

公司名称COMPANY:京山轻机 J.S.Machine

机型MODEL:JZ-B接纸机SPLICER

设计方案号DESIGN NO.: JZB接纸机

文件名FILE: JZB(1.04.1)



J.S.Machine

 J. S. Machine	京山轻机技术中心 地址: 武汉市江兴路22号 电话/传真: 027-8336 0009 Email: info@jsqjrd.com http://www.jsqjrd.com	机型MODEL: JZ-B接纸机SPLICER	工艺TECH:	版本号VER.NO.:1.04.1
		用户CUSTOMER:	标准化STD: 涂芳	日期Date:2010-1-14 13:20:52
		设计BY: 廖波	审核CHK: 严庆	设计方案号DESIGN NO.: JZB接纸机
		制图DRWN:	审定REV: 刘冬明	PAGE F1

更改记录

更改页号	更改内容	更改原因	版本号更新	发布日期
C2	添加爱默生端子对照表	添加爱默生选配	V1.04.1	2010.01.14



J.S.Machine

JZB 接纸机

1 系统概略图 System Diagram

2 电气图 Circuit diagram

3 布置图 Position diagram

4 元件清单 Part list table

5 端子线缆图 Terminal & Cable Diagram

6

7

8

9

10

目录表Index

标题 Title	页码 Page	版本 Version	日期 Date
系统概略图System Diagram			
系统概略图System Diagram	S1	1.04.0	2006-12-26
电气图Circuit diagram			
电源Power diagram	C1	1.04.0	2006-12-25
主回路Power diagram	C2	1.04.0	2006-12-23
控制回路Control diagram	C3	1.04.0	2006-12-25
控制回路Control diagram	C4	1.04.0	2006-12-25
控制回路Control diagram	C5	1.04.0	2006-12-25
控制回路Control diagram	C6	1.04.0	2006-12-25
控制回路Control diagram	C7	1.04.0	2006-12-25
控制回路Control diagram	C8	1.04.0	2006-12-25
控制回路Control diagram	C9	1.04.0	2006-12-25
控制回路Control diagram	C10	1.04.0	2006-12-25
控制回路Control diagram	C11	1.04.0	2006-12-25
控制回路Control diagram	C12	1.04.0	2006-12-25
控制回路Control diagram	C13	1.04.0	2006-12-26
布置图Position diagram			
电器柜元件排布图Part position	P1	1.04.0	2006-12-25
操作柜元件排布图Part position	P2	1.04.0	2006-12-26
面板元件排布图Part position	P3	1.04.0	2006-12-26
气动原理图Pneumatic drawing	P4	1.04.0	2006-12-26
元件清单Part list table			
元件清单Part list table	M1	1.04.0	2006-12-25
元件清单Part list table	M2	1.04.0	2006-12-25
元件清单Part list table	M3	1.04.0	2006-12-25
端子线缆图Terminal &Cable Diagram			
接线端子图Terminal Diagram	T1	1.04.0	2006-12-25
接线端子图Terminal Diagram	T2	1.04.0	2006-12-25
接线端子图Terminal Diagram	T3	1.04.0	2006-12-25
接线端子图Terminal Diagram	T4	1.04.0	2006-12-25
接线端子图Terminal Diagram	T5	1.04.0	2006-12-25



京山轻机技术中心
 地址：武汉市江兴路22号
 电话/传真：027-8336 0009
 Email: info@jsqjrd.com
 http://www.jsqjrd.com

型号MODEL:JZ-B接纸机SPLICER	工艺TECH:	版本号VER.NO.:1.04.0
用户CUSTOMER:京山轻机J.S.Machine	标准化STD:	标题TITLE:目录表Index
设计BY:	审核CHK:	设计方案号DESIGN NO.:JZB接纸机
制图DRWN:	审定REV:	PAGE F3 TOTAL F3

系统概略图 **System Diagram**



J.S.Machine

系统概略图System Diagram

项目代号说明

代号	配置
=F0	标配功能Normal Version
=F1	有CE要求选用Use for CE only
=F2	配生产管理系统选用Use for PMS

位置代号说明

代号	位置
+B1	机体Machine body
+C1	操作柜操作面板Operation panel
+C2	出纸侧操作面板Operation panel 1
+C3	展开侧操作面板Operation panel 2
+E1	电器柜Drive cabinet
+E2	操作柜Operation cabinet

端子排位置说明

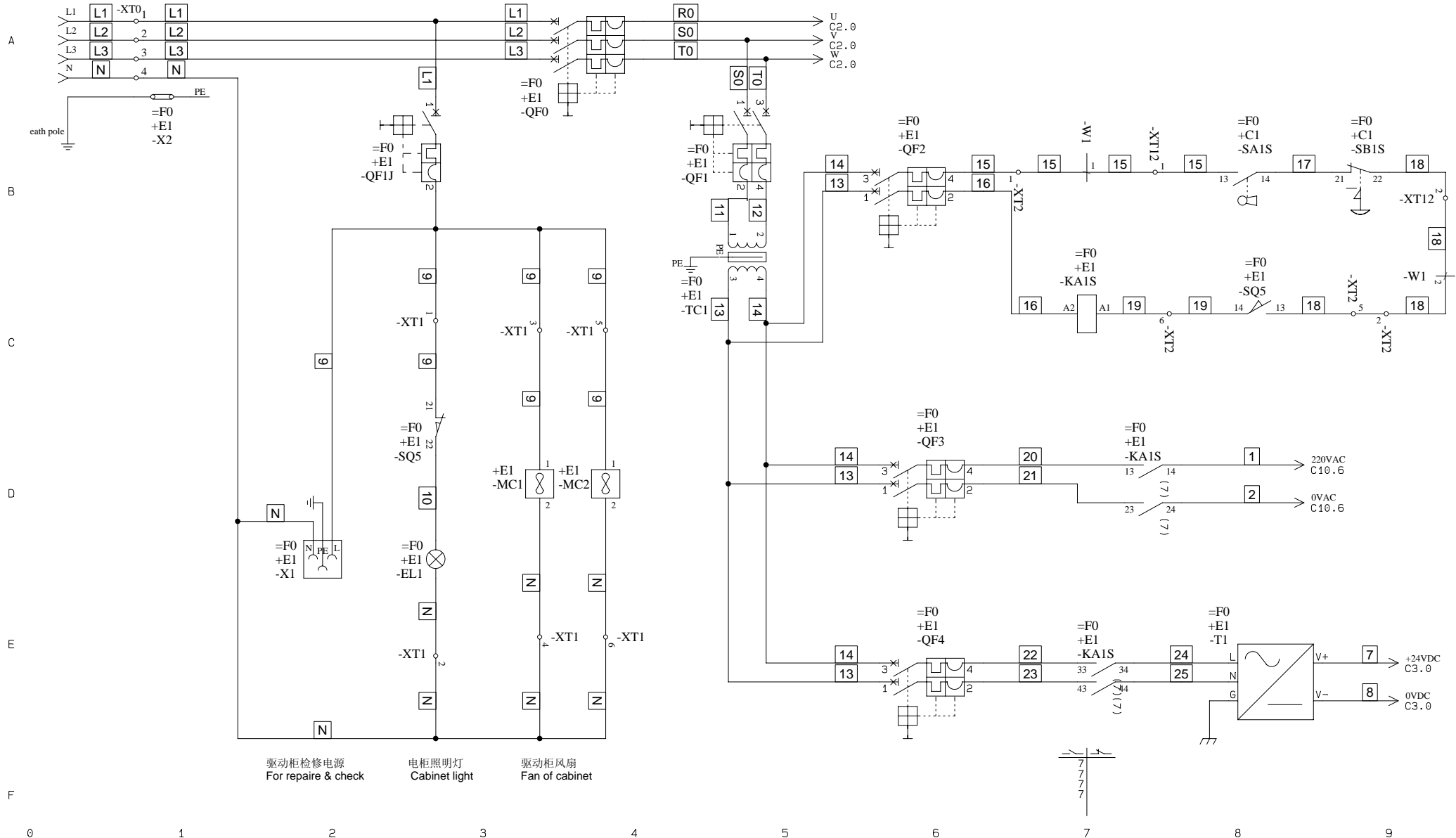
代号	位置
-XT10—11, -XT51	电器柜Drive cabinet
-XT12—15	操作柜Operation cabinet
-XT31	机体Machine body

