

SECTION 10

Standstill of machine

10.1.	Safety regulations	10-2
10.2.	Requirements on servicing	10-2
10.3.	Conditions of storage	10-3
10.4.	Maintenance during storage	10-3
10.5.	Standstill of machine	10-3

10.1. Safety regulations

Danger of accident occurs mostly during movements of machine and under pressure (e.g. pneumatics or hydraulics)!

The machine, during the works is fixed immovably and protected against repeated start by the main switch.



Danger of accident at electrical current!

- Before working on electrical installation, you should switch off the machine by means of main switch and protect the switch against unauthorised engagement.
- Disconnect the supply of mains by removal of protections in no voltage state and place adequate information.



Danger of hot surfaces!

During the casting process in the area of work and furnace, there are hot surfaces there. At open melting pot, the remains of liquid metal in the furnace are also dangerous. During draining the metal, you should observe the adequate safety regulations.



You should ensure sufficient cooling time (about ½ day).

Wearing of protective cloths

During standstill and storage of machine, you should wear the proper protective equipment.



10.2. Requirements on servicing

The works at stopped machine can be carried out only by trained and authorised personnel. !

10.3. Conditions of storage

- The machine can be stored as long as it is needed, but local regulations must be observed by the user.
- From the machine, designed for stopping, any substances, endangering the environmental protection can escape.
- The hydraulic means or lubricating oil should be pumped to prepared barrels. You should observe the regulations UVV for dangerous materials, like grease, hydraulic fluids.

10.4. Corrosion protection during storage

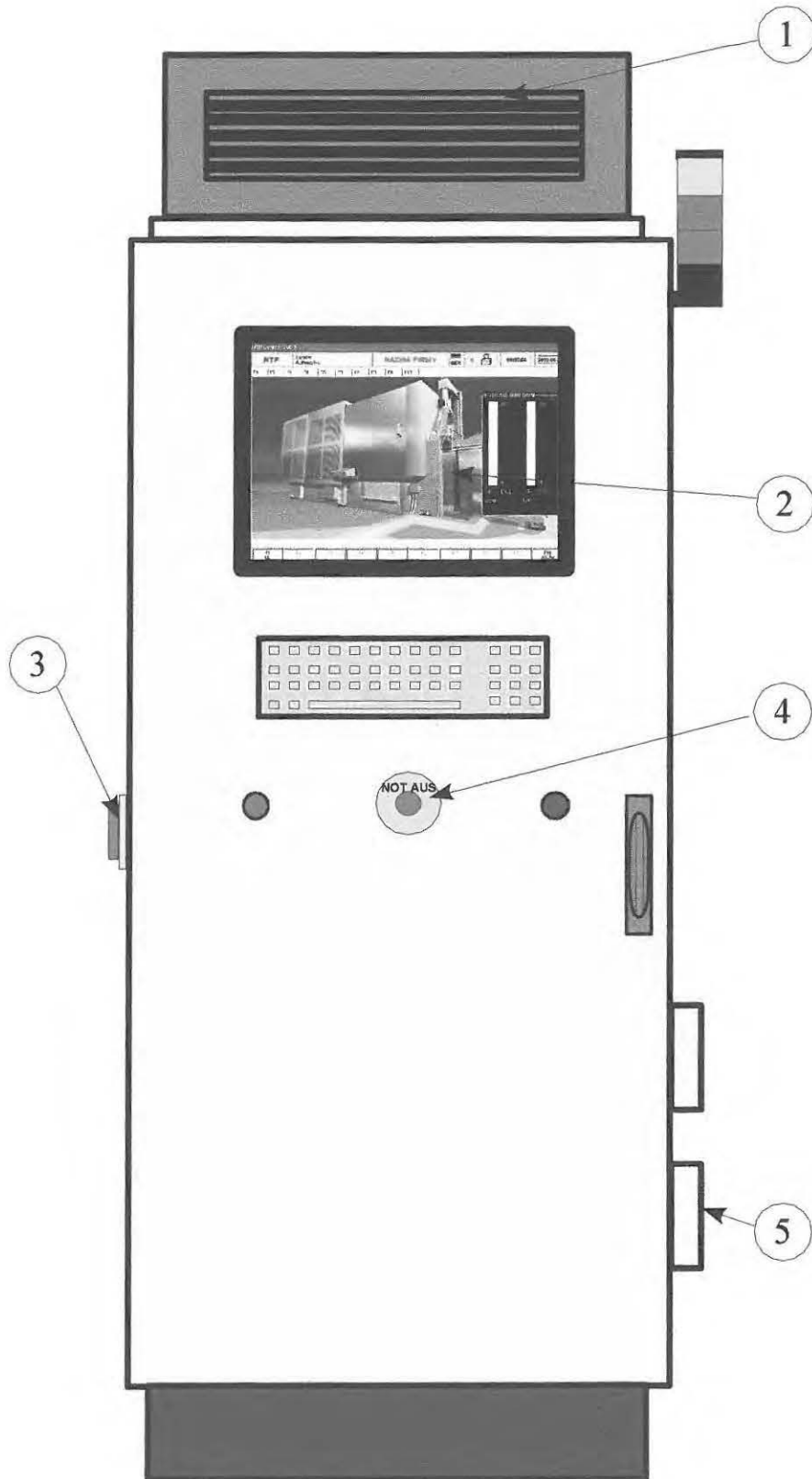
- During storage, no corrosion protective works are necessary
- From time to time, you should only check the nitrogen cylinder, if the pressure remains at constant level (according to data from the user's instruction of cylinder supplier)

10.5. Standstill of machine

- Disconnect the energy, disconnect the supply of auxiliary means, empty the tanks from hydraulic means and nitrogen, observing the producer's instruction
- You should protect the fixed and movable plate with lubricating means
- Fix the transport protections, see section 3.

SECTION 11

Electrical diagram of heating



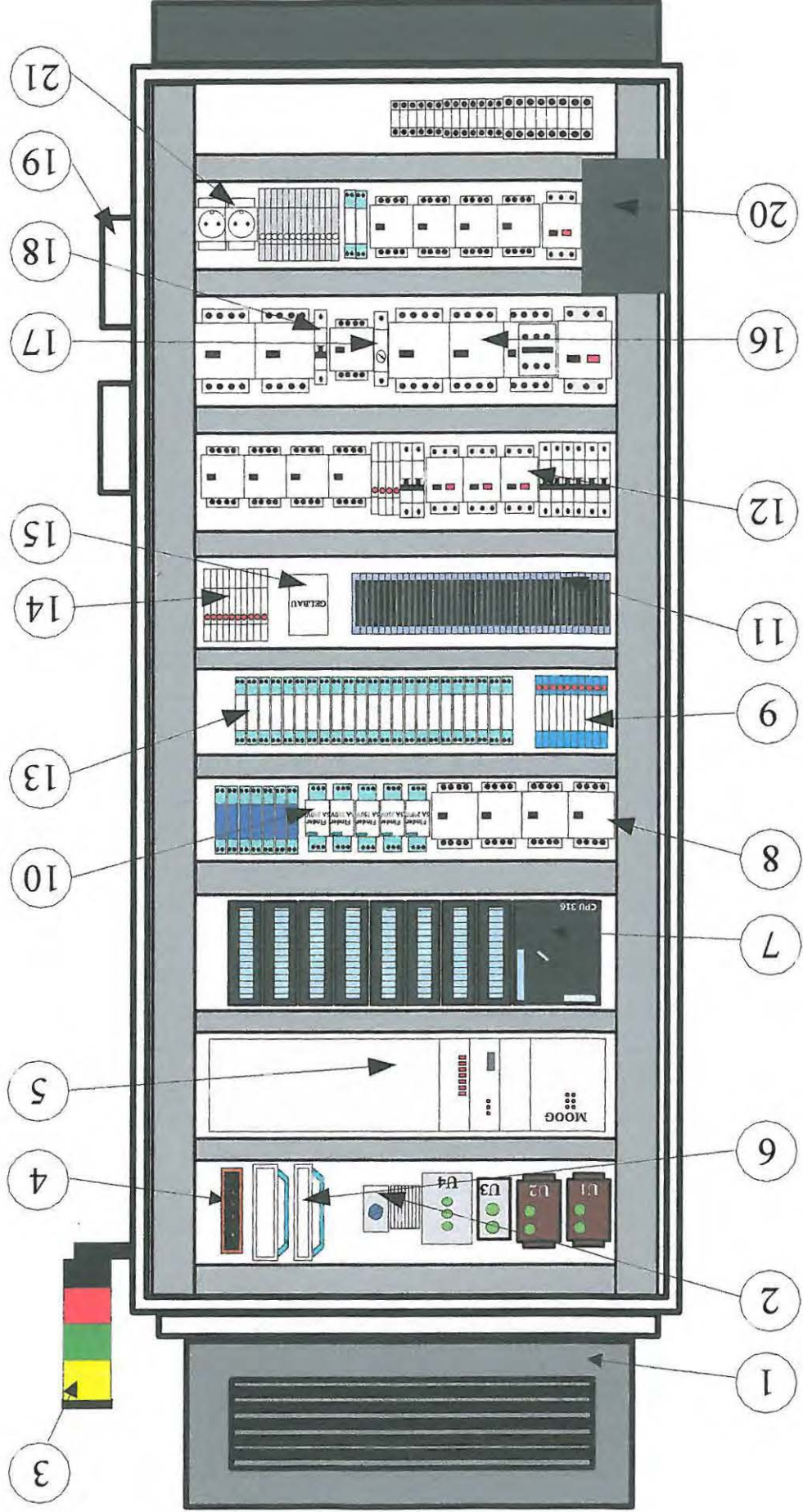
1 – Air conditioner
2 – Industrial PC Computer
3 – Main switch
4 – NOT-AUS button
5 – HAN socket

No	Name
1	Air conditioner
2	Thermostat
3	Acoustic-light signalling device
4	Controlling card PARKER
5	Injector valve controller MOOG
6	Cards, controlling the proportional valves REXROTH
7	Controller S7-316 SIEMENS
8	Contactors Telemecanique
9	Electronic relays FINDER
10	Relays FINDER 2P
11	Electronic relays MOS
12	Motor switch
13	Relays RELECO
14	Fuses 24VDC
15	Safety module Gelbau
16	Contactors Telemecanique
17	Time relay
18	Automatic fuses
19	Connection sockets HARTING
20	Transformer
21	Service socket
U1	Relay NOT AUS
U2	Relay P2HZ
U3	Safety module MAYSER
U4	Module of doors and guards DUELCO

NOTE!!!

During performing of any actions inside the control cabinet, you should earlier **switch off the air conditioner**, because of water steam condensation, which will damage the controller or cassette of system PEP. W especially it refers to summer season!!!





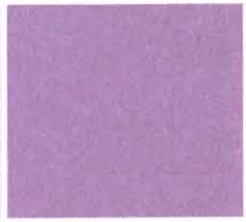


Diagrama Electrico.
Mecanica 1 4 2

Diagrama Electrico
Plant - 1 4 2

Diagrama Electrico
Plant - 3 4 4

Diagrama Electrico
Plant - 5, 6 - 8

Diagrama Electrico.
Sistema Calefacción.



2

HOT CHAMBER DIE CASTING MACHINE

QDCM 400

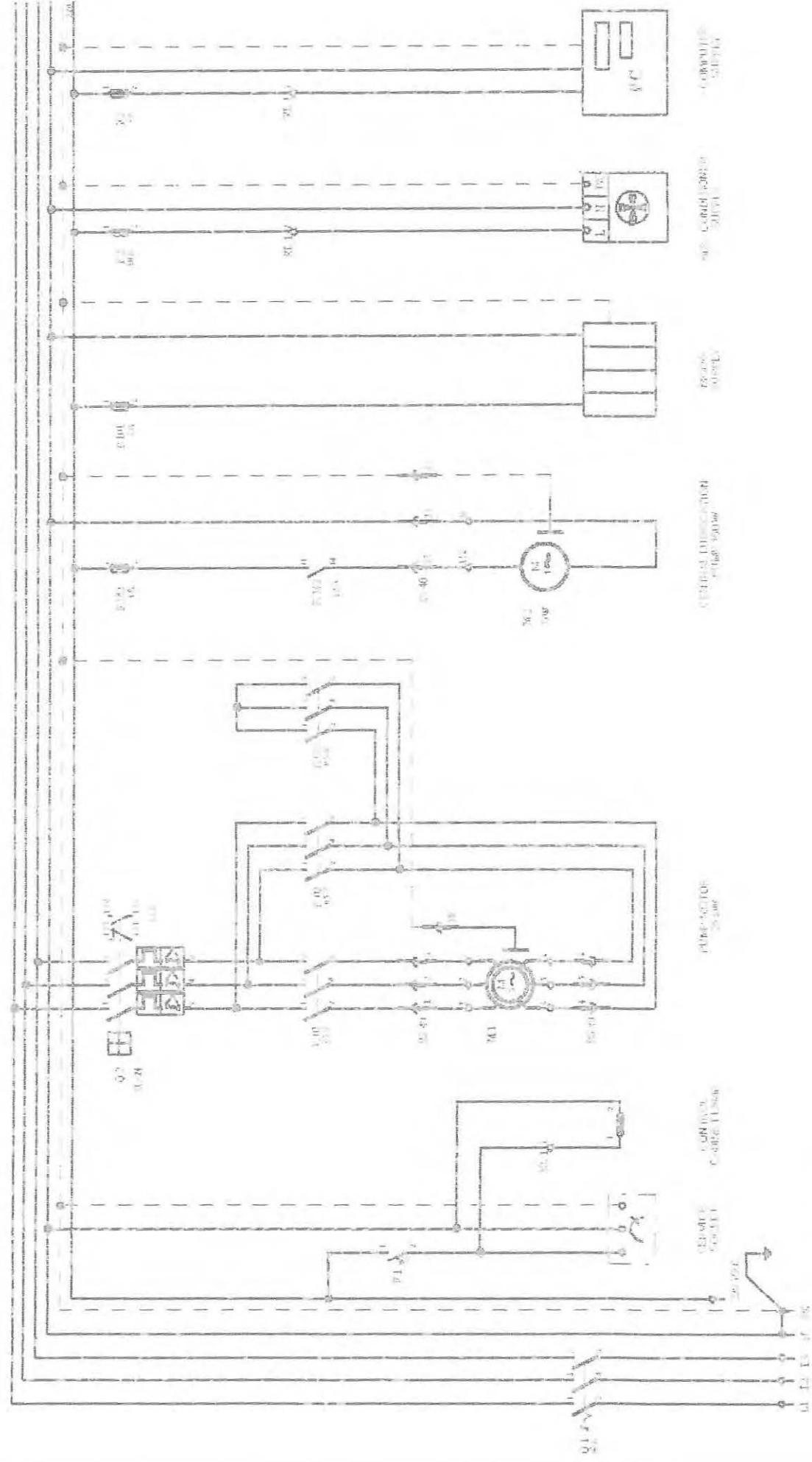
NTP

NOWOCZESNE TECHNOLOGIE PRODUKCJI Sp. z o.o.

PL - 47 - 225 KĘDZIERZYN - KOŹLE

UL. SZKOLNA 15

1 2 3 4 5 6 7 8 9 10



Príloha č. 11 k Agnos 1000 a 1000/2000

NTP

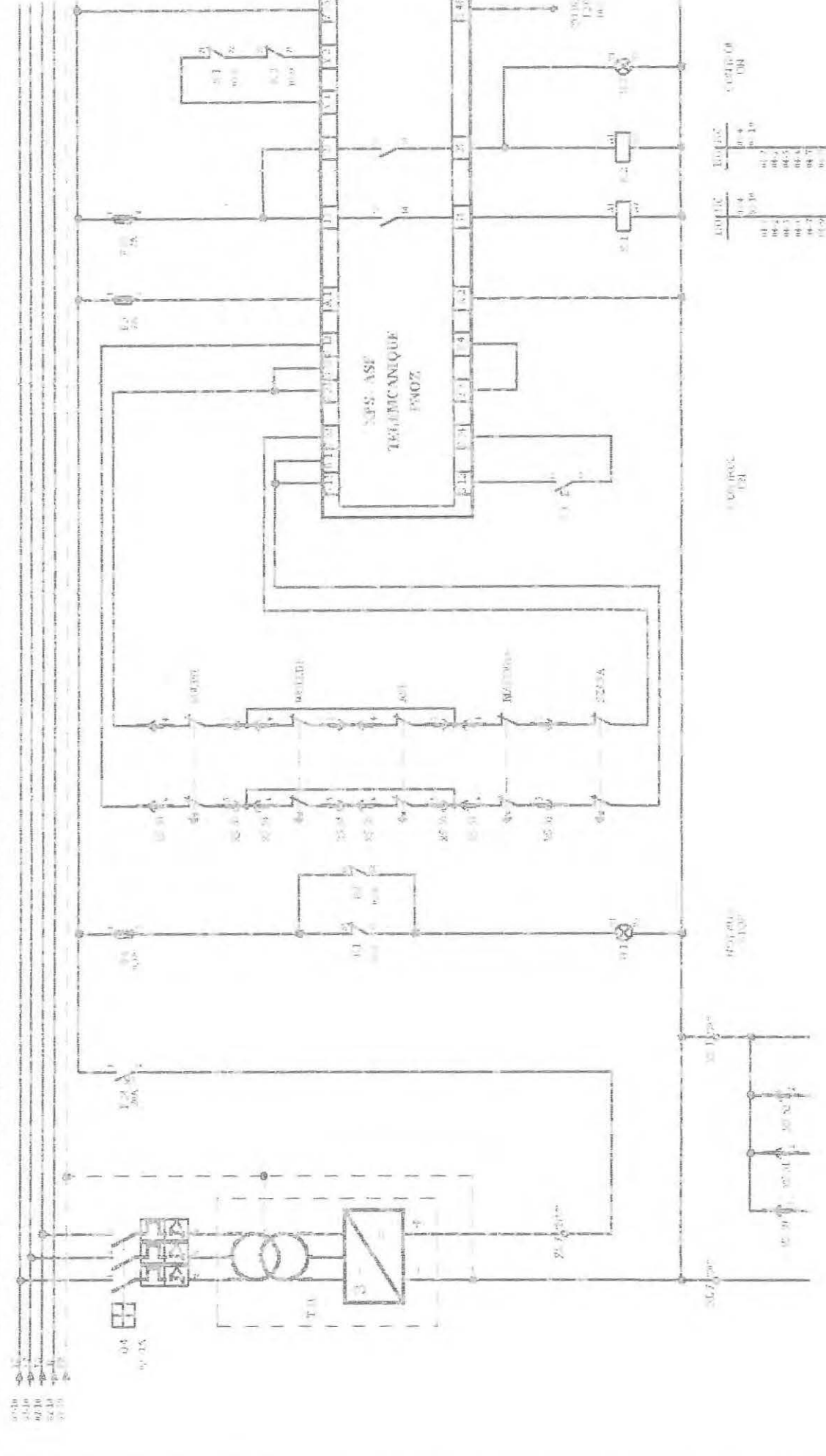
PL - 17 - 2.2.3. Kečlerovský - Kofler
 J. Kečlerovský - Kofler

1000 1000/2000
 1000 1000/2000
 1000 1000/2000

QDCM 100

1000 1000/2000

1 2 3 4 5 6 7 8 9



LETTRE	LETTRE	LETTRE	LETTRE	LETTRE
01	02	03	04	05
06	07	08	09	10
11	12	13	14	15
16	17	18	19	20
21	22	23	24	

QDCM 400

TELETYPE AUTOMATIC

PROJETEUR	100
RECEPTEUR	100
RETRANSMISSION	100
SIGNAL	100

Pl. - 4 - 225 A. Scholtes - K. Scholtes
 216 Scholtes 13
 (044) - 40 1 77 / 4 006 400
 (044) - 40 1 77 / 4 006 400
 www.nip.com.pl

1 2 3 4 5 6 7 8 9

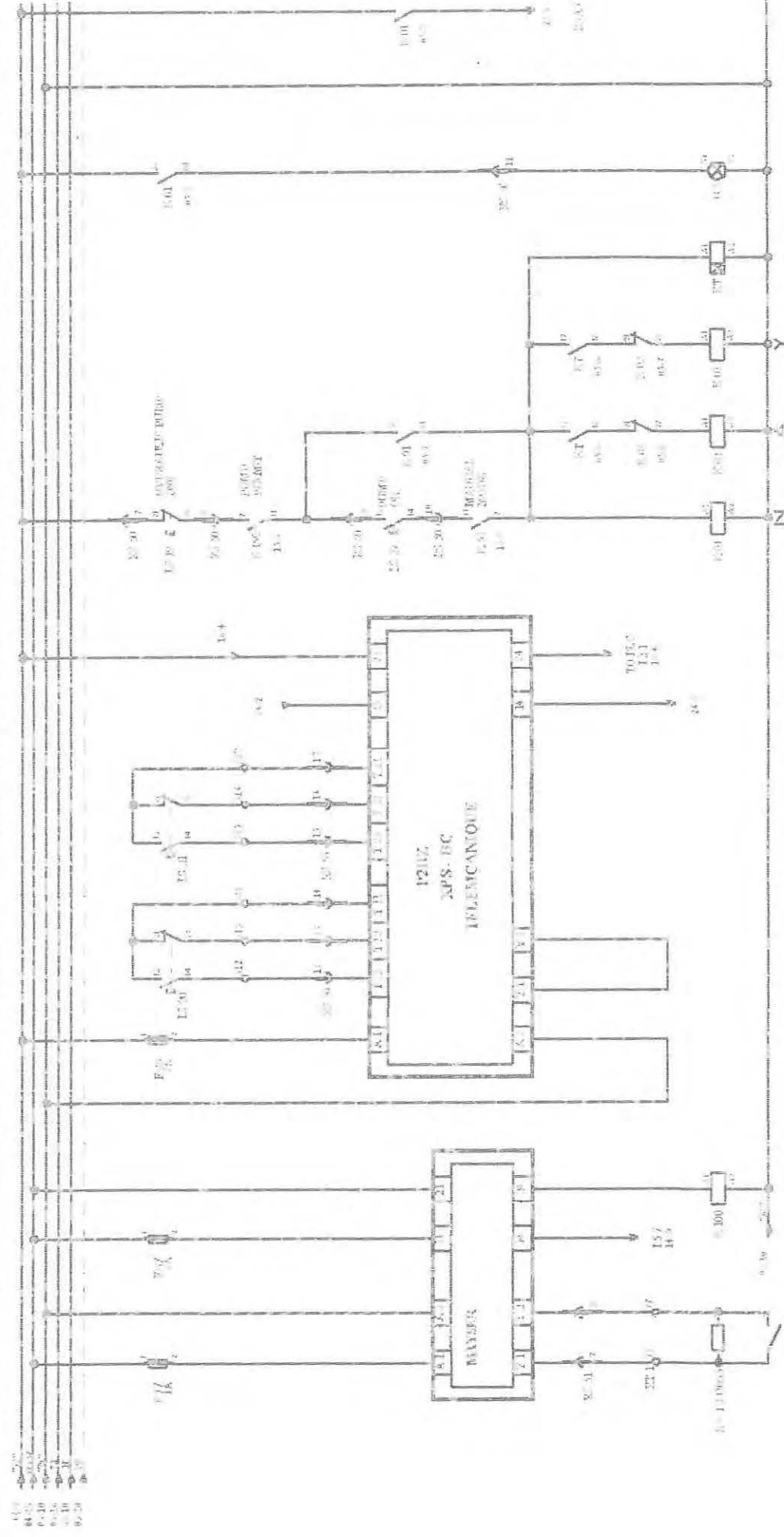


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Item	Rating	Quantity
1	100A	1
2	100A	1
3	100A	1
4	100A	1
5	100A	1
6	100A	1
7	100A	1
8	100A	1
9	100A	1

TABLE 2

TABLE 2

Item	Rating	Quantity
1	100A	1
2	100A	1
3	100A	1
4	100A	1
5	100A	1
6	100A	1
7	100A	1
8	100A	1
9	100A	1

NTP

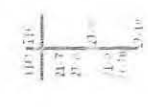
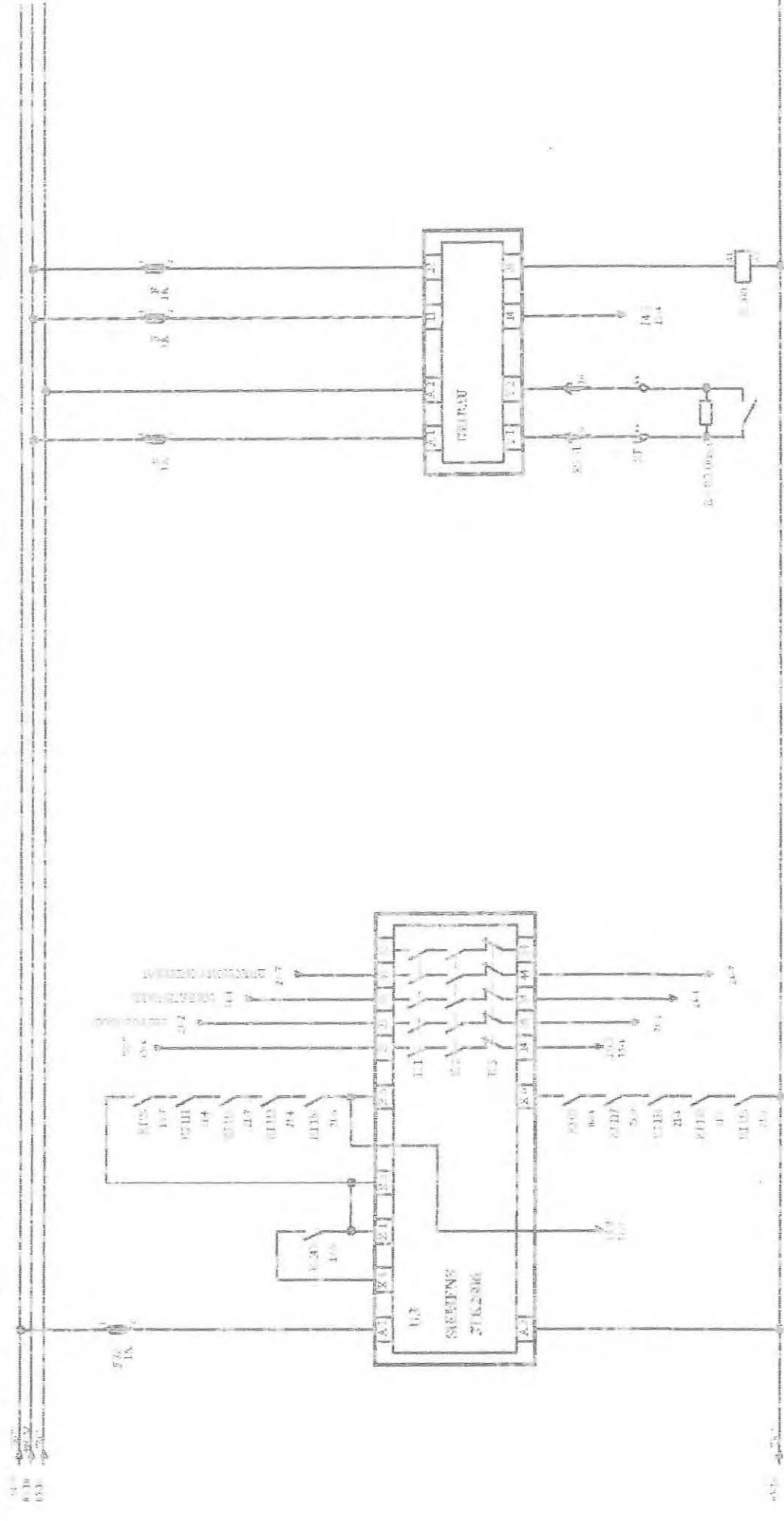
PL-07-225 Kachery m-kolir
 OL S. K. K. 15
 (05) - 48 / 77 / 0386 199A
 (06) - 48 / 77 / 0386 200B
 (07) - 48 / 77 / 0386 200C
 (08) - 48 / 77 / 0386 200D

QDCM 100

TABLE 3

Item	Rating	Quantity
1	100A	1
2	100A	1
3	100A	1
4	100A	1
5	100A	1
6	100A	1
7	100A	1
8	100A	1
9	100A	1

1 2 3 4 5 6 7 8 9



БЕЛОРУССКОЕ
ОБЩЕСТВО
ПРОЕКТИРОВЩИКОВ

10/10/10

QDCM-100

БЕЛОРУССКОЕ
ОБЩЕСТВО
ПРОЕКТИРОВЩИКОВ

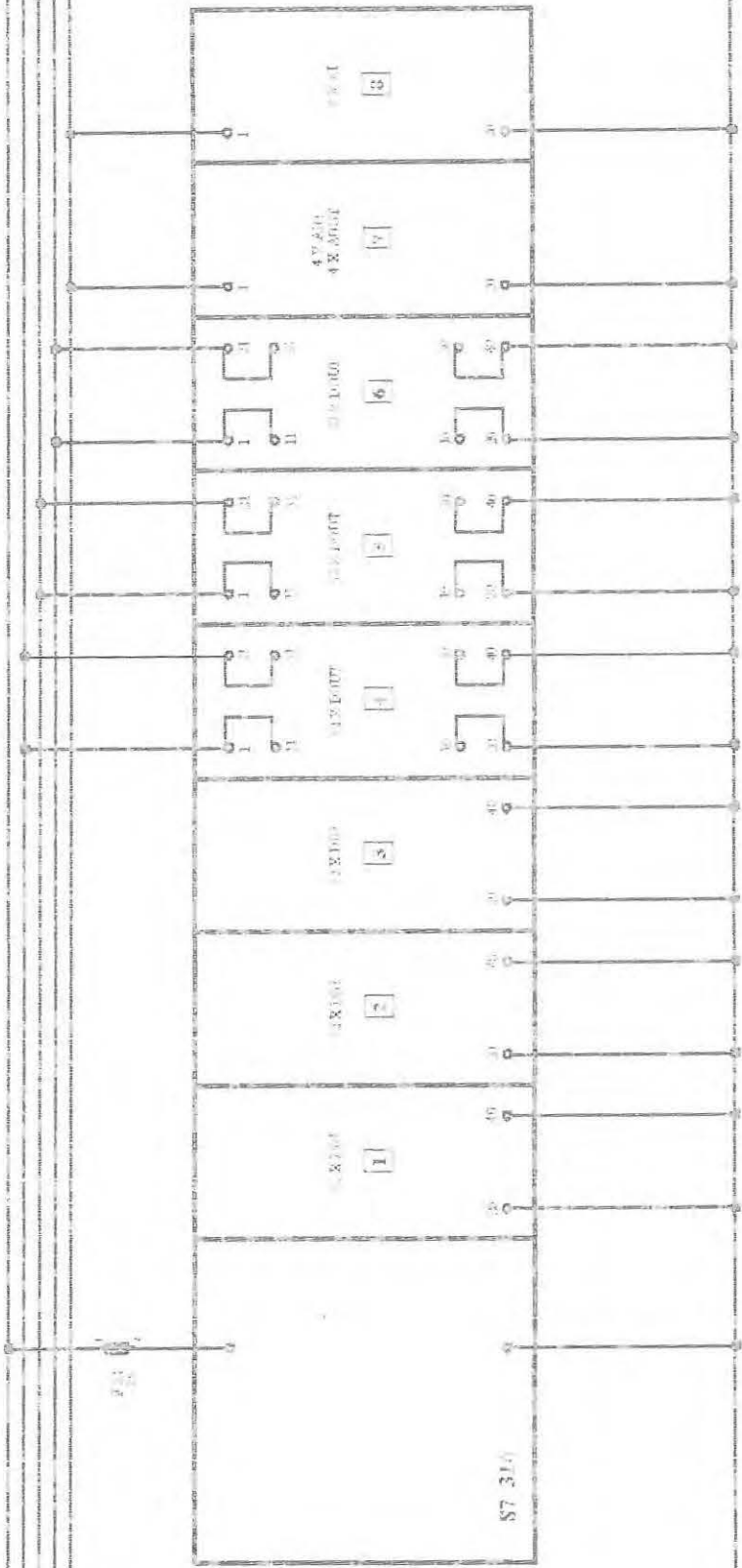
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ПРОЕКТИРОВЩИК	И.И.И.	МАШИН	МАШИН
ПРОЕКТИРОВЩИК	И.И.И.	МАШИН	МАШИН

РЛ-47-2.2.5 Контрпункт-Контр
 У.А.Контрпункт-Контр
 10/10/10
 10/10/10
 10/10/10
 10/10/10



1 2 3 4 5 6 7 8 9

100V
100V
100V
100V



100V



PL-47-225 Kuchnia-2020
UL Niskowa 15
ul. 15 71-1 SRG 400
ul. 48 71-1 SRG 400
ul. 48 71-1 SRG 400

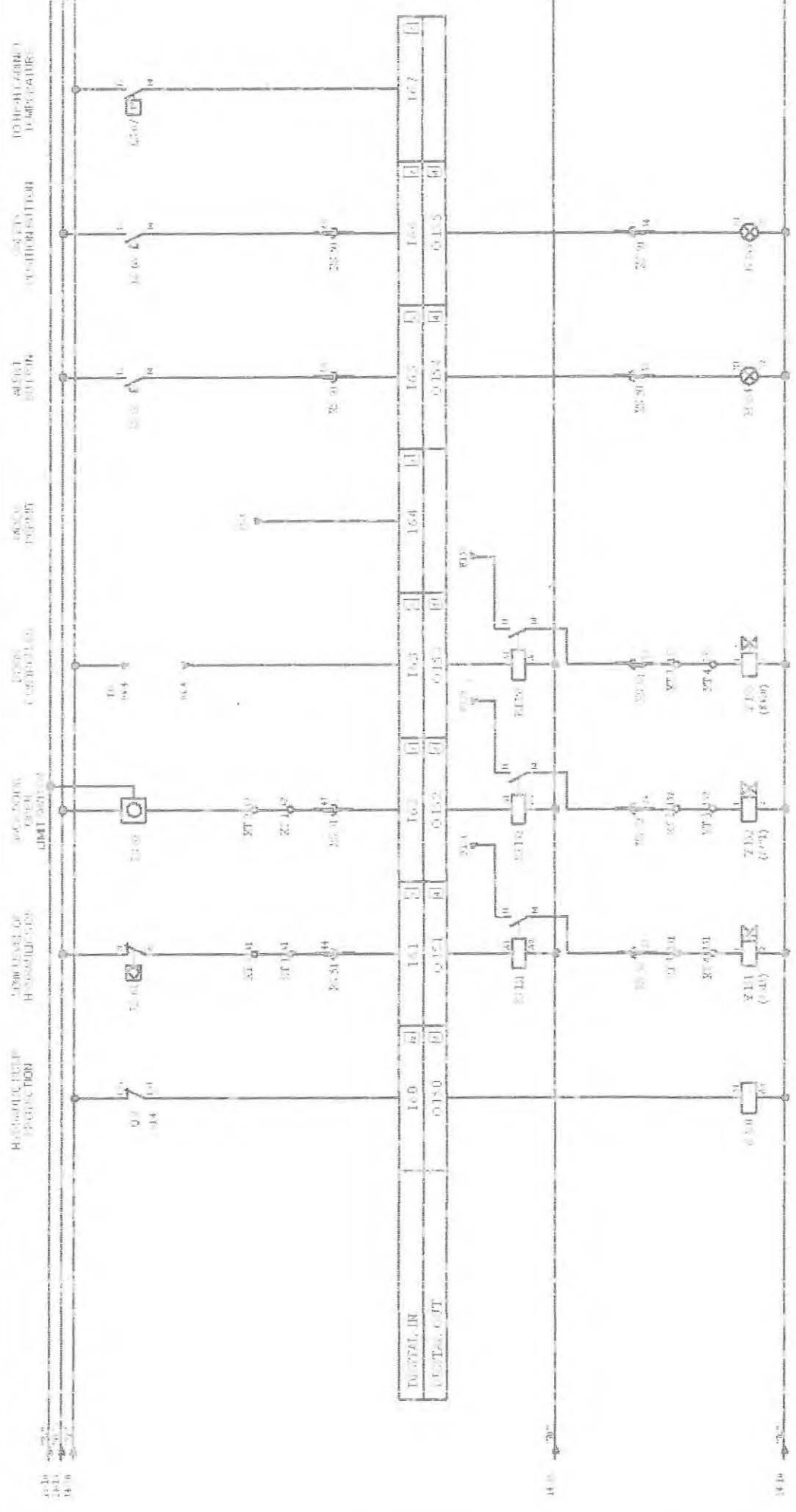
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100V	100V	100V	100V
100V	100V	100V	100V
100V	100V	100V	100V

100V

100V

100V

1 2 3 4 5 6 7 8 9 10

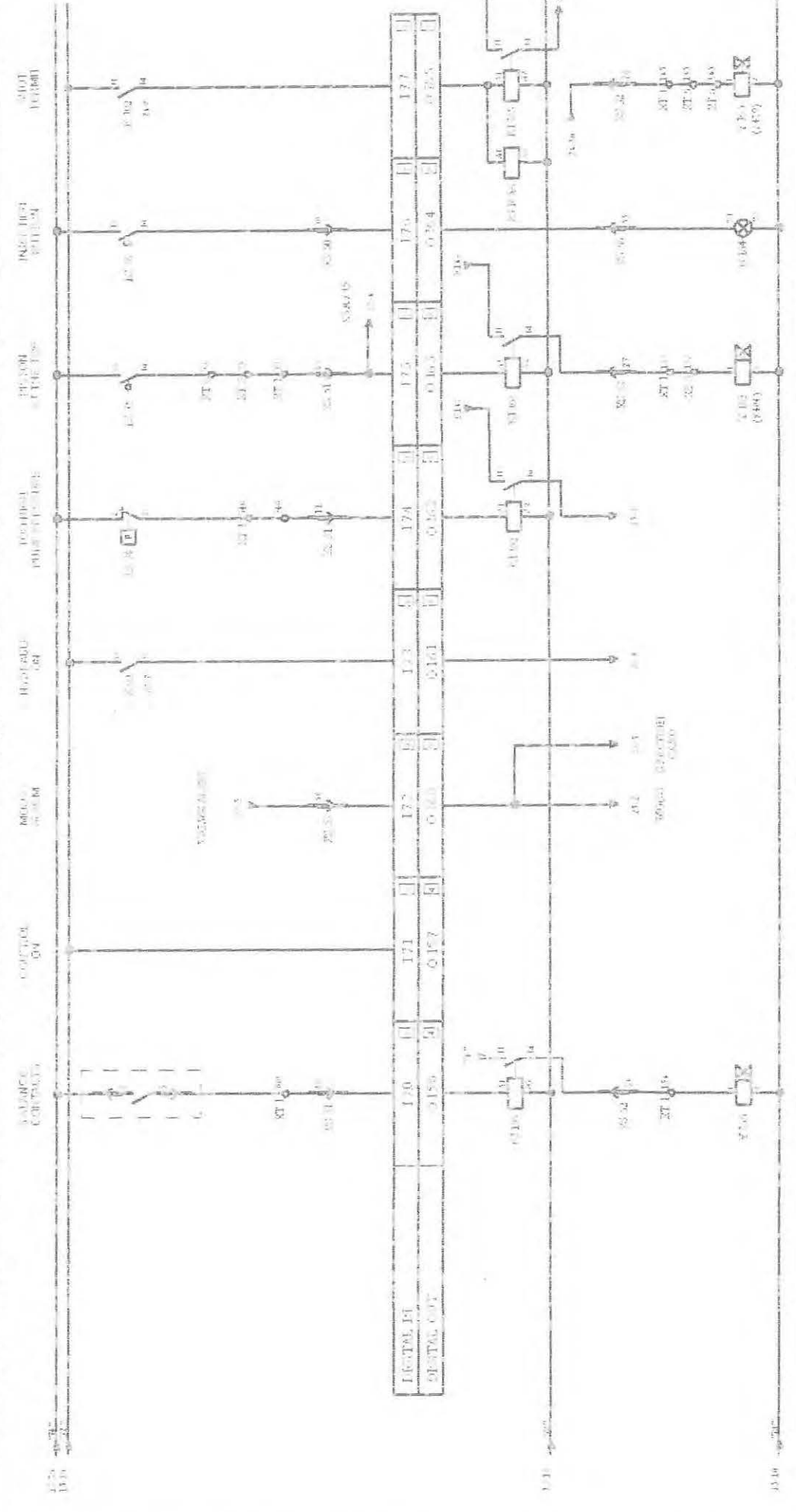


TO 010, 011, 012, 013, 014, 015, 016, 017, 018, 019, 020, 021, 022, 023, 024, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034, 035, 036, 037, 038, 039, 040, 041, 042, 043, 044, 045, 046	ADJUSTMENT OF TEMPERATURE	ADJUSTMENT OF PRESSURE	ADJUSTMENT OF VERTICAL POSITION	ADJUSTMENT OF HORIZONTAL POSITION	ADJUSTMENT OF VERTICAL POSITION	ADJUSTMENT OF HORIZONTAL POSITION	ADJUSTMENT OF SPEED	ADJUSTMENT OF CURRENT	ADJUSTMENT OF VOLTAGE	ADJUSTMENT OF TORQUE	ADJUSTMENT OF SPEED
167	168	169	170	171	172	173	174	175	176	177	178

NTP

PL - 47 - 2.2.3. Nachkriegs-Auflage
 1. Aufl. 1948
 401: + 46 / 77: + 186 / 293
 1833: + 48 / 77: + 1826 / 749
 4 - nachl. versch. Aufl., keine pT

QDCM 400



POWER SUPPLY
 CONTROL SYSTEM
 DIGITAL UNIT
 DIGITAL CONT
 MOTOR
 RELAY
 LAMP
 SWITCH
 CONTACT

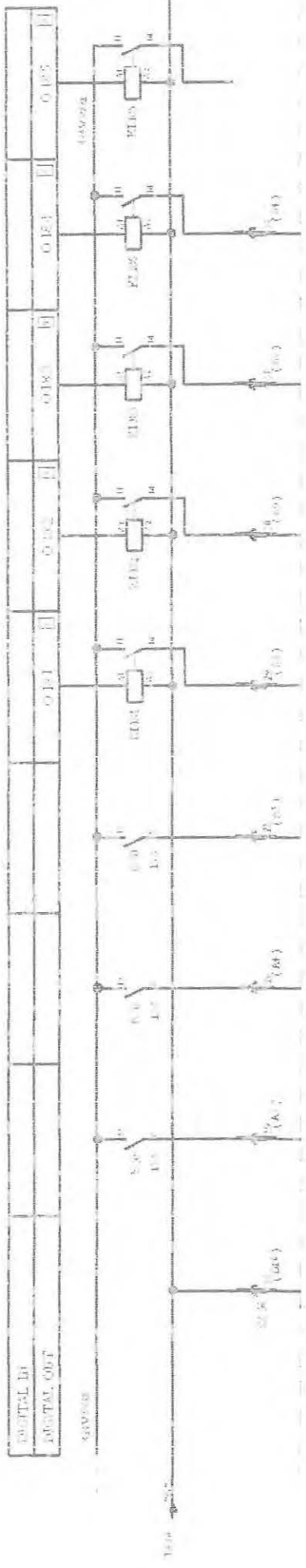
PL - 47 - 23.5 Автоматизация - 400
ЦДЦМ-400
 400 + 48 / 77 / 8 886 800
 800 + 48 / 77 / 8 886 700
 800 + 48 / 77 / 8 886 600

DATE: 1977
 DRAWN: 1977
 CHECKED: 1977

NTP

1	2	3	4	5	6	7	8	9
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11.6
10.0



2192478
WOLFF
P24112

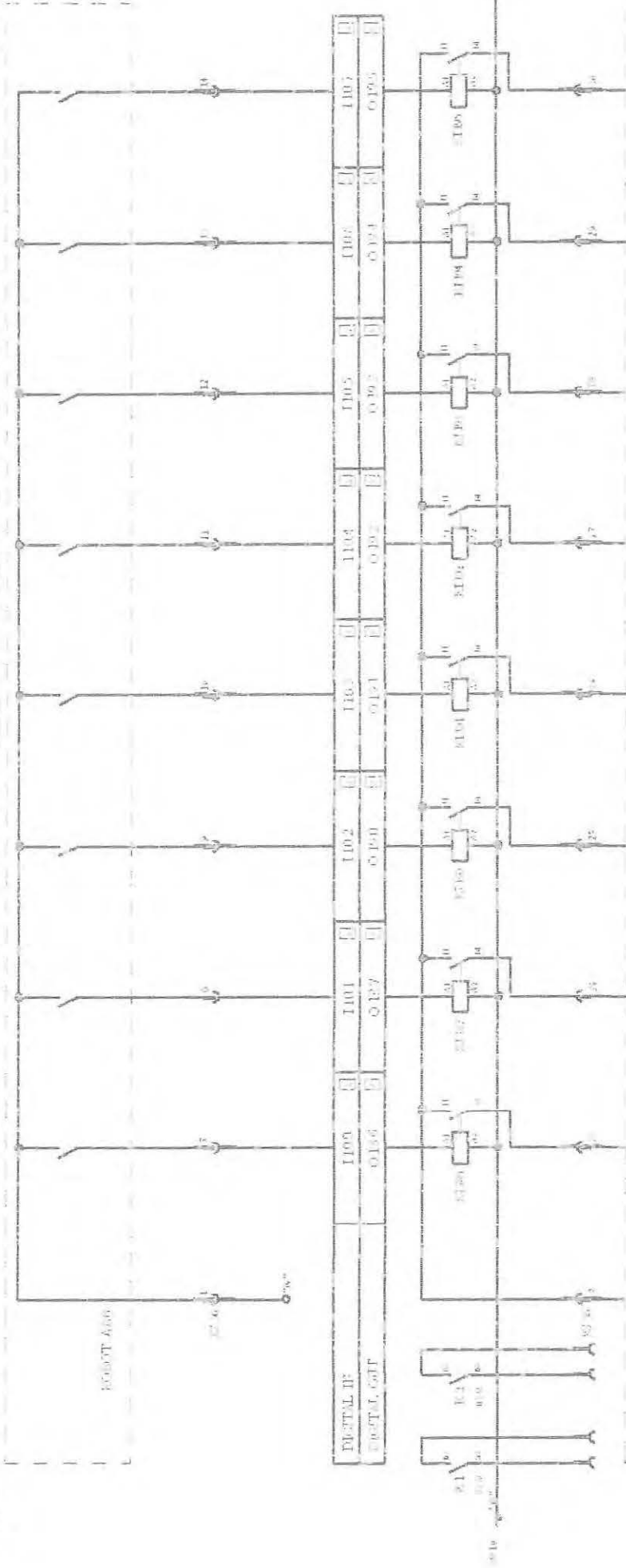
REVISION NO. 001
DATE 1956.06.01
DESIGNED BY WOLFF
CHECKED BY WOLFF
APPROVED BY WOLFF

PL - d' - 223 K (Schleppwagen-Kocher)	REVISION NO. 001	DATE 1956.06.01
UL Scheffau 15	DESIGNED BY WOLFF	CHECKED BY WOLFF
APPROVED BY WOLFF	APPROVED BY WOLFF	APPROVED BY WOLFF



1 2 3 4 5 6 7 8 9

1000



TOTAL STOP

ROBOT ARM

1000



PL - 47 - 2.25 A robot arm - K. K. K.

U.L. No. 15

Scale: 1:100
Date: 10/10/77
By: M. S. S. S.

PROJECT NO.	1000	DATE	01/01/77
DESIGNER	M. S. S. S.	CHECKED	M. S. S. S.
DATE	10/10/77	BY	M. S. S. S.

