

WinMulti - IO Screens - Autoflow

This page shows each of the IO Screens on an Autoflow and describes each Input/Output

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 ...Please note: this section is now contained within the link below

Stuga Machine IO Dictionary - Inputs

On an Autoflow machining centre there are 3 IO Screens

- 1. 1. IO
- 2. 2. IO-Infeed
- 3. 3. Spindle IO

each of these has a section below with a table describing each input and output.

Autoflow Main IO Screen



Autoflow Main IO Screen

Autoflow Main Inputs

Module A - Infeed Table

Sensor	Description	Sensor	Description
InA_GripperOff	Gripper Slip Sensor	InA_48vOk	48v Ok (No Errors)
InA_Measure1	Offcut Measure Sensor 1	InA_AirOk	Air Supply OK
InA_Measure2	Offcut Measure Sensor 2	InA_Grip	Gripper Sensor (Profile in place)
InA_GZHome	Gripper Z Axis Home	InA_EStop	Emergency Stop State
InA_GYHome	Gripper Y Axis Home	InA_ButStart	Start Button
InA_GXHome	Gripper X Axis Home	InA_ButStop	Stop Button
InA_MatLoad1	Material Load Sensor 1	InA_ButReset	ES Reset Button
InA_MatLoad2	Material Load Sensor 2	InA_ButEstop1	Emergency Stop Button 1
InA_Index	Infeed Table Index Position	InA_ButEstop2	Emergency Stop Button 2
InA_VCUOk	VCU Ok (No Errors)	InA_ButEstop3	Emergency Stop Button 3
InA_Bus415Ok	Bus415Ok (No Errors)	InA_ButAuto	Auto Load Button
InA_Bus415SOk	Bus415S Ok (No Errors)	InA_MatAtFence	Material At Back Fence Sensor
InA_24vBusOk	24v Bus Ok (No Errors)	InA_StopOver	Profile Stop
InA_24vModOk	24v Module Ok (No Errors)	InA_ButLoad	Load Button

Module B - Multihead

Sensor	Description	Sensor	Description
InB_YHome	Y Axis Home Switch	InB_ClampOSH	Clamp Outfeed Side Home
InB_ZHome	Z Axis Home Switch	InB_ClampITH	Clamp Infeed Top Home
InB_RHome	R Axis Home Switch	InB_ClampISH	Clamp Infeed Side Home
InB_ClampOTH	Clamp Outfeed Top Home	InB_OilerOK	Oiler OK (No Errors)

Module F - Saw and Outfeed

Sensor	Description	Sensor	Description
InF_SYHome	Saw Y Axis Home (forward/back)	InF_EjectHm	Ejector Home
InF_SZHome	Saw Z Axis Home (up/down)	InF_EjectOu	Ejector Out

InF_SRHome	Saw R Axis Home (rotation)	InF_AdvanceB	Saw Outfeed Advance Button
InF_EjPushHm	Eject Pusher Home	InF_InvSawOk	Saw Invertor OK (No Errors)
InF_EjPushOu	Eject Pusher Out	InF_InvExtract	Extractor Invertor OK
InF_ClampOTH	Clamp Outfeed Top Home	InF_ConvOvIO	Conveyor Overload
InF_ClampOSH	Clamp Outfeed Side Home	InF_TiltHm	Saw Blade Tilt Home (vertical)
InF_ClampITH	Clamp Infeed Top Home	InF_TiltOu	Saw Blade Tilt Out (tilted)
InF_ClampISH	Clamp Infeed Side Home	InF_GtOpen	Gate Open
InF_RollerITHm	Roller Infeed Top Home	InF_GtClosed	Gate Closed
InF_48vOk	48v Ok (no errors)	InF_GuardFront	Front Door
InF_24vBusOk	24v Bus Ok (no errors)	InF_GuardRear	Rear Door
InF_24vModOk	24v Module Ok (no errors)	InF_OffFull	Outfeed Full Sensor
		InF_ButEstop4	Emergency Stop Button 4

Autoflow Main Outputs

Module A – Infeed Table

Output	Description	Output	Description
OuA_CtrlOn		OuA_PopUp	Profile Stop Popup
OuA_Grip	Gripper	OuA_StopX	Profile Stop In/Out
OuA_GripBlow	Gripper Blower	BrakesOff	Drive Brakes
OuA_LoadBlow	LoadBlower	OuA_GripTurn	Gripper Turned?