电气图 *Circuit diagram*

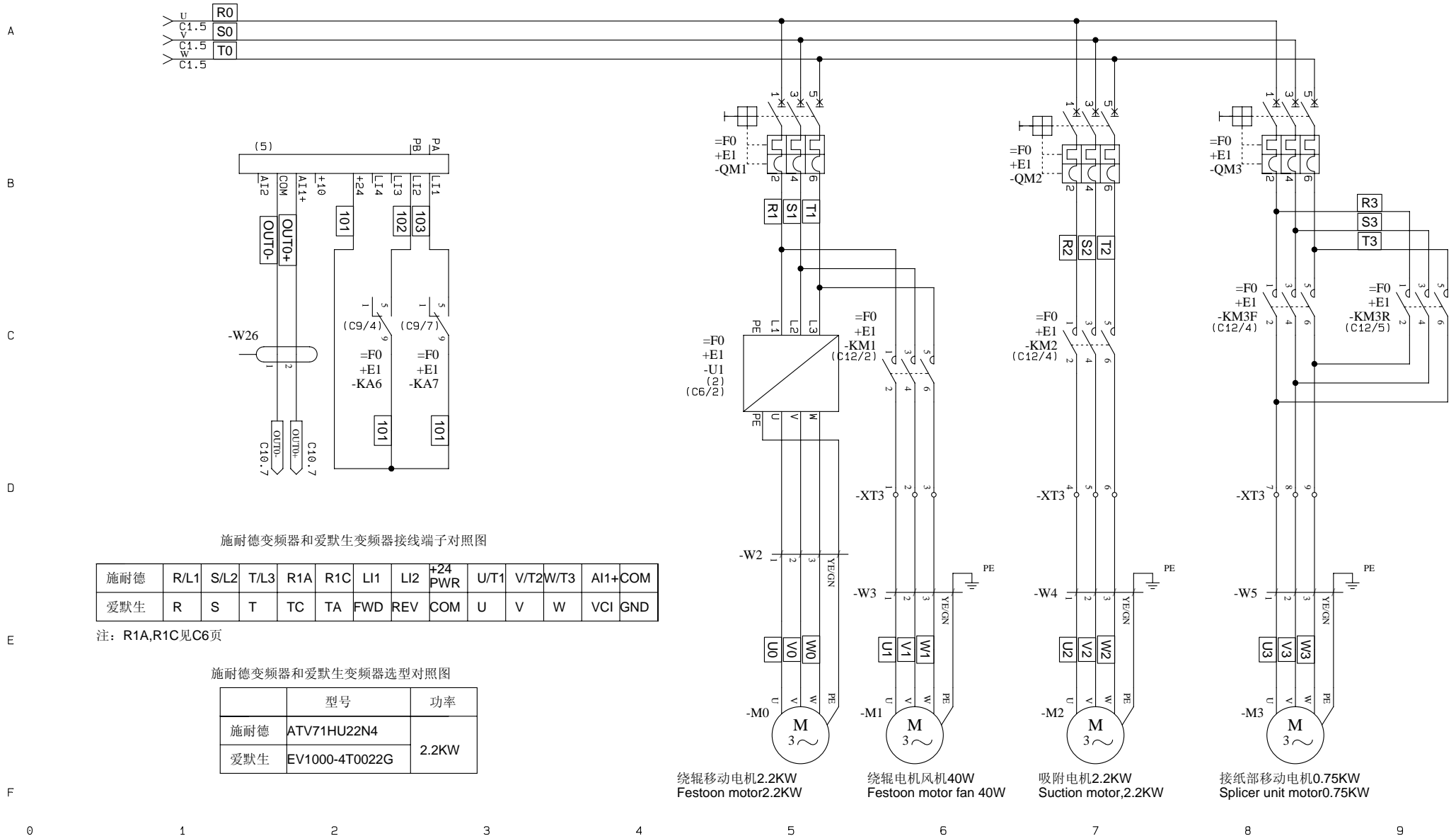


J.S.Machine

电源Power diagram



主回路Power diagram



施耐德变频器和爱默生变频器接线端子对照图

施耐德	R/L1	S/L2	T/L3	R1A	R1C	LI1	LI2	+24 PWR	U/T1	V/T2	W/T3	AI1+COM
爱默生	R	S	T	TC	TA	FWD	REV	COM	U	V	W	VCI GND

注: R1A,R1C见C6页

施耐德变频器和爱默生变频器选型对照图

	型号	功率
施耐德	ATV71HU22N4	2.2KW
爱默生	EV1000-4T0022G	

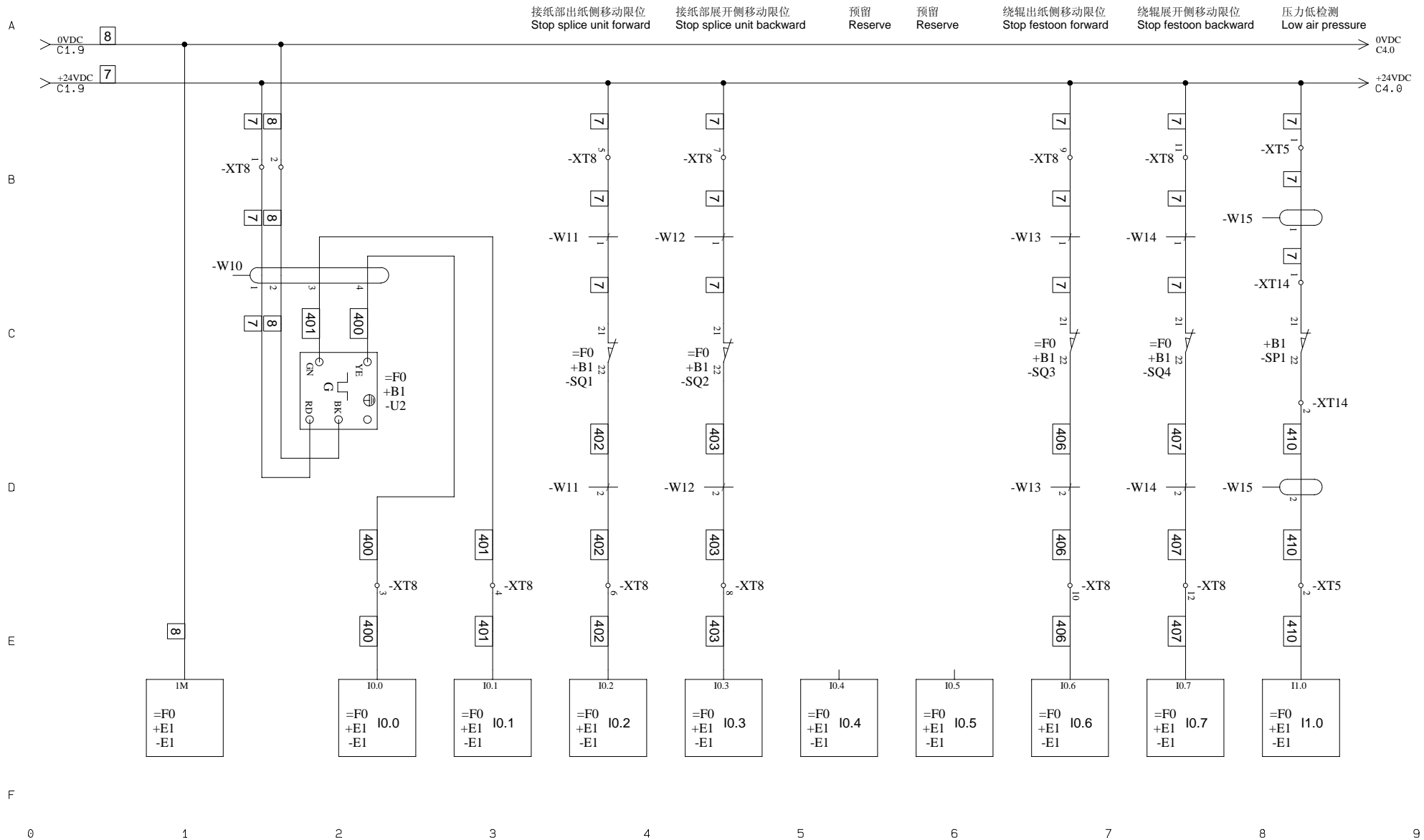
绕辊移动电机2.2KW
Festoon motor 2.2KW

绕辊电机风机40W
Festoon motor fan 40W

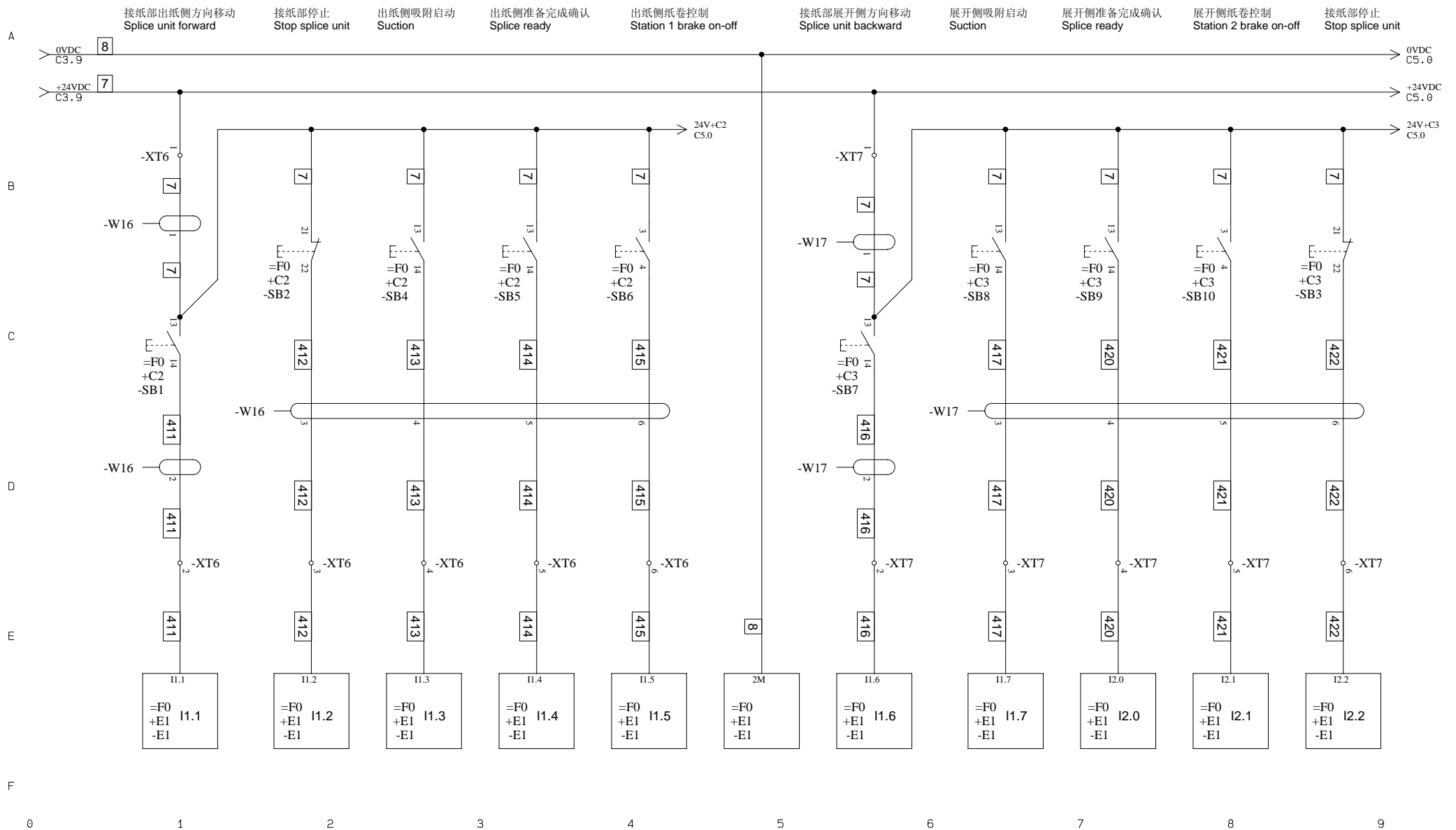
吸附电机2.2KW
Suction motor, 2.2KW

接纸部移动电机0.75KW
Splicer unit motor 0.75KW

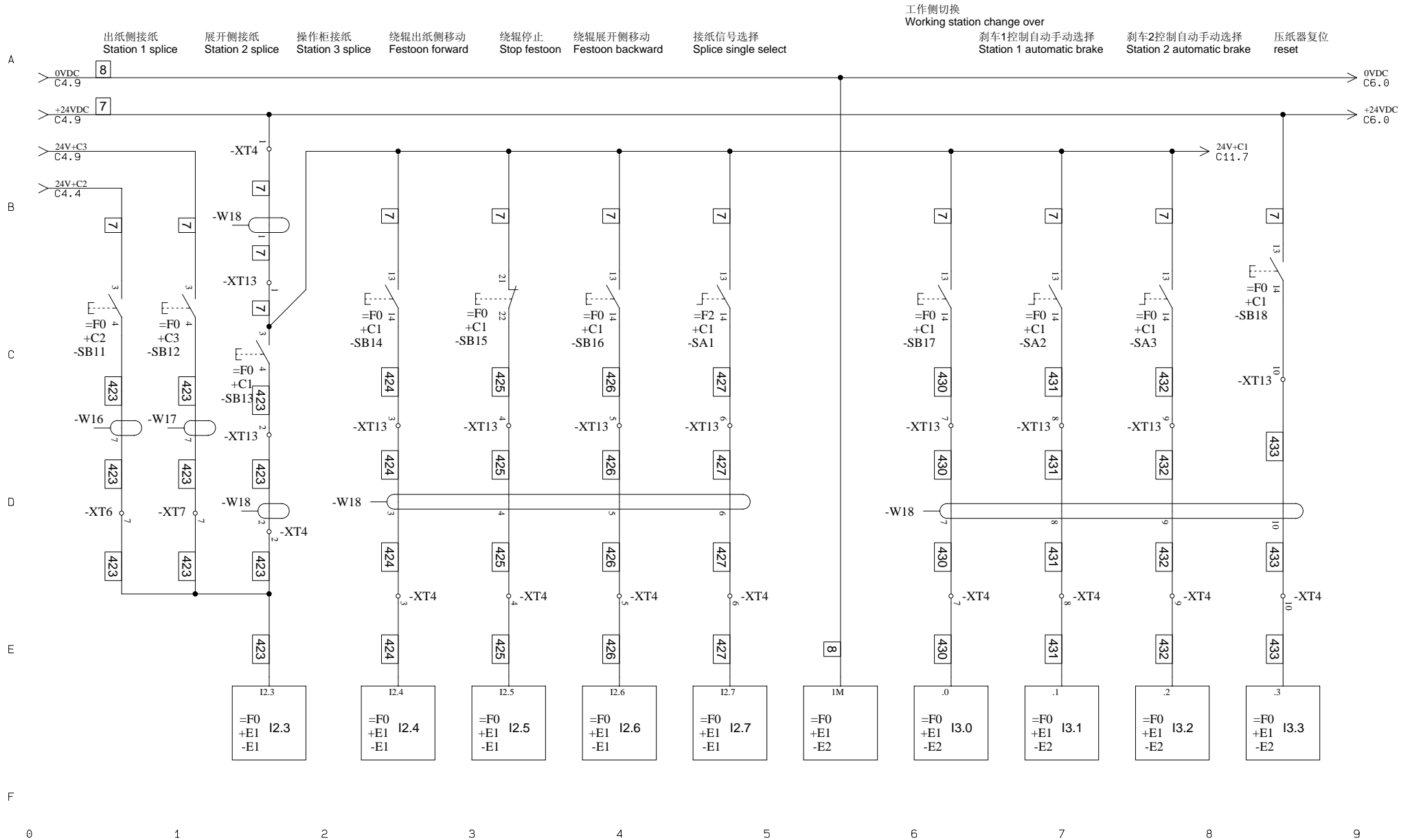
控制回路 Control diagram