1000

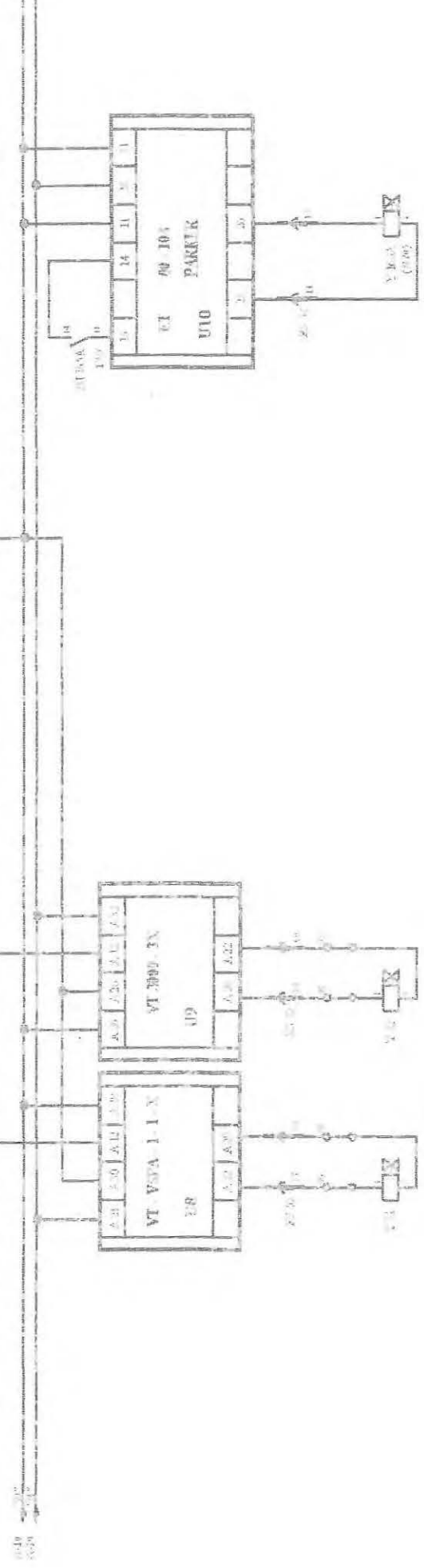
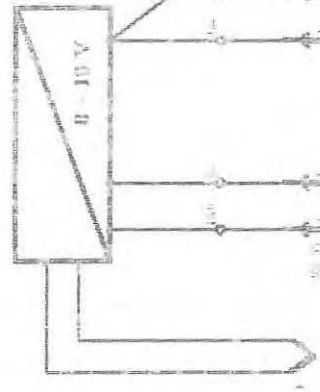
U.L. No. 15

1000

14-00000, OR 6-5400000000

CONNECTIONS

A



14-00000, OR 6-5400000000

CONNECTIONS

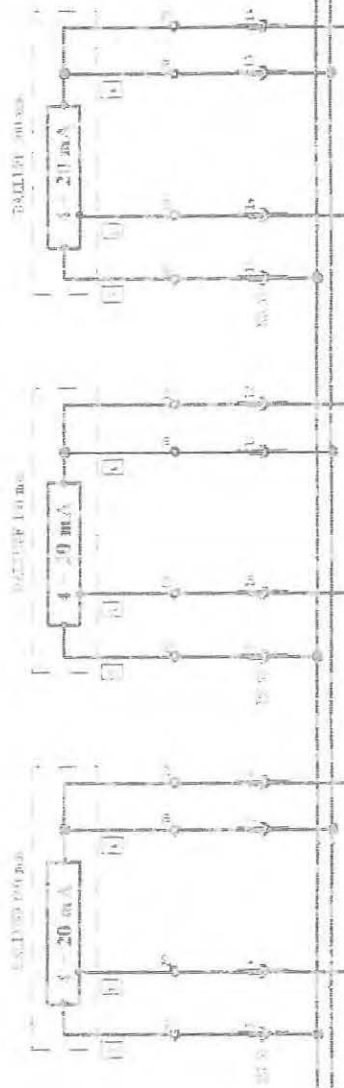
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0.10000

0.00000

0.00000

0.00000



0.10
0.10

WAZEP 100	2	3	4	5	6	7	8	9
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0.1

B

4.5

C

2.5

B

0.1

B

NTP

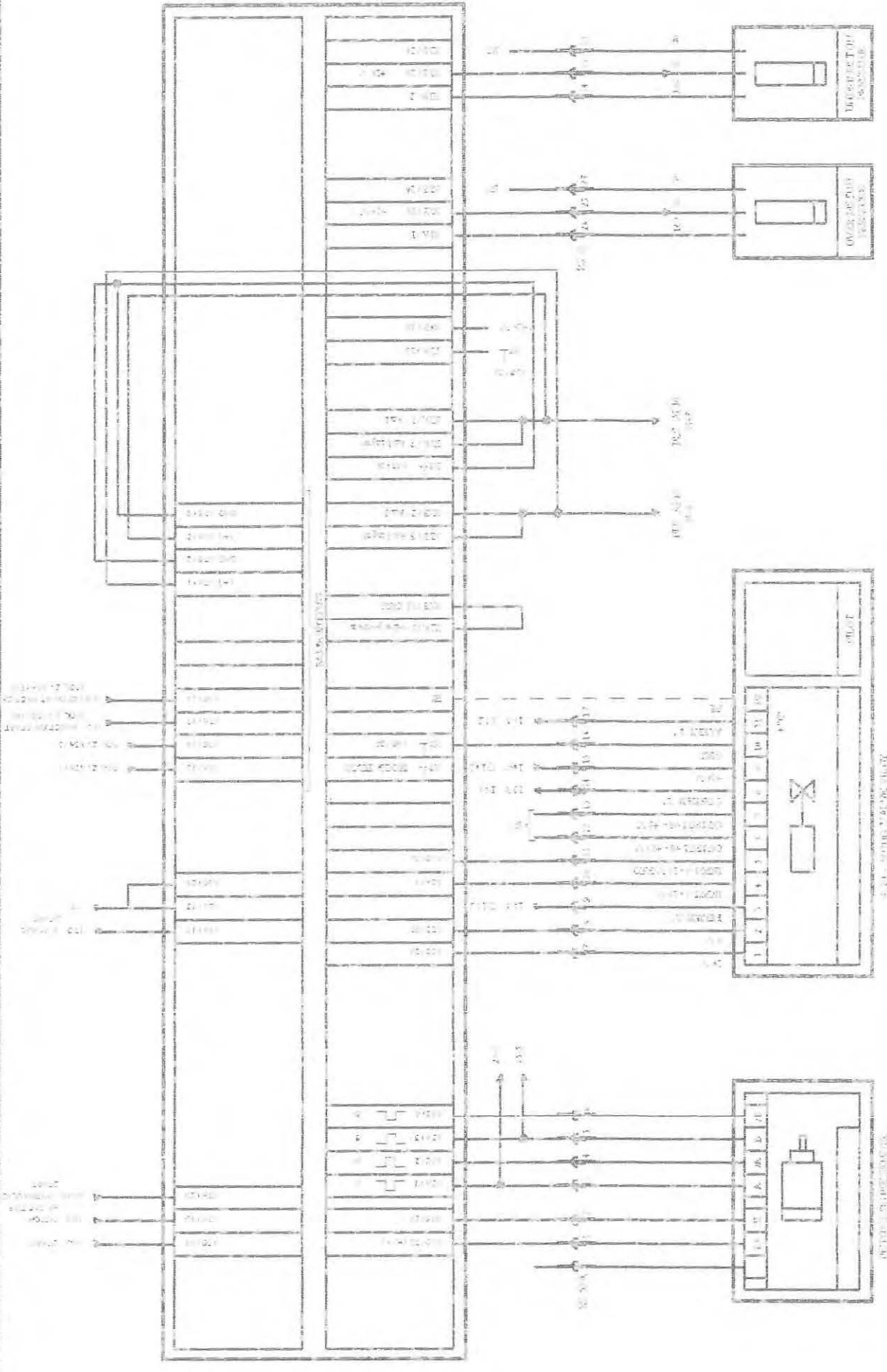
PL-17-2.2.5 Kucharskiy-Koche
 OS Sokolov IS
 tel. +38 (7) 4 986 800
 fax. +38 (7) 4 986 742
 www.ntp.com.pl

WAZEP 100 B.A.	0.10000	0.00000	0.00000
BALKON 000 B.A.	0.00000	0.00000	0.00000
EXLIDER 000 B.A.	0.00000	0.00000	0.00000

PL-17-2.2.5 Kucharskiy-Koche

0.10000

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100



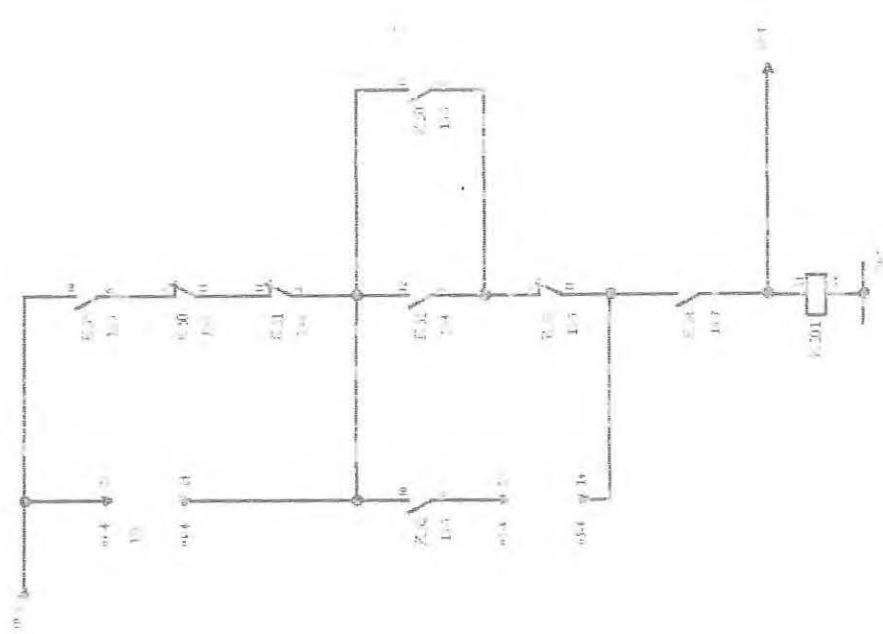
NIP

PL - 00 - 225 *Archiepym-Avile*
 U.S. Section 13
 Tel: + 48 / 77 / 4 886 293
 Fax: + 48 / 77 / 4 886 400
 e-mail: nip@nip.pl

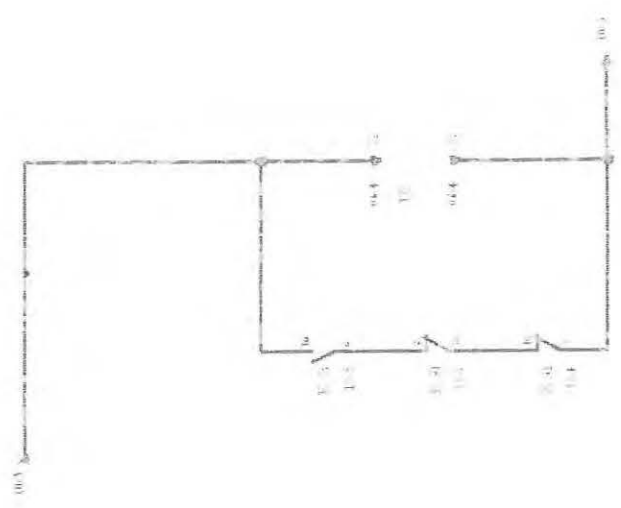
QDCM 100

PROJEKTOWA 1 1/1

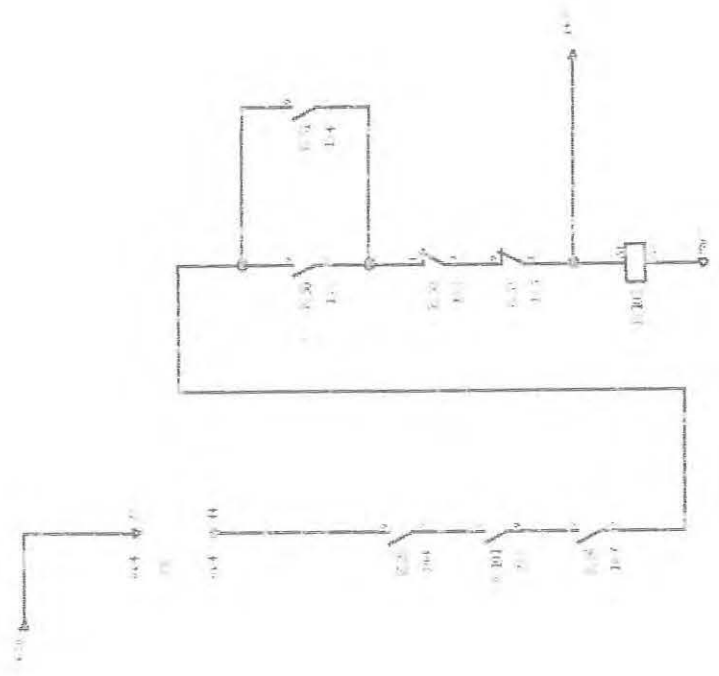
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PROJEKTOWA 1 1/1	2000.11.10	2000.11.10	2000.11.10	2000.11.10
PROJEKTOWA 1 1/1	2000.11.10	2000.11.10	2000.11.10	2000.11.10



W CLOSED CONDITION



FOR OPEN OPERATION



INJECTION CONDITION



FIG - 8 - 2.25 A. 66-10000-0.01
 714, S. K. 1001 13

10.4 - 46 / 77 / 4 1000, 500
 10.4 - 46 / 77 / 4 1000, 500
 10.4 - 46 / 77 / 4 1000, 500

REVISION NO.	DATE	BY	CHKD BY
1	10/01/2005	10/01/2005	10/01/2005
2	10/01/2005	10/01/2005	10/01/2005

QDCM 400



3

HOT CHAMBER DIE CASTING MACHINE

QDCM 400/2

NTP

NOWOCZESNE TECHNOLOGIE PRODUKCJI Sp. z o.o.

PL - 47 - 225 KĘDZIERZYN - KOŹLE

UL. SZKOLNA 15

1 2 3 4 5 6 7 8 9

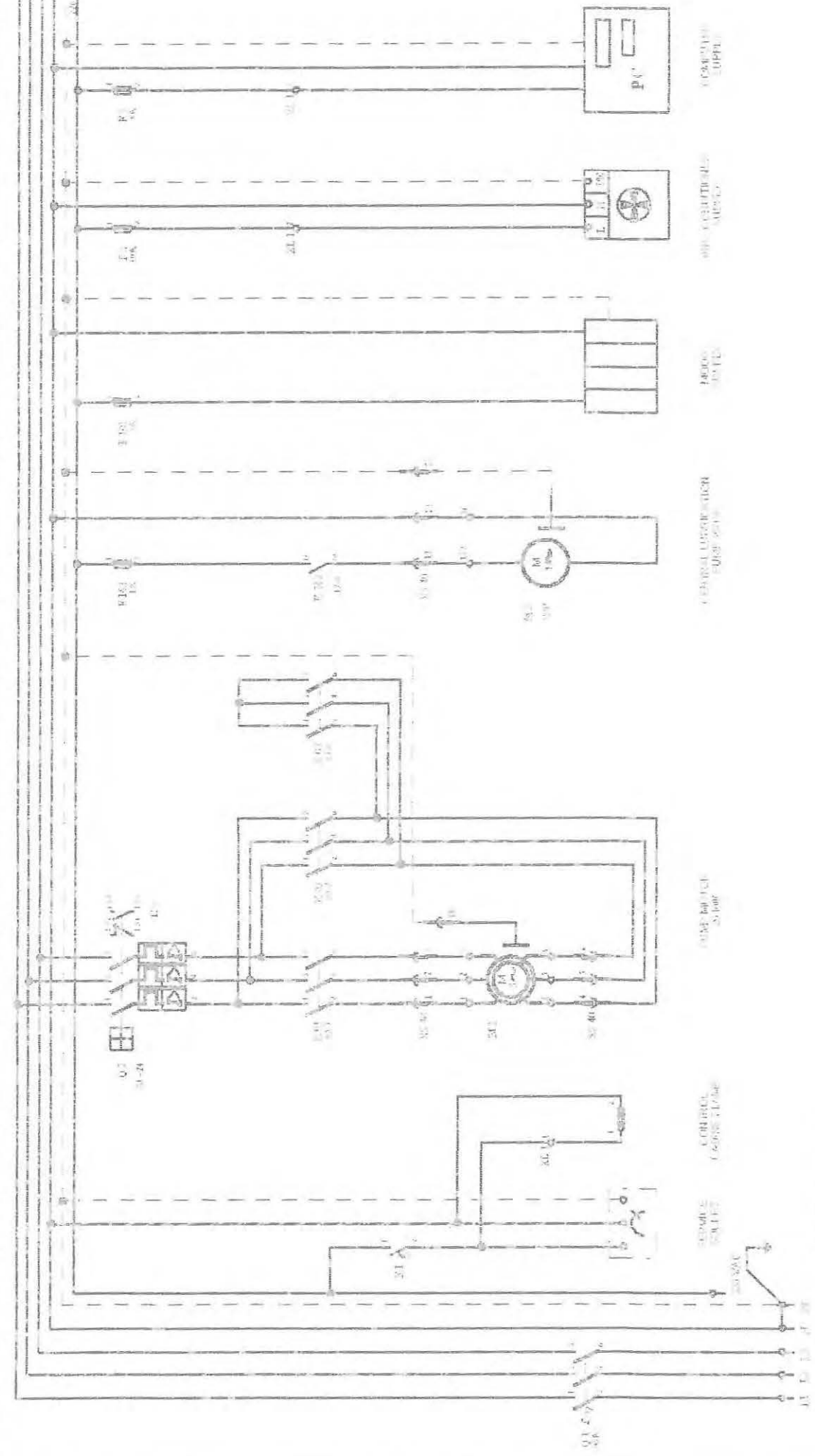


Схема снабжена выключателем и 10 220В/50Гц



Рис. 17 - 2.2.7. Кратковремен-Коды
UL-Кодовый IS

Тел. + 40 / 77 / 4 886 854
Телек. + 40 / 77 / 4 285 794
e-mail: ntp@nnp.ru, ntp@nnp.ru

Информация: 000 0000 2004 01

100-11000 200 2004 06 02

2004 06 02 08 22

100-11000 200 2004 06 02

СЕРИИ: 100

QDCM 400

МОНТАЖ
УСТАНОВКА
ПОСЛЕДОВАТЕЛЬНОСТЬ

1 2 3 4 5 6 7 8 9

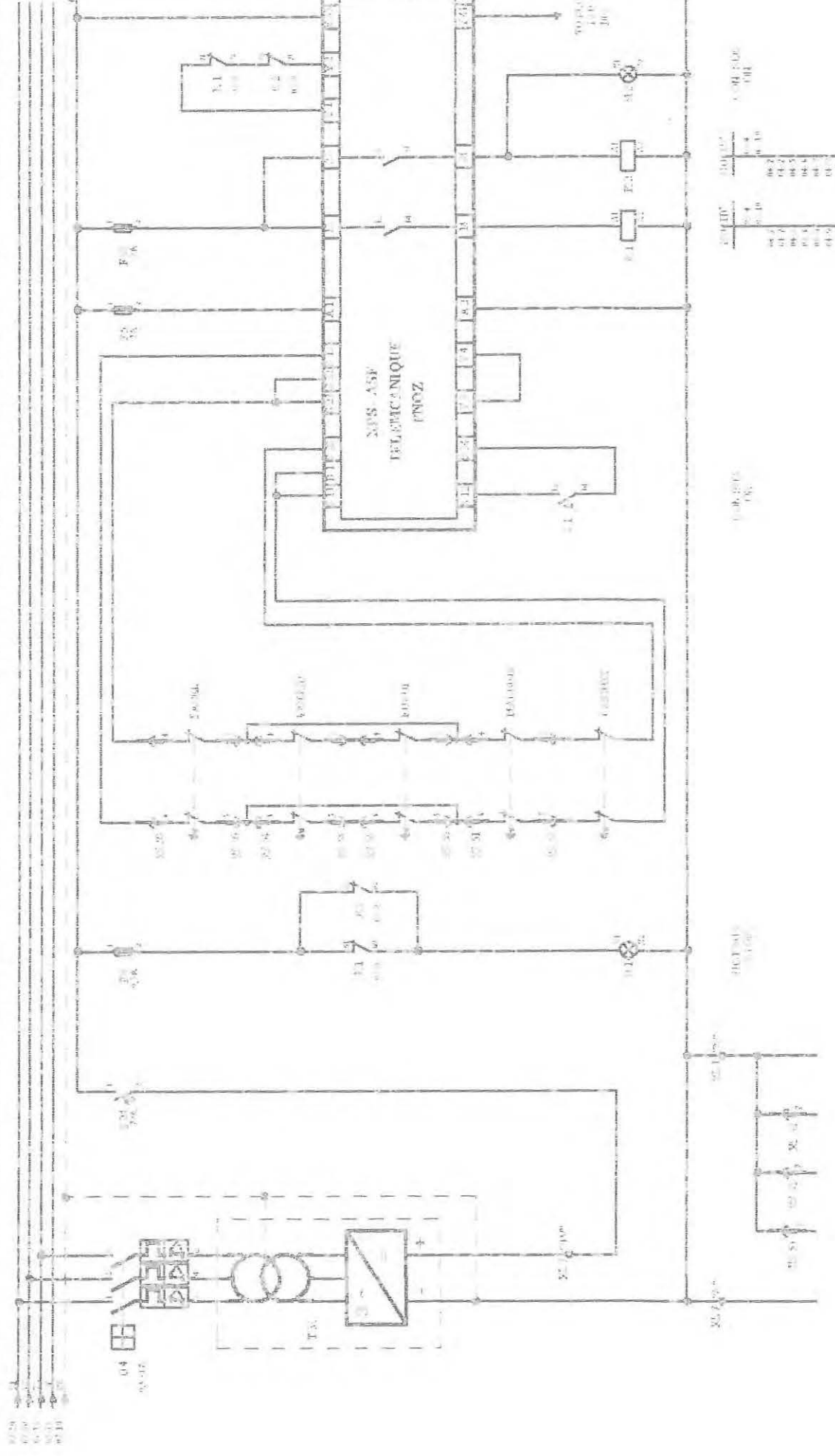


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NO.	DESCRIPTION
001	220V
002	220V
003	220V
004	220V
005	220V
006	220V
007	220V
008	220V
009	220V
010	220V

TABLE 2

NO.	DESCRIPTION
011	220V
012	220V
013	220V
014	220V
015	220V
016	220V
017	220V
018	220V
019	220V
020	220V

NTP

20. - 47 - 225 Kuchinskij-Kolce
1/2 Schokov 13

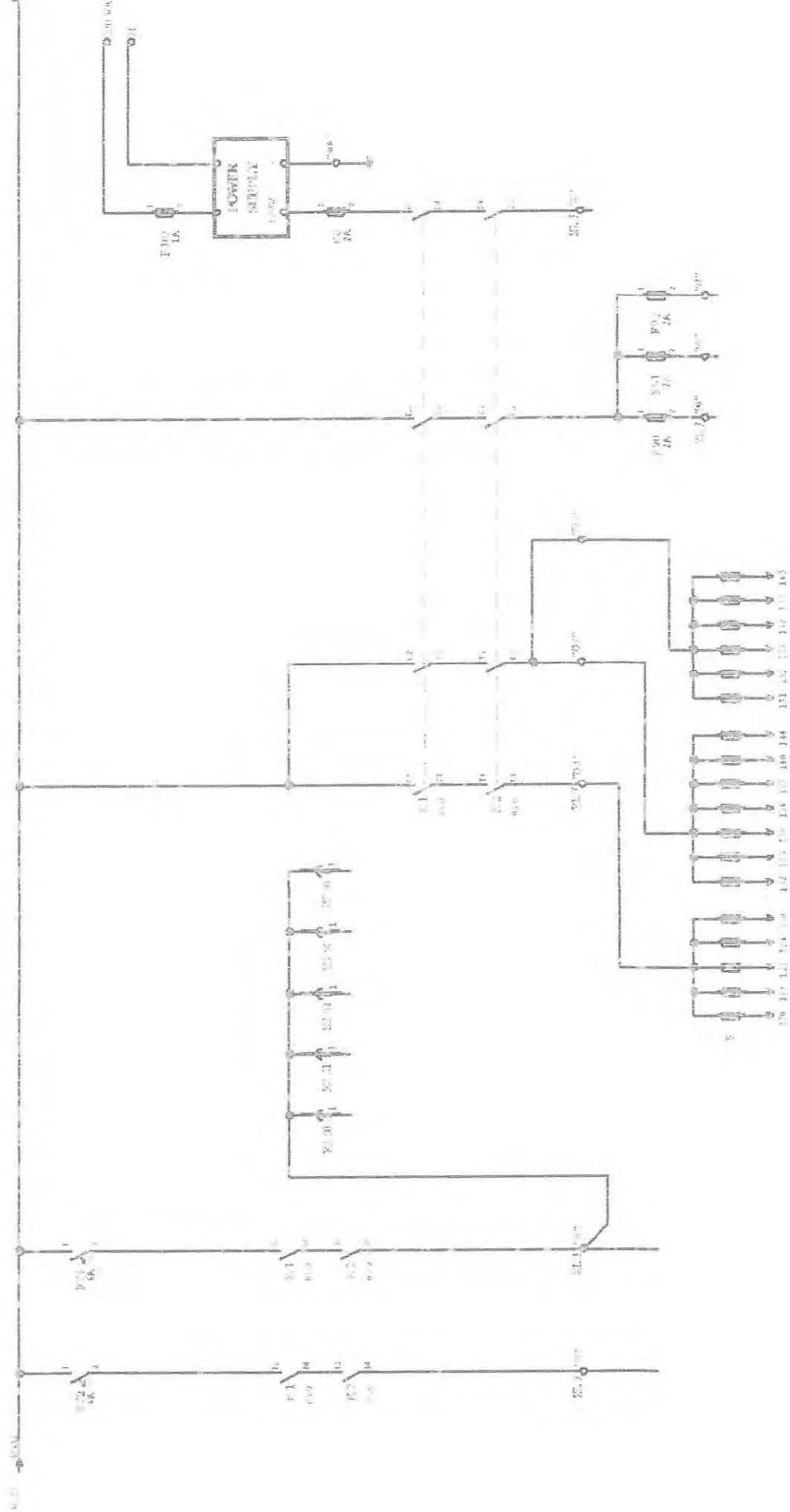
Table: 01 - 07 / 4 1956, 193
 Date: 05.11.1956, 193
 © 1956, 1956, 1956, 1956, 1956

2005.55F TELEMECANIQUE (TNOZ)

QDCM 400

001 220V
 002 220V
 003 220V
 004 220V
 005 220V
 006 220V
 007 220V
 008 220V
 009 220V
 010 220V

1 2 3 4 5 6 7 8 9 10 11



NAME
POSITION

DATE

REVISION NO.

SCALE

DATE

NTP

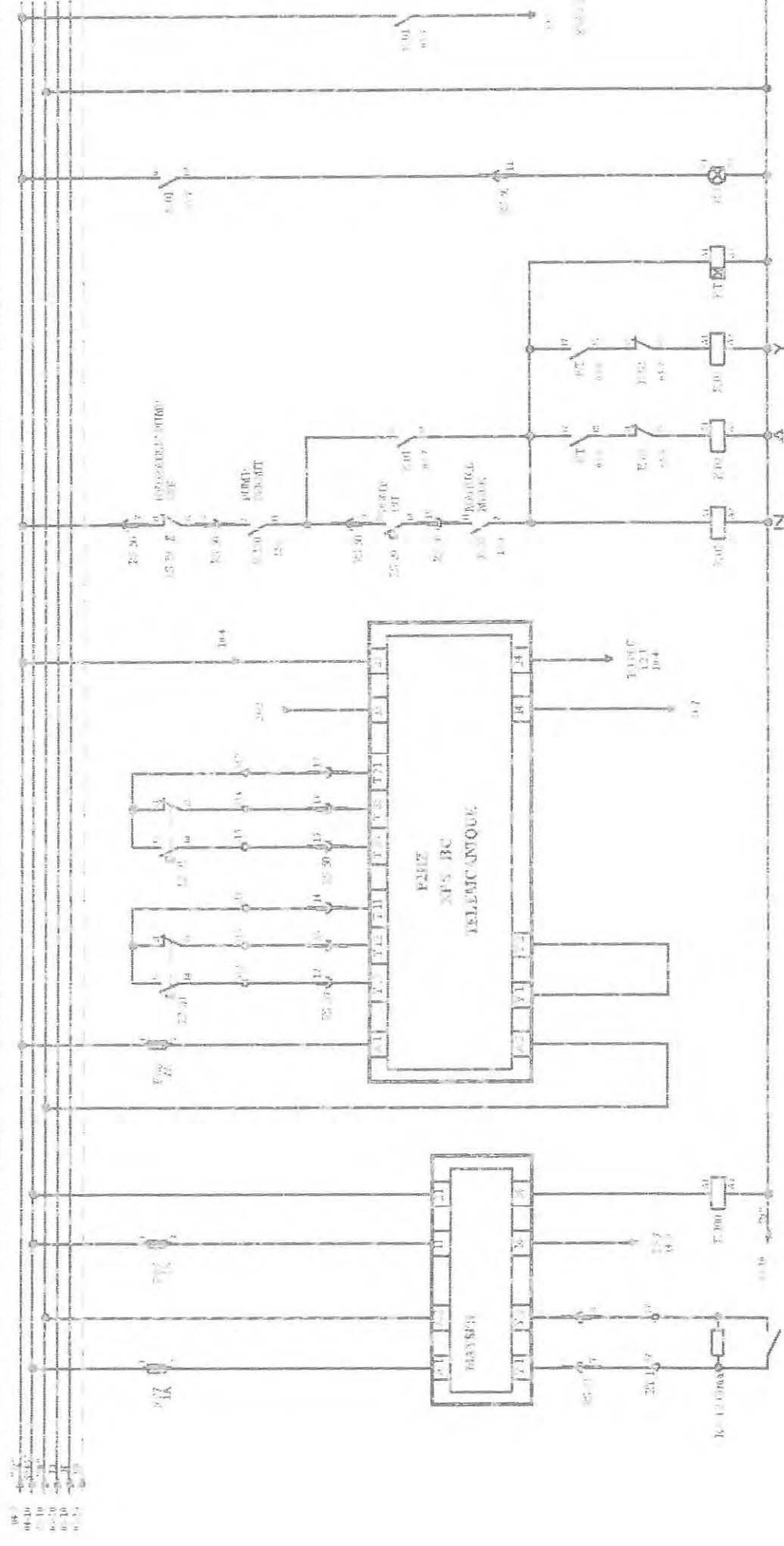
ИЗ. - 47 - 2-25 *Konstruktion-Karte*
 ИЛ. *Schaltplan 13*
 10-1 + 18 / 17 / 4 300G-50A
 10-1 + 45 / 17 / 4 300G-50B
 * - email: ntp@npp.ru, 1000000-1

УТВЕРЖАЮЩИЙ	ИЗДАНИЕ	КОЛИЧЕСТВО
ПОДПИСАВШИЙ	КОЛИЧЕСТВО	КОЛИЧЕСТВО
ПРОЕКТИРУЮЩИЙ	КОЛИЧЕСТВО	КОЛИЧЕСТВО
ПРОЕКТИРОВЩИК	КОЛИЧЕСТВО	КОЛИЧЕСТВО

ИЗДАНИЕ
 КОЛИЧЕСТВО
 КОЛИЧЕСТВО

ИЗДАНИЕ
 КОЛИЧЕСТВО
 КОЛИЧЕСТВО

1 2 3 4 5 6 7 8 9



TUBE METER (M)

100%	100%	100%	100%
0.5	0.5	0.5	0.5
0.4	0.4	0.4	0.4
0.3	0.3	0.3	0.3
0.2	0.2	0.2	0.2
0.1	0.1	0.1	0.1
0.05	0.05	0.05	0.05
0.02	0.02	0.02	0.02
0.01	0.01	0.01	0.01

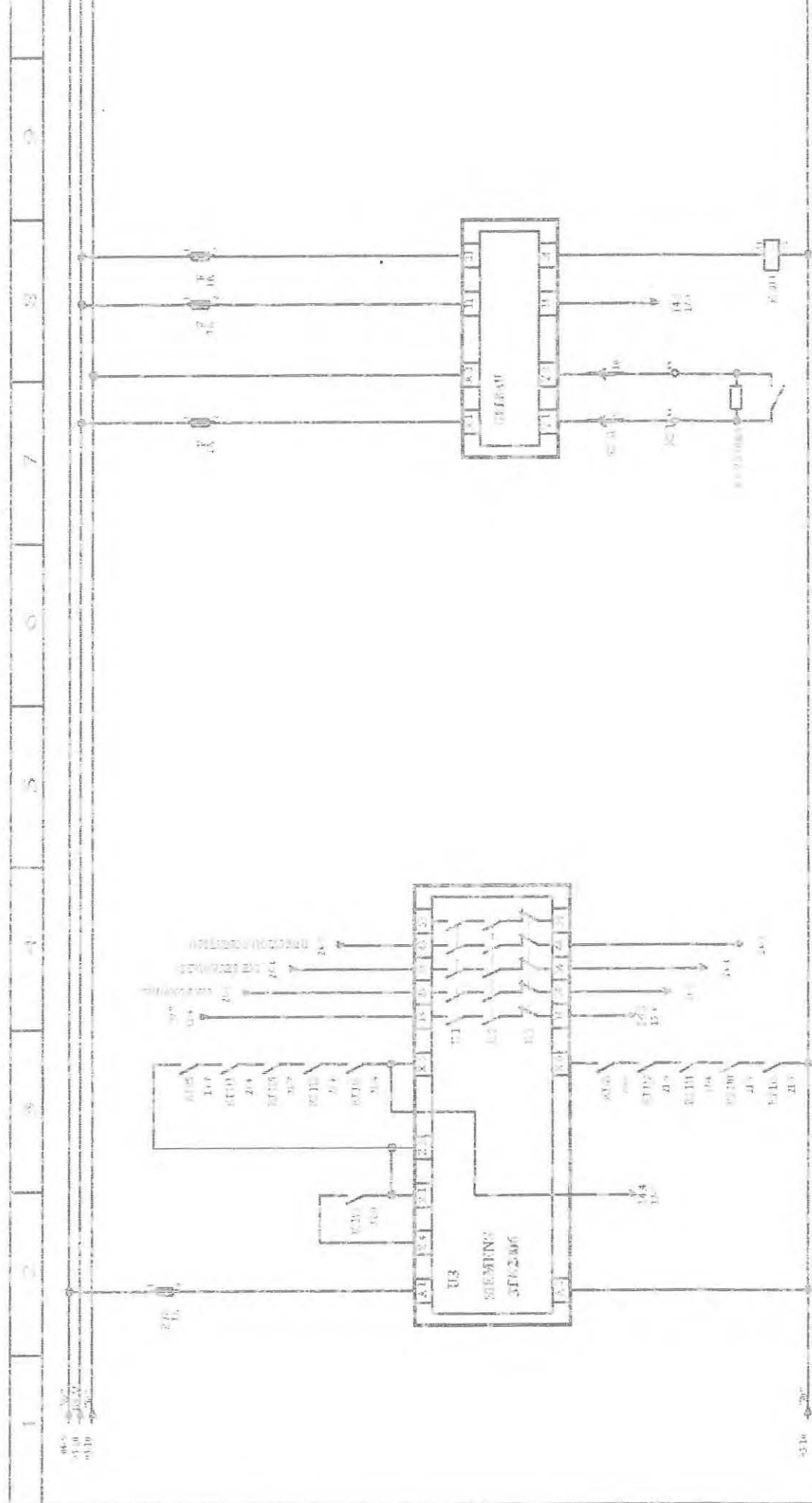
50 CLOUTIER

100%	100%
0.5	0.5
0.4	0.4
0.3	0.3
0.2	0.2
0.1	0.1
0.05	0.05
0.02	0.02
0.01	0.01

PL - 47 - 225 Anticypsyn-A-101e
 UL Schema 15
 100% 48/100% 4 000 200
 100% 48/100% 4 000 200
 100% 48/100% 4 000 200

QDCM 400





1961 0300
SOP 1.1.1961
CORREKTUR

10000
417
210
107
106

NTP

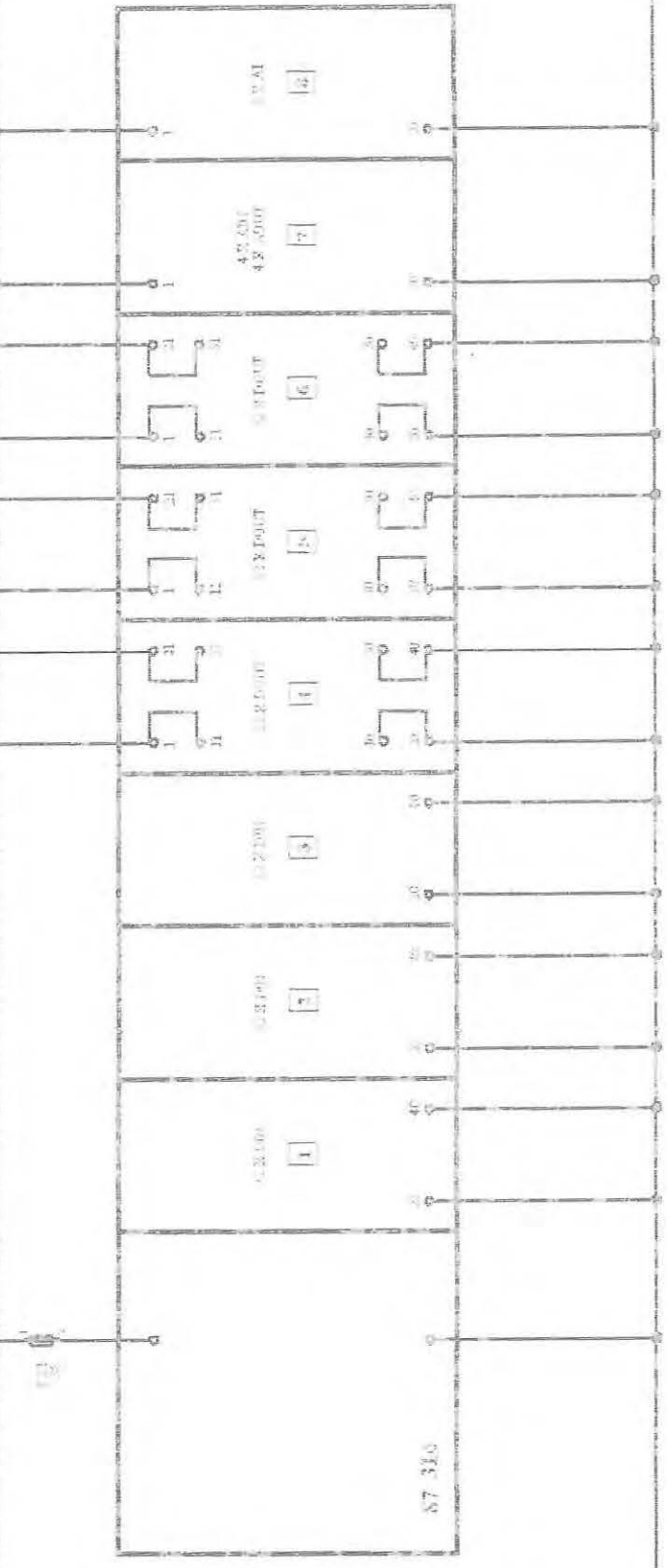
PL - 47 - 225 *Elektronen-Arbeit*
 U. Schöcherl 15
 Tel.: 46 7 77 1 4 686 20A
 GRS - 485 1 7 7 4 886 104
 G - sand, 1000/1000, 1000/1000

DATE: 1961 0300
 DRAWN BY: 1961 0300
 CHECKED BY: 1961 0300
 APPROVED BY: 1961 0300

QDCM 400

1 2 3 4 5 6 7 8 9

Legenda:
 - - - - -
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 - - - - -
 - - - - -
 - - - - -



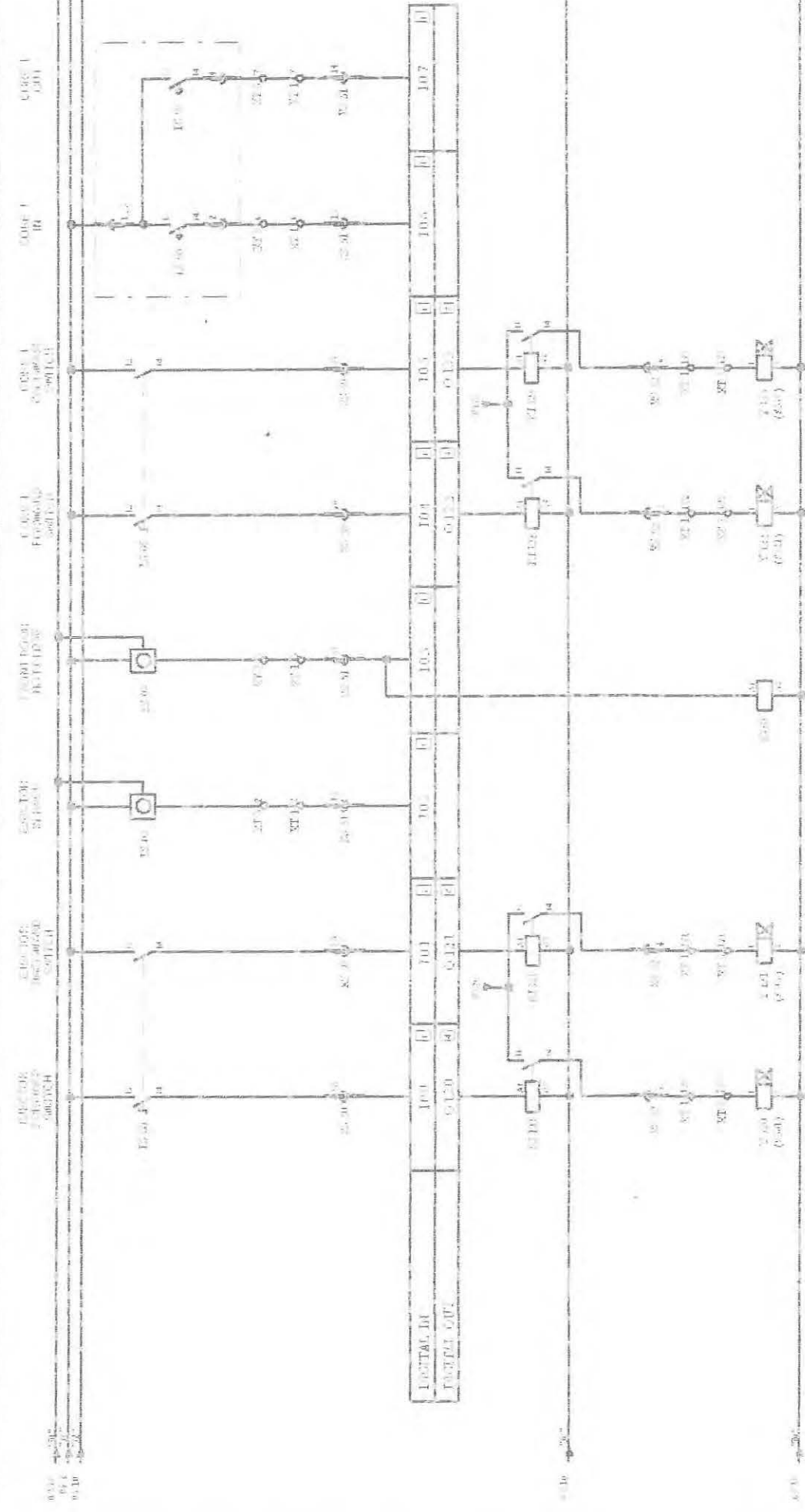
PI - 47 - 123 Kock-izlozhen-Nachle
 UA Skokhin 13
 tel: + 38 / 77 / 4 886 793
 fax: + 38 / 77 / 4 886 798
 e-mail: info@npp.kiev.ua

skladovaya karta	01.000.2.001.02
skladovaya karta	0001.01.000.000.02
skladovaya karta	01.01.000.000.02
skladovaya karta	01.01.000.000.02

skladovaya karta
 ODCM 400

skladovaya karta
 ODCM 400

1 2 3 4 5 6 7 8 9 10



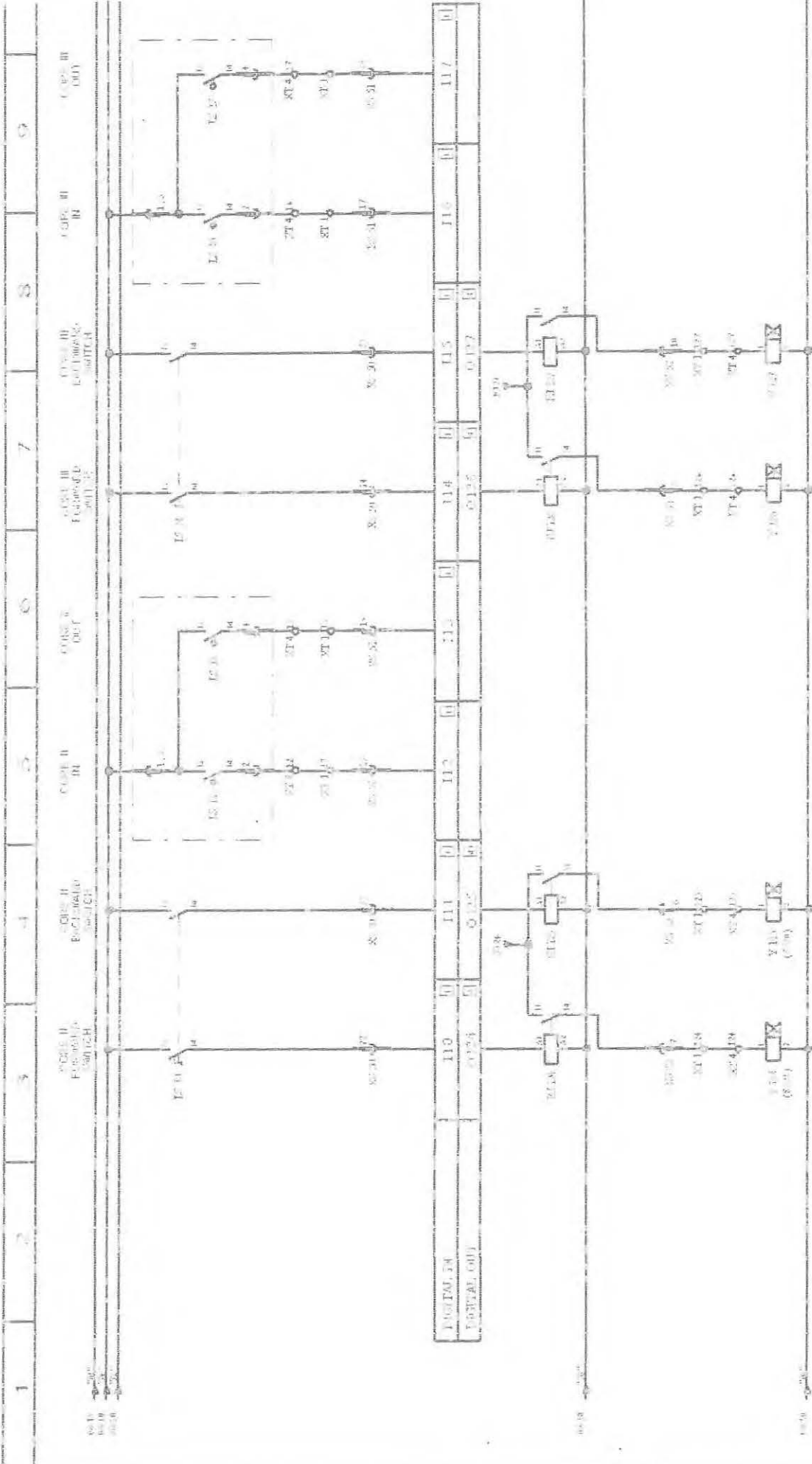
NTP

17. - 4" - 2.25 Kucheryn-Avobite
 11. S-kolna 15
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 1002 x 180 771 I 080 708
 2 - 100V 100A 50Hz 100V 100A

PROJEKTANT	19.01.2005	10.01.2005	Book 53
VERIFIED	19.01.2005	10.01.2005	Book 53
DATE	19.01.2005	10.01.2005	Book 53
SCALE	1:1	1:1	1:1

PROJEKT 1.2.25

QDCM 400



CASE II: Fused Switch

CASE II: Fused Switch

CASE II: Fused Switch

CASE II: Fused Switch

CASE II: Fused Switch

CASE II: Fused Switch

CASE II: Fused Switch

CASE II: Fused Switch

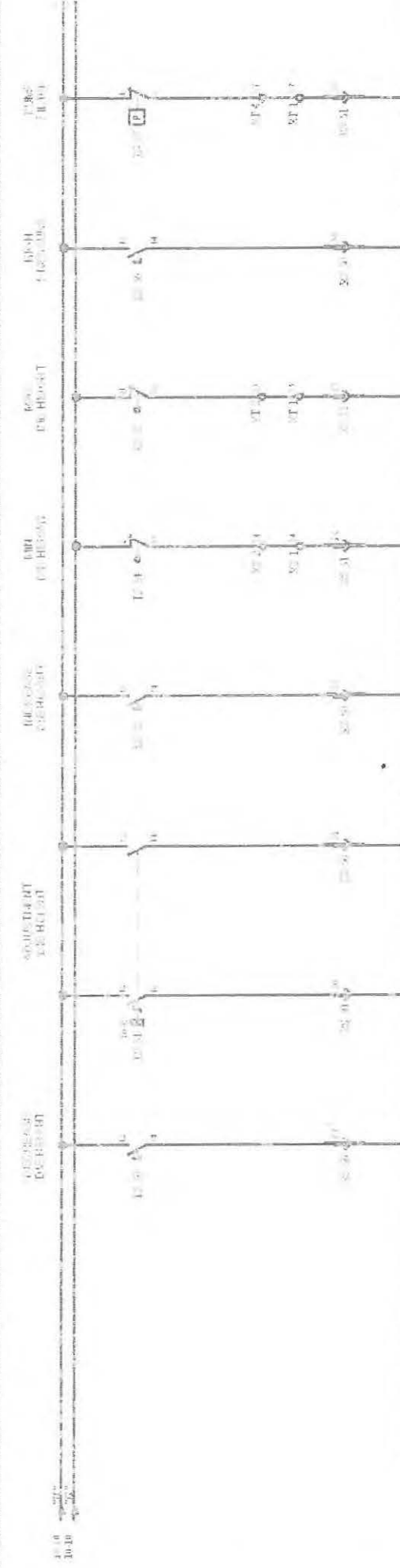
QDCM-100

DATE: 01.01.2000	BY: M. S. K.
REVISION: 01	DATE: 01.01.2000
DESCRIPTION: QDCM-100	SCALE: 1:1

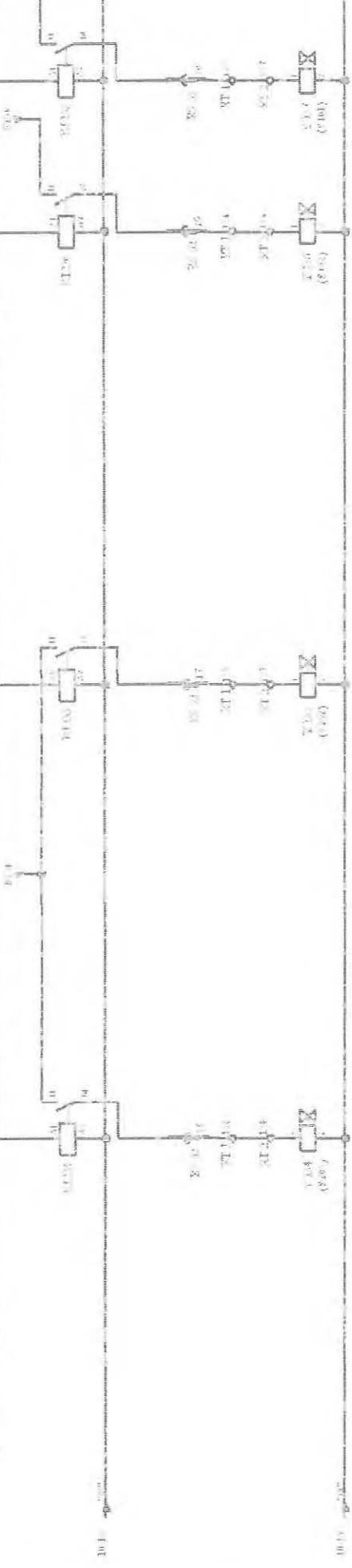
PL - 47 - 223 Kabin-80-Kode
 U. S. Kabin 13
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 1000 1000 1000 1000 1000



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DIGITAL IN	10.0	10.1	10.2	10.3	10.4	10.5	10.6	10.7	10.8
DIGITAL OUT	0.134	0.135	0.136	0.137	0.138	0.139	0.140	0.141	0.142



DIGITAL IN	10.0	10.1	10.2	10.3	10.4	10.5	10.6	10.7	10.8
DIGITAL OUT	0.134	0.135	0.136	0.137	0.138	0.139	0.140	0.141	0.142

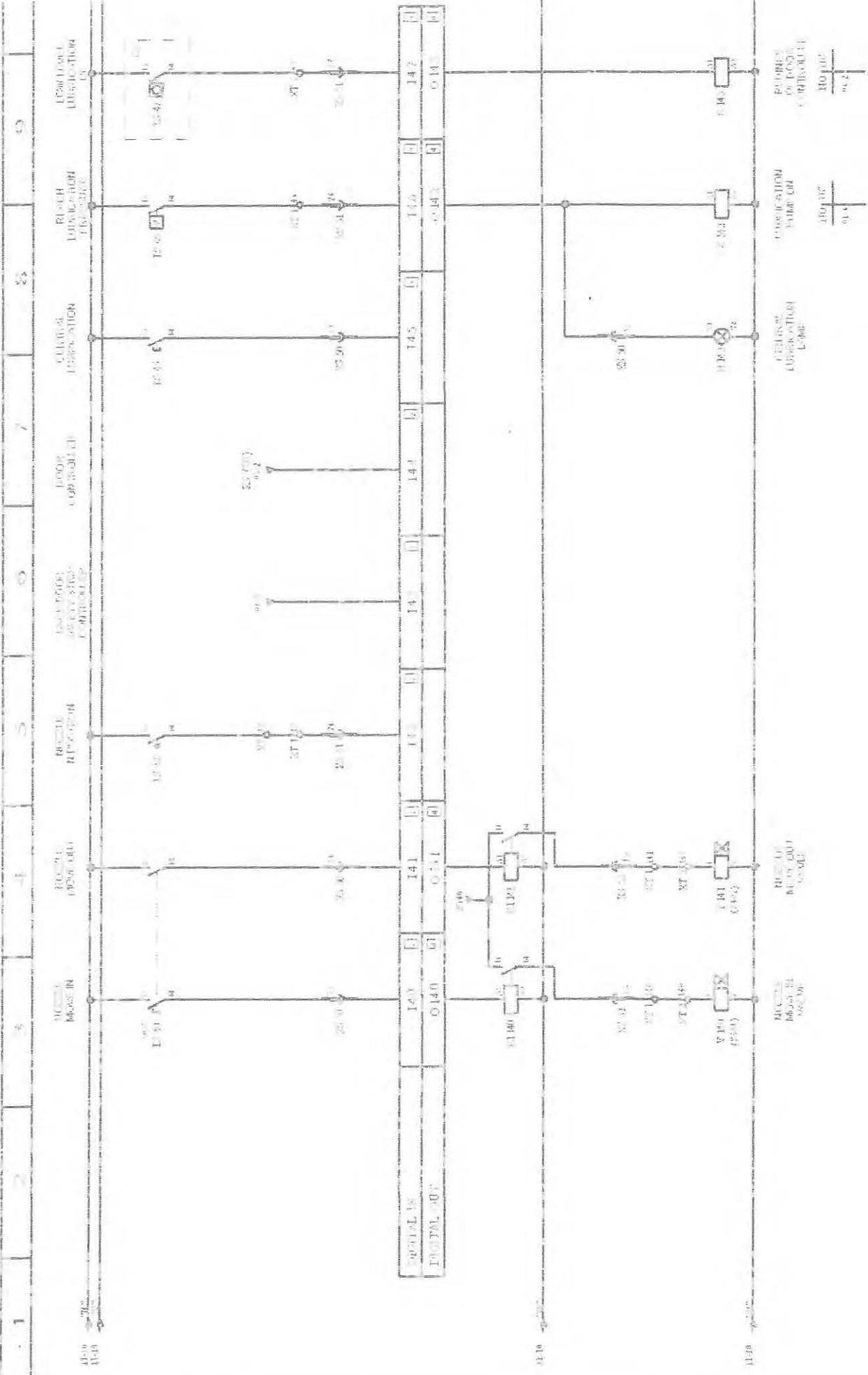


ИЛ - 47 - 2.13 Краткий-Note
 ИЛ-Счетки 15
 Изд. 1-48 / 77 / 1-876 503
 Изд. 2-48 / 77 / 1-876 506
 © 1977, NIP, Moscow, U.S.S.R.