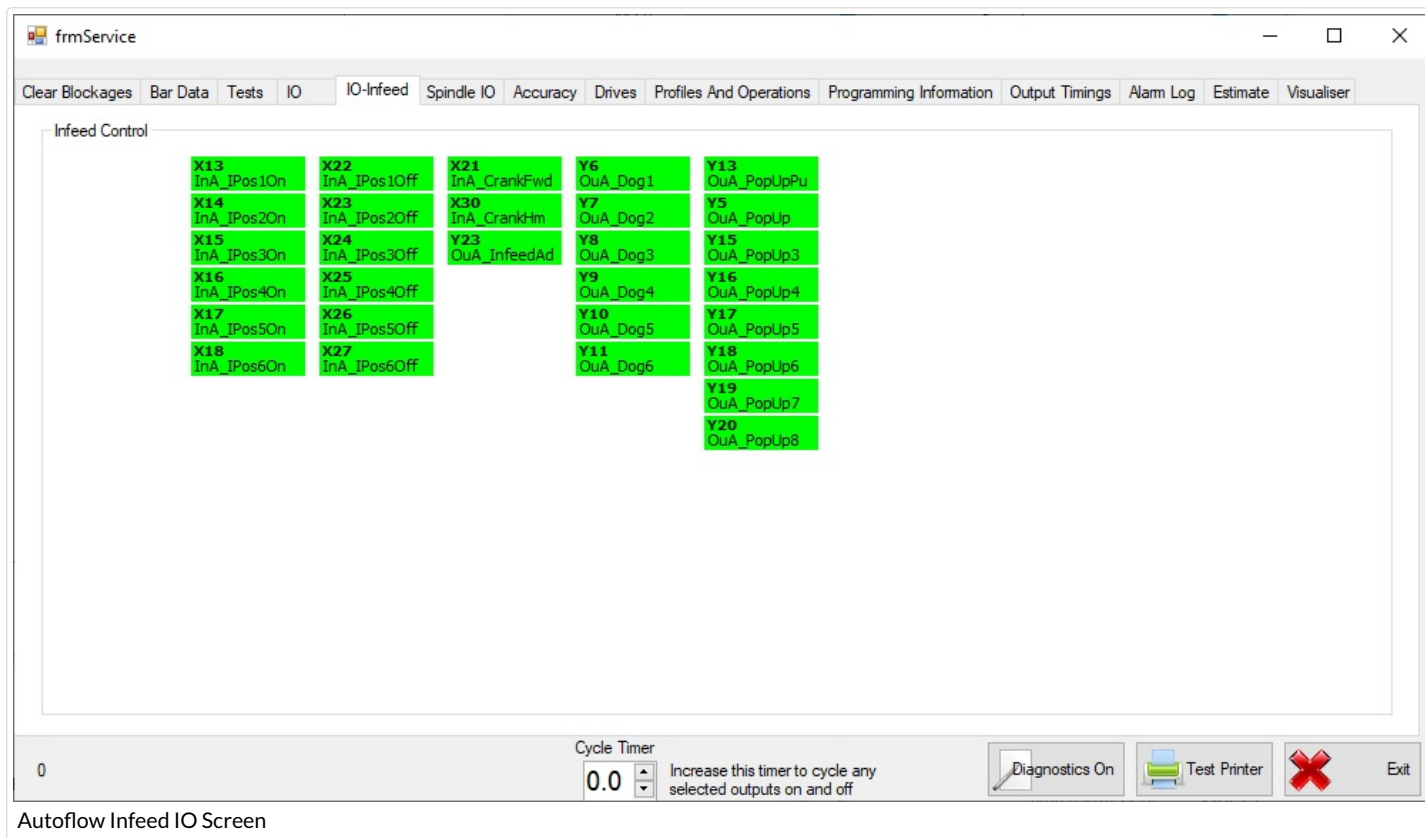
Module B – Multihead

Output	Description	Output	Description
OuB_ClampIT	Clamp Infeed Top	OuB_ClampOS	Clamp Outfeed Side
OuB_ClampIS	Clamp Infeed Side	OuB_ClampOSPos	Clamp Outfeed Side Wide Pos
OuB_ClampISPos	Clamp Infeed Side Wide Pos	OuB_Oiler	Oiler
OuB_ClampOT	Clamp Outfeed Top	OuB_OilerChn	Oiler Chain
OuB_ClampOTPos	Clamp Outfeed Top Tall Pos		

