



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

INPUT	CABLE # / WIRE COLOR	INPUT DESCRIPTION	INPUT	CABLE # / WIRE COLOR	INPUT DESCRIPTION
X 0	SDT-CB1 BK(2)BK(1)	LENGTH ENCODER CH. B	X 20		GUIDE ARM L/S 33
X 1	SDT-CB1 BK(2)BLU(1)	LENGTH ENCODER CH. A	X 21		HEAD IN COLLISION PROX.
X 2	SDT-CB15 BROWN	ANGLE ENCODER CH. A	X 22	SAW-C44 VV	HEAD RETRACT LS1
X 3	SDT-CB15 GREEN	ANGLE ENCODER CH. B	X 23	SAW-C43 PK	HEAD ADVANCE LS2
X 4	SDT-CE4 BLUE	FEED RATE ENCODER CH.B	X 24	CP4 BLK	SHUTTLE IN COLLISION PROX.
X 5	SDT-CE4 BLACK	FEED RATE ENCODER CH.A	X 25		
X 6		Not used	X 26		
X 7		Not used	X 27		
X 10	SDT-CP1 GREEN	BLADE SPEED PROX	X 30		
X 11		Not used	X 31		
X 12	CE15 WHITE	90 DEGREE MARKER	X 32		
X 13	SAW-18 BLA BK	SHUTTLE REV. OVERTRAVEL	X 33	23 BLUE	RIGHT CONVEYOR SELECT
X 14	SDT-C23 BROWN	OUT OF STOCK LS4	X 34	24 BLUE	LEFT CONVEYOR SELECT
X 15	CE15 BLUE	THERMAL OVERLOAD	X 35		RIGHT CONVEY. DIRECTION
X 16	CE16 BLUE	ALARM SAFETY RELAY	X 36	21 BLUE	LEFT CONVEY. DIRECTION
X 17	CE17 BLUE	BROKEN BLADE L/S 3	X 37	25 BLUE	CONVEYOR AUTO MODE
RETURN					

OUTPUT	CABLE # / WIRE COLOR	OUTPUT DESCRIPTION	OUTPUT	CABLE # / WIRE COLOR	OUTPUT DESCRIPTION
Y 0	CE1 RED	HYDRAULIC PUMP MOTOR M1	Y 20	HYD-C41-42 BLACK 1	HEAD RETRACT SOL. 41
Y 1	CE1A BLUE	BALDE MOTOR M2	Y 21	HYD-C41-42 BLACK 2	HEAD ADVANCE SOL. 42
Y 2		LASER	Y 22	HYD-C91-92 BLACK 2	SHUTTLE WISE OPEN SOL. 91
Y 3		Not Used	Y 23	HYD-C91-92 BLACK 1	SHUTTLE WISE CLOSE SOL.92
Y 4	CR6 BLUE	COOLANT PUMP RELAY CR6	Y 24	HYD-C81-82 BLACK 2	INFEED WISE OPEN SOL. 61
Y 5		COOLANT - MIST	Y 25	HYD-C81-82 BLACK 1	INFEED WISE CLOSE SOL. 62
Y 6	CE15 RED+GRN	WORK LIGHT	Y 26	SDT-CE15 YELLOW	ANGLE ENCODER 90Deg SET
Y 7	HYD-113 BLACK 1	SAGERLE FAST SOL. 113	Y 27	HYD-113 BLACK 2	HEAD SWING FAST SOL. 13
Y 10		Not Used	Y 30	HYD-011-116 BLACK 2	SHUTTLE FORWARD SOL. 111
Y 11	HYD-HBK BLACK 1	HEAD BREAK SOL. HBK	Y 31	HYD-011-116 BLACK 1	SHUTTLE REVERSE SOL. 112
Y 12	HYD-C11-12 BLACK 1	HEAD SWING LEFT SOL. 11	Y 32		Not Used
Y 13	HYD-C11-12 BLACK 2	HEAD SWING RIGHT SOL. 12	Y 33		Not Used
Y 14	HYD-C21-22 BLACK 1	CHIP CONV. RIGHT SOL. 22	Y 34	HYD-C71-72 BLACK 2	OUTFEED WISE OPEN SOL. 71
Y 15	HYD-C21-22 BLACK 2	CHIP CONV. LEFT SOL. 21	Y 35	HYD-C71-72 BLACK 1	OUTFEED WISE CLOSE SOL.72
Y 16	HYD-C91-92 BLACK 2	GUIDE ARM DOWN SOL. 31	Y 36		
Y 17	HYD-C91-92 BLACK 1	GUIDE ARM UP SOL. 32	Y 37		
RETURN					

Programming Icons

V Series Machines

JOB # 1234 EDIT MODE

123.000

12.125

12.0L

123.000

12.0L

GO TO JOB #	1234	QUANTITY REQUIRED	123	QUANTITY CUT	123
PREVIOUS JOB	NEXT JOB	CLEAR JOB	ASYMMETRIC CUT	QUEUE	

M Series Machines

0.000"

123.000"

90.0L

123.000"

45.0L

A1

SCRAP LENGTH 123.000"

JOB # 1234 EDIT MODE

GO TO JOB #	1234
QUANTITY REQUIRED	123
QUANTITY CUT	123
SELECT REQUIRED SHAPE	

PREVIOUS JOB	NEXT JOB	CLEAR JOB	ASYMMETRIC CUT	QUEUE
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Manual Mode, Job and Queue Screens

H18A, H22A, H28A, H32A Machines

MANUAL MODE - ONE CUT			
LENGTH	12.000 "		
FEED RATE	12.22 "/min		
BLADE SPEED	SPEED SET 119	ACTUAL SPEED 123 SFM	
BLADE MOTOR LOAD	123 %		
<div style="display: flex; justify-content: space-between;"> CUT IN TOWARDS STOCK CUT OUT TOWARDS FRONT </div>			
LAMP	SHUTTLE CLEAR	BLADE LIMIT SET	BLADE DEV. RESET
			KERF

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 "	CLEAR QUEUE
2	13	123 pcs	0 pcs	10.000 "	
3	14	123 pcs	0 pcs	15.000 "	
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



H-18A

