

Advantages of new FX5U PLC Touch Screen Control

- 1. Self intuitive, icons driven graphical user interface simplifies programming (M- Line, V-Line)
- 2. 7" and 8.4" color high resolution touch screen
- 3. Most functionality on one screen; no flipping from screen-to-screen
- 4. Control is interactive with messages for the operator which reduces the learning curve
- 5. Unified new generation PLC FX5U is the same for all automatic machines with built in Ethernet port and SD card socket
- 6. Software updates can be sent by e-mail, saved on a SD card and loaded to PLC and HMI
- 7. Replaced head up limit switch with programmable head up position. (H-line)
- 8. Built in machine diagnostic within PLC software and display on screen
- 9. Number of jobs: M20A, M16A, V18APC, V25APC, M20A120: 1000 jobs, 20 jobs in queue
- 10. Number of jobs:H18A, H22A, H28A, H32, H22A120, H28A120: 999 jobs, 10 jobs in queue

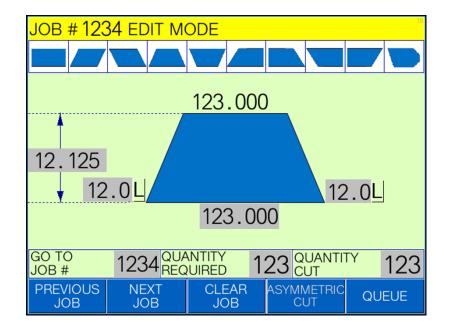
Diagnostic Screens

INP	UTS	ABLEWRY	INPUT DESCRIPTION	INPL	CABLEWEIG	INPUT DESCR	RIPTION
х	0	07-021 LUCRD8K(L	LENGTH ENCODER C			GUIDE ARM L/	
х	1	07-CE1 K (R) BLU(L	LENGTH ENCODER CI	н. а 🗙 2		HEAD IN COLL	JSION PROX
х	2	IDT-CE15 ROWN	ANGLE ENCODER CH	.a X 2	a r	HEAD RETRAC	CT_LS1
х	3		ANGLE ENCODER CH	. в 🛛 🗙 2	3 SAW-C43 PK	HEAD ADVANC	CE LS2
х	4		FEED RATE ENCODER	R CH.B X 2	4 BLK	SHUTTLE IN CO	LUSION PROX
х	5	IDT-CE4	FEED RATE ENCODER	r ch.a X 2	5		
х	6		Not used	X 2	6		
х	7		Not used	X 2	7		
X	10	IDT-CP1	BLADE SPEED PROX	X 3	0		
X	11		Not used	X 3	1		
X	12	E15 WHITE	90 DEGREE MARKER	X 3	2		
X	13	NA BA	SHUTTLE REV. OVERT	RAVEL X 3	3 ²³ BLUE	RIGHT CONVE	YOR SELECT
X	14	HT-C23 ROWN	OUT OF STOCK, LS4	X 3	4 BLUE	LEFT CONVEY	OR SELECT
X	15	LUE	THERMAL OVERLOAD	X 3	5 81.UE	RIGHT CONVE	Y. DIRECTION
X	16	(16 BLUE	ALARM SAFETY RELA	y X 3	6 BLUE	LEFT CONVEY	DIRECTION
X	17	(17 BLUE	BROKEN BLADE L/S 3	X 3	7 BLUE	CONVEYOR A	UTO MODE
RETURN		URN					

