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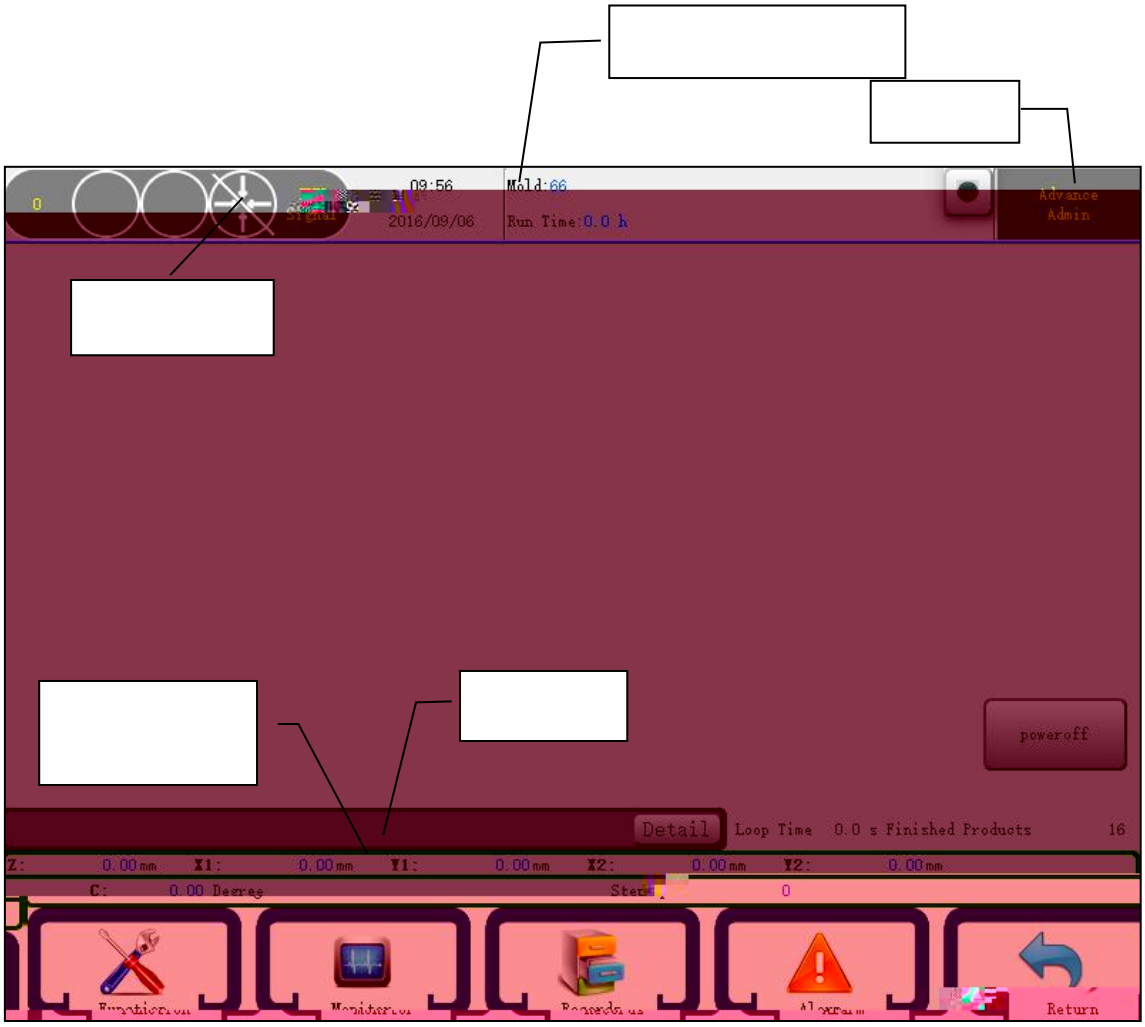
OPEN.E
S.DOOR
A.CLOSE
A.EJE
REC
START
STOP
ORI
HP
Y1-
X1-
X1+
Y1+
Z-
Z+
C-
C+
Y2-
X2-
X2+
Y2+
F1
F2
F3
F4
F5


09:56
2016/09/06
Mold:66
Run Time:0.0 h
Advance
Admin
poweroff
Detail
Loop Time 0.0 s Finished Products 16
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
C: 0.00 Degree
Return

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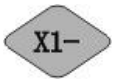
IMM Signal
09:58
2016/09/06
Mold:66
Run Time:0.0 h
Advance Admin
Horizontal-1
Fixture 1
ON
OFF
Fixture 3
ON
Fixture 2
ON
OFF
Fixture 4
ON
OFF
Sucker
Reserve
Manipul-ator I/O
Detail
Loop Time

Y1−

Y1+

Y2−

Y2+


X1−

X1+

X2−

X2+

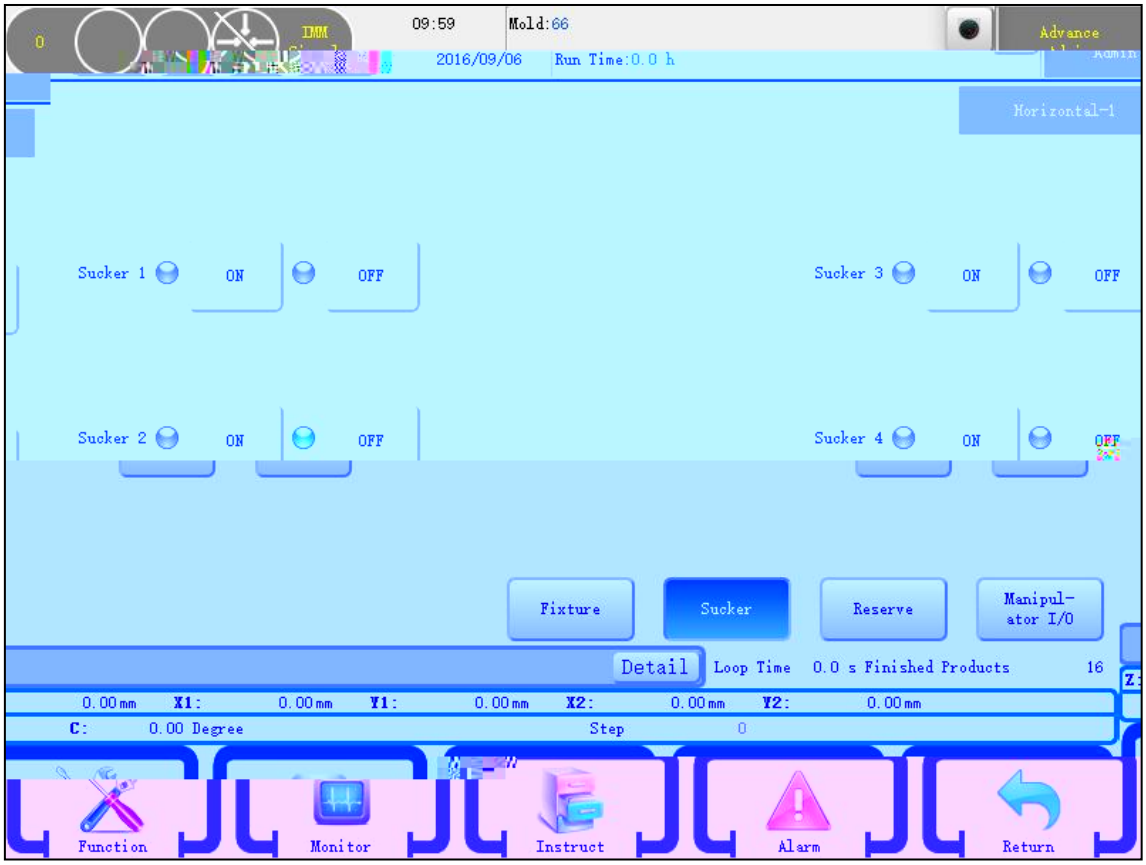
C+

C−

Z -

Z +

0
IMM Signal
09:58
2016/09/06
Mold:66
Run Time:0.0 h
Advance Admin
Horizontal-1
Fixture 1
ON
OFF
Fixture 3
ON
OFF
Fixture 2
ON
OFF
Fixture 4
ON
OFF
Sucker
Reserve
Manipul-ator I/O
Detail
Loop Time
0.0 s


09:59
Mold:66
Advance
2016/09/06
Run Time:0.0 h
Horizontal-1
Sucker 1
ON
OFF
Sucker 3
ON
OFF
Sucker 2
ON
OFF
Sucker 4
ON
OFF
Fixture
Sucker
Reserve
Manipul-
ator I/O
Detail
Loop Time 0.0 s Finished Products 16
0.00 mm X1: 0.00 mm Y1: 0.00 mm X2: 0.00 mm Y2: 0.00 mm
C: 0.00 Degree Step 0
Function
Monitor
Instruct
Alarm
Return

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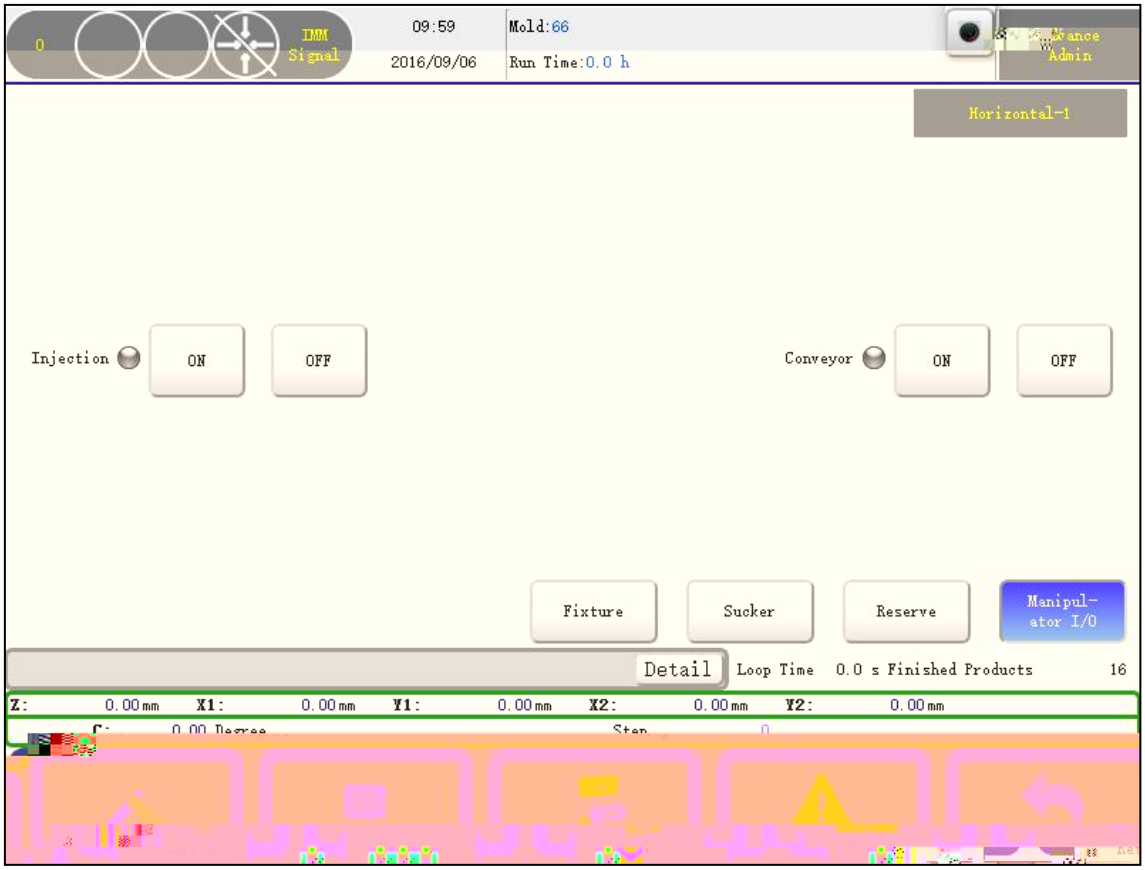
0
IMM Signal
09:59
2016/09/06
Mold:66
Run Time:0.0 h
Admin
Horizontal-1
Injection
ON
OFF
Conveyor
ON
OFF
Fixture
Sucker
Reserve
Manipul-ator I/O
Detail
Loop Time 0.0 s Finished Products 16
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm

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0
IMM
Signal
10:00
2016/09/06
Mold:66
Run Time:0.0 h
Advance
Admin
Horizontal-1
Reserve1
ON
OFF
Reserve2
ON

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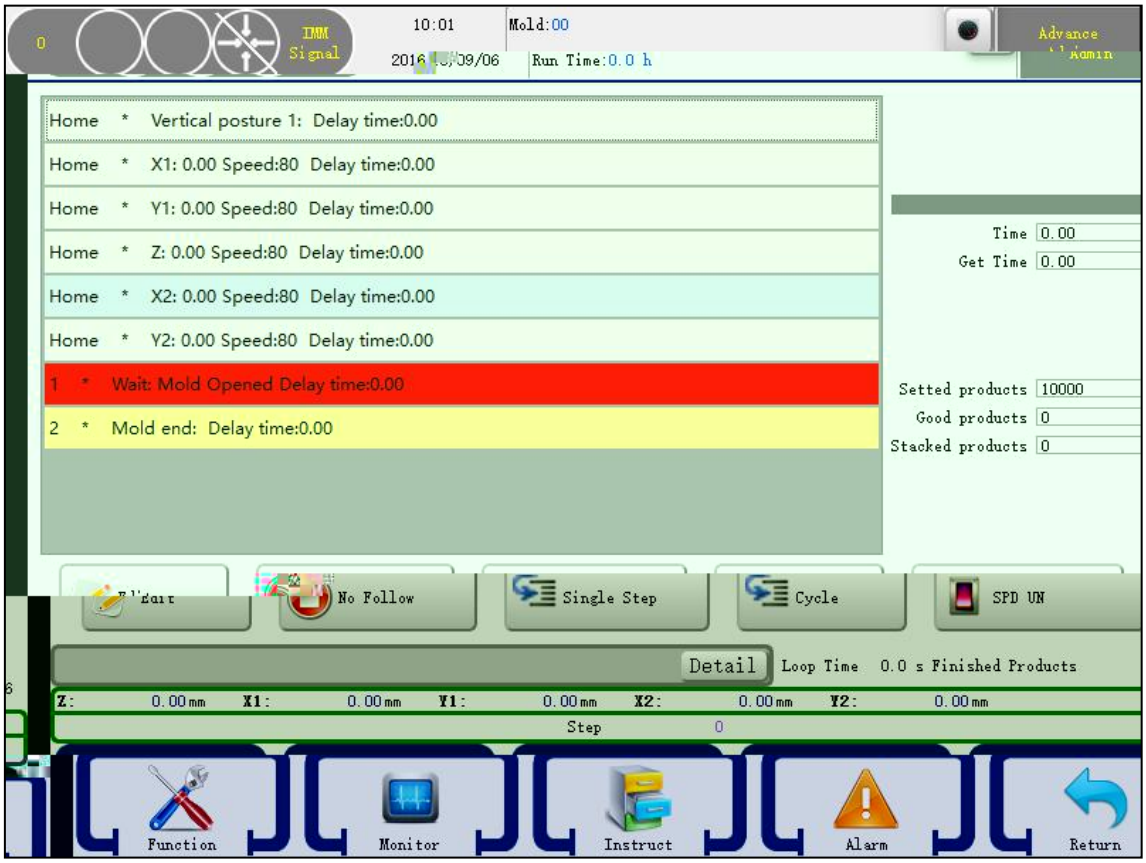
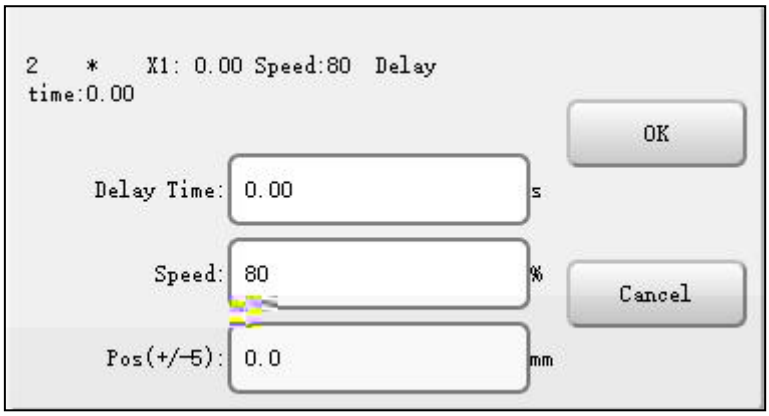
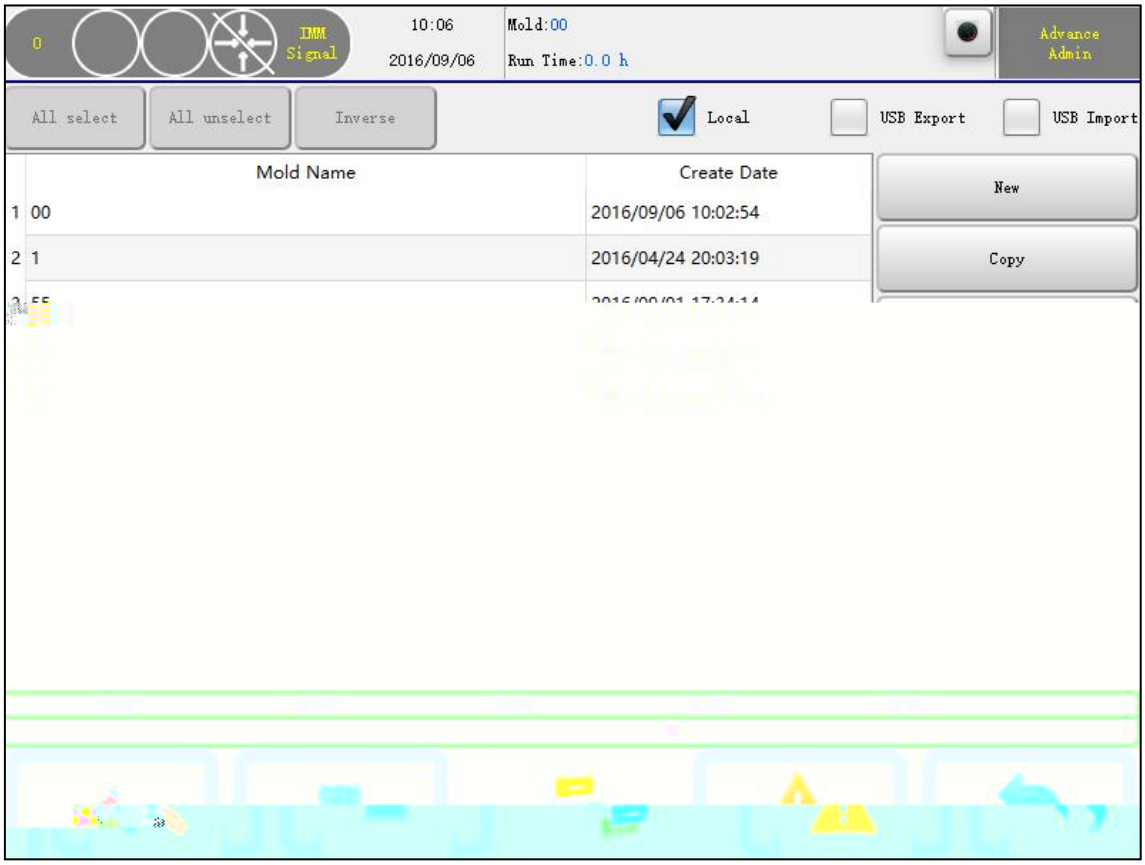
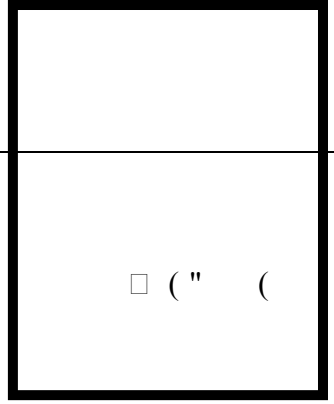

