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This article explains the operation of the D46H-002 Combination Clutch and Motor Control found on a G.W. Bliss Punch Press. The schematic was last updated 3/31/1981(see appendix). An Excel

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based simulator has been developed that predicts relay logic outputs based on the schematic and helped in the debugging of the controller.

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In 1857, Bliss formed a partnership with John Mays. Under the name of Mays & Bliss, they engaged in the machine press and die business. In 1871, Mays sold his share of the business to Bliss' cousin, J. H. Williams. Bliss later bought Williams' interest and conducted the business by himself.

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