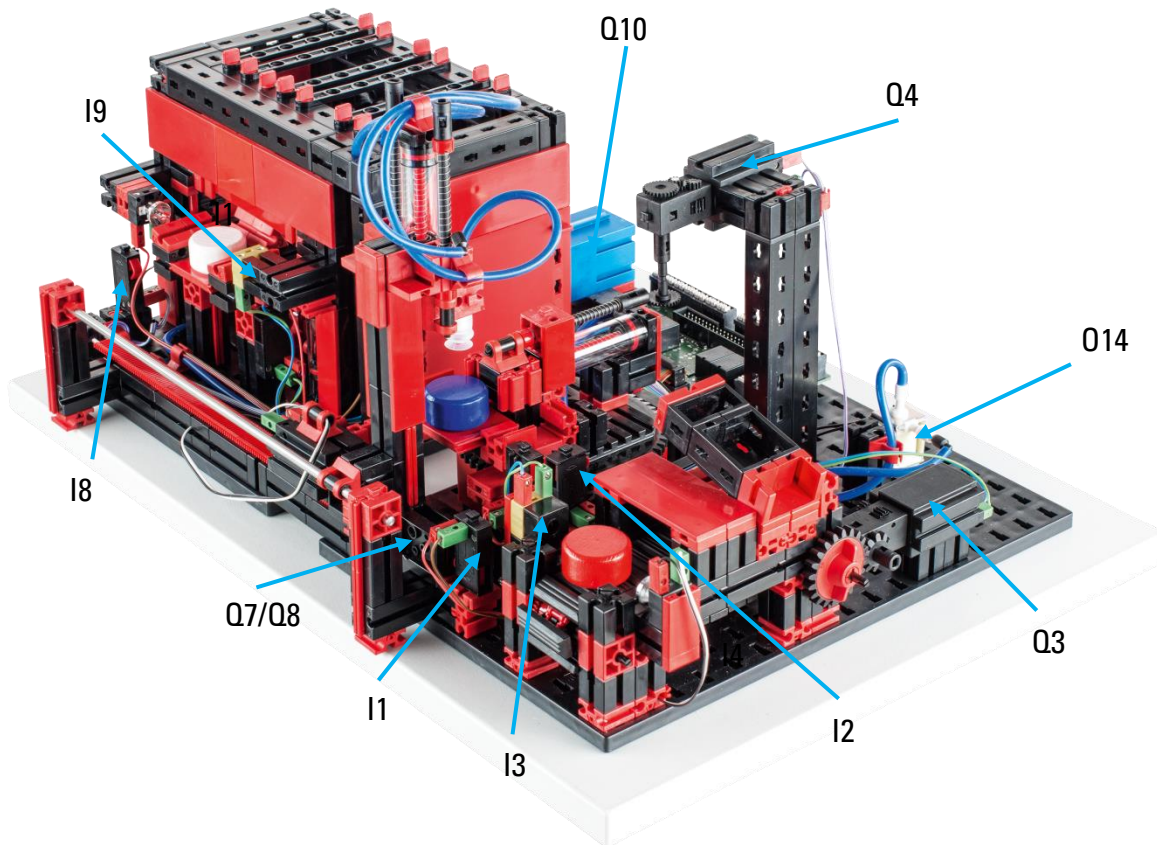


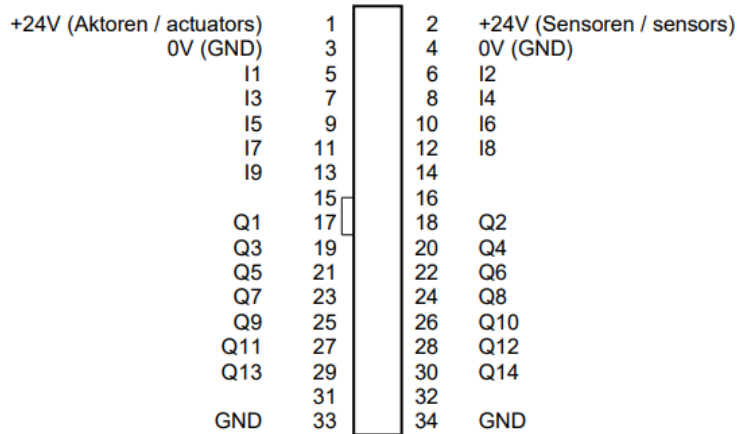
Assignment plan for the multi-processing station with kiln (MPO)



