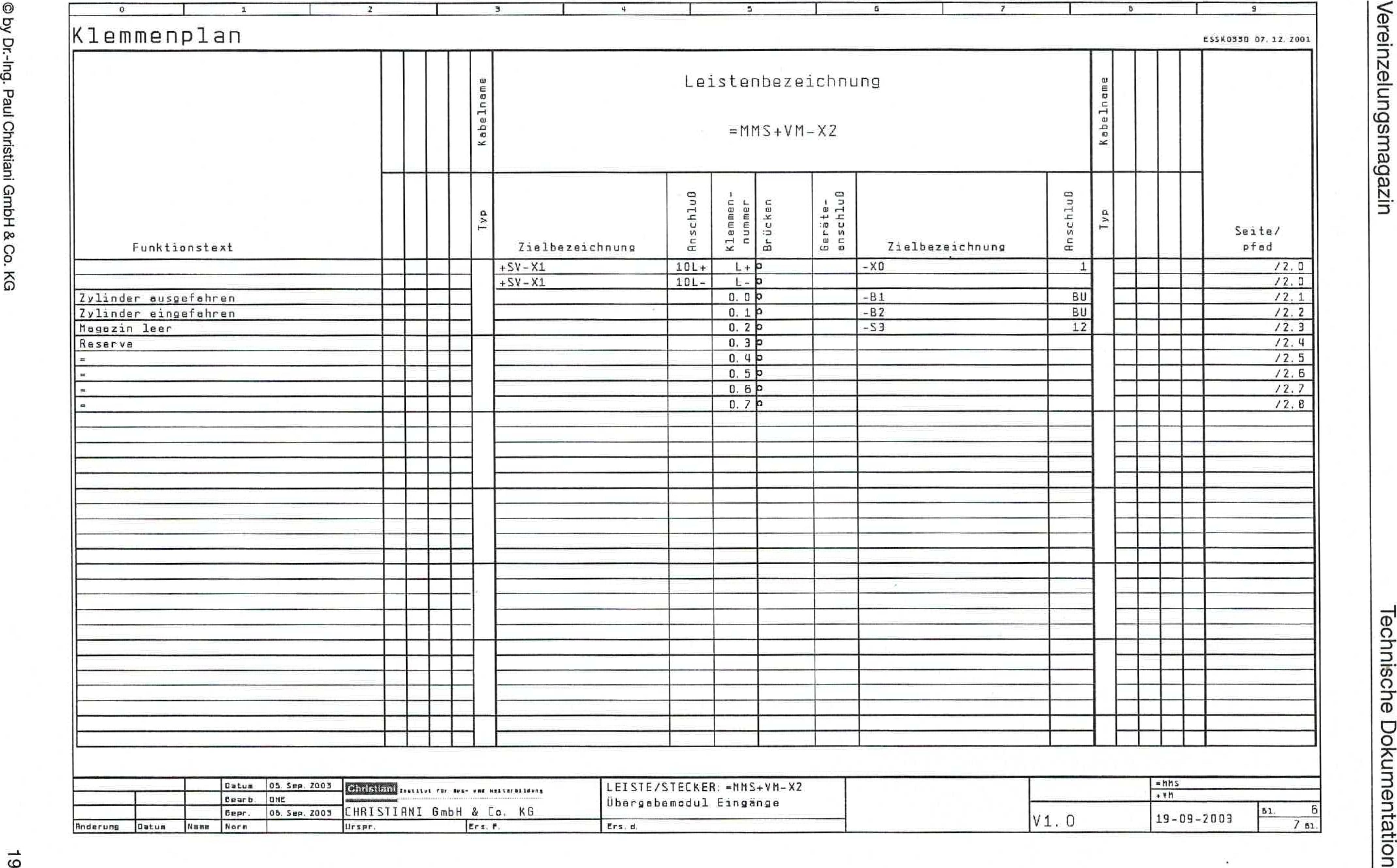
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Learning plan

