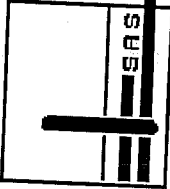


FOLIO	DESIGNATION	K	J	I	H	G	F	E	D	C	B	A	MODIFICATION	DATE	PAR
175	DEVELOPPE 175														
176	DEVELOPPE 176														
177	DEVELOPPE 177														
179	DEVELOPPE 179														
190	DEVELOPPE 190														
191	DEVELOPPE 191														
192	DEVELOPPE 192														
193	DEVELOPPE 193														
206	DEVELOPPE 206														
207	DEVELOPPE 207														
208	DEVELOPPE 208														
213	DEVELOPPE 213														
275	DEVELOPPE 275														
278	DEVELOPPE 278														
279	DEVELOPPE 279														
280	DEVELOPPE 280														
282	DEVELOPPE 282														
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285	DEVELOPPE 285														
286	DEVELOPPE 286														
290	DEVELOPPE 290														
291	DEVELOPPE 291														
292	DEVELOPPE 292														
293	IMPLANTATION 293														

SPECIFICITE CLIENT :			MODIFICATION		DATE	PAR
DESSINE LE : 28-04-2011			PAR : F.T	Nbre de FOLIOS :	111	
MACHINE : CLOUEUSE D'ASSEMBLAGE DE BLOCS			N° :		PA056	
CLIENT :			SACCHI PALLETS		TENSION : 3X400V+N	
NOM PROGRAMME :						
PUISSANCE MACHINE : 30KW			CONSOMMATION D'AIR :			



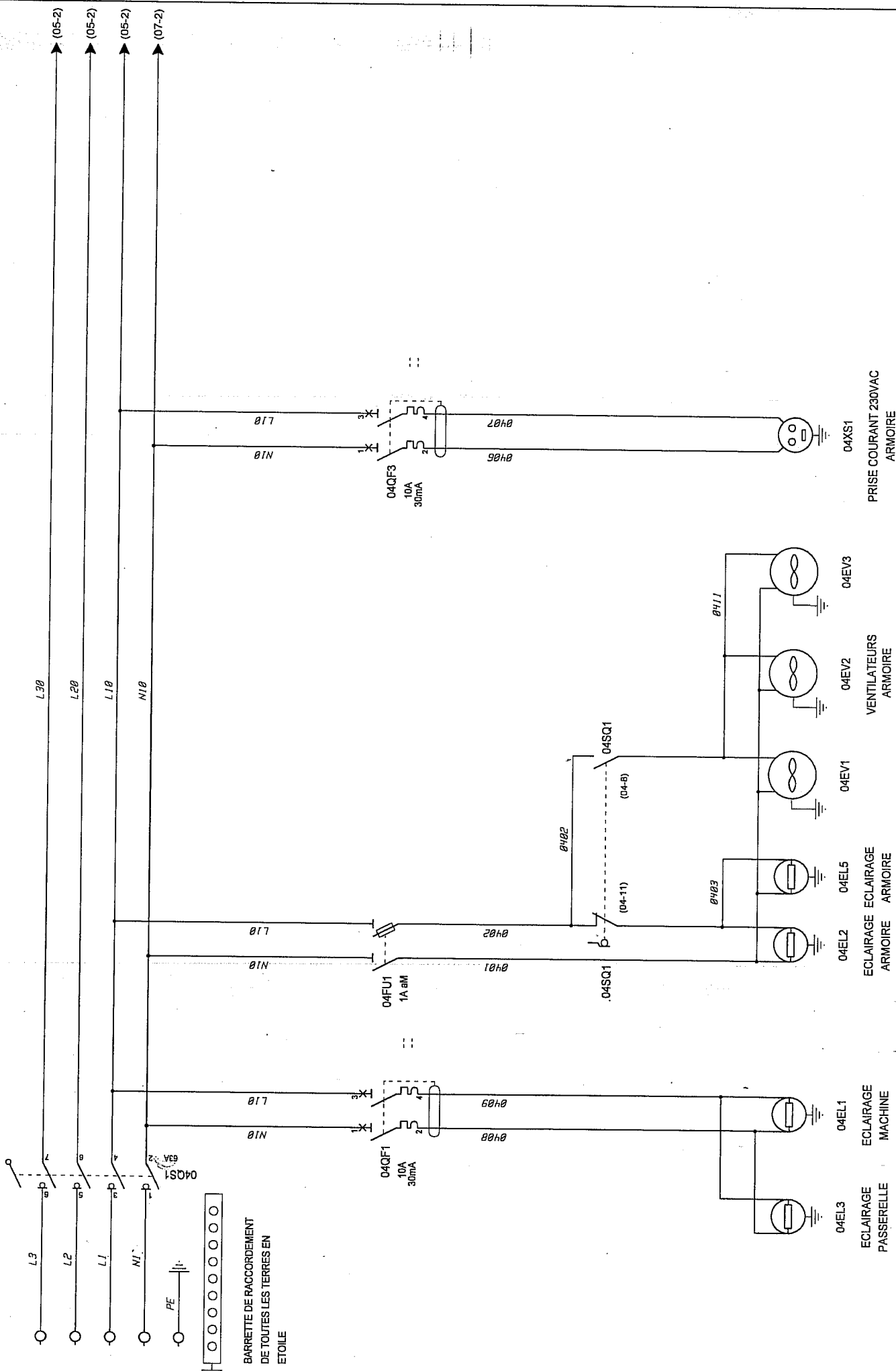
SODEME

SIEGE SOCIAL: Z.I. de la Croix Cadeau 49240 BP 60093 - AVRILLE Tél : 02-41-42-35-00 Fax: 02-41-42-30-41

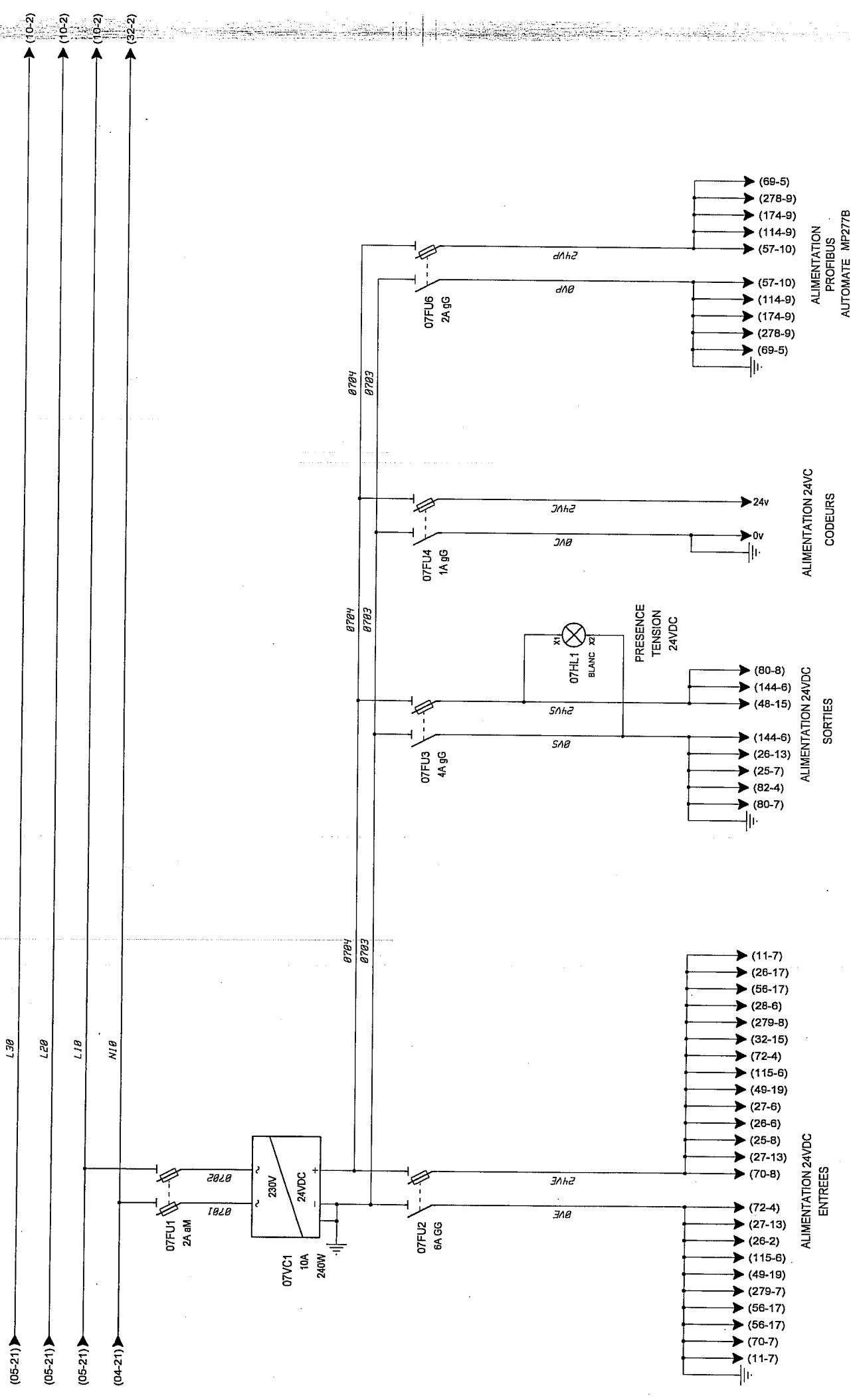
Ce plan est la propriété de S.A.S. SODEME. Il ne pourra sans son autorisation écrite, être utilisé ou communiqué à des tiers.

Toutes précautions utiles devront être prises pour en éviter la divulgation. (Loi du 11/03/1902.)

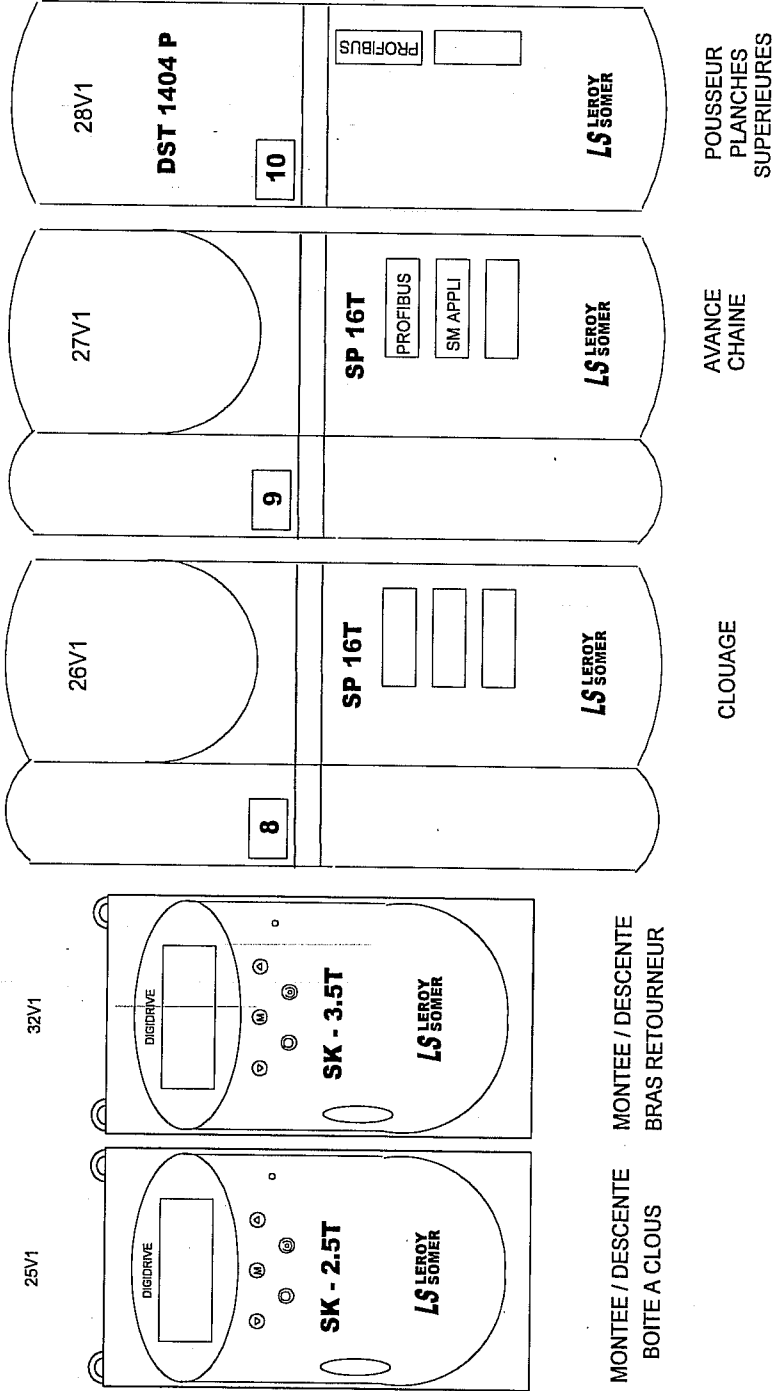
ALIMENTATION
3x400V 50Hz



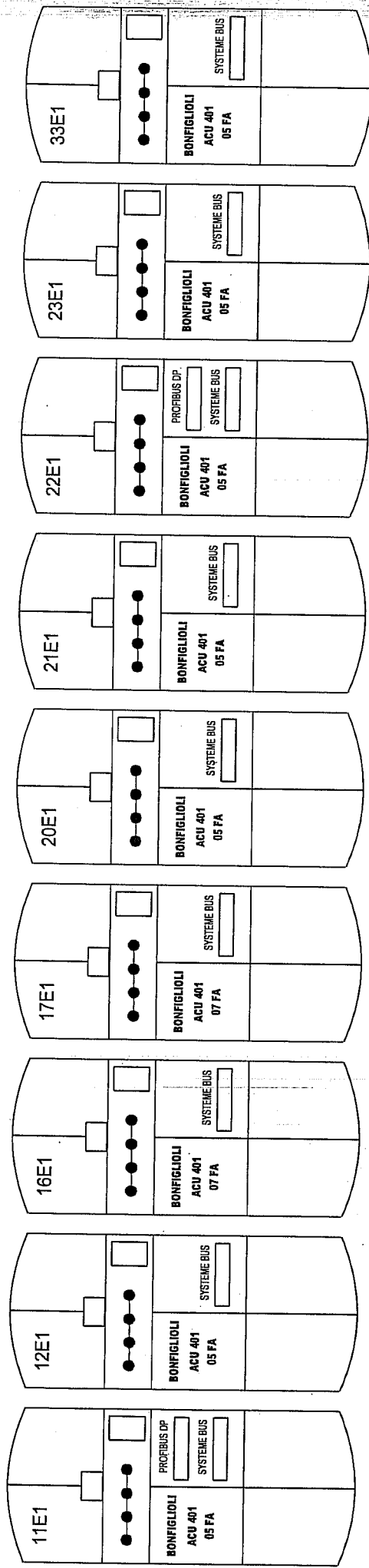
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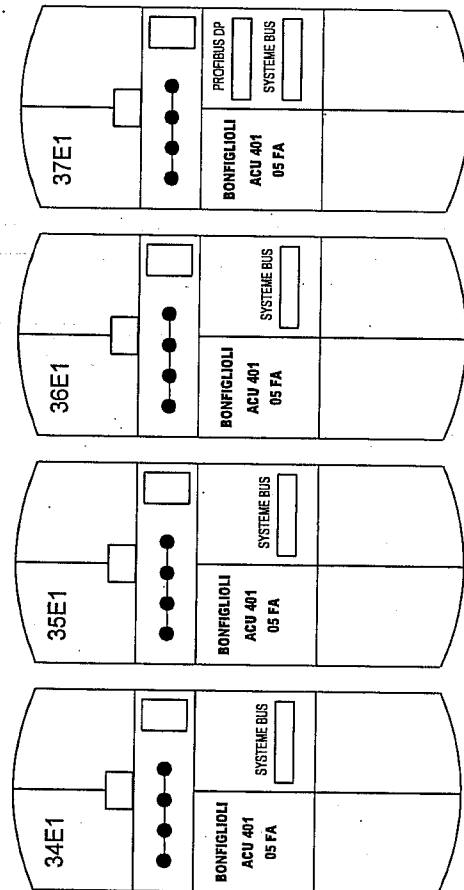
CONFIGURATION VARIATEURS CLOUEUSE