DESIGNED BY	30.06.1966 G.I.
CHECKED BY	30.06.1966 G.I.
APPROVED BY	30.06.1966 G.I.
DATE	30.06.1966

QDCM 400

TOTAL	1
TOTAL	1



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AC MAIN	MOTOR	MOTOR	MOTOR	MOTOR	MOTOR	MOTOR	MOTOR	MOTOR
143	141	142	143	144	145	146	147	148
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NTP

PL-47-223 *As per drawing - Keble*
PL-47-223-15

Wks. 1-48, 1-51, 1-52, 1-53
 Rev. 1-48, 1-51, 1-52, 1-53

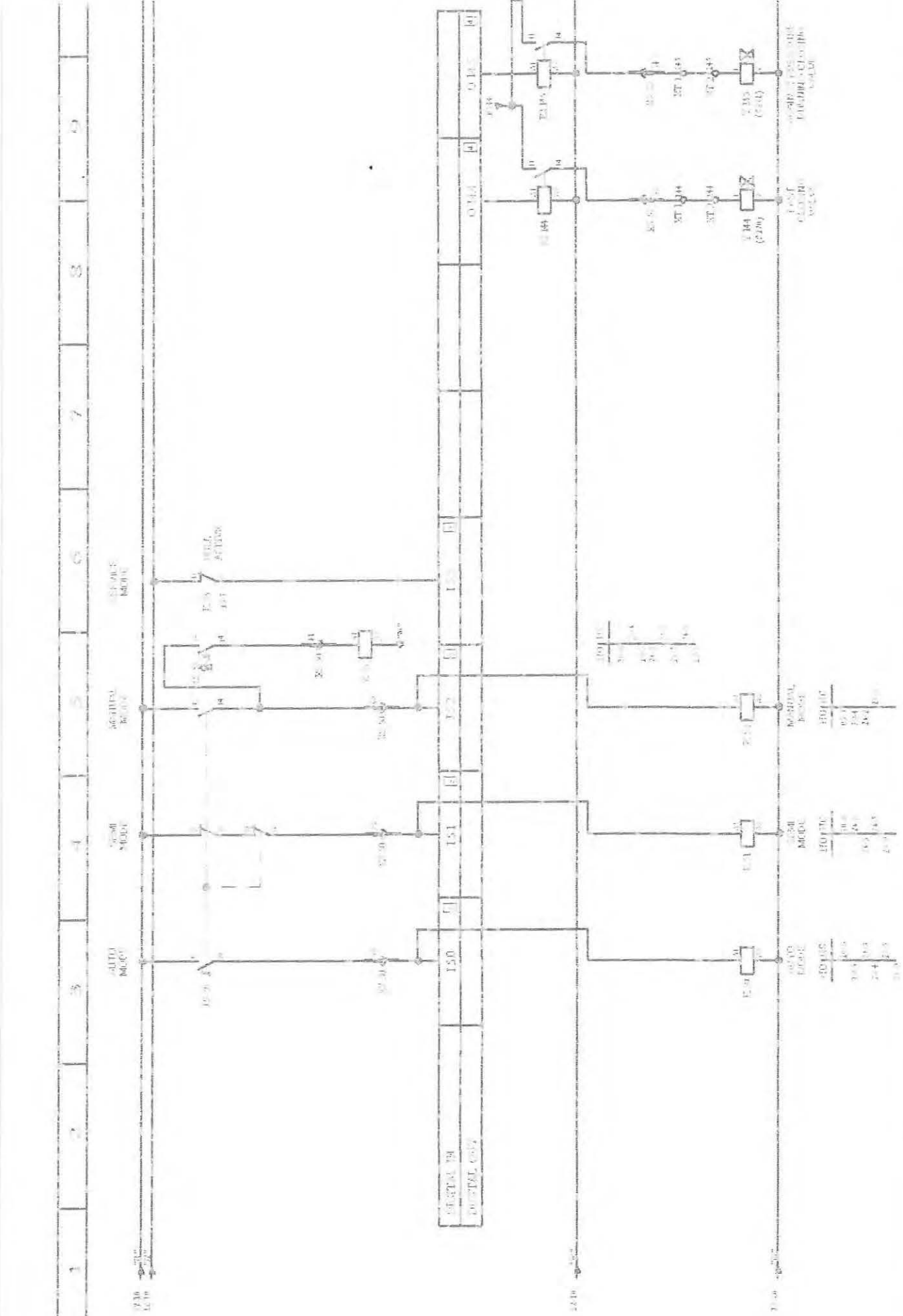
Approved: *[Signature]*, Engineer

REVISIONS

NO.	DESCRIPTION	DATE
1	AS PER DRAWING	1-48
2	AS PER DRAWING	1-51
3	AS PER DRAWING	1-52
4	AS PER DRAWING	1-53

APPROVED: *[Signature]*

DATE: 1-48



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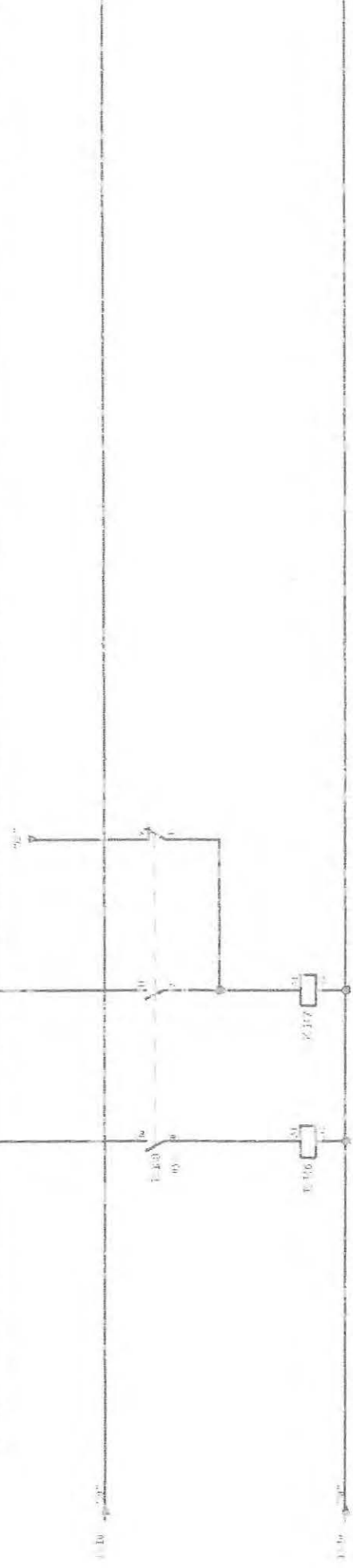
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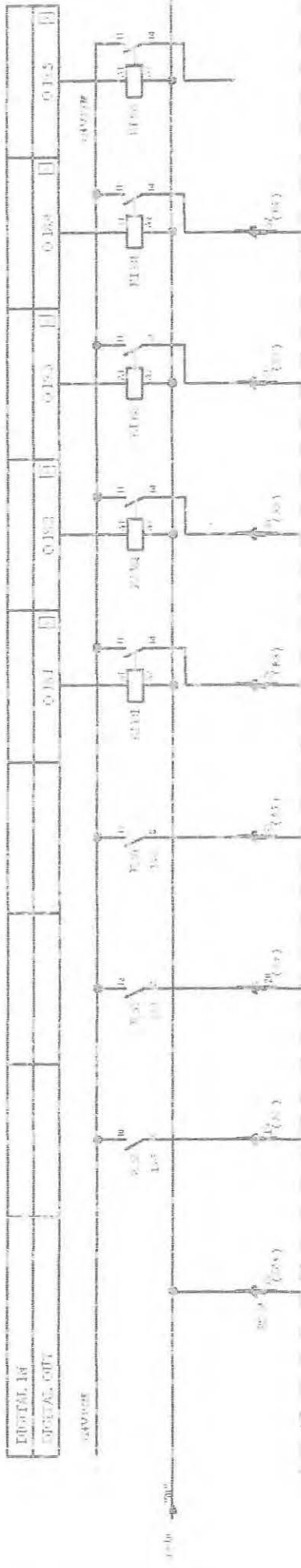
PL-17-228 *Kocherzh-Kocher*
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 Vol. 1 - 48 / 77 / 4886 F01
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DATE	2001.02.02	2001.02.02	2001.02.02
BY

QDCM 400

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STOP YES
UP YES
DOWN YES

STOP	UP	DOWN	STOP	UP	DOWN	STOP	UP	DOWN
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NTP

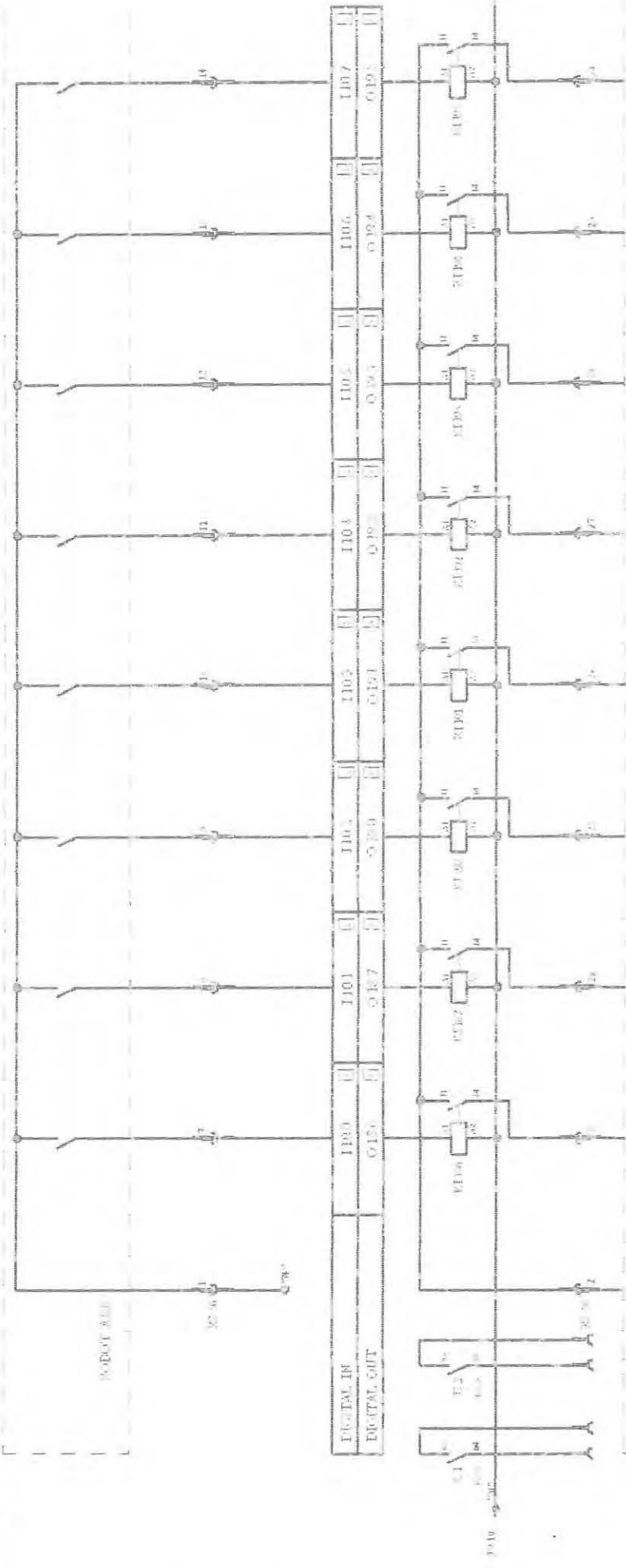
PL - 87 - 323 Kreflexsystem-3-001e
 Ullrichkollet 13
 Tel. +48 / 77 / 4 896 893
 Fax. +48 / 77 / 4 896 768
 e-mail: ntp@nyp.pl, ntp@nyp.pl

PL - 87 - 323 Kreflexsystem-3-001e
 Model: 3003-3003-02
 Max. weight: 3000 kg
 Max. height: 10-01-2008
 Max. speed: 30-01-2008

REACHING 100%
 QDCM 400

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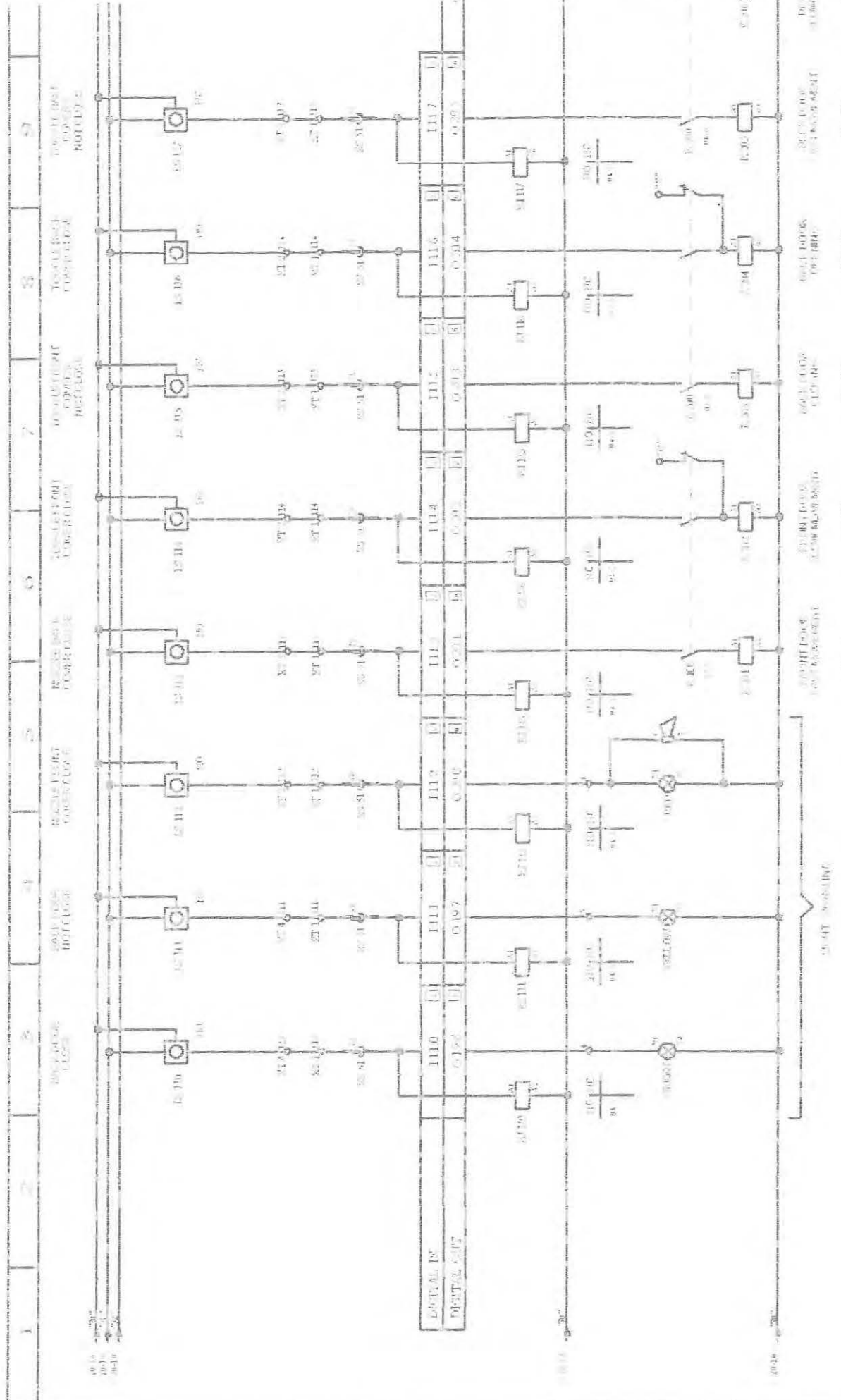
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PL-37-223 *Будетермодель*
 U.S. Patent 15

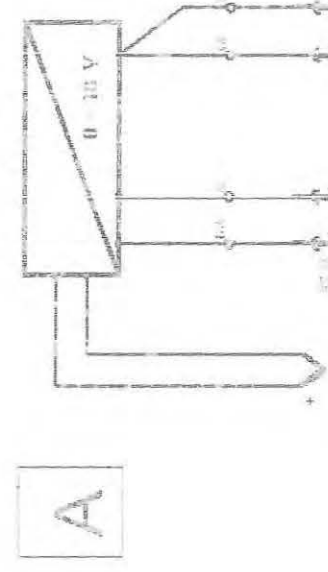
1012 - 481 771 4 886 203
 1013 - 481 771 4 886 206
 © - 1953, NTP Corp., Boston, MA

1014 - 481 771 4 886 207
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 1016 - 481 771 4 886 209
 1017 - 481 771 4 886 210
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 1019 - 481 771 4 886 212
 1020 - 481 771 4 886 213

QDCM 100

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РАСПОЛОЖЕНИЕ ЭЛЕМЕНТОВ

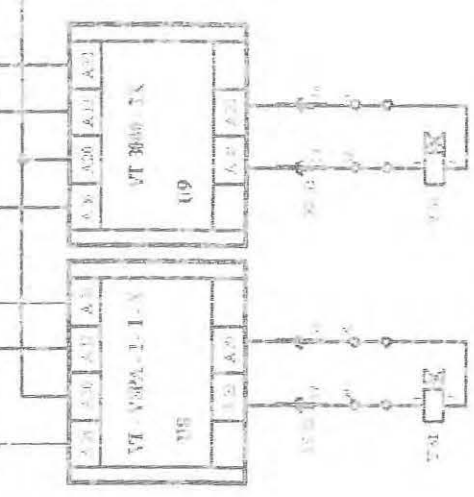


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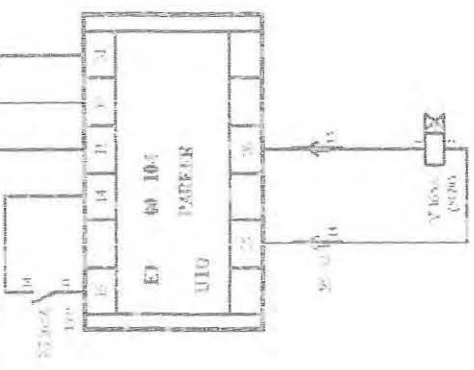
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АВТОМАТ	А11+ 3	А11- 10	А12+ 11	А12- 12	А13+ 13	А13- 14	А14+ 15	А14- 16	А15+ 17	А15- 18	А16+ 19	А16- 20
АВТОМАТ	А0V1+ 4	А0V1- 5	А0V2+ 6	А0V2- 7	А0V3+ 8	А0V3- 9	А0V4+ 10	А0V4- 11	А0V5+ 12	А0V5- 13	А0V6+ 14	А0V6- 15

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ЭЛЕМЕНТЫ И КОМПОНЕНТЫ
ПРОЕКТА ИЛИ ИТОГА РАБОТЫ



ЭЛЕМЕНТЫ И КОМПОНЕНТЫ
ПРОЕКТА ИЛИ ИТОГА РАБОТЫ

NTP

ИЛ - 87 - 225 Криворожский завод
Ул. Свободы 15
Тел.: 48 77 1 4 886 593
Факс: 48 77 1 4 886 708
E-mail: ntp@npp.kiev.ua

Исполнитель	ИЛ	ИЛ 87-225	01
Заказчик	СЗ	600	М 1000 08 92
Выполнение	10.01.2008	Рез. М	
Принятие	30.01.2008	ИЛ 87-225	01

Исполнитель ИЛ

QPCM 400

ИЛ 87-225
01

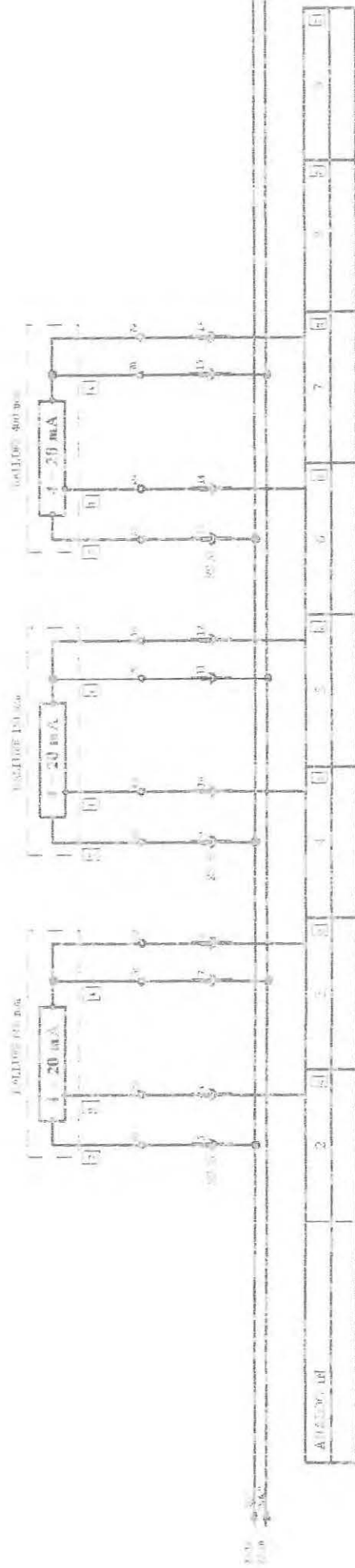
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65

B

Pl. - 47 - 2.25 Kacheryyev-Avto
Uk. Scharf 13

№ 4 9 43 / 77 / 1 1988 293
№ 4 9 43 / 77 / 1 1988 293
K. mail: ntp@yandex.ru

ntp

СЛУЖБА ПО МАТЕРИАЛАМ	№ 2001/01
МАТЕРИАЛЫ	№ 2001/01/01/01/01
ДЛЯ РАБОТЫ	№ 2001/01/01/01/01
ДЛЯ РАБОТЫ	№ 2001/01/01/01/01

QDCM 400

QDCM 400

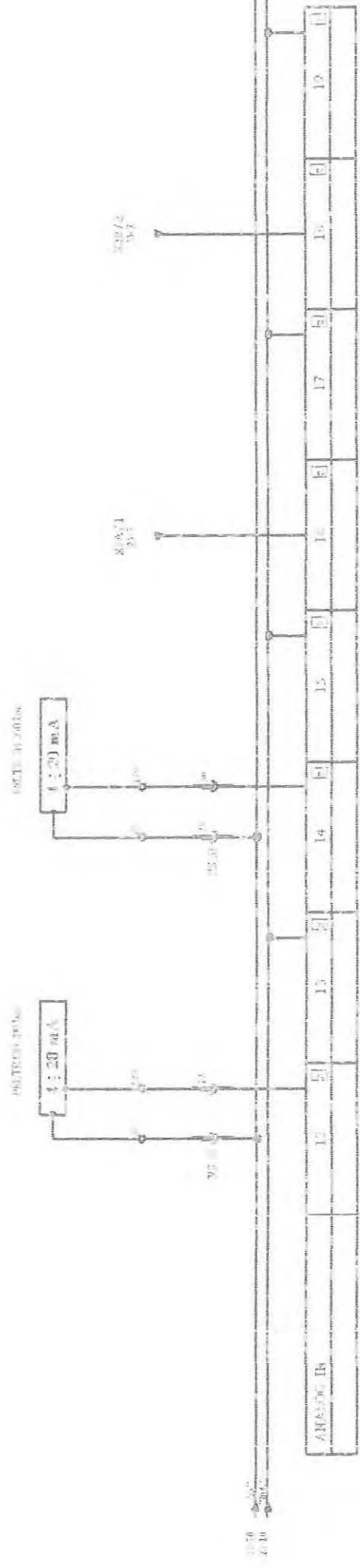
1	2	3	4	5	6	7	8	9
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1000V 5000 Hz

1000V 5000 Hz

1000V 5000 Hz

1000V 5000 Hz



7AK5507 Bb

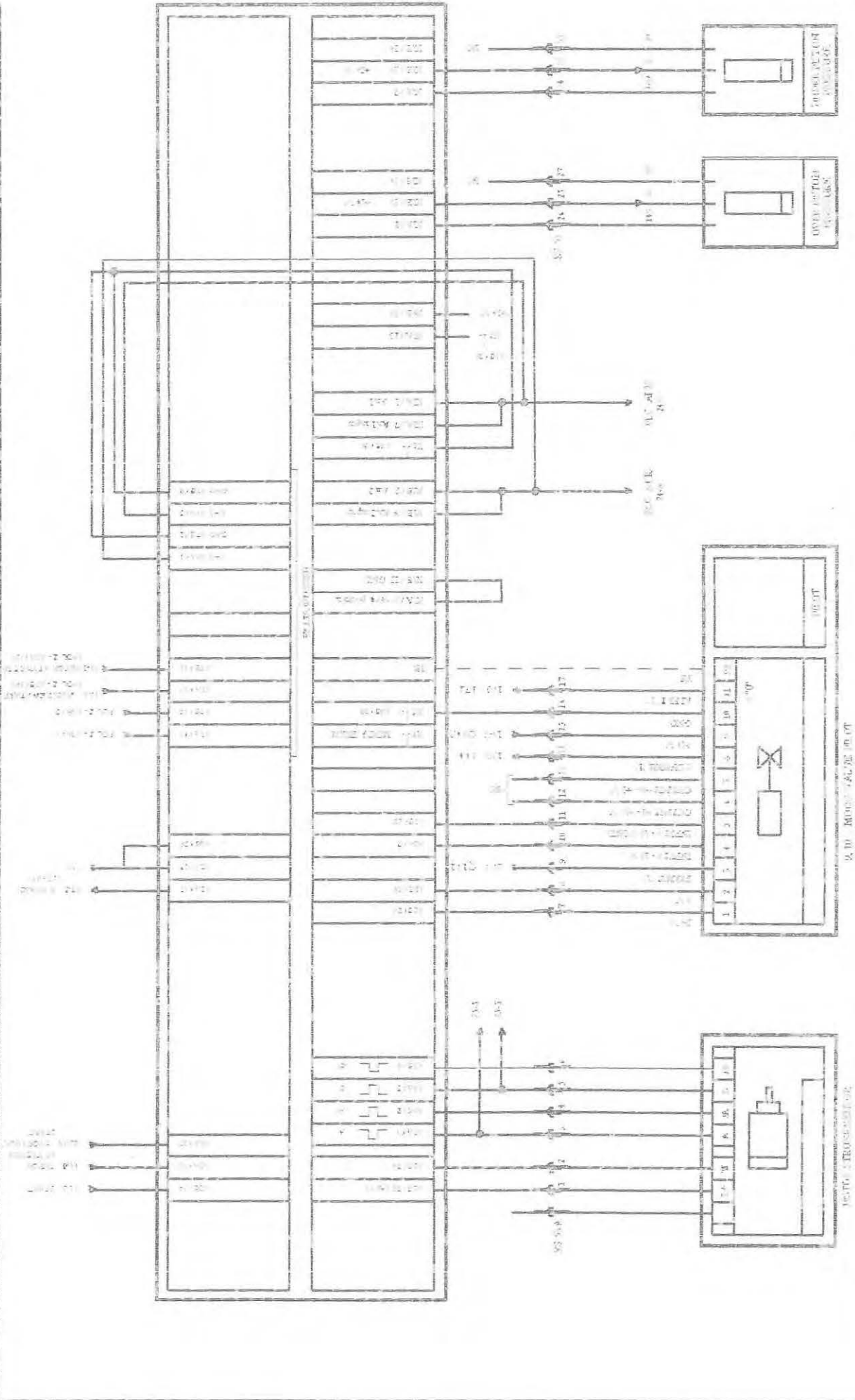
NTP

PL-47 - 225 Kubitovym-Kubit
 EL S-Kobus 15
 4014 + 48 1771 + 4886 793
 4014 + 48 1771 + 4886 793
 n. mail. (kubov, kovov, pl)

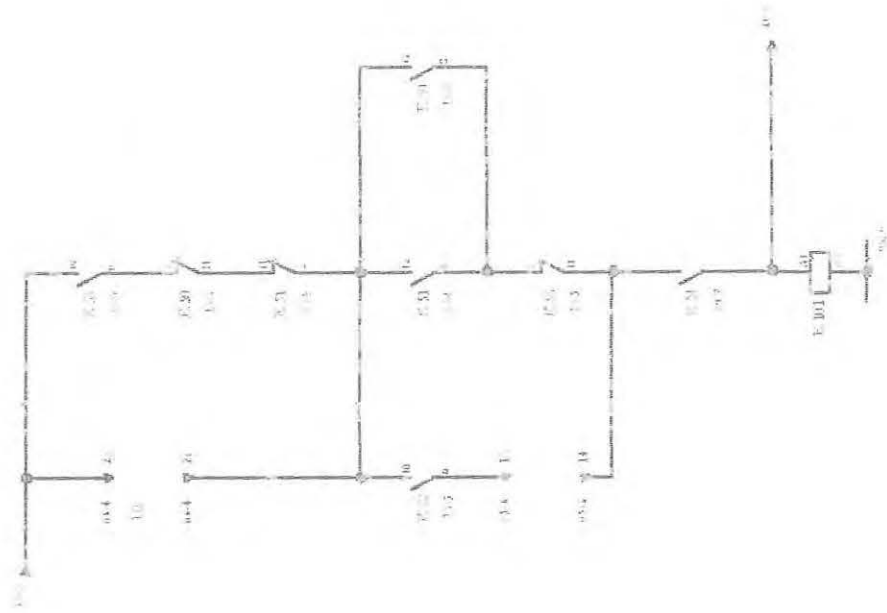
QDCM 400

1000V 5000 Hz

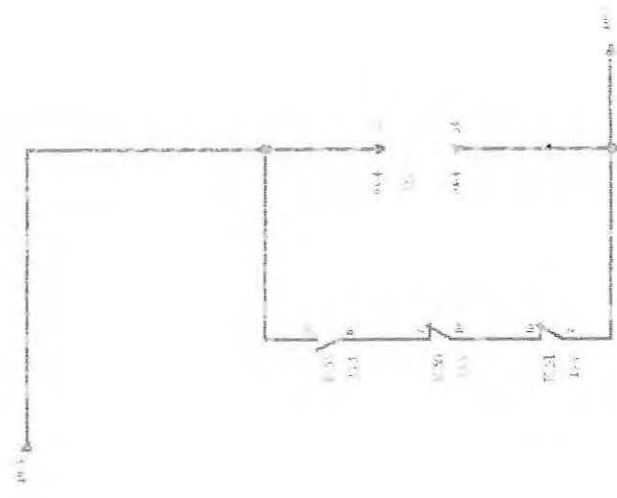
0-1000V 100V	0-1000V 100V
100V 1000V 100V	100V 1000V 100V
100V 1000V 100V	100V 1000V 100V
100V 1000V 100V	100V 1000V 100V



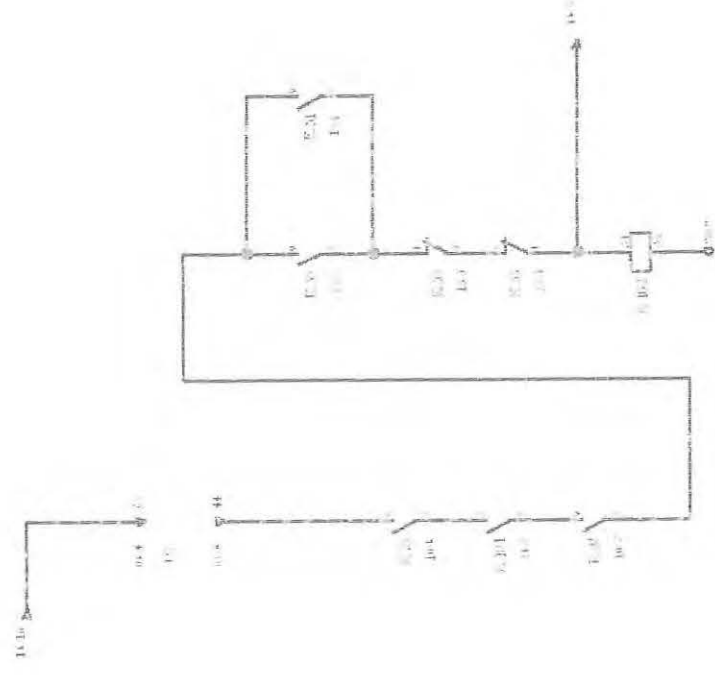
1 2 3 4 5 6 7 8 9 10



PR. 27 - 2.25



PR. 27 - 2.25



PR. 27 - 2.25



PR. - 27 - 2.25

PR. 27 - 2.25

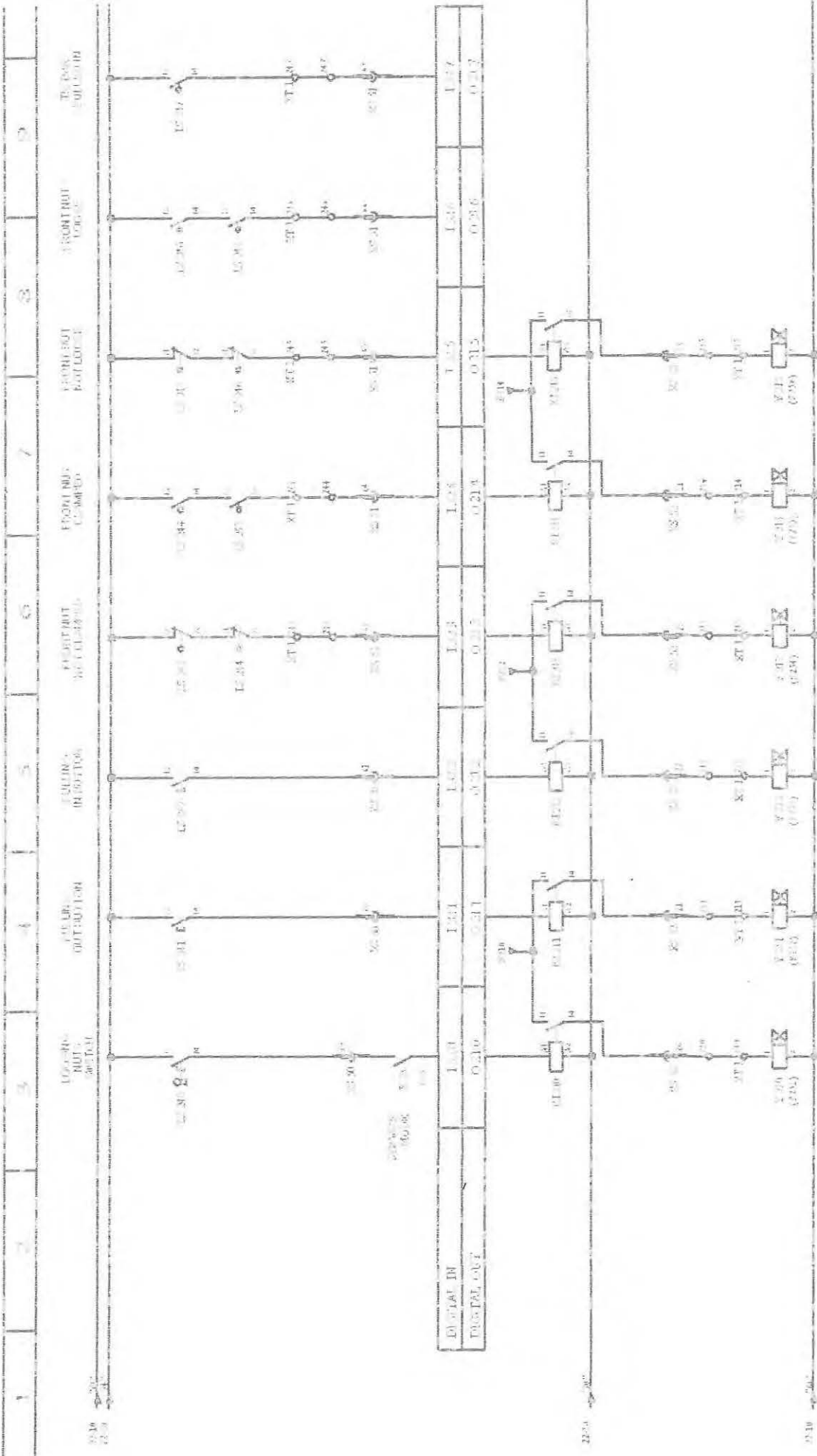
PR. 27 - 2.25

PR. 27 - 2.25	PR. 27 - 2.25
PR. 27 - 2.25	PR. 27 - 2.25
PR. 27 - 2.25	PR. 27 - 2.25
PR. 27 - 2.25	PR. 27 - 2.25

PR. 27 - 2.25

PR. 27 - 2.25

PR. 27 - 2.25



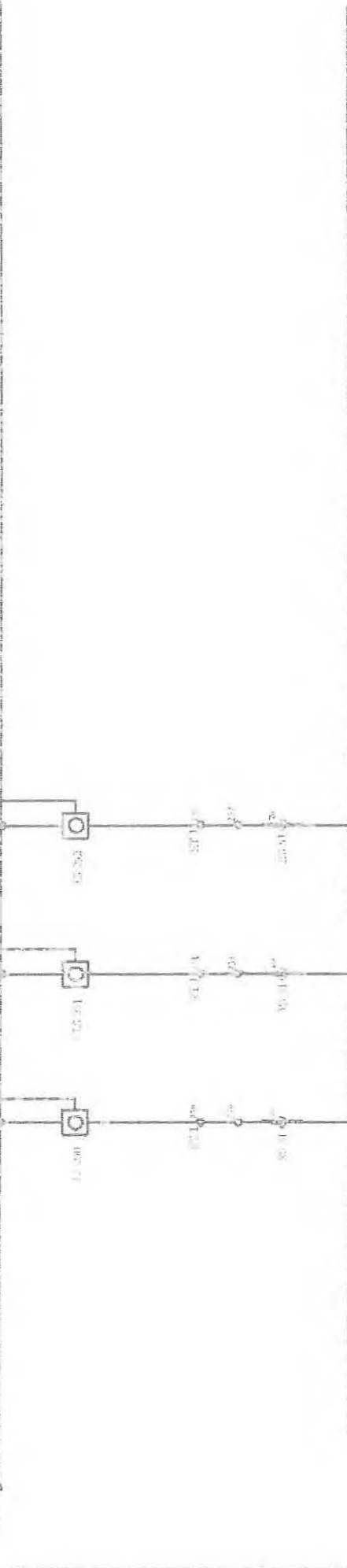
PL-47-225 Kachkovskiy-Koche
 UR, Skolova IS
 1954. 10. 21 / 77 / 1. 1956. 10. 21
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 1954. 10. 21 / 77 / 1. 1956. 10. 21

DATE: 2007. 09. 12
 006 / 21. 5. 2007. 06. 02
 30. 07. 2005. 16. 03. 14
 20. 01. 2005. 18. 28. 20. 20

QDCM 400

NTP

1	2	3	4	5	6	7	8	9	10	
UNIT 100-001			UNIT 100-001		UNIT 100-001		UNIT 100-001		UNIT 100-001	
100-001			100-001		100-001		100-001		100-001	
100-001			100-001		100-001		100-001		100-001	



UNIT	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001
100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001
100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001

1	2	3	4	5	6	7	8	9	10
100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001
100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001
100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001	100-001

NTP

PA-47-225 Newington-Airfield
 U.S. AIR FORCE
 481771-886-893
 481771-886-908
 ntp@mail.nwpd.af.mil

TELEPHONE 100-001
 100-001
 100-001
 100-001

QDCBI 400

4

HOT CHAMBER DIE CASTING MACHINE

QDCM 400

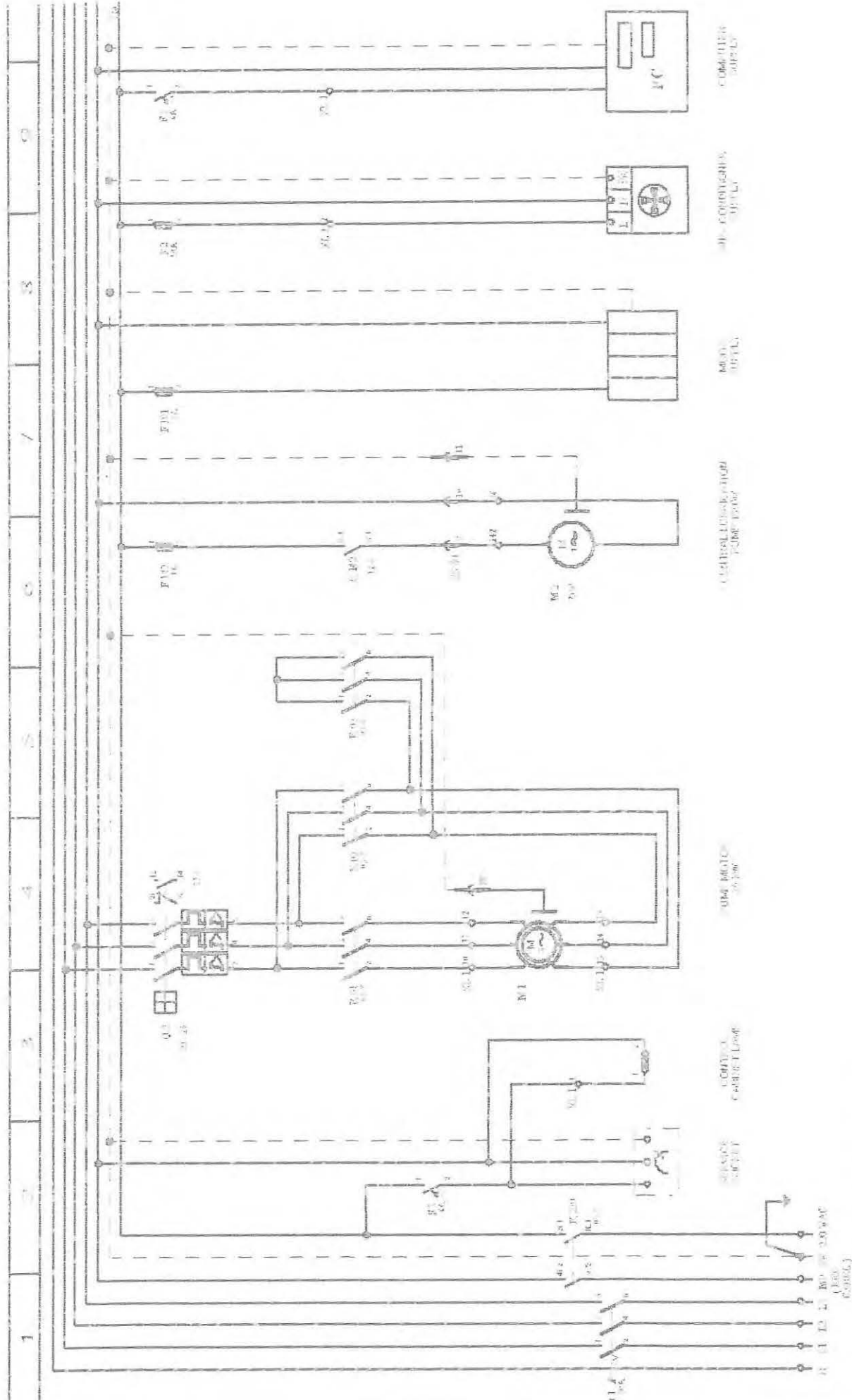
TMG 3 & 4



NOWOCZESNE TECHNOLOGIE PRODUKCJI Sp. z o.o.