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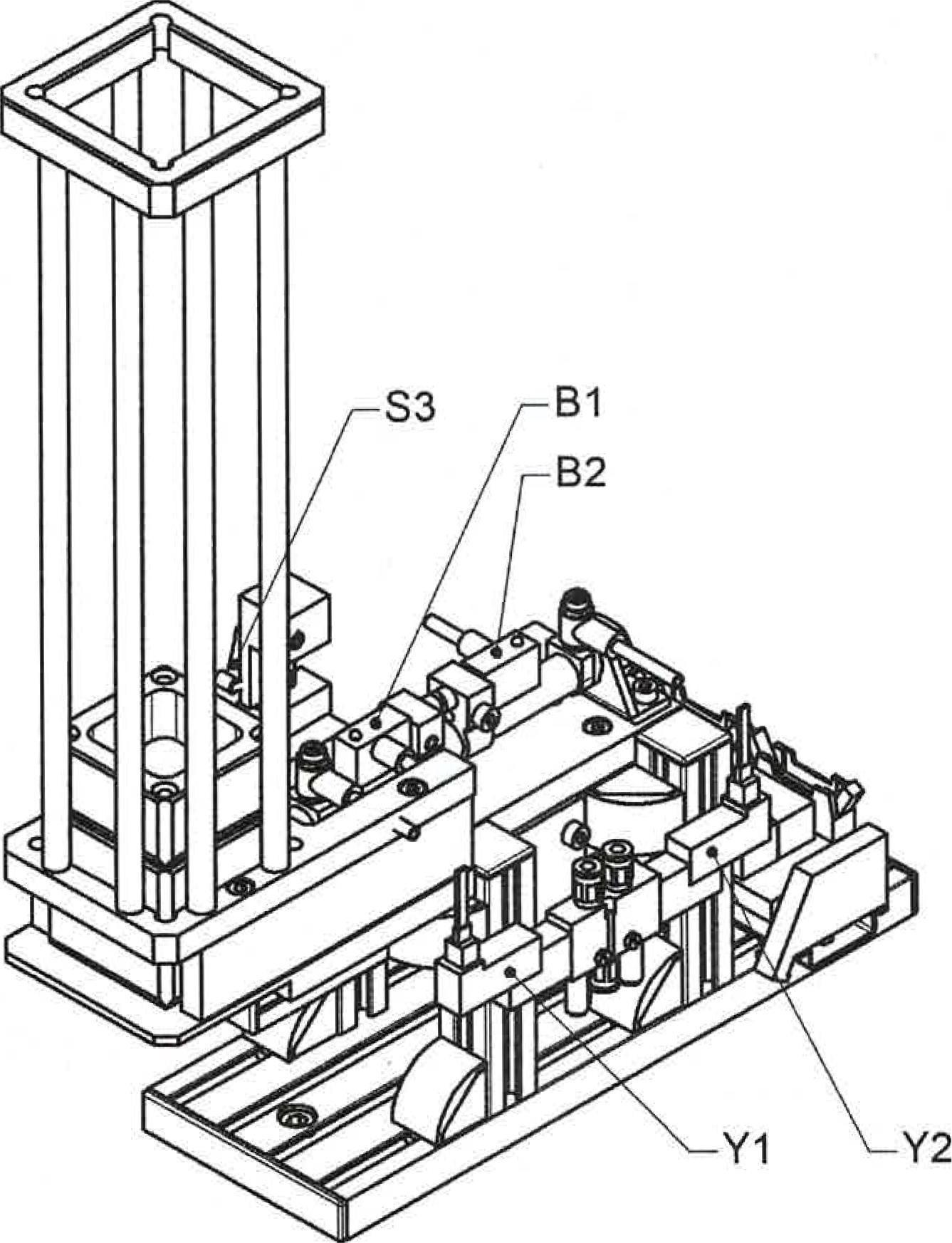
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**Technology scheme**

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**4.2 Function plan**

Separation magazine Technical documentation

Step 1

|  |  |  |
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| Forwarding conditions | **Function plan worksheet**  Steps | Actions |

