

# Bending Machine 24V

Terminal strip assignment plan:

Clamp	Actuator function	BMK
1	Power supply (+) - Actuators	24V DC
2	Power supply (+) - Sensors	24V DC
3	Power supply (-)	0V
4	Power supply (-)	0V
5	Press top limit switch	S1 (I1)
6	Press bottom limit switch	S2 (I2)
7	Rear transport carriage limit switch	S3 (I3)
8	Transport carriage front limit switch	S4 (I4)
9	Start button	S5 (I5)
10	Press light barrier	B1 (I6)
11	Light barrier removal	B2 (I7)
12	Light barrier magazine	B3 (I8)
13		
14		
15	Press up	Q1
16	Press down	Q2
17	Transport carriage back	Q3
18	Transport carriage forwards	Q4

