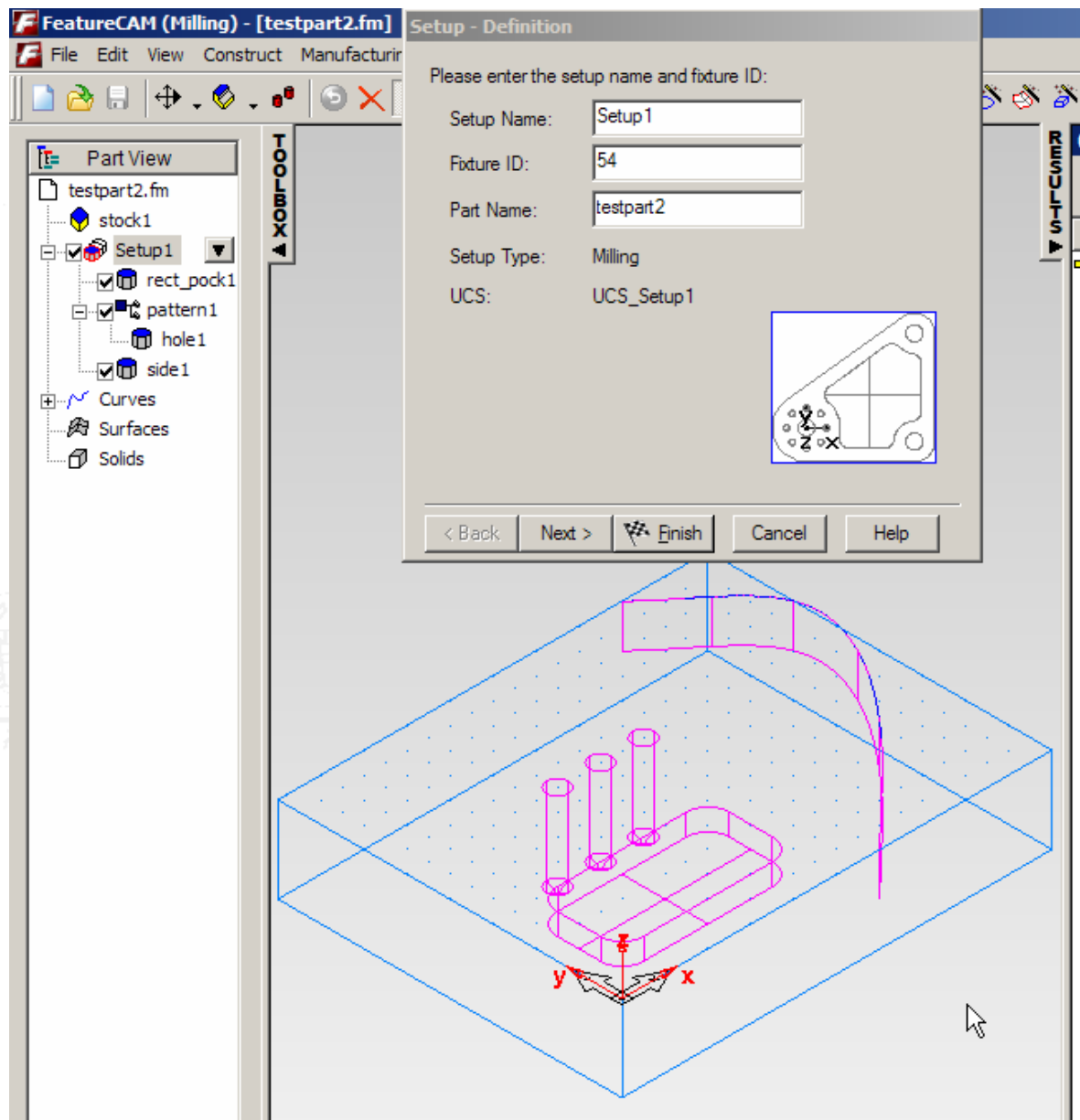
