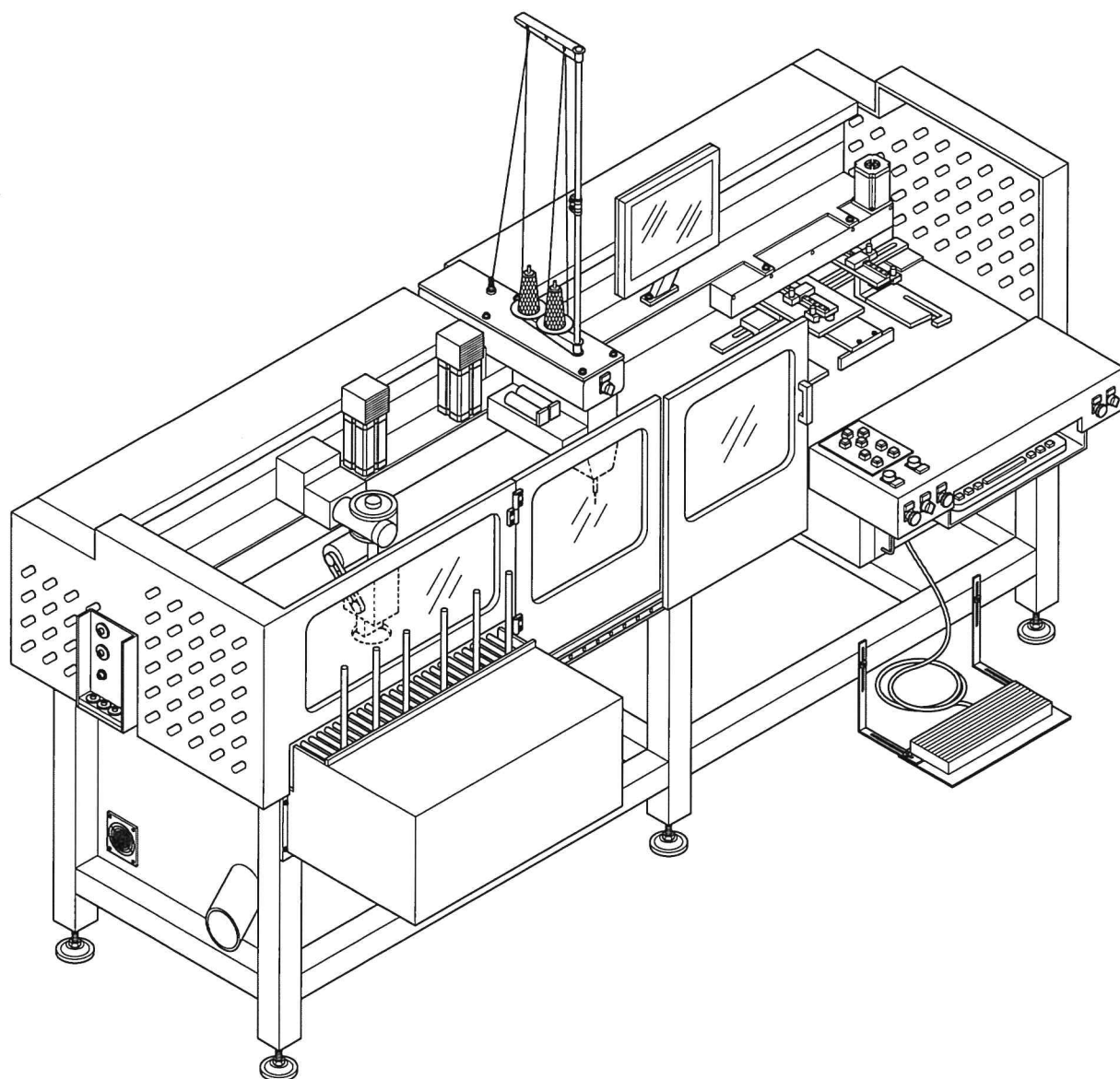


CUFF AND COLLAR SEWING MACHINE mod. UAM 03



Operating and maintenance instructions





Macchine Automatismi Industriali Camicerie Abbigliamento

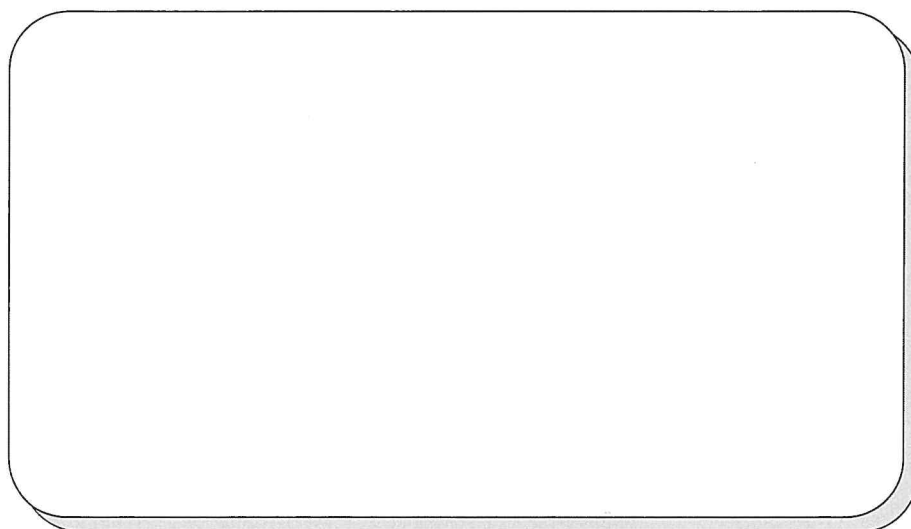
Via Casale, 23 - 24060 Torre de' Roveri (Bergamo) - ITALY

Telefono (+39) 35 580040 - Telefax (+39) 35 580920

web: www.maicaitalia.com

e-mail: info.maicaitalia@maicaitalia.com

AUTHORIZED AREA DEALER FOR ASSISTANCE



01 - GENERAL INFORMATION

FEATURES AND APPLICATION FIELD

The new UAM 03 unit was designed for shirt cuff and collar tacking. Material is sewn in lockstitches by the electronically controlled MAICA sewing machine supplied with a factory set program.

Automatic sewn cuff and collar trimming can be combined with sewing.

The control software can perform any type of stitch with automatic size regulation. The set of templates, constructed based on models and customer needs, can thus manage all sizes.

Cuff trimming is performed separately from the sewing phase: a different cut can be made with respect to the stitching.

RECOMMENDATIONS FOR USE

The Cuff and Collar sewing machine mod. UAM 03 should **only be used** for applications that require shirt cuff and collar sewing and trimming.

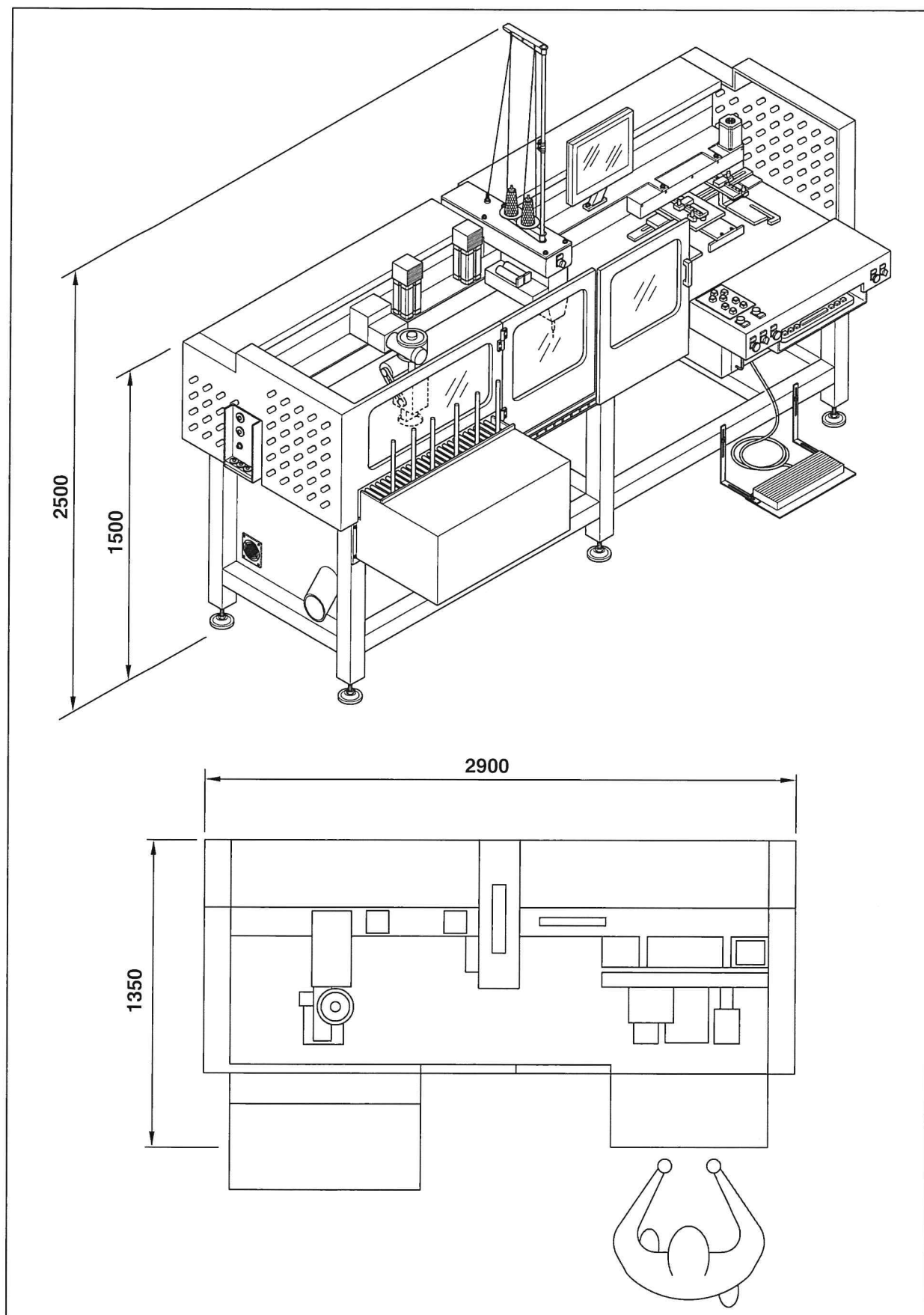
The presence of the  symbol indicates a risk and hazardous situation for the health of the operator, who must pay special attention to all warnings.

The machine is equipped with a sewing head and cutting group with moving needles and blade. It is recommended to pay particular attention when in the vicinity of these parts of the machine.

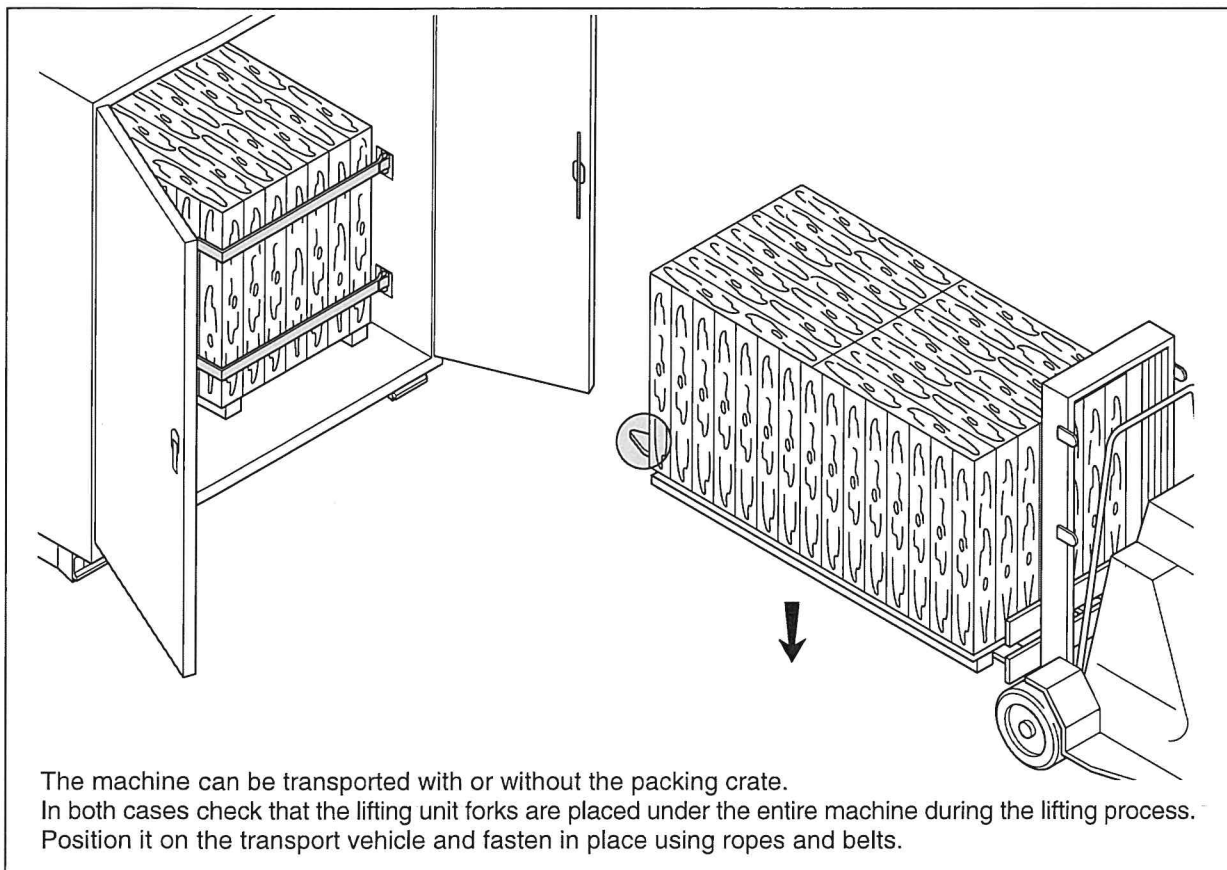
Always disconnect the machine from both the mains and the compressed air supply before commencing any tuning, replacement or maintenance operations.

Do not leave the machine exposed to weather elements such as rain, sun, etc.

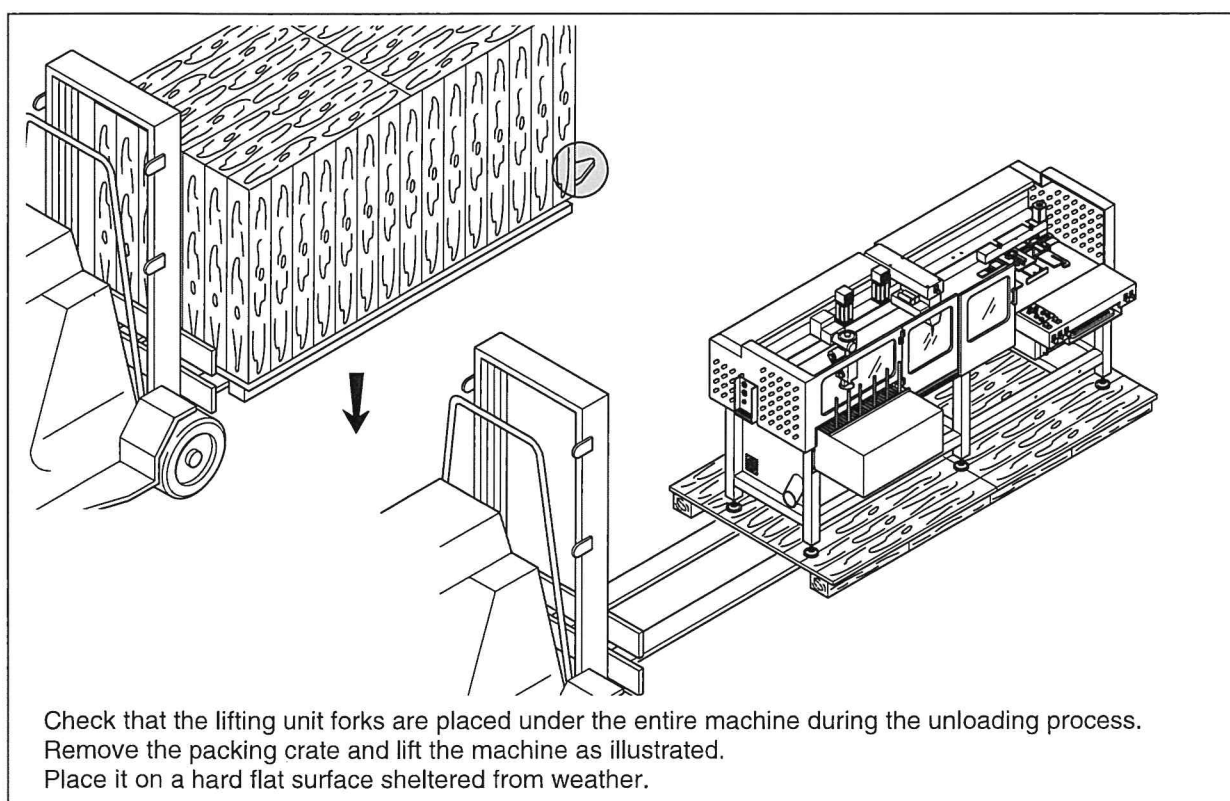
02 - CUFF AND COLLAR SEWING MACHINE MOD. UAM 03 TECHNICAL SPECIFICATIONS



03 - LIFTING AND TRANSPORT



04 - LOADING AND UNLOADING



05 - INSTALLATION

WARNING: Machine installation must be performed by specialized personnel only.

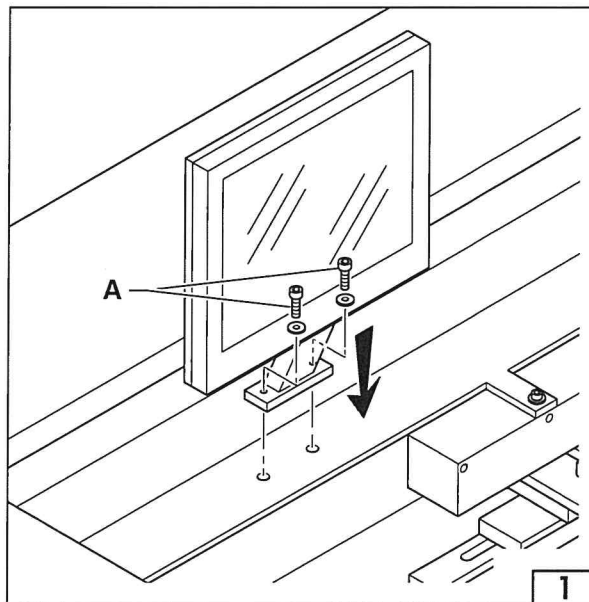
We disclaim all responsibility for damages resulting from installation not complying with these instructions or from connecting the machine to power and utility lines not satisfying the necessary requirements.

 If the machine is installed on a mezzanine, make sure that the slab can bear the load. The machine should not be installed in environments in which explosive materials or substances are present.

