

X 輸入點 Y 輸出點

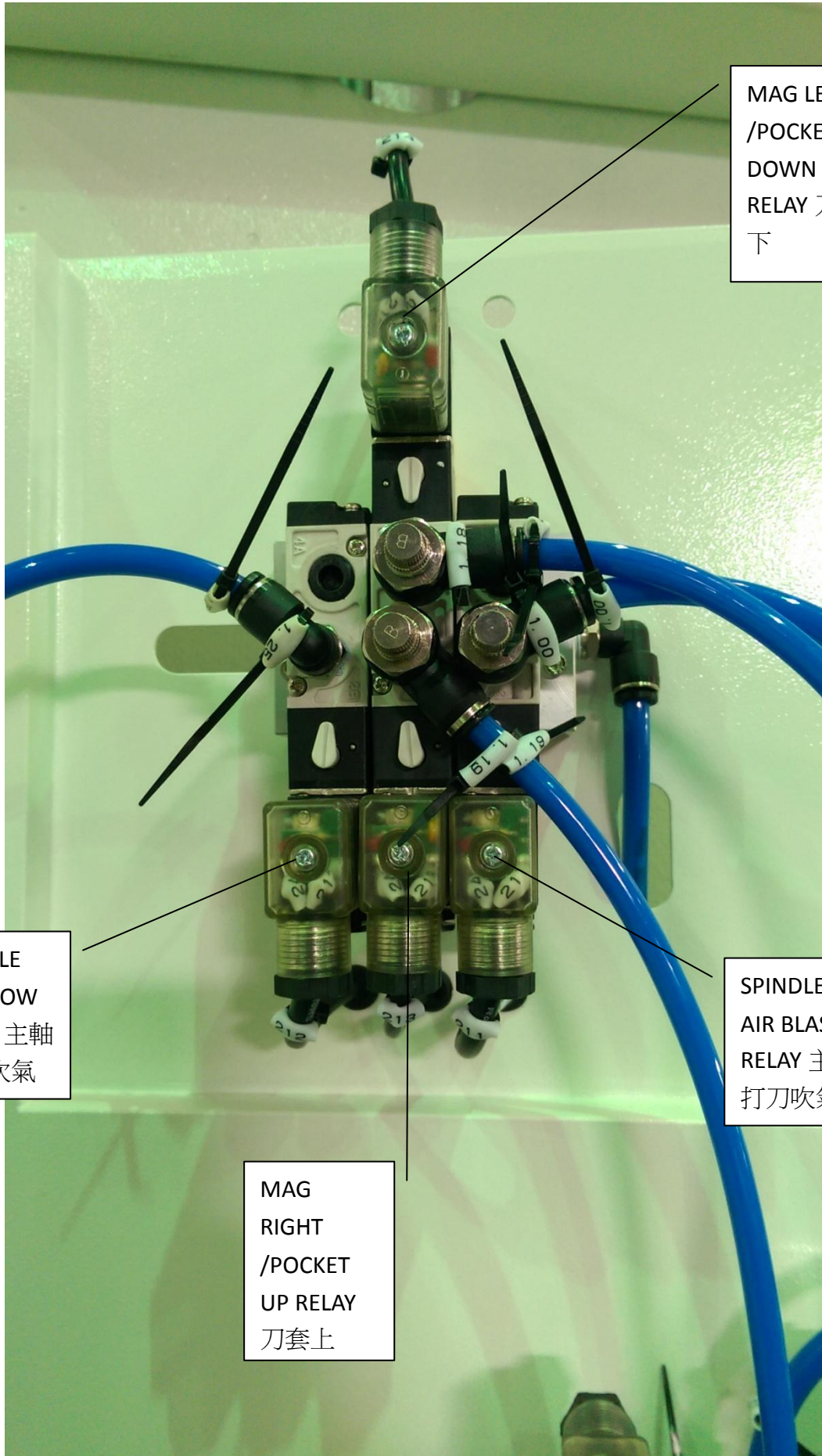
I/O-1

名稱	I/O	腳位	線號
+24V	DOCOM	1	DC24V
COOLANT A RELAY 主軸加工切削液	Y1.0	2	209
COOLANT B RELAY 側邊沖削	Y1.1	3	210
SPINDLE AIR BLASY RELAY 主軸打刀吹氣	Y1.2	4	211
SPINDLE AIR BLOW RELAY 主軸加工吹氣	Y1.3	5	212
MAG RIGHT /POCKET UP RELAY 刀套上	Y1.4	6	213
MAG LEFT /POCKET DOWN RELAY 刀套下	Y1.5	7	214
CHIP A CW RELAY 捲削機正轉	Y1.6	8	215
CHIP A CCW RELAY 捲削機反轉	Y1.7	9	216
CHIP B OVERLOAD 捲削機 B 過載	X6.0	10	117
COOLANT A OVERLOAD 主軸加工切削液過載	X6.1	11	118
OIL COOLER OVERLOAD 油冷機過載	X6.2	12	119
CHIP A OVERLOAD 捲削機 A 過載	X6.3	13	120
ARM MOTOR OVERLOAD 刀臂馬達過載	X6.4	14	121
MAG MOTOR OVERLOAD 刀套馬達過載	X6.5	15	122
LUBE LOW LEVEL SWITCH 低油位偵測	X6.6	16	123
LUBE PRESSURE 壓力檢知	X6.7	17	124
+24V	+24V	18	DC24V
0V	0V	19	24G
0V	0V	20	24G
0V	0V	21	24G
0V	0V	22	24G
0V	0V	23	24G
0V	DICOM0	24	24G
ARM SENSER LEFT1 刀臂感測(角度)	X5.4	29	113
ARM SENSER LEFT2 刀臂感測(角度)	X5.5	30	114
ARM SENSER LEFT3 刀臂感測(角度)	X5.6	31	115
ARM SENSER LEFT4 刀臂感測(角度)	X5.7	32	116
+24V	DOCOM	33	DC24V
ALARM LAMP(RED) RELAY 停止燈	Y0.0	34	201
ALARM LAMP(YELLOW) RELAY 加工結束燈	Y0.1	35	202
ALARM LAMP(GREEN) RELAY 加工執行燈	Y0.2	36	203
WORK LAMP RELAY 工作燈	Y0.3	37	204
LUBE MOTOR RELAY (LUBE 馬達)	Y0.4	38	205

M30 POWER OFF RELAY 自動斷電	Y0.5	39	206
MAG CW RELAY 刀套正轉	Y0.6	40	207
MAG CCW RELAY 刀套反轉	Y0.7	41	208
OIL COOLER FAILURE 油冷機油量偵測	X4.1	43	102
+24V	+24V	50	DC24V

I/O-2

名稱	I/O	腳位	線號
+24V	DOCOM	1	DC24V
SPINDLE SENSER ON RELAY 主軸定位(換刀)	Y3.4	6	229
SPINDLE ENCIRCLAE AIR BLOW 主軸環噴	Y3.5	7	230
EMG STOP BUTTON 緊急停止按鈕	X8.4	29	137
ARM CW RELAY 刀臂正轉	Y2.0	34	217
ARM CCW RELAY 刀臂反轉	Y2.1	35	218
Z AXIS BREAK RELAY Z 軸煞車	Y2.2	36	219
TOOL UNCLAMP RELAY 打刀缸電磁閥	Y2.3	37	220
COOLANT MOTOR RELAY 切削液馬達	Y2.5	39	222
OT RELEASE 釋放點	Y2.7	41	224
TOOL UNCLAMP LIMIT 鬆刀極限開關	X7.0	42	125
TOOL CLAMP LIMIT 夾刀極限開關	X7.1	43	126
TOOL UNCLAMP BUTTON 刀具釋放按鈕	X7.2	44	127
MAG COUNTER 刀庫感測器	X7.3	45	128
MAG LEFT/POCKET UP LS 刀庫左感測器	X7.4	46	129
MAG RIGHT/POCKET DOWN LS 刀庫右感測器	X7.5	47	130
AIR ALARM 風壓警示	X7.7	49	132
+24V	+24V	50	DC24V

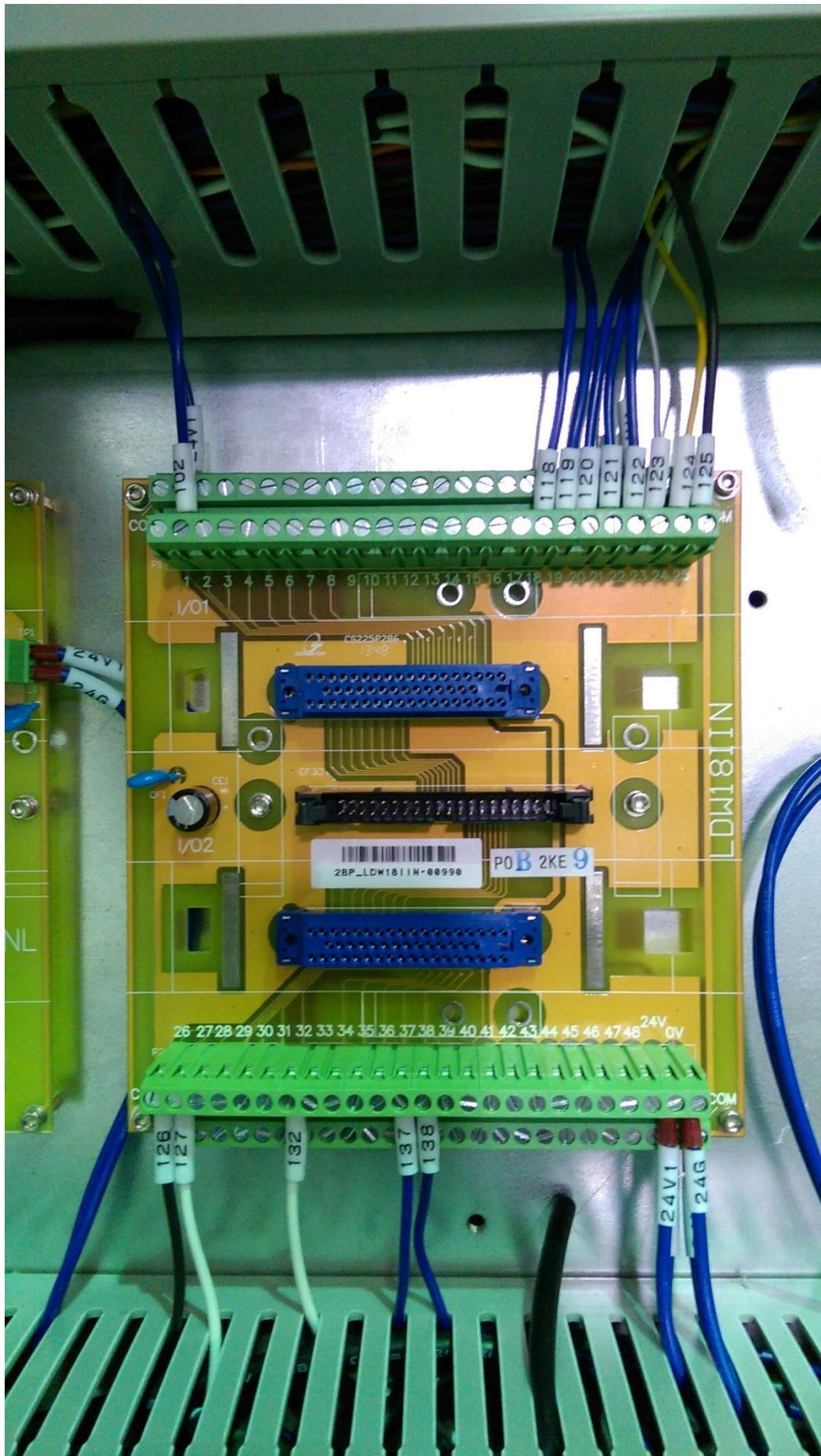


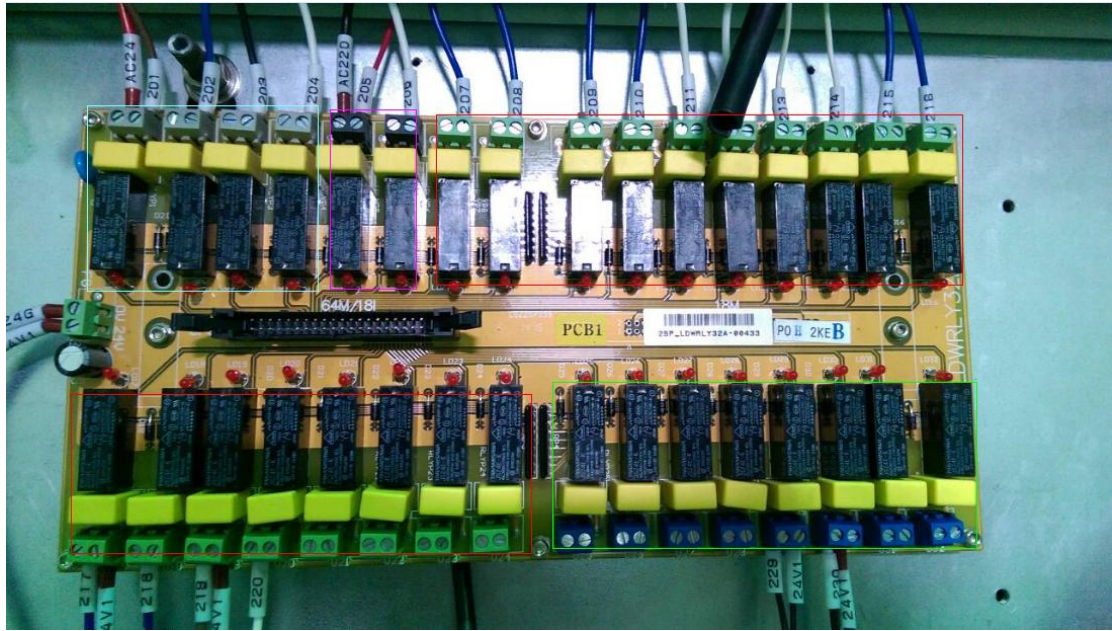
MAG LEFT
/POCKET
DOWN
RELAY 刀套
下

SPINDLE
AIR BLOW
RELAY 主軸
加工吹氣

SPINDLE
AIR BLASY
RELAY 主軸
打刀吹氣

MAG
RIGHT
/POCKET
UP RELAY
刀套上





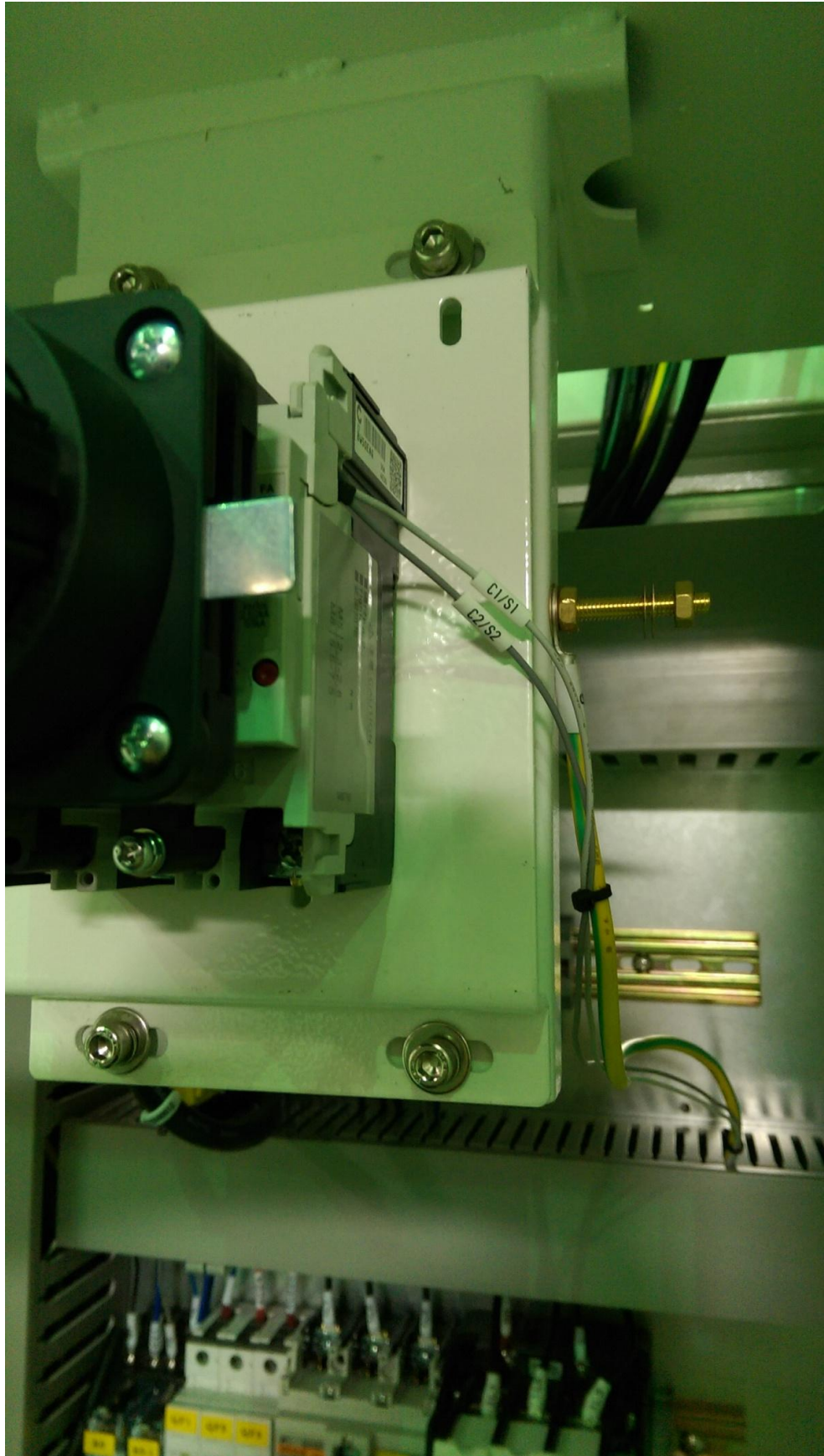
同一顏色框框裡的 RELAY 為共同電源，除了右下角綠色部分為獨立電源 RELAY 輸入電壓 DC30V/AC240V



擴充 I/O 板

I/O-7

名稱	I/O	腳位	線號
COOLANT ALARM LED 切削液警示燈	Y17.0	2	702
LUBE ALARM LED (LUBE 警示燈)	Y17.1	3	703
EMG. ALARM LED 緊急按鈕警示燈	Y17.2	4	704
AIR ALARM LED 風壓警示燈	Y17.3	5	705
HYD. ALARM LED 油壓馬達警示燈	Y17.4	6	706
DEC. X LED X 軸回原點 LED	Y17.5	7	707
DEC. Y LED Y 軸回原點 LED	Y17.6	8	708
DEC. Z LED Z 軸回原點 LED	Y17.7	9	709
RAPID OVERLOAD F 快速位移倍率	X31.2	12	712
RAPID OVERLOADA 快速位移倍率	X31.3	13	713
DEC. 4 LED 第四軸回原點 LED	Y16.0	34	734
DEC. 5 LED 第五軸回原點 LED	Y16.1	35	735
ATC READY LED NC 預備燈	Y16.2	36	736



M30 自動斷電



LUBE



刀臂感測器