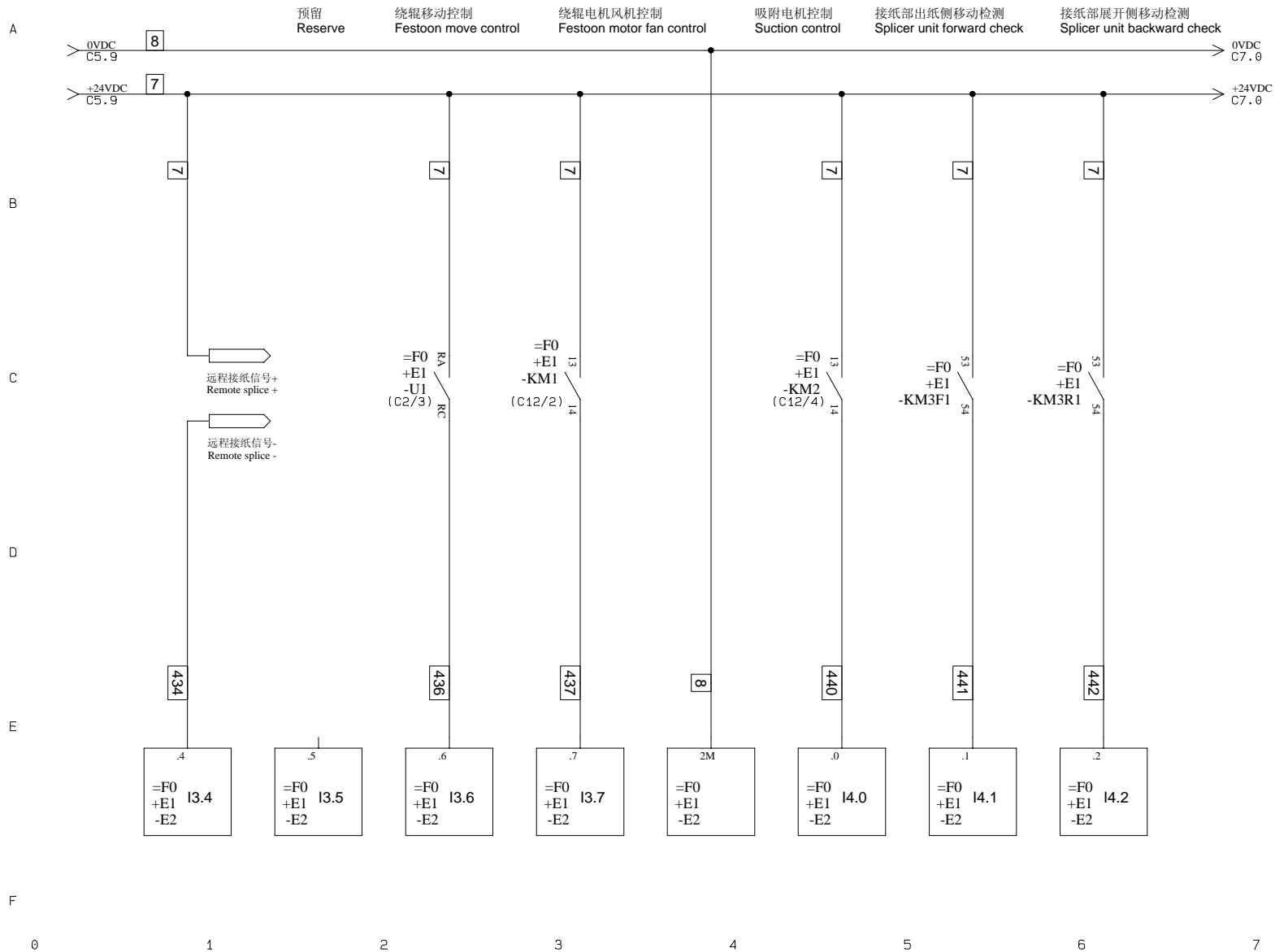
控制回路 Control diagram



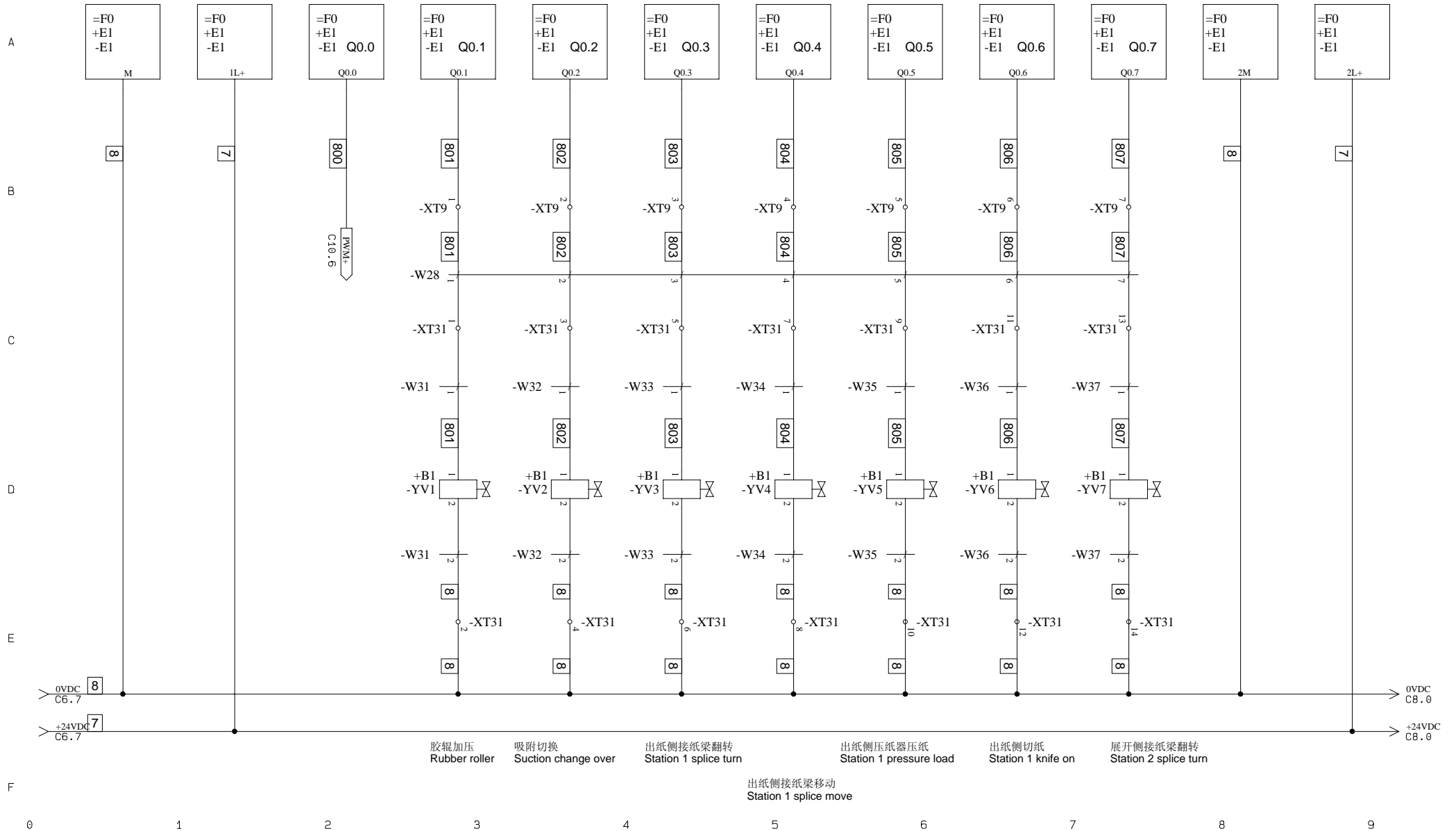
控制回路Control diagram



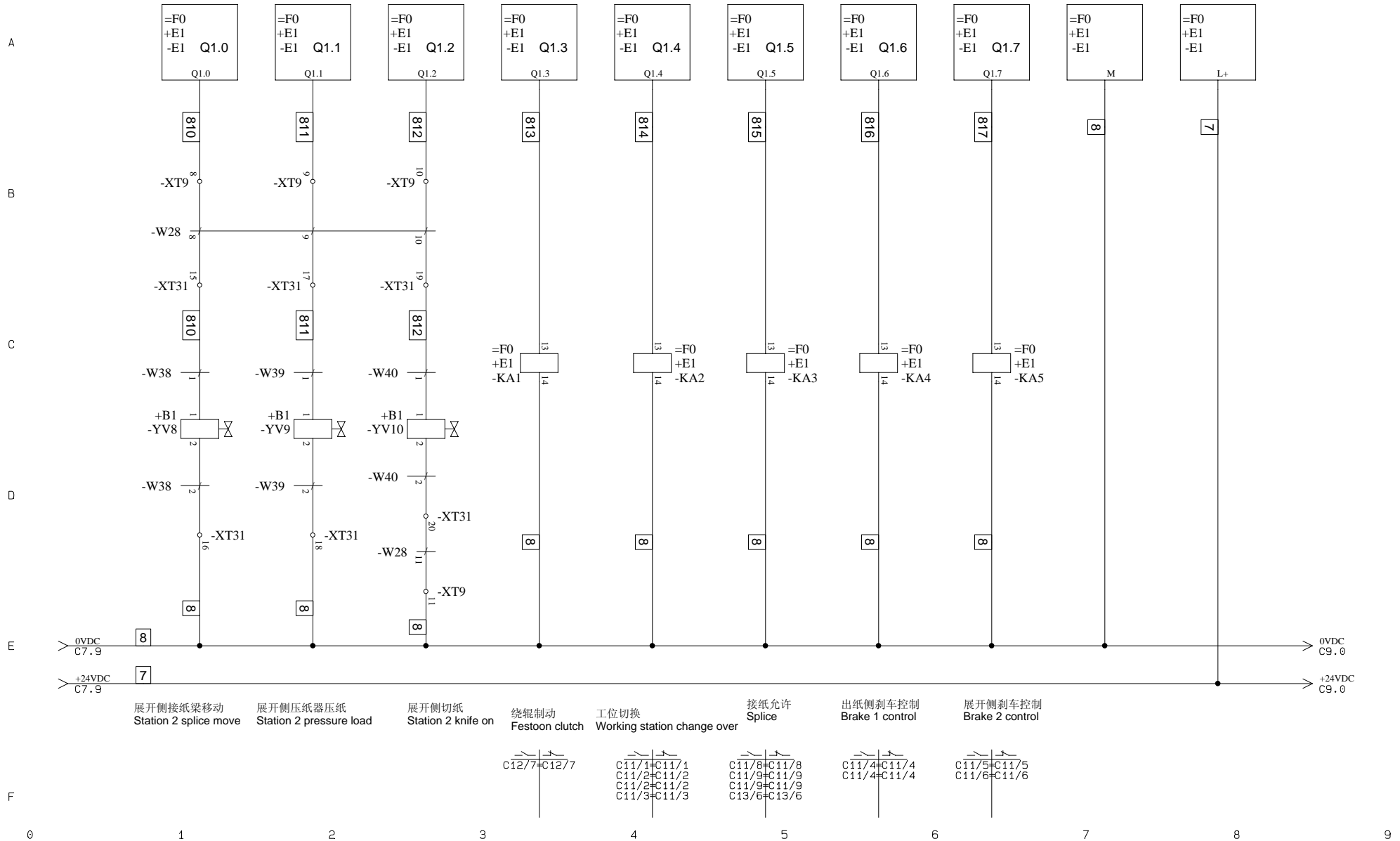
控制回路 Control diagram



控制回路 Control diagram



控制回路 Control diagram



展开侧接纸梁移动 Station 2 splice move
 展开侧压纸器压纸 Station 2 pressure load
 展开侧切纸 Station 2 knife on
 绕辊制动 Festoon clutch
 工位切换 Working station change over
 接纸允许 Splice
 出纸侧刹车控制 Brake 1 control
 展开侧刹车控制 Brake 2 control

C12/7+C12/7
 C11/4+C11/4
 C11/2+C11/2
 C11/2+C11/2
 C11/3+C11/3
 C11/8+C11/8
 C11/9+C11/9
 C11/9+C11/9
 C13/6+C13/6
 C11/4+C11/4
 C11/4+C11/4
 C11/5+C11/5
 C11/6+C11/6