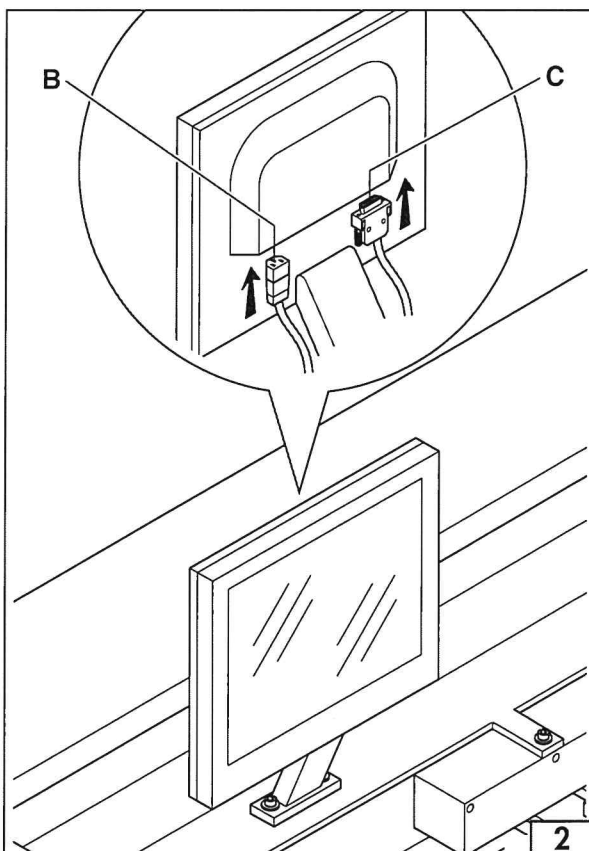
To facilitate its transport, the machine is delivered with the following parts dismantled:

- LCD monitor

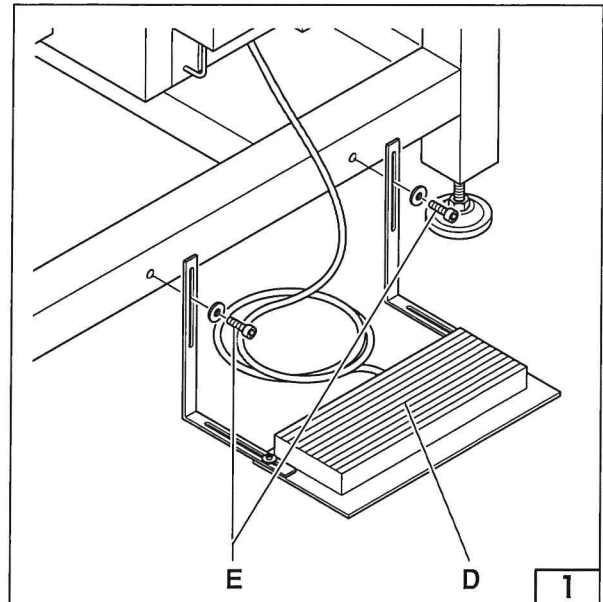
Position the monitor and secure it to the machine structure using screws "A" (fig. 1).



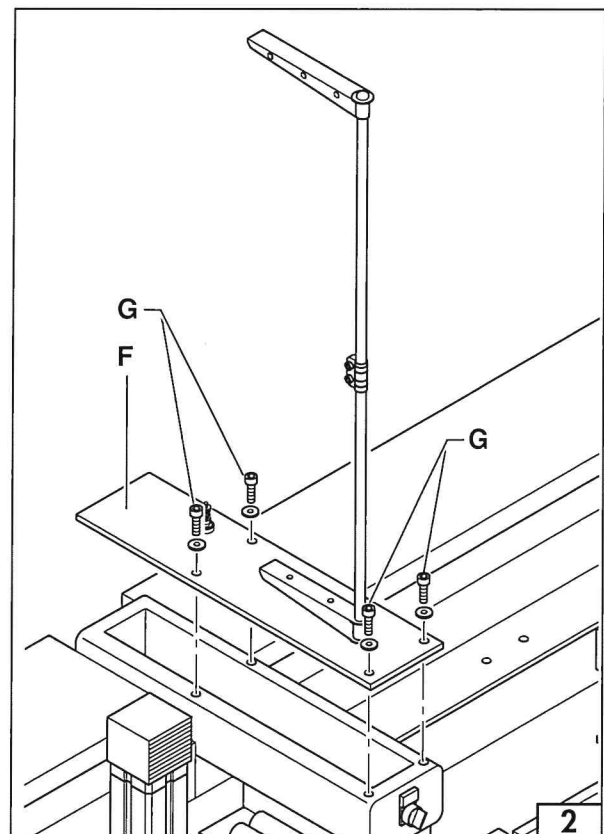
Connect power cord "B" and signal cord "C", from the computer, to the back of the monitor (fig. 2).



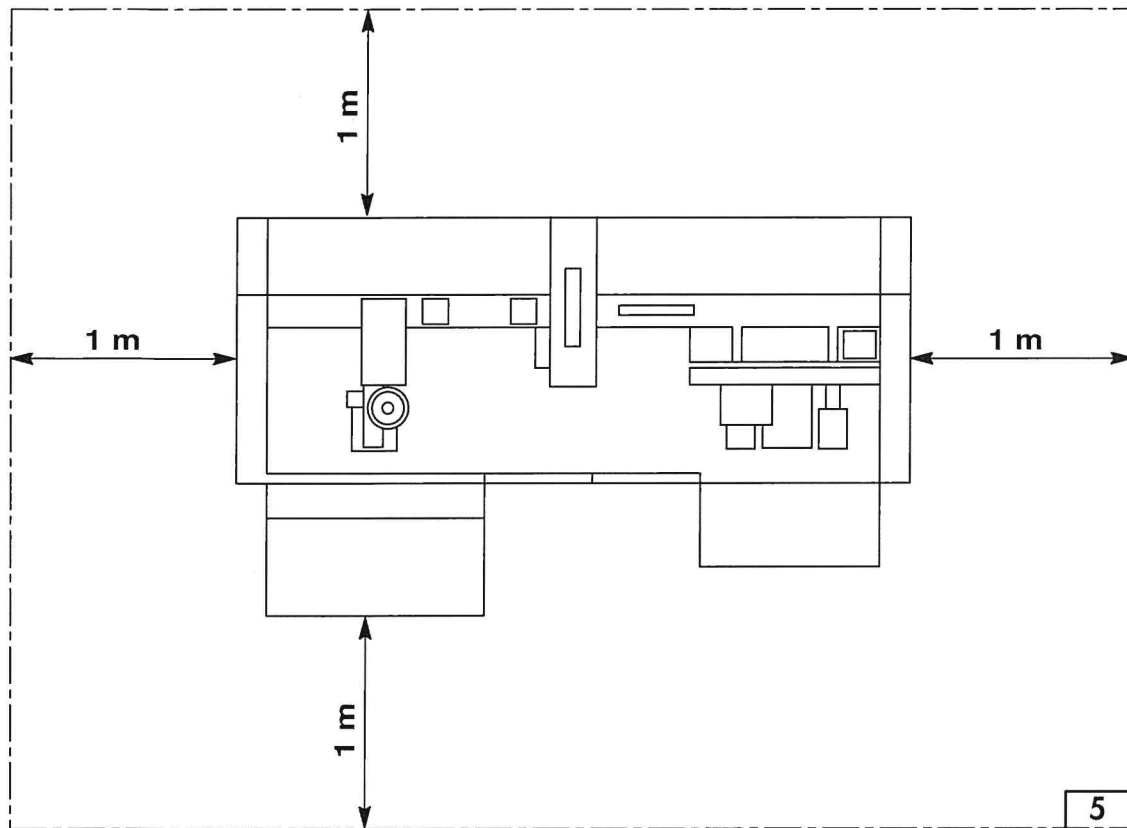
- Suction pedal:
Install the suction pedal "D" on the base using screws "E" (fig. 3).



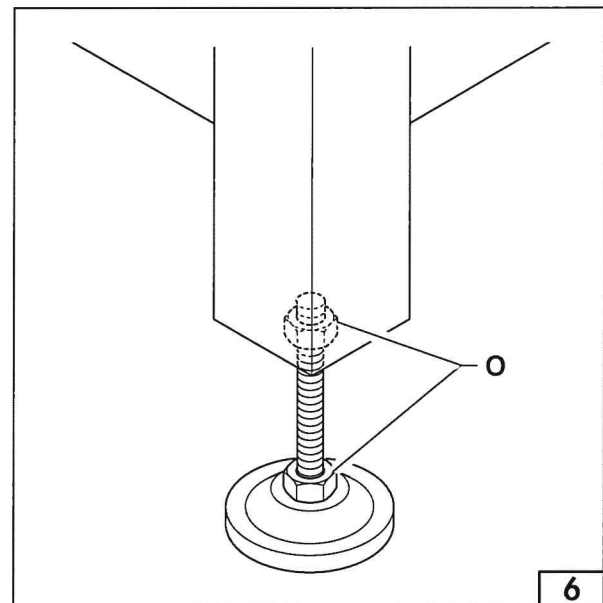
- Thread carrier:
Position the plate "F", complete with thread carriage support, and attach it to the sewing head by screwing in screws "G" (fig. 4).



To facilitate use and maintenance operations, keep the distances indicated in fig. 5.



The machine must be positioned on a flat, solid surface. To adjust, use nuts "O" (fig. 6) on the levelling feet.



ELECTRICAL CONNECTION

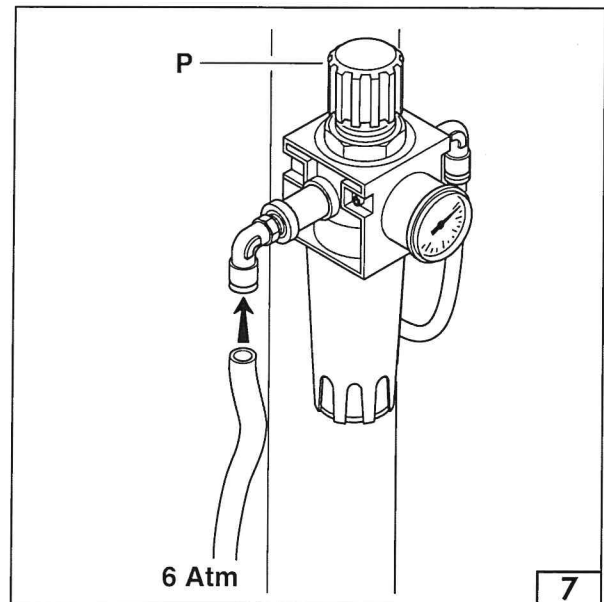
The machine is delivered complete with power supply cable.

- Connect the cable to a 380V-50Hz Three-phase power socket.
- Before installation, check the efficiency of the earthing system to which the machine is connected.
- Absorbed power is 5 kW.

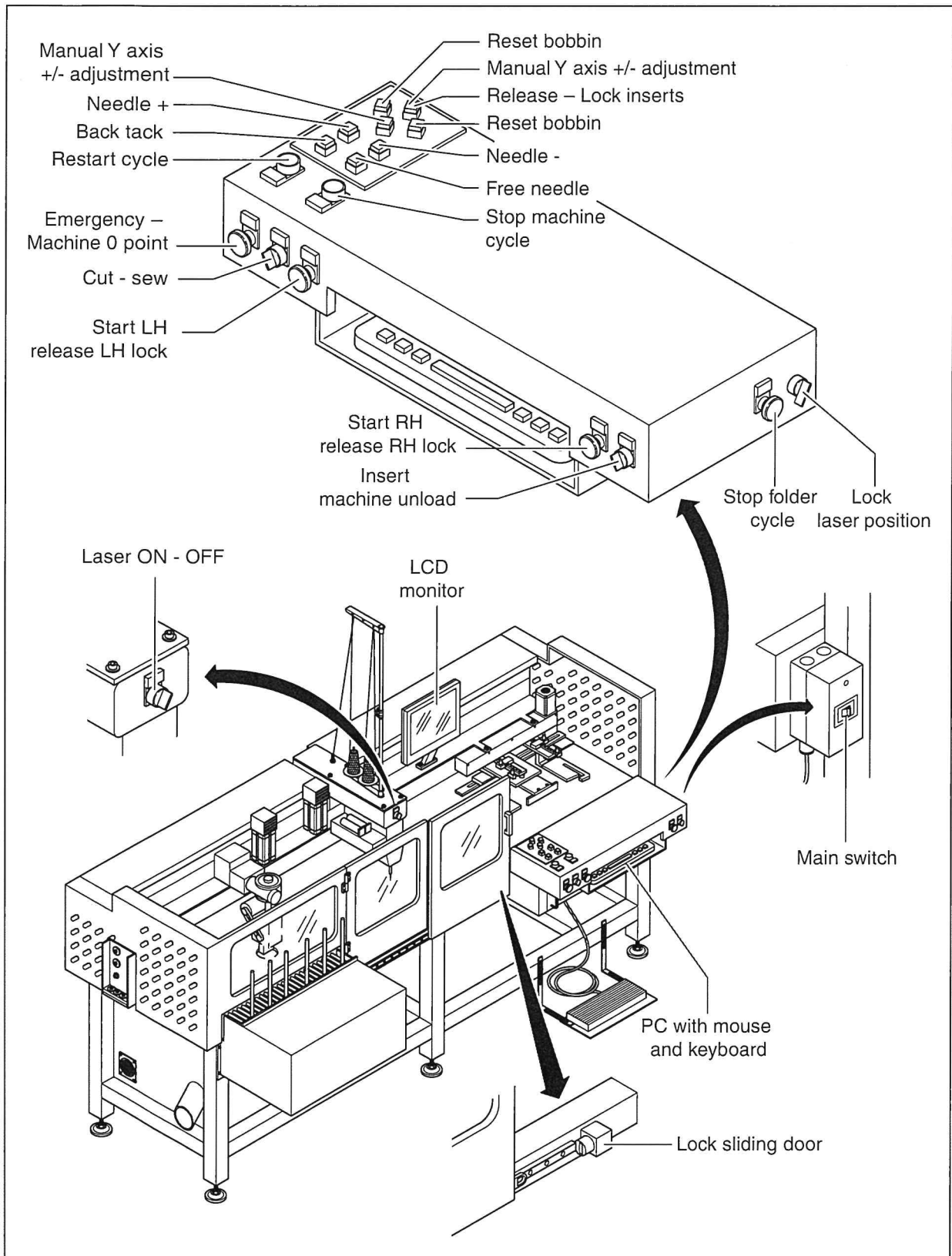
AIR PRESSURE CONNECTION

Connect the machine to a compressed air outlet making sure that the air flow is adequate to guarantee continuous operation at a pressure of 6 Atm.

Calibrate pressure regulator "P" to 6 Atm (fig. 7)



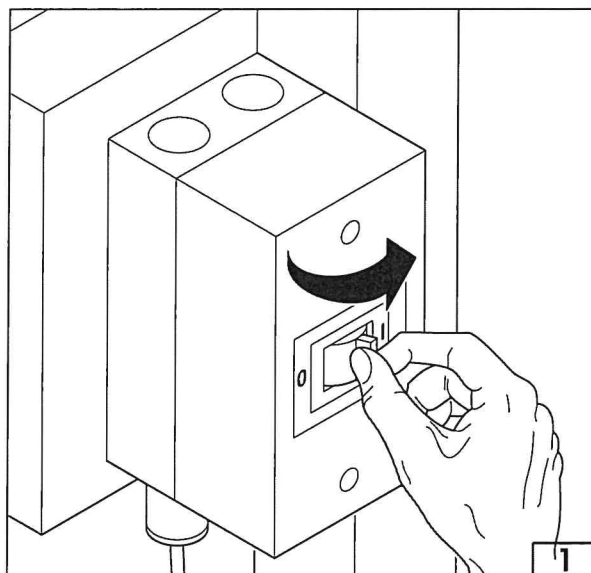
06 - MACHINE CONTROLS



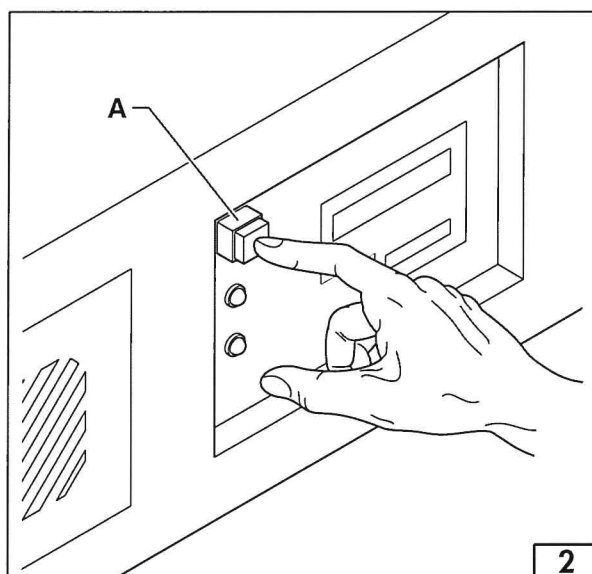
07 - USE

START-UP

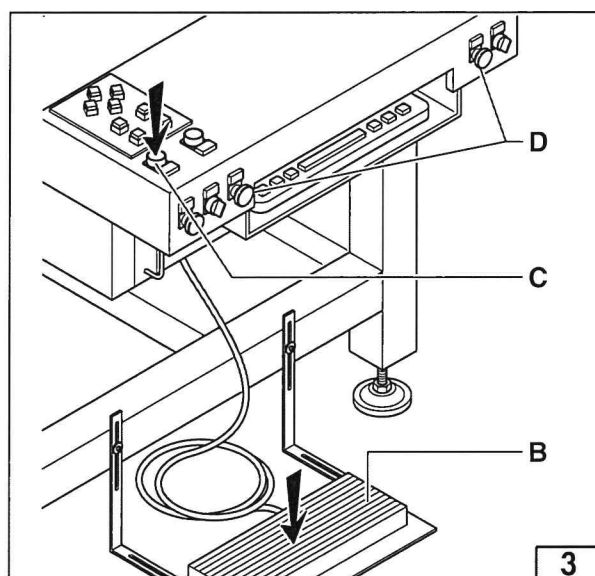
- Turn the main switch to position I (fig. 1).



- Press the red button "A" to turn on the computer (fig. 2).
- Open the air stopcock.



