

INPUT CARD (Slot No 1)			
I:1/0	E-STOP	R1	N/O
I:1/1	STOP	PB	N/C
I:1/2	START	PB	N/O
I:1/3	RESET	RE2	N/O
I:1/4	AUTO/MAN	SW	N/O
I:1/5	LIGHT CURTAIN, LC INFEED	IN	
I:1/6	LIGHT CURTAIN, LCDISCHARGE	IN	
I:1/7	LIGHT CURTAIN, INFEED CH1 STATUS		
I:1/8	LIGHT CURTAIN, INFEED CH2 STATUS		
I:1/9	LIGHT CURTAIN, DISCHARGE CH1 STATUS		
I:1/10	LIGHT CURTAIN, DISCHARGE CH2 STATUS		
I:1/11	CONVEYOR 1 -PE1A (*)	PE1A	
I:1/12	CONVEYOR 1 -PE1B (**)	PE1B	
I:1/13	CONVEYOR 2 -PE2 (**)	PE2	
I:1/14	CONVEYOR 3 -PE3 (**)	PE3	
I:1/15	CONVEYOR 4 -PE4 (**)	PE4	

INPUT CARD (Slot No 2)			
I:2/0	CONVEYOR 5 -PE5A (*)	PE5A	
I:2/1	CONVEYOR 5 -PE5B (**)	PE5B	
I:2/2	CONVEYOR 6 -PE6 (**)	PE6	
I:2/3	CONVEYOR 7 -PE7(**)	PE7	
I:2/4	CONVEYOR 8 -PE8 (**)	PE8	
I:2/5	CONVEYOR 9 -PE9A (*)	PE9A	
I:2/6	CONVEYOR 9 -PE9B (**)	PE9B	
I:2/7	CONVEYOR 10 -PE10 (**)	PE10	
I:2/8	CONVEYOR 11-PE11 (**)	PE11	
I:2/9	CONVEYOR 12-PE12 (**)	PE12	
I:2/10	CONVEYOR 13 -PE13A (*)	PE13A	
I:2/11	CONVEYOR 13 -PE13B (**)	PE13B	
I:2/12	CONVEYOR 14 - PE14 (**)	PE14	
I:2/13	CONVEYOR 15 - PE15A (LOAD IN POS LEADING)	PE15A	CBS
I:2/14	CONVEYOR 15 - PE15B (LOAD IN POS TRAILING)	PE15B	CBS
I:2/15	CONVEYOR 15 - PE15C (REF)	PE15C	

INPUT CARD (Slot No 3)			
I:3/0	OPERATOR LIGHT CURTAIN CH1		
I:3/1	OPERATOR LIGHT CURTAIN CH2		
I:3/2	SPARE		
I:3/3	CONVEYOR 16 -PE16A(*)	PE16A	
I:3/4	CONVEYOR 16 -PE16B(*)	PE16B	
I:3/5	SPARE		
I:3/6	SPARE		
I:3/7	SPARE		
I:3/8	CONVEYOR No 1 UP	RS1A	
I:3/9	CONVEYOR No 5 UP	RS5A	
I:3/10	CONVEYOR No 9 UP	RS9A	
I:3/11	CONVEYOR No 13 UP	RS13A	
I:3/12	CONVEYOR No 16 UP	RS16A	
I:3/13	CONVEYOR No 1 DN	RS1B	
I:3/14	CONVEYOR No 5 DN	RS5B	
I:3/15	CONVEYOR No 9 DN	RS9B	

