CAPTION
ELECTRICAL TABLE DEVICES
RS 250-300-400 -CP1L-

Reference	Description	Features
A1 *"CP1L-EM40"*	AUTOMATON	24V / 300mA / 20W
B1 *"TL80-011"*	DRAGGING CELULA	10 – 30 Vdc / 80mA max.
B3A *"E6A2-CW5C"*	DRAGGING ENCODER	24 V / 200mA max. Salt. C.Ab
B3B *"E6A2-CW5C"*	DRAGGING ENCODER	24 V / 200mA max. Salt. C.Ab
B4 *"IFB3004"*	INDUCTIVE SENSOR ORIGIN	24 V / 17 mA
B5 *"IFB3004"*	INDUCTIVE. SENSOR JAW PRESSURE	24 V / 17 mA
B6	THERMOCOUPLE CONTROL TA VERTICAL	Type J
B7	INTERIOR HORIZONTAL THERMOCOUPLE	Type J
B8	EXTERNAL HORIZONTAL THERMOCOUPLE	Type J
B9 *"E6A2-CW5C"*	SCREW-DOSER ENCODER	24 V / 200mA max. Salt. C.Ab
B10	THERMOCOUPLE TROQUEL	Type J
B11 *"IFB3004"*	REBOB CELL. IF PLASTIC	10-30 Vdc / 65mA
B12 *"IFB3004"*	UNWINDER INDUCTIVE SENSPR	24 V / 17 mA
B13 *"E2EG-X2C1"*	VOLUMETRIC DISPENSER. INDUCTIVE SENSOR.	24 V / 17 mA
B14 *"E3S-CL1"*	PHOTOELECTRIC SENSOR CONVEYOR BELT DETECTOR (MAXIMAL. LEVEL.) VOLUMETRIC DISPENSER	10-30 Vdc / 35 mA max.
B14b *"CM30-16BBP-KW1"*	PHOTOELECTRIC SENSOR CONVEYOR BELT DETECTOR (max. Volum.) SCREW-DOSER	10-40 Vdc / 10mA
B14c *"E3JM-R4M4T-G"*	PHOTOELECTRIC DETECTOR CONVEYOR BELT (max. Volum.) ICE DISPENSER.	12-24 Vdc / 65mA
B15 *"IFB3004"*	INDUCTIVE SENSOR FLUFFY ORIGIN	24 V / 17 mA
B16 *"IFB004"*	PHOTOELECTRIC DETECTOR CONVEYOR BELT (min. Volum.) ICE DISPENSER.	12-24 Vdc / 65mA
B17 *"IFB004"*	LEFT FINAL DETECTOR	12-24 Vdc / 65mA
B18 *"IFB004"*	RIGHT FINAL DETECTOR	12-24 Vdc / 65mA
B19 *"IFB004"*	SCREW-DOSER DOOR DETECTOR	12-24 Vdc / 65mA
B20 *"IFB004"*	NON-PLASTIC DETECTOR	12-24 Vdc / 65mA
B21 *"IFB004"*	IF PLASTIC DETECTOR	12-24 Vdc / 65mA
B22 *"IFB004"*	VOLUM MINIMUM DISPENSER DETECTOR..	12-24 Vdc / 65mA
B23 *"IFB004"*	VOLUM MAXIMUM DISPENSER DETECTOR..	12-24 Vdc / 65mA
B24 *"IFB004"*	EXTERNAL PACKAGES COUNTER	12-24 Vdc / 65mA
B25 *"IFB004"*	45º FINAL DETECTOR	12-24 Vdc / 65mA
B26 *"IFB004"*	0º FINAL DETECTOR	12-24 Vdc / 65mA
B27 *"IFB004"*	COUNTER DEGREES INCLINED DETECTOR	12-24 Vdc / 65mA
B28*"E3S-CL1"*	PHOTOELECTRIC SENSOR TABLE	10-30 Vdc / 35 mA max.

