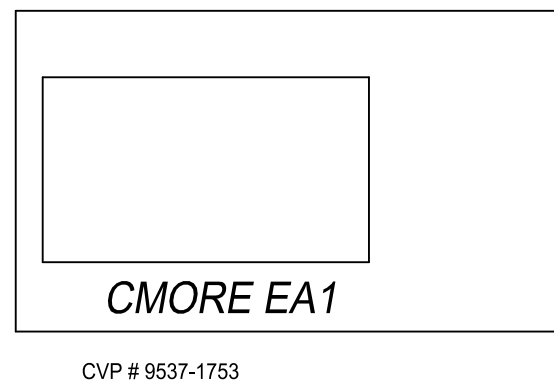
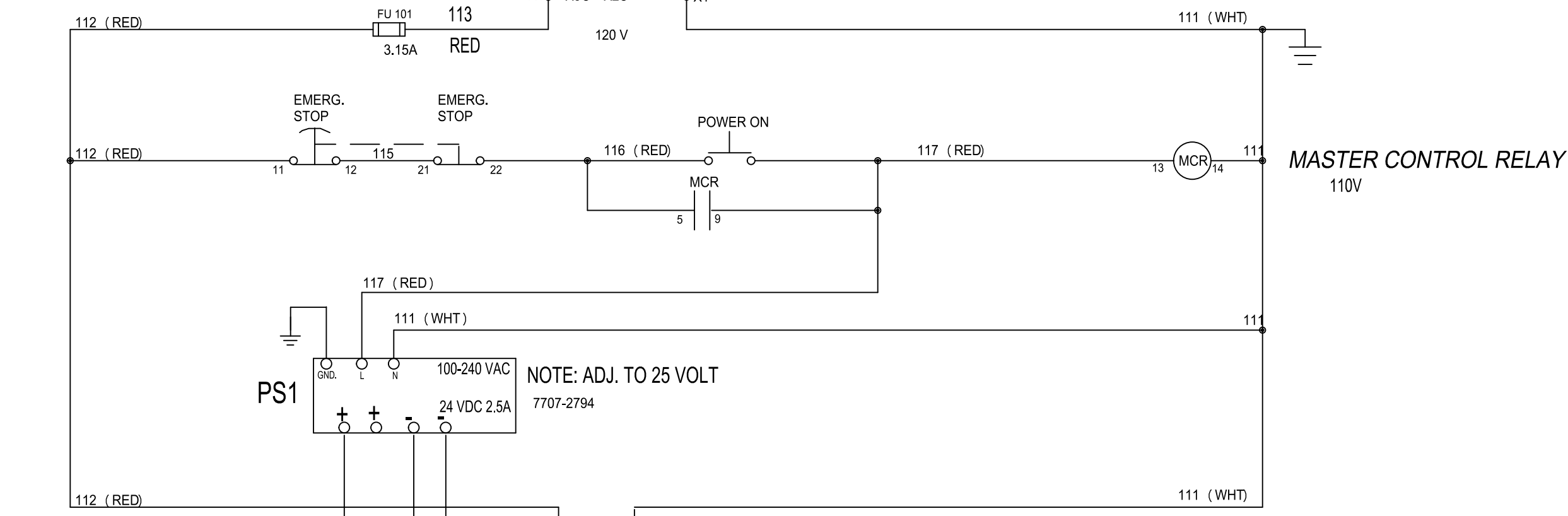
