Project:	13B01
Description:	Linea taglio trasversale
Comm:	A97
Customer:	Novastilmec S.p.a.
Receiver:	

Builder:

elettromeccanica ERCA s.r.l.
IMPIANTI - SISTEMI - AUTOMAZIONE
VIA CONCORDIA, 37 - RENATE
(MILANO) - ITALY
TEL. +39-0362/924631
FAX +39-0362/925069
E-MAIL tecnico@ercasrl.it - amministrazione@ercasrl.it

GENERALS CHARACTERISTIC TABLE

Working voltage:	400V
Auxiliary voltage:	220V-110V-24Vdc
Isolation voltage:	690V
Working current:	1600A
S.C. current:	10KA
Ext. isolation degree:	IP23
Int. isolation degree:	IP20
Norms reference:	EN60204-1
Size BxHxP:	14400x2300x800
Installation:	PAVEMENT
Pred. wires arrived:	LOW
Carpentry:	METAL

Note:

Line sense Right-Left

Customer:

NOVASTILMEC S.p.A.
Coil Processing Equipment

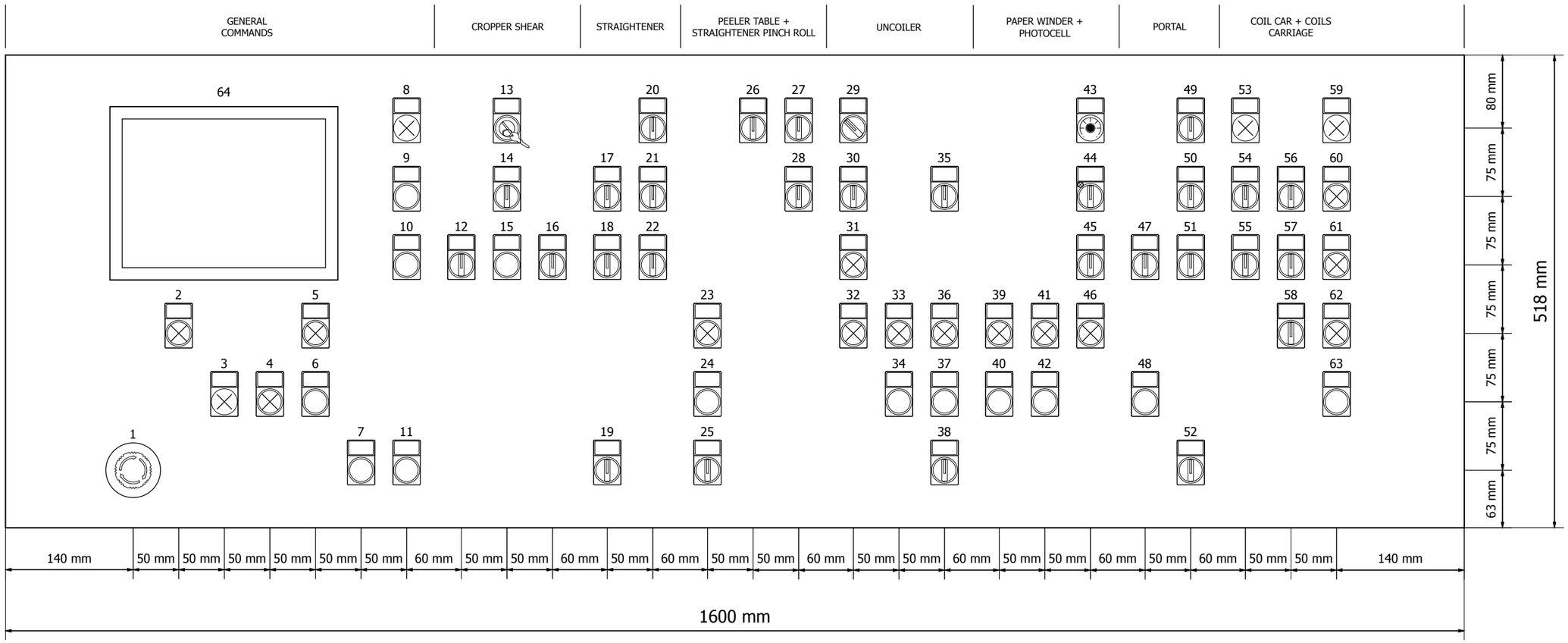
Date creation project: 02/01/2013

Revision	Date	Controlled	Approved	Drawer

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Date	05/02/2013	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cover sheet		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm:	A97		Installation: Linea taglio trasversale		Page 1
Revision		Replacement of	Replaced by			Group:	Of 414

P01 CONSOLE LAYOUT



Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P01 console layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 80
Revision			Replacement of / Replaced by			Group:	Of 414

Legend P01

Position	Short name	Description	Label
1	150S8	Red mushroom button diam.40 with lock to pressure and unlock to rotation	EMERGENCY ON FROM P01
2	819S0	Blue luminous button	ENTRY ZONE GENERAL RESET
3	837H3	24V red led lamp	LINE STOP ALARM
4	819S2	Red luminous button	LINE STOP
5	813S2	Blue luminous button	MACHINE POSITIONING START
6	813S3	Red button met.	MACHINE POSITIONING STOP
7	819S3	Yellow button met.	ENTRY SECTION FORWARD
8	835H7	24V yellow led lamp	COIL LOW DIAMETER
9	819S5	White button met.	LINE SPEED INCREASE
10	819S6	Black button met.	LINE SPEED DECREASE
11	819S4	Black button met.	ENTRY SECTION BACKWARD
12	816S4	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 2 EXIT TABLE UP - DOWN
13	817S1	Black key selector 2 positions extraction to 0 contact NO	CROPPER SHEAR MANUAL - AUTOMATIC
14	817S2	Black selector 3 pulses position return to centre contacts 2NO	CROPPER SHEAR BLADES CLEARANCE - / +
15	817S0	White button met.	CROPPER SHEAR CUT
16	816S2	Black selector 3 pulses position return to centre contacts 2NO	SHEAR EXIT TABLE UP - DOWN
17	815S4	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER FOLD HEAD ROLL UP - DOWN
18	815S0	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER DEFLECTOR ROLL UP - DOWN
19	814S3	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER FORWARD - BACKWARD
20	814S4	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER 1° SCREW JACK UP - DOWN
21	814S6	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER 2° SCREW JACK UP - DOWN
22	815S2	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER SCREW JACKS COUPLED UP - DOWN
23	814S0	Green luminous button	ENTRY STRAIGHTENER PINCH ROLL CLOSE
24	814S1	Red button met.	ENTRY STRAIGHTENER PINCH ROLL OPEN
25	813S6	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER PINCH ROLL FORWARD - BACKWARD
26	812S6	Black selector 3 pulses position return to centre contacts 2NO	SIDE GUIDES 1 OPEN - CLOSE
27	812S0	Black selector 3 pulses position return to centre contacts 2NO	PEELER TABLE EXTEND - RETRACT
28	812S2	Black selector 3 pulses position return to centre contacts 2NO	PEELER TABLE UP - DOWN
29	810S0	Black selector 2 permanent positions contact NO	DECOILING UP - DOWN

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Enclosure legend		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 81
Revision		Replacement of	Replaced by			Group:	Of 414

Legend P01

Position	Short name	Description	Label
30	807S6	Black selector 3 pulses position return to centre contacts 2NO	DECOILER SUPPORT UP - DOWN
31	811S6	White luminous button	COILS IN THE MIDDLE INDICATOR ON - OFF
32	811S7	Blue luminous button	DECOILER IN THE MIDDLE LINE POSITION
33	810S7	Green luminous button	UNCOILER MANDREL EXPANSION
34	811S0	Red button met.	UNCOILER MANDREL COLLAPSE
35	810S5	Black selector 3 pulses position return to centre contacts 2NO	UNCOILER MOTOR SIDE - OPERATOR SIDE
36	810S1	Green luminous button	UNCOILER TENSION START
37	810S2	Red button met.	UNCOILER TENSION STOP
38	810S3	Black selector 3 pulses position return to centre contacts 2NO	UNCOILER FORWARD - BACKWARD
39	809S6	Green luminous button	PHOTOCELL SEARCH EDGE START
40	809S7	Red button met.	PHOTOCELL SEARCH EDGE STOP
41	809S4	Green luminous button	AUTOMATIC ALIGNMENT PHOTOCELL
42	809S5	Red button met.	MANUAL ALIGNMENT PHOTOCELL
43	380R1	Potentiometer 10K 1 turn	PAPER WINDER REGULATION
44	808S5	Green luminous selector 3 position perm.	PAPER WINDER MANUAL - 0 - AUTOMATIC
45	809S1	Black selector 3 pulses position return to centre contacts 2NO	PAPER WINDER IN - OUT
46	809S3	Blue luminous button	PAPER WINDER AUTOMATIC CENTERING
47	808S0	Black selector 3 pulses position return to centre contacts 2NO	REAR ROLL ROTATION FORWARD - BACKWARD
48	808S4	Black button met.	CENTRE PRESSURE ROLLS
49	807S4	Black selector 3 pulses position return to centre contacts 2NO	FRONT PRESSURE ROLL UP - DOWN
50	807S0	Black selector 3 pulses position return to centre contacts 2NO	CENTRE PRESSURE ROLL UP - DOWN
51	807S2	Black selector 3 pulses position return to centre contacts 2NO	REAR PRESSURE ROLL UP - DOWN
52	808S2	Black selector 3 pulses position return to centre contacts 2NO	UNCOILERS+CONTEMPORARY ROTATION ROLLS FORWARD - BACKWARD
53	835H3	24V yellow led lamp	COIL CAR UNDER UNCOILER
54	806S2	Black selector 3 pulses position return to centre contacts 2NO	LOADING COIL CAR UP - DOWN
55	806S4	Black selector 3 pulses position return to centre contacts 2NO	COILS ROTATION ANTICLOCKWISE - CLOCKWISE
56	805S6	Black selector 3 pulses position return to centre contacts 2NO	COILS CARRIAGE FORWARD - BACKWARD
57	805S4	Black selector 3 pulses position return to centre contacts 2NO	RAIL COILS CARRIAGE OPEN - CLOSE
58	806S0	Black selector 3 pulses position return to centre contacts 2NO	COIL CAR OPERATOR SIDE - MOTOR SIDE
59	835H4	24V yellow led lamp	COIL CAR UNDER COILS CARRIAGE

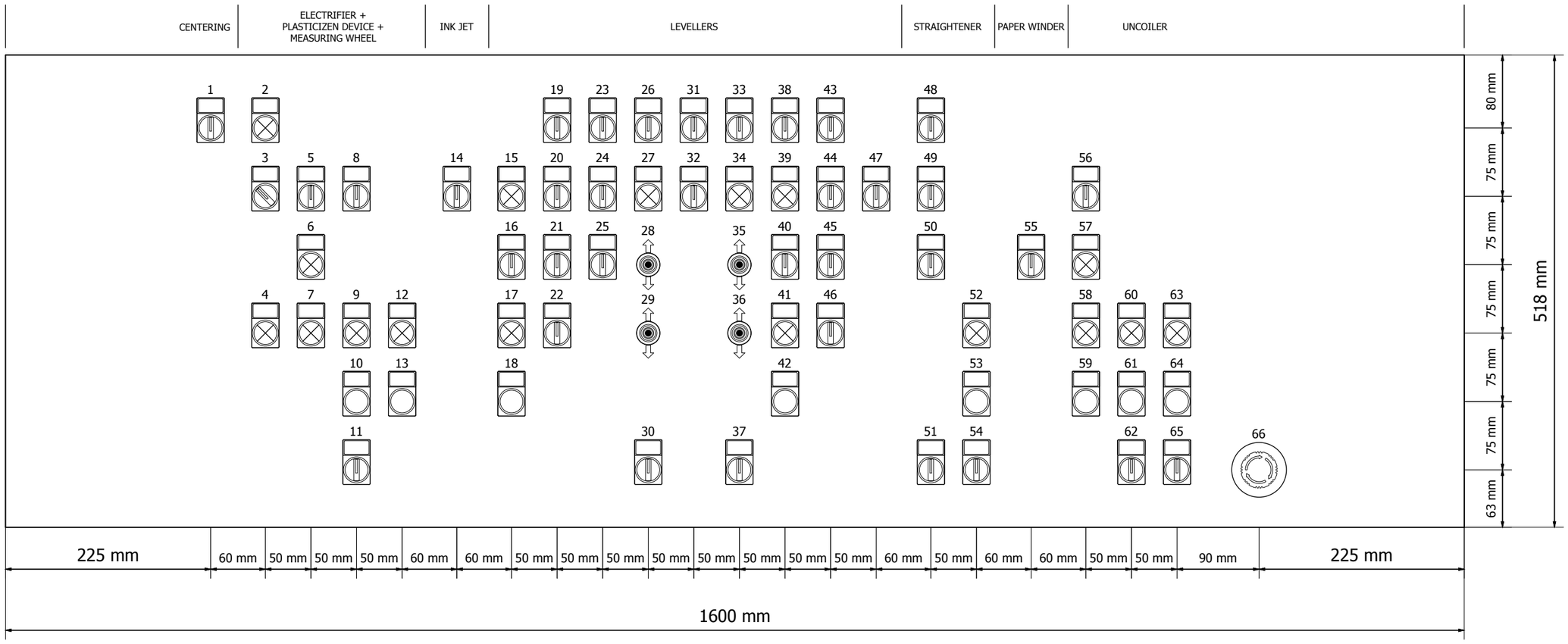
Legend P01

Position	Short name	Description	Label
60	805S0	Yellow luminous button	COILS CARRIAGE POSITIONING STATION 1
61	805S2	Yellow luminous button	COILS CARRIAGE POSITIONING STATION 2
62	805S3	Yellow luminous button	COILS CARRIAGE POSITIONING STATION 3
63	805S1	Red button met.	COILA CARRIAGE POSITIONING STOP
64	800P1	Simatic touch multi panel MP 277 8"	OPERATOR PANEL

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ENTRY LINE SIDE P02 CONSOLE LAYOUT



Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Entry line side P02 console layout		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 85
Revision		Replacement of	Replaced by			Group:	Of 414

Legend

P02 LATO INGRESSO LINEA

Position	Short name	Description	Label
1	878S4	Black selector 3 pulses position return to centre contacts 2NO	SIDE GUIDES 2 OPEN - CLOSE
2	878S2	Green luminous button	ELECTRIFIER ON / OFF
3	878S0	Black selector 2 permanent positions contact NO	LOWER HEATER LAMPS MANUAL - AUTOMATIC
4	877S7	Green luminous button	LOWER HEATING PAPER LAMP 2 ON
5	877S4	Black selector 3 pulses position return to centre contacts 2NO	LOWER ROLLS SUPPORT TRANSLATION OPERATOR SIDE - MOTOR SIDE
6	878S1	Green luminous button	LOWER PRE HEATING PAPER LAMPS ON
7	877S6	Green luminous button	LOWER HEATING PAPER LAMP 1 ON
8	877S0	Black selector 3 pulses position return to centre contacts 2NO	UPPER ROLLS SUPPORT TRANSLATION OPERATOR SIDE - MOTOR SIDE
9	877S2	Green luminous button	PLASTICIZEN DEVICE UPPER ROLL CLOSE
10	877S3	Red button met.	PLASTICIZEN DEVICE UPPER ROLL UP
11	876S4	Black selector 3 pulses position return to centre contacts 2NO	PLASTICIZEN DEVICE FORWARD - BACKWARD
12	876S2	Green luminous button	MEASURING WHEEL DOWN
13	876S3	Red button met.	MEASURING WHEEL UP
14	868S6	Black selector 3 pulses position return to centre contacts 2NO	HEAD INK JET UP - DOWN
15	875S5	Yellow luminous button	LEVELLER 2 GREASE LUBRICATION RESET
16	875S6	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 2 CLEANING ROLLS OPERATOR SIDE - MOTOR SIDE
17	876S0	Green luminous button	LEVELLER 2 CLEANING ROLLS START
18	876S1	Red button met.	LEVELLER 2 CLEANING ROLLS STOP
19	873S4	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER BACK UP ROLL 7 UP - DOWN
20	876S6	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 2 SLIDING JOINTS UP - DOWN
21	875S0	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 2 UPPER BENCH LOCKED - RELEASE
22	875S2	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 2 LOWER BENCH LOCKED - RELEASE
23	873S2	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER BACK UP ROLL 6 UP - DOWN
24	859S2	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 1 - LEVELLER 2 TABLE UP - DOWN
25	859S4	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 2 ENTRY ROLL UP - DOWN
26	868S4	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER BACK UP ROLL 5 UP - DOWN
27	875S4	Yellow luminous button	LEVELLER 2 SELECTION
28	869S4	Manipulator 2 pulses position return to centre 2NO	LEVELLER SCREW JACKS 3 UP - DOWN
29	869S6	Manipulator 2 pulses position return to centre 2NO	LEVELLER SCREW JACKS 4 UP - DOWN

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Enclosure legend		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 86
Revision		Replacement of	Replaced by			Group:	Of 414

Legend

P02 LATO INGRESSO LINEA

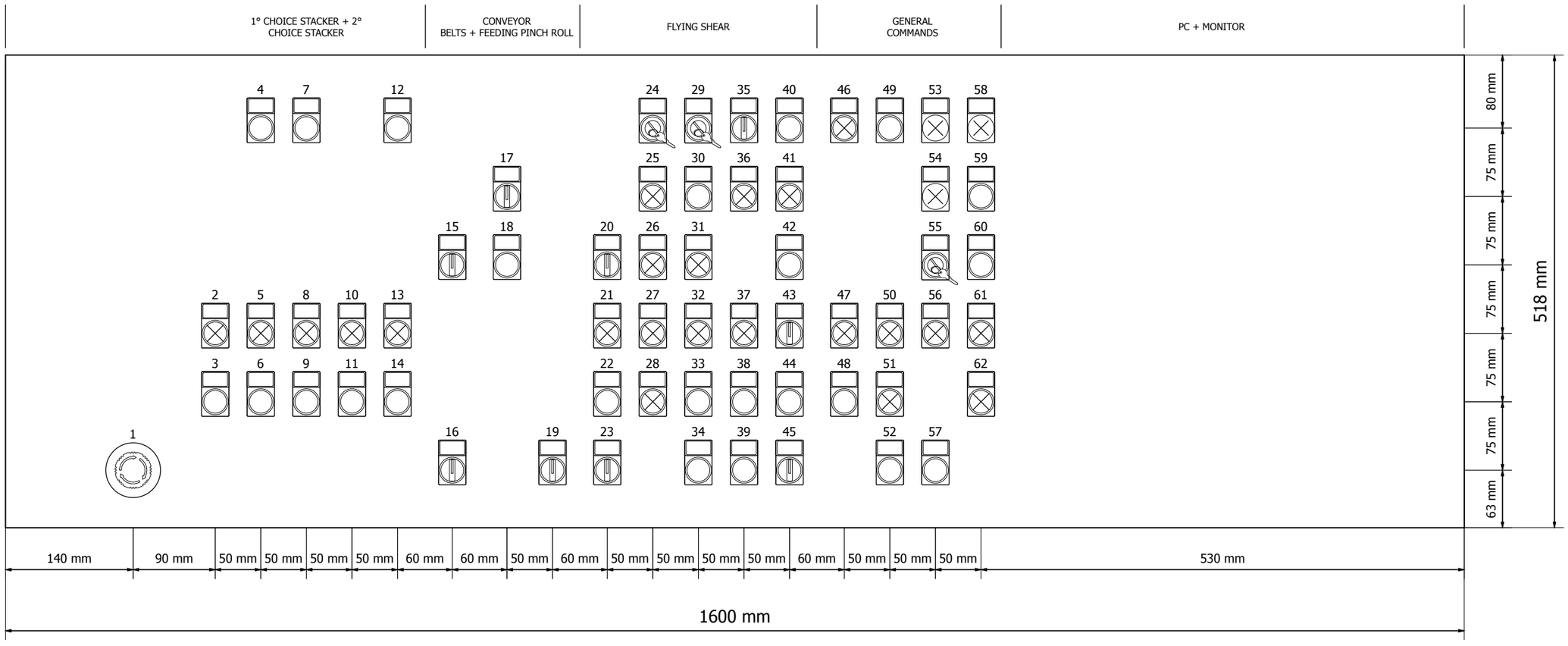
Position	Short name	Description	Label
30	871S6	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 2 FORWARD - BACKWARD
31	868S2	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER BACK UP ROLL 4 UP - DOWN
32	870S0	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER UPPER BENCH UP - DOWN
33	868S0	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER BACK UP ROLL 3 UP - DOWN
34	871S0	Yellow luminous button	LEVELLER 1 SELECTION
35	869S0	Manipulator 2 pulses position return to centre 2NO	LEVELLER SCREW JACKS 1 UP - DOWN
36	869S2	Manipulator 2 pulses position return to centre 2NO	LEVELLER SCREW JACKS 2 UP - DOWN
37	867S2	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 1 FORWARD - BACKWARD
38	867S6	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER BACK UP ROLL 2 UP - DOWN
39	871S1	Yellow luminous button	LEVELLER 1 GREASE LUBRICATION RESET
40	871S2	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 1 CLEANING ROLLS OPERATOR SIDE - MOTOR SIDE
41	871S4	Green luminous button	LEVELLER 1 CLEANING ROLLS START
42	871S5	Red button met.	LEVELLER 1 CLEANING ROLLS STOP
43	867S4	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER BACK UP ROLL 1 UP - DOWN
44	870S2	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 1 SLIDING JOINTS UP - DOWN
45	870S4	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 1 UPPER BENCH LOCKED - RELEASE
46	870S6	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 1 LOWER BENCH LOCKED - RELEASE
47	859S0	Black selector 3 pulses position return to centre contacts 2NO	LEVELLER 1 ENTRY ROLL UP - DOWN
48	858S2	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER 1° SCREW JACK UP - DOWN
49	858S4	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER 2° SCREW JACK UP - DOWN
50	858S6	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER SCREW JACKS COUPLED UP - DOWN
51	858S0	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER FORWARD - BACKWARD
52	857S6	Green luminous button	ENTRY STRAIGHTENER PINCH ROLL CLOSE
53	857S7	Red button met.	ENTRY STRAIGHTENER PINCH ROLL OPEN
54	857S4	Black selector 3 pulses position return to centre contacts 2NO	STRAIGHTENER PINCH ROLL FORWARD - BACKWARD
55	856S2	Black selector 3 pulses position return to centre contacts 2NO	PAPER WINDER IN - OUT
56	857S0	Black selector 3 pulses position return to centre contacts 2NO	UNCOILER MOTOR SIDE - OPERATOR SIDE
57	856S5	Blue luminous button	DECOILER IN THE MIDDLE LINE POSITION
58	856S6	Green luminous button	UNCOILER MANDREL EXPANSION

Legend

P02 LATO INGRESSO LINEA

Position	Short name	Description	Label
59	856S7	Red button met.	UNCOILER MANDREL COLLAPSE
60	856S0	Green luminous button	UNCOILER TENSION START
61	856S1	Red button met.	UNCOILER TENSION STOP
62	855S6	Black selector 3 pulses position return to centre contacts 2NO	UNCOILER FORWARD - BACKWARD
63	855S4	Green luminous button	AUTOMATIC ALIGNMENT PHOTOCELL
64	855S5	Red button met.	MANUAL ALIGNMENT PHOTOCELL
65	855S2	Black selector 3 pulses position return to centre contacts 2NO	UNCOILERS+CONTEMPORARY ROTATION ROLLS FORWARD - BACKWARD
66	150S9	Red mushroom button diam.40 with lock to pressure and unlock to rotation	EMERGENCY ON FROM P02

EXIT LINE SIDE P02 CONSOLE LAYOUT



Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Exit line side P02 console layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	89
Revision			Replacement of / Replaced by			Group:	Of 414

Legend

P02 LATO USCITA LINEA

Position	Short name	Description	Label
1	150S10	Red mushroom button diam.40 with lock to pressure and unlock to rotation	EMERGENCY ON FROM P02
2	888S3	Green luminous button	1° CHOICE STACKER ASPIRATION CONVEYOR BELT START
3	888S4	Red button met.	1° CHOICE STACKER ASPIRATION CONVEYOR BELT STOP
4	888S6	Yellow button met.	SUPPORTS MANUAL CYCLE STACKER 2° BOX
5	888S1	Green luminous button	1° CHOICE STACKER 2° BOX AUTOMATIC
6	888S2	Red button met.	1° CHOICE STACKER 2° BOX MANUAL
7	885S6	Yellow button met.	SUPPORTS MANUAL CYCLE STACKER 1° BOX
8	886S1	Green luminous button	1° CHOICE STACKER 1° BOX AUTOMATIC
9	886S2	Red button met.	1° CHOICE STACKER 1° BOX MANUAL
10	885S7	Green luminous button	SHEET CONVEYOR STACKER 1° BOX START
11	886S0	Red button met.	SHEET CONVEYOR STACKER 1° BOX STOP
12	885S4	Yellow button met.	SUPPORTS MANUAL CYCLE 2° CHOICE STACKER
13	885S2	Green luminous button	2° CHOICE STACKER AUTOMATIC
14	885S3	Red button met.	2° CHOICE STACKER MANUAL
15	884S6	Black selector 3 pulses position return to centre contacts 2NO	2° CONVEYOR BELT 2° CHOICE - 1° CHOICE
16	885S0	Black selector 3 pulses position return to centre contacts 2NO	3° CONVEYOR BELT FORWARD - BACKWARD
17	884S1	Black selector 3 pulses position return to centre contacts 2NO	1° FEEDING PINCH ROLL UP - DOWN
18	885S5	Black button met.	ENTRY 1° CHOICE STACKER FEEDING PINCH ROLL DOWN
19	884S4	Black selector 3 pulses position return to centre contacts 2NO	2° CONVEYOR BELT FORWARD - BACKWARD
20	883S5	Black selector 3 pulses position return to centre contacts 2NO	HEADING SHEETS SCRAPS CONVEYOR BELT UP - DOWN
21	883S1	Green luminous button	CONVEYOR BELTS START
22	883S2	Red button met.	CONVEYOR BELTS STOP
23	883S3	Black selector 3 pulses position return to centre contacts 2NO	1° CONVEYOR BELT FORWARD - BACKWARD
24	882S1	Black key selector 2 positions extraction to 0 contact NO	FLYING SHEAR BLADES CHANGE DISABLE - ENABLE
25	882S5	Blue luminous button	FLYING SHEAR BLADES CHANGE POSITION 1
26	882S6	Blue luminous button	FLYING SHEAR BLADES CHANGE POSITION 2
27	882S7	Blue luminous button	FLYING SHEAR BLADES CHANGE POSITION 3
28	883S0	Blue luminous button	FLYING SHEAR BLADES CHANGE POSITION 4
29	881S6	Black key selector 2 positions extraction to 0 contact NO	FLYING SHEAR MAINTENANCE - WORK
30	881S7	White button met.	FLYING SHEAR CUT

Legend

P02 LATO USCITA LINEA

Position	Short name	Description	Label
31	881S3	Green luminous button	FLYING SHEAR AUTOMATIC CUT
32	881S0	Green luminous button	FLYING SHEAR AUTOMATIC
33	881S1	Red button met.	FLYING SHEAR MANUAL
34	880S6	Yellow button met.	FLYING SHEAR FORWARD
35	882S2	Black selector 3 pulses position return to centre contacts 2NO	FLYING SHEAR BLADES CLEARANCE - / +
36	881S2	Blue luminous button	FLYING SHEAR ALARMS RESET
37	881S4	Green luminous button	FLYING SHEAR FLYWHEEL START
38	881S5	Red button met.	FLYING SHEAR FLYWHEEL STOP
39	880S7	Black button met.	FLYING SHEAR BACKWARD
40	882S0	Blue button met.	FLYING SHEAR RESET N° CUT
41	882S4	Yellow luminous button	FLYING SHEAR GREASE LUBRICATION RESET
42	880S5	Blue button met.	TAIL ENCODER UP
43	880S3	Black selector 3 pulses position return to centre contacts 2NO	TAIL PINCH ROLL UP - DOWN
44	880S2	Black button met.	TAIL PINCH ROLL EXPULSION TAIL
45	880S0	Black selector 3 pulses position return to centre contacts 2NO	TAIL PINCH ROLL FORWARD - BACKWARD
46	886S3	Blue luminous button	CENTRAL ZONE RESET
47	857S2	Blue luminous button	MACHINE POSITIONING START
48	857S3	Red button met.	MACHINE POSITIONING STOP
49	887S0	Blue button met.	GENERAL RESET
50	886S6	Green luminous button	LINE START
51	886S7	Red luminous button	LINE STOP
52	887S1	Yellow button met.	ENTRY SECTION FORWARD
53	895H7	24V white led lamp	24Vdc SOLENOID VALVES TENSION
54	896H0	24V white led lamp	110Vac AUXILIARY TENSION
55	130S1	Black key selector 2 positions extraction to 0 contact NO	AUXILIARY INSERTION 0 - 1
56	887S3	Green luminous button	COMMANDS START
57	887S2	Black button met.	ENTRY SECTION BACKWARD
58	890H2	24V yellow led lamp	COIL LOW DIAMETER
59	887S4	White button met.	LINE SPEED INCREASE
60	887S5	Black button met.	LINE SPEED DECREASE