B32 *"IFB3004"*	S. INDUCTIVE ON UNWINDER	24 V / 17 mA
B33 *"IFB3004"*	S. INDUCTIVE OFF UNWINDER	24 V / 17 mA
EXT	AUXILIAR RELAY EXTERNAL OUTPUT	
F1 *"A9R81425"*	GENERAL DIFFERENTIAL	30mA / In 25 A
F2 *"XPS-AS"*	SECURITY RELAY	24 V/ 250 mA
F4F *"LRD07"*	THERMAL RELAY VOLUMETRIC/ENDLESS DISPENSER	1,5 A – 2.5 A
F5F *"LDR07"*	THERMAL RELAY TOLVA (VOLUM. MIXER	1-1.6A
F7F *"LRD07"*	THERMAL RELAY CONVEYOR BELT	1,5 A – 2.5 A
F7bF *"LRD07"*	THERMAL RELAY ENDLESS MIXER	1,5 A – 2.5 A
F15F *"LRD06"*	THERMAL RELAY UP DISPENSER VASE	1A - 1.6 A
F16F *"LRD06"*	THERMAL RELAY LOW DISPENSER VASE	1A - 1.6 A
F17F *"LRD07"*	THERMAL RELAY INVERSOR CONVEYOR BELT	1,5 A – 2.5 A
F19F *"LRD10"*	THERMAL RELAY TABLE	4 A -6 A
F23F *"LRD10"*	THERMAL RELAY VACUUM	4 A -6 A
F33BF *"LRD07"*	THERMAL RELAY VIBRATOR CRUSHED ICE	1,5 A – 2.5 A
F38F *"LRD07"*	THERMAL RELAY UNWINDER	1,5 A – 2.5 A
F39F *"LRD08"*	THERMAL RELAY VACUUM PUMP	2,5 A - 4 A
G1 *"S8VK-G12024"*	POWER SOURCE	24 V / 5 A
H1	UV LIGHT	220 V / 15 W
K1A *"P2RF-05-PU"*	AUX RELAY DRAGGING FREQUENCY CONVERTER	2 A / 4 - 48 V DC
K2A *"P2RF-05-PU"*	AUX RELAY. MULTIHEAD SP SIGNAL. AUX RELAY. IN SIGNAL WEIGHTER	2 A / 4 - 48 V DC
K3A *"P2RF-05-PU"*	AUX RELAY. ON. VOLUMETRIC DISPENSER.	10 A / 250 Vac
K3A *"P2RF-05-PU"*	AUX RELAY. NO SCREWDOSER AUX RELAY. LEFT WEIGHT (DMP10B) AUX RELAY. MULTIHEAD DOWNLOAD	2 A / 4 - 48 V DC
K4A*"P2RF-05-PU"*	AUX RELAY. MULTIHEAD VIBRATOR SIGNAL/MAXIMAL DISPENSER LEVEL.	2 A / 4 - 48 V DC
K5A *"P2RF-05-PU"*	AUX RELAY. HOPPER DOOR	2 A / 4 - 48 V DC
K6A *"P2RF-05-PU"*	AUX RELAY. HORIZ REFRIGERATION	2 A / 4 - 48 V DC
K7A *"P2RF-05-PU"*	AUX RELAY. INERT GAS	2 A / 4 - 48 V DC
K8A *"P2RF-05-PU"*	AUX RELAY TABLE	10 A / 250 Vac
K9A *"P2RF-05-PU"*	AUX RELAY. CONVEYOR BELT. AND SCREW-DOSER MIXER	10 A / 250 Vac
K9B *"P2RF-05-PU"*	AUX RELAY. CONVEYOR BELT. AUX RELAY. SCREW-DOSER MIXER	10 A / 250 Vac
K9C *"P2RF-05-PU"*	AUX RELAY. ACCELERATOR	10 A / 250 Vac
K10A *"P2RF-05-PU"*	AUX RELAY. DATER SIGNAL	2 A / 4 - 48 V DC
K11A *"P2RF-05-PU"*	AUX RELAY. ON/OFF DATER	10 A / 250 Vac
K12A *"P2RF-05-PU"*	AUX RELAY. WELDING ON/OFF	10 A / 250 Vac
K13A *"P2RF-05-PU"*	AUX RELAY ALARM. CODIFIER. (MARKEN/MARCOPACK/VIDEOJET)	2 A / 4 - 48 V DC
K13BA *"P2RF-05-PU"*	AUX RELAY. SECOND CODIFIER ALARM.	2 A / 4 - 48 V DC
K15A *"P2RF-05-PU"*	AUX RELAY. GROUPING ALARM	2 A / 4 - 48 V DC
K16A*"P2RF-05-PU"*	AUX RELAY.VERTICAL REFRIGERATION	2 A / 4 - 48 V DC
K17A *"P2RF-05-PU"*	AUX RELAY. METAL DETECTOR	2 A / 4 - 48 V DC
K18A *"P2RF-05-PU"*	AUX RELAY. LABELLING MACHINE	10 A / 250 Vac
K19A *"P2RF-05-PU"*	AUX RELAY. “TROQUEL” PID	10 A / 250 Vac
K20A *"P2RF-05-PU"*	AUX RELAY. RIGHT WEIGHT DOWNLOAD	2 A / 4 - 48 V DC

