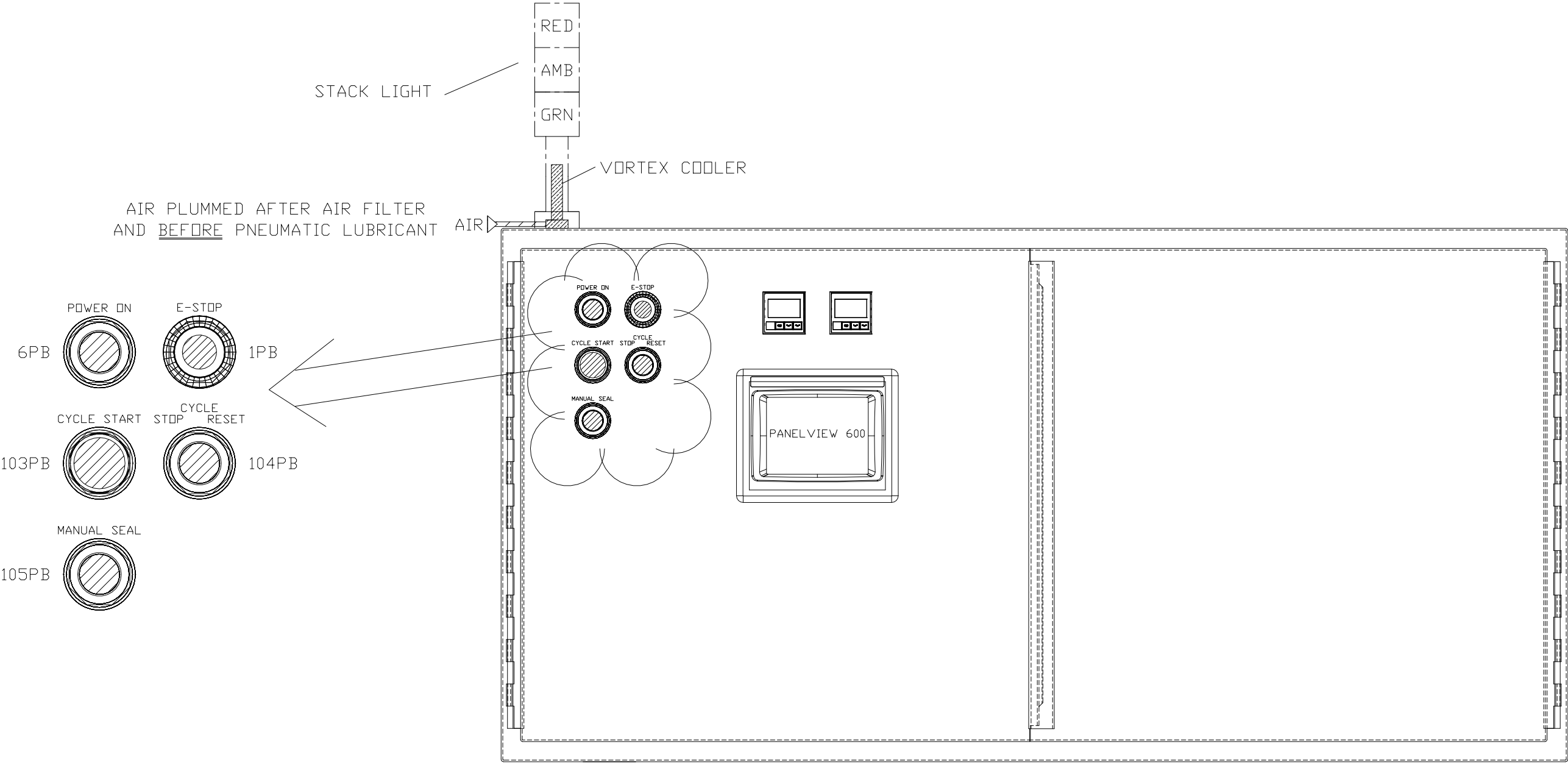


*ANY CUSTOM CHANGES WILL NOT BE ON LAYOUT

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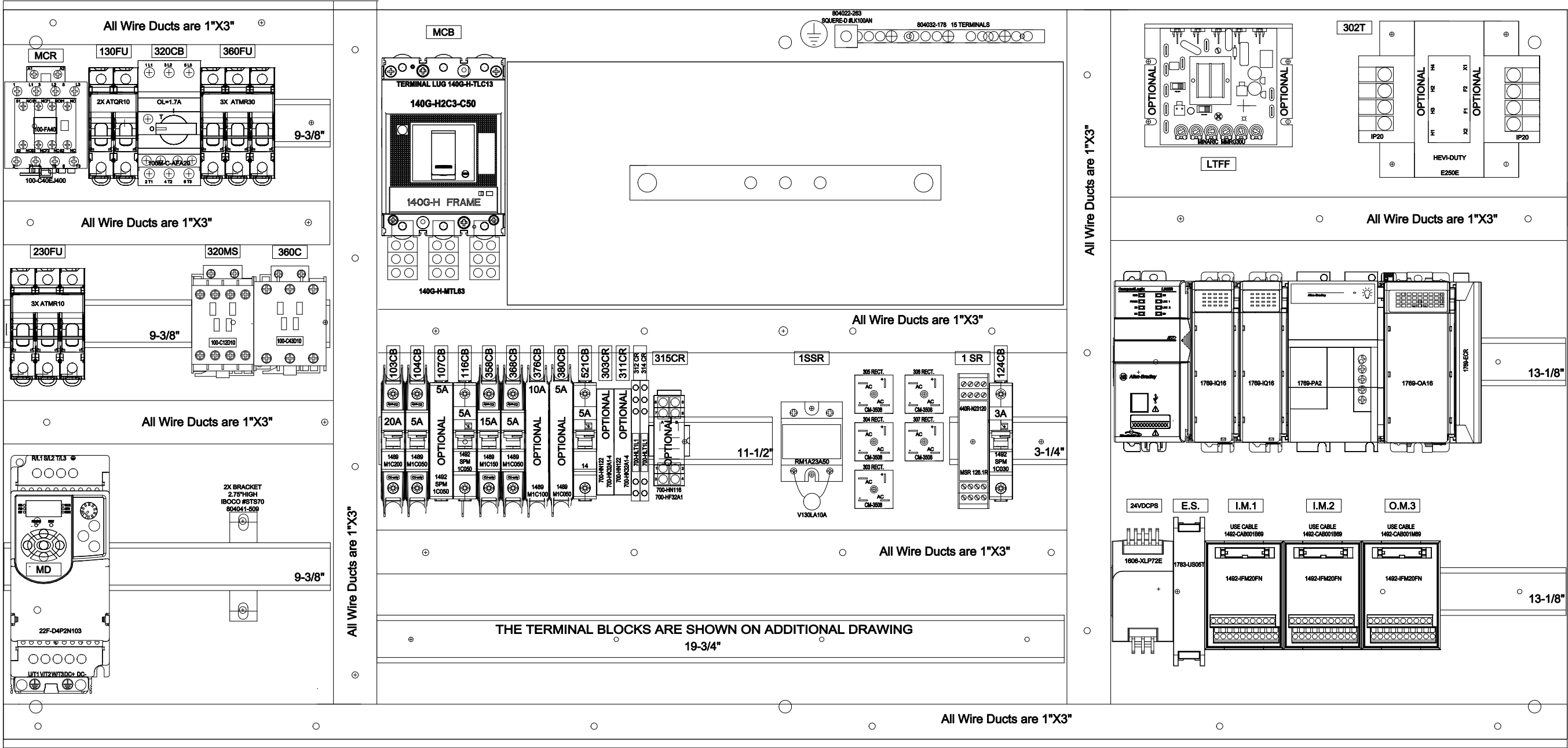
REV. A	ELECTRICAL SCHEMATIC	SIZE: B
DESIGNER: PJW		DATE: 03-26-2019
MODEL: 25TW-28		SHEET: 1 OF 1
BLUE MARBLE		DRAWING NUMBER: 16423_L/□-01

ENCLOSURE LAYOUT FOR RIGHT HANDED MACHINE. FLIP LAYOUT FOR LEFT HANDED MACHINES.