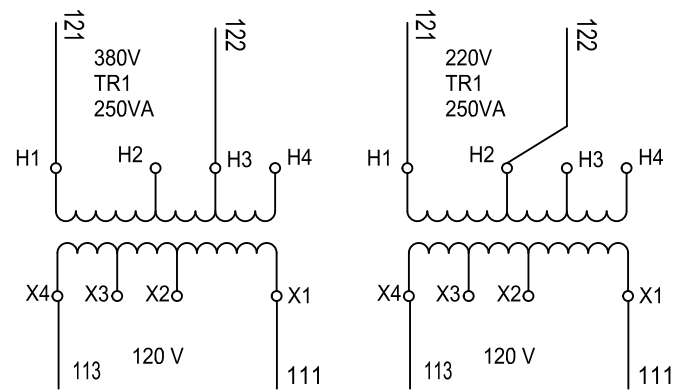
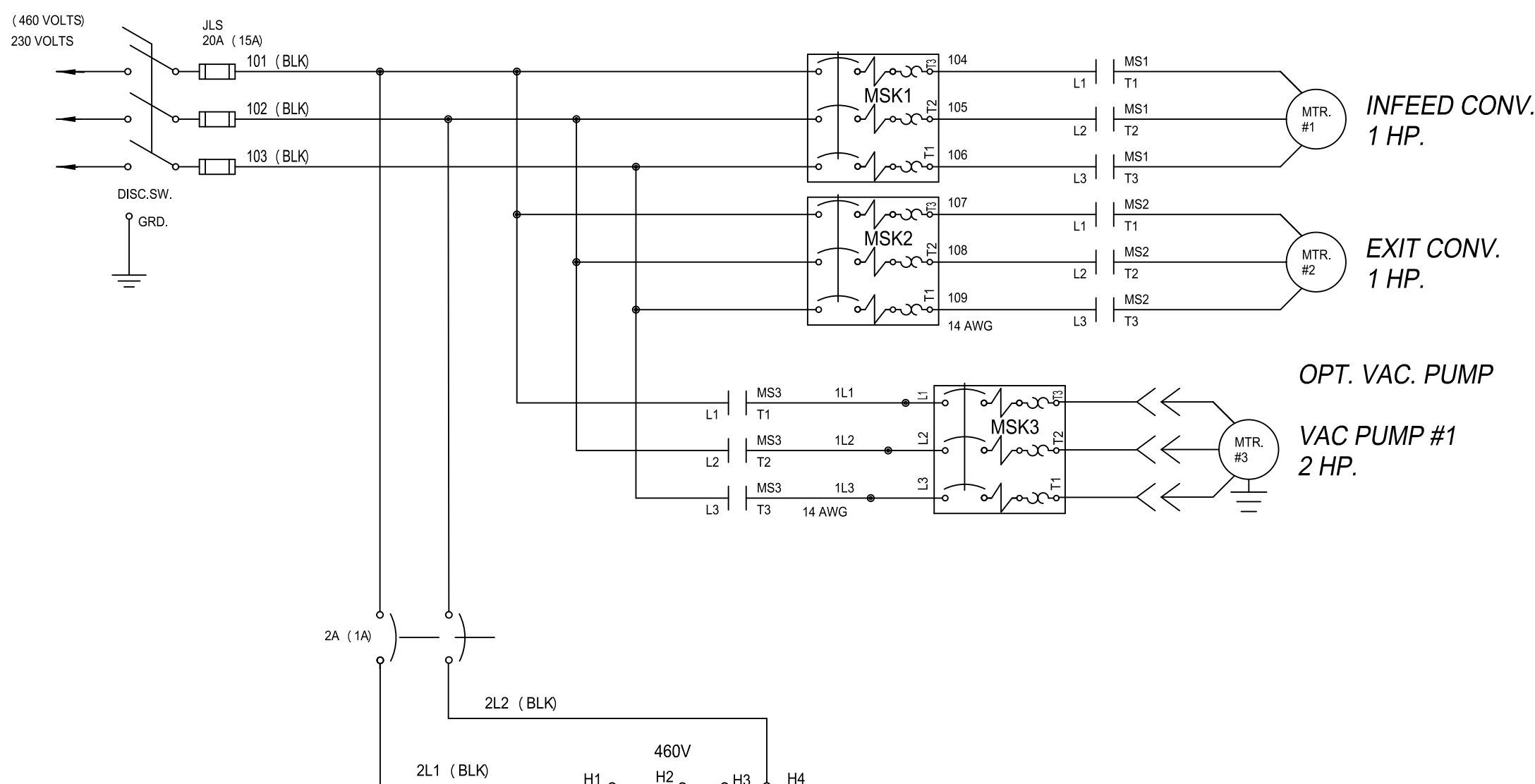


