

# Mold Wiring Systems



## Typical Installation Instructions

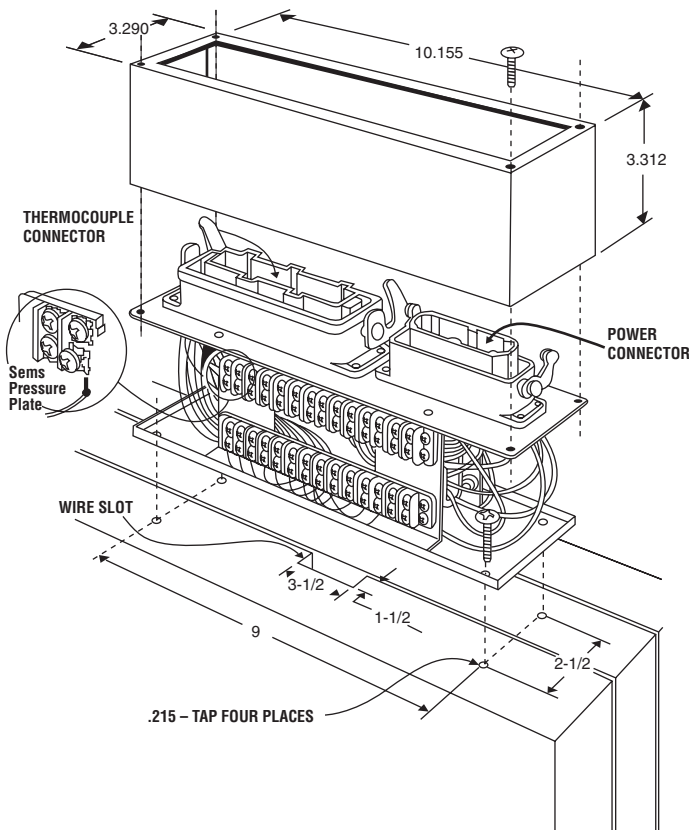
Your Mold Wiring System or Connectors may or may not look exactly like the illustration. The installation principles are however the same for all Athena Mold Wiring Systems.

### Mold Mounting Suggestions

Provide clearance for water inlets and eye bolts.

The Mold Wiring System can be mounted:

- ▲ Directly on the mold plates
- ▲ On an insulation plate
- ▲ On spacers to provide additional clearance



### NOTE!

Mold Wiring System **MUST** be grounded to mold to ensure operator safety. A ground wire is included for your convenience.

### Wiring Suggestions

We have found these methods to greatly simplify the wiring of our Mold Wiring Systems:

- ▲ Lay the box on its side with only one set of terminal blocks facing you. It doesn't matter which side you wire first.
- ▲ Feed the wires through the opening between the two terminal blocks.
- ▲ Cut off excess wire. **Keep no more than 1-1/2 - 2"**
- ▲ Slide wire under the pressure SEMS plate described below.
- ▲ Lay the system over on the other side and repeat these steps.

1. The terminal blocks are completely prewired to both the Power and Thermocouple Connectors.
2. Terminal blocks are numbered by **MOLD ZONE** for ease of installation and troubleshooting.
3. Feed the wires from the mold wire slot through the opening(s) in the bottom of the Mold Wiring System. Slide the mold wires under the SEMS pressure plate on the appropriate zone-numbered terminal.
4. The **RED** and **WHITE** wires are the **THERMOCOUPLE SIDE**. Install thermocouple wire from the mold. +(White/upper) -(Red/lower) to the corresponding zone number on the upper and lower terminal blocks.
5. Install the **POWER** wires on the opposite two terminal blocks marked Power side to corresponding number on the terminal blocks, one to upper and one to lower.
6. Place the cover over the Mold Wiring System and tighten with the four screws supplied.

As shown in the illustration, the terminal blocks are provided with SEMS pressure screws (with square, captive compression plates) that ensure tight, secure connections by simply inserting the wires under the plate and tightening the screws with either a Phillips or standard slotted screwdriver.

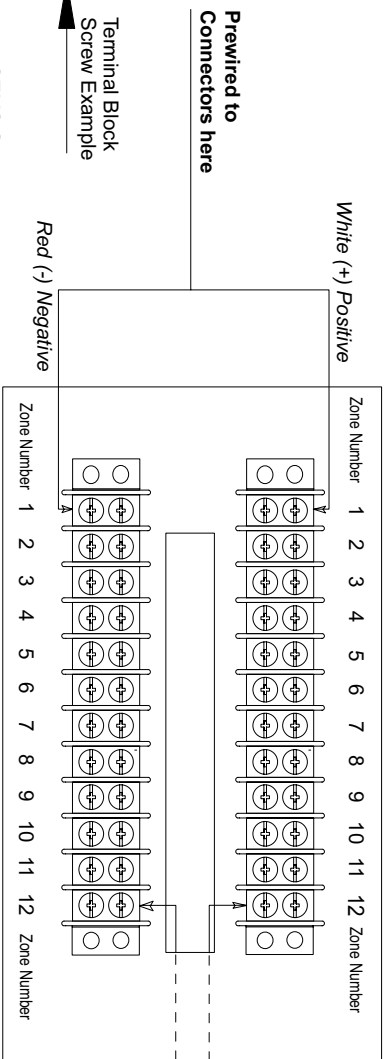
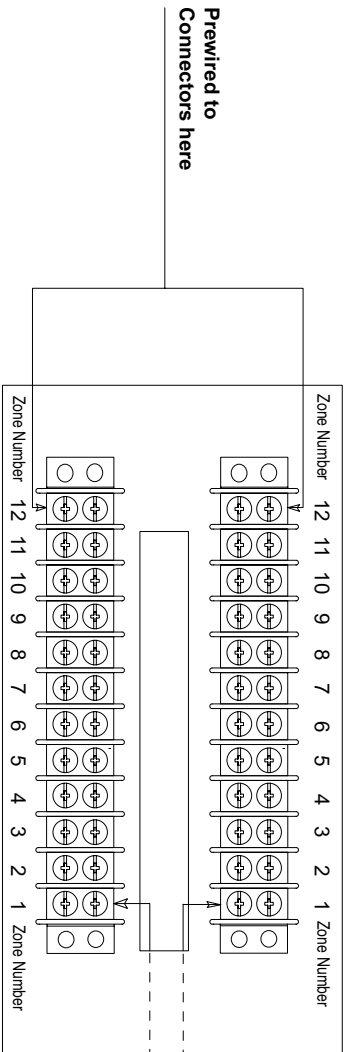