10:01
Mold:00
Run Time:0.0 h
Home * Vertical posture 1: Delay time:0.00
Home * X1: 0.00 Speed:80 Delay time:0.00
Home * Y1: 0.00 Speed:80 Delay time:0.00
Home * Z: 0.00 Speed:80 Delay time:0.00
Home * X2: 0.00 Speed:80 Delay time:0.00
Home * Y2: 0.00 Speed:80 Delay time:0.00
1 * Wait: Mold Opened Delay time:0.00
2 * Mold end: Delay time:0.00
Time 0.00
Get Time 0.00
Setted products 10000
Good products 0
Stacked products 0
No Follow
Single Step
Cycle
SPD UN
Detail
Loop Time 0.0 s Finished Products
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step 0
Function
Monitor
Instruct
Alarm
Return


2 * X1: 0.00 Speed:80 Delay time:0.00
OK
Delay Time: 0.00 s
Speed: 80 %
Cancel
Pos(+/-5): 0.0 mm


0
IMM Signal
10:06
2016/09/06
Mold:00
Run Time:0.0 h
Advance Admin
All select
All unselect
Inverse
Local
USB Export
USB Import
Mold Name
Create Date
New
Copy
1 00
2016/09/06 10:02:54
2 1
2016/04/24 20:03:19



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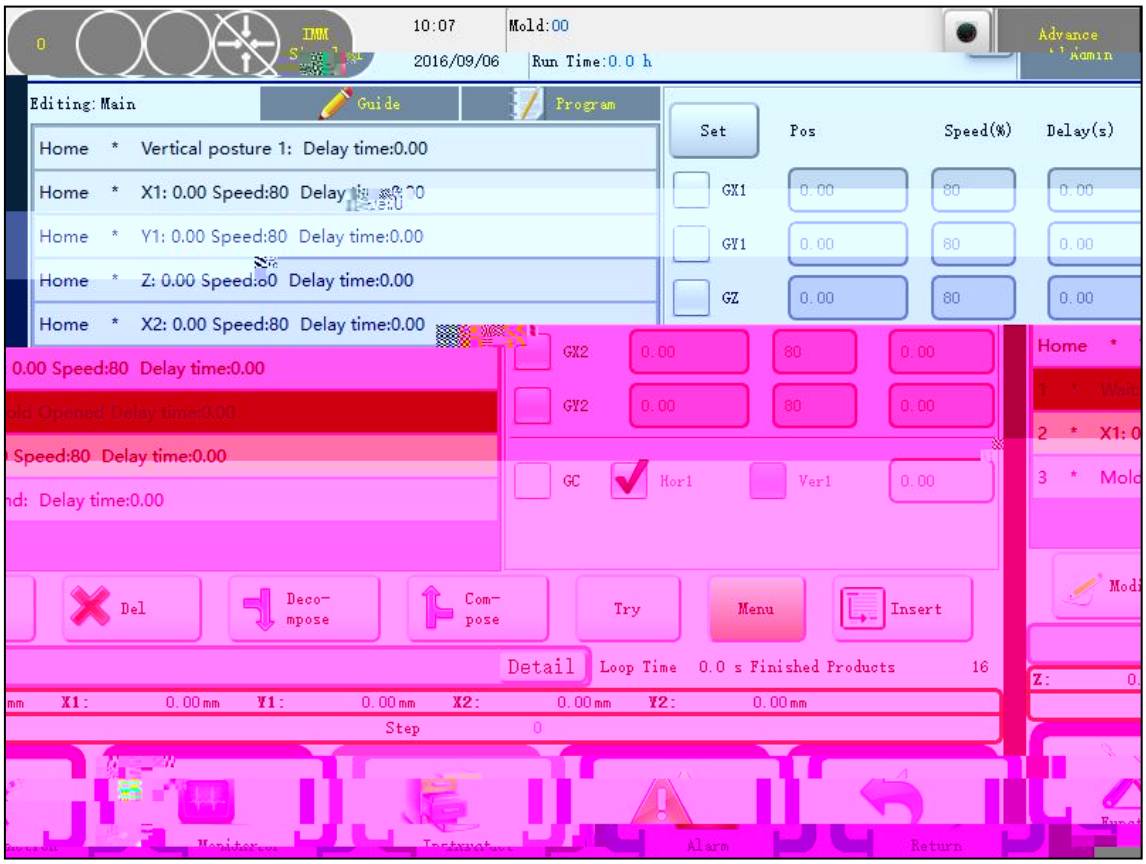
10:07
Mold:00
2016/09/06
Run Time:0.0 h
Advance
Editing: Main
Guide
Program
Set
Pos
Speed(%)
Delay(s)
Home * Vertical posture 1: Delay time:0.00
Home * X1: 0.00 Speed:80 Delay
Home * Y1: 0.00 Speed:80 Delay time:0.00
Home * Z: 0.00 Speed:80 Delay time:0.00
Home * X2: 0.00 Speed:80 Delay time:0.00
GX1
GY1
GZ
GX2
GY2
GC
Hor1
Ver1
Del
Deco-mpose
Com-pose
Try
Menu
Insert
Detail
Loop Time 0.0 s Finished Products 16
X1: 0.00mm
Y1: 0.00mm
X2: 0.00mm
Y2: 0.00mm
Step 0
Alarm
Return

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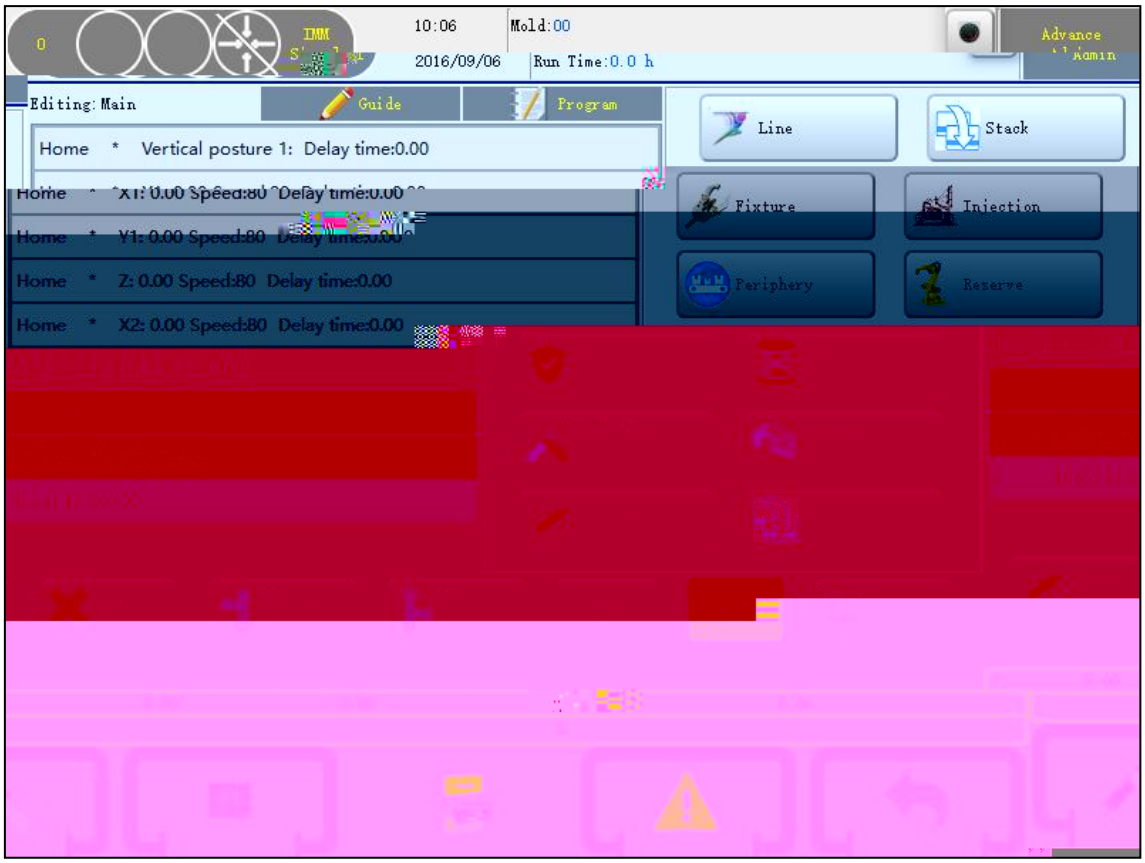
10:06
Mold:00
2016/09/06
Run Time:0.0 h
Advance
Admin
Editing: Main
Guide
Program
Line
Stack
Home * Vertical posture 1: Delay time:0.00
Fixture
Injection
Periphery
Reserve
Home * Z: 0.00 Speed:80 Delay time:0.00
Home * X2: 0.00 Speed:80 Delay time:0.00

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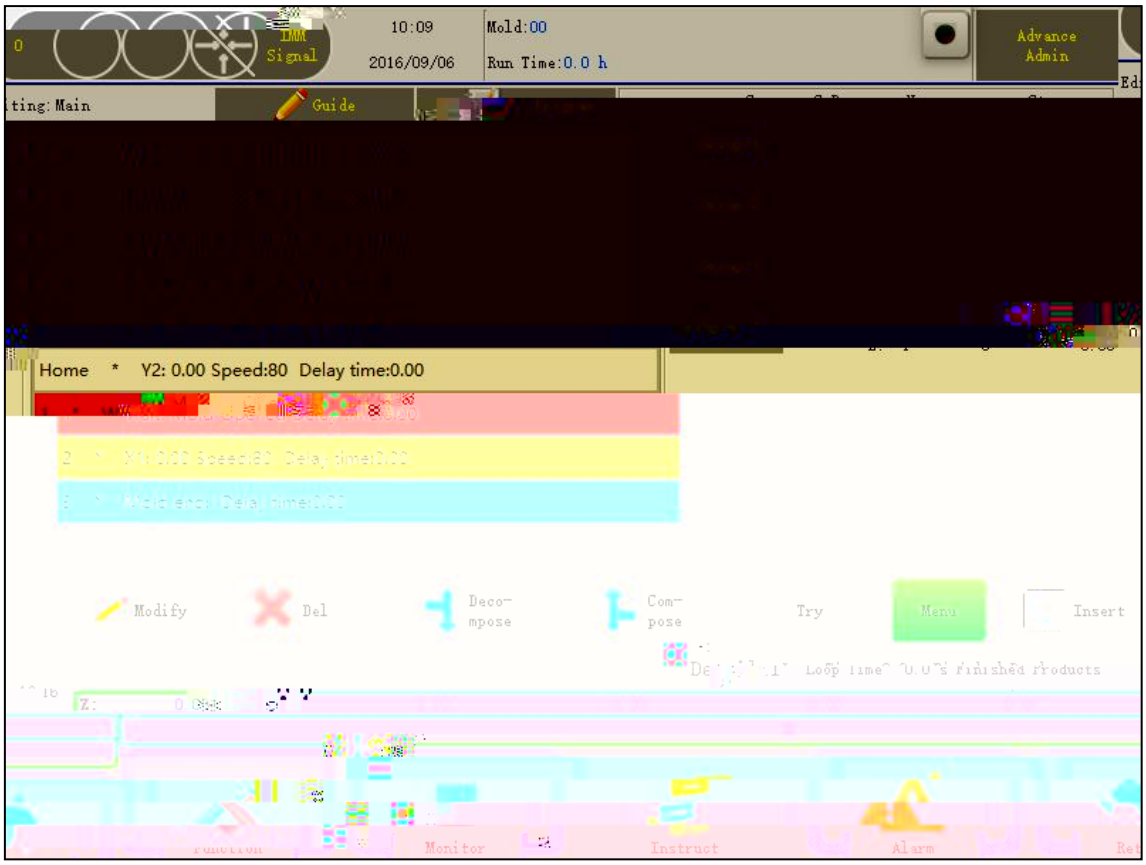
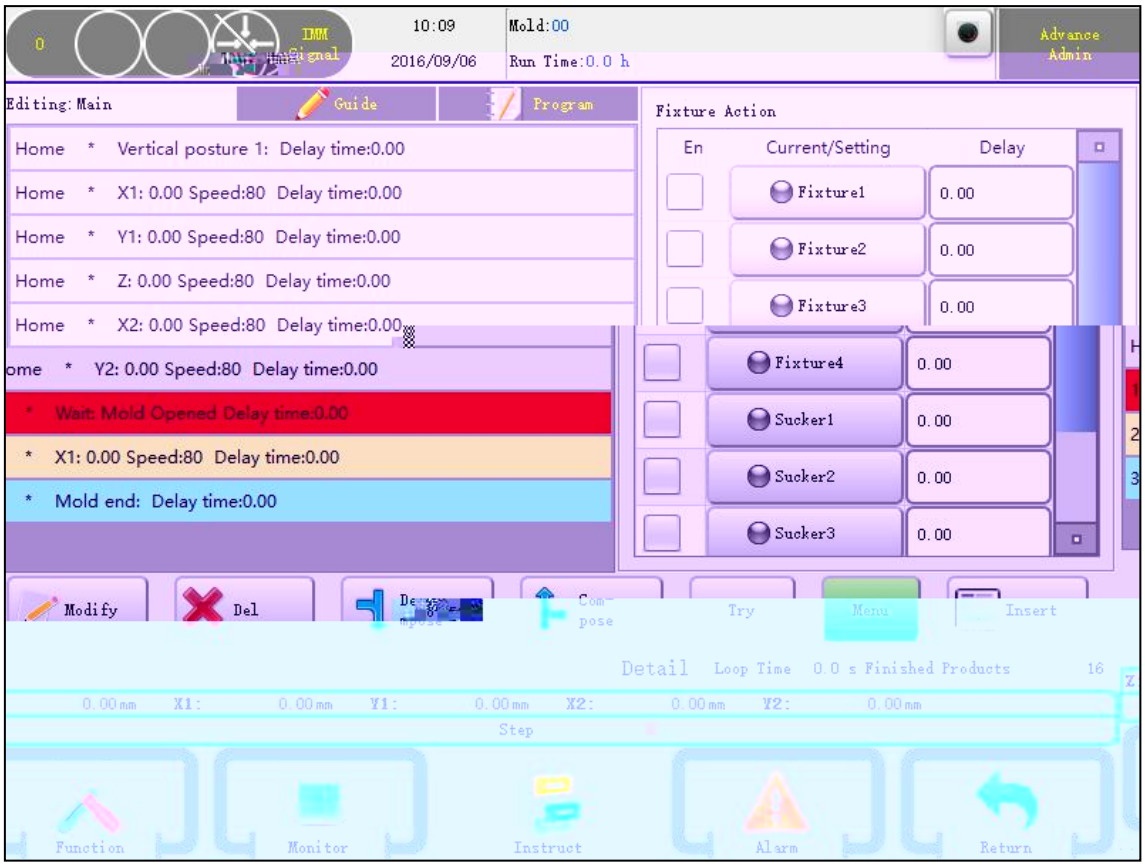

