

Connections for CNC coilers and systems incl. Orbit

Main power supply:

3x400-480 VAC Volts + Ground and no neutral, 50/60Hz, 25 Amps, 6 kW

Compressed air supply:

6 Bar (connector R1/4"). Machine regulator set to 5,5 Bars.

Signal Interface to line:

Harting 24-p HAN Female connector, Male cable connector included in delivery.

Pin no.	Description	Function
1	External +24 VDC in	For Error and Ready
2	Error output (+24 VDC)	+24 VDC when machine fault
3	Ready output (+24 VDC)	+24 VDC spring ready for delivery
4	Spare	No function
5	External 0V in	For external starts
6	External start 1 (+24 VDC)	>200 ms input gives one spring
7	External start 2 (+24 VDC)	>200 ms input gives one spring
8	Spare	No function
9	Spare	No function
10	Spare	No function
11	Spare	No function
12	Spare	No function
13	Spare	No function
14	Spare	No function
15	Spare	No function
16	Spare	No function
17	Internal 0 V out	Used for external units
18	Internal +24 VDC out	Used for external units
19	Line e-stop circuit NC	Option
20	Line e-stop circuit NC	Option
21	E-stop safety relay signal NC	Opens when security circuit is released
22	E-stop safety relay signal NC	Opens when security circuit is released
23	Safety circuit jumper	23 and 24 connected
24	Safety circuit jumper	23 and 24 connected
PE	Ground	Ground

READY: High when system is ready to deliver one spring, low during spring production.
Connect 24 VDC to pin no. 1. Signal will be on pin no. 3.

ERROR: Normally low, high when alarm, fault or E-stop occurs.
Connect 24 VDC to pin no. 1. Signal will be on pin no. 2.

START 1: Deliver one spring if a >200 ms 24 VDC signal is given, if READY is high and ERROR is low. Connect 0 VDC to pin no. 5. When 24 VDC is given to pin 6, one spring is delivered.

All signals are using relays.

External START only works with key, on operator's panel, in AUTO mode.

JUMPER BETWEEN PIN NO.23 AND 24 MUST BE PRESENT FOR MACHINE ENABLING.