Module F – Saw and Outfeed

Output	Description	Output	Description
OuF_ClitHi	Clamp Infeed Top High Press	OuF_Eject	Saw Ejector
OuF_ClampITR	Clamp Infeed Top Tall Pos	OuF_OffBlow	Outfeed Blower
OuF_ClampOT	Clamp Outfeed Top	OuF_Siren	Long Length Siren
OuF_ClampIS	Clamp Infeed Side	OuF_Gate	Long Length Safety Gate
OuF_ClampOS	Clamp Outfeed Side	OuF_SawOn	Saw Blade
OuF_EjectPush	Eject Pusher	OuF_ExtractO	Extractor
OuF_Conveyor	Outfeed Conveyor	OuF_ChuteBlo	Chute Blower

Autoflow Infeed IO Screen



Autoflow Infeed Inputs

Infeed Control - Inputs

Sensor	Description	Sensor	Description	Sensor	Description
InA_Pos1On	Infeed Flapper 1 On	InA_Pos1Off	Infeed Flapper 1 Off	InA_CrankFwd	Infeed Crank Forward
InA_Pos2On	Infeed Flapper 2 On	InA_Pos2Off	Infeed Flapper 2 Off	InA_CrankHm	Infeed Crank Home
InA_Pos3On	Infeed Flapper 3 On	InA_Pos3Off	Infeed Flapper 3 Off	InA_Infeed_Ad	?
InA_Pos4On	Infeed Flapper 4 On	InA_Pos4Off	Infeed Flapper 4 Off		
InA_Pos5On	Infeed Flapper 5 On	InA_Pos5Off	Infeed Flapper 5 Off		
InA_Pos6On	Infeed Flapper 6 On	InA_Pos6Off	Infeed Flapper 6 Off		

Autoflow Infeed Outputs

Infeed Control - Outputs

Output	Description	Output	Description
OuA_Dog1	?	OuA_PopUpPu	?
OuA_Dog2	?	OuA_PopUp	Profile Stop Popup
OuA_Dog3	?	OuA_PopUp3	Pop Up Cylinder 3
OuA_Dog4	?	OuA_PopUp4	Pop Up Cylinder 4
OuA_Dog5	?	OuA_PopUp5	Pop Up Cylinder 5
OuA_Dog6	?	OuA_PopUp6	Pop Up Cylinder 6
		OuA_PopUp7	Pop Up Cylinder 7
		OuA_PopUp8	Pop Up Cylinder 8