10:09
2016/09/06
Mold:00
Run Time:0.0 h
Advance
Admin
Guide
Home * Y2: 0.00 Speed:80 Delay time:0.00
Modify
Del
Deco-
mpose
Com-
pose
Try
Menu
Insert
Monitor
Instruct
Alarm


10:09
2016/09/06
Mold:00
Run Time:0.0 h
Advance
Admin
Editing: Main
Guide
Program
Fixture Action
En
Current/Setting
Delay
Home * Vertical posture 1: Delay time:0.00
Home * X1: 0.00 Speed:80 Delay time:0.00
Home * Y1: 0.00 Speed:80 Delay time:0.00
Home * Z: 0.00 Speed:80 Delay time:0.00
Home * X2: 0.00 Speed:80 Delay time:0.00
ome * Y2: 0.00 Speed:80 Delay time:0.00
* Wait: Mold Opened Delay time:0.00
* X1: 0.00 Speed:80 Delay time:0.00
* Mold end: Delay time:0.00
Fixture1
Fixture2
Fixture3
Fixture4
Sucker1
Sucker2
Sucker3
0.00
Modify
Del
Try
Menu
Insert
Detail
Loop Time 0.0 s Finished Products 16
X1:
Y1:
X2:
Y2:
Step
Function
Monitor
Instruct
Alarm
Return

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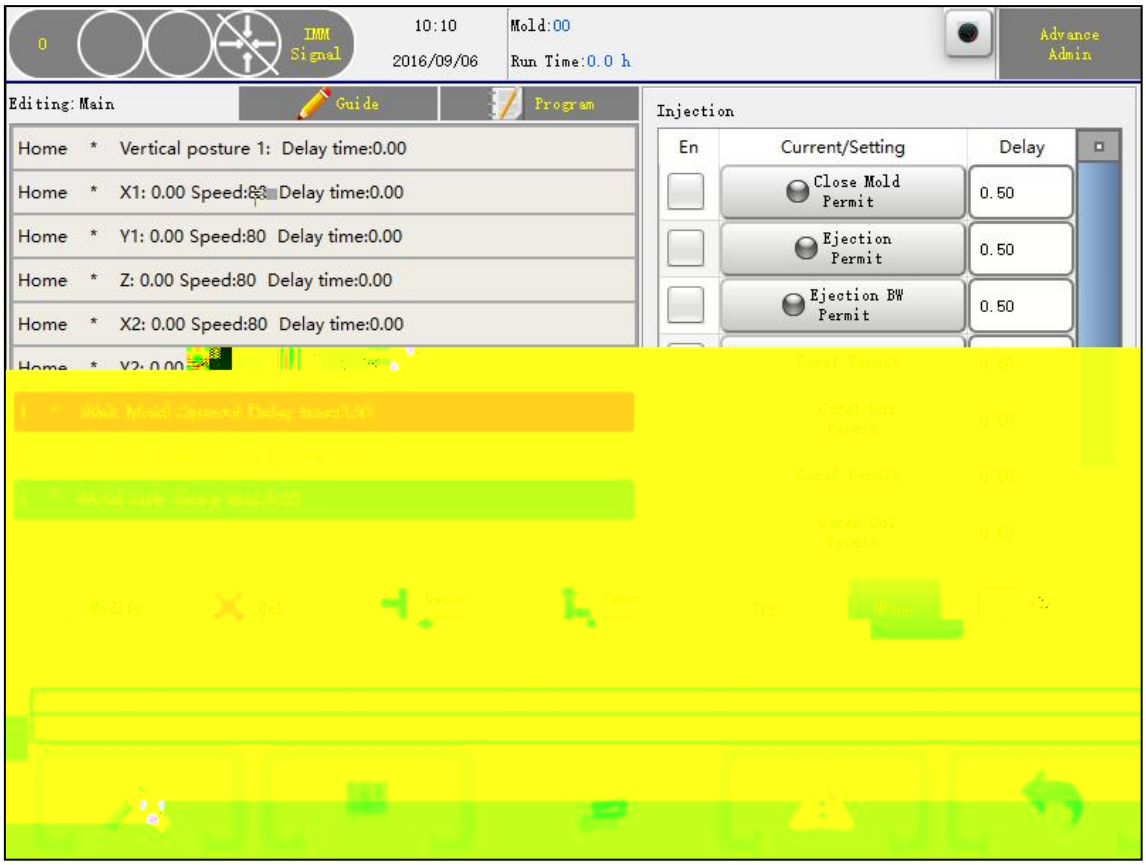
0
EMM
Signal
10:10
2016/09/06
Mold:00
Run Time:0.0 h
Advance
Admin
Editing: Main
Guide
Program
Home * Vertical posture 1: Delay time:0.00
Home * X1: 0.00 Speed:80 Delay time:0.00
Home * Y1: 0.00 Speed:80 Delay time:0.00
Home * Z: 0.00 Speed:80 Delay time:0.00
Home * X2: 0.00 Speed:80 Delay time:0.00
Injection
En
Current/Setting
Delay
Close Mold Permit
0.50
Ejection Permit
0.50
Ejection BW Permit
0.50

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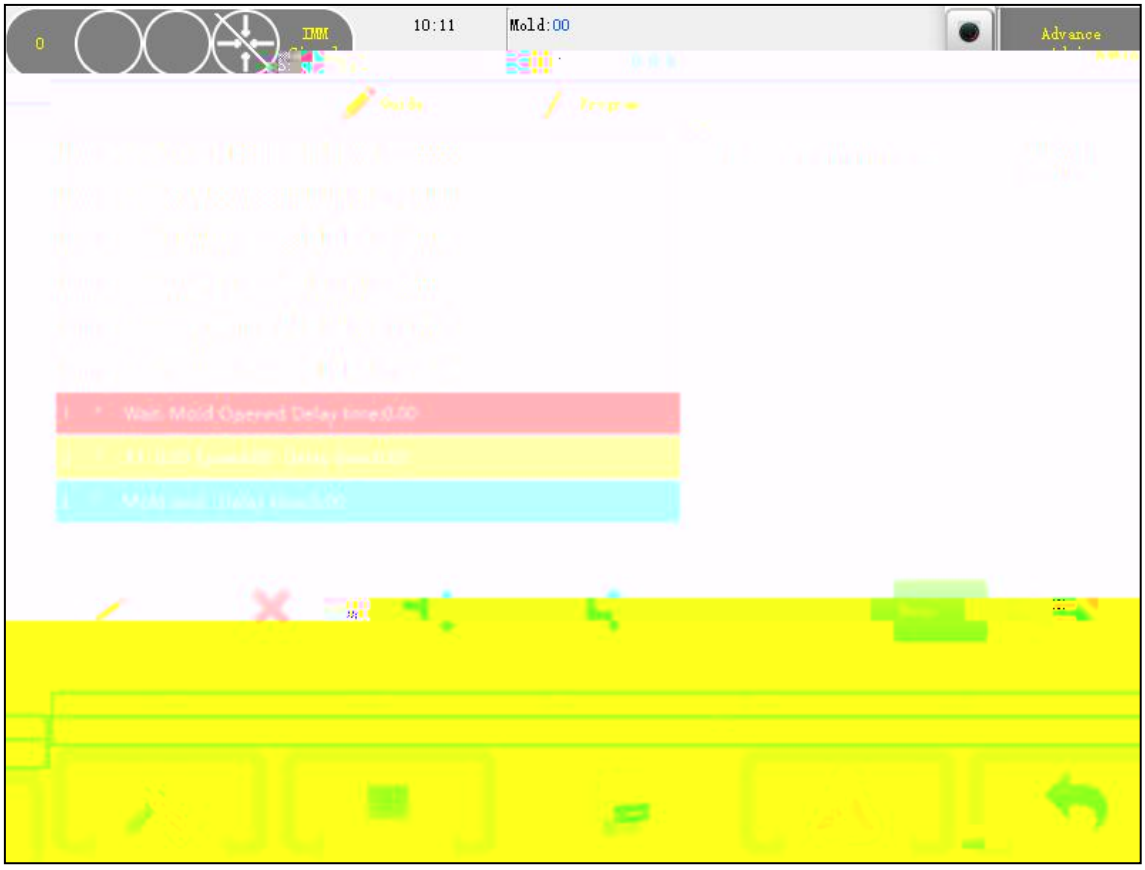
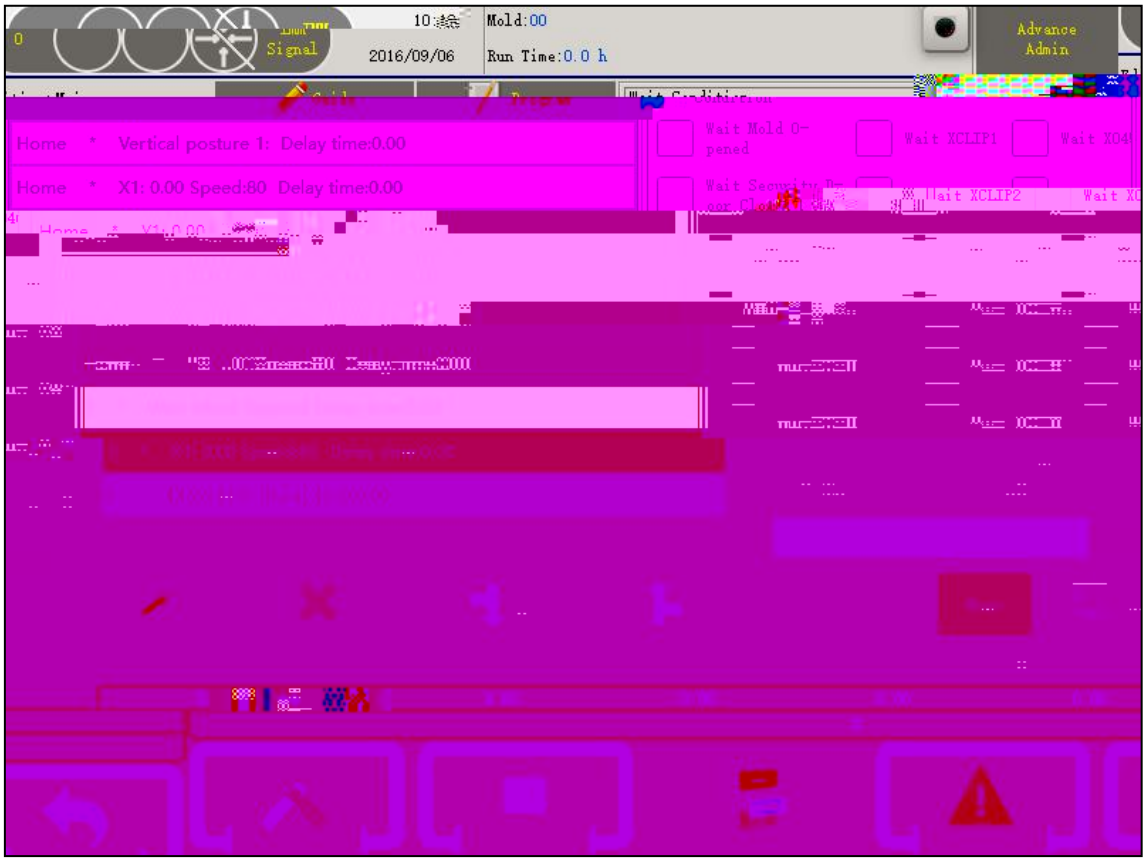
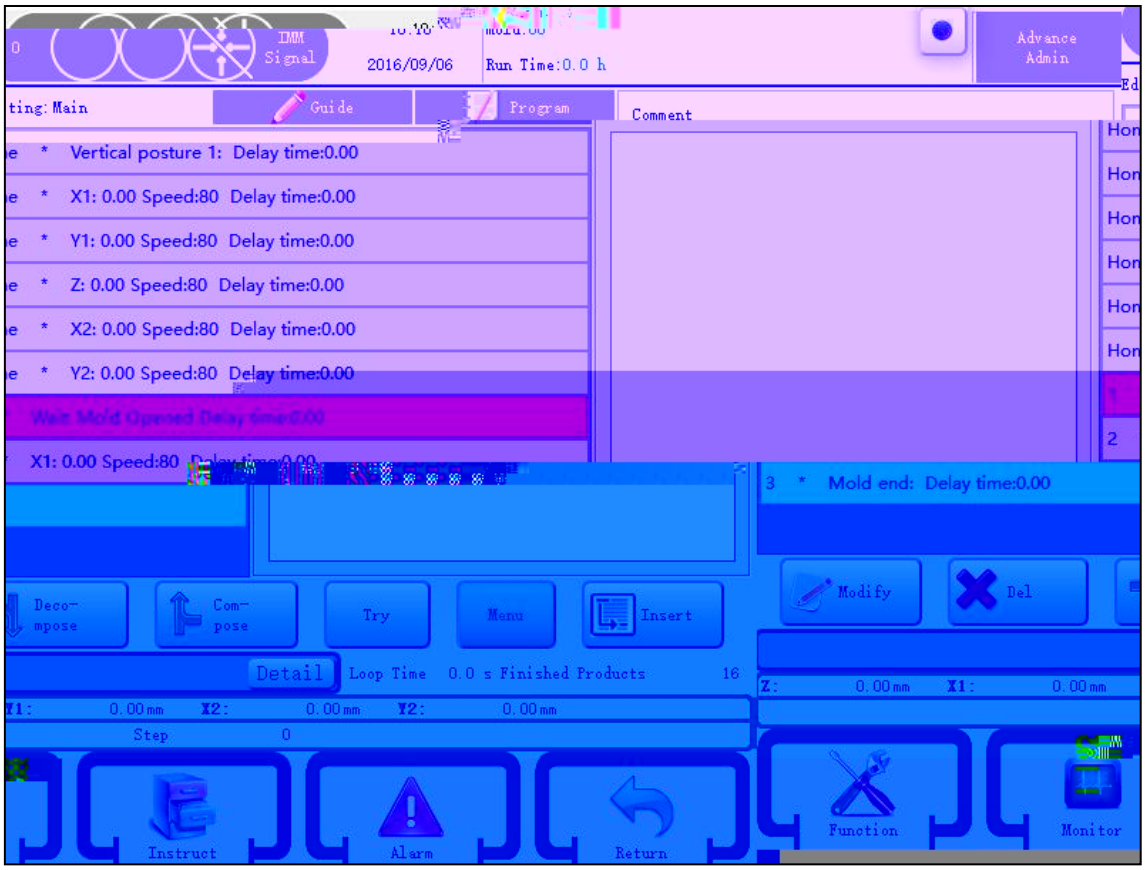

IMM
10:11
Mold:00
Advance

10:12
Mold:00
Advance


Signal
10:
2016/09/06
Mold:00
Run Time:0.0 h
Advance
Admin
Home * Vertical posture 1: Delay time:0.00
Home * X1: 0.00 Speed:80 Delay time:0.00
Wait Mold O-
pened
Wait XCLIP1
Wait XCLIP2


IMM Signal
2016/09/06
Run Time:0.0 h
Advance Admin
ting: Main
Guide
Program
Comment
e * Vertical posture 1: Delay time:0.00
e * X1: 0.00 Speed:80 Delay time:0.00
e * Y1: 0.00 Speed:80 Delay time:0.00
e * Z: 0.00 Speed:80 Delay time:0.00
e * X2: 0.00 Speed:80 Delay time:0.00
e * Y2: 0.00 Speed:80 Delay time:0.00
X1: 0.00 Speed:80
3 * Mold end: Delay time:0.00
Modify
Del
Deco-mpose
Com-pose
Try
Menu
Insert
Detail
Loop Time 0.0 s Finished Products 16
Z: 0.00mm X1: 0.00mm
Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step 0
Instruct
Alarm
Return
Function
Monitor

1 2 3 4 5 6 7 8 9 0
Q W E R T Y U I O P BS
A S D F G H J K L
Z X C V B N M ENT
Shift
Space
EN

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0
IMM
Signal
10:23
2016/09/06
Mold:00
Run Time:0.0 h
Advance
Admin
Editing: Main
Guide