|  |  |
| --- | --- |
|  | S Retract cylinder |
|  |

Step 4

Cylinder is retracted

Full level ok start signal

Step 2

Cylinder is extended

Step 3

Extend cylinder

— HS I Retract cylinder

Cylinder is retracted

Step 4

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Step 2

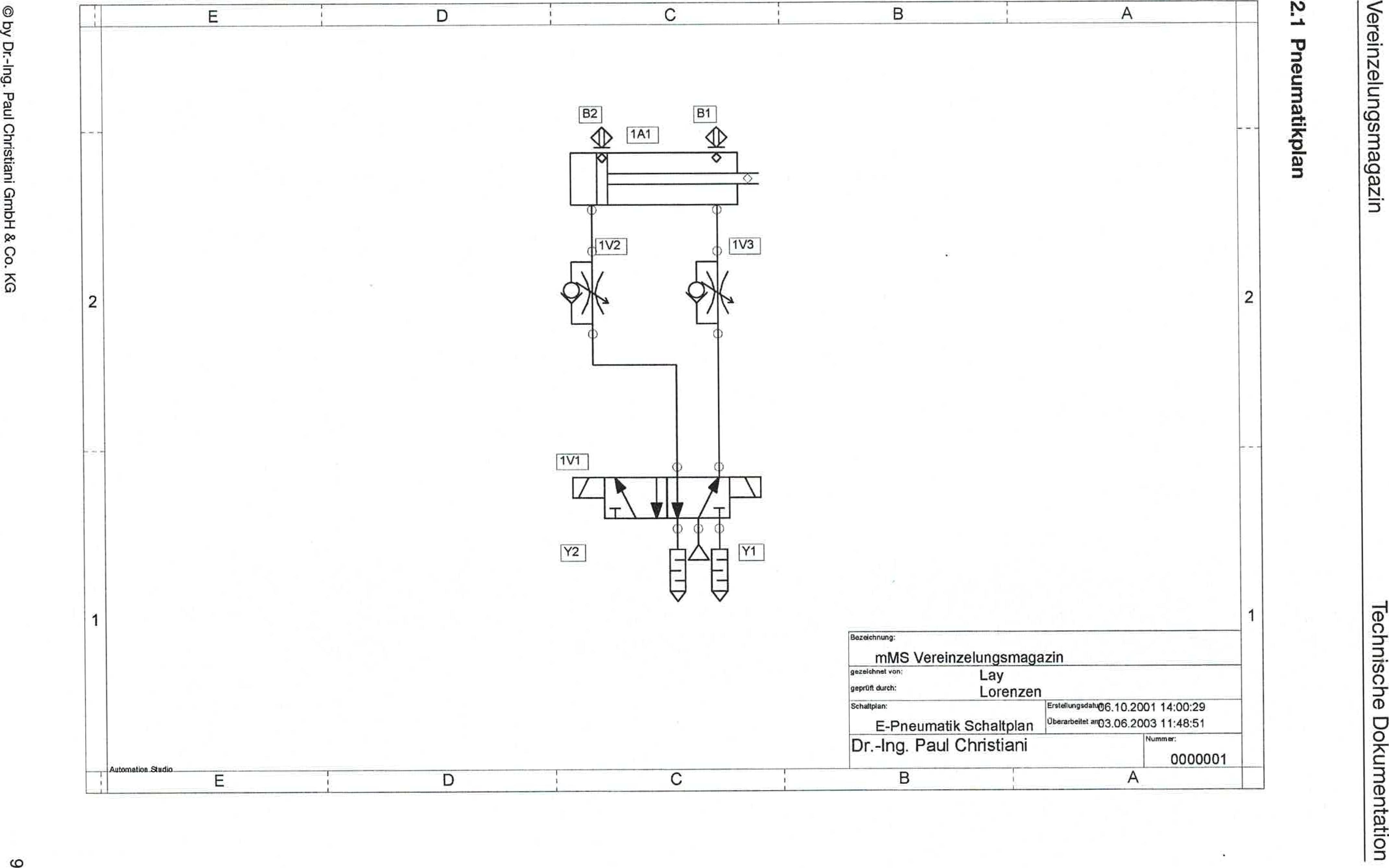
**1.3 Total stack list**

Separation magazine Technical documentation

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| **01.00 Carrier kit** | | | |
| **Item No.** | **Number** | **component** | **remark** |
| 01.01 | 1 | Grooved plate 80/14x230 | mechanical processing |
| 01.02 | 4 | Al profile 20x20x85 |  |
| 01.03 | 2 | Cover cap 80x14 black |  |
| 01.04 | 8 | Angle 20x20 NU6 |  |
| 01.05 | 8 | Angle cover cap 20x20 |  |
| 01.06 | 12 | Hammer nut M4 NU6 |  |
| 01.07 | 16 | Cylinder head screw ISO 4762 - M4x8 - 8.8 |  |
| 01.08 | 4 | T-slot nut M4 NU5 steel |  |
| 01.09 | 2 | cylinder head screw**DIN**7984 - M6x16 - 8.8 |  |
| 01.10 | 2 | Hammer nut M6 NU8 |  |
| 01.11 | 1 | AI profile 40120x171 |  |
| 01.12 | 8 | Cover cap 20x20 |  |
| **02.00 Kit insert** | | | |
| 02.01 | 1 | Plate 70/10x225 | mechanical processing |
| 02.02 | 4 | T-slot nut M4 NU6 |  |
| 02.03 | 6 | Cylinder head screw ISO 4762- M4x10 - 8.8 |  |
| 02.04 | 1 | slider | mechanical processing |
| 02.05 | 1 | Pneumatic round cylinder D= 10 stroke= 60 |  |
| 02.06 | 1 | Foot mounting for cylinder D= 10 |  |
| 02.07 | 2 | Clamp holder for cylinder switch d=10 |  |
| 02.08 | 2 | Cylinder switch for cylinder d= 10 |  |
| 02.09 | 2 | PU pipe black D= 4 I= lm |  |
| 02.10 | 2 | Throttle valve M5 exhaust air throttled |  |