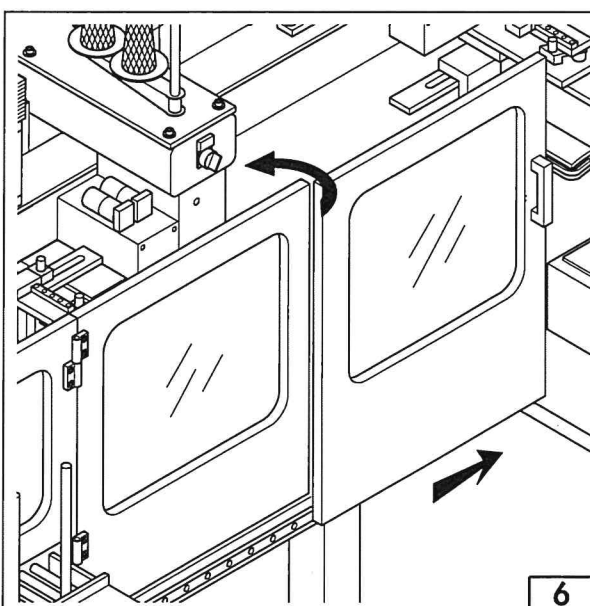
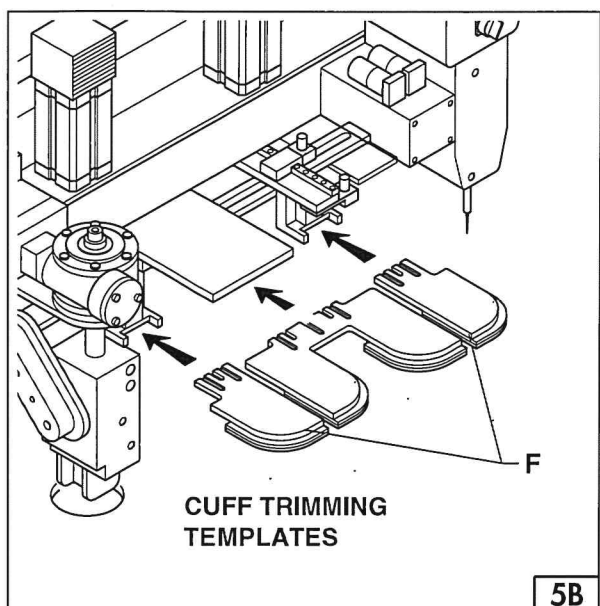
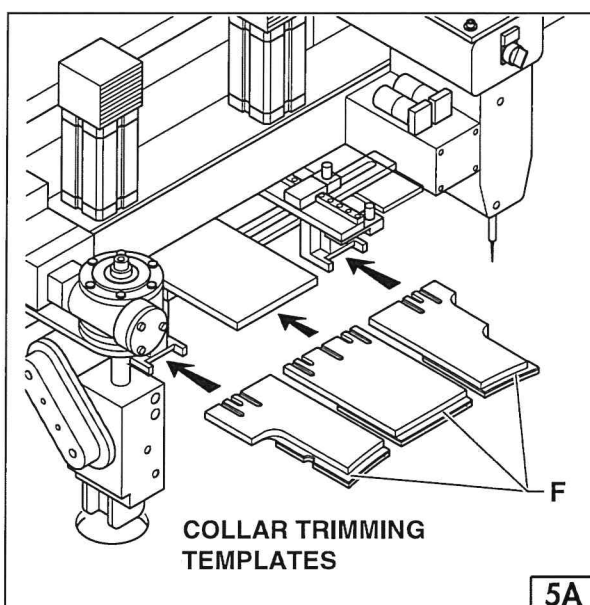
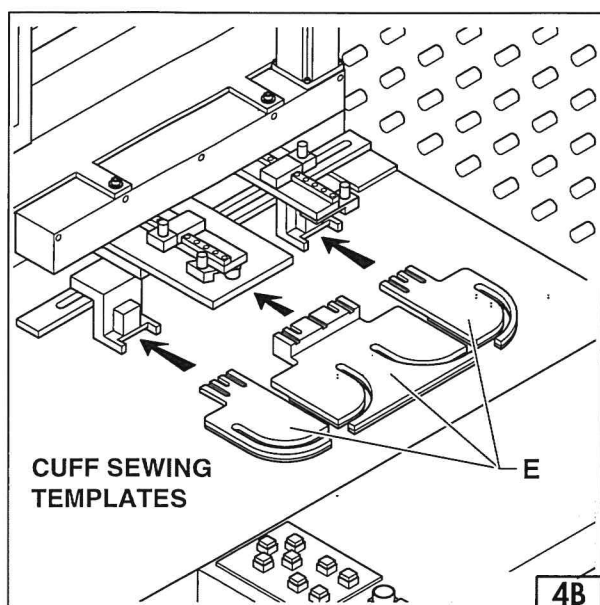
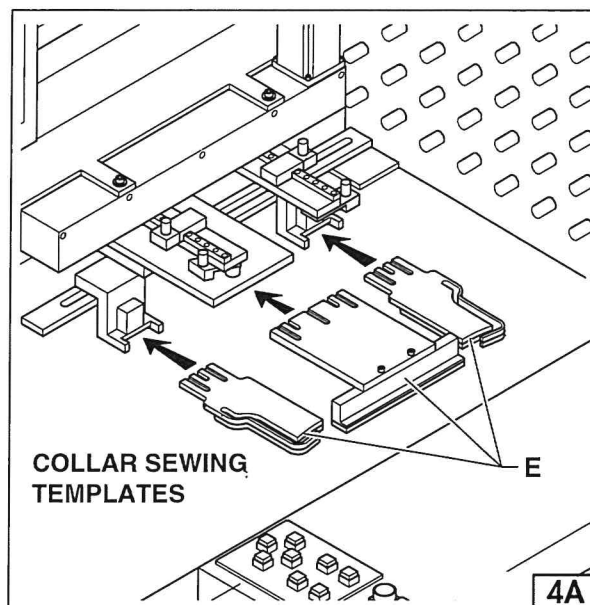
- Run "machine 0 point" search (fig. 3):
Press the suction pedal "B" and press the Restart cycle button "C".
Simultaneously press the Start RH and LH buttons "D".
In sequence, the sewing carriage, needle, trimmer and cutting carriage move to point 0.



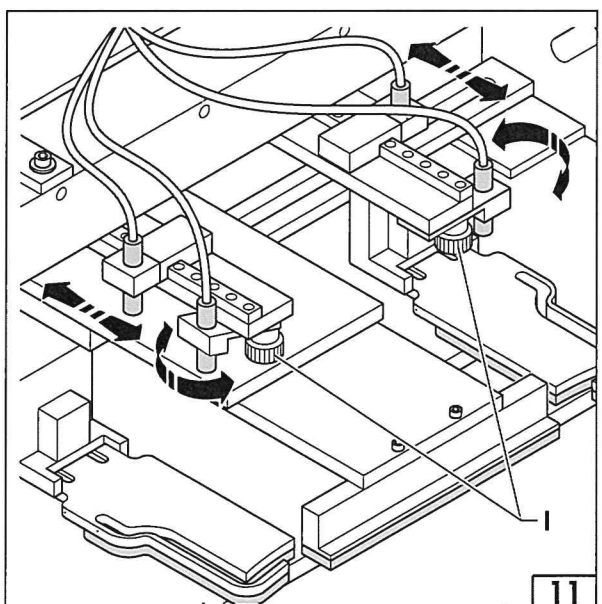
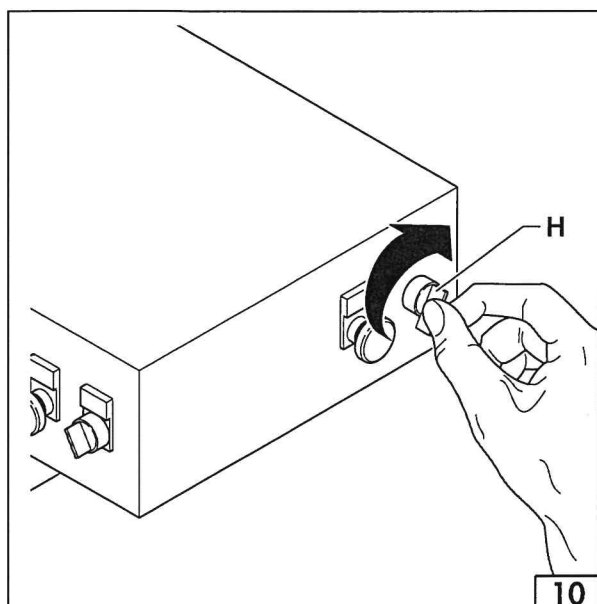
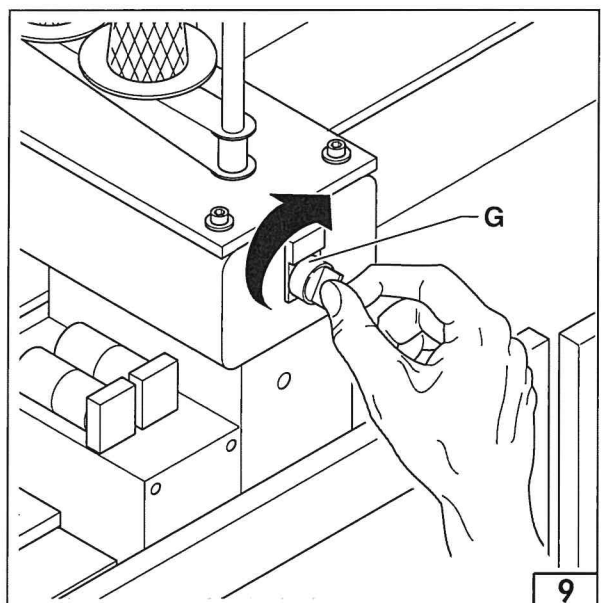
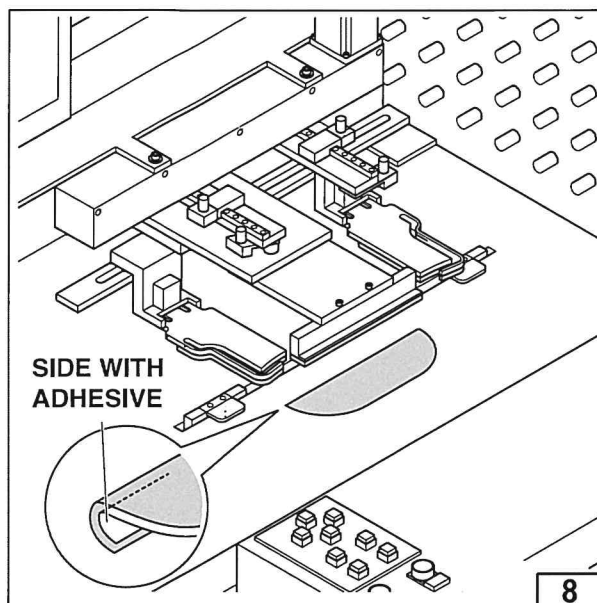
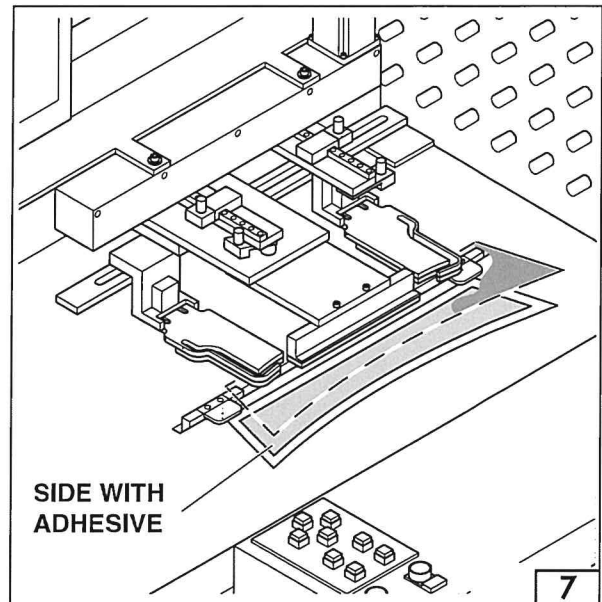
- Based on the cuff or collar model, insert the 3 templates "E" (fig. 4A – 4B) on the guides on the sewing carriage (see paragraph changing templates).

Similarly, install the 3 templates "F" on the cutting carriage (fig. 5A – 5B).

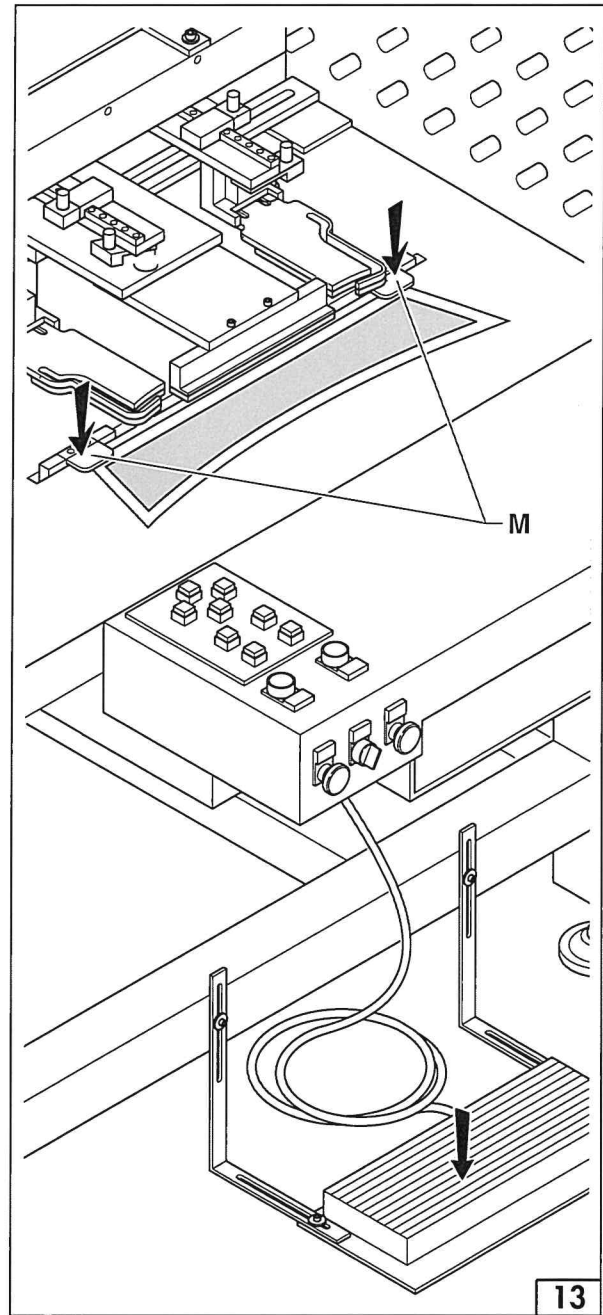
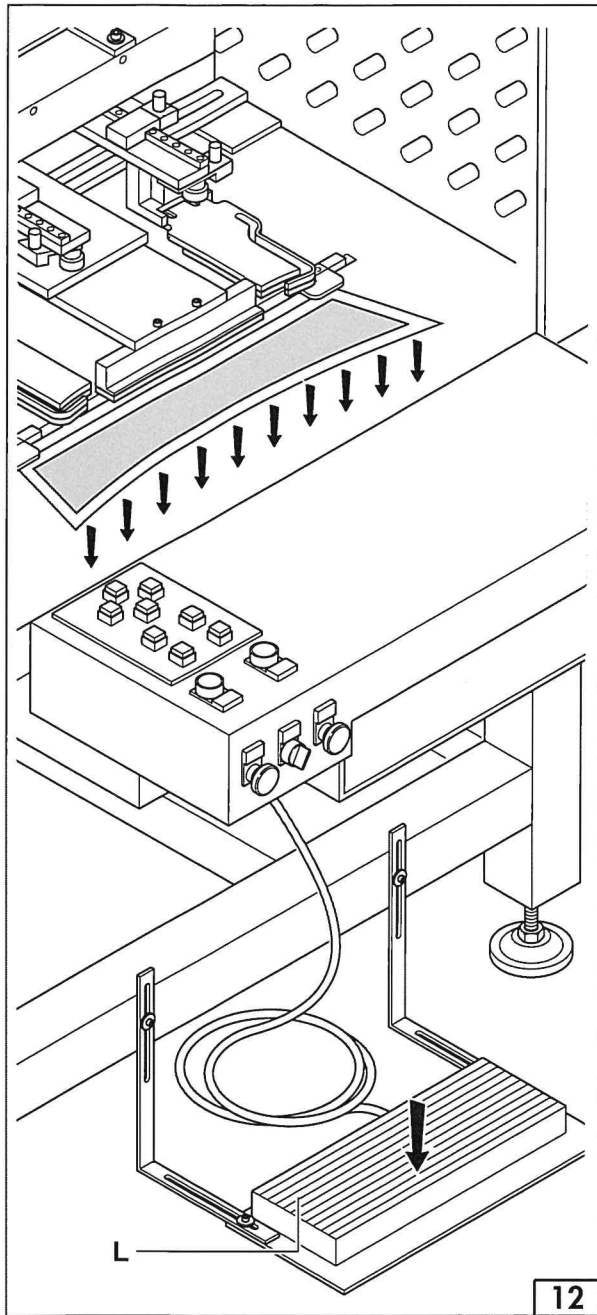
- Select the sewing program from the memory or load it from a floppy disk. Refer to the specific programming manual for instructions on these operations.
- Check the inserted size (see programming manual).
- Thread the sewing machine.
- Make sure doors are closed (fig. 6)



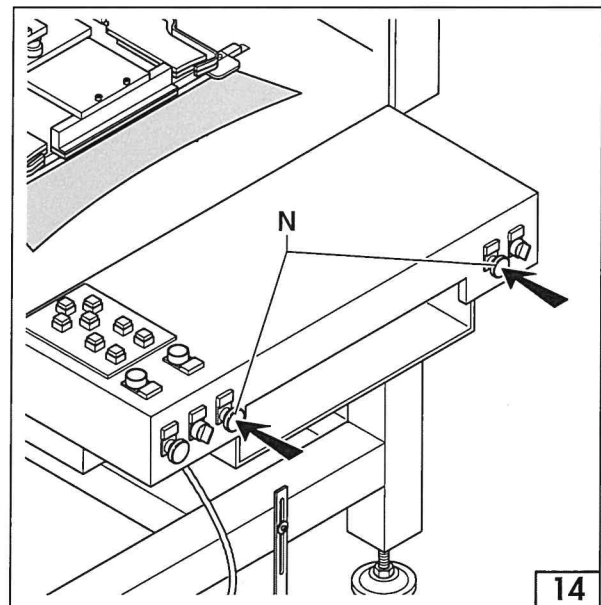
- Position the collar or cuff according to the process; for collars, first position the part with the adhesive as shown in fig. 7 while cuffs should be positioned as illustrated in fig. 8.
- Lasers are installed to facilitate correct collar or cuff positioning. - Turn on lasers using selector "G" (fig. 9).
- If necessary, adjust lasers using the laser position lock selector "H" (fig. 10) to move to the required point (fig. 11). For front lasers, loosen hand wheel "I". When finished, lock lasers by rotating selector "H".



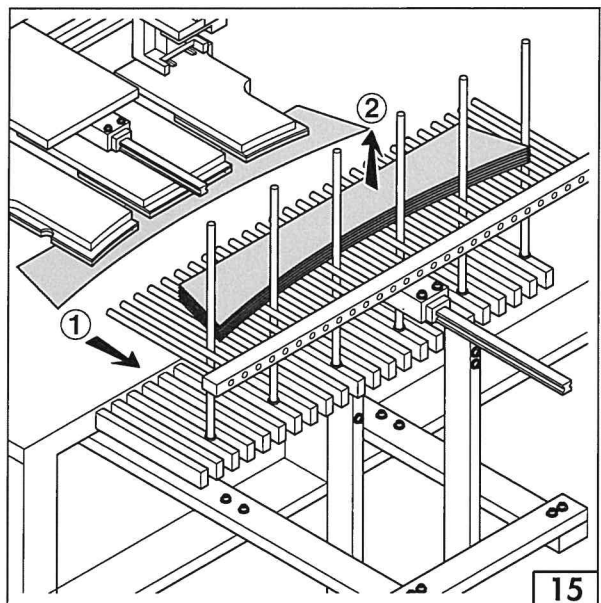
- After positioning, press pedal "L" (fig. 12). Fabric is suctioned against the work surface.
- Press the pedal again to lower the clamp "M" (fig. 13) which further locks the collar or cuff in place.



- Simultaneously press the Start RH and LH buttons "N" (fig. 14) to start the work cycle.
- In sequence, the sewing carriage moves first and positions itself on the fabric with slight suction; the clamps lift and the carriage moves under the sewing machine which, following the template, sews.
- In the second phase the fabric is moved to a central suction area; the sewing carriage deposits the fabric and returns to retrieve a new piece.
- A second carriage simultaneously moves the fabric to the trimming area.



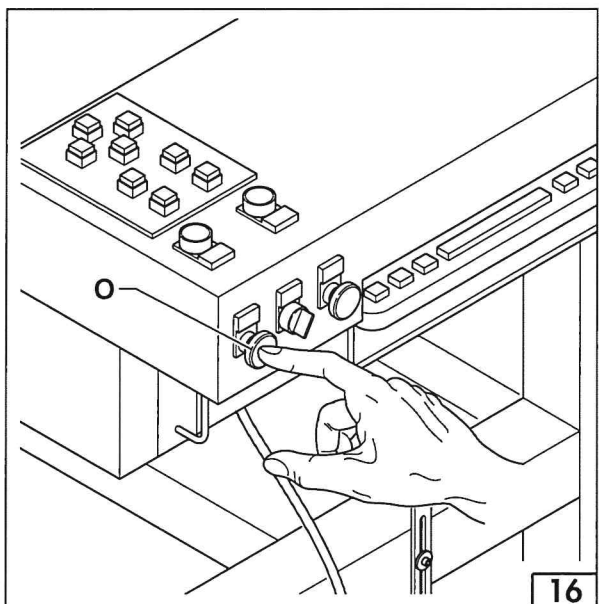
- After trimming, finished pieces are placed on the unloader and automatically stacked (fig. 15) reader to be retrieved by the operator.



Any anomalies are signalled by alarms displayed on the screen.

In case of need, the machine can be stopped immediately by pressing emergency button "O" (fig. 16).

After an emergency stop, run the "machine 0 point" search again as described at the beginning of this paragraph.



THREADING THE MACHINE

The sewing is a knotted stitch type.