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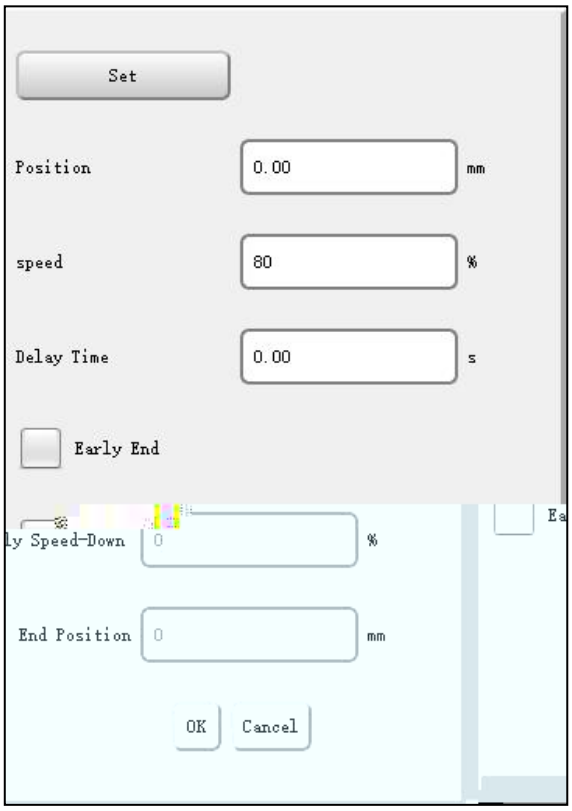
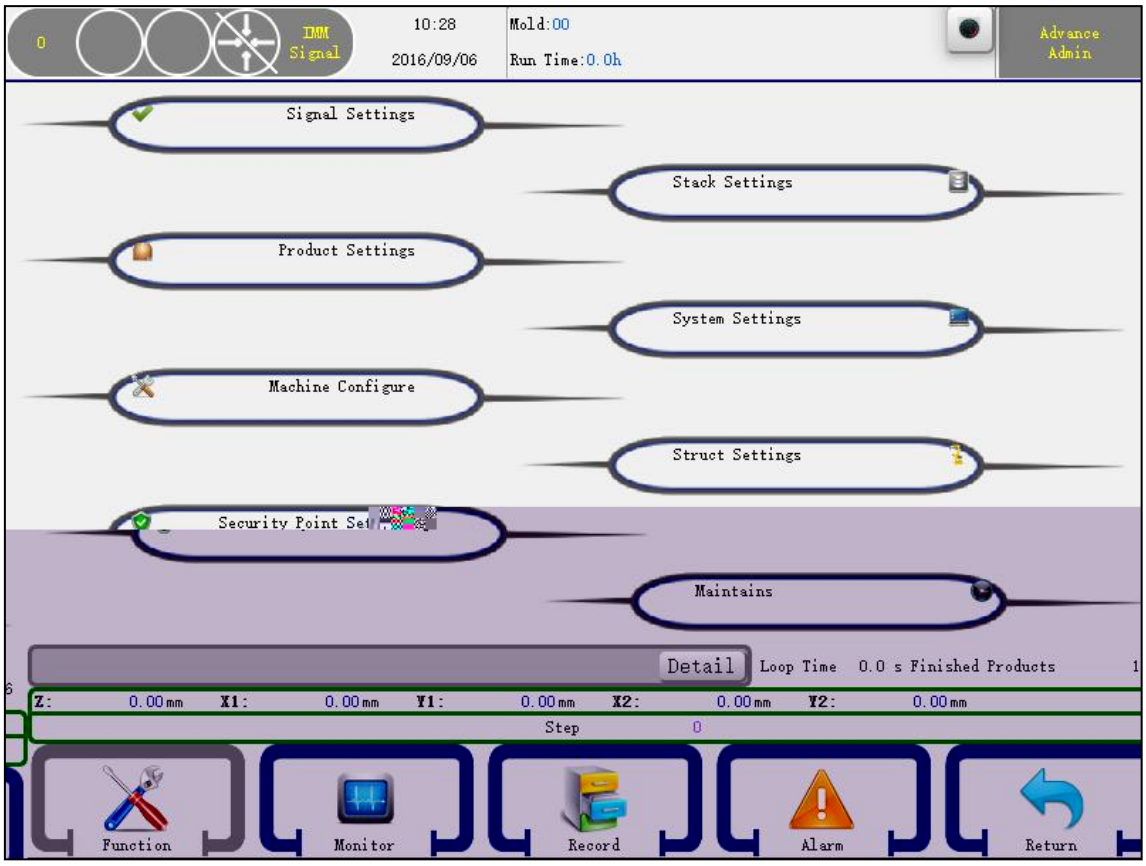
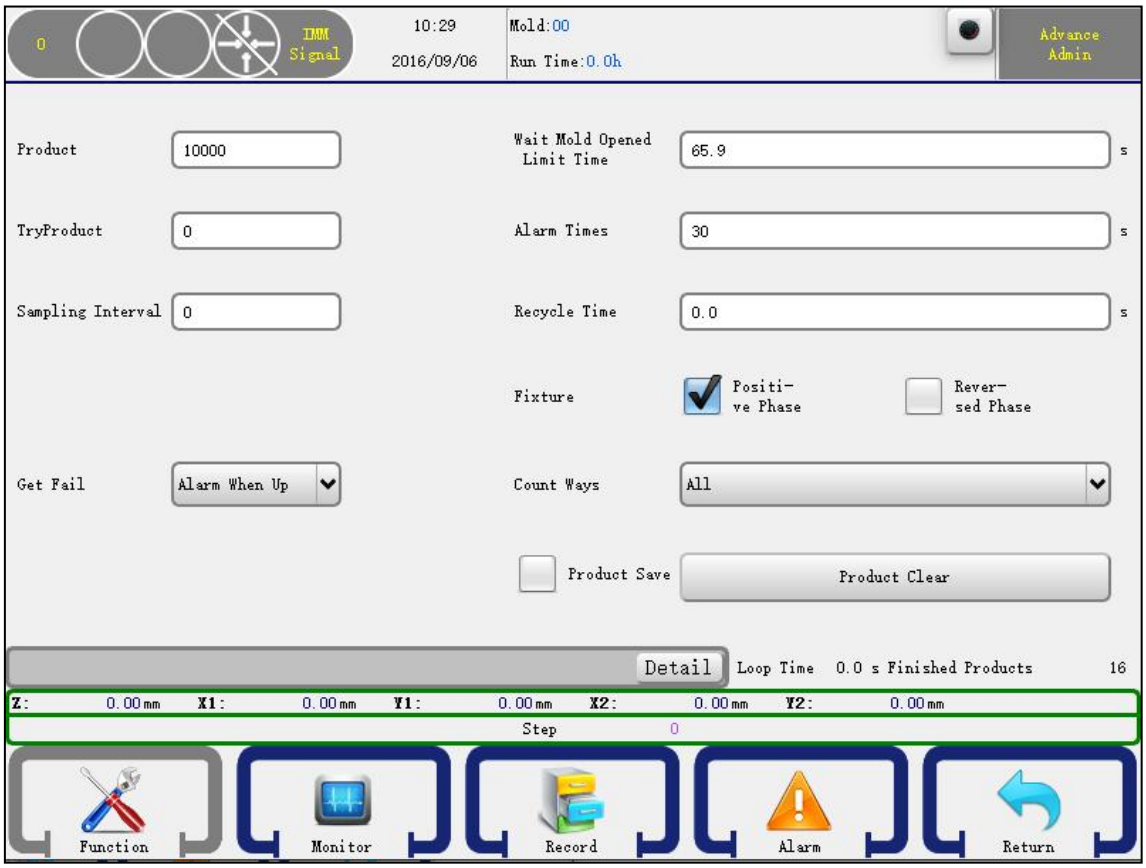
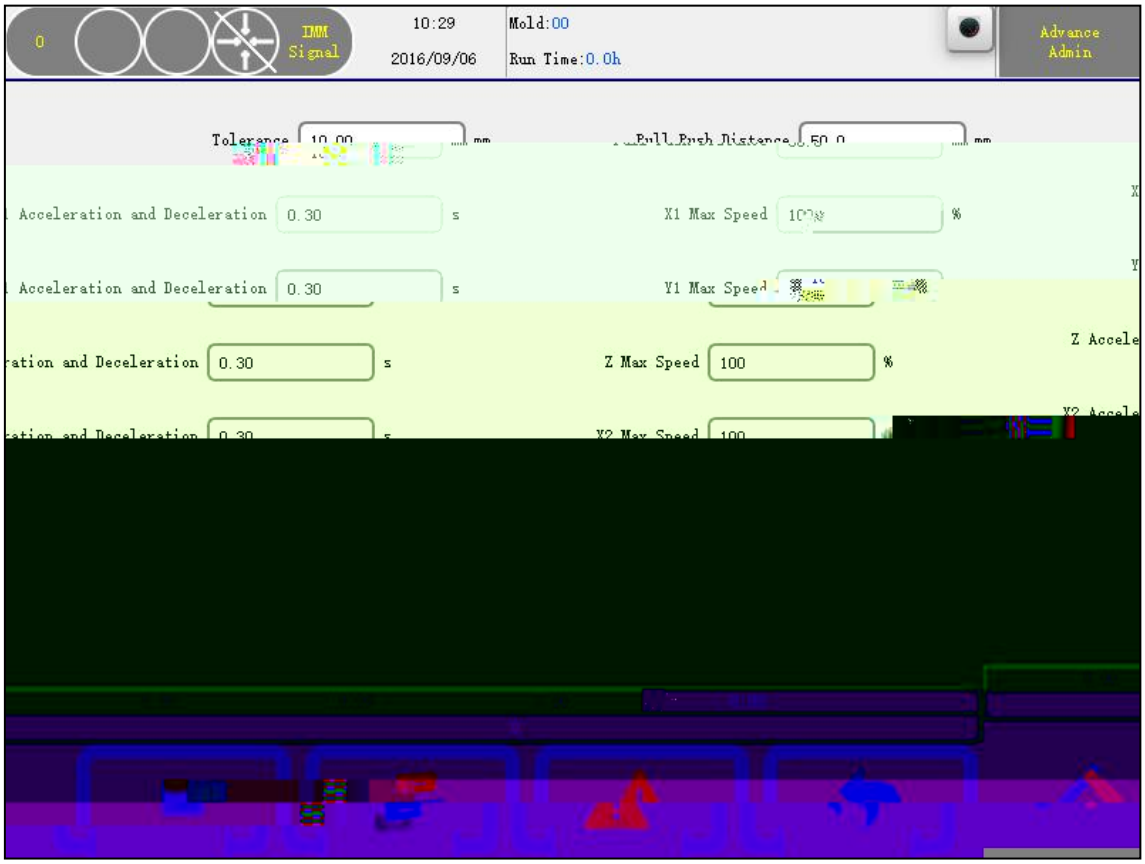
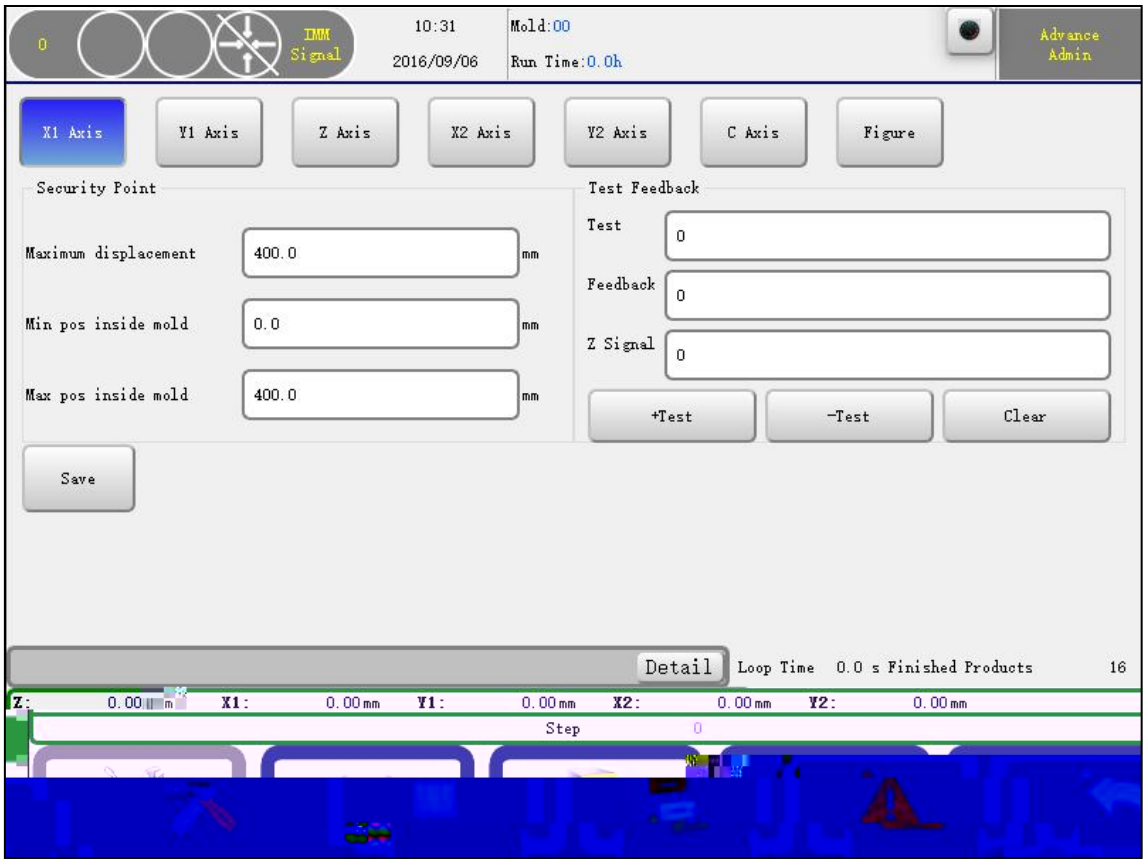

Set
Position
0.00
mm
speed
80
%
Delay Time
0.00
s
Early End
ly Speed-Down
0
%
End Position
0
mm
OK
Cancel

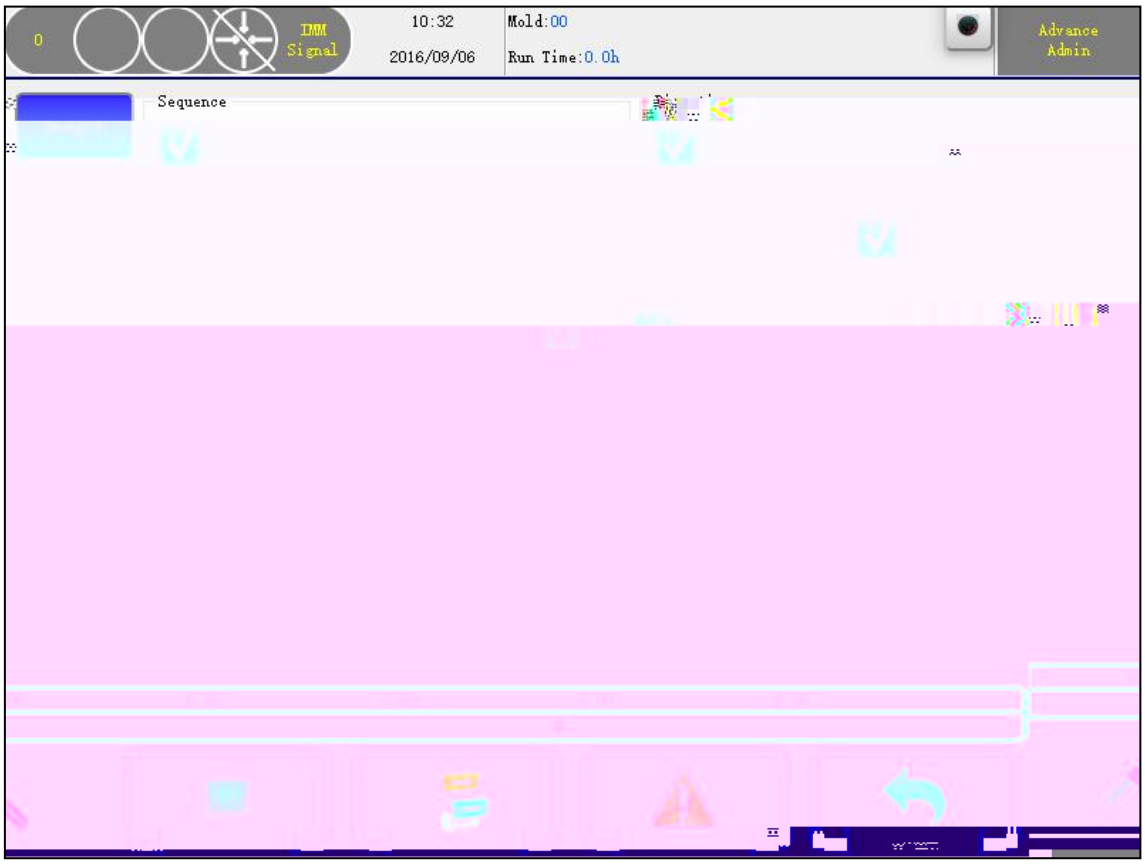

0
IMM
Signal
10:28
2016/09/06
Mold:00
Run Time:0.0h
Advance
Admin
Signal Settings
Stack Settings
Product Settings
System Settings
Machine Configure
Struct Settings
Security Point Set
Maintains
Detail
Loop Time 0.0 s Finished Products 1
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step 0
Function
Monitor
Record
Alarm
Return

