

2 - Axis Pick & Place

SIPN

| Signal | Symbol | I/O | Logic |
|---------------------|--------|-----|---------------------------|
| Base at place | SB_P | I | |
| Lid at place | SL_P | I | |
| Base clamped | SB_M | I | |
| Lid clamped | SL_M | I | |
| Part leaving | S_L | I | Assembled part leaving |
| Item detected | ST_D | I | Item detected under tool |
| Moving X | ST_X | I | Tool moving along x-axis |
| Moving Z | ST_Z | I | Tool moving along z-axis |
| Base clamp at limit | SBC | I | Clamp at top/bottom limit |
| Lid clamp at limit | SLC | I | Clamp at top/bottom limit |
| Base emitter | AB-E | O | Emit base |
| Lid emitter | AL-E | O | Emit lid |
| Base clamp | AB-M | O | Clamp base |
| Lid clamp | AL-M | O | Clamp lid |
| Base conveyor | AB-C | O | |
| Lid conveyor | AL-C | O | |
| Move X | AT_X | O | Move tool down x-axis |
| Move Z | AT_Z | O | Move tool down z-axis |
| Grab | AT_G | O | Grab part with tool |
| Raise Base clamp | RB-M | O | |
| Raise Lid clamp | RL-M | O | |