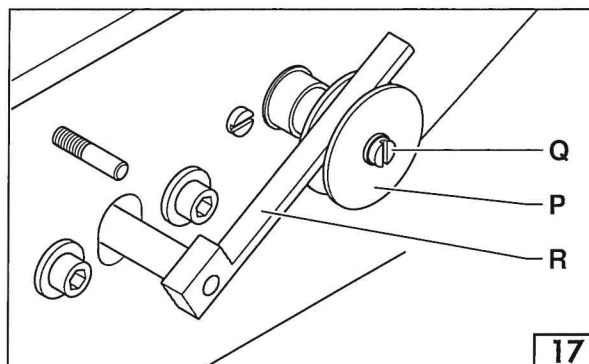
The threading is performed as you would on any normal sewing machine (where necessary please refer to the relative manual).

When threading it is advisable to press emergency pushbutton, so that any movement of the sewing foot and relative needle is disabled.

BOBBIN WINDING

There is a device for automatic bobbin winding on the right-hand side of the sewing machine (fig.17).

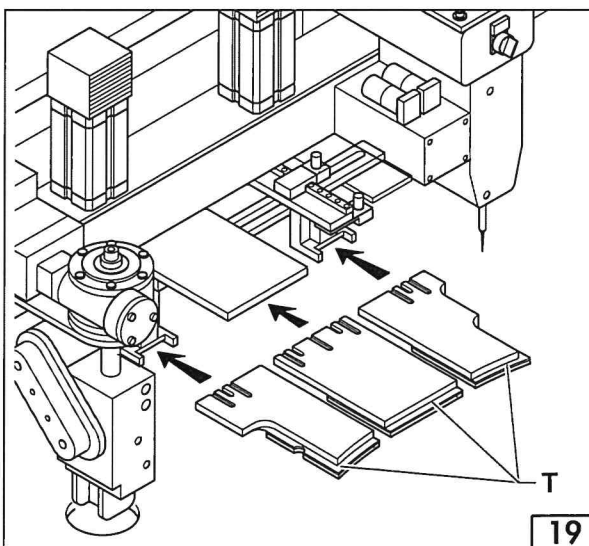
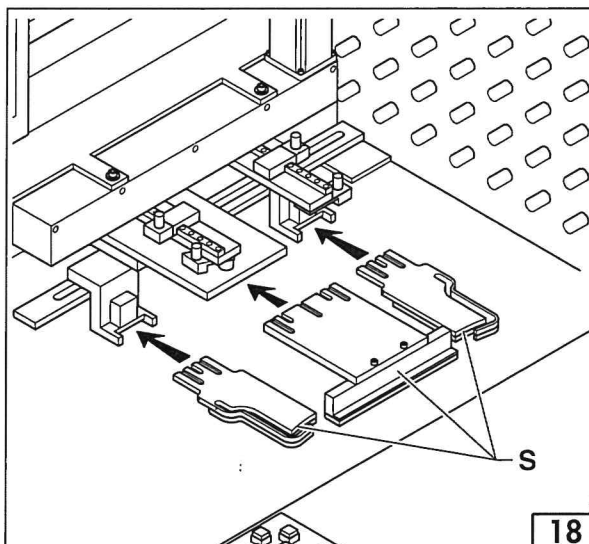
- Insert the empty bobbin "P" on spindle "Q". Wind two or three turns of thread manually.
- Press lever "R" against the winding roller.
- Insert the wound bobbin in its housing and press the  bobbin reset button.



CHANGING TEMPLATES

Each collar or cuff model requires a specific set of templates which is constructed according to customer request. To replace them, open the "Change Template" menu page (see programming manual).

- Click buttons   with the mouse
- Press the  "Release/Lock inserts" button
- Remove the templates in use and insert the 3 templates "S" (fig. 18) and "T" (fig. 19) on the guides on the sewing and cutting carriages respectively.
- Press the  "Release/Lock inserts" button again and make sure templates are correctly installed.



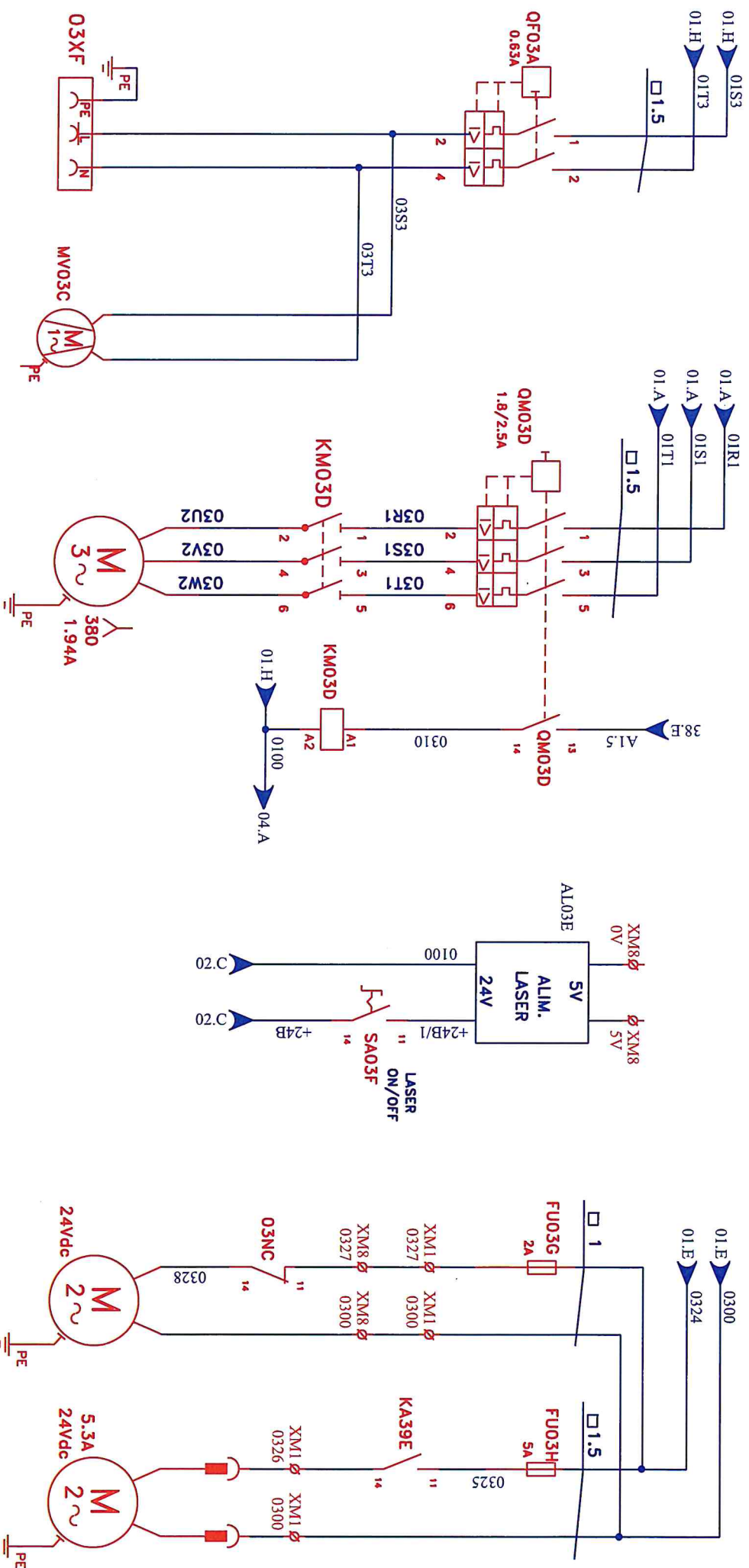
AUSILIARI
INSERITI

Commissa UAM03

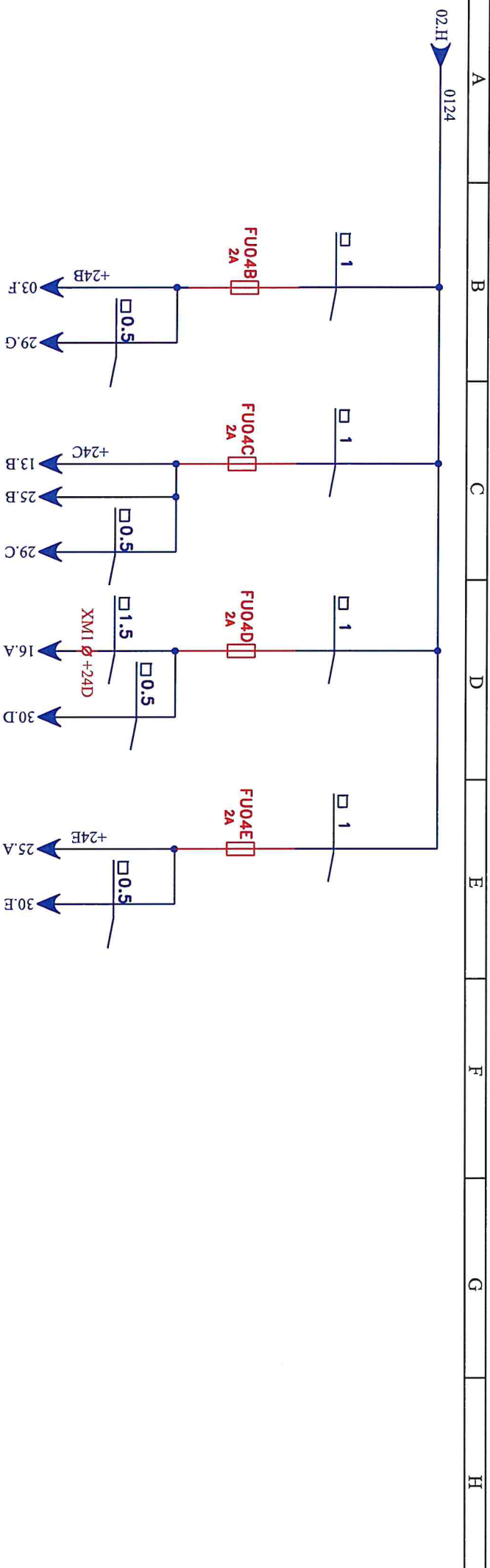
- CIRCUITO EMERGENZA -

<i>Data</i>	24/03/2014 18.19	<i>Scala</i>	1:1

Via Casale,23

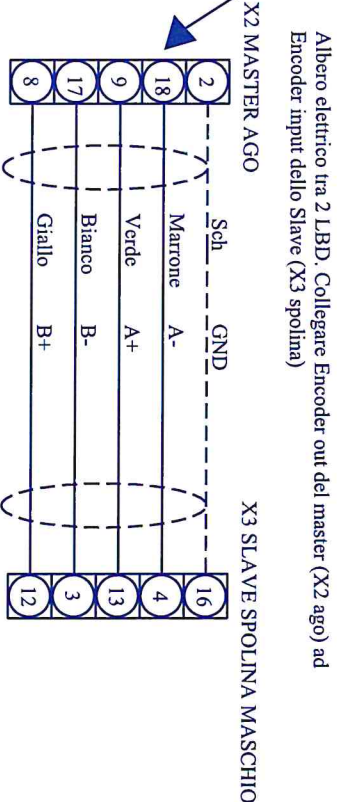
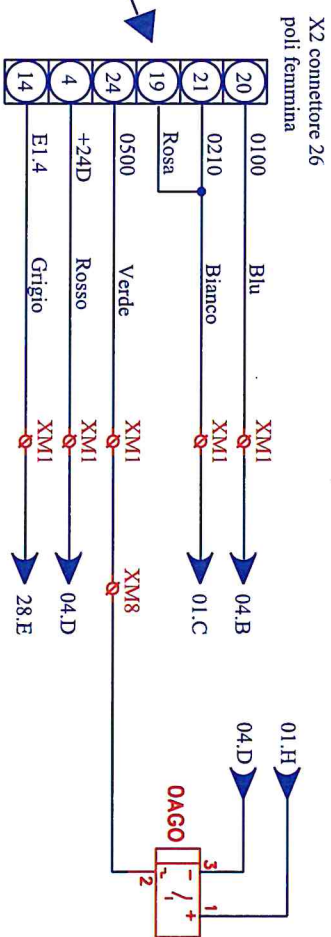
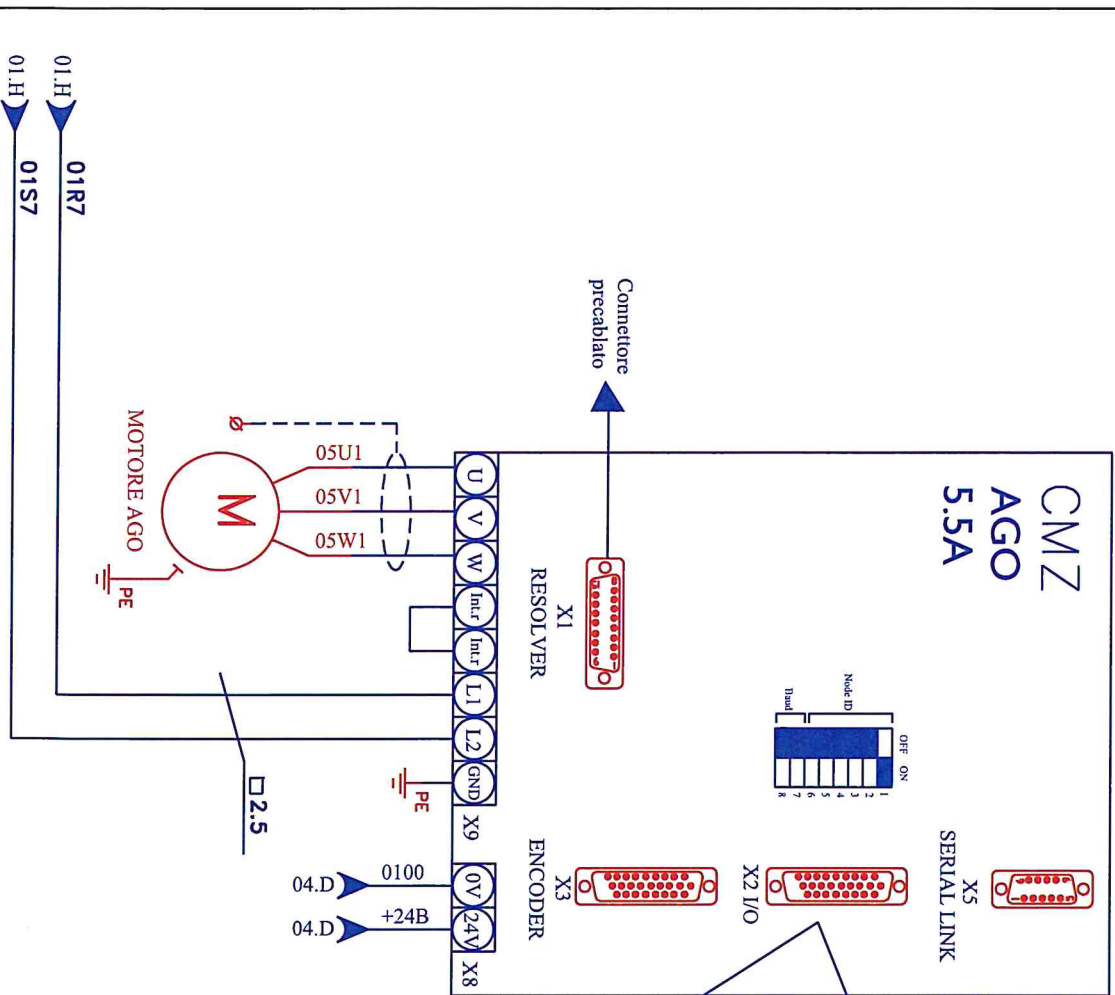


Cliente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI	Pag. 03 di 50		Firma	M.G.	M.A.I.C.A. Srl Torre De Roveri (BG) Via Casale,23		
			Cod.	Cad	Tagliacuci_Pg03.DWG	Vers.		0.0	
Commessa	UAM03		- POTENZA ASPIRAZIONE - - E NASTRO SCARICO-		Data	04/06/2013 11.30		Scala	1:1

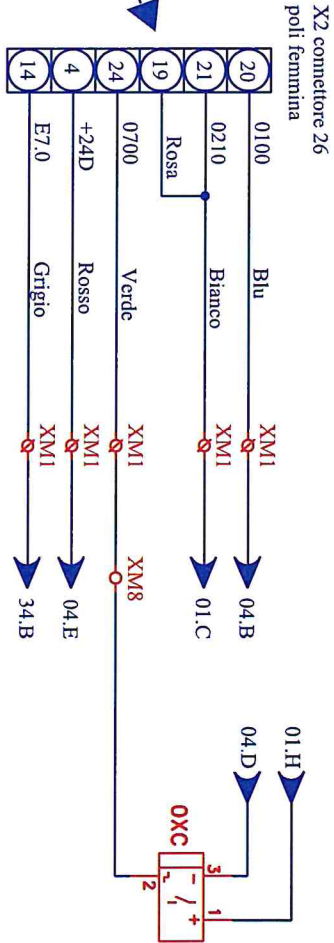
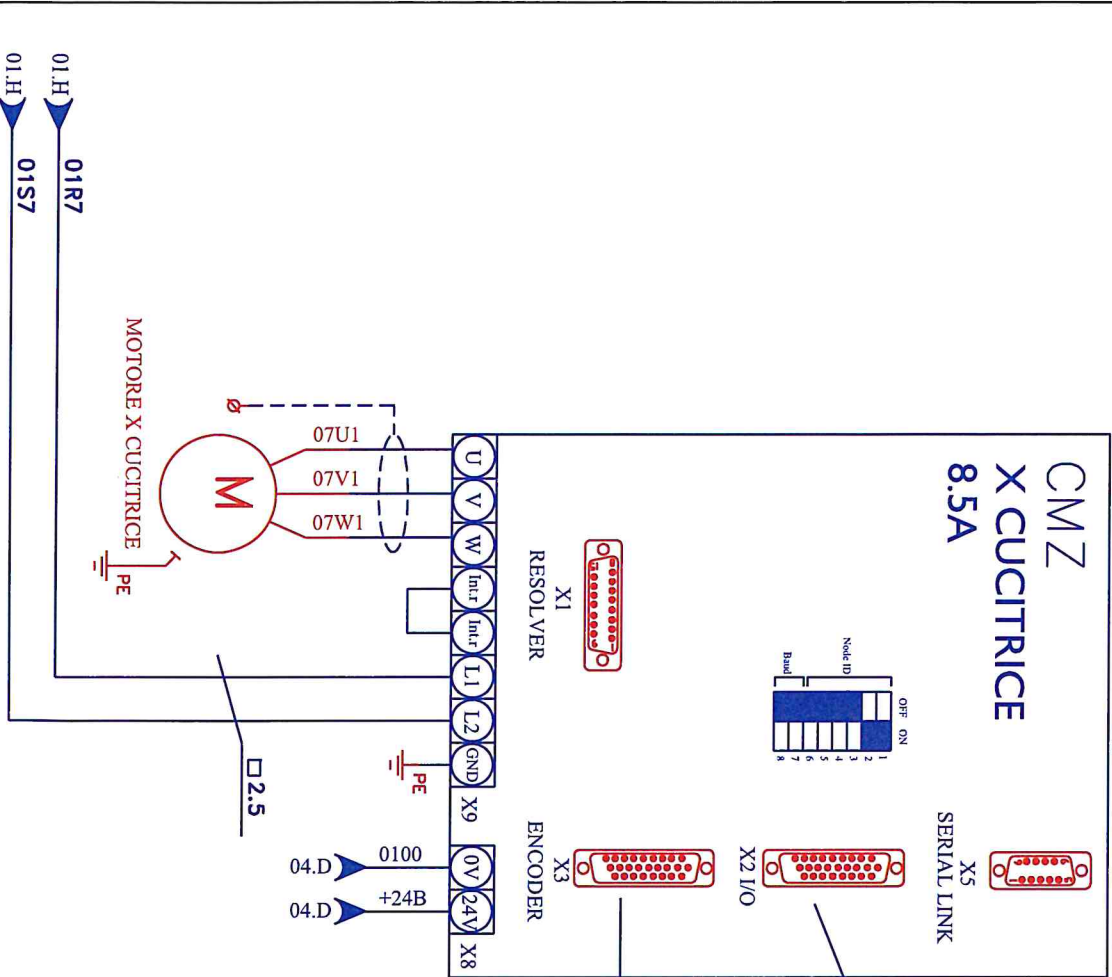