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REV. A	ELECTRICAL SCHEMATIC	SIZE: B
DESIGNER: PJW		DATE: 09-18-2015
MODEL: 25TW-28		SHEET: 1 OF 1
ENCLOSURE LAYOUT		DRAWING NUMBER: LAYOUT-01



LAYOUT FOR THE LEFT HAND MACHINE

*Custom options may not be represented on this layout

ARPAC

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REV. A	ELECTRICAL SCHEMATIC	SIZE: B
DESIGNER: PJW		DATE: 03-09-2018
MODEL: 25TW-28		SHEET: 7 OF 9
ARPAC		DRAWING NUMBER: #####-07

Arpac BOM

Parent Number: 16423-E Parent Revision: 0
Description: ASSY, ELEC, #16423, 25TW-28-LH, 460V
Model:

Assembly Part Number: 16423-ELEC
Description: ASSY, ELEC, #16423, 25TW-28-LH, 460V

Item	Qty	Arpac Part	Description
1	1.00	123456-026N	25TW-28, ELEC, SUBASSY, CORE, LH, COMPACTLOGIX L30ER
2	1.00	123456-027E	25TW-28 (460V) HIGH VOLTAGE, ELEC, SUBASSY, POWERFLEX 4M

Arpac BOM

Parent Number: 16423-EL Parent Revision: 0

Description: ASSY, ELEC, #16423, 25TW-28-LH, 460V

Model:

Assembly Part Number: 123456-026N

Assembly Drawing Number: 123456

Description: 25TW-28, ELEC, SUBASSY, CORE, LH, COMPACTLOGIX L30ER

Quantity: 1.00

Item	Qty	Arpac Part	Description
1	5.00	804003-139	CABLE, QD, 5M 90-DEGREE MICRO 4-PIN BLK PVC, (USE 848706 FOR STRETCH)
2	2.00	804003-135	CABLE, QD, 5M STRAIGHT MICRO 4-PIN BLK PVC
3	2.00	804003-204	CABLE, QD, 5M STRAIGHT MICRO 8-PIN BLK PVC
4	1.00	804000-758	CIRCUIT BREAKER, 1P 3A 277V TRIP=05-10 IR=10KA UL1077 SUPPLEMENTAL PROT
5	2.00	804000-760	CIRCUIT BREAKER, 1P 5A 277V TRIP=05-10 IR=10KA UL1077 SUPPLEMENTAL PROT
6	2.00	804000-655	CIRCUIT BREAKER, 1P 5A 277V TRIP=05-10 IR=10KA UL489
7	1.00	804000-658	CIRCUIT BREAKER, 1P 15A 277V TRIP=05-10 IR=10KA UL489
8	1.00	804000-659	CIRCUIT BREAKER, 1P 20A 277V TRIP=05-10 IR=10KA UL489
9	1.00	804035-006	CONTACT, AUX. 2NO, FRONT MOUNT, FOR 140M BREAKERS
10	1.00	804035-016	CONTACT, AUX. 4NO, TOP MOUNTED FOR IEC CONTACTORS 100-C ALL
11	1.00	804002-002	CONTACTOR, IEC 12A COIL=120VAC 1NO LINE-SIDE-COIL
12	1.00	804002-117	CONTACTOR, IEC 4P 37A COIL= 24VDC 4NO LINE-SIDE-COIL W/INTEGRATED-D
13	1.00	804044-193	ENCLOSURE, 21X45, LH, SUB PANEL FOR CUSTOM 25TW/45TW ENCLOSURES
14	1.00	804044-226	ENCLOSURE, 24X 48X 10 ENCLOSURE, LH INCLUDES CUTOOTS FOR HEATER AND DOORS
15	1.00	804005-345	ETHERNET SWITCH, 5 PORT (COPPER), UNMANAGED, DIN RAIL MOUNT, STRATIX 2000
16	4.00	804027-001	LEGEND PLATE, BLANK STANDARD GRAY
17	1.00	804027-023	LEGEND PLATE, YELLOW E-STOP ROUND FOR 30MM PB
18	1.00	804017-046	LIGHT STACK, 70MM BASE 16IN AL NEMA4 BLK-HOUSING W/CAP-&-GASKET
19	1.00	804017-026	LIGHT STACK, 70MM GRN 120VAC NEMA4X BLK-HOUSING STEADY-INCANDESCENT
20	1.00	804017-027	LIGHT STACK, 70MM RED 120VAC NEMA4X BLK-HOUSING STEADY-INCANDESCENT
21	1.00	123456-202B	LOW FILM ALARM KIT ELECTRICAL COMPONENTS A-B
22	1.00	804018-249	OPERATOR INTERFACE, PANELVIEW PLUS 7 - 7", PERFORMANCE MODEL, BRANDLESS B
23	2.00	804007-234	PHOTO SENSOR, REFLECTOR, 1.25" ROUND, W M5 MTG SCREW POST
24	2.00	804007-135	PHOTO SENSOR, RETRO-POLAR DC PNP QD RANGE=3M W/6IN-PIGTAIL NEMA4X/6P
25	1.00	804005-271	PLC, COMPACTLOGIX, ACCESSORY END CAP RIGHT
26	2.00	804005-303	PLC, COMPACTLOGIX, ACCESSORY, IFM CBL 0.1M 1769-IQ16 AND -IQ16F INPUTS
27	1.00	804005-305	PLC, COMPACTLOGIX, ACCESSORY, IFM CBL 0.1M 1769-OA16 & -OW16 OUTPUTS TO
28	2.00	804005-266	PLC, COMPACTLOGIX, DIGITAL 16IN 24VDC SINK/SOURCE
29	1.00	804005-267	PLC, COMPACTLOGIX, DIGITAL 16OUT 120/240VAC
30	1.00	804005-269	PLC, COMPACTLOGIX, POWER SUPPLY, 120/240VAC, 2.0A @ 5VDC, 0.8A @ 24VDC
31	1.00	804005-349	PLC, COMPACTLOGIX, CPU 1MB, DUAL ETHERNET, USB PORT, NO MOTION
32	3.00	804993-133	PLC, IFM BASE, DIGITAL, 20PT, 2-LEVEL, NARROW
33	1.00	804993-138	POWER SUPPLY 24VDC 3.0AMP
34	5.00	804006-130	PROXIMITY SENSOR, DC 2-WIRE 4.0MM NO QD 12MM UNSHIELDED SHORT-BARREL, S/A
35	1.00	804004-008	PUSH BUTTON, 30MM EXTENDED RED MOMENTARY 1NO/1NC NEMA4
36	1.00	804004-009	PUSH BUTTON, 30MM FLUSH GRN MOMENTARY 1NO/1NC NEMA4
37	1.00	804004-013	PUSH BUTTON, 30MM FLUSH YEL MOMENTARY 1NO/1NC NEMA4
38	1.00	804004-372	PUSH BUTTON, 30MM GUARDED GRN ILL LED 12-130V, MOMENTARY 1NO/1NC, UL TYPE
39	1.00	804004-108	PUSH BUTTON, 30MM MUSHROOM RED ILL LED 12-130V, PUSH-PULL 1NO/1NCLB NE
40	5.00	804001-001	RECTIFIER, BRIDGE 35.0A 800V
41	2.00	804008-107	RELAY, EXTRA SLIM, SPDT COIL=115VAC 6A W/LED REV-POL&COIL-SURGE-PROTECT
42	1.00	804008-139	RELAY, SAFETY MINOTAUR MSR126.1R 24V IN=2NC OUT=2NO MONITORED MANUAL
43	1.00	804008-023	RELAY, SOLID-STATE 1PST COIL=24+VAC 50A INPUT=24-265VAC OUTPUT=230VAC ZE
44	1.00	804020-007	SUPPRESSOR, METAL OXIDE VARISTOR, MADE BY HARRIS