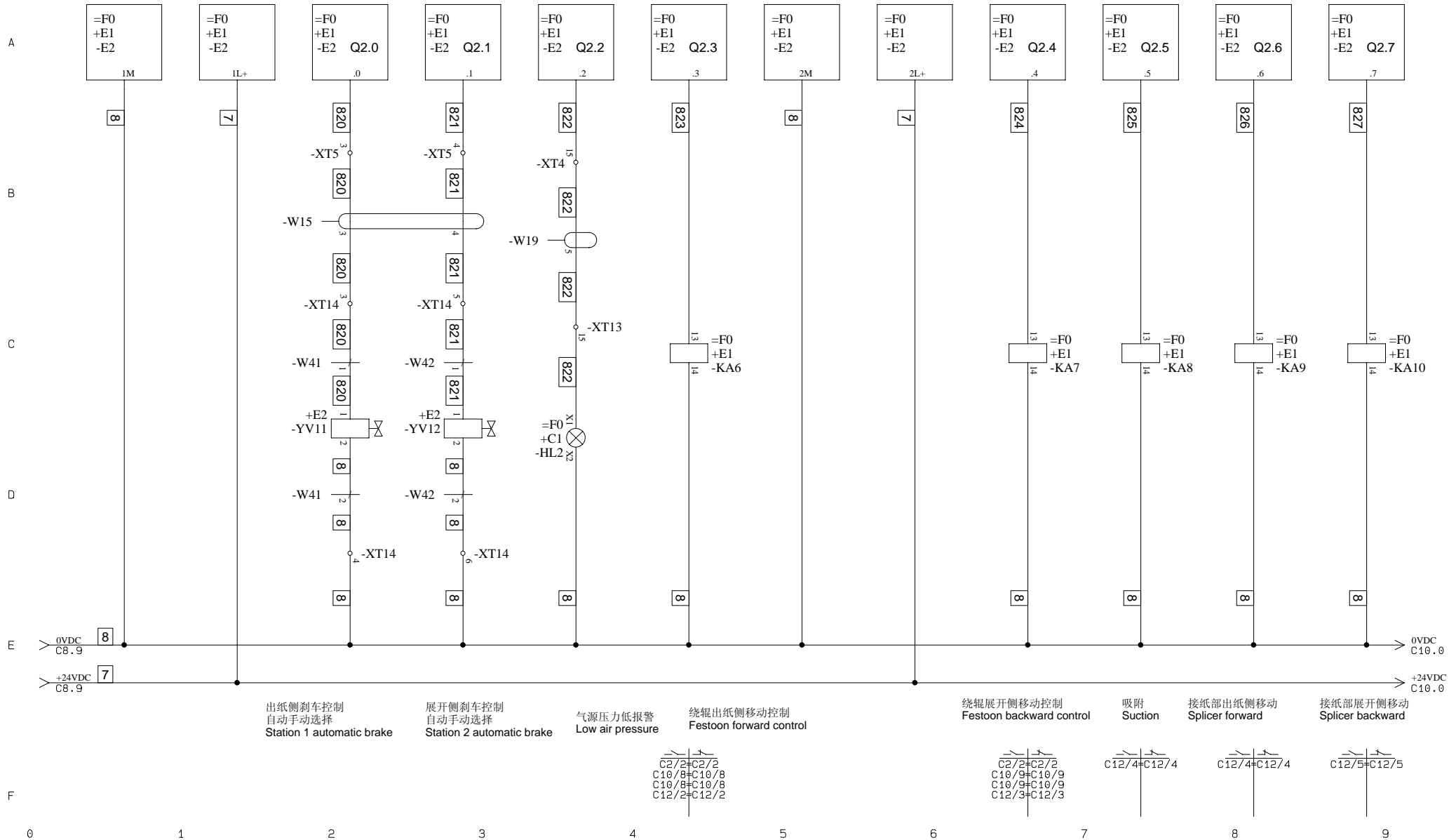


机型MODEL: JZ-B接纸机SPLICER
 用户CUSTOMER: 京山轻机J.S. Machine
 设计BY:
 制图DRWN:

工艺TECH:
 标准STD:
 审核CHK:
 审定REV:

版本号VER.NO.: 1.04.0 修改日期Modify: 2006-12-25
 标题TITLE: 控制回路Control diagram
 设计方案号DESIGN NO.: JZB接纸机
PAGE C8 TOTAL C13

控制回路 Control diagram



出纸侧刹车控制
自动手动选择
Station 1 automatic brake

展开侧刹车控制
自动手动选择
Station 2 automatic brake

气源压力低报警
Low air pressure

绕辊出纸侧移动控制
Festoon forward control

绕辊展开侧移动控制
Festoon backward control

吸附
Suction

接纸部出纸侧移动
Splicer forward

接纸部展开侧移动
Splicer backward

C2/2+C2/2
C10/8+C10/8
C10/8+C10/8
C12/2+C12/2

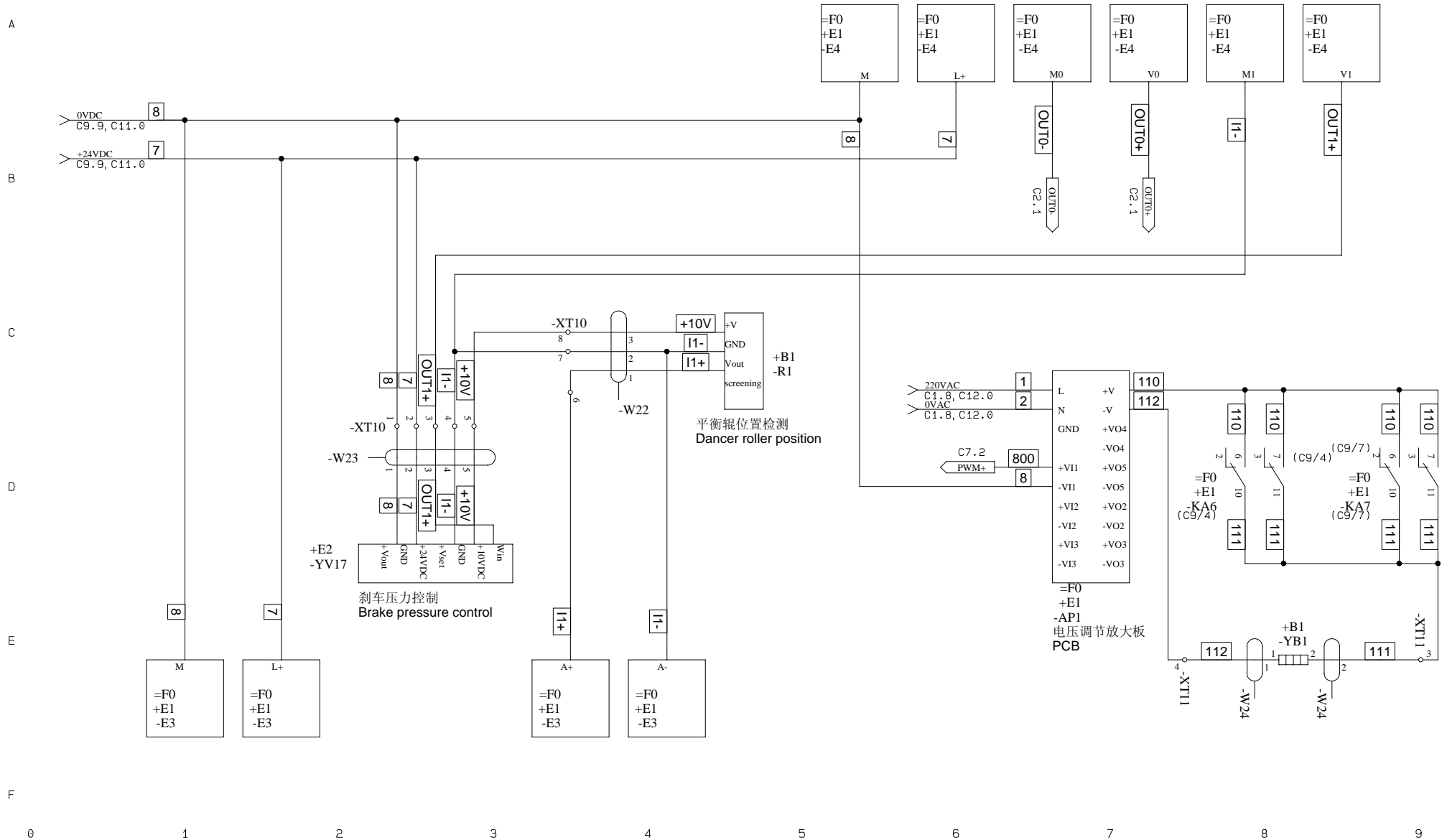
C2/2+C2/2
C10/9+C10/9
C10/9+C10/9
C12/3+C12/3