ALIM. 24Vdc LASER
ALIM. 24Vdc E NODI CAN
ALIM. 24Vdc INGRESSI
ALIM. 24Vdc USCITE

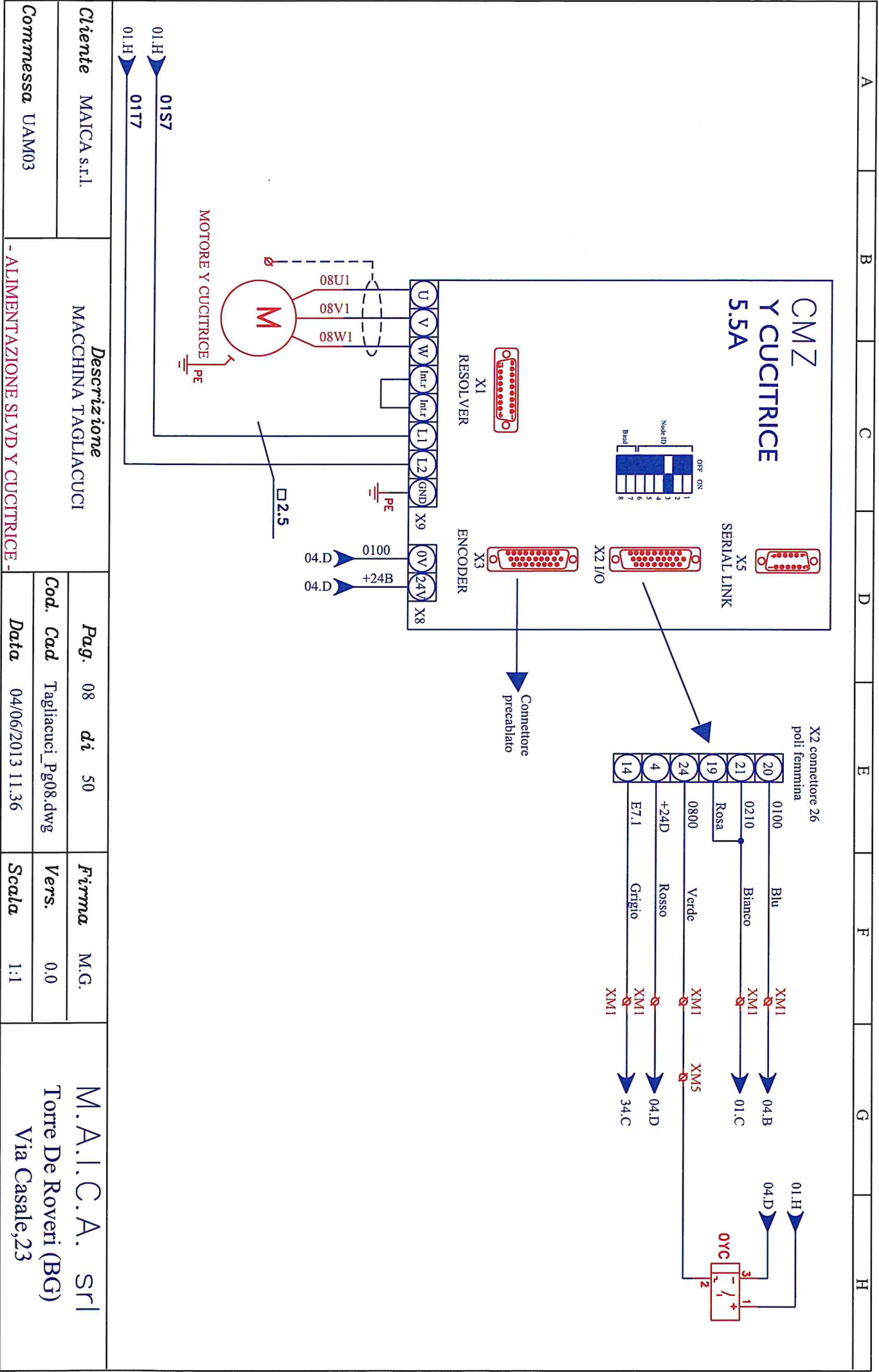
Ciente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI				Pag. 04 di 50		Firma M.G.		M.A.I.C.A. Srl Torre De Roveri (BG) Via Casale, 23	
Commessa	UAM03										
		- FUSIBILI 24VDC -				Cod. Cad	Tagliacuci_Pg04.DWG	Vers.	0.0		
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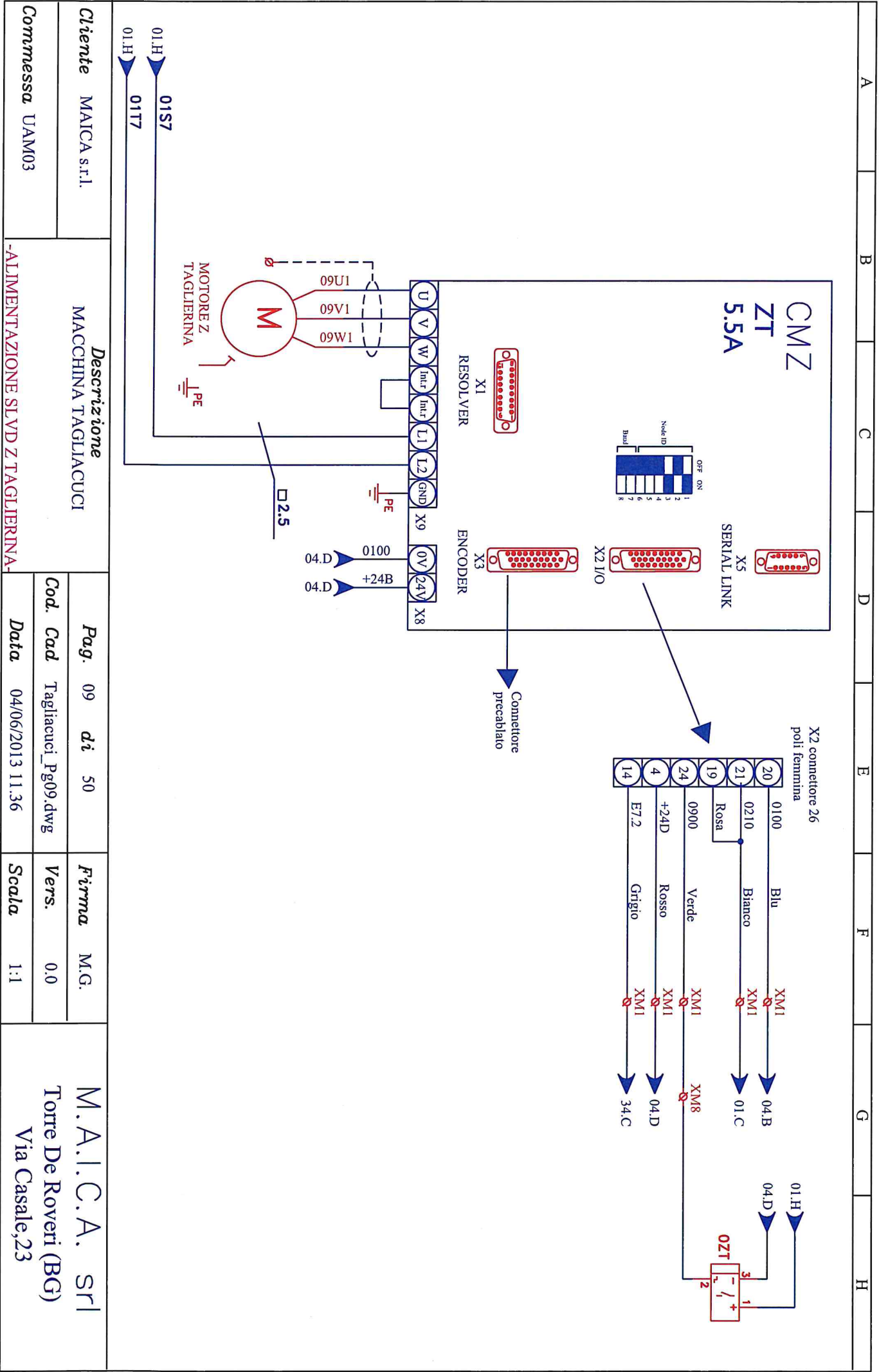


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Cliente MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI		M.A.I.C.A. S.r.l Torre De Roveri (BG) Via Casale,23	
	Commissa UAM03	- ALIMENTAZIONE SLVD X CUCITRICE -		
	Pag. 07	di 50	Firma M.G.	
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	Data 04/06/2013 11.35	Scala 1:1		

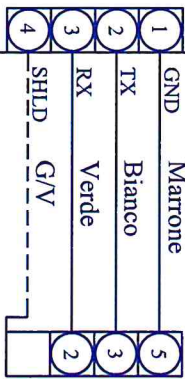
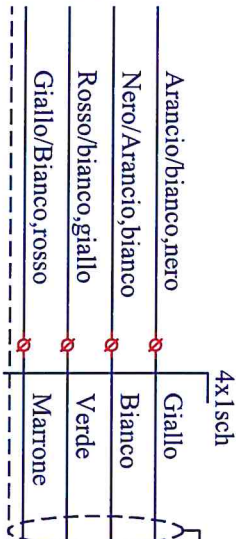
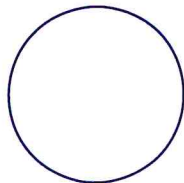
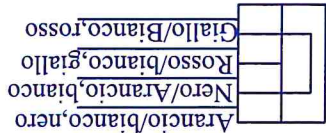




[illegible]

[illegible]

Connettore lato motore

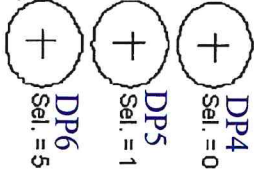


Connettore 9
poli maschio
FCT241 RS232

Settaggi switch azionamento laser

DP1		DP2	
Corrente motore	Riservato	1	OFF
1	OFF	2	OFF
2	OFF	3	OFF
3	OFF	4	OFF
4	OFF	5	OFF
5	OFF	6	OFF
6	OFF	7	ON
7	ON	8	ON

DP3	
Riservato	1
1	OFF
2	OFF
3	OFF
4	OFF
5	OFF
6	ON

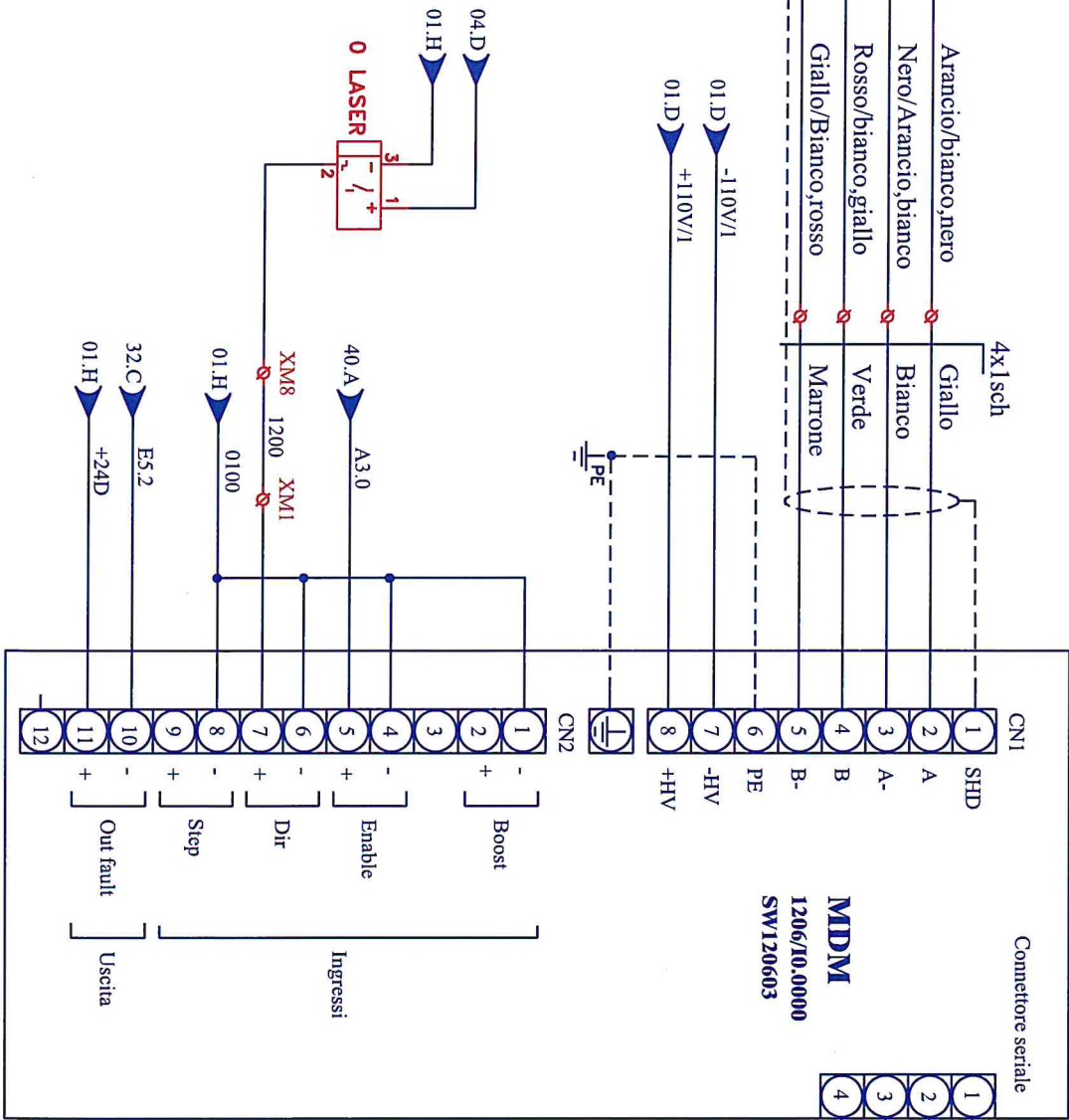


Ciente MAICA s.r.l.

Commessa UAM03

Descrizione
MACCHINA TAGLIACUCI

COLLEGAMENTO AZIONAMENTO
LASER REGOLAZIONE



Pag. 12 di 50

Cod. Cad Tagliacuci_Pg12.dwg

Data 04/06/2013 12.15

Firma M.G.

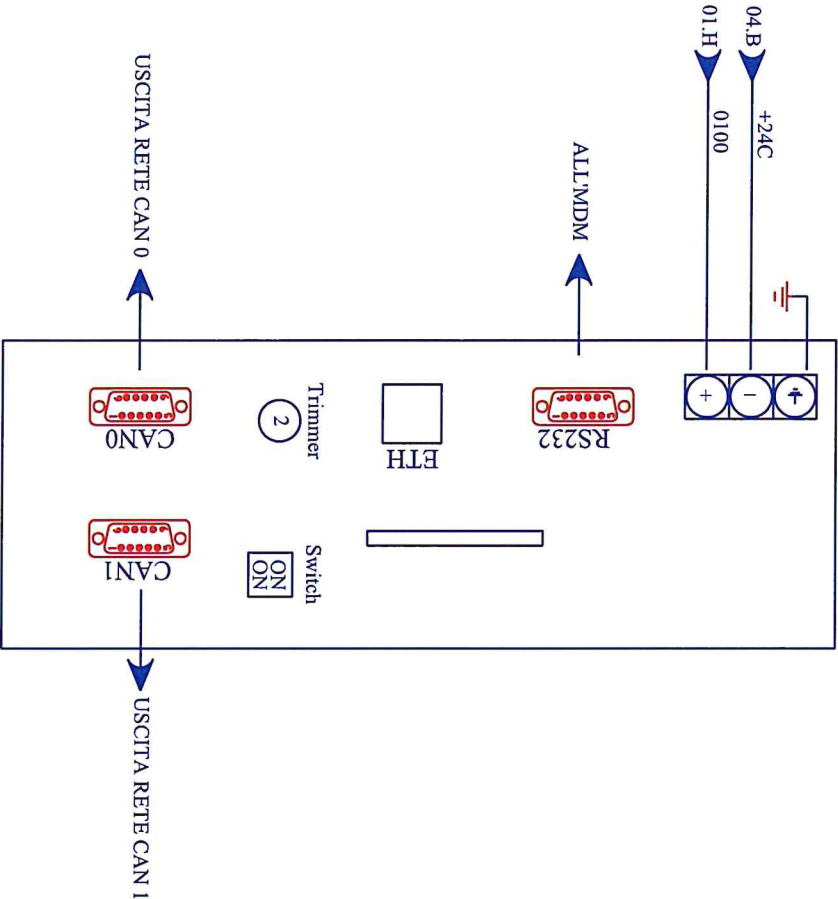
Vers. 0.0

Scala 1:1

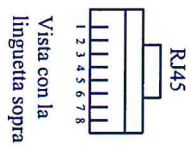
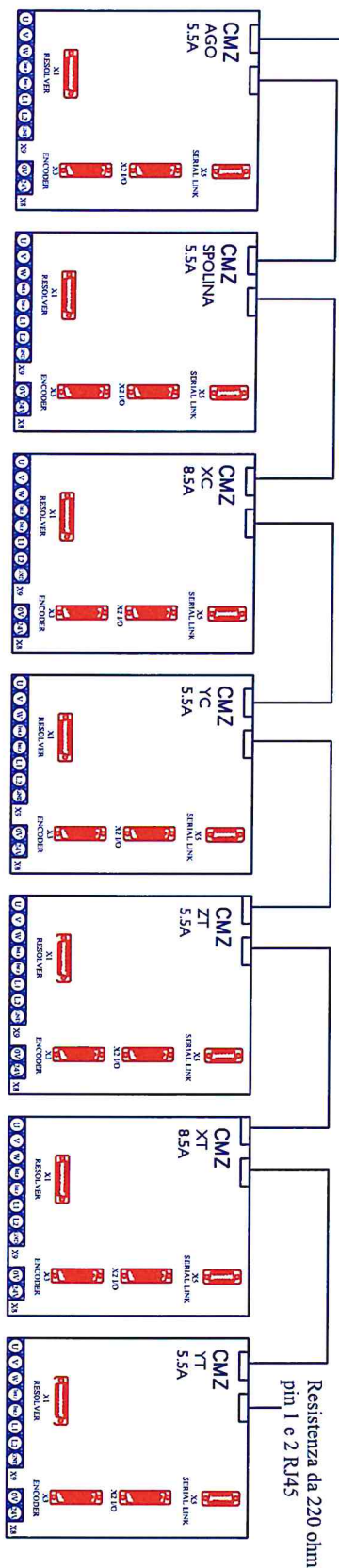
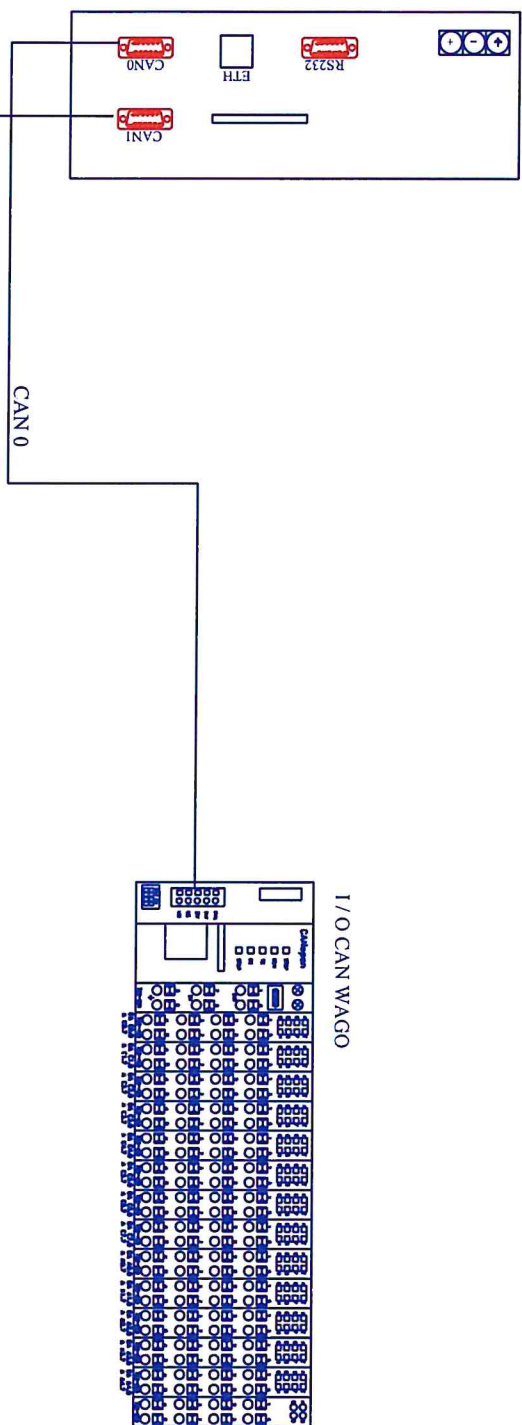
M.A.I.C.A. Srl
Torre De Roveri (BG)
Via Casale,23