PL - 47 - 225 KĘDZIERZYN - KOŹLE

UL. SZKOLNA 15



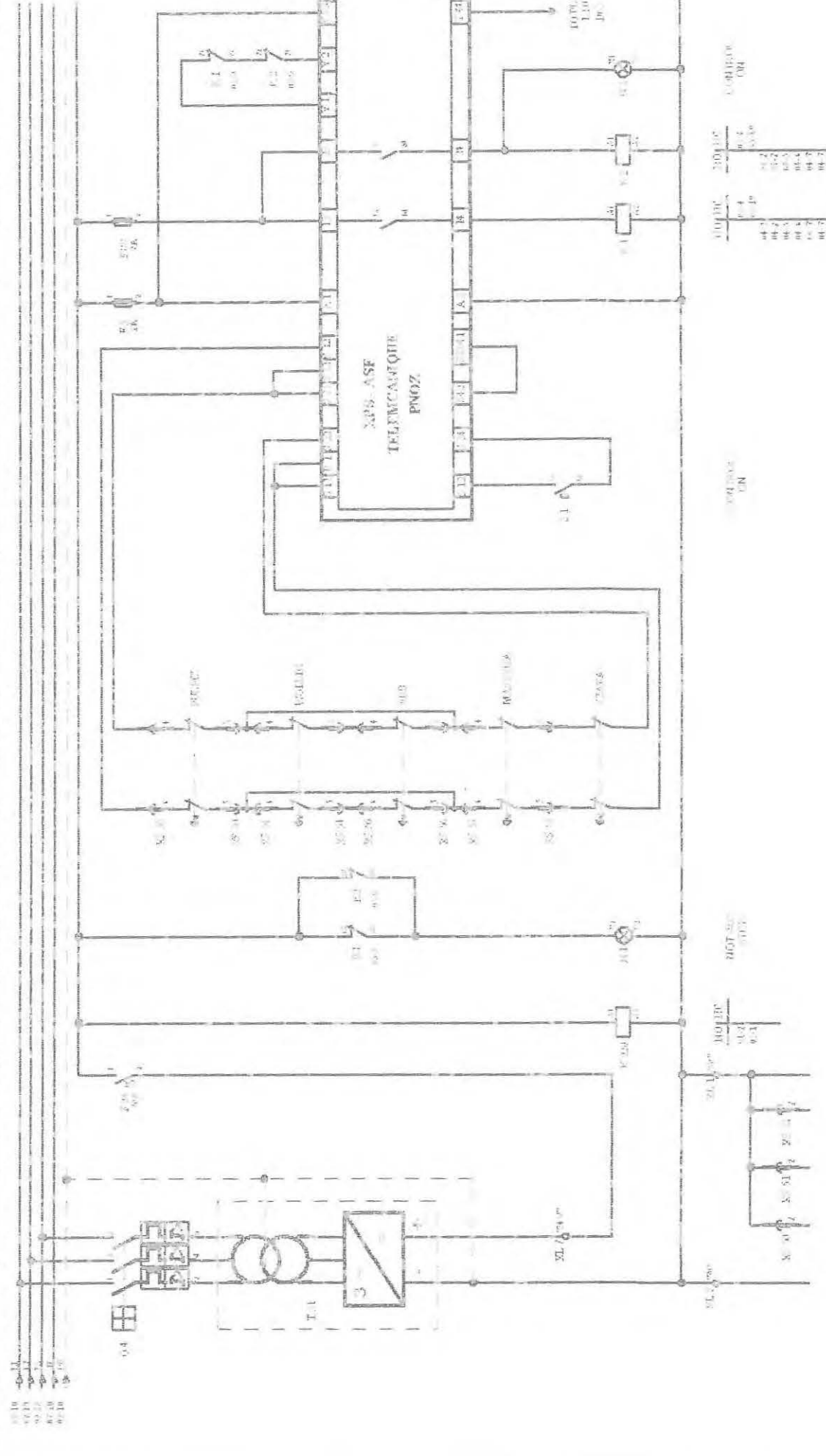
POWER SUPPLY SYSTEM WIRING DIAGRAM

PL - 47 - 225 Kędzierzyn - Koźle
Ul. Szkolna 15
 Tel.: +48 77 4 000 393
 Fax: +48 77 4 000 700
 e-mail: as@pulpin.pl

NIP

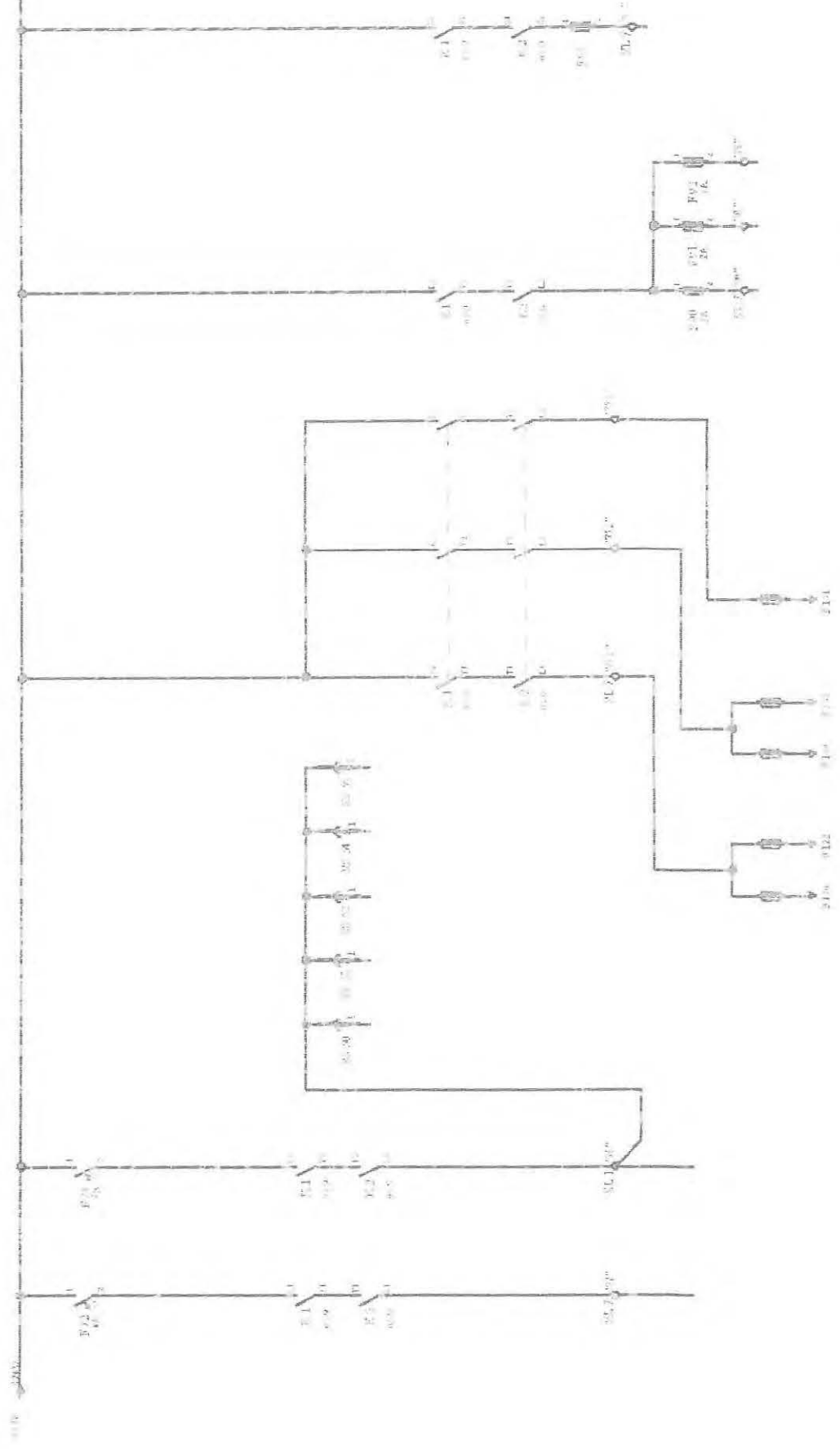
SCHEME NO.	R800 2005 01	MACHINE TYPE	QDCM 400
MACHINE NO.	2005 / M S 200 / 02-03		TMG 3 & 4
DESIGNER	75-11-2005		
DATE	10-11-2005		

1 2 3 4 5 6 7 8 9



NO	SYM	WART	WYK
1	R1	100Ω	100
2	R2	100Ω	100
3	R3	100Ω	100
4	R4	100Ω	100
5	R5	100Ω	100
6	R6	100Ω	100
7	R7	100Ω	100
8	R8	100Ω	100
9	R9	100Ω	100
10	R10	100Ω	100
11	R11	100Ω	100
12	R12	100Ω	100

1 2 3 4 5 6 7 8 9



SKYOT
CZAJKA
CZAJKA

3006
MOS 3192

01110160000 SUPPLY

01110160000 SUPPLY

KODS 010015



FL - 47 - 225 Kędzierzyn - Koźle

Ul. Szkolna 15

Tel: + 48 77 74 080 503
Fax: + 48 77 74 080 700
e-mail: kedy@npp.lodz.pl

SCHEME ID: PRCO 2005 01

ASSEMBLY NO: 3005 / M S100 / 01-03

REV: 0005 14-11-2005

DATE: 14-11-2005

MODULE TOP

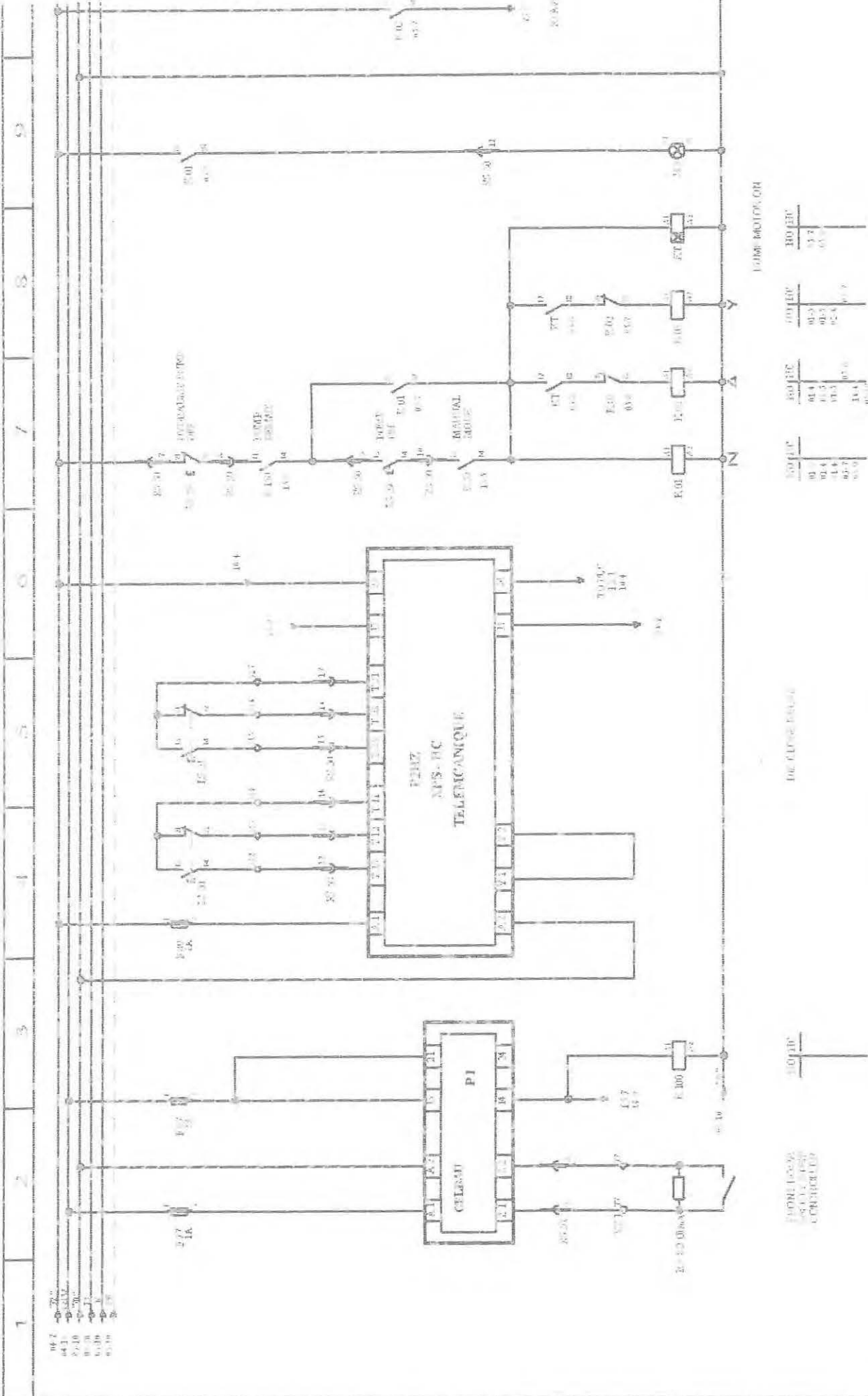
QDCM 400

TMG 3 2 3

SCHEM

1/1

1/1



POMIENIONA
KONSTRUKCYJNY
KONDUKTOR

100W

DE FUSE BOARD

COMP	QUANTITY	DESCRIPTION
01	005	011
02	005	012
03	005	013
04	005	014
05	005	015
06	005	016
07	005	017
08	005	018
09	005	019
10	005	020

COMP	QUANTITY	DESCRIPTION
01	005	011
02	005	012
03	005	013
04	005	014
05	005	015
06	005	016
07	005	017
08	005	018
09	005	019
10	005	020

FL - 47 - 225 Kozłowiezów - Kozłowiez

III. Szkolna 15

tel.: 4 40 77 / 4 806 543
fax: 4 48 77 / 4 806 704
e-mail: ntp@nbp.pl



SCHEMATIC NO. 24800.2005.01

MACHINE NO. 2005.06.3000.05.03

DATE 14.11.2005

BY: [Signature]

MACHINE TOP

QDCM 400

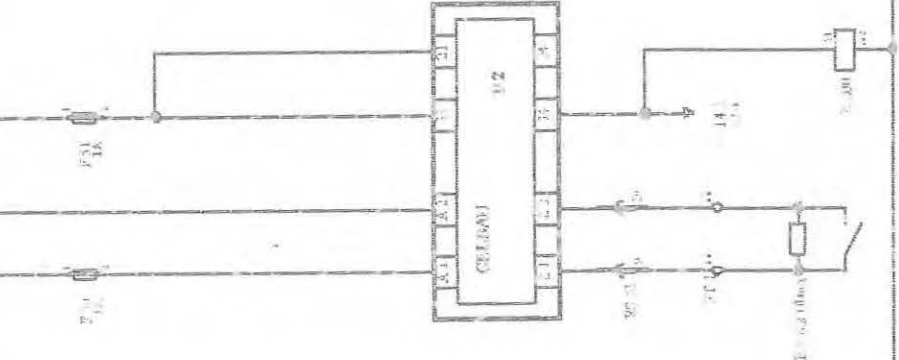
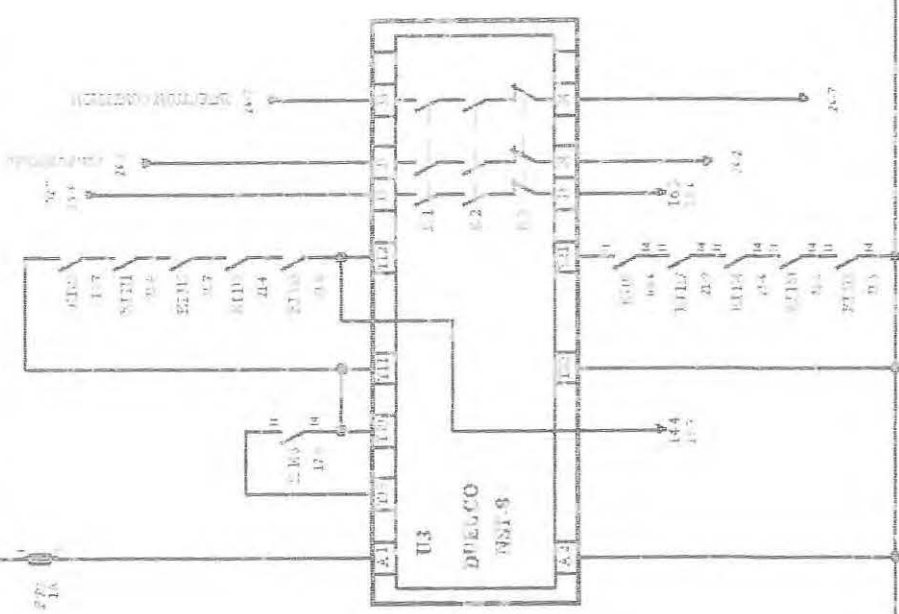
FIG. 2.4

SCM

DS.2

1

1 2 3 4 5 6 7 8 9



100V AC
200V AC
250V AC



PL - 47 - 225 Kędzierzyn - Koźle
Ul. Szkolna 15
Tel: 4 36 77 74 006 033
Tel: 4 36 77 74 056 004
e-mail: Wzrost@400000.pl

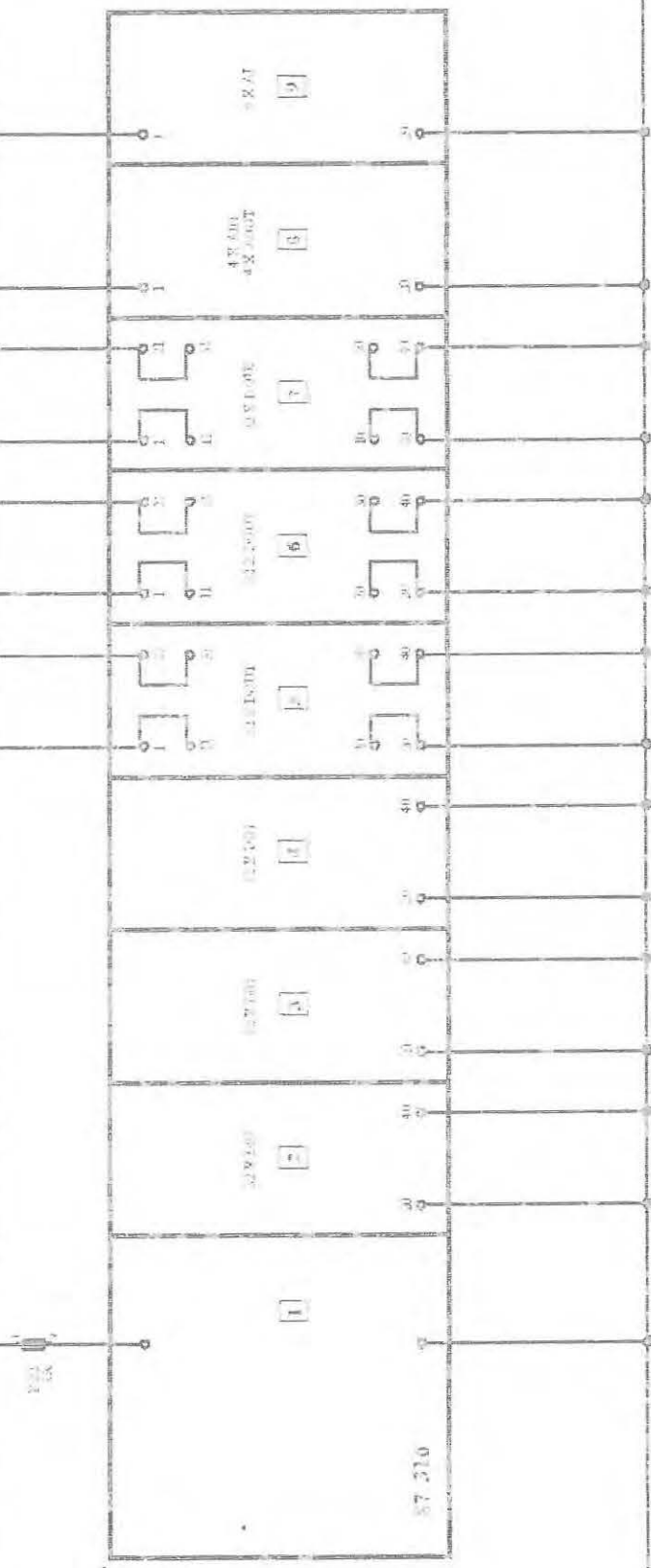
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MACHINE NO.	2005.M-5100.05-0
DESIGNER	14.11.2005
DATE	14.11.2005
PROJECTOR	14.11.2005
WORKSHEET NO.	W000004 IV

MACHINE TYPE
QDCM 400
TWC 3 & 4

SHEET NO. 1

1 2 3 4 5 6 7 8 9 10

0-10V
 0-10V
 0-10V
 0-10V



D D B B A



PL - 47 - 225 Kędzierzyn - Koźle
 Ul. Szkolna 15
 tel.: + 48 77 74 806 503
 fax: + 48 77 74 806 206
 e-mail: rtp@kpd.com.pl

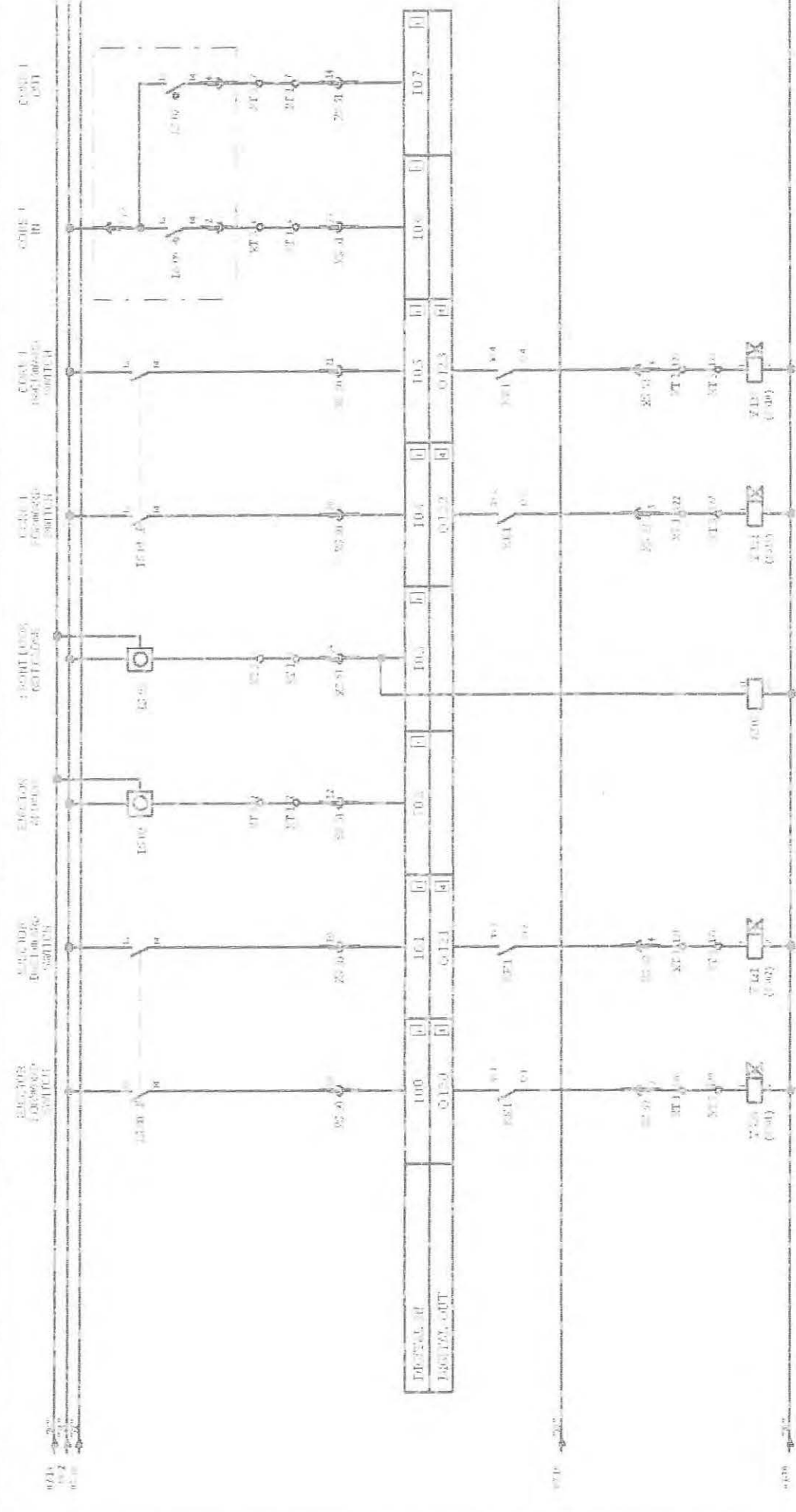
SCHLUSSEL NR.	4802 205.01
MASCHINEN NR.	2002.06.S100.008.01
TECHNISCHER	14.11.2103
ILLUSTRATION	14.11.2103
DATE	14.11.2003
BY	14.11.2003
SCALE	1:1

MACHINE TYPE

QDCM 400
TMC 3 5 4

SCH	1
END	1
TOTAL	1

1	2	3	4	5	6	7	8	9
---	---	---	---	---	---	---	---	---



100	100.5	10.7	10.5	10.5	10.5	10.5	10.5	10.7
-----	-------	------	------	------	------	------	------	------

NTP
 PL - 47 - 225 Kędzierzyn - Koźle
 Ul. Szkolna 15
 Tel.: +48 77 74 006 503
 Fax: +48 77 74 006 505
 e-mail: ntp@wp.poznan.pl

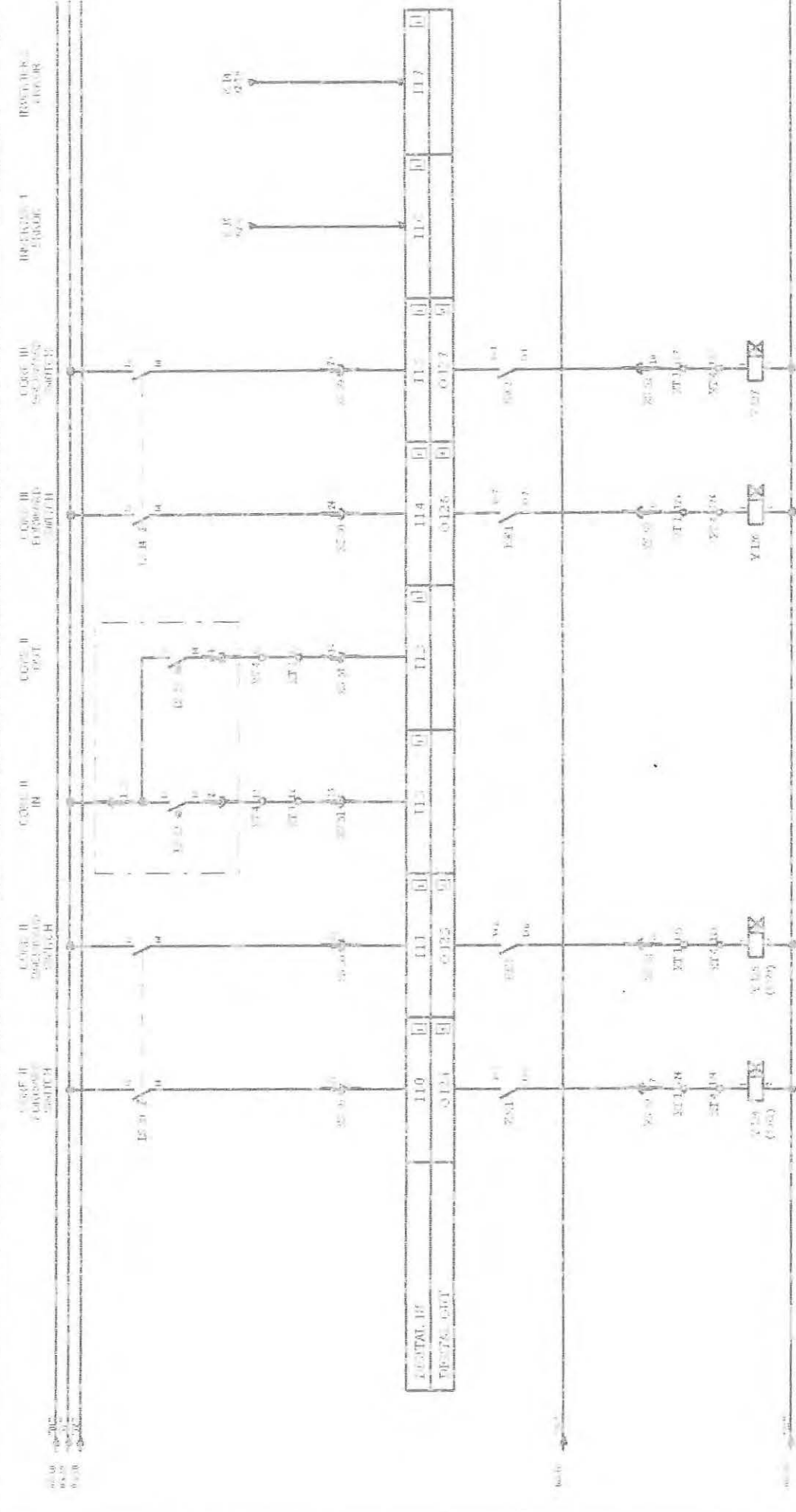
MACHINE NO. 0900 2005 01
 MACHINE NO. 2005 M 5100 / 02-01
 PRODUCTION 14-11-2005
 DECEPTION 14-11-2005
 Wymagania

MACHINE TYPE
QDCM 400
 TMG 3 & 4

SECTION: FUSE-CIRCUIT BREAKER
 SECTION: STOP VALVE
 SECTION: STOP VALVE
 SECTION: STOP VALVE

100µC
 10V

1	2	3	4	5	6	7	8	9	10
---	---	---	---	---	---	---	---	---	----



CONTROL UNIT	110	111	112	113	114	115	116	117	118
TESTING UNIT	0124	0125	0126	0127	0128	0129	0130	0131	0132

NTP

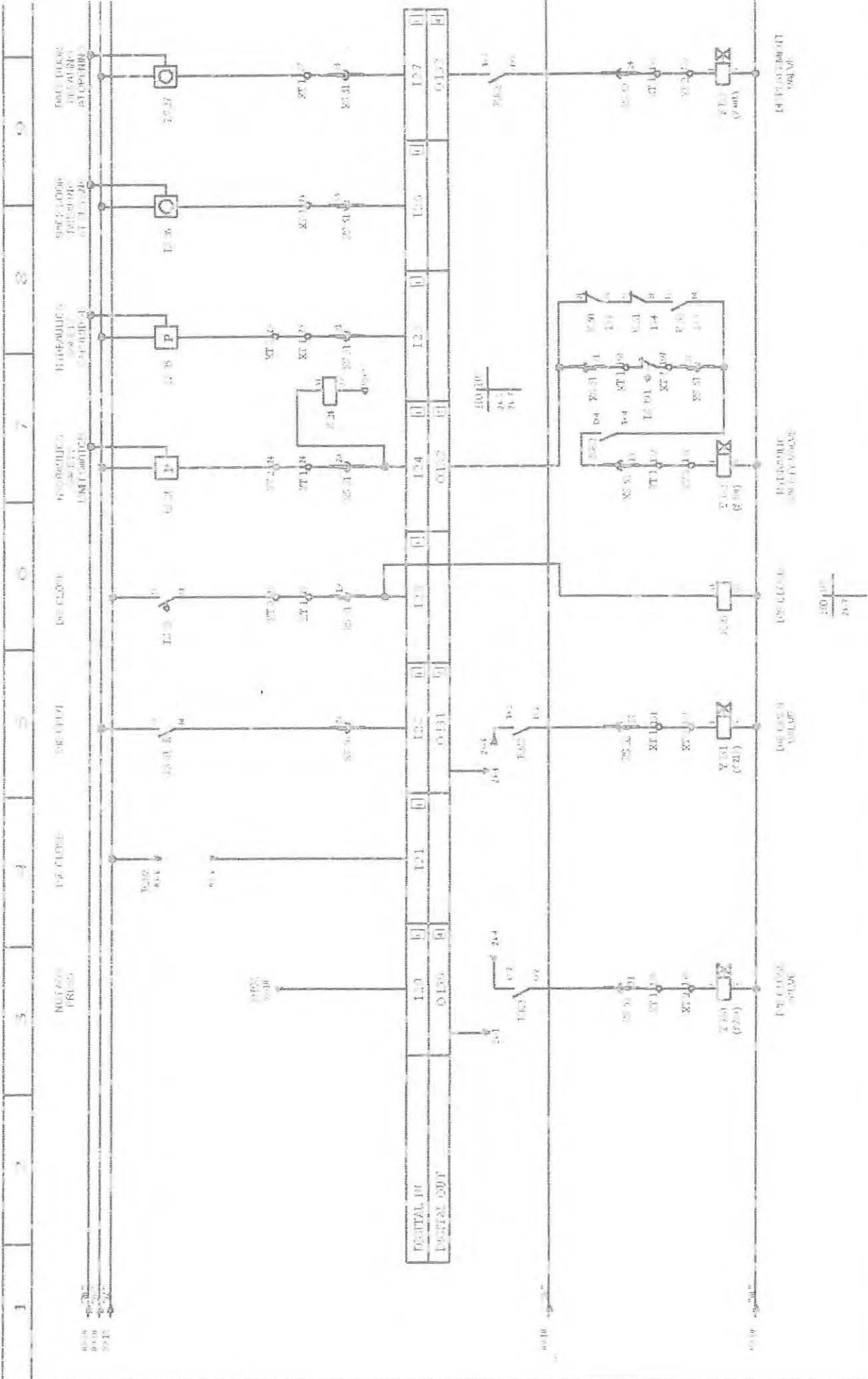
PL - 47 - 225 Kozłowski - Nozła
 Ul. Sokoła 15
 tel: 4 40 77 7 4 886 597
 fax: 4 43 77 4 000 300
 e-mail: ntp@poczta.onet.pl

SCHEMATIC: M806.2005.01
 MACHINE NO: 2005.06.501.03.03
 DATE: 11.11.2005
 DRAWING NO: 10-31.2005

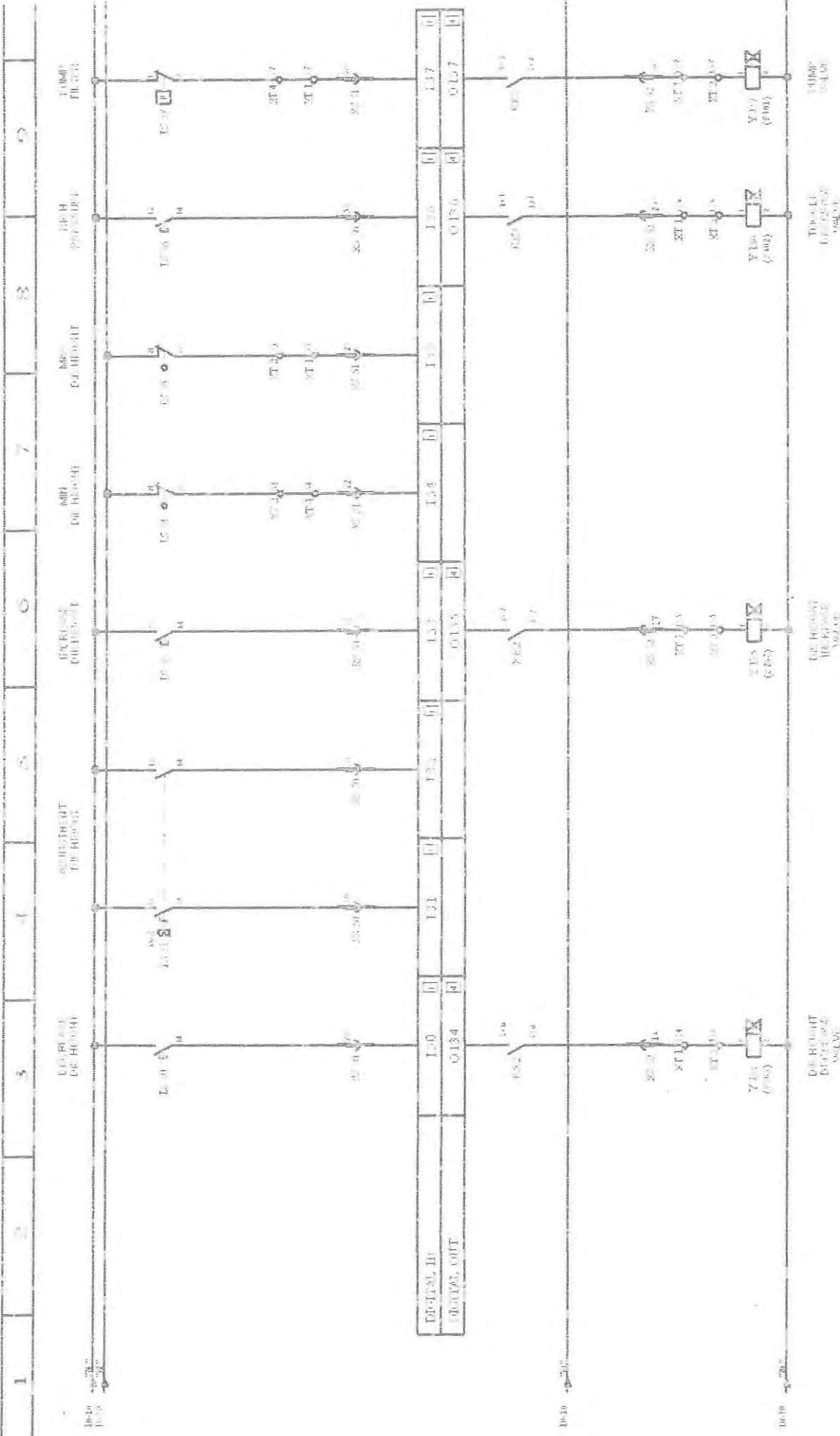
PL - 47 - 225 Kozłowski - Nozła
 Ul. Sokoła 15
 tel: 4 40 77 7 4 886 597
 fax: 4 43 77 4 000 300
 e-mail: ntp@poczta.onet.pl

SCHEMATIC: M806.2005.01
 MACHINE NO: 2005.06.501.03.03
 DATE: 11.11.2005
 DRAWING NO: 10-31.2005

SCHEMATIC: M806.2005.01
 MACHINE NO: 2005.06.501.03.03
 DATE: 11.11.2005
 DRAWING NO: 10-31.2005



1	2	3	4	5	6	7	8	9
<p> SCHEME NO. 8800.2005.01 MACHINE NO. 2005 / 08 \$100 / 08 08 DESIGNED 14-11-2005 DATE 14-11-2005 </p>								
<p> FL-47 - 235 Kędzierzyn - Koźle UL. STROJOWA 15 Tel.: +48 77 74 886 591 Fax: +48 77 74 886 599 e-mail: asp@cep.huta.np.pl </p>								
<p> QDCM 400 YMC 3 8 4 </p>								
<p> MACHINE TYP </p>								



STATION	1	2	3	4	5	6	7	8	9	10
STOP	Z1	Z2	Z3	Z4	Z5	Z6	Z7	Z8	Z9	Z10
START	S1	S2	S3	S4	S5	S6	S7	S8	S9	S10
RELAY	I-0	I-1	I-2	I-3	I-4	I-5	I-6	I-7	I-8	I-9
CONTACTOR	C134	C135	C136	C137						

NTP

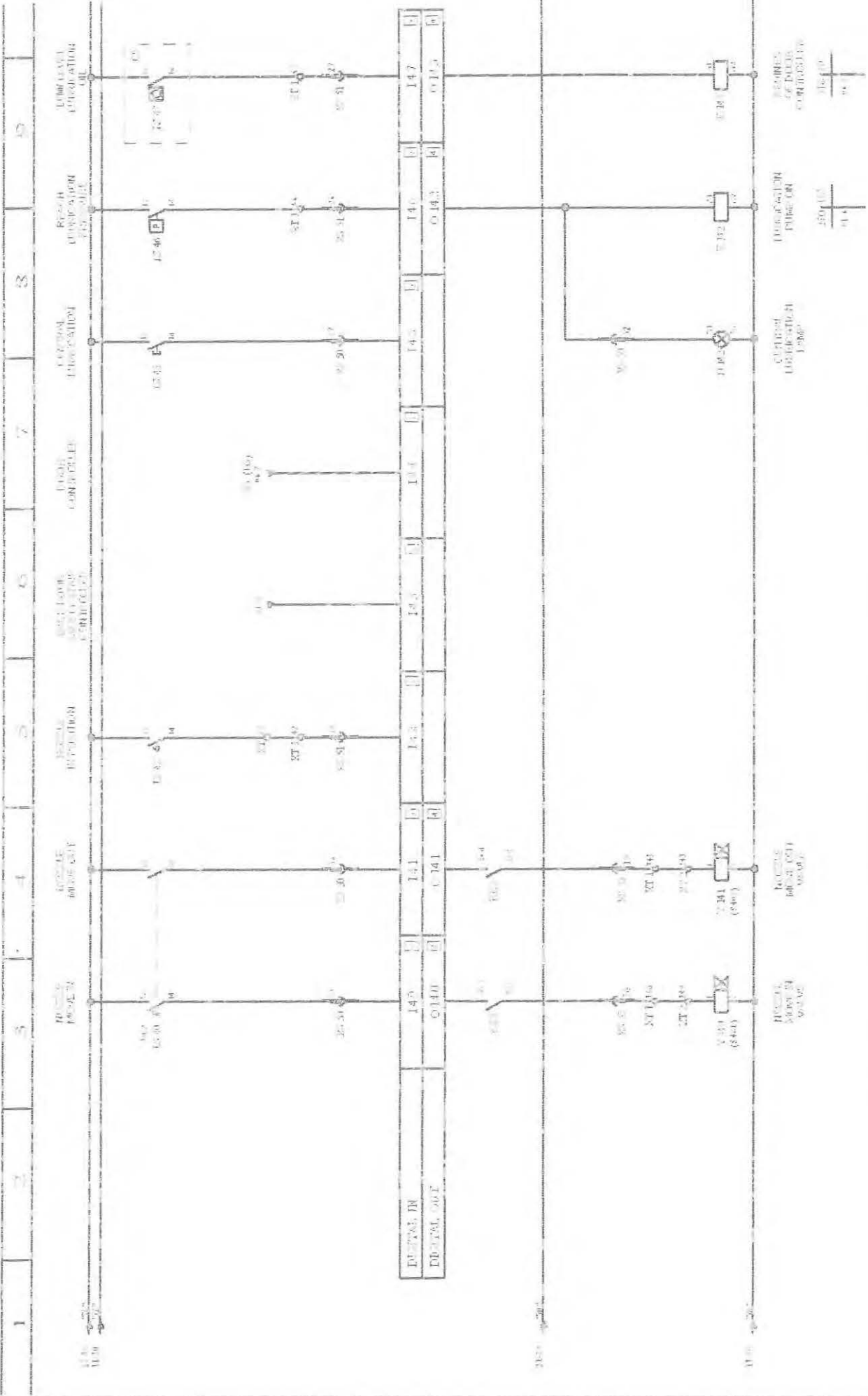
FL - 47 - 225 Kądzierzyn - Koźle
 III, Szkolna 15
 Tel: +91 77 4 886 001
 Telex: 4 26 77 4 886 001
 e-mail: ntp@npp.nmtp.pl

SCHM
 1

MACHINE NO.
 ODCM 400
 TNG 3 & 4

SCHEMATIC NO. 4000 0005 01
 MACHINE NO. 2005 00500 0000
 DATE 1987
 DRAWN BY

DE HIGHT
 DE HIGHT
 DE HIGHT



FL - 47 - 225 Kędzierzya - Kozle
III. SZKOLIA 15
 Tel.: +48 77 74 006 600
 Fax: +48 77 74 286 208
 e-mail: ntp@npp.com.pl

NTP

SCHEMATIC NO. **QDCM 400**
IMC 3 & 4

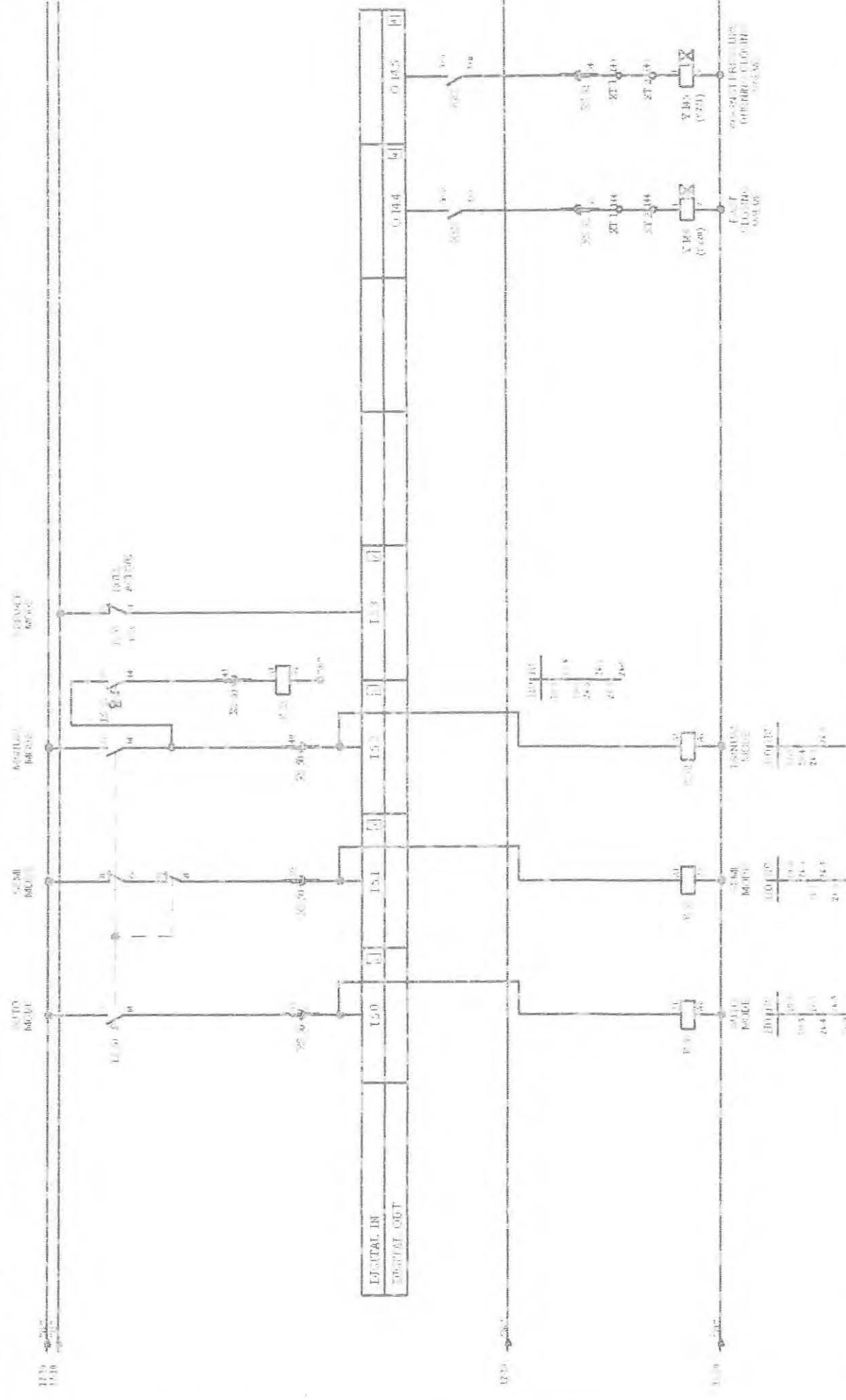
ACTUATOR NO. **05100 2005 05**
 MACHINE NO. **2005 / 05100 / 02-03**

DESIGN NO. **13-11-2005** Rev. 01
 DATE OF ISSUE **10.11.2005**

NO. SHEET **TOP**

TOTAL SHEETS **1**

1	2	3	4	5	6	7	8	9
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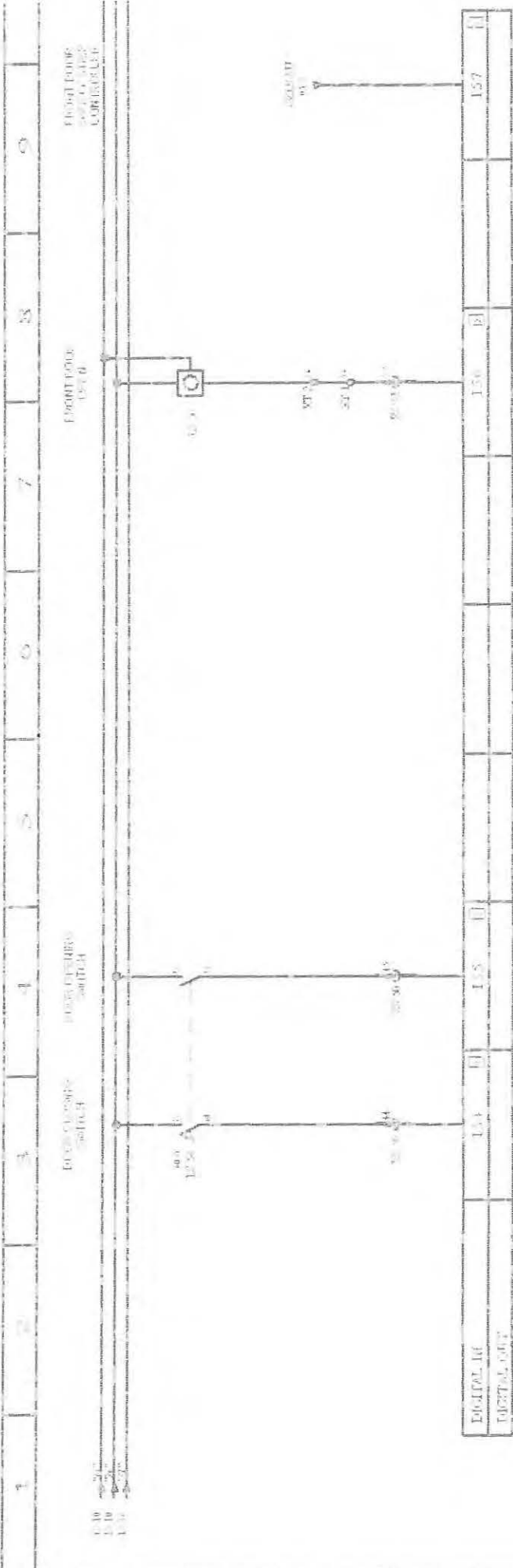
ЭЛ - 47 - 225 Көзүлөгүн - Козёлө
УИ. S-KOIN. 15
 Төлө: + 48 / 77 / 8 896 833
 Тел.: + 48 / 77 / 4 986 200
 e-mail: info@nnp.kg

NTIP

SCHEMATIC NO. 0000 2005.01
 MACHINE NO. 2005 - 08500 / 05.03
 TESTED BY 18.11.2005 P.B.A.BE
 DRAWN BY 18.11.2005 M.K.H.A.BE

SCHEMATIC NO. 0000 2005.01
 MACHINE NO. 2005 - 08500 / 05.03
 TESTED BY 18.11.2005 P.B.A.BE
 DRAWN BY 18.11.2005 M.K.H.A.BE

QDCM 400
TMG 3 & 4



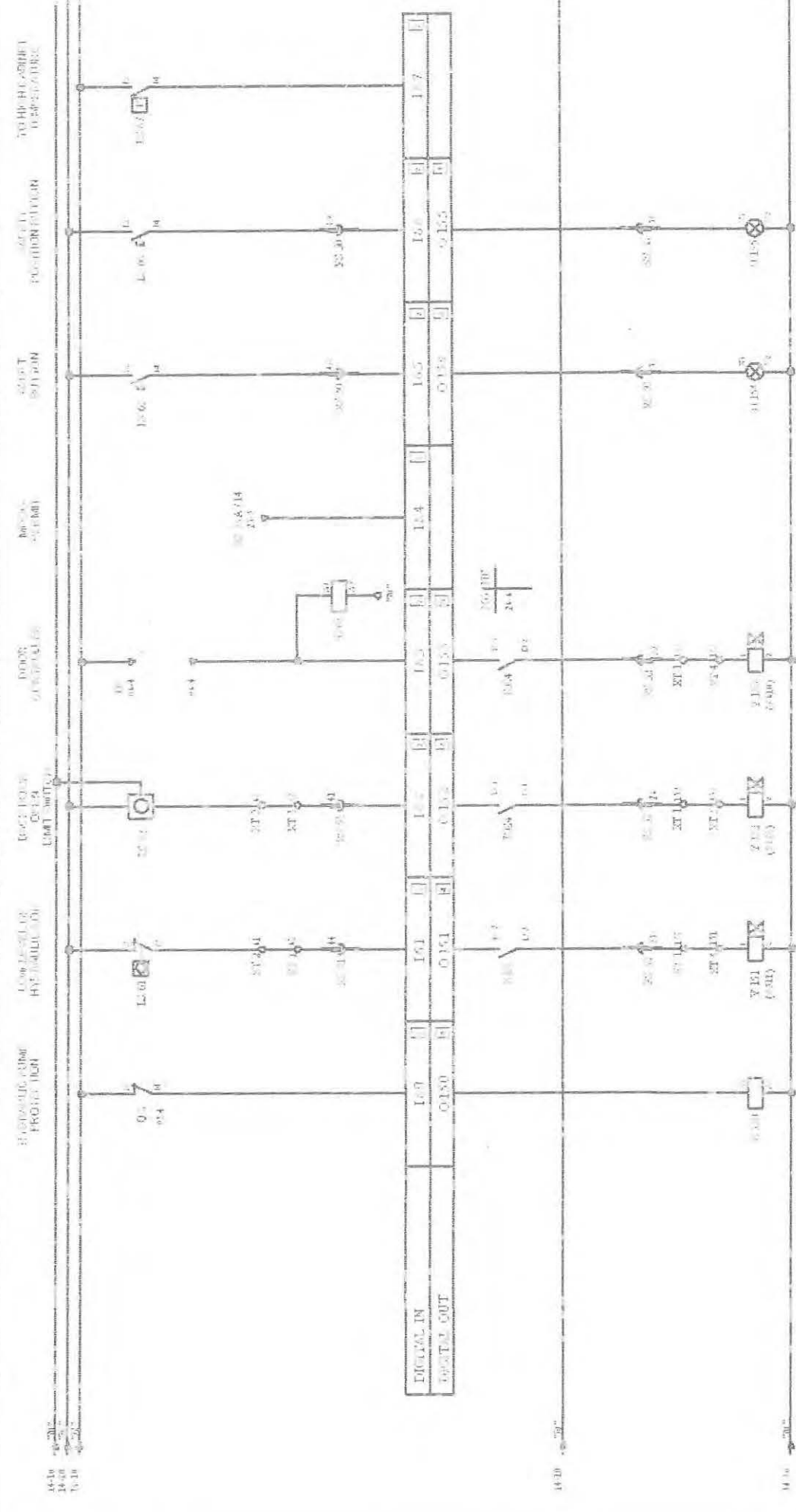
1	2	3	4	5	6	7	8	9	10

NTP

PL - 47 - 225 Kędzierzyn - Koźle
 Ul. Szkolna 15
 Tel: +48 77 14 886 001
 Fax: +48 77 14 886 209
 e-mail: ntp@nnp.pl