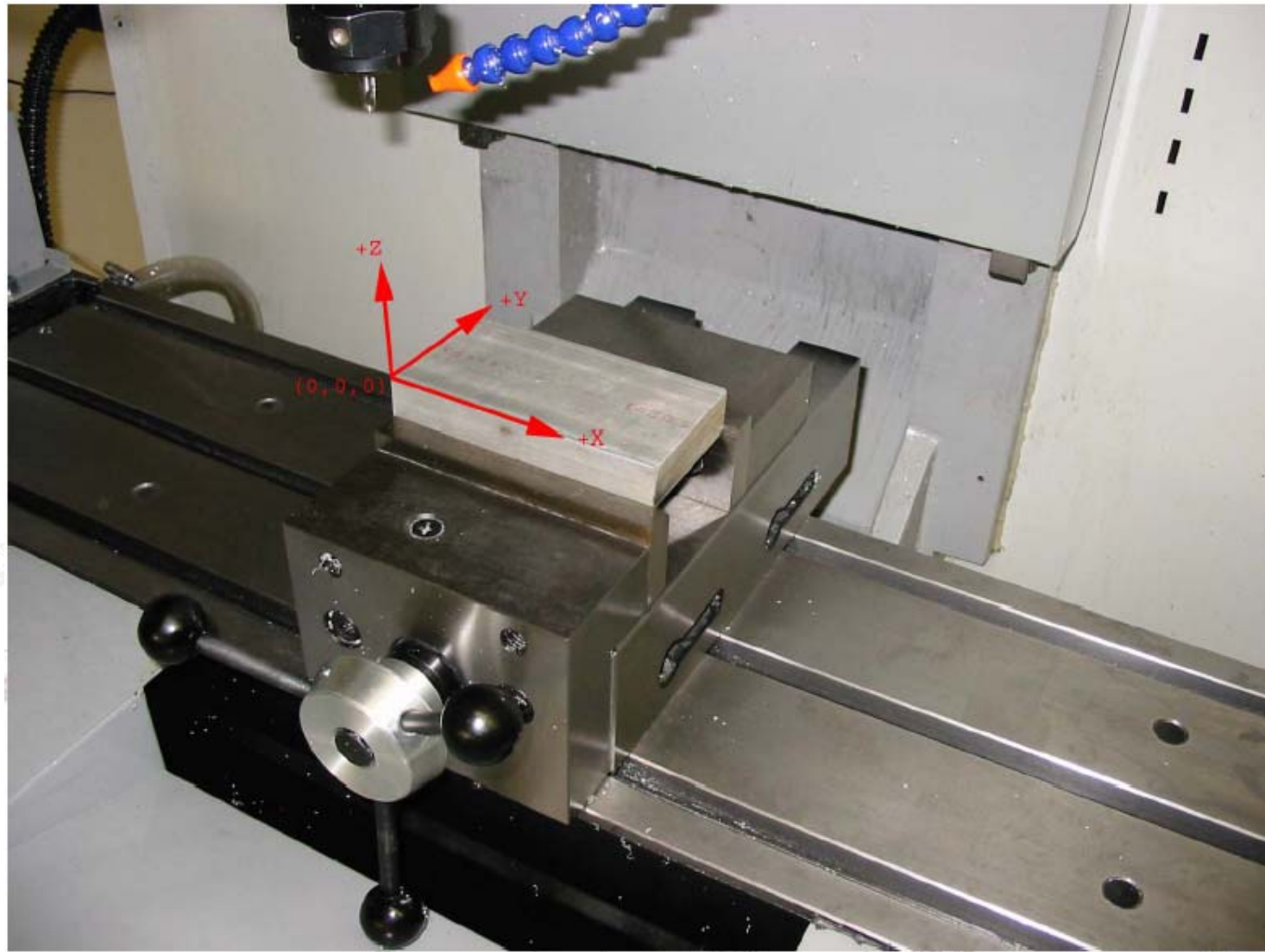