C12/4+C12/4

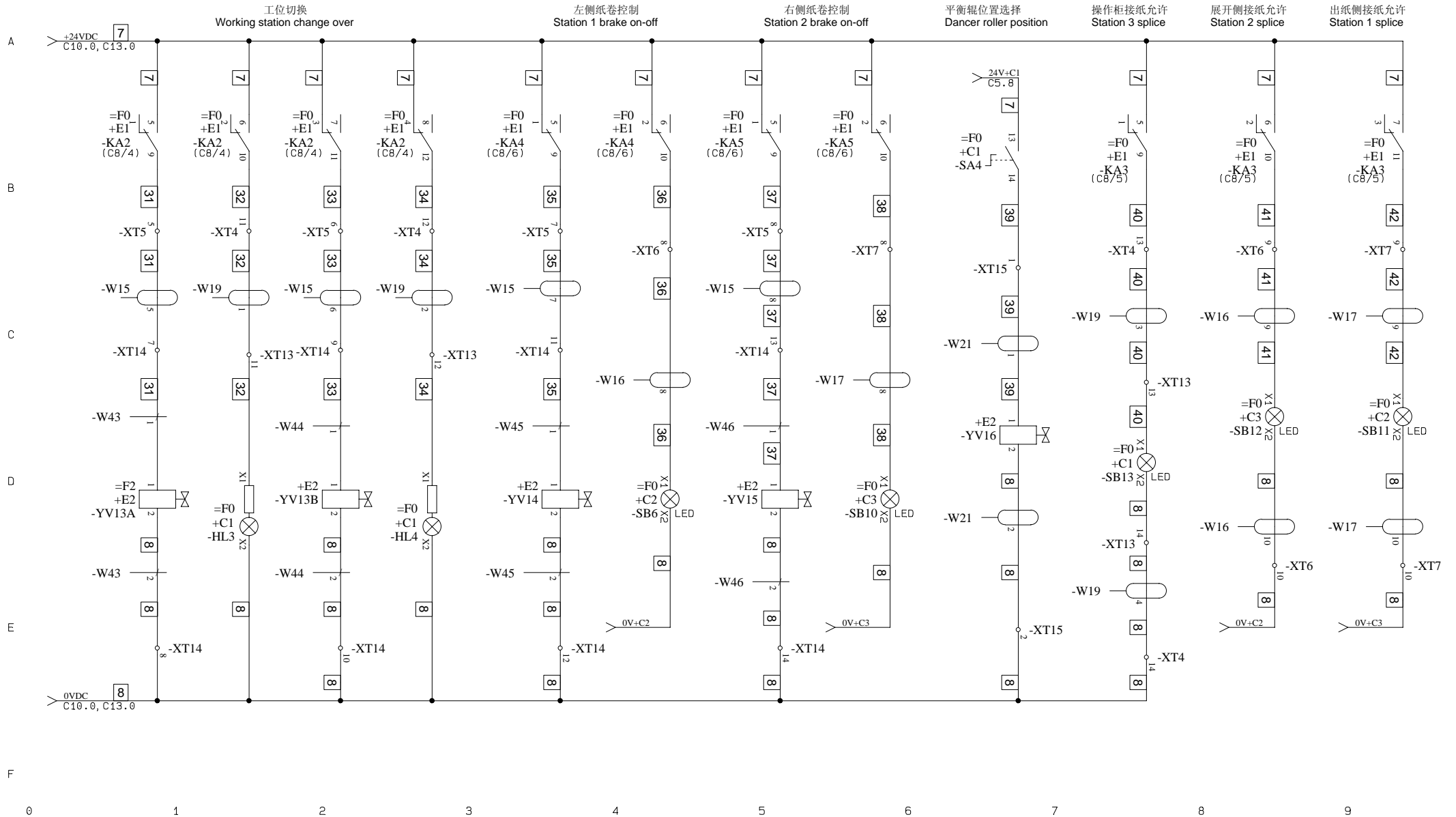
C12/4+C12/4

C12/5+C12/5

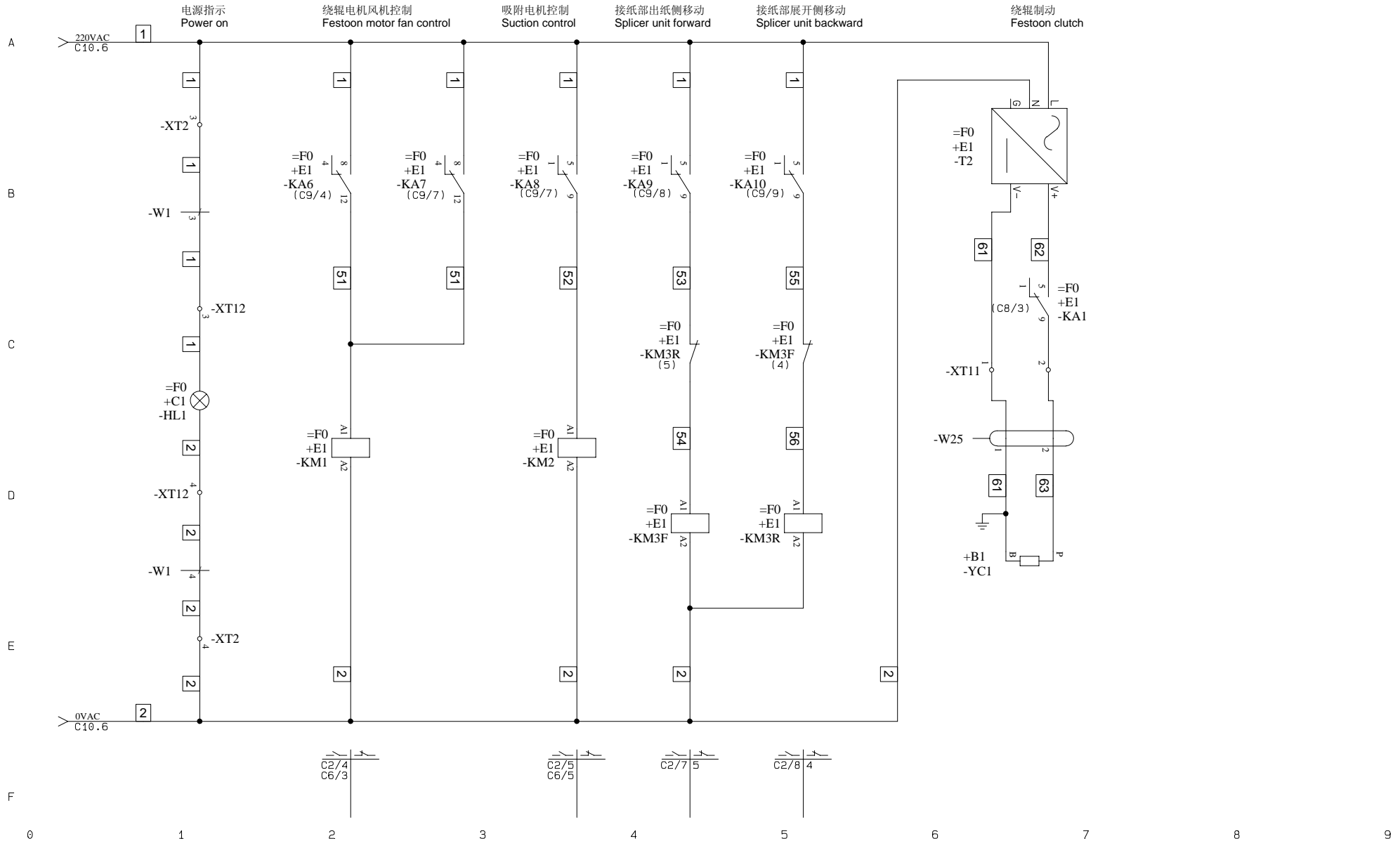
控制回路 Control diagram



控制回路 Control diagram

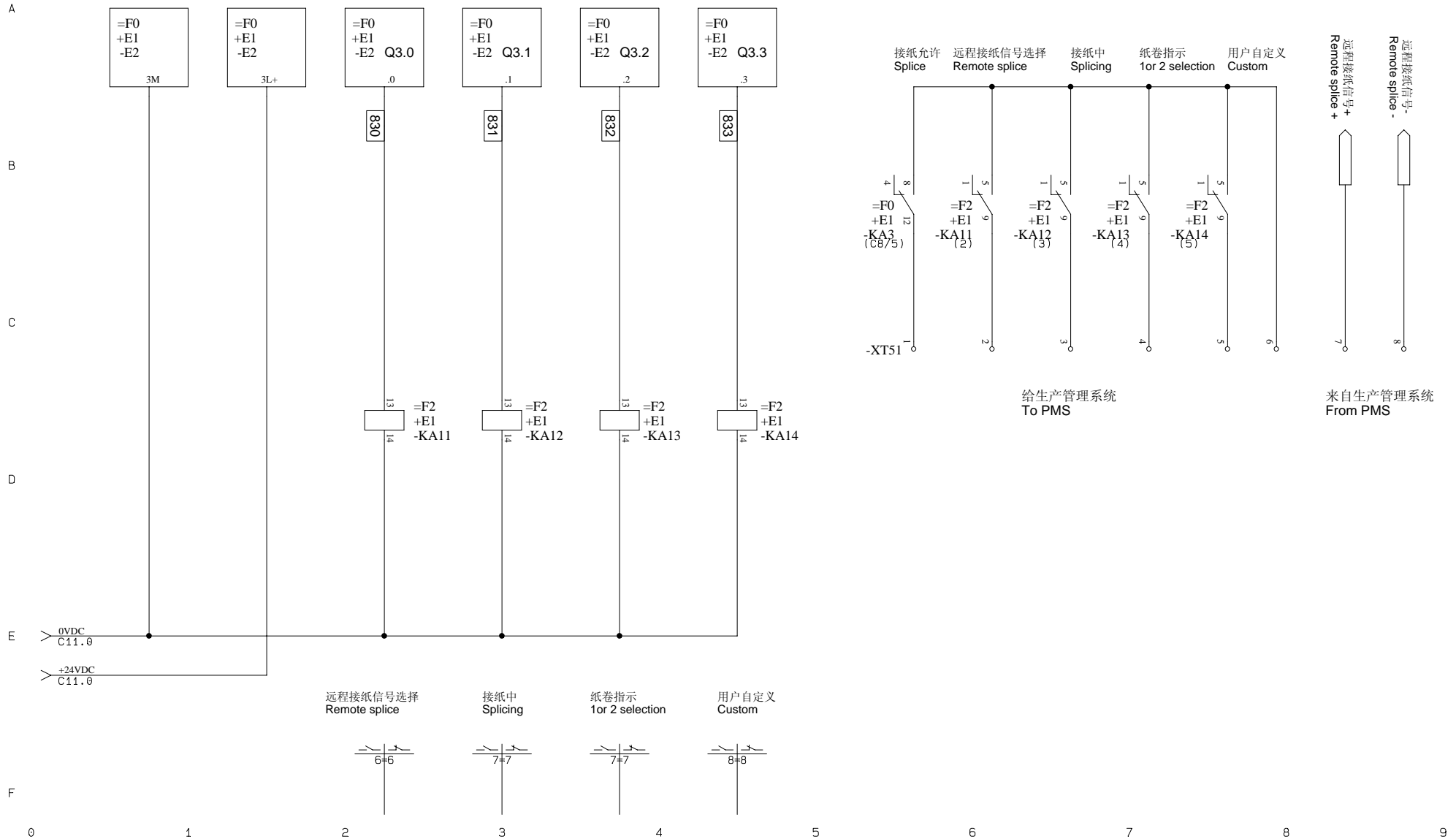


控制回路 Control diagram



控制回路 Control diagram

配生产管理系统时使用
Use for Production Management System

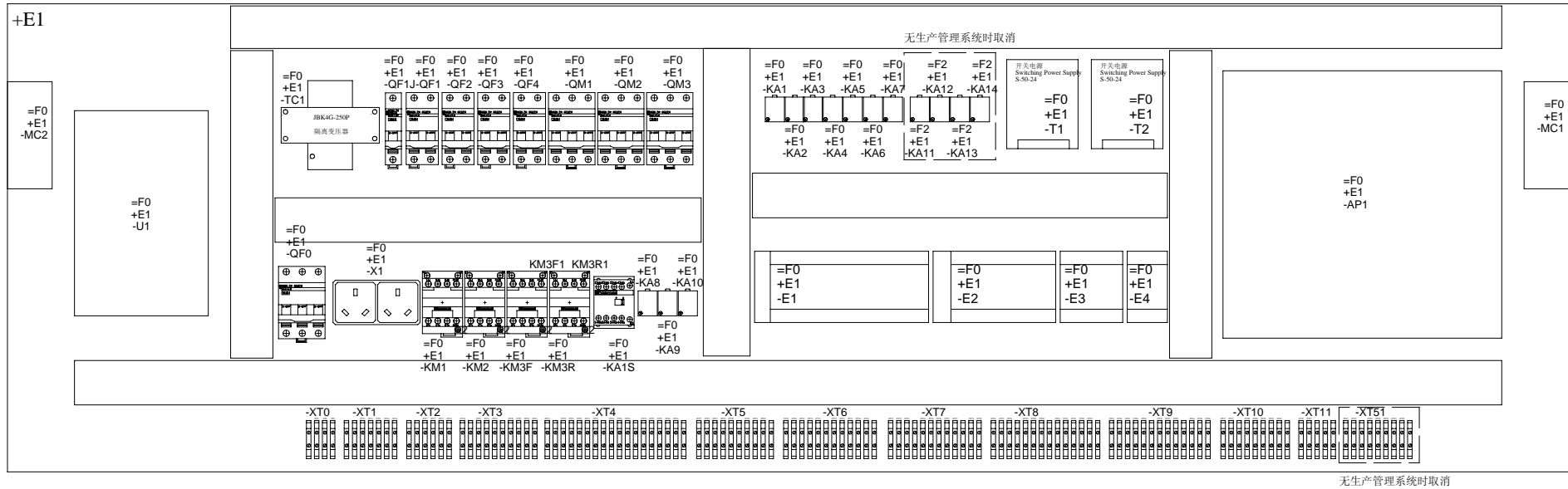


布置图 **Position diagram**



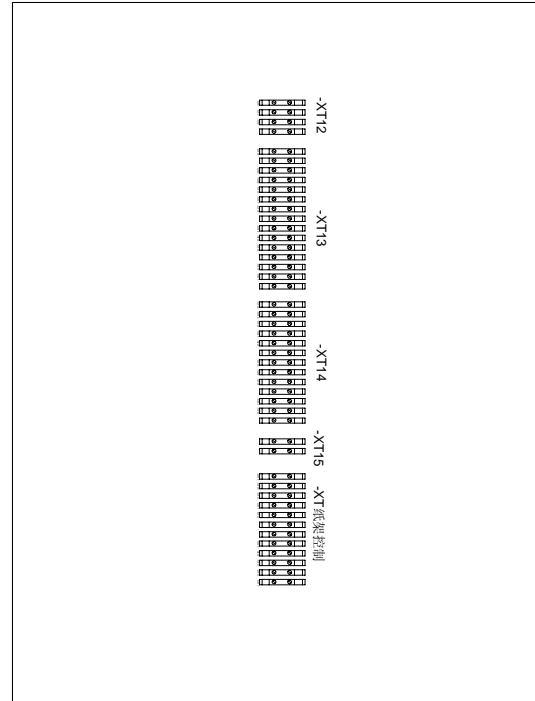
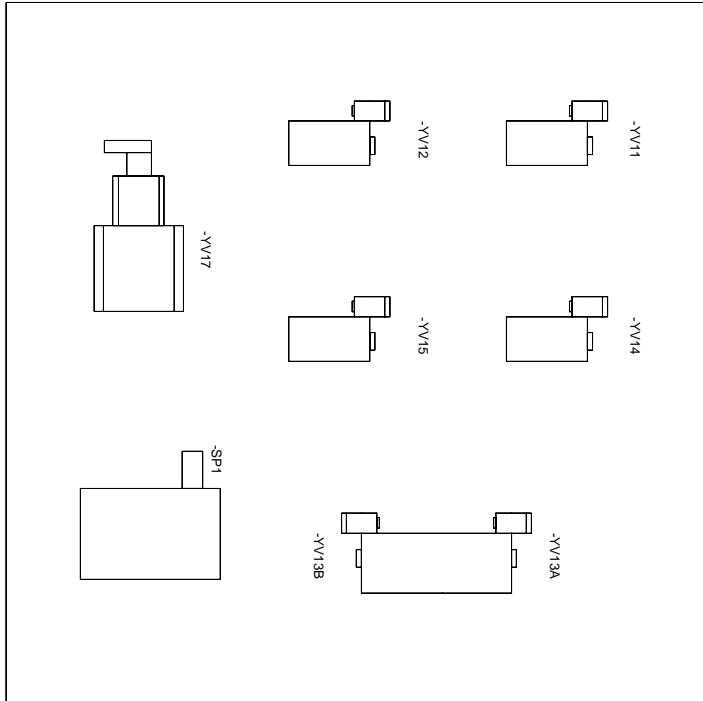
J.S.Machine

