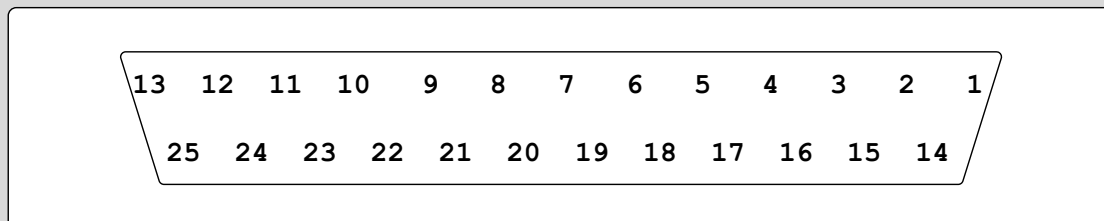


## 9 Active communication and signal flow

### STO\_2\_1 Inputs



### 9.1 Inputs on STO\_2\_1 (DSUB25)

Pin	Signal	Description
①	+24VDC_IO_IN	external supply voltage +24VDC
2	+24VDC_IO_IN	external supply voltage +24VDC
③	START_1_EXT_IO_IN	external start signal for start mode automatic
④	START_2_EXT_IO_IN	external start signal for start mode automatic
⑤	STOP_IN	abort cycle → 超声波循环的停止 (外部输入)
⑥	US_TEST_IN	power loss measurement → 功率测试 (外部输入)
7	US_STOP_1_IN	stop ultrasonic (24VDC)
8	US_STOP_2_IN	contact cut off (GND)
⑨	RESET_IN	error acknowledgment 错误信息的复位
10	TRIGGER_IN	external trigger
11	START_CONFIRM_IN	start confirm (option enable)
12	READY_CONFIRM_IN	ready confirm (option enable)
13	RESERVE_13_IN	
⑭	DATASET_1_IN	data set switching
⑮	DATASET_2_IN	data set switching
⑯	DATASET_3_IN	data set switching
⑰	DATASET_4_IN	data set switching
⑱	DATASET_5_IN	data set switching
19	SSK_CABINE_IN	sound enclosure door closed (option enable)
20	SSK_CABINE_LIFT_IN	lift door not closed (option enabled)
21	RESERVE_21_IN	
22	RESERVE_22_IN	
23	AMPL_AIN	analogue amplitude input 0-10VDC (0-100% amplitude)
⑳	GND24VDC_IO_IN	external supply voltage GND
25	GND24VDC_IO_IN	external supply voltage GND

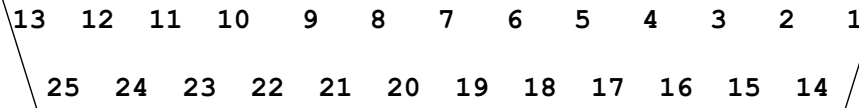
接外部+24V电源，  
pin1与pin2都需要接

接外部+24V启动电源，并保持一定的  
时序，当sto\_2-2 ping 13信号off后中断启动信号

5组可外部调用的数据库端

外部24V电源的接地  
-24V), Pin24与Pin25任接其一。

## STO\_2\_2 Outputs



## 9.2 Outputs on STO\_2\_2 (DSUB25)

Pin	Signal	Description
①	+24VDC_IO_IN	external supply voltage +24VDC
②	+24VDC_IO_IN	external supply voltage +24VDC
3	ERROR_HIGHPRIO_OUT	high priority error (turn off generator)
④	ERROR_OUT	error 错误信号
5	ERROR_CODE1_OUT	error code
6	ERROR_CODE2_OUT	error code
7	ERROR_CODE3_OUT	error code
⑧	READY_OUT	ready for new cycle 新的一个循环已准备好。
9	US_ACTIVE_OUT	ultrasonic activated
⑩	RESTPOS_OUT	rest position press 气缸的零点信号（零点）
11	RESERVE_11_OUT	
12	START_OUT	start cycle done
13	MV_OUT	magnetic valve set (cylinder pre stroke/down)
⑭	START_RETURN_OUT	back stroke active (cylinder back stroke/up) 气缸电磁阀工作信号
⑮	GOOD_PART_COUNT_OUT	successful cycle finished 焊接后的产品为OK
⑯	BAD_PART_COUNT_OUT	cycle finished with error 焊接后的产品为NG
17	RESERVE_17_OUT	
18	RESERVE_18_OUT	
19	RESERVE_19_OUT	
20	SSK_MV_LIFTDOOR_OUT	magnetic valve lift door (option enable)
21	RESERVE_21_OUT	
22	RESERVE_22_OUT	
23	POWER_AOUT	analogue power output 0-10VDC (0-120% power)
⑳	GND24VDC_IO_IN	external supply voltage GND 外部24V的接地端。
25	GND24VDC_IO_IN	external supply voltage GND