FEATURECAM SETUP ZERO



COORDINATE SYSTEM



WORK OFFSETS

- Work Offsets
 - G54-G59
 - G54 X & Y aligned with vice step jaw left front
 - Set G54 Z to height of top of work (type number, press F1)





SETTING WORK OFFSET

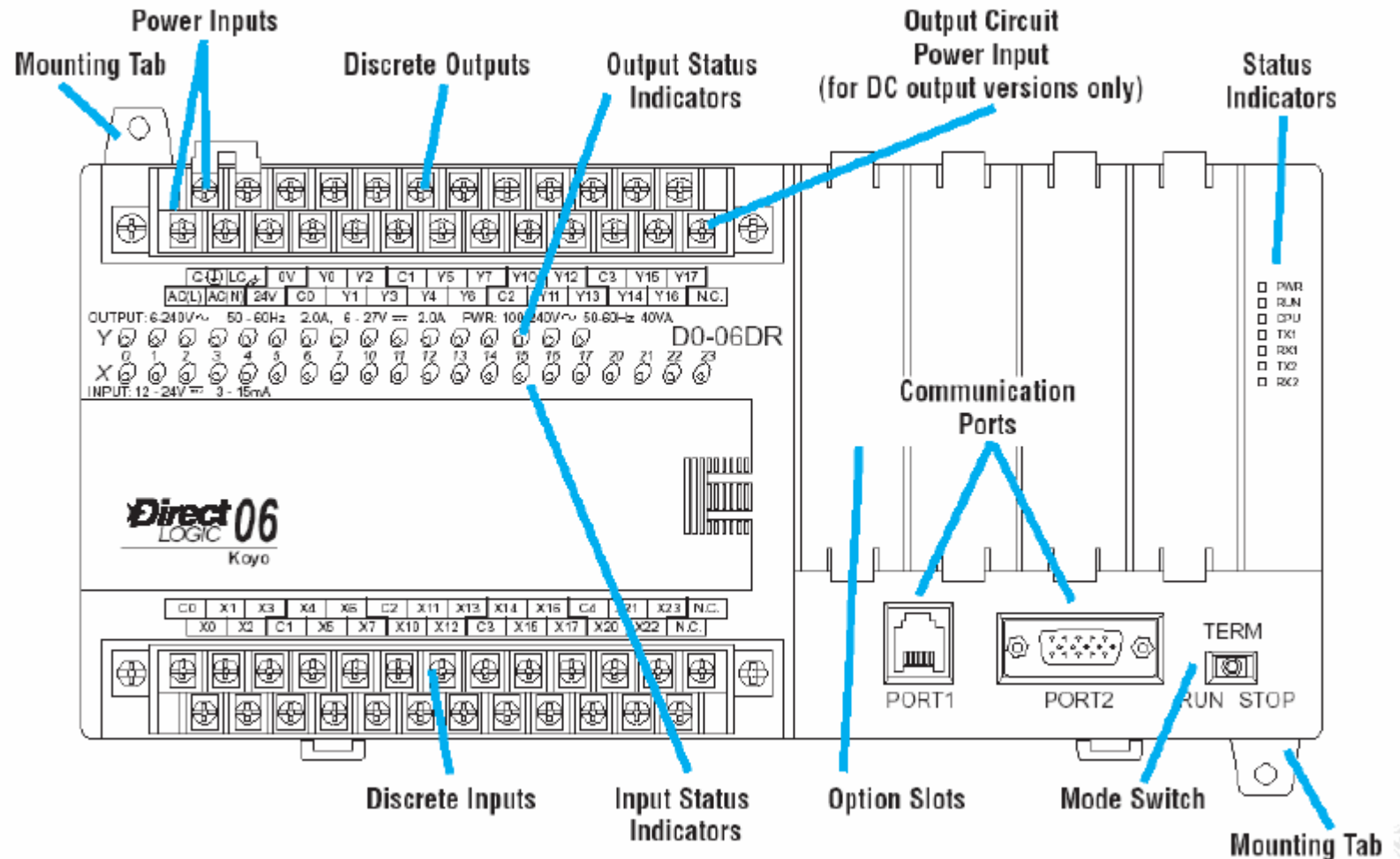
WORK ZERO OFFSET

G CODE	X	Y	Z	
G 52	0.	0.	0.	
G 54	-18.4871	-8.1975	6.4515	
G 55	-18.8788	-8.5888	0.	
G 56	-22.6688	-6.8888	0.	
G 57	-16.3988	-2.6288	6.8888	
G 58	-12.4185	-8.8782	5.8248	
G 59	-18.4871	-8.8782	5.2285	
G154 P1	0.	0.	0.	(G118)
G154 P2	0.	0.	0.	(G111)
G154 P3	0.	0.	0.	(G112)
G154 P4	0.	0.	0.	(G113)
G154 P5	0.	0.	0.	(G114)
G154 P6	0.	0.	0.	(G115)
G154 P7	0.	0.	0.	(G116)
G154 P8	0.	0.	0.	(G117)
G154 P9	0.	0.	0.	(G118)
G154 P10	0.	0.	0.	(G119)
G154 P11	0.	0.	0.	(G120)
G154 P12	0.	0.	0.	(G121)
G154 P13	0.	0.	0.	(G122)
G154 P14	0.	0.	0.	(G123)
G154 P15	0.	0.	0.	(G124)
G154 P16	0.	0.	0.	(G125)
G154 P17	0.	0.	0.	(G126)

