COMPLEX SOLUTIONS MADE SIMPLE



DEEP SEA ELECTRONICS PLC **DSE704 AUTOSTART CONTROL MODULE OPERATING MANUAL**



DSE Model 704 Control System Operators Manual

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DESCRIPTION OF OPERATION 1

MANUAL MODE OPERATION

To initiate a start sequence in MANUAL, press the pushbutton, and the start sequence is initiated.

NOTE:- There is no Start Delay in this mode of operation.

If the pre-heat output option is selected this timer is then initiated, and the auxiliary output selected is energised.

After the above delay the Fuel Solenoid is energised, then the Starter Motor is engaged.

The engine is cranked for a 10 second period. If the engine fails to fire during this cranking attempt then the starter motor is disengaged for a 10 second period. Should this sequence continue

beyond the 3 starting attempts, the start sequence will be terminated and Fail to Start will be illuminated.

When the engine fires, the starter motor is disengaged and locked out at 20 Hz measured from the Alternator output. Rising oil pressure can also be used to disconnect the starter motor, however it cannot be used for underspeed or overspeed detection.

After the starter motor has disengaged, the Safety On timer is activated (which is fixed at 12 seconds), allowing Oil Pressure, High Engine Temperature, Under-speed, Charge Fail and any delayed Auxiliary fault inputs to stabilise without triggering the fault.

Once the engine is running, the Warm Up timer, if selected, is initiated, allowing the engine to stabilise before it can be loaded.

The generator will run off load, unless the mains supply fails or a Remote Start on load signal is applied, at which point the load will be transferred to the generator.

The generator will continue to run On load regardless of the state of the mains supply or remote start input until the Auto mode is selected.

If Auto mode is selected, and the mains supply is healthy with the remote start on load signal not active, then the Remote Stop Delay Timer begins, after which, the load is disconnected. The generator will then run off load allowing the engine a cooling down period.

Selecting **STOP** de-energises the **FUEL SOLENOID**, bringing the generator to a stop.

NOTE:- The safety on time (used for delayed alarms) is pre set to 12 seconds and can not be changed.

1.2 AUTOMATIC MODE OF OPERATION

This mode is activated by pressing the pushbutton. An LED indicator beside the button confirms this action.

Whether the start sequence is initiated by mains (utility) failure or by remote start input, the following sequence is followed:

To allow for short term mains supply transient conditions or false remote start signals, the Start Delay timer is initiated. After this delay, if the pre-heat output option is selected then the pre-heat timer is initiated, and the corresponding auxiliary output (if configured) will energise.

NOTE:- If the mains supply returns within limits, (or the Remote Start signal is removed if the start sequence was initiated by remote start) during the Start Delay timer, the unit will return to a stand-by state.

After the above delays the **Fuel Solenoid** is energised, then one second later, the **Starter Motor** is engaged.

The engine is cranked for a 10 second period. If the engine fails to fire during this cranking attempt then the starter motor is disengaged for a 10 second rest period. Should this sequence continue beyond the 3 starting attempts, the start sequence will be terminated and

Fail to Start • ____ fault will be illuminated.

When the engine fires, the starter motor is disengaged and locked out at 20 Hz measured from the Alternator output. Rising oil pressure can also be used to disconnect the starter motor, however it cannot be used for underspeed or overspeed detection.

After the starter motor has disengaged, the **Safety On** timer is activated, allowing Oil Pressure, High Engine Temperature, Under-speed, Charge Fail and any delayed Auxiliary fault inputs to stabilise without triggering the fault.

Once the engine is running, the **Warm Up** timer, if selected is initiated, allowing the engine to stabilise before accepting the load.

If the remote start is being used and has been configured to **Remote start is on load**, or the mains has failed, the load will be transferred to the generator.

On the return of the mains supply, (or removal of the **Remote Start** signal if the set was started by remote signal), the **Stop** delay timer is initiated. Once it has timed out, the load is transferred back to the mains (utility). The **Cooling** timer is then initiated, allowing the engine a cooling down period off load before shutting down. Once the **Cooling** timer expires the **Fuel Solenoid** is de-energised, bringing the generator to a stop.