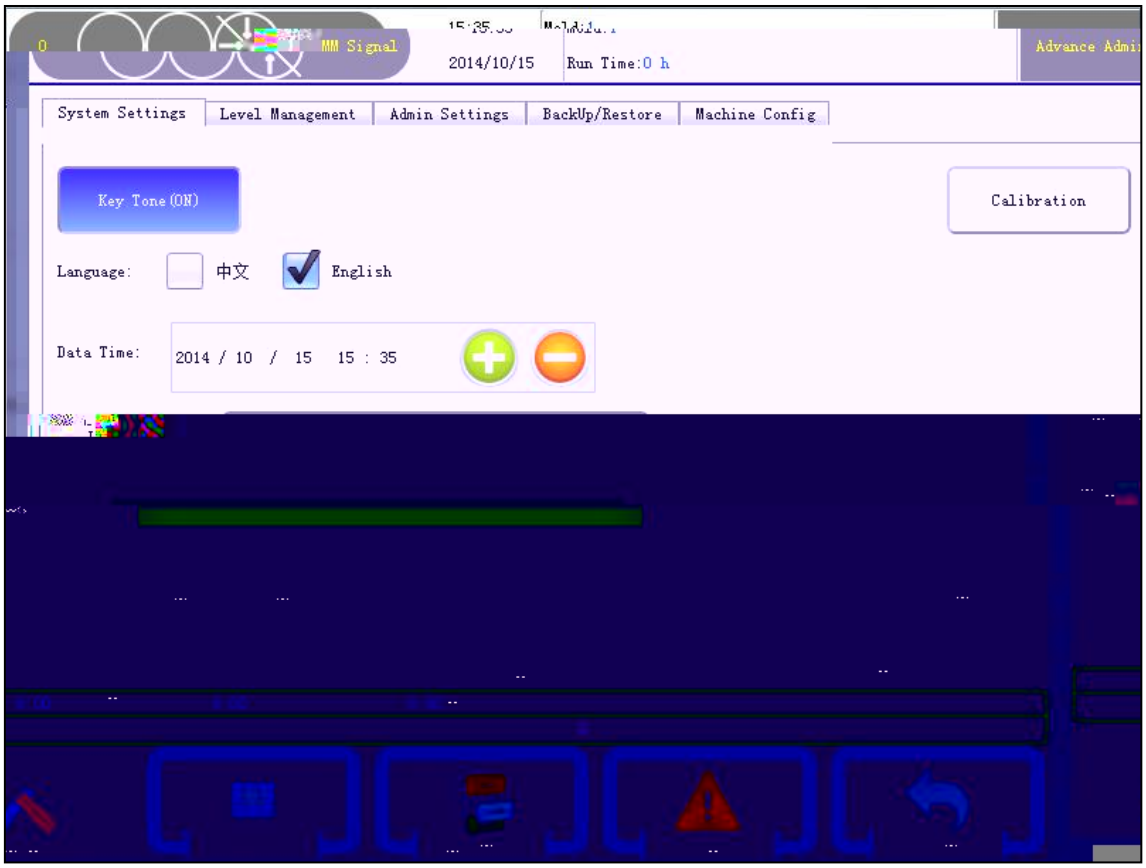
10:28
Mold:00
2016/09/06
Run Time:0.0h
Detect fixture 1
Positi-
ve Phase
Detect Postion
Horizontal
Detect Security Door
Not Use
Detect fixture 2
Positi-
ve Phase
Detect Origin
Don't need Mo.
Detect Pressure
Not Use
Detect fixture 3
Positi-
ve Phase
U/D Position
Vertical
Detect Mid Mold
Not Use
Detect fixture 4
Positi-
ve Phase
Hor Standby
No Limit Lock
Ejection Link Lock
Not Use
Close Mold
Not Use
Auto Run
Not Use
Detail
Loop Time 0.0 s Finished Products
Z: 0.00
X1: 0.00mm
Y1: 0.00mm
X2: 0.00mm
Y2: 0.00mm
Monitor
Record
Alarm
Return


0
IMM Signal
10:29
2016/09/06
Mold:00
Run Time:0.0h
Advance Admin
Product
10000
Wait Mold Opened Limit Time
65.9
s
TryProduct
0
Alarm Times
30
s
Sampling Interval
0
Recycle Time
0.0
s
Fixture
Positive Phase
Reversed Phase
Get Fail
Alarm When Up
Count Ways
All
Product Save
Product Clear
Detail
Loop Time 0.0 s Finished Products 16
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step 0
Function
Monitor
Record
Alarm
Return


IMM Signal
10:29
2016/09/06
Mold:00
Run Time:0.0h
Advance Admin
Tolerance
mm
Pull Push Distance
mm
Acceleration and Deceleration
0.30
s
X1 Max Speed
%
Acceleration and Deceleration
0.30
s
Y1 Max Speed
%
ration and Deceleration
0.30
s
Z Max Speed
100
%
Z Accele
ration and Deceleration
0.30
s
X2 Max Speed
100
%
X2 Accele


0
IMM Signal
10:31
2016/09/06
Mold:00
Run Time:0.0h
Advance Admin
X1 Axis
Y1 Axis
Z Axis
X2 Axis
Y2 Axis
C Axis
Figure
Security Point
Maximum displacement
400.0
mm
Min pos inside mold
0.0
mm
Max pos inside mold
400.0
mm
Test Feedback
Test
0
Feedback
0
Z Signal
0
+Test
-Test
Clear
Save
Detail
Loop Time 0.0 s Finished Products 16
Z: 0.00 mm
X1: 0.00 mm
Y1: 0.00 mm
X2: 0.00 mm
Y2: 0.00 mm
Step 0


0
IMM
Signal
10:32
2016/09/06
Mold:00
Run Time:0.0h
Advance
Admin
Sequence


MM Signal
2014/10/15
Run Time:0 h
Advance Admi
System Settings
Level Management
Admin Settings
BackUp/Restore
Machine Config
Key Tone(ON)
Calibration
Language:
中文
English
Data Time:
2014 / 10 / 15 15 : 35

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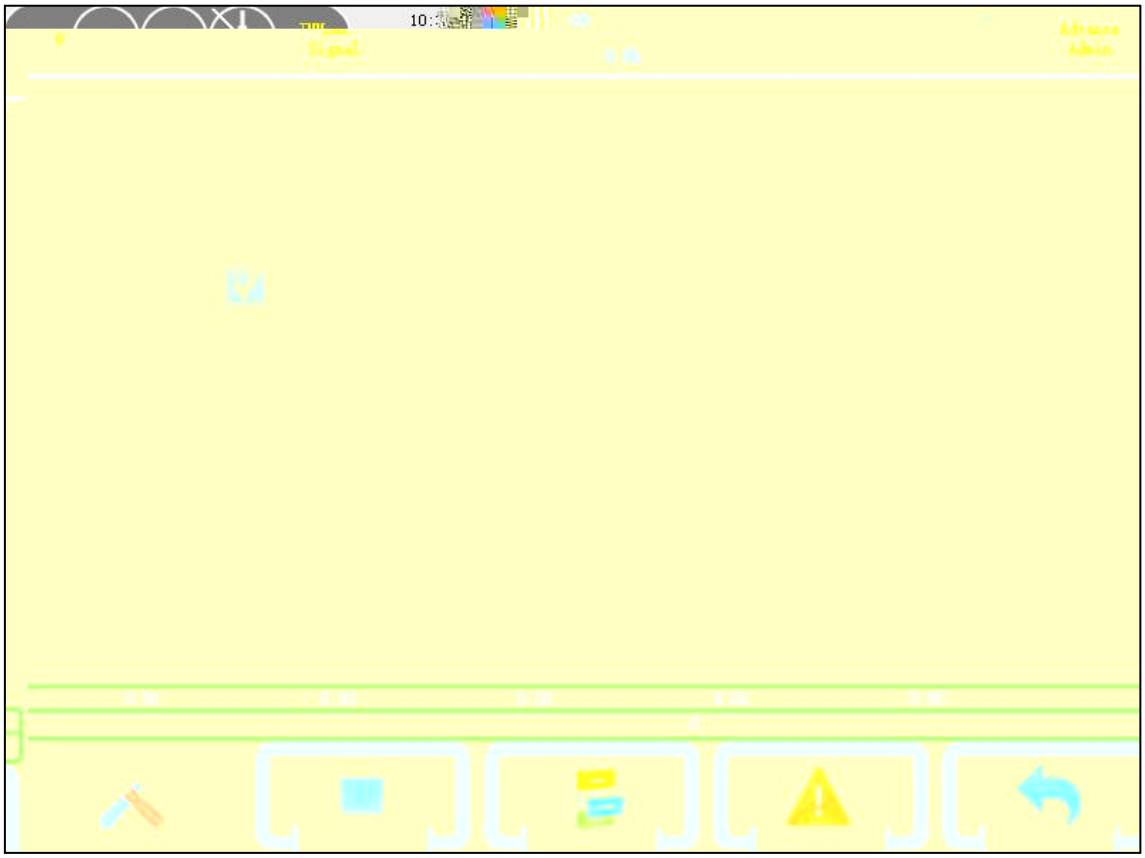

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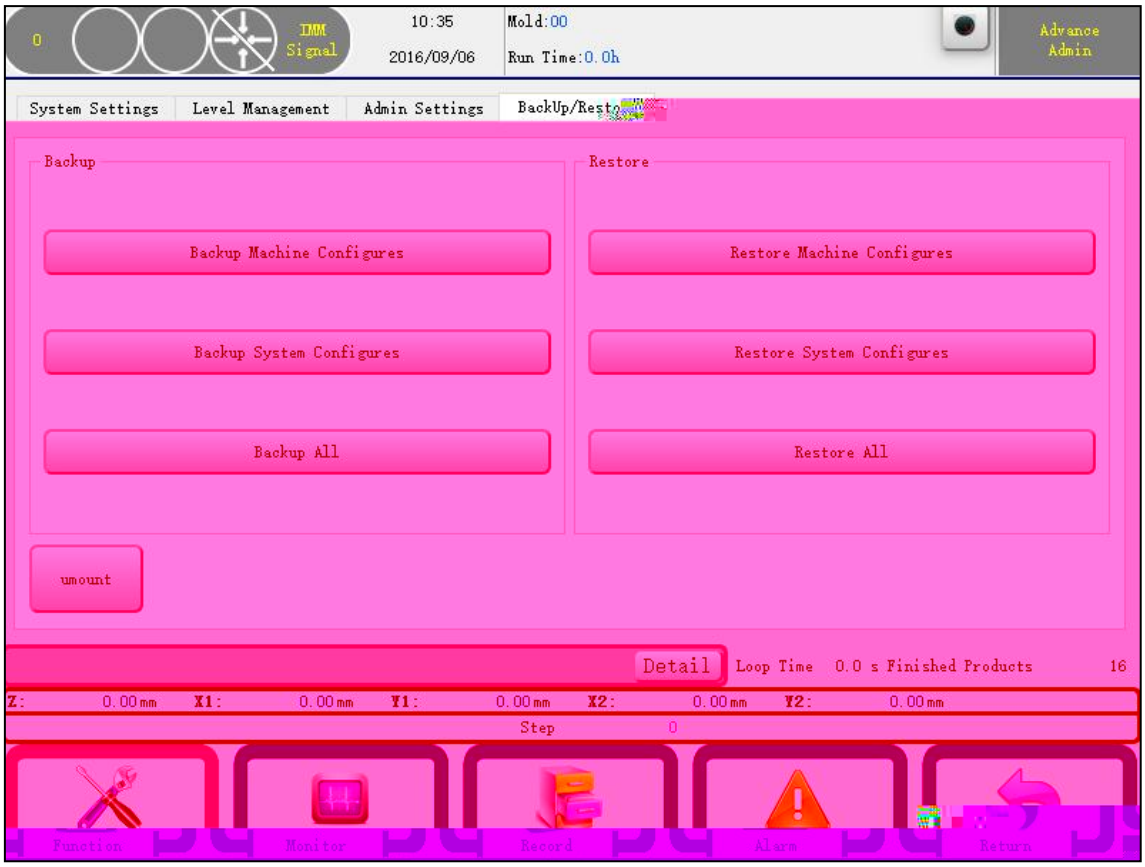
0
IMM Signal
10:35
2016/09/06
Mold:00
Run Time:0.0h
Advance Admin
System Settings
Level Management
Admin Settings
BackUp/Resto
Backup
Backup Machine Configures
Backup System Configures
Backup All
Restore
Restore Machine Configures
Restore System Configures
Restore All
umount
Detail
Loop Time 0.0 s Finished Products 16
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step 0
Function
Monitor
Record
Alarm
Return

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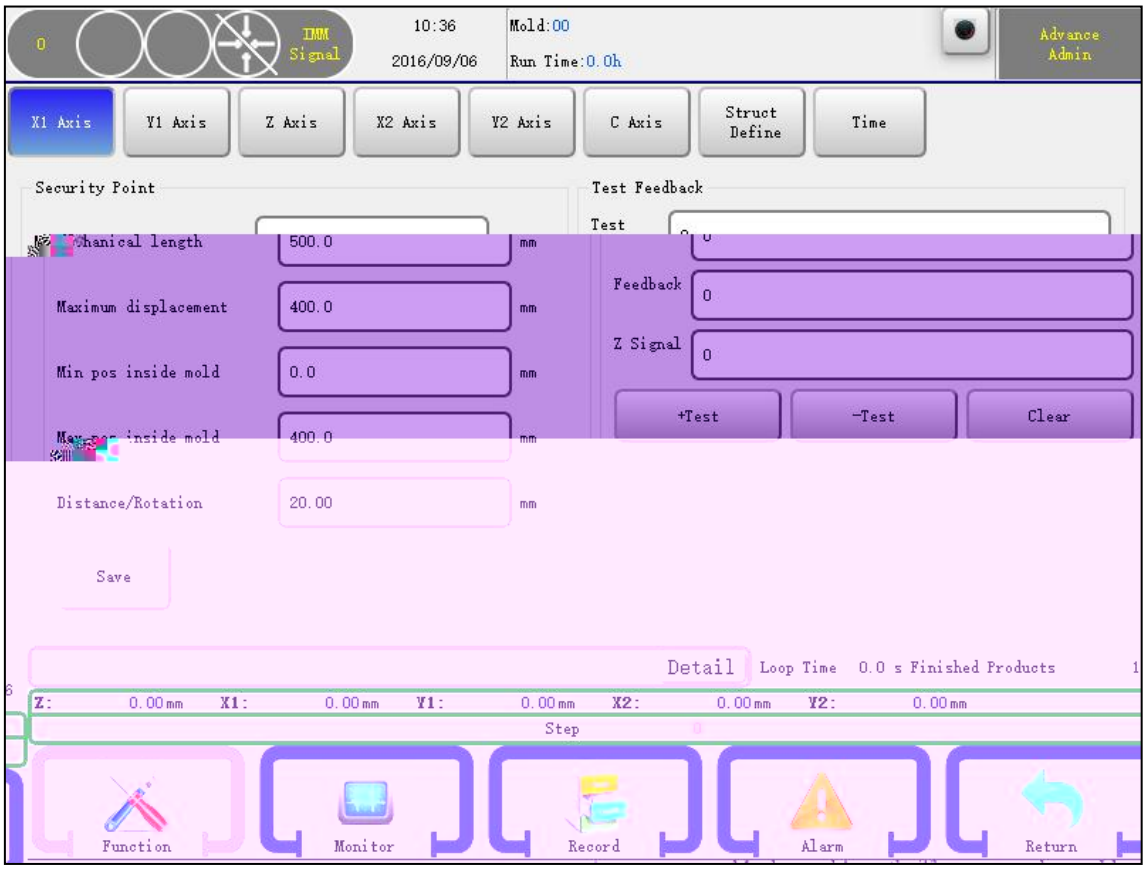
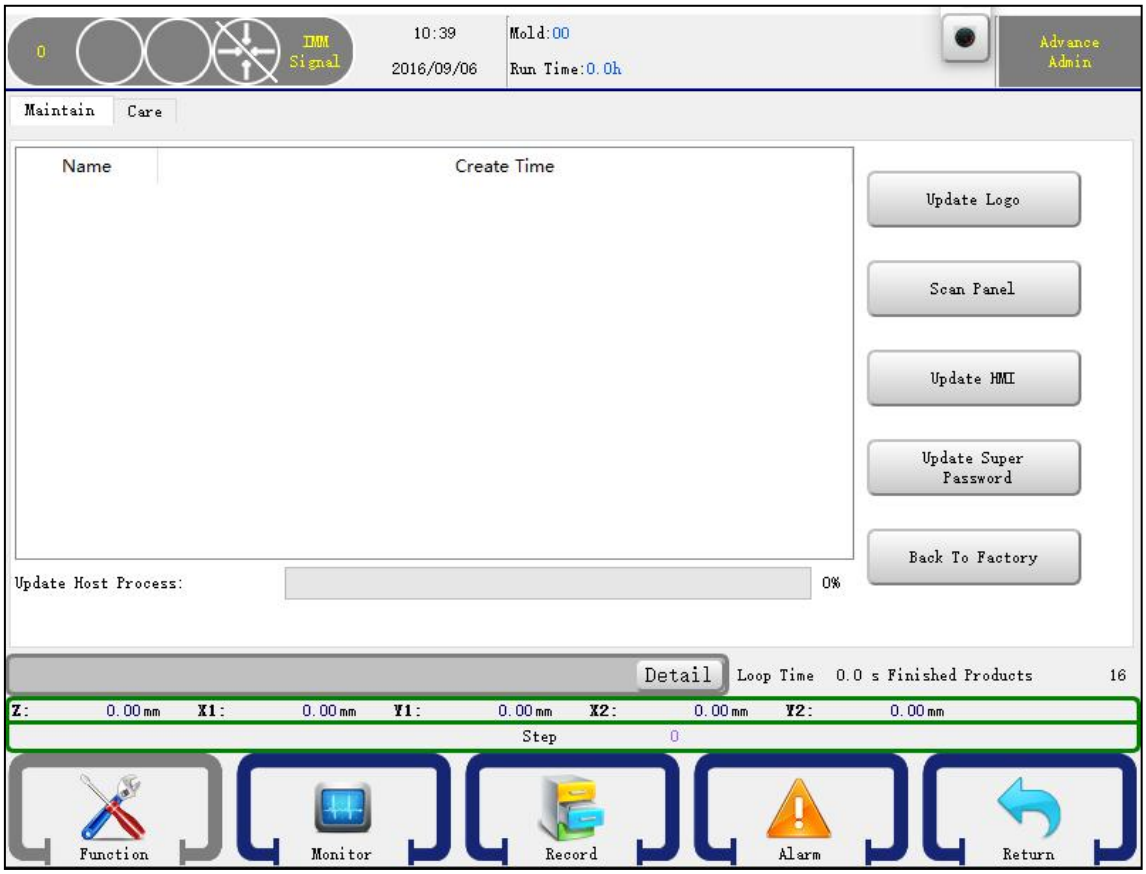