CLIENT: 100 9800 2005 01
 MACHINE: 100 2005 04 S100 05 01
 Description: 14.11.2005 BATA SP
 DISSE: 1104 30.11.2005 Warszawa SP

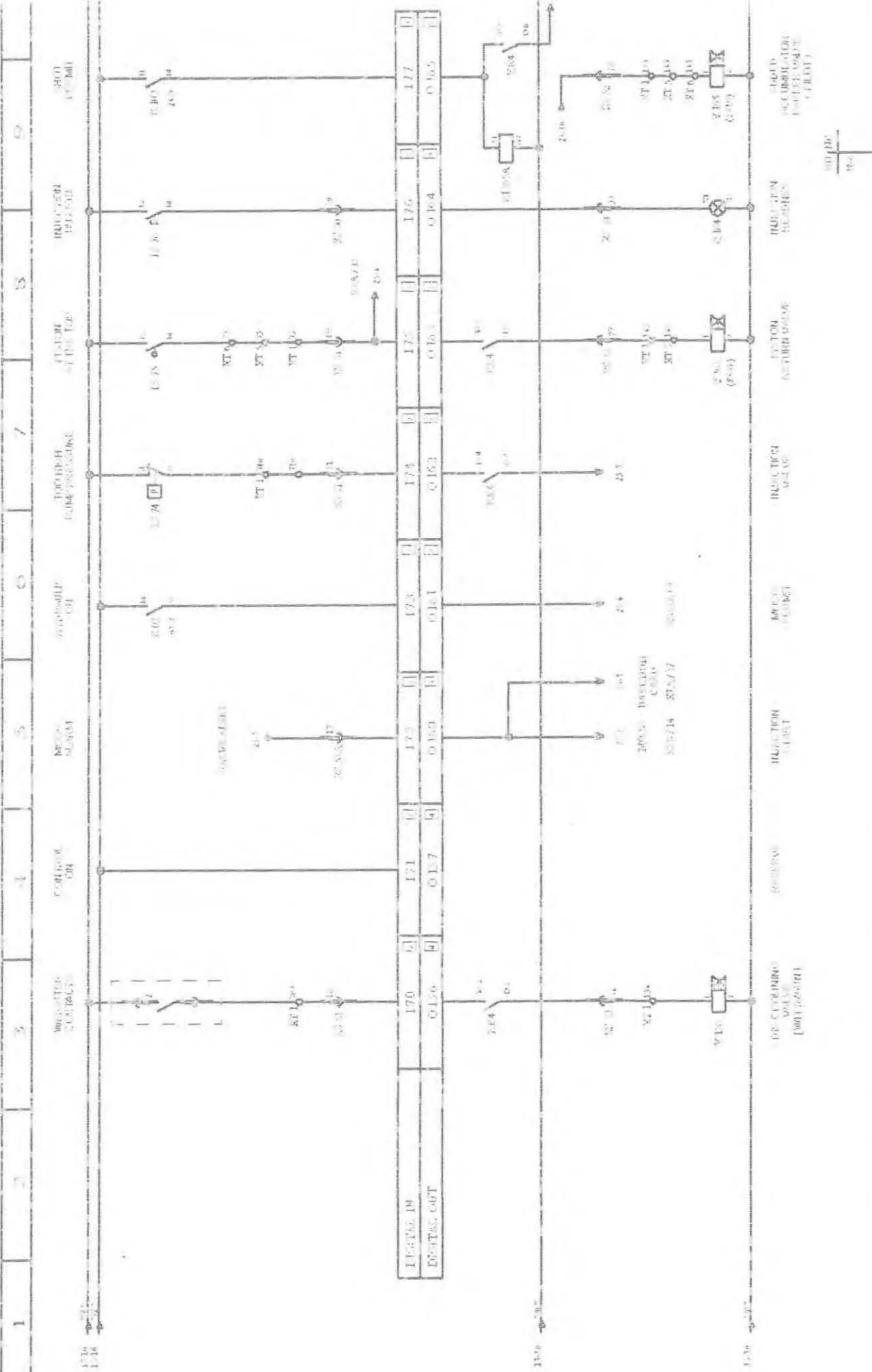
MACHINE TYPE: **QDCM 400**
TMO 3 & 4



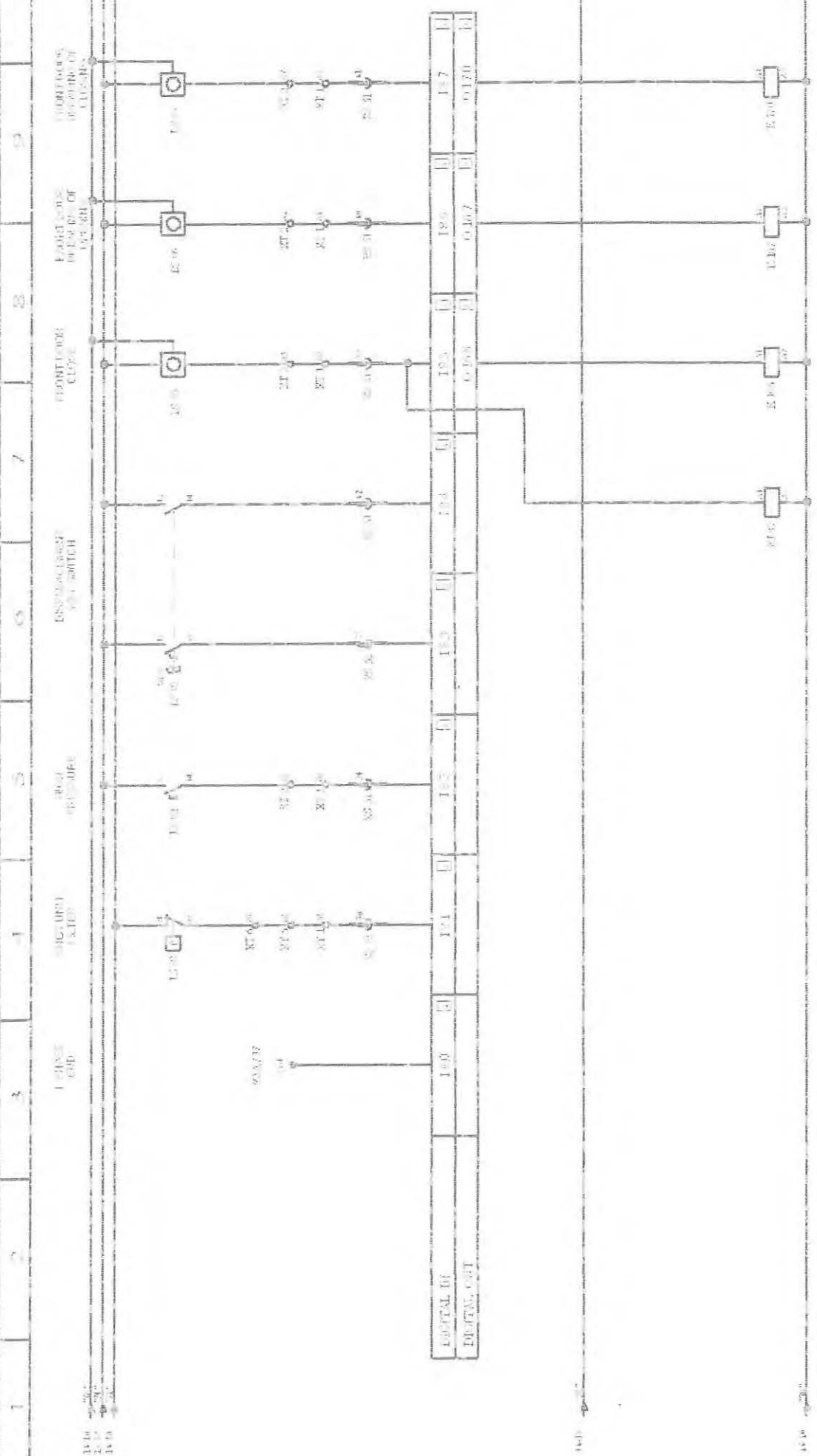
SCHEMATIC	MACHINE	TYPE	SHEET
PL - 47 - 225 Kędzierzyn - Koźle Ul. Szkolna 15 44-100 Kędzierzyn-Koźle Tel: 071/4 866 593 Fax: 071/4 866 703 e-mail: rbczy@kcm.com.pl	QDCM 400	TMG 2 & J	1

SCHEMATIC NO.	MACHINE NO.	DATE
005-045101-02-03	3005-045101-02-03	02.07

OPERATOR	INSPECTOR	DATE



	PL - 47 - 223 Kędzierzyn - Koźle Ul. Szkolna 15 tel: +48 77 74 86 593 fax: +48 77 74 86 704 e-mail: biuro@npt.com.pl		SCHEME ID: MSO 2005_01 MACHINE ID: MSO 2005_05-03 DESIGNER: 14.11.2005 <i>Pat. BY</i> EXECUTIVE: 10.11.2005 <i>Włodzisław</i>		MACHINE TYPE: QDCM 400 TMG 3 & 4	SCHEDULE Page 1
	MOCY FUEL (Fuel Power)		MOCY FUEL (Fuel Power)		MOCY FUEL (Fuel Power)	MOCY FUEL (Fuel Power)



1000
 1000
 1000

100	101	102	103	104	105	106	107	108	109	110
100	101	102	103	104	105	106	107	108	109	110

FRONT PANEL	FRONT PANEL	FRONT PANEL	FRONT PANEL	FRONT PANEL
STOP	STOP	STOP	STOP	STOP
START	START	START	START	START

NTP
 FL - 47 - 225 Көзгерісін - Көзік
 Ул. Сәткөл 15
 Ғаб. + 487773 886 593
 Ғаб. + 487773 886 709
 e-mail: asqazov@npp.np

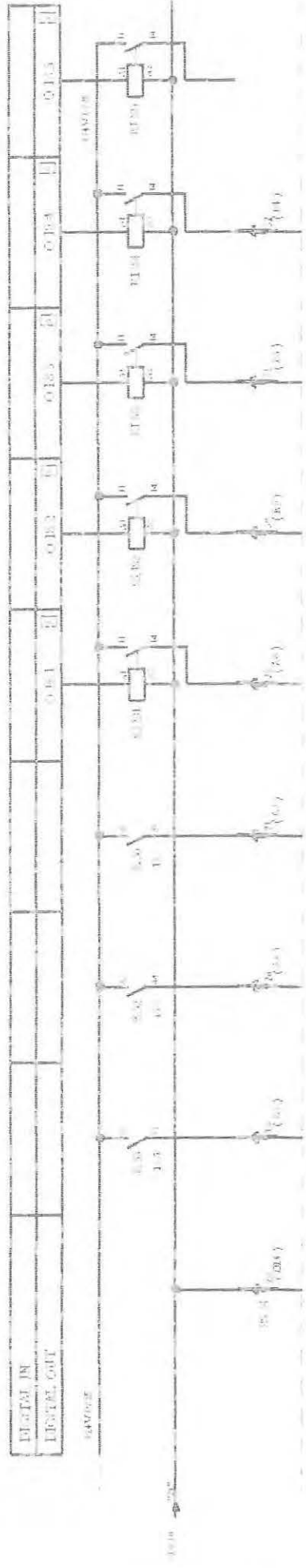
SCHEMATIC
 1000
 1000
 1000

MACHINE NO. 8805 2005.07
 MACHINE 100 2005.07 8805.08.03
 DESIGNED BY 81-11-2005
 EXECUTED BY 81-11-2005
 CHECKED BY 81-11-2005
 APPROVED BY 81-11-2005

MACHINE NO. 8805 2005.07
QDCM 400
TRIG 3 & 4

1	2	3	4	5	6	7	8	9
---	---	---	---	---	---	---	---	---

100
100



RYBAK
WOLNY
WOLNY

SCHEMATIC	NO. OF	NO. OF	NO. OF	NO. OF	NO. OF	NO. OF	NO. OF	NO. OF
100V	100	100	100	100	100	100	100	100

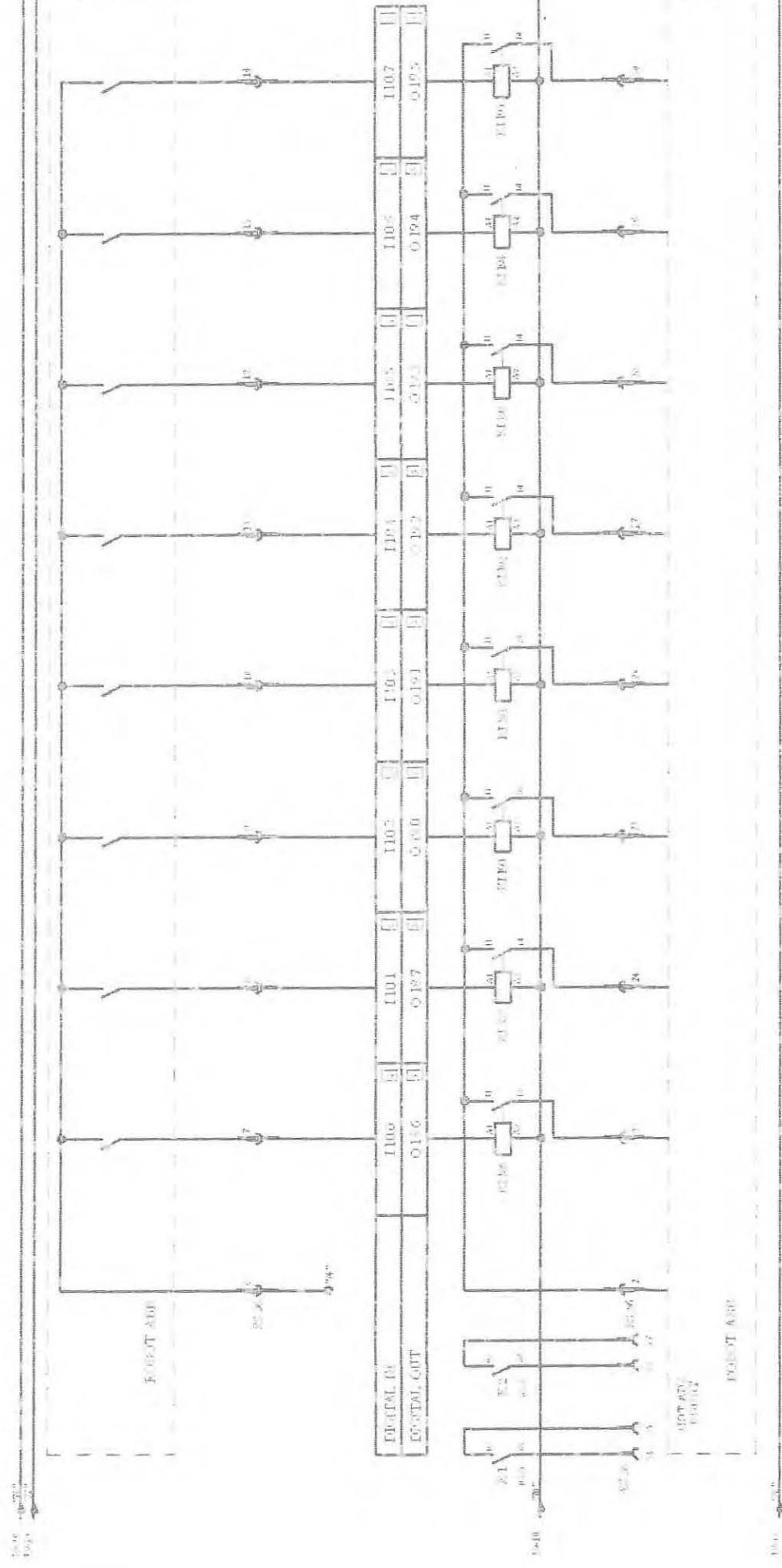


PL - 47 - 225 Kędzierzyn - Koźle
Ul. Szkolna 15
104 1 00 11 13 005 501
100 2 1 0 7 7 1 1 000 200
e-mail: akc@op.pl

SCHEMATIC	NO. OF	NO. OF	NO. OF	NO. OF	NO. OF	NO. OF	NO. OF
100V	100	100	100	100	100	100	100

QDCM 400
TMC 3 & 4

SCH	100V
TOTAL	100V



FL - 47 - 225 Kędzierzyn - Koźle
Ul. Szkolna 15

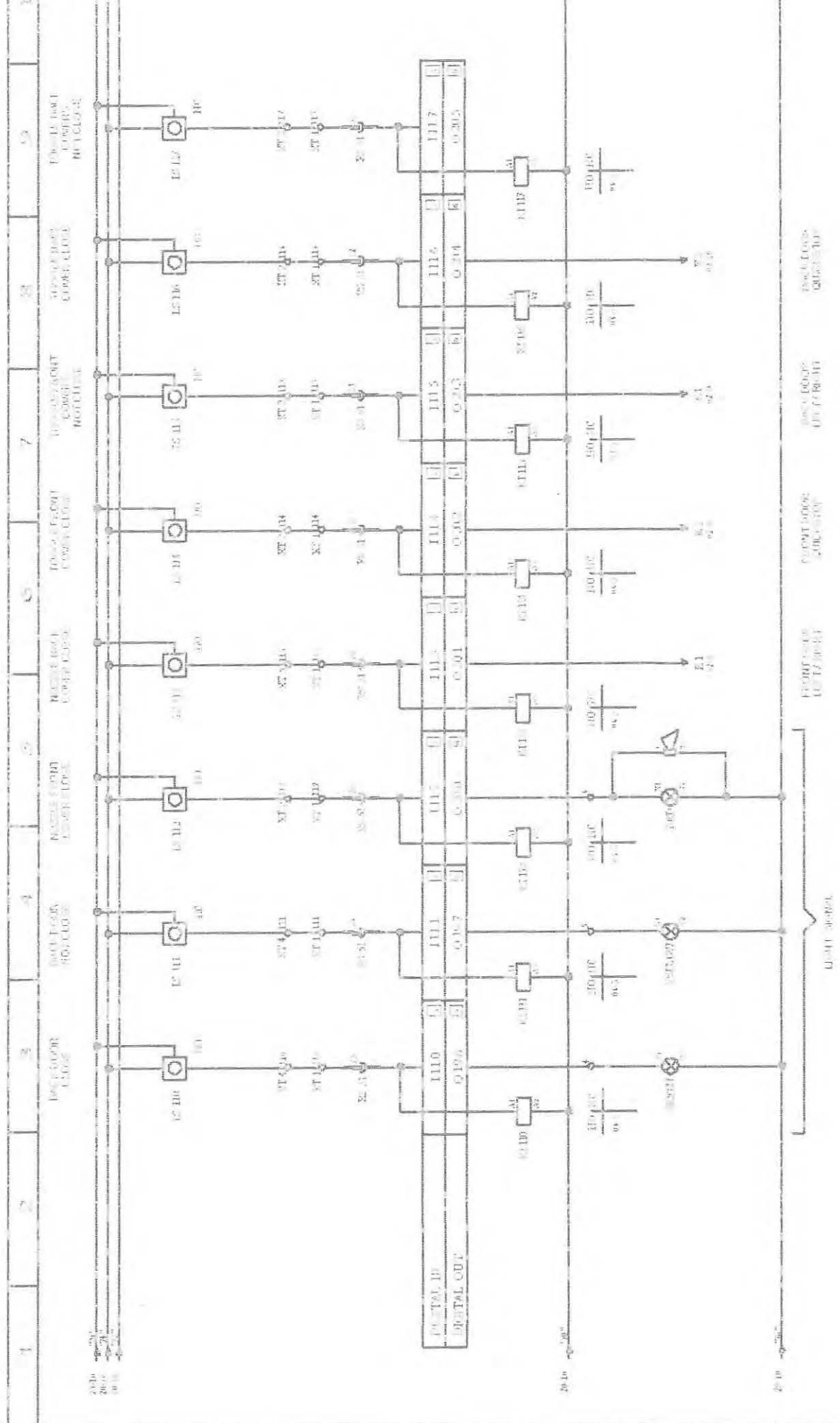
tel: +48 77 74 850 593
fax: +48 77 74 856 400
e-mail: biuro@nmp.com.pl

SCHEMATIC NO	TRSC0 2005 03
MACHINE NO	2005 / M2500 / 02 03
DESIGNER	13.11.2005 Karko
DATE	10.11.2005 W. Karko

MACHINE TOP

QDCM 400
TRC 3 & 4

SCALE	
DATE	



SCHEMATIC		MACHINE TYPE	
L1110		QDCM 400	
TOTAL		TIMING 3 & 4	

NO.	DATE	BY	CHKD.
1	11.11.2005	M. S.	M. S.

NO.	DATE	BY	CHKD.
1	11.11.2005	M. S.	M. S.

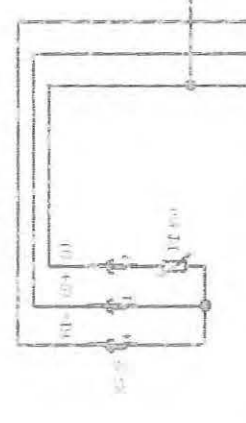
NO.	DATE	BY	CHKD.
1	11.11.2005	M. S.	M. S.

PL - 47 - 225 Kędzierzyn - Koźle
 ul. Szkolna 10
 tel: +48 77 4 005 503
 fax: +48 77 4 006 700
 e-mail: ntp@wp.poczta.onet.pl



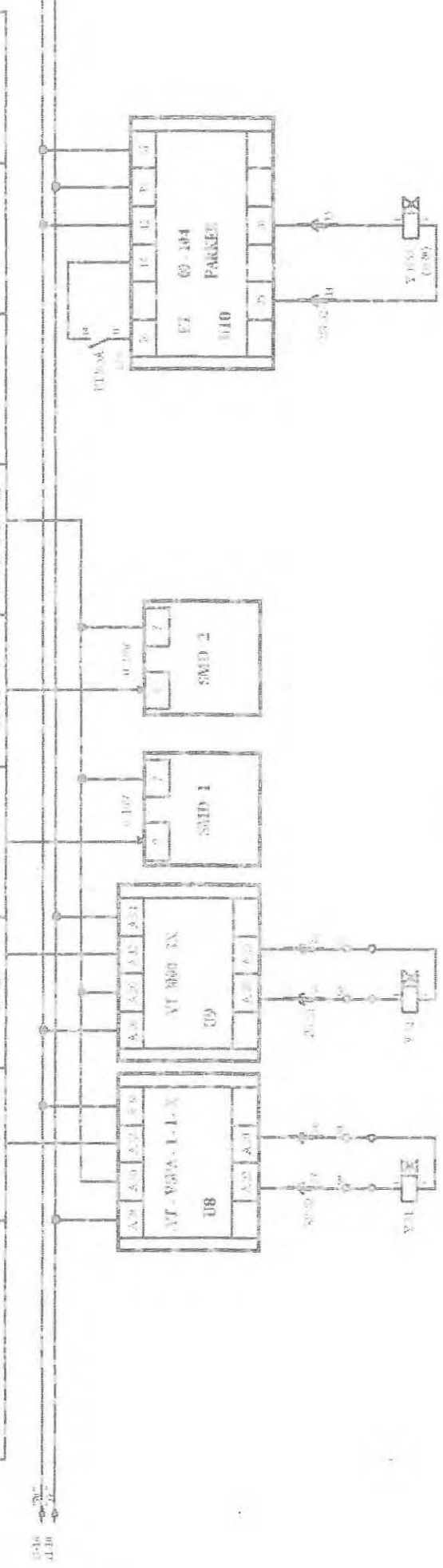
1	2	3	4	5	6	7	8	9
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HYDRAULIC ELEMENTS



PERIPHERALS

TRANSFORMER



TRANSFORMER
111 110

TRANSFORMER
111 111

TRANSFORMER
111 112

TRANSFORMER
111 113

TRANSFORMER
111 114

NTP

PL-47 - 225 Kędzierzyn - Koźle
III Szkolna 15
Tel: +48 77 73 885 893
Fax: +48 77 73 885 788
e-mail: ntp@nyp.com.pl

SCHEMATIC NO: 4800 200 01
MATERIAL NO: 200 57 89 5100 2 01-03
DESIGNER: M-11-2005
DATE: 15.11.2005

MACHINE TYPE: QDCM 400
TMC 3 & 4

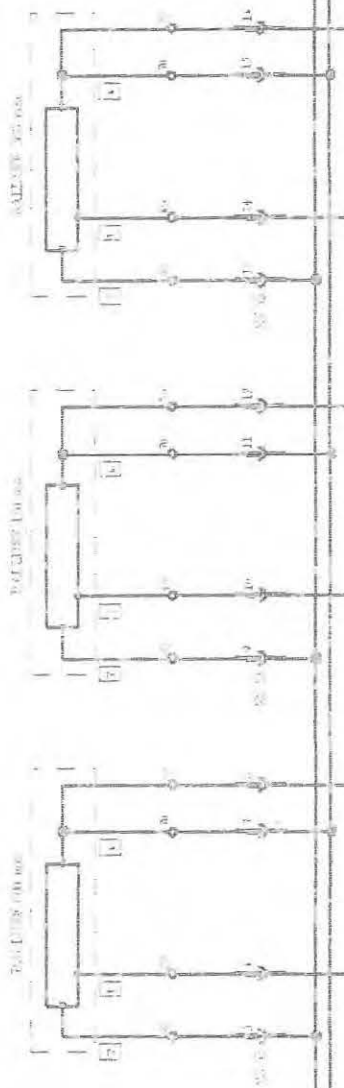
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PLANS

RECEIVED

DATE

NO.



AMMOC Dr	Part 3	Part 4	Part 5	Part 7
----------	--------	--------	--------	--------



PL - 47 - 205 Kępczyńska - Koźle
Ul. Szkolna 15

Tel.: + 48 77 73 826 505
Fax: + 48 77 73 826 700
e-mail: ntp@poczta.onet.pl

SCHEME NO.	0000 2005 01
REVISION NO.	2005 / M 5100 / 00 03
DATE	15.11.2005
DESIGNER	15.11.2005
CHECKER	15.11.2005

PROJECT

ODCM 400

TMC 3 & 4

SCH.	2
Draw	
TOTAL	

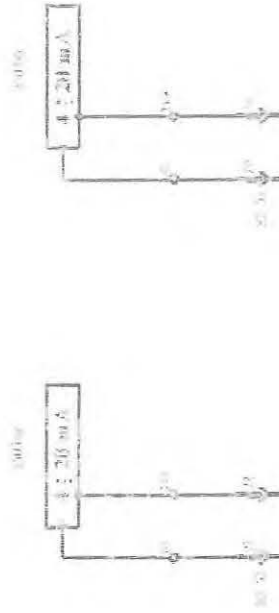
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Prędkość obrotowa

Moc silnika (kW)

Ciężar przeniesienia

Prędkość obrotowa



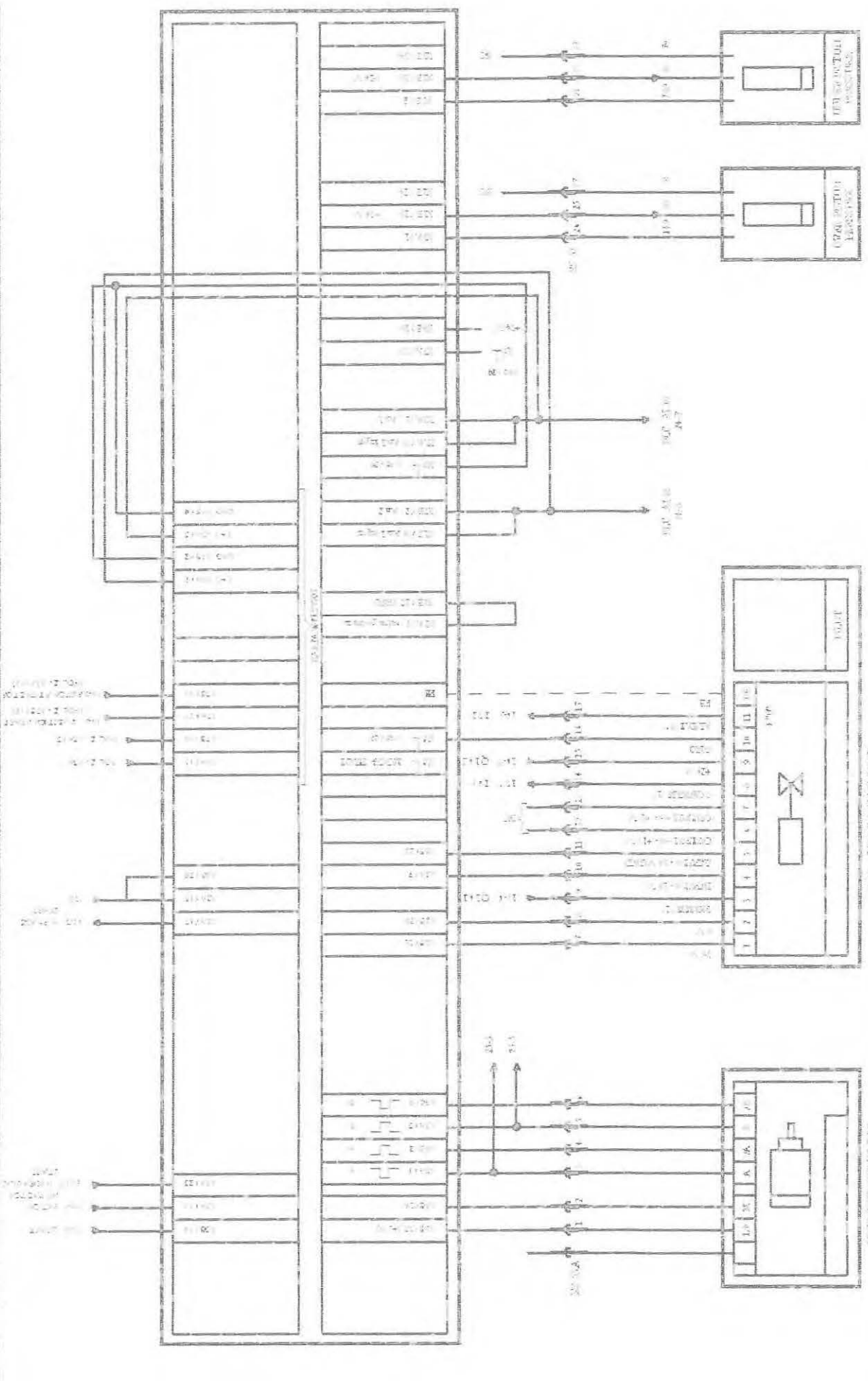
PL - 47 - 225 Kędzierzyn - Koźle
 ul. Szkolna 15
 Tel.: + 48 77 64 806 000
 Fax: + 48 77 64 806 400
 e-mail: obchod@nntp.pl

Model: 400	Model: 400
Max. prędkość: 1000	Max. prędkość: 1000
Prędkość: 1000	Prędkość: 1000
Prędkość: 1000	Prędkość: 1000

MODEL: 400
 QDCM 400
 TMO 3 & 4

SCHEM	1000
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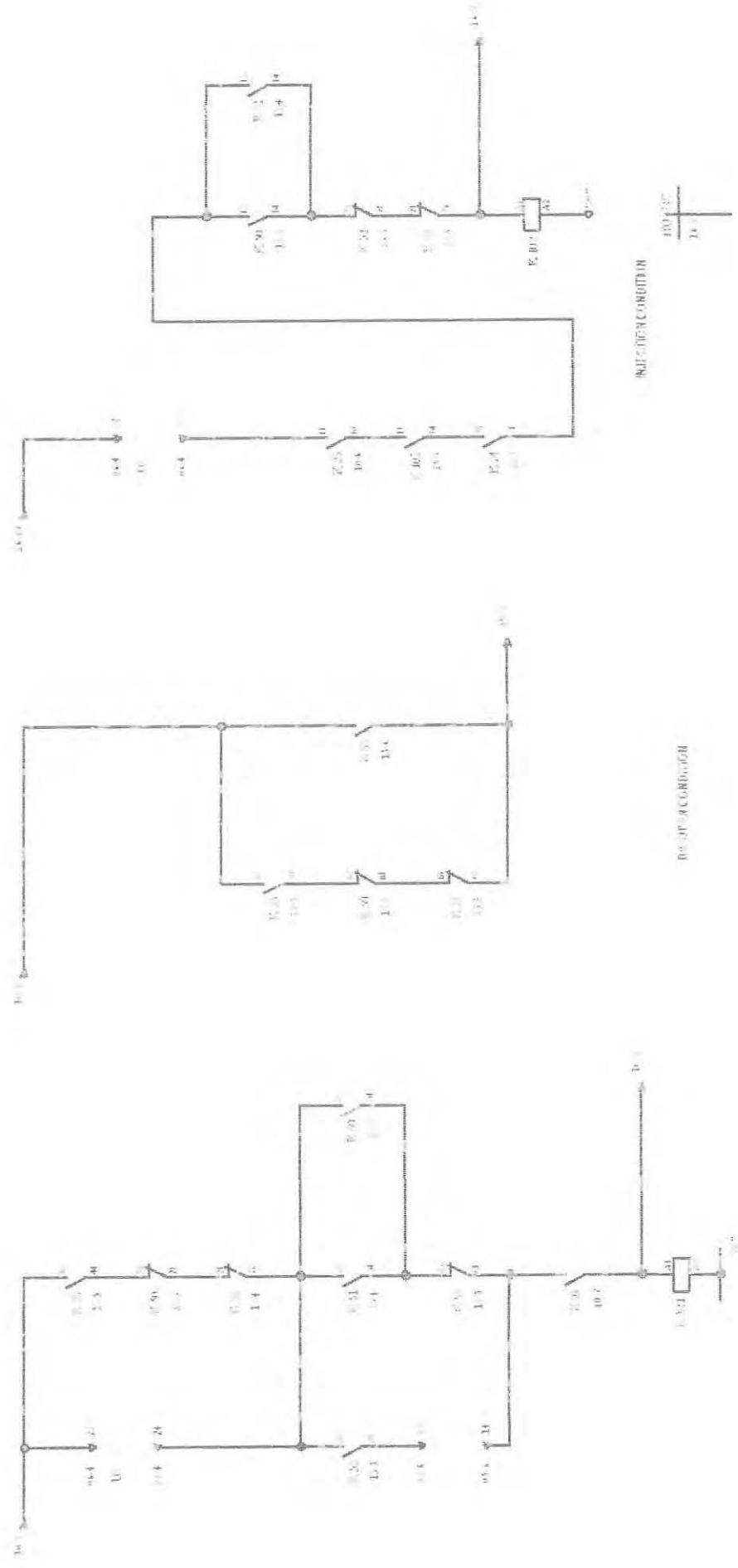
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FL - 47 - 225 Kędzierzyn - Koźle
 III. SZKICHA 15
 tel.: + 48 77 7 4 886 583
 fax: + 48 77 7 4 886 488
 e-mail: sprzedaz@nyp.pl

SCHEMATIC I.D. 8800 2005 01
 MACHINE NO. 2009 / M-5-100 / 09-03
 DATE ISSUE 16.11.2005 Date 07
 DESIGN I.D. 10.11.2005 Approved 07

MACHINE TAG
QDCM 400
 TMC 3 & 4

SCM	
CON	
TOTAL	



BEZPIECZYSTWO



BEZPIECZYSTWO



INIEKCYJNA

FL - 47 - 225 Kędzierzyn - Koźle
 Ul. Szkolna 15

tel.: +48 77 71 00 6 013
 fax: +48 77 71 4 00 6 703
 e-mail: sklep@nmp.nmp.pl



SCHEMAT	BRD. 2003.03
TYTUŁ	2003.03-5107.03-03
DATA	10.11.2003
PROJEKTANT	Krzysztof W.
WYKONAWCA	Wojciech W.

MACHINA

QDCM 400
 IMG 3.5.4

SCHEM	1
DATA	2
WYKONAWCA	3

5

HOT CHAMBER DIE CASTING MACHINE

QDCM 400

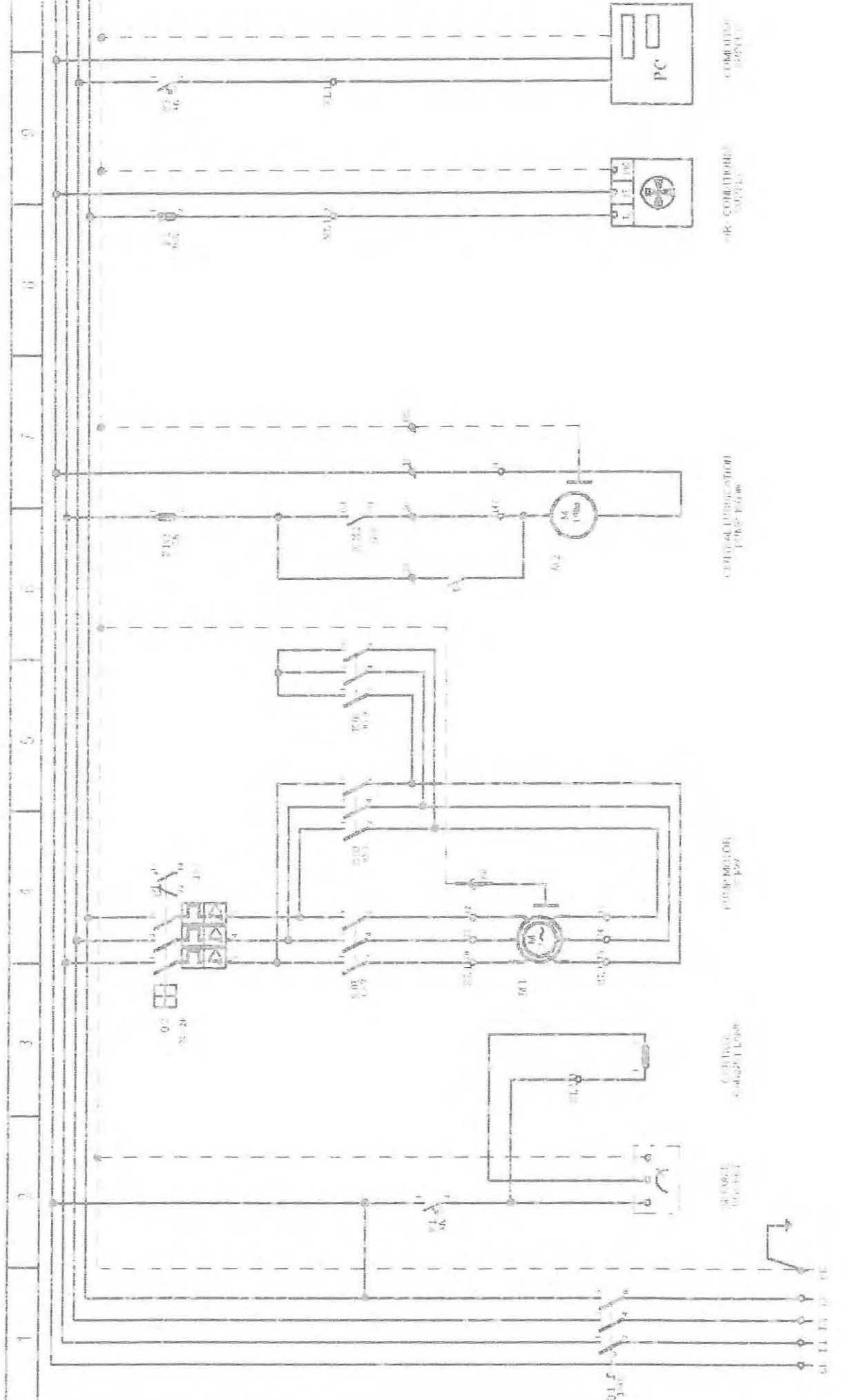
TMG 7&8

NTP

NOWOCZESNE TECHNOLOGIE PRODUKCJI Sp. z o.o.

PL - 47 - 225 KĘDZIERZYN - KOŹLE

UL. SZKOLNA 15



10000 0000



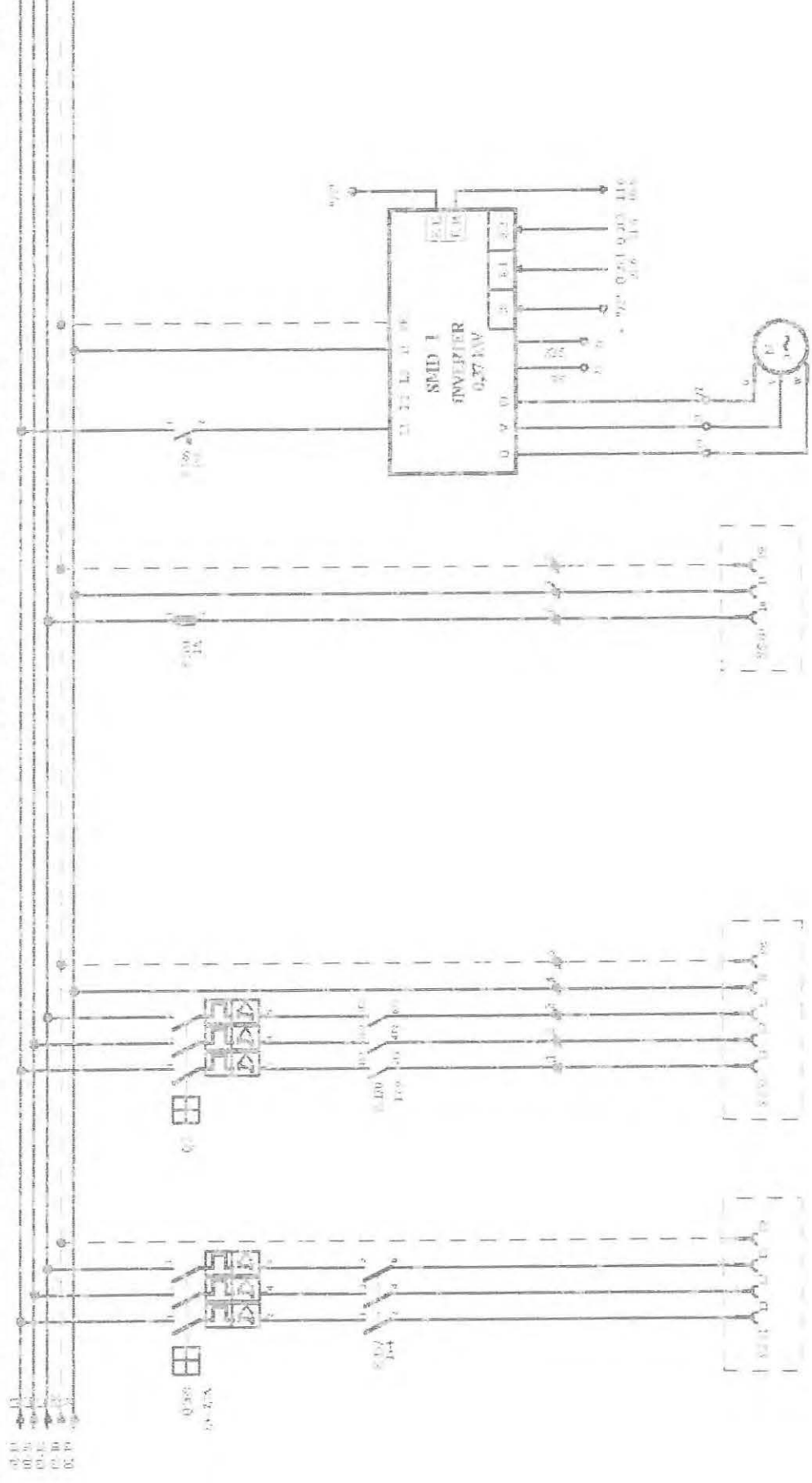
PL - 47 - 225 Kędzierzyn-Koźle
 ul. Szkolna 15
 TEL.: +48 077 428 05 93
 FAX: +48 077 428 02 84
 www.nip.com.pl

TMG 7&8

QDCM 400

SCH
 10000
 10000

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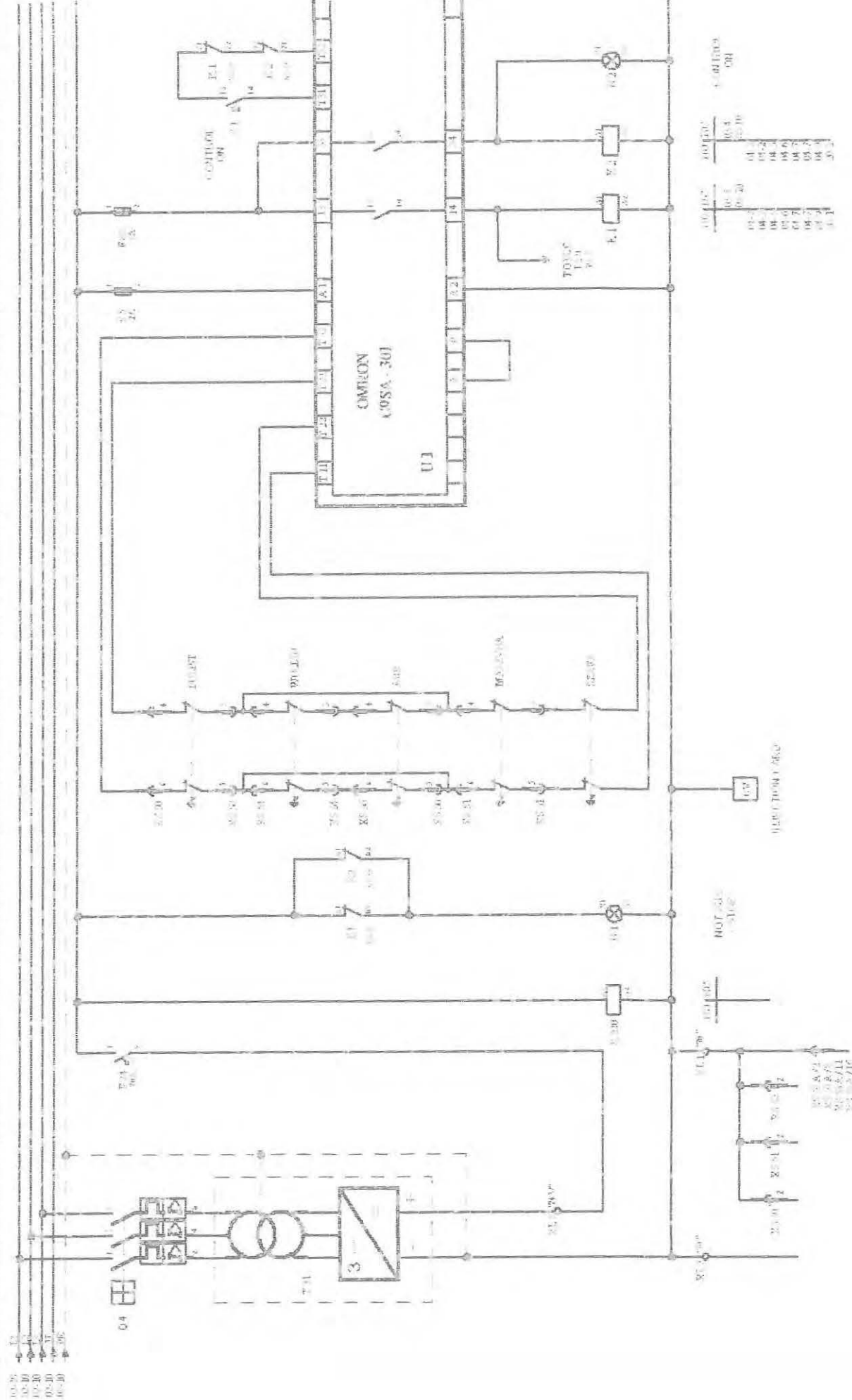
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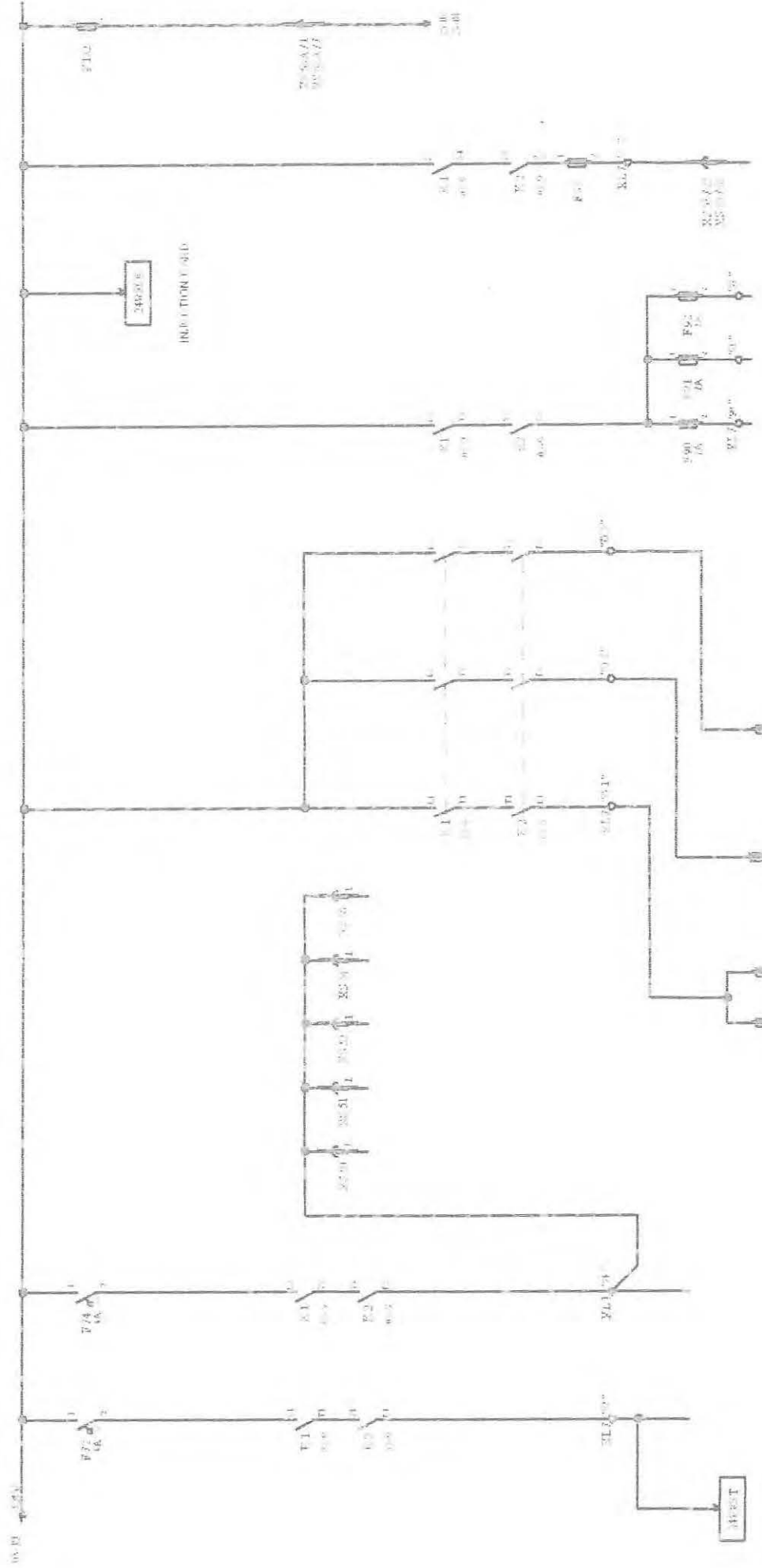
OPRACOWANIE
PRZEKAZAŁ
0.0000

