

XC4	
V	
G	
+24V	A
0V	D
GND	B

Power suply	
L1	+24V
N	0V

Simatic 22.5
DC/DC/DC

PWR

driver

+24V	++	2
+24V	++	3
+24V		9
+24V		11
0V		5

Inputs	
I 0.0	RK A
I 0.1	RK B

handwheel A
handwheel B

XC2	XC1	I 0.2	
	7	I 0.3	hydr. vpředu/SAC
		I 0.4	urychlení
	13	+24V L+	
		0V M_1M	
7	8*	I 0.5	VB
	12	I 0.6	LU
	11	I 0.7	PU
	2	I 1.0	UAC
		I 1.1	POB
5		I 1.2	ZPS
4		I 1.3	PPS
		I 1.4	rychloposun vzad
	10	I 1.5	rychloposun vpřed
7		I 14.0	Enkodér KM A
8		I 14.1	Enkodér KM B

KA23 - hydraulically in front
acceleration of grinding

internal grinding
left table lever
right table lever
termination of the cycle
enable grindig
rear end of screw
front end of the screw
quick feed backwards
quick feed forwards
encoder stepping motor A
encoder stepping motor B

Outputs

Q 0.0	
Q 0.1	
Q 0.2	
Q 0.3	
Q 0.4	
Q 0.5	Res.
13	via rele Q 0.6 KAC
11	via rele Q 0.7 X>WSP
	Q1.0 Z stop
8	Q1.1 Res.

end of automatic cycle
X>Wheel start point

XC3	
PUL-	4
DIR-	1

stepping motor frekv.
stepping motor dir.

XC1, XC2 and XC3 connectors of original system
SB signal board

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