0
IMM Signal
10:36
2016/09/06
Mold:00
Run Time:0.0h
Advance Admin
X1 Axis
Y1 Axis
Z Axis
X2 Axis
Y2 Axis
C Axis
Struct Define
Time
Security Point
Test Feedback
Test
Feedback
Z Signal
+Test
-Test
Clear
Maximum displacement
400.0
mm
Min pos inside mold
0.0
mm
Distance/Rotation
20.00
mm
Save
Detail
Loop Time 0.0 s Finished Products
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step
Function
Monitor
Record
Alarm
Return


0
IMM Signal
10:39
2016/09/06
Mold:00
Run Time:0.0h
Advance Admin
Maintain
Care
Name
Create Time
Update Logo
Scan Panel
Update HMI
Update Super Password
Back To Factory
Update Host Process:
0%
Detail
Loop Time 0.0 s Finished Products 16
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step 0
Function
Monitor
Record
Alarm
Return

0
IMM Signal
15:40
2014/10/15
Mold:1
Run Time:0 h
Advance Admin
Manipulator I/O
Injection Machine I/O
Manipulator I/O
Injection Machine I/O
Input
Output
Input
Output
X010 Horizon-1
X011
X012 Fixture1
X013 Fixture2
X014 Sucker2
X015 Sucker1
X016 X1 Out Limit
X017 X1 In Limit
Y010 Horizon-1
Y011 Vertical-1
Y012
Y013 Fixture2 Valve
Y014 Sucker2 Valve
Sucker1 Valve
Y016 Main Forward Valve
Y017 Adjust Sub Back
Loop Time
0 Finished Products
Z: 0.00mm Y1: 0.00mm Y2: 0.00mm
Step 0
Function
Monitor
Instruct
Alarm
Return

,

10:40
Mold:00
2016/09/06
Run Time:0.0h
Advance
Admin
Alarm History
Modify Log
Alarm Number
Alarm Infomation
Alarm DateTime
Alarm ModifyTime
1 500 Lost contact with MainCtrl! 16-09-01 16:59 no-solve
2 500 Lost contact with MainCtrl! 16-09-01 16:5 no-solve
3 500 Lost contact with MainCtrl! 16-09-01 16:39
4 500 Lost contact with MainCtrl! 16-08-31 16:04 no-solve
5 500 Lost contact with MainCtrl! 16-08-25 11:51 no-solve
6 500 Lost contact with MainCtrl! 16-08-01 11:39 no-solve
7 500 Lost contact with MainCtrl! 16-08-01 11:39 no-solve
8 500 Lost contact with MainCtrl! 16-06-22 16:18 no-solve
9 500 Lost contact with MainCtrl! 16-04-24 20:04
10 500 Lost contact with MainCtrl! 16-04-24 20:03
Detail
Loop Time 0.0 s Finished Products
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step 0

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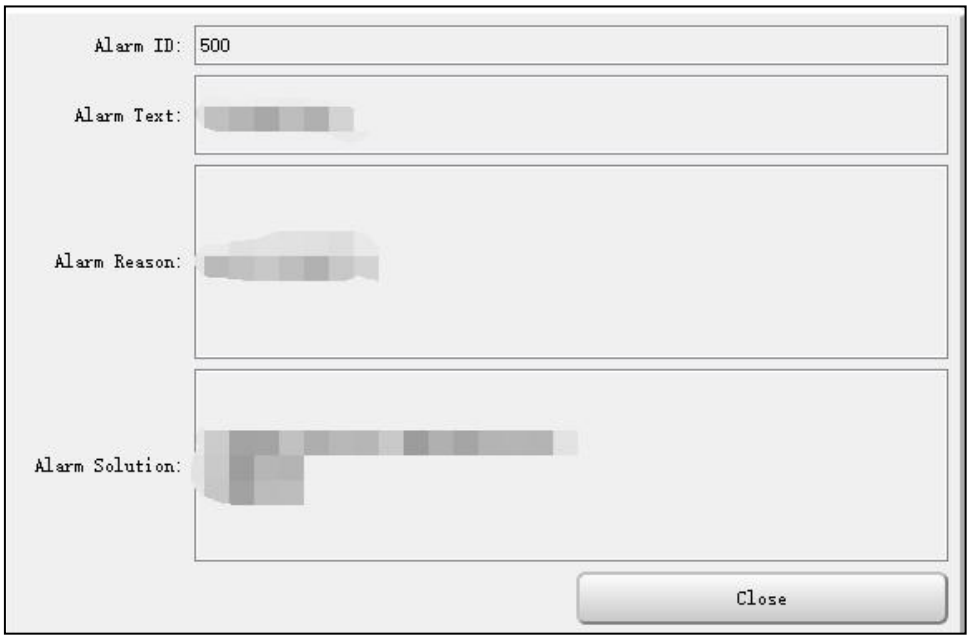
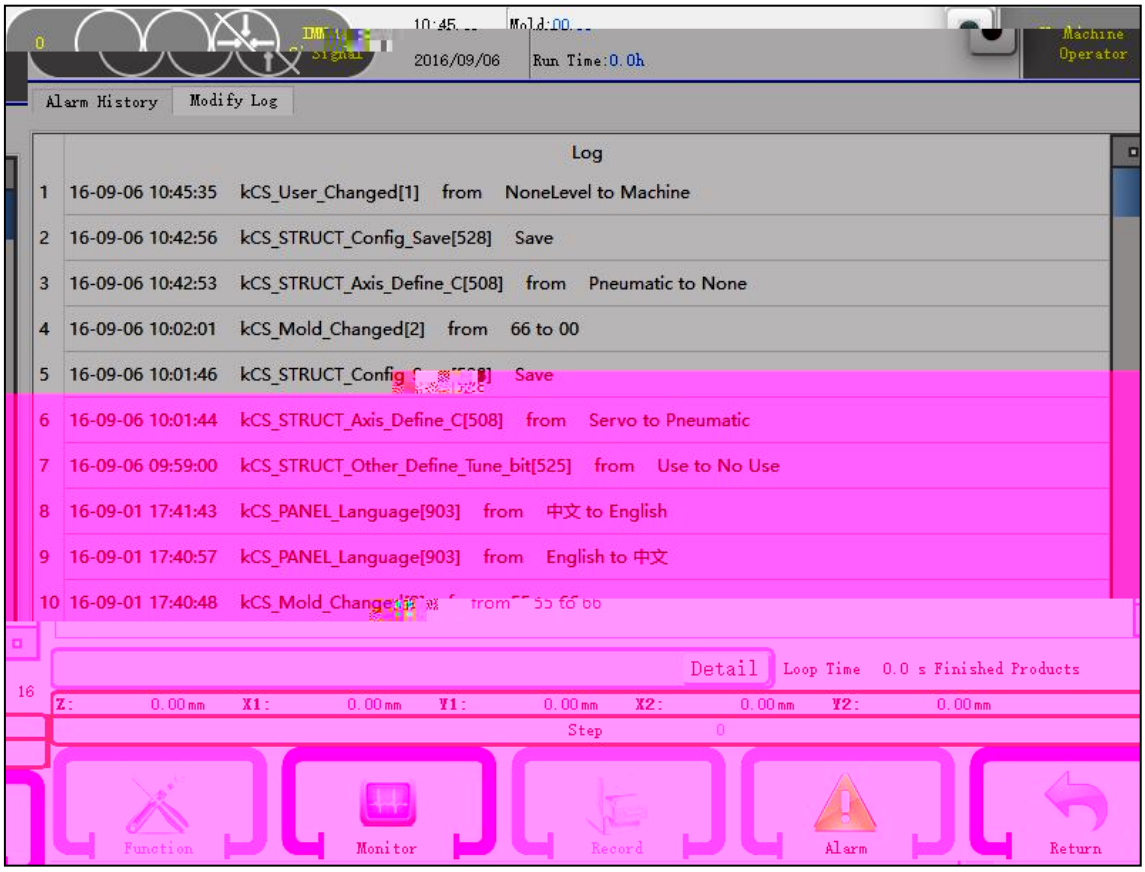

Alarm ID: 500
Alarm Text:
Alarm Reason:
Alarm Solution:
Close


2016/09/06
Run Time:0.0h
Machine Operator
Alarm History
Modify Log
Log
1 16-09-06 10:45:35 kCS_User_Changed[1] from NoneLevel to Machine
2 16-09-06 10:42:56 kCS_STRUCT_Config_Save[528] Save
3 16-09-06 10:42:53 kCS_STRUCT_Axis_Define_C[508] from Pneumatic to None
4 16-09-06 10:02:01 kCS_Mold_Changed[2] from 66 to 00
5 16-09-06 10:01:46 Save
6 16-09-06 10:01:44 kCS_STRUCT_Axis_Define_C[508] from Servo to Pneumatic
7 16-09-06 09:59:00 kCS_STRUCT_Other_Define_Tune_bit[525] from Use to No Use
8 16-09-01 17:41:43 kCS_PANEL_Language[903] from 中文 to English
9 16-09-01 17:40:57 kCS_PANEL_Language[903] from English to 中文
Detail
Loop Time 0.0 s Finished Products
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm
Step
Function
Monitor
Record
Alarm
Return

22	–	
23		
24	–	
2 00		– 100
2 00		– 100
2 00		– 100
0 00		– 100
1 00		– 100
2 00		– 100
3		
4	–	
	–	–
0 2 00		– 2 100
1 2 00		– 2 100
2 2	2 –	2

3 2	2	2
100		1 , (– – 〃 〃), ( ) 2 , , . (10000, 3)
101		
102		
10 –		1. – .
10 –		2. , , .
10 –		3. , . .
112		1. .
113		2. , .
114		
11		
11		
11		

11		1. ,
11		
120		.
121		2. ,
122		
123		
124		
12 –		
12		
12		
12		
12		
130	.	– _ ″ ″
131	.	– _″ ″
132	.	– _″ ″

133		– .
134		– _ ″ ″
13		– _″ ″
13		– _″ ″
13		– .
1 0 2		1. , (– – ″ ″), ( ) 2. , , . (10000, 3)
1 1 2		
1 4 2 –	2	1. – .
		2. , , .
1 2 –	2	3. , .

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1 2	2	1. . 2. , .
1 2	2	
1 0 2	2	
1 1 2	2	
1 2 2	2	1. ,
1 3 2	2	
1 4 2	2	. 2. ,
1 2	2	
1 2		
1 2		
1 2		
1 2		
1 0 2	2 .	– –″ 2 ″
1 1 2	2 .	– –″ 2 ″
1 2 2	2 2	– –″ 2 ″

21		
21		1. , .
21		2. ,
220		
221		
222		
223	–	
224		
22		
22 –		
22 –		
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22		
230	.	– _″ ″
231	.	– _″ _ ″

232 .

234

23

23

300

301

302

304 1.

31	– , – , 10	10
31	,	
320	.	
323		
32	.	.
32		
330 ,	–	
332 ,	– –	
333 ,	– –	
3 0 2	.	–
3 1 2		
3 2		
3 3		
3 4		
3		

00		1. 2. 3.
01 /		1. 2. 3. 4.
02		1. - 2. , - 0
03		1. 2. , -
04		
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0		1. 2. -

00 , –	, ( )	1. – 2. –
02 , –	, ( )	1. – 2. –
04 – ,	( ),	1. –
0 ,	, .	2.
0 2	(2), 2	2 .
00 043		1.
01 044		2.
02 1		
03 2		
04 3		

0 4		
0 1		
0 2		
0		
0		
10		
11		
1000	1. , 2. 1 , 1 – – ( )	1. 2. , –
1001	1. 1 , 1 – , ( )	1. 2.
1002	1. 1 , 1 – , 2. , , (–)	1. 2.

1003 –		
1004		
100	1. – , 1 2. 3. 4. 1 ( ), , 1 .	1. 2. 3.
100 1	1. , , – , 1 2. , – , – , 1 3. , , 1	1. 1 2.
100	1 , 1 –	1. –

100 –	1 , 1 –	1. –
100	1 , 1 – ,	1. 1 2.
1010 1	1 , – ,	1. 1 2.
1011 1	1 , – ,	–
1012	1 2	1. 1 2 2. 1 2
1013		
1014		
101		
101		
101		1.

		2.
101	,	1. 2. , , ,
1020 , –	,	1. 2. , –
1021 ,	,	1.
1022 ,	,	2. , –
1023 ,	,	1.
1024 ,		2. , –

102 , 2	1. , , – , 2 2. , – , , – , 2 3. , , 2	1. 2 2.
102 –		1. – 2. , – –
103	,	
103 –		
1040		. ,
10 4	– –	
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10 2 2		
10 2 2		
10		
10 0		

10 1		
1100	,	1. 2.
1101	,	1. 2.
1102	,	
1103	, ,	
1104 , –		1. 2.
110 , –	,	1. 2.
110		1. 2. 3. , – –

110	,	1. 2. 3. , – –
110	,	1. 2. , –
110	,	1. 2. , –
1120		
1121		
1122	,	
1123	,	
1124	,	

112	,	
112 ,	,	1. 2.
112 ,	– ,	1. 2.
1140 , –	, 	1. 2. 3. , – –
1141 , –	, –	1. 2. 3. , – –
1142 ,	,	1. 2. 3. , – –

1143

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114

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114 , –	,	1. 2. 3. , – –
11 0 1 ,	1. , – , 1 2. , – , 1 / 3. , – , 1 /	
11 1 1 ,	1. , – , 1 2. , – , 1 / 3. , – , 1 /	
11 2 1 ,	1 , ,	

11 3 1 , 1	1 , 1	1. 1 2. 1
11 4 1 , 1	1 , 1	1. 1 2. 1
11 ,	,	1. 2.
11 0 2 ,	1. , – , 2 2. , – , 2 / 3. , – , 2 /	
11 1 2 ,	1. , – , 2 2. , – , 2 / 3. , – , 2 /	

11 2 2 2
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11 3 2 2 , 2 1. 2
, 2 2. 2

11 4 2 2 , 1. 2
, 2
2 2.
2

11 0 ,

11 1 ,

11 2 1.

2.

11 3 1.
2.

