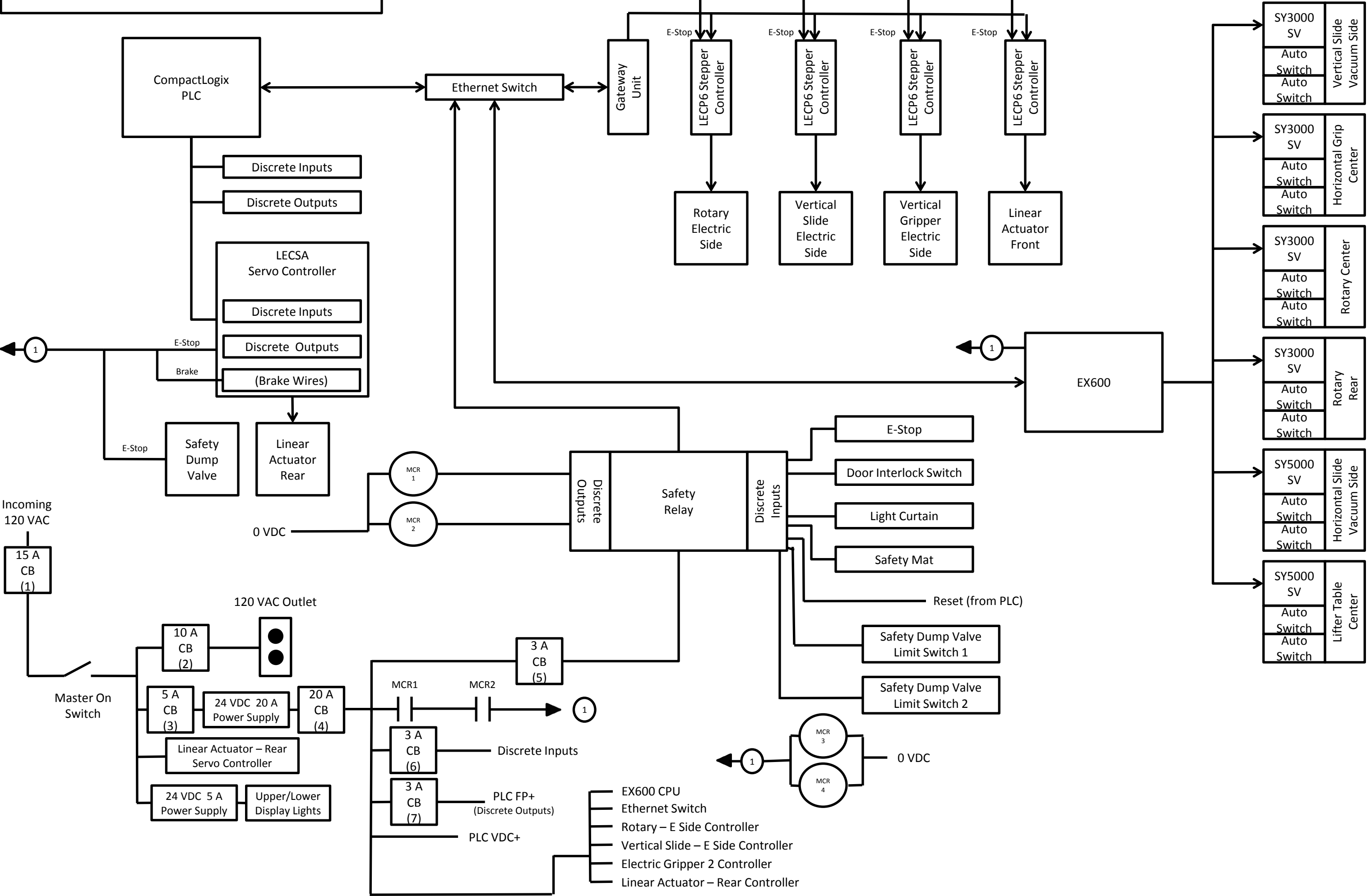
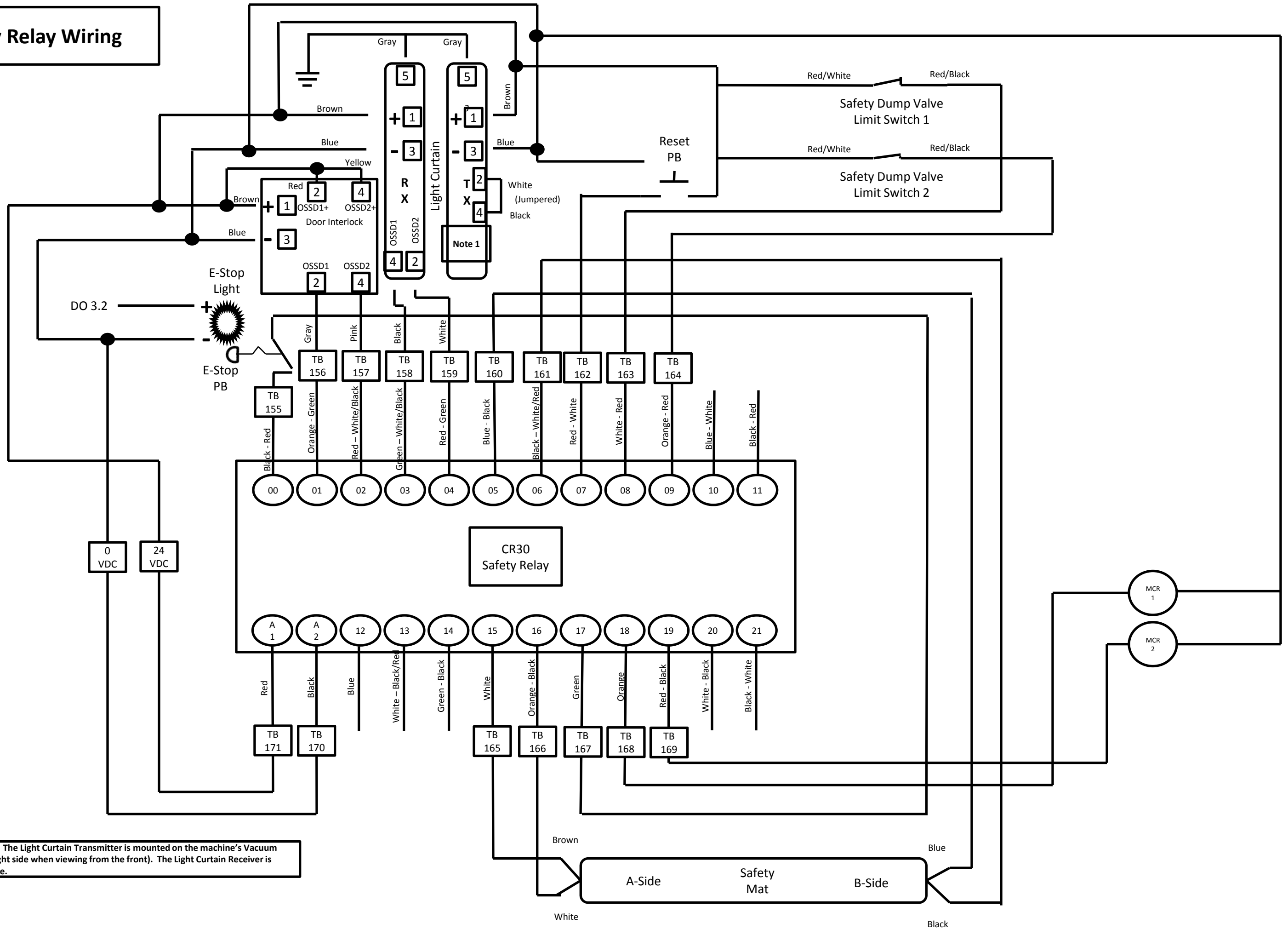