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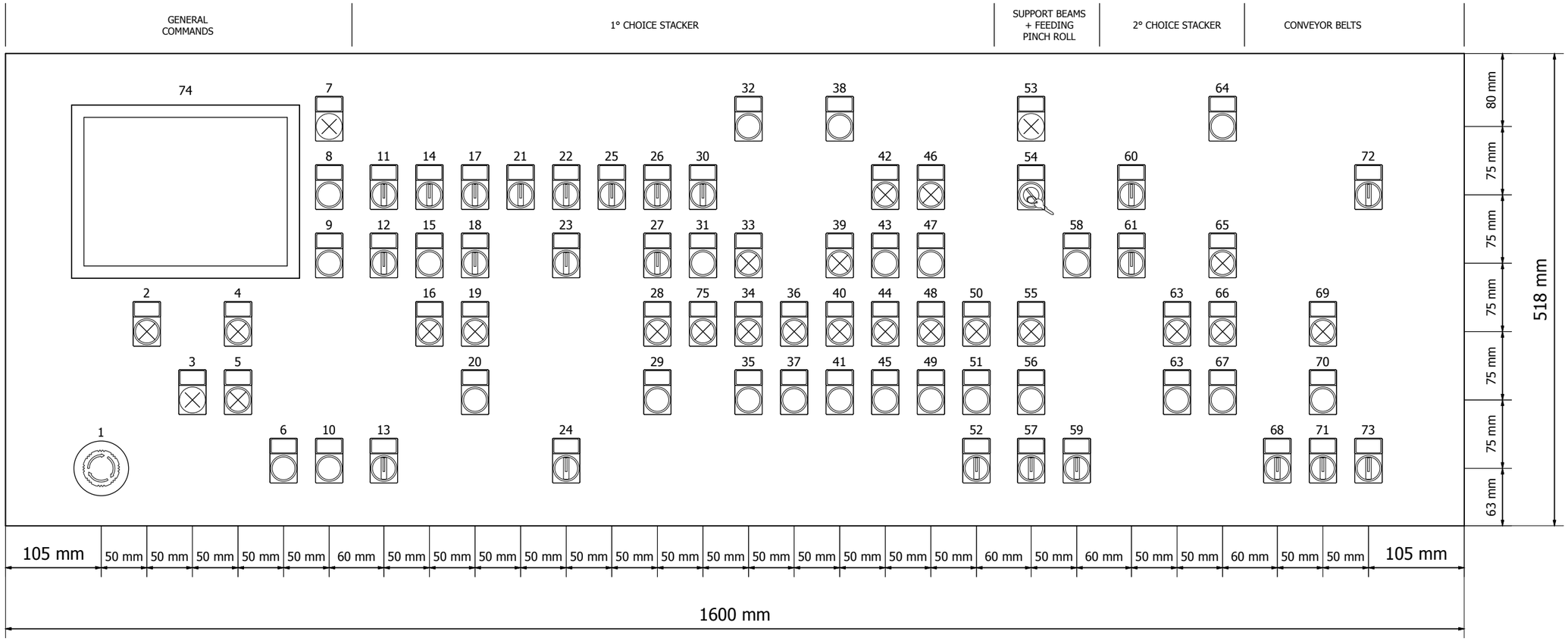
Legend

P02 LATO USCITA LINEA

Position	Short name	Description	Label
61	855S0	Green luminous button	HYDRAULIC UNIT START
62	855S1	Red luminous button	HYDRAULIC UNIT STOP

Date	20/02/2013	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Enclosure legend		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale		Page 92
Revision			Replacement of / Replaced by			Group:	Of 414

P03 CONSOLE LAYOUT



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Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P03 console layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 94
Revision			Replacement of / Replaced by			Group:	Of 414

Legend P03

Position	Short name	Description	Label
1	150S7	Red mushroom button diam.40 with lock to pressure and unlock to rotation	EMERGENCY ON FROM P03
2	913S4	Blue luminous button	EXIT ZONE RESET
3	936H7	24V red led lamp	LINE STOP ALARM
4	913S6	Green luminous button	LINE START
5	913S7	Red luminous button	LINE STOP
6	914S0	Yellow button met.	ENTRY SECTION FORWARD
7	935H0	24V yellow led lamp	COIL LOW DIAMETER
8	914S2	White button met.	LINE SPEED INCREASE
9	914S3	Black button met.	LINE SPEED DECREASE
10	914S1	Black button met.	ENTRY SECTION BACKWARD
11	912S2	Black selector 3 pulses position return to centre contacts 2NO	COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 2° BOX OPERATOR SIDE - MOTOR SIDE
12	912S6	Black selector 3 pulses position return to centre contacts 2NO	COMBINED ROLLS 1° CHOICE STACKER 2° BOX UP - DOWN
13	912S4	Black selector 3 pulses position return to centre contacts 2NO	COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 2° BOX FORWARD - BACKWARD
14	911S2	Black selector 3 pulses position return to centre contacts 2NO	WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 2° BOX OPERATOR SIDE - MOTOR SIDE
15	917S3	Blue button met.	2° PALLET LOADING TRANSFER PLATFORM START
16	917S0	Green luminous button	AUTOMATIC DOWNLOAD AFTER 1° WEIGHING TRANSFER PLATFORM
17	910S4	Black selector 3 pulses position return to centre contacts 2NO	PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX OPERATOR SIDE - MOTOR SIDE
18	909S6	Black selector 3 pulses position return to centre contacts 2NO	PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX UP - DOWN
19	910S6	Green luminous button	PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX START
20	910S7	Red button met.	PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX STOP
21	913S2	Black selector 3 pulses position return to centre contacts 2NO	LOADING PALLET TRANSFER PLATFORM 1° CHOICE STACKER 2° BOX OPERATOR SIDE - MOTOR SIDE
22	911S4	Black selector 3 pulses position return to centre contacts 2NO	COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX OPERATOR SIDE - MOTOR SIDE
23	912S0	Black selector 3 pulses position return to centre contacts 2NO	COMBINED ROLLS 1° CHOICE STACKER 1° BOX UP - DOWN
24	911S6	Black selector 3 pulses position return to centre contacts 2NO	COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX FORWARD - BACKWARD
25	911S0	Black selector 3 pulses position return to centre contacts 2NO	WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX OPERATOR SIDE - MOTOR SIDE
26	910S0	Black selector 3 pulses position return to centre contacts 2NO	PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX OPERATOR SIDE - MOTOR SIDE
27	909S4	Black selector 3 pulses position return to centre contacts 2NO	PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX UP - DOWN
28	910S2	Green luminous button	PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX START
29	910S3	Red button met.	PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX STOP

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Enclosure legend		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Group:	Page 95 Of 414
Revision							

Legend P03

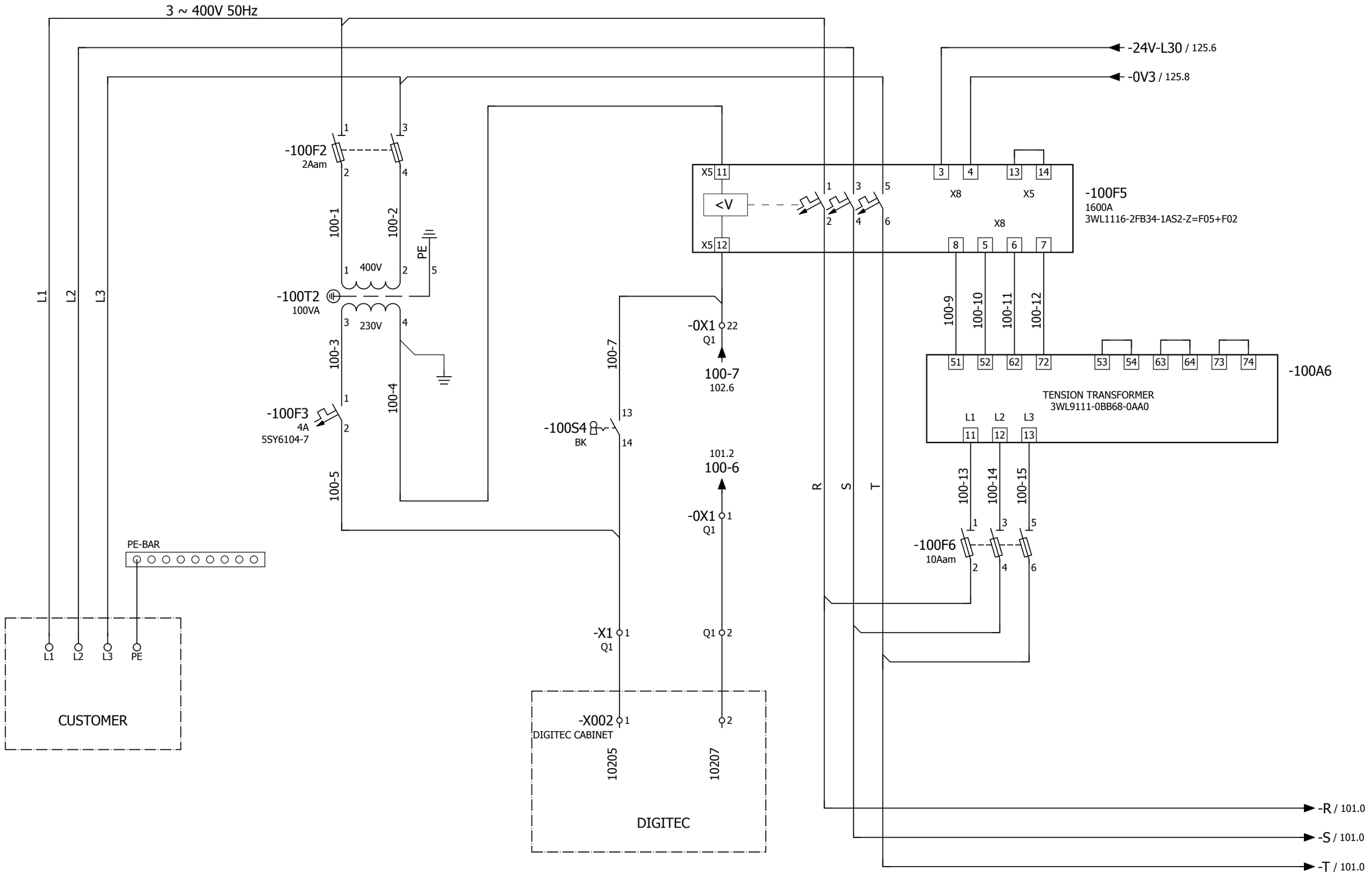
Position	Short name	Description	Label
30	913S0	Black selector 3 pulses position return to centre contacts 2NO	LOADING PALLET TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX OPERATOR SIDE - MOTOR SIDE
31	917S2	Blue button met.	1° PALLET LOADING TRANSFER PLATFORM START
32	909S0	Yellow button met.	CYCLE JOGGERS STACKER 2° BOX
33	909S3	Green luminous button	1° CHOICE STACKER 2° BOX READY
34	909S1	Green luminous button	1° CHOICE STACKER 2° BOX AUTOMATIC
35	909S2	Red button met.	1° CHOICE STACKER 2° BOX MANUAL
36	908S3	Blue luminous button	1° CHOICE STACKER POSITIONING START
37	908S4	Red button met.	1° CHOICE STACKER POSITIONING STOP
38	908S2	Yellow button met.	CYCLE JOGGERS STACKER 1° BOX
39	908S5	Green luminous button	1° CHOICE STACKER 1° BOX READY
40	908S6	Green luminous button	1° CHOICE STACKER 1° BOX AUTOMATIC
41	908S7	Red button met.	1° CHOICE STACKER 1° BOX MANUAL
42	916S0	Green luminous button	1° CHOICE STACKER 3° BOX ASPIRATION FAN START
43	916S1	Red button met.	1° CHOICE STACKER 3° BOX ASPIRATION FAN STOP
44	916S2	Green luminous button	1° CHOICE STACKER 4° BOX ASPIRATION FAN START
45	916S3	Red button met.	1° CHOICE STACKER 4° BOX ASPIRATION FAN STOP
46	915S4	Green luminous button	1° CHOICE STACKER 1° BOX ASPIRATION FAN START
47	915S5	Red button met.	1° CHOICE STACKER 1° BOX ASPIRATION FAN STOP
48	915S6	Green luminous button	1° CHOICE STACKER 2° BOX ASPIRATION FAN START
49	915S7	Red button met.	1° CHOICE STACKER 2° BOX ASPIRATION FAN STOP
50	915S0	Green luminous button	1° CHOICE STACKER ASPIRATION CONVEYOR BELT START
51	915S1	Red button met.	1° CHOICE STACKER ASPIRATION CONVEYOR BELT STOP
52	915S2	Black selector 3 pulses position return to centre contacts 2NO	1° CHOICE STACKER ASPIRATION CONVEYOR BELT FORWARD - BACKWARD
53	935H5	24V red led lamp	SHEET SUPPORT BEAMS OUT OF PHASE
54	907S4	Black key selector 3 position return to centre extraction to 0	SHEET SUPPORT BEAMS TIMING FRONT - REAR
55	907S6	Green luminous button	SHEET CONVEYOR STACKER 1° BOX START
56	907S7	Red button met.	SHEET CONVEYOR STACKER 1° BOX STOP
57	908S0	Black selector 3 pulses position return to centre contacts 2NO	SHEET CONVEYOR STACKER 1° BOX FORWARD - BACKWARD
58	914S6	Black button met.	ENTRY STACKER FEEDING PINCH ROLL DOWN

Legend P03

Position	Short name	Description	Label
59	907S2	Black selector 3 pulses position return to centre contacts 2NO	ENTRY STACKER FEEDING PINCH ROLL + SHEET CONVEYOR FORWARD - BACKWARD
60	907S0	Black selector 3 pulses position return to centre contacts 2NO	PACKAGE FORMING ROLL 2° CHOICE STACKER IN - OUT
61	906S6	Black selector 3 pulses position return to centre contacts 2NO	PACKAGE FORMING ROLL 2° CHOICE STACKER UP - DOWN
63	906S1	Blue luminous button	2° CHOICE STACKER POSITIONING START
63	906S2	Red button met.	2° CHOICE STACKER POSITIONING STOP
64	906S0	Yellow button met.	CYCLE JOGGERS 2° CHOICE STACKER
65	906S5	Green luminous button	2° CHOICE STACKER READY
66	906S3	Green luminous button	2° CHOICE STACKER AUTOMATIC
67	906S4	Red button met.	2° CHOICE STACKER MANUAL
68	914S4	Black selector 3 pulses position return to centre contacts 2NO	3° CONVEYOR BELT FORWARD - BACKWARD
69	905S2	Green luminous button	CONVEYOR BELTS START
70	905S3	Red button met.	CONVEYOR BELTS STOP
71	905S6	Black selector 3 pulses position return to centre contacts 2NO	2° CONVEYOR BELT FORWARD - BACKWARD
72	905S0	Black selector 3 pulses position return to centre contacts 2NO	HEADING SHEETS SCRAPS CONVEYOR BELT UP - DOWN
73	905S4	Black selector 3 pulses position return to centre contacts 2NO	1° CONVEYOR BELT FORWARD - BACKWARD

74	900P1	Simatic touch multi panel MP 277 8"	OPERATOR PANEL

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Enclosure legend		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 97
Revision			Replacement of / Replaced by			Group:	Of 414



⇦97

101⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Supply circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	100
Revision		Replacement of	Replaced by			Group:	Of 414

100.9 / -R
100.9 / -S
100.9 / -T
3 ~ 400V 50Hz
-R / 102.0
-S / 102.0
-T / 102.0

-101F1
4Agl
1 3 5
2 4 6

-0X0 1
-0X0 2
-0X0 3
Q1

101-1
101-2
101-3

-101H2 Q1
-101H3 Q2
-101H4 Q3
-101H5 Q4
-101H6 Q5
-101H7 Q6
5 6 7
4 3

100.5 / 100-6
-0X1 1 Q11
-0X1 2 Q11 101-4
-0X1 3 Q11 101-5
-0X1 4 Q11 101-6
-0X1 5 Q11 101-7
-0X1 6 Q11 101-8
101-9
-0X1 7 Q11

-0X0 4
-0X0 5
-0X0 6
Q7

101-1
101-2
101-3

-101H10 Q9
-101H9 Q8
-101H8 Q7
5 6 7
4 3

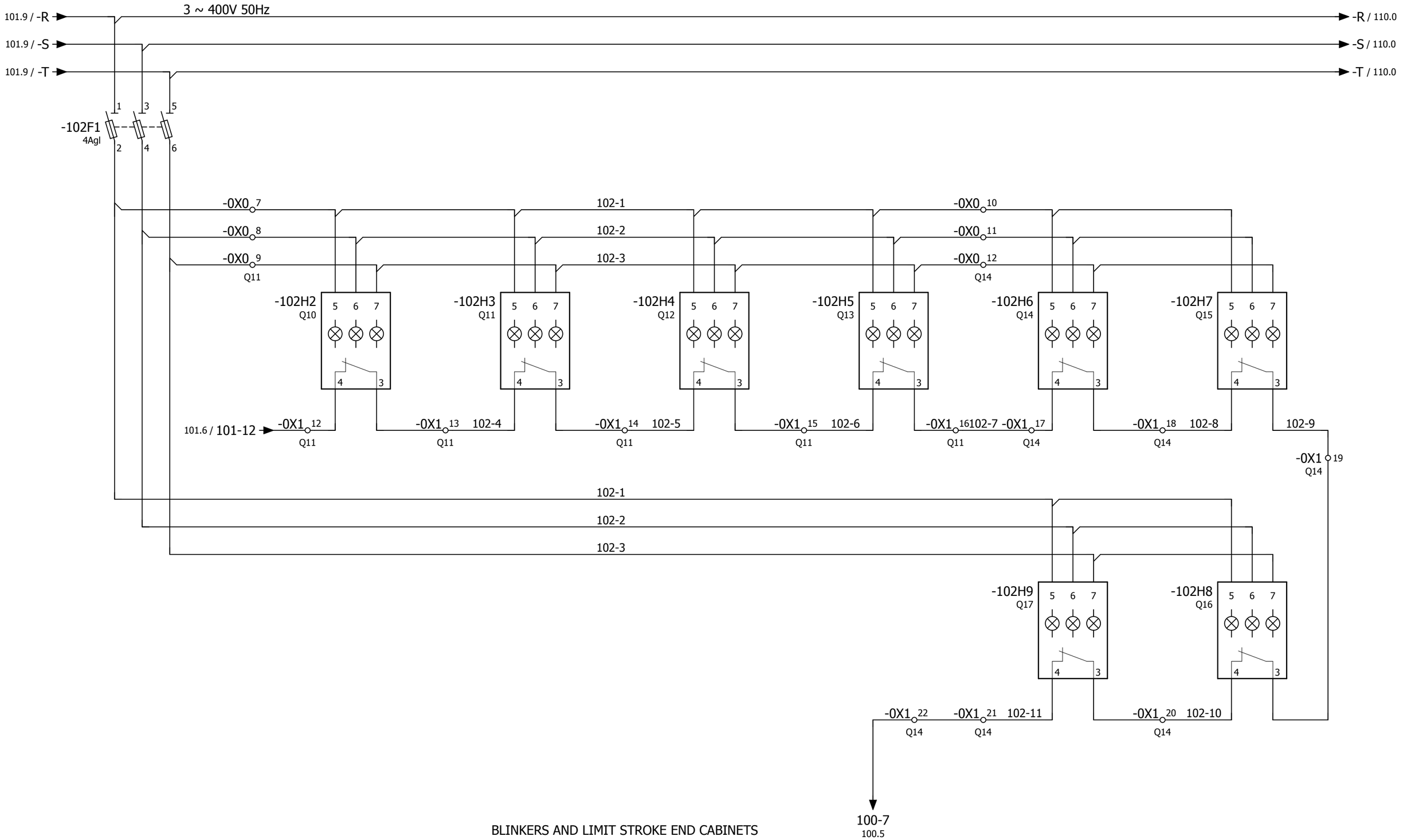
-0X1 10 Q11 101-11
-0X1 9 Q11 101-10
-0X1 8 Q11
-0X1 11 Q11

101-12
102.2

BLINKERS AND LIMIT STROKE END CABINETS

⇦100
102⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Supply circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	101
Revision			Replacement of / Replaced by			Group:	Of 414

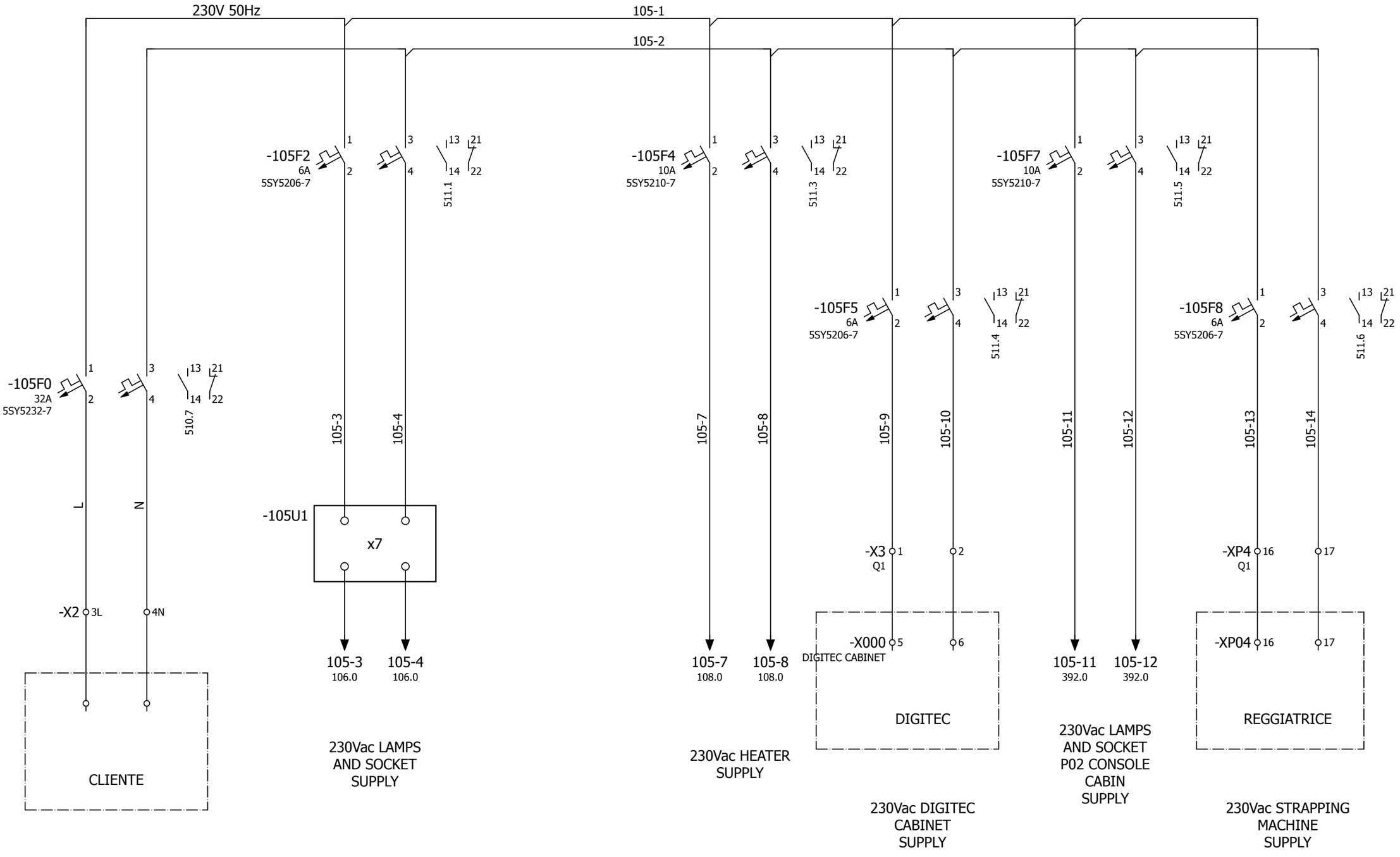


BLINKERS AND LIMIT STROKE END CABINETS

⇦101

105⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Supply circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 102
Revision			Replacement of / Replaced by			Group:	Of 414



102

106

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 230V from customer suplpy		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 105
Revision			Replacement of / Replaced by			Group:	Of 414

105.2 / 105-3 → 105-3 → 105-3 / 107.0

105.2 / 105-4 → 105-4 → 105-4 / 107.0

106K1
106.0
13 14 23 24

-0X2 1
-0X2 2
Q11

106-2 -0X2 3
106-3 -0X2 4
Q11

-106H2
11W
Q1
LAMPCP22

-106H3
11W
Q6
LAMPCP22

-106H4
11W
Q8
LAMPCP22

-106S1
BK
XB4-BG61
13
14

106-1

-106K1
A1
A2

-XQ25 11 Q1
-XQ28 11 Q1

-XQ25.2 5 Q25
-XQ28.2 5 Q28

PE 1 3 2 -106H12 Q25

PE 1 3 2 -106H11 Q28

-XQ25.2 6 Q25
-XQ28.2 6 Q28

-XQ25 12 Q1
-XQ28 12 Q1

3RH1140-1AP00
13 – 14 106.2
23 – 24 106.2
33 – 34 511.7
43 – 44

ENTRY BOX AND
STACKER BOX LAMPS

-0X3 1
-0X3 2
Q11

106-2
106-3

-0X3 3
-0X3 4
Q14

-106H7
11W
LAMPCP22

-106H8
11W
LAMPCP22

-106H9
11W
LAMPCP22

-106H10
11W
LAMPCP22

LAMPS INTERNAL CABINET

⇦105

107⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Internal cabinet illumination supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	106
Revision			Replacement of / Replaced by			Group: / Of	414

106.9 / 105-3

106.9 / 105-4

105-3

105-4

-107X1
Q??
09967

-107X2
Q??
09967

-XP1
Q1

-XP01
P01

-107X4
P01
09967

-XP2
Q1

-XP02
P02

105-3
849.0

105-4
849.0

-XP3
Q1

-XP03
P03

-107X6
P03
09967

INTERNAL CABINET SOCKET

INTERNAL CABINET SOCKET

SOCKET P01

P02 SOCKET

SOCKET P03

-X5
Q1

-X5.1
Q1

-107X8

-107X9

BALANCE
1 SOCKET

BALANCE
2 SOCKET

106

108

Date	13/05/2014
Drawing	13B01
Drawer	Tengattini Marco
Revision	

NOVASTILMEC S.p.A. Coil Processing Equipment

Comm: A97

Replacement of | Replaced by

elettromeccanica ERCA s.r.l.