11 ,
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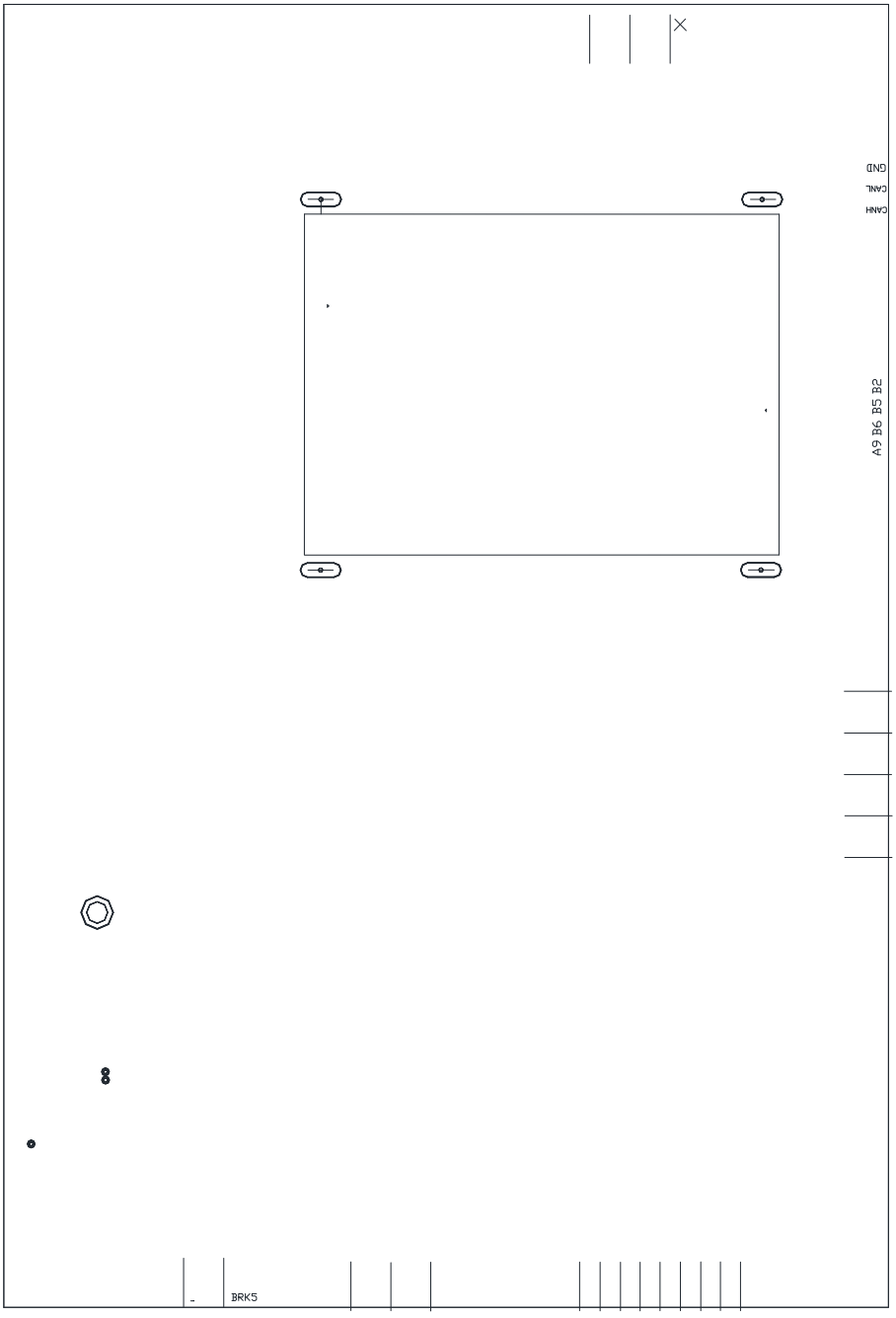
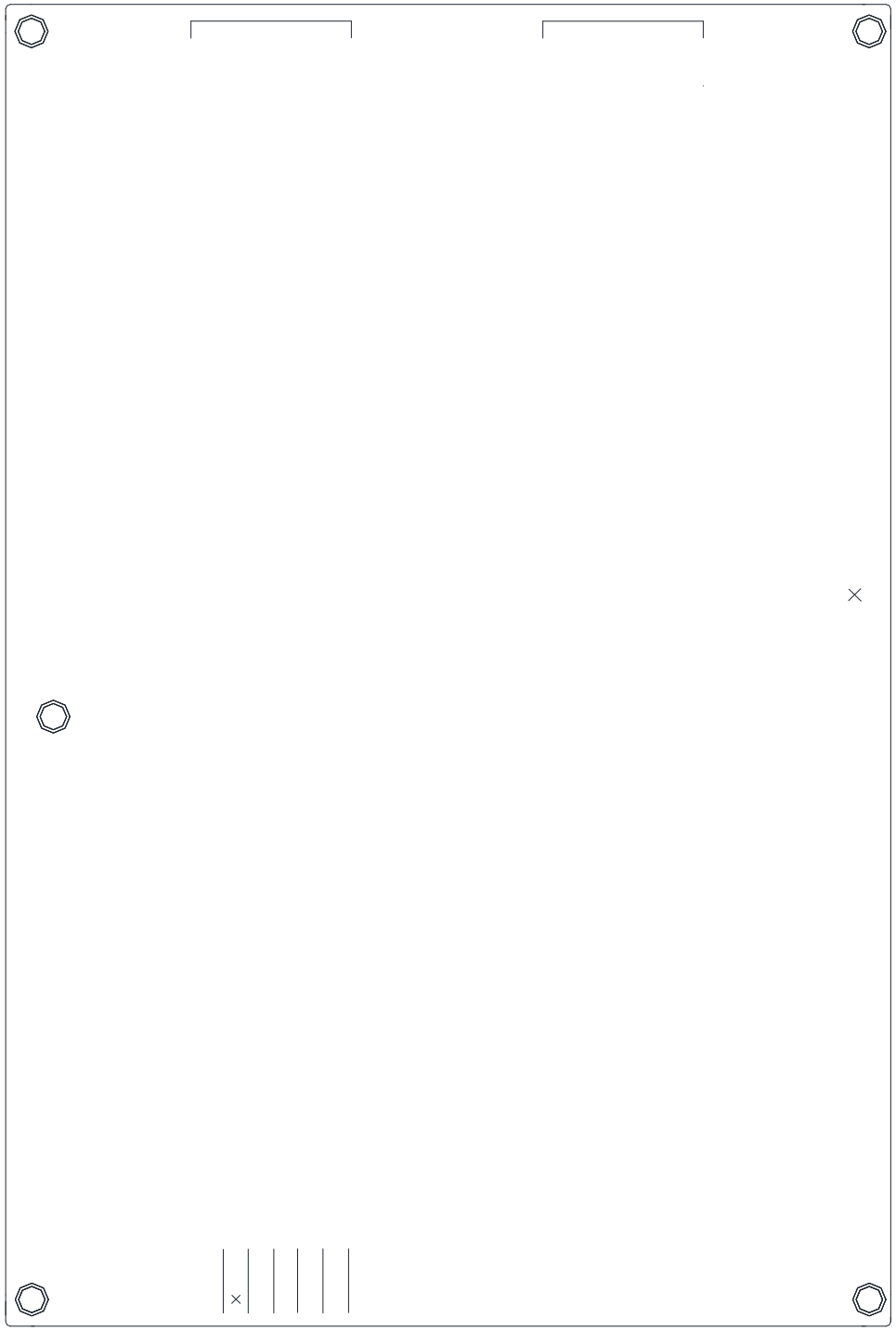
11 – ,	– , – ,	
11 – , 1	– , – , 1	–
11 , ,	, , ,	
11 0 , ,	, , ,	
11 1 – ,	– , 1	1. 2. 0 0
11 2	, ,	–
11 3	,	
1200 1 , 1	1. , 2. ,	
1201 1 , 1		

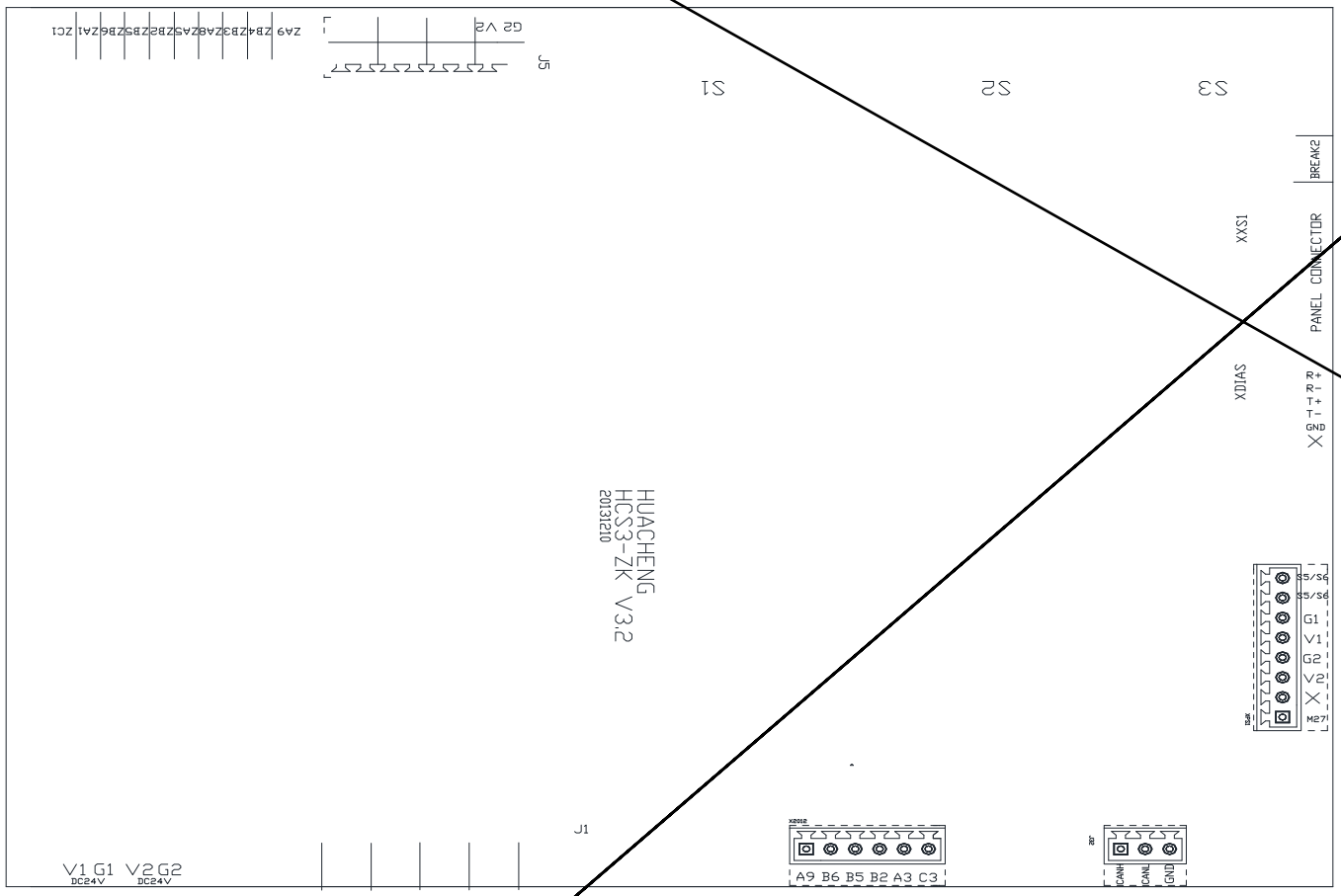
1202 2 – , 2		
1203 2 , 2 –		
1204 3 , 3		
120 3 , 3 –		
120 4 , 4		
120 4 , 4 –		
120 1 , 1		
120 1 , 1		
1210 2 , 2		
1211 2 , 2 –		
1212 3 , 3		
1213 3 , 3 –		
1214 4 , 4		
121 4 , 4 –		
1300		

1301	1. 1	1. – 1
	2. , 1	2.
1302	1. 2	1. – 2
	2. , 2	2. 2
1303 –		 0
1304 –	,	
130		 0
130 1	, , 0 .	
130 2		
130 3	, , .	
130 4	, , . , , ,	

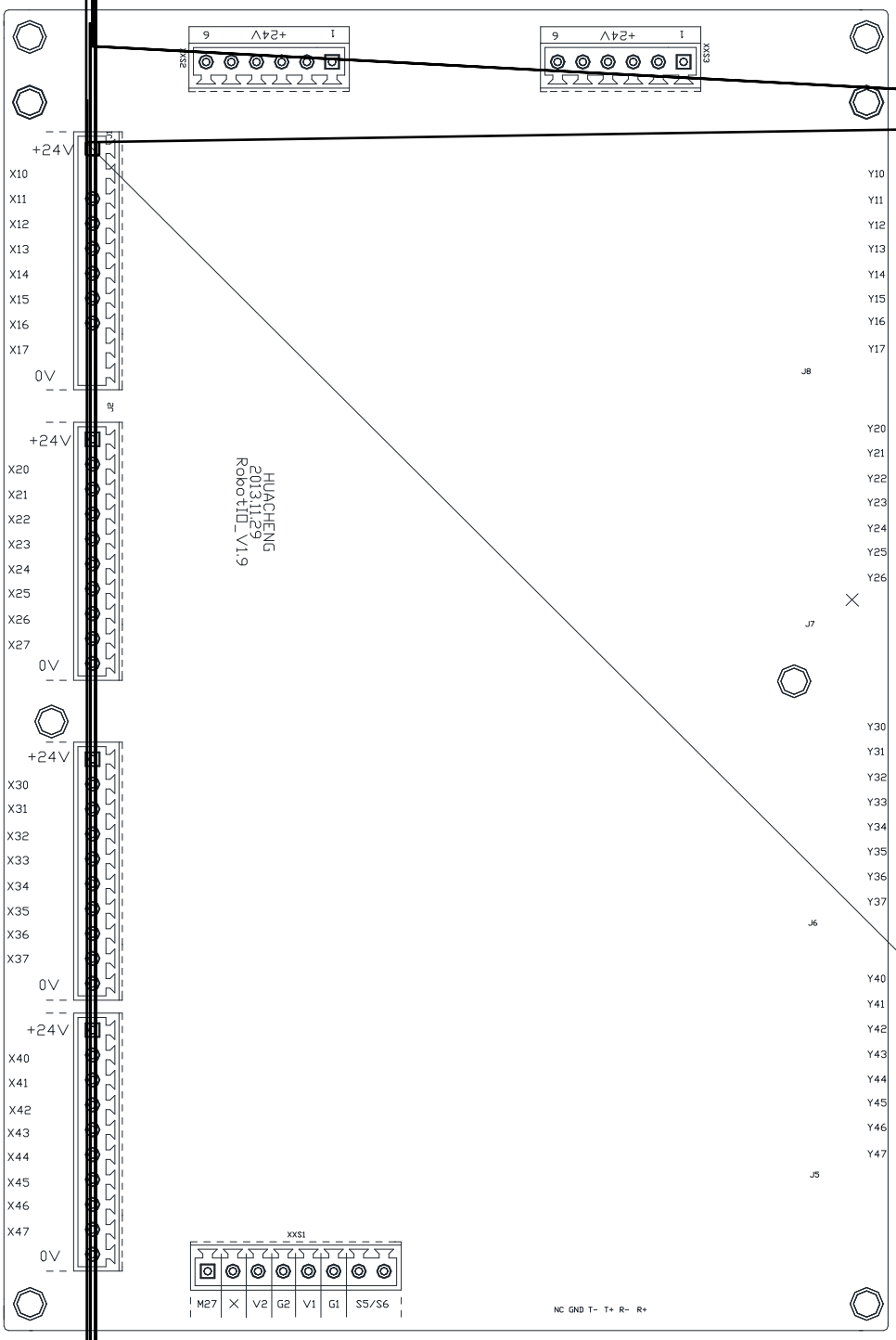
	, , , – . , , .	
1310 1		
1311 2		
1312		
1313		
1314		
131 2		
131 2		
1400	, . , ,	1. 2.
1403 2	, . , ,	1. 2.


GND
CANL
CANH
A9 B6 B5 B2
BRKS

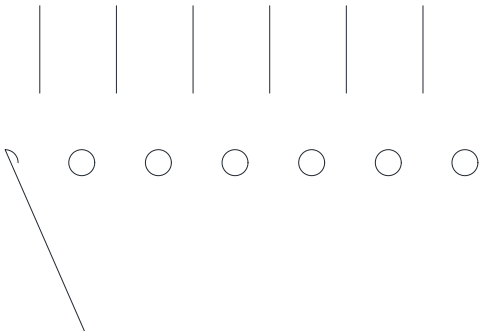


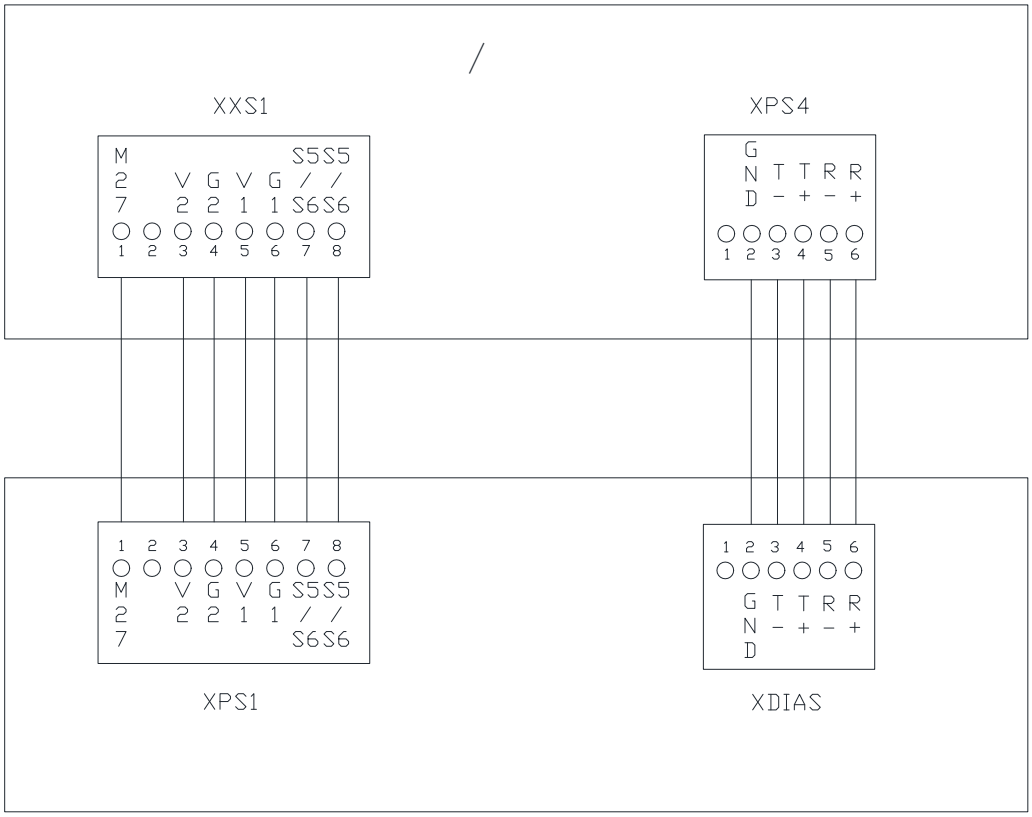

HUACHENG
HCS3-ZK V3.2
20131210
PANEL CONNECTOR
XXS1
XDIAS
BREAK2
S1
S2
S3
J5
J1
V1 G1 V2 G2
DC24V DC24V
A9 B6 B5 B2 A3 C3
CANH
CANL
GND
G1
V1
G2
V2
M27

