

M/R III SUBPANEL DEFINITIONS

PLC OUTPUTS

501 MERCURY SWITCH(CUREING LAMP)
502 CUREING LAMP POWER
503 AIR JET SOLENOID
504 COATING PUMP MOTOR
505 DUMP VALVE(WASH)
506 WASH MOTOR
507 INDEX MOTOR RELAY
600 SPINDLE #1 ON/OFF RELAY
601 SPINDLE #2 ON/OFF RELAY
602 SPINDLE #3 ON/OFF RELAY
603 SPINDLE #1 SELECT RELAY
604 SPINDLE #2 SELECT RELAY
605 SPINDLE #3 SELECT RELAY
606 COAT SPIN OFF RELAY
607 HASKEL PUMP SOLENOID
700 VACUUM SOLENOID #1
701 VACUUM SOLENOID #2
702 VACUUM SOLENOID #3
703 WINDOW OPEN/CLOSE SOLENOID
704 UV LAMP SOLENOID
705 UV LAMP FWD/REV SOLENOID
706 SPINDLE UP SOLENOID
707 SPINDLE DOWN SOLENOID

PLC INPUTS

0 VACUUM SIGNAL #1
1 VACUUM SIGNAL #2
2 VACUUM SIGNAL #3
3 DOOR OPEN
4 EMPTY
5 L/R REAR DOORS
6 SPINDLE DOWN
7 INDEX POSITION
8 EMPTY
9 FOOT SWITCH
10 LIGHT CURTAIN
11 LAMP HOME
12 LAMP EXTEND
13 DOOR CLOSED
14 SPINDLE UP

RELAY LAYOUT

RELAY 1: SPINDLE #1 ON/OFF
RELAY 2: SPINDLE #2 ON/OFF
RELAY 3: SPINDLE #3 ON/OFF
RELAY 4: SPINDLE #1 SELECT
RELAY 5: SPINDLE #2 SELECT
RELAY 6: SPINDLE #3 SELECT
RELAY 7: COAT SPIN OFF
RELAY 8: LAMP START
RELAY 9: LAMP FWD/REV
RELAY 10: INDEX MOTOR
RELAY 11: LAMP POWER

CIRCUIT BREAKER LAYOUT

5AMP: LAMP MOTOR/FANS
10D AMP: LAMP
10C AMP: MACHINE