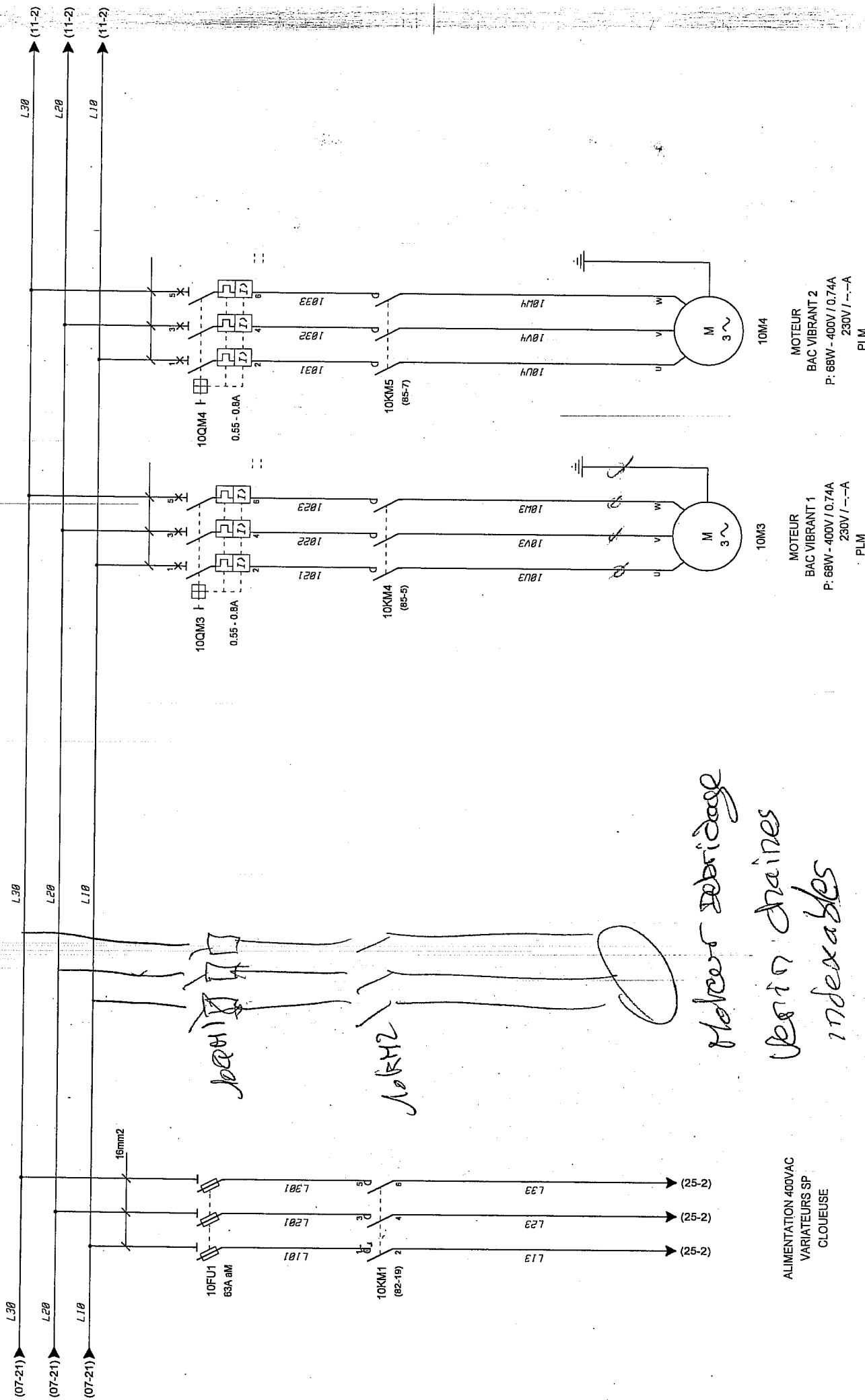
CONFIGURATION VARIATEURS REGLAGES

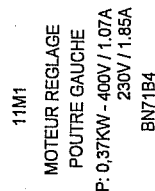


POUTRE GAUCHE POUTRE DROITE EPAISSEURS PLANCHES INFERIEURES PLANCHES SUPERIEURES DISTRIBUTEUR DE PLATEAUX GUIDES POUTRE DROITE GUIDES POUTRE CENTRALE GUIDES POUTRE DROITE GUIDES RETOURNEUR

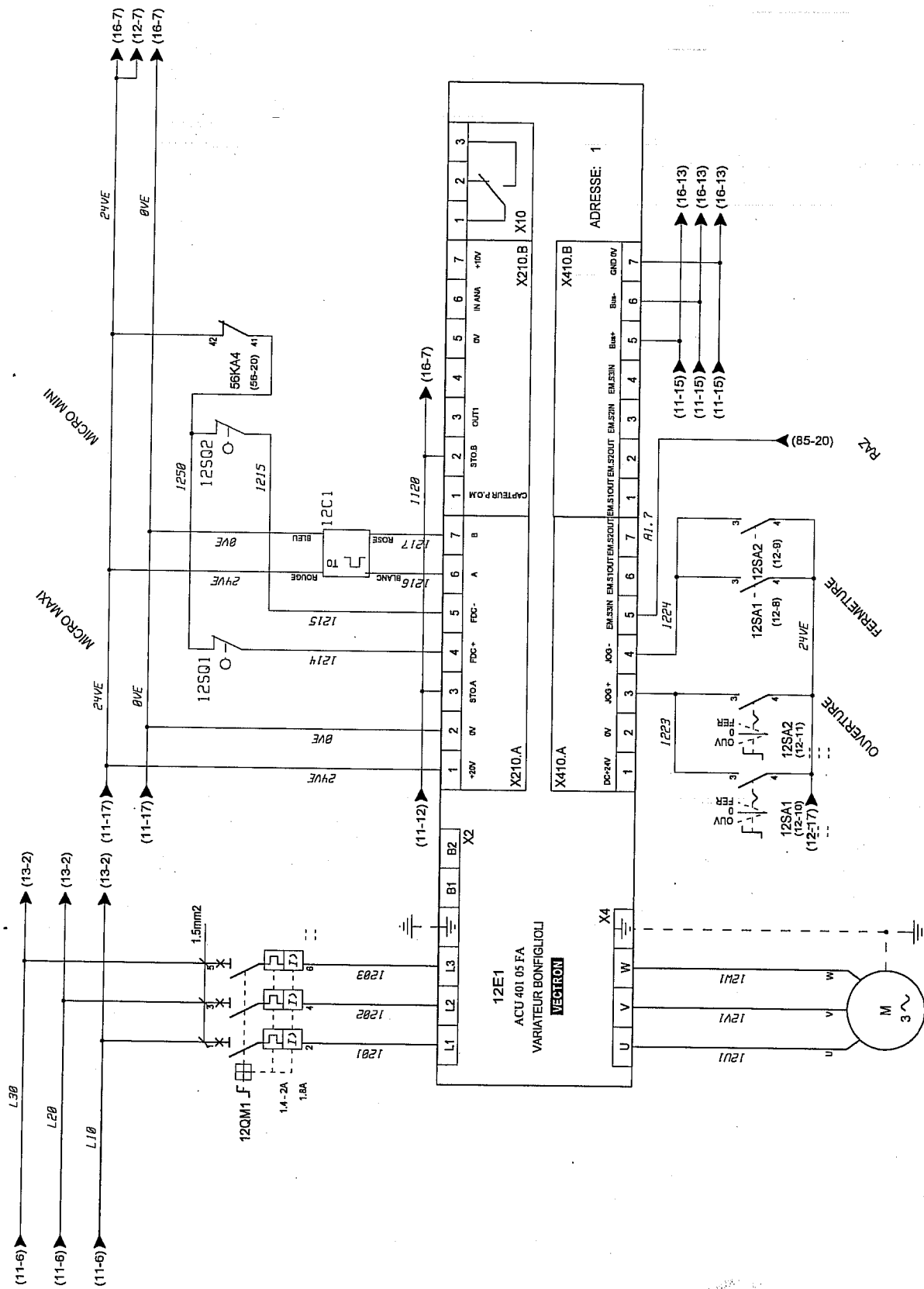


BUTEE RETOURNEUR BRAS RETOURNEUR GUIDES TABLE DE ROTATION AXE TABLE DE ROTATION



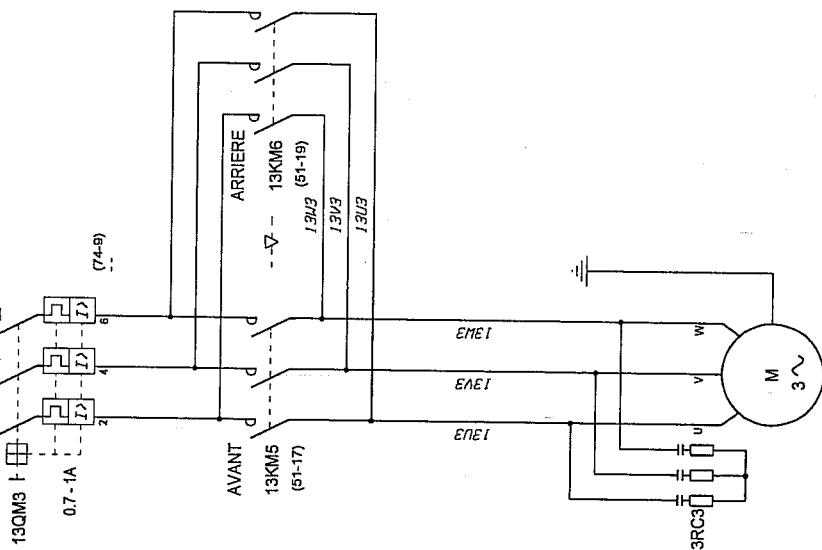
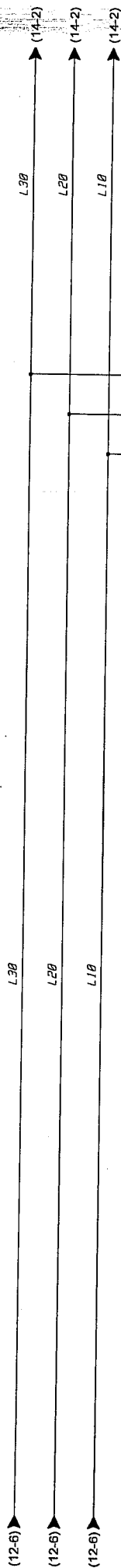