If the mains should fail (or a **Remote Start** signal is re-activated) whilst the generator is **Cooling** down, the load will be immediately transferred to the generator.

Should the mains supply fall outside limits again (or the **Remote Start** signal be re-activated) during the cooling down period, the set will return on load.

NOTE:- The safety on time (used for delayed alarms) is pre set to 12 seconds and can not be changed.

1.3 WARNINGS

Warnings are used to warn the operator of an impending fault

BATTERY CHARGE FAILURE, if the module does not detect a voltage from the warning light terminal on the auxiliary charge alternator, the icon will illuminate. (Either 8 Volts or 16 Volts depending on the configuration of **Nominal DC Voltage**).

Inputs 1 and 2 can be configured as warnings or shutdowns. The relevant icon will be illuminated when the input is active

1.4 SHUTDOWNS

Shutdowns are latching and stop the Generator. The alarm must be cleared, and the fault removed to reset the module. In the event of a shutdown the appropriate icon will be illuminated

NOTE:- The alarm condition must be rectified before a reset will take place. If the alarm condition remains it will not be possible to reset the unit (The exception to this is the Low Oil Pressure alarm and similar 'delayed alarms', as the oil pressure will be low with the engine at rest). Any subsequent warnings or shutdowns that occur will be displayed steady, therefore only the first-up shutdown will appear flashing.

NOTE:- The safety on time (used for delayed alarms) is pre set to 12 seconds and can not be changed.

FAIL TO START, if the engine does not fire after the pre-set 3 attempts at starting, a shutdown will be initiated.

The icon will illuminate.

LOW OIL PRESSURE, if the module detects that the engine oil pressure has fallen below the low oil pressure switch after the **Safety On** timer has expired, a shutdown will occur.

The icon will illuminate.

HIGH ENGINE TEMPERATURE if the module detects that the engine coolant temperature has exceeded the high engine temperature switch after the **Safety On** timer has expired, a shutdown will occur.

The significant in the interest in the interes

OVERSPEED, if the engine speed exceeds the pre-set trip (14% above the nominal frequency) a shutdown is initiated. Overspeed is not delayed, it is an **immediate shutdown**.

The sicon will illuminate.

NOTE:- During the start-up sequence the overspeed trip level is extended to 24% above the normal frequency for the duration of the saftey timer to allow an extra trip level margin. This is used to prevent nuisance tripping on start-up.

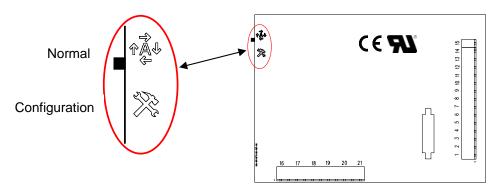
UNDERSPEED, if the engine speed falls below the pre-set trip (20% of the nominal frequency) after the **Safety On** timer has expired, a shutdown is initiated.

The icon will illuminate.

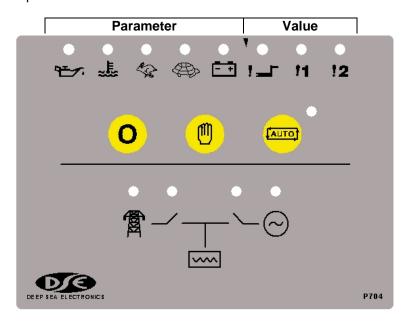
Inputs 1 and 2 can be configured as warnings or shutdowns. The relevant icon will be illuminated when the input is active

2 CONFIGURATION INSTRUCTIONS

♦ With the unit in **Stop** mode, **Configuration Mode** is selected by operation of a small switch on the rear, left-hand edge of the PCB. This is partially hidden to prevent accidental operation.