K21A *"P2RF-05-PU"*	AUX RELAY RIGHT WEIGHT SIGNAL	2 A / 4 - 48 V DC
K22A" *P2RF-05-PU"*	AUX RELAY. LEFT WEIGHT SIGNAL	2 A / 4 - 48 V DC
K23A *"P2RF-05-PU"*	AUX RELAY. VACUUM	2 A / 4 - 48 V DC
K24A *"P2RF-05-PU"*	AUX RELAY. RAISE DISPENSER VASE	10 A / 250 Vac
K25A *"P2RF-05-PU"*	AUX RELAY. LOW DISPENSER VASE	10 A / 250 Vac
K26A *"P2RF-05-PU"*	AUX RELAY. RIGHT COIL CENTER ENGINE	10 A / 250 Vac
K27A *"P2RF-05-PU"*	AUX RELAY. LEFT COIL CENTER ENGINE	10 A / 250 Vac
K28A *"P2RF-05-PU"*	AUX RELAY. SCREW-DOSER DOOR DETECTOR	10 A / 250 Vac
K30A *"P2RF-05-PU"*	AUX RELAY. SERVODRIVE	10 A / 250 Vac
K30B *"P2RF-05-PU"*	AUX RELAY. RESET	10 A / 250 Vac
K31A *"P2RF-05-PU"*	AUX RELAY. UV LIGHT	10 A / 250 Vac
K32A *"P2RF-05-PU"*	AUX RELAY. ELECTRICITY REMOVER	10 A / 250 Vac
K33A *"P2RF-05-PU"*	AUX RELAY. HOPPER MIXER	10 A / 250 Vac
K33bA *"P2RF-05-PU"*	AUX RELAY. CRUSHED ICE	10 A / 250 Vac
K34A *"P2RF-05-PU"*	AUX RELAY. CRUSHER	10 A / 250 Vac
K35A *"P2RF-05-PU"*	AUX RELAY. CONVEYOR BELT INVERSOR.	10 A / 250 Vac
K36A *"P2RF-05-PU"*	AUX RELAY. FINAL DETECTOR. 45º	10 A / 250 Vac
K37A *"P2RF-05-PU"*	AUX RELAY. FINAL DETECTOR. 0º	10 A / 250 Vac
K38A *"P2RF-05-PU"*	AUX RELAY. UNWINDER	10 A / 250 Vac
K39A *"P2RF-05-PU"*	AUX RELAY. VACUUM PUMP	10 A / 250 Vac
K40A *"P2RF-05-PU"*	AUX RELAY. SCREW-DOSER DOOR	10 A / 250 Vac
K1M *"LC1D12"*	CONTACTOR "ON CARRUSEL"	25 A, AC1 /12 A, AC3
K2M "J7KNA-AR-22"	EMERGENCY REDUNDANT MINI CONTACTOR	
K4M *"LC1D12"*	VOLUMETRIC DISPENSER CONTACTOR - SCREW-DOSER	25 A, AC1 /12 A, AC3
K5M *"LCD12"*	HOPPER MIXER CONTACTOR	25 A, AC1 /12 A, AC3
K7M *"LC1D12"*	CONVEYOR BELT CONTACTOR	25 A, AC1 /12 A, AC3
K7bM *"LC1D12"*	SCREW-DOSER MIXER CONTACTOR	25 A, AC1 /12 A, AC3
K10M *"LC1D25"*	POWER CONTACTOR.	40 A, AC1 /25 A, AC3
K11M *"LC1D25"*	POWER CONTACTOR.	40 A, AC1 /25 A, AC3
K12M *"LC1D25"*	POWER CONTACTOR. SERVODRIVER/DRAGGING	40 A, AC1/25 A, AC3
K13M - Omron-J7KNA-09-10	RIGHT COIL CENTER CONTACTOR	10 A DC 24V
K14M -Omron-J7KNA-09-10	LEFT COIL CENTER CONTACTOR	10 A DC 24V
K15M *"LC1D12"*	UP DISPENSER VASE CONTACTOR	25 A, AC1 /12 A, AC3
K16M *"LC1D12"*	LOW DISPENSER VASE CONTACTOR	25 A, AC1 /12 A, AC3
K17M *"LC1D12"*	POWER ELEVATOR/SCREWDOSER INVERTER CONTACTOR	25 A, AC1 /12 A, AC3
K21M *"LC1D25"*	ICE SIFTER CONTACTOR	25 A, AC1 /12 A, AC3
K23M *"LC1D25"*	VACUUM CONTACTOR	25 A, AC1 /12 A, AC3
K33BM *"LC1D25"*	CRUSHED ICE VIBRATOR CONTACTOR.	25 A, AC1 /12 A, AC3
K39M *"LC1D12"*	CONTACTOR VACUUM PUMP	25 A, AC1 /12 A, AC3
K40M *"LC1D12"*	CONTACTOR COIL SPLICER	25 A, AC1 /12 A, AC3