11C1: CODEUR DEPLACEMENT
11SB1: OUVERTURE REGLAGE
11SB2: FERMETURE REGLAGE
11SQ1: MICRO MAXI
11SQ2: MICRO MINI

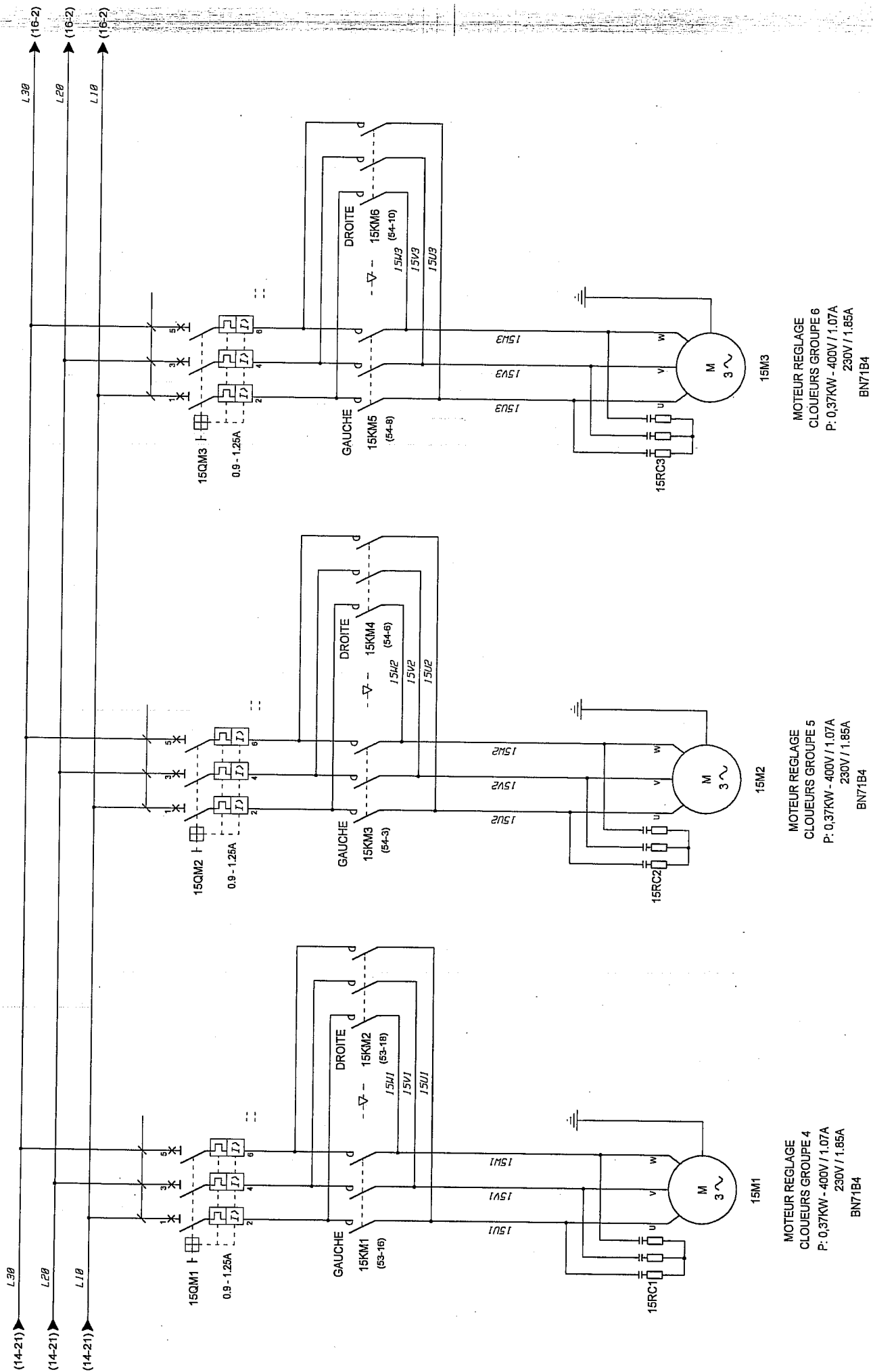


12M1
MOTEUR REGLAGE
POUTRE DROITE
P: 0,37KW - 400V / 1,07A
230V / 1,85A
BN71B4

12C1: CODEUR DEPLACEMENT
12SB1: OUVERTURE REGLAGE
12SB2: FERMETURE REGLAGE
12SQ1: MICRO MAXI
12SQ2: MICRO MINI



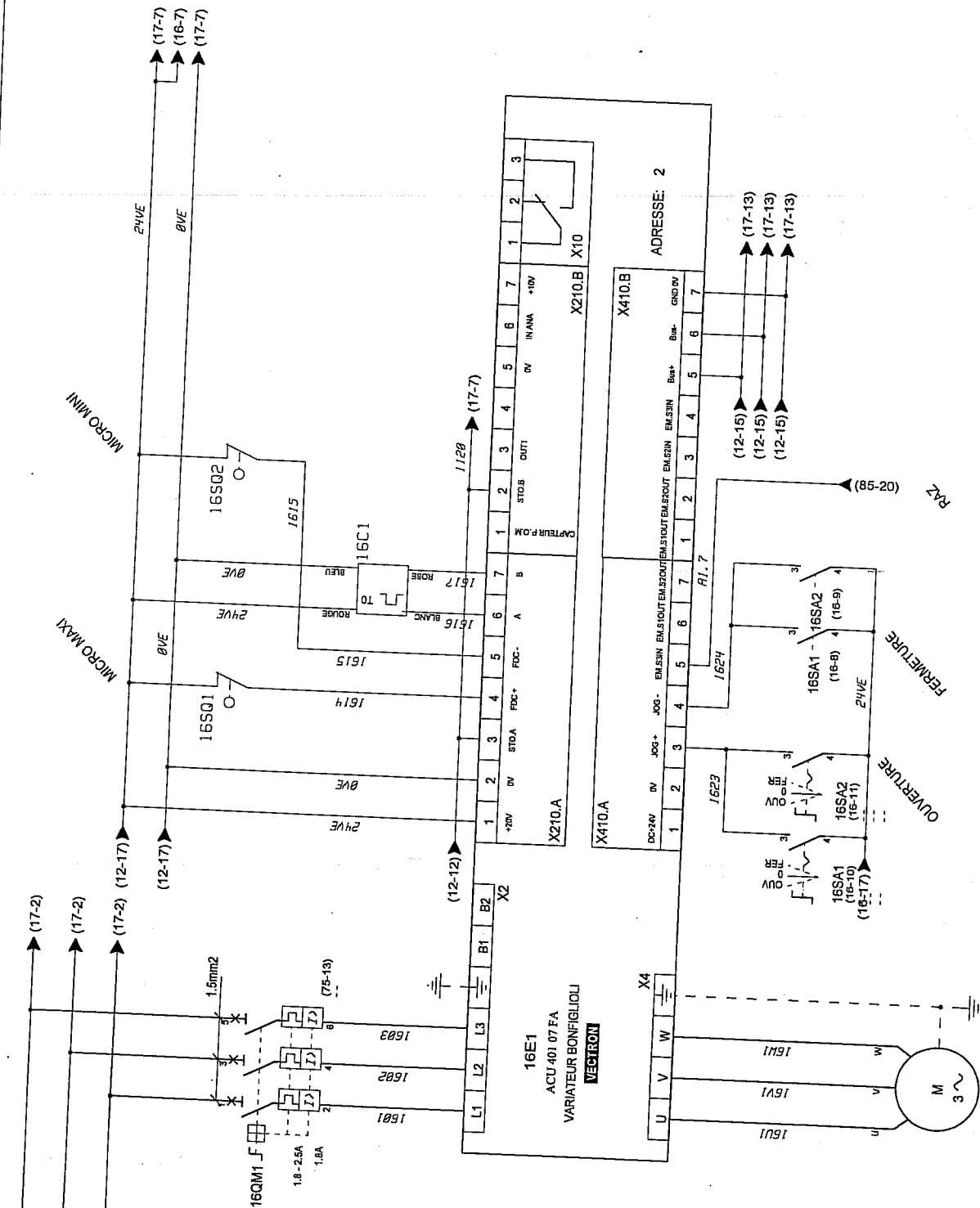
MOTEUR REGLAGE
DEPHASEUR CHAINES
P: 0.25KW - 400V / 0.76A
230V / 1.32A
BN71A4

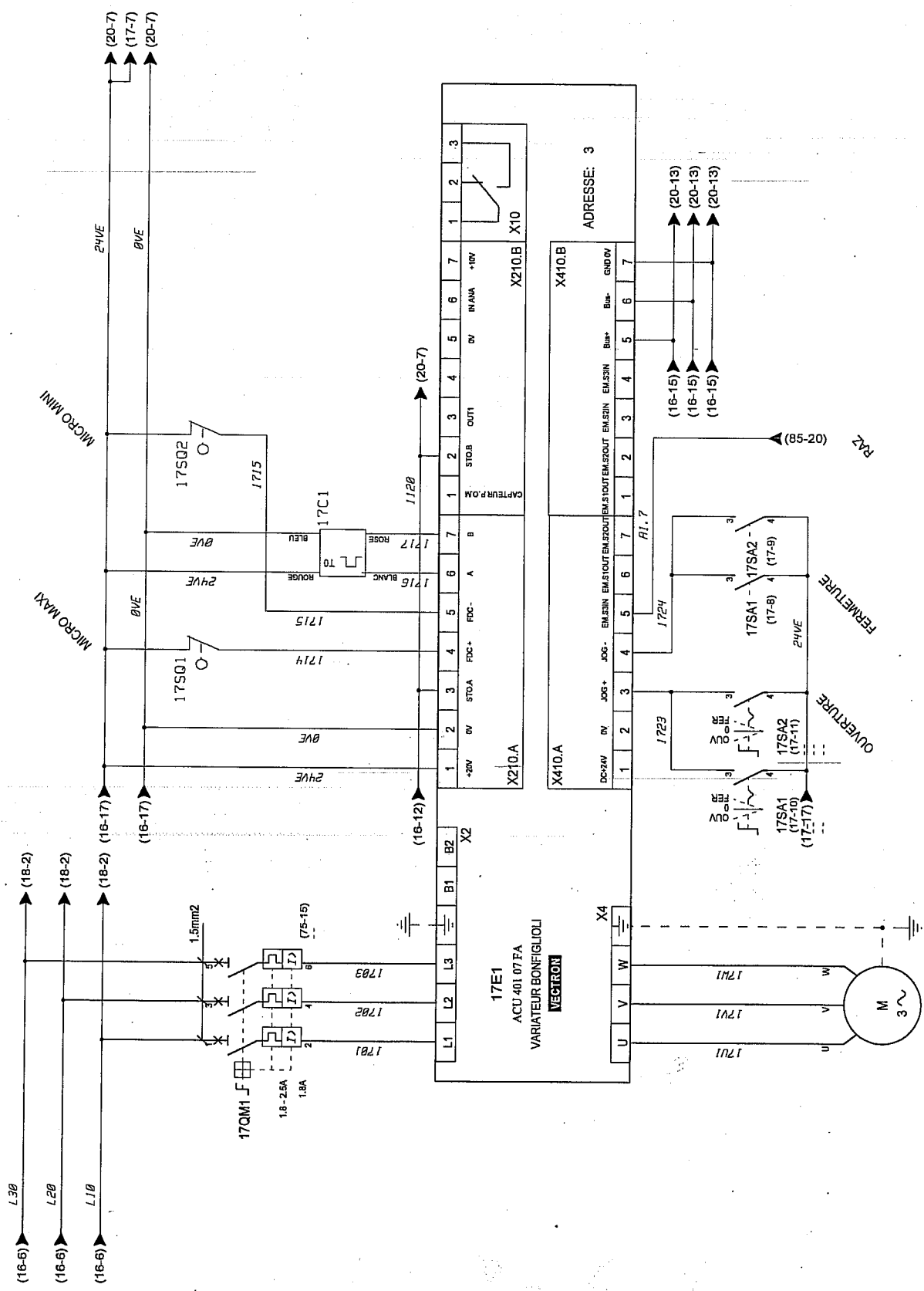


MOTEUR REGLAGE
CLOUEURS GROUPE 4
P: 0.37KW - 400V / 1.07A
230V / 1.85A
BN71B4

MOTEUR REGLAGE
CLOUEURS GROUPE 5
P: 0.37KW - 400V / 1.07A
230V / 1.85A
BN71B4

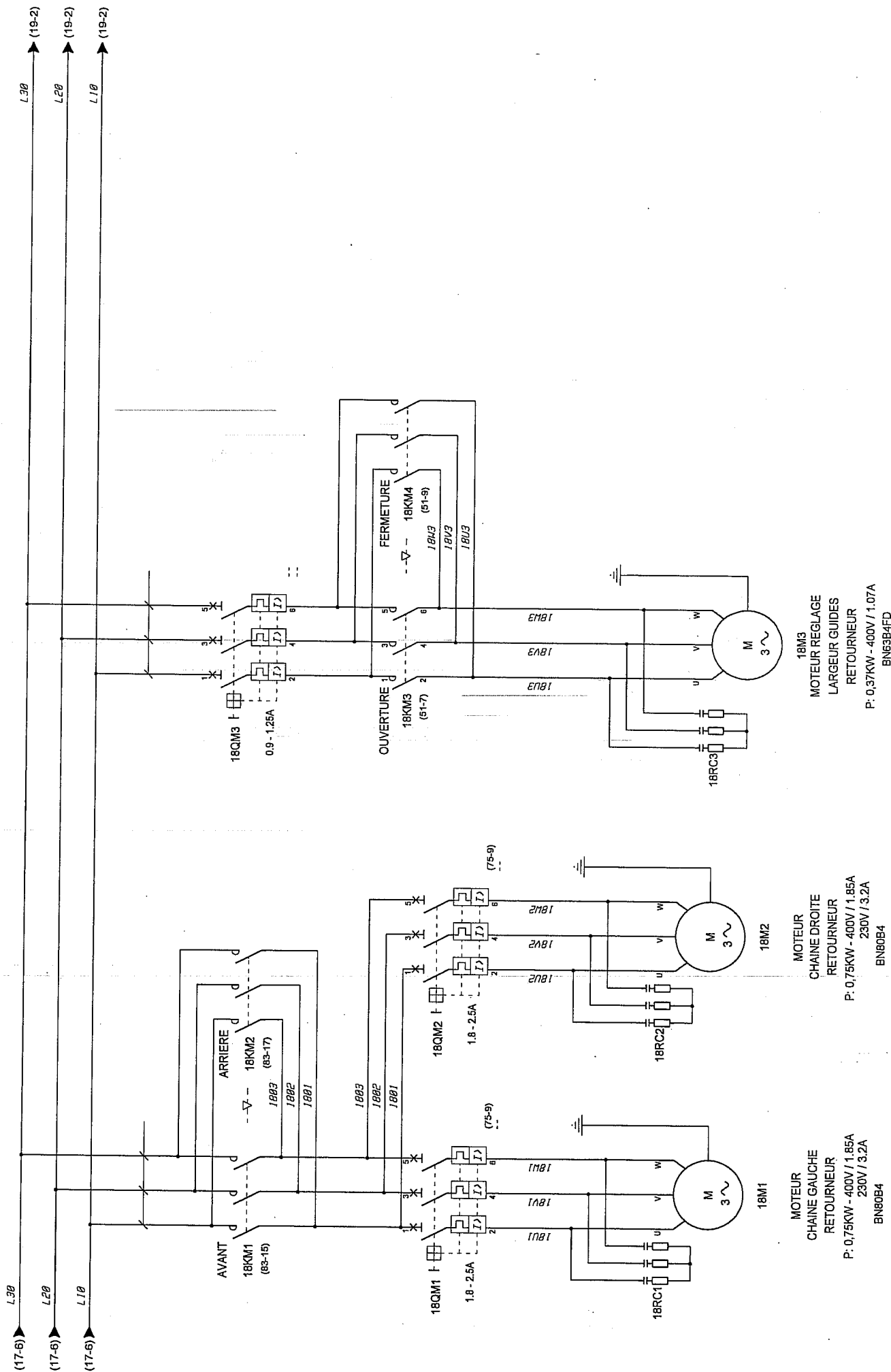
MOTEUR REGLAGE
CLOUEURS GROUPE 6
P: 0.37KW - 400V / 1.07A
230V / 1.85A
BN71B4

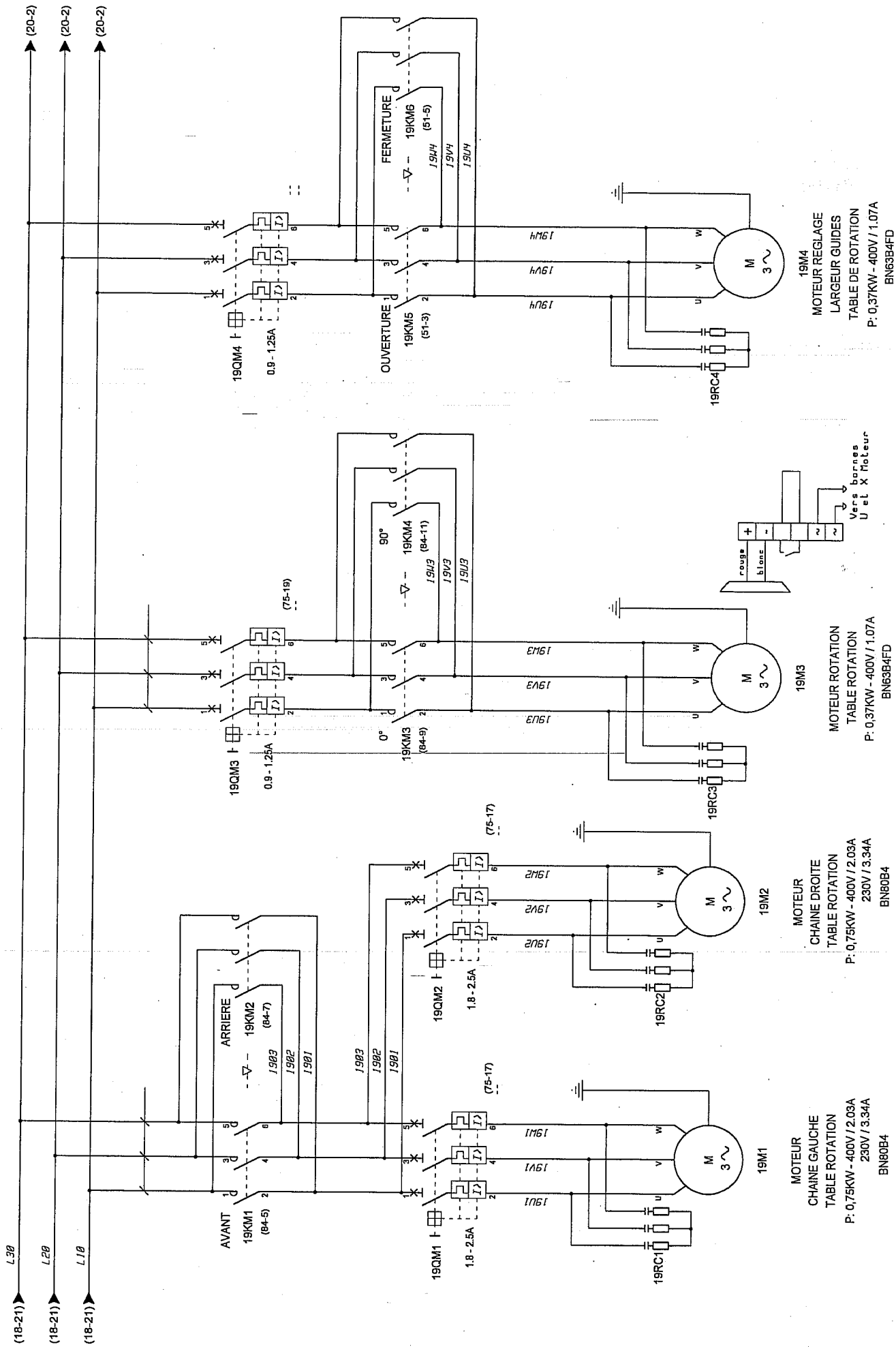


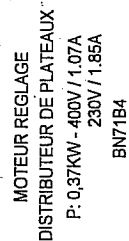


MOTEUR REGLAGE
EPAISSEURS PLANCHES SUPERIEURES
P: 0,75KW - 400V / 1,93A
230V / 3,34A
BN80B4

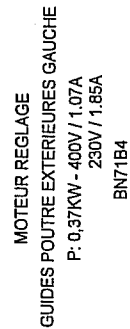
17C1: CODEUR DEPLACEMENT
17SB1: OUVERTURE REGLAGE
17SB2: FERMETURE REGLAGE
17SQ1: MICRO MAXI
17SQ2: MICRO MINI