Function: Socket supply

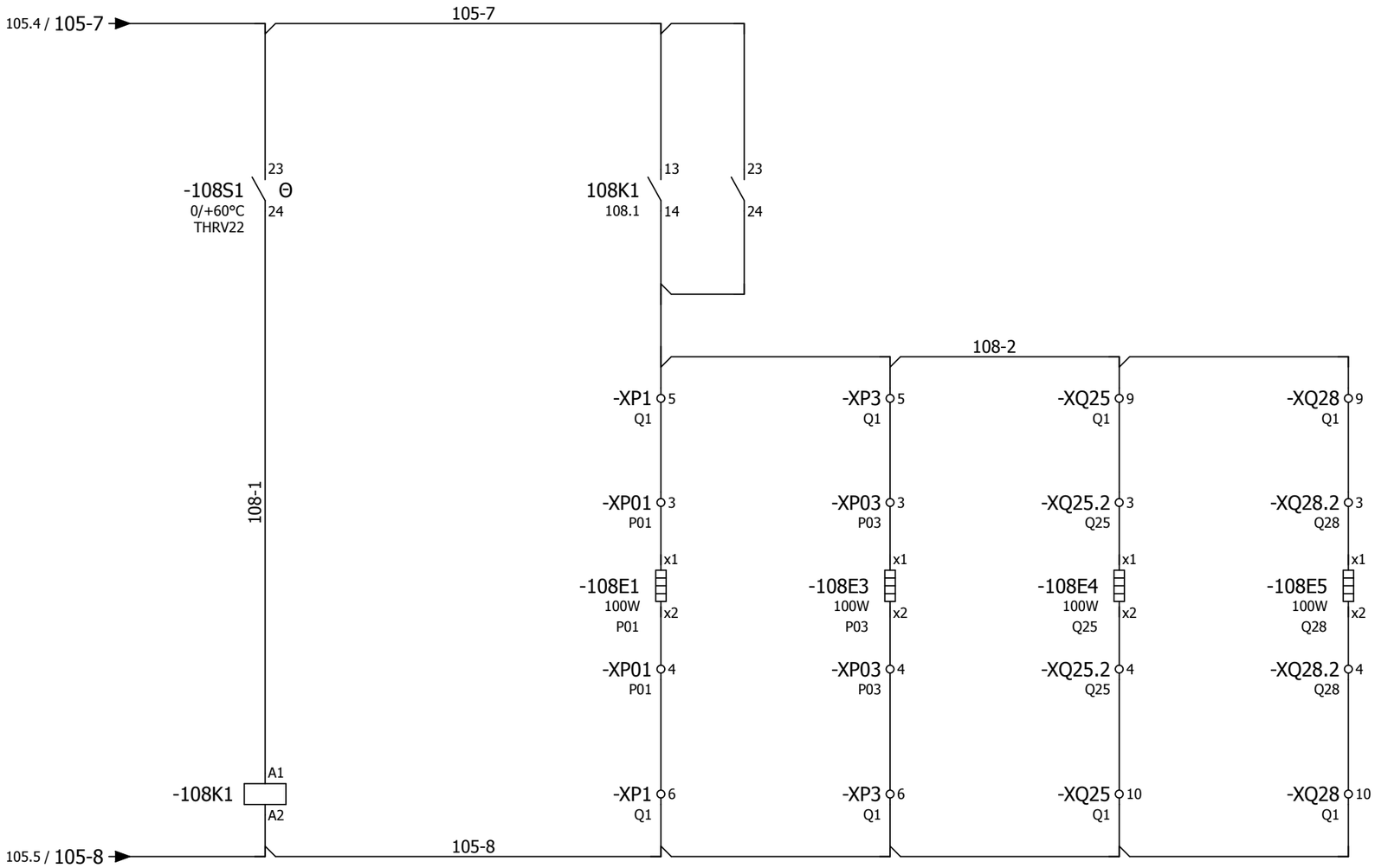
Installation: Linea taglio trasversale

=

+

Page 107

Group: Of 414



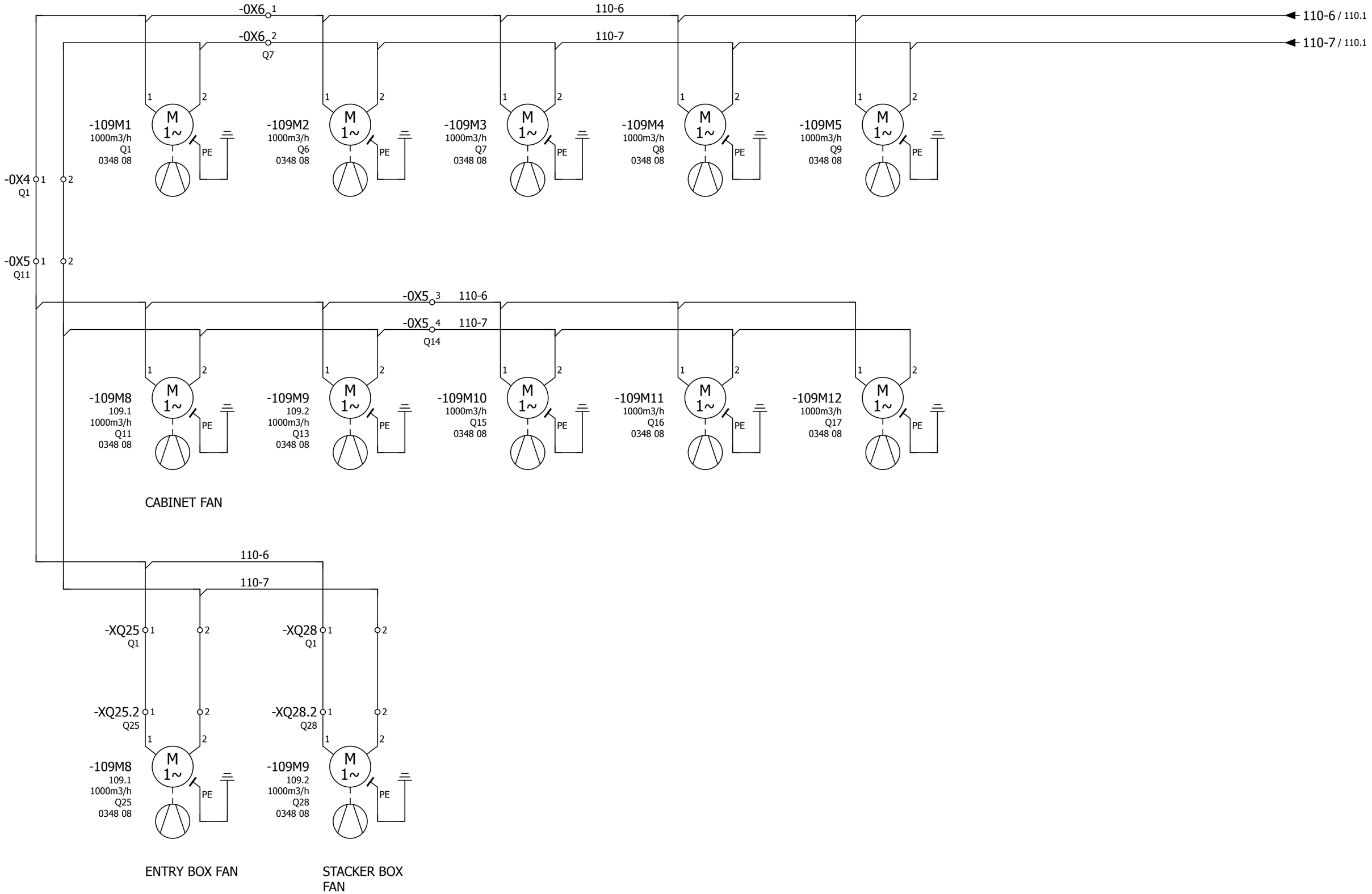
HEATER SUPPLY

3RH1140-1AP00
13 – 14 108.3
23 – 24 108.3
33 – 34
43 – 44

⇦107

109⇨

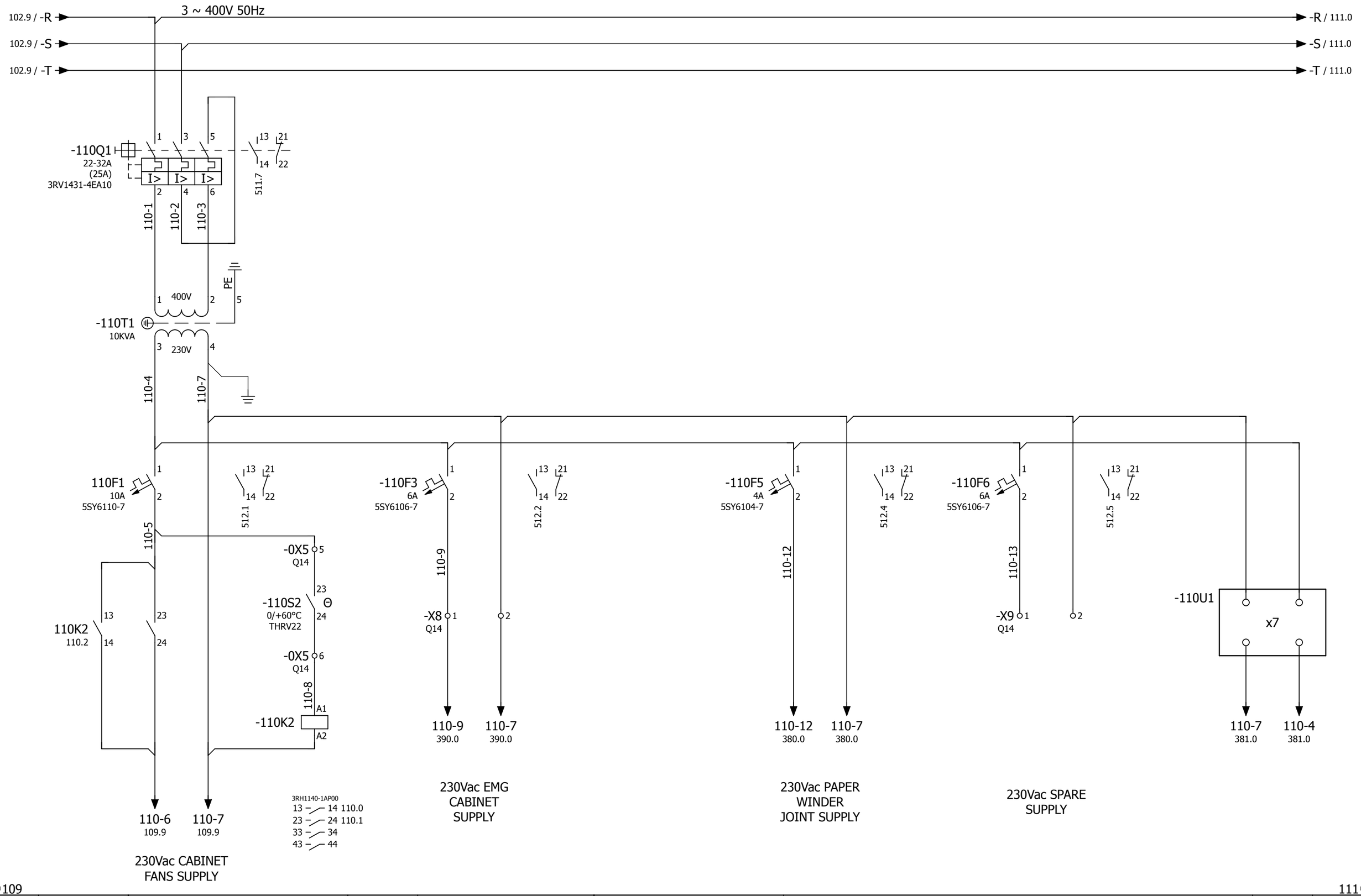
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Heater supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 108
Revision			Replacement of / Replaced by			Group:	Of 414



108

110

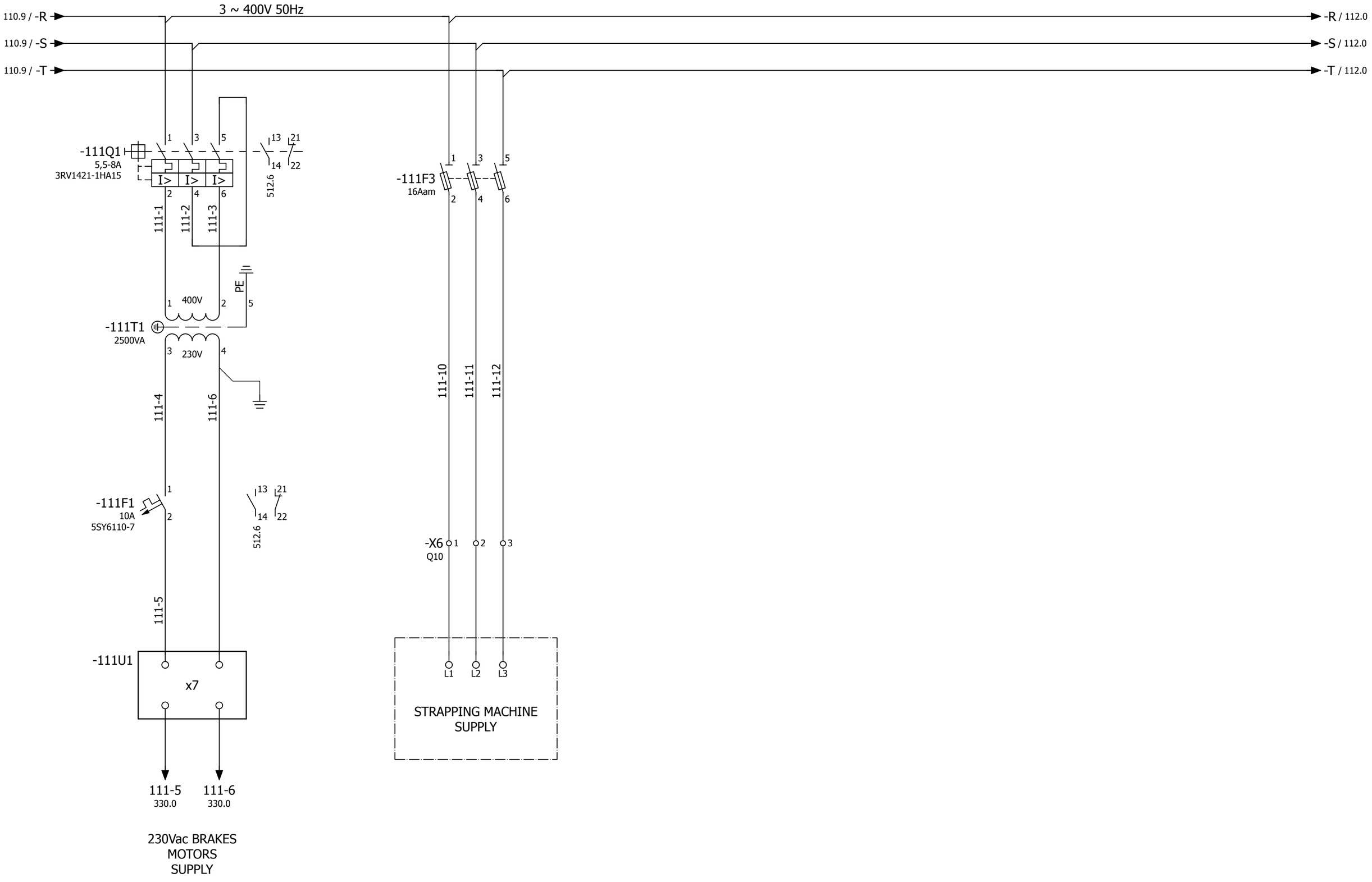
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinets fan supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 109
Revision			Replacement of / Replaced by			Group:	Of 414



⇦109

111⇨

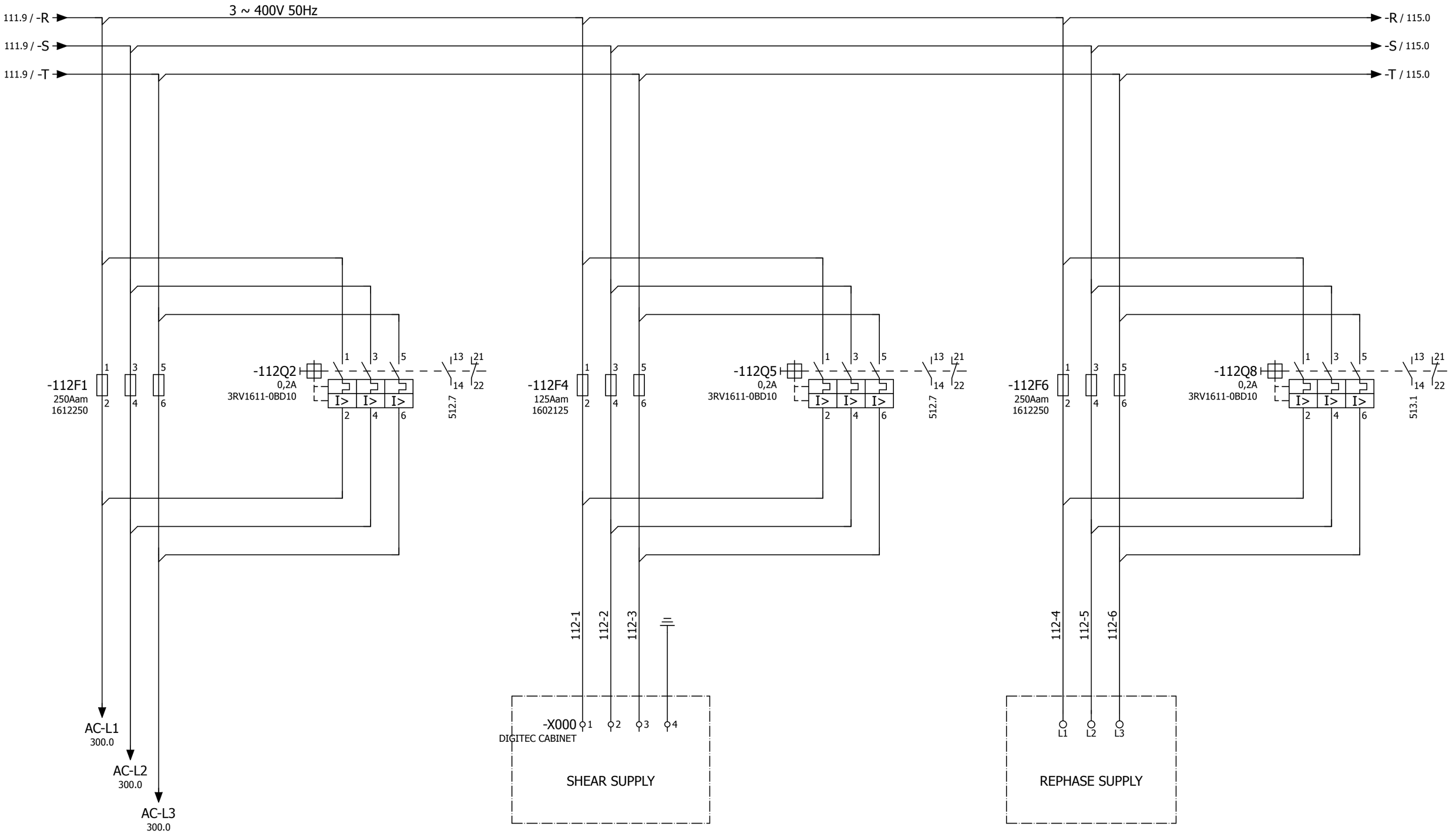
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 230V auxiliary circuits supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 110
Revision		Replacement of	Replaced by			Group:	Of 414



⇦110

112⇨

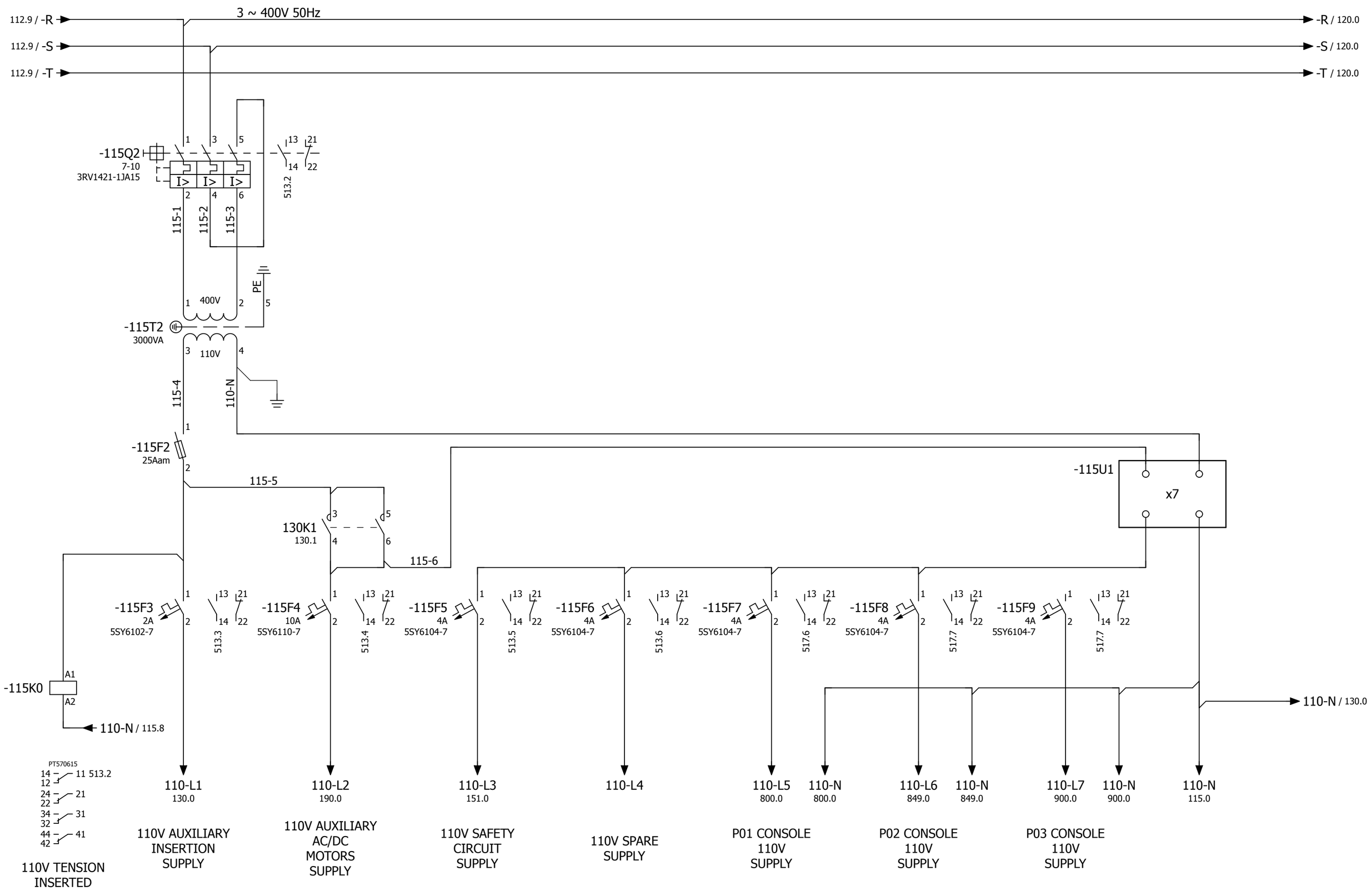
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 230V auxiliary circuits supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	111
Revision		Replacement of	Replaced by			Group:	Of 414



⇦111

115⇨

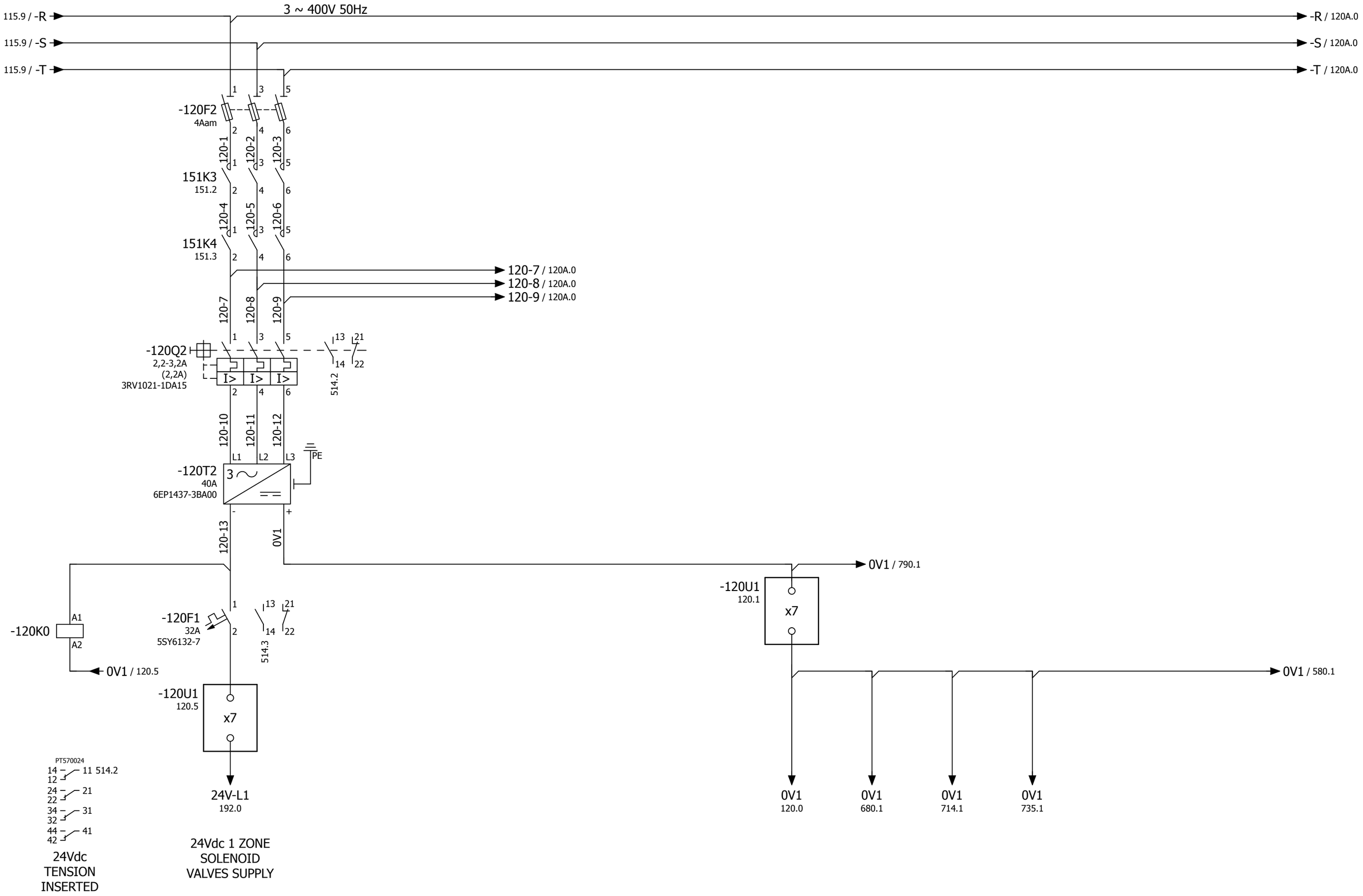
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 400V supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 112
Revision		Replacement of	Replaced by			Group:	Of 414



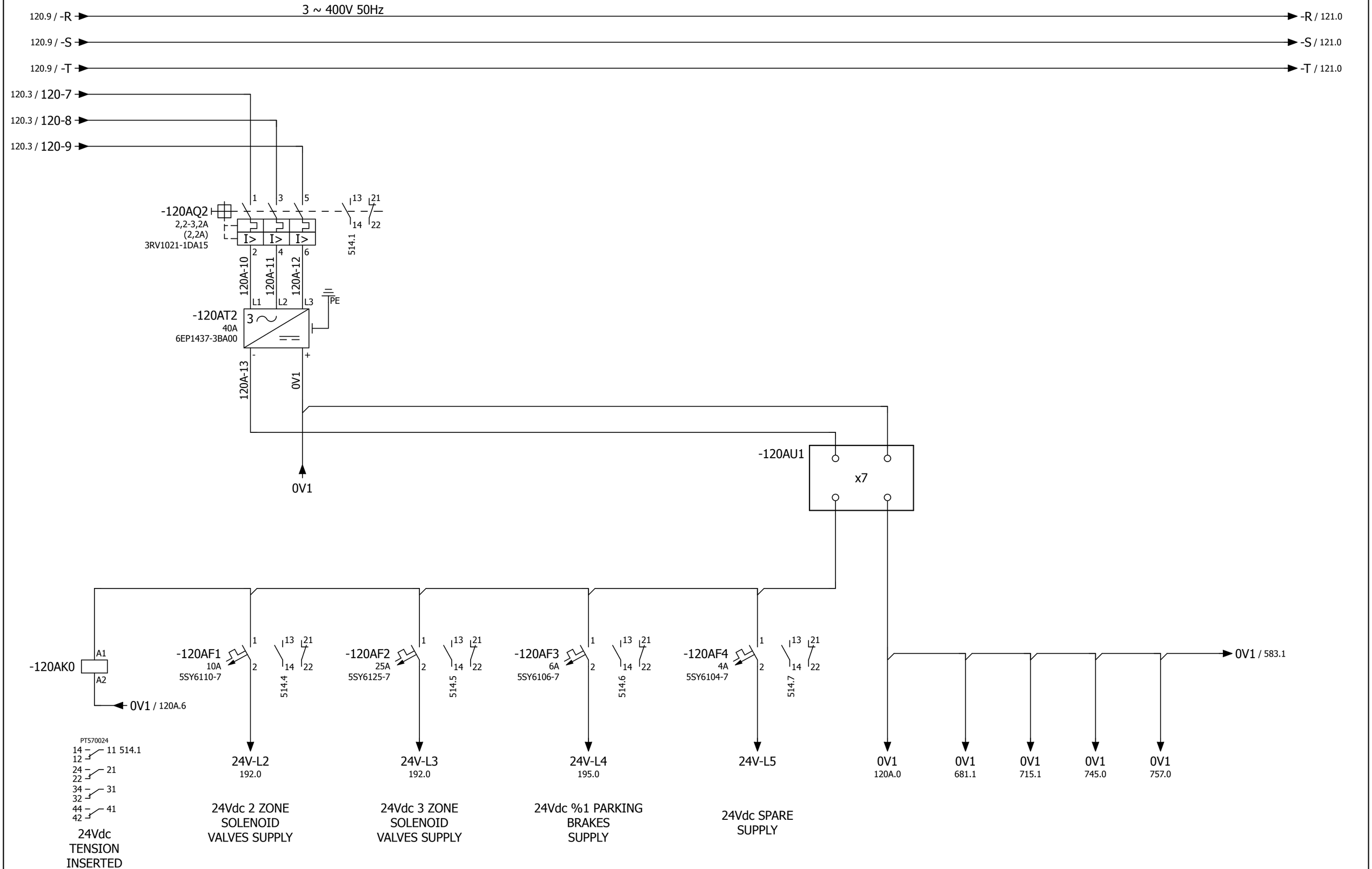
112

120

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 110V auxiliary circuits supply		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	115
Revision						Group:	Of 414



Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: 24Vdc auxiliary circuits supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	120
Revision		Replacement of	Replaced by			Of	414



⇦120

121⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 24Vdc auxiliary circuits supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 120A
Revision			Replacement of / Replaced by			Group:	Of 414

120A.9 / -R
120A.9 / -S
120A.9 / -T
3 ~ 400V 50Hz
-R / 125.0
-S / 125.0
-T / 125.0

-121Q2
2,2-3,2A
(2,2A)
3RV1021-1DA15
1 3 5 13 21
I> I> I>
2 4 6 14 22
514.7

121-1
121-2
121-3

-121T2
40A
6EP1437-3BA00
L1 L2 L3 PE
- +

121-4
0V2

-122U1
x7

0V2 / 122.0
121-4 / 122.0

-121K0
A1
A2
0V2 / 122.8

-121F1 6A 5SY6106-7 1 2
-121F2 6A 5SY6106-7 1 2 13 21 14 22 515.1
-121F3 6A 5SY6106-7 1 2 13 21 14 22 515.2
-121F4 6A 5SY6106-7 1 2
-121F5 6A 5SY6106-7 1 2 13 21 14 22 515.3
-121F6 6A 5SY6106-7 1 2 13 21 14 22 515.4
-121F7 6A 5SY6106-7 1 2 13 21 14 22 515.5
-121F8 6A 5SY6106-7 1 2 13 21 14 22 515.6

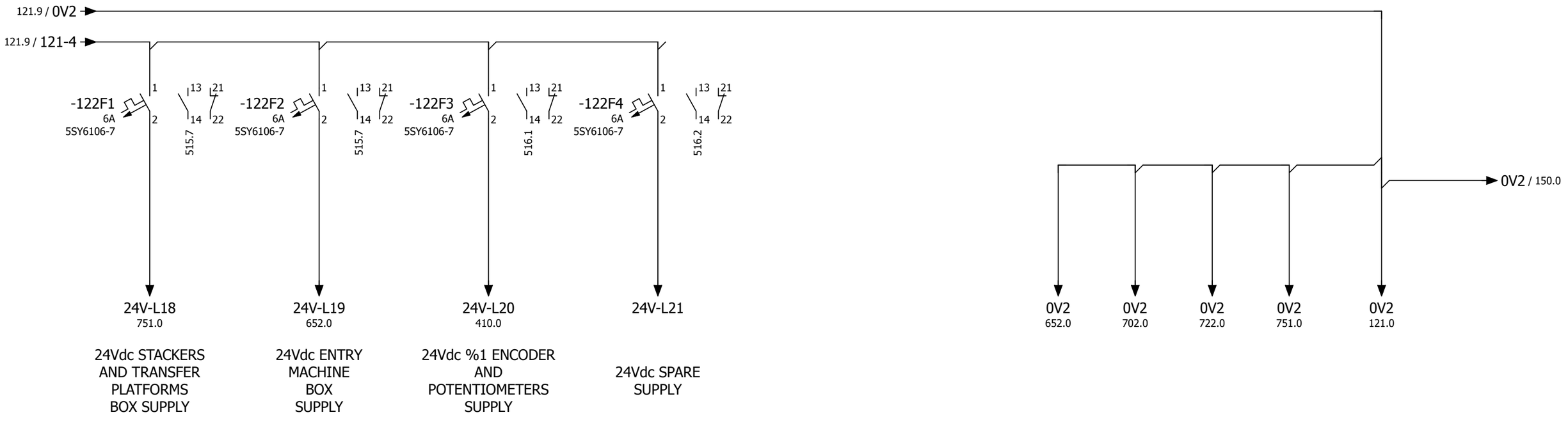
PT570024
14 12 11 514.7
24 22 21
34 32 31
44 42 41

24Vdc TENSION INSERTED

24V-L10 500.0 — 24Vdc CABINET INPUT SUPPLY
24V-L11 550.0 — 24Vdc MACHINE EDGE INPUT SUPPLY
24V-L12 430.0 — 24Vdc CABINET OUTPUT SUPPLY
24V-L13 409.0 — 24Vdc PLC SUPPLY
24V-L14 150.0 — 24Vdc EMERGENCY RELAYS SUPPLY
24V-L15 157.0 — 24Vdc SAFETY OPERATOR SUPPLY
24V-L16 702.0 — 24Vdc 1 LEVELLER BOX SUPPLY
24V-L17 722.0 — 24Vdc 2 LEVELLER BOX SUPPLY

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: 24Vdc auxiliary circuits supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	121
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



⇦121

125⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 24Vdc auxiliary circuits supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	122
Revision			Replacement of / Replaced by			Group: / Of	414

121.9 / -R
121.9 / -S
121.9 / -T
3 ~ 400V 50Hz

-R / 200.0
-S / 200.0
-T / 200.0

125-6

156K5
156.4
DELAY ZONE
1 SAFETY
125-9
156K6
156.5
125-12
-0X10
Q14
-1X10
Q7
-125F1
6AgI
24V-DZ0
207.3
209.4
210.3
220.3
221.3
249.3
249.6
251.5

161K5
161.4
DELAY ZONE
2 SAFETY
125-8
161K6
161.5
125-11
-0X10
Q14
-1X10
Q7
-125F2
6AgI
24V-DZ1
205.3
206.3
207.3
208.3
209.3
210.3
211.3
212.3
222.5
225.5
230.6
235.6
237.6

166K5
166.4
DELAY ZONE
3 SAFETY
125-7
166K6
166.5
125-10
-0X10
Q14
-1X10
Q7
-125F3
6AgI
24V-DZ2
205.3
206.3
207.3
208.3
209.3
210.3
211.3
212.3
220.6
221.6
241.5
245.3
247.5

151K7
151.3
125-5
151K8
151.4
-0X10
Q14
-1X10
Q7
-125F4
6AgI
24V-DZ3
205.3
206.3
207.3
208.3
209.3
210.3
211.3
212.3
245.6
253.5
255.3
255.6
259.3
259.6
263.3
263.6
265.5
267.3
267.6
271.3
271.6
273.3
273.6
275.3
275.6
277.3
277.6

-125Q6
2,2-3,2A
(2,2A)
3RV1021-1DA15
I>
516.3

125-1
125-2
125-3

-125T2
40A
6EP1437-3BA00
L1 L2 L3 PE
-
+

125-4
0V3

125F6
40A
5SY6140-7
516.3

-125U1
x7

24V-L30
100.7
24V-L30
220.2
24V-L30
586.0
0V3
100.7
0V3
220.2
0V3
201.4

DRIVERS NOT AREA SAFETY
DRIVERS AREA 1 SAFETY
DRIVERS AREA 2 SAFETY
DRIVERS AREA 3 SAFETY
24Vdc DRIVERS SUPPLY
24Vdc DC-LINK AND CU320 SUPPLY
24Vdc DRIVERS SUPPLY
24Vdc DC-LINK AND CU320 SUPPLY

122
130

Date	13/05/2014
Drawing	13B01
Drawer	Tengattini Marco
Revision	

NOVASTILMEC S.p.A. Coil Processing Equipment

Comm: A97
Replacement of | Replaced by

elettromeccanica ERCA s.r.l.

Function: 24V drivers suplpy
Installation: Linea taglio trasversale

=
+
Page 125
Group: Of 414

115.1 / 110-L1 → 110V 50Hz

110-L1 / 446.1 →

-XP2 13
Q14

-XP02 13
P02

13
-130S1
BK
A97.P02.165
P02
14

-XP02 14
P02

-XP2 14
Q14

130-1

A1
-130K1
A2

115.9 / 110-N →

110-N / 151.0 →

DIGITEC

-XEME 40
Q15
-X002 19
DIGITEC CABINET

130-2

23
130K1
130.1
24

130-3

-XEME 41
Q15
-X002 20
DIGITEC CABINET

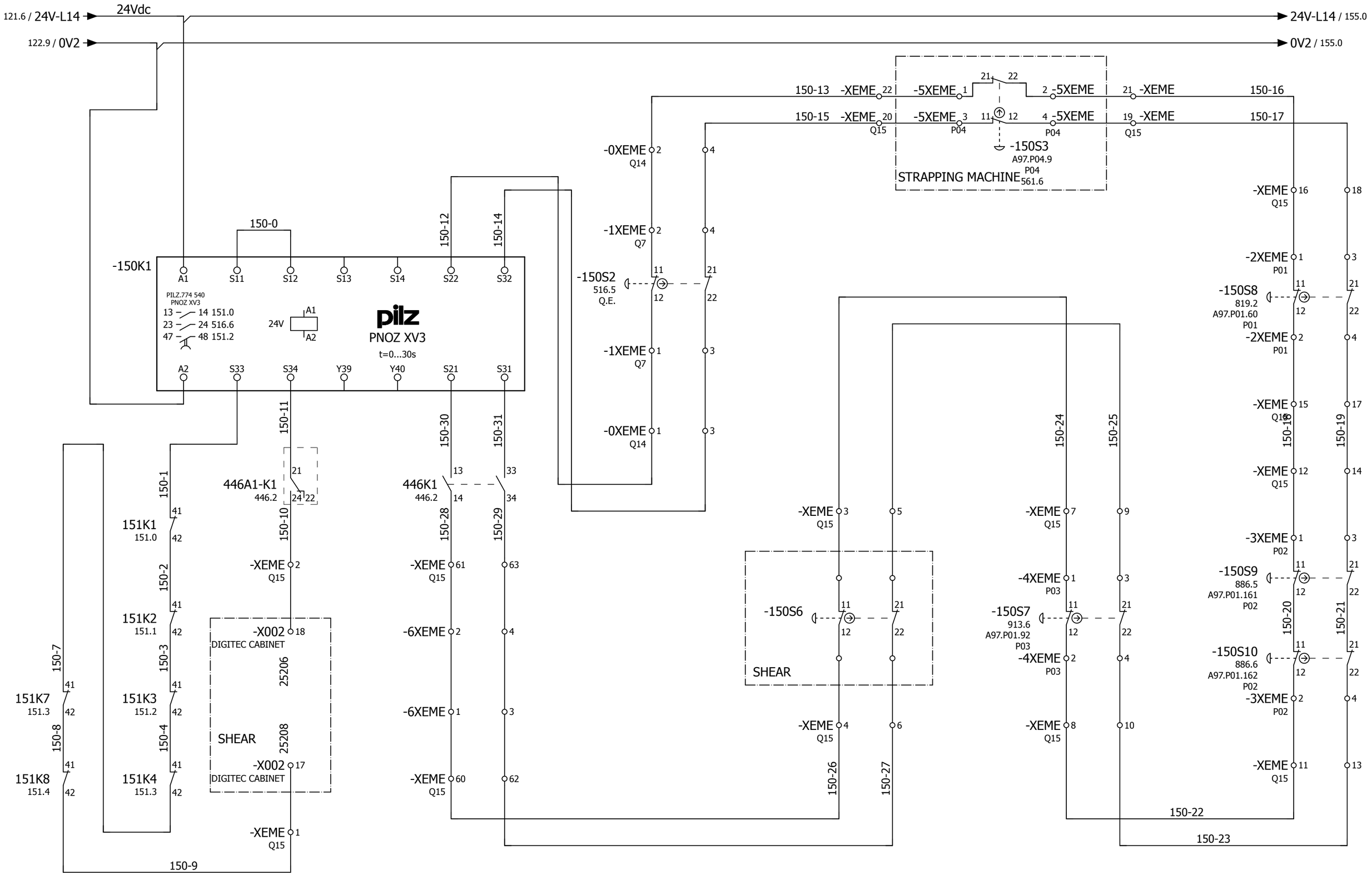
AUXILIARY
INSERTION

3RT1026-1AG20
1 — 2
3 — 4 115.2
5 — 6 115.2
23 — 24 130.4
33 — 34 516.4

⇦125

150⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Auxiliary insertion		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale		Page 130
Revision			Replacement of / Replaced by			Group:	Of 414



130

151

Date	13/05/2014
Drawing	13B01
Drawer	Tengattini Marco
Revision	

NOVASTILMEC S.p.A. Coil Processing Equipment

Comm: A97

Replacement of | Replaced by

elettromeccanica ERCA s.r.l.

Function: Emergency circuit

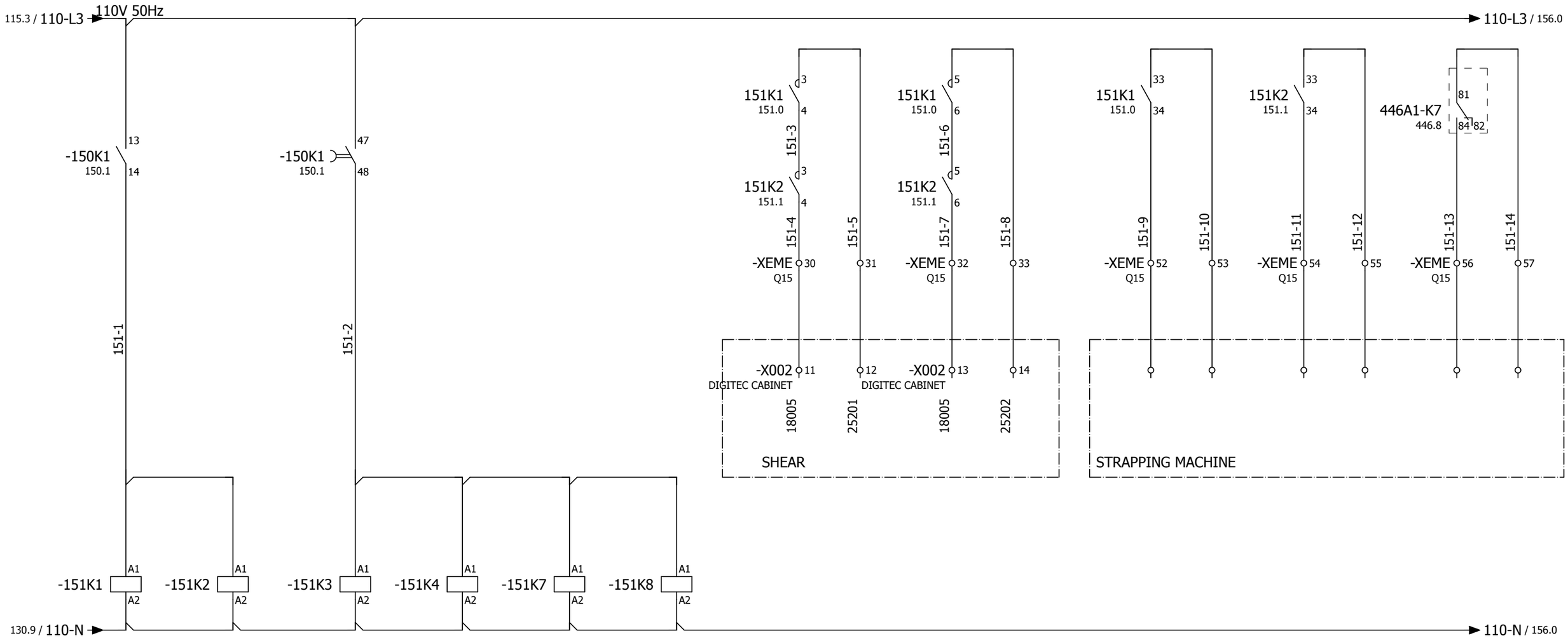
Installation: Linea taglio trasversale

=

+

Page 150

Group: Of 414



ISTANTANEOUS EMERGENCY

EMERGENCY DELAYED

3RT1024-1AG20

1	2	190.1	
3	4	151.5	
5	6	151.6	
33	34	151.7	
41	42	150.1	

3RT1024-1AG20

1	2	190.1	
3	4	151.5	
5	6	151.6	
33	34	151.8	
41	42	150.1	

3RT1024-1AG20

1	2	120.1	
3	4	120.2	
5	6	120.2	
41	42	150.1	

3RT1024-1AG20

1	2	120.1	
3	4	120.2	
5	6	120.2	
41	42	150.1	

3RT1024-1AG20

1	2		
3	4	125.4	
5	6	190.5	
41	42	150.0	

3RT1024-1AG20

1	2		
3	4	125.4	
5	6	190.5	
41	42	150.0	

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Emergency auxiliary circuit		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	151
Revision			Replacement of / Replaced by			Group: / Of	414

150.9 / 24V-L14 → 24Vdc

150.9 / 0V2 →

→ 24V-L14 / 160.0

→ 0V2 / 157.0

155-0

155-7

155-8

-155K1

A1 S11 S12 S13 S14 S22 S32

PILZ.774 540
PNOZ XV3

13 – 14 156.1
23 – 24 516.7
47 – 48 156.3

24V A1 A2

pilz
PNOZ XV3
t=0...30s

A2 S33 S34 Y39 Y40 S21 S31

155-6

155-13

155-14

155-1

446A1-K2
446.3
31 34 32

155-5

156K1
156.1
21 22

155-2

156K2
156.2
21 22

155-3

156K3
156.3
21 22

155-4

156K4
156.3
21 22

156K6
156.5
21 22

155-50

156K5
156.4
21 22

155-40

157K1
157.1
13 14 33 34

GATE
A97.200.1

155-9

155-10

157K2
157.2
13 14 33 34

GATE
A97.200.2

155-11

155-12

157K3
157.3
13 14 33 34

GATE
A97.200.3

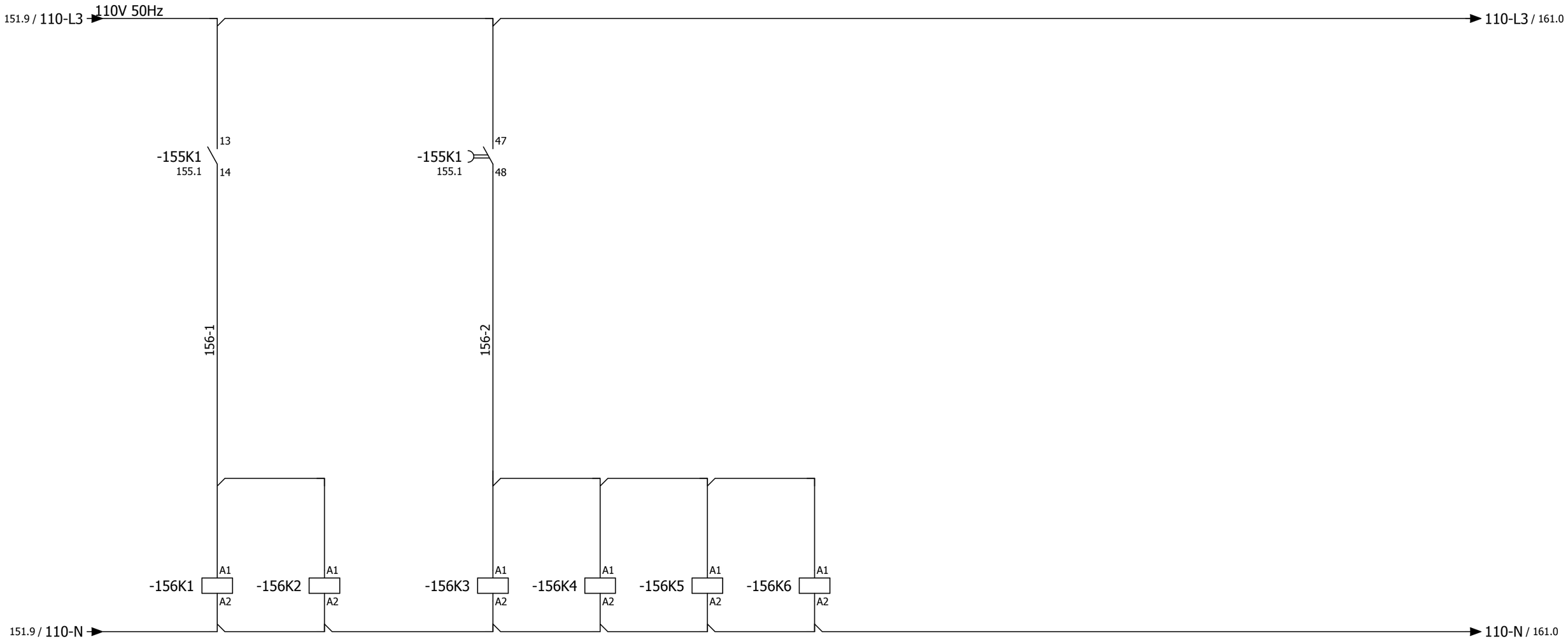
155-13

155-14

⇦151

156⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 1 safety		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 155
Revision			Replacement of / Replaced by			Group:	Of 414



ISTANTANEOUS EMERGENCY

EMERGENCY DELAYED

3RT1024-1AG20
1 2 190.1
3 4
5 6
21 22 155.1

3RT1024-1AG20
1 2 190.1
3 4
5 6
21 22 155.1

3RT1026-1AG20
1 2 192.1
3 4 192.1
5 6 195.1
21 22 155.1

3RT1026-1AG20
1 2 192.1
3 4 192.1
5 6 195.1
21 22 155.1

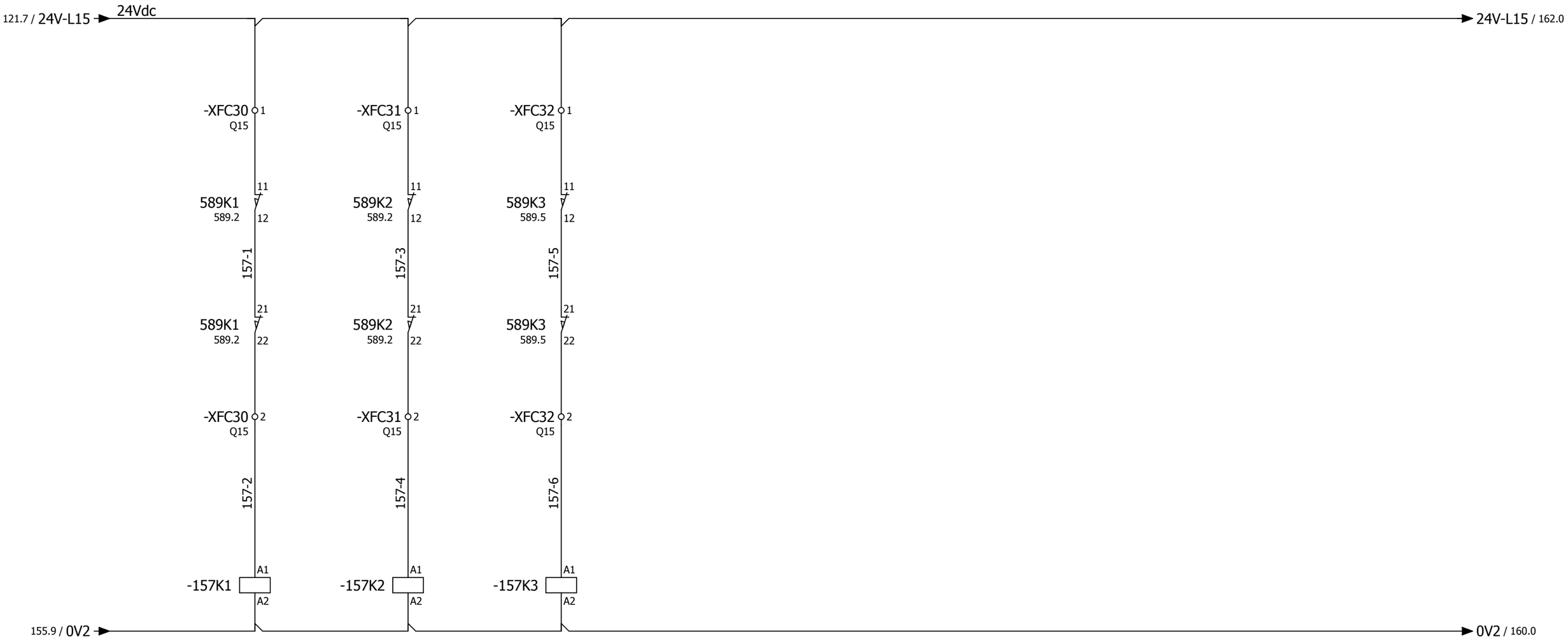
3RT1024-1AG20
1 2 125.2
3 4 190.5
5 6
21 22 155.2

3RT1024-1AG20
1 2 125.2
3 4 190.5
5 6
21 22 155.2

⇦155

157⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 1 safety		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	156
Revision		Replacement of	Replaced by			Group:	Of 414



GATE 1 ENTRY ZONE
A97.200.1

GATE 2 ENTRY ZONE
A97.200.2

GATE 3 ENTRY ZONE
A97.200.3

3RH1131-1BB40
21 22
13 14 155.8
33 34 155.9
43 44 517.2

3RH1131-1BB40
21 22
13 14 155.8
33 34 155.9
43 44 517.3

3RH1131-1BB40
21 22
13 14 155.8
33 34 155.9
43 44 517.4

⇦156
160⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 1 safety		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale		Page 157
Revision			Replacement of / Replaced by			Group:	Of 414

155.9 / 24V-L14 → 24Vdc

157.9 / 0V2 →

24V-L14 / 165.0

0V2 / 162.0

160-0

160-7

160-8

-160K1

A1 S11 S12 S13 S14 S22 S32

PILZ.774 540
PNOZ XV3

13 — 14 161.1
23 — 24 516.7
47 — 48 161.3

24V A1 A2

pilz
PNOZ XV3
t=0...30s

A2 S33 S34 Y39 Y40 S21 S31

160-6 160-5 160-9 160-10

160-1

446A1-K3
446.4
41 44 42

160-5

161K1
161.1
31 32

160-2

161K2
161.2
31 32

160-3

161K3
161.3
21 22

161K6
161.5
21 22

160-4 160-50

161K4
161.3
21 22

161K5
161.4
21 22

160-40

162K1
162.1
13 14 33 34

GATE
A97.201.1

160-9 160-10

157

161

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 2 safety		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	160
Revision						Group:	Of 414

156.9 / 110-L3 → 110V 50Hz

110-L3 / 166.0 →

-160K1 13 14 — 160.1

-160K1 47 48 — 160.1

161-1

161-2

CESOIA

-XEME 43 → -X055 1

-XEME 45 → -X055 3

Q15 — DIGITEC CABINET

161-3

161-6

161K1 13 14 — 161.1

887S7 23 24

161-4

161-7

887S7 33 34

161K2 13 14 — 161.2

161-8

161-5

-XEME 46 → -X055 4

-XEME 44 → -X055 2

Q15 — DIGITEC CABINET

-161K1 A1 A2

-161K2 A1 A2

-161K3 A1 A2

-161K4 A1 A2

-161K5 A1 A2

-161K6 A1 A2

156.9 / 110-N →

110-N / 166.0 →

ISTANTANEOUS EMERGENCY

EMERGENCY DELAYED

3RT1024-1AG20

1	2	190.2
3	4	
5	6	
13	14	161.5
23	24	161.5
31	32	160.1

3RT1024-1AG20

1	2	190.2
3	4	
5	6	
13	14	161.5
23	24	161.5
31	32	160.1

3RT1024-1AG20

1	2	192.6
3	4	195.3
5	6	190.6
21	22	160.1

3RT1024-1AG20

1	2	192.6
3	4	195.3
5	6	190.6
21	22	160.1

3RT1024-1AG20

1	2	125.3
3	4	
5	6	
21	22	160.2

3RT1024-1AG20

1	2	125.3
3	4	
5	6	
21	22	160.2

⇦160

162⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 2 safety		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	161
Revision			Replacement of / Replaced by			Group: / Of	414

157.9 / 24V-L15 → 24Vdc

24V-L15 / 167.0 →

-XFC40 Q15 — 1

590K1 590.2 — 11 / 12

162-1

590K1 590.2 — 21 / 22

-XFC40 Q15 — 2

162-2

-162K1 — A1 / A2

160.9 / 0V2 →

0V2 / 165.0 →

GATE 1 CENTRAL
ZONE
A97.201.1

3RH1131-1BB40
21 — 22
13 — 14 160.8
33 — 34 160.9
43 — 44 518.2

⇦161

165⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 2 safety		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 162
Revision			Replacement of / Replaced by			Group:	Of 414