REDAKTOR
0.0000

1 2 3 4 5 6 7 8 9



NO. OF	NO. OF
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02	005
03	006
04	007
05	008
06	009
07	010
08	011
09	012
10	013



TRUCI (03) (03)

STANOWISZKO

STANOWISZKO

STANOWISZKO

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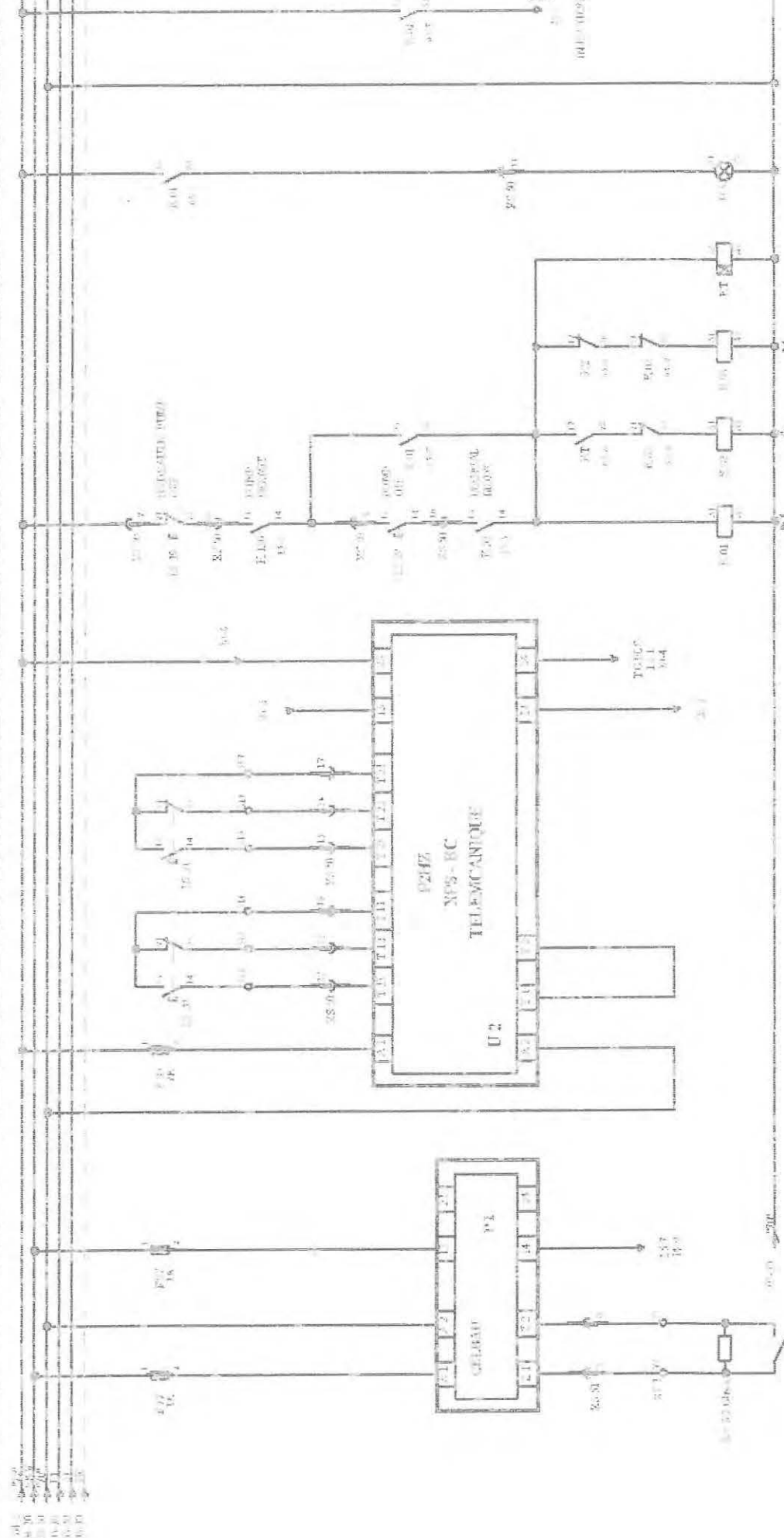
PL - 47 - 225 Kędzierzyn-Koźle
 Ul. Szkolna 15
 tel.: +48 077 452 66 93
 fax: +48 077 452 67 09
 www.nip.pl, www.pl

TMG 7&8

QDCM 400

LCM	0
CASA	0
TOTAL	0

1 2 3 4 5 6 7 8 9



PODAK BISTROU

1001	1002	1003	1004
01	02	03	04
05	06	07	08
09	10	11	12

01 1001-1004

SPORTLOPS
ZAKLADY
CZESKIEN

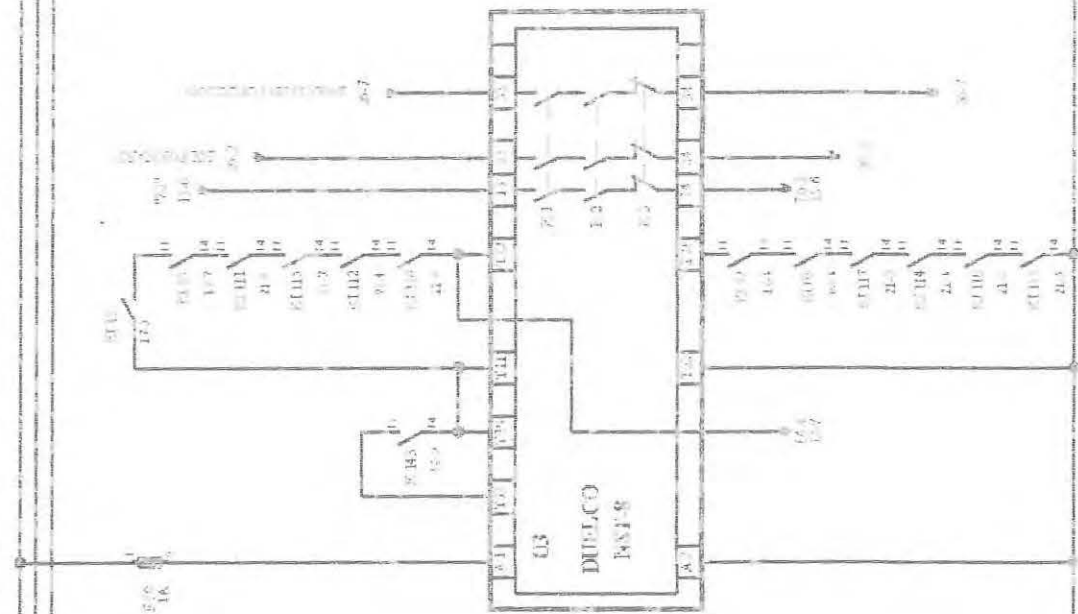
TMG 788

QDCM 400

PL - 47 - 225 Kędzierzyn-Koźle
Ul. Szkolna 15
Tel.: +48 677 485 00 93
Fax: +48 077 485 67 00
www.nip.com.pl

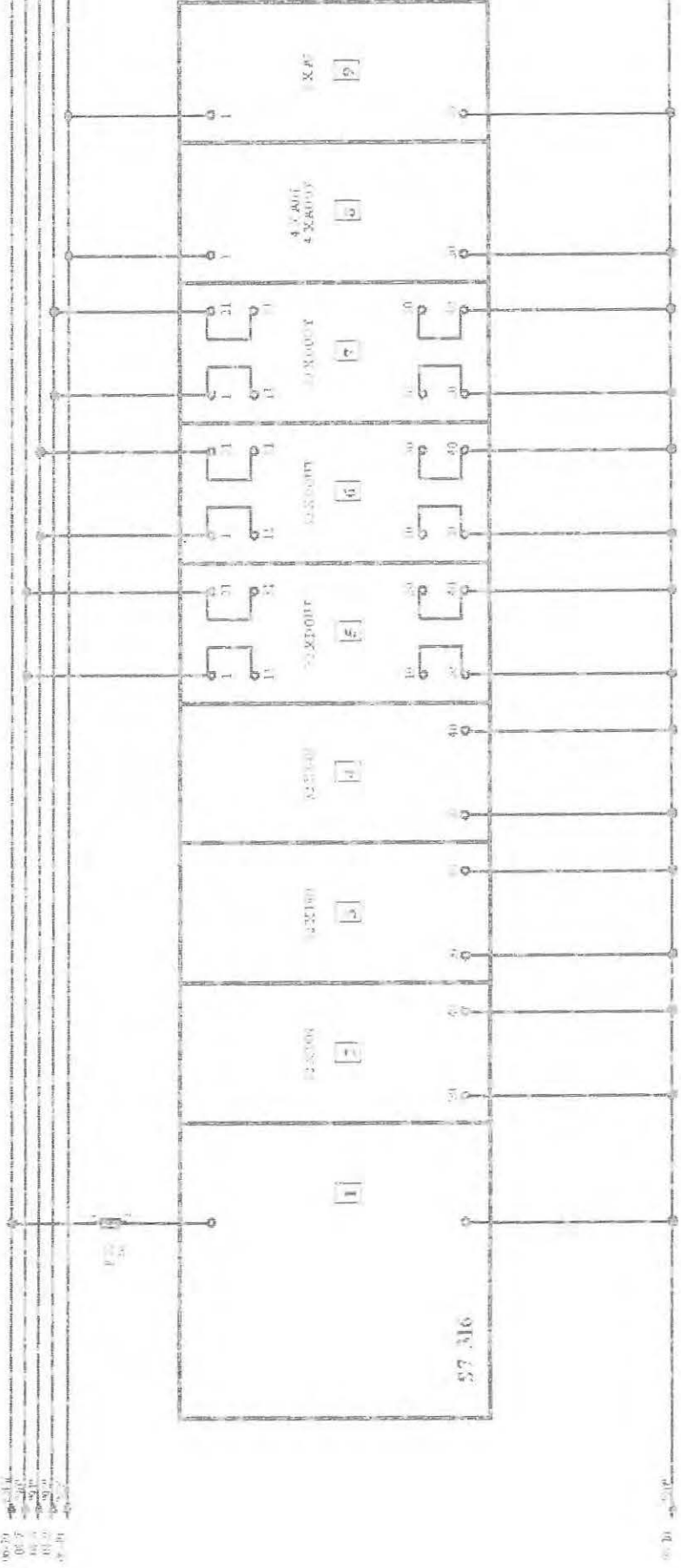


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1 2 3 4 5 6 7 8 9

06.01
06.02
06.03
06.04
06.05



06.06

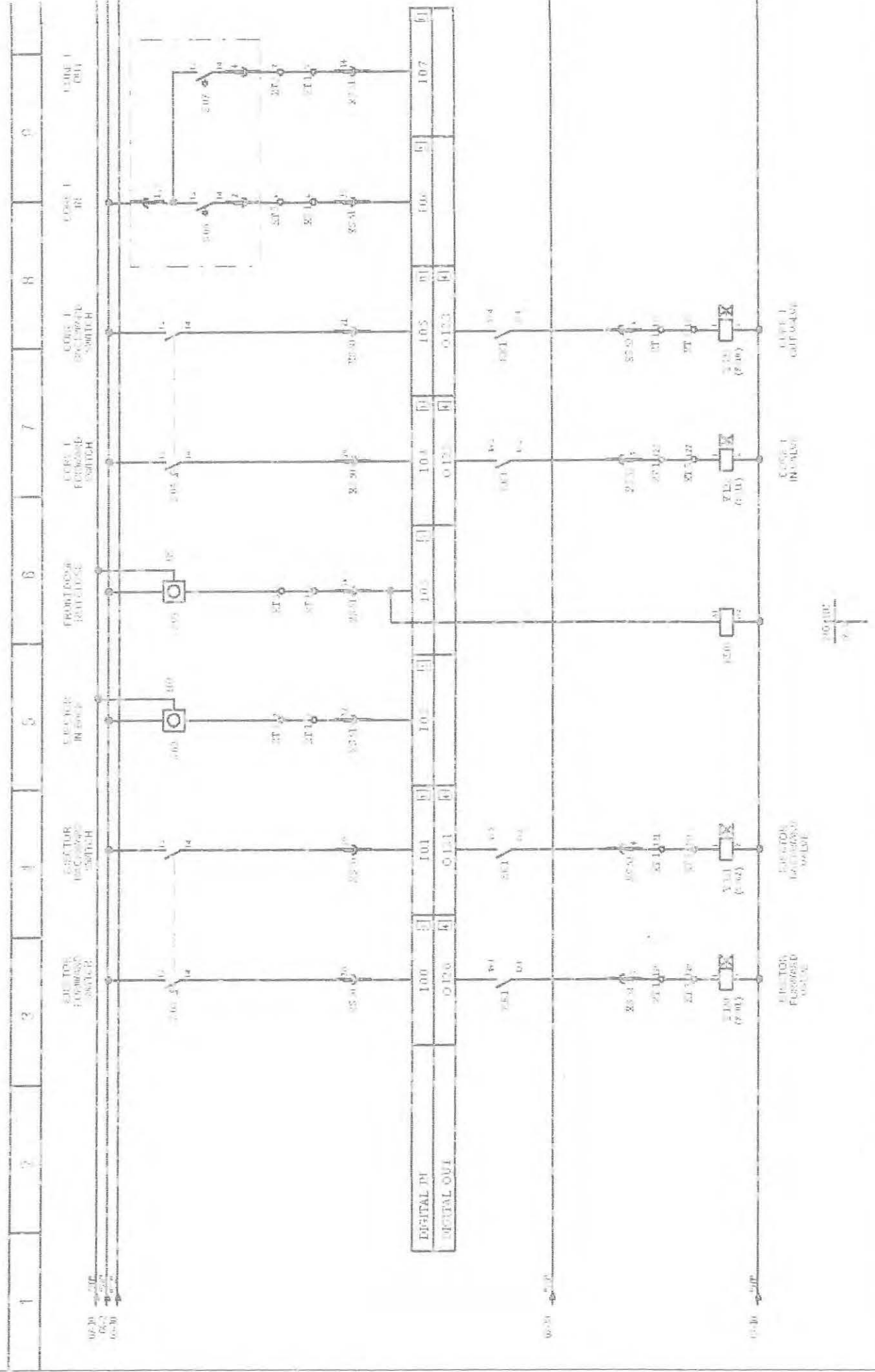
SCHEMATA
LITERATURA
0

QDCM 400

TING 7&8

PL - 47 - 226 Kędzierszyn-Koźle
Ul. Szkolna 15
Tel.: +48 077 488 05 93
Fax: +48 077 488 07 08
www.nip.com.pl





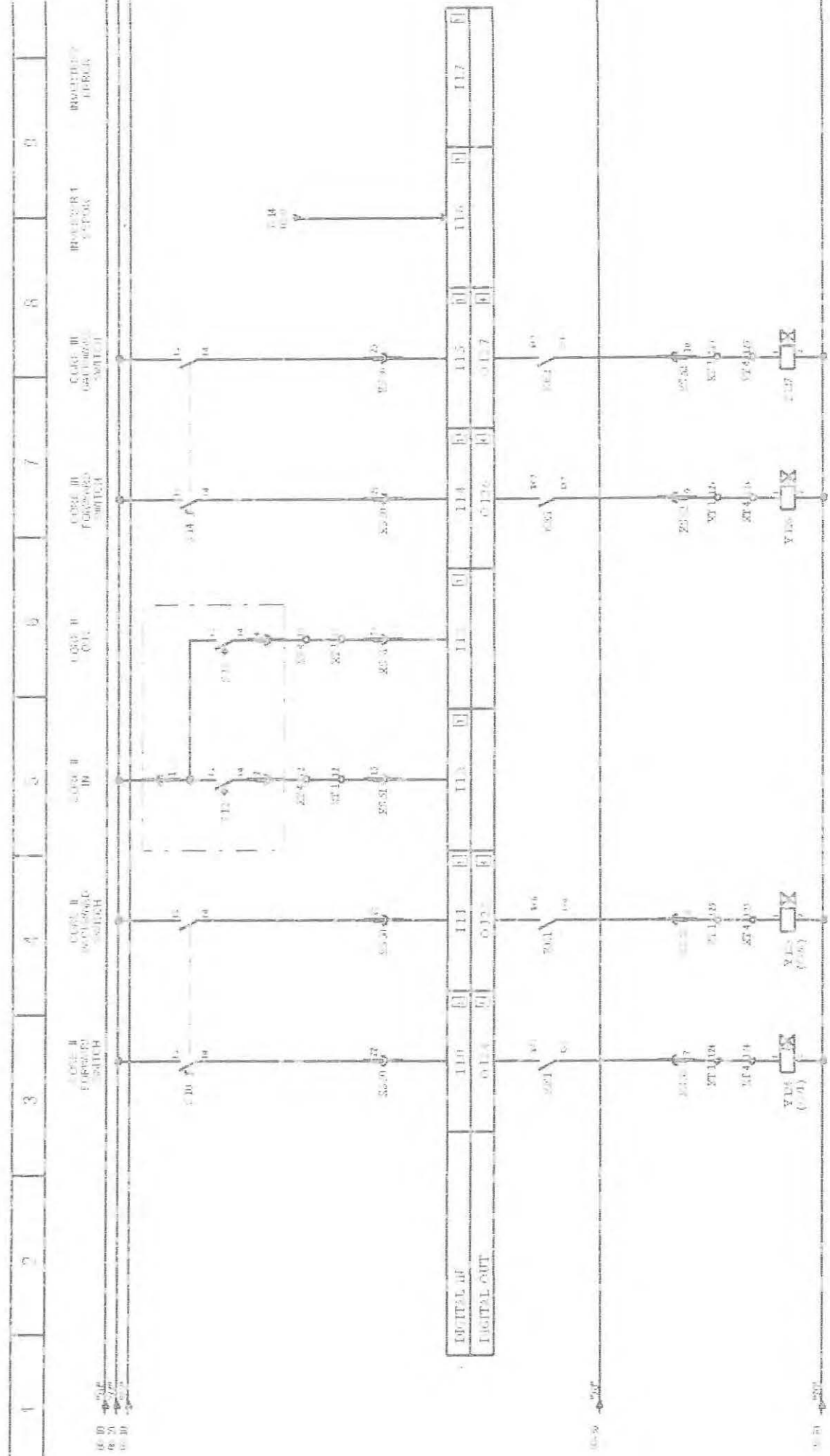
PL - 47 - 225 Kedzierzyn-Kozle
 Ul. Szkolna 15
 Tel.: +48 077 406 66 93
 Fax.: +48 077 406 07 00
 www.nmp.com.pl

TMG 7&8

QDCM 400

SCHEMATA	0
TOTAL	0





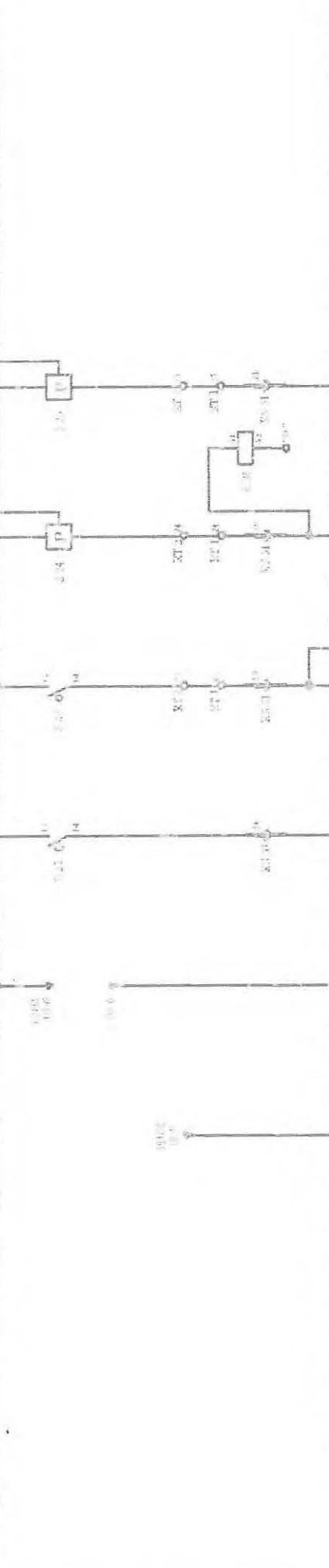
PL - 47 - 225 Kadzierszyn-Koście
 Ul. Szkolna 15
 Tel.: +48 077 420 60 00
 Fax.: +48 077 420 67 00
 www.nip.com.pl

TMG 7&8

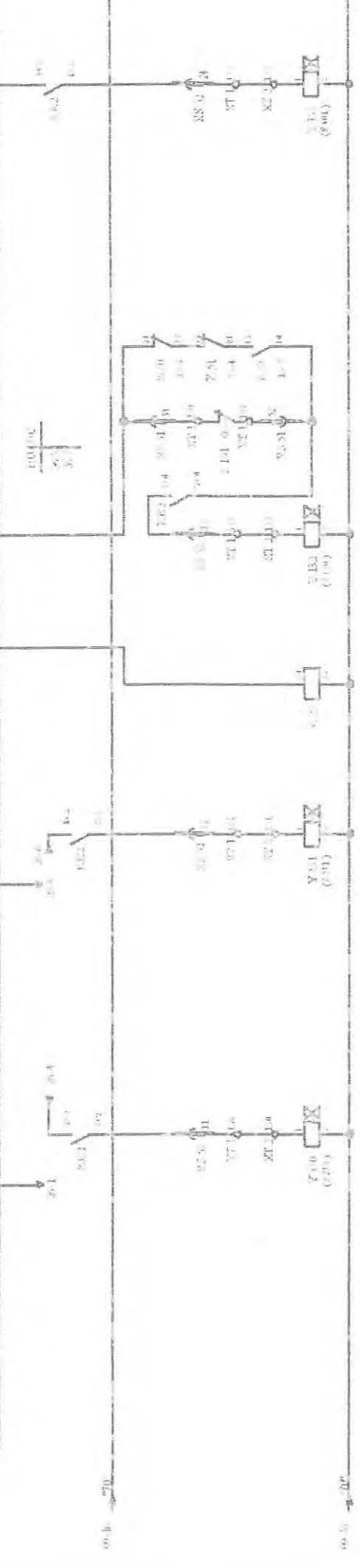
QDCM 400



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03.0	03.0	03.0	03.0	03.0	03.0	03.0	03.0	03.0	03.0



NOZ	1.0	1.1	1.2	1.3	1.4	1.5	1.6	1.7
01.0	01.0	01.0	01.0	01.0	01.0	01.0	01.0	01.0
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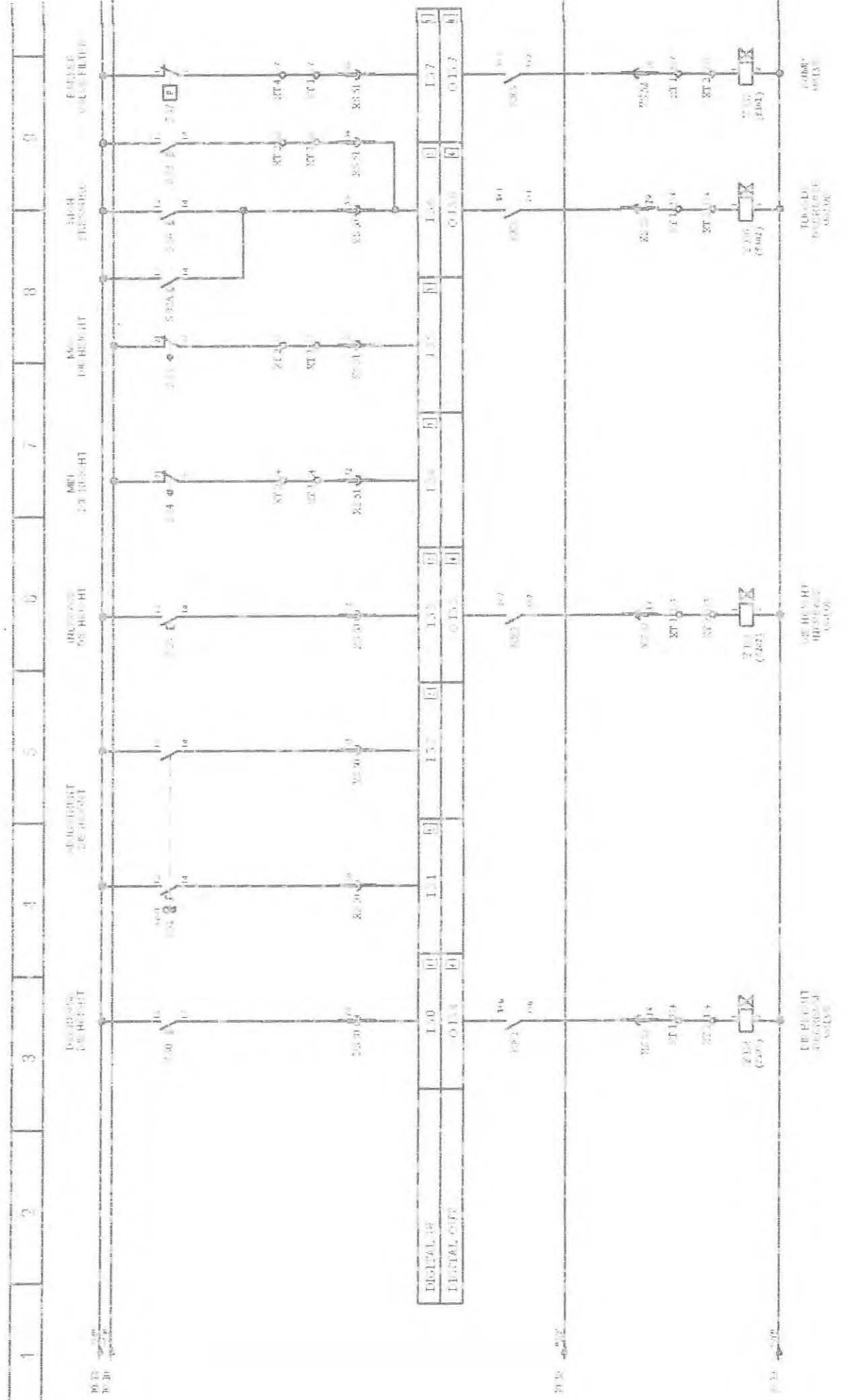
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03.0	03.0	03.0	03.0	03.0	03.0	03.0	03.0	03.0

PL - 47 - 225 Kędziersyn-Kozie
 Ul. Szkolna 15
 Tel.: +48 077 430 05 57
 Fax: +48 077 430 07 00
 www.nip.com.pl

NIP

TMG 7&8

QDCM 400



1	2	3	4	5	6	7	8	9	10
DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.	DRUCKSCHALTER DRUCKSCHW.
FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.	FUNKELKONTAKT DRUCKSCHW.

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1.00	1.01	1.02	1.03	1.04	1.05	1.06	1.07	1.08	1.09
0.13.0	0.13.1	0.13.2	0.13.3	0.13.4	0.13.5	0.13.6	0.13.7	0.13.8	0.13.9

1.00	1.01	1.02	1.03	1.04	1.05	1.06	1.07	1.08	1.09
0.13.0	0.13.1	0.13.2	0.13.3	0.13.4	0.13.5	0.13.6	0.13.7	0.13.8	0.13.9

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0.13.0	0.13.1	0.13.2	0.13.3	0.13.4	0.13.5	0.13.6	0.13.7	0.13.8	0.13.9

1.00	1.01	1.02	1.03	1.04	1.05	1.06	1.07	1.08	1.09
0.13.0	0.13.1	0.13.2	0.13.3	0.13.4	0.13.5	0.13.6	0.13.7	0.13.8	0.13.9

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1.00	1.01	1.02	1.03	1.04	1.05	1.06	1.07	1.08	1.09
0.13.0	0.13.1	0.13.2	0.13.3	0.13.4	0.13.5	0.13.6	0.13.7	0.13.8	0.13.9

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1.00	1.01	1.02	1.03	1.04	1.05	1.06	1.07	1.08	1.09
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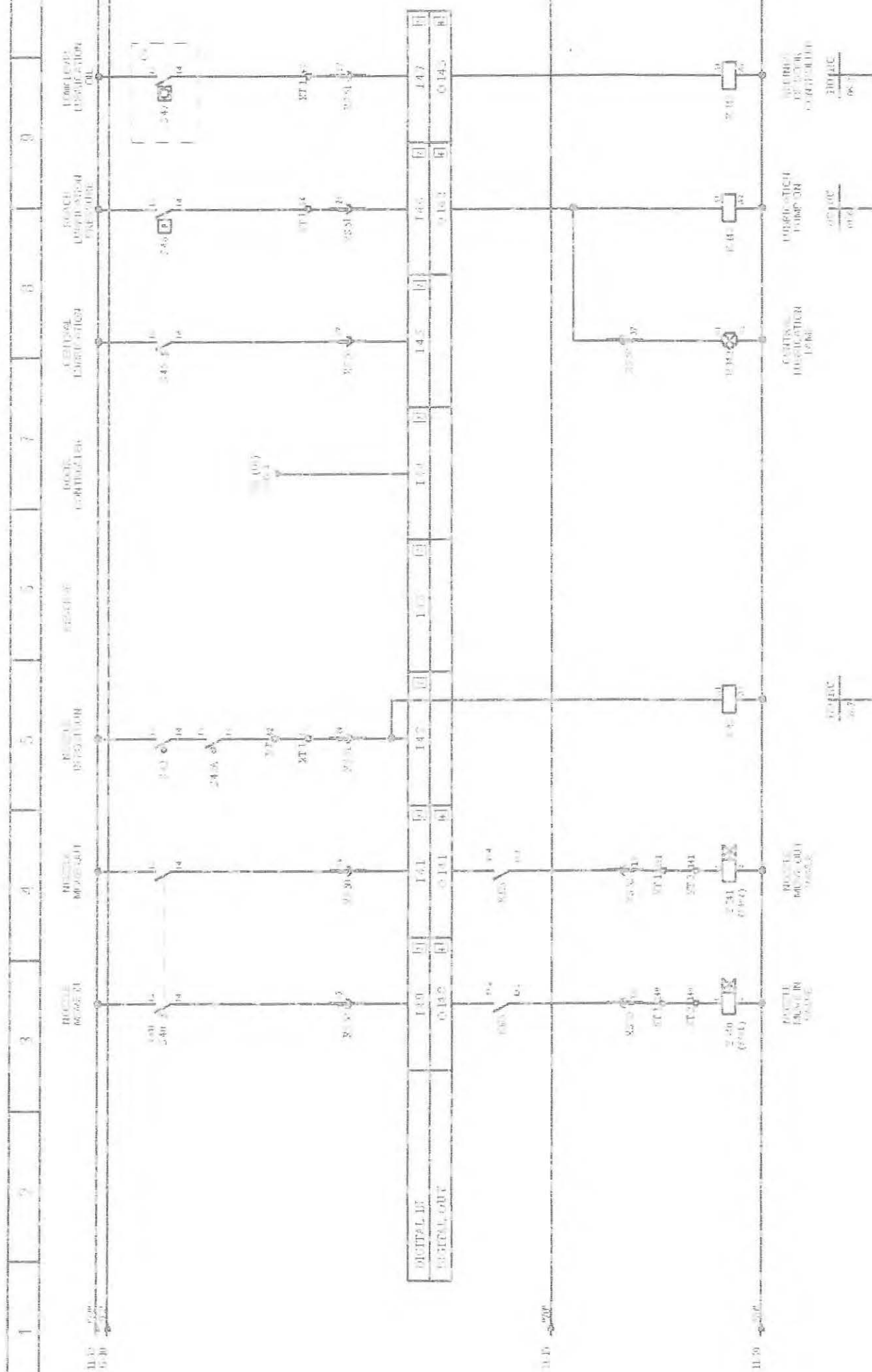
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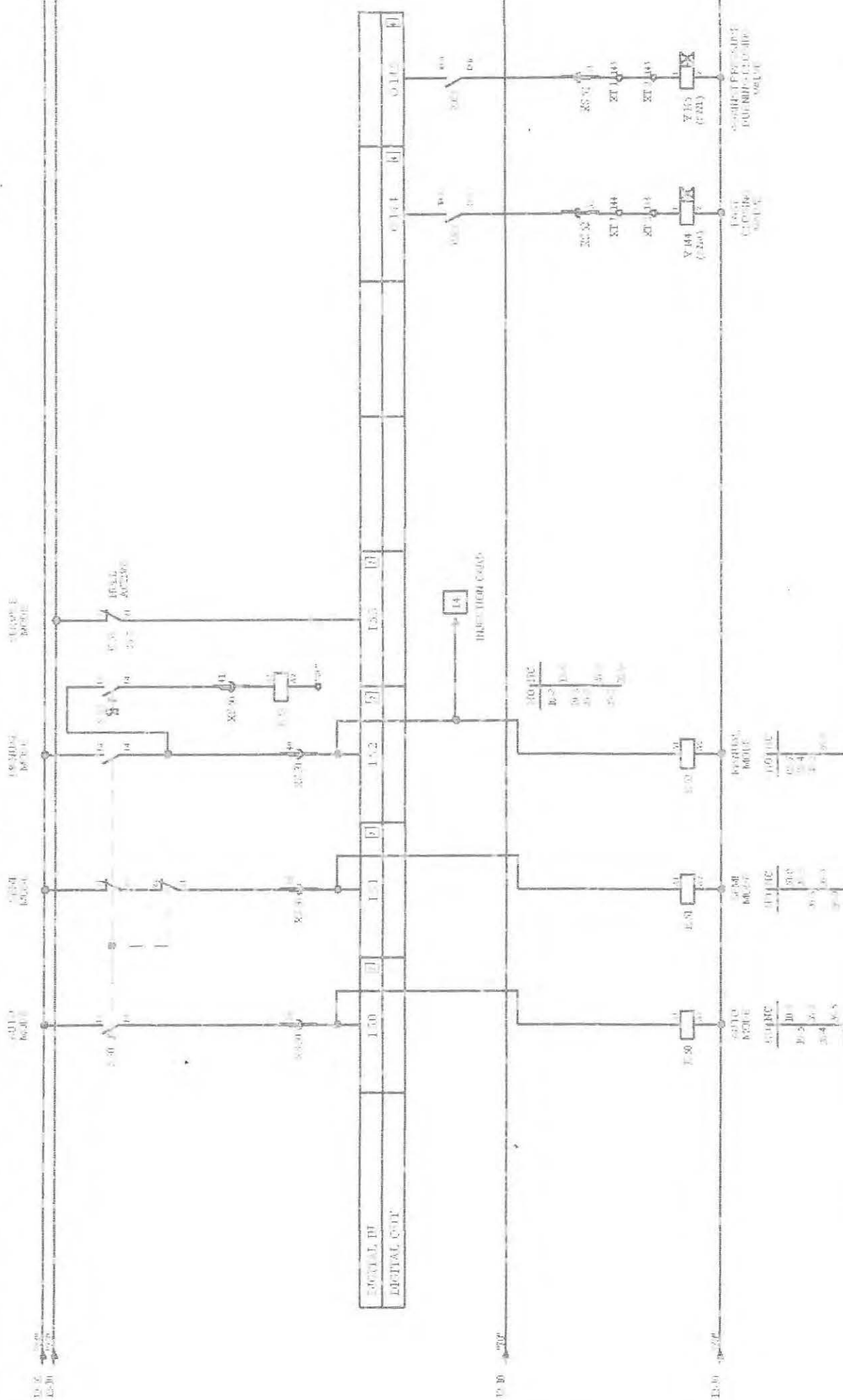
PL - 47 - 225 Kedzierzyn-Koźle
 Ul. Szkoła 15
 Tel.: +48 077 400 69 93
 Fax: +48 077 400 67 00
 www.nip.com.pl

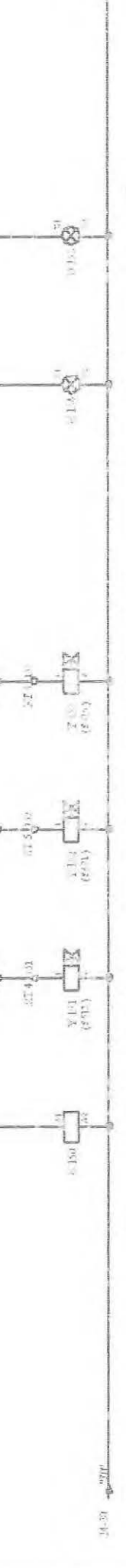
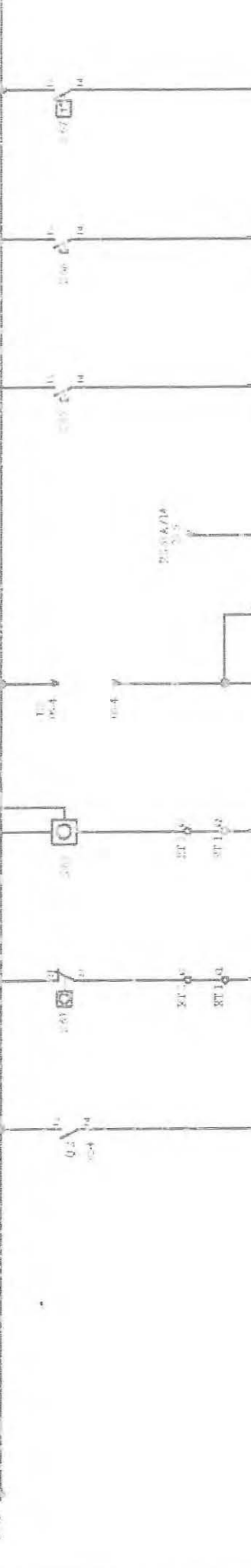
TMG 788

ODCM 400

SCH
 1000
 1000





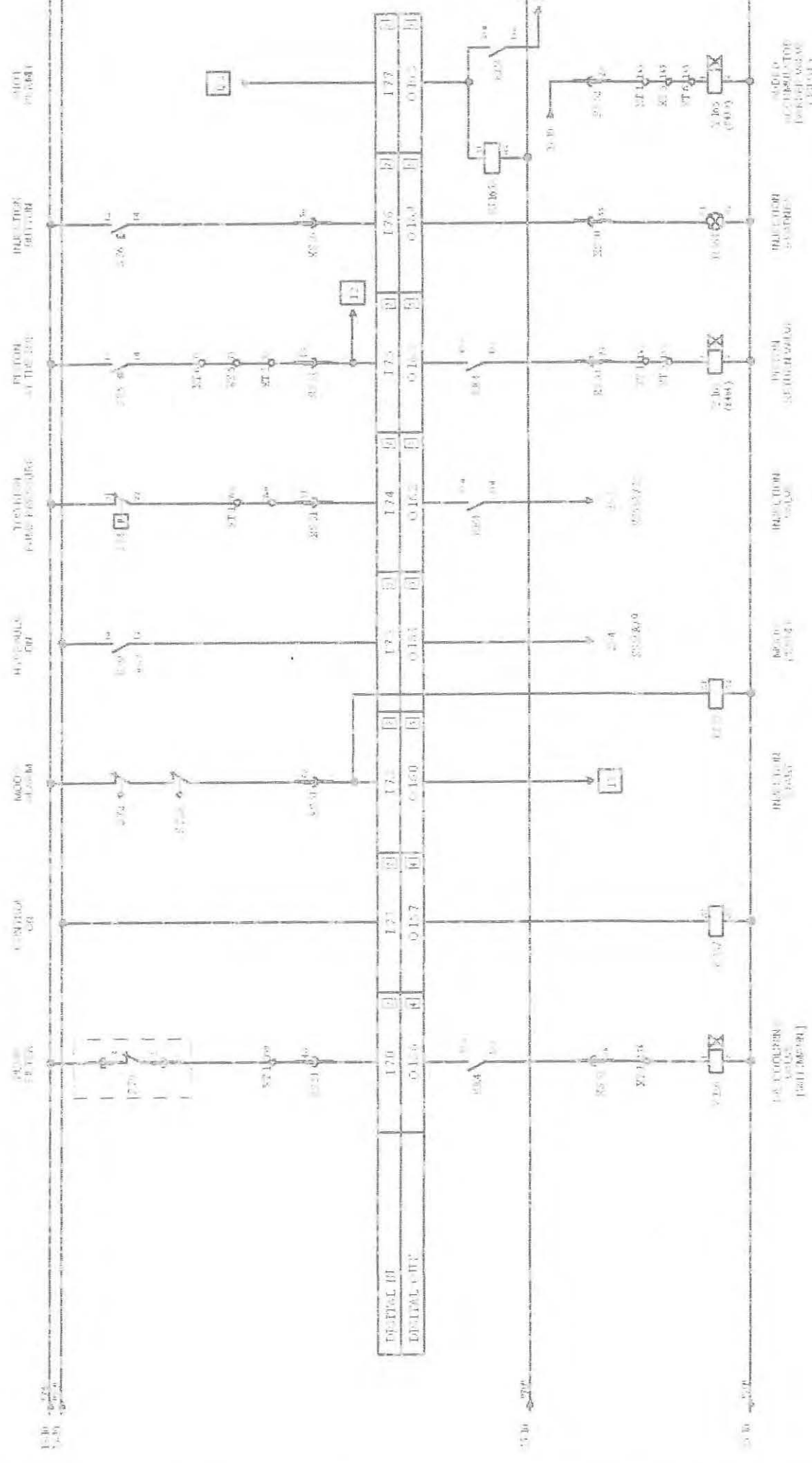


NIP
 PL - 47 - 225 Kędzierzyn-Koźle
 ul. Szkolna 15
 tel.: +48 077 455 05 70
 fax: +48 077 433 67 89
 www.nip.com.pl

TMG 7&8
QDCM 400

SCH.	100
REV.	1
DATE	10.07.07

1 2 3 4 5 6 7 8 9



PL - 47 - 225 Kędzierzyn-Koźle
 Ul. Szkolna 15
 tel.: +48 077 486 65 93
 fax: +48 077 418 07 02
 www.nip.com.pl

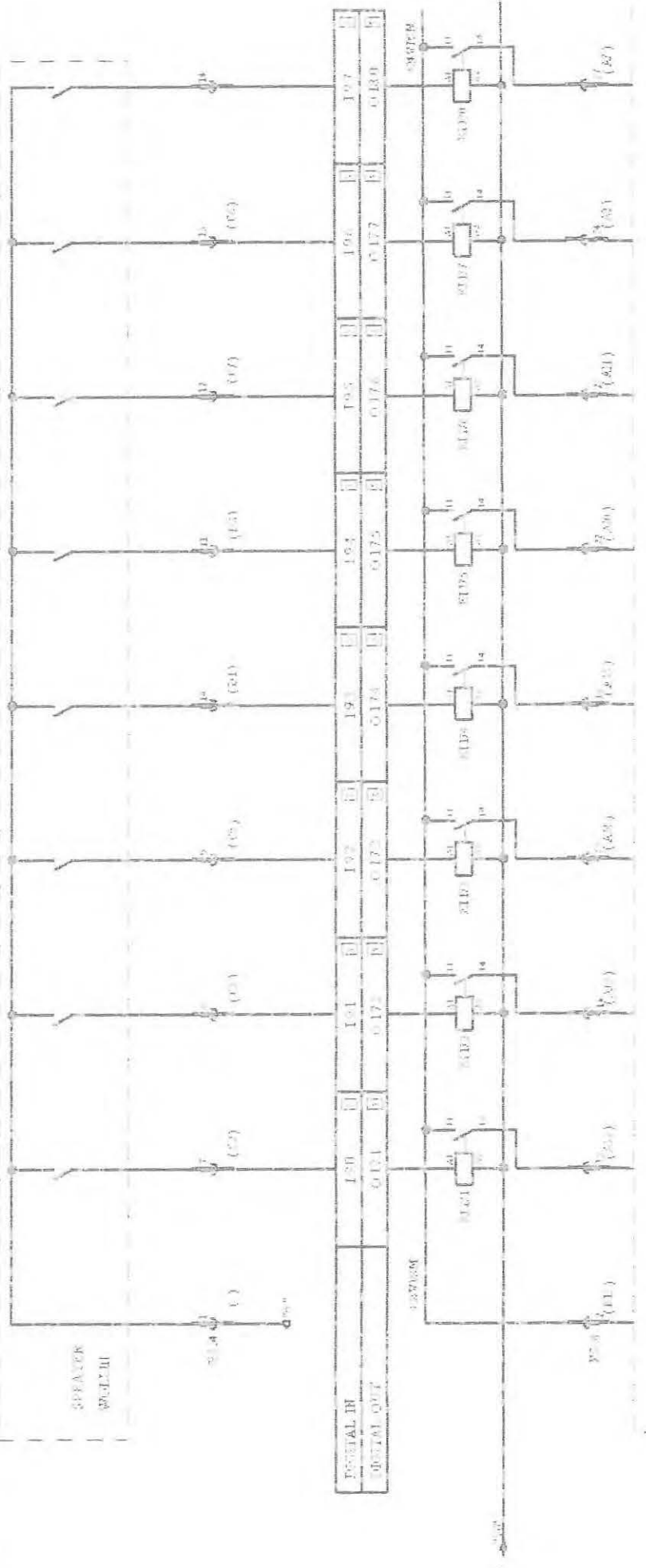
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TMG 7&8

QDCM 400

SCH
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100	101	102	103	104	105	106	107	108	109
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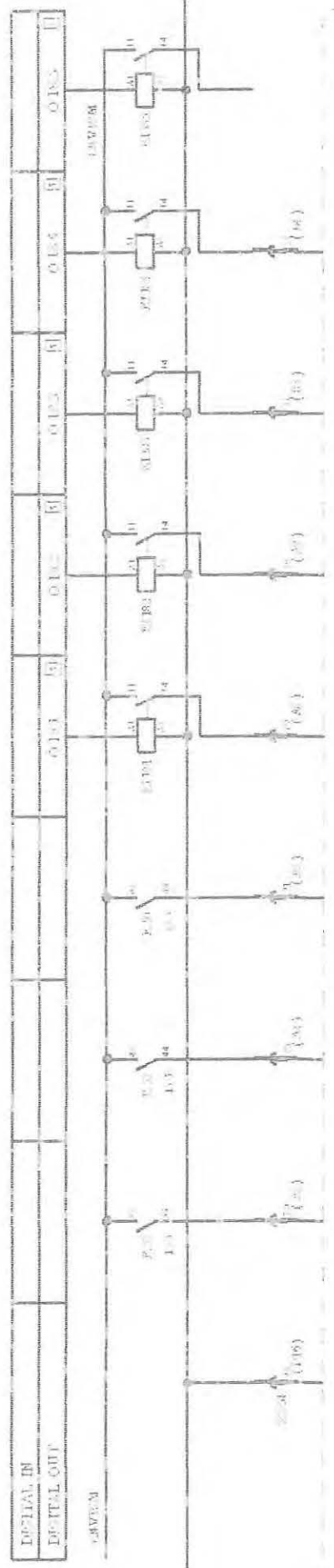
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SYMBOL 100 101 102 103 104 105 106 107 108 109

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PL 10
PL 10



PL 10
PL 10

PL 10
PL 10

SCHEMATIC	REVISION	DATE	BY	CHKD	APPV	REVISION	DATE	BY	CHKD	APPV

NTP

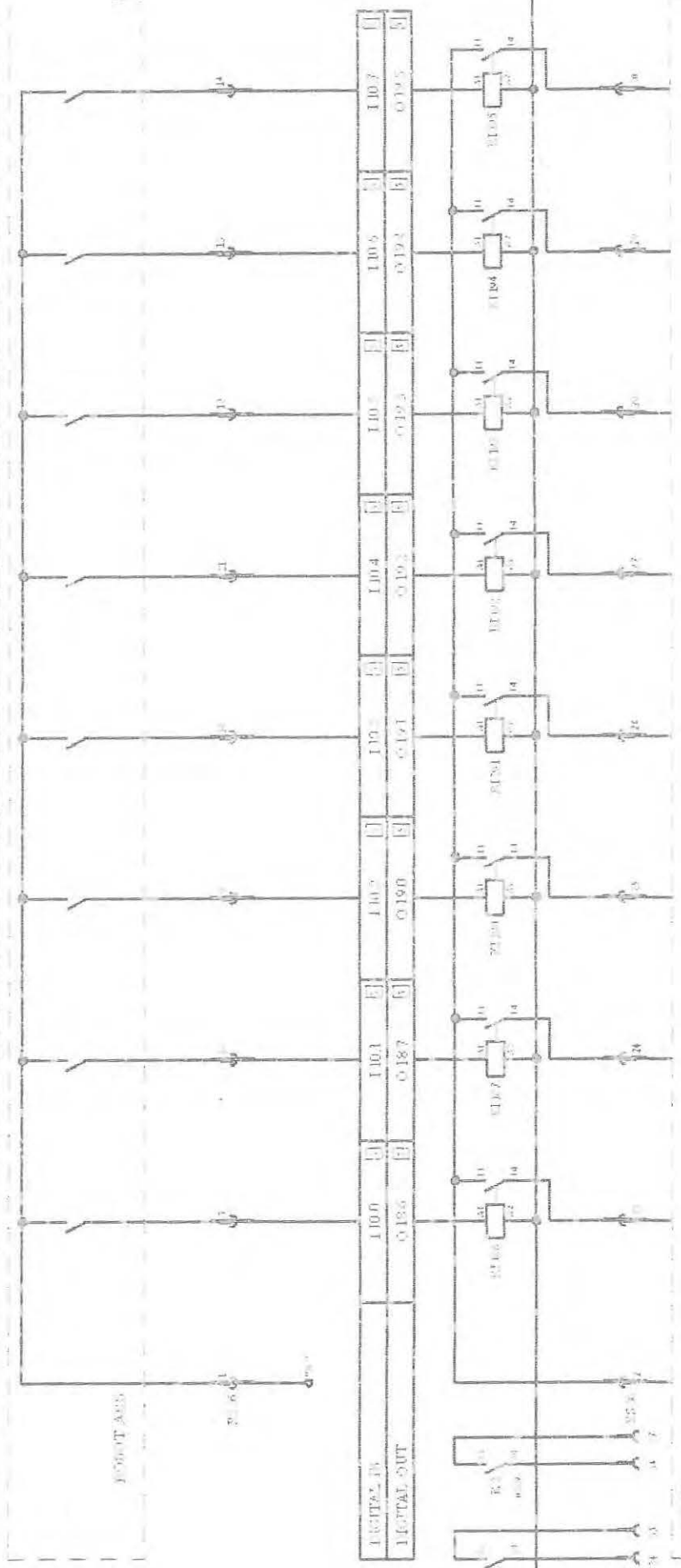
PL - 47 - 225 Kędzierzyn-Koźle
Ul. Szkolna 15
Tel.: +48 077 488 65 93
Fax.: +48 077 488 67 46
www.ntp.com.pl