M1S *"R88M-G75030H-S2"*	JAWS SERVOMOTOR	1 KW
M2S *"R88M-G40030H-S2"*	RIGHT DRAGGING SERVOMOTOR.	200 W
M3S *"R88M-G40030H-S2"*	LEFT DRAGGING SERVOMOTOR	200 W
M4S *"R88M-K1K520F-S2"*	SCREWDOSER SERVOMOTOR	400
M2M *"M.ASINC 1350rpm"*	RIGHT DRAGGING ENGINE	0.25 KW - 1 A
M3M *"M.ASINC 1350rpm"*	LEFT DRAGGING ENGINE	0.25 KW - 1 A
M4M *"M.ASINC 1370rpm"*	VOLUMETRIC DISPENSER ENGINE	0.37 KW - 1.2 A
M5M*"Spaggiari SW063FA"*	HOPPER MIXER ENGINE	0.37 KW - 1.2 A
M7M *"M.ASINC 1370rpm"*	CONVEYOR BELT ENGINE	0.37 KW - 1.2 A
M7bM*"M.ASINC1370rpm"*	SCREWDOSER ENGINE	0.37 KW - 1.2 A
M15M *"M. ASINC"*	RAISER - LOWER DISPENSER ENGINE	90W – 0.5 A
M19M*"M.ASINC 1500rpm"*	TABLE ENGINE	0.75KW – 2A
M21M*"M.ASINC 1350rpm"*	ICE SIFTER ENGINE	0.12KW – 0.5A
M38M *"M.ASINC1370rpm"*	UNWINDER ENGINE	0.37 KW - 1.2 A
M39M *"M.ASINC1680rpm"*	VACUUM PUMP ENGINE	1.25 KW - 3.3 A
PID _V *"E5CD"*	VERTICAL WELDING TEMPERATURE CONTROLLER	220 V / 35 mA
PID _HI *"E5CD"*	INTERIOR HORIZONTAL WELDING TEMPERATURE CONTROLLER	220 V / 35 mA
PID _HE *"E5CD"*	EXTERNAL HORIZONTAL WELDING TEMPERATURE CONTROLLER	220 V / 35 mA
PID _T *"E5CD"*	TROQUEL WELDING TEMPERATURE CONTROLLER	220 V / 35 mA
Q1M "A9F79425"	Magneto. MAIN 3+N	20 A
R1	VERTICAL WELDING RESIST.	400w
R2	HORIZ INTERNAL WELDING RESIST.	150W-200W x 2
R3	HORIZ EXTERNAL WELDING RESIST.	150W-200W x2
R8	DRAG REGENERATION RESIST.	150W
R10	TROQUEL WELDING RESIST.	165W
S1	TRIPOLAR SECTIONER 3+N	---
S2, S3 *"D4DS-1AFS"*	FINAL DOOR RACE	2 A / 240V
S4 "ZBE 102"	EMERGENCY BUTTON	
SHE *"G3PB-215B"*	EXTERNAL HORIZ WELD SOLID STATE RELAY.	15 A (max)
SHI *"G3PB-215B"*	INTERNAL HORIZ WELD SOLID STATE RELAY	15 A (max)
ST *"G3PB-215B"*	TROQUEL WELD SOLID STATE	15 A (max)
SV *"G3PB-215B"*	VERTICAL WELDING SOLID-STATE RELAY	15 A (max)
T1 *"CEL-4"*	ELECTRICITY REMOVER	Up 220V / IP 0.2A Us. 4000VA / Is 2.5mA
TC1 "E5C2"	REGULATOR Ta MARCOPACK	220V/2VA
U0 *"NS5"*	TACTIL SCREEN	24 Vdc / 15W
U1 *"R88D-GP08H"*	JAWS SERVODRIVER	1KW
U2, U2B *"R88D-GT04H"*	LEFT/RIGHT DRAGGING SERVODRIVER	200w
U2I *V1000"YASKAWA*	LEFT DRAGGING FREQUENCY CONVERTER	1.1 KW
U2D *V1000"YASKAWA*	RIGHT DRAGGING FREQUENCY CONVERTER	1.1 KW
U4 *"R88D-KT15F"*	SCREWDOSER SERVODRIVER	400w
U4 *J1000"YASKAWA*	VOLUMETRIC FREQUENCY CONVERTER	1.1 KW
U6	VIBRATOR TRAY REGULATOR	----
U7	VIBRATOR MULTIHEAD REGULATOR	----
U19 *J1000"YASKAWA*	TABLE FREQUENCY CONVERTER	
U38 *J1000"YASKAWA*	UNWINDER FREQUENCY CONVERTER	0.37 KW