# Electrical Concept Block Diagram

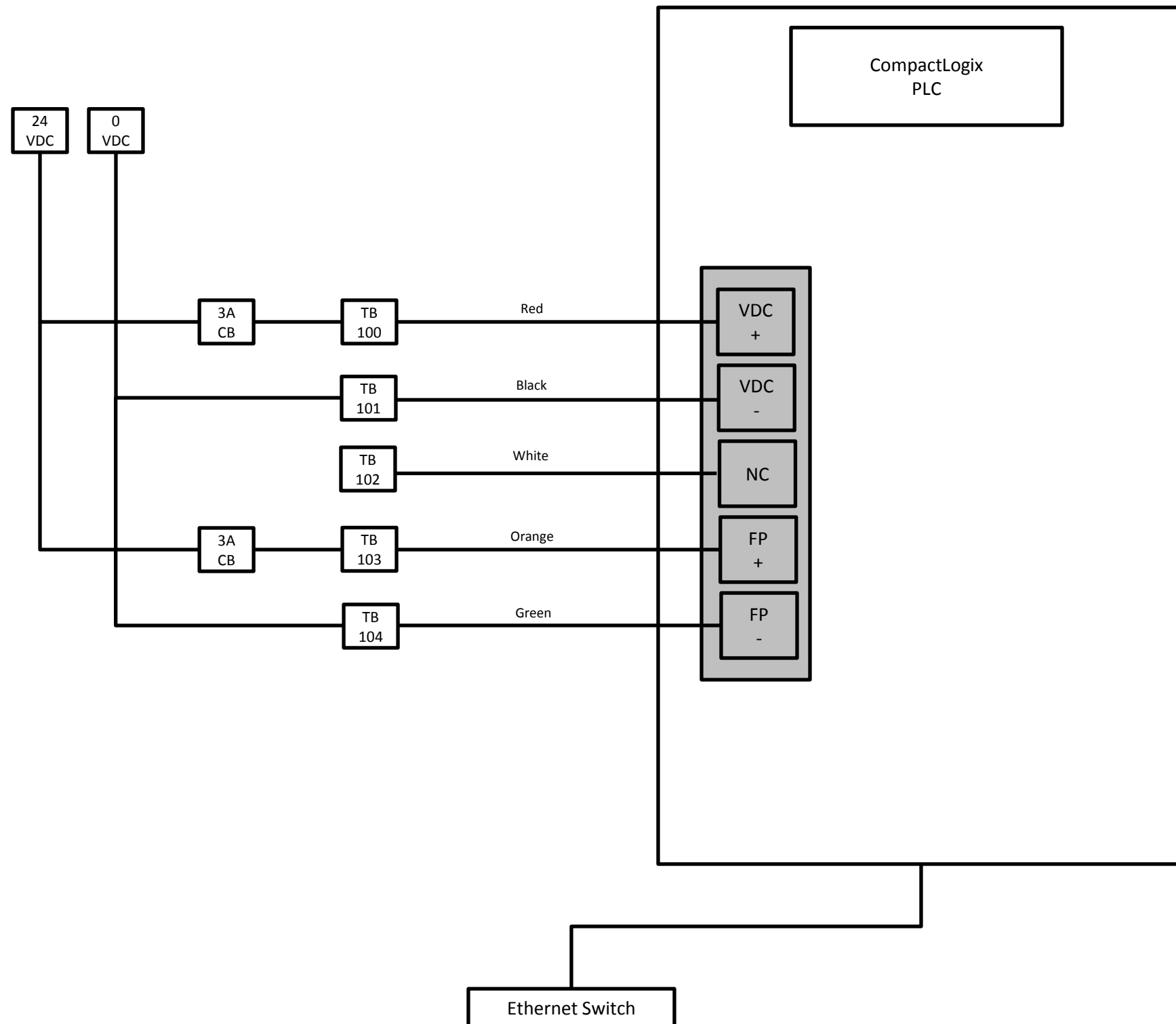


# Safety Relay Wiring

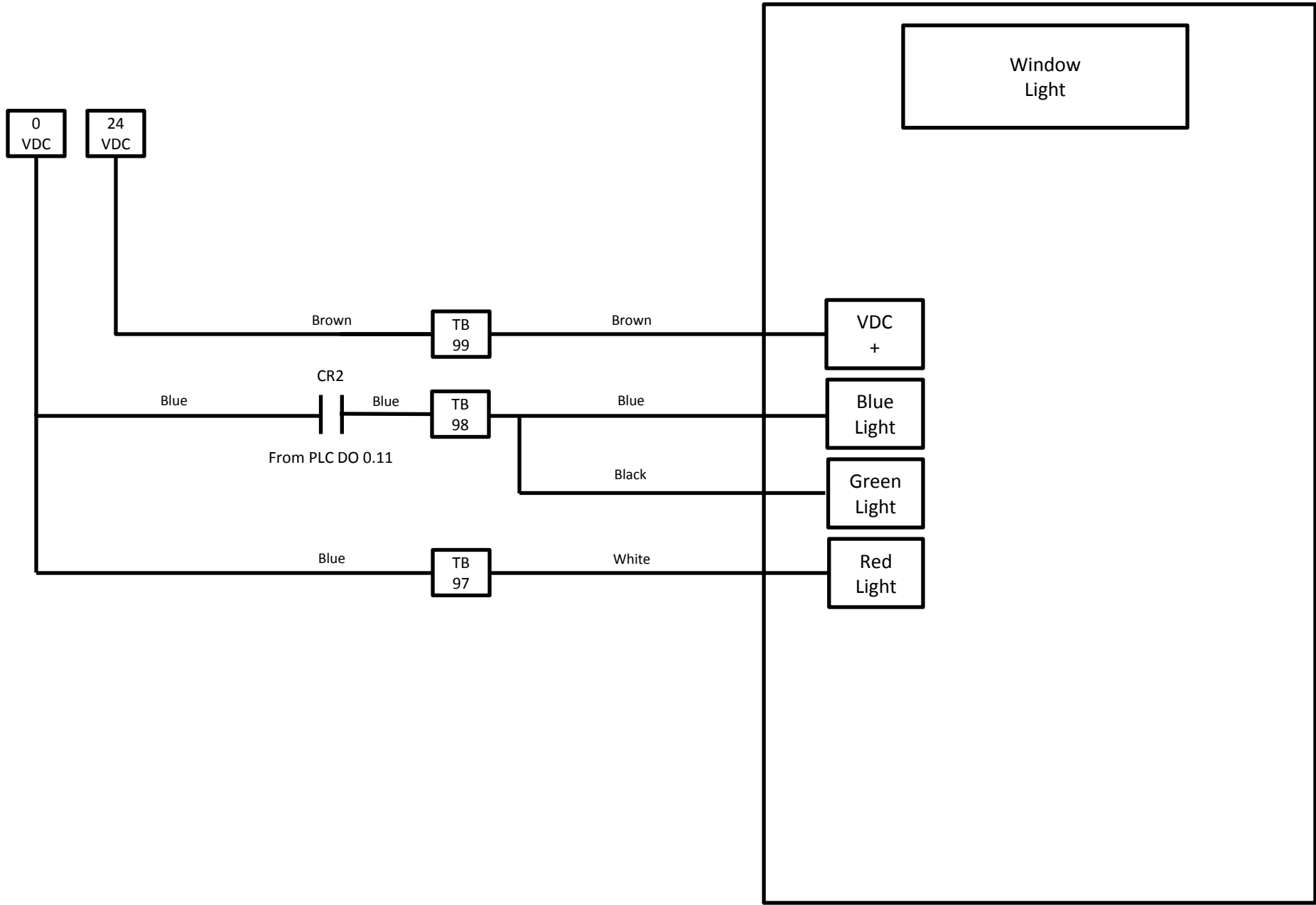


Note 1: The Light Curtain Transmitter is mounted on the machine's Vacuum side (right side when viewing from the front). The Light Curtain Receiver is opposite.