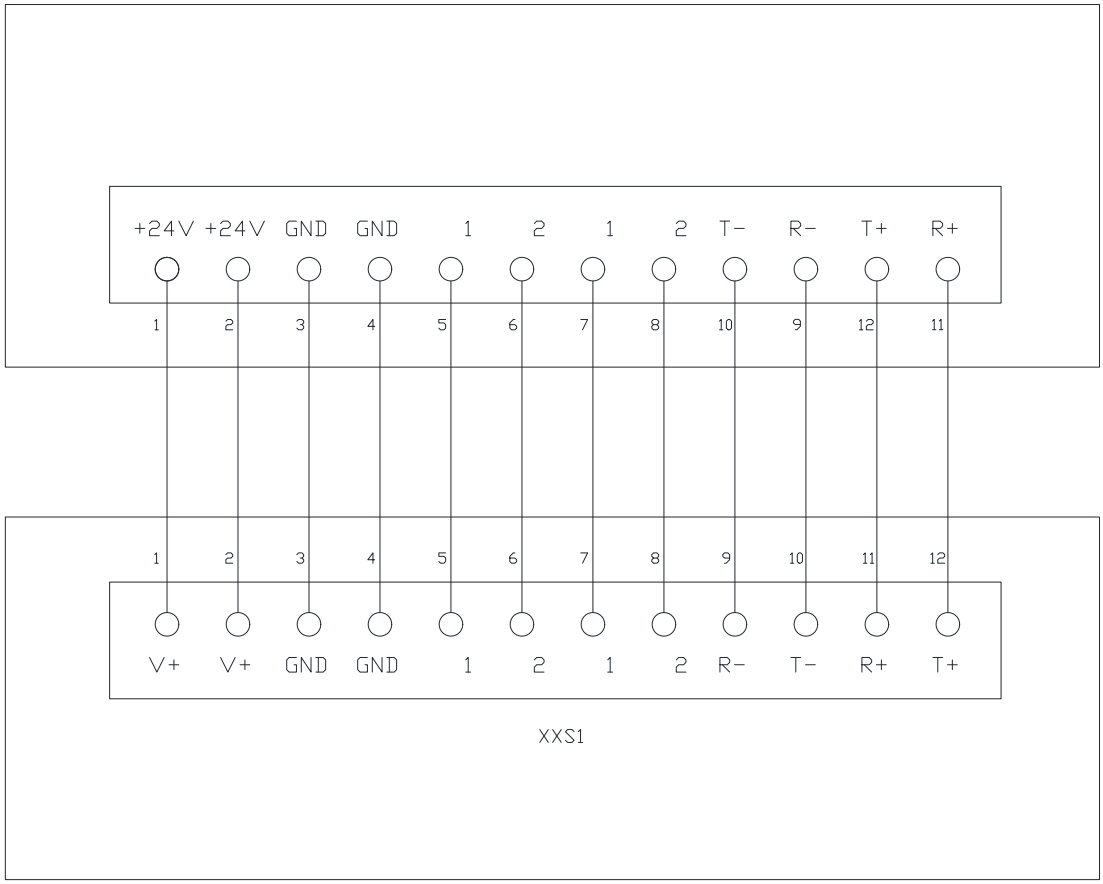
.4



+24V
X10
X11
X12
X13
X14
X15
X16
X17
0V
+24V
X20
X21
X22
X23
X24
X25
X26
X27
0V
+24V
X30
X31
X32
X33
X34
X35
X36
X37
0V
+24V
X40
X41
X42
X43
X44
X45
X46
X47
0V
HUACHENG
2013.11.29
RobotIO_V1.9
Y10
Y11
Y12
Y13
Y14
Y15
Y16
Y17
J8
Y20
Y21
Y22
Y23
Y24
Y25
Y26
J7
Y30
Y31
Y32
Y33
Y34
Y35
Y36
Y37
J6
Y40
Y41
Y42
Y43
Y44
Y45
Y46
Y47
J5
XXS1
M27
V2
G2
V1
G1
S5/S6
NC GND T- T+ R- R+




XXS1
M 2 7
V 2
G 2
V 1
G 1
S5/S6
S5/S6
1 2 3 4 5 6 7 8
XPS4
GND
T −
T +
R −
R +
1 2 3 4 5 6
1 2 3 4 5 6 7 8
M 2 7
V 2
G 2
V 1
G 1
S5/S6
S5/S6
XPS1
1 2 3 4 5 6
GND
T −
T +
R −
R +
XDIAS


+24V +24V GND GND 1 2 1 2 T- R- T+ R+
1 2 3 4 5 6 7 8 10 9 12 11
1 2 3 4 5 6 7 8 9 10 11 12
V+ V+ GND GND 1 2 1 2 R- T- R+ T+
XXS1

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0.0		1
0.0		0
0.0		1
0.0		10000
0.11		2 00

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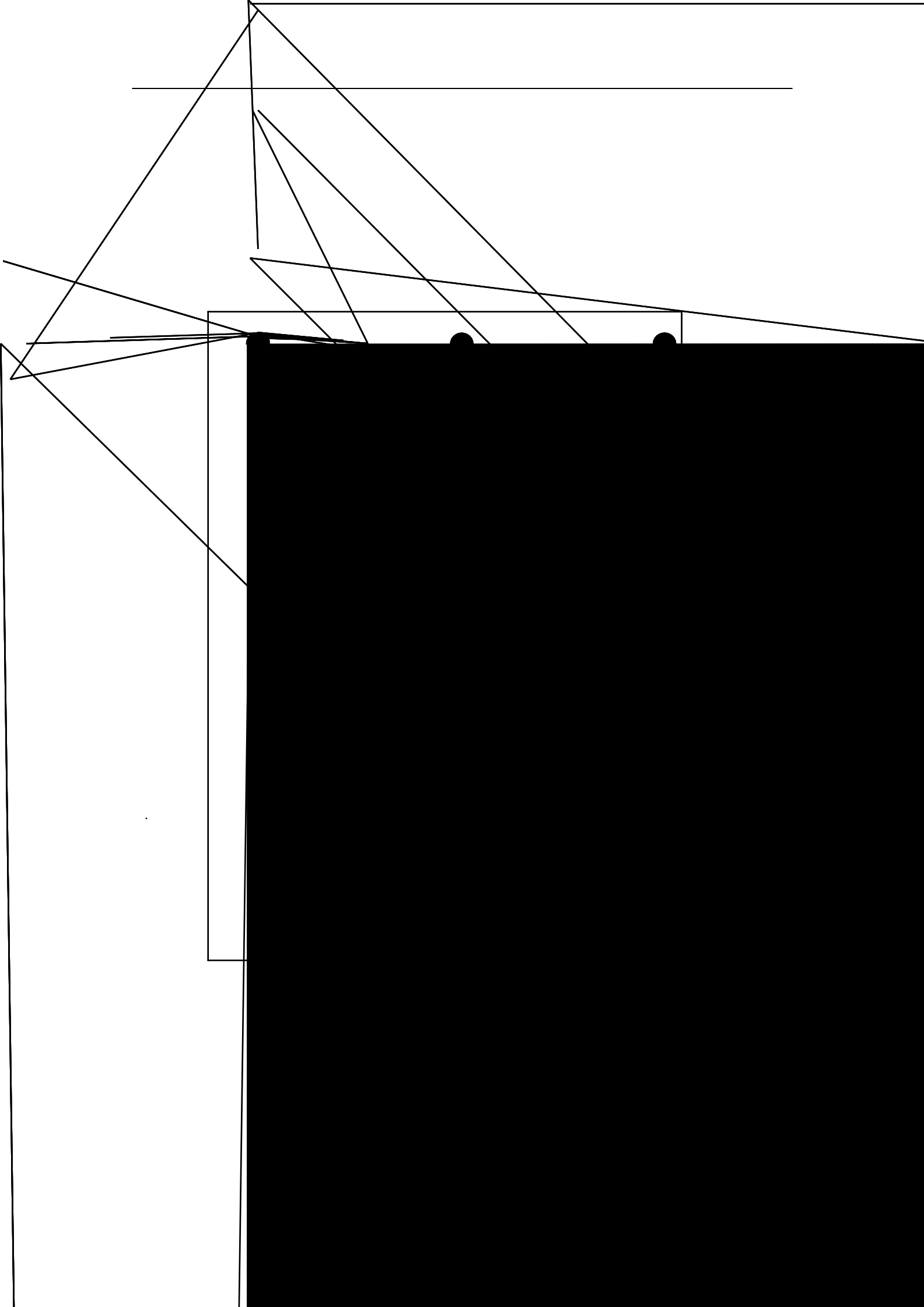
1	+		3	1	1
2	–		4	2	
3	+			1	2
4	–			2	
	+		21	+	
	–		22	–	
	+		4	+	
	–		4	–	
	+		23	+	
10	–		24	–	
13			13		
2	+24	+24		+	+
2	0		41	–	–
			3	–	
1			3	+	
23		–	2	–	–

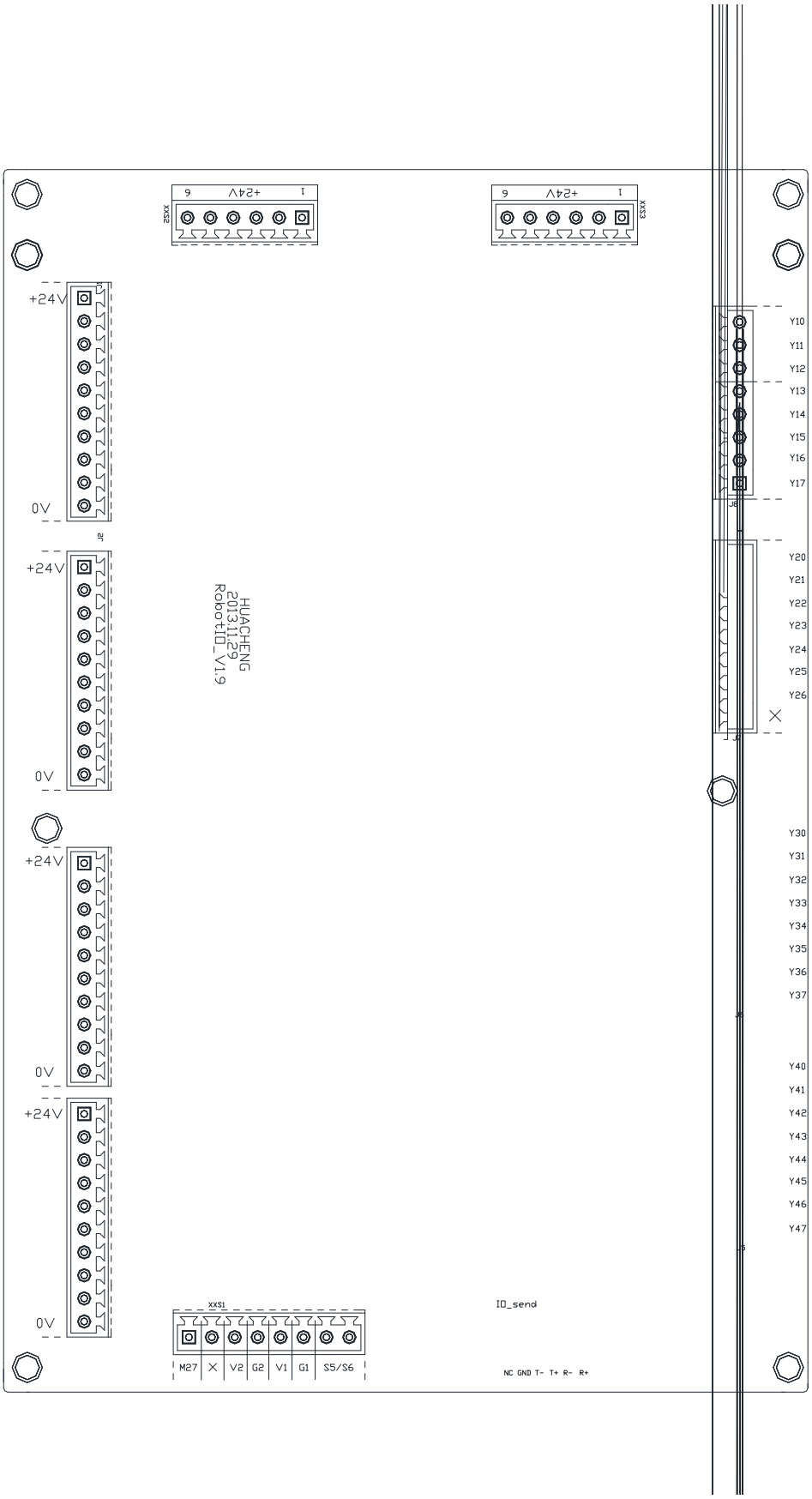
–

1310 2 /

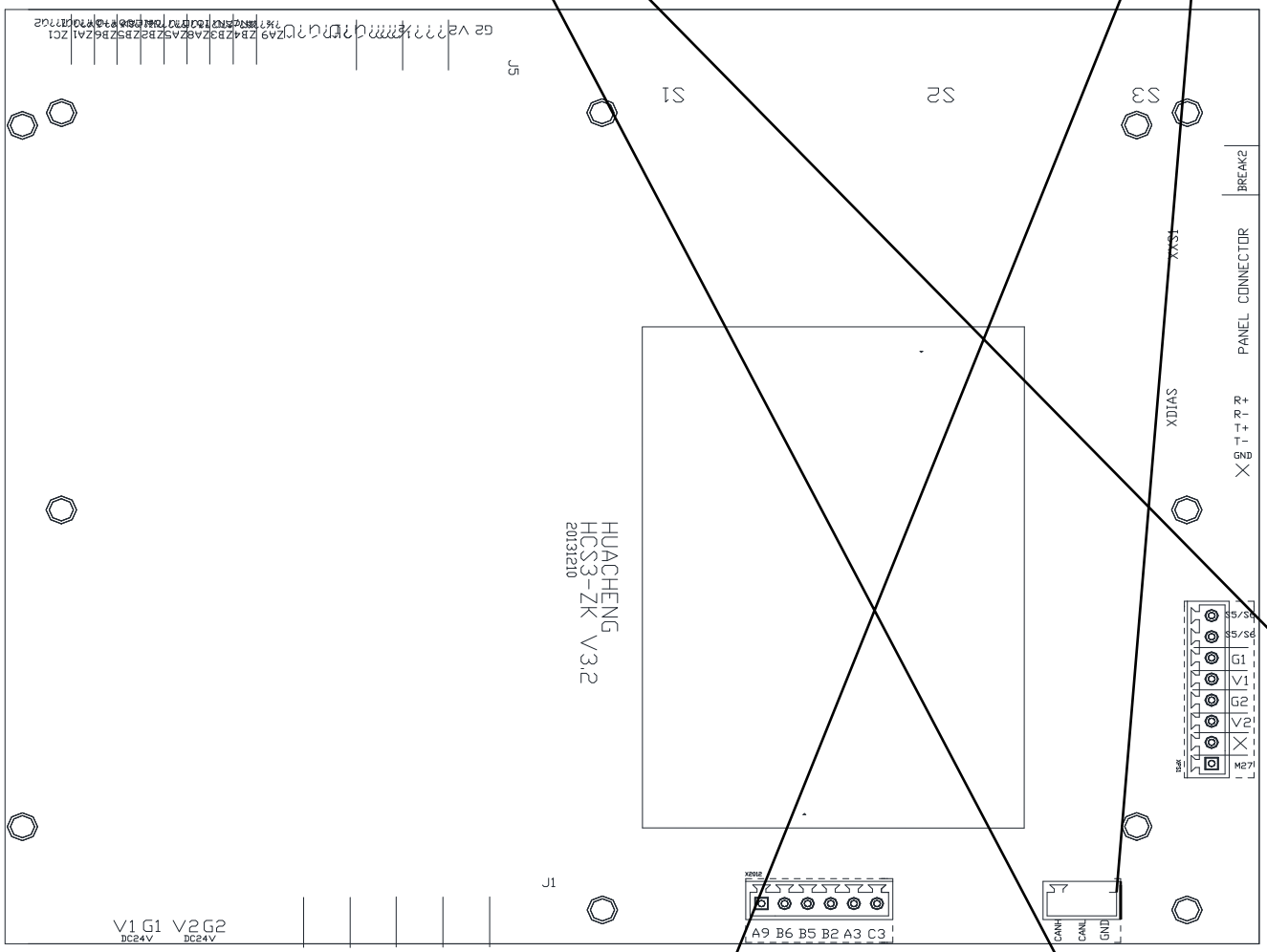
.0		***0
.1		0012
.3		14
.4		1
.21		0000
.2		14
. 4		1***

			–		
1	+		23		1
2	–		22		
3	+		2		2
4	–		24		
	+		1		
	–		1		
	+		1		
	–		1		
	+		1		
10	–		20		
13			14		
2	+24	+24	1		24 +
2	0		13		24 –
1					
23		–	4		–





+24V
0V
HUACHENG
2013.11.29
RobotIO_V1.9
XXS1
M27
V2
G2
V1
G1
S5/S6
IO_send
NC GND T- T+ R- R+
Y10
Y11
Y12
Y13
Y14
Y15
Y16
Y17
Y20
Y21
Y22
Y23
Y24
Y25
Y26
Y30
Y31
Y32
Y33
Y34
Y35
Y36
Y37
Y40
Y41
Y42
Y43
Y44
Y45
Y46
Y47


HUACHENG
HCS3-ZK V3.2
20131210
PANEL CONNECTOR
BREAK2
XDIAS
J1
J5
S1
S2
S3
V1 G1 V2 G2
DC24V DC24V
A9 B6 B5 B2 A3 C3
CANH CANL GND