Z POSITION : -5.8343 WRITE ADD/F1 SET/OFFSET TOGGLE

RAPID 58X
JOGGING Y AXIS HANDLE .0001

PLC FRONT PANEL

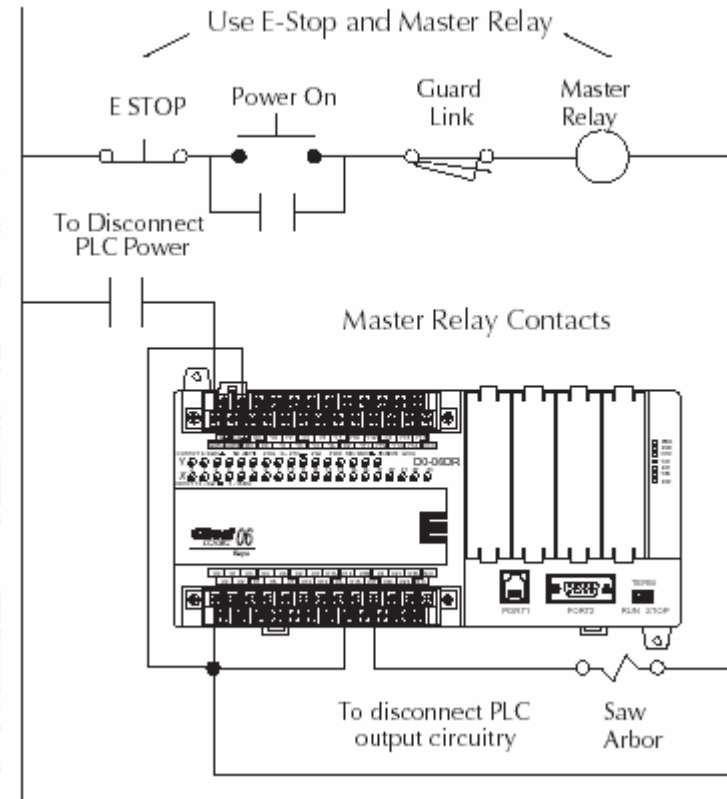
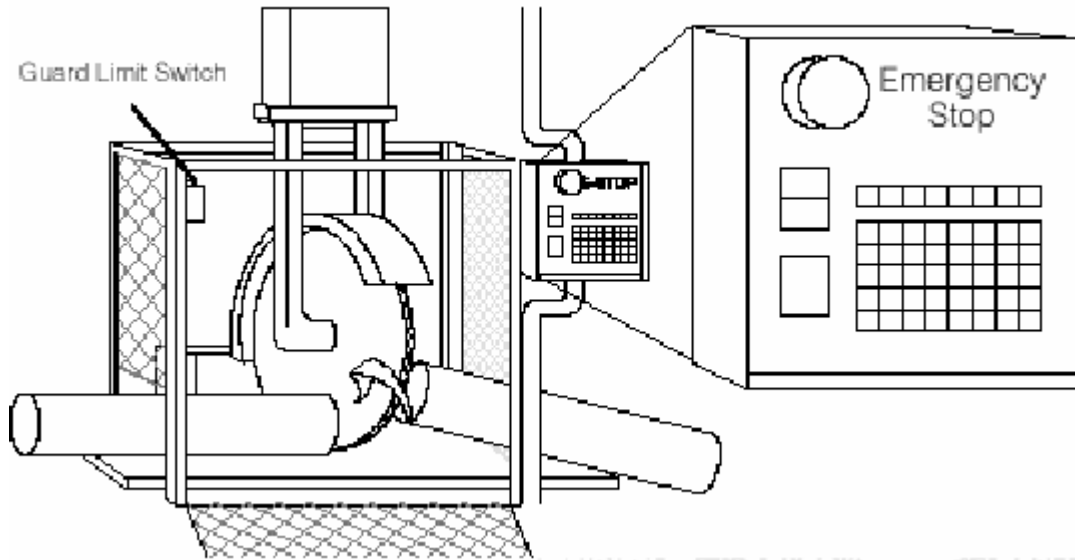