X1 "L1,L2"	220V TERMINALS CONNECTION	220 Vac
X2 "+,-"	TERMINALS DC CONNECTION	24 Vdc
X3 "L3,L4"	TERMINALS FORCE CONNECTION 220 V (WITH EMERGENCY)	220 Vac
X4 "R1,S1,T1"	FORCE CONNECTION TERMINALS 380 V	380 Vac / 3 Ph
X5	PLC INPUT TERMINALS (0.xx)	24 Vdc
X6	PLC OUTPUT TERMINALS (1.xx)	24 Vdc
X7	PLC OUTPUT TERMINALS (2.xx)	24 Vdc
X8 "L31,L41"	SERVO TERMINALS CONNECTOR	220 Vac
X_HE	EXTERNAL HORIZ WELDING CONNECTOR	5 Pins
X_HI	INTERNAL HORIZ WELDING CONNECTOR.	5 Pins
X_T	TROQUEL WELDING CONNECTOR.	5 Pins
X_V	VERTICAL WELDING CONNECTOR	5 Pins
XS_C	EXTRACTOR TAPE CONNECTOR	3Ph - 380V
XS_CA	CONVEYOR BELT CONNECTOR	3Ph - 380V
X_D	SCREWDOSER DOSIFIER CONNECTOR	16 pins
XS_R	MIXER FORCE CONNECTOR	3Ph - 380V
Y32	TRAY VIBRATOR	----
Y34	MULTIHEAD VIBRATOR	----
Y0M "SMC"EAV3000-F03-5YZ-Q	PROGRESSIVE OPENING ELECTROV.	24vdc
Y2M "Joucomatic"52000163	VERTICAL WELDING ELECTROV.	24vdc
Y3M "Joucomatic"52000163	BLADE ELECTROV.	24vdc
Y4M"Joucomatic"52000163	UNWINDER ELECTROV	24vdc
Y5M"Joucomatic" 52000163	EUROPEAN TROQUEL ELECTROV.	24vdc
Y6M "Joucomatic"52000163	ENGLISH FOLD ELECTROV.	24vdc
Y7M "Joucomatic"52000163	RETAINER CLAMPS ELECTROV.	24vdc
Y8M "Asco 1/4 SCE272A018"	HORIZONTAL REFRIGERATION ELECTROV.	24vdc
Y9M "Asco 1/4 SCE272A018"	VERTICAL REFRIGERATION ELECTROV.	24vdc
Y10M "Joucomatic"52000163	BAG VIBRATOR ELECTROV	24vdc
Y11M "Joucomtic"	DRAGGING ELECTROV.	24vdc
Y12M "End of Race"	LAMINAR BRAKE ELECTROV.	24vdc
Y13M "Asca 1/4 SCE272A018"	INERT GAS ELECTROV.	24vdc
Y14M "Joucomatic52000163"	BENDER ELECTROV.	24vdc
Y15M "Joucomatic 52000163"	FLUFFY ELECTROV.	24vdc
Y17M "Joucomtic 52000163"	VACUUM PLUNGER ELECTROV.	24vdc
Y18M "Joucomtic 52000163"	EXTERNAL PACKAGES COUNTER ELECTROV.	24vdc
Y19M "Joucomtic 52000163"	LEFT ACCUMULATOR ELECTROV	24vdc