TMG 7 & B

QDCM 400

1 2 3 4 5 6 7 8 9

10 B
11 B



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DIGITAL OUT	0186	0187	0190	0191	0192	0193	0194	0195

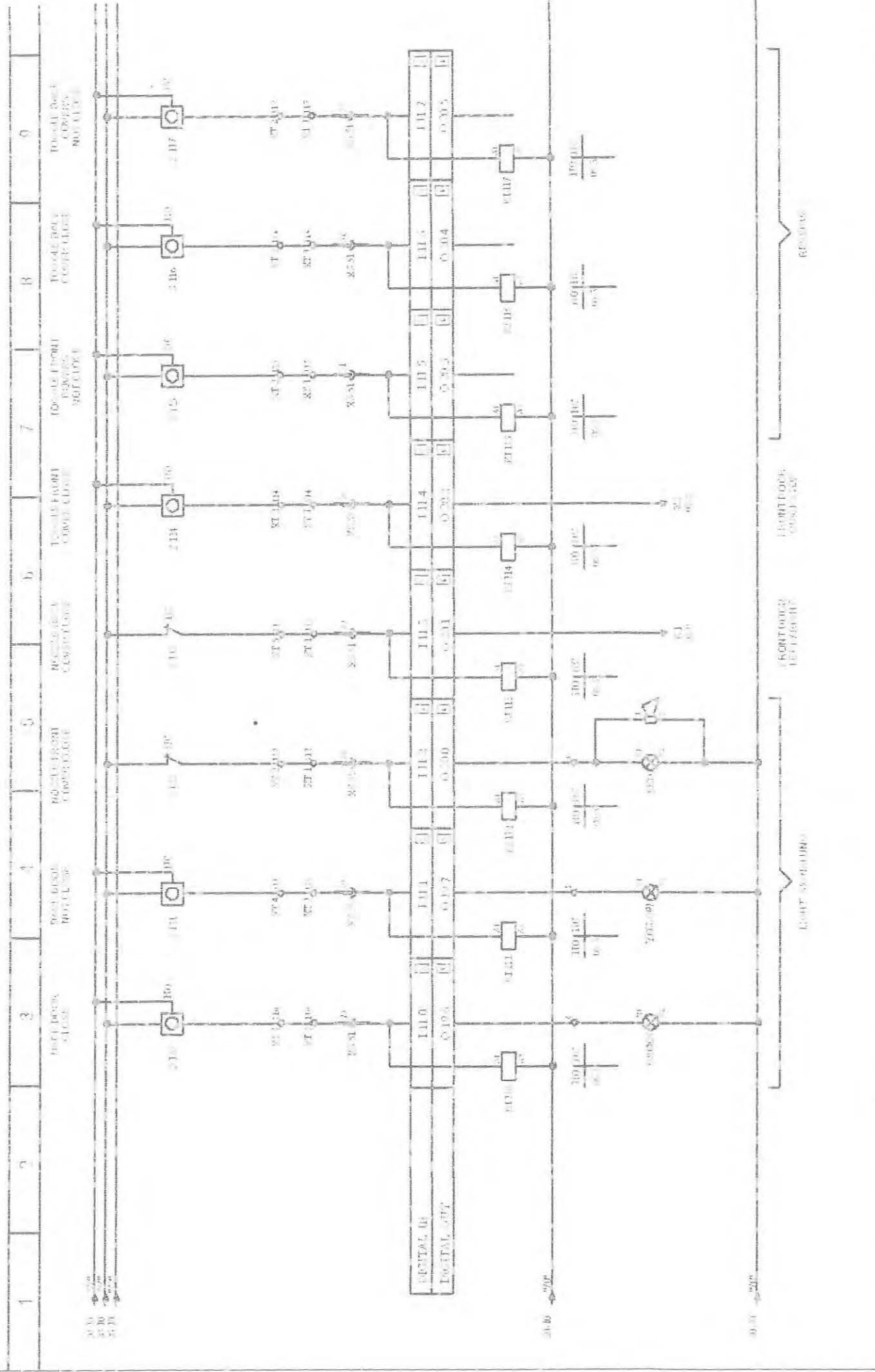
12 B
13 B



PL - 47 - 225 Kędzierzyn-Koźle
Ul. Szkolna 15
Tel.: +48 077 485 65 93
Fax: +48 077 485 67 00
www.ntp.pl

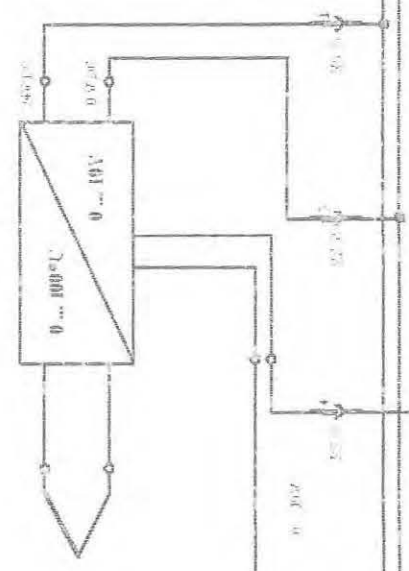
TMG 7&8

QDCM 400

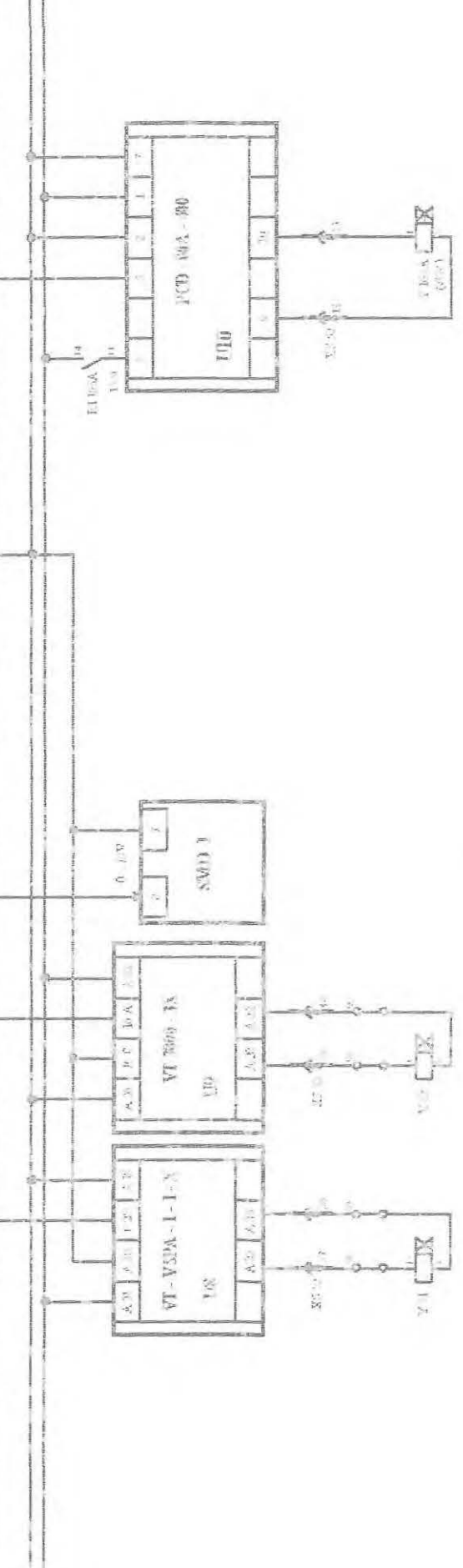


1 2 3 4 5 6 7 8 9 0

Hamowanie od 0 do 100%
0 ... 100V



ATP/LS 10	20/11	30/11	40/11	50/11	60/11	70/11	80/11	90/11	100/11
ATP/LS 0.1	20/11	30/11	40/11	50/11	60/11	70/11	80/11	90/11	100/11



0.5V/0.1A
0.5V/0.1A
0.5V/0.1A
0.5V/0.1A
0.5V/0.1A
0.5V/0.1A
0.5V/0.1A
0.5V/0.1A
0.5V/0.1A
0.5V/0.1A

NIP

PL - 47 - 225 Kędzierzyn-Koźle
Ul. Szkolna 15
Tel.: +48 077 455 66 03
Fax: +48 077 455 67 08
www.nip.com.pl

TMG 7&8

QDCM 400

SCHN
1000
1000

1	2	3	4	5	6	7	8	9
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DEKODYFICJA
0, 120V

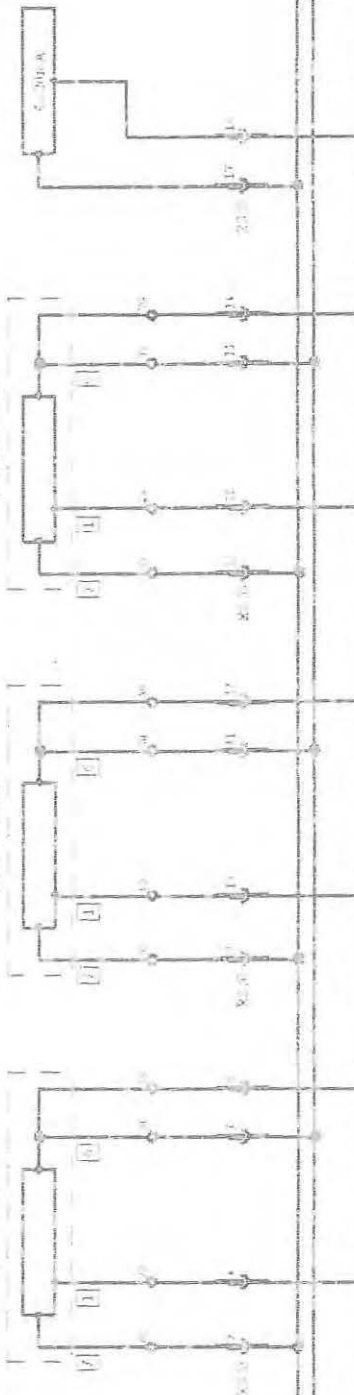
DEKODYFICJA
0, 120V

DEKODYFICJA
0, 120V

DEKODYFICJA

DEKODYFICJA

DEKODYFICJA



ANALOG 0V	MS 15	MS 10	MS 11	MS 12	MS 13	MS 14	MS 15
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01.20
02.10

PL - 47 - 225 Kędzierzyn-Koźle
Ul. Szkolna 15
teln.: +48 077 488 66 93
faks.: +48 077 488 67 09
www.nip.com.pl

TMG 7 & 8

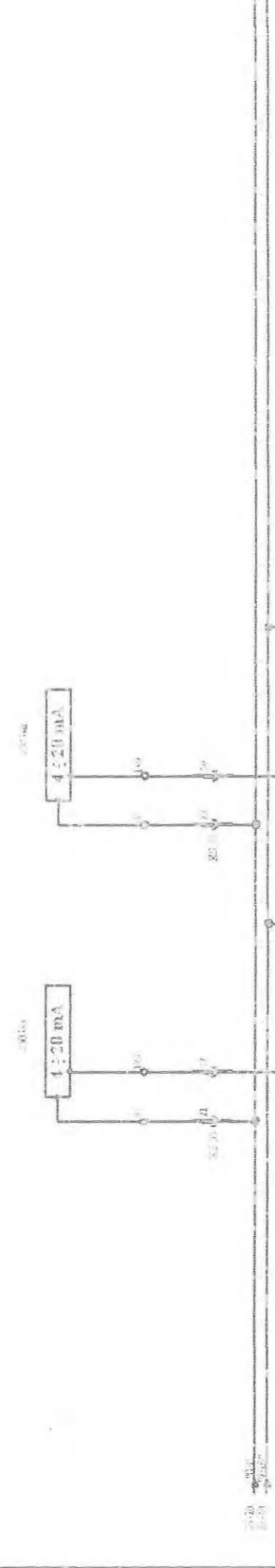
ODCM 400

SCH
1/2004



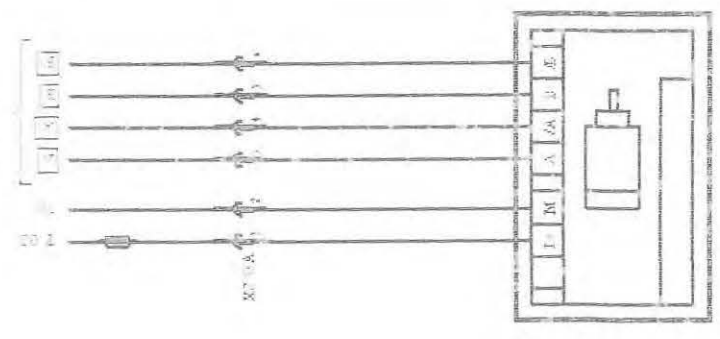
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WYKONANIE PRAC PROJEKTOWYCH W ZAKŁADACH PROJEKTOWYCH I WYKONAWCZYCH "NIP" S.A. W WARSZAWIE

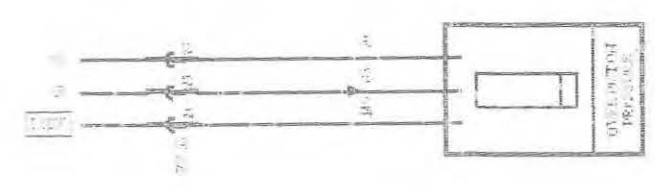
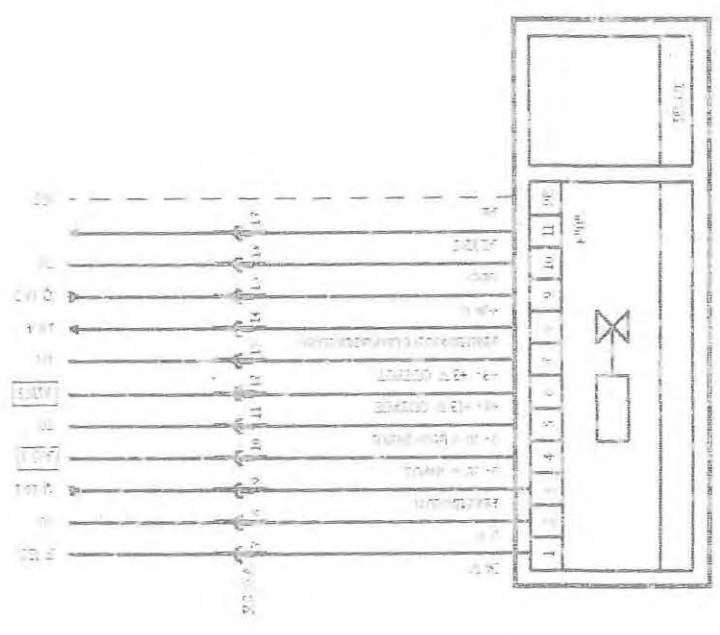


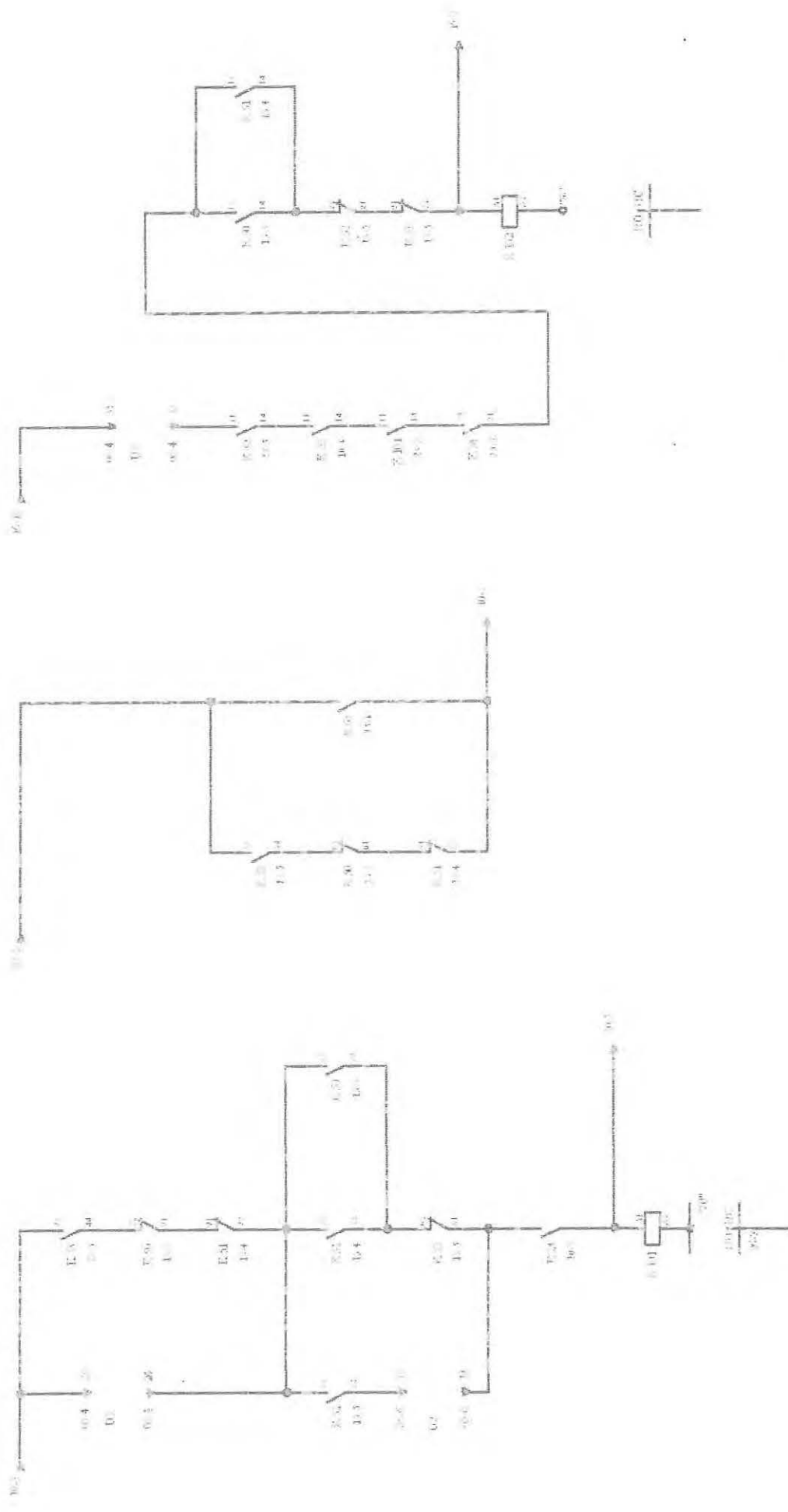
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015-0304-0000



015-0304-0000





REZERV KURBITIM

REZERV KURBITIM

REZERV KURBITIM

6

HEATING CONTROL

"TMG"

7 & 8

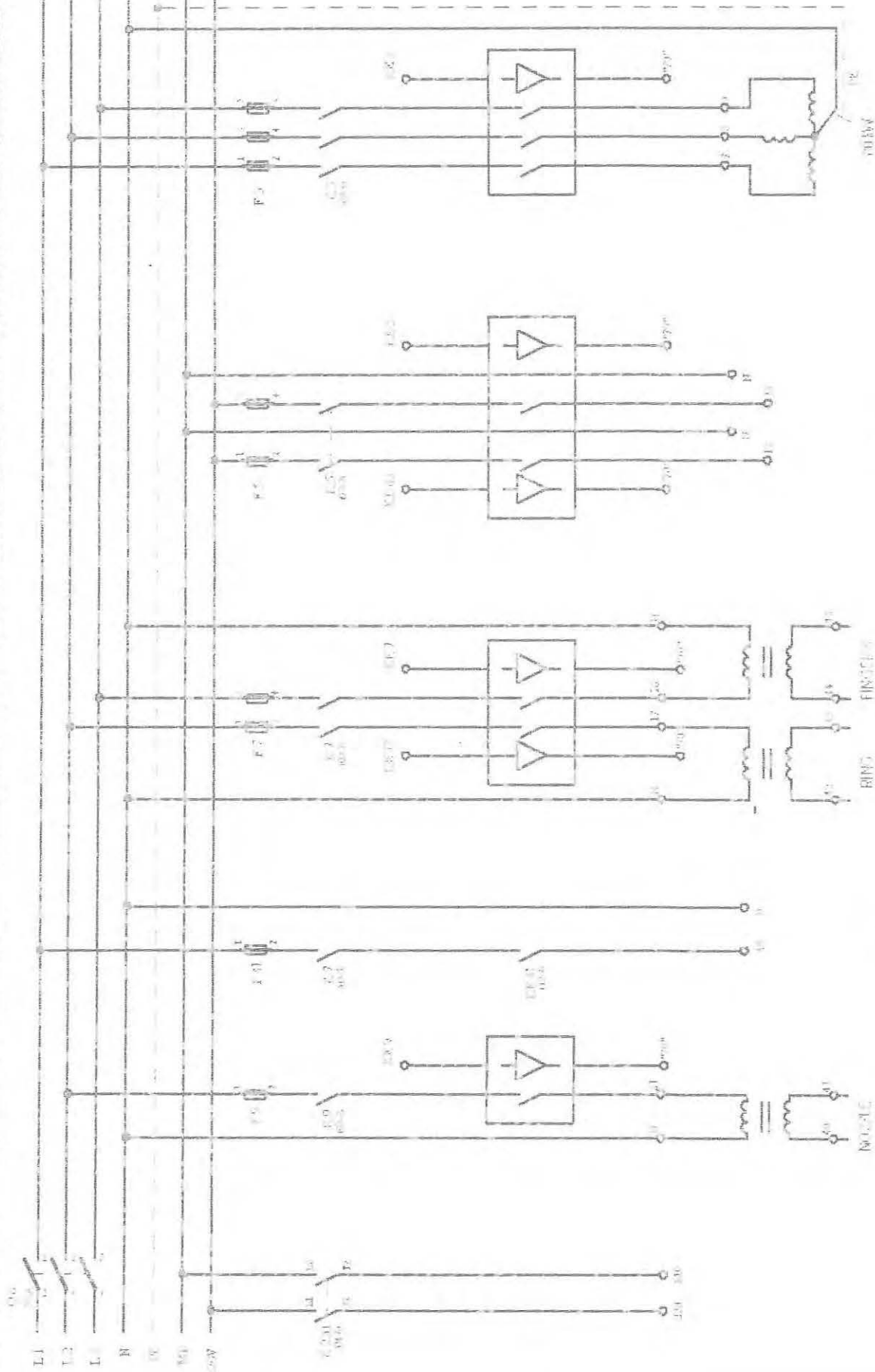
NTP

NOWOCZESNE TECHNOLOGIE PRODUKCJI Sp. z o.o.

PL - 47 - 225 KĘDZIERZYN - KOŹLE

UL. SZKOLNA 15

1 2 3 4 5 6 7 8



NOZZLE
 VERTICAL TRIPPER II
 FINICE II
 TUBE II

PL - 47 - 225 Kędzierzyn-Koźle
 Ul. Szkolna 15
 tel.: +48 077 433 95A 503
 fax: +48 077 433 6 7 100
 www.nip.pl

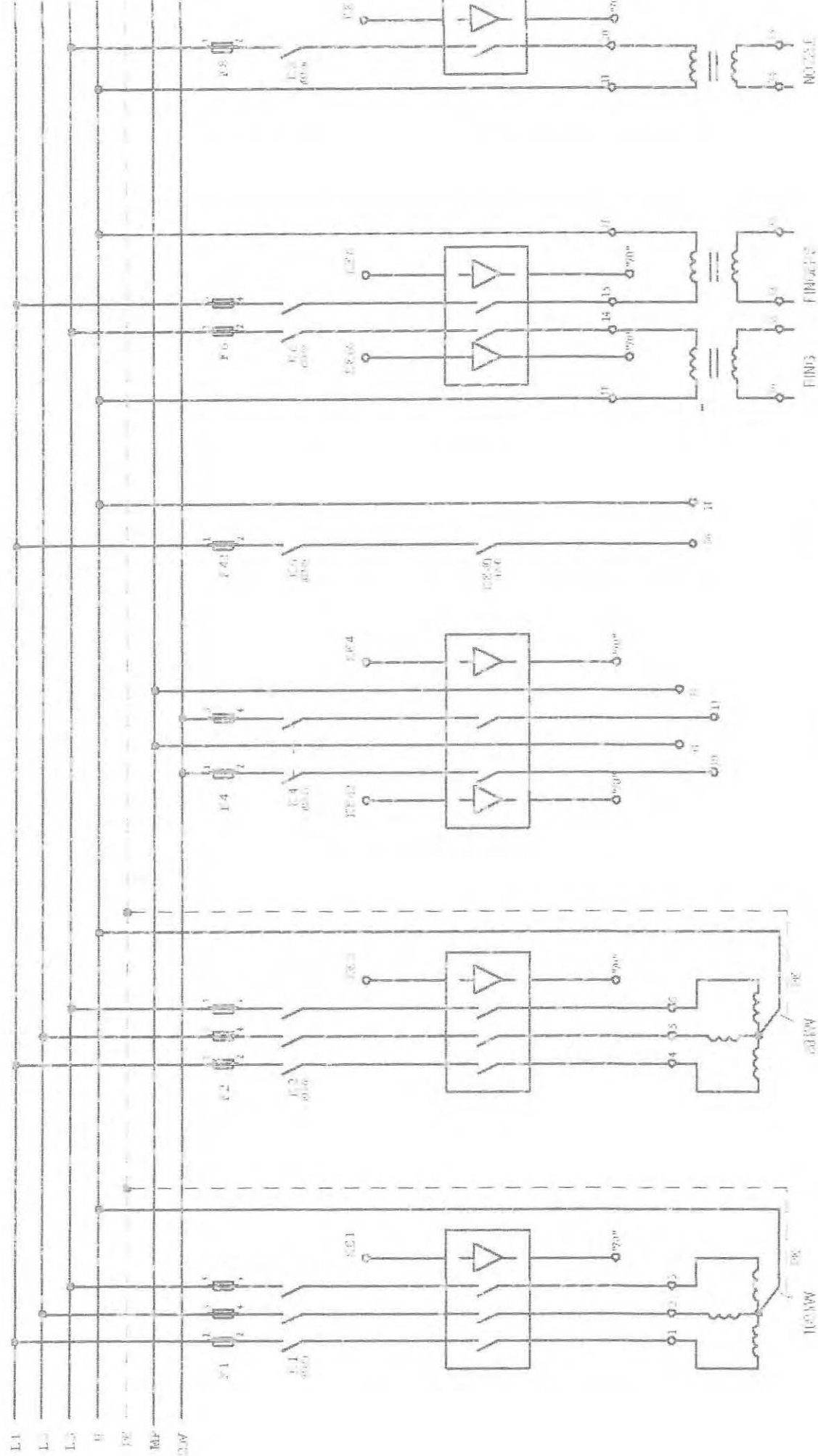


TMG

HEATING CONTROL
 728

SCHEMATIC

1 2 3 4 5 6 7 8 9



L1
L2
L3
N
PE
MF
0.0V

F1
F2
F3
F4
F5
F6
F7
F8
F9

K1
K2
K3
K4
K5
K6
K7
K8
K9

1000W
600W
1000W
1000W
1000W
1000W
1000W
1000W
1000W

MEI
MEI
MEI
MEI
MEI
MEI
MEI
MEI
MEI

1000W
600W
1000W
1000W
1000W
1000W
1000W
1000W
1000W

NO/NC/1
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NO/NC/1
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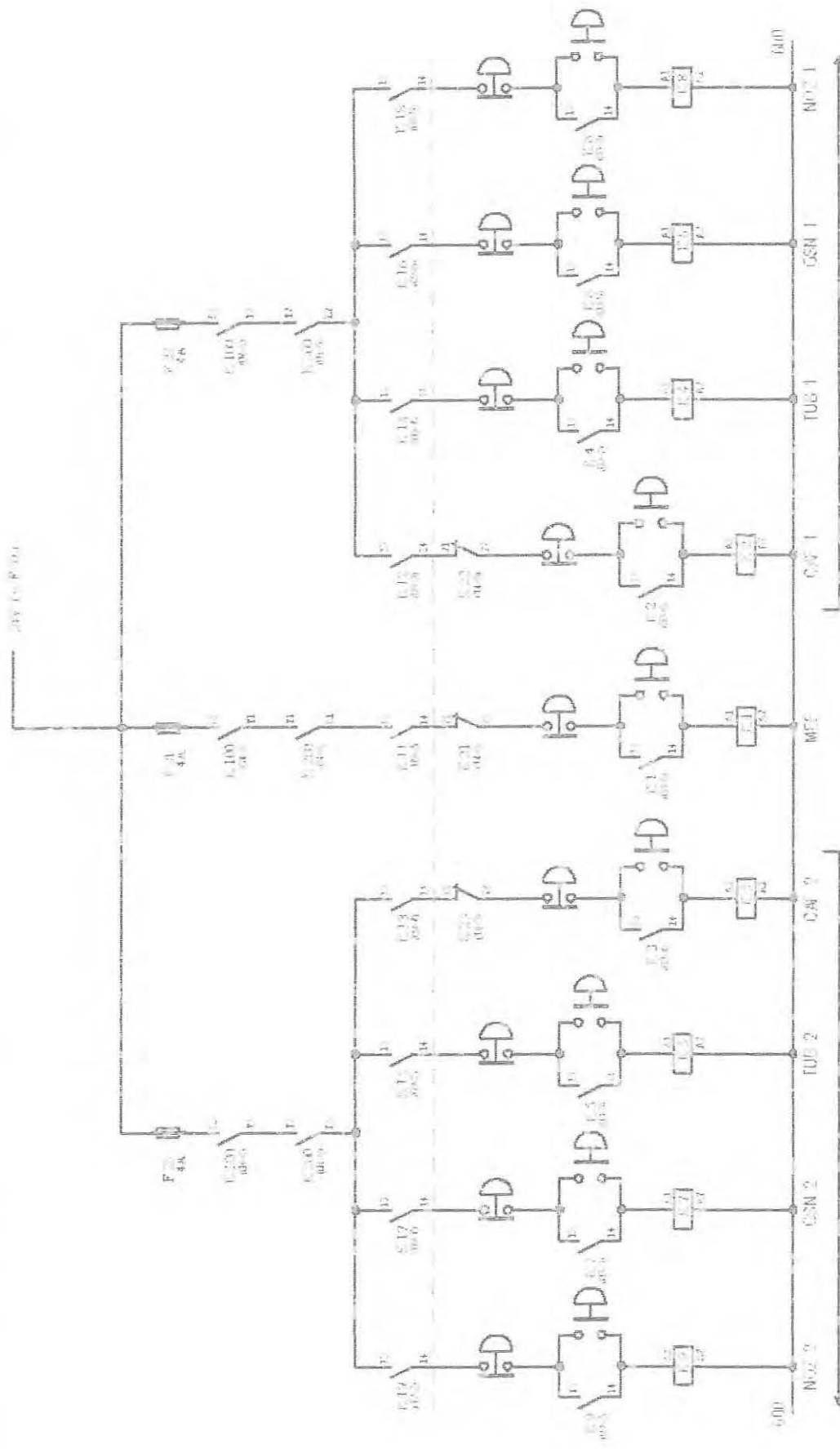
NTP

PL-47 - 225 Kędzierzyn-Koźle
Ul. Szkolna 15
Tel.: +48 077 425 05 93
Fax: +48 077 425 07 49
www.ntp.com.pl

TMG

HEATING CONTROL

788



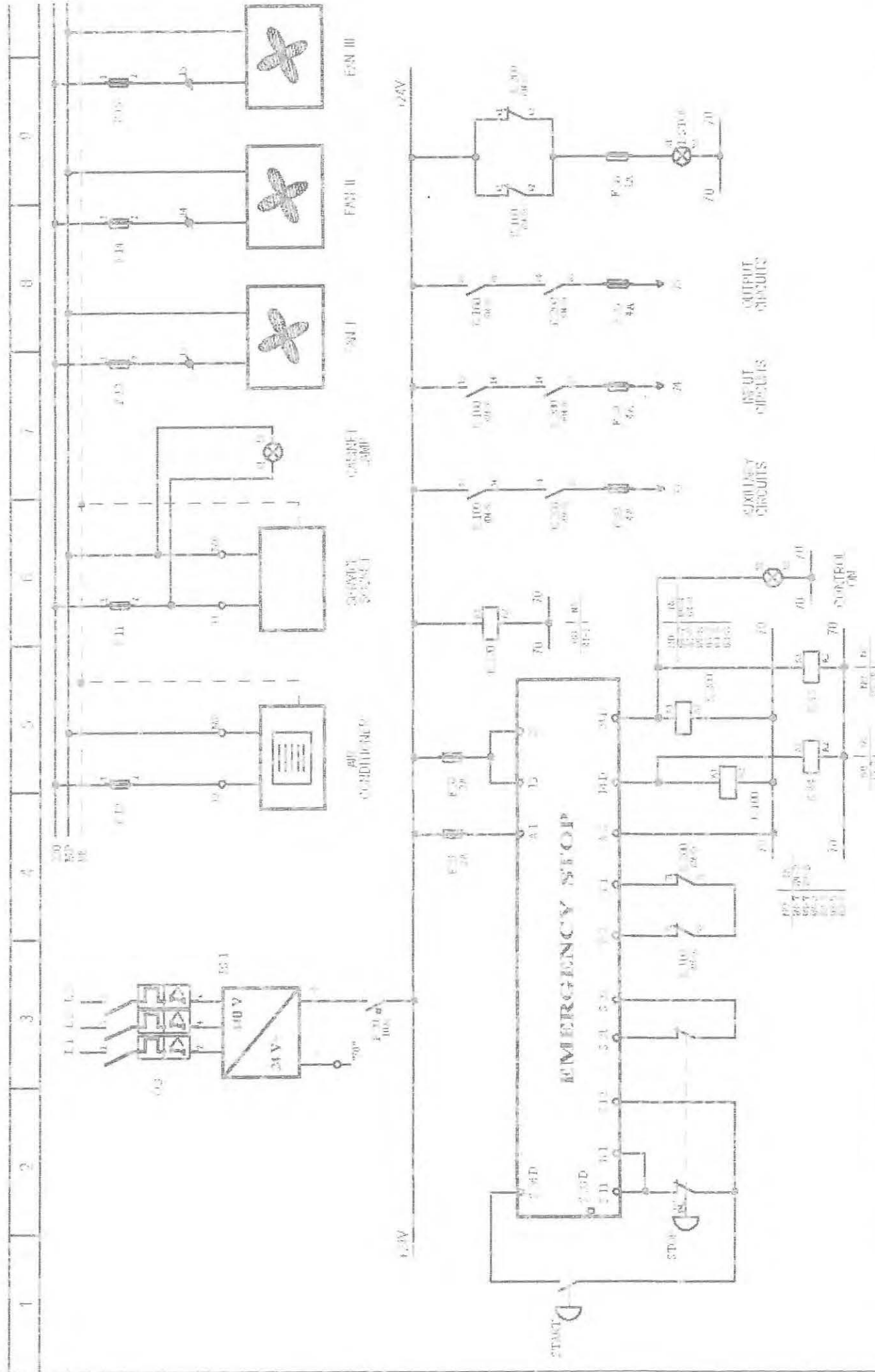
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PL-47 - 225 Kędzierzyn-Koźle
 ul. Szkolna 15
 tel.: 4-83 077 483 415 323
 tel.: 4-83 077 483 07 05
 www.nip.pl

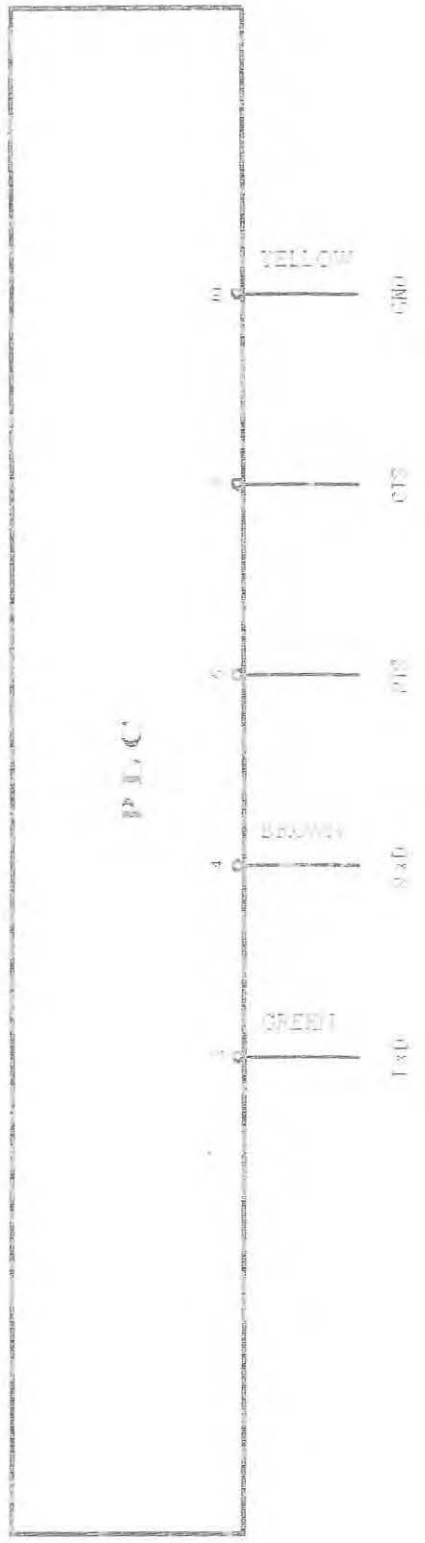
TMG

HEATING CONTROL





1	2	3	4	5	6	7	8	9
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RS 232
TO CONTROL PANEL

PL-47 - 225 Kędzierzyn-Koźle
Ul. Szkolna 15
tel.: +48 077 403 50 03
fax: +48 077 403 67 05
www.nip.com.pl



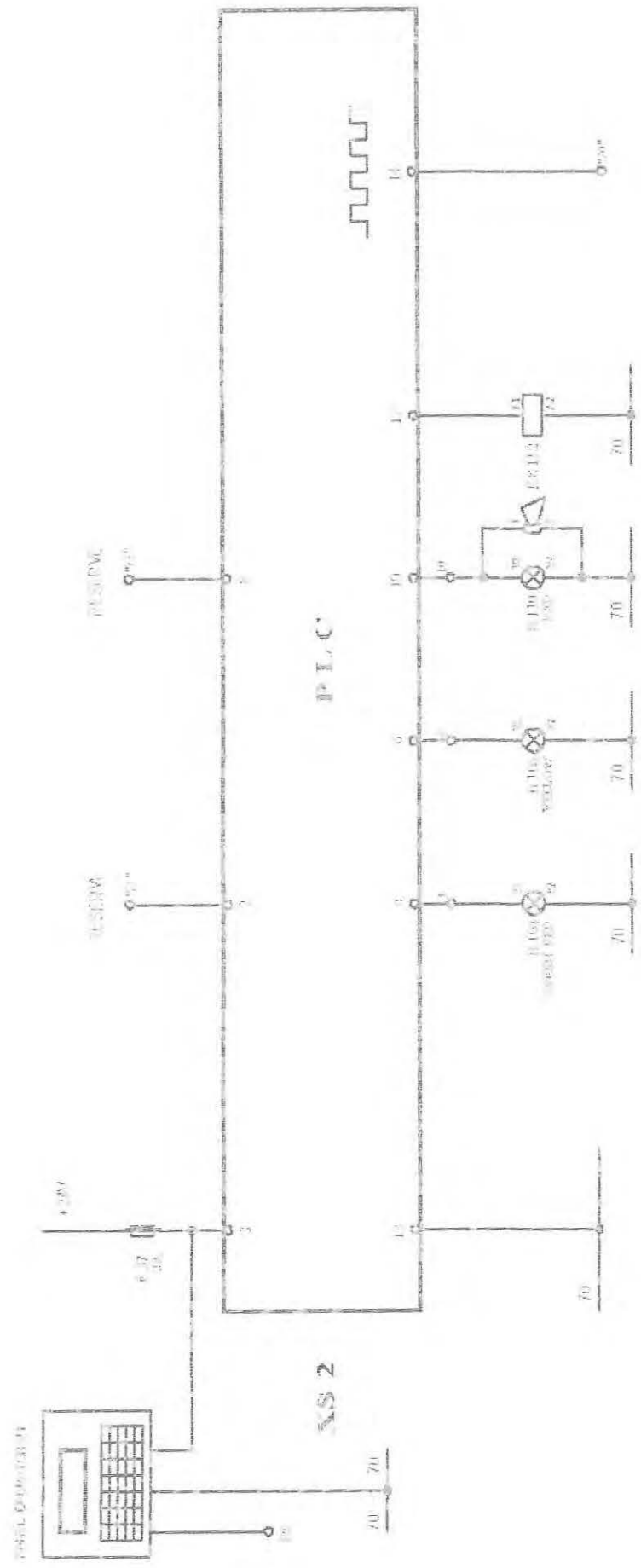
TMG

HEATING CONTROL

7-88

SCHEM
Czytelny
Wzrost

1 2 3 4 5 6 7 8 9



10 11 12



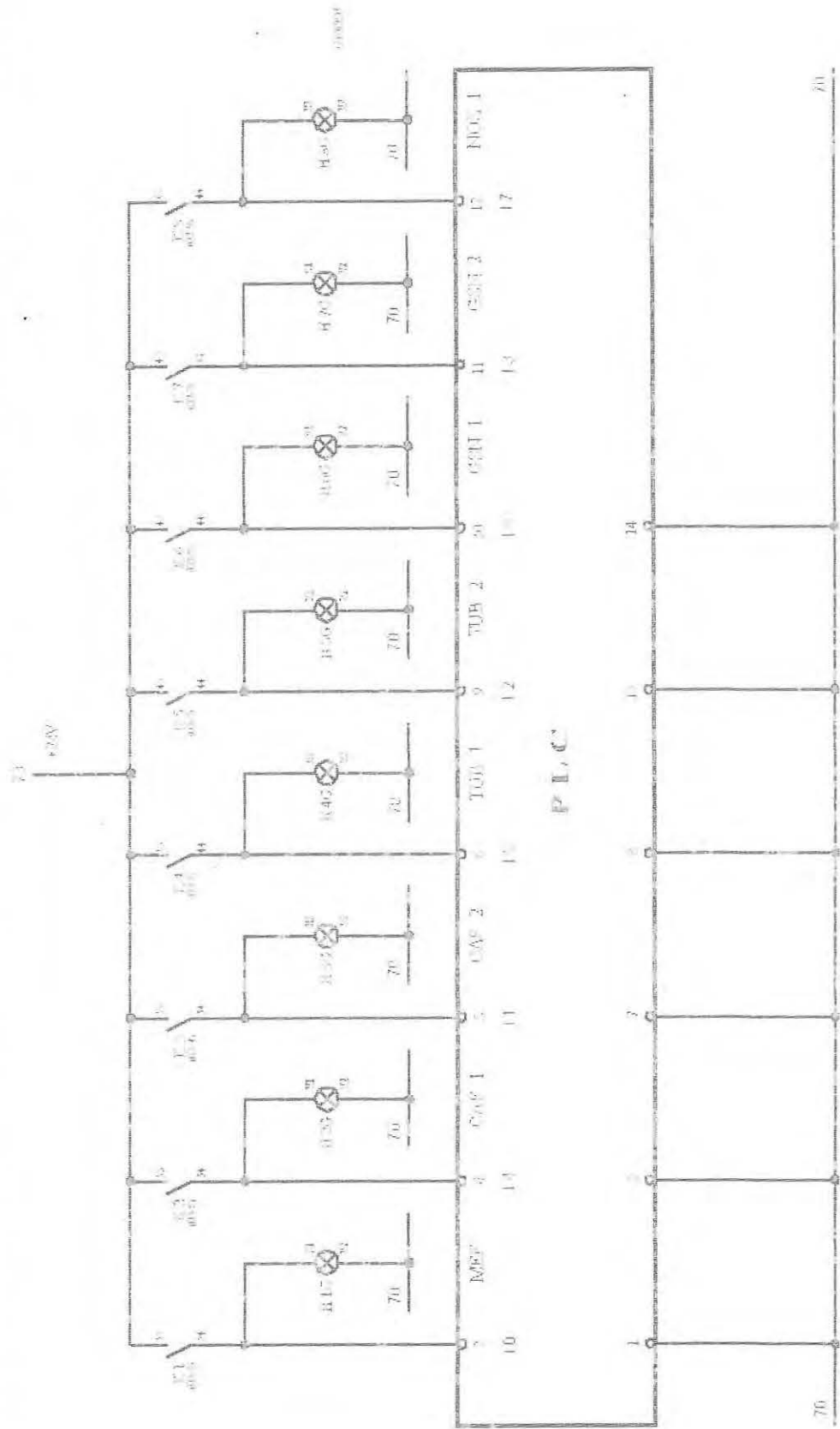
Pl. - 47 - 225 Kędzierzyn-Koźle
 Ul. Szkolna 15
 tel.: +48 077 480 65 93
 fax: +48 077 480 67 08
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TMG

HEATING CONTROL
 788

SCH
 0

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NS 3

PLC

SCHEM	0
PLANT	
DATE	

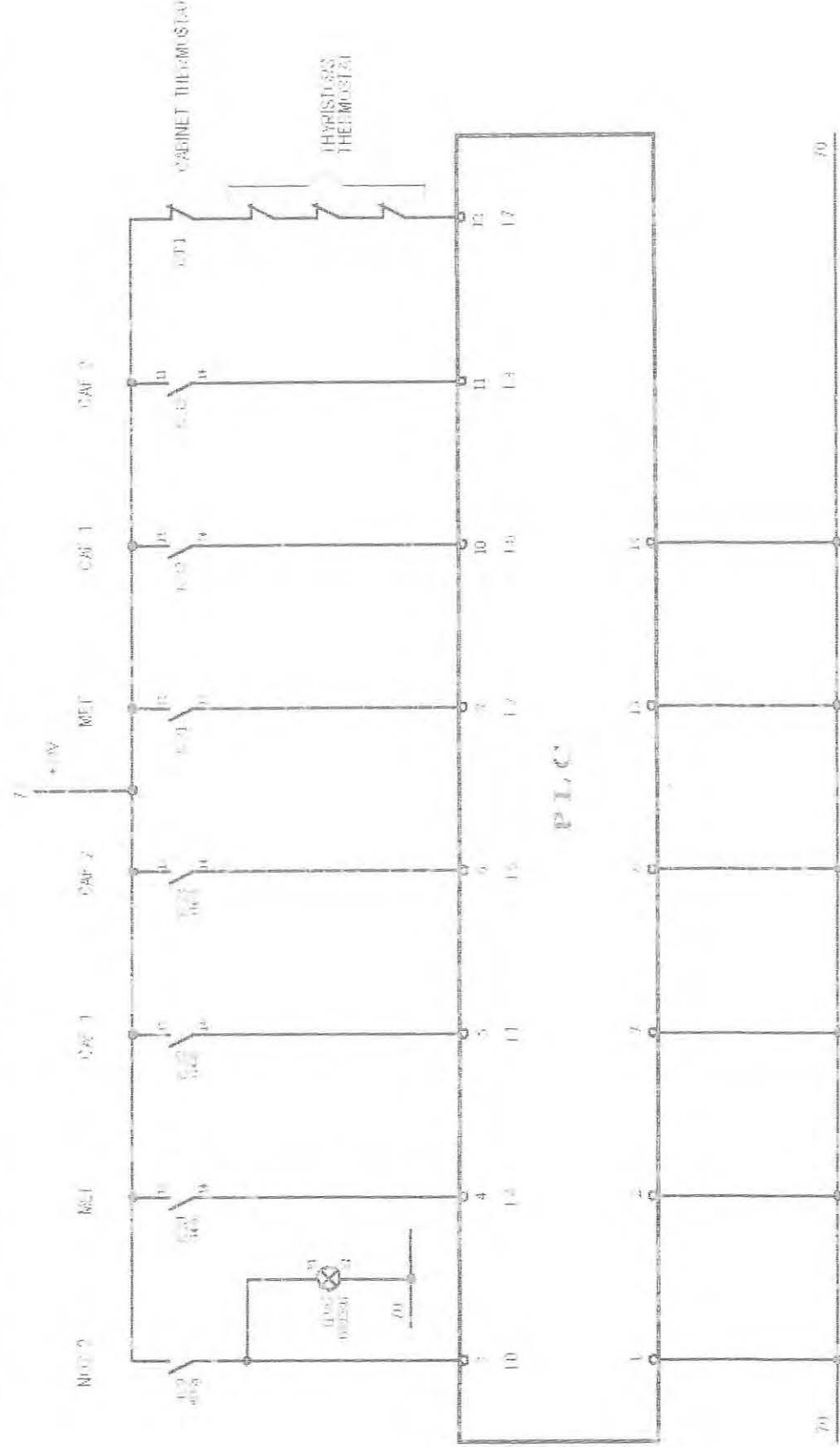
HEATING CONTROL

TMG

PL-47 - 225 Kędzierszyn-Koście
 ul. Sokoła 15
 tel.: +48 077 405 65 03
 fax: +48 077 405 67 89
 www.nip.com.pl



