SAH3-PLC Touch Screen Control System
Non-woven bag system
Version Ver2.0

User
Manual

瑞安市辉煌工控设备厂

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一、 Introduction

SAH3-PLC touch screen control system is a factory specially developed for high-speed high-precision fixed-length control of NC product. By high-speed dedicated motion control PLC touch screen, as well as Taiwan and step (servo) motor component. Intuitive operation is simple, widely used in various types of high-speed cross-cutting machine, computer bag machine, woven bag machine and printing, packaging, food, light industry and other industries need to fixed-length control the machine.
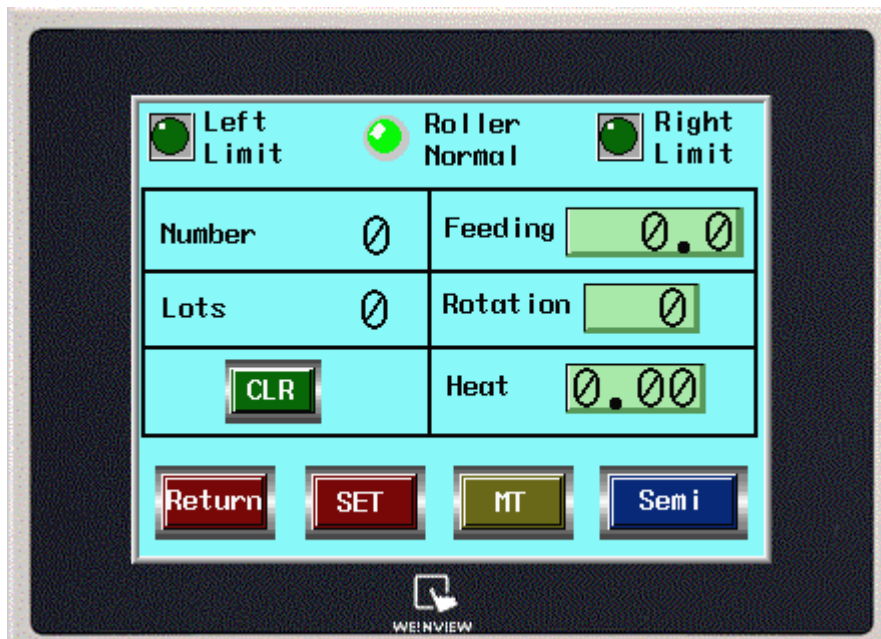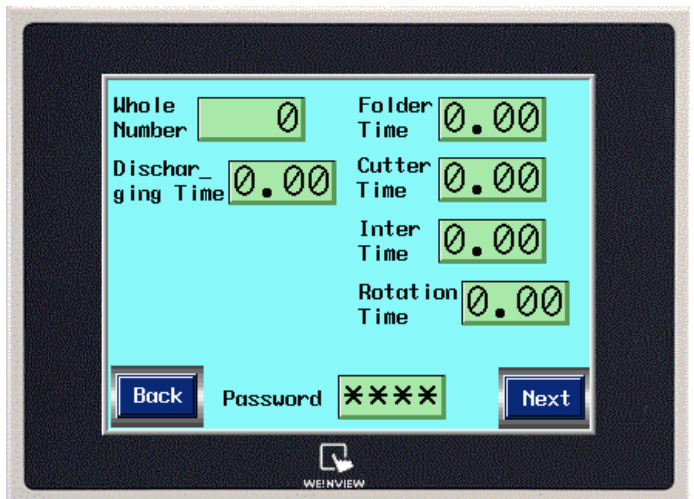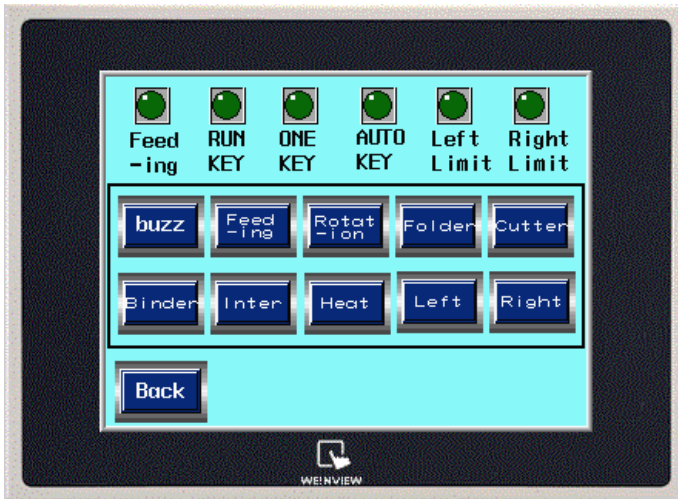
二、 Control panel

➤ Boot screen

- Press the button to enter the Chinese Chinese menu, press the button to enter the English menu, English