- Once Configuration Mode is selected, the 'Auto' LED will commence rapid flashing, and all normal operation is suspended.
- The **Stop** pushbutton can be used to select the LED 'code' that corresponds to the required function. The 5 left-hand LED's will form the code. See configuration table over leaf.
- ◆ The **Manual** pushbutton will allow the user to change the associated value. The 3 right-hand LED's inform the user of the current setting for the chosen function. See configuration table over leaf.
- When the required parameters are displayed, pressing the **Auto** button will save the new setting, and the process is repeated for each function change.
- ♦ When configuration is complete, the **Configuration Mode** Selector Switch should be returned to the 'Normal' position.



3 CONFIGURATION TABLES

		F	UNCTIC	NS AND	CONF	IGURATIO	ON TABLE			
Function	٠.	*F	₹	(- +	<u> </u>	! 1	! 2	Value (Default in Bold	
re-heat Timer	0	0	0	0	•	0	0	0	0 Seconds	
						0	0	•	5 Seconds	
						0	•	0	10 Seconds	
						0	•	•	15 Seconds	
						•	0	0	20 Seconds	
						•	0	•	30 Seconds	
						•	•	0	60 Seconds	
						•	•	•	180 Seconds	
Jsed to pre-heat the e	engine p	rior to cr	anking.	The out	out is ac	tive for the	duration	of the set	ting, prior to cranking.	
			<u> </u>						<u> </u>	
start Delay	0	0	0		0	0	0	0	0 Seconds	
nan Bolay				_		0	0	•	5 Seconds	
						0	•	0	10 Seconds	
						0	•	•	15 Seconds	
						•	0	0	20 Seconds	
							0	•	30 Seconds	
							•	0	60 Seconds	
	<u> </u>						<i>i</i> ::	•	180 Seconds	
lsed to give a delay b	etween	activatin	ig the re	mote sta	art input,	or a main	is failure, a	and actua	lly starting the engine.	
			1				ī			
top Delay	0	0	0	•	•	0	0	0	0 Seconds	
lains Return Delay						0	0	•	5 Seconds	
						0	•	0	10 Seconds	
						0	•	•	15 Seconds	
						•	0	0	20 Seconds	
						•	0	•	30 Seconds	
						•	•	0	60 Seconds	
						•	•	•	180 Seconds	
nergise to Stop lold Timer	0			0	0	0	0	•	0 Seconds 5 Seconds	
							0	•	0	10 Seconds
								0	•	•
						•	0	0	20 Seconds	
						•	0	•	30 Seconds	
						•	•	0	60 Seconds	
						•	•	•	180 Seconds	
Ised for the control	of the e	naine st	op sole	noid. W	hen the	engine is	to be sto	opped, th	e Energise To Stop outp	
ecomes active, closi	ng the s	stop sole	noid (fu	el valve)). When	the engin	e comes	to rest, th	ne stop solenoid will rema	
nergised for the perio	o or the	Energis	e 10 St	p rimei	, to ensi	are the en	gine nas o	come to a	complete stop.	
Jorna un Tima									O Cooseeds	
Varm-up Timer	0	0		0		0	0	0	0 Seconds	
						0	0	•	5 Seconds	
						0	•	0	10 Seconds 15 Seconds	
						0				
							0	0	20 Seconds	
							0	0	30 Seconds 60 Seconds	
	gine be	ng custil	able for	100 57	1 tha =1=	ourc of the	o general	or load a	180 Seconds	
valari batiria an tha an										
	before				0	0	0	0	0 Seconds	
or the engine to warn		0	_	_				•		
or the engine to warn	o before	0	•			\cap	()		5 Seconde	
or the engine to warn		0				0	0		5 Seconds	
or the engine to warn		0				0	•	0	10 Seconds	
Delay between the en or the engine to warm Cooling Timer		0	•				•	0	10 Seconds 15 Seconds	
or the engine to warn		0	•			0	•	0	10 Seconds 15 Seconds 20 Seconds	
or the engine to warn		0	•			0	•	0	10 Seconds 15 Seconds 20 Seconds 30 Seconds	
or the engine to warn		0	•			0	•	0	10 Seconds 15 Seconds 20 Seconds	