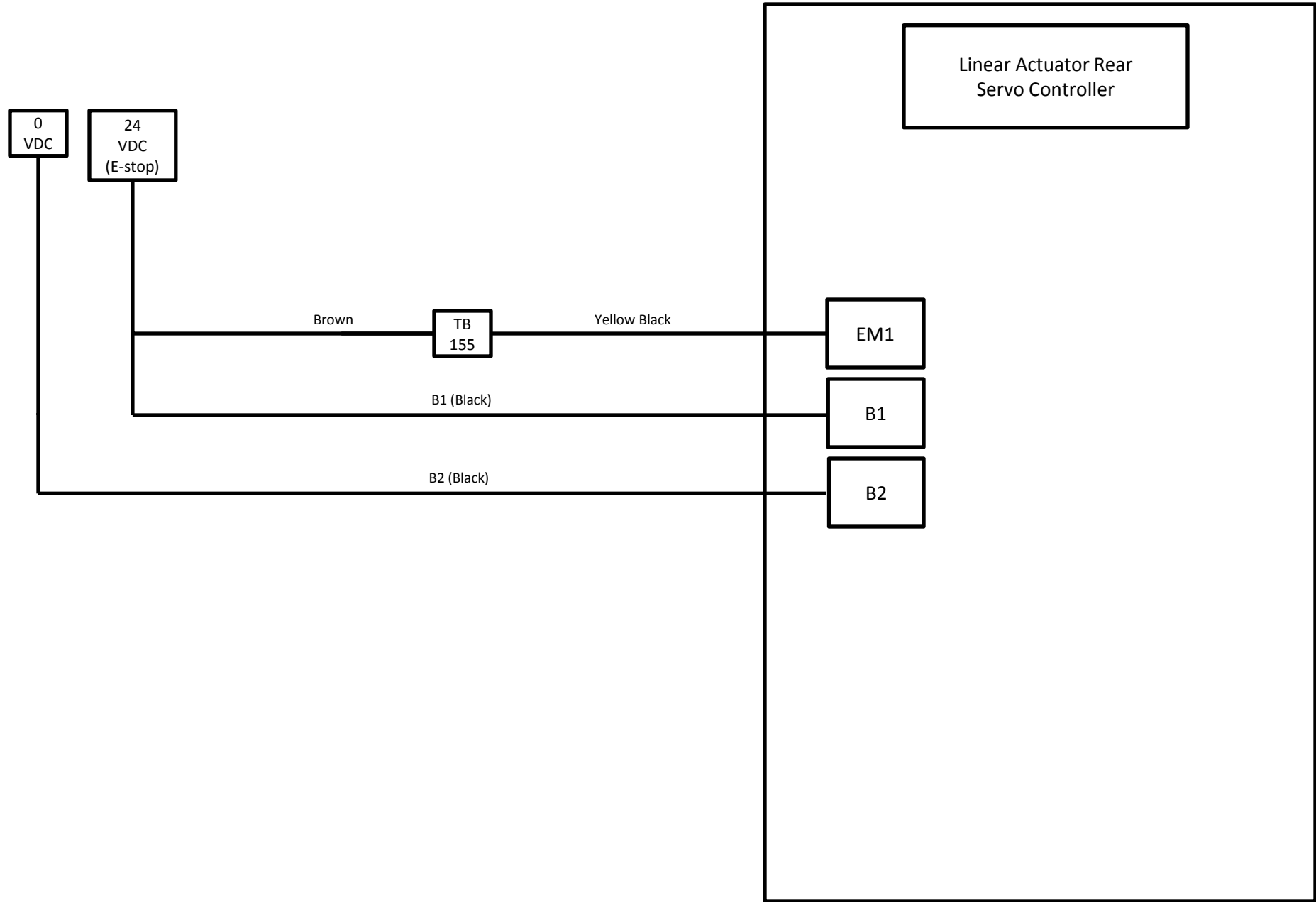
# PLC Power and Communication Wiring



# Window Light Wiring

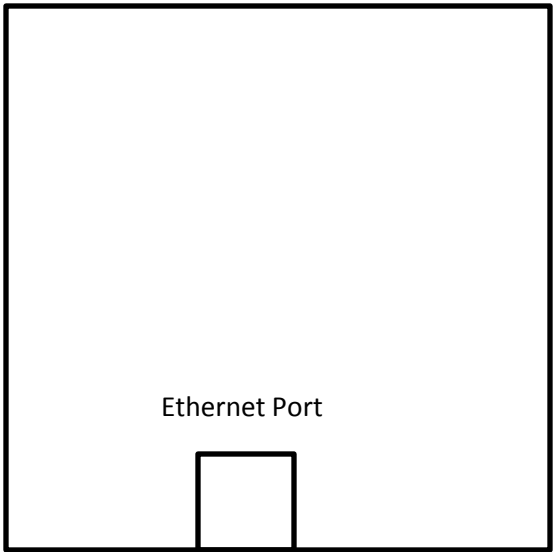


# Linear Actuator Brake and E-stop Wiring

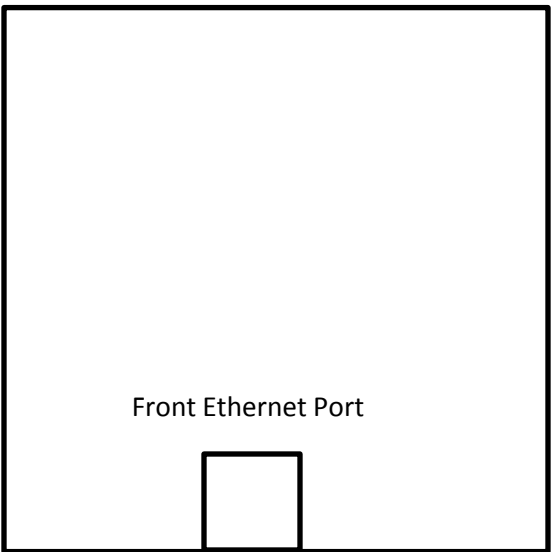


# Ethernet Communications Routing

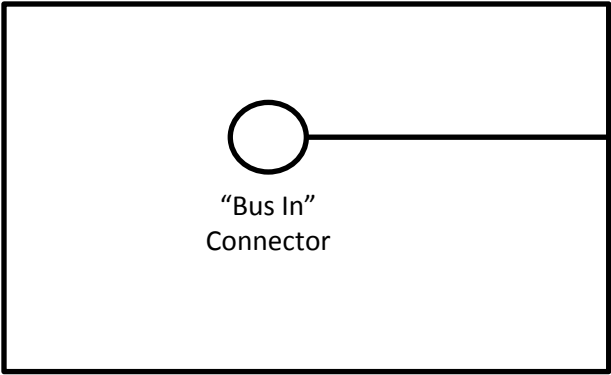
Safety Relay



CompactLogix PLC



EX600



Ethernet Ports

1

2

3

4

5

Ethernet Switch

CN2 Stat Switch  
Left Position  
("On")

