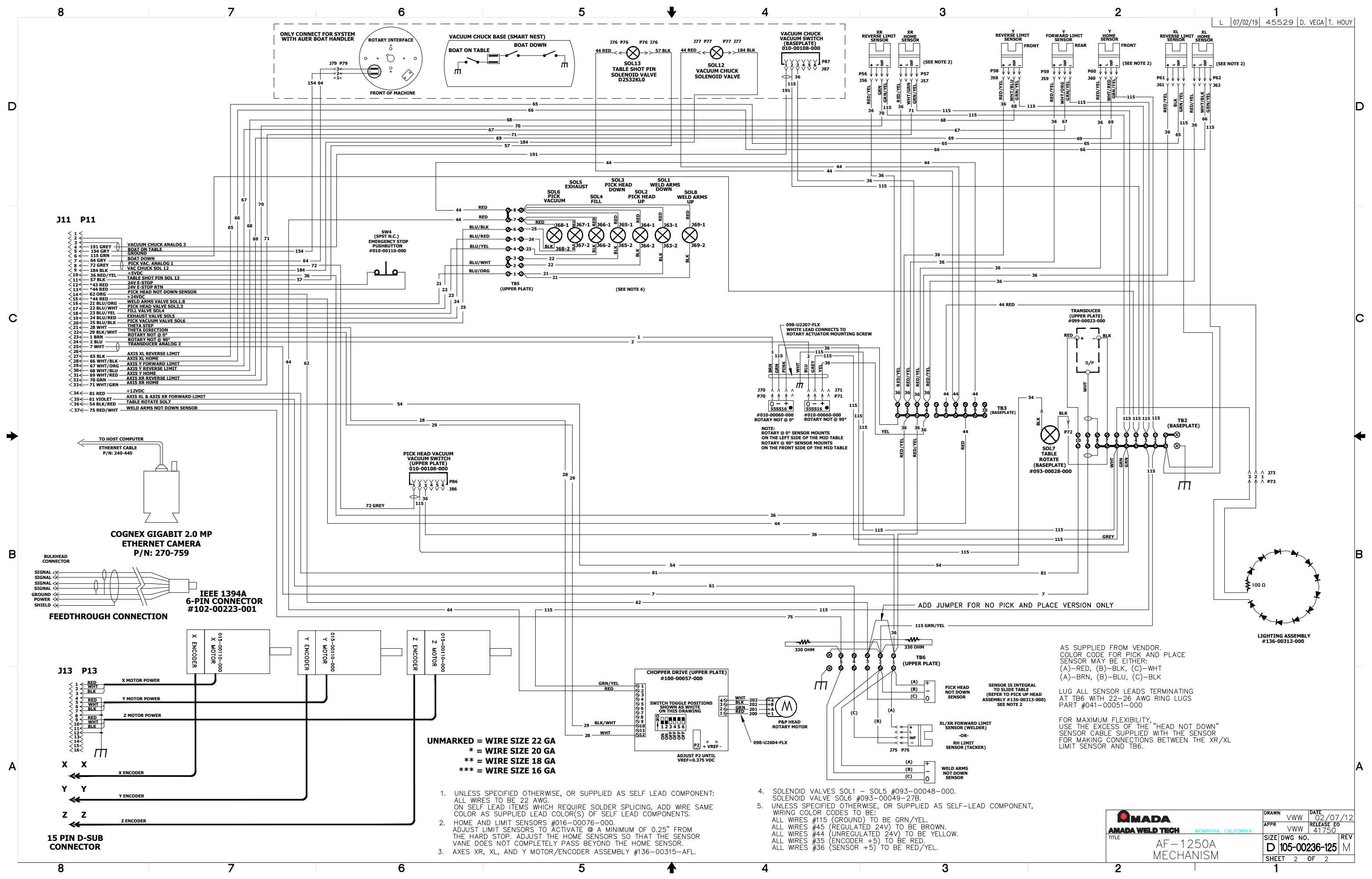


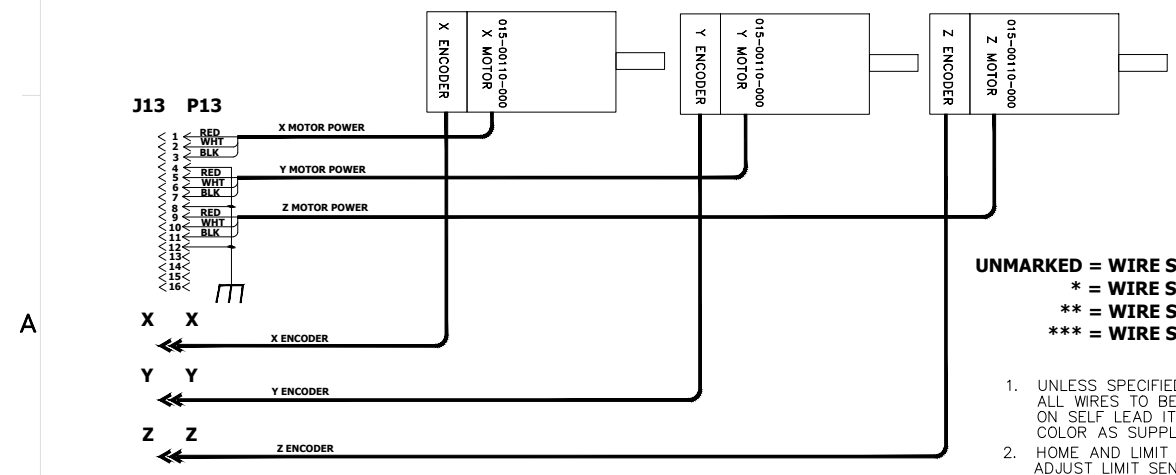
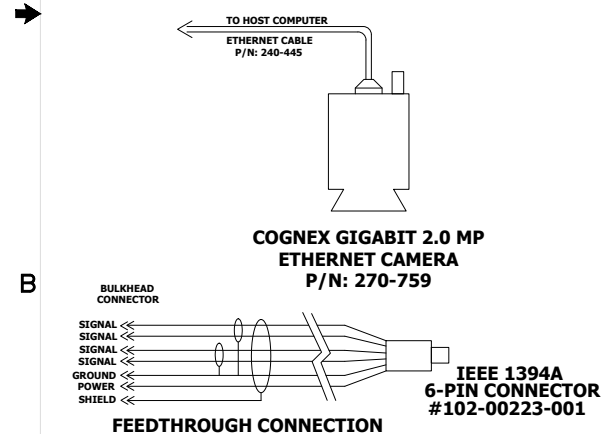
FOR SYSTEM WITH WM-3000 WELD MONITOR, USE WITH SCHEMATIC #105-00290-002
FOR SYSTEM WITH AF-450 LID TRANSFER, USE WITH SCHEMATIC #105-00255-ELE
FOR SYSTEM WITH MG-2000 AUER BOAT HANDLER, USE WITH SCHEMATIC #105-00236-200