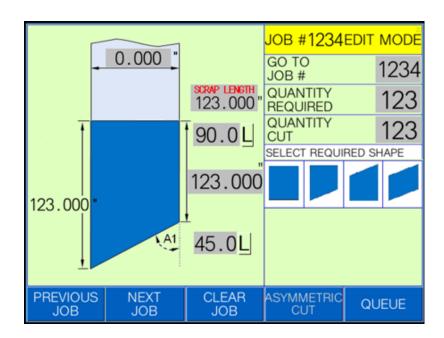
OUT	PUT CARLE #	OUTPUT DESCRIPTION	OUTPUT	GABLE #	OUTPUT DESCRIPTION
Y	0 11 RED	HYDRAULIC PUMP MOTOR M1	Y 20	HID-041_42 BLACK 1	HEAD RETRACT SOL, 41
Υ	1 8.UE	BALDE MOTOR M2	Y 21	MID-041_42 BLACK 2	HEAD ADVANCE SOL, 42
Y	2	LASER	Y 22	MID-C91_92 BLACK 2	SHUTTLE VISE OPEN SOL, 91
Υ	3	Not Used	Y 23	MID-C91_92 BLACK 1	SHUTTLE VISE CLOSE SOL,92
Y	4 CR6 BLUE	COOLANT PUMP RELAY CR6	Y 24	MID-081_82 BLACK 2	INFEED VISE OPEN SOL, 61
Y	5	COOLANT - MIST	Y 25	MID-081_62 BLACK 1	INFEED VISE CLOSE SOL, 62
Υ	6 RED+GRN	WORK LIGHT	Y 26	COT-CE15 YELLOW	ANGLE ENCODER 90Deg SET
Y	7 HYD-I18 BLACK 1	SAGEFLE FAST SOL, 113	Y 27	878-018 8.408.1	HEAD SWING FAST SOL, 13
Y	10	Not Used	Y 30	BAGE2	SHUTTLE FORWARD SOL, 111
Y	11 HYD-HBK BLACK 1	HEAD BREAK SOL, HBK	Y 31	BLACK 1	SHUTTLE REVERSE SOL. 112
Y	12 BLACK 2	HEAD SWING LEFT SOL, 11	Y 32		Not Used
Y	13 BLACK 1	HEAD SWING RIGHT SOL, 12	Y 33		Not Used
Y	14 8LADX 2	CHIP CONV, RIGHT SOL, 22	Y 34	HID-C71_72 BLACK 2	OUTFEED VISE OPEN SOL, 71
Y.	15 840-021_22 BLACK 1	CHIP CONV, LEFT SOL, 21	Y 35	HD-C71_72 BLACK 1	OUTFEED VISE CLOSE SOL72
Y.	16 80.000 2	GUIDE ARM DOWN SOL, 31	Y 36		
Y.	17 HVD-C31_32 8LAOK 1	GUIDE ARM UP SOL, 32	Y 37		
F	RETURN				

Programming Icons

V Series Machines



M Series Machines



H18A, H22A, H28A, H32A Machines

MANUAL MODE - ONE CUT							
LENGTH	12. 000 ["]						
FEED RATE	12. 22 "/min						
BLADE SPEED	SPEED SET ACTUAL SPEED 119 123 SFM						
BLADE MOTOR LOAD 123 %							
CUT IN TOWARDS STOCK	CUT OUT TOWARDS FRONT						
0/0 100 80 80 40 2	20 0 20 40 60 60 100 %						
LAMP SHUT CLE	KERE						

JOB EDIT MODE					
ENTER JOB #	123				
PIECES REQUIRED	123				
PIECES CUT	123				
LENGTH	234.000				

LAMP	QUEUE		KERF

	JOBS TO BE EXECUTED IN QUEUE							
JOB IN QUEUE	JOB#	QTY. Req	QTY. CUT	LENGTH Req	JOB			
1	_1_	123 pcs	0 pcs	5.000 "				
2	_13_	123 pcs	0 pcs	10.000	CLEAR			
3	_14_	123 pcs	0 pcs	15.000 "	QUEUE			
4	_15_	123 pcs	0 pcs	20.000 "				
5	_16	123 pcs	0 pcs	25.000 "				
6	123	123 pcs	0 pcs	30.000				
7	124	123 pcs	0 pcs	35.000				
8	125	123 pcs	0 pcs	40.000 "				
9	126	123 pcs	0 pcs	100.000 "				
10	999	123 pcs	0 pcs	500.000 "				

Controller Comparison - Old vs New

V-18APC60





V-18