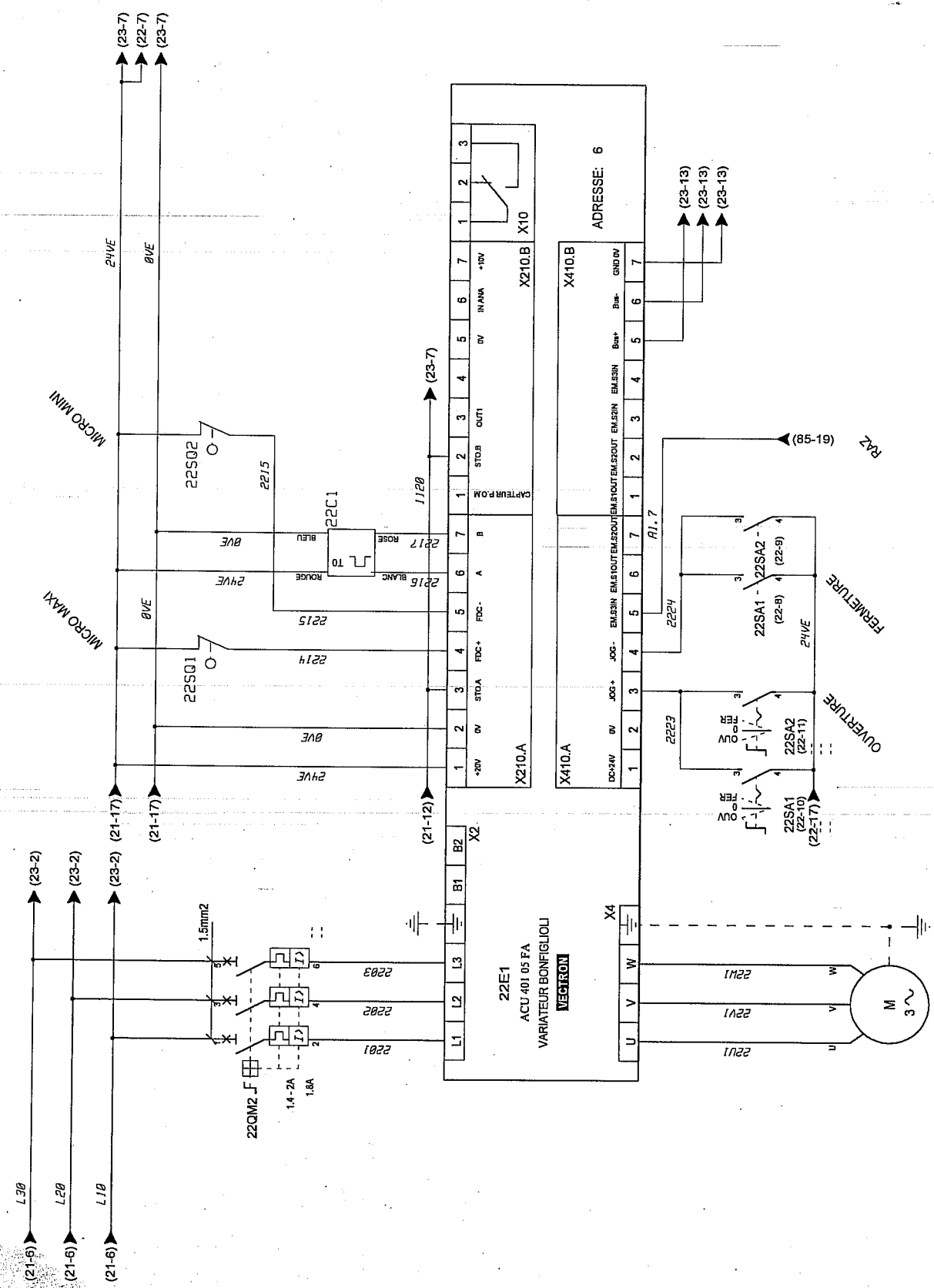




20C1: CODEUR DEPLACEMENT
20SB1: OUVERTURE REGLAGE
20SB2: FERMETURE REGLAGE
20SQ1: MICRO MAXI
20SQ2: MICRO MINI

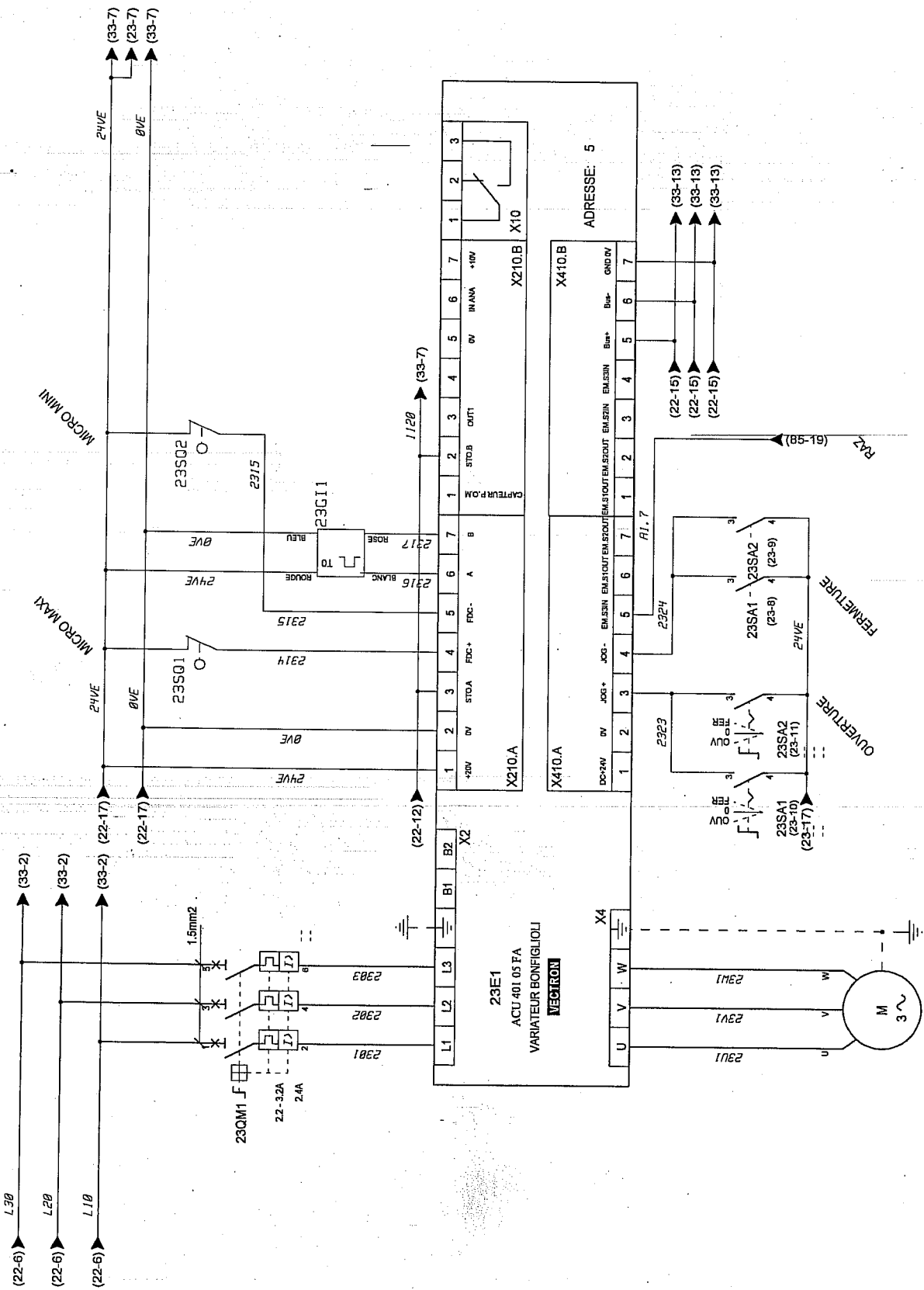


21C1: CODEUR DEPLACEMENT
21SB1: OUVERTURE REGLAGE
21SB2: FERMETURE REGLAGE
21SQ1: MICRO MAXI
21SQ2: MICRO MINI



MOTEUR REGLAGE
GUIDES POUR CENTRALE
P: 0,37KW - 400V / 1,07A
230V / 1,85A
BN71B4

22C1: CODEUR DEPLACEMENT
22SB1: OUVERTURE REGLAGE
22SB2: FERMETURE REGLAGE
22SQ1: MICRO MAXI
22SQ2: MICRO MINI



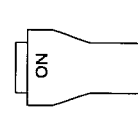
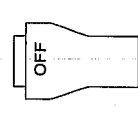
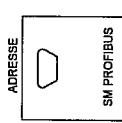
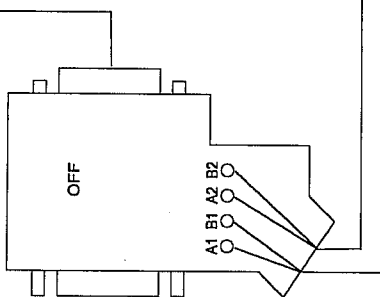
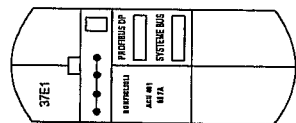
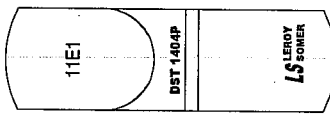
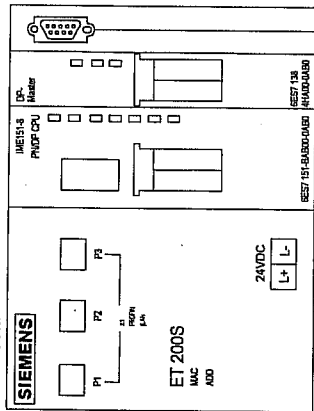
23M1
MOTEUR REGLAGE
GUIDES POUTRE DROITE
P: 0,37KW - 400V / 1,07A
230V / 1,85A
BN7184

21C1: CODEUR DEPLACEMENT
21SB1: OUVERTURE REGLAGE
21SB2: FERMETURE REGLAGE
21SQ1: MICRO MAXI
21SQ2: MICRO MINI

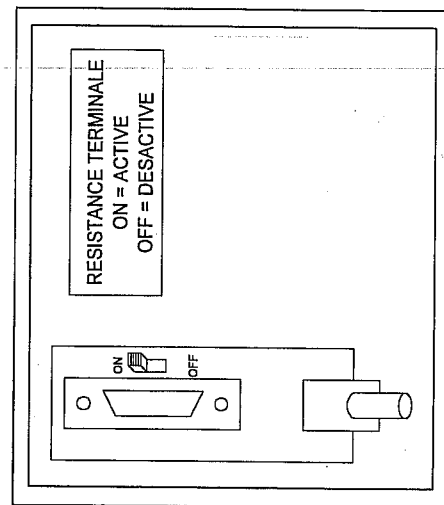
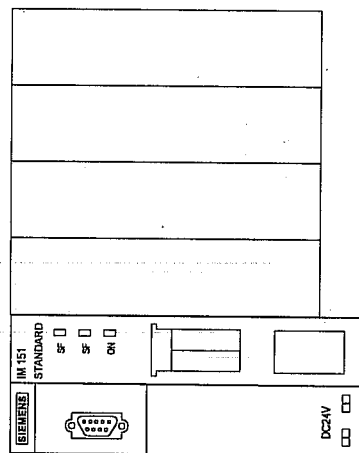
ARCHITECTURE PROFIBUS

PUPITRE CHARGEUR DE BLOCS

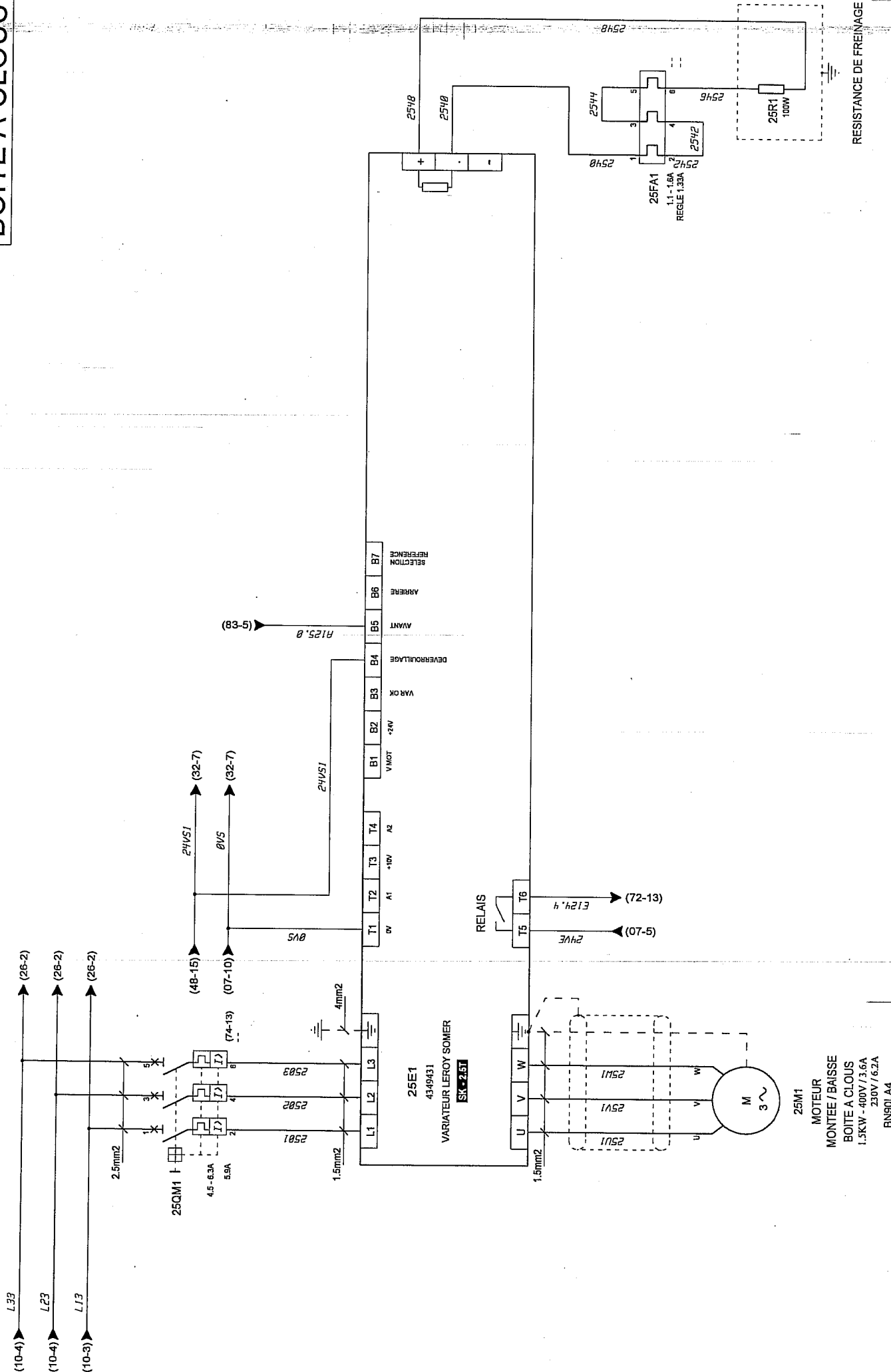
ADRESSE:



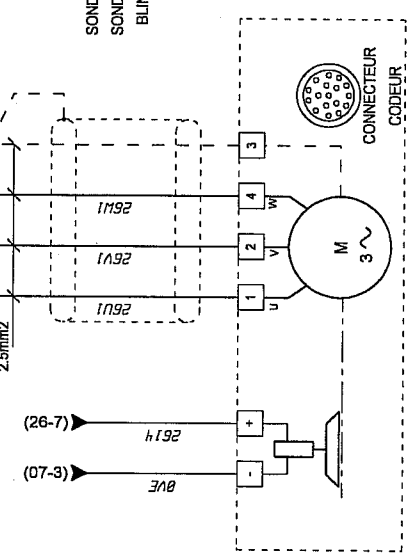
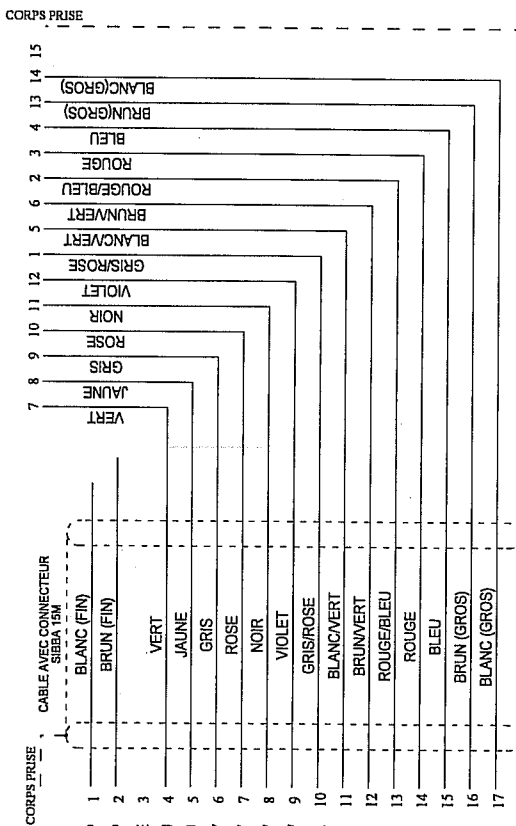
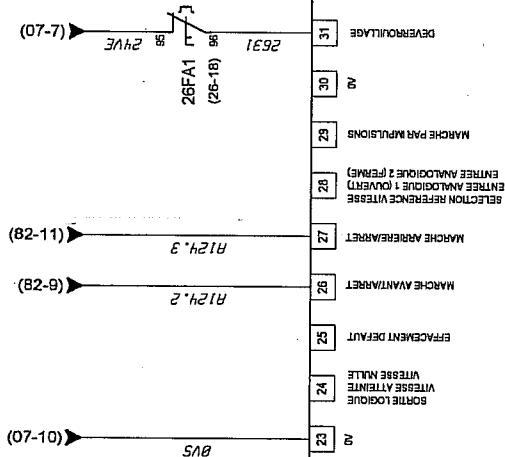
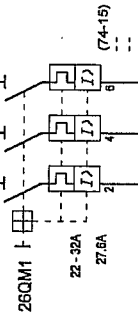
ADRESSE:



BOITE A CLOUS



CLOUAGE



RESISTANCE DE FREINAGE

SMV 142 UDE01 BACDA

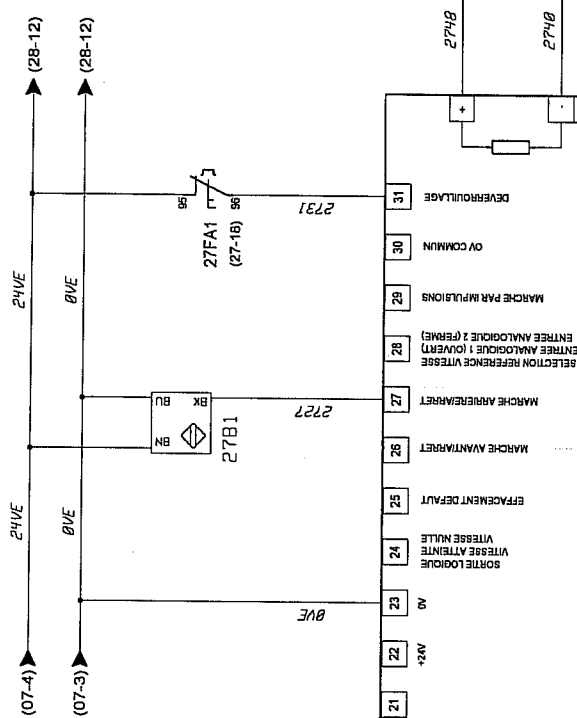
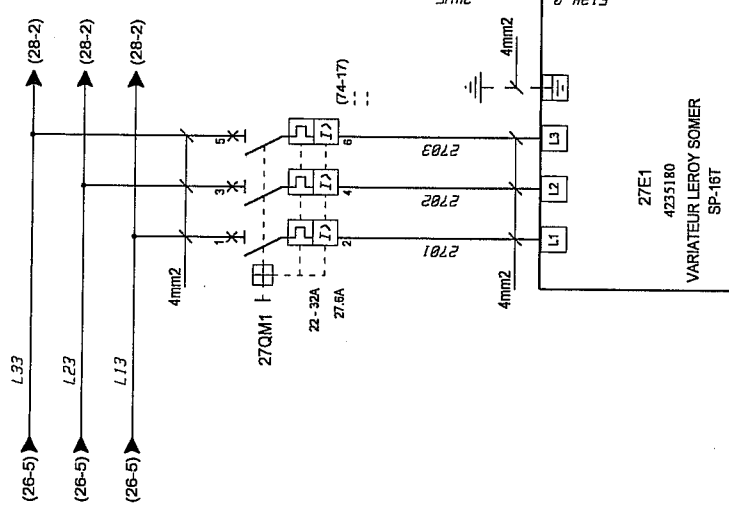
S.O.S. SODEHE

C:\SEE ELECTRICAL\EXPERT\MACHINE\PALETTE\CLOUEUSE D'ASSEMBLAGE DE BLOC\PA056 SACCHI PALLETS\

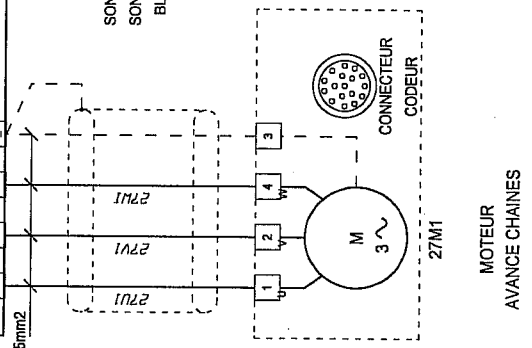
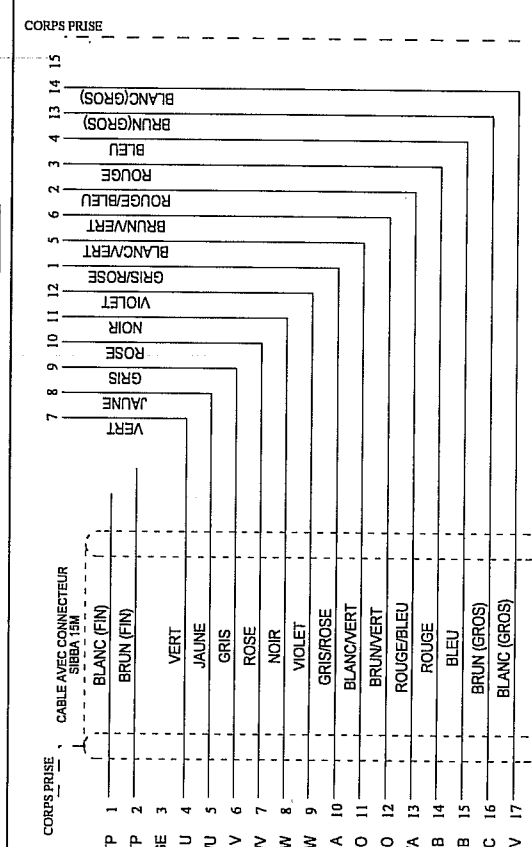
PUISSANCE

26-04-2011 26/11

AVANCE CHAINE

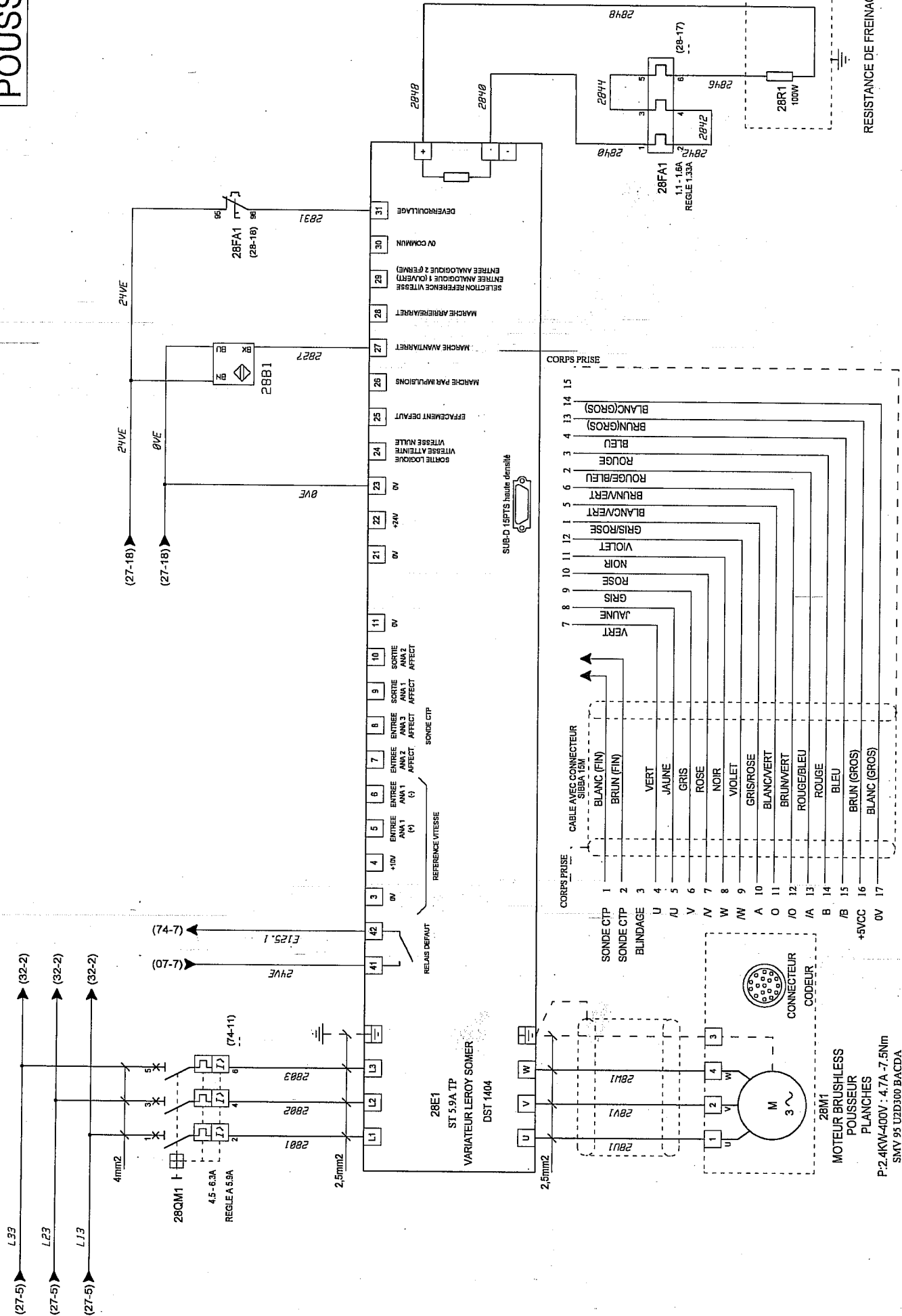


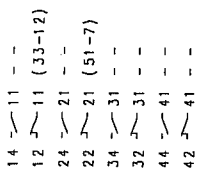
SUB-D 15PTS



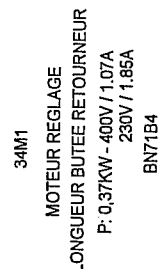
RESISTANCE DE FREINAGE

POUSSEUR

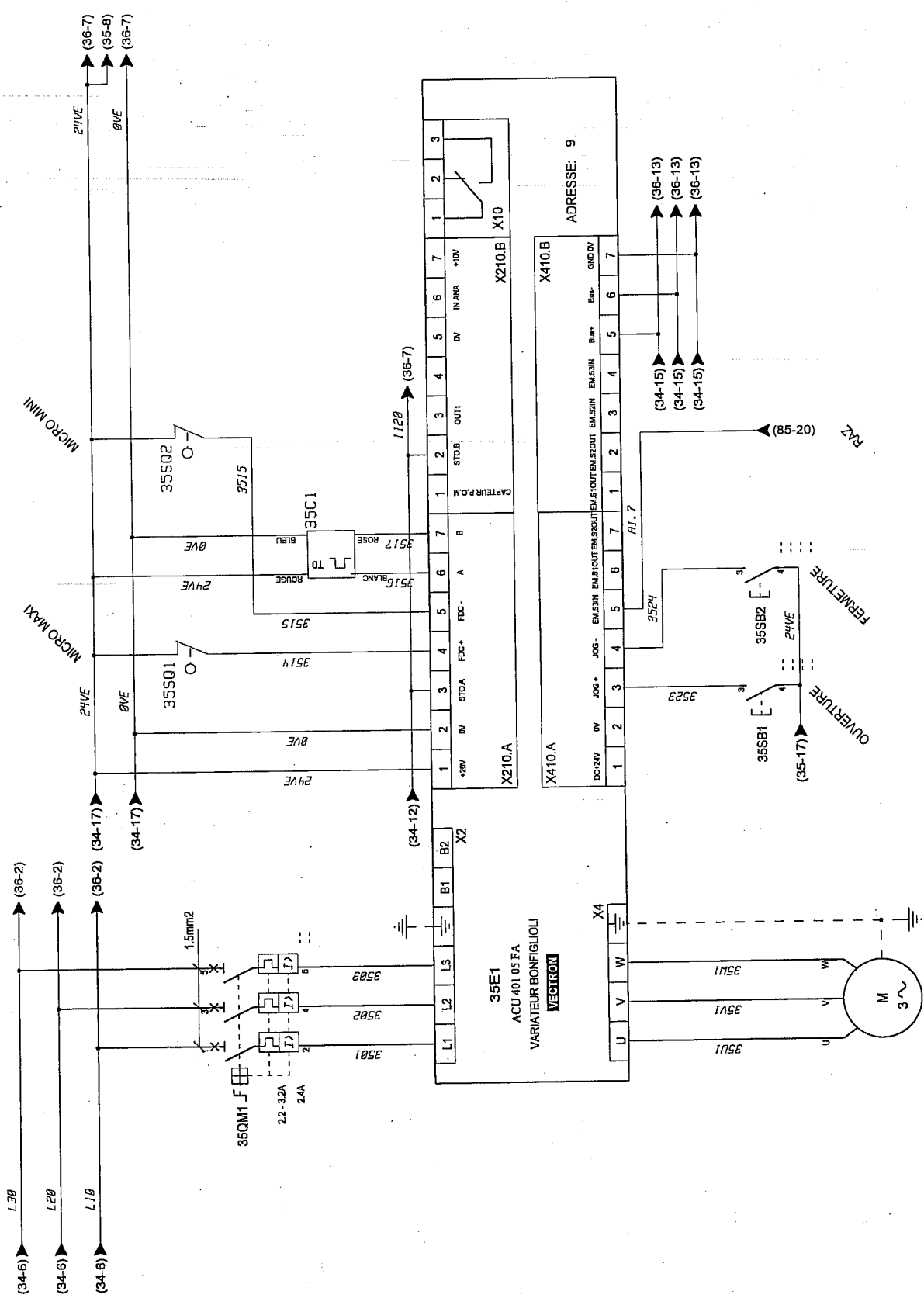




33C1: CODEUR DEPLACEMENT
33SB1: OUVERTURE REGLAGE
33SB2: FERMETURE REGLAGE
33SQ1: MICRO MAXI
33SQ2: ANTICOLLISION CHAINES