➤ Main Screen

Parameters	Description	MIN	MAX	Initial	Units
Main screen parameter					
Wheel condition	Wheel current state（normal⇔ERR）	pilot lamp			
Left limit	Limit the left wheel position (X1 port)	pilot lamp			
Right limit	Roller right extreme position (X2 port)	pilot lamp			
Number	The number of the current work	0	9999	0	
Lots	The current number of batches of work	0	9999	0	
CLR	Press the number of the Qing, the number of zero, the number of the Qing approved	pilot lamp			
Feeding	The length of the current crop	5.0	999.9	25	mm
Rotation	The current angle of rotation	1	360	90	Deg
Heat	Sealing of the working hours	0	9.99	0.50	S
Cover	To return to the boot screen	KEY			
SET	Enter the parameter setting screen	KEY			
Manual	Manual work to enter the screen	KEY			
MODE	Semi⇔AUTO Select the machine works	KEY			
Manual Work Screen					
Feeding step	Feeding step, the light	pilot lamp			
RUN	Run the switch to open when the light (X0 port)	pilot lamp			
Single Switch	Point second switch open, the light (X4 port)	pilot lamp			
Auto Switch	Automatic switch to open when the light (X3 port)	pilot lamp			
Left limit	Left limit in place, the light (X1 port)	pilot lamp			
Right limit	Limit the right place, the light (X2 port)	pilot lamp			
Speaker	Is pressed, the speaker output (Y6 port)	KEY			
Feeding	Pressed when the feeding step to send a feed	KEY			
Rotation	When pressed, spin rotation step once	KEY			
Folder Material	Is pressed, the clip materials solenoid valve output (Y2 port)	KEY			
Cutter	Is pressed, the cutter solenoid valve output	KEY			

|	(Y3 port)				
Binder	When pressed, the pressure is expected solenoid valve output (Y7 port)	KEY			
Interpolation	When pressed, which push the solenoid valve output (Y4 port)	KEY			
Heat	Is pressed, the sealing solenoid valve outputs (Y0 port)	KEY			
Left	Is pressed, the wheel stepping to the left to go	KEY			
Right	Is pressed, the wheel to the right step to go	KEY			
Back	Return to the main screen	KEY			
Parameter is set to screen first floor					
The whole number of	The number of single-batch	6	9999	100	张
Cutter Delay	Delay wheel cutter and working hours	0	9.99	0.05	S
Cutter Time	Cutter's working hours	0	9.99	0.20	S
Rotational latency	Delayed rotation step of working hours	0	9.99	0.10	S
Switch Delay	Running Time delay switch	0	9.99	0.05	S
Discharging time	The waiting time for discharge	0	9.99	0.30	S
Password	The lower screen to enter the password	0	9999	0008	
Back	Return to the main screen				
Next	Access to the lower screen (when the password is correct)				
Parameter is set to the second level screen					
Roller Length	Restrictions on the length of roller	100	2000	1000	mm
Roller Speed	Roller of working speed	0	99	15	%
Roller Diameter	The diameter of the feed roller	10.00	99.99	32.50	mm
Feeding speed	Feeding rate of step	0	9	1	d
Default	Initialize all the parameters	KEY			
Password	The lower screen to enter the password	0000	9999	2858	
The third layer parameter setting screen					
Change Password	Change Password	0000	9999	2858	
Limited number of batches	Limited number of batches	0000	9999	0	
Back	Return to the main screen				

Note: To enable the approved limit the number of functions, according to the following methods to set,

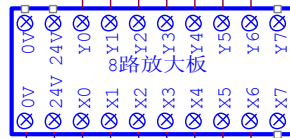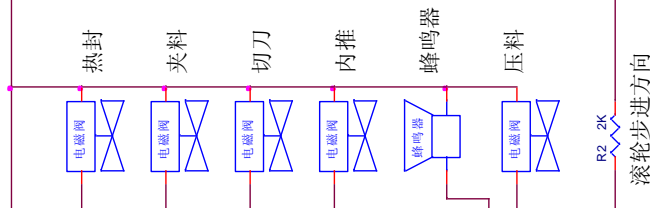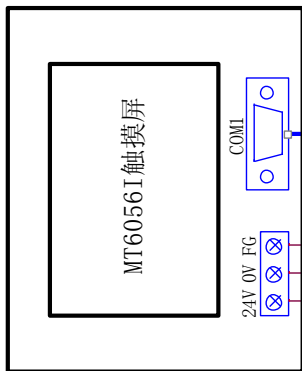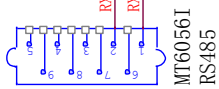λ into the second layer of screen, enter the factory password 2858

λ into the third layer of the screen, set up to limit the number of grant
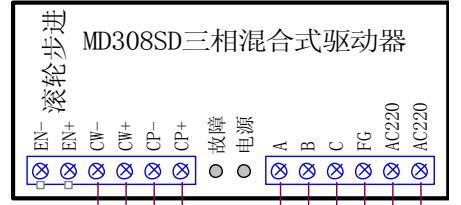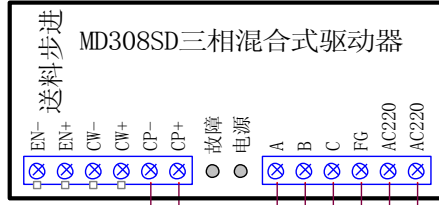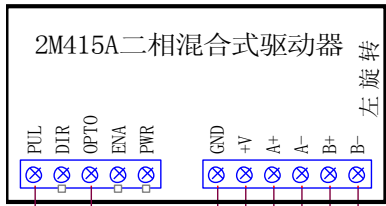
λ change the factory password, remember password for your own good