Y20M "Joucomtic 52000163"	RIGHT ACCUMULATOR ELECTROV	24vdc
Y23M "Joucomtic 52000163"	EDGES BLOCK CLOSE ELECTROV.	24vdc
Y24M "Joucomtic 52000163"	EDGES SIGNAL ELECTROV.	24vdc
Y25M "Joucomtic 52000163"	SCREWDOSER DOOR ELECTROV.	24vdc

CAPTION RS NS5

DRIVER'S NOMENCLATURE

Nomenclature	*Description*
	Power Drivers
R, S, T	Three-phase input power conductors
R1, S1, T1	Three-phase power supply from output protective contactors
L1, L2	Power supply 220V differential output (F1)
L3, L4	Power supply 220V output Seta Emergency
(+), (-)	Positive and negative power supply 24 Vdc. Output from F. Power
	PLC Input Drivers
0.00	Pair Maximum Servo Clamp **U1. CN1**
0.01	Counter Detector Degrees **Tilted –B27-**
0.02	Encoder Input Dragging –**B3-**out-A
0.03	Encoder Input Dragging –**B3-**out-B
0.04	Unwinder Detector –**B12-**
0.05	SP Multihead / In weight –**K2A-**
0.06	Detector Safety Machine (Pressure Clamps) –**B5-**
0.07	Cell Detector Input Dragging –**B1-**
0.08	PLC Emergency INPUT –**S4-**
0.09	PLC Security Door Inputs –**K10M, K11M-**
0.10	March unwinder – **B32 -**
0.11	Servo position Signal Screw-doser- **U4 cn1-**
1.00	Next Source Detector –**B4-**
1.01	Volumetric Dosing Detector –**B13-**
1.02	Multihead Vibration Detector–**K4A-**/Detector (Max. Level)-**B14**
1.03	Servo Jaw Alarm –**U1. CN1_Pin 12-**
1.04	Variable Alarm Drag –**U2. MB-**
1.05	Encoder Alarm –**K13A-**
1.06	Metal Detector Alarm –**K17A-**
1.07	Grouping Alarm –**K15A-**
1.08	Cell Counter External Packages **-B24-**
1.09	Signal Pedal Discharge (MP1)
1.10	Signal Position Jaw –**U1. CN1_Pin 14-**
1.11	Screw-doser and volumetric Servo Alarm –**U4.cn1-**
2.00	Centered Cell Non Plastic Coil **–B20-**
2.01	Centered Cell Plastic SI Coil **–B21-**
2.02	Minimum Volumetric Dispenser **–B22-**
2.03	Maximum Volumetric Dispenser **–B23-**
2.04	C.A. Detector (Max. Endless Volume in RS DV and DS)**–B14b**
2.05	Minimum Ice Dosing Detector **–B16-**
2.06	Volumetric drive alarm (RS DV and DS)

2.07	Thermal Relay Alarm Elevators
2.08	Screw-doser Door Detector **-B19-** / Final Detector 45o **-B25-**
2.09	Final Detector 0o **-B26-**
2.10	Left End Detector **-B17-**
2.11	Right Final Detector **–B18-**