PLC WIRING

- Power Inputs
- Signal Inputs
- Control Outputs

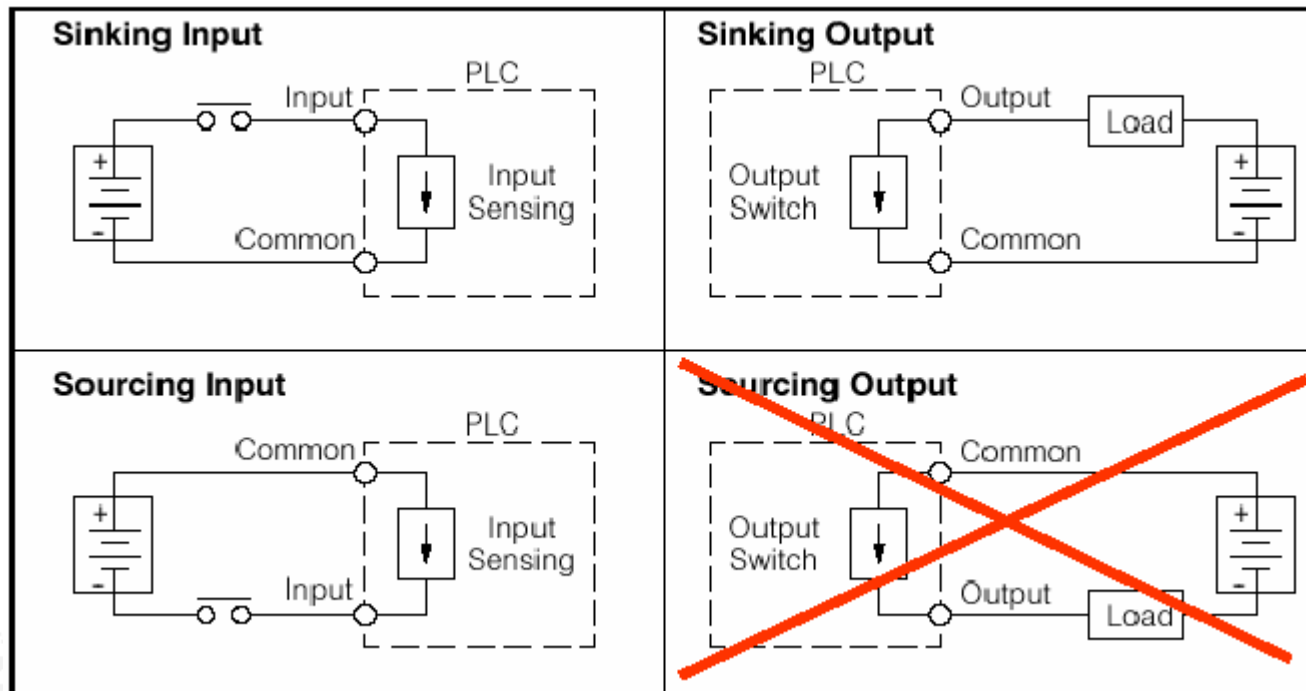


POWER WIRING



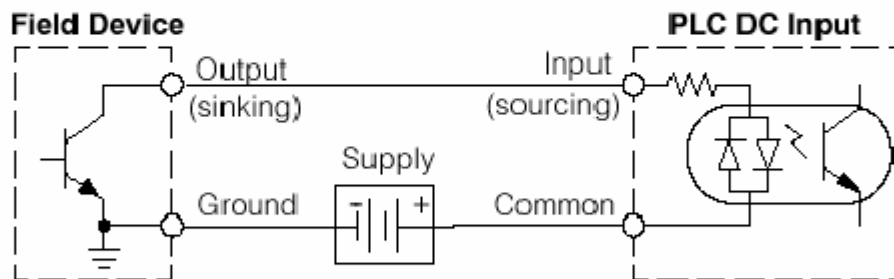
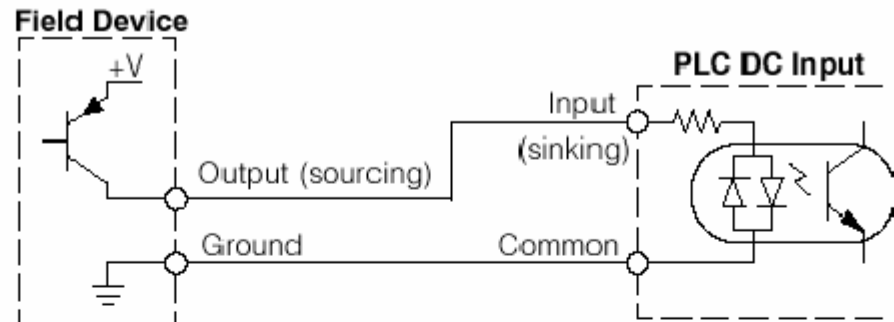
- Three levels of protection:
 - PLC logic - shutdown sequence
 - PLC output power disconnect
 - E-Stop shutdown of all energy sources