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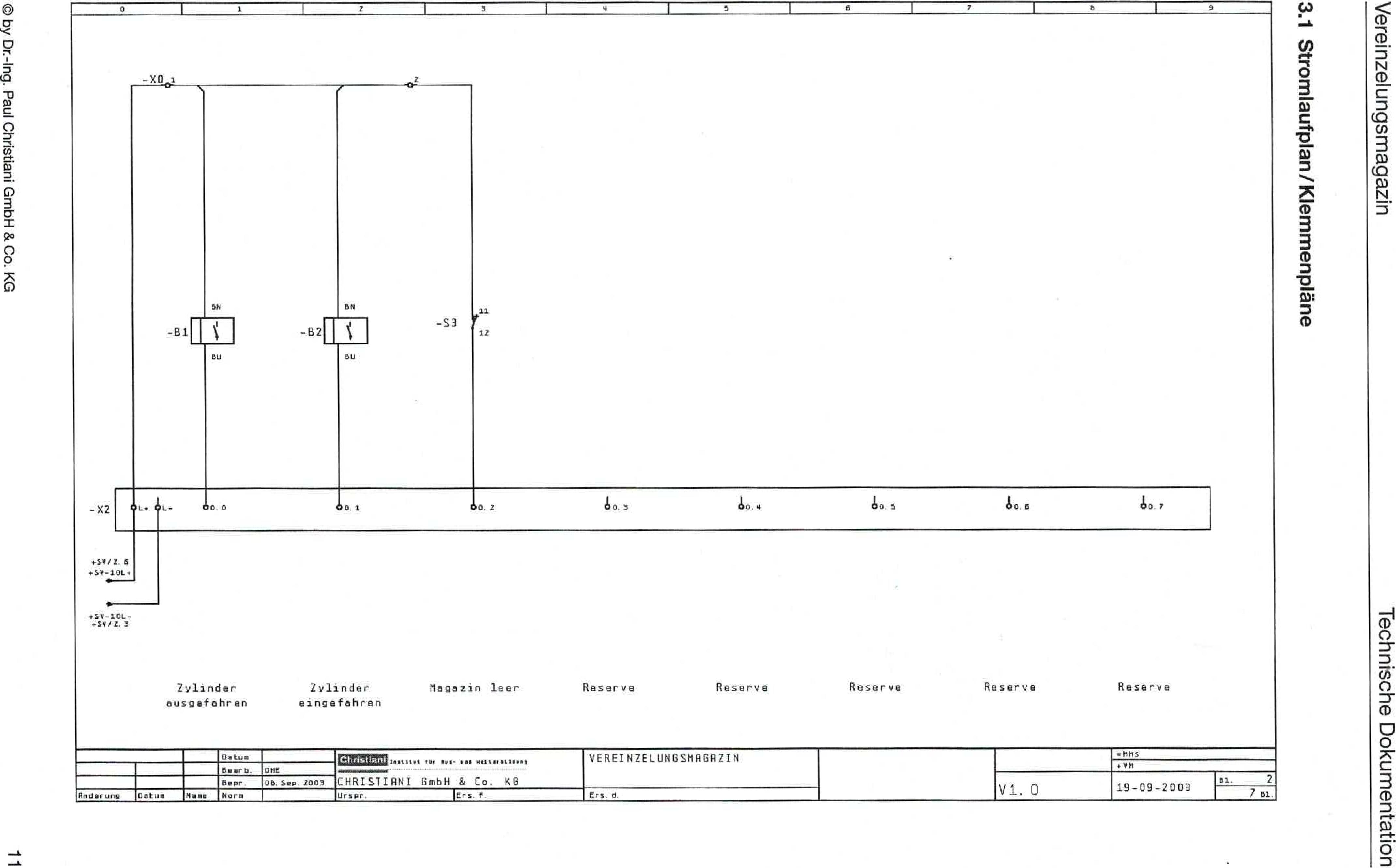
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**3.1 Circuit diagram/terminal plan**

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2 cylinders extended

Cylinder retracted

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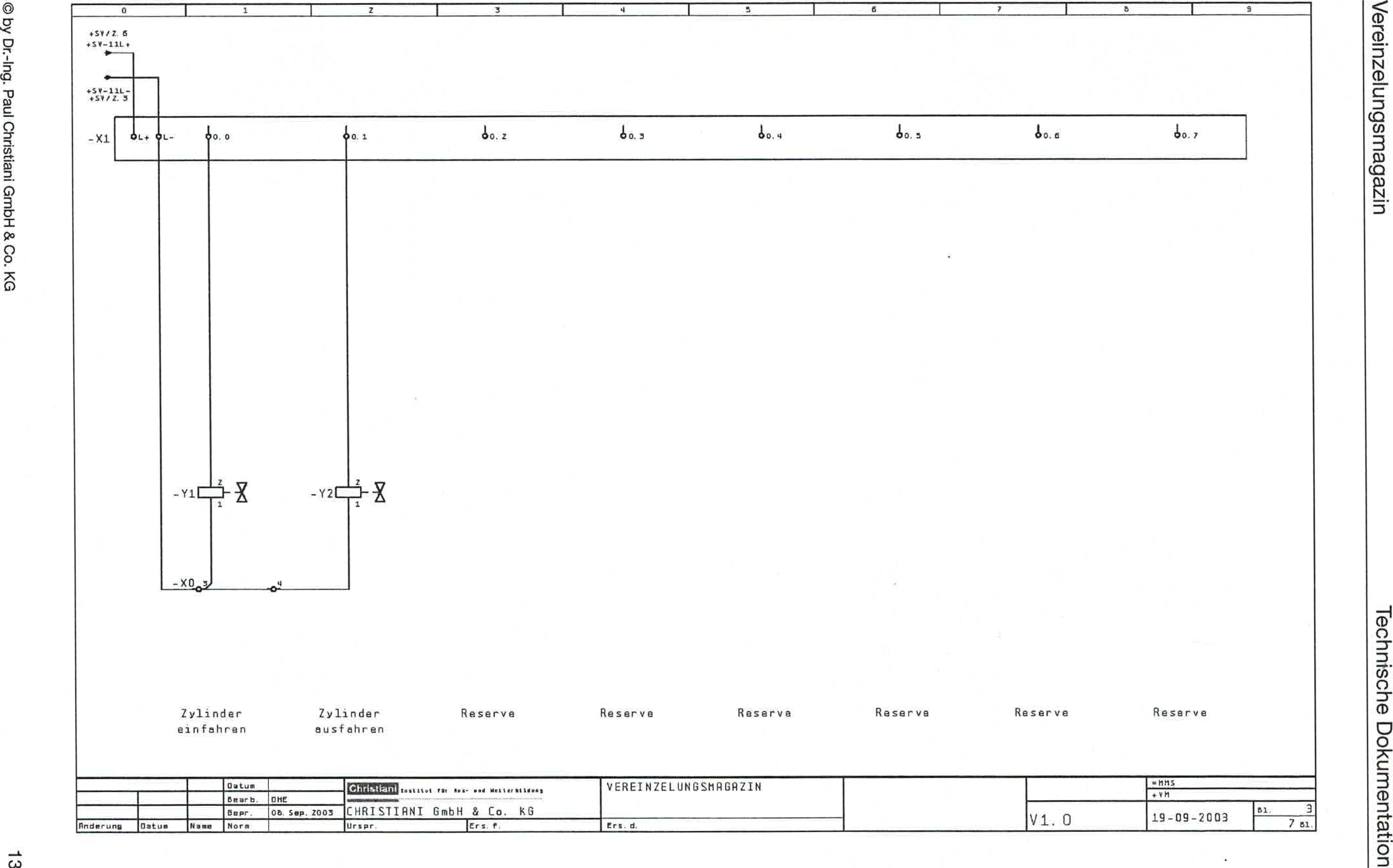
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Retract cylinder

