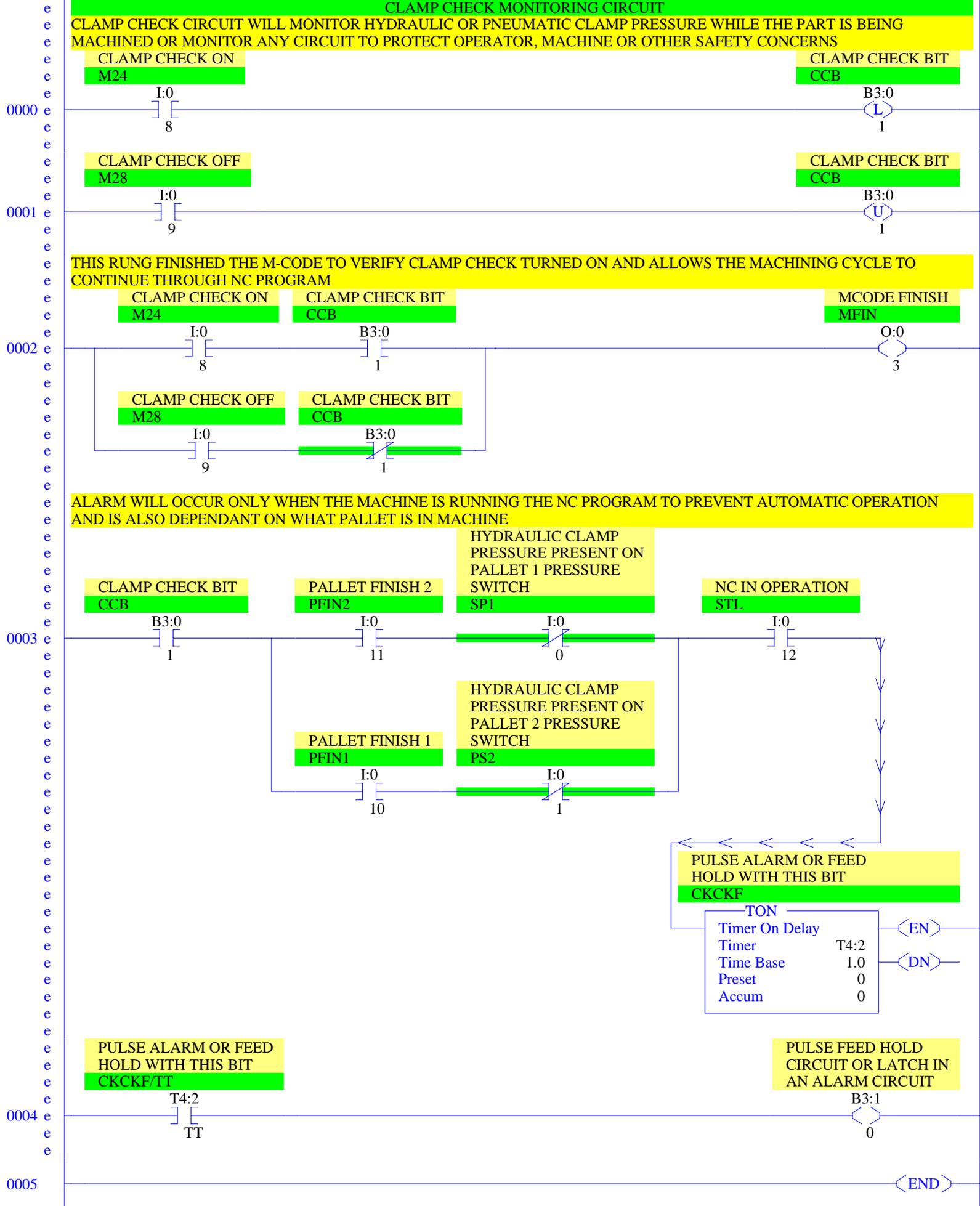


CLAMP CHECK MONITORING CIRCUIT

CLAMP CHECK CIRCUIT WILL MONITOR HYDRAULIC OR PNEUMATIC CLAMP PRESSURE WHILE THE PART IS BEING MACHINED OR MONITOR ANY CIRCUIT TO PROTECT OPERATOR, MACHINE OR OTHER SAFETY CONCERNS



THIS RUNG FINISHED THE M-CODE TO VERIFY CLAMP CHECK TURNED ON AND ALLOWS THE MACHINING CYCLE TO CONTINUE THROUGH NC PROGRAM

ALARM WILL OCCUR ONLY WHEN THE MACHINE IS RUNNING THE NC PROGRAM TO PREVENT AUTOMATIC OPERATION AND IS ALSO DEPENDANT ON WHAT PALLET IS IN MACHINE

CLAMP CHECK BIT
CCB

PALLET FINISH 2
PFIN2

HYDRAULIC CLAMP PRESSURE PRESENT ON PALLET 1 PRESSURE SWITCH
SP1

NC IN OPERATION
STL

PALLET FINISH 1
PFIN1

HYDRAULIC CLAMP PRESSURE PRESENT ON PALLET 2 PRESSURE SWITCH
PS2

PULSE ALARM OR FEED HOLD WITH THIS BIT
CCKF

TON		(EN)
Timer On Delay	T4:2	(DN)
Timer	1.0	
Time Base	0	
Preset	0	
Accum	0	

PULSE ALARM OR FEED HOLD WITH THIS BIT
CCKF/TT

PULSE FEED HOLD CIRCUIT OR LATCH IN AN ALARM CIRCUIT