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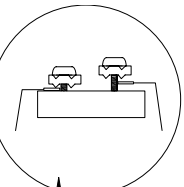


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# 12-Zone Terminal Block Wiring Layout Zones 1-12



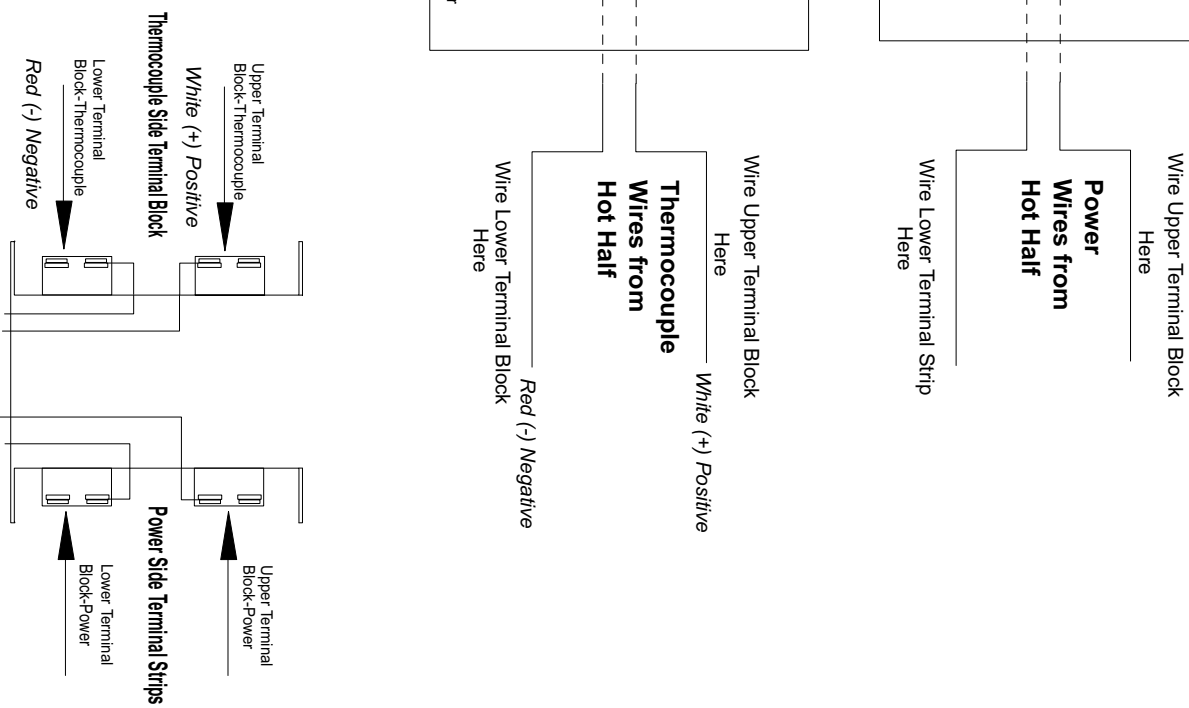
## Thermocouple Side



Note: Pressure Plates on SEMS Screws are captive and move out when screw is loosened.  
 Simply slide the wire under the plate and re-tighten the screw. NO CRIMPING or FERRULES required. Do NOT tighten on insulation.

Terminal Block		Terminal Block
Upper	Lower	
1	1	Zone #1
2	2	Zone #2
3	3	Zone #3
4	4	Zone #4
5	5	Zone #5
6	6	Zone #6
7	7	Zone #7
8	8	Zone #8
9	9	Zone #9
10	10	Zone #10
11	11	Zone #11
12	12	Zone #12

Terminal Block		Terminal Block
Upper	Lower	
+ White	- Red	
1	1	Zone #1 T/C
2	2	Zone #2 T/C
3	3	Zone #3 T/C
4	4	Zone #4 T/C
5	5	Zone #5 T/C
6	6	Zone #6 T/C
7	7	Zone #7 T/C
8	8	Zone #8 T/C
9	9	Zone #9 T/C
10	10	Zone #10 T/C
11	11	Zone #11 T/C
12	12	Zone #12 T/C



ALL wires from Hot Half enter through BOTTOM of Mold Wiring System