INPUT CARD (Slot No 4)			
I:4/0	CONVEYOR No 13 DN	RS13B	
I:4/1	CONVEYOR No 16 DN	RS16B	
I:4/2	CBS SYSTEM START (GREEN/LITE)PLC	PB /LT	N/O
I:4/3	CBS CYCLE STOP (YELLOW)PLC	PB/LT	N/O
I:4/4	CBS SAFETY RESET	PB	N/O
I:4/5	CBS LIGHT CUTAIN, LC INP BYPASS	PB	N/O
I:4/6	CBS LIGHT CUTAIN, LC DISCHARGE BYPASS	PB	N/O
I:4/7	SPARE		
I:4/8	CBS SCANNER ZONE 1 STATUS		
I:4/9	CBS SCANNER ZONE 2 STATUS		
I:4/10	WAPPER READY (FROM COLUMBIA)		
I:4/11	BANNER INFED MUTE SENSOR 1	PE	
I:4/12	BANNER INFED MUTE SENSOR 2	PE	
I:4/13	BANNER DISCHARGE MUTE SENSOR 1	PE	
I:4/14	BANNER DISCHARGE MUTE SENSOR 2	PE	
I:4/15	SPARE		

OUTPUT CARD (Slot No 5)			
O:5/0	SPARE	XX	
O:5/1	DISCHARGE LIGHT CURTAIN CH1	XX	
O:5/2	DICHARGE LIGHT CURTAIN CH2	XX	
O:5/3	INFEED LIGHT CURTAIN CH1	XX	
O:5/4	INFEED LIGHT CURTAIN CH2	XX	
O:5/5	SPARE	XX	
O:5/6	SPARE	XX	
O:5/7	SPARE	XX	
O:5/8	SPARE	XX	
O:5/9	SPARE	XX	
O:5/10	SPARE	XX	
O:5/11	SPARE	XX	
O:5/12	SPARE	XX	
O:5/13	SPARE	XX	
O:5/14	SPARE	XX	
O:5/15	SPARE	XX	

OUTPUT CARD (Slot No 6)			
O:6/0	SPARE	XX	
O:6/1	SPARE	XX	
O:6/2	SPARE	XX	
O:6/3	CONVEYOR 15 (*)	VFD19(*)	
O:6/4	CONVEYOR 16	VFD20	
O:6/5	CONVEYOR 16	VFD21	
O:6/6	CONVEYOR 1 (UP)	SOL1A	
O:6/7	CONVEYOR 1 (DOWN)	SOL1B	
O:6/8	CONVEYOR 5 (UP)	SOL2A	
O:6/9	CONVEYOR 5 (DOWN)	SOL2B	
O:6/10	CONVEYOR 9 (UP)	SOL3A	
O:6/11	CONVEYOR 9 (DOWN)	SOL3B	
O:6/12	CONVEYOR 13 (UP)	SOL4A	
O:6/13	CONVEYOR 13 (DOWN)	SOL4B	
O:6/14	CONVEYOR 16 (UP)	SOL5A	
O:6/15	CONVEYOR 16 (DOWN)	SOL5B	

OUTPUT CARD (Slot No 7)			
O:7/0	MAIN STOP LITE, RED	R4	
O:7/1	MAIN FAULT LITE, AMBER	R5	
O:7/2	MAIN RUN LITE	R6	
O:7/3	MAIN BUZZER	R7	
O:7/4	CBS SAFETY SYSTEM RESET, BLUE	LT	
O:7/5	CBS AUTO CYCLE START, GREEN	LT	
O:7/6	CBS AUTOMATIC, GREEN	BACON	
O:7/7	CBS SYSTEM FAULT, RED	BACON	
O:7/8	CBS SYSETM READY TO ENTER, BLUE	BACON	
O:7/9	CBS AUTOMATIC WARNING, BUZZER	BACON	
O:7/10	WRAPPER START (TO COLUMBIA)	R8	
O:7/11	WRAPPER FULL/PATIAL (TO COLUMBIA)	R9	
O:7/12	BANNER INFEED MUTE SENSOR 1 STATUS		
O:7/13	BANNER INFEED MUTE SENSOR 2 STATUS		
O:7/14	BANNER DISCHARGE MUTE SENSOR 1 STATUS		
O:7/15	BANNER DISCHARGE MUTE SENSOR 2 STATUS		

1535 E. Edinger Avenue • Santa Ana, CA 92705

BLUE MARBLE PALLETIZER CONVEYOR CONTROL

(MAIN CONTROL IN/OUTPUTS)

SCALE: NONE

DRAWN BY: J.S/D.D

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