PLC

(Note 1) COM2
Y2
Y3
Y4
Y5
COM 0
X7

Bar feeder

BLK — COMMON
WHT — START RELOAD
GRN — AUTO MODE
RED — E-STOP
BRN — COLLET OPEN

COLLET PRESSURE
NOTE 2

GROUP 1

GROUP 2
BLK — END OF BAR COM
ORG/BLK — END OF BAR N/O
LOADER OK
LOADER OK
NOTE 3 — WHT/BLK — E-STOP
NOTE 3 — WHT — E-STOP
NOTE 5
NOTE 4 — GRN — SPIN. INH. COM
NOTE 4 — GRN/WHT — SPIN. INH. N/O

Notes
1. PLC's are normally shipped with all outputs commons tied together. Separate COM2 from the others.

2. Wire collet P/S so contact closes when collet is closed. Set parameter #0 to 0 on bar feeder.

3. Connect these wires to interlock terminals (remove existing jumper)

4. Break spindle OFF/AUTO wire and splice these in

PLC to barfeeder interface
4/99