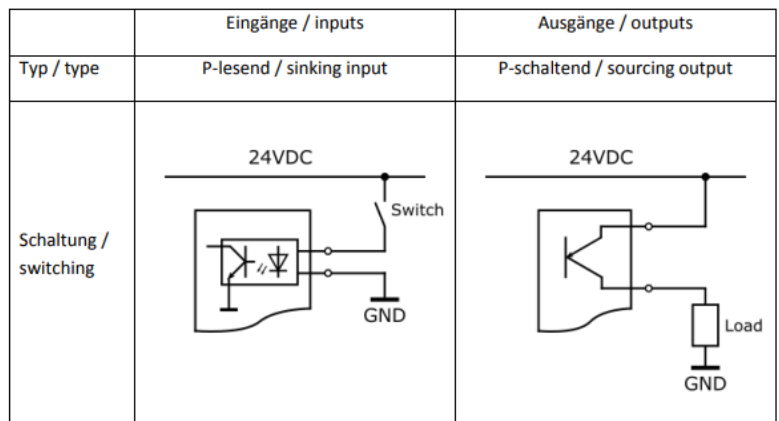
Not shown: Q1, Q2, Q5, Q6, Q9, Q11, Q12, Q13, I4, I5, I6, I7

Terminal no. (ST1)	Function	Designation
1	Power supply (+) actuators	24V DC
2	Power supply (+) sensors	24V DC
3	Power supply (-)	0V
4	Power supply (-)	0V
5	Reference switch turntable (suction position)	I1
6	Reference switch turntable (conveyor belt position)	I2
7	Light barrier end of conveyor belt	I3
8	Reference switch turntable (saw position)	I4
9	Reference switch suction (turntable position)	I5
10	Reference switch oven feeder inside	I6
11	Reference switch oven feeder outside	I7
12	Reference switch vacuum (kiln position)	I8
13	Light barrier kiln	I9
17	Turn motor turntable clockwise	Q1 (M1)
18	Turn motor slewing ring anti-clockwise	Q2 (M1)
19	Conveyor belt motor forwards	Q3 (M2)
20	Motor saw	Q4 (M3)
21	Retract oven feeder motor	Q5 (M4)
22	Extend oven feeder motor	Q6 (M4)
23	Vacuum towards oven motor	Q7 (M5)
24	Vacuum towards turntable motor	Q8 (M5)
25	Lamp kiln	Q9
26	Compressor	Q10
27	Valve vacuum	Q11
28	Valve lowering	Q12
29	Valve kiln door	Q13
30	Valve feeder	Q14
31	PWM turntable	PWM (M1)
32	PWM vacuum	PWM (M5)





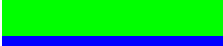













17x2 Stiftleiste / 17x2 pin header




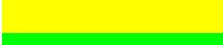

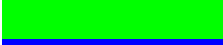

SPS Eingangs- und Ausgangskonfiguration / PLC input and output configuration



Model wiring

Terminal	Header ST1		Ribbon cable	Sensors + actuators on model
5	Turntable reference button	1		
2	24V (Sensor)	2		I1
6	Turntable reference button	3		I2
2	24V (Sensor)	4		I3
7	Light barrier end of conveyor belt	5		
2	24V (Sensor)	6		
17	Turn motor turntable clockwise	7		Q1/Q2 (M1)
18	Turn turntable anti-clockwise	8		
3.4	GND	9		
2	24V (Sensor)	10		Light barrier lamp
9	Vacuum reference button	11		I5
2	24V (Sensor)	12		
8	Turntable reference button pos. saw	13		I4
2	24V (Sensor)	14		
3.4	GND	15		Q3 (M2)
19	Conveyor belt	16		
3.4	GND	17		Q4 (M3)
20	Saw	18		
	not assigned	19		
	not assigned	20		

ST2

	not assigned	1		
	not assigned	2		
21	Retract oven feeder	3		Q5/Q6 (M4)
22	Extend oven feeder	4		
10	Oven feeder inside	5		I6
2	24V (Sensor)	6		
11	Oven feeder outside	7		I7
2	24V (Sensor)	8		
12	Vacuum on oven	9		I8
2	24V (Sensor)	10		
23	Vacuum to oven	11		Q7/Q8 (M5)
24	Vacuum to turntable	12		
3.4	GND	13		Q9 (oven light)
25	Lamp kiln	14		
3.4	GND	15		Q10 (compressor)
26	Compressor	16		
13	Oven light barrier	17		I9
2	24V (Sensor)	18		
3.4	GND	19		
2	24V (Sensor)	20		Light barrier lamp

3.4 27	Terminal V1
3.4 28	Terminal V2
3.4 29	Terminal V3
3.4 30	Terminal V4

Q11 (Valve vacuum)
Q12 (lower valve)
Q13 (oven door valve)
Q14 (feeder valve)

red = power supply
 yellow = Motor poles reversible via relay

Schlauchanschlussplan / air line layout plan