FUNCTIONS AND CONFIGURATION TABLE										
97		&	(2)	<u></u>	!	! 1	! 2	Value (Default in Bold)		
0	•	Õ	0	0	0	0	0	50 Hz (O/S +14% / Overshoot +24%)		
					0	0	•	60 Hz (O/S +14% / Overshoot +24%)		
The systems nominal frequency. Either 50 Hz or 60 Hz										
0	•	0	0	•	0	0	0	12V DC (CF 8V)		
					·	_	•	24V DC (CF 16V)		
oltage.	Either 1	2 Volts	or 24 Vo	lts. It is	used for th	ne charge	alternato	r failure level.		
0	•	0	•	0	0	0	0	Close on Fault		
					0	0	•	Open on Fault		
Configuration for the oil pressure switch. Either to close to battery negative on a fault, or open on a fault.										
0	•	0) •	•	0	0	0	Close on Fault		
					0	0	•	Open on Fault		
olant te	mperatu	re switc	ch. Eithe	r to clos	e to batter	y negative	on a fau	lt, or open on a fault.		
0	•	•	0	0	0	0	0	Disabled		
					0	0	•	Enabled (2 Second Delay)		
arter mo						•		tects oil pressure.		
		s. due t	o the dif	terent m	onitoring p	points on I	ubrication	systems.		
for all ge	enerator	-,								
	enerator				0		0	Disabled		
for all ge	enerator	•	0	•	0	0	0	Disabled		
0	•	•	_	•	0	0	•	Enabled (U/S -20%)		
0	•	•	_	• if the fre	0	0	•			
0	•	•	_	if the fre	0	0	•	Enabled (U/S -20%)		
,	equence O oltage. O pressu O olant te	equency. Either O oltage. Either 1 O pressure switch olant temperatu	equency. Either 50 Hz oltage. Either 12 Volts opressure switch. Either olant temperature switch	equency. Either 50 Hz or 60 Hz oltage. Either 12 Volts or 24 Vo pressure switch. Either to close olant temperature switch. Either	equency. Either 50 Hz or 60 Hz O O O O O O O O O O O O O O O O O O O	equency. Either 50 Hz or 60 Hz O O O O O O O O O O O O O O O O O O O	equency. Either 50 Hz or 60 Hz O O O O O O O O O O O O O O O O O O O	equency. Either 50 Hz or 60 Hz O O O O O O O O O O O O O O O O O O O		

Simulated mains - If the input is active the generator will not start in the event of a mains failure. E.G. if the generator is supporting a non 24 hour operation, a 24 hour timer can be used to prevent a mains failure from starting the generator and taking load.

Remote start on load (ignore if simulated	0	•	•	•	•	0	0	0	Remote start is off load
mains)						0	0	•	Remote start is on load

- The remote start input can be configured to one of the following.

 Remote start is off load The generator will start and run off load when the remote start input is active.
- Remote start is on load The generator will start, and the load transferred to the generator when the remote start is active.

	FUNCTIONS AND CONFIGURATION TABLE									
Function	٠٠.	~.E	\Q	(2)	- +	!	! 1	! 2	Value (Default in Bold)	
Auxiliary Input 1 Function	•	0	0	0	0	0	0	0	Immediate Warning Close on Fault	
						0	0	•	Immediate Warning Open on Fault	
						0	•	0	Immediate Shutdown Close on Fault	
						0	•	•	Immediate Shutdown Open on Fault	
						•	0	0	Delayed Warning Close on Fault	
						•	0	•	Delayed Warning Open on Fault	
						•	•	0	Delayed Shutdown Close on Fault	
						•	•	•	Delayed Shutdown Open on Fault	

Programmable input, can be configured to on of the following

- ♦ Immediate warning close on fault If the input is activated at any time the unit will alarm and energise the common warning and common alarm output.
- ♦ Immediate warning open on fault If the input is deactivated at any time the unit will alarm and energise the common warning and common alarm output.
- Immediate shutdown close on fault If the input is activated at any time the generator will be shutdown and energise the common warning and common shutdown output. The generator can not be started.
- ♦ Immediate shutdown open on fault If the input is deactivated at any time the generator will be shutdown and energise the common warning and common shutdown output. The generator can not be started.
- Delayed warning close on fault If the input is activated and the saftey time has elapsed the unit will alarm and energise the common warning and common alarm output.
- Delayed warning open on fault If the input is deactivated and the saftey time has elapsed the unit will alarm and energise the common warning and common alarm output.
- Delayed shutdown close on fault If the input is activated and the saftey time has elapsed the generator will be shutdown and energise the common warning and common shutdown output.
- Delayed shutdown open on fault If the input is deactivated and the saftey time has elapsed the generator will be shutdown and energise the common warning and common shutdown output.