PLC INPUTS AND OUTPUTS



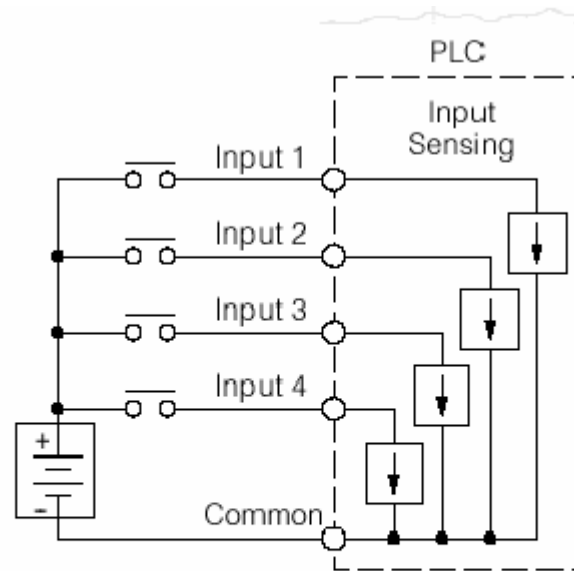
- Sinking = drawing current
- Sourcing = supplying current
- Sinking output connects to sourcing input
- Sourcing output connects to sinking input

DLO6 SIGNAL INPUTS



C0	X1	X3	X4	X6	C2	X11	X13	X14	X16	C4	X21	X23	N.C.
X0	X2	C1	X5	X7	X10	X12	C3	X15	X17	X20	X22	N.C.	

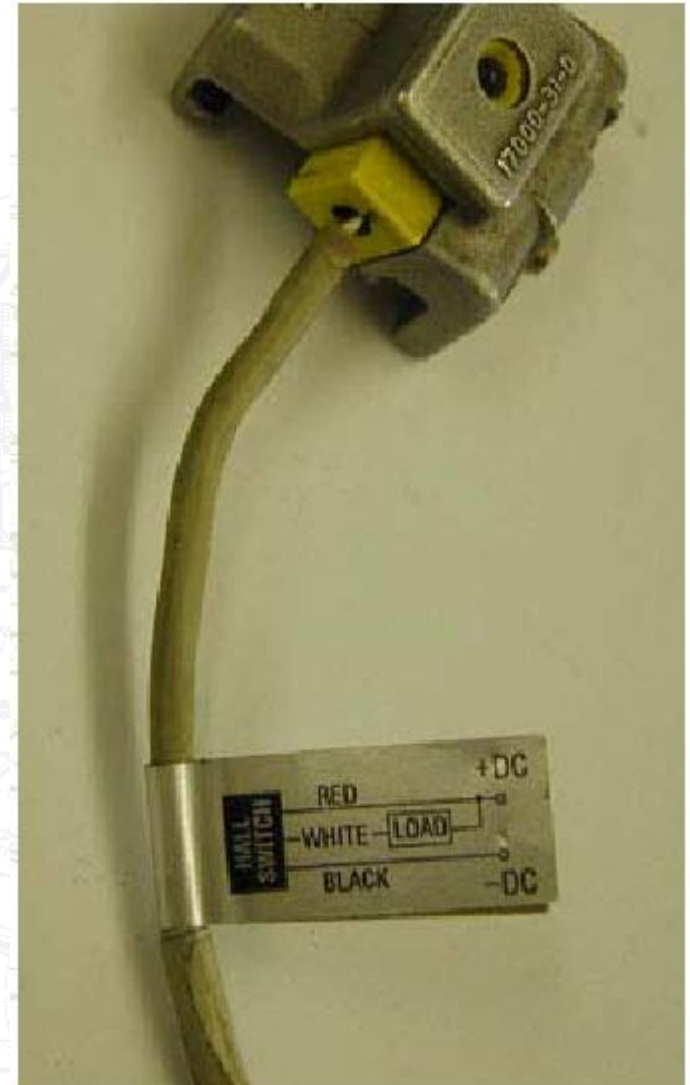
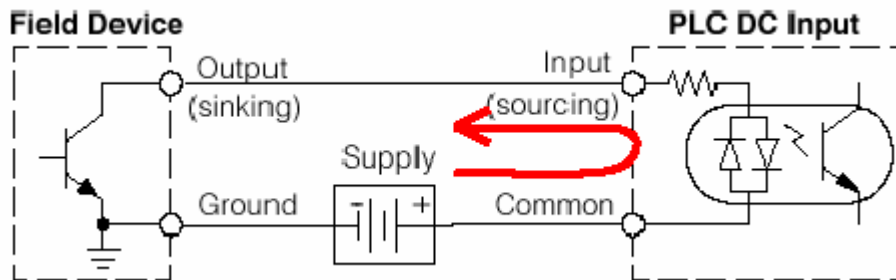
SIGNAL INPUTS