A	B	C	D	E	F	G	H
---	---	---	---	---	---	---	---

Sistema controllore FCT 241



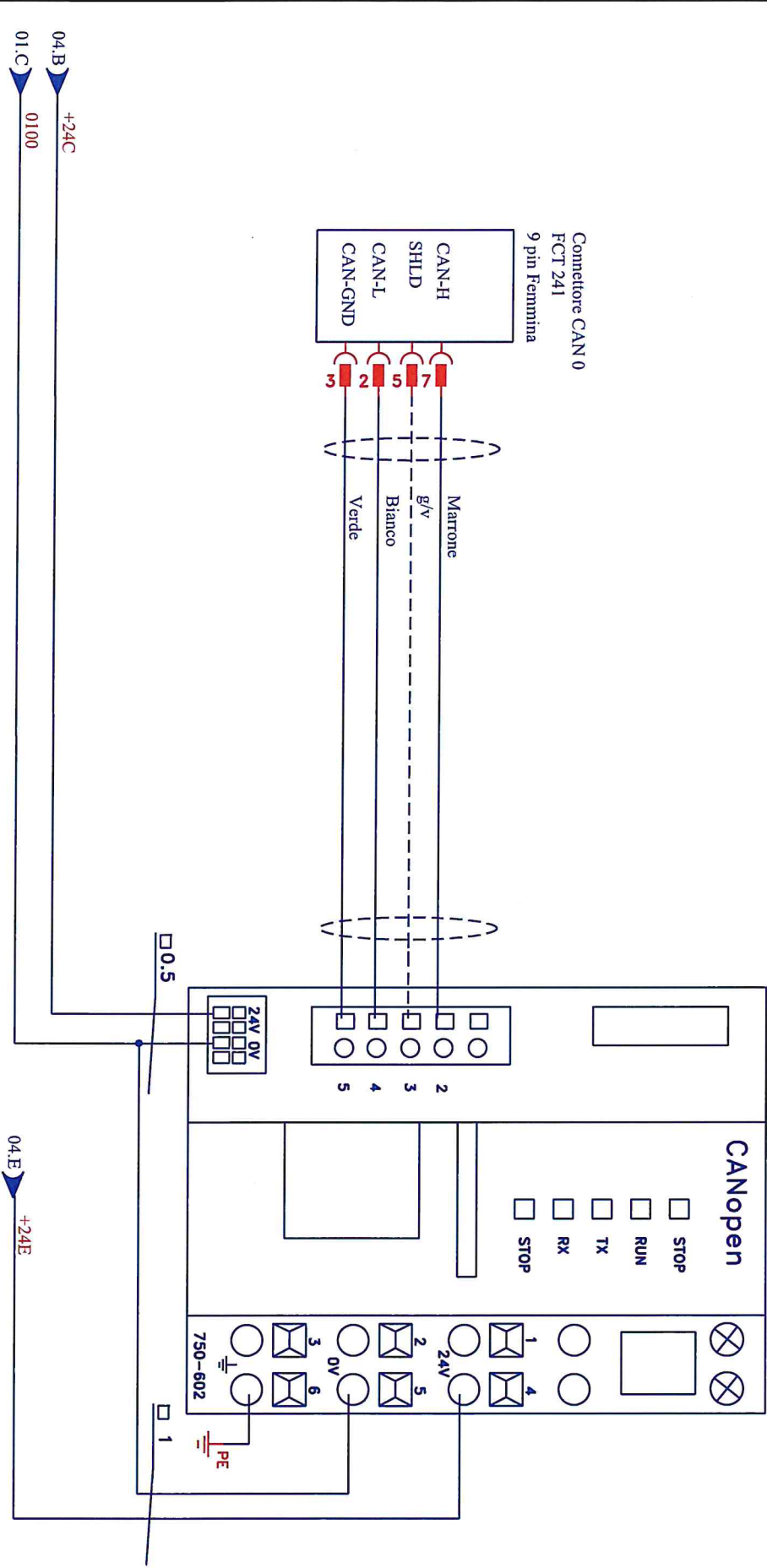
Ciente	MAICA s.r.l.	Descrizione				M.A.I.C.A. Srl				
		MACCHINA TAGLIACUCI				Torre De Roveri (BG)				
Commessa	UAM03									Via Casale,23



Cliente MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI		Pag. 14 di 50		Firma M.G.		M.A.I.C.A. S.r.l Torre De Roveri (BG) Via Casale,23
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	Commessa UAM03	- RETE CAN -		Data	04/06/2013 11.40	Scala	1:1

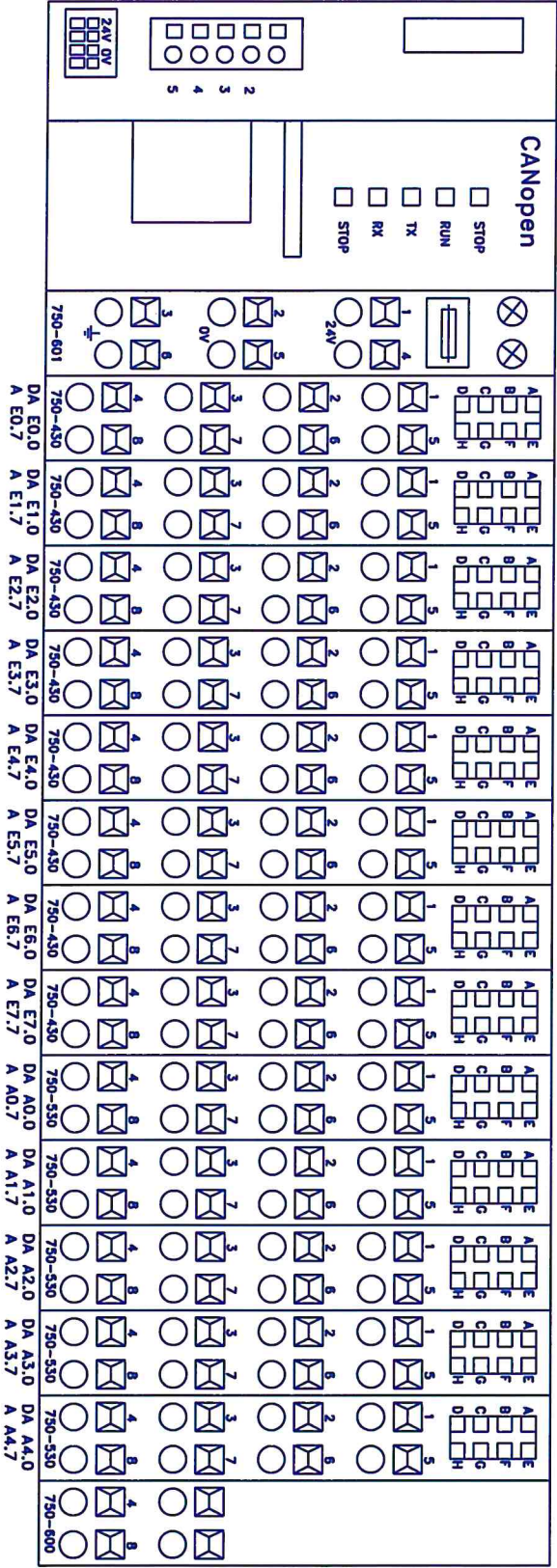
A	B	C	D	E	F	G	H
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NODO CAN MODULO ALIM.

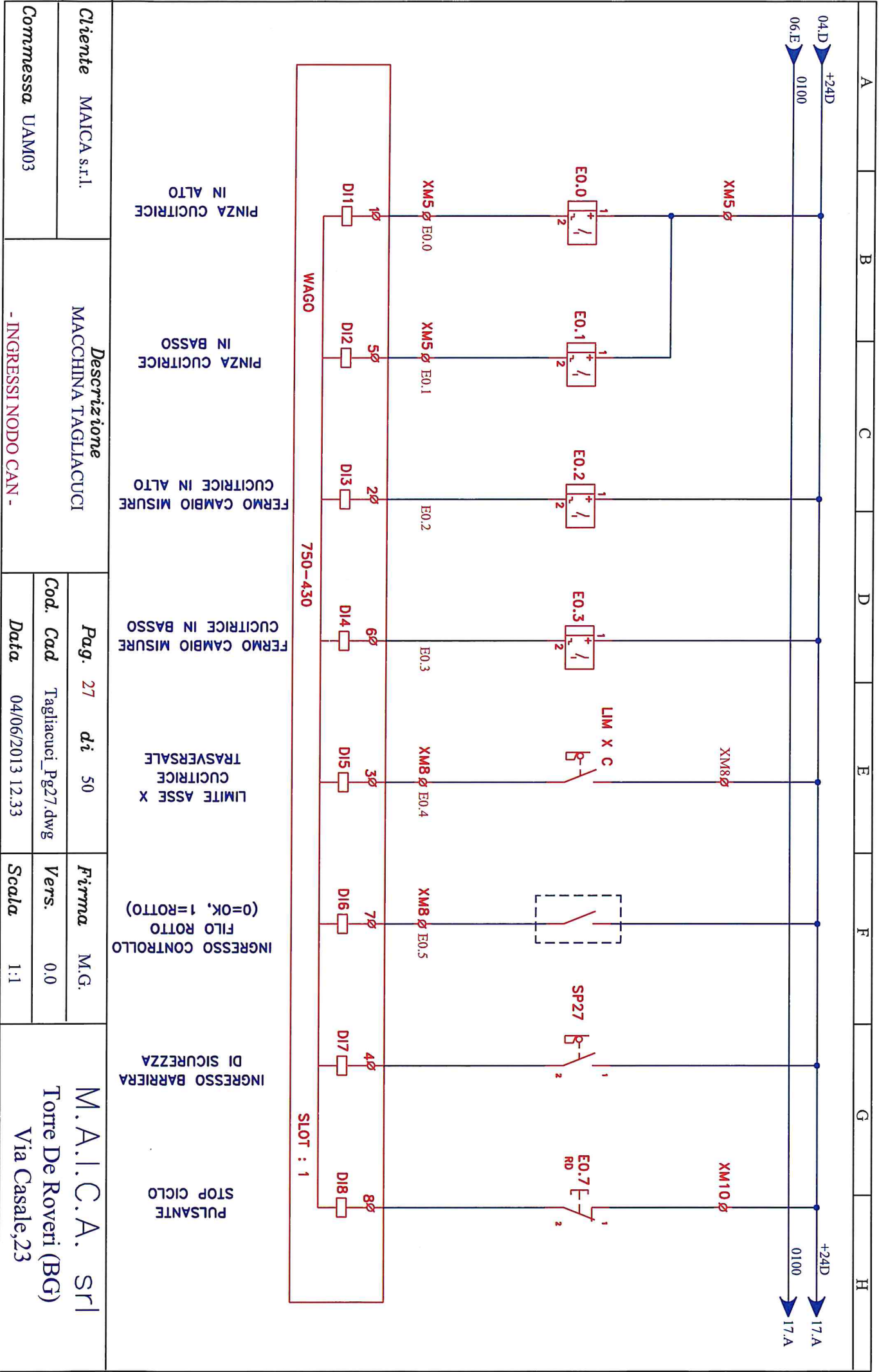


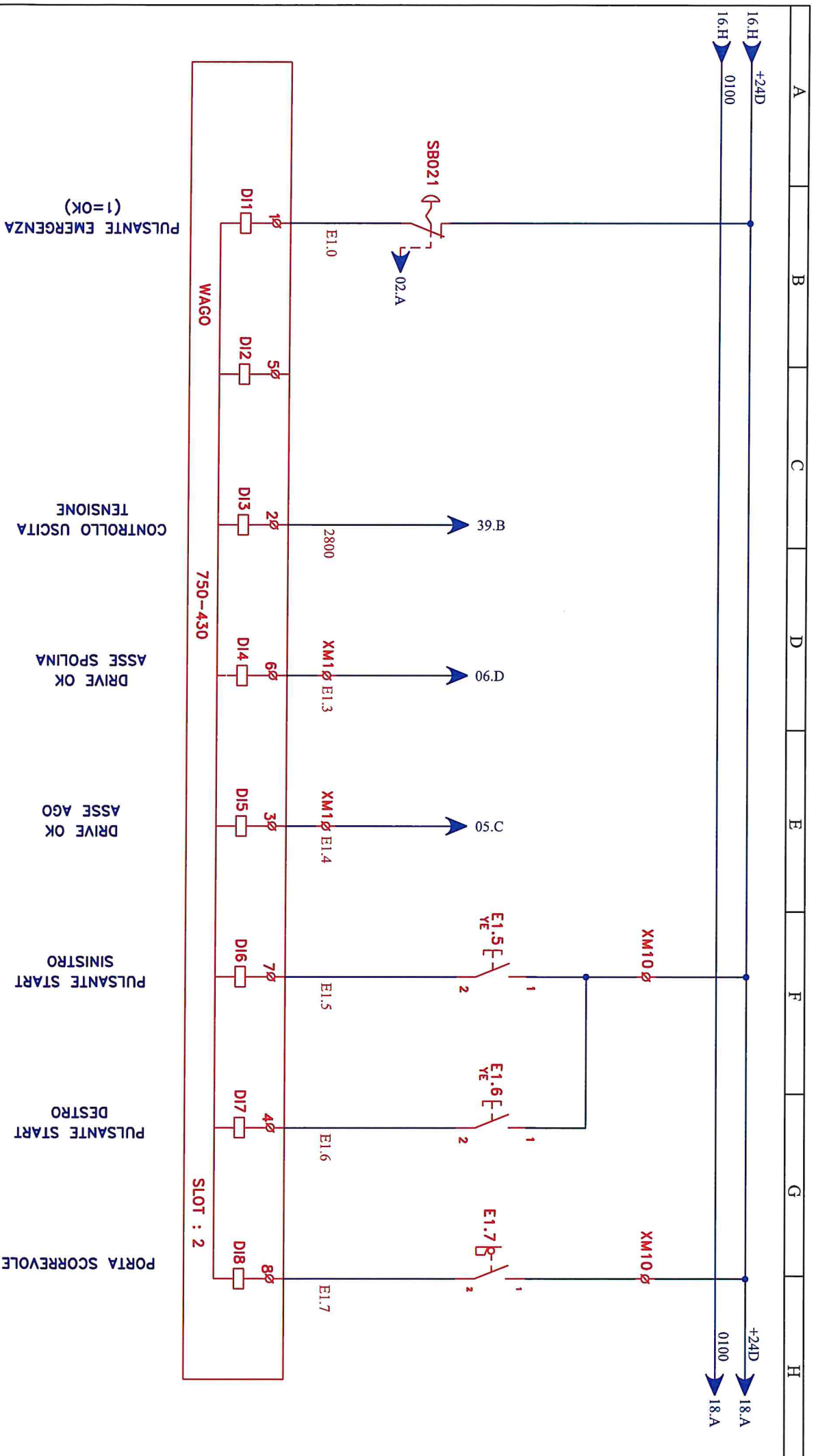
Cliente MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI	Pag. 25 di 50	Firma M.G.	M.A.I.C.A. Srl Torre De Roveri (BG) Via Casale,23
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Commessa UAM03	-ALIMENTAZIONE NODO CAN -			
		Data 04/06/2013 11.41	Scala 1:1	

