ddress	PLC comment	Device name	Pin	Bus type	Sheet ref. Sensor function
001.0	Identifier Pallet A in changer	=MA+SC-K5	1		/46.A2
001.1	Lower pallet fixing device open sensor 2 (right front)	=CM+MB.01-K2	10		/33.E4
001.1	Upper pallet forward stop switch	=CM+MB.01-K2	2		/31.E4
001.1	Operating panel Enable switch 1	=MA+SC-K3	10		/53.A3
001.1	Laser on	=MA+SC-K3	2		/61.B2
001.1	Identifier Pallet B in changer	=MA+SC-K5	2		/46.A3
001.1	No excess temperature motor	=MA+SC-K5	10		/47.D4
01.2	Lower pallet fixing device open sensor 3 (left front)	=CM+MB.01-K2	11		/33.E5
01.2	Lower pallet forward slow switch	=CM+MB.01-K2	3		/31.E5
01.2	Laser Emission indicator	=MA+SC-K3	3		/61.B3
01.2	Operating panel Enable switch 2	=MA+SC-K3	11		/53.A4
01.2	Lift frame up cylinder 1	=MA+SC-K5	3		/46.A4
01.2	Circuit breaker ON (Hydraulic)	=MA+SC-K5	11		/47.D5
01.3	Lower pallet forward stop switch	=CM+MB.01-K2	4		/31.E7
01.3	Lower pallet fixing device open sensor 4 (left rear)	=CM+MB.01-K2	12		/33.E7
1.3	Suction filter no excess temp.	=MA+SC-K3	12		/58.B7
1.3	Laser alarm	=MA+SC-K3	4		/61.B4
01.3	Lift frame down Cylinder 1	=MA+SC-K5	4		/46.A5
1.4	Upper pallet fixing device open sensor 1 (right rear)	=CM+MB.01-K2	5		/32.E2
1.4	Front Lift Plate at bottom	=CM+MB.01-K2	13		/68.E6
1.4	Laser warning	=MA+SC-K3	5		/61.B5
1.4	Lift frame end position cylinder 2	=MA+SC-K5	5		/46.A6
)1.5	Upper pallet fixing device open sensor 2 (right front)	=CM+MB.01-K2	6		/32.E4
01.5	Laser pierce detect flag	=MA+SC-K3	6		/61.B6
01.5	Lift frame end position cylinder 3	=MA+SC-K5	6		/46.A6
01.6	Upper pallet fixing device open sensor 3 (left front)	=CM+MB.01-K2	7		/32.E5
1.6	Laser reflection alarm	=MA+SC-K3	7		/61.B7
1.6	Lift frame end position cylinder 4	=MA+SC-K5	7		/46.A7
1.7	Upper pallet fixing device open sensor 4 (left rear)	=CM+MB.01-K2	8		/32.E7
1.7	Laser suction No excess temperature motor	=MA+SC-K3	8		/58.C3
001.7	Hydraulic oil level ok	=MA+SC-K5	8		/48.B3

TRUM	MPF TRUMPF Project-designation			Change number	Edited	Reviewed	Approved	Designation			Content PLC I/O list Sorting A (Ascending					
		I Sat at consmitted Irill again 1000 tings RE		34711-08	01.02.2024	01.02.2024		Circuit diagram TruLaser 1000 fiber BE	agram TruLaser 1000 fiber BE		address) Page 2					
		Project number	Vers.proj.	Doc.type		TCN521ZX 03.04.2023	TCN521ZX 17.05.2023	TCN520HU 17.05.2023	Document number	Doc. part	Version	Status	Id number	Sheet	Туре	Format
	China COPYRIGHT BY TRUMPF	93630-5-E1	03	E3S	Original record	TCN521TE	TCN521TE	TCN520HU	93630-5-201	002	03	RE	2815136	111 of 111	E1	А3