160.9 / 24V-L14 → 24Vdc

162.9 / 0V2 →

→ 24V-L14 / 167.0

→ 0V2 / 167.0

-165K1

PILZ.774 540
PNOZ XV3

A1 S11 S12 S13 S14 S22 S32

13 — 14 166.1
23 — 24 517.1
47 — 48 166.3

24V A1 A2

pilz
PNOZ XV3
t=0...30s

A2 S33 S34 Y39 Y40 S21 S31

165-0 165-7 165-8 165-6 165-13 165-14

165-1 165-2 165-3 165-4 165-40 165-5 165-50

446A1-K4
446.5
51 54 52

166K1 166.1 — 21 22
166K2 166.2 — 21 22
166K3 166.3 — 21 22
166K4 166.3 — 21 22
166K5 166.4 — 21 22
166K6 166.5 — 21 22

167K1 167.1 — 13 14 33 34
GATE A97.202.1

167K2 167.2 — 13 14 33 34
GATE A97.202.2

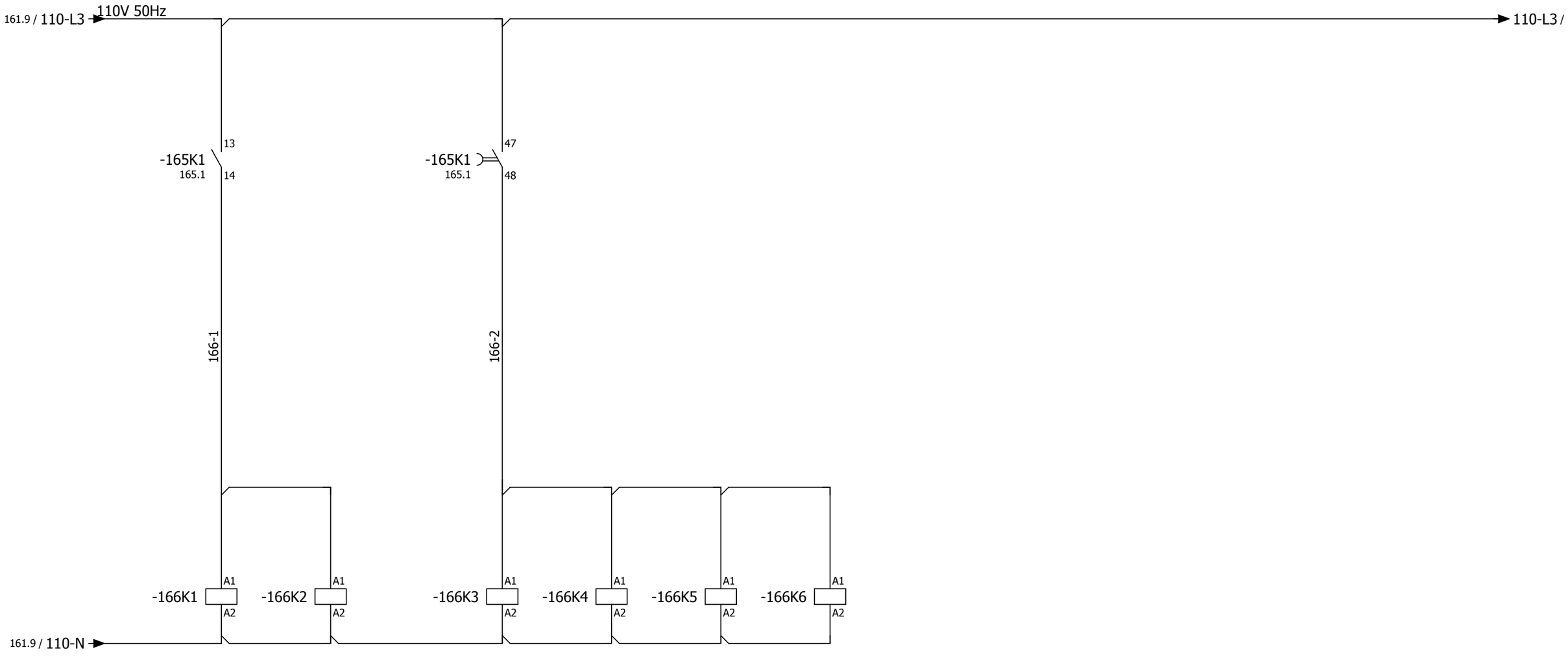
167K3 167.3 — 13 14 33 34
GATE A97.202.3

165-9 165-10 165-11 165-12 165-13 165-14

⇦162

166⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 3 safety		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 165
Revision			Replacement of / Replaced by			Group:	Of 414



ISTANTANEOUS EMERGENCY

EMERGENCY DELAYED

3RT1024-1AG20
1 2 190.3
3 4
5 6
21 22 165.1

3RT1024-1AG20
1 2 190.3
3 4
5 6
21 22 165.1

3RT1026-1AG20
1 2 192.8
3 4 192.8
5 6 195.4
21 22 165.1

3RT1026-1AG20
1 2 192.8
3 4 192.8
5 6 195.4
21 22 165.1

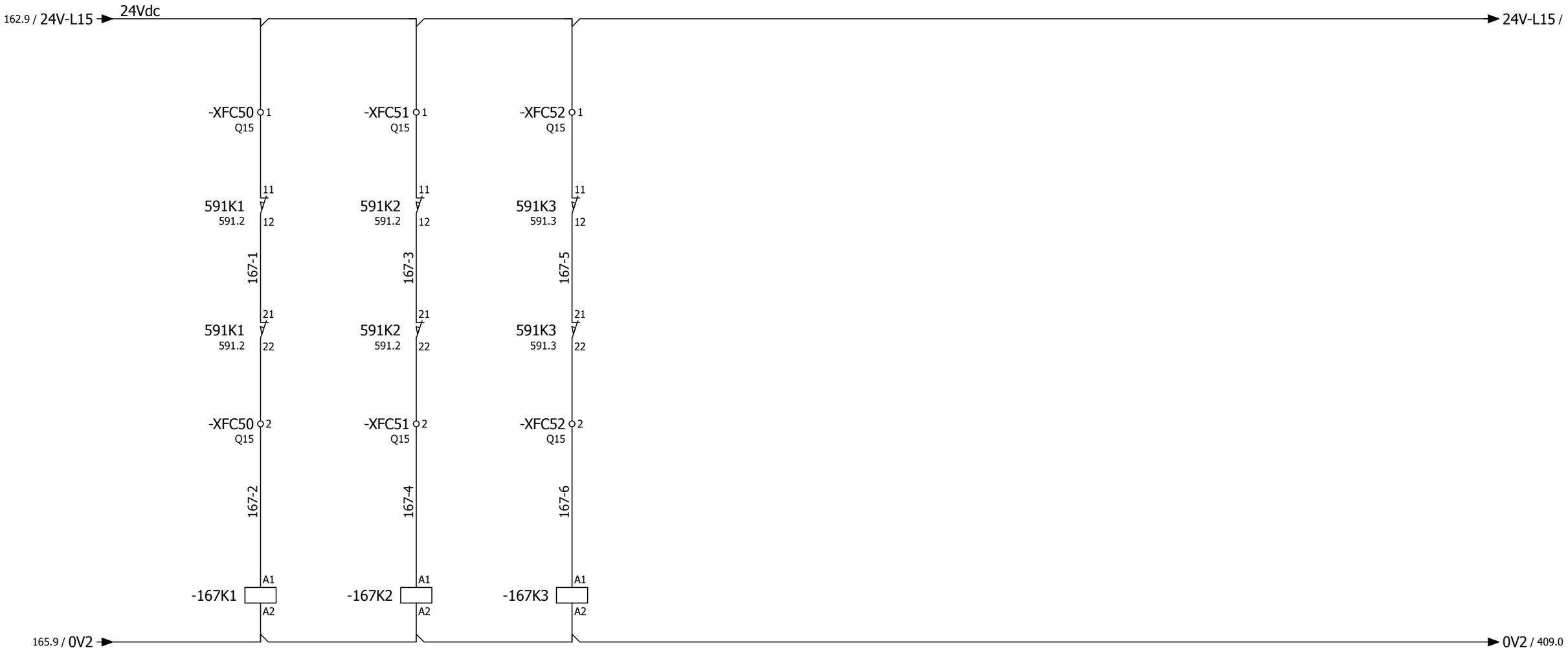
3RT1024-1AG20
1 2 125.4
3 4 190.8
5 6
21 22 165.2

3RT1024-1AG20
1 2 125.4
3 4 190.8
5 6
21 22 165.2

165

167

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 3 safety		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	166
Revision		Replacement of	Replaced by			Group:	Of 414



GATE 1 EXIT ZONE
A97.202.1

GATE 2 EXIT ZONE
A97.202.2

GATE 3 EXIT ZONE
A97.202.3

3RH1131-1BB40
21 22
13 14 165.8
33 34 165.9
43 44 519.2

3RH1131-1BB40
21 22
13 14 165.8
33 34 165.9
43 44 519.3

3RH1131-1BB40
21 22
13 14 165.8
33 34 165.9
43 44 519.4

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Area 3 safety		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	167
Revision			Replacement of / Replaced by			Group: / Of	414

115.2 / 110-L2 — 110V 50Hz

110-L2 / 202.0

151K1 — 151.0 — ISTANTANEOUS EMERGENCY — 190-1

151K2 — 151.1 — ISTANTANEOUS EMERGENCY

151K7 — 151.3 — EMERGENCY DELAYED — 190-5

151K8 — 151.4 — EMERGENCY DELAYED

110-Z10

156K1 — 156.1 — ISTANTANEOUS AREA 1 SAFETY — 190-2 — 156K2 — 156.2 — 110-Z1 — 430.1 — AC MOTORS AREA 1 SAFETY

161K1 — 161.1 — ISTANTANEOUS AREA 2 SAFETY — 190-2 — 161K2 — 161.2 — 110-Z2 — 440.1 — AC MOTORS AREA 2 SAFETY

166K1 — 166.1 — ISTANTANEOUS AREA 3 SAFETY — 190-2 — 166K2 — 166.2 — 110-Z3 — 441.1 — AC MOTORS AREA 3 SAFETY

110-Z0 — 430.1 — AC MOTORS SAFETY NOT AREA

156K5 — 156.4 — DELAY AREA 1 SAFETY — 190-6 — 156K6 — 156.5 — 110-Z11 — 360.0 — BRAKES AREA 1 SAFETY

161K3 — 161.3 — DELAY AREA 2 SAFETY — 190-7 — 161K4 — 161.3 — 110-Z12 — 364.0 — BRAKES AREA 2 SAFETY

166K5 — 166.4 — DELAY AREA 3 SAFETY — 190-8 — 166K6 — 166.5 — 110-Z13 — 367.0 — BRAKES AREA 3 SAFETY

167

192

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors circuit supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	190
Revision		Replacement of	Replaced by			Group:	Of 414

120.1 / 24V-L1 → 24Vdc

120A.1 / 24V-L2 →

120A.3 / 24V-L3 →

156K3
156.3
DELAY AREA 1 SAFETY
192-3
156K4
156.3

-192F1

192-2

161K3
161.3
DELAY AREA 2 SAFETY
192-6
161K4
161.3

166K3
166.3
DELAY AREA 3 SAFETY
192-9
166K4
166.3

24V-Z1 580.1 | 24V-Z1 680.1 | 24V-Z1 714.1 | 24V-Z1 734.1

SOLENOID VALVES
AREA 1 SAFETY

192-2 580.1 | 192-2 680.1 | 192-2 718.0 | 192-2 745.0 | 192-2 780.1

SOLENOID VALVES
SAFETY NOT
AREA

24V-Z2 583.1

SOLENOID VALVES
AREA 2 SAFETY

24V-Z3 795.0 | 24V-Z3 758.0

SOLENOID VALVES
AREA 3 SAFETY

⇦190

195⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Solenoid valves supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 192
Revision		Replacement of	Replaced by			Group:	Of 414

120A.4 / 24V-L4 → 24Vdc

156K3
156.3
5
6
195-3
DELAY AREA 1 SAFETY

161K3
161.3
3
4
195-4
DELAY AREA 2 SAFETY

166K3
166.3
5
6
195-5
DELAY AREA 3 SAFETY

156K4
156.3
5
6

161K4
161.3
3
4

166K4
166.3
5
6

24V-Z11
681.1

24V-Z11
715.1

24V-Z11
736.1

24V-Z12

24V-Z13
781.1

PARKING BRAKES
AREA 1 SAFETY

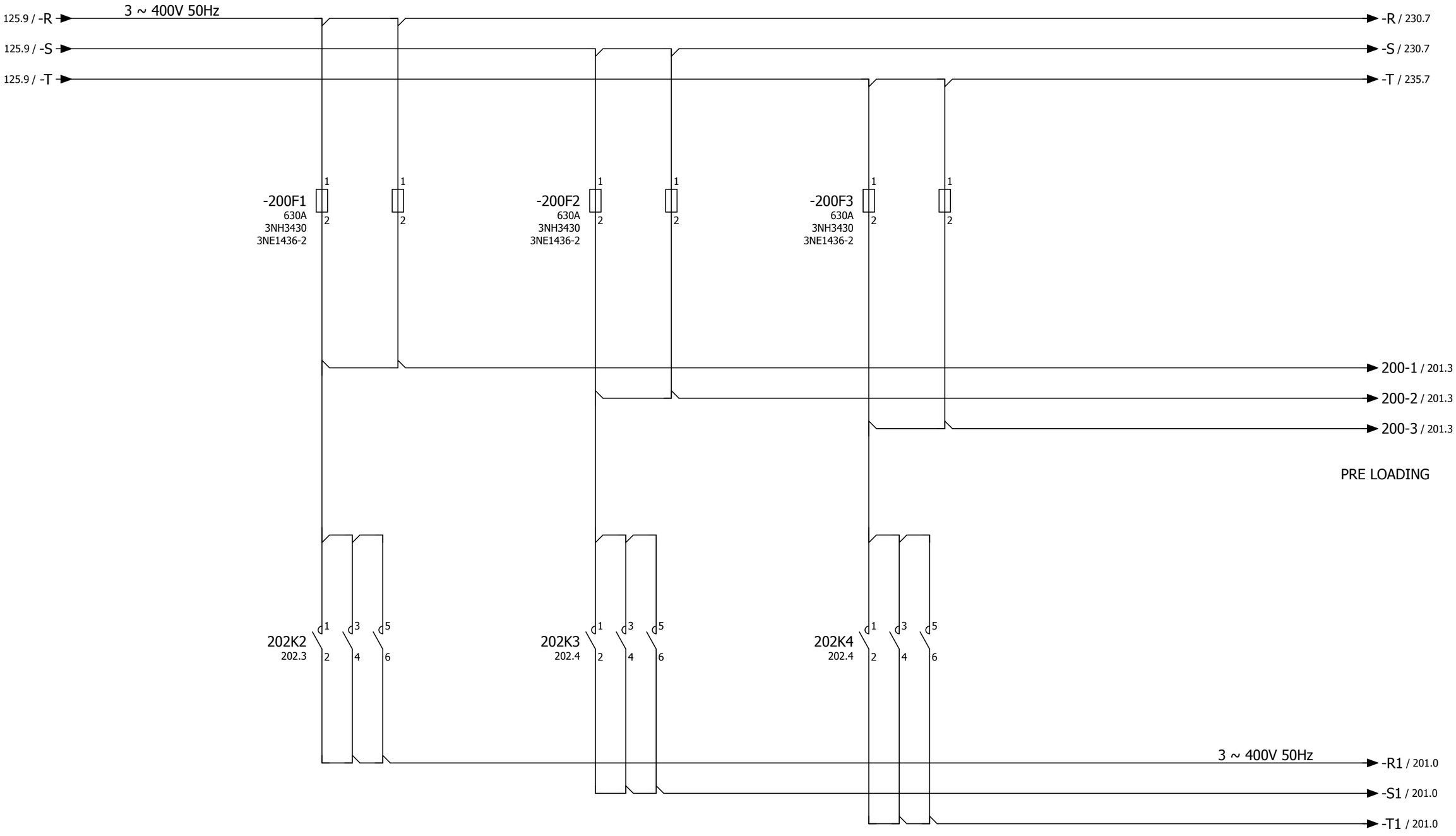
PARKING BRAKES
AREA 2 SAFETY

PARKING BRAKES
AREA 3 SAFETY

⇦192

200⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Parking brakes supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 195
Revision			Replacement of / Replaced by			Group:	Of 414



195

201

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Bus ac/dc drivers		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	200
Revision		Replacement of	Replaced by			Group:	Of 414

200.9 / -R1 — 3 ~ 400V 50Hz
200.9 / -S1
200.9 / -T1

200.9 / 200-1 — 3 ~ 400V 50Hz
200.9 / 200-2
200.9 / 200-3

201.9 / -24V-L30 — 24Vdc
125.9 / -0V3

-24V-L30 / 201.4
-0V3 / 205.0

-201L1
630/800KW
1430A 380-480V 50/60Hz
6SL3000-0EE41-4AA0

1 2 3 4 5 6

201-1 201-2 201-3

202.2
202-1
202.2
201-4

-201T1
Q3

U1 V1 W1 PE SH1 — L1 L2 L3 — -X9 1 2 3 4 5 6 7 8 — -X41 2 1 3 4

SIEMENS

SINAMICS S120 POWER MODULE
BLOCKSIZE

6SL3330-6TE41-3AA3

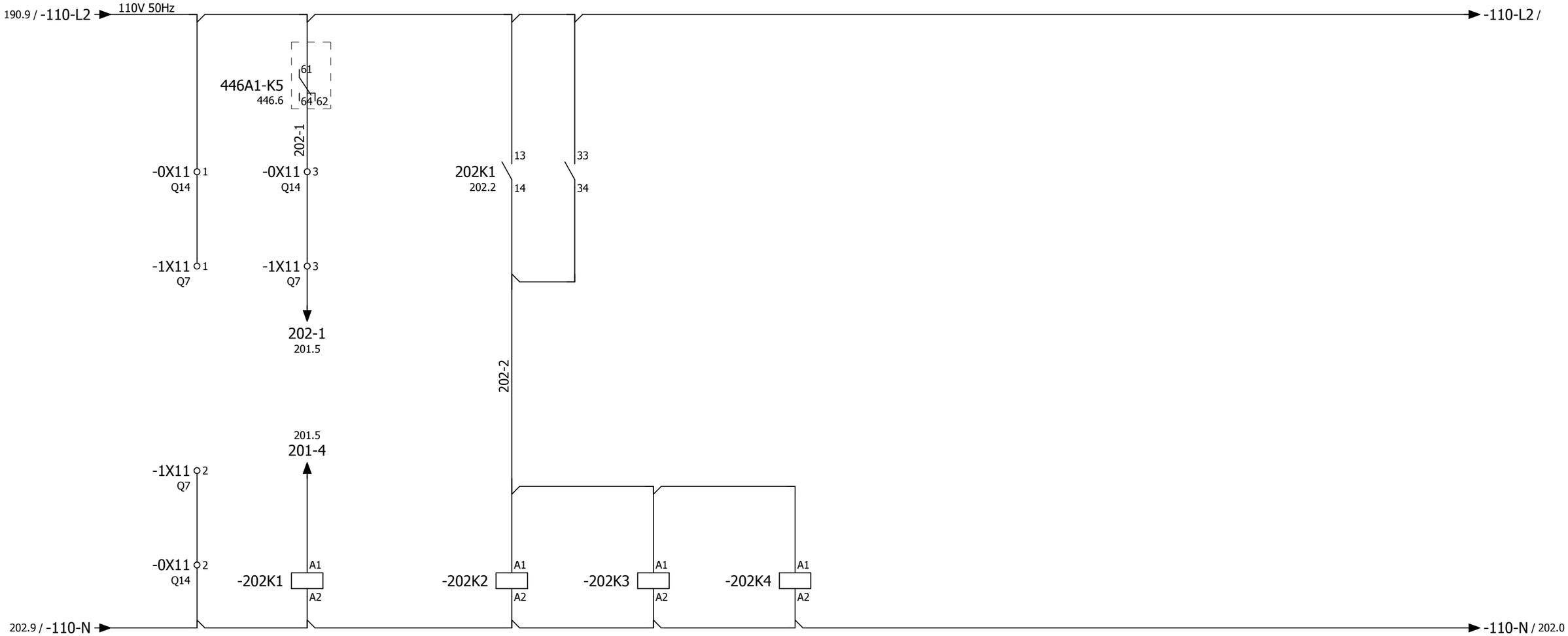
DCN DCP/R1 — BRAKING MODULE DCNA DCPA — DRIVE-CLiQ -X400

CliQ 0
205.3

600Vdc
-DCN / 220.0
-DCP / 220.0

⇦200 202⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Driver ac/dc bus		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 201
Revision		Replacement of	Replaced by			Group:	Of 414



DC BUS
INSERTION

3RH1131-1AF00
21 22
13 14 202.3
33 34 202.3
43 44

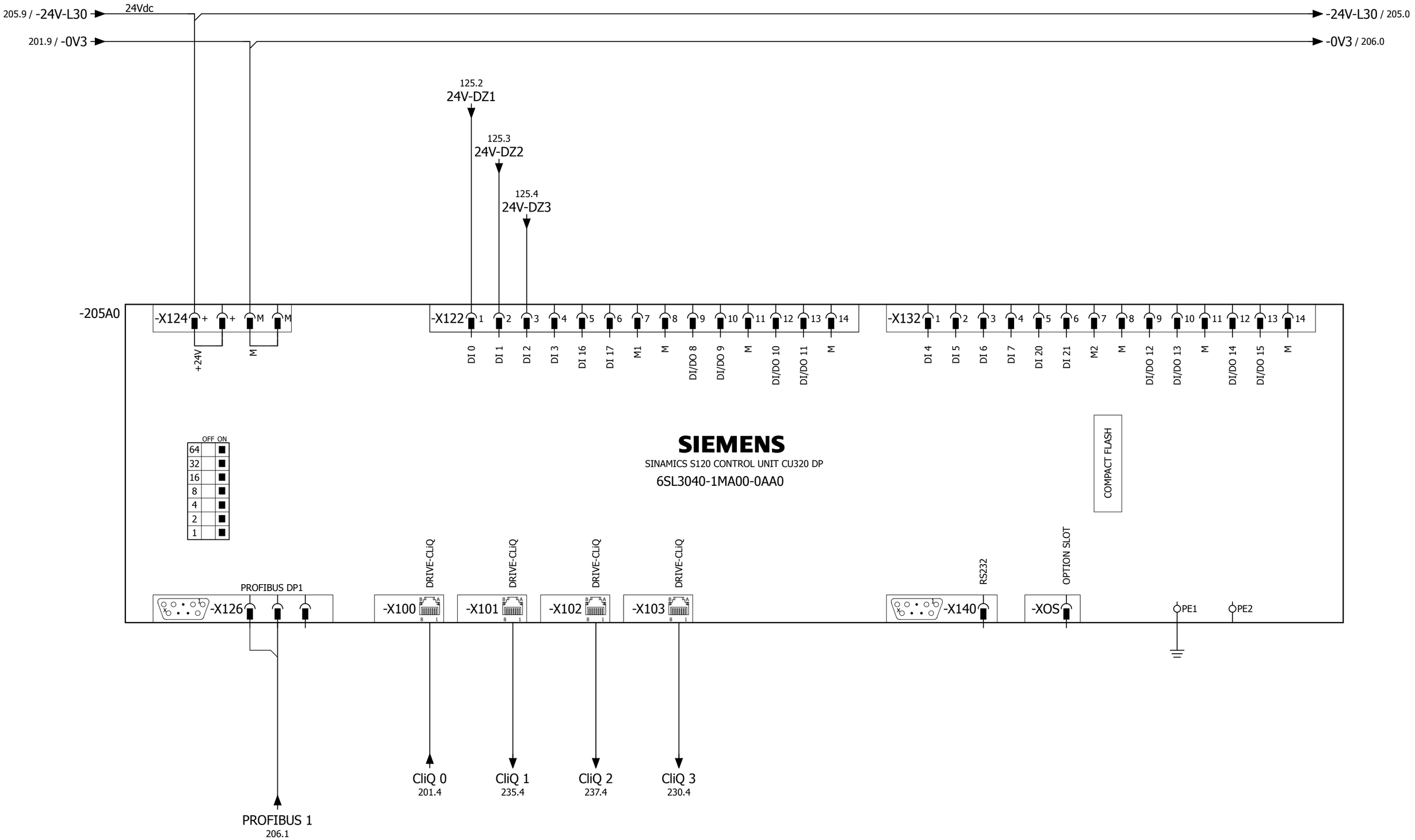
3RT1466-6AF36
1 2 200.2
3 4 200.2
5 6 200.2
13 14
43 44
21 22
31 32

3RT1466-6AF36
1 2 200.4
3 4 200.4
5 6 200.4
13 14
43 44
21 22
31 32

3RT1466-6AF36
1 2 200.5
3 4 200.6
5 6 200.6
13 14
43 44
21 22
31 32

⇦201
205⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Driver ac/dc bus		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 202
Revision		Replacement of	Replaced by			Group:	Of 414



⇦202

206⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	205
Revision		Replacement of	Replaced by			Group:	Of 414

206.9 / -24V-L30 → 24Vdc → -24V-L30 / 206.0

205.9 / -0V3 → -0V3 / 207.0

125.2 24V-DZ1

125.3 24V-DZ2

125.4 24V-DZ3

463.3 463-4

-206A0
Q7

-X124: + + M M
+24V, M

-X122: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 0, DI 1, DI 2, DI 3, DI 16, DI 17, M1, M, DI/DO 8, DI/DO 9, M, DI/DO 10, DI/DO 11, M

-X132: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 4, DI 5, DI 6, DI 7, DI 20, DI 21, M2, M, DI/DO 12, DI/DO 13, M, DI/DO 14, DI/DO 15, M

OFF	ON
64	■
32	■
16	■
8	■
4	■
2	■
1	■

SIEMENS

SINAMICS S120 CONTROL UNIT CU320 DP

6SL3040-1MA00-0AA0

COMPACT FLASH

PROFIBUS DP1 -X126

DRIVE-CLiQ -X100

DRIVE-CLiQ -X101

DRIVE-CLiQ -X102

DRIVE-CLiQ -X103

RS232 -X140

OPTION SLOT -XOS

PE1 PE2

205.2 / PROFIBUS 1

PROFIBUS 1
207.1

CliQ 0
222.5

CliQ 1
225.5

CliQ 2
241.5

CliQ 3
253.5

⇦205 207⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 206
Revision			Replacement of / Replaced by			Group:	Of 414

207.9 / -24V-L30 → 24Vdc → -24V-L30 / 207.0

206.9 / -0V3 → -0V3 / 208.0

1° CHOICE STACKER
1° BOX OPERATOR
SIDE AND
MOTOR SIDE
SHEET SUPPORT

125.2 24V-DZ1
125.1 24V-DZ0
125.3 24V-DZ2
125.4 24V-DZ3
586.2 586-0
586.2 586-1
586.3 586-2
586.4 586-3

-207A0
Q8

-X124: + + M M
+24V
M

-X122: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 0 | DI 1 | DI 2 | DI 3 | DI 16 | DI 17 | M1 | M | DI/DO 8 | DI/DO 9 | M | DI/DO 10 | DI/DO 11 | M

-X132: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 4 | DI 5 | DI 6 | DI 7 | DI 20 | DI 21 | M2 | M | DI/DO 12 | DI/DO 13 | M | DI/DO 14 | DI/DO 15 | M

SIEMENS
SINAMICS S120 CONTROL UNIT CU320 DP
6SL3040-1MA00-0AA0

COMPACT FLASH

	OFF	ON
64		■
32		■
16		■
8		■
4		■
2		■
1		■

PROFIBUS DP1 -X126
DRIVE-CLiQ -X100
DRIVE-CLiQ -X101
DRIVE-CLiQ -X102
DRIVE-CLiQ -X103
RS232 -X140
OPTION SLOT -XOS
PE1
PE2

206.2 / PROFIBUS 1

PROFIBUS 1
208.1

CliQ 0
249.7

CliQ 1
255.7

⇦206

208⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2	=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97			Installation: Linea taglio trasversale	Page 207
Revision			Replacement of	Replaced by			Group: Of 414

208.9 / -24V-L30 → 24Vdc → -24V-L30 / 208.0

207.9 / -0V3 → -0V3 / 209.0

1° CHOICE STACKER
2° BOX OPERATOR
SIDE AND
MOTOR SIDE
SHEET SUPPORT

125.2 24V-DZ1
125.3 24V-DZ2
125.4 24V-DZ3
586.5 586-4
586.6 586-5
586.7 586-6
586.8 586-7

-208A0
Q9

-X124: + + M M
+24V
M

-X122: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 0 / DI 1 / DI 2 / DI 3 / DI 16 / DI 17 / M1 / M / DI/DO 8 / DI/DO 9 / M / DI/DO 10 / DI/DO 11 / M

-X132: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 4 / DI 5 / DI 6 / DI 7 / DI 20 / DI 21 / M2 / M / DI/DO 12 / DI/DO 13 / M / DI/DO 14 / DI/DO 15 / M

SIEMENS
SINAMICS S120 CONTROL UNIT CU320 DP
6SL3040-1MA00-0AA0

COMPACT FLASH

	OFF	ON
64		■
32		■
16		■
8		■
4		■
2		■
1		■

PROFIBUS DP1 -X126
DRIVE-CLiQ -X100
DRIVE-CLiQ -X101
DRIVE-CLiQ -X102
DRIVE-CLiQ -X103
RS232 -X140
OPTION SLOT -XOS
PE1 PE2