CN 3

CN 2

CN 1

Gateway Unit

CN 4

LESH16DK-50

CN 4

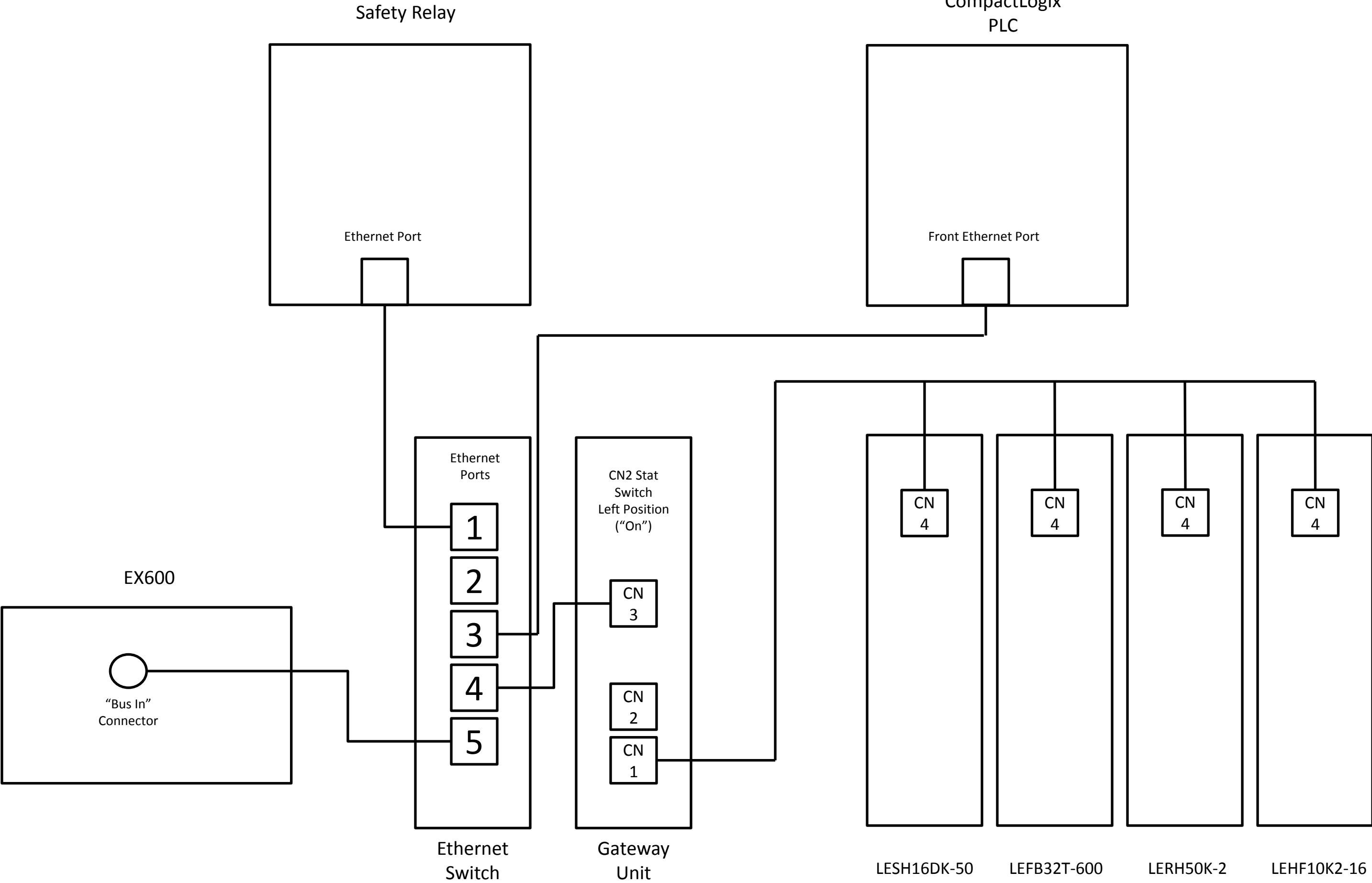
LEFB32T-600

CN 4

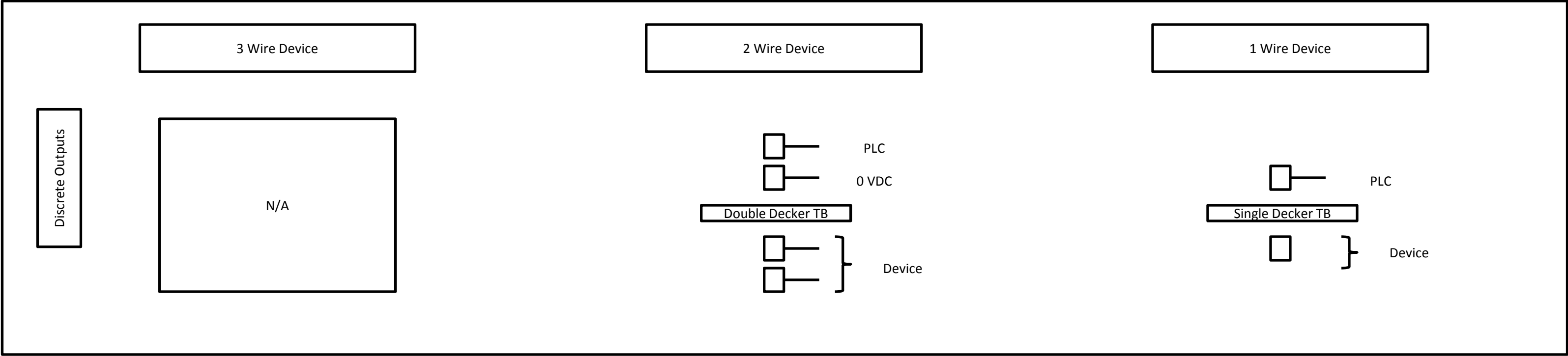
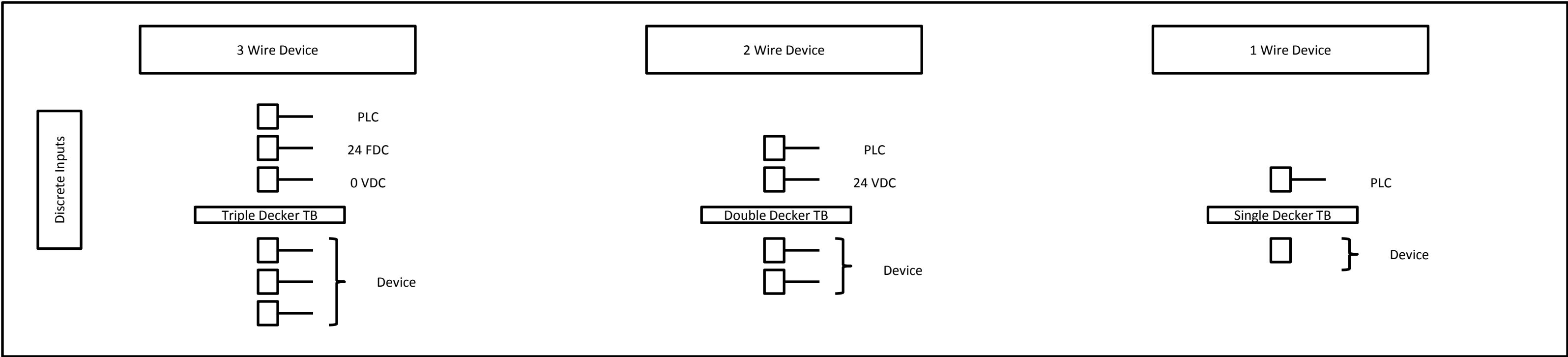
LERH50K-2

