**BILLET CASTER MACHINE OVERVIEW**

SAW MOTOR TABLE

3

2

4

ASSEMBLY

1 CUTTING MOTOR 1(11KW)

TRACTION MOTOR CONVEYER CONVEYER MOTOR CUTTING MOTOR 1(11KW)

CUTTING MOTOR 2(2.2KW)

5

**BILLET CASTER MACHINE OVERVIEW**

3

CONVEYOR MOTOR (0.75 KW)

DOL STARTER

(NOT CONTROLLED BY PLC)

**IM PLC (5 DI &3 DO)**

**6ES7 151 8AB01 0AB0**

2

CUTTING MOTOR 1 (11KW)

RDOL STARTER

(NOT CONTROLLED BY PLC)

CUTTING MOTOR 2 (2.2KW)

DOL STARTER

(NOT CONTROLLED BY PLC)

SAW MOTOR ON/OFF (5.5 KW)

DOL STARTER

(CONTROLLED BY PLC)

G-120 DRIVE (2.2KW)

PM-6SL3 224 0BE22 2UA0

CU-6SL3 244 0BB13 1FA0

2UA0

TRACTION MOTOR

(CONTROLLED BY PLC)

4

1

5