Multiple sinking inputs

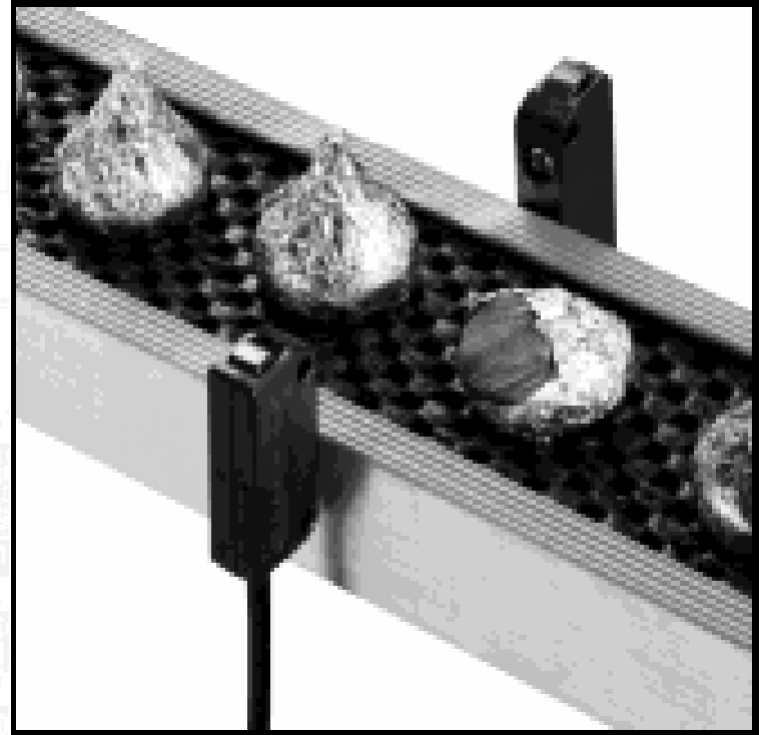
TYPICAL INPUT DEVICE

- The tag indicates that the LOAD (PLC input has a +DC common
 - this is a sinking output
 - Sinking output => sourcing input



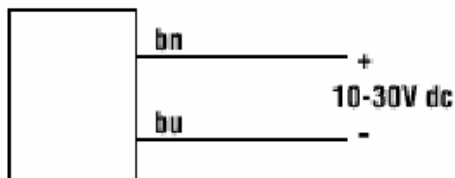
ANOTHER INPUT DEVICE

- Photosensor – comes in either NPN (sinking) or PNP (sourcing)



