

iQ Series

ULTRASONIC WELDING SYSTEM



HAND PROBE



AUTOMATED



PRESS

43Q220-P-301 OPERATING A DUKANE THRUSTER FROM A PLC Dukane Ultrasonic Welders



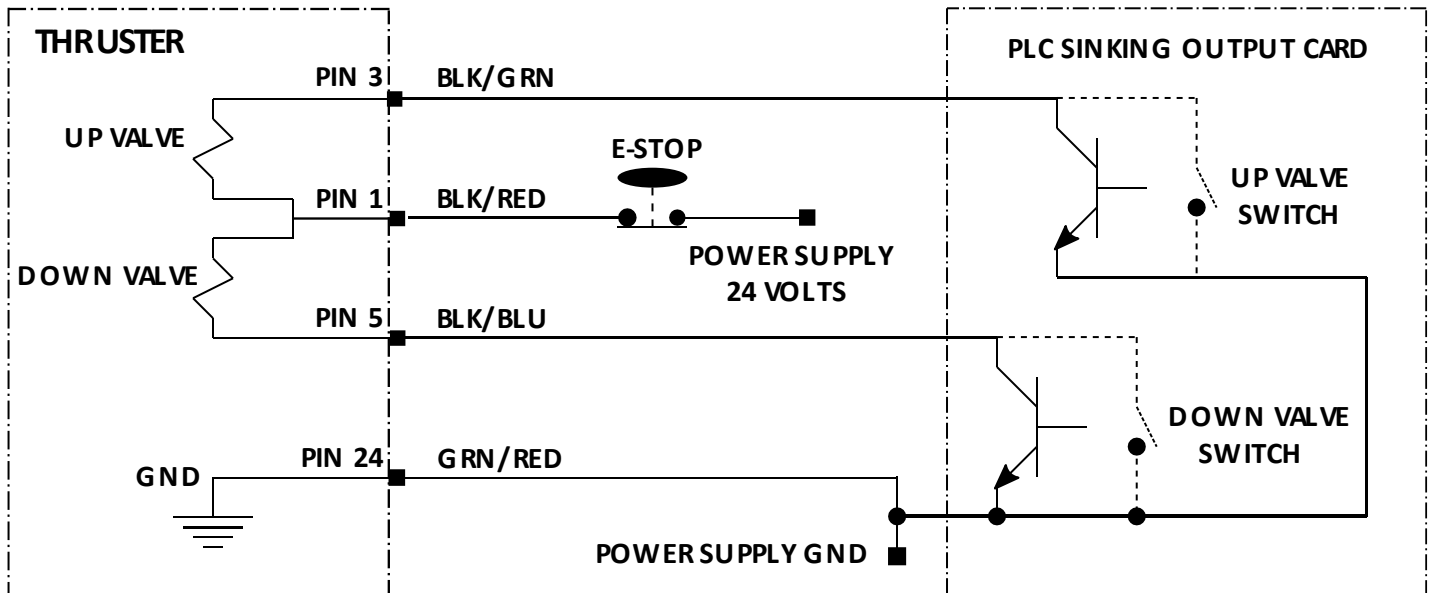
CONNECTING A 43Q220-P-301 THRUSTER TO A PLC

Thruster Cable part number: 200-1413

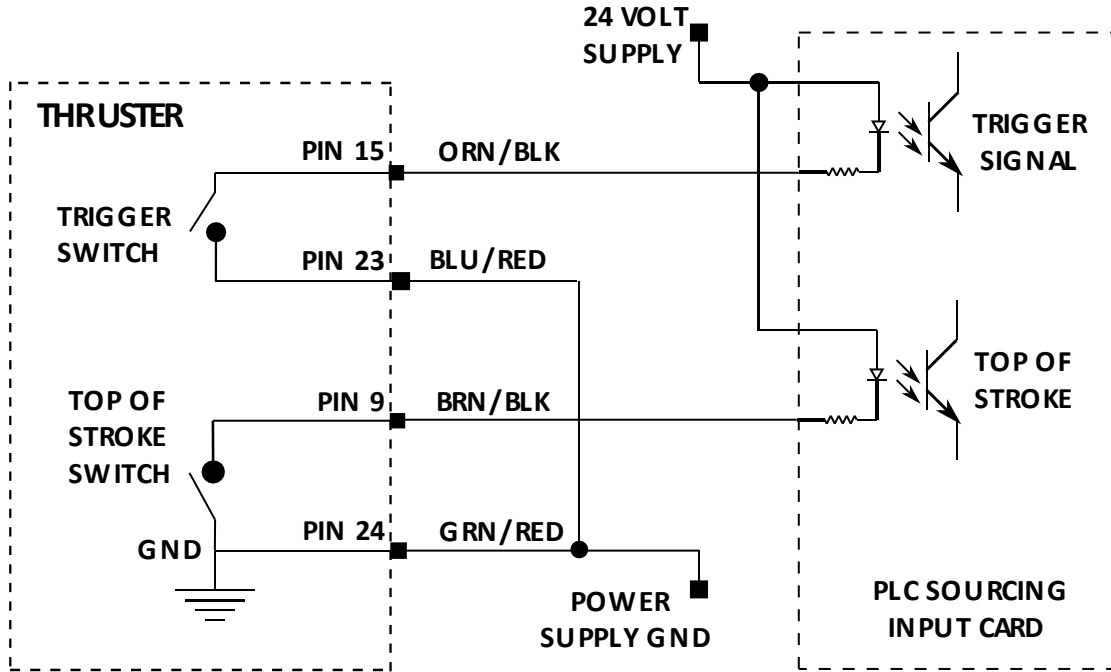
The cable is provided with a connector on both ends. If desired cut the connector from one end to expose the individual wires. Below are the pins used for thruster control. At minimum only 4 connections are needed. The Top of Stroke, Trigger and Dual Pressure Valve connections are optional if additional functionality is desired.