Extend cylinder

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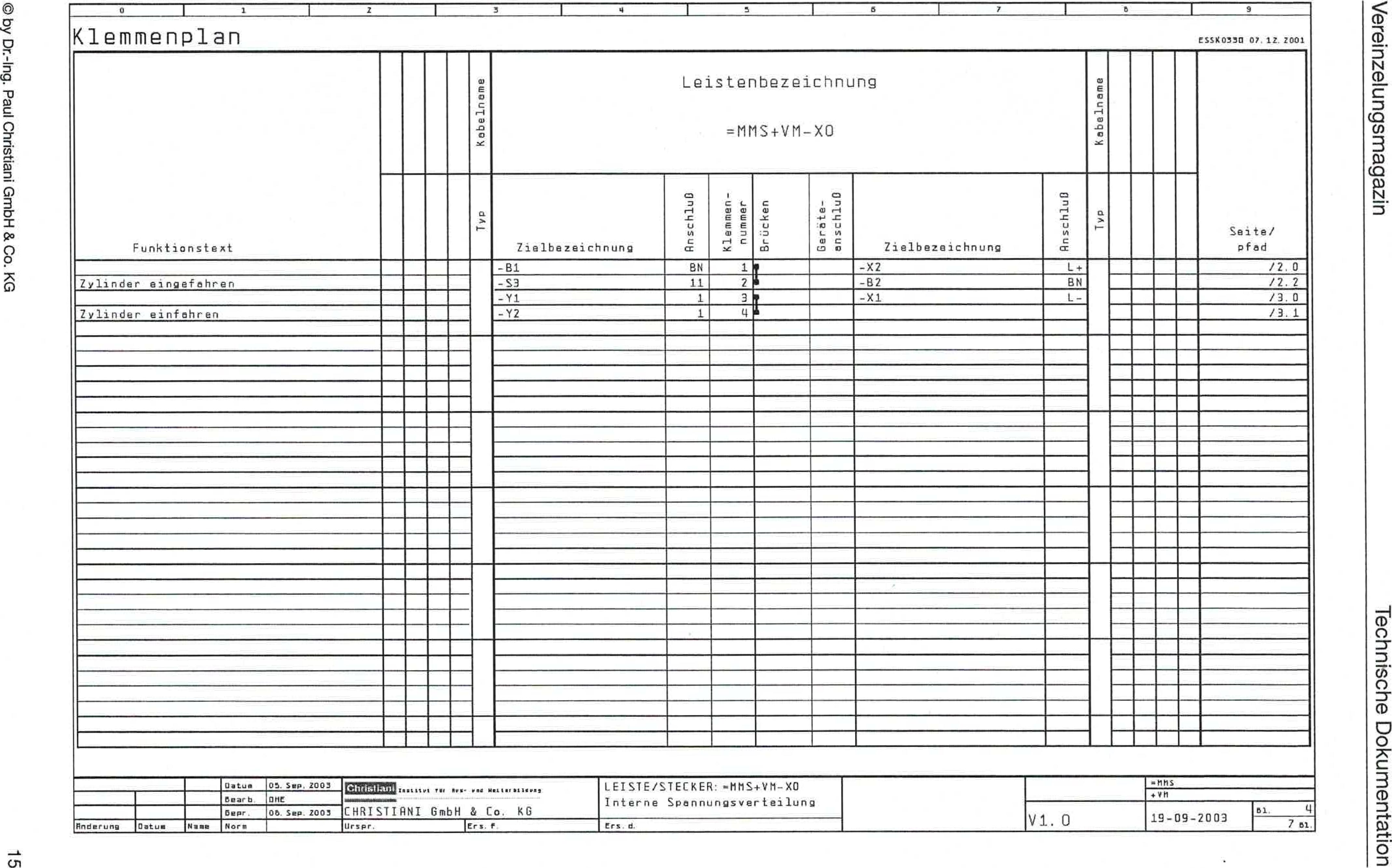
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Terminal diagram