电器柜元件排布图 Part position

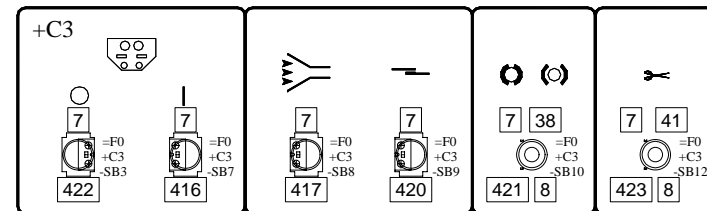
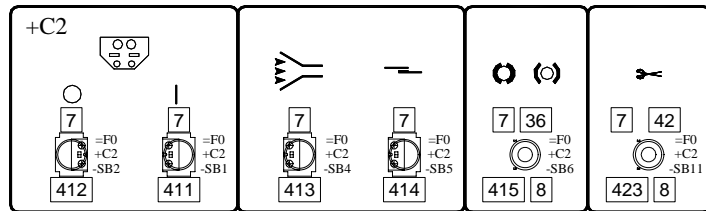
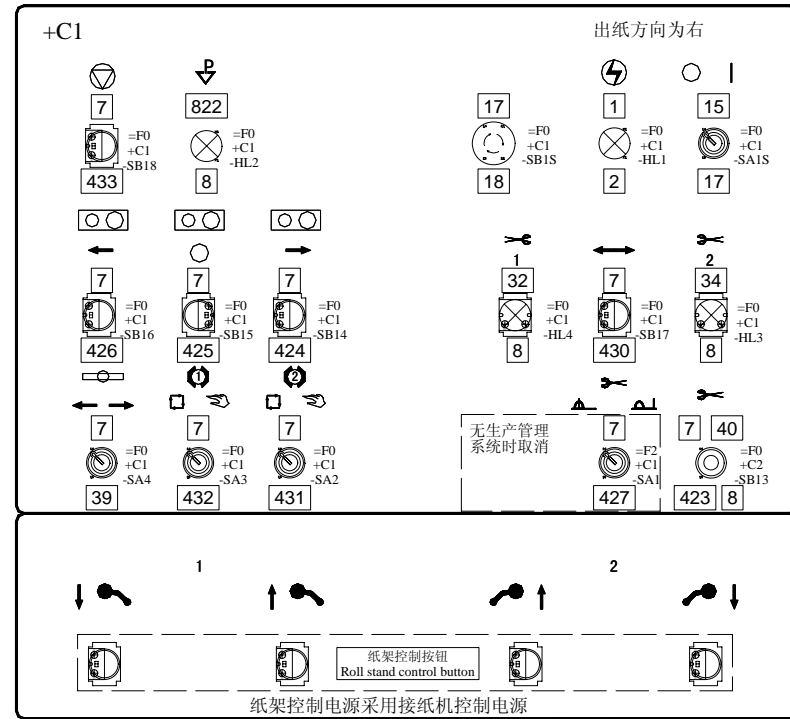
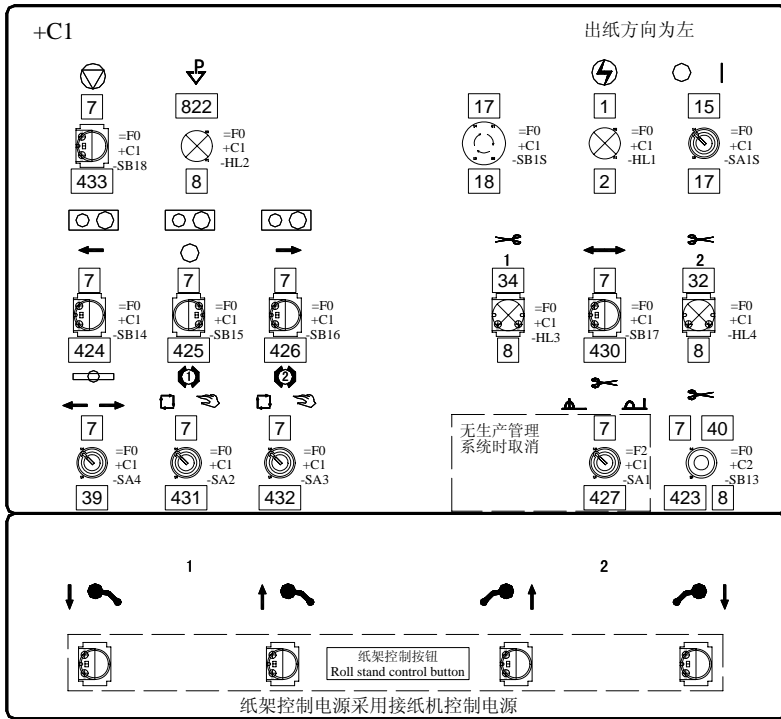


无生产管理系统时取消

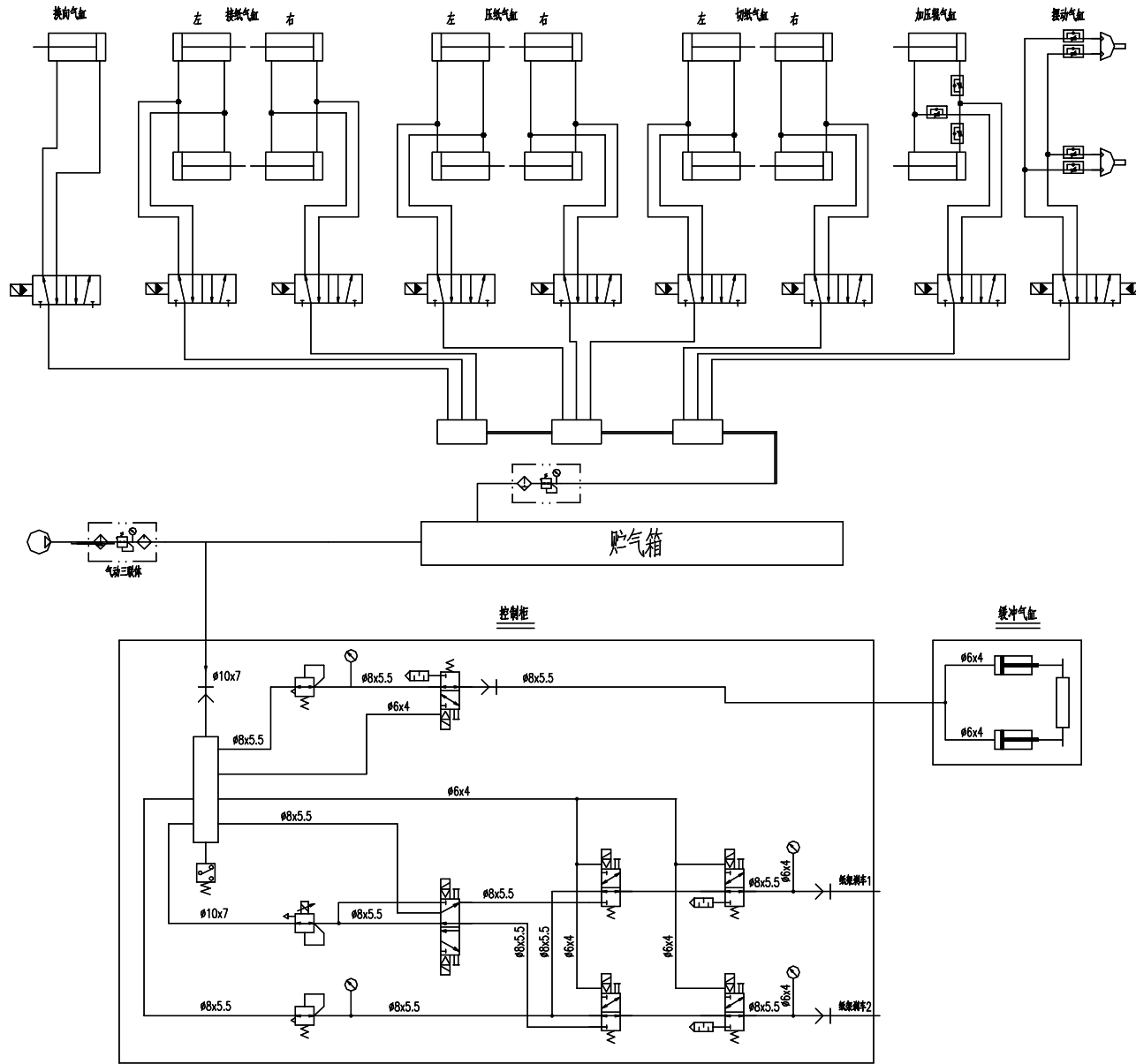
操作柜元件排布图Part position



面板元件排布图 Part position



气动原理图 Pneumatic drawing



元件清单 **Part list table**



J.S.Machine

元件清单Part list table

代号 Code	位置 Location	型号 Model	功能 Function	备注 Remarks
=F0+B1-SQ1	C3/4	XCK-J10541	接纸部出纸侧移动限位 Stop splice unit forward	
=F0+B1-SQ2	C3/5	XCK-J10541	接纸部展开侧移动限位 Stop splice unit backward	
=F0+B1-SQ3	C3/7	XCK-J10541	绕辊出纸侧移动限位 Stop festoon forward	
=F0+B1-SQ4	C3/8	XCK-J10541	绕辊展开侧移动限位 Stop festoon backward	
=F0+B1-U2	C3/2	EL58C300Z5/28P10X6PR	绕辊位置检测 Festoon position	
=F0+C1-HL1	C12/1	XB2BVM1C	电源指示 Power on	
=F0+C1-HL2	C9/4	XB2BVB4C	气源压力低报警 Low air pressure	
=F0+C1-HL3	C11/2	XB2BVB3C	工位1指示 Working station 1	
=F0+C1-HL4	C11/3	XB2BVB3C	工位2指示 Working station 2	
=F0+C1-SA1S	C1/8	XB2BG21	钥匙开关 key switch	
=F0+C1-SA2	C5/7	XB2BD21	刹车1控制自动手动选择 Station 1 automatic brake	
=F0+C1-SA3	C5/8	XB2BD21	刹车2控制自动手动选择 Station 2 automatic brake	
=F0+C1-SA4	C11/7	XB2BD21	平衡辊位置选择 Dancer roller position	
=F0+C1-SB1S	C1/9	XB2BS542C	急停开关 Emergency stop	
=F0+C1-SB13	C5/2	XB2BW33B1C	操作柜接纸 Station 3 splice	
=F0+C1-SB14	C5/3	XB2-BA31C	绕辊出纸侧移动 Festoon forward	
=F0+C1-SB15	C5/3	XB2-BA42C	绕辊停止 Stop festoon	
=F0+C1-SB16	C5/4	XB2-BA31C	绕辊展开侧移动 Festoon backward	
=F0+C1-SB17	C5/6	XB2-BA21C	工作侧切换 Working station change over	
=F0+C1-SB18	C6/1	XB2-BA21C	压纸器复位 reset	
=F0+C2-SB1	C4/1	XB2-BA31C	接纸部出纸侧方向移动 Splice unit forward	
=F0+C2-SB2	C4/2	XB2-BA42C	接纸部停止 Stop splice unit	
=F0+C2-SB4	C4/3	XB2-BA21C	出纸侧吸附启动 Suction	
=F0+C2-SB5	C4/3	XB2-BA31C	出纸侧准备完成确认 Splice ready	
=F0+C2-SB6	C4/4	XB2BW33B1C	出纸侧纸卷控制 Station 1 brake on-off	
=F0+C2-SB11	C5/1	XB2BW33B1C	出纸侧接纸 Station 1 splice	
=F0+C3-SB3	C4/9	XB2-BA42C	接纸部停止 Stop splice unit	
=F0+C3-SB7	C4/6	XB2-BA31C	接纸部展开侧方向移动 Splice unit backward	
=F0+C3-SB8	C4/7	XB2-BA21C	展开侧吸附启动 Suction	
=F0+C3-SB9	C4/7	XB2-BA31C	展开侧准备完成确认 Splice ready	
=F0+C3-SB10	C4/8	XB2BW33B1C	展开侧纸卷控制 Station 2 brake on-off	
=F0+C3-SB12	C5/1	XB2BW33B1C	展开侧接纸 Station 2 splice	



机型MODEL: JZ-B接纸机SPLICER
 用户CUSTOMER: 京山轻机J.S.Machine
 设计BY:
 制图DRWN:

工艺TECH:
 标准化STD:
 审核CHK:
 审定REV:

版本号VER.NO.: 1.04.0
 标题TITLE: 元件清单Part list table
 设计方案号DESIGN NO.: JZB接纸机
 PAGE M1 TOTAL M3

元件清单Part list table

代号 Code	位置 Location	型号 Model	功能 Function	备注 Remarks
=F0+E1-AP1	C10/7	DYFD01	电压调节放大板 PCB	
=F0+E1-E1	C3/1	6ES7 216-2AD23-0XB0	CPU	
=F0+E1-E2	C5/6	6ES7 223-1BL22-0XA0	数字量扩展模块 Extend module	
=F0+E1-E3	C10/1	6ES7 231-0HC21-0XA0	模拟量输入模块 Extend module	
=F0+E1-E4	C10/5	6ES7 232-0HB22-0XA0	模拟量输出模块 Extend module	
=F0+E1-EL1	C1/3	电柜照明灯light for cabinet	电柜照明灯 Cabinet light	
=F0+E1-KA1	C8/3	MY4I4N 24DC	绕辊制动 Festoon clutch	
=F0+E1-KA1S	C1/7	CA2DN40M7C	急停回路控制 Emerg. control	
=F0+E1-KA2	C8/4	MY4I4N 24DC	工位切换 Working station change over	
=F0+E1-KA3	C8/5	MY4NN 24VDC	接纸允许 Splice	
=F0+E1-KA4	C8/6	MY4I4N 24DC	出纸侧刹车控制 Brake 1 control	
=F0+E1-KA5	C8/6	MY4I4N 24DC	展开侧刹车控制 Brake 2 control	
=F0+E1-KA6	C9/4	MY4I4N 24DC	绕辊出纸侧移动控制 Festoon forward control	
=F0+E1-KA7	C9/7	MY4I4N 24DC	绕辊展开侧移动控制 Festoon backward control	
=F0+E1-KA8	C9/7	MY4I4N 24DC	吸附 Suction	
=F0+E1-KA9	C9/8	MY4I4N 24DC	接纸部出纸侧移动 Splicer forward	
=F0+E1-KA10	C9/9	MY4I4N 24DC	接纸部展开侧移动 Splicer backward	
=F0+E1-KM1	C12/2	LC1D0910M5C	绕辊电机风机控制 Festoon motor fan control	
=F0+E1-KM2	C12/4	LC1D0910M5C	吸附电机控制 Suction control	
=F0+E1-KM3F	C12/4	LC1D0901M5C	接纸部出纸侧移动 Splicer unit forward	
=F0+E1-KM3F1	C6/5	LA1DN20	接纸部出纸侧移动检测 Splicer unit forward check	
=F0+E1-KM3R	C12/5	LC1D0901M5C	接纸部展开侧移动 Splicer unit backward	
=F0+E1-KM3R1	C6/6	LA1DN20	接纸部展开侧移动检测 Splicer unit backward check	
=F0+E1-QF0	C1/4	NSC100D3025	电源控制 Power control	
=F0+E1-QF1	C1/5	C32NC2/2P	隔离变压器初级保护 Transformer protection	
=F0+E1-QF1J	C1/3	C32N-C1/1P	检修回路断路器 For repair & check	
=F0+E1-QF2	C1/6	C32NC3/2P	急停回路保护 Emerg. stop protection	
=F0+E1-QF3	C1/6	C32NC3/2P	控制回路保护 Control circuit protection	
=F0+E1-QF4	C1/6	C32NC2/2P	24VDC电源保护 24VDC power protection	
=F0+E1-QM1	C2/3	GV2-M14	绕辊电机保护 Festoon motor protection	
=F0+E1-QM2	C2/5	GV2-M10	吸附电机保护 Suction motor protection	
=F0+E1-QM3	C2/7	GV2-M07	接纸部移动电机保护 Splicer unit motor protection	