NODO CAN

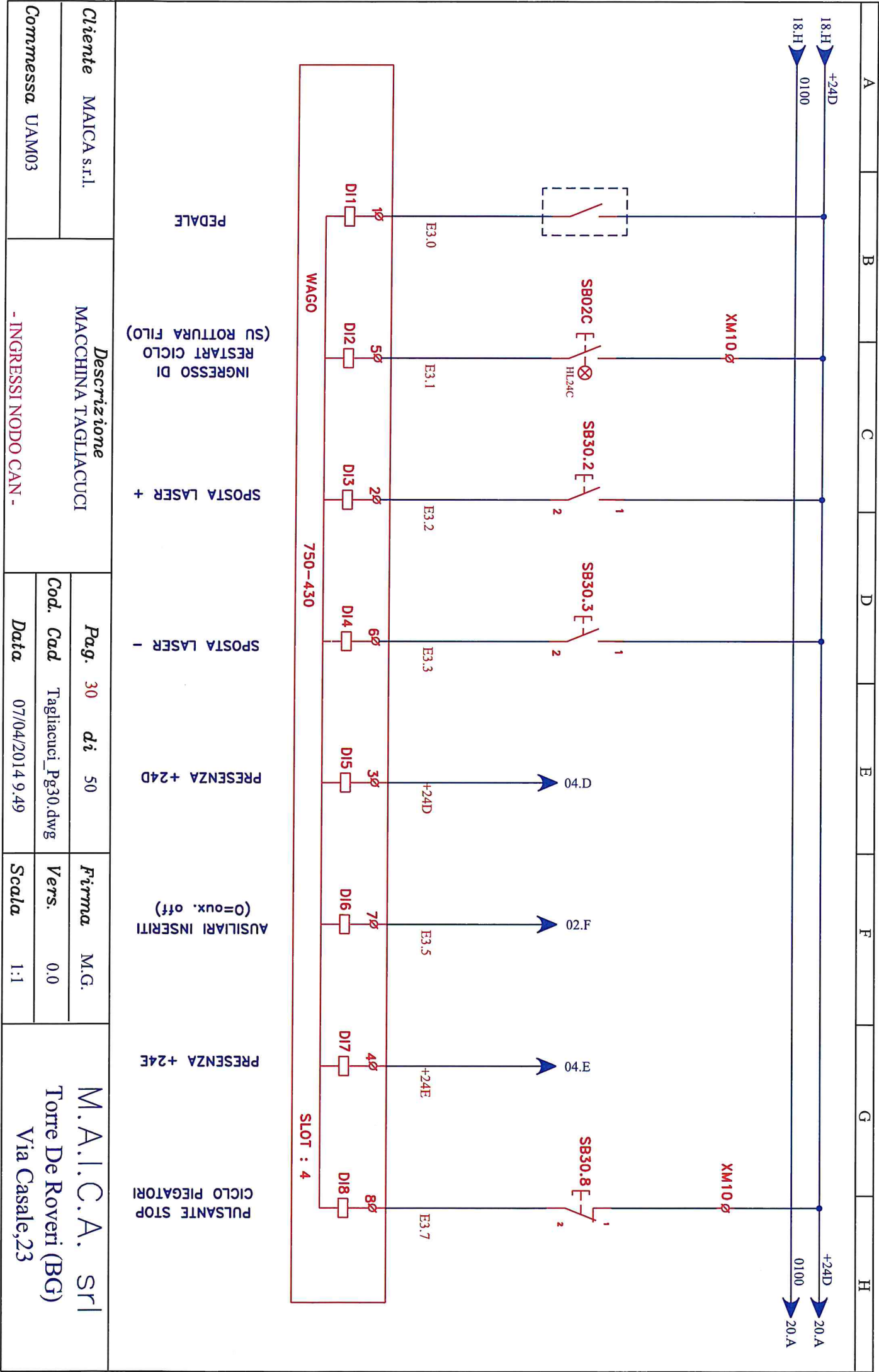


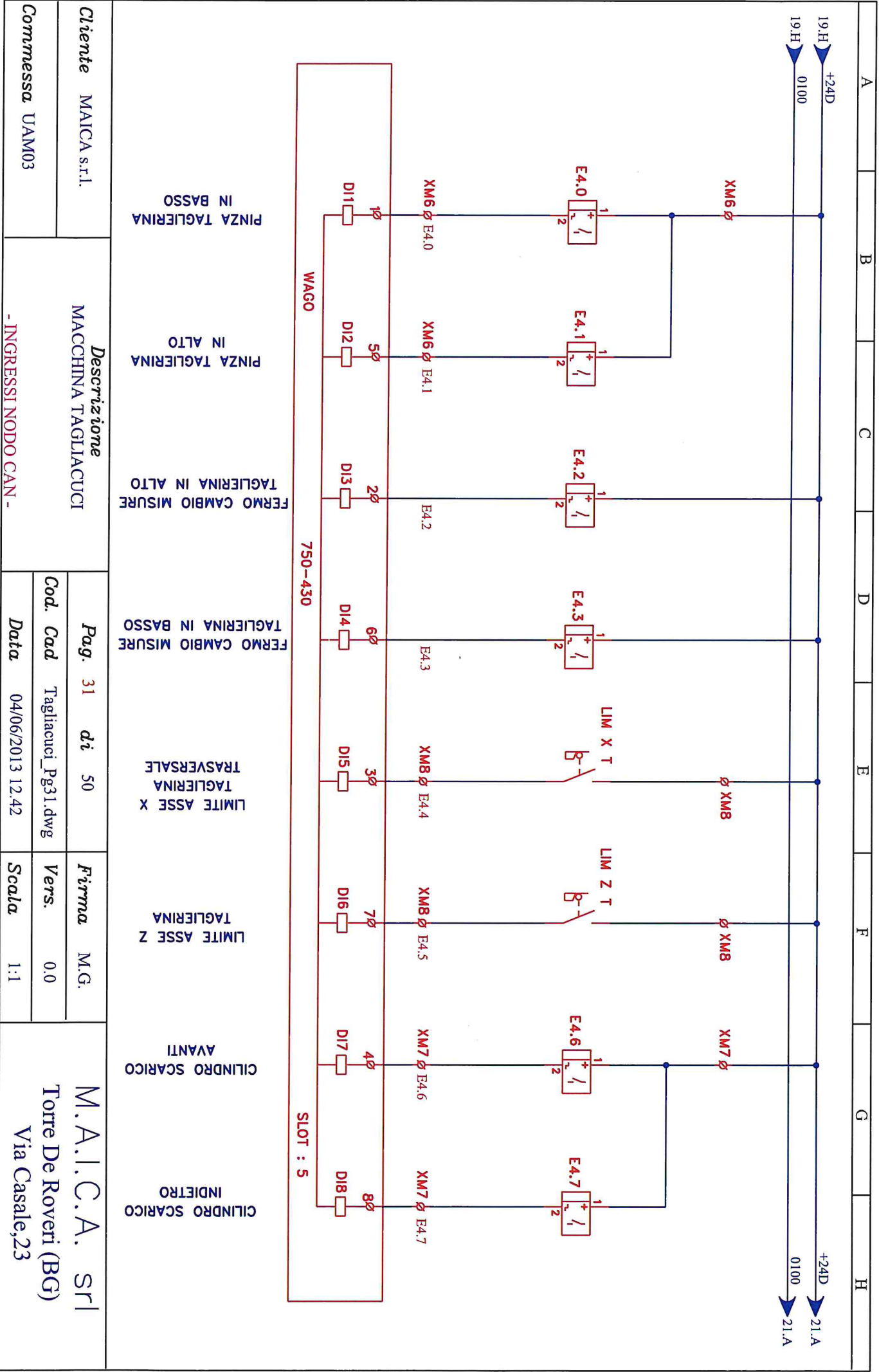
Cliente MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI		Pag. 26	di 50	Firma M.G.	M.A.I.C.A. S.r.l Torre De Roveri (BG) Via Casale,23
			Cod. Cad Tagliacuci_Pg26.dwg	Vers. 0.0		
Commessa UAM03	RACK NODO CAN E I/O		Data 04/06/2013 12.33	Scala 1:1		



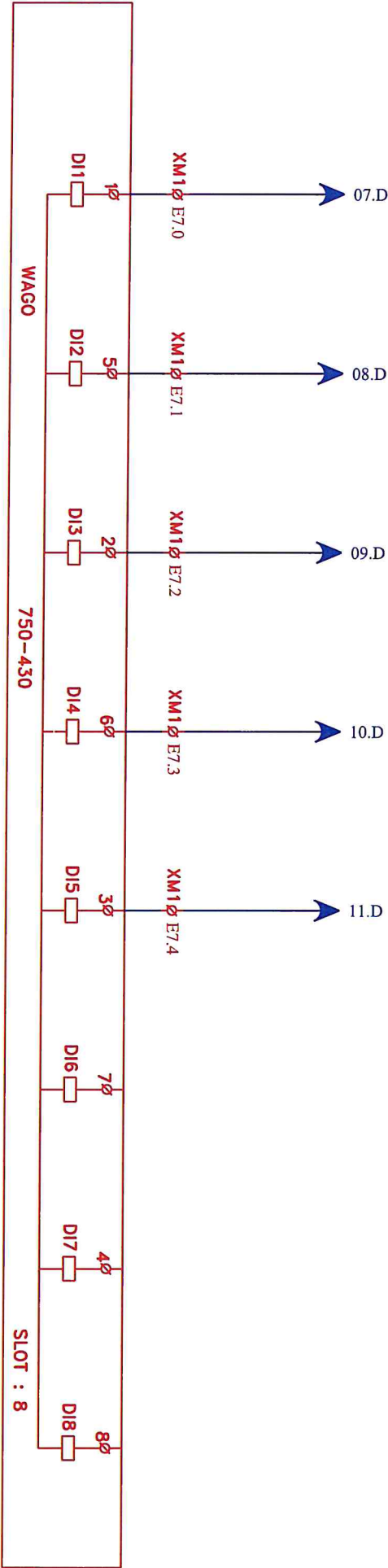


Cliente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI		Pag. 28	di 50	Firma	M.G.	M.A.I.C.A. Srl Torre De Roveri (BG) Via Casale,23
Commessa	UAM03			Cod. Cad	Tagliacuci_Pg28.dwg	Vers.	0.0	
		Data	04/06/2013 11.42	Scala	1:1			
		- INGRESSI NODO CAN -						





A	B	C	D	E	F	G	H
21.H	+24D						+24D
21.H	0100						0100
							23.A
							23.A



ASSE X CUCITRICE
DRIVE OK

ASSE Y CUCITRICE
DRIVE OK

ASSE Z TAGLIERINA
DRIVE OK

ASSE X TAGLIERINA
DRIVE OK

ASSE Y TAGLIERINA
DRIVE OK

Ciente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI			Pag. 34 di 50		Firma	M.G.	M.A.I.C.A. Srl Torre De Roveri (BG) Via Casale,23
Commessa	UAM03				Cod. Cad	Tagliacuci_Pg34.dwg	Vers.	0.0	
		Data	04/06/2013 11.43	Scala	1:1				

WAGO 750-530

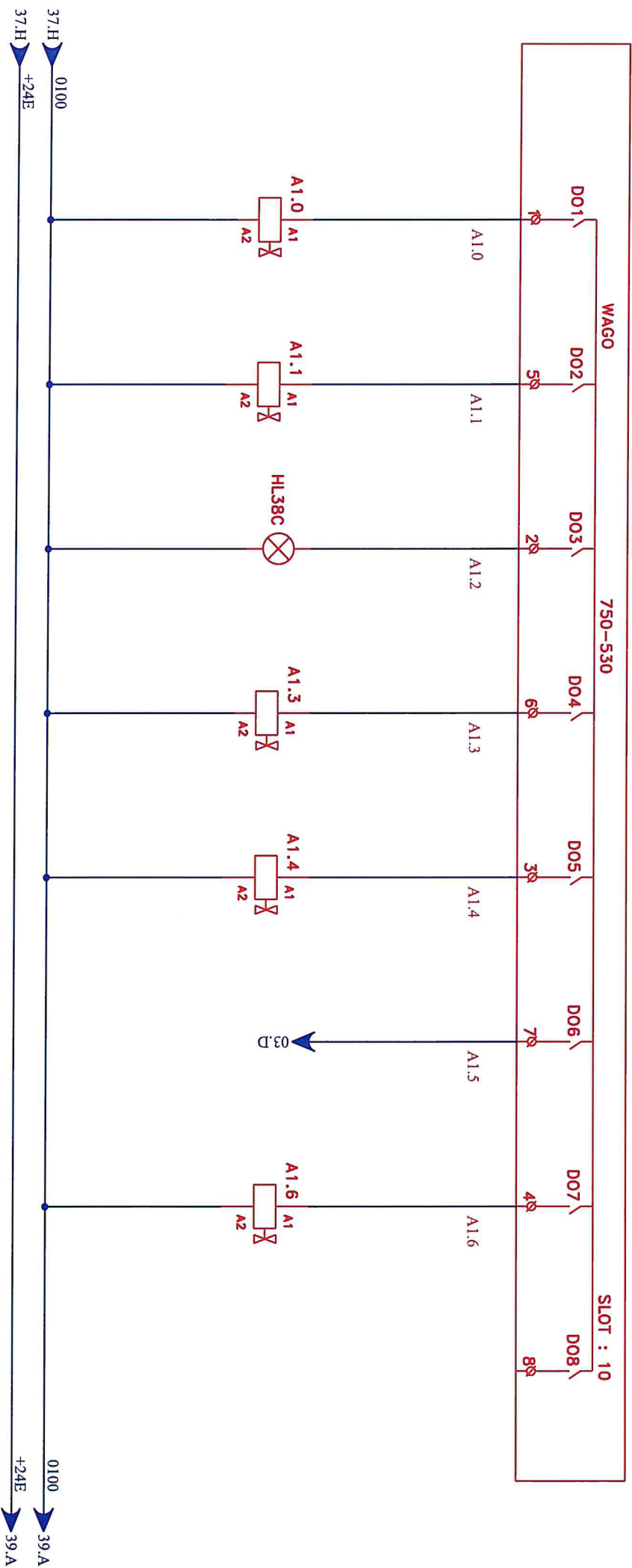
SLOT : 9

DO1 DO2 DO3 DO4 DO5 DO6 DO7 DO8

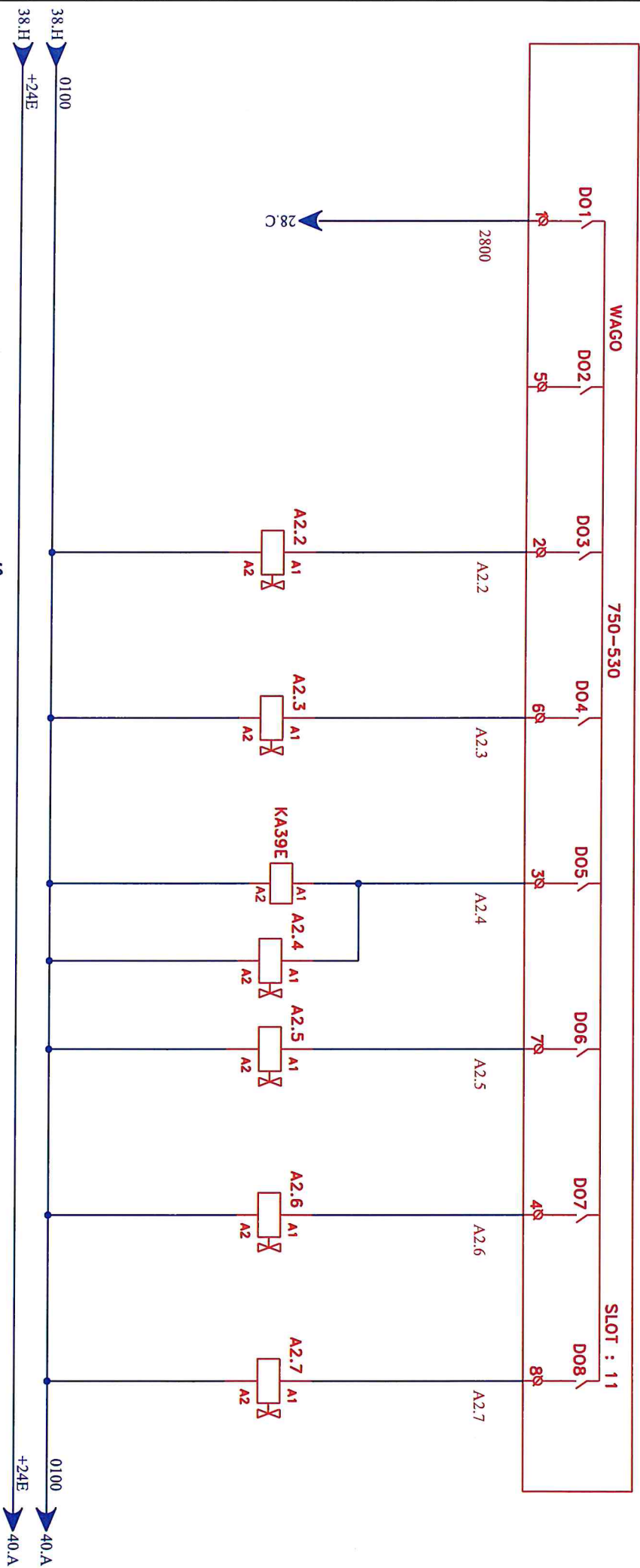
10 50 20 60 30 70 40 80



Cliente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI							
Commessa	UAM03								
		Pag.	37	di	50	Firma	M.G.	M.A.I.C.A. Srl Torre De Roveri (BG) Via Casale,23	
		Cod. Cad	Tagliacuci_Pg37.dwg		Vers.	0.0			
		Data	04/06/2013 11.43		Scala	1:1			
		- USCITE NODO CAN -							



Cliente MAICA s.r.l.		Descrizione MACCHINA TAGLIACUCI		Pag. 38 di 50		Firma M.G.		M.A.I.C.A. Srl Torre De Roveri (BG) Via Casale,23	
Commessa UAM03		- USCITE NODO CAN -		Cod. Cad Tagliacuci_Pg38.dwg		Vers. 0.0		Scala 1:1	
Data 04/06/2013 12.45									



CONTROLLO TENSIONE USCITE

SOFFIO LUBRIFICAZIONE CROCHET

RAFFREDDAMENTO ASPIRAZIONE

COMANDO FORBICE TAGLIERINA

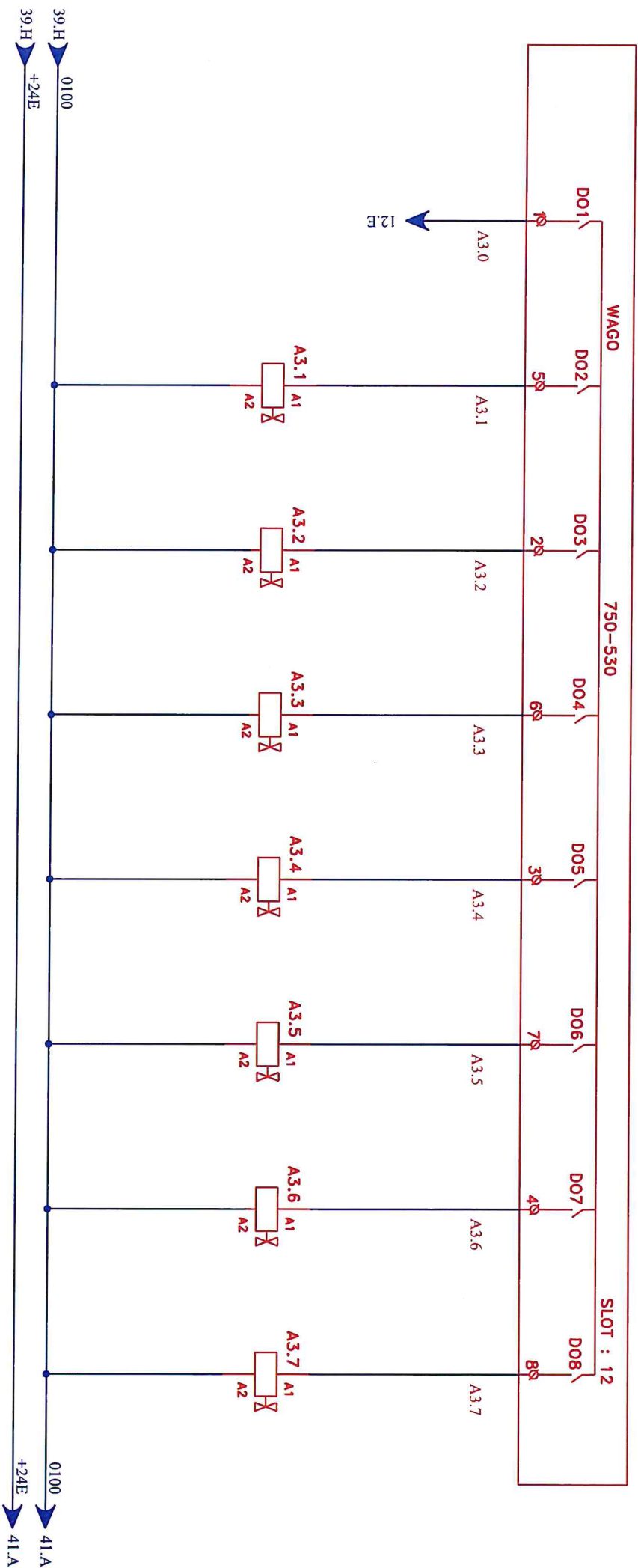
SOFFIO SCARTI TAGLIERINA

ASPIRAZIONE ZONA PIEGA

ASPIRAZIONE ZONA CENTRALE

SCARICO AVANTI

Ciente	MAICA s.r.l.	Descrizione		MACCHINA TAGLIACUCI		Pag. 39 di 50		Firma	M.G.	M.A.I.C.A. Srl	
										Torre De Roveri (BG)	
Commissa	UAM03	- USCITE NODO CAN -				Cod. Cad Tagliacuci_Pg39.dwg		Vers.	0.0	Via Casale,23	
						Data 04/06/2013 11.44		Scala	1:1		



ABILITAZIONE DRIVER
REGOLAZIONE LASER

COMANDO MOLLA
CARICO DESTRA
INTERNA

COMANDO MOLLA
CARICO SINISTRA
INTERNA

ABBASSA CILINDRO
SCARICO

CILINDRO IMPILATORE
CORSIA CORTA

CILINDRO IMPILATORE
CORSIA LUNGA

CILINDRO
IMPILATORE AVANTI

CILINDRO COMANDO
MOLLA FERMAPEZZO
ZONA CARICO

Cliente MAICA s.r.l.

Descrizione
MACCHINA TAGLIACUCI

Pag. 40 di 50

Firma M.G.

