

**1.5
ELECTRICAL
CONNECTION****1****1.5.1
MAINS CONNECTION**

Connection of the machine is to be carried out according to the VDE Regulations or according to the specifications of the local Electricity Board.

The machine is equipped with a PEN-terminal for the connection to a TN-C mains (4 wire system).

If the machine is connected to a TN-S mains (5 wire system) the bridge between the N-terminal strip and the PE-terminal has definitely to be removed.

The machine must be connected for clockwise rotary field.

Only peripheral units can be operated by the machine, which comply with the VDE Regulations for the suppression of interference by electrical operating material and plants.

The determination of the cable cross sections and the main fuses is to be effected in compliance with the specifications on the cover sheet of the mains connection diagrams (see service manual - part 1).

Remark: The values indicated in chapter 1.5.3 only apply to standard machines. In case of additional power consumers (mould heating, sockets, etc) the cross sections and the pre-fuse must be dimensioned correspondingly!

The connection points for mains connection via the main switch .1-Q1 and the position of the PE-N bridge are indicated in the "Arrangement plan of the electric cabinet" and on page 1 of group 1.

Motor, heating and control are fused separately in the electric cabinet. Consult table 1.5.4. for the size of the fuses. The main switch .1-Q1 stops the entire machine.

Please refer to service manual, part 1 (Electric/Electronics) for the detailed mains connection diagrams.

Note: mains supply adaption

The factory-made connection of the control transformers is designed for 400 volt. If the mains supply deviates from this voltage, the primary configuration of the control transformers has to be altered correspondingly.