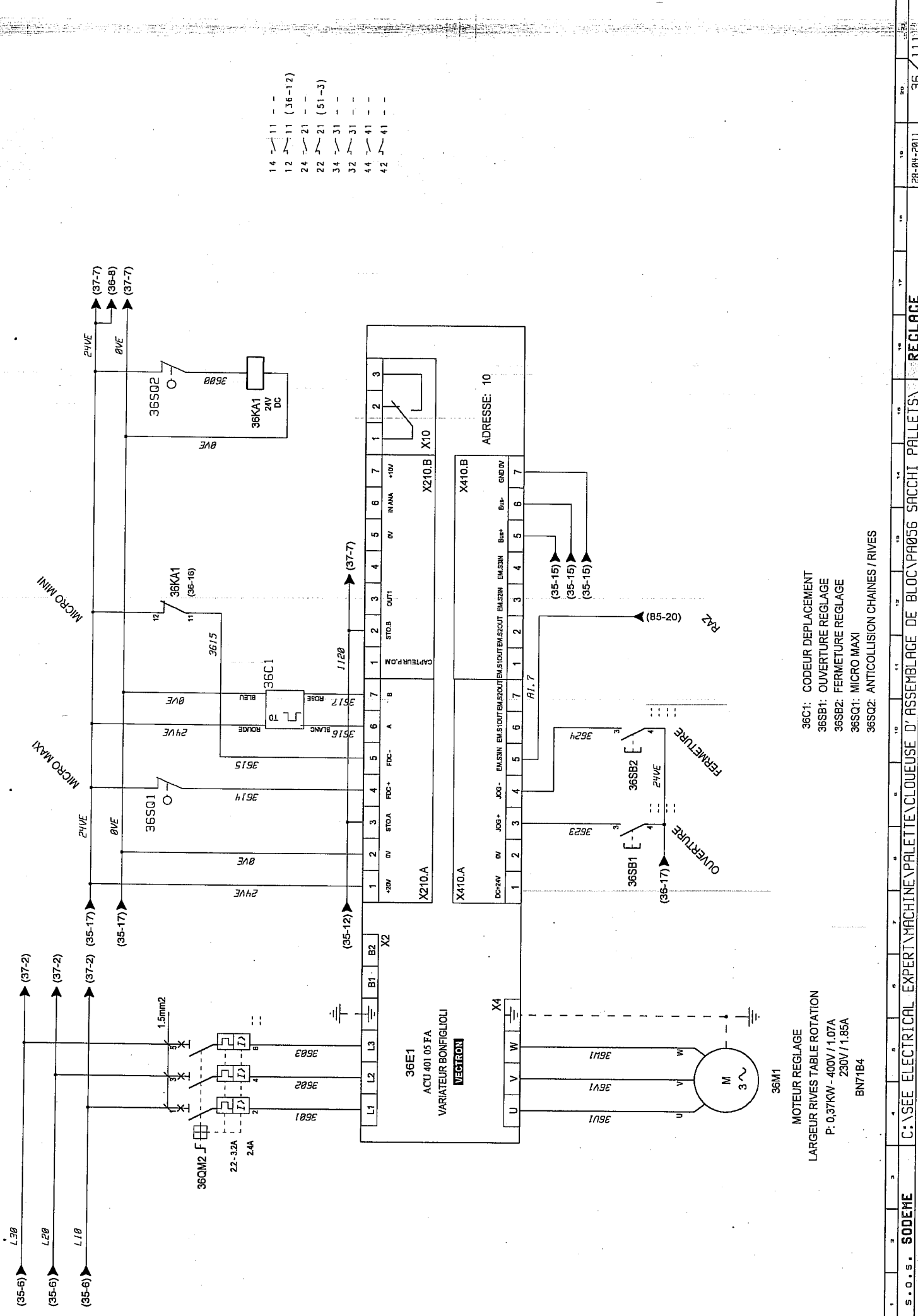


27C1: CODEUR DEPLACEMENT
27SB1: OUVERTURE REGLAGE
27SB2: FERMETURE REGLAGE
27SQ1: MICRO MAXI
27SQ2: MICRO MINI



35M1
 MOTEUR REGLAGE
 ECARTEMENT BRAS RETOURNEUR
 P: 0,37KW - 400V / 1,07A
 230V / 1,85A
 BN71B4

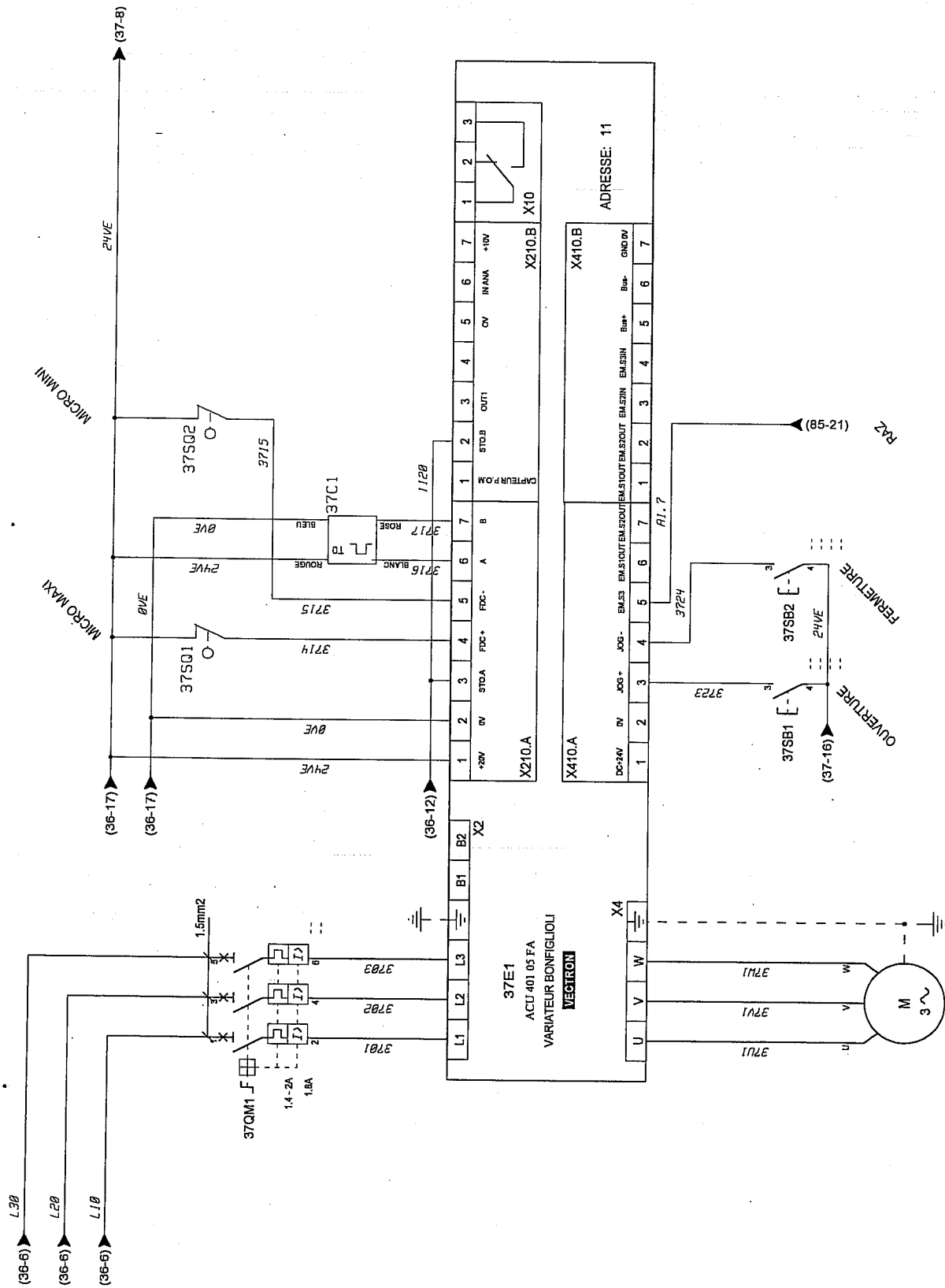
28C1: CODEUR DEPLACEMENT
 28SB1: OUVERTURE REGLAGE
 28SB2: FERMETURE REGLAGE
 28SQ1: MICRO MAXI
 28SQ2: MICRO MINI



36E1
 ACU 401 05 FA
 VARIATEUR BONFIGLIOLI
 VECTRON

36M1
 MOTEUR REGLAGE
 LARGEUR RIVES TABLE ROTATION
 P: 0,37KW - 400V / 1,07A
 230V / 1,85A
 BN71B4

36C1: CODEUR DEPLACEMENT
 36SB1: OUVERURE REGLAGE
 36SB2: FERMETURE REGLAGE
 36SQ1: MICRO MAXI
 36SQ2: ANTICOLLISION CHAINES / RIVES



37C1: CODEUR DEPLACEMENT
37SB1: OUVERTURE REGLAGE
37SB2: FERMETURE REGLAGE
37SQ1: MICRO MAXI
37SQ2: MICRO MINI

PARAMETRES DU VARIATEUR 26V1 CLOUAGE SP-16T				
PARAMETRES		VALEUR	PARAMETRES	VALEUR
0.00		0	8.01	1
0.01		0	8.02	0
0.02		1840	8.03	0
0.03		0.015	8.07	1
0.04		0.015	8.08	1
0.05		1	8.09	1
0.06		225	8.10	10.03
0.07		1500	8.11	0
0.08		100	8.12	1
0.09		-	8.13	10.33
0.14		50	8.14	0
0.15		Fast	8.15	0
0.16		RP	6.08	0
0.41		3	4.05	225
0.42		6	4.06	225
0.43		1.0	4.07	225
0.44		0		
0.45		0		
0.46		14.63		
0.47		0		
0.48		SERVO		

PARAMETRES DU VARIATEUR 27V1 AVANCE CHAINE SP-16T				
PARAMETRES		VALEUR	PARAMETRES	VALEUR
0.00		0	8.01	1
0.01		0	8.02	0
0.02		1840	8.03	0
0.03		0.015	8.07	1
0.04		0.015	8.08	1
0.05		1	8.09	1
0.06		225	8.10	10.03
0.07		1500	8.11	0
0.08		100	8.12	1
0.09		-	8.13	10.33
0.14		50	8.14	0
0.15		Fast	8.15	0
0.16		RP	6.08	0
0.41		3	4.05	225
0.42		6	4.06	225
0.43		1.0	4.07	225
0.44		0		
0.45		0		
0.46		14.63		
0.47		0		
0.48		SERVO		

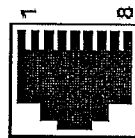
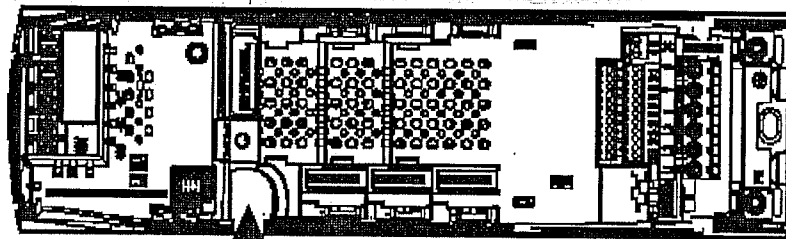
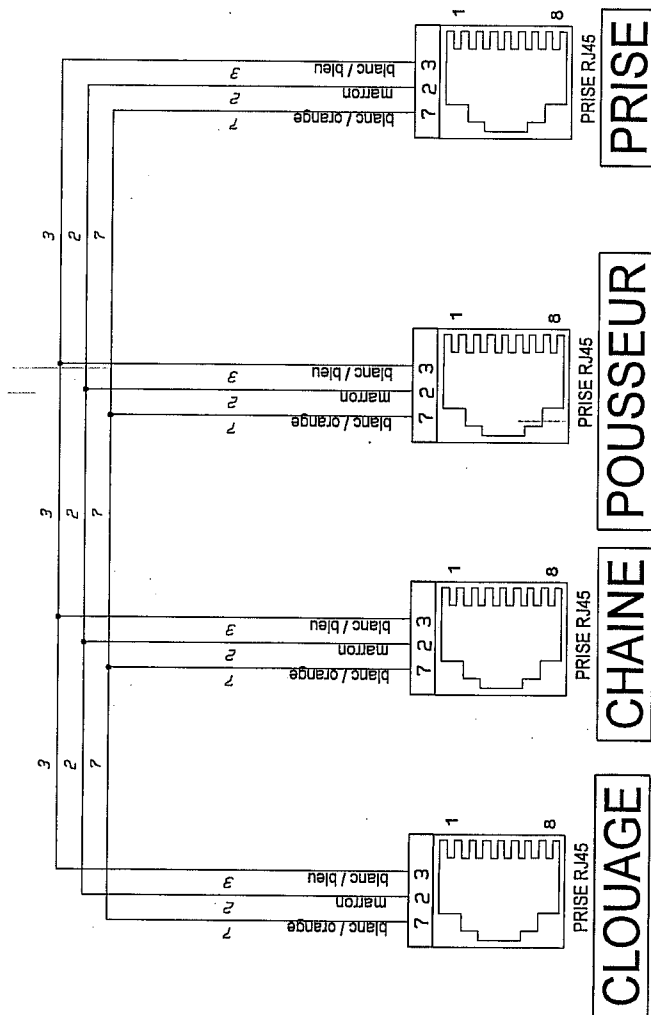
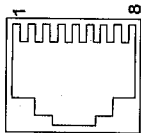
PARAMETRES DU VARIATEUR 28V1 POUSSEUR PLANCHE DST 1404 P			
PARAMETRES	VALEUR	PARAMETRES	VALEUR
0.00	0	8.01	1
0.01	0	8.02	0
0.02	1840	8.03	0
0.03	0.015	8.07	1
0.04	0.015	8.08	1
0.05	1	8.09	1
0.06	225	8.10	10.03
0.07	1500	8.11	0
0.08	100	8.12	1
0.09	-	8.13	10.33
0.14	50	8.14	0
0.15	Fast	8.15	0
0.16	RP	6.08	0
0.41	3	4.05	225
0.42	6	4.06	225
0.43	1.0	4.07	225
0.44	0		
0.45	0		
0.46	14.63		
0.47	0		
0.48	SERVO		

PARAMETRES DU VARIATEUR 25V1 BOITE A CLOUS SK - 2.5T				
PARAMETRES	VALEUR	PARAMETRES	VALEUR	
01	0	23	FR	
02	80	24	1	
03	0.3S	25	0	
04	0.1S	26	OFF	
05	PR	27	0	
06	1.07	28	NO	
07	1400 tr/min	29	NO	
08	400	30	1	
09	0.79	31	1	
10	L2	32	OFF	
11	20	33	0	
12	60	34	ON	
13	0	35	0	
14	0	36	FR	
15	1.5HZ	37	6KHZ	
16	4-20mA	38	0	
17	OFF	39	50HZ	
18	VISU DEF.	40	AUTO	
19	VISU DEF.	41	AnSI	
20	VISU DEF.	42	4.8	
21	VISU DEF.	43	1.1	
22	L0	44	2	

PARAMETRES DU VARIATEUR 32V1 BRAS RETOURNEUR SK - 3.5T				
PARAMETRES	VALEUR	PARAMETRES	VALEUR	
01	0	23	FR	
02	80	24	1	
03	0.3S	25	0	
04	0.1S	26	OFF	
05	PR	27	0	
06	2.07	28	NO	
07	1400 tr/min	29	NO	
08	400	30	1	
09	0.79	31	1	
10	L2	32	OFF	
11	20	33	0	
12	60	34	ON	
13	0	35	0	
14	0	36	FR	
15	1.5HZ	37	6KHZ	
16	4-20mA	38	0	
17	OFF	39	50HZ	
18	VISU DEF.	40	AUTO	
19	VISU DEF.	41	AnSI	
20	VISU DEF.	42	4.8	
21	VISU DEF.	43	1.1	
22	L0	44	2	