UNMARKED = WIRE SIZE 22 GA
* = WIRE SIZE 20 GA
** = WIRE SIZE 18 GA
*** = WIRE SIZE 16 GA

NOTE: PC IP ADDRESS TO BE SET STATIC 192.168.255.1
GALIL MC TO BE SET STATIC 192.168.255.2



- J11 P11**
- <1 VACUUM CHUCK ANALOG 3
 - <2 BOAT ON TABLE
 - <3 GROUND
 - <4 BOAT DOWN
 - <5 PICK VAC ANALOG 1
 - <6 VAC CHUCK SOL 12
 - <7 +5VDC
 - <8 TABLE SHOT PIN SOL 13
 - <9 24V E-STOP
 - <10 24V E-STOP RTN
 - <11 PICK HEAD NOT DOWN SENSOR
 - <12 +24VDC
 - <13 WELD ARMS VALVE SOL1,8
 - <14 PICK HEAD VALVE SOL1,3
 - <15 FILL VALVE SOL4
 - <16 EXHAUST VALVE SOL5
 - <17 PICK VACUUM VALVE SOL6
 - <18 THETA DIRECTION
 - <19 ROTARY NOT @ 0°
 - <20 ROTARY NOT @ 90°
 - <21 TRANSUCER ANALOG 2
 - <22
 - <23
 - <24
 - <25
 - <26
 - <27 AXIS XL REVERSE LIMIT
 - <28 AXIS XL HOME
 - <29 AXIS Y FORWARD LIMIT
 - <30 AXIS Y REVERSE LIMIT
 - <31 AXIS Y HOME
 - <32 AXIS XR REVERSE LIMIT
 - <33 AXIS XR HOME
 - <34 +12VDC
 - <35 AXIS XL & AXIS XR FORWARD LIMIT
 - <36 TABLE ROTATE SOL7
 - <37 WELD ARMS NOT DOWN SENSOR



UNMARKED = WIRE SIZE 22 GA
 * = WIRE SIZE 20 GA
 ** = WIRE SIZE 18 GA
 *** = WIRE SIZE 16 GA

- UNLESS SPECIFIED OTHERWISE, OR SUPPLIED AS SELF LEAD COMPONENT: ALL WIRES TO BE 22 AWG. ON SELF LEAD ITEMS WHICH REQUIRE SOLDER SPlicing, ADD WIRE SAME COLOR AS SUPPLIED LEAD COLOR(S) OF SELF LEAD COMPONENTS.
- HOME AND LIMIT SENSORS #016-00076-000. ADJUST LIMIT SENSORS TO ACTIVATE @ A MINIMUM OF 0.25" FROM THE HARD STOP. ADJUST THE HOME SENSORS SO THAT THE SENSOR VANE DOES NOT COMPLETELY PASS BEYOND THE HOME SENSOR.
- AXES XR, XL, AND Y MOTOR/ENCODER ASSEMBLY #136-00315-AFL.
- SOLENOID VALVES SOL1 - SOL5 #093-00048-000. SOLENOID VALVE SOL6 #093-00049-27B.
- UNLESS SPECIFIED OTHERWISE, OR SUPPLIED AS SELF-LEAD COMPONENT, WIRING COLOR CODES TO BE:
 ALL WIRES #115 (GROUND) TO BE GRN/YEL.
 ALL WIRES #45 (REGULATED 24V) TO BE BROWN.
 ALL WIRES #44 (UNREGULATED 24V) TO BE YELLOW.
 ALL WIRES #35 (ENCODER +5) TO BE RED.
 ALL WIRES #36 (SENSOR +5) TO BE RED/YEL.

AS SUPPLIED FROM VENDOR. COLOR CODE FOR PICK AND PLACE SENSOR MAY BE EITHER:
 (A)-RED, (B)-BLK, (C)-WHT
 (A)-BRN, (B)-BLU, (C)-BLK

LUG ALL SENSOR LEADS TERMINATING AT TB6 WITH 22-26 AWG RING LUGS PART #041-00051-000

FOR MAXIMUM FLEXIBILITY, USE THE EXCESS OF THE "HEAD NOT DOWN" SENSOR CABLE SUPPLIED WITH THE SENSOR FOR MAKING CONNECTIONS BETWEEN THE XR/XL LIMIT SENSOR AND TB6.

<p>AMADA WELD TECH MONROVIA, CALIFORNIA</p>	DRAWN VWW APPR VWW	DATE 02/07/12 RELEASE ED 41750
	TITLE AF-1250A MECHANISM	SIZE DWG NO. D 105-00236-125 SHEET 2 OF 2