Auxiliary Input 2 Function	•	0	0	0	•	0	0	0	Immediate Warning Close on Fault
						0	0	•	Immediate Warning Open on Fault
						0	•	0	Immediate Shutdown Close on Fault
						0	•	•	Immediate Shutdown Open on Fault
						•	0	0	Delayed Warning Close on Fault
						•	0	•	Delayed Warning Open on Fault
						•	•	0	Delayed Shutdown Close on Fault
						•	•	•	Delayed Shutdown Open on Fault

Programmable input, can be configured to on of the following

- Immediate warning close on fault If the input is activated at any time the unit will alarm and energise the common warning and common alarm output.
- Immediate warning open on fault If the input is deactivated at any time the unit will alarm and energise the common warning and common alarm output.
- ♦ Immediate shutdown close on fault If the input is activated at any time the generator will be shutdown and energise the common warning and common shutdown output. The generator can not be started.
- ♦ Immediate shutdown open on fault If the input is deactivated at any time the generator will be shutdown and energise the common warning and common shutdown output. The generator can not be started.
- Delayed warning close on fault If the input is activated and the saftey time has elapsed the unit will alarm and energise the common warning and common alarm output.
- Delayed warning open on fault If the input is deactivated and the saftey time has elapsed the unit will alarm and energise the common warning and common alarm output.
- ♦ Delayed shutdown close on fault If the input is activated and the saftey time has elapsed the generator will be shutdown and energise the common warning and common shutdown output.
- ♦ Delayed shutdown open on fault If the input is deactivated and the saftey time has elapsed the generator will be shutdown and energise the common warning and common shutdown output.

	FUNCTIONS AND CONFIGURATION TABLE									
Function	۲٠٠		₹	(2)	- +	!	! 1	! 2	Value (Default in Bold)	
Auxiliary Output 1	•	0	0	•	0	0	0	0	Not used	
Function						0	0	•	Pre-heat	
						0	•	0	Engine Running	
						0	•	•	Common Warning	
						•	0	0	Common Shutdown	
						•	0	•	System in Auto	
						•	•	0	Common Alarm	
						•	•	•	Energise to Stop	

Programmable output can be configured to one of the following.

- Pre-heat. The output is energised for the period of pre-heat time prior to cranking, and between the cranking attempts.
- Engine Running. The output is active after the saftey timer has elapsed.
- Common warning. The output is active if there are any warning alarm active.
- Common shutdown The output is active if there are any shutdown alarms active.
- System in auto. The output is active when the system is in automatic mode.
- Common Alarm. The output is active if there is any alarm condition.
- Energise to stop. The output is energised when the engine is required to stop (normal or fault conditions), and
 will remain energised for the period of the Energise To Stop Timer, to ensure the engine has come to a complete
 stop.

Auxiliary Output 2	•	0	0	•	•	0	0	0	Not used
Function						0	0	•	Pre-heat
						0	•	0	Engine Running
						0	•	•	Common Warning
						•	0	0	Common Shutdown
						•	0	•	System in Auto
						•	•	0	Common Alarm
						•	•	•	Energise to Stop

Programmable output can be configured to one of the following.

- Pre-heat. The output is energised for the period of pre-heat time prior to cranking, and between the cranking attempts.
- Engine Running. The output is active after the saftey timer has elapsed.
- Common warning. The output is active if there are any warning alarm active.
- Common shutdown The output is active if there are any shutdown alarms active.
- System in auto. The output is active when the system is in automatic mode.
- Common Alarm. The output is active if there is any alarm condition.
- Energise to stop. The output is energised when the engine is required to stop (normal or fault conditions), and will remain energised for the period of the Energise To Stop Timer, to ensure the engine has come to a complete stop.