Arpac BOM

Parent Number: 16423-EL Parent Revision: 0
Description: ASSY, ELEC, #16423, 25TW-28-LH, 460V
Model:

Assembly Part Number: 123456-026N
Assembly Drawing Number: 123456
Description: 25TW-28, ELEC, SUBASSY, CORE, LH, COMPACTLOGIX L30ER
Quantity: 1.00

Item	Qty	Arpac Part	Description
45	2.00	804025-225	SWITCH, MAGNETICALLY CODED, 2 N.C. SOLID-STATE RELAYS, W/ LED INDICATOR,
46	2.00	804023-136	TEMPERATURE CONTROLLER, 1/16 DIN, TC/mV/RTD, 100-240VAC, 3 RLY ALARM OUTP
47	1.00	804031-040	VALVE, 120VAC, USE WITH VORTEX COOLERS
48	1.00	803041	VORTEX COOLER, 400BTUH, CONTINOUS OPERATION, NEMA12
49	2.00	804023-001	WIRE, THERMOCOUPLE, 20 AWG, TYPE J, SEE COMMENTS FOR SPARE PARTS SALES
50	1.00	999999-003	WIRING MAT'L PER MACHINE TYPICAL NORMAL USAGE

Arpac BOM

Parent Number: 16423-EL Parent Revision: 0
Description: ASSY, ELEC, #16423, 25TW-28-LH, 460V
Model:

Assembly Part Number: 123456-027E
Assembly Drawing Number: 123456
Description: 25TW-28 (460V) HIGH VOLTAGE, ELEC, SUBASSY, POWERFLEX 4M
Quantity: 1.00

Item	Qty	Arpac Part	Description
1	1.00	804000-599	CIRCUIT BREAKER, 3P 50A 480V H-FRAME TRIP (THM/MAG)=NOMIN/0500A IR=25KA
2	1.00	804000-624	CIRCUIT BREAKER, ROTARY OPER MECHANISM, H-FRAME BLK HANDLE 12" DEPTH MAX
3	1.00	804000-619	CIRCUIT BREAKER, ACCESSORY, LUG KIT, H-FRAME 6 WIRES/LUG WITH TERMINAL CO
4	1.00	804000-643	CIRCUIT BREAKER, ACCESORY, H-FRAME, TERMINAL LUG, QTY 3, FCCu 1x14-1/0(2.
5	1.00	804024-003	TRANSFORMER, 1PH 2.0KVA 240/480 120/240 NEMA3R ENCAPSULATED
6	2.00	804015-262	FUSE, 10A, 600V, TIME DELAY, CLASS CC, CURRENT LIMITING, HIGHLY INDUC
7	1.00	804036-071	FUSE HOLDER 30A 2 POLE CC CLASS 600V WITH BLOWN FUSE INDICATOR
8	1.00	804012-358	DRIVE, AC, 2HP 460V, 3PH, 4.2A OUTPUT, POWERFLEX 4M, LED-KEYPAD, IP20 OPE
9	2.00	804036-072	FUSE HOLDER 30A 3 POLE CC CLASS 600V WITH BLOWN FUSE INDICATOR
10	3.00	804015-063	FUSE, 30A 600V FAST-ACTING CLASS-CC
11	3.00	804015-013	FUSE, 10A 600V FAST-ACTING CLASS-CC
12	1.00	804000-123	CIRCUIT BREAKER, IEC 1.60- 2.5A SER."C"
13	1.00	804002-007	CONTACTOR, IEC 43A COIL=120VAC 1N0 LINE-SIDE-COIL

Arpac BOM

Parent Number: 16423-EL Parent Revision: 0
Description: ASSY, ELEC, #16423, 25TW-28-LH, 460V
Model: