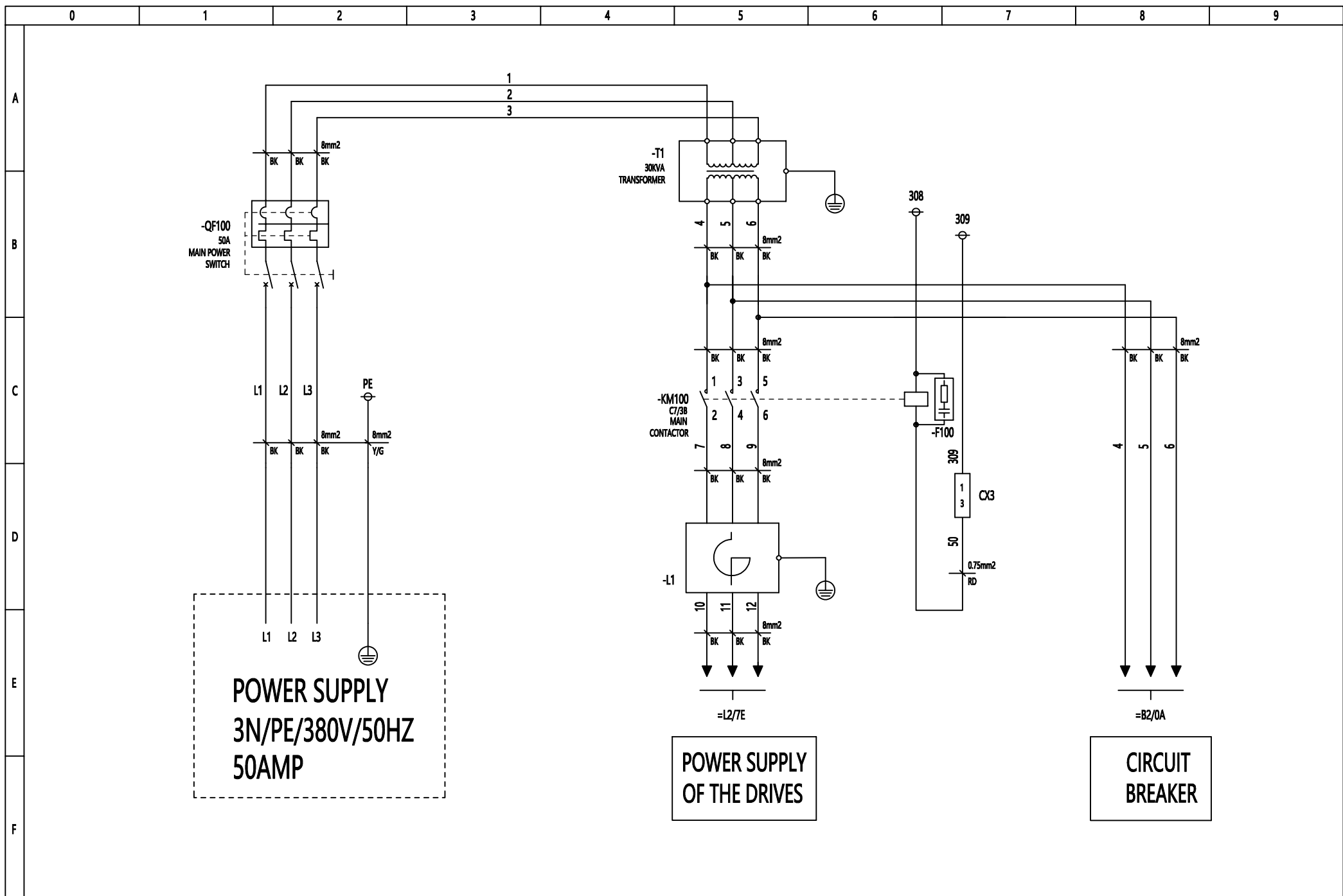
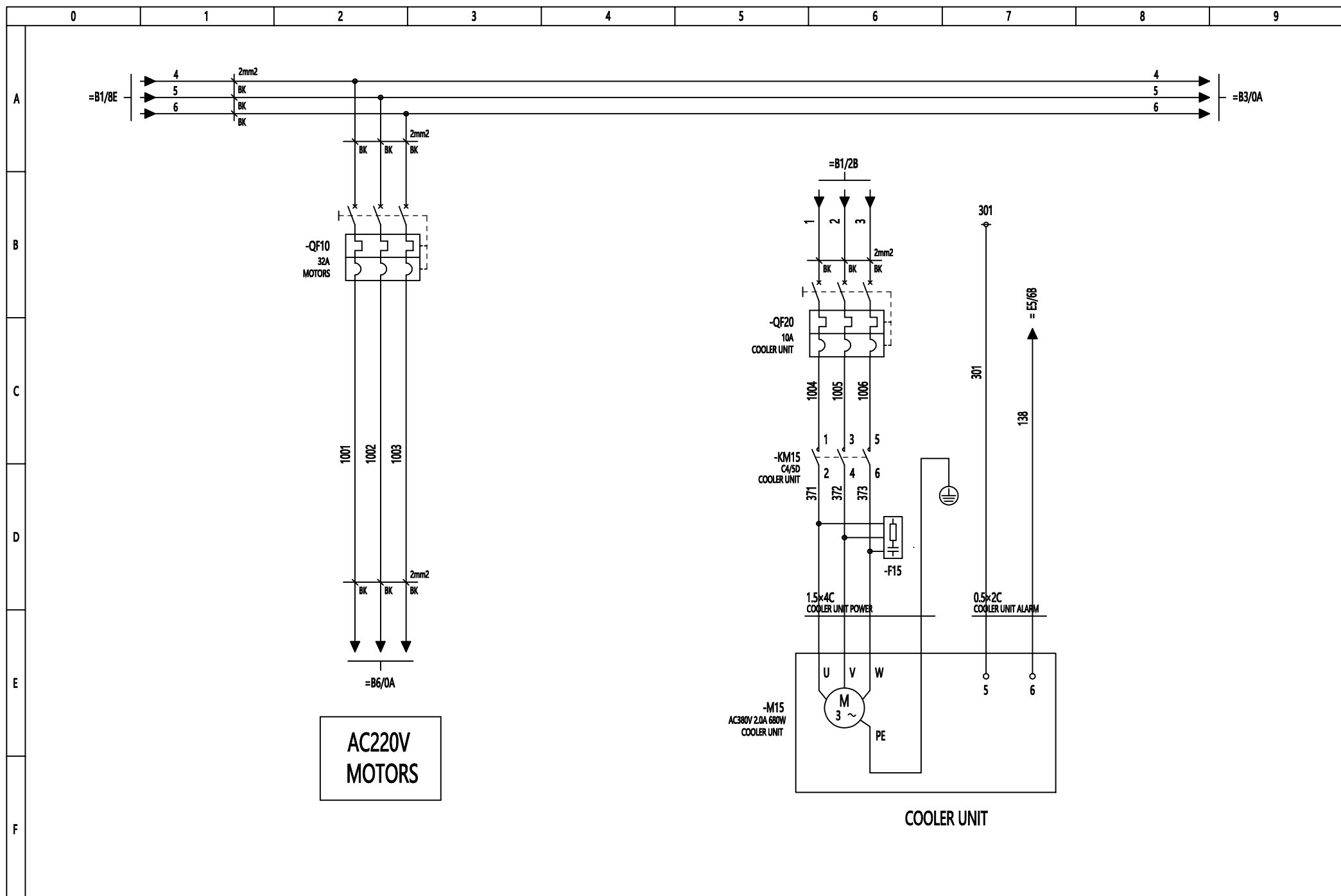


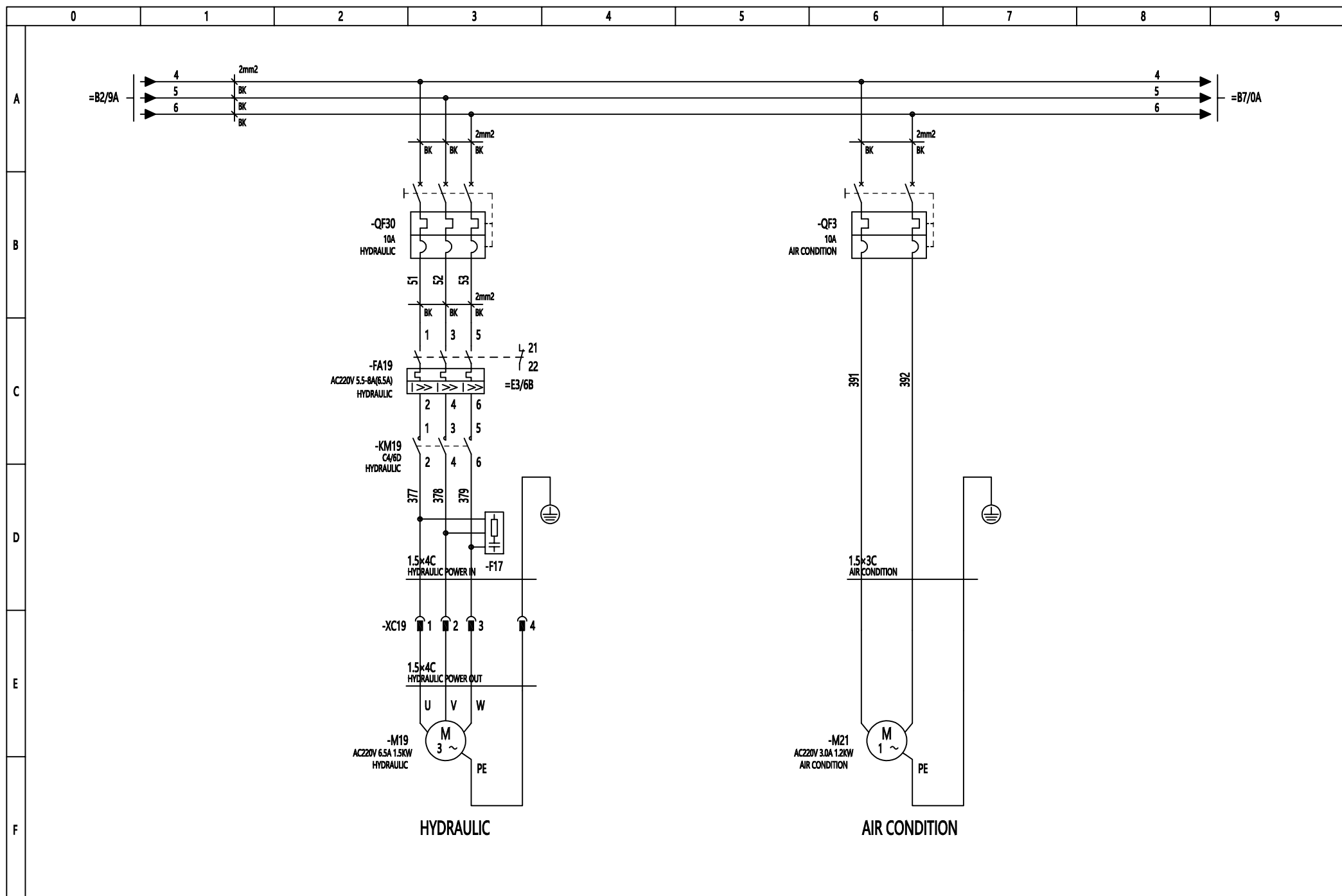
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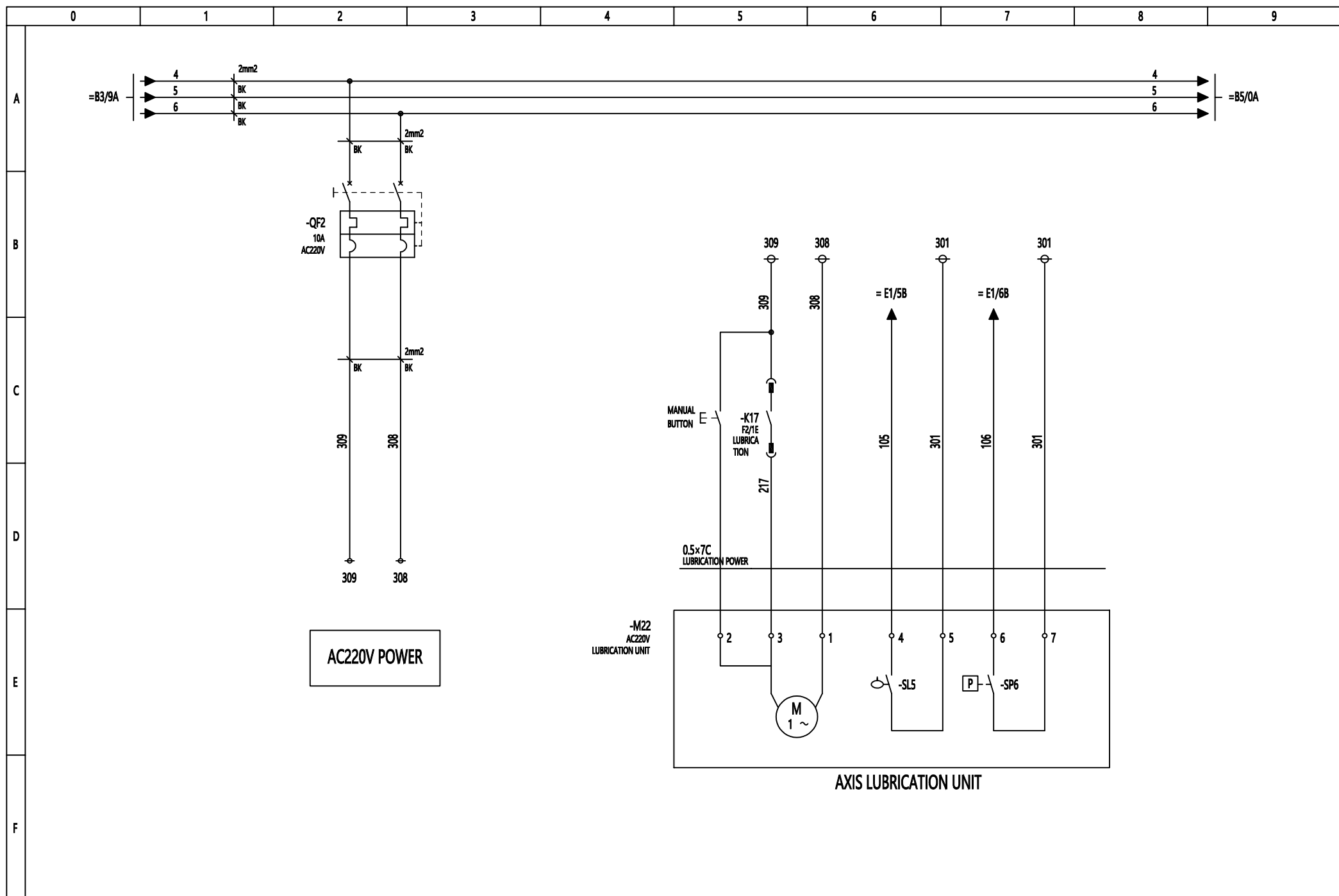
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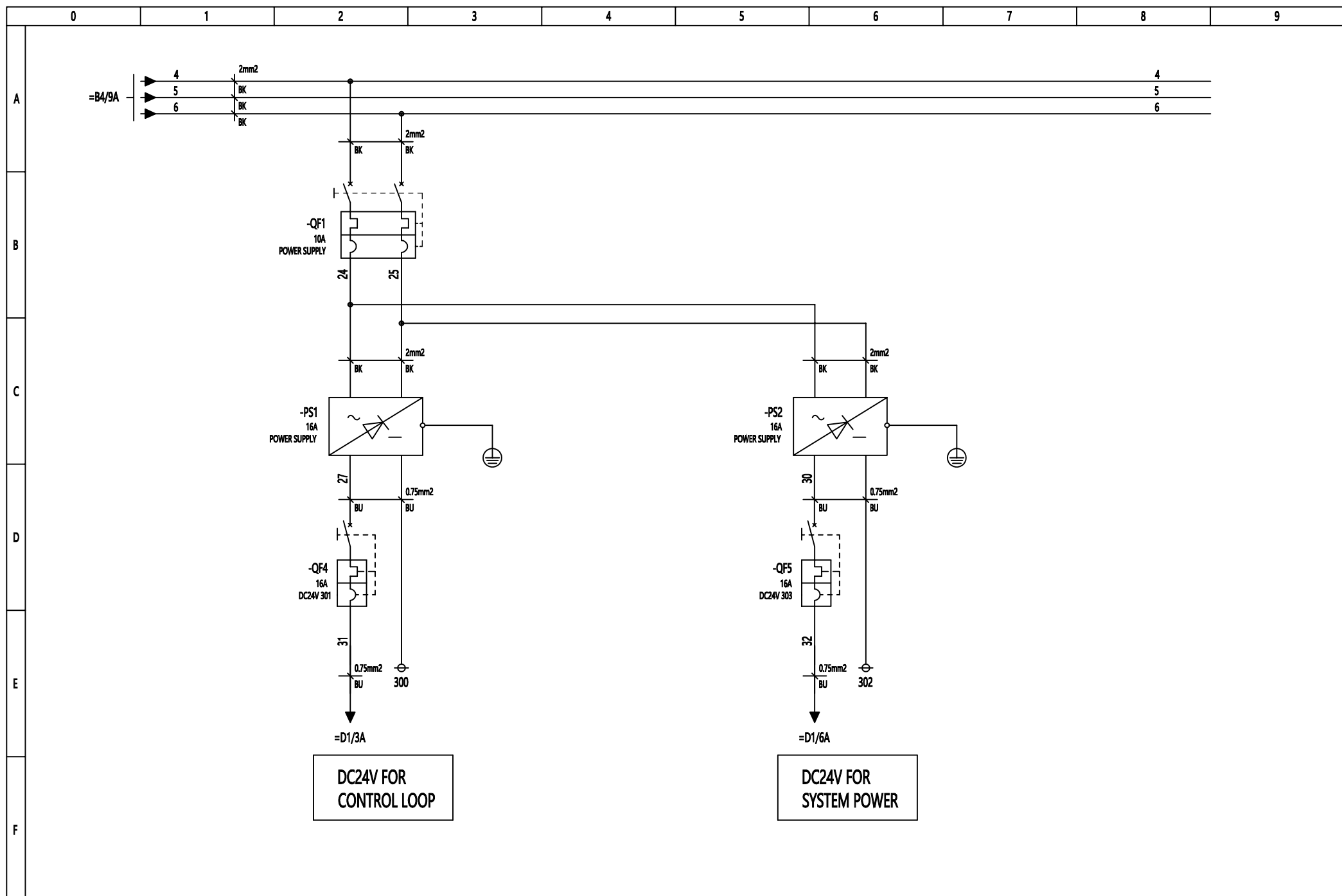


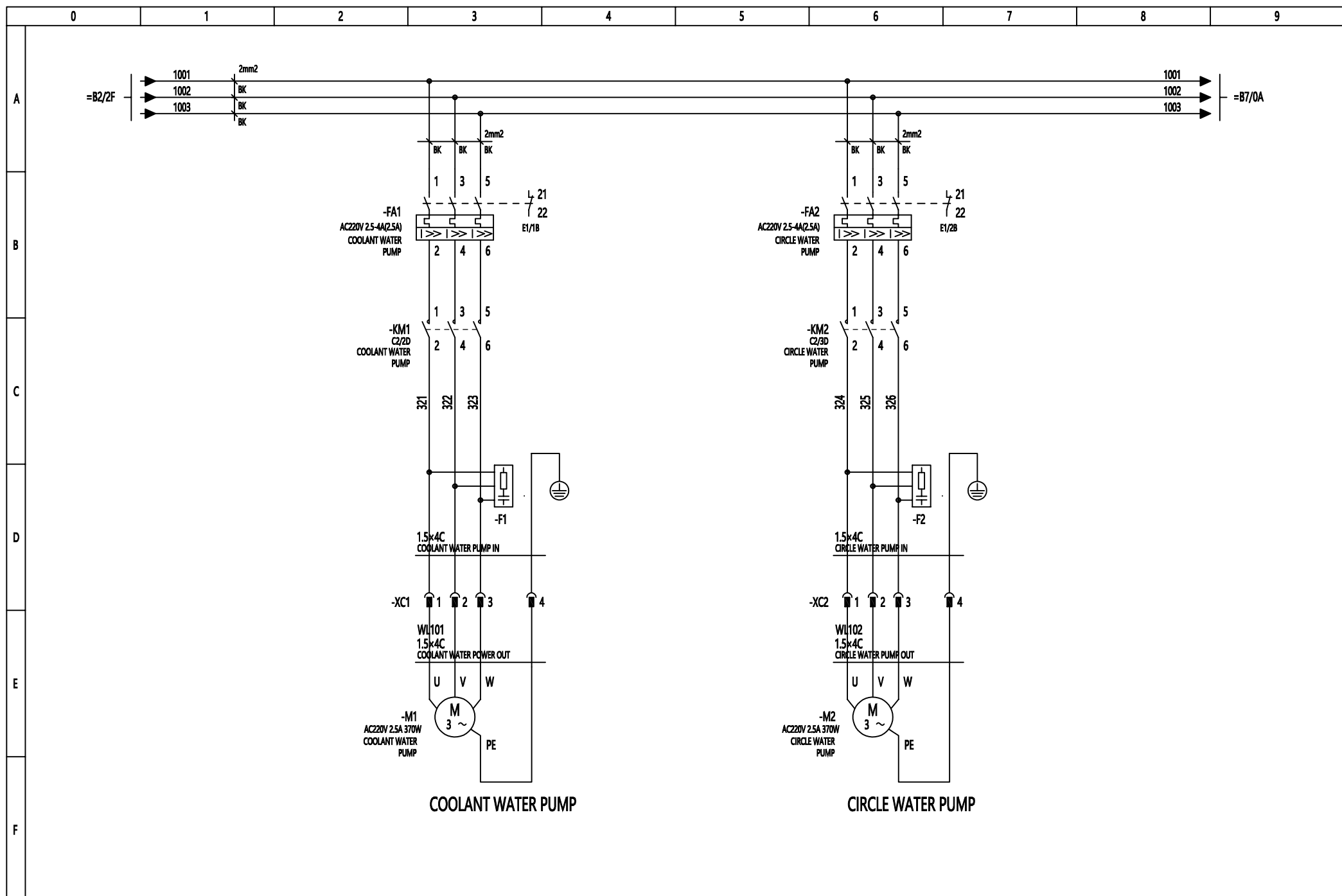


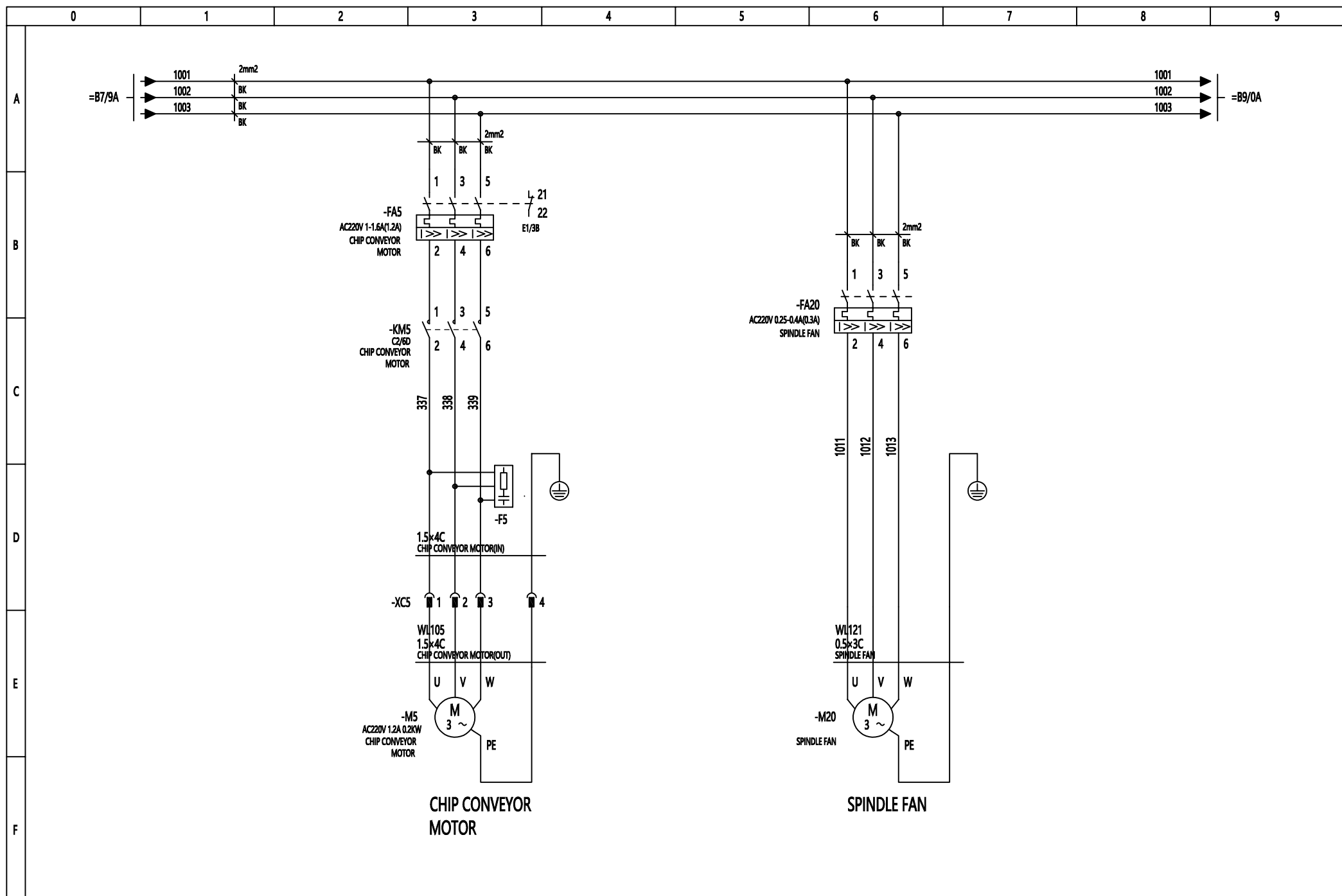
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		Date	2022/10/08	VF SERIES						Page B2
										Page B

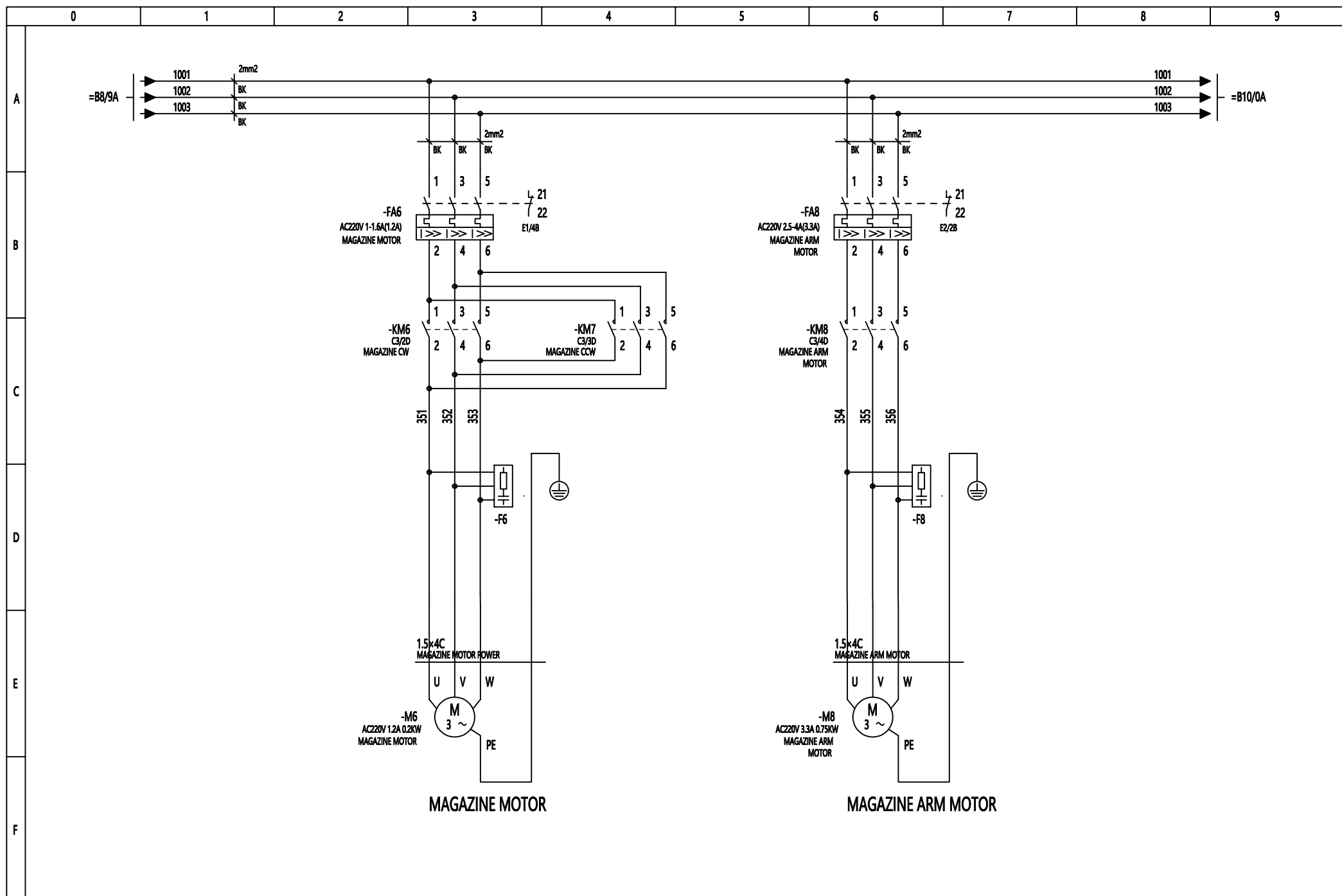


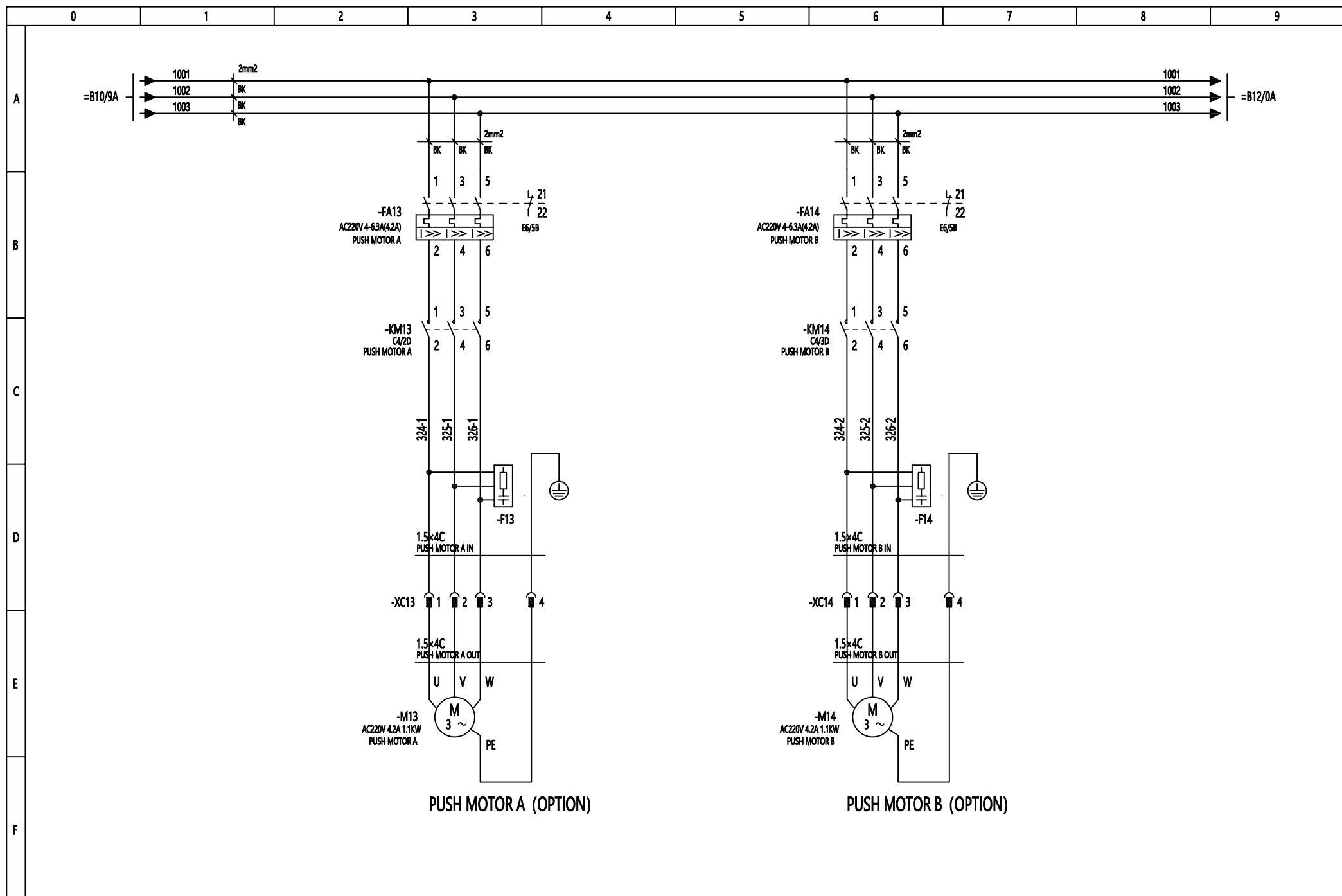


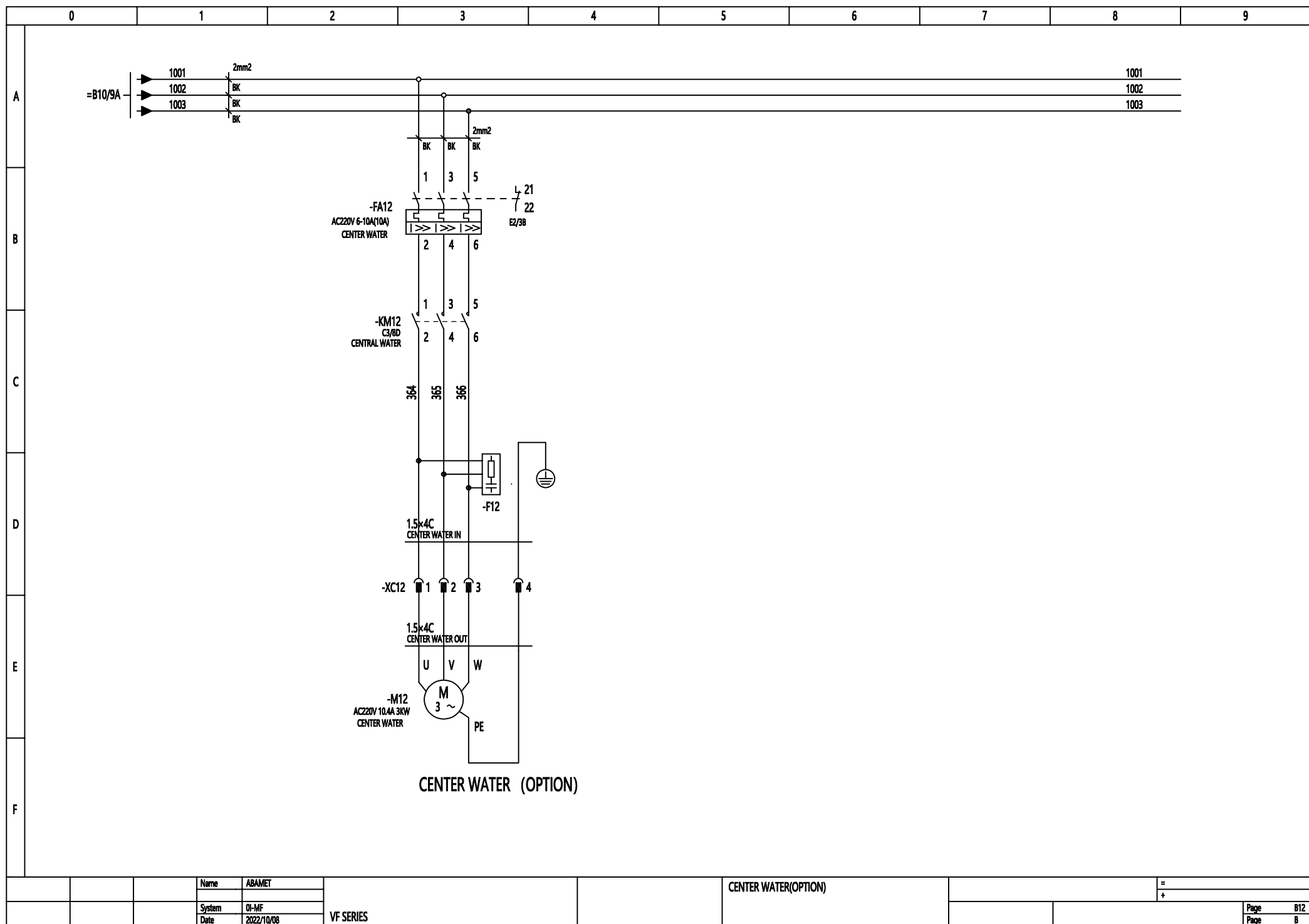


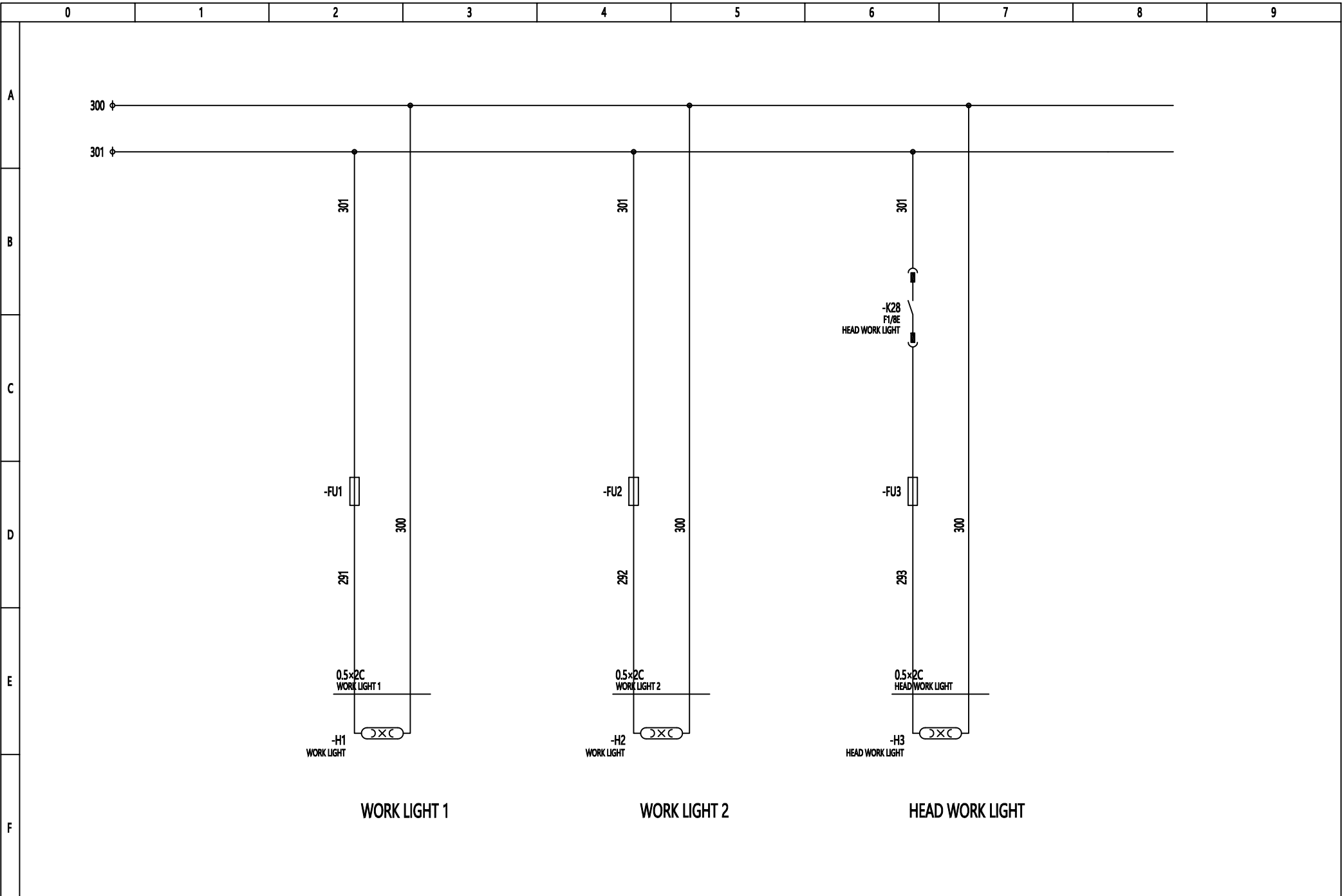




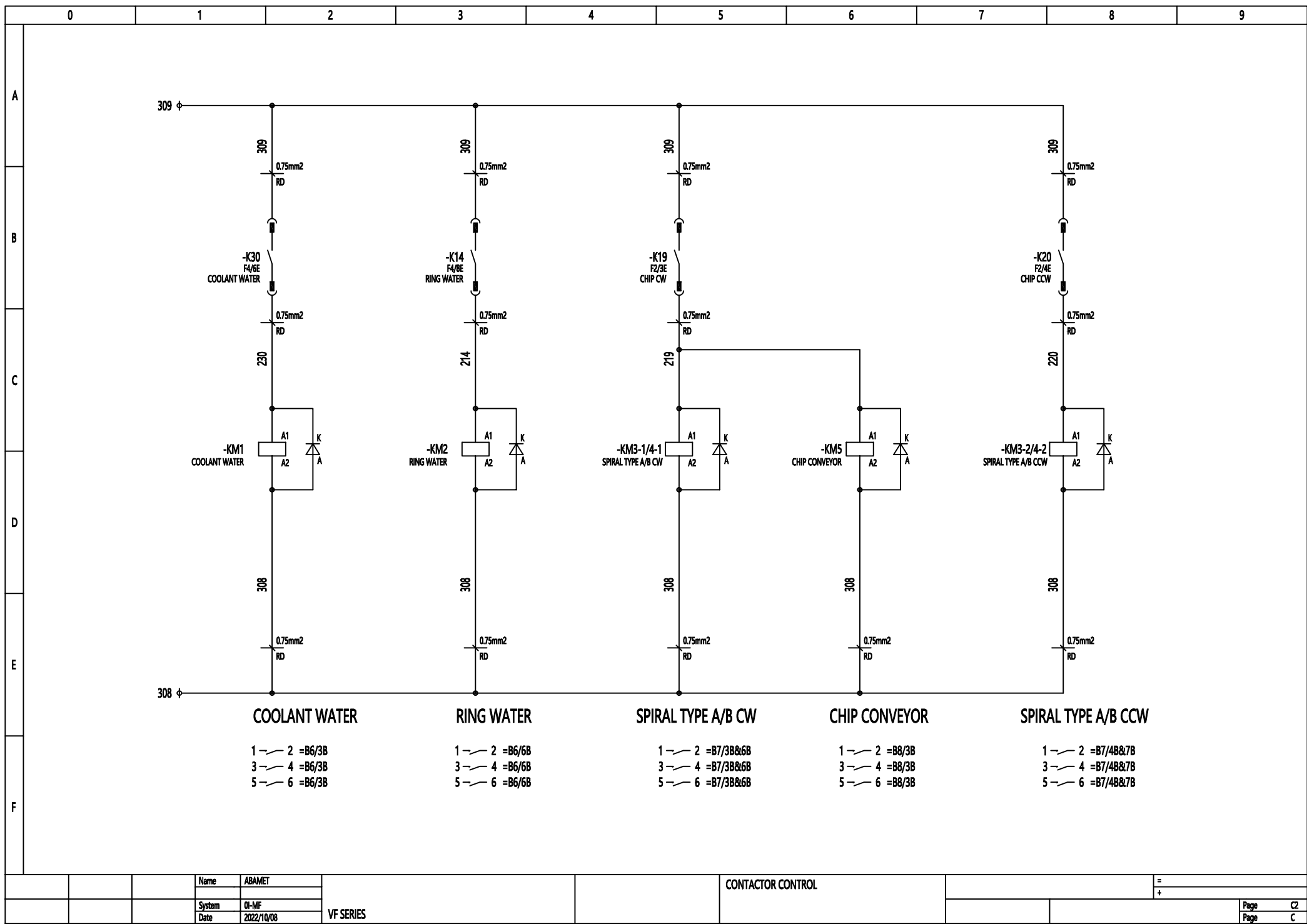








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									Page C



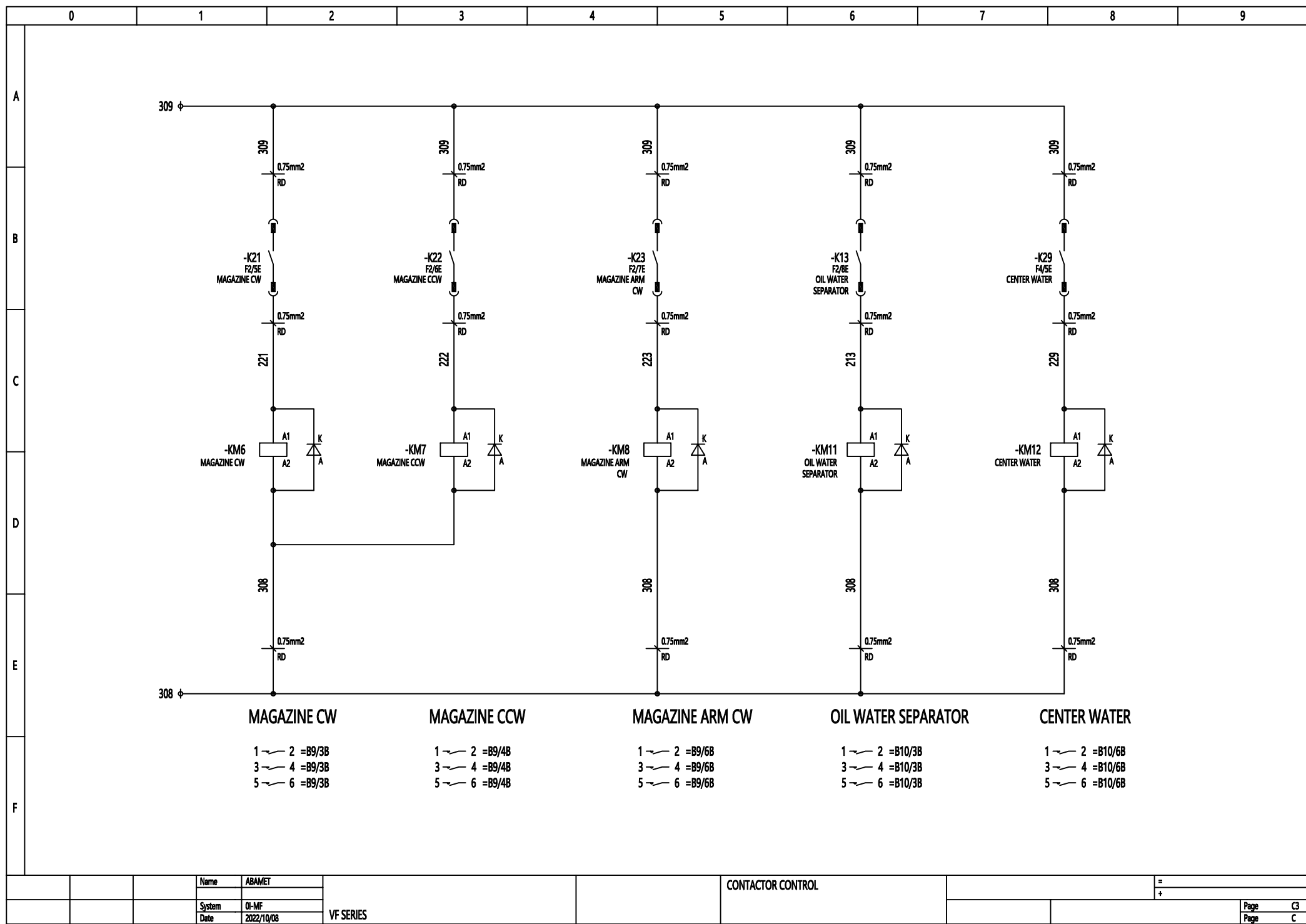
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System	01-MF
Date	2022/10/08

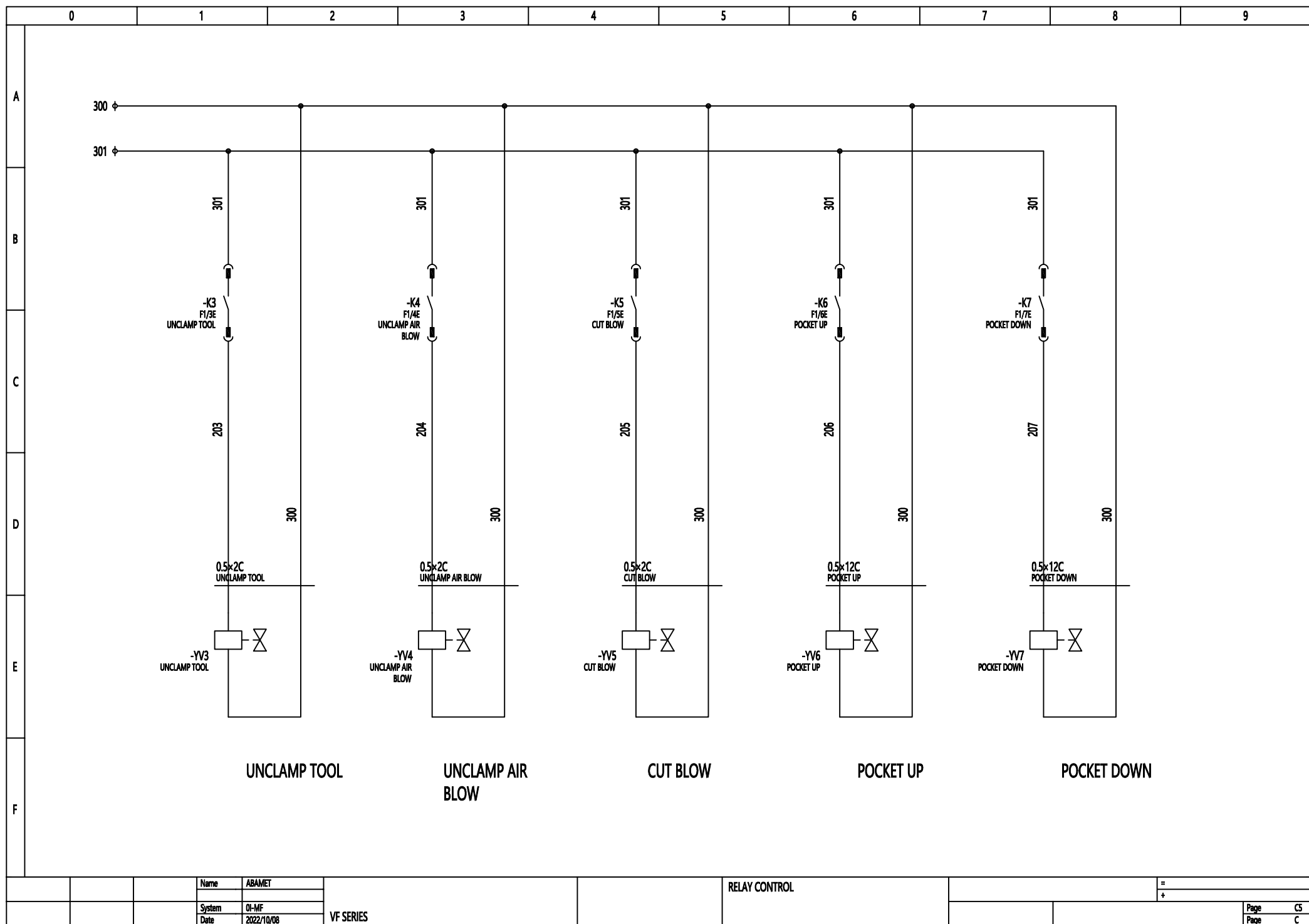
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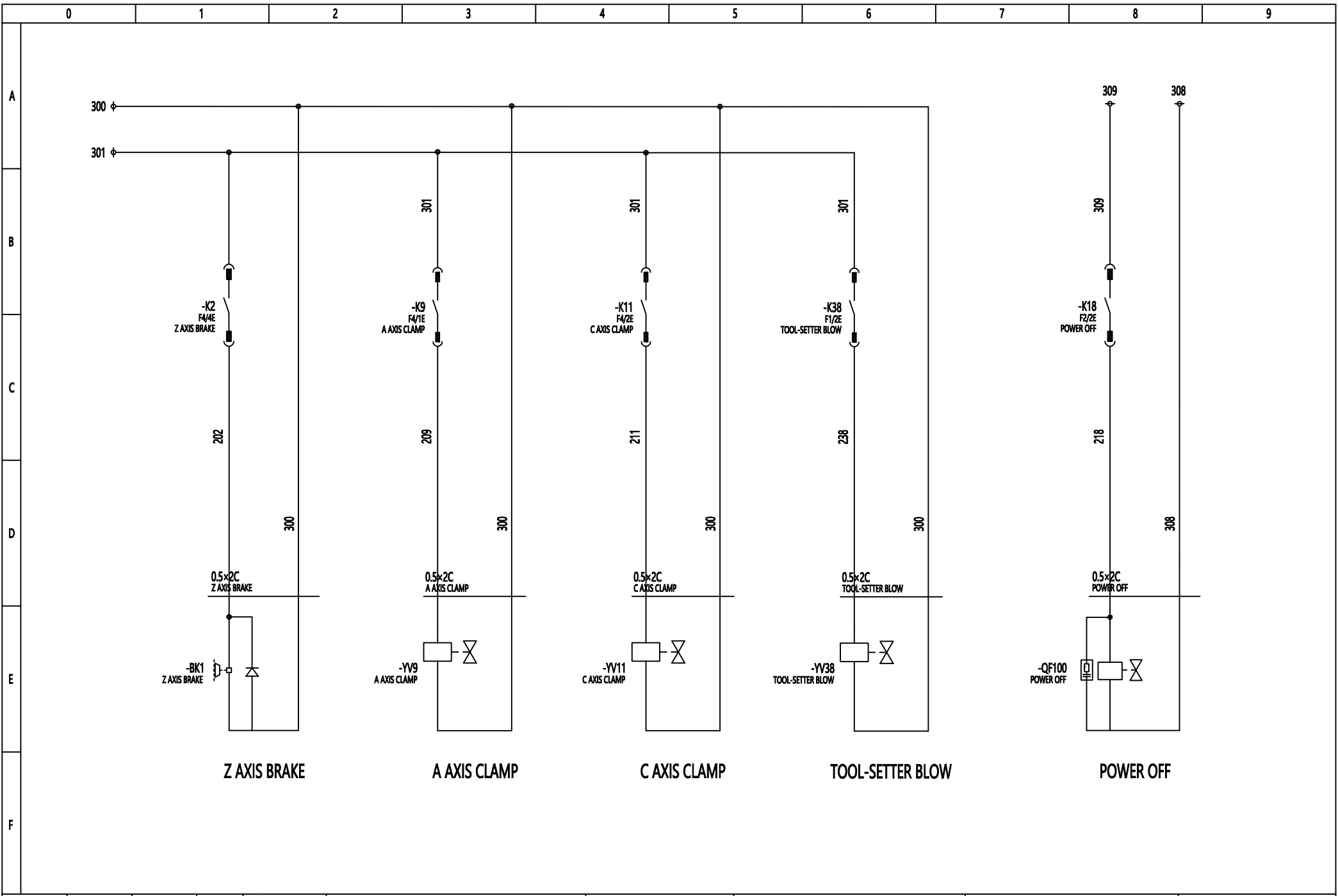
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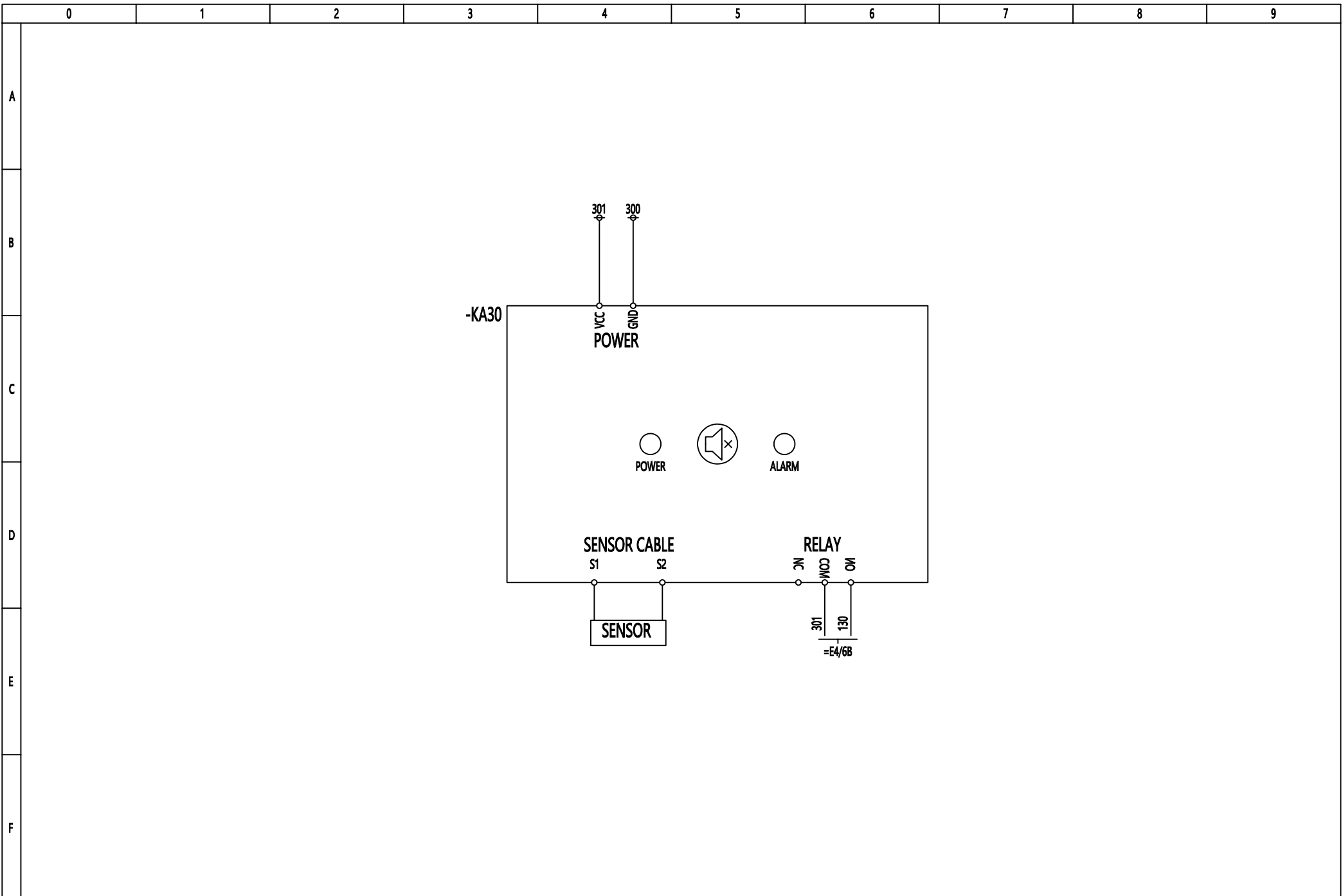
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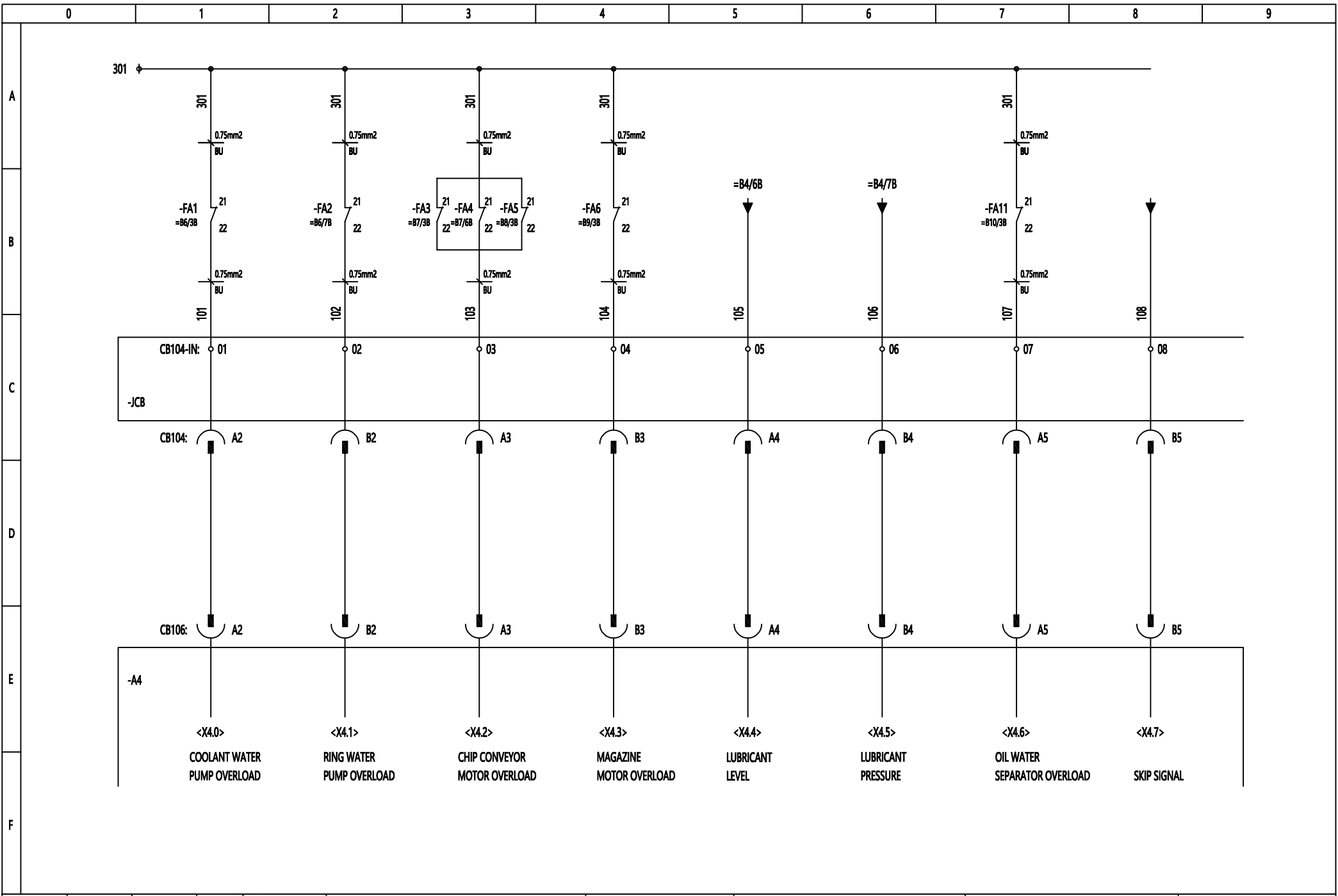


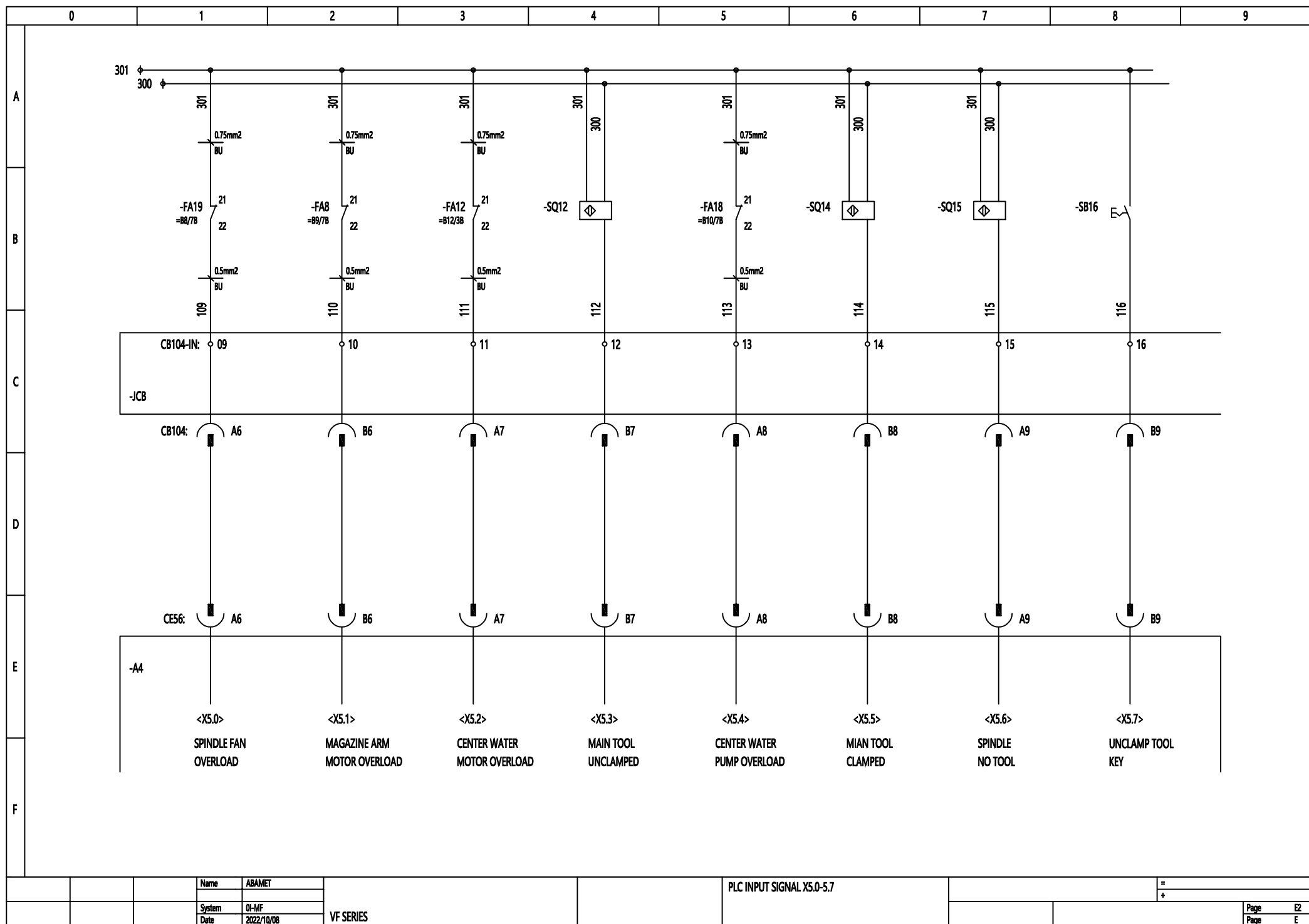


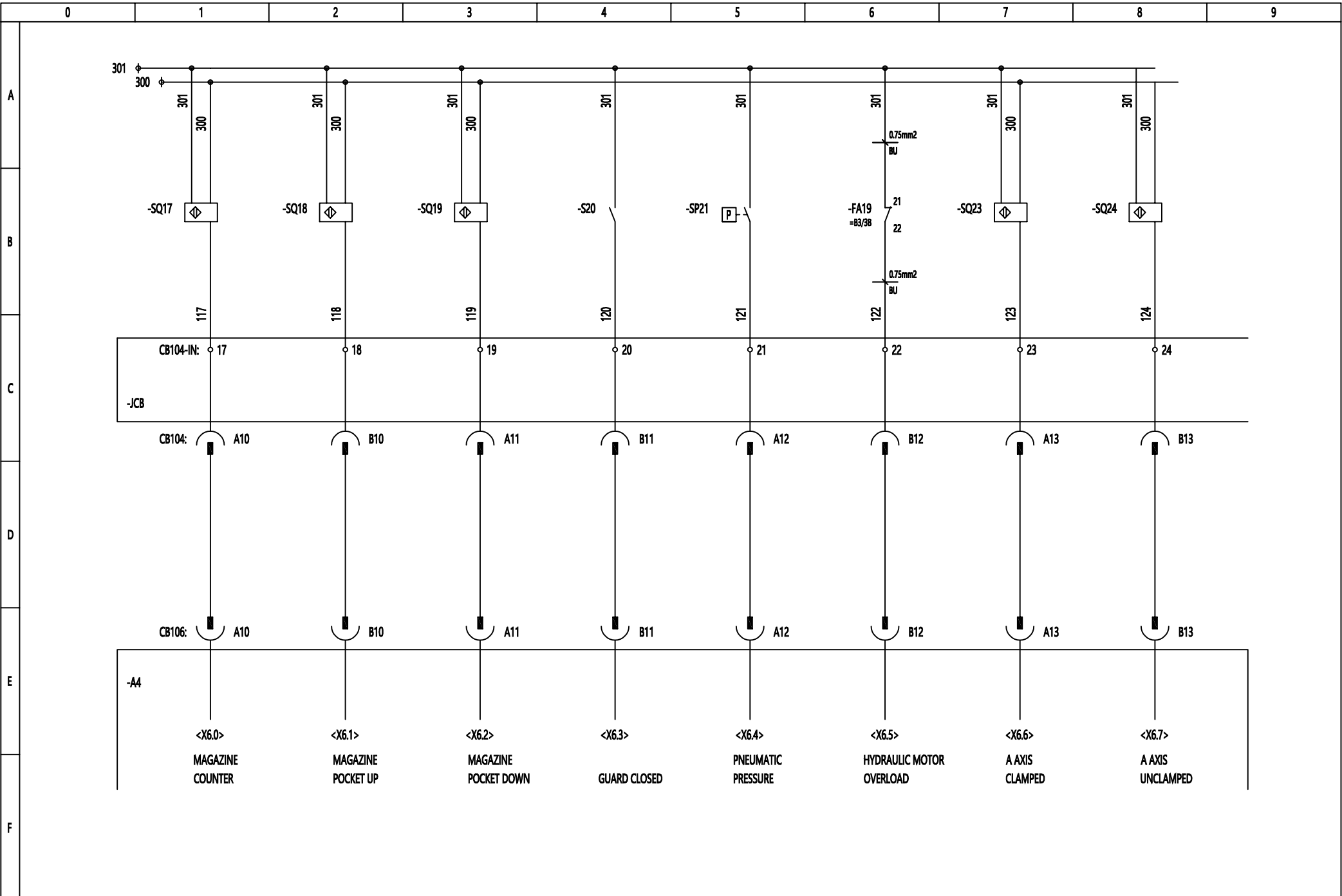


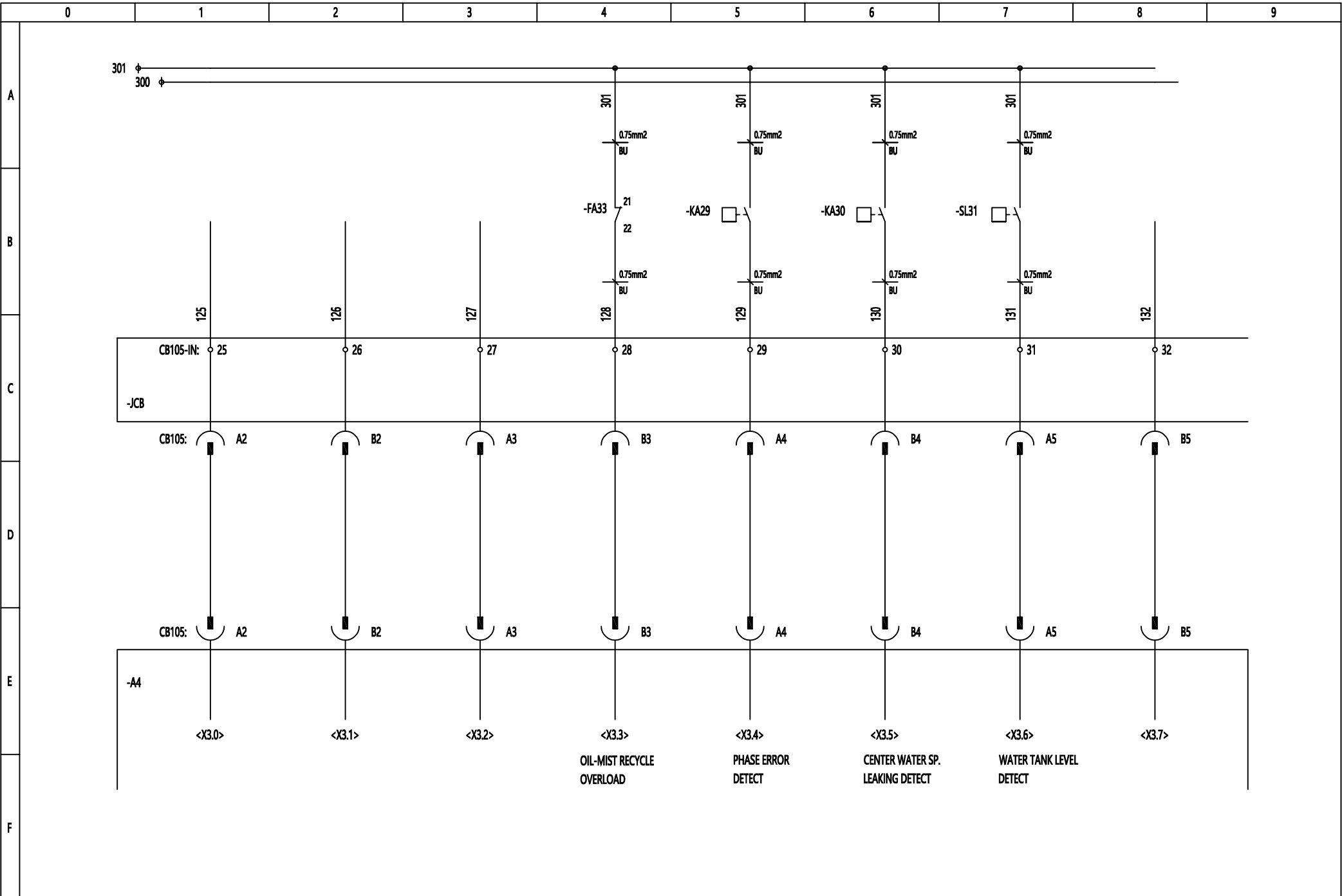


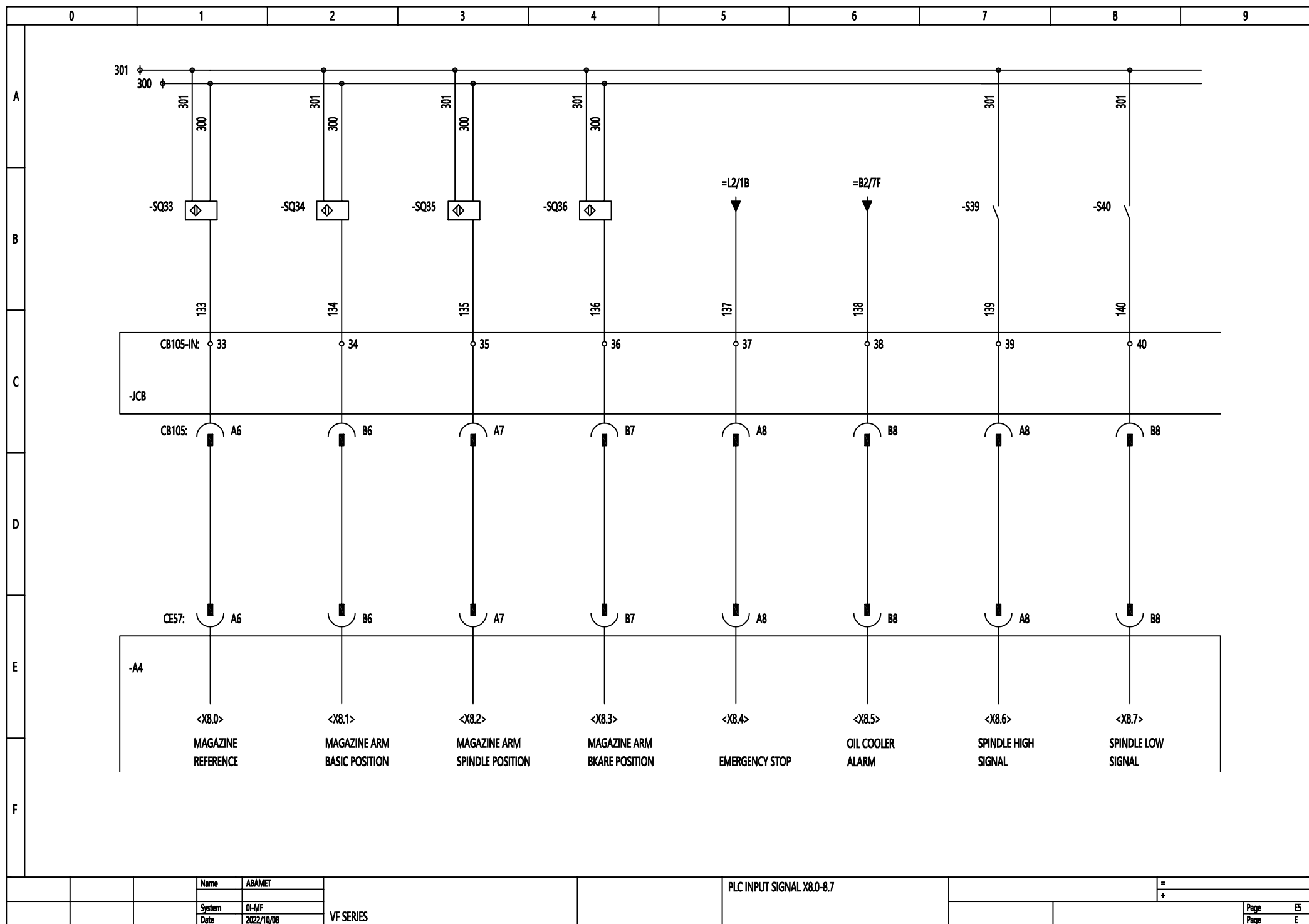
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										+		
			System	0I-MF								Page
			Date	2022/10/08						Page	D	

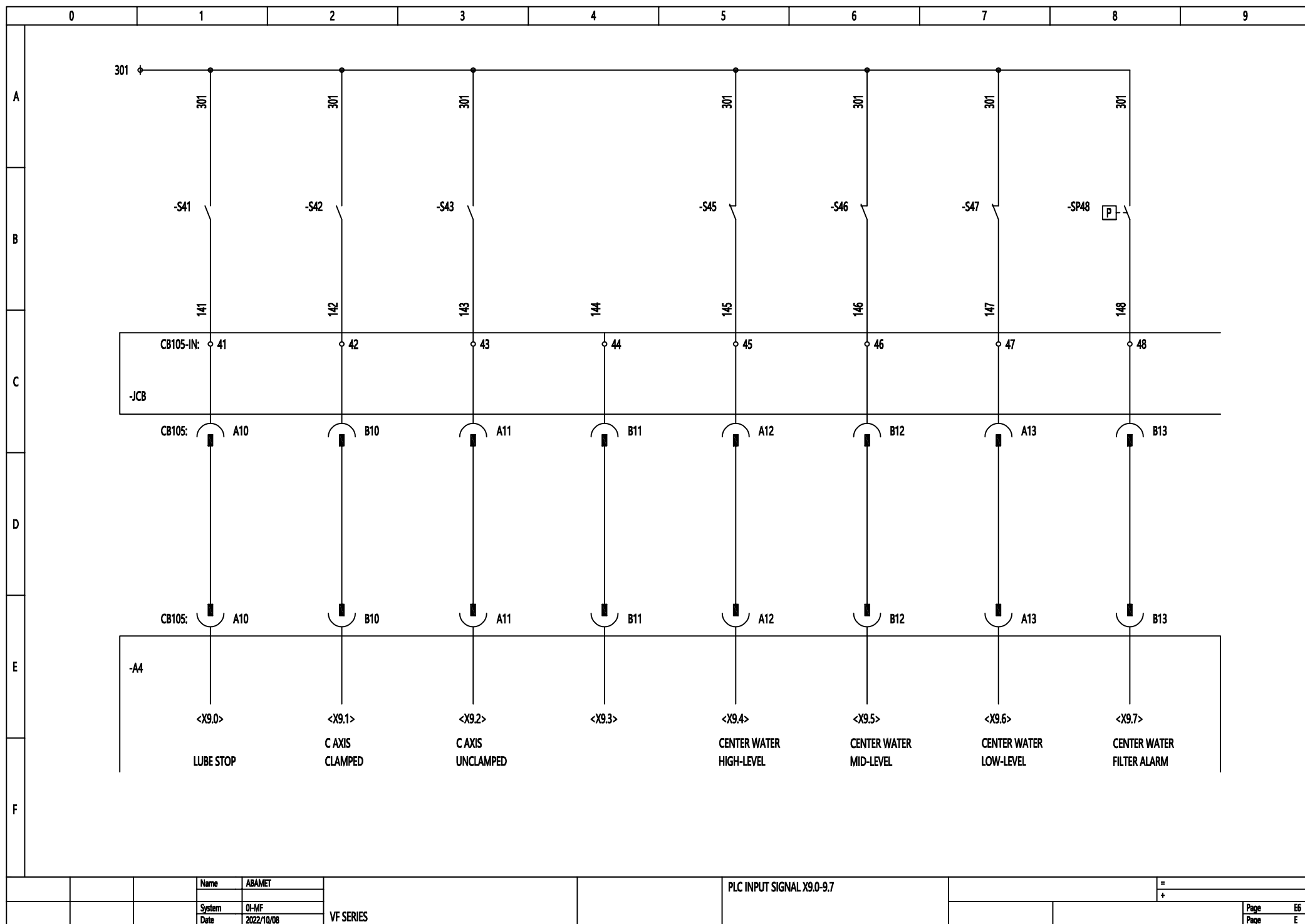


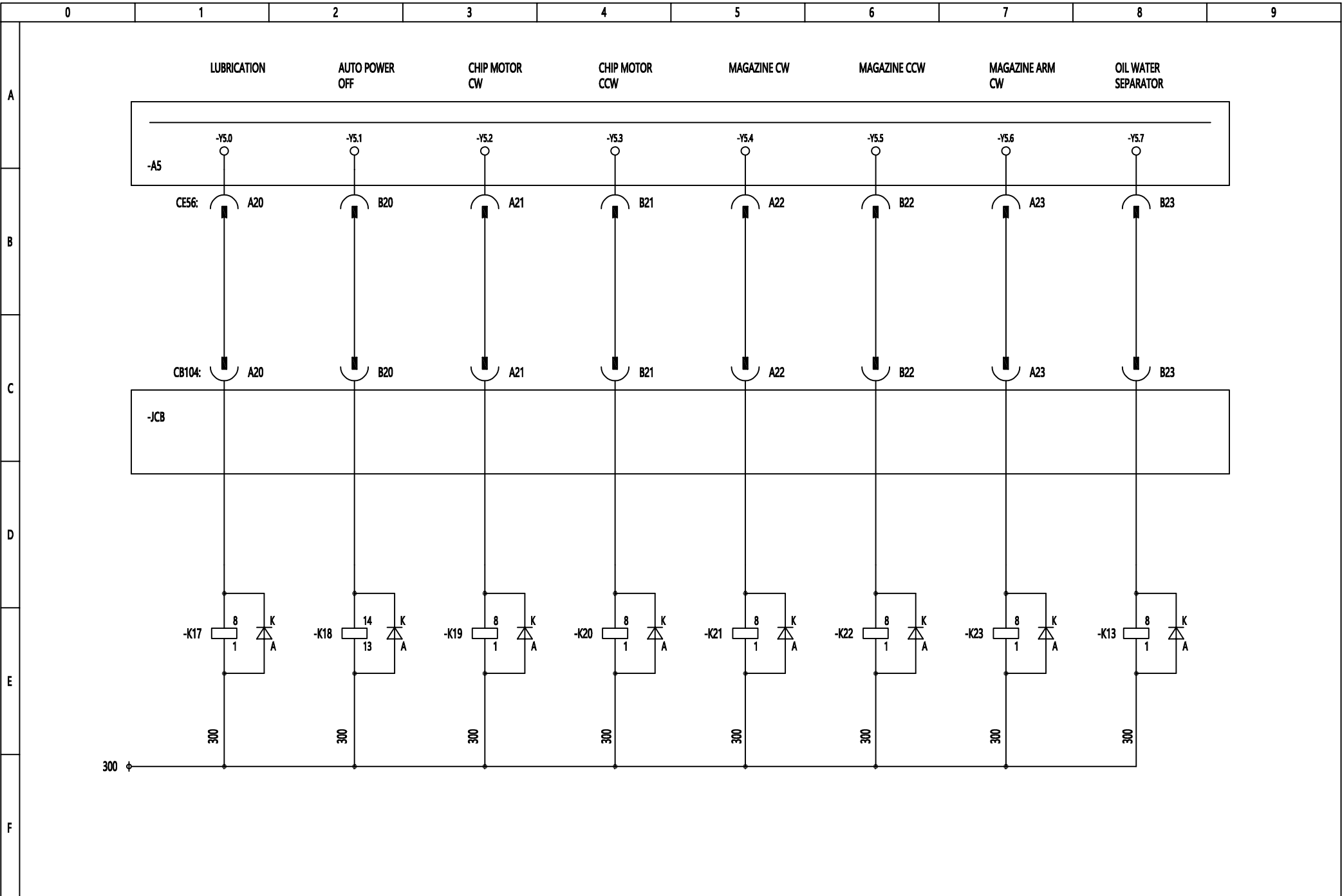


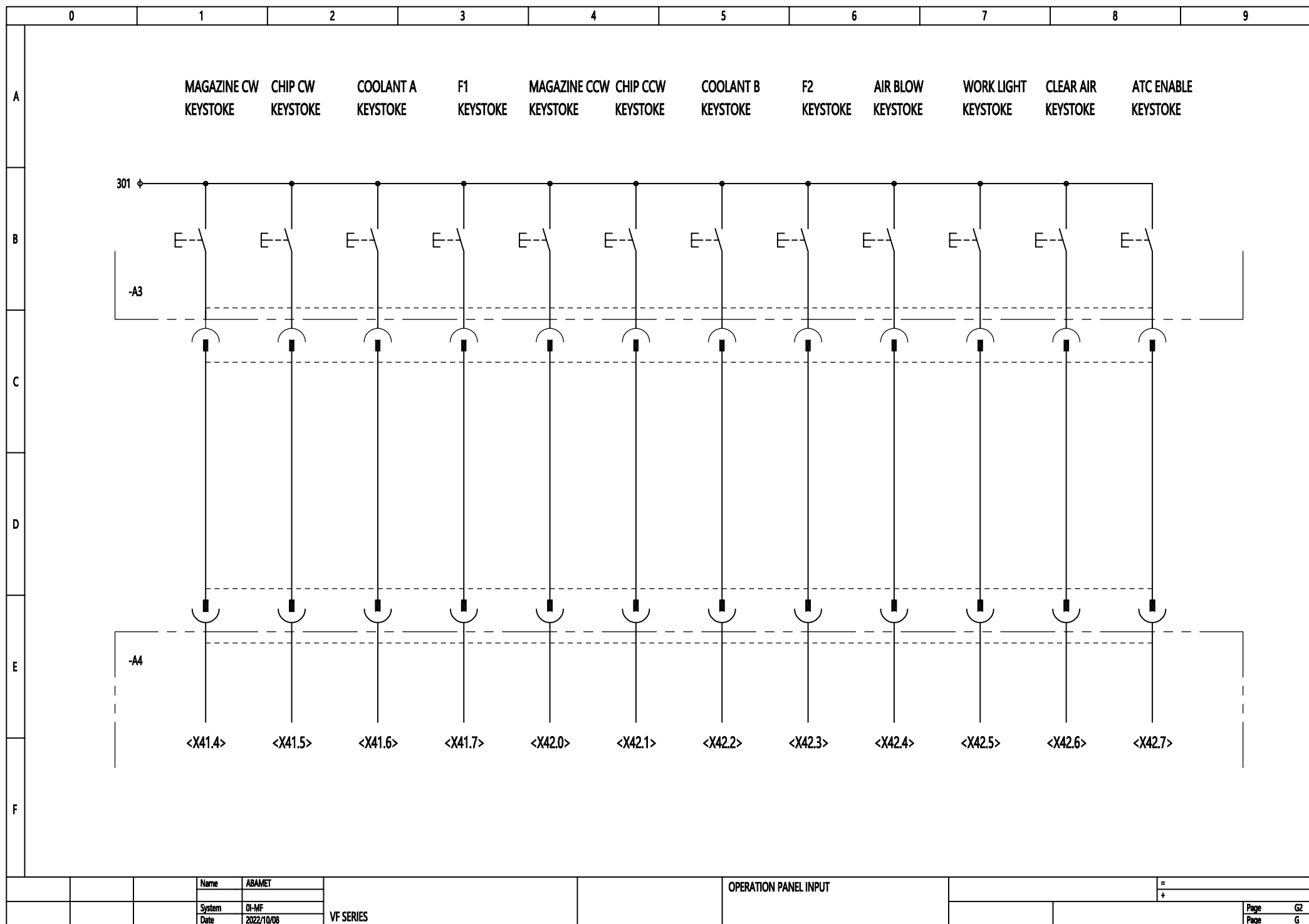


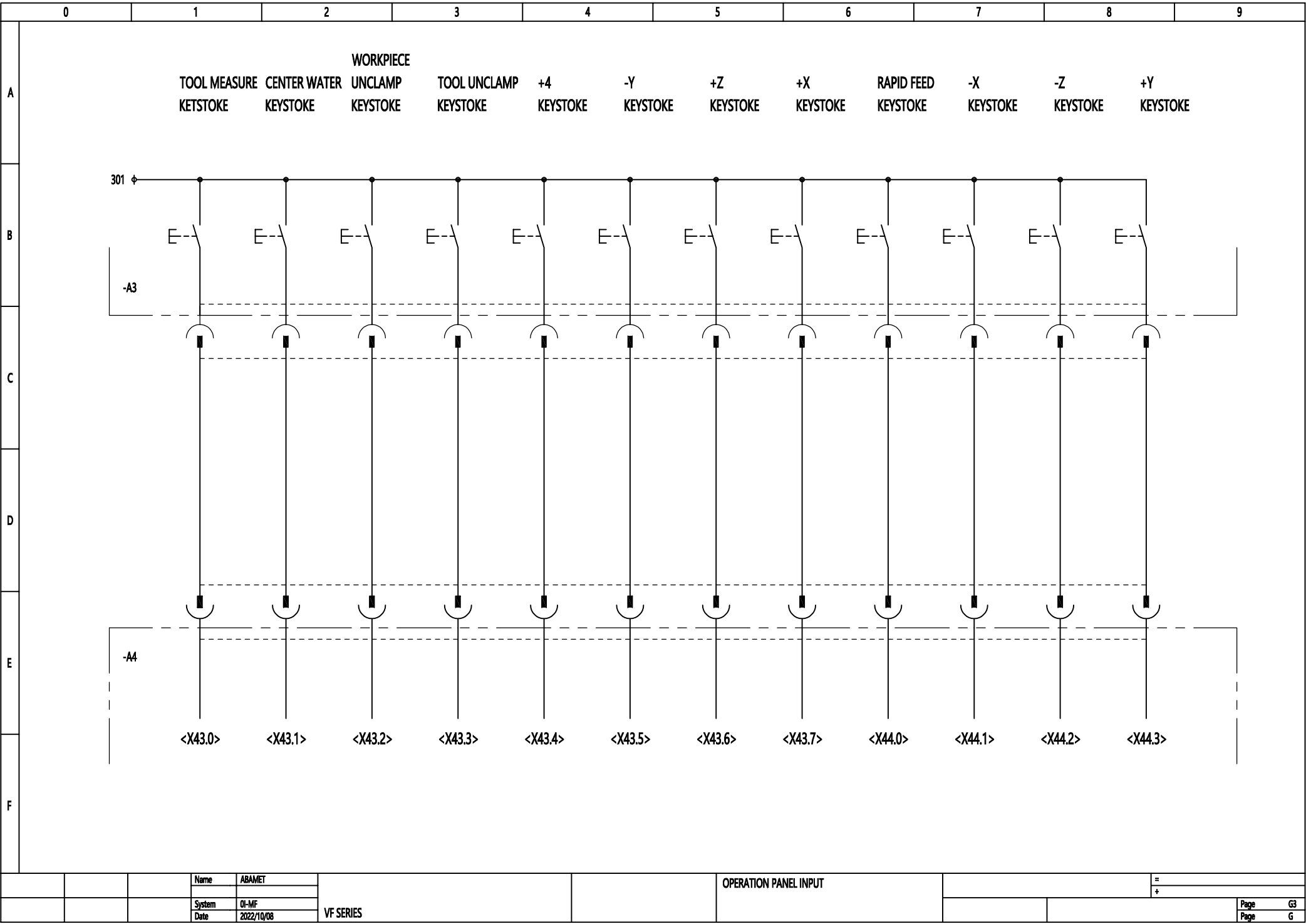


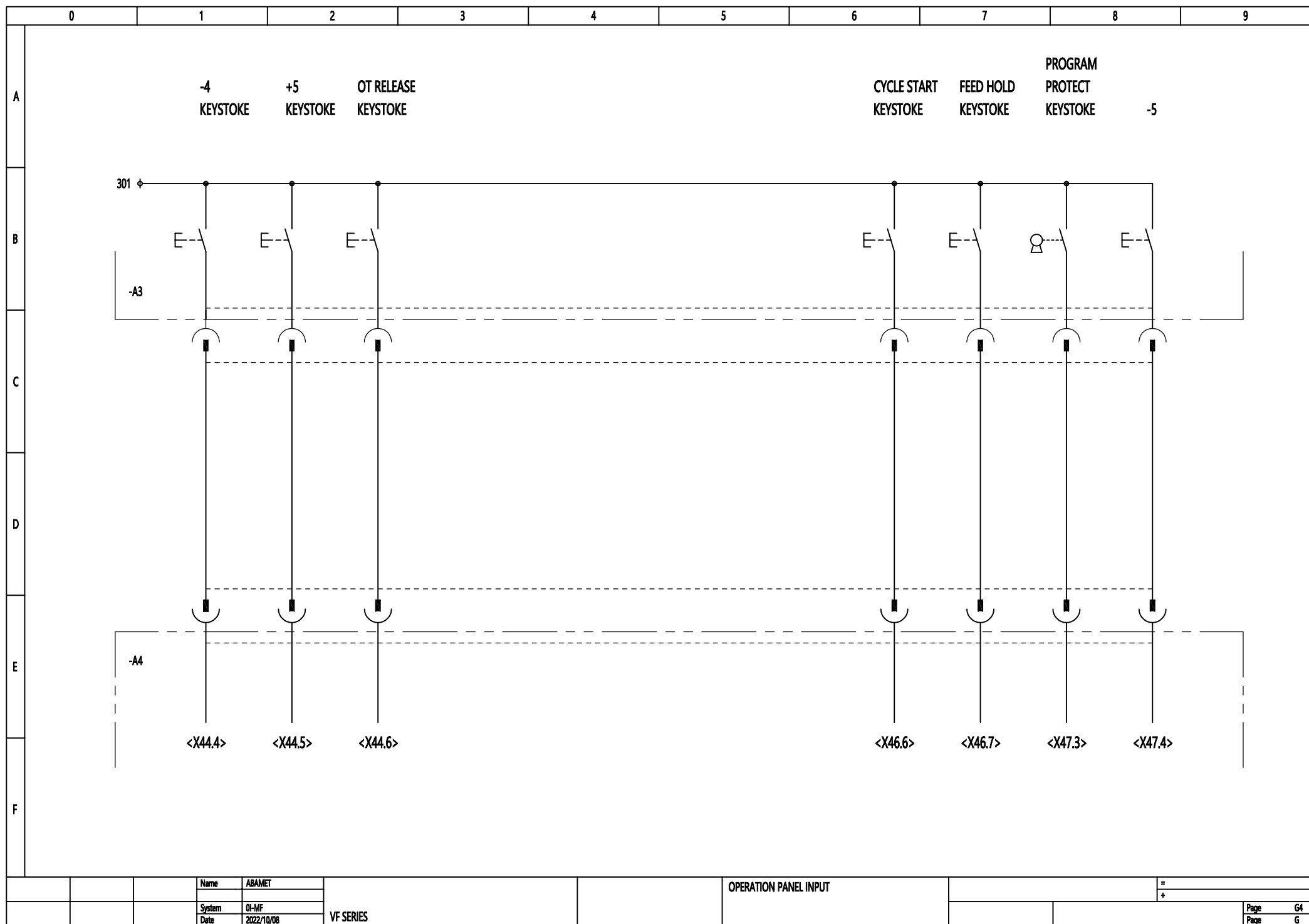


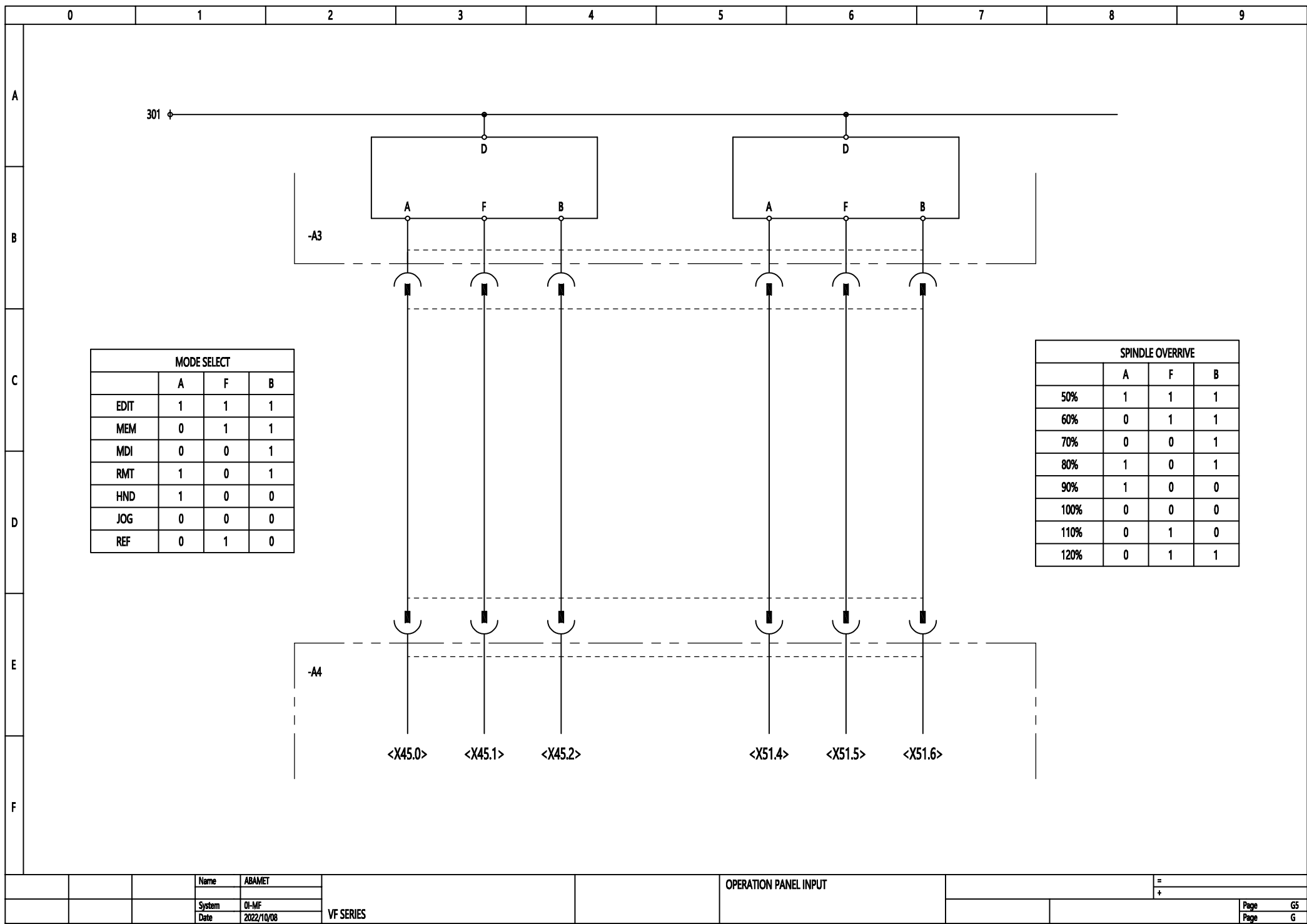


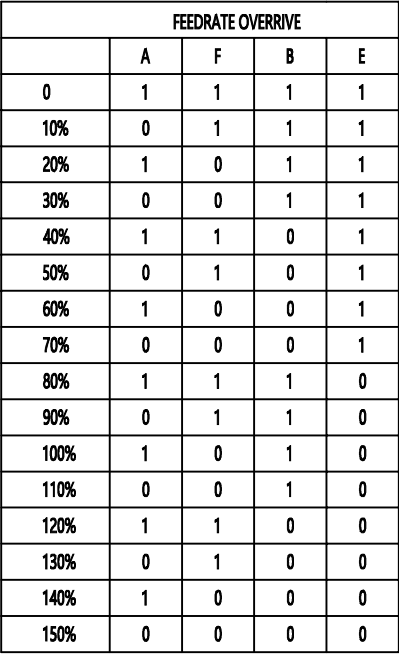


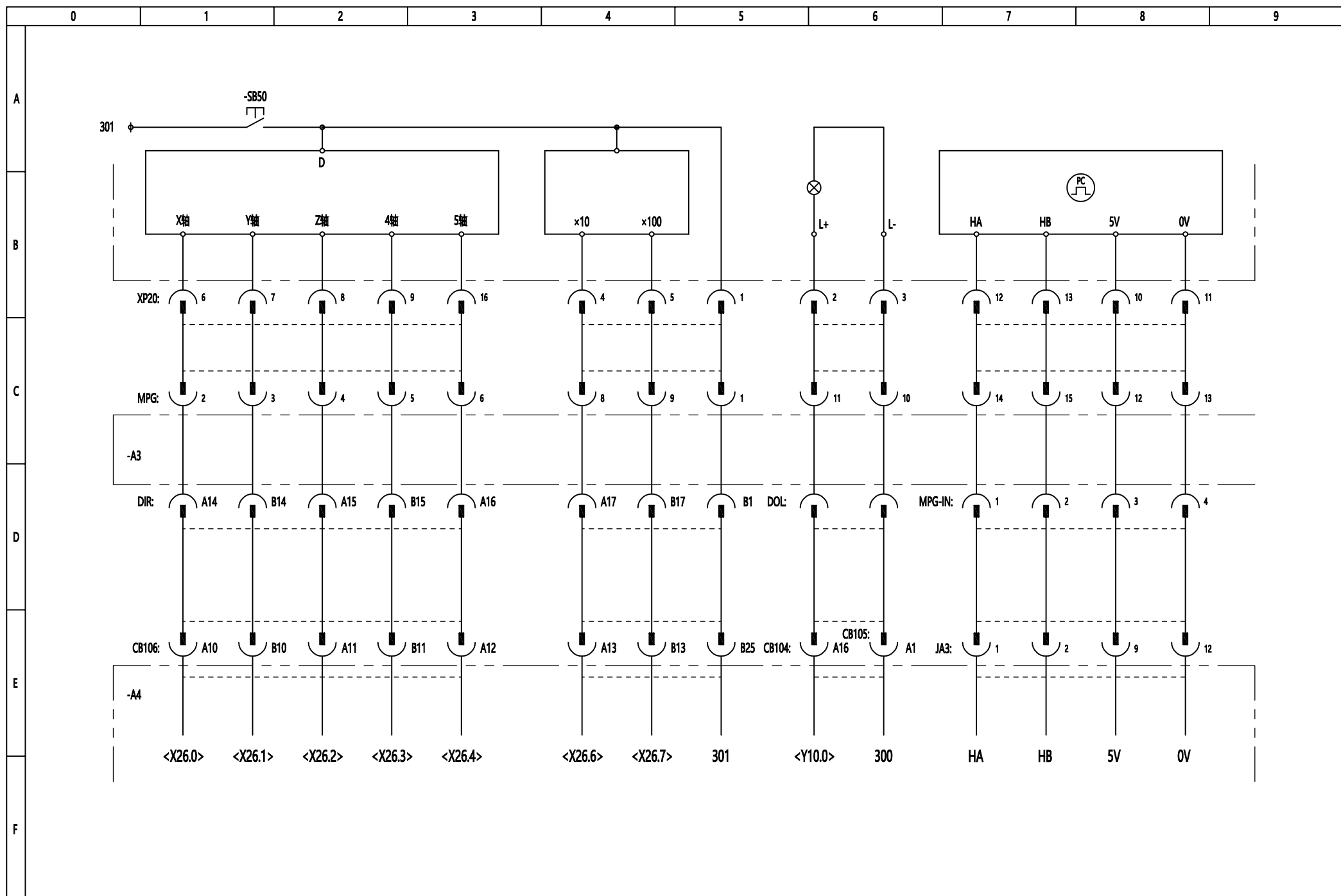


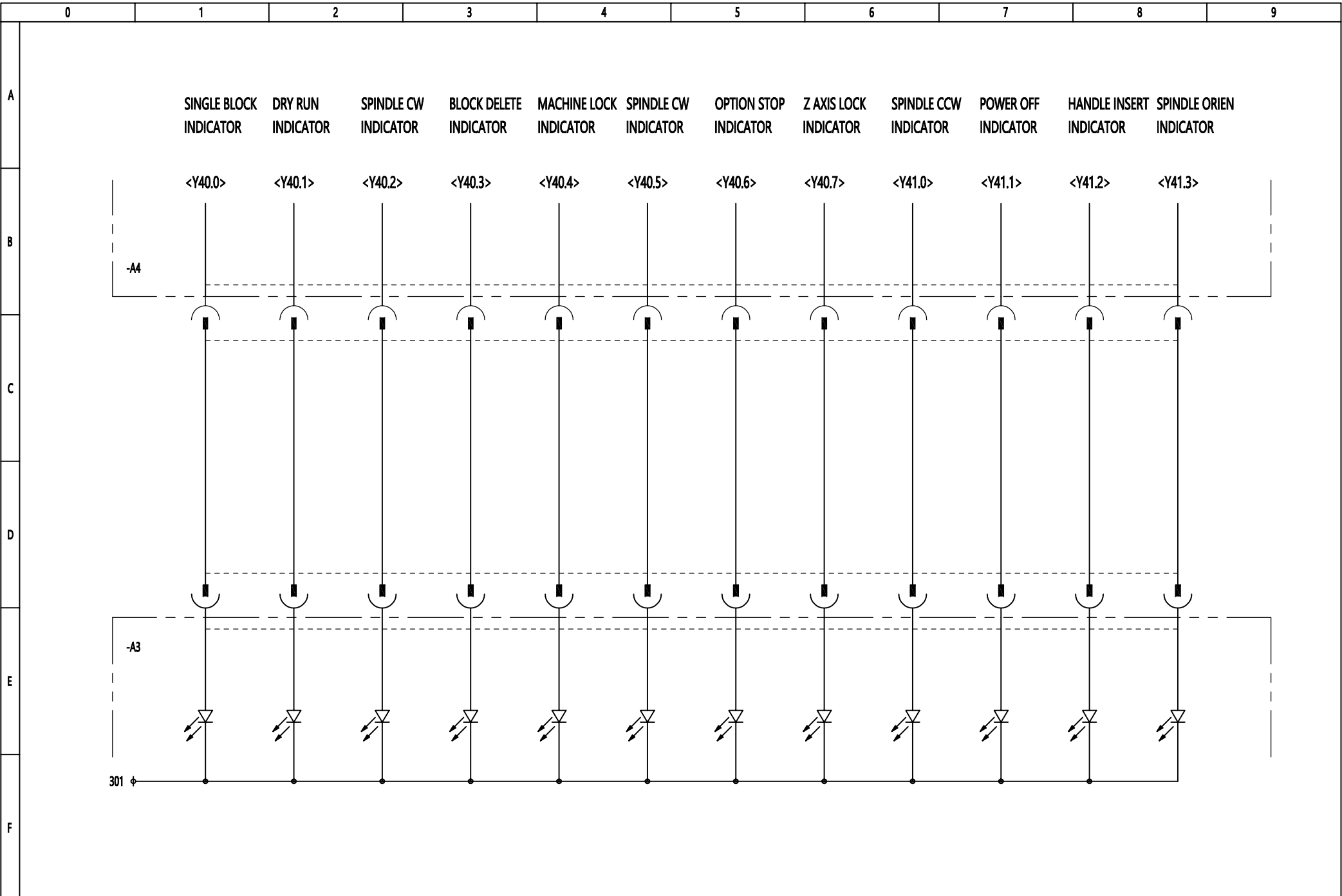












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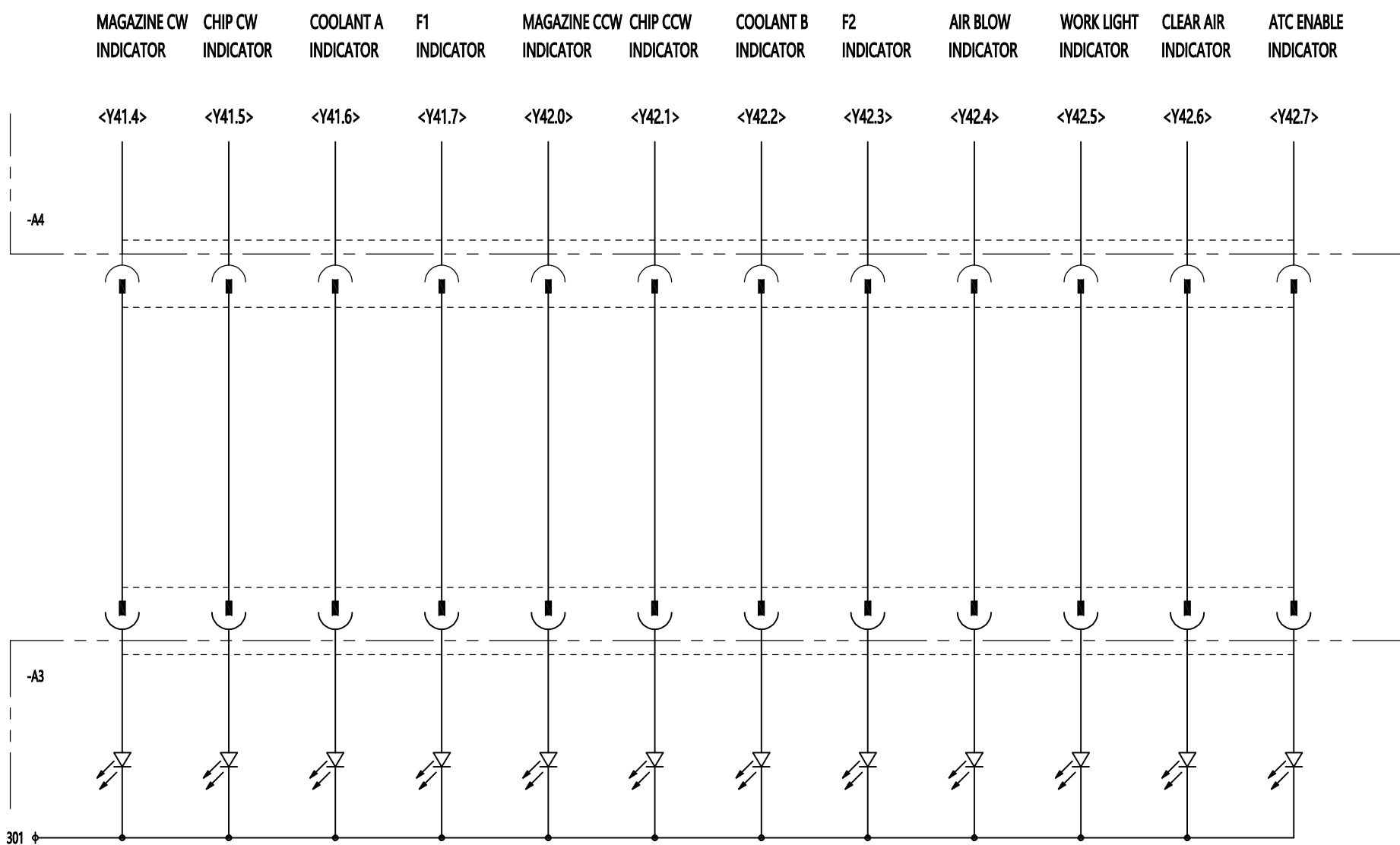
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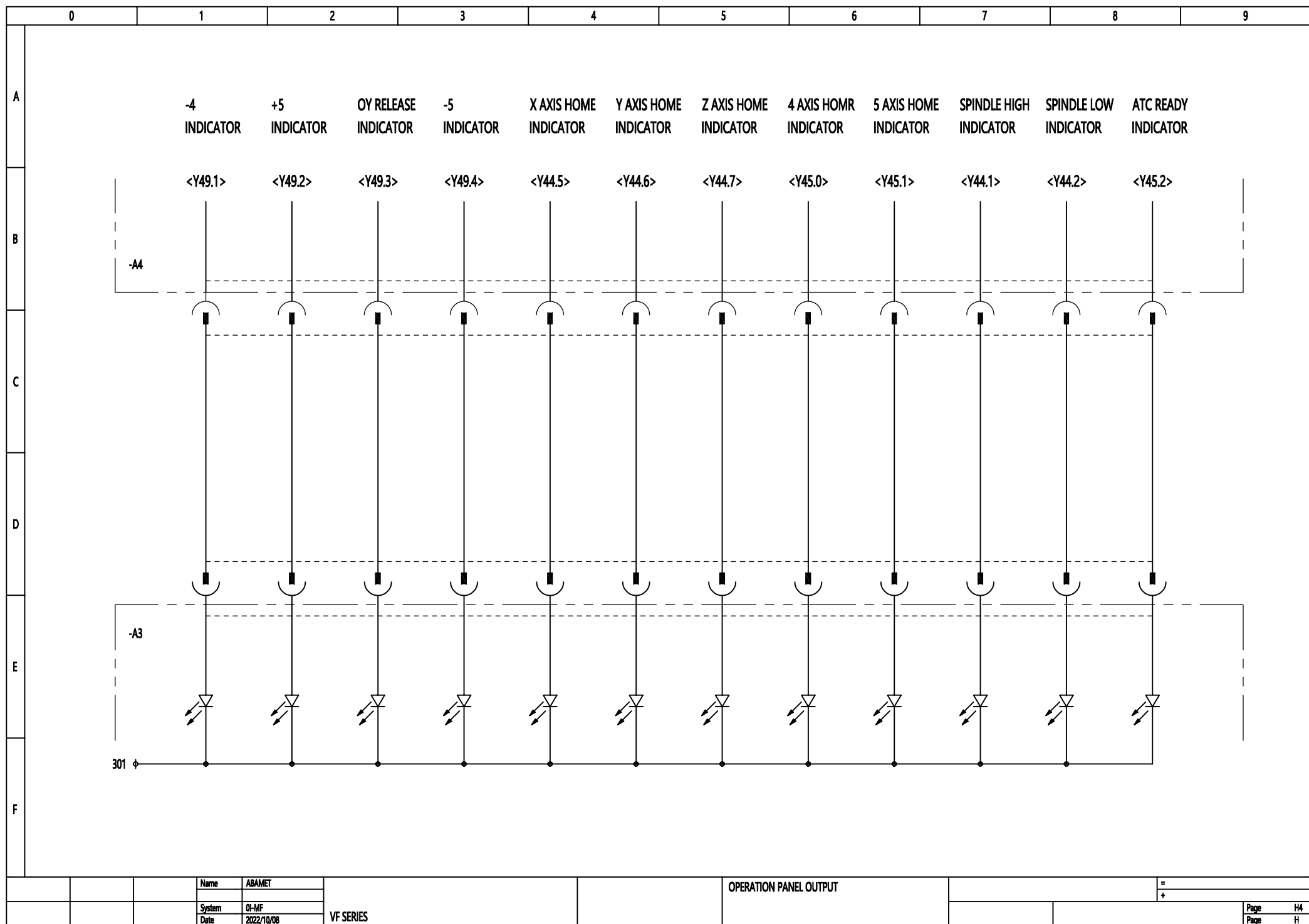
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System	01-MF
Date	2022/10/08

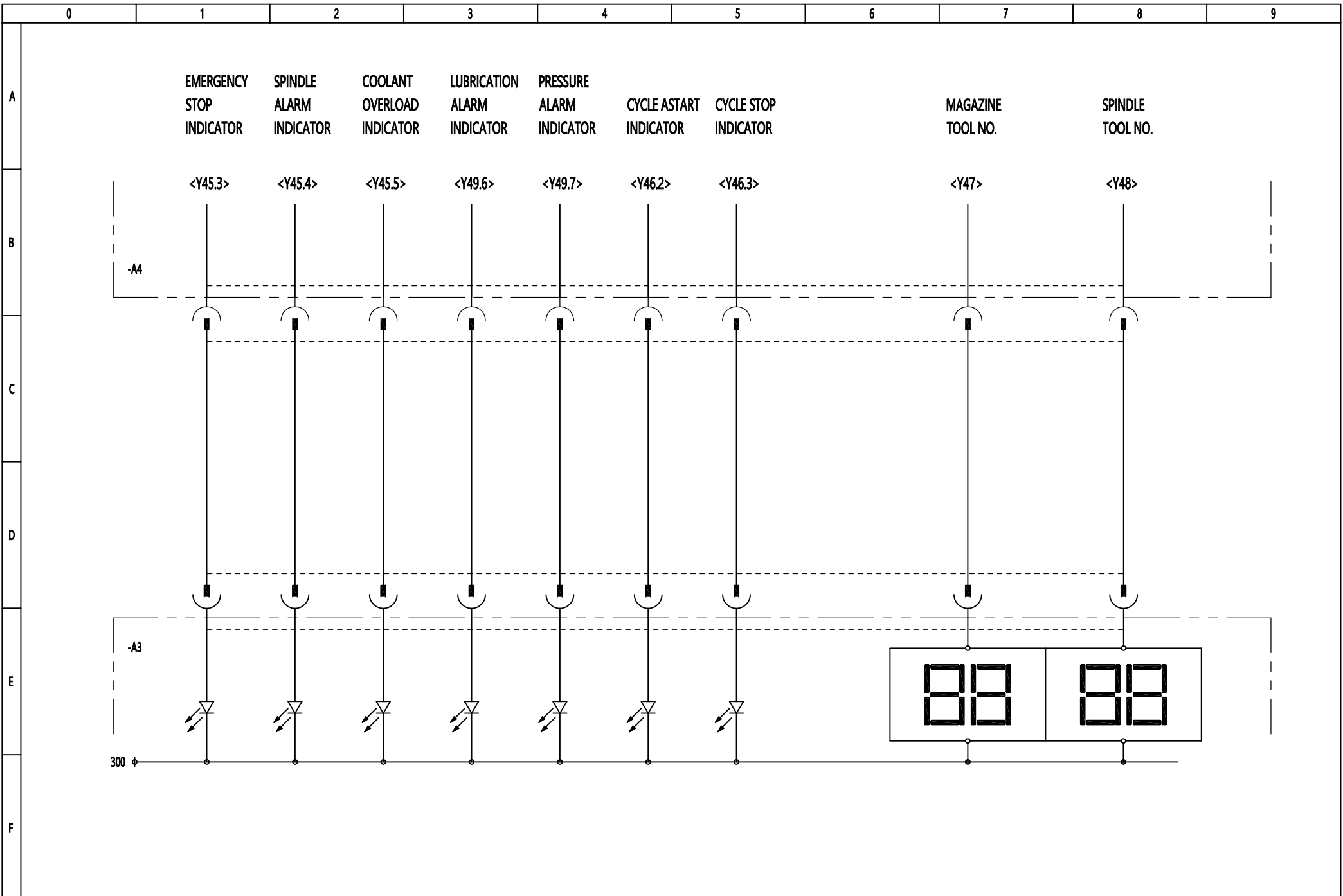
VF SERIES

OPERATION PANLE OUTPUT

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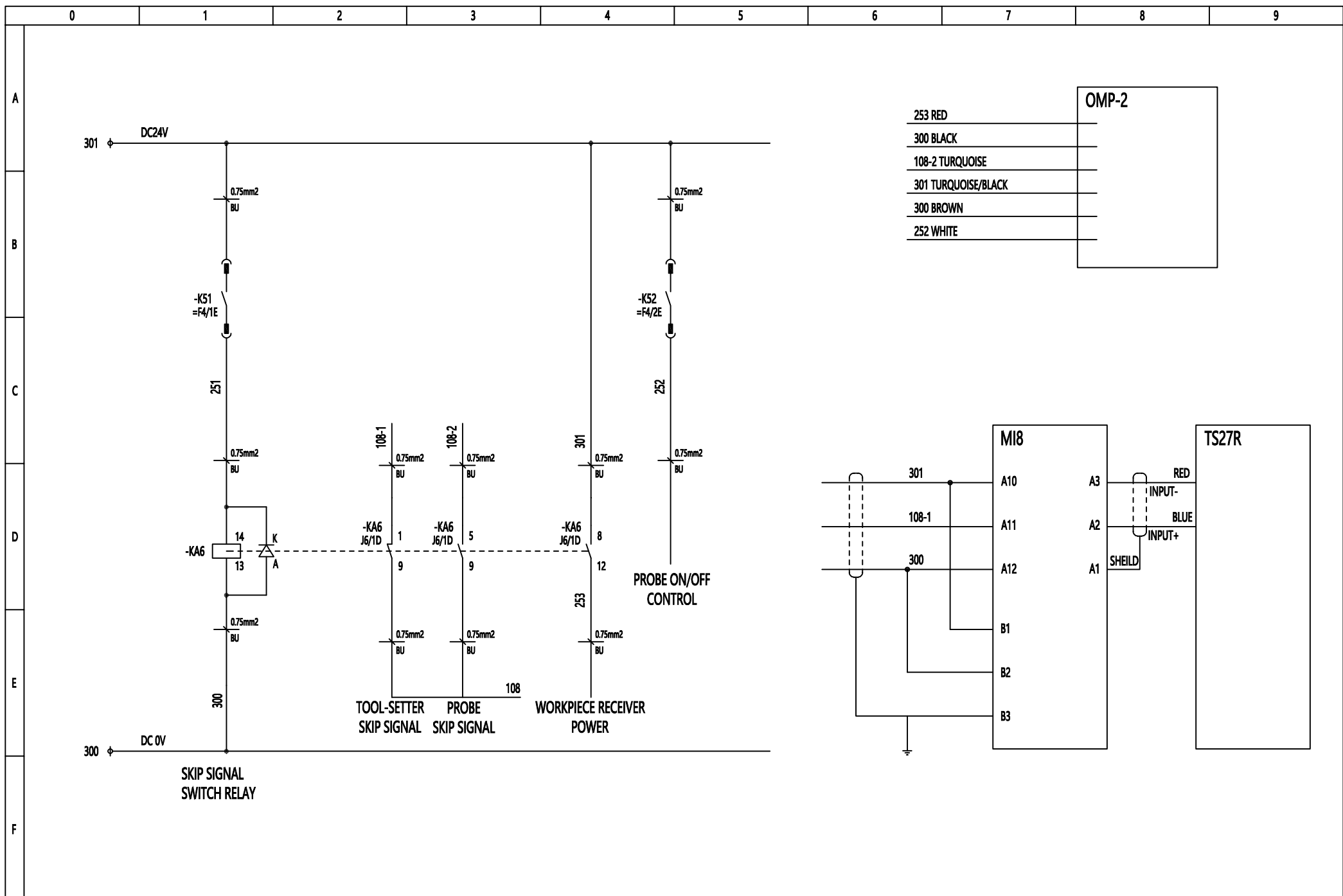
0		1		2		3		4		5		6		7		8		9	
A																			
B																			
C																			
D																			
E																			
F																			

GIFU MAGAZINE CONNECT LIST

PIN	WIRE NO.	MEANING
+	301	DC24V
+	301	DC24V
-	300	0V
30	119	MAGAZINE POCKET DOWN
31	118	MAGAZINE POCKET UP
32	117	MAGAZINE COUNTER
34	134	ARM BASIC POSITION
35	135	ARM SPINDLE POSITION
36	136	ARM BKAKE POSITION
37	133	MAGAZINE BASIC POSITION

PIN	WIRE NO.	MEANING
20	207	POCKET DOWN
21	206	POCKET UP
T	300	0V
U1	354	MAGAZINE ARM MOTOR
V1	355	
W1	356	
E	PE	MAGAZINE MOTOR
U2	351	
V2	352	
W2	353	
E	PE	

			Name	ABAMET	VF SERIES		GIFU MAGAZINE CONNECT LIST																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
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	0	1	2	3	4	5	6	7	8	9			
A	CB106 ADDRESS TABLE												
	PLC INPUT SIGNAL					PLC OUTPUT SIGNAL							
B	PLC ADDRESS	SIGNAL MEAN	I/O PIN	PORT PIN	WIRE NO.	NOTE	PLC ADDRESS	SIGNAL MEAN	I/O PIN	PORT PIN	PORT PIN	WIRE NO.	NOTE
	X4.0	COOLANT WATER PUMP OVERLOAD	CB106:A2	J CB104:A2	101	-FA1	Y4.0	OT RELEASE	CB106:A16	J CB104:A16	J K01	201	
	X4.1	RING WATER PUMP OVERLOAD	CB106:B2	CB104:B2	102	-FA2	Y4.1	TOOL-SETTER BLOW	CB106:B16	CB104:B16	J K38	238	
	X4.2	CHIP CONVEYOR MOTOR OVERLOAD	CB106:A3	CB104:A3	103	-FA3/4/5	Y4.2	UNCLAMP TOOL	CB106:A17	CB104:A17	J K03	203	
	X4.3	MAGAZINE MOTOR OVERLOAD	CB106:B3	CB104:B3	104	-FA6	Y4.3	UNCLAMP AIR BLOW	CB106:B17	CB104:B17	J K04	204	
	X4.4	LUBRICANT LEVEL	CB106:A4	CB104:A4	105		Y4.4	CUT BLOW	CB106:A18	CB104:A18	J K05	205	
C	X4.5	LUBRICANT PRESSURE	CB106:B4	CB104:B4	106		Y4.5	POCKET UP	CB106:B18	CB104:B18	J K06	206	
	X4.6	OIL WATER SEPARATOR OVERLOAD	CB106:A5	CB104:A5	107	-FA11	Y4.6	POCKET DOWN	CB106:A19	CB104:A19	J K07	207	
	X4.7	SKIP SIGNAL	CB106:B5	CB104:B5	108	-SK8	Y4.7	WORK LIGHT	CB106:B19	CB104:B19	J K28	228	
	24V1	+24V	CB106:B25	CB104:B25	301		24V1	+24V	CB106:A24	CB104:A24			
	X5.0	SPINDLE FAN OVERLOAD	CB106:A6	CB104:A6	109	-FA20	Y5.0	LUBRICATION	CB106:A20	CB104:A20	J K17	217	
	X5.1	MAGAZINE ARM MOTOR OVERLOAD	CB106:B6	CB104:B6	110	-FA8	Y5.1	AUTO POWER OFF	CB106:B20	CB104:B20	J K18	218	
D	X5.2	CENTER WATER MOTOR OVERLOAD	CB106:A7	CB104:A7	111	-FA12	Y5.2	CHIP MOTOR CW	CB106:A21	CB104:A21	J K19	219	
	X5.3	MAIN TOOL UNCLAMPED	CB106:B7	CB104:B7	112		Y5.3	CHIP MOTOR CCW	CB106:B21	CB104:B21	J K20	220	
	X5.4	CENTER WATER PUMP OVERLOAD	CB106:A8	CB104:A8	113	-FA18	Y5.4	MAGAZINE CW	CB106:A22	CB104:A22	J K21	221	
	X5.5	MAIN TOOL CLAMPED	CB106:B8	CB104:B8	114		Y5.5	MAGAZINE CCW	CB106:B22	CB104:B22	J K22	222	
	X5.6	SPINDLE NO TOOL	CB106:A9	CB104:A9	115		Y5.6	MAGAZINE ARM CW	CB106:A23	CB104:A23	J K23	223	
	X5.7	UNCLAMP TOOL KEY	CB106:B9	CB104:B9	116	-SB16	Y5.7	OIL WATER SEPARATOR	CB106:B23	CB104:B23	J K13	213	
E	24V1	+24V	CB106:B24	CB104:B24	301		24G1	0V	CB106:A1	CB104:A1			
	X6.0	MAGAZINE COUNTER	CB106:A10	CB104:A10	117	-SQ17							
	X6.1	MAGAZINE POCKET UP	CB106:B10	CB104:B10	118	-SQ18							
	X6.2	MAGAZINE POCKET DOWN	CB106:A11	CB104:A11	119	-SQ19							
	X6.3	GUARD CLOSED	CB106:B11	CB104:B11	120	-S20							
	X6.4	PNEUMATIC PRESSURE	CB106:A12	CB104:A12	121	-SP21							
F	X6.5	HYDRAULIC MOTOR OVERLOAD	CB106:B12	CB104:B12	122	-FA19							
	X6.6	A AXIS CLAMPED	CB106:A13	CB104:A13	123								
	X6.7	A AXIS UNCLAMPED	CB106:B13	CB104:B13	124								
	24V1	+24V	CB106:A25	CB104:A25	301								

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C										
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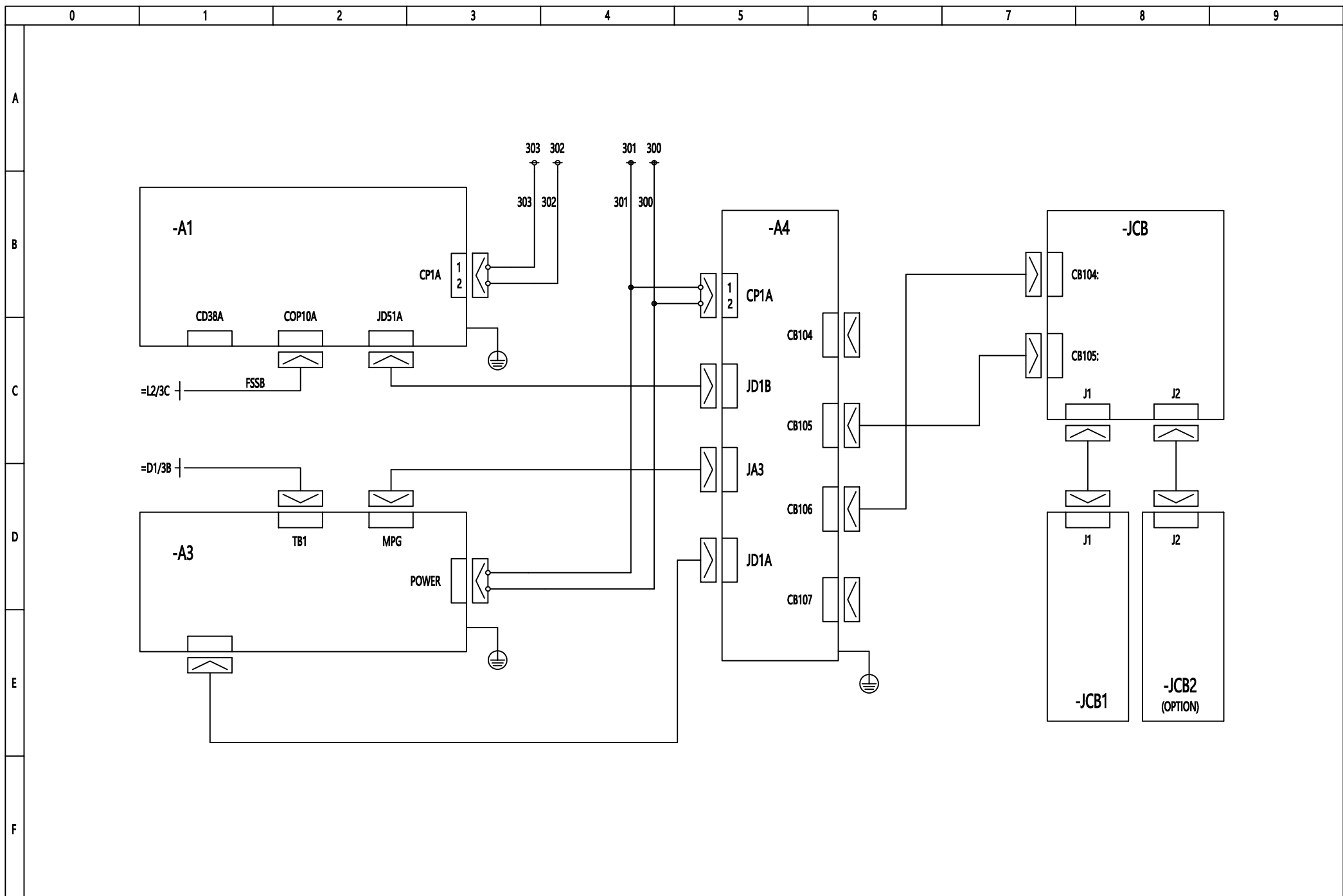
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X3.0		CB10S:A2	J CB10S:A2	125	
X3.1		CB10S:B2	CB10S:B2	126	
X3.2		CB10S:A3	CB10S:A3	127	
X3.3	OIL-MIST RECYCLE OVERLOAD	CB10S:B3	CB10S:B3	128	
X3.4	PHASE ERROR DETECT	CB10S:A4	CB10S:A4	129	
X3.5	CENTER WATER SP. LEAKING DETECT	CB10S:B4	CB10S:B4	130	
X3.6	WATER TANK LEVEL DETECT	CB10S:A5	CB10S:A5	131	
X3.7		CB10S:B5	CB10S:B5	132	
24V1	+24V	CB10S:B25	CB10S:B25	301	
X8.0	MAGAZINE REFERENCE	CB10S:A6	CB10S:A6	133	
X8.1	MAGAZINE ARM BASIC POSITION	CB10S:B6	CB10S:B6	134	
X8.2	MAGAZINE ARM SPINDLE POSITION	CB10S:A7	CB10S:A7	135	
X8.3	MAGAZINE ARM BKARE POSITION	CB10S:B7	CB10S:B7	136	
X8.4	EMERGENCY STOP	CB10S:A8	CB10S:A8	137	
X8.5	OIL COOLER ALARM	CB10S:B8	CB10S:B8	138	
X8.6	SPINDLE HIGH SIGNAL	CB10S:A9	CB10S:A9	139	
X8.7	SPINDLE LOW SIGNAL	CB10S:B9	CB10S:B9	140	
24V1	+24V	CB10S:B24	CB10S:B24	301	
X9.0	LUBE STOP	CB10S:A10	CB10S:A10	141	
X9.1	C AXIS CLAMPED	CB10S:B10	CB10S:B10	142	
X9.2	C AXIS UNCLAMPED	CB10S:A11	CB10S:A11	143	
X9.3		CB10S:B11	CB10S:B11	144	
X9.4	CENTER WATER HIGH-LEVEL	CB10S:A12	CB10S:A12	145	
X9.5	CENTER WATER MID-LEVEL	CB10S:B12	CB10S:B12	146	
X9.6	CENTER WATER LOW-LEVEL	CB10S:A13	CB10S:A13	147	
X9.7	CENTER WATER FILTER ALARM	CB10S:B13	CB10S:B13	148	
24V1	+24V	CB10S:A25	CB10S:A25	301	

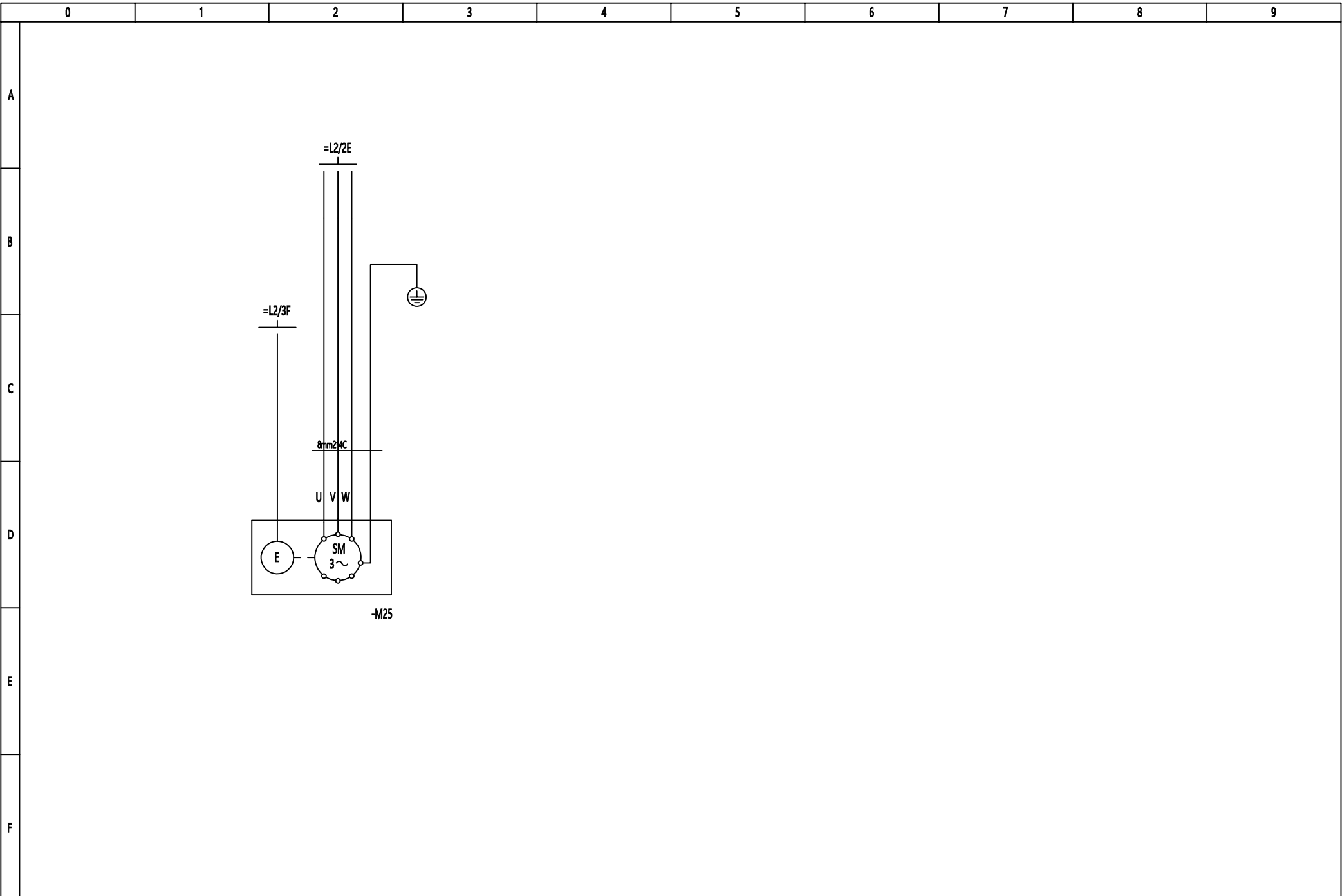
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Y2.1		CB10S:B16	CB10S:B16			
Y2.2		CB10S:A17	CB10S:A17			
Y2.3		CB10S:B17	CB10S:B17			
Y2.4		CB10S:A18	CB10S:A18			
Y2.5		CB10S:B18	CB10S:B18			
Y2.6		CB10S:A19	CB10S:A19			
Y2.7		CB10S:B19	CB10S:B19			
24V1	+24V	CB10S:A24	CB10S:A24			
Y3.0	A AXIS CLAMP	CB10S:A20	CB10S:A20	JCB1 K42	209	
Y3.1	SKIP SIGNAL SWITCH RELAY	CB10S:B20	CB10S:B20	JCB1 K41	251	
Y3.2	PROBE ON/OFF CONTROL	CB10S:A21	CB10S:A21	JCB1 K41	252	
Y3.3	Z AXIS BRAKE	CB10S:B21	CB10S:B21	JCB1 K02	202	
Y3.4	CENTER WATER	CB10S:A22	CB10S:A22	JCB1 K29	229	
Y3.5	COOLANT WATER	CB10S:B22	CB10S:B22	JCB1 K30	230	
Y3.6	CENTER WATER PUMP	CB10S:A23	CB10S:A23	JCB1 K31	231	
Y3.7	RING WATER	CB10S:B23	CB10S:B23	JCB1 K14	214	
24G1	0V	CB10S:A1	CB10S:A1			

Name	ABAMEI
System Date	01-Mar 2022/10/08
VF SERIES	

CB10S ADDRESS TABLE	= +
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Page No. K2





		Name	ABAMET	VF SERIES	SPINDLE CONNECT			=
		System	0I-MF					+
		Date	2022/10/08					
						Page	L4	
						Page	L	