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2004

PLC

NIP

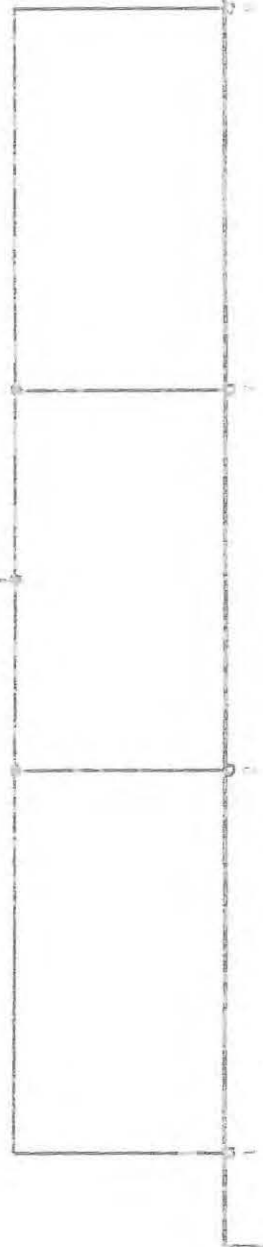
PL - 47 - 225 Kędzierzyn-Koźle
 Ul. Szkolna 15
 Tel.: +48 077 423 65 93
 Fax.: +48 077 423 67 03
 www.nip.com.pl

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HEATING CONTROL
 788

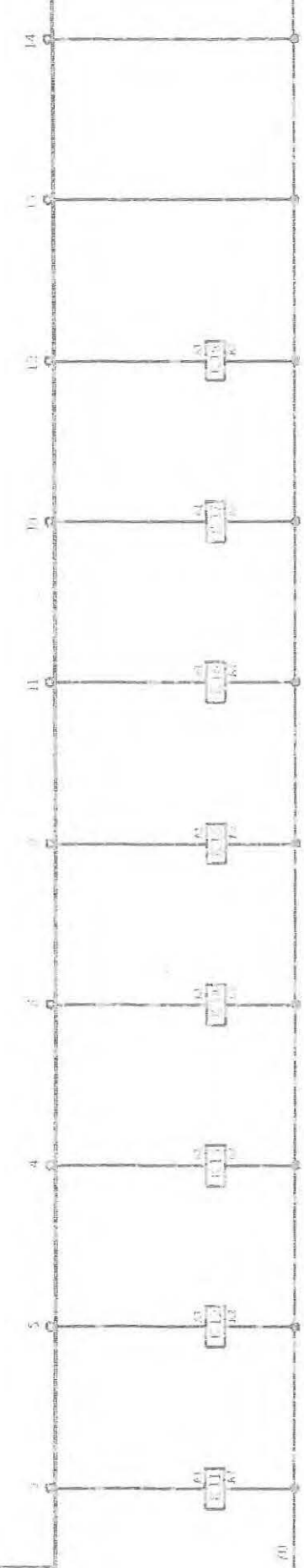
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24
+10V



XSS

PLC



M01	CNF1	CNF2	USB1	USB2	55NT (FRS)1	55NT (FRS)2	MOZ1
80 86	10 86	83 86	55 86	80 86	50 86	50 86	80 86
85-31117	85-31117	85-31117	85-31117	85-31117	85-31117	85-31117	85-31117

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Ul. Szkolna 15
Tel.: +48 077 480 05 05
Fax: +48 077 480 07 06
www.plc.com.pl

TMG

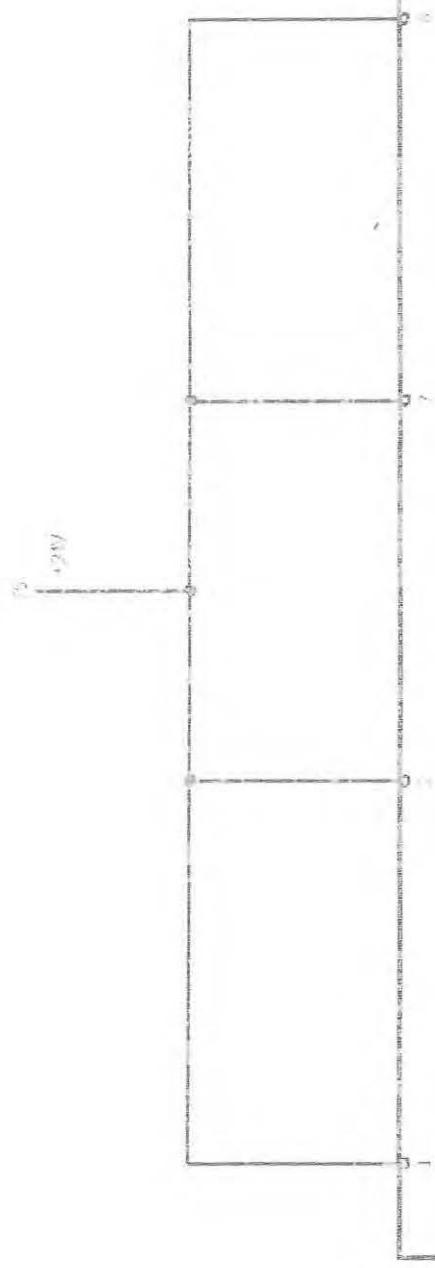
HEATING CONTROL

7&8

5010
1.000
00
PLC

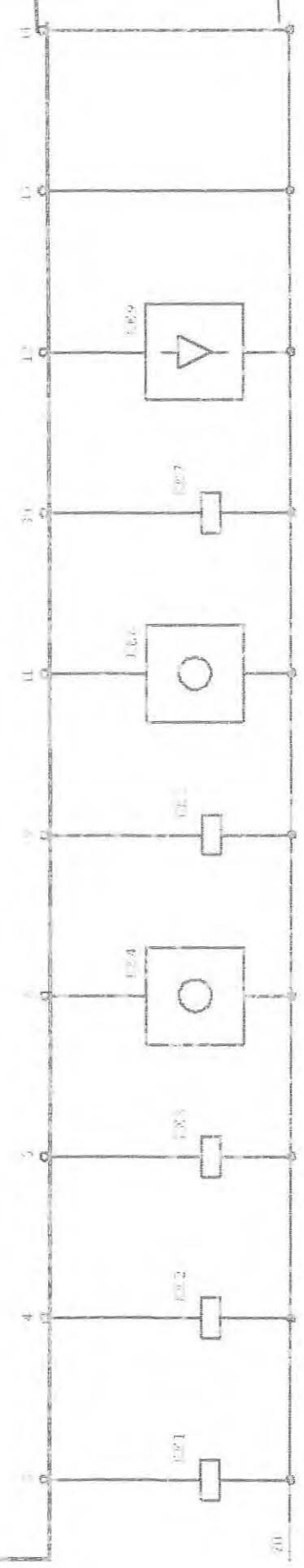


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XS 6

PLC



ME1	ME2	ME3	ME4	ME5	ME6	ME7	ME8	ME9
NO	NC	NO	NO	NC	NO	NO	NO	NO
ME11	ME12	ME13	ME14	ME15	ME16	ME17	ME18	ME19
NO	NO	NO	NO	NO	NO	NO	NO	NO
ME21	ME22	ME23	ME24	ME25	ME26	ME27	ME28	ME29
NO	NO	NO	NO	NO	NO	NO	NO	NO



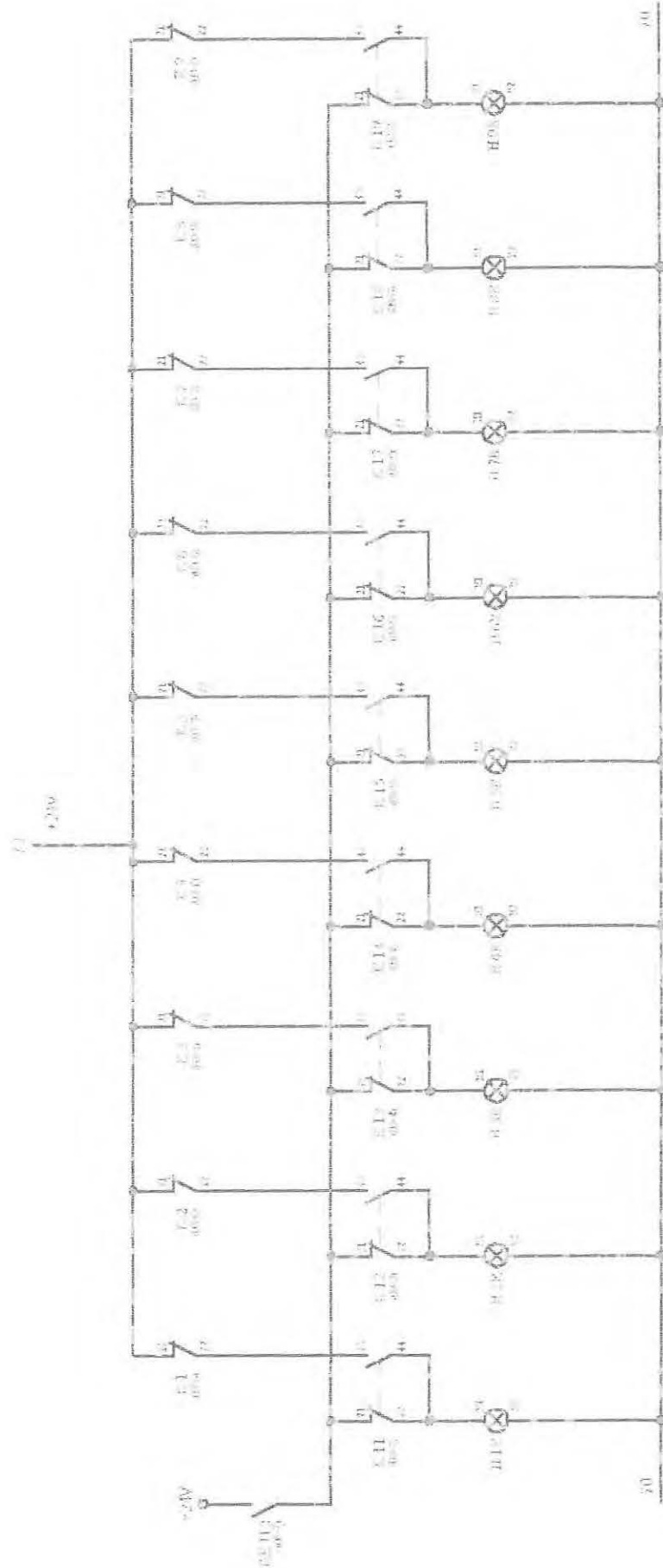
PL - 47 - 225 Kępczyńskiego-Kozła
 Ul. Szkoła 15
 40-03 077-480-40-93
 40-03 077-480-67-80
 www.nip.com.pl

TMC

HEATING CONTROL

753

1 2 3 4 5 6 7 8 9 0



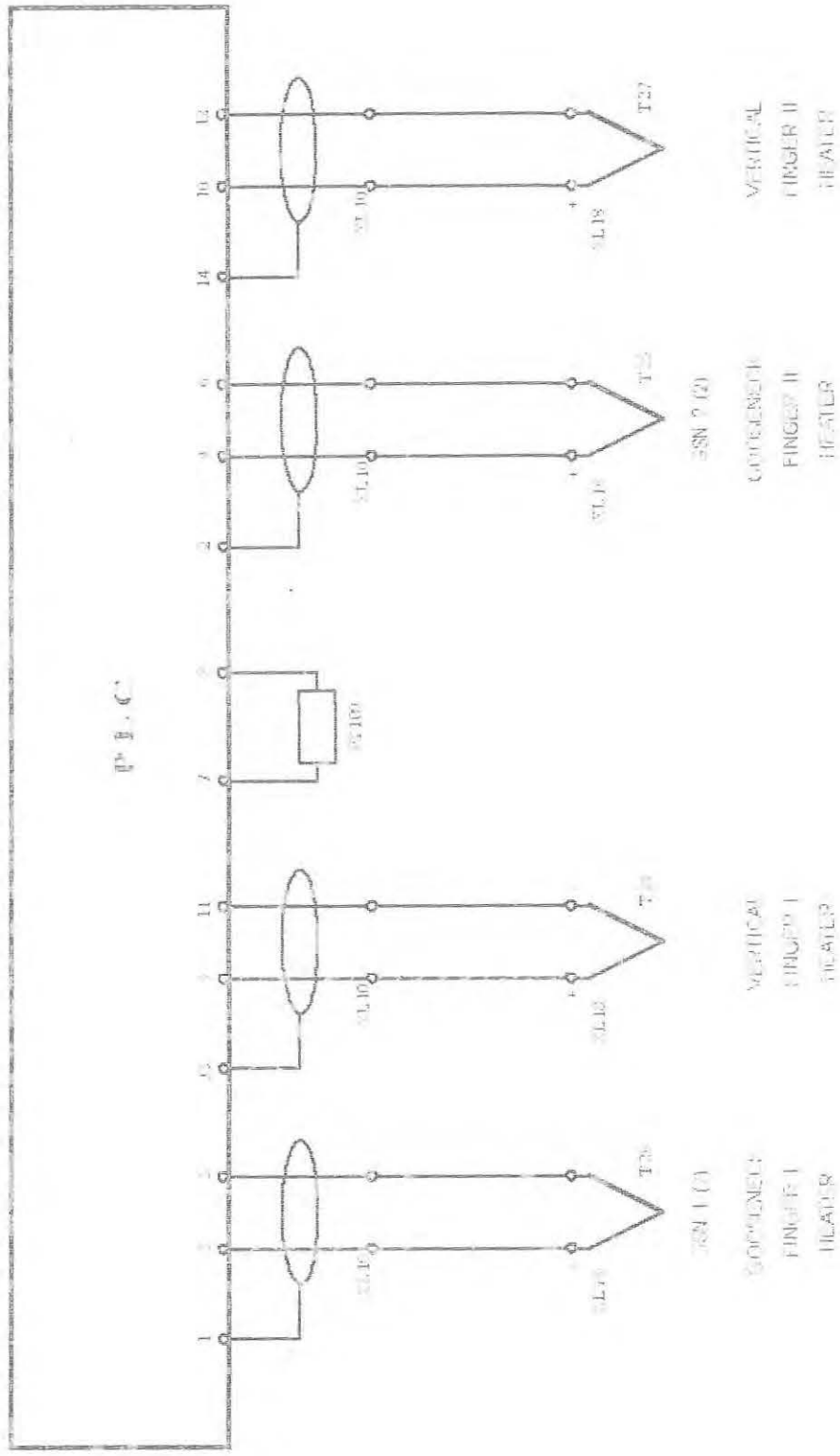
PL - 47 - 225 Kędzierzyn-Koźle
 Ul. Szkolna 15
 Tel.: +48 077 455 06 93
 Fax: +48 077 455 07 00
 www.nip.com.pl

TMG

HEATING CONTROL

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SCR
 1
 1

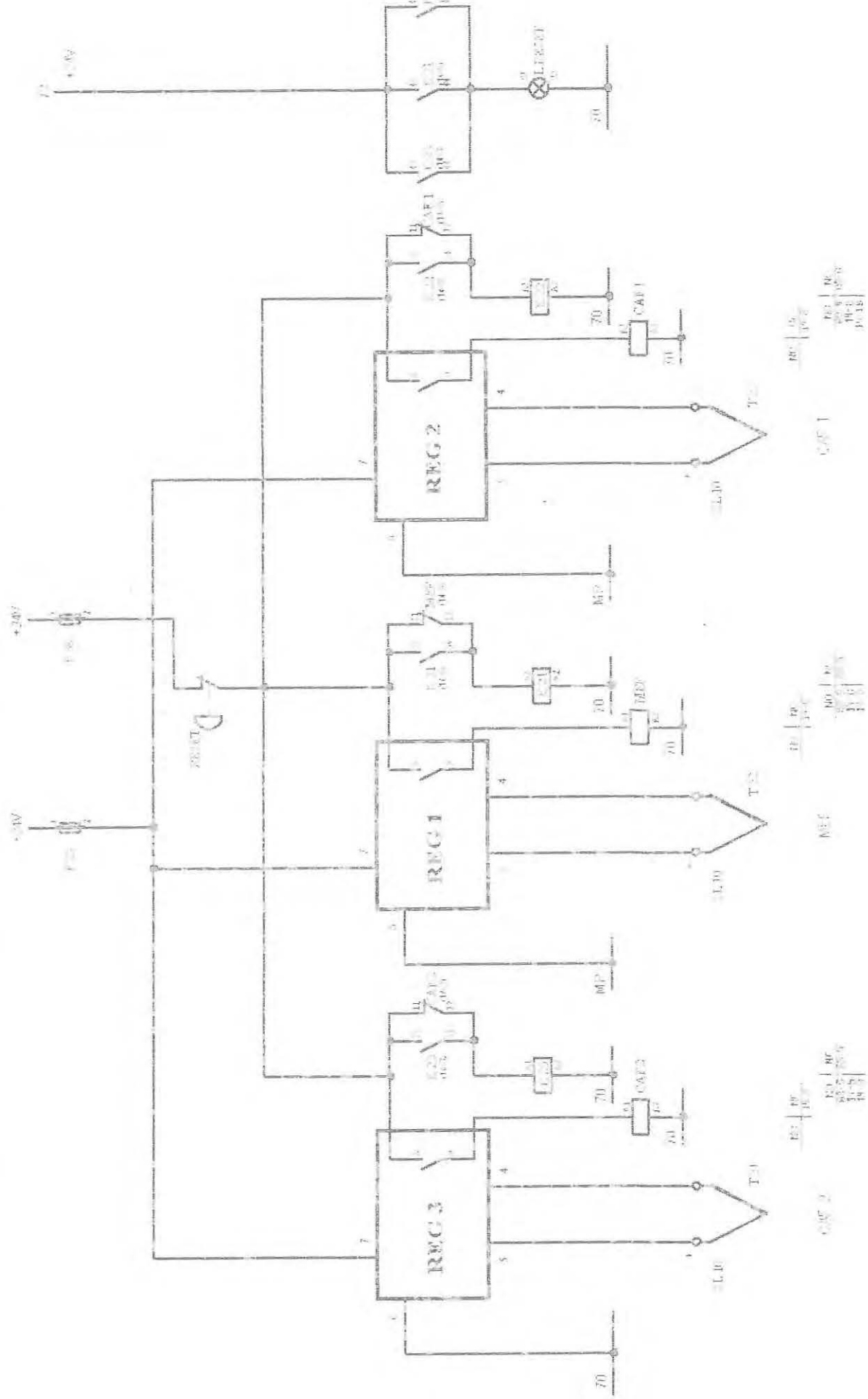


SSN 1 (1)
 GONNENEL
 FINGER I
 HEATER

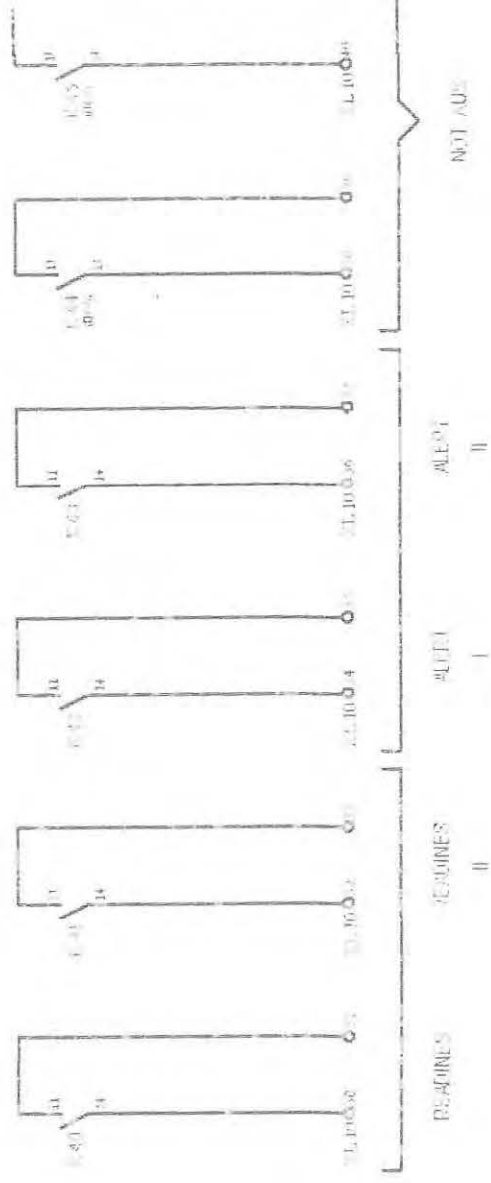
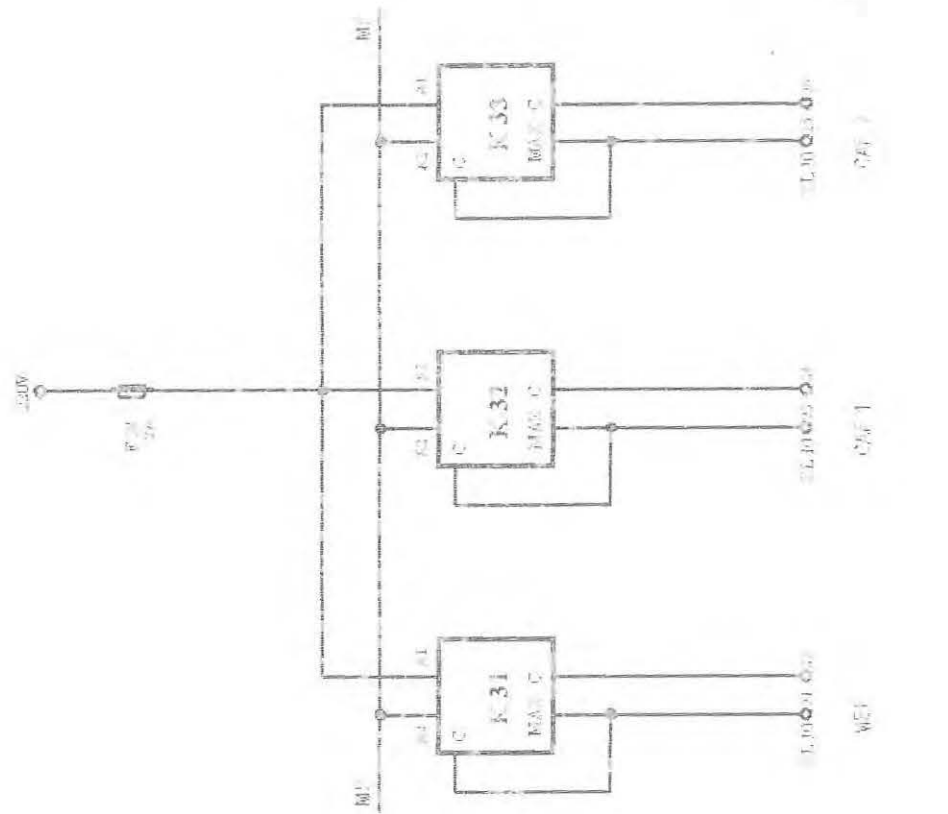
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 GONNENEL
 FINGER II
 HEATER

SSN 3 (3)
 GONNENEL
 FINGER I
 HEATER

1 2 3 4 5 6 7 8 9 10 11 12



1	2	3	4	5	6	7	8	9
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NET ADE

ALERT II

ALERT I

RESUMES II

RESUMES

SCHEMATA
SYMBOLE
1

HEATING CONTROL

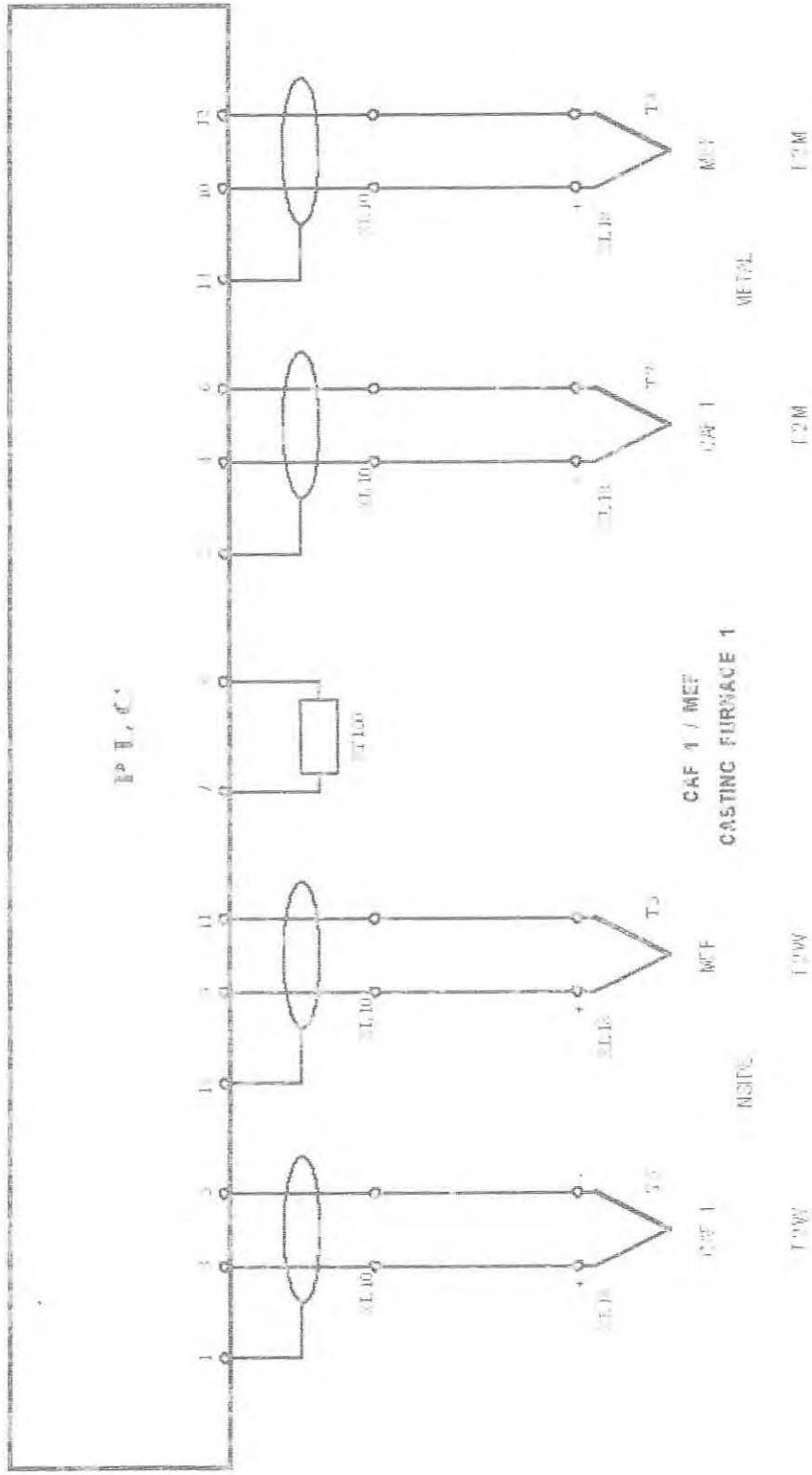
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fax: +48 677 450 67 08
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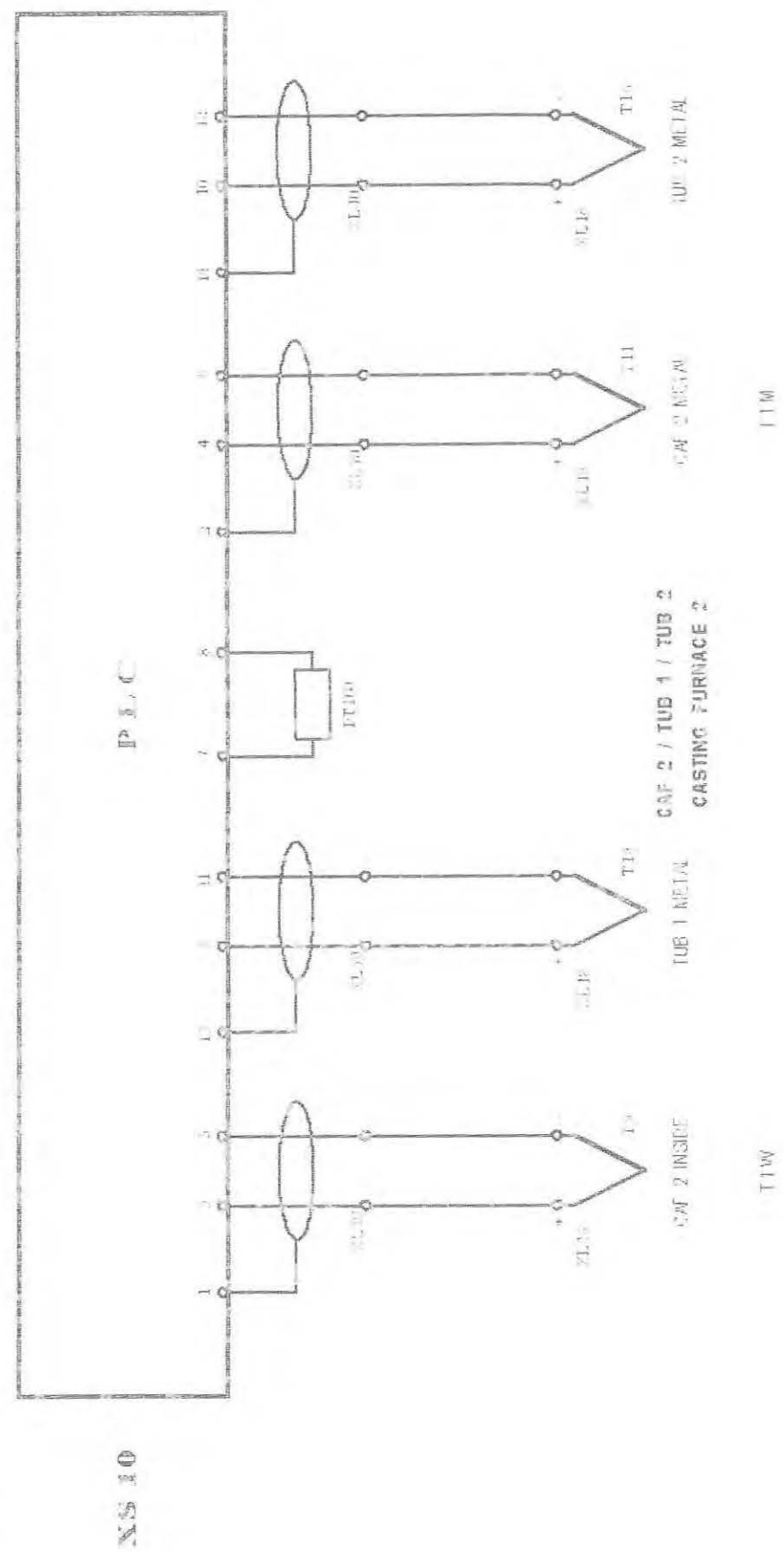
PL-47 - 225 Kędzierszyn-Kozie
 ul. Szkolna 15
 tel: +48 071 482 66 93
 fax: +48 071 482 67 08
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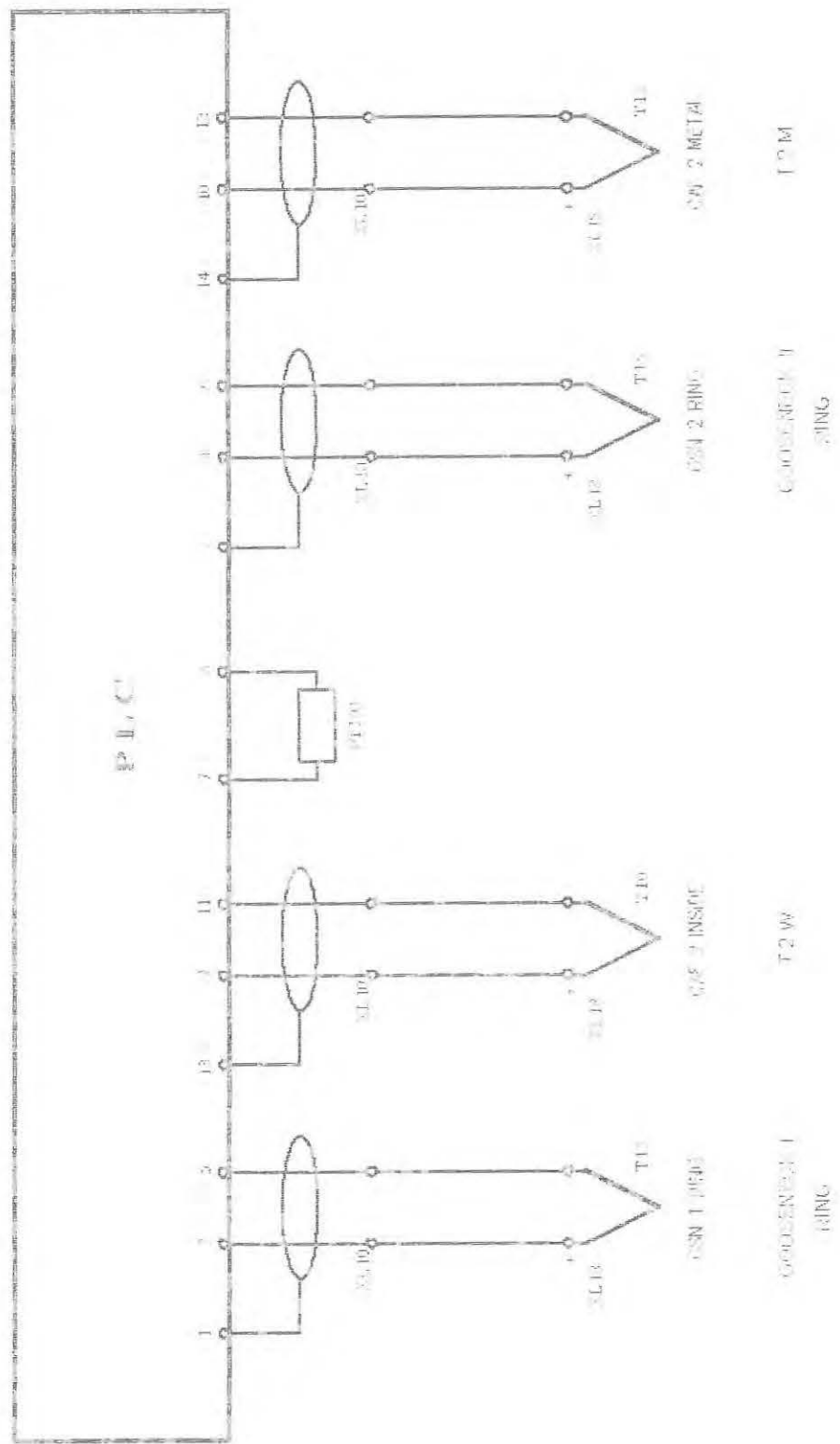
HEATING CONTROL
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SCHEMATA
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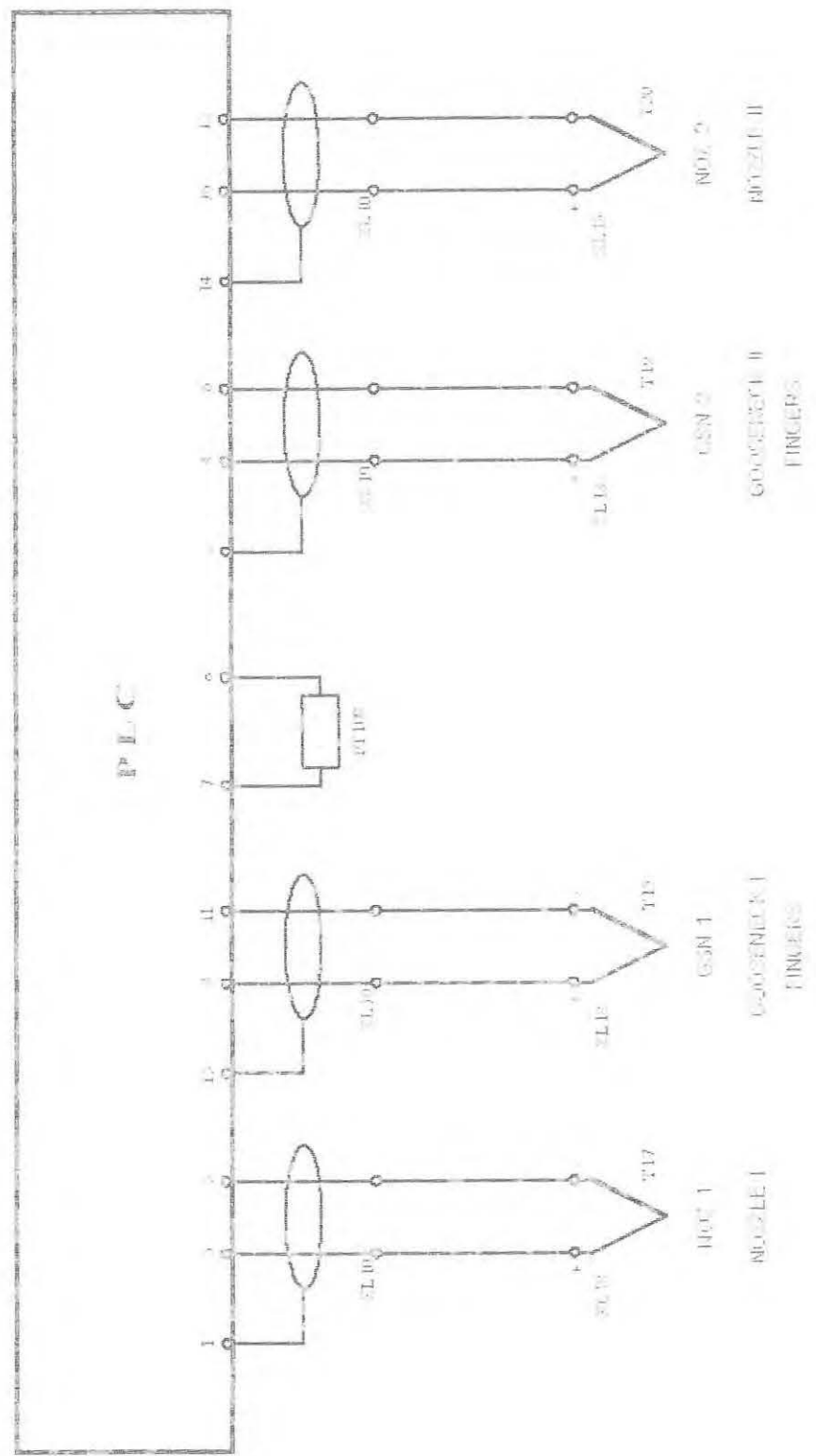
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1 2 3 4 5 6 7 8 9



1 2 3 4 5 6 7 8 9



NS 12

PLC

TV1
 TV2
 TV3
 TV4
 PI10
 TV3
 TV2
 TV1
 GSN 1
 GSN 1
 GSN 2
 GSN 2
 NOZ 1
 NOZ 2
 NOZ 1 I
 NOZ 2 I
 FINGERS
 FINGERS
 FINGERS
 FINGERS



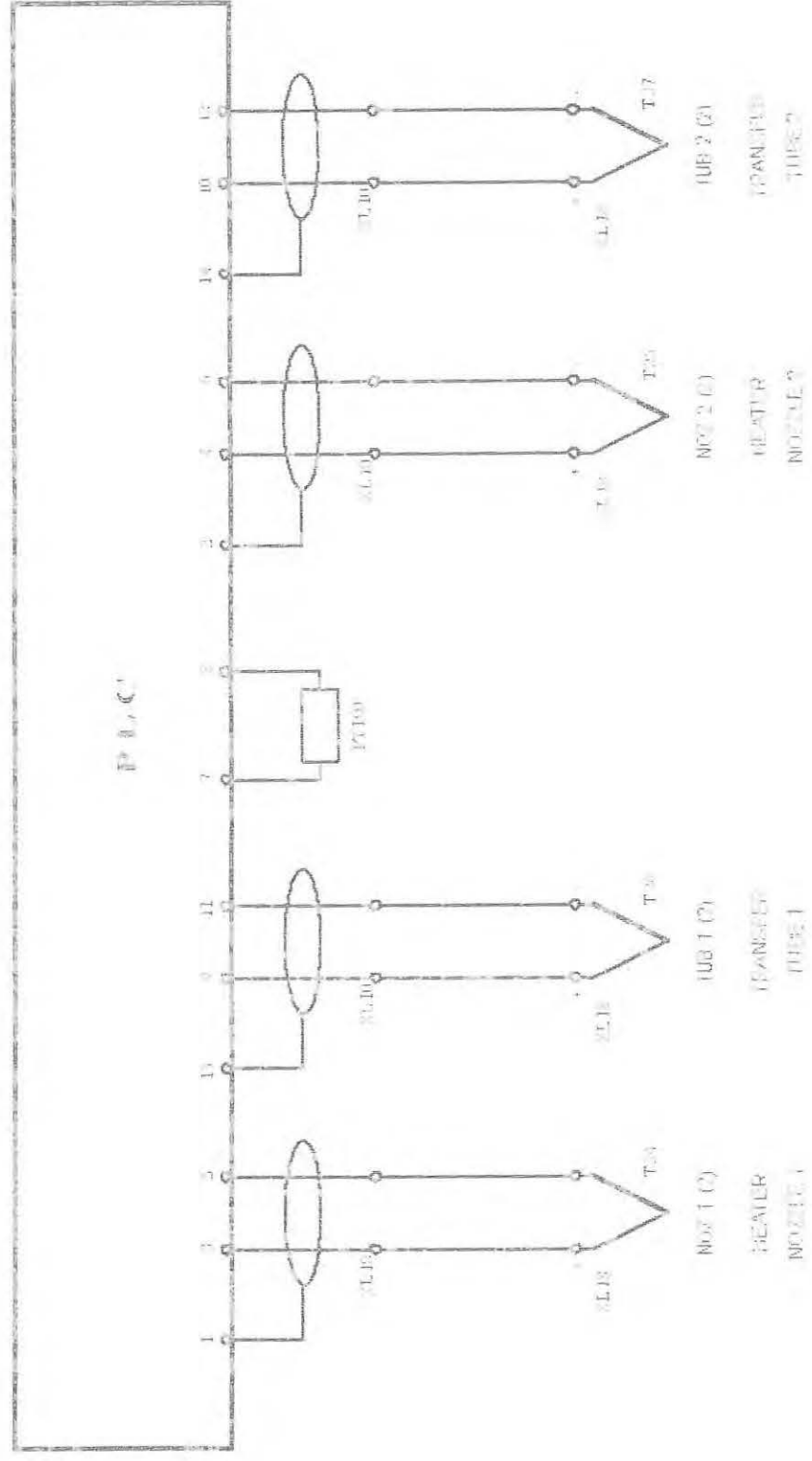
PL - 47 - 225 Mędzierzyn-Koźle
 Ul. Szkolna 15
 tel.: +48 077 448 65 93
 fax: +48 077 450 07 05
 www.nipar.com.pl

TMG

HEATING CONTROL

728

SCHEM
 2
 1



P.L.C.

NS 13

HEATING CONTROL

TMG

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Ul. Szkolna 15
tel.: +48 077 483 05 03
fax: +48 077 483 07 10
www.nip.com.pl



SECTION 13

Hydraulic diagrams

SECTION 14

Mechanical drawings

SECTION 15

Drawings of furnaces

SECTION 16

List of hydraulic parts

17. LIST OF ELECTRICAL PARTS

No.	Name	Symbol
TELEMECANIQUE		
	Relay PNOZ	XPS – AS 5140
	Relay P2HZ	XPS – BC 1110
	Limit switch	XCS-A701
	Limit switch	XCK-M
	Limit switch	XCK-J
	Drive switch	GV3ME63/40-63A
	Drive switch	GZ1-M06, GZ1-M07
	Power contactor	LP1 D6511
	Time relay	RE7YR
	Contact	LAD N31
	Contact	LA1KN22
	Contactor	LP1 K12
	Contactor	LC1 D32
	Button	XB4 BW 33 B5
	Button	XB4 BW 34 B5
	Button	XB4 BW 31 B5
	Button	XB4 BW 35 B5
	Button	XB4 BW 36 B5
	Button	ZB4 BA 2
	Button	ZB4 BC 2
	Button	ZB4 BC 5
	Key switch I-II	ZB4 BG 4
	Key switch I-II-III	ZB4 BC O
	Button I-O-II	ZB4 BJ 5
	Button I-O-II	ZB4 BJ 3
	NOT AUS	ZB4 BS 55
MOELLER		
	Main switch (100A 3-phase)	P3-100/EA/SVB
	Emergency stop switch	RPV
	Button	RLTR-GN-S
	Lamp	RLF-RT
	Button	RLT-GN
	Button	RLT-RT
SIEMENS		
	Limit switch	3SE3 120 –1D
	PLC Controller S7-300	S7-316 2DP
	Digital input	SM 321 DI
	Digital output	SM322 DO
	Analog module	SM 335 AI4/AO4
	Analog module	SM 331
	Door module	3TK 2806-0BB4

	Power supply 24VDC/20A	6EP1436-2BA00
MERLIN GERIN		
	Fuse	C60N1PC6
	Fuse	C60N1PC20
	Fuse	C60N1PC63
FINDER		
	LED module	99.80.9.024.99
	Relay 4P 24VDC 5A	55.34.9.024.0040
	Relay 2P 24VDC 5A	40.52.9.024.0000
	Electronical relay	34.51.7.024.0010
	Relay socket	93.01.7.024
WIELAND BAMBERG		
	Relay WRS-SSDC-60V3A	80.020.2003.0
HARTING		
	Plug 72 pin	09160723001
	Plug casing 72 pin	09300160541
	Socket 72 pin	09160723101
	Socket casing 72 pin	09300160306
	Plug 42 pin	09160423001
	Plug casing 42 pin	09300100543
	Socket 42 pin	09160423101
	Socket casing 42 pin	09300100303
	Plug 24 pin	09160243001
	Plug casing 24 pin	09300060543
	Socket 24 pin	09160243101
	Socket casing 24 pin	09300060302
	Socket 6/12 pin	09380182601
	Plug 6/12 pin	09380182701
	Socket 6 pin	09330062616
	Casing 6pin	09330062716
	Socket 10 pin	09330102616
	Plug 10 pin	09330102716
SAREL		
	Control cabinet	2000x800x600
	Thermostat (BLUE)	
WERMA		
	Signalling device	WERMA-SIGNALTECHNIK
BALLUFF		
	Measurement device – die stroke	BTL 5 A11-M 0600-P-S32 Out 0+10V
	Measurement device – nozzle stroke	BTL 5 A11-M 0500-P-S32 Out 0+10V
	Measurement device – ejector stroke	BTL 5 A11-M 0150-P-S32 Out 0+10V
	Magnet	BTL 5F-2814-1S
	Plug	BKS-33M-00
	Limit switch	BNS 516-360-S4-C

RELECO		
	Relay IR-C DC24V + podstawa	C10-A10X
BERNSTEIN COMPACT		
	Alu box	16x16x9
	Alu box	36x12x8
	Alu box	26x16x8
	Alu box	7,5x8x6
LEGRAND		
	Service socket 220VAC (16A)	
MAYSER		
	Safety module D-89073 Ulm	SG-EFS-104 ZK2/1
VOGEL		
	Pressure switch	DS-W 20-2
	Level switch	WS-32-2/150
REXROTH		
U8	Control card	VSPA1-1-11C
U9	Control card	VT 3000-36a
PARKER		
U10	Control card	ET 00-104-10
CZAKI		
	Przetwornik temperatury	TCD-3000 „J”
Others		
	Power supply CS224/90-264 XAS02VH [24VDC/2,5A]	CABUR
	Industrial PC Computer PowerPAC 140526002 P/No. 2-A09F-2001	Kontron
	Rack – System Module E128-210/PSC2/E124-714	MOOG
	Electrical drive R17FDT71D8/2/BMG/HR 440V/60Hz/0,06&0,25kW	SEW Eurodrive

BRIOKS NF 46/2180/G

SLOW BURNING HYDRAULIC FLUID TYPE HFC

- Is a slow burning hydraulic – lubricating fluid, produced in ICSO Chemical Production, in co-operation with company INSPEC – The GREAT BRITAIN, sold up to now under the name: BREOX NF 46/2180/ICSO.
As the quality is concerned, it complies with the best reputed product of class HFC VI of generation, used on European markets.
- Is a water – glycol fluid, containing all line of improvers and lubricating and anti-wear additives. It does not contain the nitrite corrosion inhibitors.
- Belongs to non toxic products and is a little harmful for natural environment. It has long life, very good anti-wear properties, confirmed during long usage in many coal mines and casting works. It complies with all requirements, contained in VI Luxembourg Report. It is allowed for use in Poland.
- Is designed for usage in hydraulic systems of machines, working in conditions of high fire danger, most of all in coal mines and casting industry. It can be used in all hydraulic devices as fluid HFC, being equivalent of the latest hydraulic fluids e.g. Ecupsol Hydrother, Houghto Safe and introduced in place of mineral oil to improve the work safety.
- Has been tested by the Chief Institute of Mining in usage tests and allowed for usage in mining GM 37/97.

SPECIFICATION

Kind of requirement	Range
Outer look	homogeneous, stable, colourless or light yellow fluid of slight blushing without mechanical impurity
Kinematic viscosity in 40 °C mm ² /s	not less than 41,5
Water contents, %	37 - 39

PACKING, STORAGE

BRIOKS NF 46/2180/G is packed in steel drums 200 l.

Storage period 12 months from production date.

ICSO Chemical Production ensures the technical consultancy, full service in the range of implementation and usage of the fluid, and methods of product quality control. ICSO Chemical Production ensures to the consignees of BRIOKS NF 46/2180/G the co-operation in the range of water-glycol economy of hydraulic fluids, by offering reliable methods of utilisation. BRIOKS NF 46/2180/G is sold in barrels 200 l.

Identifications data;

Machine type	Hot chamber die casting machine
Machine model no.	QDCM 400 Standard
Machine serial no.	2003/M-S400/08-01
Order no.	776
Control	SIEMENS S7-316
Clamping force	4000 kN
Power supply	3 x 440V, 60 Hz
Year	2005
Customer	IML Ltd.

Producer

Firm	Nowoczesne Technologie Produkcji Sp. z o.o.
Street	ul. Szkolna 15
Place	47-225 Kędzierzyn-Koźle
Telephone	0048 77/ 4886593
Fax	0048 77/ 4886784

REASON OF THIS DOCUMENT;

This available operational manual advises the user of an HOT CHAMBER DIE CASTING MACHINE of the following

- mode of operation
- operation
- safety instructions
- servicing.

SAFE KEEPING;

The operational manual is to be kept near the machine and it must be available at all times.

**WARNING****USER OPINION;**

Dear Reader,
Periodically our Operational Manuals are brought up to date.
With your suggestions of improvement you will help us to improve our Operational Manual.
Please let us have your information in writing, by fax or give us a call under the numbers below.

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Nowoczesne Technologie Produkcji Sp. z o.o., ul. Szkolna 15
47-225 Kędzierzyn-Koźle, Poland
Phone: 0048 77/ 488 65 93 Fax: 0048 77/ 488 67 84

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