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| Function text |  |  |  |  | IatonuTaq | Bar designation  .MMS+VM-X0 | | | | | | | IaUJBUT@gGl |  |  |  |  | somersault/ pfed |
|  |  |  |  |  | Target definition | oniyzsuu | Klernmen-  number | Bridges | Devices-  connection | Target name | pnjyDsuy | dhey |  |  |  |  |
|  |  |  |  |  |  | -B1 | BN | 1/ | |  | -X2 | L-4. |  |  |  |  |  | /2.0 |
| cylinder retracted |  |  |  |  | -S3 | 11 | 7i | |  | -B2 | BN |  |  |  |  | /2.2 |
|  |  |  |  |  | -Y1 | 1 | 3T | |  | -X1 | L- |  |  |  |  | /3.0 |
| cylinder retract |  |  |  |  | -Y2 | 1 | **t1 A** | |  |  |  |  |  |  |  | 13.1 |
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CHRISTIRNI GmbH & Co. KG

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POWER PLUG:=MMS+VM-X0 Internal voltage distribution

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**Christiani**

**Technical Institute for Education and Training**

**mMS training concept**

**Mechatronics/Automation Technology**

**Technical documentation**

**Functional module**

**Separation magazine**

Order No. 64424

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| Separation magazine Technical documentation | | |
| **Table of contents**  **1 mechanics** | |  |
| 1.1 | Functional description | 1 |
| 1.2 | Overall drawing | 3 |
| 1.3 | Complete parts list | 7 |
| **2** | **Pneumatics** |  |
|  | Pneumatic plan | 9 |
| **3** | **Electrics** |  |
| 3.1 | Circuit diagram/terminal plan | 11 |
| **4** | **PLC programming** |  |
| 4.1 | Technology scheme | 21 |
| 4.2 | Functional description | 23 |
| 4.3 | Steps | 25 |
| **5** | **Commissioning instructions** | 29 |