CN 4

LEHF10K2-16



**PLC Terminal Blocks  
Discrete I/O Wiring (Typical)**



## Stepper Controller Layout

LESH16DK-50

*Vertical Slide - Electric Side*

LEFB32T-600

*Linear Actuator - Front*

LERH50K-2

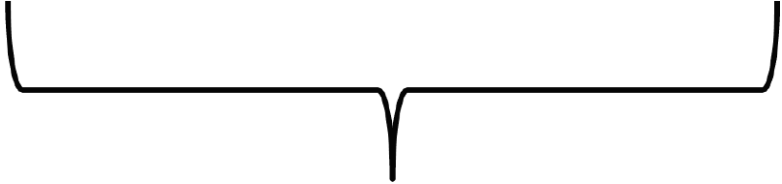
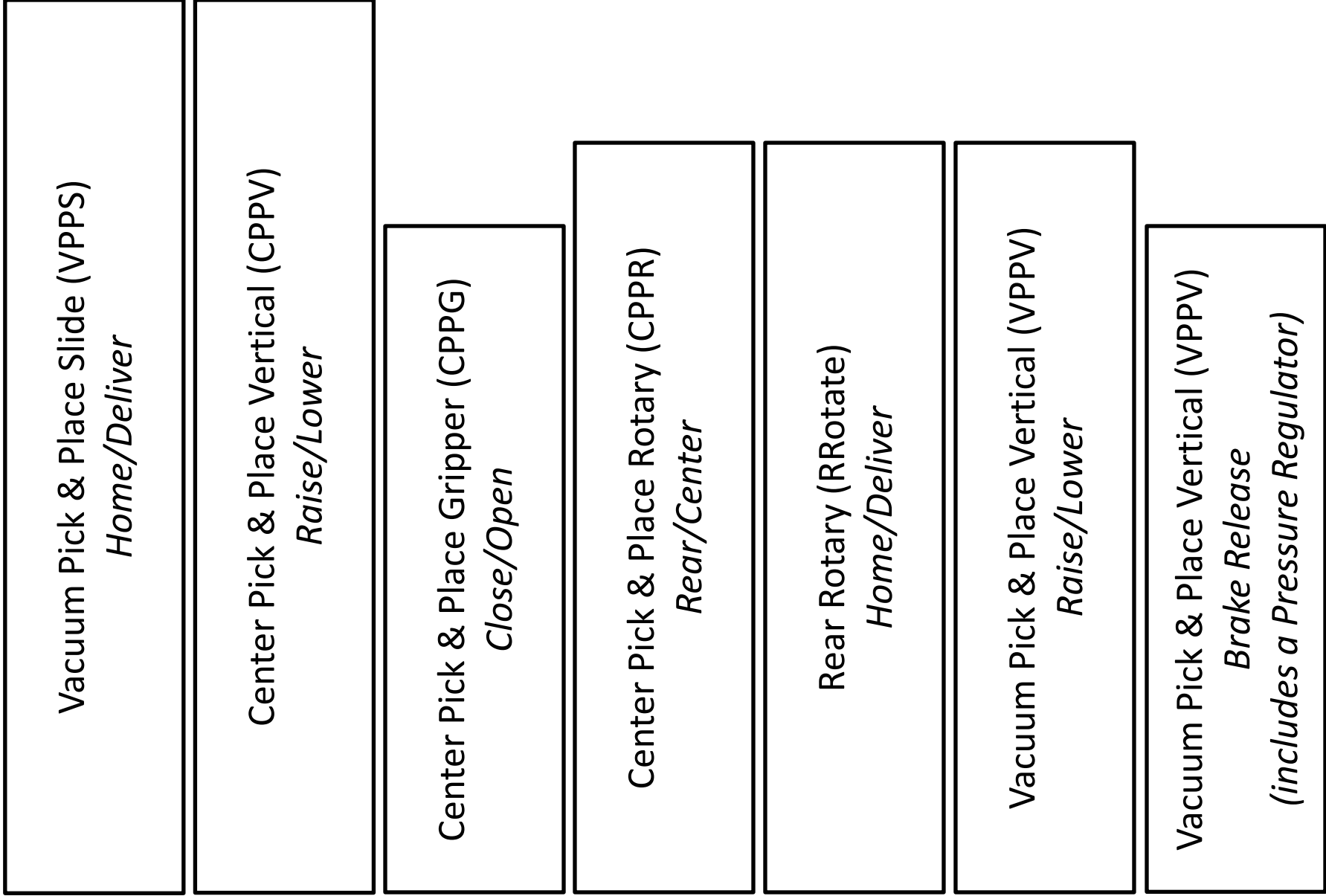
*Rotary - Electric Side*

LEHF10K2-16

*Vertical Gripper - Electric Side*



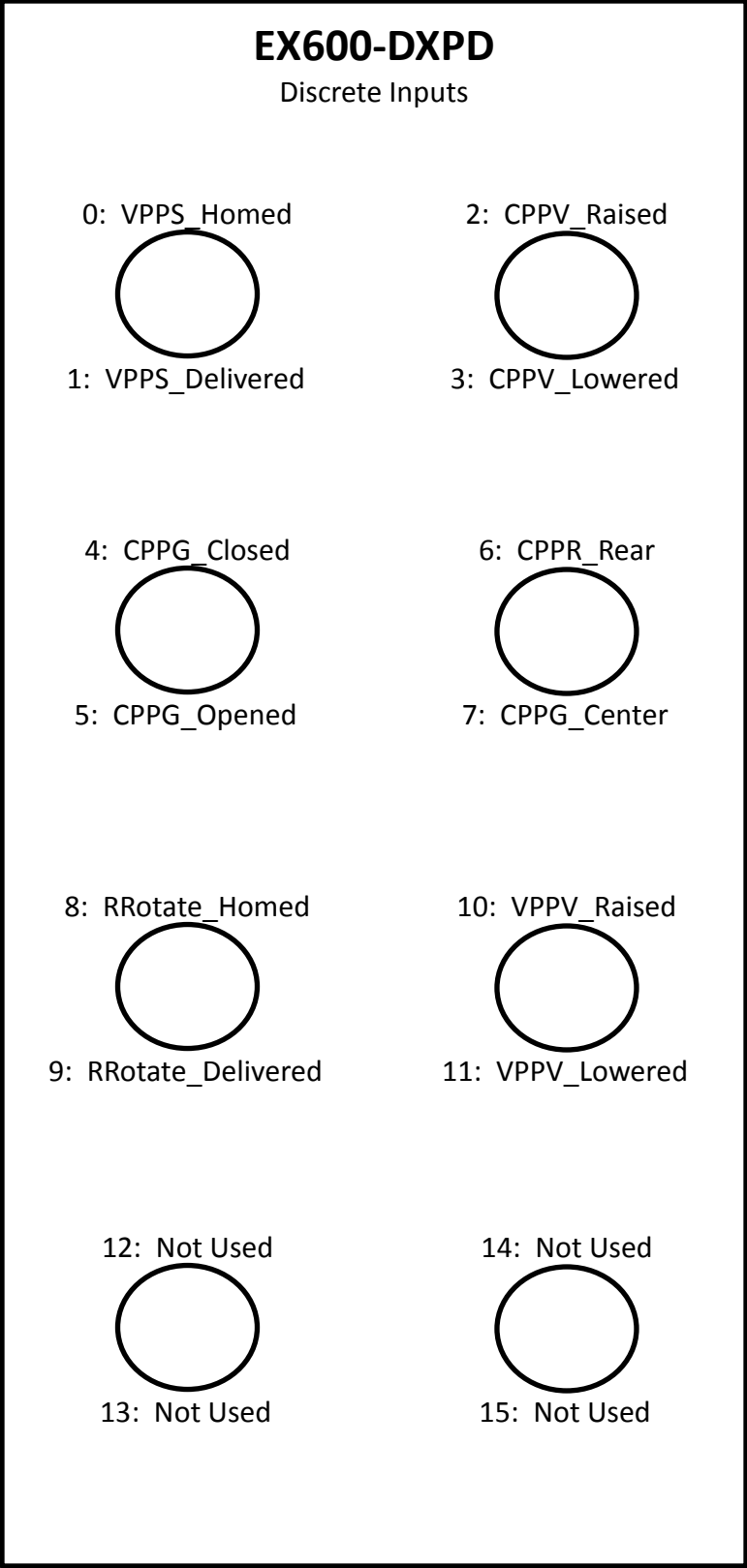
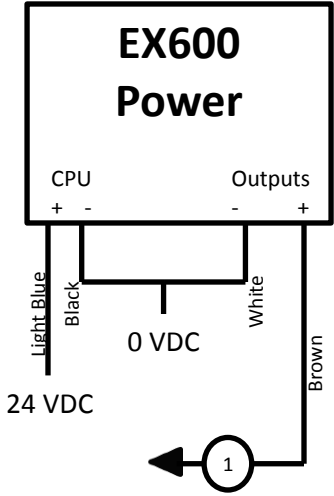
SY Mixed Manifold Layout