Mains Under	•	0	•	0	0	0	0	0	60V / 70V
Voltage						0	0	•	70V / 80V
(Trip / Return)						0	•	0	80V / 90V
						0	•	•	90V / 100V
						•	0	0	120V / 140V
						•	0	•	140V / 160V
						•	•	0	160V / 180V
						•	•	•	180V /200V

If for example 180/200 is selected the generator will be started and the load transferred if any phase falls below 180V with respect to the neutral for the duration of the delay start timer. The load will be transferred back to mains when the mains voltage returns to 200V or higher for the duration of the mains return timer. (The system must be in Auto)

4 TERMINAL DESCRIPTION

PIN No	DESCRIPTION	CABLE SIZE	NOTES
1	DC Plant Supply Input (-ve)	1.0mm	Connected to plant battery negative
2	DC Plant Supply Input	1.0mm	Connected to plant battery positive
	(+ve)		(Recommended Fuse 2A)
3	Fuel relay Output	1.0mm	Used to operate the fuel relay.
4	Start relay Output	1.0mm	Used to operate the cranking relay.
5	Auxiliary Output relay 1	1.0mm	Configurable output.
6	Auxiliary Output relay 2	1.0mm	Configurable output.
7	Charge Fail Input/ Excitation	1.0mm	Must NOT be connected to plant supply
	Output		negative if not used.
8	Low Oil Pressure Input	0.5mm	Switch to negative.
9	High Engine Temp Input	0.5mm	Switch to negative.
10	Auxiliary Input 1	0.5mm	Switch to negative.
11	Auxiliary Input 2	0.5mm	Switch to negative.
12	Remote Start Input	0.5mm	Switch to negative.
13	Mains loading Relay	1.0mm	Used to close the mains
	Normally Open contact		contactor / breaker
14	Generator loading Relay	1.0mm	Used to close the generator
	Normally Open contact		contactor / breaker
15	Functional Earth	1.0mm	Connect to a good clean earth point
16	Mains L1	1.0mm	Connect to Mains L1 supply (AC)
	Voltage Monitoring Input		(Recommend 2A Fuse Max.)
17	Mains L2	1.0mm	Connect to Mains L1 supply (AC)
	Voltage Monitoring Input		(Recommend 2A Fuse Max.)
18	Mains L3	1.0mm	Connect to Mains L1 supply (AC)
	Voltage Monitoring Input		(Recommend 2A Fuse Max.)
19	Mains N	1.0mm	Connect to Mains N supply (AC)
	Voltage Monitoring Input		
20	Alternator Input L1	1.0mm	Do not connect if not used. (2A Fuse)
21	Alternator Input N	1.0mm	Do not connect if not used.

NOTE:- For single phase mains monitoring the neutral should be connected to terminal 19, L1 should be connected to terminals 16,17 and 18.

NOTE:- For two phase mains monitoring the L2 should be connected to terminal 19, L1 should be connected to terminals 16,17 and 18. The voltage between the two phases must not exceed 305 Volts.

NOTE:- All the outputs are solid state, rated at 1.2 Amps 8 Volts to 35 Volts DC, and switch to battery negative when active.

5 SPECIFICATION

DC Supply: 8 Volts to 35 Volts DC Continuous.

Cranking Dropouts: Able to survive 0 Volts for 50 mS, providing supply was at

least 10 V before dropout and supply recovers to 5 Volts. This is achieved without the need for internal batteries.

