

Connections	DIGITAL 01 DIGITAL ADDRESS: 0															DIGITAL 02 DIGITAL ADDRESS: 1															DIGITAL 03 DIGITAL ADDRESS: 2															DIGITAL 04 DIGITAL ADDRESS: 3														
	REF	ANALOG 02 ANALOG ADDRESS: 2															ANALOG 03 ANALOG ADDRESS: 3															ANALOG 04 ANALOG ADDRESS: 4															ANALOG 05 ANALOG ADDRESS: 5													
Ref	K4	K7	K24	#NA	K20	K21	K22	K23	K11	K8	K14	KA103	KA203	KA303	KA403	KA503	KA603	KA703	KA803	KA100	KA101	KA200	KA201	KA300	KA301	KA400	KA401																																	
Signal Type	D	D	D	D	D	D	D	D	D	D	D	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A																																
Module	0	0	0	0	0	0	0	0	0	0	0	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3																																	
Address Channel	00	01	02	03	04	05	06	07	08	09	10	00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15																																	
Function	MAIN_POWER_LATCH	LAMP_POWER_CTRL	O2_POWER	0	O2_SRC	O2_SAMPLE_1	O2_SAMPLE_2	O2_SAMPLE_3	SPEED_FEEDBACK	TRANSPORT_MOTION_FAULT	spare	spare	ALARM_HORN	spare	spare	spare	TEMPERATURE_ZONE_1_K	TEMPERATURE_ZONE_2_K	TEMPERATURE_ZONE_3_K	TEMPERATURE_ZONE_4_K	TEMPERATURE_ZONE_5_K	TEMPERATURE_ZONE_6_K	TEMPERATURE_ZONE_7_K	TEMPERATURE_ZONE_8_K	ZONE_1_TOP	ZONE_1_BOTTOM	ZONE_2_TOP	ZONE_2_BOTTOM	ZONE_3_TOP	ZONE_3_BOTTOM	ZONE_4_TOP	ZONE_4_BOTTOM																												
Type	PROCESSOR	DO	DO	DO	DO	DO	DO	DO	DI	DI	DO	AI	AI	AI	AI	AI	AI	AI	AI	AO	AO	AO	AO	AO	AO	AO	AO																																	
Range	ADDRESS: 0-3	4 ch DO 12-140 Vac sw	4 ch DO 12-140 Vac sw	4 ch DO 12-140 Vac sw	4 ch DO 12-140 Vac sw	4 ch DO 12-140 Vac sw	4 ch DO 12-140 Vac sw	4 ch DO 12-140 Vac sw	4ch DI 2-16Vdc .025ms	4 ch DI 2-16Vdc .025ms	4 ch DO 5-60 Vdc	2 ch AI Type K -150 to 1372 C	2 ch AI Type K -150 to 1372 C	2 ch AI Type K -150 to 1372 C	2 ch AI Type K -150 to 1372 C	2 ch AI Type K -150 to 1372 C	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc																																		
Part Nbr	322-094410-02	322-094401-01	322-094401-01	322-094401-01	322-094401-01	322-094401-01	322-094401-01	322-094401-01	322-094406-01	322-094412-01	322-094405-01	322-094405-01	322-094405-01	322-094405-01	322-094405-01	322-094405-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01																																		
Opto PN	B3000-B	SNAP-OAC5MA	SNAP-OAC5MA	SNAP-OAC5MA	SNAP-OAC5MA	SNAP-OAC5MA	SNAP-OAC5MA	SNAP-DC5-FAST	SNAP-DC5MA	SNAP-DC5MA	SNAP-AITM	SNAP-AITM	SNAP-AITM	SNAP-AITM	SNAP-AITM	SNAP-AITM	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25																																		