RESEAU CT-RTU

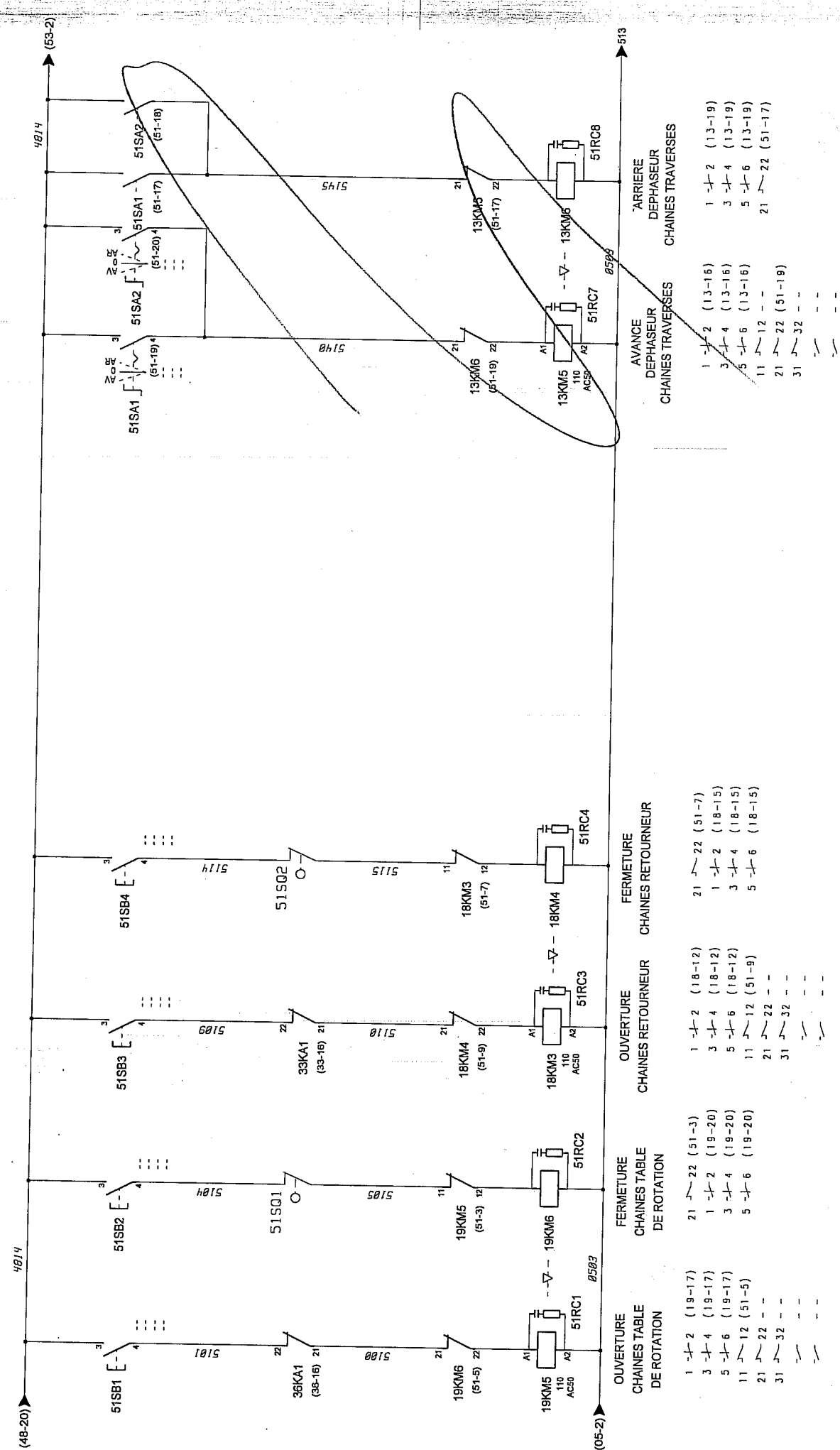
COULEUR	RJ45	Connecteur CTU
BLANC/ORANGE	1	RESISTANCE
ORANGE	2	RX-/TX-
BLANC/VERT	3	0V
BLEU	4	+24V
BLANC/BLEU	5	0V
VERT	6	VALID TX
BLANC/MARRON	7	RX+/TX+
MARRON	8	-



[illegible]

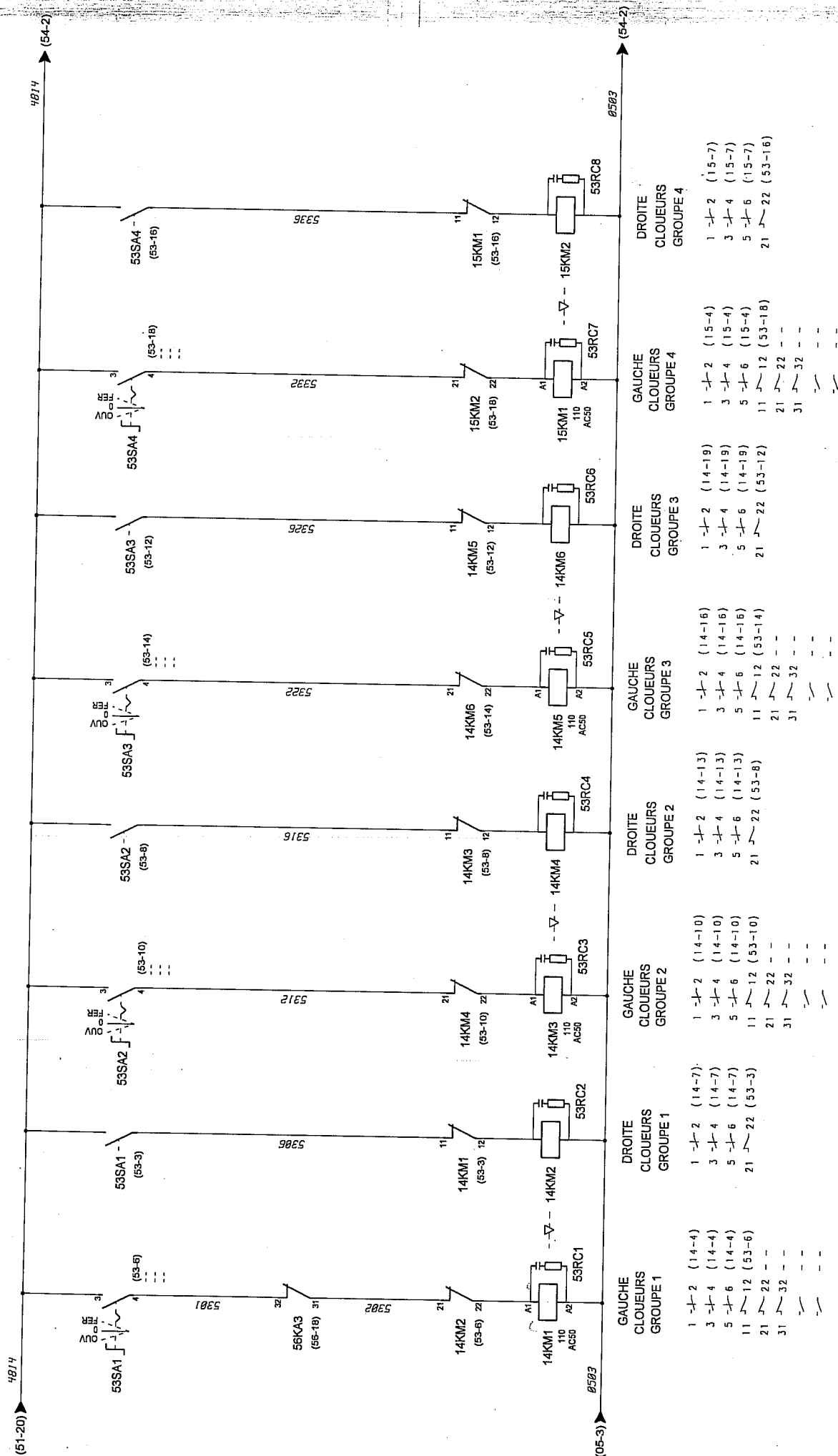
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21					
S.O.S. SODEME										C:\SEE ELECTRICAL EXPERT\MACHINE\PALETTE\CLOUSEUSE D'ASSEMBLAGE DE BLOC\PA056 SACCHI PALLETSA\											DEVELOPPE		28-04-2011		49 / 111

51SA1 : AVANT / ARRIERE DEPHASAGE PLASTRON DROIT
 51SA2 : AVANT / ARRIERE DEPHASAGE PLASTRON GAUCHE

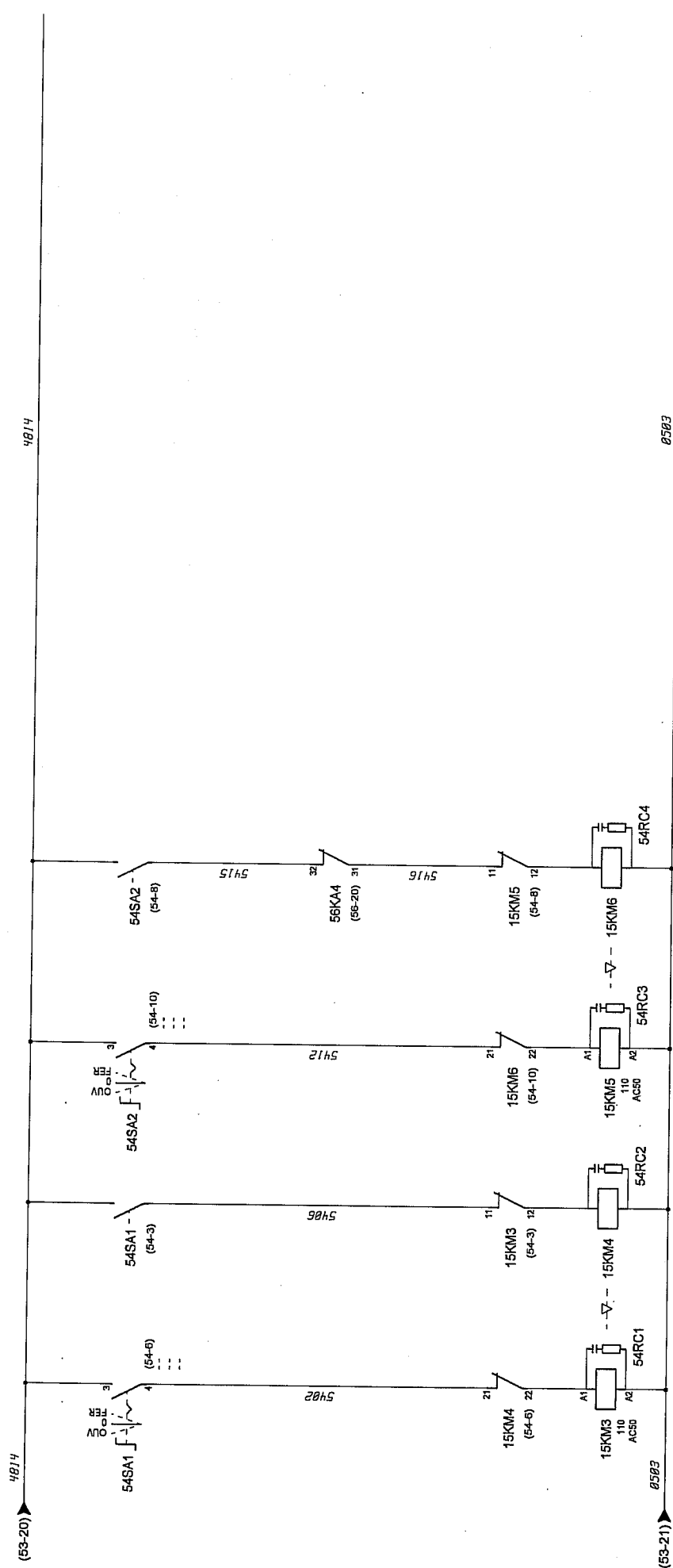


AVANCE		ARRIERE	
DEPHASEUR		DEPHASEUR	
CHAINES TRAVERSES		CHAINES TRAVERSES	
1	2	1	2
3	4	3	4
5	6	5	6
11	12	21	22
21	22	31	32
31	32		

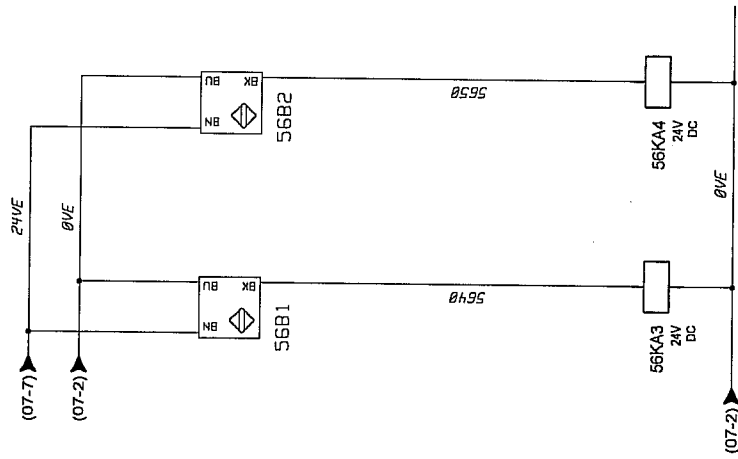
53SA1 : OUVERTURE / FERMETURE CLOUEURS GROUPE 1
 53SA2 : OUVERTURE / FERMETURE CLOUEURS GROUPE 2
 53SA3 : OUVERTURE / FERMETURE CLOUEURS GROUPE 3
 53SA4 : OUVERTURE / FERMETURE CLOUEURS GROUPE 4



54SA1 : OUVERTURE / FERMETURE CLOUEURS GROUPE 5
 54SA2 : OUVERTURE / FERMETURE CLOUEURS GROUPE 6

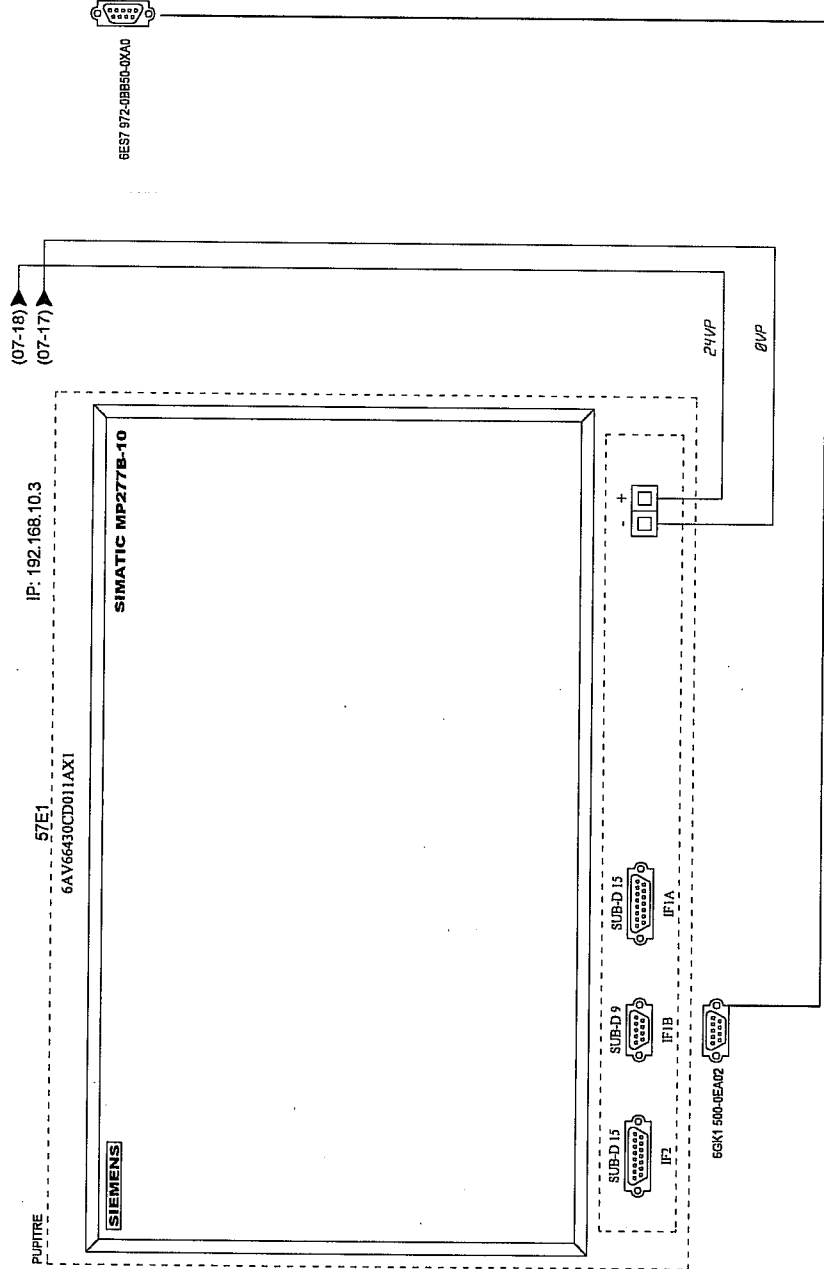


GAUCHE CLOUEURS GROUPE 5		DROITE CLOUEURS GROUPE 5		GAUCHE CLOUEURS GROUPE 6		DROITE CLOUEURS GROUPE 6	
1	2	1	2	1	2	1	2
15-10	15-10	15-13	15-16	15-16	15-16	15-19	15-19
3	4	3	4	3	4	3	4
15-10	15-10	15-13	15-16	15-16	15-16	15-19	15-19
5	6	5	6	5	6	5	6
15-10	15-10	15-13	15-16	15-16	15-16	15-19	15-19
11	12	11	12	11	12	11	12
54-6	54-6	54-3	54-10	54-10	54-10	54-8	54-8
21	22	21	22	21	22	21	22
31	32	31	32	31	32	31	32
-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-



ANTI COLLISION		ANTI COLLISION	
LONGERON GAUCHE		LONGERON DROIT	
GROUPE CLOUEUR N°1		GROUPE CLOUEUR N°6	
14	11	14	11
12	11	12	11
24	21	24	21
22	21	22	21
34	31	34	31
32	31 (53-3)	32	31 (54-10)
44	41	44	41
42	41 (11-14)	42	41 (12-13)