	PLC Output Drivers
1000	Servo Jaws CW **CN1 –-U1**
1001	CCW NC1 Clamps Servo **-U1**
1002	Servo Dragging CW **CN1–U2 U3-**Servo Screw-doser CW-**U4**
1003	Servo Dragging CCW **CN1 –U2 U3-/** Servo Screw-Doser CCW-**U4**
1004	Dater On/Off **–K11A-**
1005	Dater marker **–K10A-**
1006	Conveyor Belt **–K9A-**
1007	Unwinder ENGINE **–K38A-/** Rewinding Cylinder **–Y4M-**
1100	Volumetric Discharge **–K3A-**/ Multihead DP **–K3A-**
1101	Solenoid valve Vertical welding **–Y2M-**
1102	Blade solenoid valve **–Y3M-**
1103	Inert Gas **–K7A-**
1104	Welding PID'S (E5CB) **–K12A-**
1105	Run Servo Jaw **–CN1–U1-**
1106	Run Drive Dragging **–U2. S1-** Run Servo Dragging **–CN1–U**2**U3-**
1107	Power Supply Servo Clamp **–K30A-**
1200	English Fold Electrov.**–Y6M-**
1201	Clamps Electrov.**–Y7M-**
1202	Horizontal Cooling **–K6A-**
1203	Volumetric Hopper Mixer and Screw-doser **–K33A-**
1204	S5 Drive Dragging V1000
1205	Doubler – Expulsor Bag**–Y14M-EXT** (external signal)
1206	Vertical Cooling **–K16A-**
1207	Crushed Ice Vibrator**–K33bA**
1300	Low Dispenser **–K25A-**
1301	Up Dispenser **–K24A-**
1302	Plunger or Vacuum Electrov. **–Y17M-**
1303	Screw-doser Servo Run-**U4-** / S1 Left 0º
1304	Screw-doser Feeder Inverter **–K35A-**
1305	Labeller **–K18A-**
1306	Screw-doser Door **-Y25M-** / S2 Right 45o
1307	Electricity remover **–K32A** Ultraviolet Light **–K31A-** Ice Crusher-**K34A**
1400	Left Coil Center – **K26A-**
1401	Right Coil Center – **K27A-**
1402	Edges Signal Electrov.**–Y24M-**
1403	**-** ON/OFF European "Troquel" Welding **–K19A-**
1404	External Package Counter Electrov. **Y18M** r
1405	European "Troquel" Electrov **–Y5M-**
1406	Vacuum Pump belts Dragging engine **K39A**

1407	Electrov. Block Closes Edges**–Y23M-**
1500	
	Welding drivers
SO	Powering phase PIDs for Temperature control
Sv	Vertical Welding Power resistance
Shi	Internal horizontal welding power resistance.
SHE	External horizontal weld power resistance.
S+, S-	Positive and negative thermocouple connection for Temperature reading
	Dragging and Unwinder Conductors
AVA	Dragging Frequency Drive Alarm (NC)
V+, RP	Pulse Input for Dragging Reference Speed (Vref)
Has	Pulses Dragging PLC Output
	Dater Drivers
ACO	Encoder alarm
CO	Encoder power *(Phase)*
SF	Signal Dater, performs date marking on bag
ALM	Negative for detecting Dater and Servo-Driver alarms
	Other Drivers
S12	Positive loop (+V) for door safety Category 3
S22	Negative loop (- 0 V) for door safety Category 3
SE	Label signal
ALA	Grouping Alarm
ALD	Metal Alarm
SP	Multihead Signal
DP	Signal given to the Multihead for Download
SV	Multihead Signal Vibrator
SVM	Multihead Signal Feeder

VARIADOR DRAGGING BY COMMUNICATIONS

CIF011 **INVERTER** CONNECTOR

RDA - ---------- R- , S- (bridge)

RDB + ---------- R+ , S+ (bridge)

- Dragging by communications

CIF 11 BACK CONNECTOR

1st ON
2nd ON
3rd ON
4th OFF
5th ON
6th ON

OMRON MATERIAL MACHINE CONFIGURATION

-SCREEN:	**NS5 SQ0B**
-PLC:	**CP1LE EM40CDT D (24-16)**
-MODULE:	**CP1W CIF11 (DRAGGING COMMUNICATIONS)**
-MODULO:	**CP1W 20EDT (12-8)**
-MODULE:	**CP1W 8ET (8) SCREWDOSER**
-MODULE:	**CP1W 8ET (8) OPTIONAL EXTRAS**