These are Blocked Center Valves

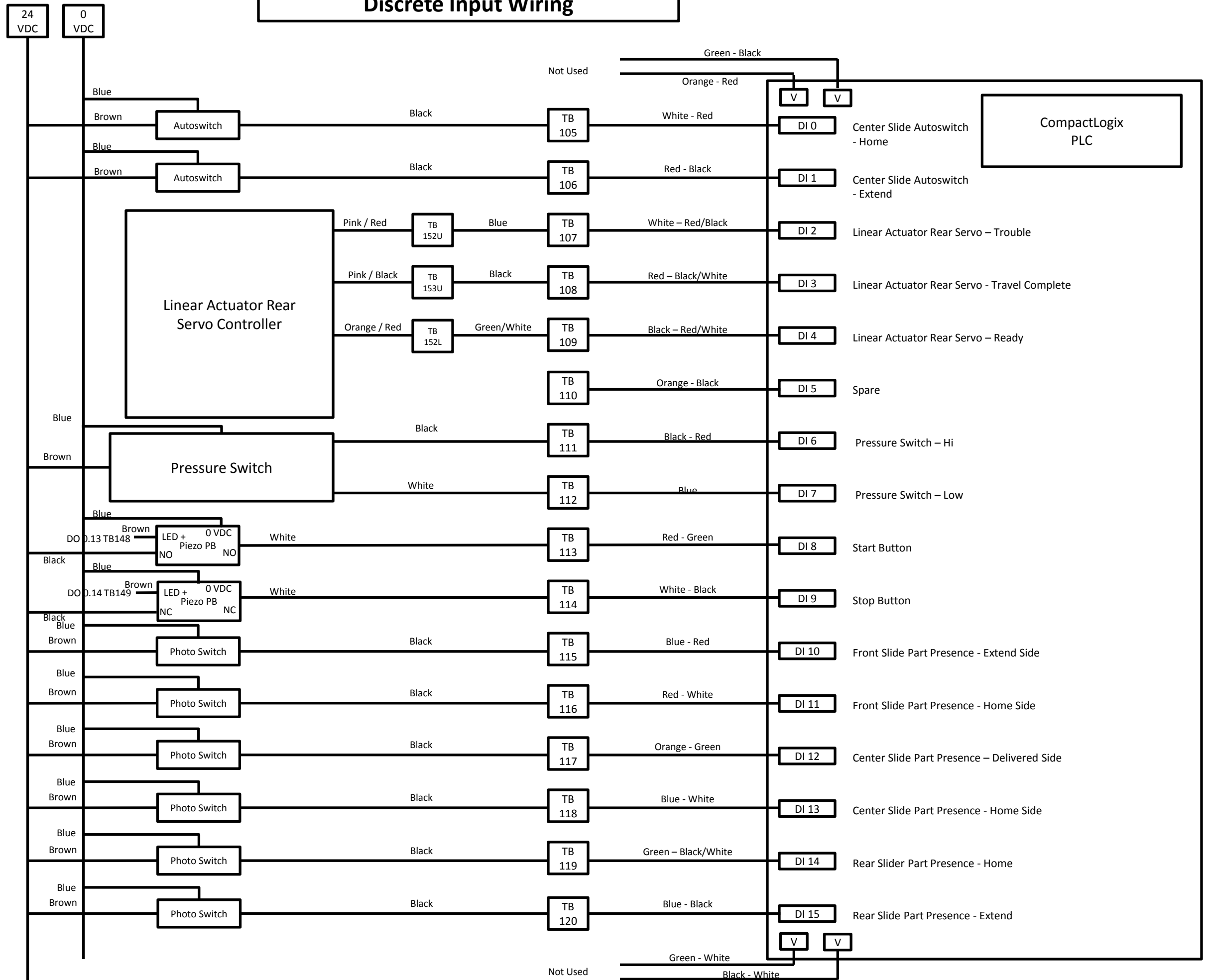
This Valve includes a Regulator.

# EX600

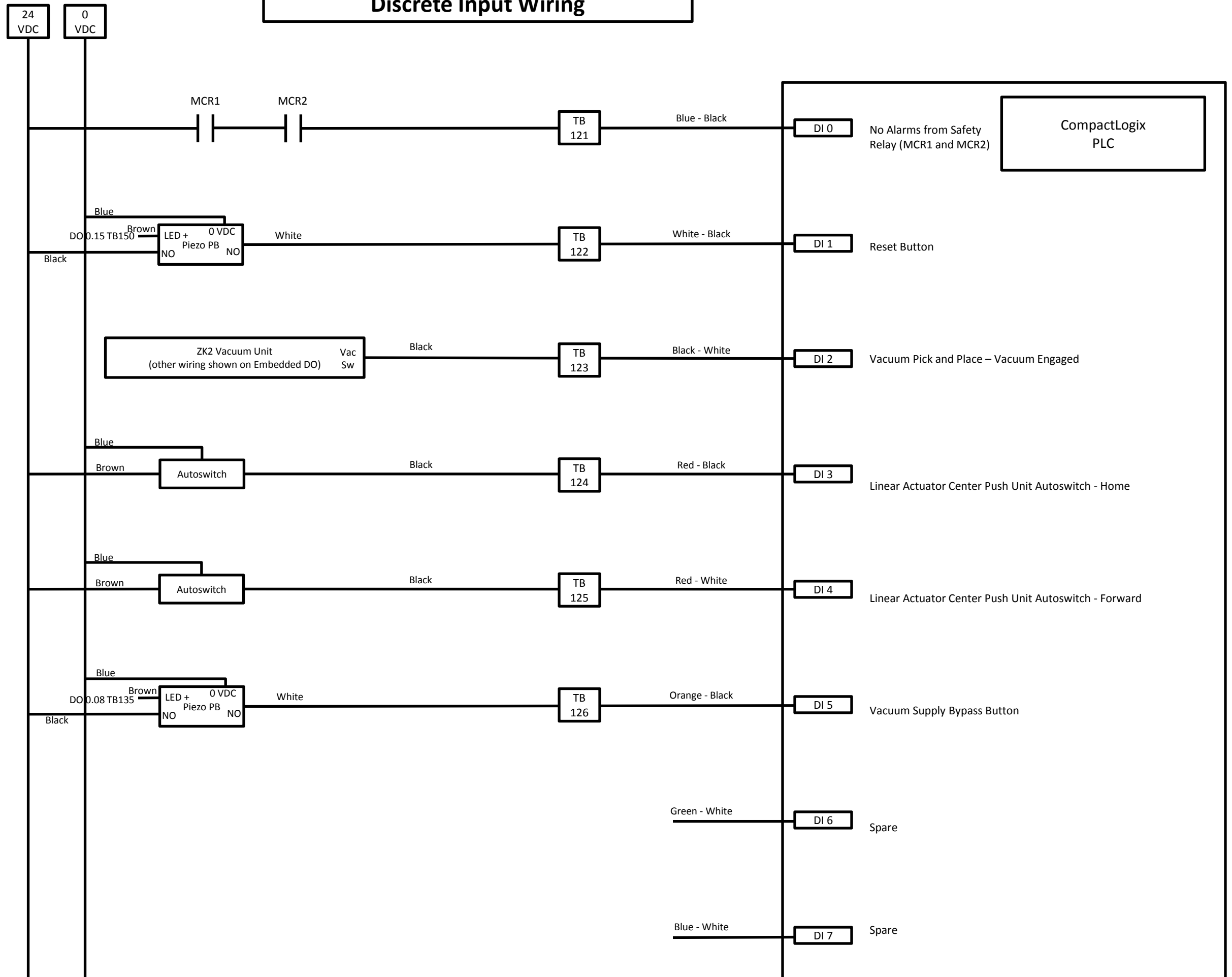


Note: The unit labels the I/O: 0 thru 15; the software map the same I/O: 0.0 thru 1.7.