Max. Current: Operating 50mA Standby 10mA

Alternator Input Range: 75 Volts (ph-N) to 277 Volts (ph-N) AC (+20%)

Mains Input Voltage 15 – 277 Volts (ph-N) AC (+20%) Alternator Input Frequency: 50 - 60 Hz at rated engine speed

(Minimum: 75V AC Ph-N)

(Crank Disconnect from 15V Ph-N @ 20Hz)

Overspeed +14% (+24% overshoot)

Underspeed -20%

Mains Frequency 50 - 60 Hz

Start Output: 1.2 Amp DC at supply voltage.
Fuel Output: 1.2 Amp DC at supply voltage.
Auxiliary Outputs: 1.2 Amp DC at supply voltage.
Dimensions: 125mm x 165mm x 28 mm

Charge Fail: 12 Volts = 8 Volts CF 24 Volts = 16 Volts CF

Operating Temperature Range: -30°C to + 70°C

Applicable Standards Compliant with BS EN 60950 Low Voltage Directive

Compliant with BS EN 50081-2: 1992 EMC Directive Compliant with BS EN 61000-6-4: 2000 EMC Directive

C € Compliance to European Legislation

Registered Component for USA & Canada

Deep Sea Electronics plc reserve the right to change specification without notice.

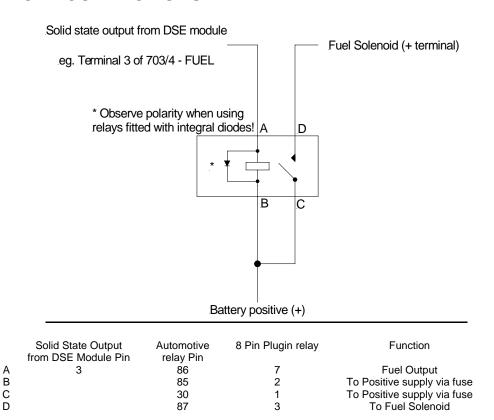
SOLID STATE OUTPUTS

DSE's utilisation of Solid State Outputs gives many advantages, the main points being:

- No Moving Parts
- Fully Overload / Short Circuit Protected.
- Smaller dimensions hence lighter, thinner and cheaper than conventional relays.
- Less power required making them far more reliable.

The main difference from conventional outputs is that solid state outputs switch to negative (-ve) when active. This type of output is normally used with an automotive or plug in relay.

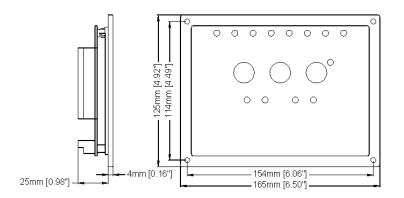
TYPICAL CONNECTIONS



Example of relay pins connected to DSE solid state output to drive a fuel solenoid. See overleaf for overall typical wiring diagram

NOTE:- The Close Mains Relay should be NORMALLY CLOSED when de-energised for fail safe reasons. Should the DC supply fail the mains will always be available. The output from the DSE solid state output when energised will OPEN the relay therefore isolating the mains supply.

7 DIMENSIONS



Dimensions:

165mm x 125mm x 29mm (6.5" x 4.9" x 1.2")

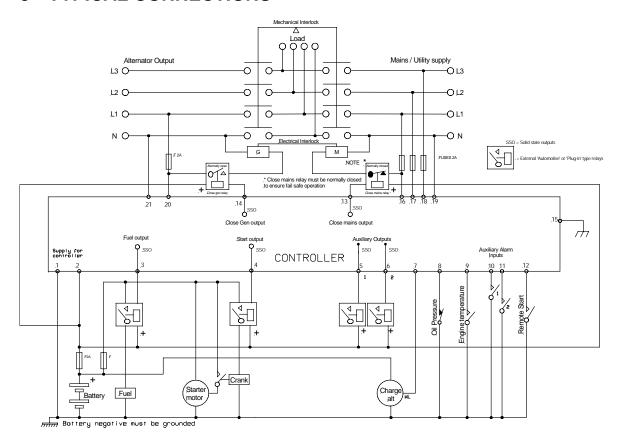
Panel cutout:

149mm x 109mm (5.9" x 4.3")

Mounting Method:

4 x 4.2mm diameter holes suitable for M4 screws

8 TYPICAL CONNECTIONS



Terminals suitable for 22-16 awg (0.6mm²-1.3mm²) field wiring Tightening Torque = 0.8N-m (7lb-in)