REVISIONS			
LTR	DESCRIPTION	DATE	APPRVD
A	RELEASED TO PRODUCTION	03/19/2015	NMB



PUSHER #1 RETR.

GAS PRESSURE (OPT.)

PUSHER #2 RETR.

INFEED APPROACH PE

PUSHER #3 RETR.

INFEED #1

INFEED #2

INFEED #3

EXIT #1

EXIT #2

EXIT #3

HEAD 1 LOAD REQUEST

HEAD 2 LOAD REQUEST

HEAD 3 LOAD REQUEST

STOP MAN. OVERRIDE

00 = AUTO 01 = STOP 1 UP
10 = STOP 2 UP 11 = STOP 3 UP

STOP MAN. OVERRIDE

TOTE INFEED #0

CONVEYOR STOP

CONVEYOR START

HEAD 4 DUMPING

HEAD 1 DUMPING

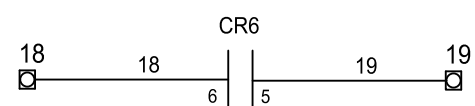
HEAD 2 DUMPING

HEAD 3 DUMPING

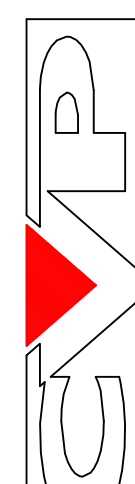
PUSHER #4 RETR.

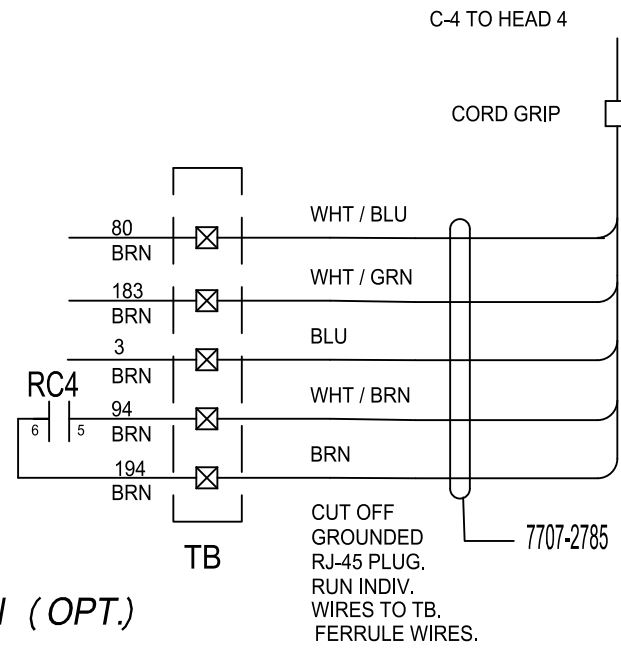
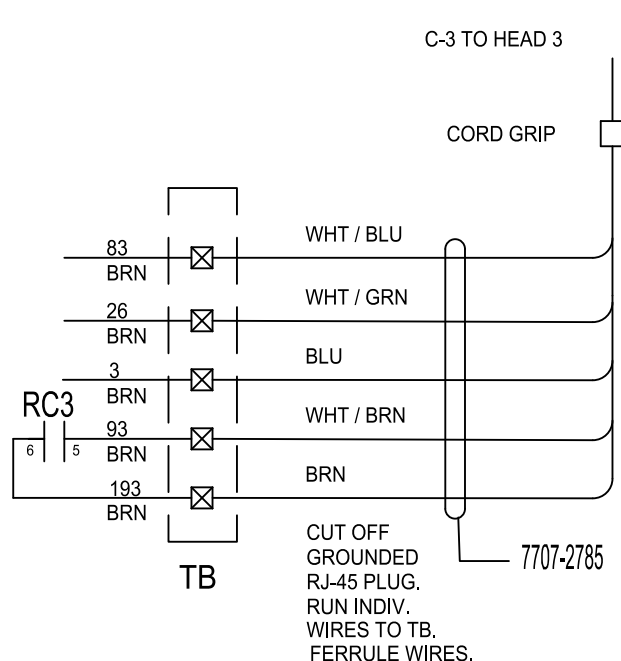
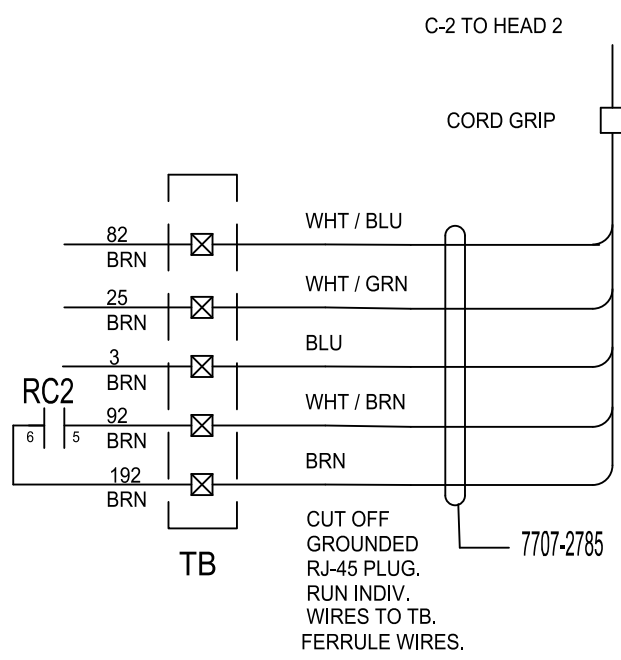
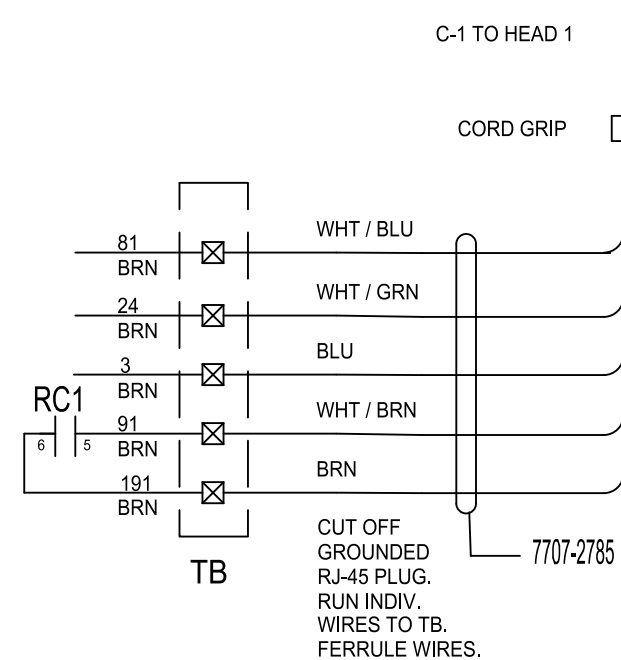
INFEED #4