机型MODEL: JZ-B接纸机SPLICER
 用户CUSTOMER: 京山轻机J.S.Machine
 设计BY:
 制图DRWN:

工艺TECH:
 标准STD:
 审核CHK:
 审定REV:

版本号VER.NO.: 1.04.0
 标题TITLE: 元件清单Part list table
 设计方案号DESIGN NO.: JZB接纸机
 PAGE M2 TOTAL M3

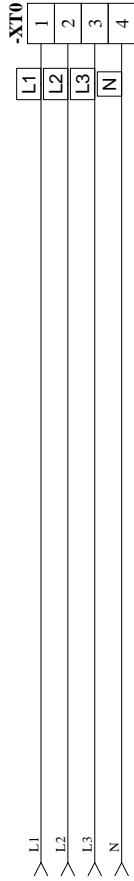
端子线缆图 Terminal & Cable Diagram



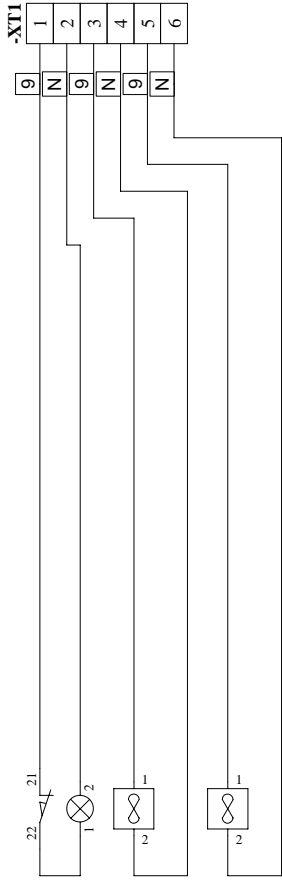
J.S.Machine

接线端子图 Terminal Diagram

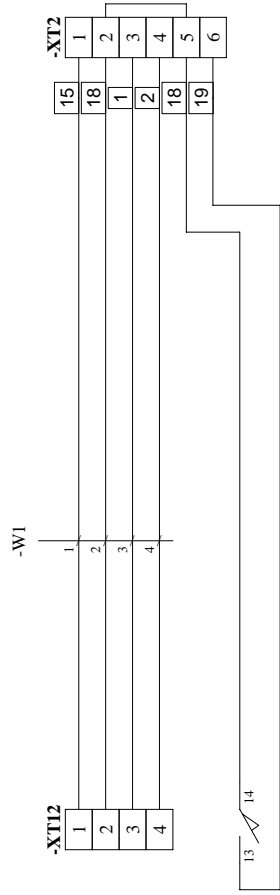
外部



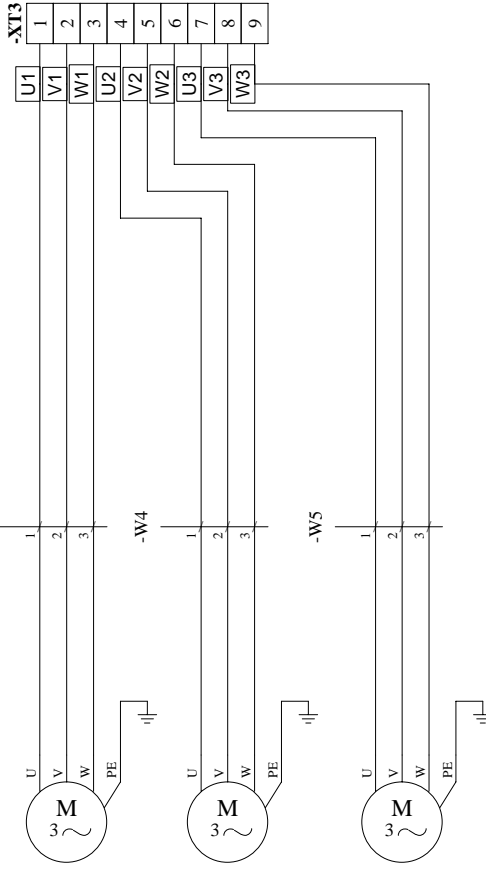
电源
Power



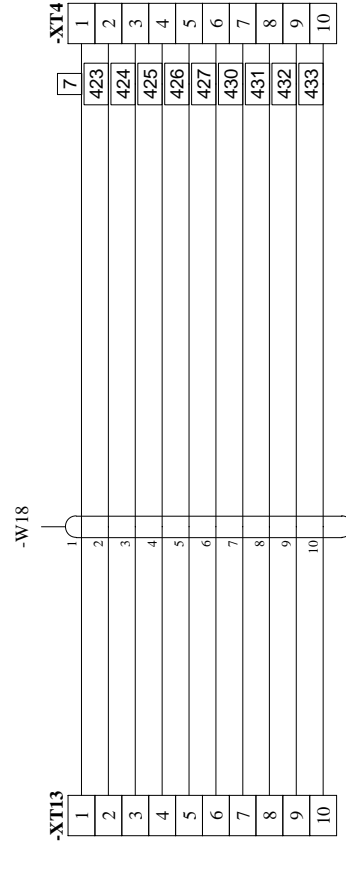
=F0 +E1 电柜门检测
-SQ5 door of cabinet
=F0 +E1 电柜照明灯
-EL1 Cabinet light
+E1 -MC1 驱动柜风扇
Fan of cabinet
+E1 -MC2 驱动柜风扇
Fan of cabinet



=F0 电柜门检测
+E1 door of cabinet
-SQ5



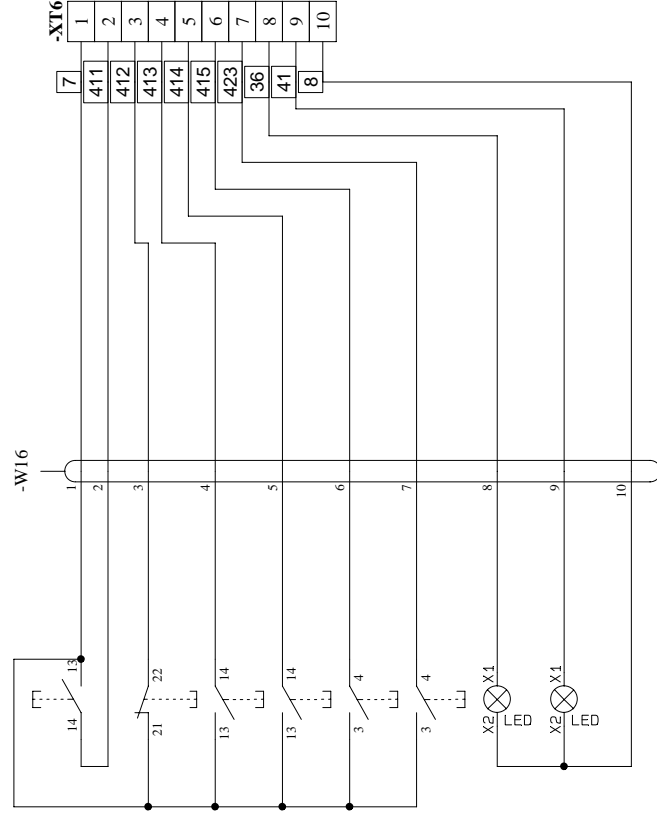
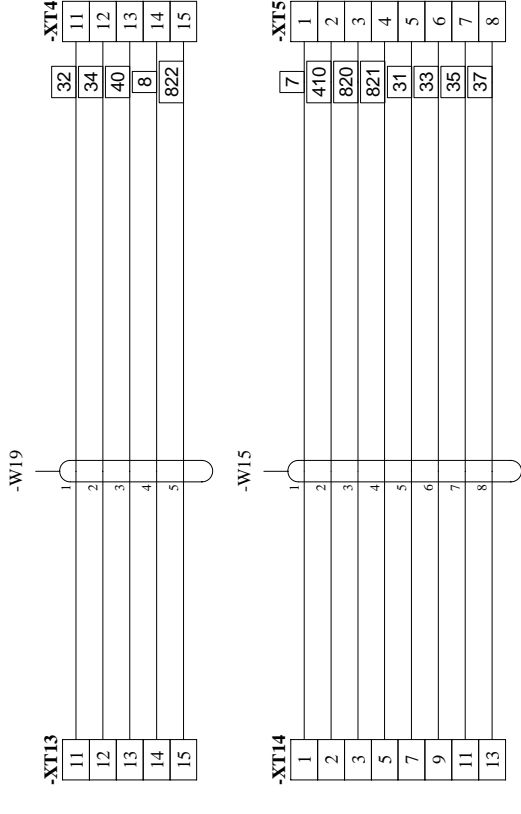
-M1 绕辊电机风机40W
Festoon motor fan 40W
-M2 吸屑电机2.2KW
Suction motor, 2.2KW
-M3 接纸部移动电机0.75KW
Splicer unit motor 0.75KW



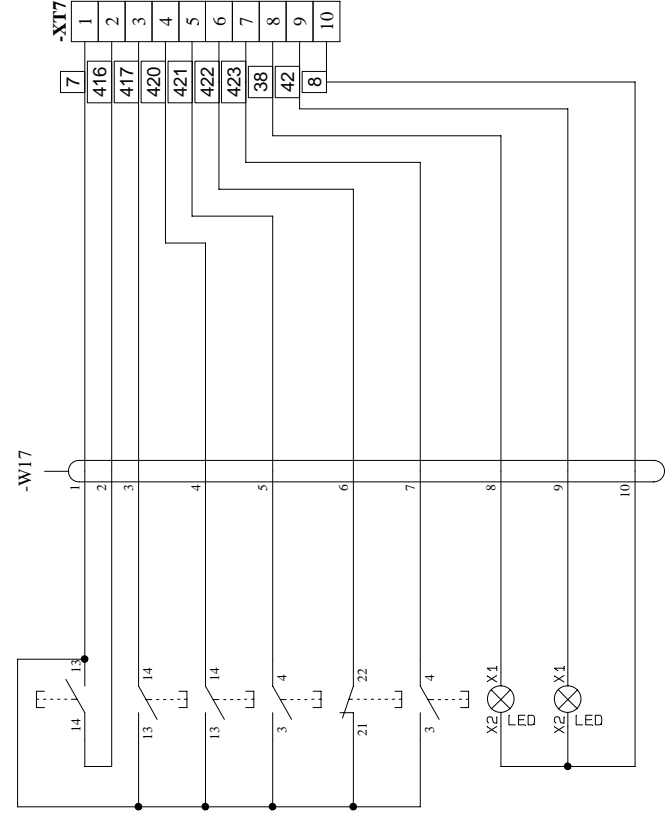
-M3 接纸部移动电机0.75KW
Splicer unit motor 0.75KW