λ To Jilao modified password, if the password is forgotten, only to return for board factory, and remember

三、 Installation dimensions

204mm

SCH-1定长控制器
（面板）

150mm

138mm

192mm

开孔尺寸：
SCH-1/SCH-2：
192mm W x 138mm H
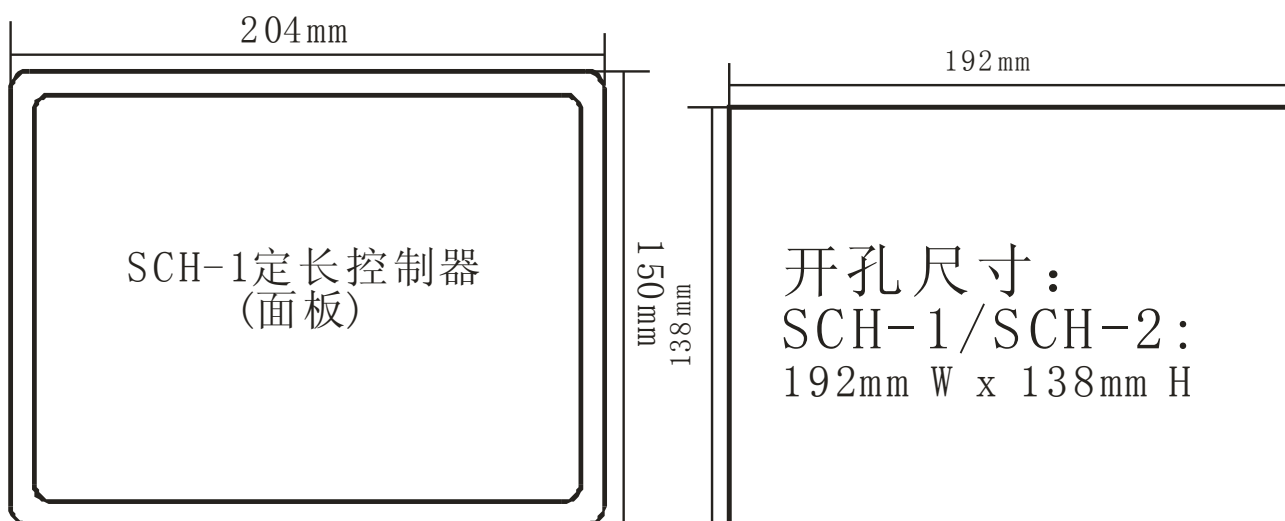
➢ feed, wheel pulse of 800-step（S1=OFF，S2=ON，S3=ON，S4=OFF），
Current 5A（I1=OFF，I2=ON），

➢ Rotary pulse of 1 / 8 sub（SW1=ON，SW2=ON，SW3=OFF），
Current 0.84A（SW4=OFF，SW5=OFF，SW6=ON）

四、 Wiring diagram

2M415A二相混合式驱动器　右旋转

PUL DIR OPTO ENA PWR　GND +V A+ A- B+ B-

0V 24V　+V+V

步进电机

2M415A二相混合式驱动器　左旋转

PUL DIR OPTO ENA PWR　GND +V A+ A- B+ B-

0V 24V　+V+V

步进电机

MD308SD三相混合式驱动器　送料步进

EN- EN+ CW- CW+ CP- CP+　故障 电源　A B C FG AC220 AC220

步进电机　220V 220V　机架地

MD308SD三相混合式驱动器　滚轮步进

EN- EN+ CW- CW+ CP- CP+　故障 电源　A B C FG AC220 AC220

步进电机　220V 220V

热封 夹料 切刀 内推 蜂鸣器 压料

电磁阀 电磁阀 电磁阀 电磁阀 蜂鸣器 电磁阀

R2 2K　滚轮步进方向

SAH2-PLC RS485

6 7 8 9
1 2 3 4 5

D+ D-

RX+ RX-

MT6056I RS485

8路放大板

0V 24V Y0 Y1 Y2 Y3 Y4 Y5 Y6 Y7
0V 24V X0 X1 X2 X3 X4 X5 X6 X7

MT6056I触摸屏

COM1

24V 0V FG

弱点地

SAH2-PLC

V+ Y0 Y1 Y2 Y3 Y4 Y5 Y6 Y7 Y8 Y9 10 11 12 13 FG V- V+

A+ A- B+ B-

M X0 X1 X2 X3 X4 X5 X6 X7 M X8 X9 10 11 12 13 M L+

弱点地　0V 24V

100W开关电源

24V 0V FG

~220V

弱点地

限位 限位 踏运行 动/手动 次

接近开关 接近开关

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