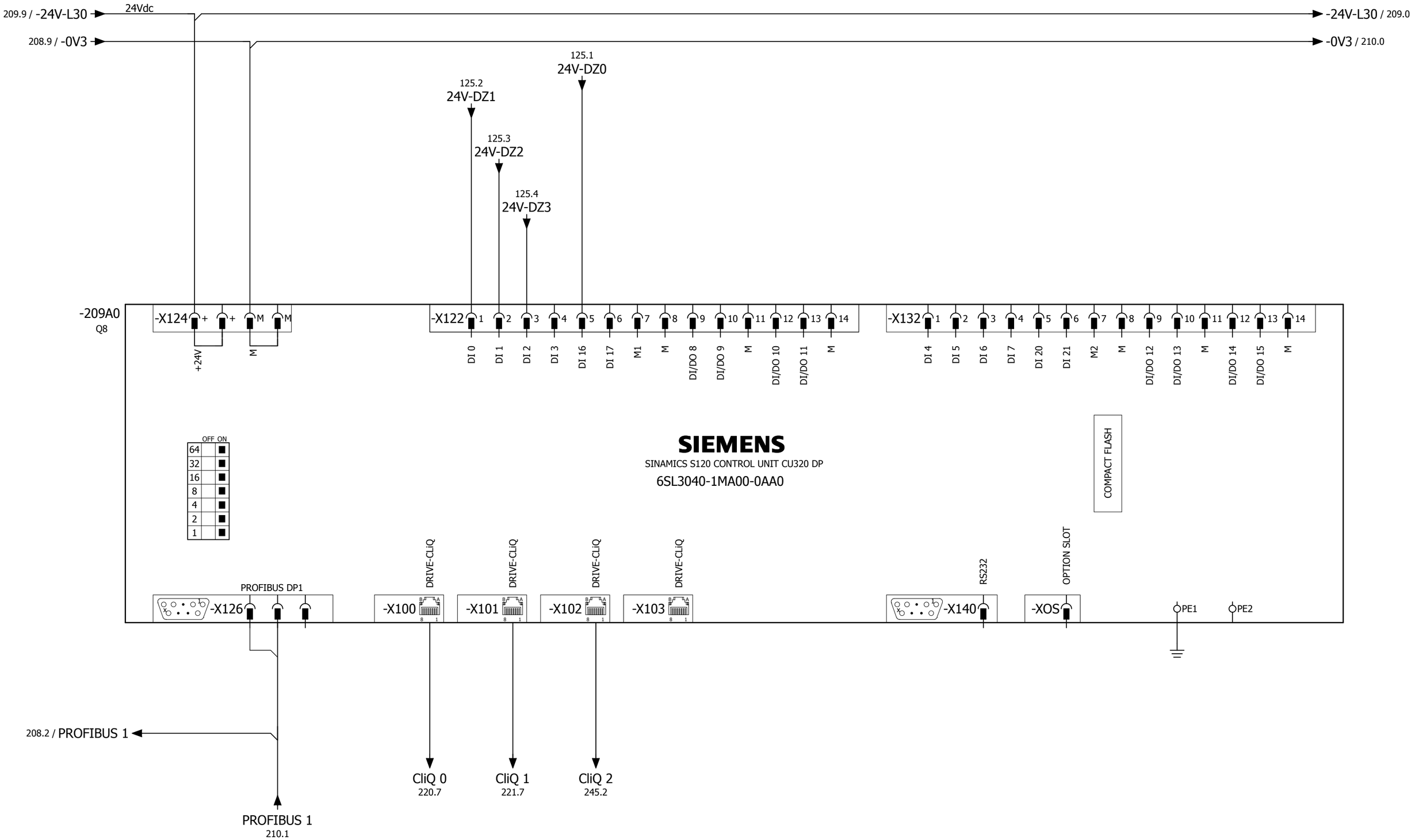
207.2 / PROFIBUS 1 ←

CliQ 0
263.7

PROFIBUS 1
209.1

⇦207
209⇨

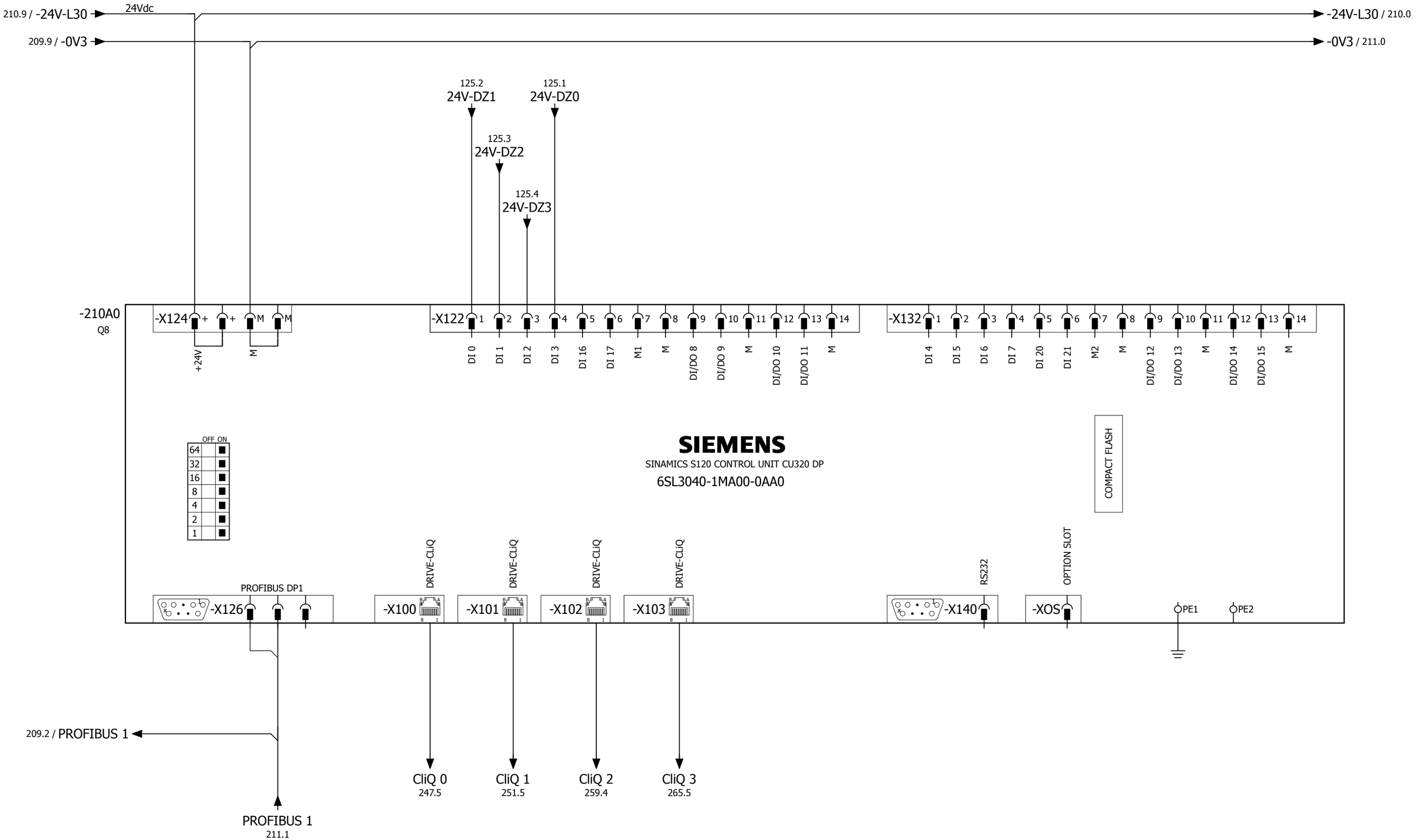
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2	=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97			Installation: Linea taglio trasversale	Page 208
Revision			Replacement of	Replaced by			Group: Of 414



⇦208

210⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	209
Revision		Replacement of	Replaced by			Group:	Of 414



⇦209

211⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 210
Revision			Replacement of / Replaced by			Group:	Of 414

211.9 / -24V-L30 → 24Vdc → -24V-L30 / 211.0

210.9 / -0V3 → -0V3 / 212.0

125.2 24V-DZ1

125.3 24V-DZ2

125.4 24V-DZ3

-211A0
Q9

-X124: + + M M
+24V M

-X122: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 0 DI 1 DI 2 DI 3 DI 16 DI 17 M1 M DI/DO 8 DI/DO 9 M DI/DO 10 DI/DO 11 M

-X132: 1 2 3 4 5 6 7 8 9 10 11 12 13 14
DI 4 DI 5 DI 6 DI 7 DI 20 DI 21 M2 M DI/DO 12 DI/DO 13 M DI/DO 14 DI/DO 15 M

SIEMENS

SINAMICS S120 CONTROL UNIT CU320 DP

6SL3040-1MA00-0AA0

COMPACT FLASH

	OFF	ON
64		■
32		■
16		■
8		■
4		■
2		■
1		■

PROFIBUS DP1 -X126

DRIVE-CLiQ -X100

DRIVE-CLiQ -X101

DRIVE-CLiQ -X102

DRIVE-CLiQ -X103

RS232 -X140

OPTION SLOT -XOS

PE1 PE2

210.2 / PROFIBUS 1

PROFIBUS 1
212.1

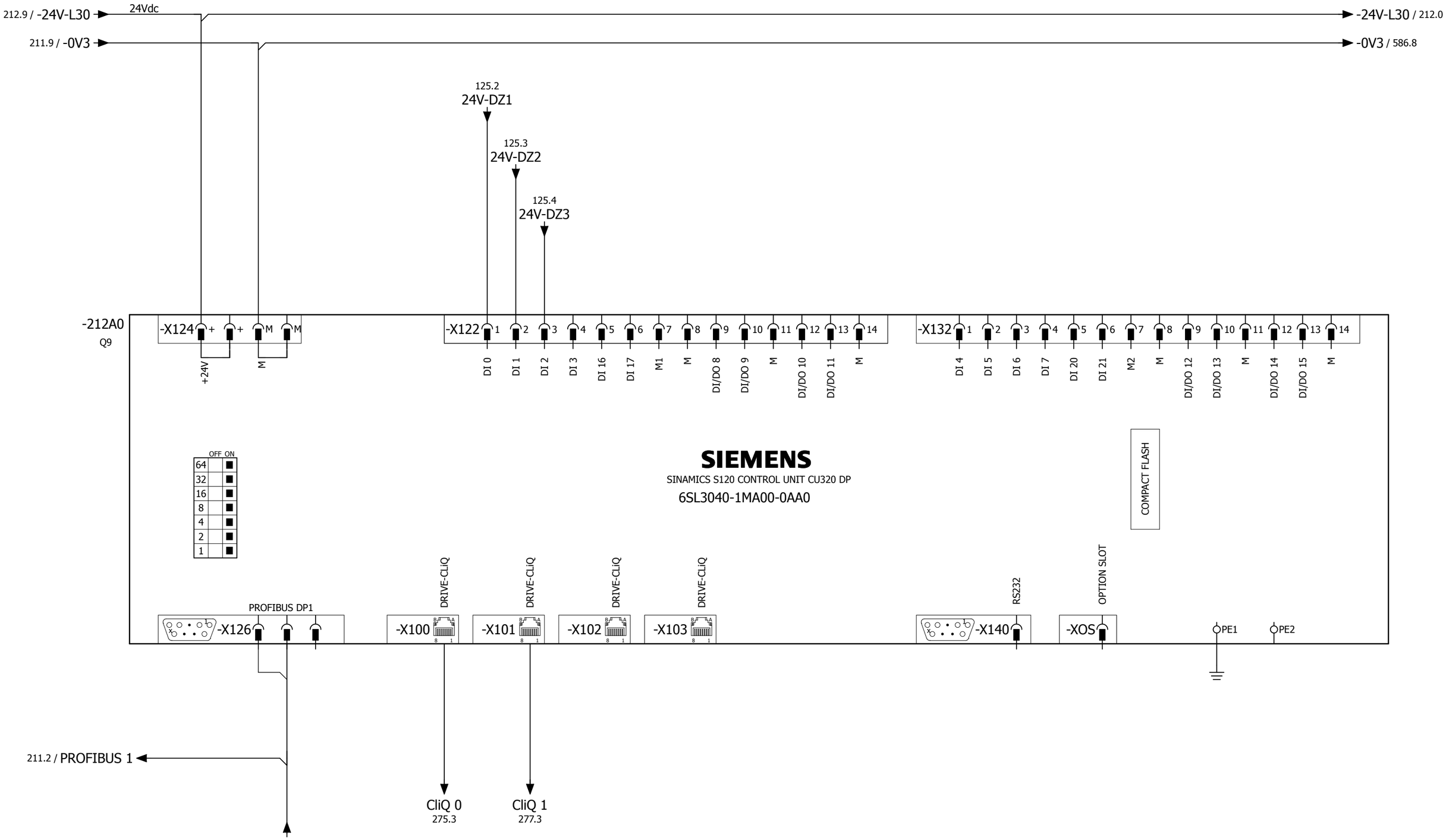
CliQ 0
267.7

CliQ 1
271.7

CliQ 2
273.3

⇦210 212⇨

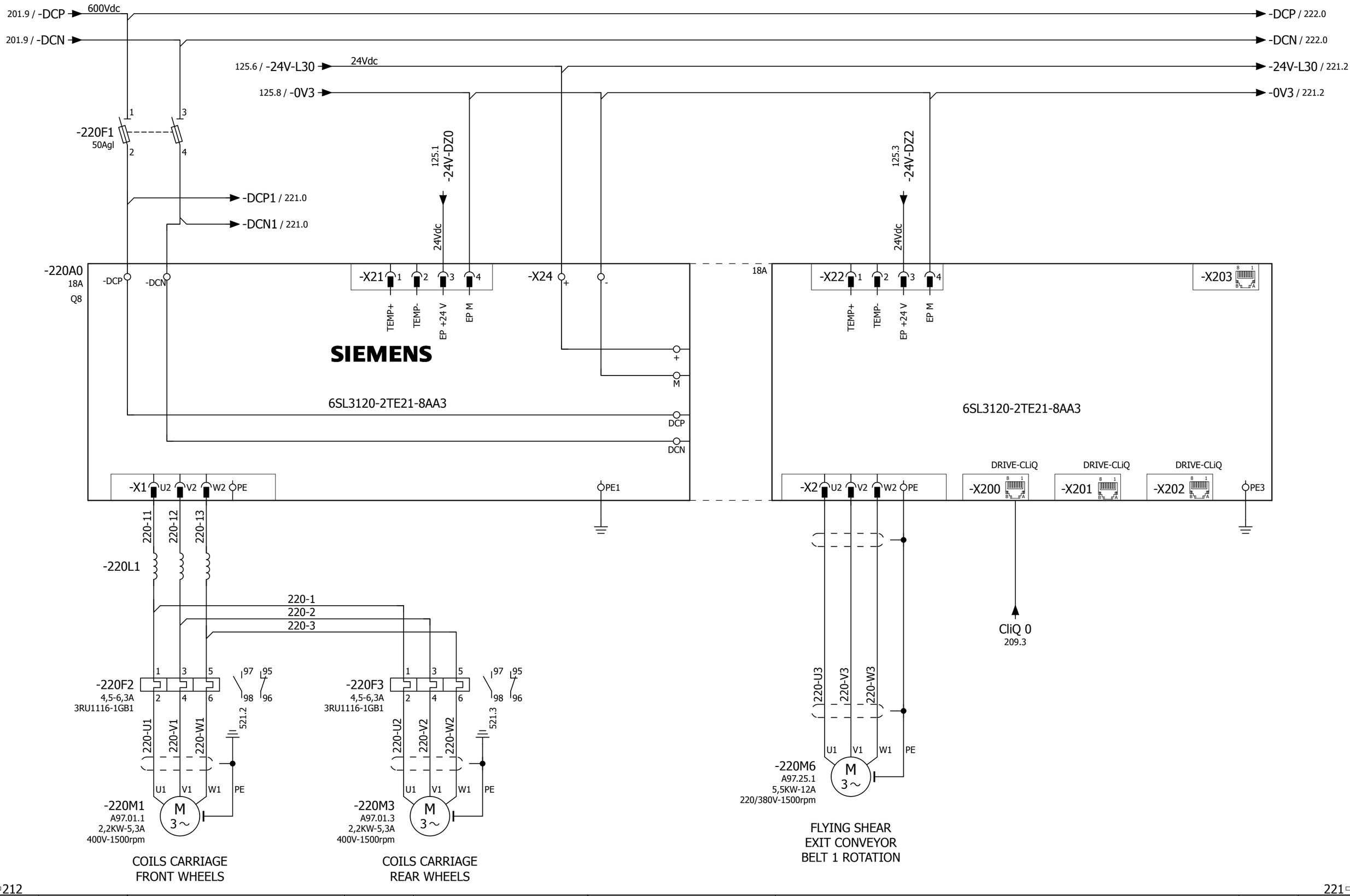
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 211
Revision			Replacement of / Replaced by			Group:	Of 414



211

220

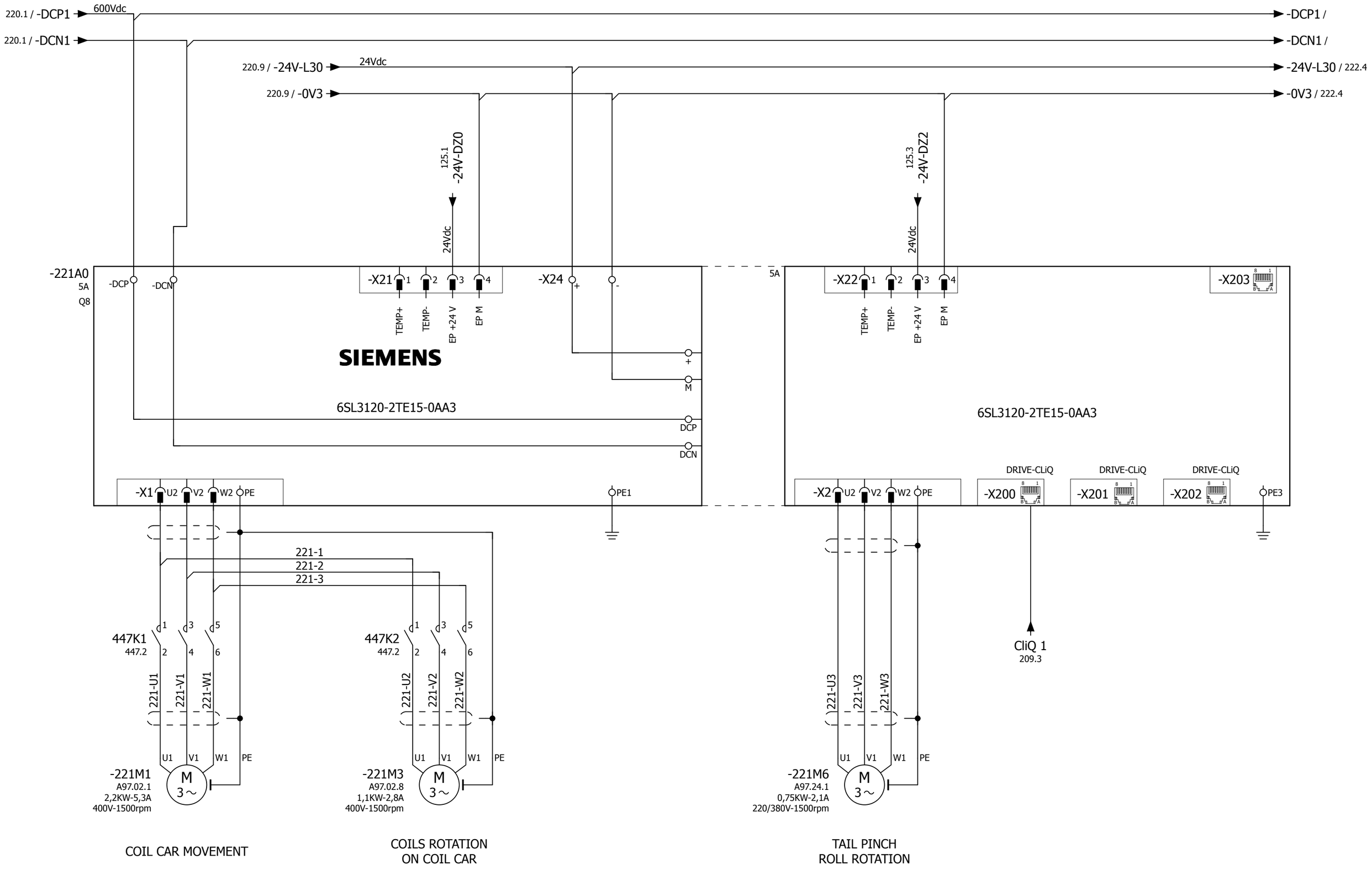
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sinamics control unit CU320-2		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 212
Revision		Replacement of	Replaced by			Group:	Of 414



⇦212

221⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Coils carriage and exit flying shear belt conveyor 1 rotation motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	220
Revision		Replacement of	Replaced by			Group:	Of 414



COIL CAR MOVEMENT

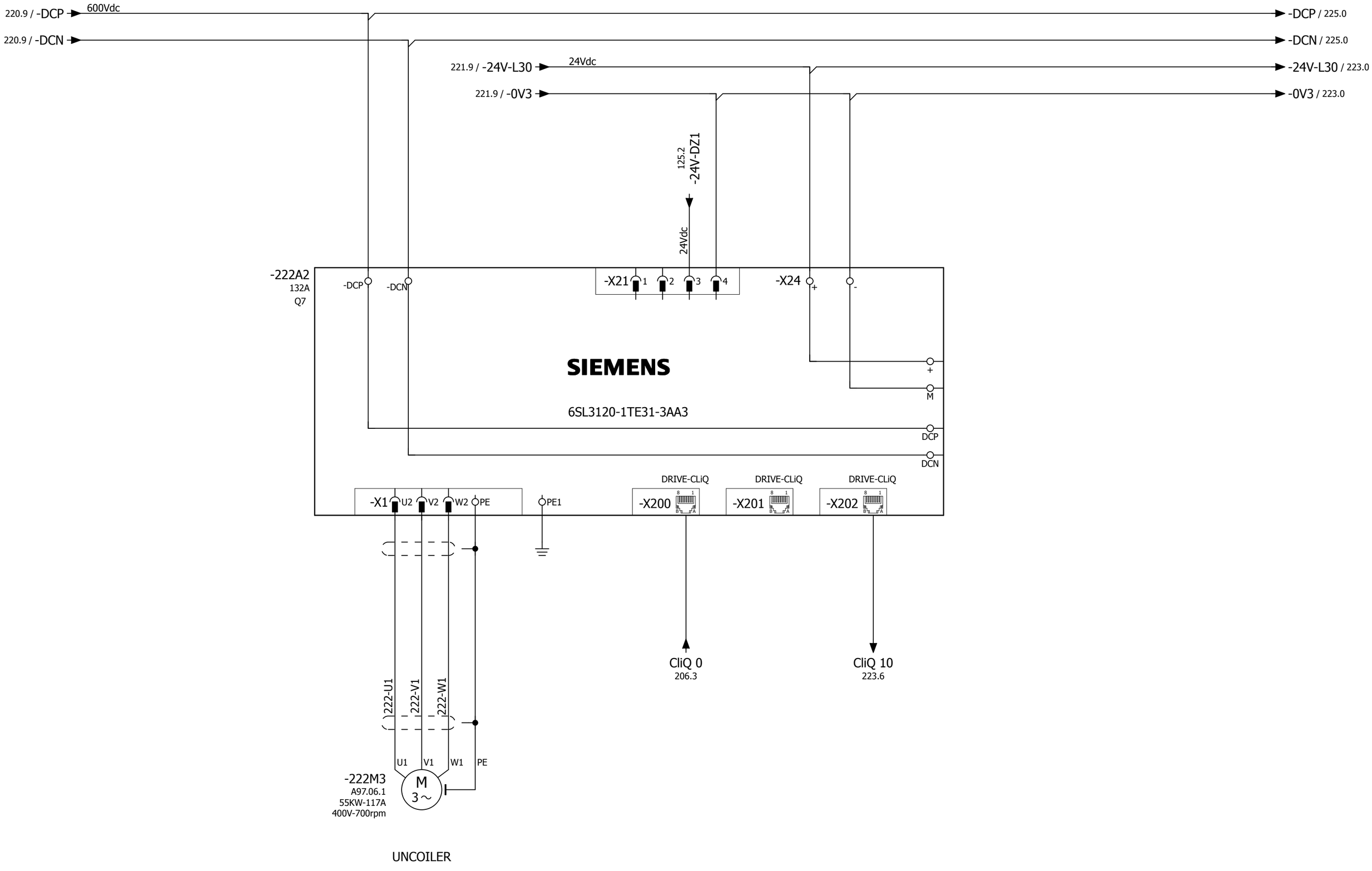
COILS ROTATION
ON COIL CAR

TAIL PINCH
ROLL ROTATION

⇦220

222⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Coil car and tail pinch roll rotation motor		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	221
Revision			Replacement of / Replaced by			Group: / Of	414



UNCOILER

⇦221

223⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Uncoiler motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	222
Revision		Replacement of	Replaced by			Group:	Of 414