接线端子图 Terminal Diagram

外部



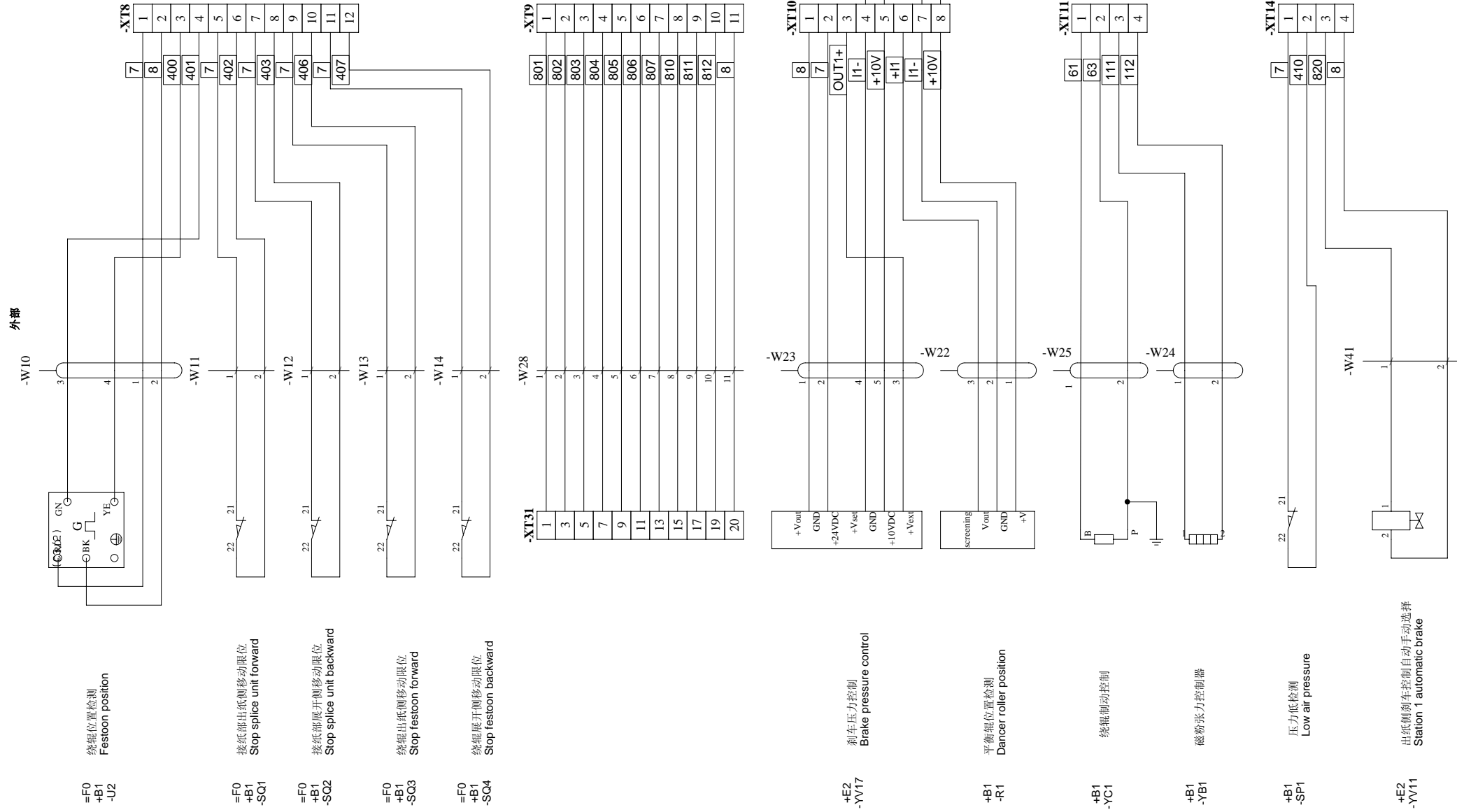
- =F0 +C2 -SB1 接纸部出纸侧方向移动 Splice unit forward
- =F0 +C2 -SB2 接纸部停止 Stop splice unit
- =F0 +C2 -SB4 出纸侧吸纸 Suction
- =F0 +C2 -SB5 出纸侧准备完成确认 Splice ready
- =F0 +C2 -SB6 出纸侧吸纸控制 Station 1 brake on-off
- =F0 +C2 -SB11 出纸侧接纸 Station 1 splice
- =F0 +C2 -SB6 左侧吸纸控制 Station 1 brake on-off
- =F0 +C3 -SB12 展开侧接纸允许 Station 2 splice



- =F0 +C3 -SB7 接纸部展开侧方向移动 Splice unit backward
- =F0 +C3 -SB8 展开侧吸纸 Suction
- =F0 +C3 -SB9 展开侧准备完成确认 Splice ready
- =F0 +C3 -SB10 展开侧吸纸控制 Station 2 brake on-off
- =F0 +C3 -SB3 接纸部停止 Stop splice unit
- =F0 +C3 -SB12 展开侧接纸 Station 2 splice
- =F0 +C3 -SB10 右侧吸纸控制 Station 2 brake on-off
- =F0 +C2 -SB11 出纸侧接纸允许 Station 1 splice

接线端子图 Terminal Diagram

外部



=F0
+B1
-U2

绕辊位置检测
Festoon position

=F0
+B1
-SQ1

接纸部展纸侧移动限位
Stop splice unit forward

=F0
+B1
-SQ2

接纸部展纸侧移动限位
Stop splice unit backward

=F0
+B1
-SQ3

绕辊展纸侧移动限位
Stop festoon forward

=F0
+B1
-SQ4

绕辊展纸侧移动限位
Stop festoon backward

+E2
-YV17

刹车压力控制
Brake pressure control

+B1
-R1

平衡辊位置检测
Dancer roller position

+B1
-YC1

绕辊制动控制

+B1
-YB1

磁粉张力控制器

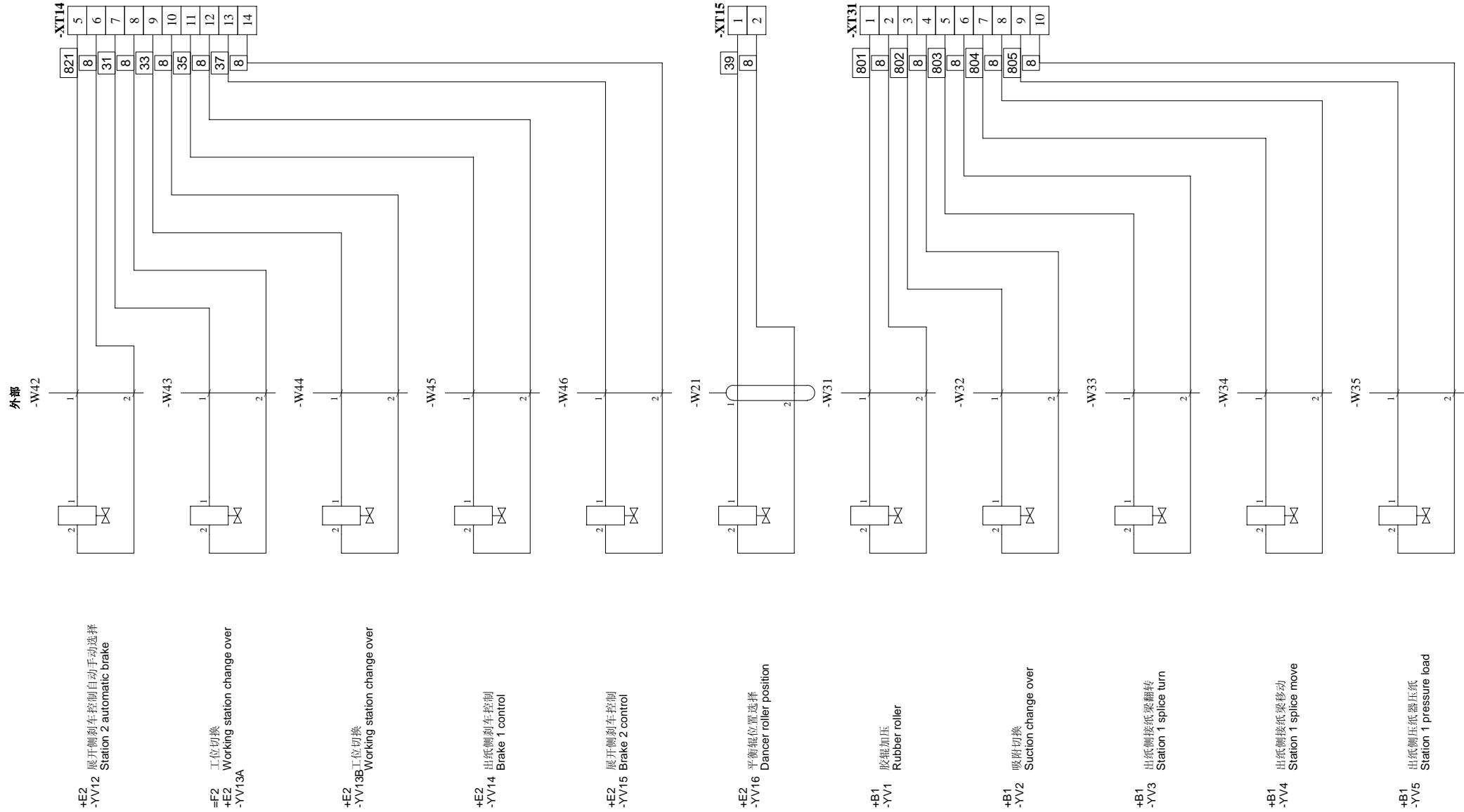
+B1
-SP1

压力低检测
Low air pressure

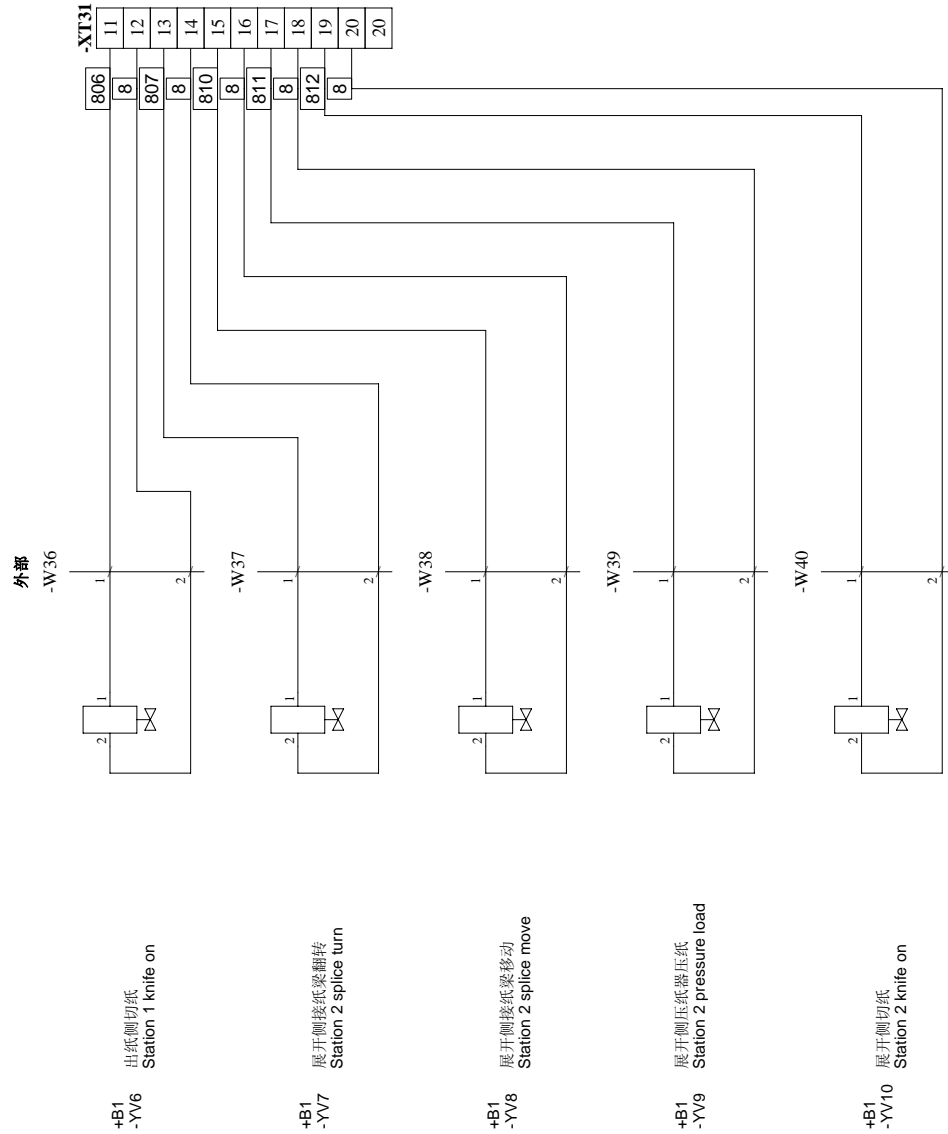
+E2
-YV11

出纸侧刹车控制自动手选
Station 1 automatic brake

接线端子图 Terminal Diagram



接线端子图 Terminal Diagram



-XT151	1
	2
	3
	4
	5
	6
	7
	8

与生产管理系统连接
Connection to PMS