HEAD 4 / LOAD REQUEST



DRY CONTACTS FOR FEED CONVEYOR CONTROL

ITEM	QTY	PART NO.	MATERIAL DESCRIPTION				NOTE	
MATERIAL			<div></div>				SCHEMATIC, CONVEYOR MULTI LINE, 24 VDC OUTPUTS KOYO DL06 PLC, CMORE 230V/ 380V/ 460V	REV A
FINISH								
QTY.			DRAWN MMB CHKD	DATE 03/19/2015	APPROVD RMI	DATE	DRAWING NO. D-0243-0879	
UNLESS OTHERWISE SPECIFIED: BREAK ALL SHARP CORNERS: 2.006 FOLLOWING TOLERANCES:			ANGLES FRACT. 2 PL DEC. 3 PL DEC. ±0.007 ±.005		SCALE	SHEET 1 OF 1		
±.004					—			



- NOTES:
- 1) FOR CABLE 0, FERRULE BOTH ENDS EXCEPT 4 COLORS, TIE TOGETHER ONE END IN TERMINAL 10.
 - 2) MACHINE 1 IS THE ONE NEAREST THE TOTE INFEED.
 - 3) OPTIONAL EXIT CONVEYOR PE, IS USED FOR AUTO SHUTDOWN OF EXIT CONVEYOR DURING TOTE BACKUP. MANUAL RESTART REQUIRED WHEN PE CLEAR.
 - 4) "INVERT PE" PRESET SHOULD BE SET = 1 WHEN EXIT CONVEYOR FLOW IS THE SAME DIRECTION AS THE TOP CONVEYOR AND SET = 0 WHEN OPPOSITE.
 - 5) ROUTE ALL NETWORK CABLES SEPARATE FROM POWER WIRING AND OUTSIDE OF PANEL WIREWAY.
 - 6) REFERENCE PNEUMATIC
D-9743-1481 (4 HEAD MACHINE)
D-9743-1187 (3 HEAD MACHINE)

PLC PROGRAM: MLCONVCM3A

(3 HEAD MACHINE,

PLC PROGRAM: MLCONVCM4A

(4 HEAD MACHINE,

SCREEN PROGRAM: MLCONVCM4