222.9 / -24V-L30 → 24Vdc

222.9 / -0V3 →

→ -24V-L30 / 225.4

→ -0V3 / 225.4

222.6
CliQ 10

-223A1
Q7

-X524 + + M M

+24V

M

-X500

DRIVE-CLiQ

SIEMENS

6SL3055-0AA00-5CA2

PE -X520

-X521	A	A*	B	B*	R	R*	CTRL	M
	1	2	3	4	5	6	7	8

-X531	P ENCODER	M ENCODER	-TEMP	+TEMP	CLOCK	CLOCK*	DATA	DATA*
	1	2	3	4	5	6	7	8

223-1 223-2 223-3 223-4 223-5 223-6 223-7 223-8 223-9 223-10

-223E2
A97.06.5

A A* B B* R R*

\+

\-

ENCODER HTL ...Vdc

11 T 12

-223PTC
A97.06.6

PIN	ENC	WIRE	N.WIRES
	A	WH	223-1
	A+	YE	223-2
	B	WH	223-3
	B+	GN	223-4
	+	WH+RD	223-8
	0V	WH+GY	223-7
	SCH	SCH	SCH

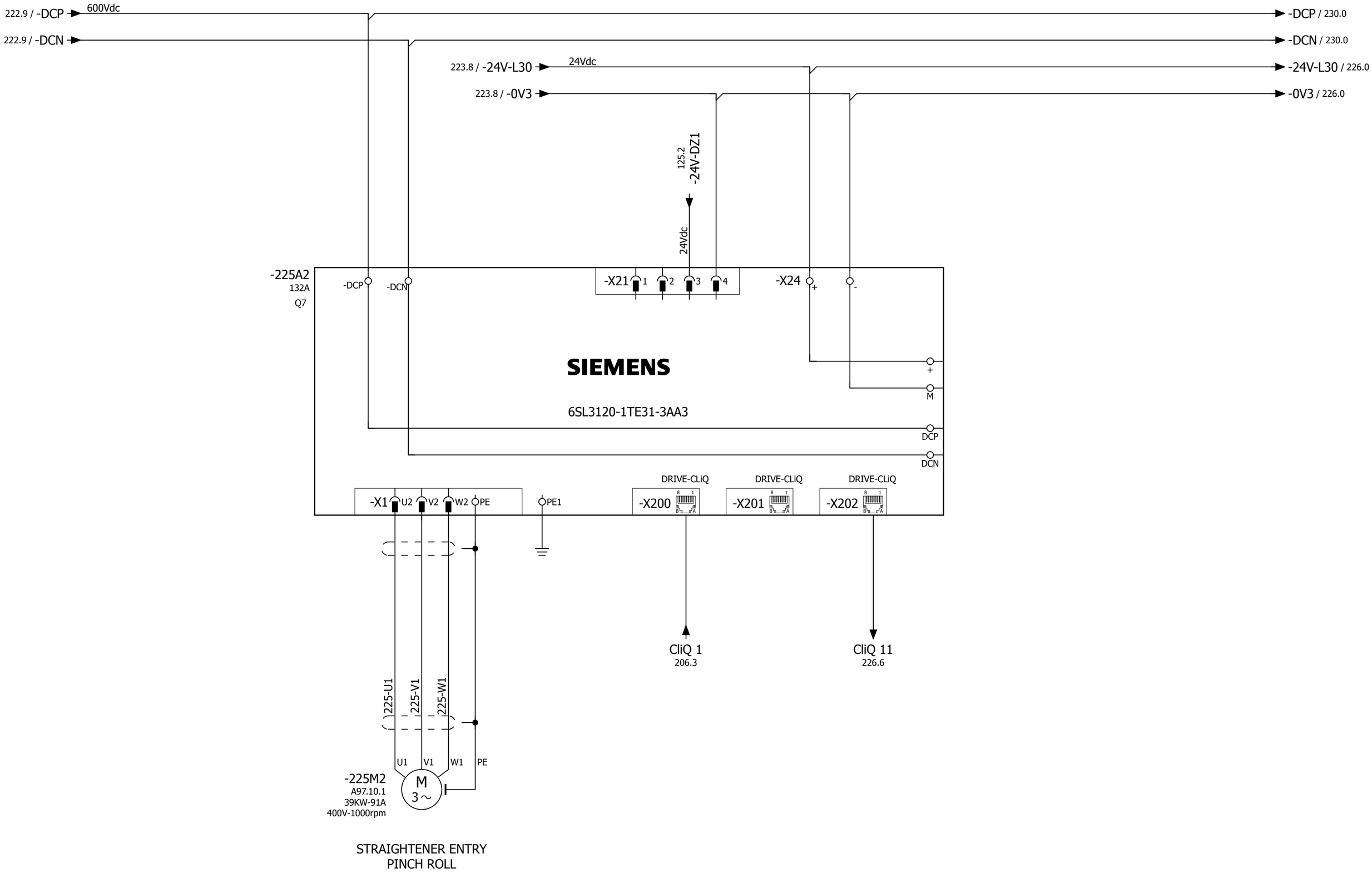
DECOILER
ENCODER

DECOILER THERMAL
PAD

⇦222

225⇨

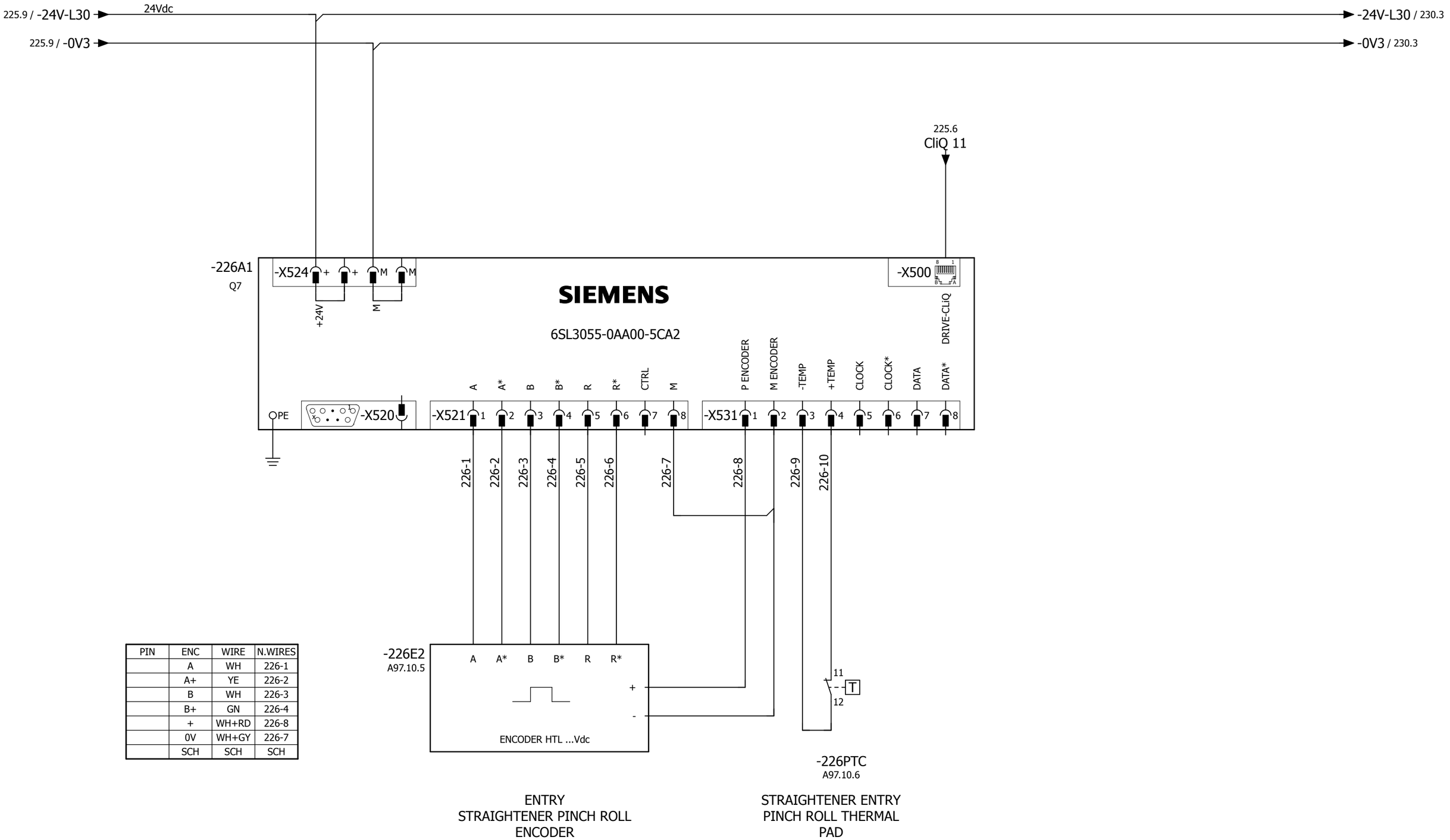
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Uncoiler motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	223
Revision		Replacement of	Replaced by			Group:	Of 414



⇦223

226⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Straightener entry pinch roll motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	225
Revision		Replacement of	Replaced by			Group:	Of 414



PIN	ENC	WIRE	N.WIRES
	A	WH	226-1
	A+	YE	226-2
	B	WH	226-3
	B+	GN	226-4
	+	WH+RD	226-8
	0V	WH+GY	226-7
	SCH	SCH	SCH

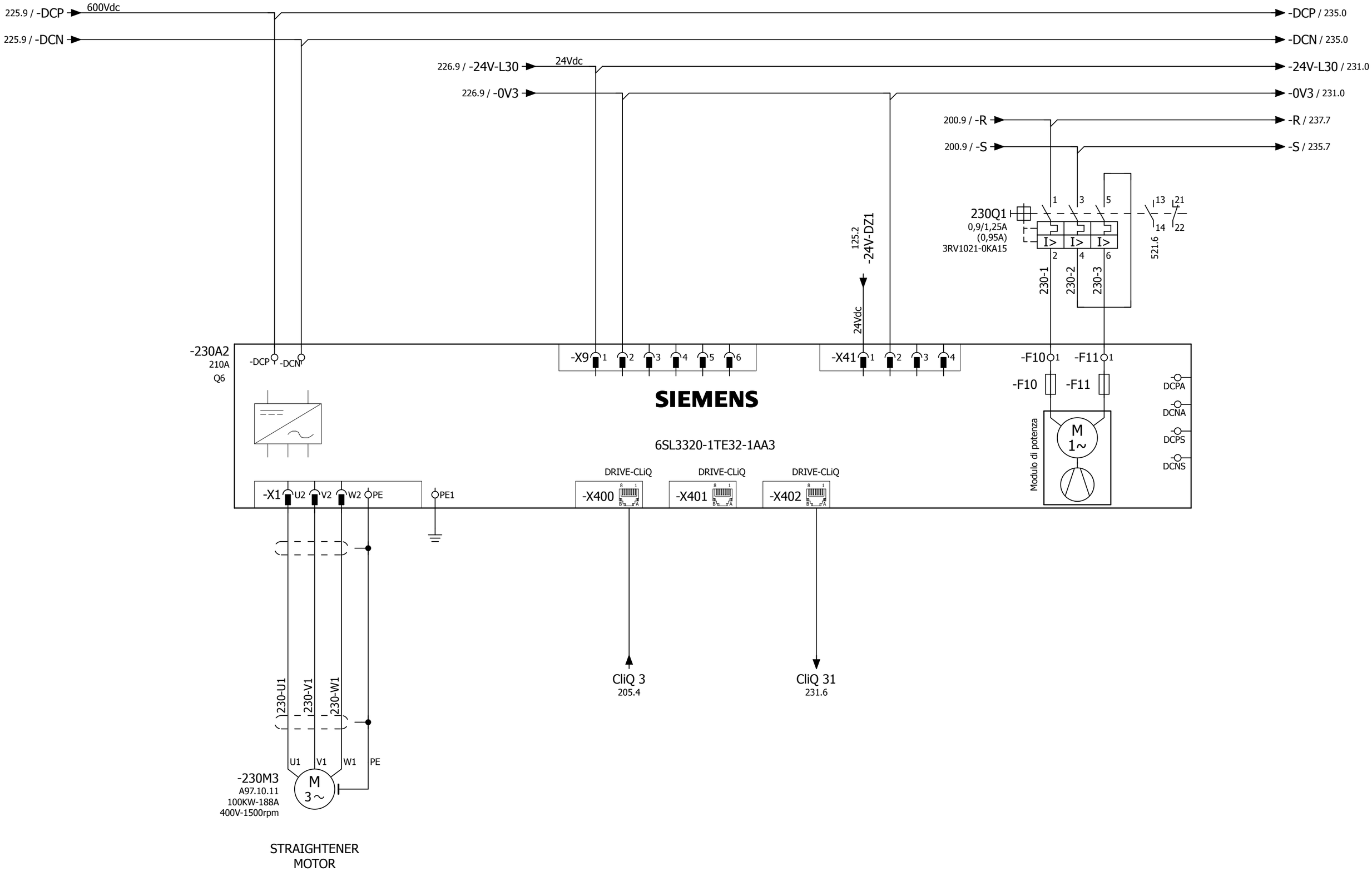
ENTRY
STRAIGHTENER PINCH ROLL
ENCODER

STRAIGHTENER ENTRY
PINCH ROLL THERMAL
PAD

⇦225

230⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Straightener entry pinch roll motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	226
Revision		Replacement of	Replaced by			Group:	Of 414



⇦226

231⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Straightener motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 230
Revision		Replacement of	Replaced by			Group:	Of 414

230.9 / -24V-L30 → 24Vdc → -24V-L30 / 235.3

230.9 / -0V3 → -0V3 / 235.3

230.5
CliQ 31

-231A1
Q6

-X524 + + M M
+24V
M

-X500
DRIVE-CLiQ

SIEMENS

6SL3055-0AA00-5CA2

PE -X520

-X521 1 A, 2 A*, 3 B, 4 B*, 5 R, 6 R*, 7 CTRL, 8 M

-X531 1 P ENCODER, 2 M ENCODER, 3 -TEMP, 4 +TEMP, 5 CLOCK, 6 CLOCK*, 7 DATA, 8 DATA*

230-1 A
230-2 A*
230-3 B
230-4 B*
230-5 R
230-6 R*
230-7 M
230-8 P ENCODER
230-9 -TEMP
230-10 +TEMP

PIN	ENC	WIRE	N.WIRES
	A	WH	226-1
	A+	YE	226-2
	B	WH	226-3
	B+	GN	226-4
	+	WH+RD	226-8
	0V	WH+GY	226-7
	SCH	SCH	SCH

-231E2
A97.10.15

A A* B B* R R*
\+
\-
ENCODER HTL ...Vdc

11
T
12

-231PTC
A97.10.16

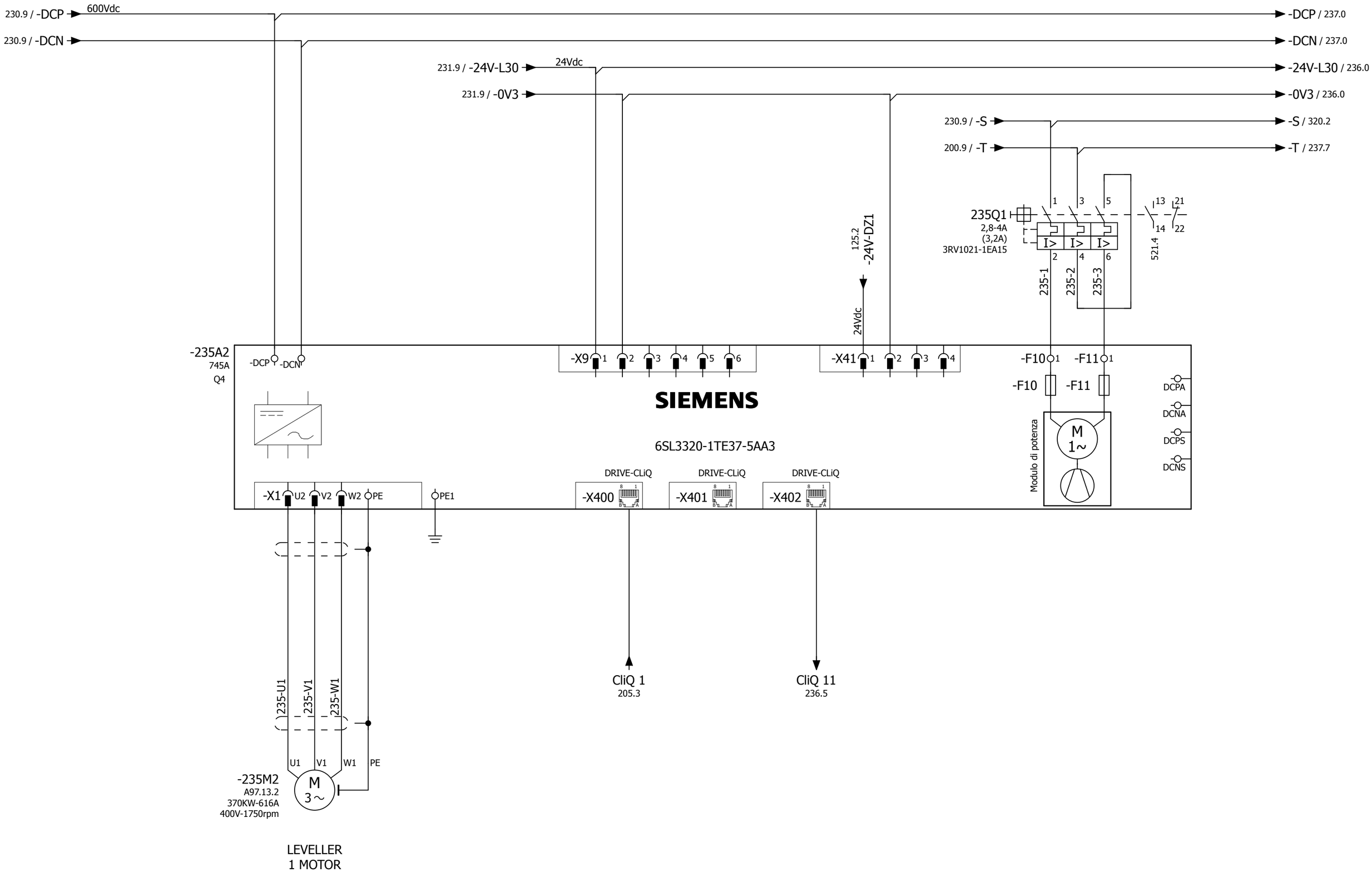
STRAIGHTENER ENCODER

STRAIGHTENER THERMAL PAD

⇦230

235⇨

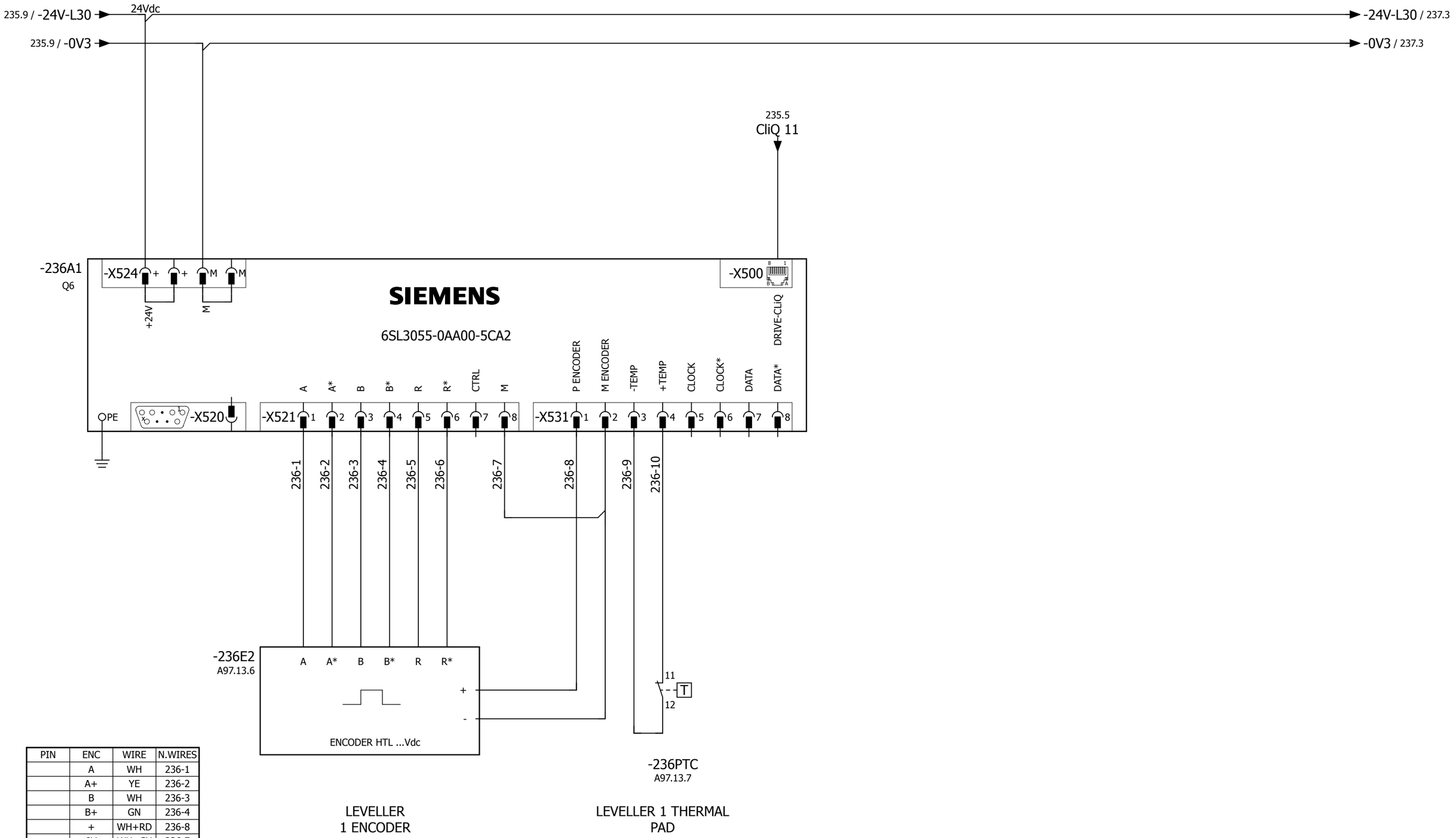
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Straightener motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	231
Revision		Replacement of	Replaced by			Group:	Of 414



231

236

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Leveller 1 motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 235
Revision		Replacement of	Replaced by			Group:	Of 414



PIN	ENC	WIRE	N.WIRES
	A	WH	236-1
	A+	YE	236-2
	B	WH	236-3
	B+	GN	236-4
	+	WH+RD	236-8
	0V	WH+GY	236-7
	SCH	SCH	SCH

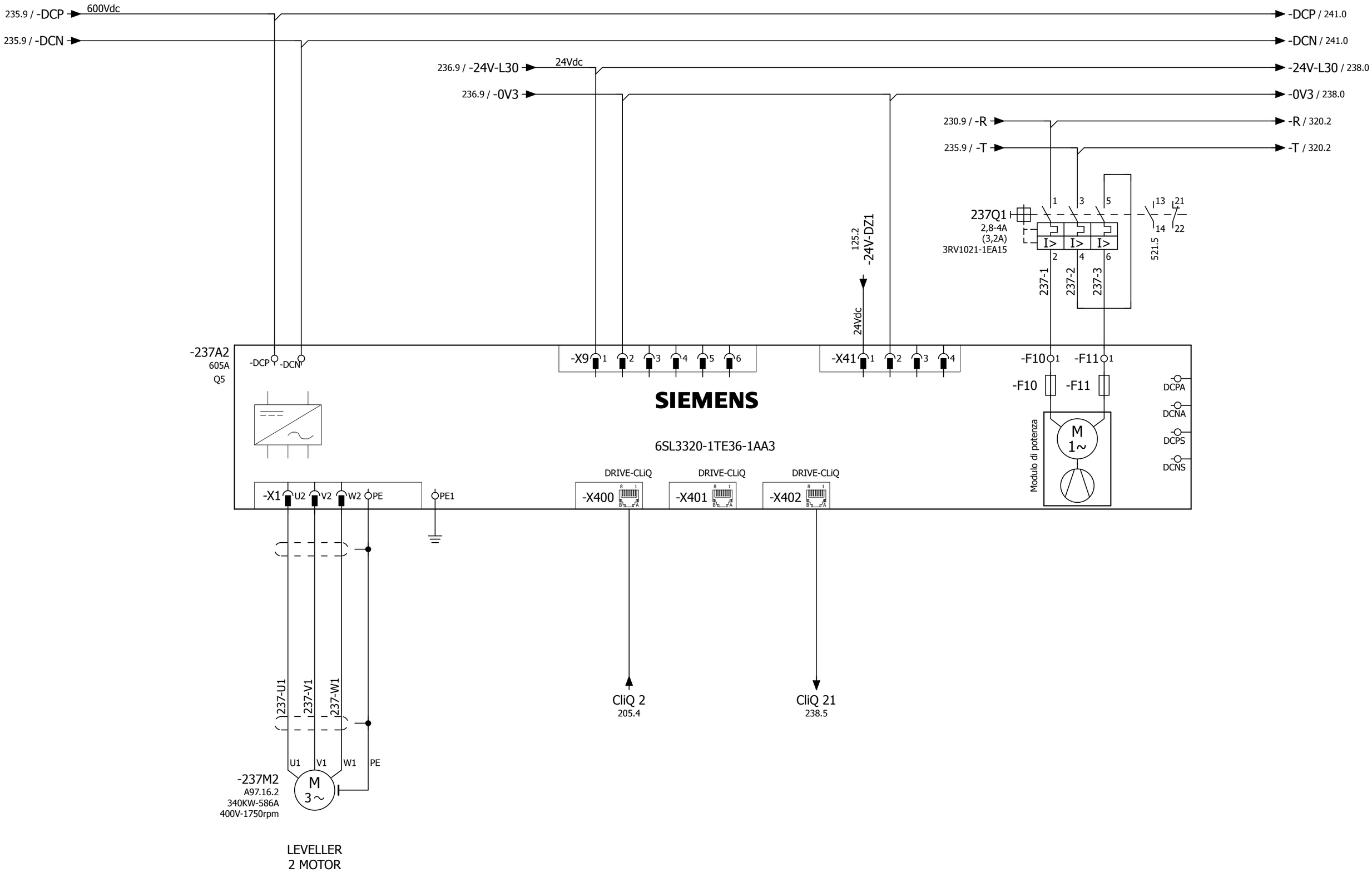
LEVELLER
1 ENCODER

LEVELLER 1 THERMAL
PAD

⇦235

237⇨

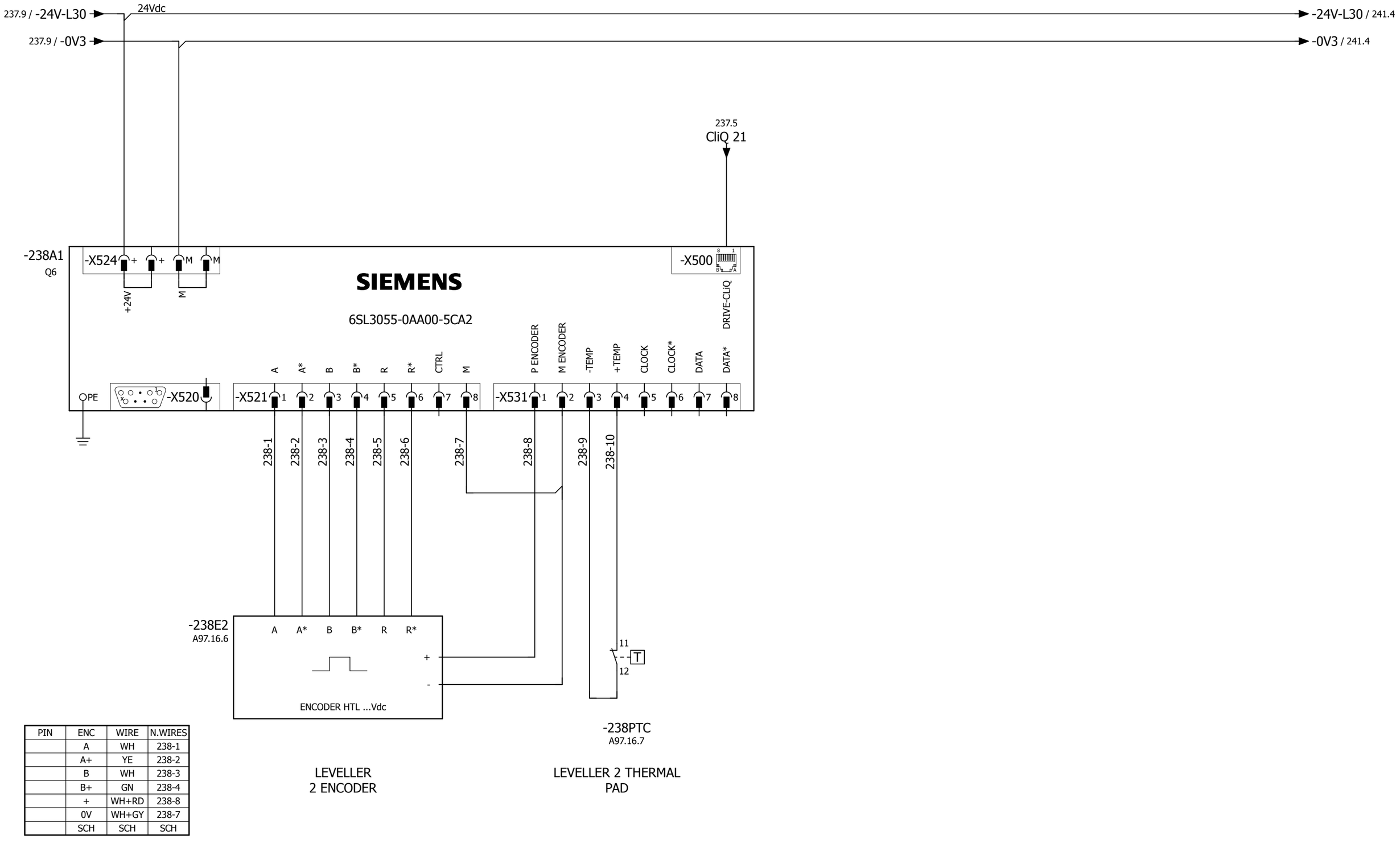
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 motor		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 236
Revision			Replacement of / Replaced by			Group:	Of 414



⇦236

238⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Leveller 2 motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 237
Revision		Replacement of	Replaced by			Group:	Of 414