M.A.I.C.A. Srl

Commessa UAM03

- USCITE NODO CAN -

Cod. Cad Tagliacuci_Pg40.dwg

Vers. 0.0

Torre De Roveri (BG)

Data 04/06/2013 12.46

Scala 1:1

Via Casale,23

WAGO 750-530

SLOT : 13

DO1 DO2 DO3 DO4 DO5 DO6 DO7 DO8

10 50 20 60 30 70 40 80



Cliente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI			Pag. 41 di 50		Firma	M.G.	M. A. I. C. A. Srl Torre De Roveri (BG) Via Casale,23
Commessa	UAM03				Cod. Cad	Tagliacuci_Pg41.dwg	Vers.	0.0	
		Data	04/06/2013 11.44	Scala	1:1				
		- USCITE NODO CAN -							

A	B	C	D	E	F	G	H
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XM5 (LATO CUCITRICE)

+24D	
+24D	
+24D	
0100	
0800	
E0.0	
E0.1	

XM6 (LATO TAGLIERINA)

+24D	
+24D	
+24D	
0100	
1100	
E4.0	
E4.1	

XM7 (SCARICO)

+24D	
+24D	
+24D	
E4.6	
E4.7	
E5.0	
E5.1	

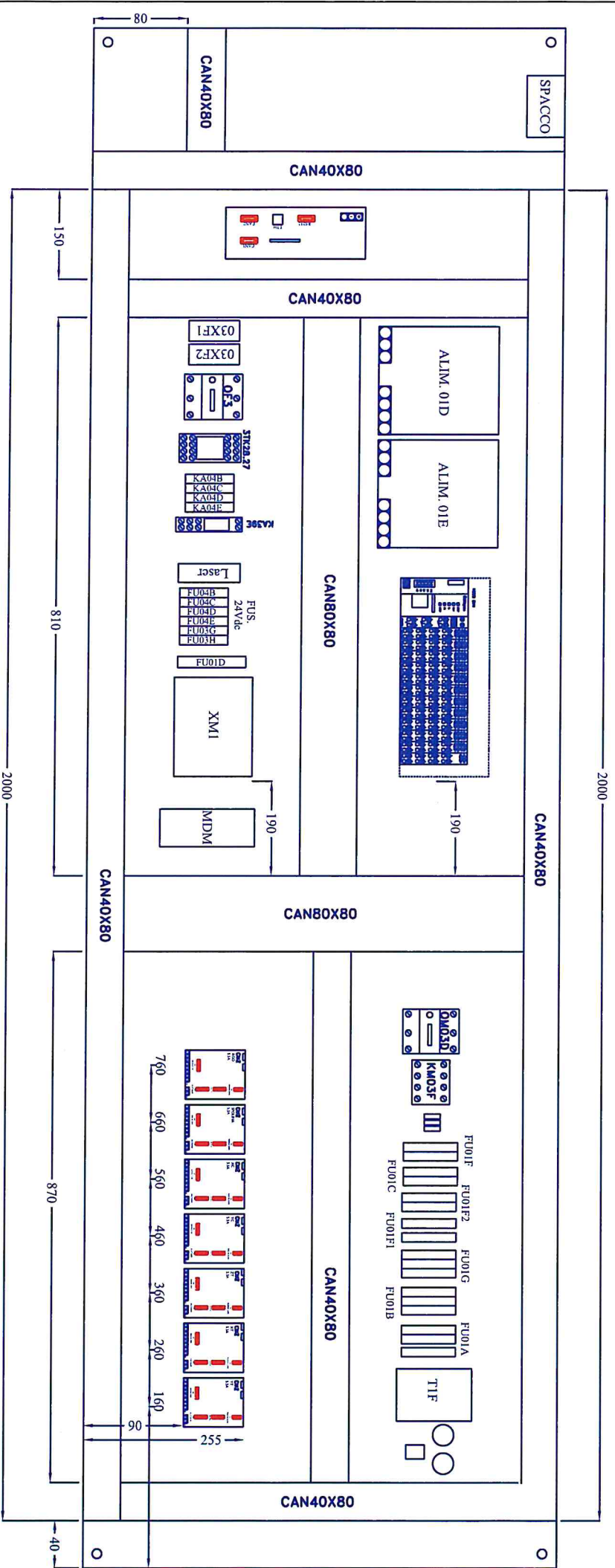
XM10 (IMPIANTORI)

+24D	
+24D	
+24D	
E2.0	
E2.1	
E2.2	
E2.3	
E2.4	

XM8

0100	0100
0100	0100
0100	0100
+24D	+24D
+24D	+24D
+24D	+24D
E0.5	E0.4
E4.5	E4.4
0201	0202
0203	0202
0203	02Y11
0700	0900
0500	1000
	1200
+5V	0V
0327	0300

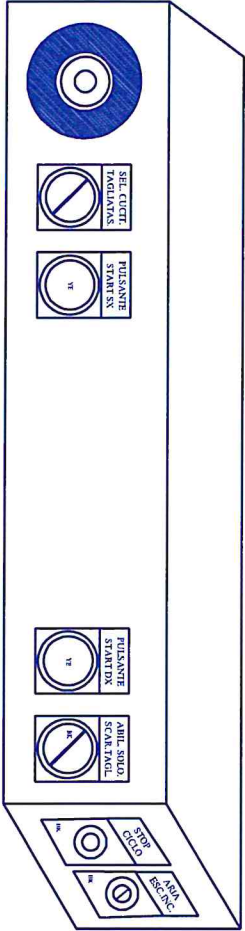
Ciente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI				Pag. 43 di 50		Firma	M.G.	M.A.I.C.A. srl Torre De Roveri (BG) Via Casale,23		
Commissa	UAM03					Cod. Cad		Tagliacuci_Pg43.dwg	Vers.			0.0
- MORSETTIERE SULLA MACCHINA -						Data		04/06/2013 11.51	Scala			1:1



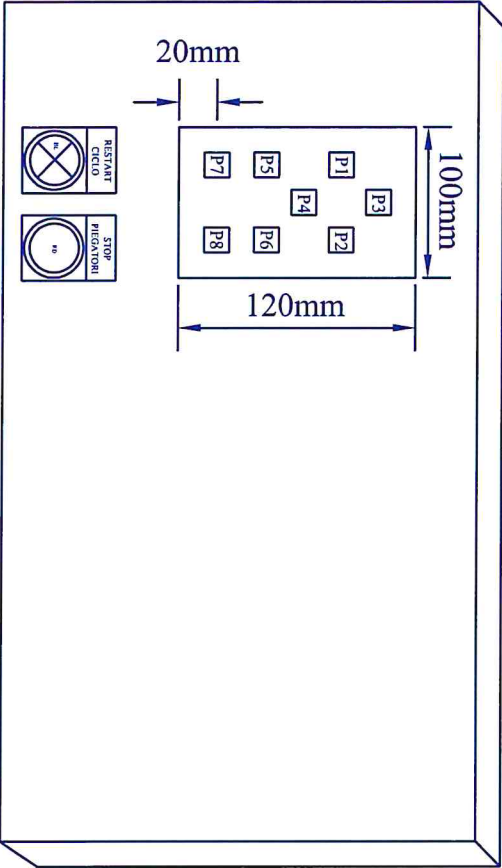
Ciente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI		Pag.	44	di	50	Firma	M.G.	M.A.I.C.A. srl Torre De Roveri (BG) Via Casale,23
Commissa	UAM03			Cod. Cad	Tagliacuci_Pg44.dwg	Vers.	0.0			
		Data	04/06/2013 11.54	Scala	1:1					
		- LAYOUT QUADRO -								

A	B	C	D	E	F	G	H
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Pulsantiera
vista frontale



Pulsantiera
vista superiore



Ciente	MAICA s.r.l.	Descrizione MACCHINA TAGLIACUCI				M.A.I.C.A. Srl			
Commessa	UAM03	-PULSANTIERA-	Pag.	47	di	50	Firma	M.G.	Torre De Roveri (BG) Via Casale,23
			Cod.	Cad	Tagliacuci_Pg47.dwg		Vers.	0.0	
			Data	06/02/2012 8.55		Scala	1:1		

CAVO MULTIPLO (3x1,5 COLORATO)		
Cavo CM3 da morsettiera Xm4 a quadro elettrico		
Colore	Segnale	Descrizione
Blu	0300	Alimentazione motore forbice
Marrone	326	Alimentazione motore forbice

CAVO MULTIPLO (6 x 0.5 COLORATO)		
Cavo CM5 da morsettiera XM5 (lato cucitrice) a quadro elettrico		
Colore	Segnale	Descrizione
Marrone	+24D	+24Volt
Bianco	0100	0 Volt
Grigio	E0.0	Pinza cucitrice in alto
Rosa	E0.1	Pinza cucitrice in basso
Verde	0800	Micro di 0 asse y cucitrice
Giallo		Libero

CAVO MULTIPLO (6 x 0.5 COLORATO)		
Cavo CM6 da morsettiera XM6 (lato taglierina) a quadro elettrico		
Colore	Segnale	Descrizione
Marrone	+24D	+24Volt
Bianco	0100	0 Volt
Grigio	E4.0	Pinza taglierina in alto
Rosa	E4.1	Pinza taglierina in basso
Verde	1100	Micro di 0 asse y taglierina
Giallo		Libero

CAVO MULTIPLO (6 x 0.5 COLORATO)		
Cavo CM7 da morsettiera XM7 (scarico) a quadro elettrico		
Colore	Segnale	Descrizione
Marrone	+24D	+24Volt
Bianco		Libero
Grigio	E4.6	Cilindro scarico avanti
Rosa	E4.7	Cilindro scarico indietro
Verde	E5.0	Cilindro scarico alto
Giallo	E5.1	Cilindro scarico basso

CAVO MULTIPLO (25 x 0,5 COLORATO)		
Cavo CM8 da morsettiera XM8 a quadro elettrico		
Numero Filo	Segnale	Descrizione
Bianco	0100	0 Volt
Marrone	+24D	+24 Volt
Verde	E0.4	Limite asse XC (azzurro)
Giallo	E0.5	Rottura filo (marrone / +24v rosso / 0100 bianco)
Grigio	E4.4	Limite asse XT (azzurro)
Rosa	E4.5	Limite asse ZT (azzurro)
Blu	1200	Ingresso fc zero motore regolazione laser
Rosso	0201	Limite XC (grigio)
Nero	0202	Limite XC (nero)
Viola	0202	Limite XT (nero)
Grigio/Rosa	0203	Limite XT (grigio)
Bianco/Nero	0203	Limite ZT (grigio)
Marrone/Rosso	02Y11	Limite ZT (nero)
Rosso/Blu	0700	Micro di 0 XC
Bianco/Verde	0900	Micro di 0 ZT
Marrone/Verde	+24D	+24 Volt
Bianco/Giallo	0500	Micro di 0 Ago
Giallo/Marrone	0V	Alimentazione laser
Bianco/Grigio	0V	Alimentazione laser
Grigio/Marrone	+5V	Alimentazione laser
Bianco/Rosa	+5V	Alimentazione laser
Rosa/Marrone	0300	Avvolgi spolina
Marrone/Blu	1000	Micro di 0 XT
Bianco/Blu	0327	Avvolgi spolina
Bianco/Rosso	0327	Avvolgi spolina

CAVO MULTIPLO (2 x 0.5 COLORATO)		
Cavo CM9 Alimentazione laser		
Colore	Segnale	Descrizione
Marrone	+24B/1	Laser On/Off
Bianco	+24B	Laser On/Off

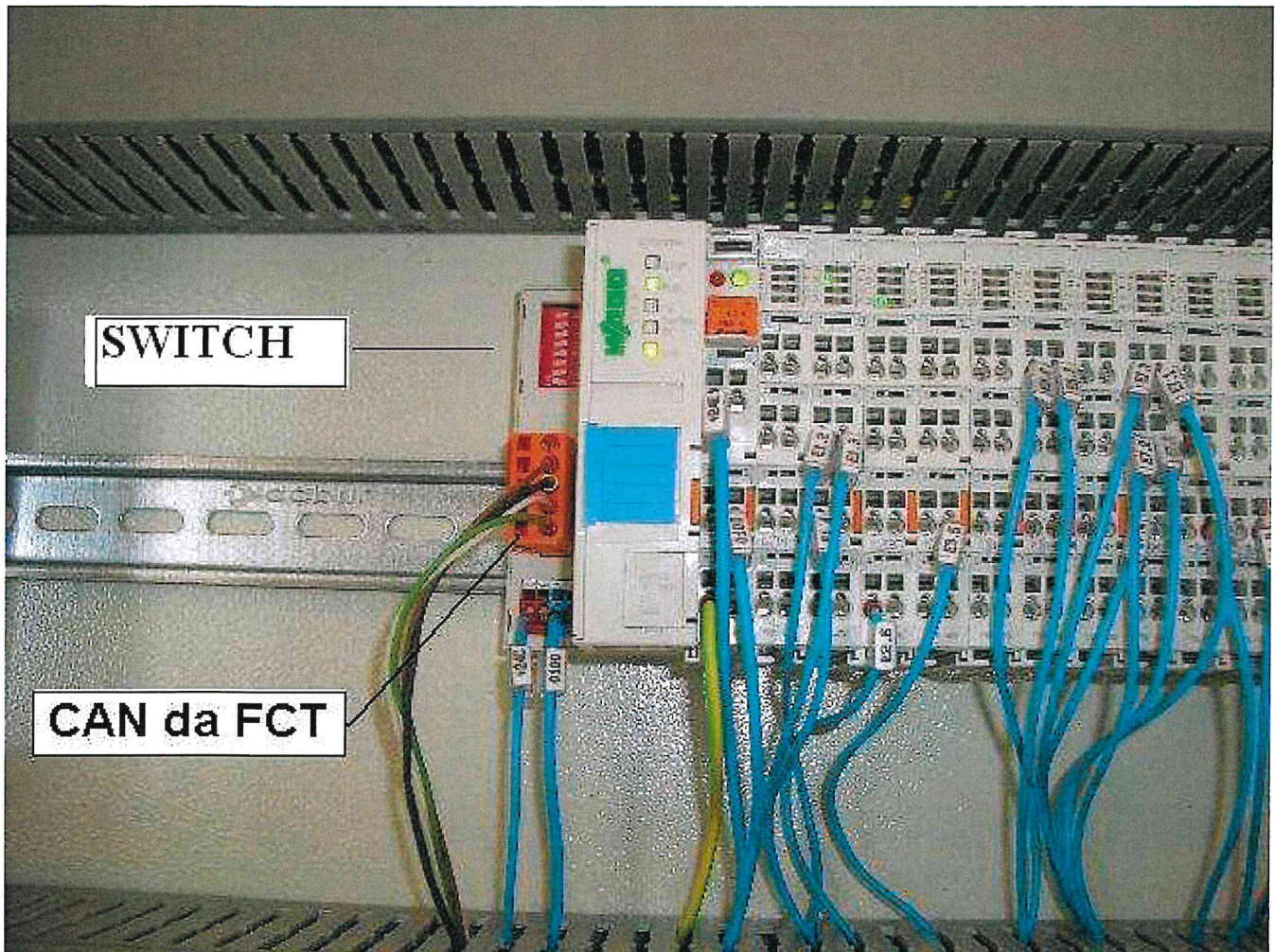
CAVO MULTIPLO (6x 0.5 COLORATO)		
Cavo CM10 da morsettiera XM10 (impilatori) a quadro elettrico		
Colore	Segnale	Descrizione
Marrone	+24D	+24Volt
Bianco	E2.0	Impilatore indietro
Grigio	E2.1	Impilatore avanti
Rosa	E2.2	Cilindro corsa 1 basso
Verde	E2.3	Cilindro corsa 1 alto
Giallo	E2.4	Cilindro corsa 2

CAVO MULTIPLO (25 x 0,5 COLORATO)		
Cavo CM11 (pulsanti sx)		
Numero Filo	Segnale	Descrizione
Bianco	0100	0 Volt
Marrone	+24D	+24 Volt pulsanti
Verde	E6.0	Pulsante 1
Giallo	E6.1	Pulsante 2
Grigio	E6.2	Pulsante 3
Rosa	E6.3	Pulsante 4
Blu	E6.4	Pulsante 5
Rosso	E6.5	Pulsante 6
Nero	E6.6	Pulsante 7
Viola	E6.7	Pulsante 8
Grigio/Rosa	A0.5	Emergenza
Rosso/Blu	0201	Emergenza
Bianco/Verde	E1.0	Emergenza
Marrone/Verde	+24D	Emergenza
Bianco/Giallo	E5.5	Selettore scelta movimento macchina cucitrice
Giallo/Marrone	E5.4	Selettore scelta movimento macchina tagliatessuto
Bianco/Grigio	E0.7	Pulsante stop ciclo
Grigio/Marrone	A1.2	Lampada ausiliari inseriti
Bianco/Rosa	02Y33	Pulsante start ausiliari
Bianco/Blu	02Y34	Pulsante start ausiliari
Rosa/Marrone	+24D	+24 Volt tastierino
Marrone/Blu	E3.1	Ingresso di restart ciclo (su rottura filo)
Bianco/Rosso	E1.5	Pulsante start sinistro
Marrone/Rosso		
Bianco/Nero		

CAVO MULTIPLO (4 x 0,5 COLORATO)		
Cavo CM12 (pulsanti dx)		
Numero Filo	Segnale	Descrizione
Bianco	E1.6	Pulsante start destro
Marrone	+24D	+24 Volt pulsanti
Verde	E3.7	Pulsante stop ciclo piegatori
Giallo	E5.6	Abilita solo scarico taglierina

CAVO MULTIPLO (37*0.5)		
Cavo multiplo collegamento valvole		
Numero Filo	Segnale	Descrizione
Bianco	A0.0	Pinza cucitrice
Marrone	A0.1	Fermo taglie cucitrice
Verde	A0.2	Sblocca pinza cucitrice dx
Giallo	A0.3	Sblocca pinza cucitrice sx
Grigio	A0.4	Alza pinza taglierina
Rosa	A1.0	Alza fermo taglie taglierina
Blu	A1.1	Sblocca pinza taglierina sx
Rosso	A1.3	Sblocca pinza taglierina dx
Nero	A1.4	Apri tensione
Viola	A1.6	Rasafilo
Grigio/Rosa	A2.4	Soffio scarti taglierina (insieme a A2.4 nel rele)
Rosso/Blu	A2.2	Soffio lubrificazione crochet
Bianco/Verde	A2.3	Raffreddamento aspirazione
Marrone/Verde	A2.5	Aspirazione 1 (zona piega)
Bianco/Giallo	A2.6	Aspirazione 2 (zona centrale)
Giallo/Marrone	A2.7	Scarico avanti
Bianco/Grigio	A3.1	Comando molla carico dx interna
Grigio/Marrone	A3.2	Comando molla carico sx interna
Bianco/Rosa	A3.3	Abbassa cilindro scarico
Bianco/Blu	A3.4	Impilatore corsa corta
Rosa/Marrone	A3.5	Impilatore corsa lunga
Marrone/Blu	A3.6	Cilindro impilatore (ava.-ind.)
Bianco/Rosso	A3.7	Cilindro comando molla ferma pezzo al carico
Marrone/Rosso	A4.0	Forcone
Bianco/Nero	A4.1	Sgancio piastra sx
Marrone/Nero	A4.2	Sgancio piastra dx
Grigio/Verde	A4.3	Olio lubrificazione
Giallo/Grigio	A4.4	Comando molla carico destra esterna
Rosa/Verde	A4.5	Comando molla carico sinistra esterna
Giallo/Rosa	A4.6	Aspirazione portastecche
Verde/Blu		
Giallo/Blu		
Verde/Rosso	0100	0 Volt
Giallo/Rosso	0100	0 Volt
Verde/Nero	0100	0 Volt
Giallo/Nero	0100	0 Volt
Grigio/Blu	0100	0 Volt

PROCEDURA PER SETTARE VELOCITA' BAUD-RATE (1 MB)



1. Scollegare il cavo CAN proveniente da FCT CMZ
2. Spegnerne alimentazione 24Vdc al nodo
3. Mettere tutti i BIT (dello switch) a OFF
4. Accendere 24Vdc al nodo
5. Mettere il BIT 8 = ON
6. Attendere tutti i LED accesi
7. Spegnerne alimentazione 24Vdc al nodo
8. Mettere il BIT 8 = OFF e mettere il BIT 1 = ON (ID=1)
9. Accendere 24Vdc al nodo
10. Ricollegare il cavo CAN proveniente da FCT CMZ
11. Spegnerne e riaccendere l'FCT CMZ (Con già il PRJ caricato in Flask)

FINE PROCEDURA