Wire Color	Pin no#	Function
BLK/RED	1	22 Volts
BLK/GRN	3	Up Valve
BLK/BLU	5	Down Valve
BRN/BLK	9	Top of Stroke (relative to GND)
ORN/BLK	15	Trigger
BLU/RED	23	Trigger return
YEL/RED	20	Dual Pressure Valve
GRN/RED	24	GND

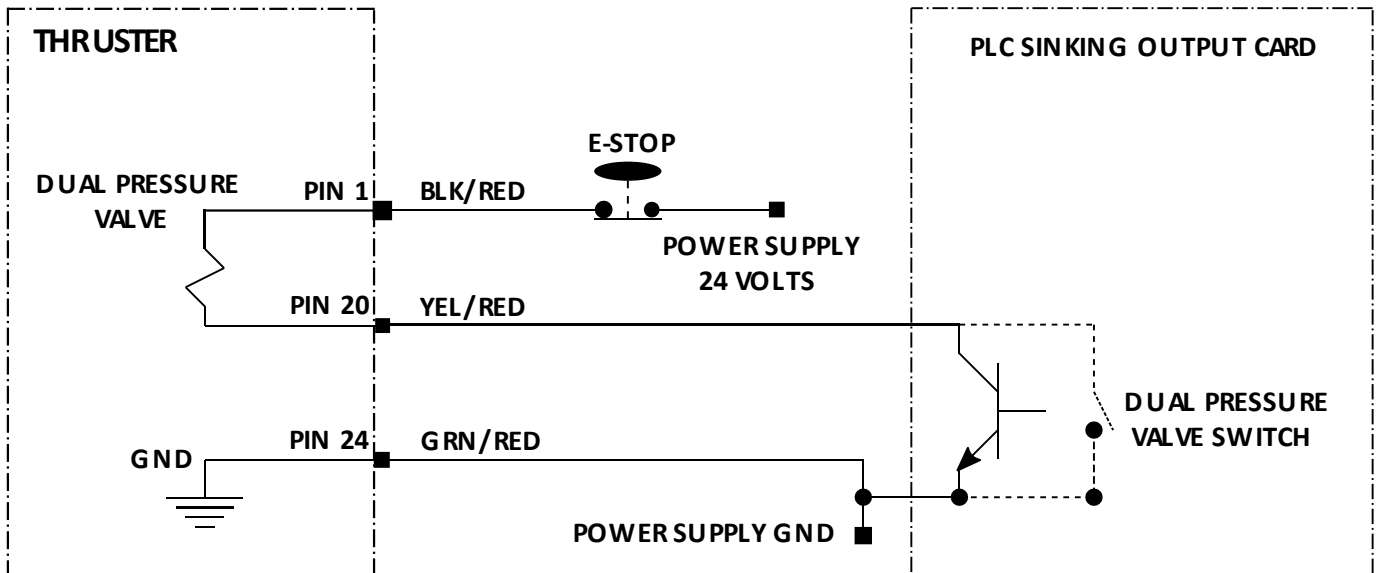
It is recommended that an E-stop be inserted between the 24 volt power supply and the cable connection. This will turn both valves off, allowing the thruster to go to a neutral state. The 24 volt power supply should be capable of supplying 0.5 amps or more.



OPTIONAL TRIGGER SWITCH AND TOP OF STROKE SIGNALS



OPTIONAL DUAL PRESSURE VALVE



NOTE: These signals are not necessary for operation. These are only provided as optional if additional functionality is required.

Dukane

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