PART NUMBER 322-094409-08 16 CHANNEL RACK

Connections	DIGITAL 03 DIGITAL ADDRESS: 4															DIGITAL 04 DIGITAL ADDRESS: 5															DIGITAL 05 DIGITAL ADDRESS: 6															DIGITAL 06 DIGITAL ADDRESS: 7														
	REF	ANALOG 03 ANALOG ADDRESS: 6															ANALOG 04 ANALOG ADDRESS: 7															ANALOG 05 ANALOG ADDRESS: 8															ANALOG 06 ANALOG ADDRESS: 9													
Ref	KA500	KA501	KA600	KA601	KA700	KA701	KA800	KA801	KA112	KA111	KA212	KA211	KA4	K2	KA500	KA501	KA600	KA601	KA700	KA701	KA800	KA801	KA112	KA111	KA212	KA211	KA4	K2																																
Signal Type	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A																															
Module	4	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6																															
Address Channel	00	01	02	03	04	05	06	07	08	09	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29																														
Function	ZONE_5_TOP	ZONE_5_BOTTOM	ZONE_6_TOP	ZONE_6_BOTTOM	ZONE_7_TOP	ZONE_7_BOTTOM	ZONE_8_TOP	ZONE_8_BOTTOM	LEFT_EDGE_HEAT1	RIGHT_EDGE_HEAT1	LEFT_EDGE_HEAT2	RIGHT_EDGE_HEAT2	O2_INPUT	spare	BELT_SPEED_OUTPUT	spare	ZONE_9_TOP	ZONE_9_BOTTOM	ZONE_10_TOP	ZONE_10_BOTTOM	ZONE_11_TOP	ZONE_11_BOTTOM	ZONE_12_TOP	ZONE_12_BOTTOM	ZONE_13_TOP	ZONE_13_BOTTOM	ZONE_14_TOP	ZONE_14_BOTTOM	ZONE_15_TOP	ZONE_15_BOTTOM																														
Type	PROCESSOR	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO	AI	AI	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO	AO																															
Range	ADDRESS: 4-7	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AI -20+20mA	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc	2 ch AO 0-10 Vdc																															
Part Nbr	322-094410-02	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094400-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01	322-094402-01																															
Opto PN	B3000-B	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AIMA	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25	SNAP-AOV-25																															

PART NUMBER 322-094409-16 16 CHANNEL RACK

MAIN_POWER_LATCH = POWER ON, K4
LAMP_POWER_CTRL = CONTACTOR, K7, K1
RED_LAMP = LIGHT TOWER RED LAMP
YEL_LAMP = LIGHT TOWER YELLOW LAMP
GRN_LAMP = LIGHT TOWER GREEN LAMP
ALARM_HORN = AUDIBLE ALARM BUZZER
TRANSPORT_MOTION_FAULT = BELT TRANSPORT MOTION SENSOR
SPEED_FEEDBACK = BELT SPEED FEEDBACK
PRESSURE_SW_CDA = LOW AIR PRESSURE ALARM SWITCH
F/S = WATER COOLING FLOW SWITCH
TEMPERATURE_ZONE_X = THERMOCOUPLE INPUT, TYPE K, FROM ZONE X
CABINET_TEMP = FURNACE CABINET TEMPERATURE THERMOCOUPLE
ZONE_X_TOP = ZONE X SCR OUTPUT FOR TOP IR HEATING ELEMENT
BELT_SPEED_OUTPUT = OUTPUT SIGNAL TO BELT MOTOR CONTROLLER
UCD_RUN = ULTRASONIC BELT CLEANER DRAIN TIMER CYCLE
UCD_DRN = ULTRASONIC BELT CLEANER DRAIN TIMER CYCLE
Spare = SPARE CHANNEL
NA = NOT INSTALLED
RIGHT_EDGE_HEATX = EDGE HEATER X, RIGHT SIDE SCR CONTROL
LEFT_EDGE_HEATX = EDGE HEATER X, LEFT SIDE SCR CONTROL

= JUMPER INSTALLED
 = JUMPER NOT INSTALLED

LEFT_EDGE_HEATX = EDGE HEATER X, LEFT SIDE SCR CONTROL

2. COM3 - COMMUNICATION TO ELEMENT MONITOR BOARDS
1. COM2 - COMMUNICATION TO MODULES OR RACKS

NOTES:

REV	DESCRIPTION	DATE	APPROVED
4	Add PRES_SW_FG_MANIFOLD	8/22/2010	JMC
3	CHANGE TO B300-B, ADD 2ND POWER SUPPLY	8/7/2010	JMC
2	MOVED O2_POWER. ADDED O2_SRC. B3000 JUMPERS	8/10/2009	JMC
1	CHANGED B3000 INTERFACE TO COM2. REVERSE COM2 WIRES.	7/24/2009	JMC

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APPROVALS DATE TITLE

DWN JMC	3/16/11	
CHKD SBARBER	3/16/11	
ENGR JMC	3/16/11	
PM JMC	3/16/11	

AG-1215
PLC CONFIGURATION
DOCUMENT NUMBER

11-004 802-101701

SIZE: B PRNT: 3/21/11 SN: 1815129601 SHEET 1 OF 1