Autoflow Spindle IO Screen

frmService

Clear Blockages

Bar Data

Tests

IO

IO-Infeed

Spindle IO

Accuracy

Drives

Profiles And Operations

Programming Information

Output Timings

Alarm Log

Estimate

Visualiser

Spindle Control

Y46

OuB_Spin1On

Y47

OuB_Spin2On

Y49

OuB_Spin4On

Y50

OuB_Spin5On

Y51

OuB_Spin6On

Y53

OuB_Spin8On

Y62

OuB_SpinFwd

Y38

OuB_Spin1Pl

Y39

OuB_Spin2Pl

Y41

OuB_Spin4Pl

Y42

OuB_Spin5Pl

Y43

OuB_Spin6Pl

Y45

OuB_Spin8Pl

Y63

OuB_50Hz

Y55

OuB_Spin2DP

Y57

OuB_Spin4DP

Y59

OuB_Spin6DP

Y61

OuB_Spin8DP

Y374

OuB_InvRst

X67

InB_Spin1Hm

X68

InB_Spin2Hm

X70

InB_Spin4Hm

X71

InB_Spin5Hm

X72

InB_Spin6Hm

X74

InB_Spin8Hm

X90

InB_InvSpinOk

X75

InB_Spin1Ou

X76

InB_Spin2Ou

X78

InB_Spin4Ou

X79

InB_Spin5Ou

X80

InB_Spin6Ou

X82

InB_Spin8Ou

X103

InB_Spin2DPH

X105

InB_Spin4DPH

X107

InB_Spin6DPH

X109

InB_Spin8DPH

X95

InB_Spin2DPO

X97

InB_Spin4DPO

X99

InB_Spin6DPO

X101

InB_Spin8DPO

X490

InB_Spin2OT

X492

InB_Spin4OT

X494

InB_Spin6OT

X496

InB_Spin8OT

Spindle Diagnosis

Spindle Stop

Spindle Start

Spindle Pulse

On

1000

Off

400

0

Cycle Timer

0.0

Increase this timer to cycle any selected outputs on and off

Diagnostics On

Test Printer

Exit

Autoflow Spindle IO Screen

Spindle Inputs

Sensor	Description	Sensor	Description
InB_Spin1Hm	Spindle 1 Home	InB_Spin5Hm	Spindle 5 Home
InB_Spin1Ou	Spindle 1 Out	InB_Spin5Ou	Spindle 5 Out
InB_Spin1DPHm	Spindle 1 Dbl Plunge Home	InB_Spin5DPHm	Spindle 5 Dbl Plunge Home
InB_Spin1DPOu	Spindle 1 Dbl Plunge Out	InB_Spin5DPOu	Spindle 5 Dbl Plunge Out
InB_Spin2Hm	Spindle 2 Home	InB_Spin6Hm	Spindle 6 Home
InB_Spin2Ou	Spindle 2 Out	InB_Spin6Ou	Spindle 6 Out
InB_Spin2DPHm	Spindle 2 Dbl Plunge Home	InB_Spin6DPHm	Spindle 6 Dbl Plunge Home
InB_Spin2DPOu	Spindle 2 Dbl Plunge Out	InB_Spin6DPOu	Spindle 6 Dbl Plunge Out
InB_Spin3Hm	Spindle 3 Home	InB_Spin7Hm	Spindle 7 Home
InB_Spin3Ou	Spindle 3 Out	InB_Spin7Ou	Spindle 7 Out
InB_Spin4Hm	Spindle 4 Home	InB_Spin8Hm	Spindle 8 Home
InB_Spin4Ou	Spindle 4 Out	InB_Spin8Ou	Spindle 8 Out
InB_Spin4DPHm	Spindle 4 Dbl Plunge Home	InB_Spin8DPHm	Spindle 8 Dbl Plunge Home
InB_Spin4DPOu	Spindle 4 Dbl Plunge Out	InB_Spin8DPOu	Spindle 8 Dbl Plunge Out

Spindle Outputs

Output	Description	Output	Description
OuB_Spin1On	Spindle 1 On	OuB_Spin5On	Spindle 5 On
OuB_Spin1Pl	Spindle 1 Plunge	OuB_Spin5Pl	Spindle 5 Plunge
OuB_Spin1DP	Spindle 1 Double Plunge	OuB_Spin5DP	Spindle 5 Double Plunge
OuB_Spin2On	Spindle 2 On	OuB_Spin6On	Spindle 6 On
OuB_Spin2Pl	Spindle 2 Plunge	OuB_Spin6Pl	Spindle 6 Plunge
OuB_Spin2DP	Spindle 2 Double Plunge	OuB_Spin6DP	Spindle 6 Double Plunge
OuB_Spin3On	Spindle 3 On	OuB_Spin7On	Spindle 7 On
OuB_Spin3Pl	Spindle 3 Plunge	OuB_Spin7Pl	Spindle 7 Plunge
OuB_Spin4On	Spindle 4 On	OuB_Spin8On	Spindle 8 On
OuB_Spin4Pl	Spindle 4 Plunge	OuB_Spin8Pl	Spindle 8 Plunge
OuB_Spin4DP	Spindle 4 Double Plunge	OuB_Spin8DP	Spindle 8 Double Plunge

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