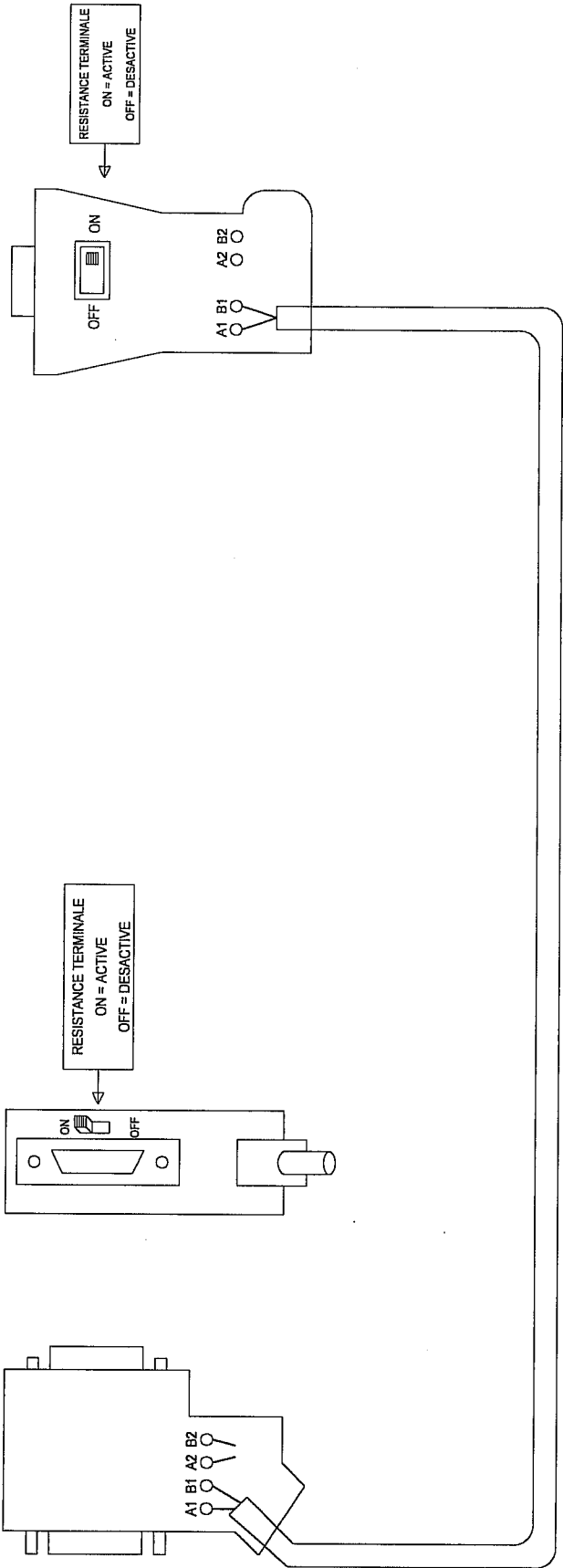
AFFICHEUR SIEMENS MP277B

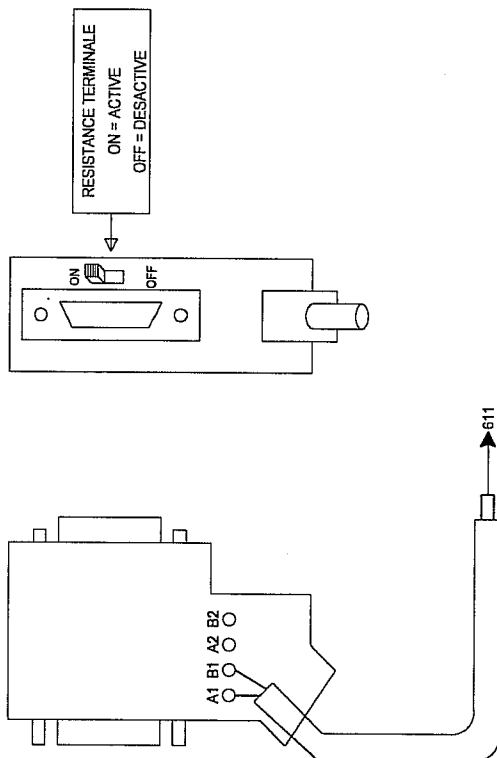
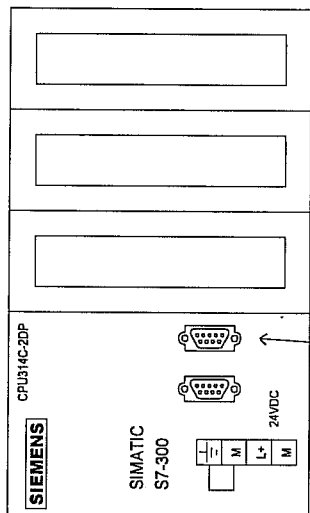


LIAISON AUTOMATE <----> MP277B-10P

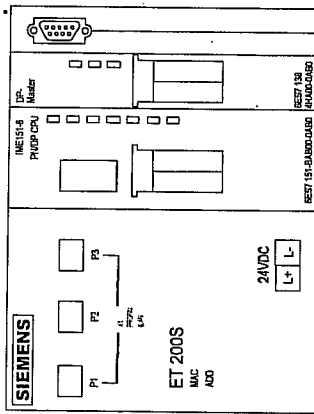
COTE AUTOMATE S7-300
CONNECTEUR 6ES7 972-0BB50-0XA0

COTE PUPITRE OPERATEUR MP277B-10
CONNECTEUR 6ES7 500-0FC00

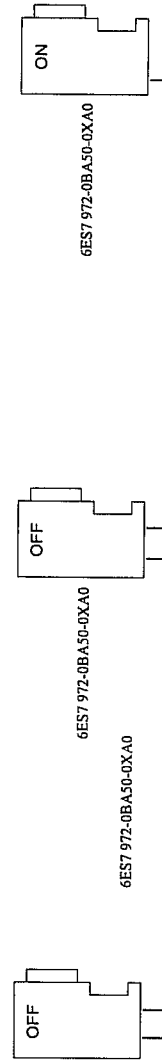
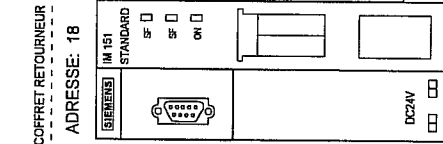
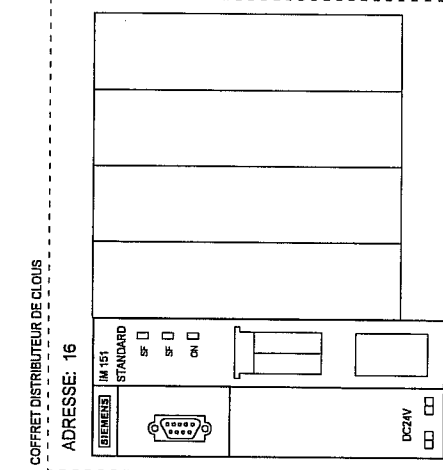
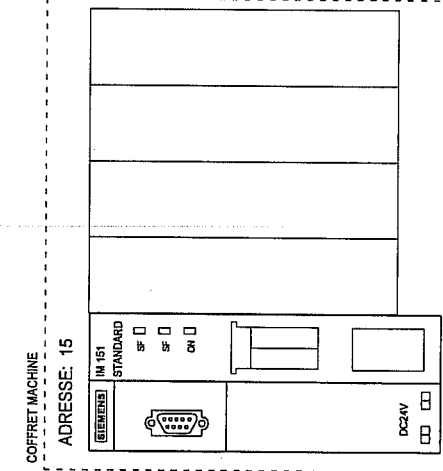
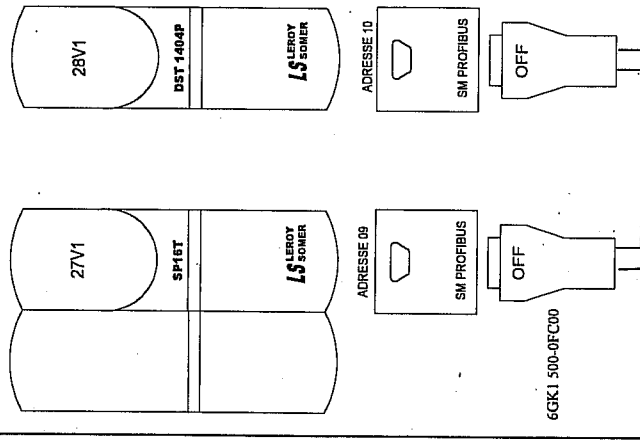
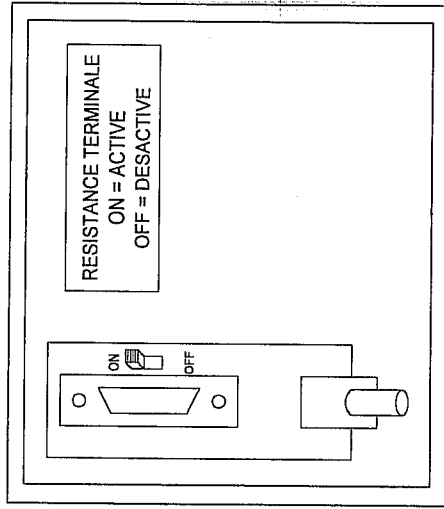
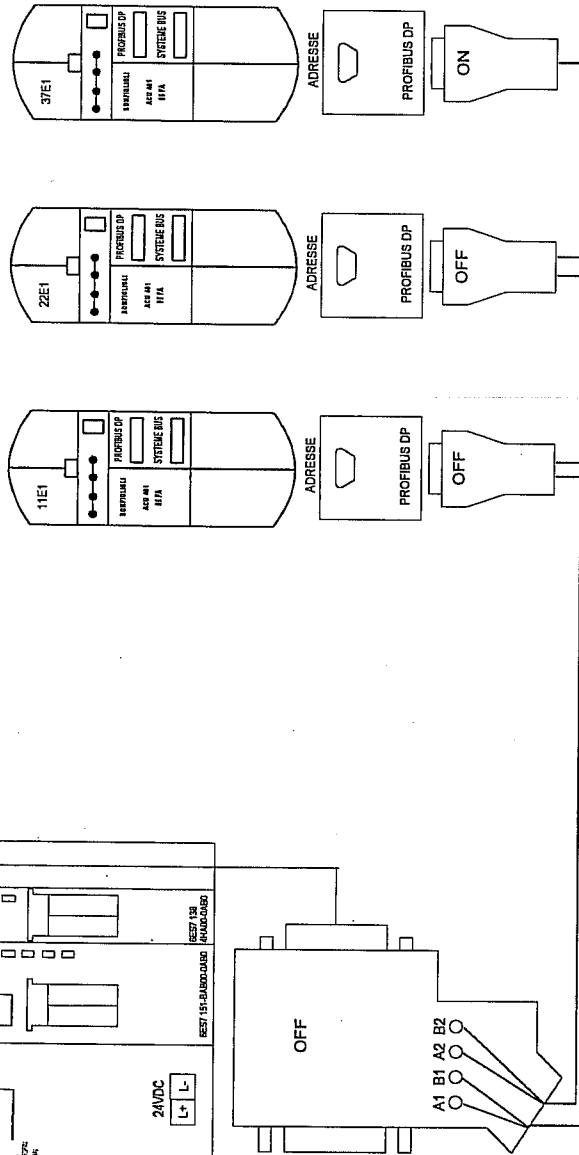




ADRESSE:



ARCHITECTURE PROFIBUS



The diagram illustrates a PROFIBUS DP network configuration. It features a central horizontal bus line. On the left side, there are nine slave stations (11E1 to 36E1) and one master station (37E1) on the right. Each station is represented by a rectangular block with a 'PROFIBUS DP' section on the left and a 'SYSTEME BUS' section on the right. The 'PROFIBUS DP' section includes a 'PROFIBUS DP' label and a 'SYSTEME BUS' label. The 'SYSTEME BUS' section includes a 'SYSTEME BUS' label and a 'SYSTEME BUS' label. The stations are connected to the central bus line via a series of switches labeled 'OFF' and 'ON'. The master station (37E1) is connected to the bus line via a switch labeled 'ON'. The slave stations are connected to the bus line via switches labeled 'OFF'.

CONFIGURATION CPU SIEMENS ARMOIRE

CPU

69E1	SIEMENS ET200S	IM151 STANDARD	PM-E DC 24V	8DI DC 24V	8DI DC 24V	8DI DC 24V	8DI DC 24V	8DI DC 24V	PM-E DC 24V	8DO DC 24V/0.5A	8DO DC 24V/0.5A	8DO DC 24V/0.5A	8DO DC 24V/0.5A	8DO DC 24V/0.5A	8DO DC 24V/0.5A	FIN DE LIGNE
70E1																
72E1																
74E1																
75E1																
76E1																
78E1																
79E1																
80E1																
82E1																
83E1																
84E1																
85E1																

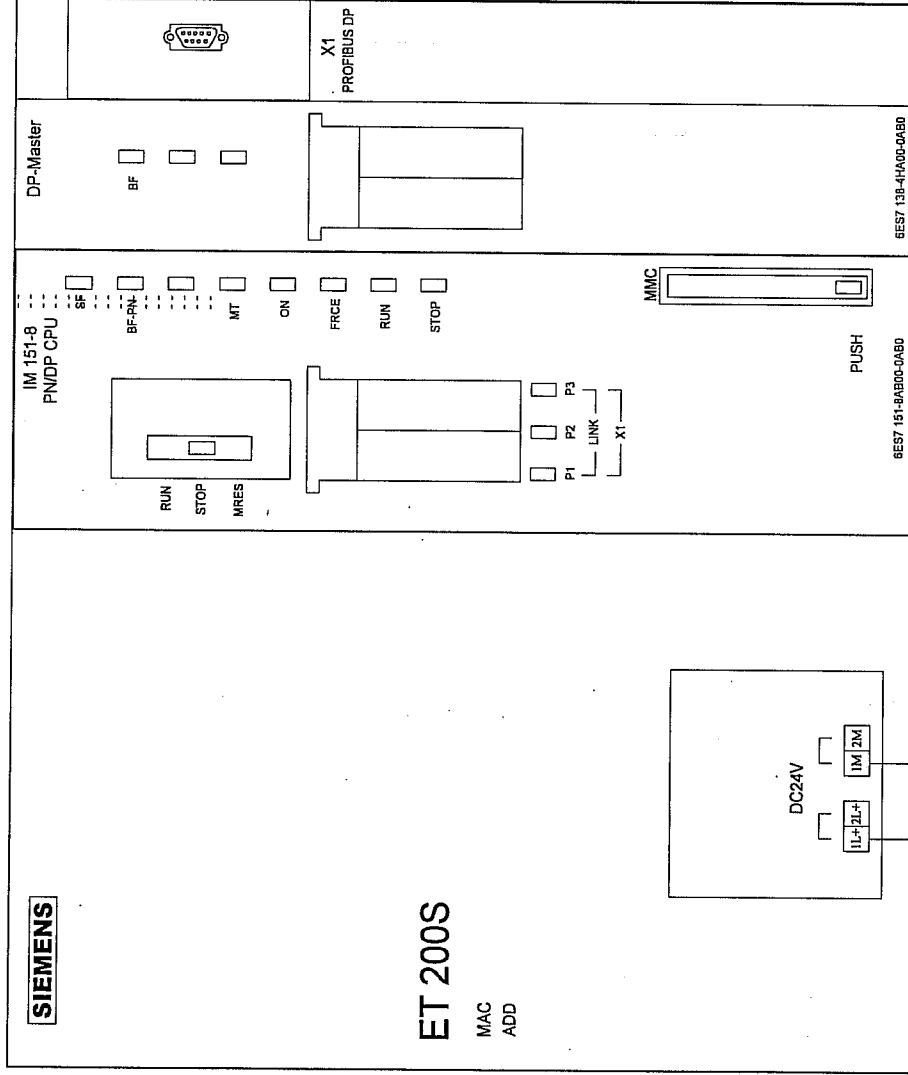
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69E1
6ES7 151-8AB00-0AB0

SIEMENS

ET 200S

MAC
ADD



LIAISON AUTOMATE <----> VARIATEURS