**1.1 Functional description**

**Separation magazine Technical documentation**

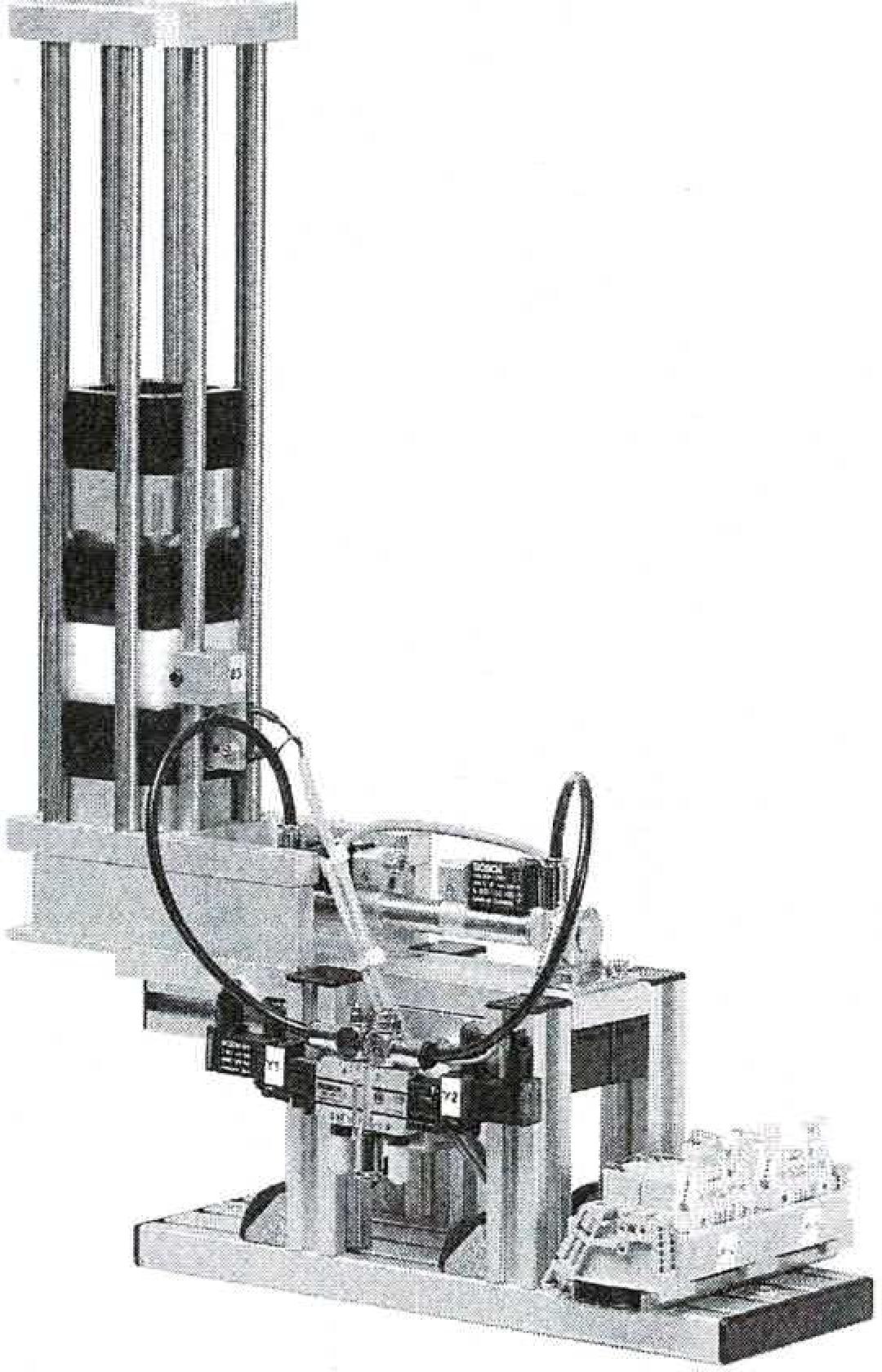
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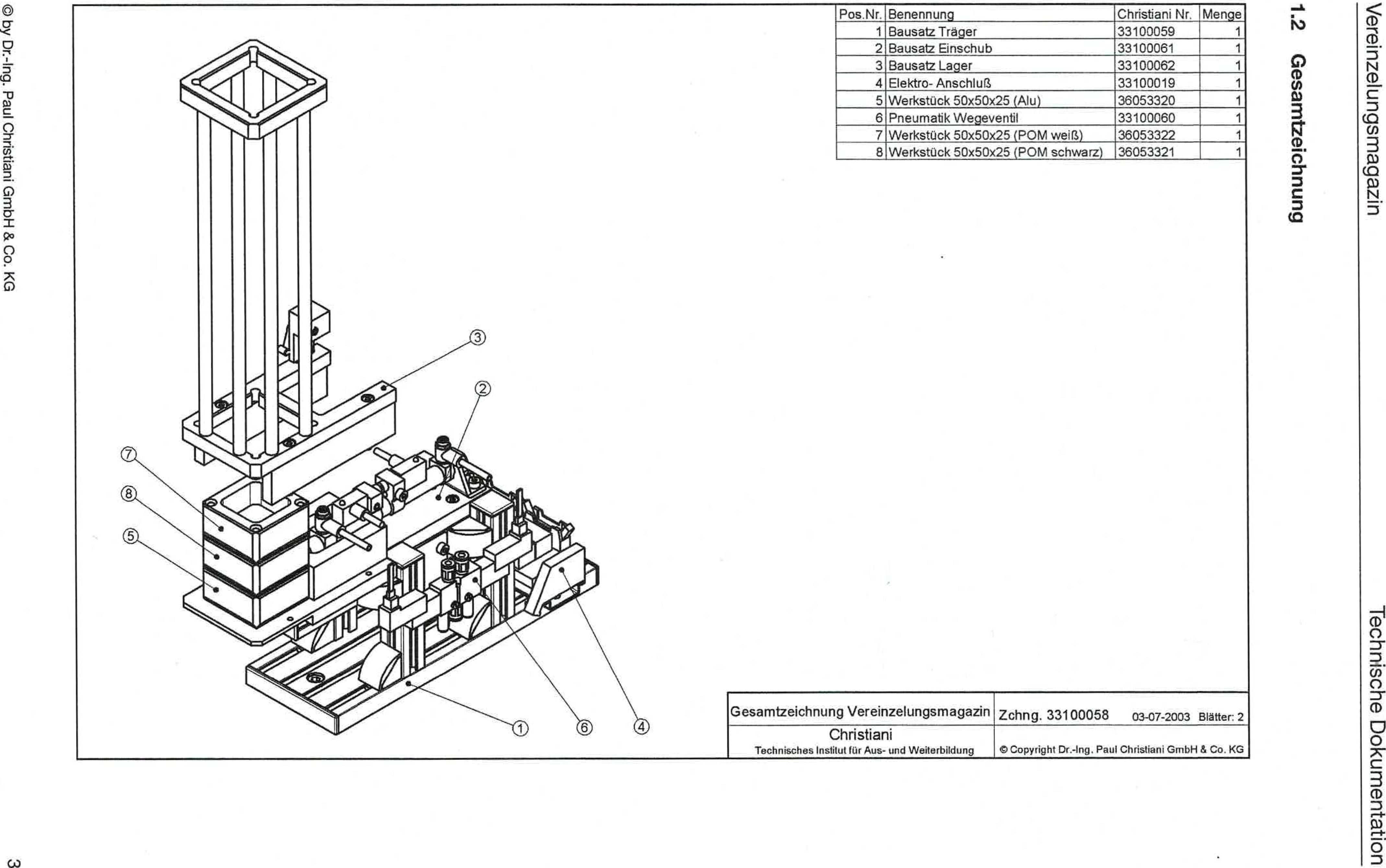
The separating magazine can accommodate up to 10 stacked workpieces. A pneumatic cylinder controlled by a 5/2-way valveWhenever a workpiece is loaded, the bottommost workpiece is ejected from the stack. A limit switch checks the loading status of the magazine.