# PLC Embedded Discrete Input Wiring



# PLC Slot 1 Discrete Input Wiring



# PLC Slot 2 Wiring

24  
VDC

0  
VDC

Green - White/Black

DI 0

Spare

Black - Red/White

DI 1

Spare

Orange

DI 2

Spare

Black

DI 3

Spare

Black - Red

DI 4

Spare

Green - Black

DI 5

Spare

White - Red

DI 6

Spare

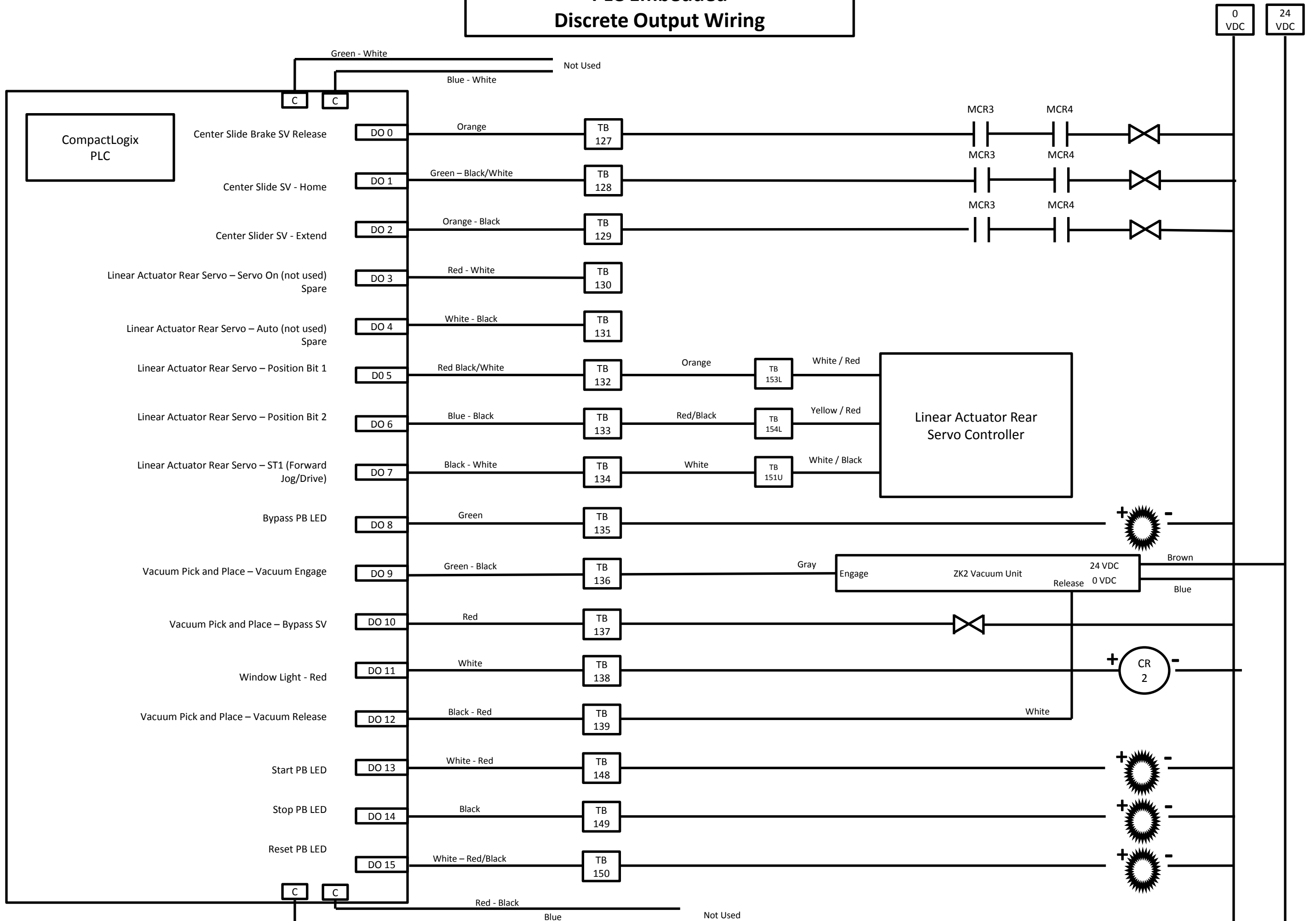
Orange - Red

DI 7

Spare

CompactLogix  
PLC

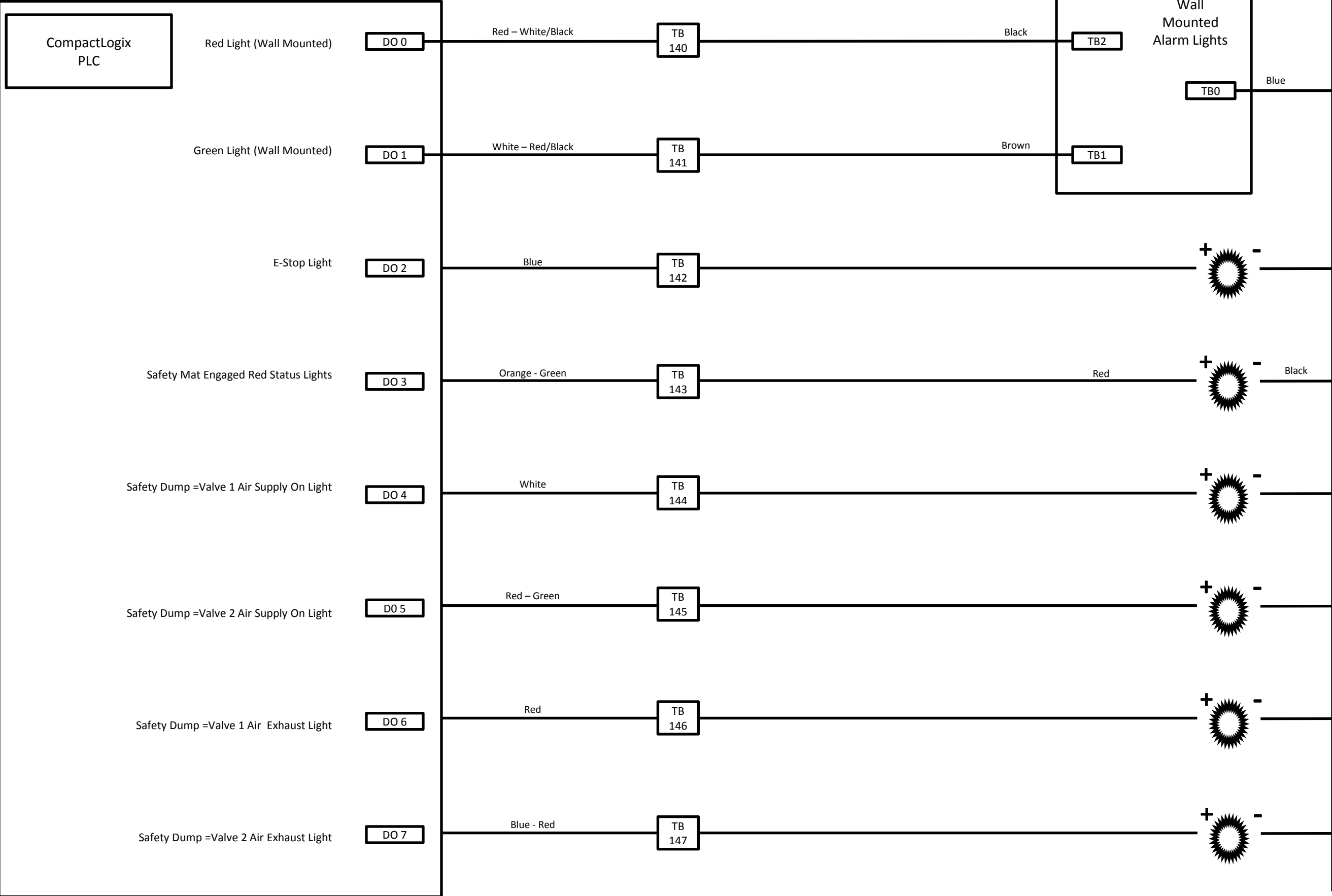
# PLC Embedded Discrete Output Wiring



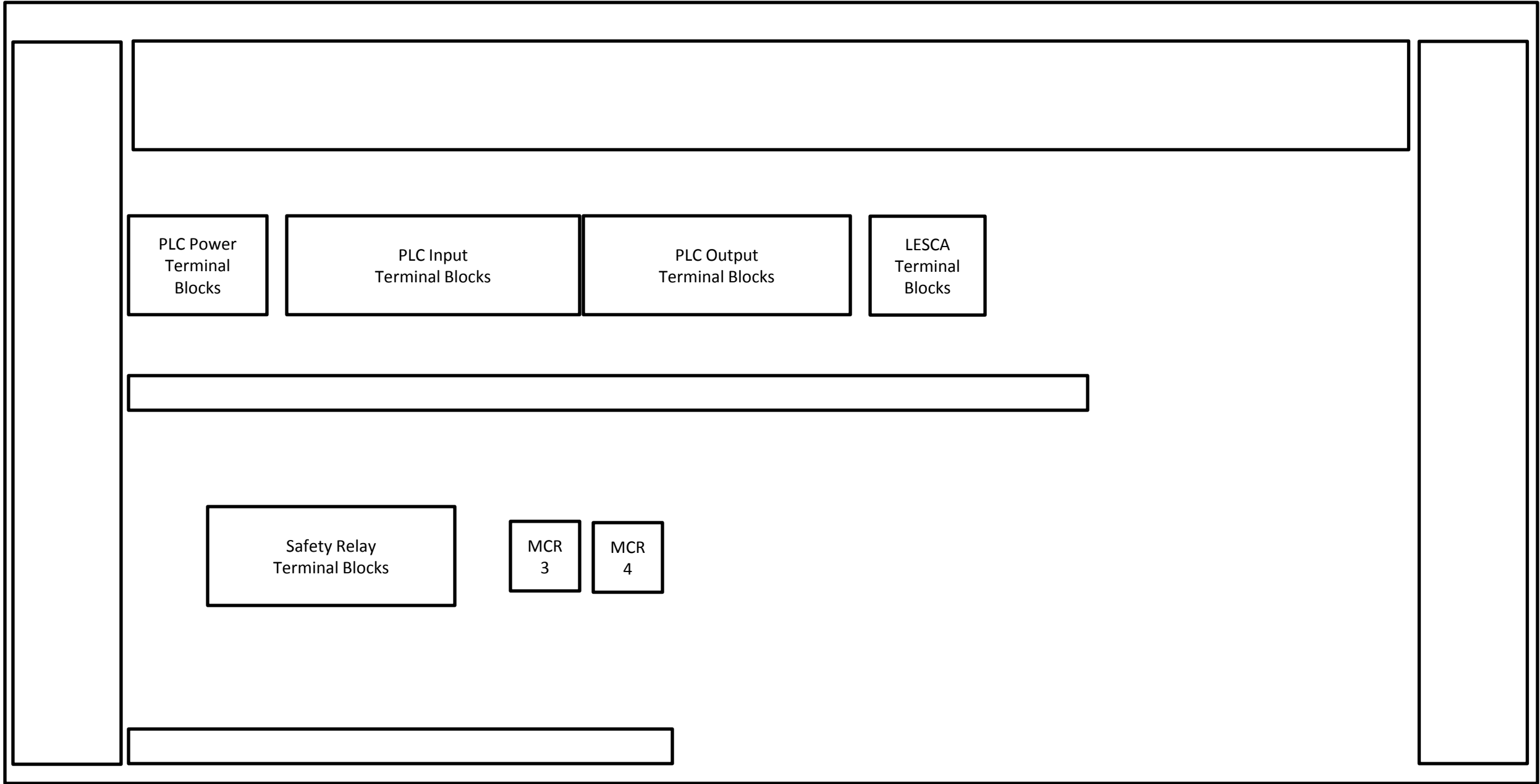
# PLC Slot 3 Discrete Output Wiring

0  
VDC

24  
VDC

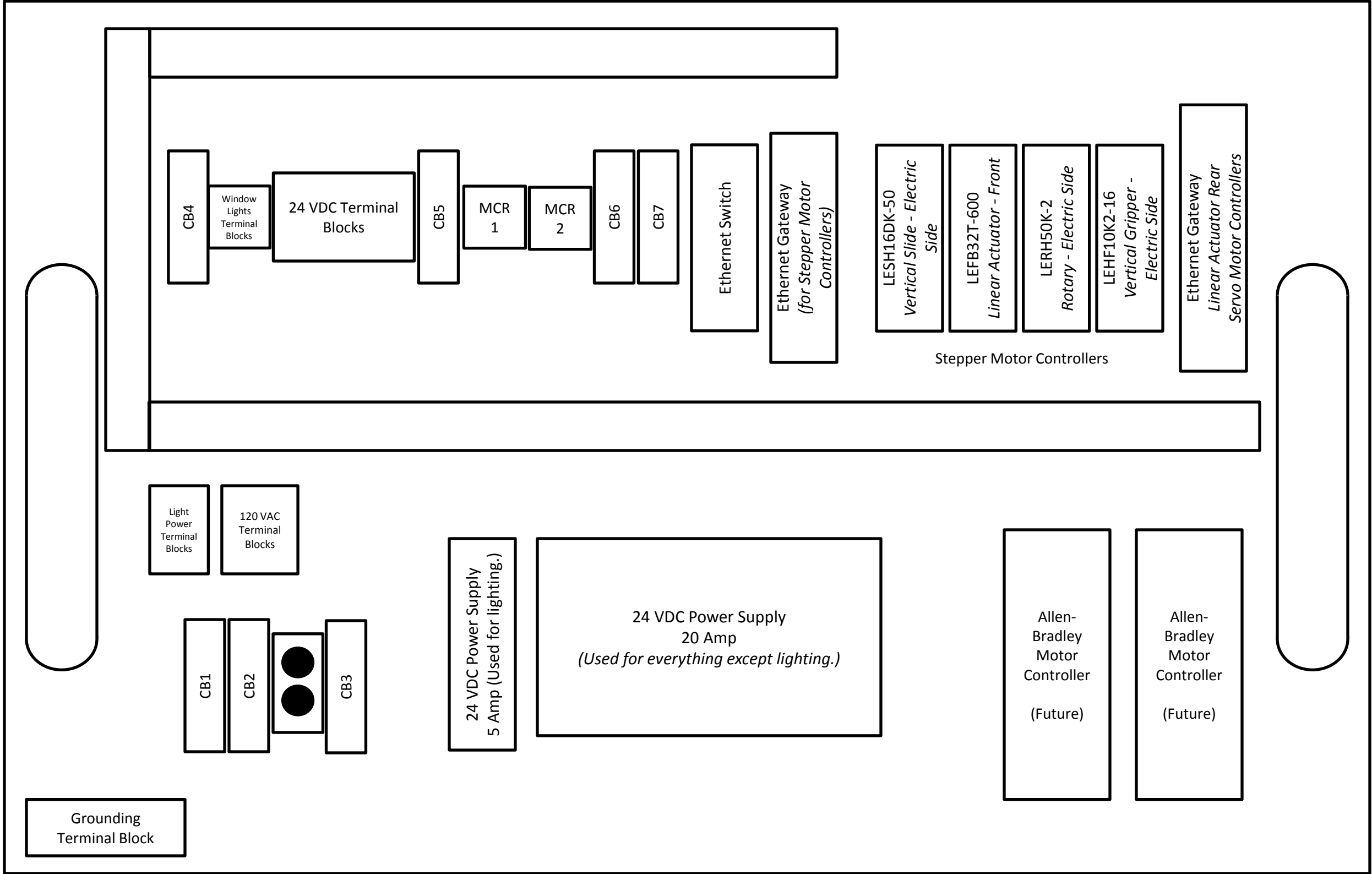


# Upper Panel Layout





# Lower Panel Layout



## Lower Panel Layout

CB4

Window  
Lights  
Terminal  
Blocks

24 VDC Terminal  
Blocks

CB5

MCR  
1

MCR  
2

CB6

CB7

Ethernet Switch

Ethernet Gateway  
(for Stepper Motor  
Controllers)

LESH16DK-50  
Vertical Slide - Electric  
Side

LEFB32T-600  
Linear Actuator - Front

LERH50K-2  
Rotary - Electric Side

LEHF10K2-16  
Vertical Gripper -  
Electric Side

Ethernet Gateway  
Linear Actuator Rear  
Servo Motor Controllers

Stepper Motor Controllers

Light  
Power  
Terminal  
Blocks

120 VAC  
Terminal  
Blocks

CB1

CB2



CB3

24 VDC Power Supply  
5 Amp (Used for lighting.)

24 VDC Power Supply  
20 Amp  
(Used for everything except lighting.)

Allen-  
Bradley  
Motor  
Controller  
  
(Future)

Allen-  
Bradley  
Motor  
Controller  
  
(Future)

Grounding  
Terminal Block