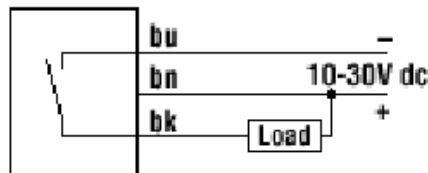
Emitters

Cabled Hookup



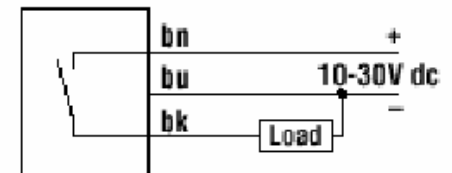
Receivers with NPN Outputs

Cabled Hookup

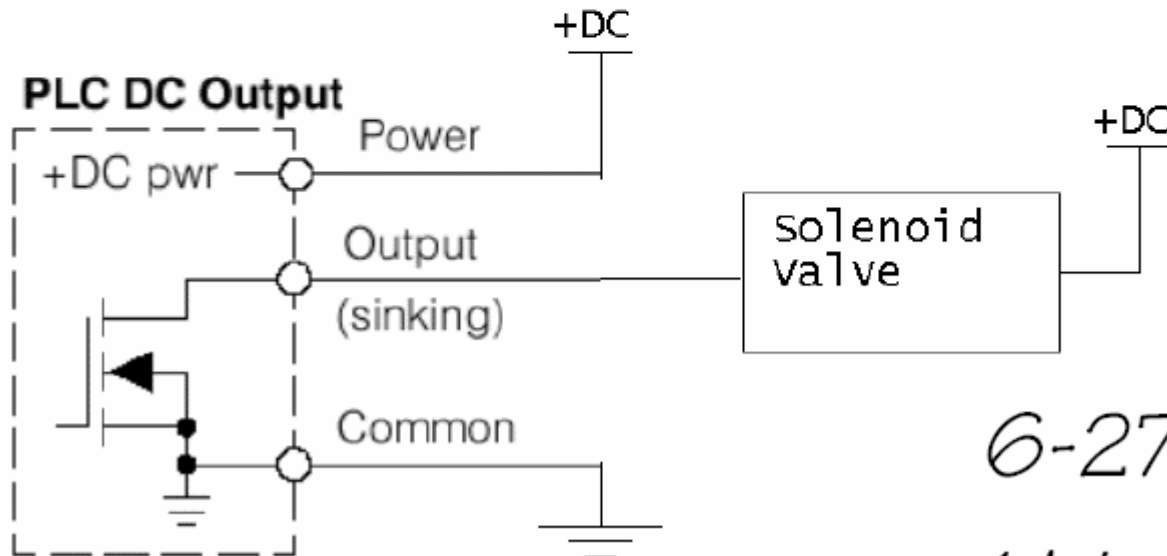
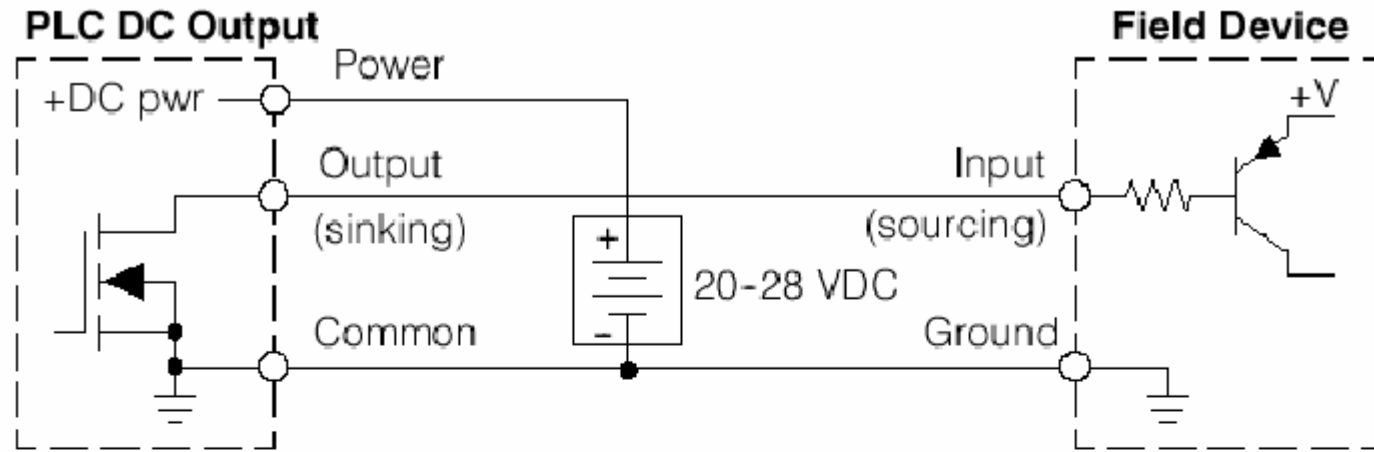


Receivers with PNP Outputs

Cabled Hookup



DC CONTROL OUTPUTS



6-27VDC
1A/output

DC CONTROL OUTPUTS

0V	Y0	Y2	C1	Y5	Y7	Y10	Y12	C3	Y15	Y17
C0	Y1	Y3	Y4	Y6	C2	Y11	Y13	Y14	Y16	+V