The functional module is completely built on a mounting platform of size 80 x 230 mm and can be flexibly used individually or together with other­functional assemblies are mounted on an aluminum profile plate.

Two 8-bit transfer connectors are available as transfer modules for connection to a PLC. Three digital PLC inputs and two digital PLC outputs are required. The supply voltage of the function moduleis 24 VDC.

The compressed air connection with approx. 4 bar is made via 4 mm connections.





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| Item No. | designation | Christiani No. | Crowd |
| 1 | kitCarrier Kit insert | 33100059  33100061 | 1 1 |
| 2 |
| 3 | Bearing kit | 33100062 | 1 |
| 4 | Electrical connection | 33100019 | 1 |
| 5 | Workpiece 50x50x25 (aluminum) | 36053320 | 1 |
| 6 | Pneumatic directional valve | 33100060 | 1 |
| 7 | Workpiece 50x50x25 (POM wen) | 36053322 | 1 |
| 8 | Workpiece 50x50x25 (POM black) | 36053321 | 1 |

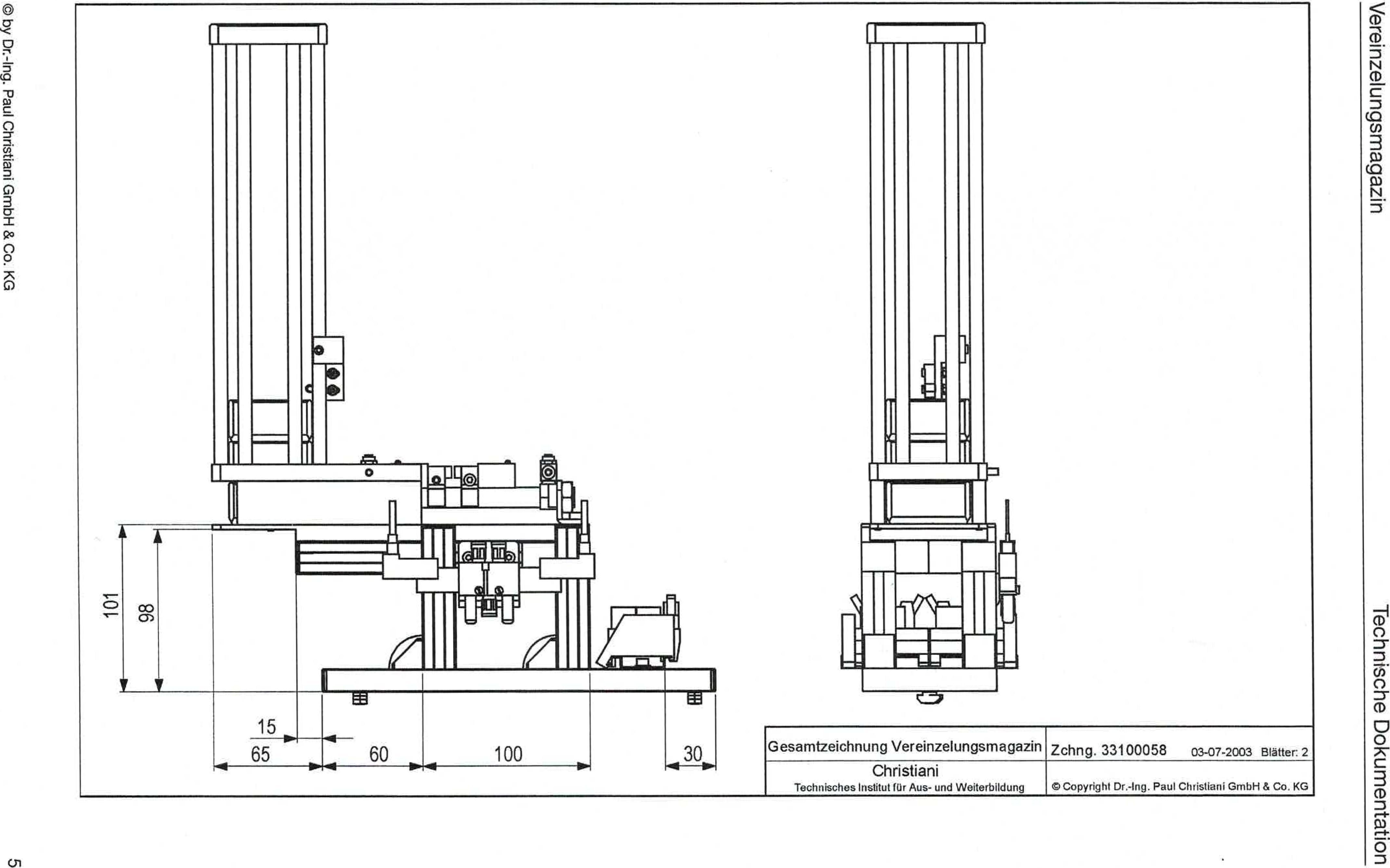
General drawing of the separation magazine

Drawing 33100058 03-07-2003 Blatter: 2

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03-07-2003 Blatter: 2

General drawing of the distribution magazine drawing 33100058

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