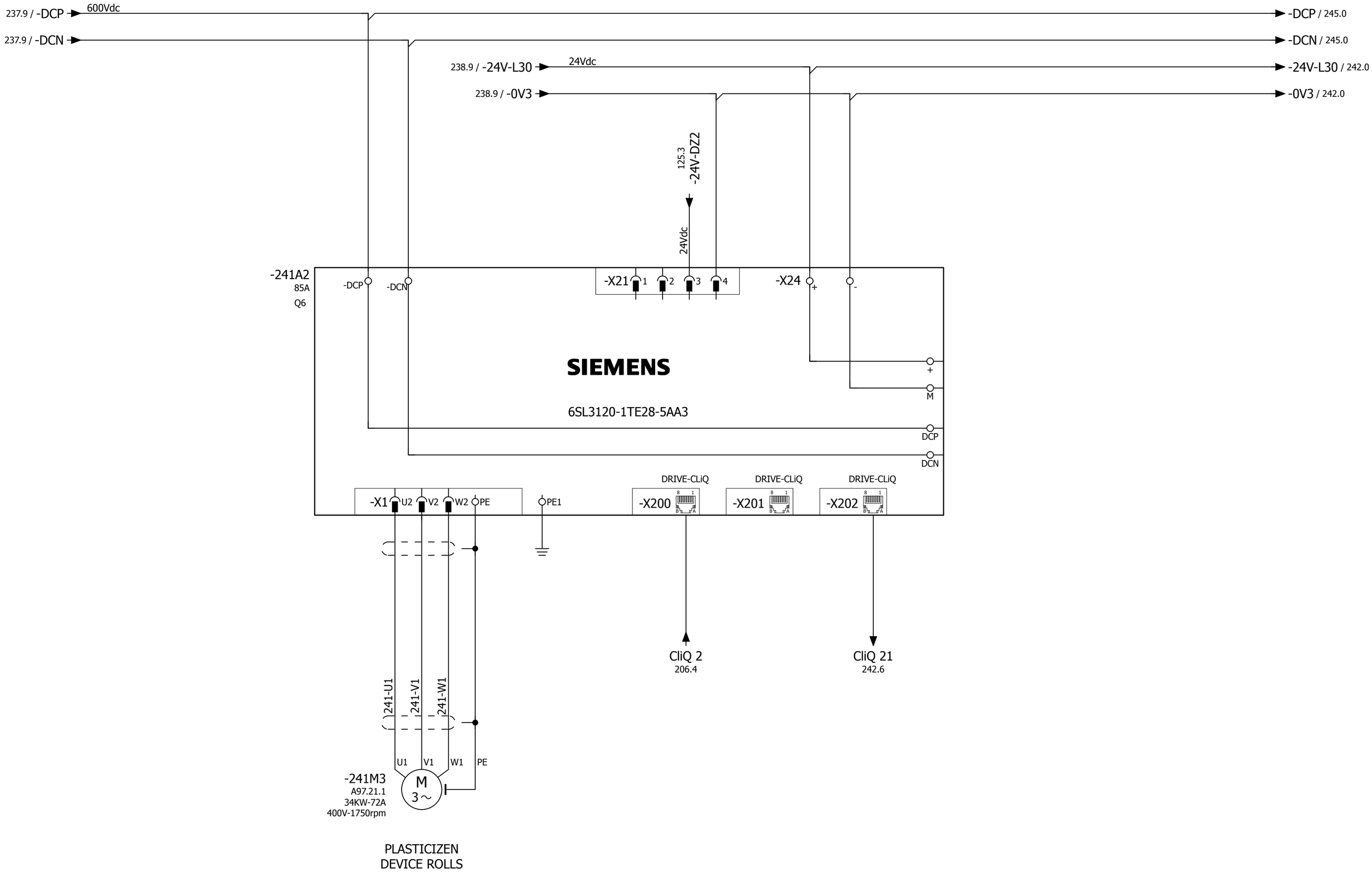


PIN	ENC	WIRE	N.WIRES
	A	WH	238-1
	A+	YE	238-2
	B	WH	238-3
	B+	GN	238-4
	+	WH+RD	238-8
	0V	WH+GY	238-7
	SCH	SCH	SCH

⇦237

241⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 motor		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	238
Revision			Replacement of / Replaced by			Group: / Of	414



PLASTICIZEN
DEVICE ROLLS

⇦238

242⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Plasticizen device rolls motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	241
Revision		Replacement of	Replaced by			Group:	Of 414

241.9 / -24V-L30 → 24Vdc → -24V-L30 / 245.2

241.9 / -0V3 → -0V3 / 245.2

241.6
CliQ 21

-242A1
Q6

-X524 + + M M

+24V

M

SIEMENS

6SL3055-0AA00-5CA2

-X500

DRIVE-CLiQ

-X520

-X521 A A* B B* R R* CTRL M

-X531 P ENCODER M ENCODER -TEMP +TEMP CLOCK CLOCK* DATA DATA*

PE

242-1 242-2 242-3 242-4 242-5 242-6 242-7 242-8 242-9 242-10

PIN	ENC	WIRE	N.WIRES
	A	WH	242-1
	A+	YE	242-2
	B	WH	242-3
	B+	GN	242-4
	+	WH+RD	242-8
	0V	WH+GY	242-7
	SCH	SCH	SCH

-242E2
A97.21.3

A A* B B* R R*

\+

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ENCODER HTL ...Vdc

11 T 12

-242PTC
A97.21.4

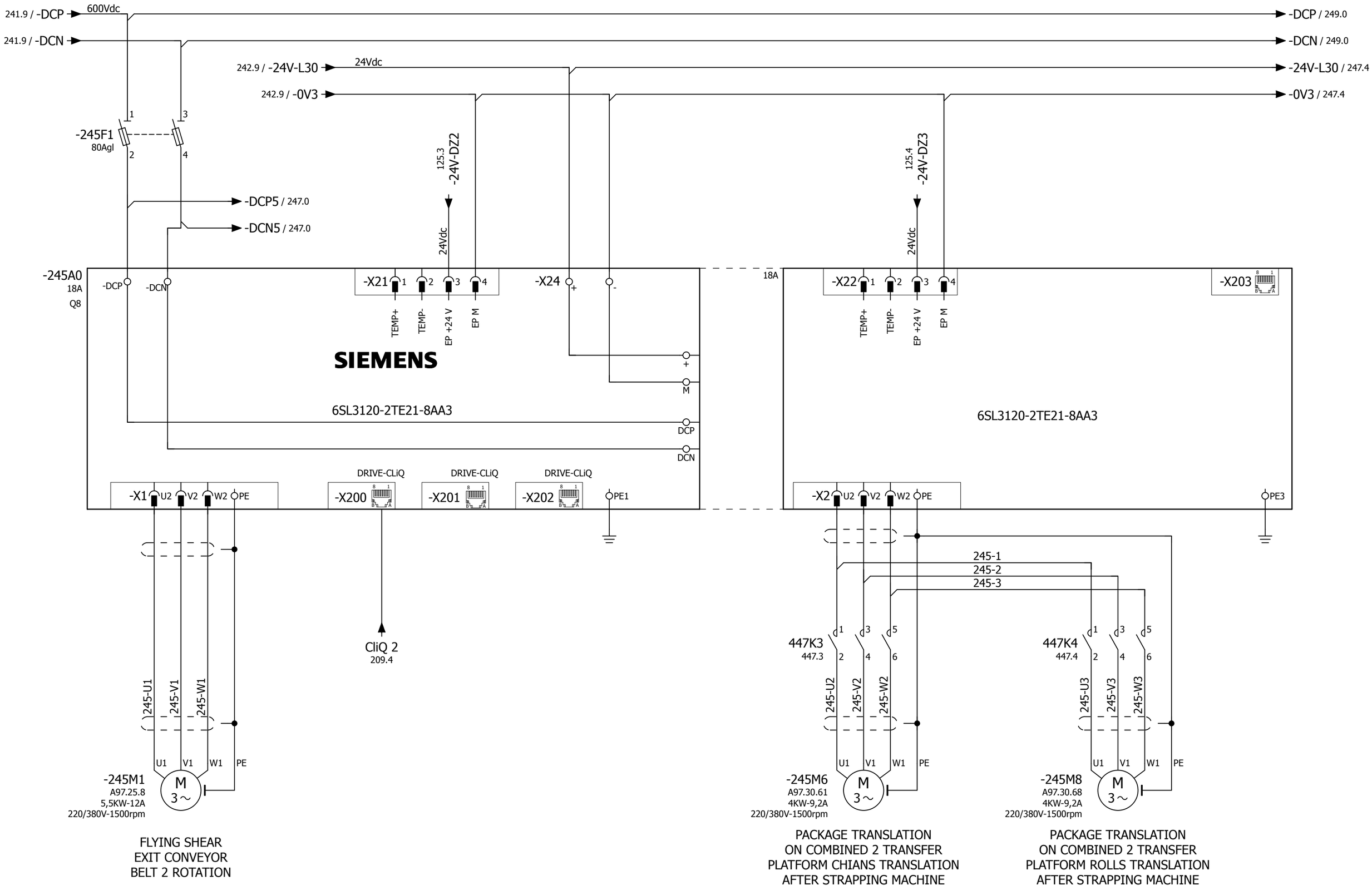
PLASTICIZEN
DEVICE ROLLS ENCODER

PLASTICIZEN DEVICE
ROLLS THERMAL
PAD

⇦241

245⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Plasticizen device rolls motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	242
Revision		Replacement of	Replaced by			Group:	Of 414



⇦242

247⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Exit shear conveyor belt 2 rotation and combined 2° transfer platform after strapping machine motor		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page 245	
Revision						Group:	Of 414

245.1 / -DCP5 → 600Vdc

245.1 / -DCN5 →

245.9 / -24V-L30 → 24Vdc → -24V-L30 / 249.2

245.9 / -0V3 → -0V3 / 249.2

125.3 -24V-DZ2

24Vdc

-247A2
30A
Q8

-DCP -DCN

-X21 1 2 3 4

-X24 + -

SIEMENS

6SL3120-1TE23-0AA3

+
M
DCP
DCN

DRIVE-CLiQ DRIVE-CLiQ DRIVE-CLiQ

-X1 U2 V2 W2 PE PE1

-X200 -X201 -X202

CliQ 0
210.3

247-U1 247-V1 247-W1

U1 V1 W1 PE

-247M3
A97.25.16
7,5KW-15,5A
220/380V-1500rpm

M
3 ~

FLYING SHEAR
EXIT CONVEYOR
BELT 3 ROTATION

⇦245

249⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Exit flying shear conveyor belt 3 rotation motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	247
Revision		Replacement of	Replaced by			Group:	Of 414

245.9 / -DCP → 600Vdc
245.9 / -DCN →
247.9 / -24V-L30 → 24Vdc
247.9 / -0V3 →

→ -DCP / 259.0
→ -DCN / 259.0
→ -24V-L30 / 253.4
→ -0V3 / 251.5

-249F1
80AgI
1 2 3 4

→ -DCP2 / 253.0
→ -DCN2 / 253.0
→ -DCP2 / 251.0
→ -DCN2 / 251.0

125.1 -24V-DZ0
24Vdc

→ -24V-L30 / 251.4
→ -0V3 / 251.4

125.1 -24V-DZ0
24Vdc

-249A0
9A
Q8

-DCP -DCN

-X21 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X24 + -

9A

-X22 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X203

SIEMENS

6SL3120-2TE21-0AA3

+
M
DCP
DCN

6SL3120-2TE21-0AA3

DRIVE-CLiQ DRIVE-CLiQ DRIVE-CLiQ

-X1 U2 V2 W2 PE
PE1

-X2 U2 V2 W2 PE
-X200 -X201 -X202
PE3

CliQ 0
207.3

249-U1 249-V1 249-W1
U1 V1 W1 PE

-249M1
A97.26.11
1,1KW-4A
400V-3000rpm
M 3 ~

249-U2 249-V2 249-W2
U1 V1 W1 PE

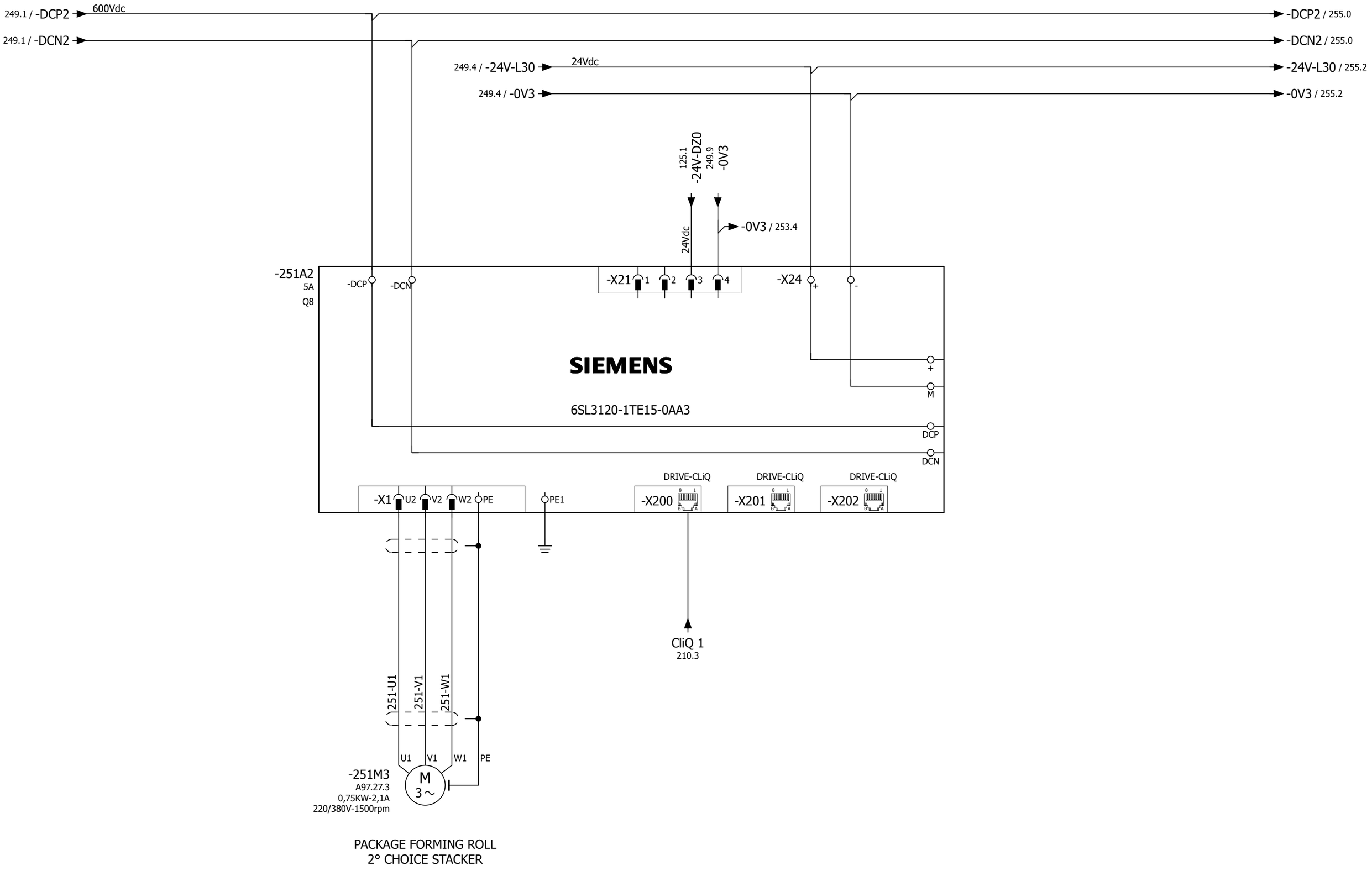
-249M6
A97.26.16
1,1KW-4A
400V-3000rpm
M 3 ~

OPERATOR SIDE SHEET
SUPPORT ROTATION 2°
CHOICE STACKER

MOTOR SIDE SHEET
SUPPORT ROTATION 2°
CHOICE STACKER

⇦247
251⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: o.s. and m.s. sheet support rotation 2° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	249
Revision		Replacement of	Replaced by			Group:	Of 414

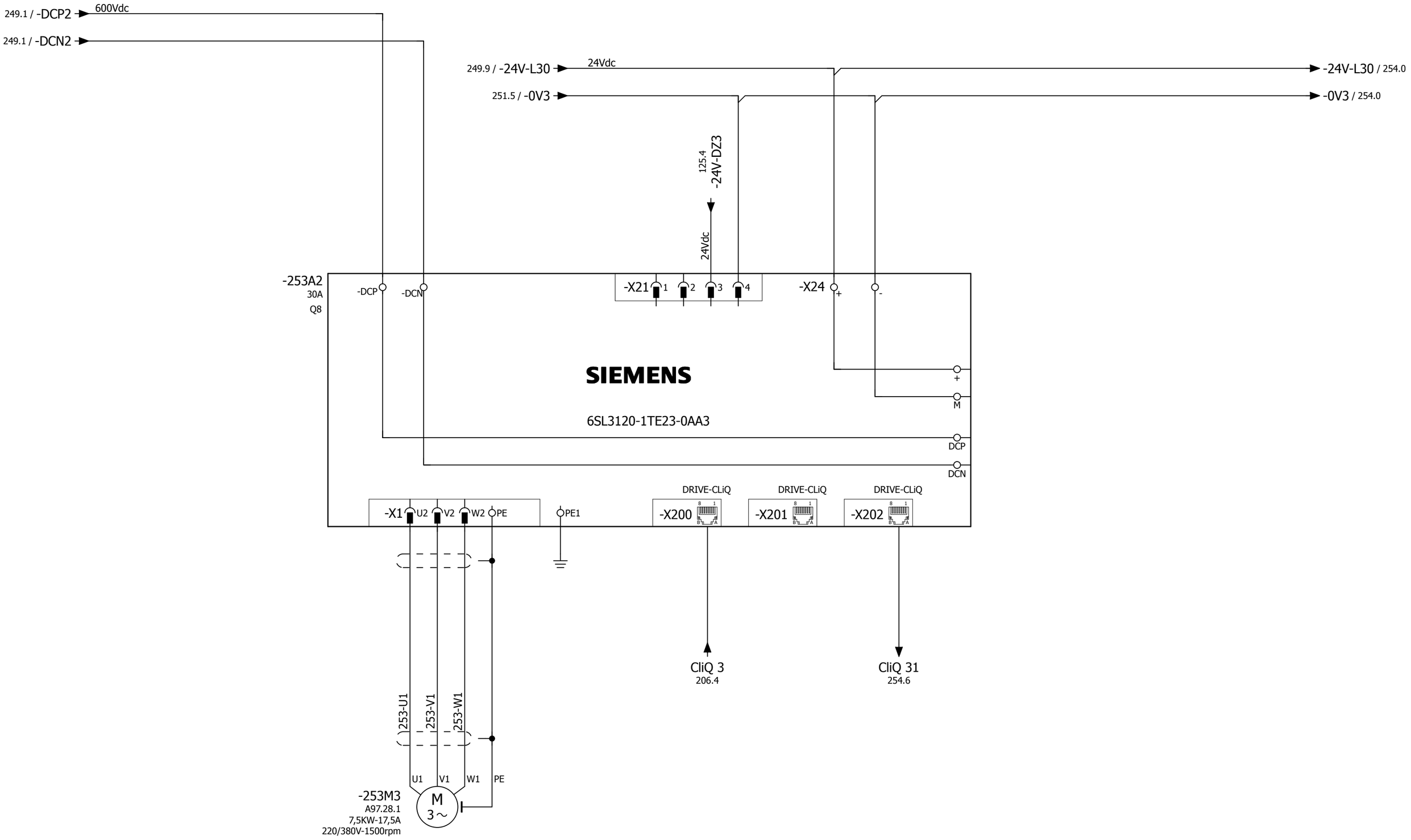


PACKAGE FORMING ROLL
2° CHOICE STACKER

⇦249

253⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Package forming roll 2° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	251
Revision		Replacement of	Replaced by			Group:	Of 414



LOWER FEEDING PINCH
ROLL 1° CHOICE STACKER

⇦251

254⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Lower feeding pinch roll 1° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	253
Revision		Replacement of	Replaced by			Group:	Of 414

253.9 / -24V-L30 → 24Vdc → -24V-L30 / 256.0

253.9 / -0V3 → -0V3 / 255.6

253.6
CliQ 31

-254A1
Q8

-X524 + + M M

+24V

M

-X500

DRIVE-CLiQ

SIEMENS

6SL3055-0AA00-5CA2

OPE -X520

-X521 A A* B B* R R* CTRL M

-X531 P ENCODER M ENCODER -TEMP +TEMP CLOCK CLOCK* DATA DATA*

254-1 254-2 254-3 254-4 254-5 254-6 254-7 254-8

-254E2
A97.28.4

A A* B B* R R*

\+

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ENCODER HTL 1024S/R

PIN	ENC	WIRE	N.WIRES
	A	WH	254-1
	A+	YE	254-2
	B	WH	254-3
	B+	GN	254-4
	+	WH+RD	254-8
	0V	WH+GY	254-7
	SCH	SCH	SCH

LOWER FEEDING PINCH ROLL 1
CHOICE STACKER ENCODER

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Lower feeding pinch roll 1° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 254
Revision		Replacement of	Replaced by			Group:	Of 414

251.9 / -DCP2 → 600Vdc

251.9 / -DCN2 →

251.9 / -24V-L30 → 24Vdc → -24V-L30 / 263.4

251.9 / -0V3 → -0V3 / 263.4

254.9 / -0V3 → -0V3 / 256.0

125.4 -24V-DZ3 → 24Vdc

125.4 -24V-DZ3 → 24Vdc

256.7 CliQ 12

-255A0
9A
Q8

-DCP

-DCN

-X21 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X24 + -

SIEMENS

6SL3120-2TE21-0AA3

+
M
DCP
DCN

-X1 U2 V2 W2 PE

PE1

255-U1 255-V1 255-W1

U1 V1 W1 PE

-255M1
A97.28.20
2,29KW-5,6A
400V-3000rpm
M
3 ~

1° CHOICE STACKER
1° BOX OPERATOR
SIDE SHEET SUPPORT

9A

-X22 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X203

6SL3120-2TE21-0AA3

DRIVE-CLiQ DRIVE-CLiQ DRIVE-CLiQ

-X2 U2 V2 W2 PE

-X200 -X201 -X202

PE3

CliQ 1
207.3

CliQ 11
256.3

255-U2 255-V2 255-W2

U1 V1 W1 PE

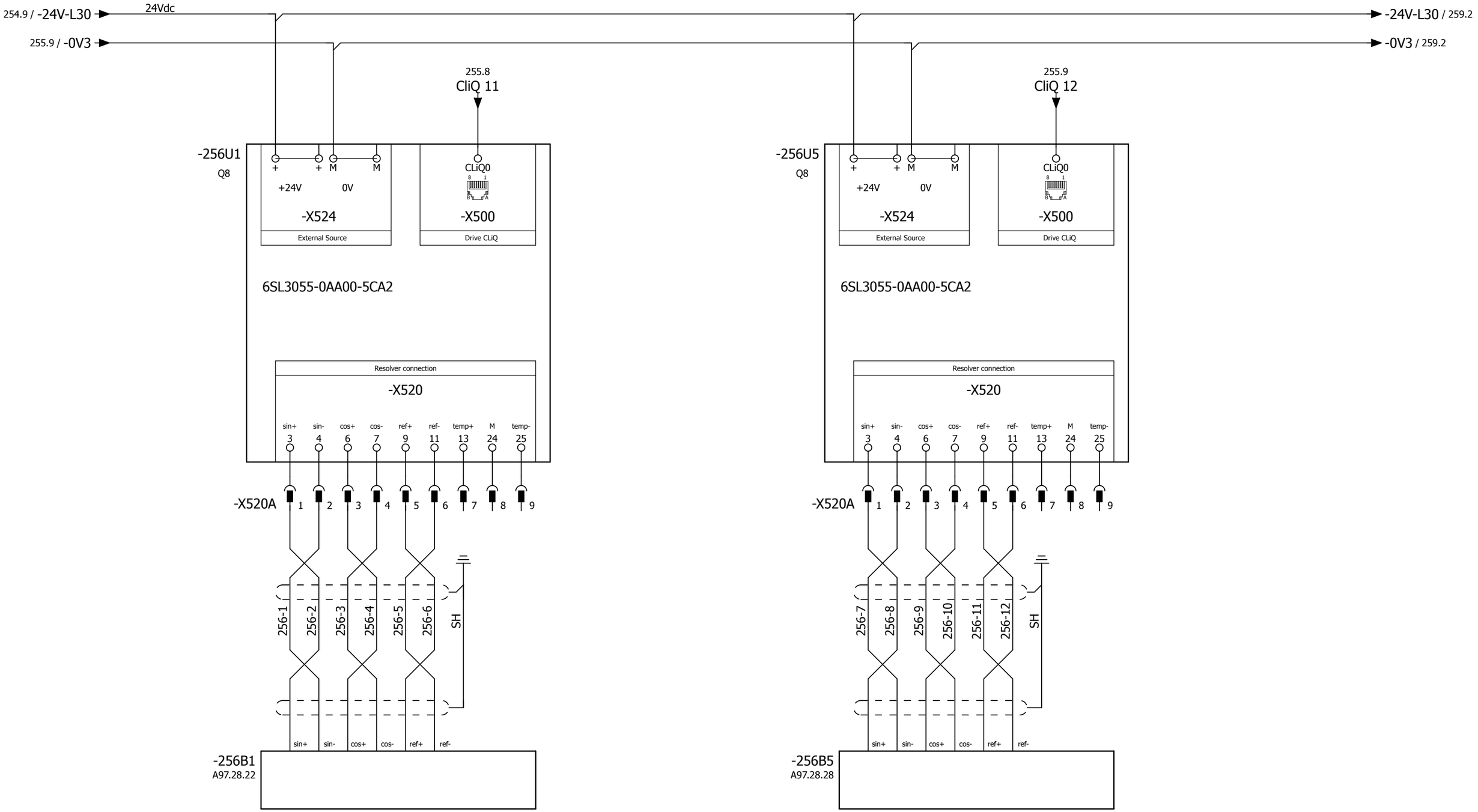
-255M6
A97.28.26
2,29KW-5,6A
400V-3000rpm
M
3 ~

1° CHOICE STACKER
1° BOX MOTOR
SIDE SHEET SUPPORT

⇦254

256⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: o.s. and m.s. sheet support 1° choice stacker 1° box motor		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	255
Revision			Replacement of / Replaced by			Group: / Of	414



OPERATOR SIDE SHEET
SUPPORT 1° CHOICE
STACKER 1° BOX RESOLVER

MOTOR SIDE SHEET
SUPPORT 1° CHOICE
STACKER 1° BOX RESOLVER

⇦255

259⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: o.s. and m.s. sheet support 1° choice stacker 1° box motor		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	256
Revision			Replacement of / Replaced by			Group: / Of	414

249.9 / -DCP → 600Vdc
249.9 / -DCN →
256.9 / -24V-L30 → 24Vdc
256.9 / -0V3 →

→ -DCP / 267.0
→ -DCN / 267.0
→ -24V-L30 / 263.2
→ -0V3 / 263.2

-259F1
80AgI
1 2 3 4

→ -DCP3 / 263.0
→ -DCN3 / 263.0
→ -DCP3 / 265.0
→ -DCN3 / 265.0

125.4 -24V-DZ3
24Vdc

125.4 -24V-DZ3
24Vdc

-259A0
9A
Q9

-DCP -DCN

-X21 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X24 + -

SIEMENS

6SL3120-2TE21-0AA3

+ M DCP DCN

DRIVE-CLiQ DRIVE-CLiQ

-X1 U2 V2 W2 PE

-X200 -X201 PE1

CliQ 2
210.4

9A

-X22 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X203

6SL3120-2TE21-0AA3

DRIVE-CLiQ

-X2 U2 V2 W2 PE

-X202 PE3

-259L1
259-11 259-12 259-13

-259L2
259-21 259-22 259-23

259-1
259-2
259-3

259-4
259-5
259-6

-259F2
1,8-2,5A
3RU1116-1CB1
1 3 5 97 95
2 4 6 98 96
259-U1 259-V1 259-W1
520.2
U1 V1 W1 PE

-259F3
1,8-2,5A
3RU1116-1CB1
1 3 5 97 95
2 4 6 98 96
259-U2 259-V2 259-W2
520.3
U1 V1 W1 PE

-259F4
1,8-2,5A
3RU1116-1CB1
1 3 5 97 95
2 4 6 98 96
259-U3 259-V3 259-W3
520.4
U1 V1 W1 PE

-259F5
1,8-2,5A
3RU1116-1CB1
1 3 5 97 95
2 4 6 98 96
259-U4 259-V4 259-W4
520.5
U1 V1 W1 PE

-259M1
A97.28.32
0,75KW-2,1A
220/380V-1500rpm
M 3~

-259M3
A97.28.34
0,75KW-2,1A
220/380V-1500rpm
M 3~

-259M6
A97.28.35
0,75KW-2,1A
220/380V-1500rpm
M 3~

-259M8
A97.28.37
0,75KW-2,1A
220/380V-1500rpm
M 3~

1° SHEET CONVEYOR
OPERATOR SIDE 1° CHOICE
STACKER FROM 1° BOX
TO 2° BOX

2° SHEET CONVEYOR
OPERATOR SIDE 1° CHOICE
STACKER FROM 1° BOX
TO 2° BOX

1° SHEET CONVEYOR
MOTOR SIDE 1° CHOICE
STACKER FROM 1° BOX
TO 2° BOX

2° SHEET CONVEYOR
MOTOR SIDE 1° CHOICE
STACKER FROM 1° BOX
TO 2° BOX

⇦256
263⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Sheet conveyor 1° choice stacker motors		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	259
Revision			Replacement of / Replaced by			Group:	Of 414

259.1 / -DCP3 → 600Vdc
259.1 / -DCN3 →

259.9 / -24V-L30 → 24Vdc
259.9 / -0V3 →

→ -24V-L30 / 264.0
→ -0V3 / 264.0

125.4 -24V-DZ3
24Vdc

→ -24V-L30 / 255.4
→ -0V3 / 255.4

264.7 CliQ 12

-263A0
9A
Q9

-DCP -DCN

-X21 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X24 + -

9A

-X22 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X203

SIEMENS

6SL3120-2TE21-0AA3

+ M DCP DCN

6SL3120-2TE21-0AA3

DRIVE-CLiQ DRIVE-CLiQ DRIVE-CLiQ

-X1 U2 V2 W2 PE

PE1

-X2 U2 V2 W2 PE

-X200 -X201 -X202

PE3

CliQ 0
208.3

CliQ 11
264.3

263-U1 263-V1 263-W1

U1 V1 W1 PE

-263M1
A97.28.86
2,29KW-5,6A
400V-3000rpm

M 3 ~

263-U2 263-V2 263-W2

U1 V1 W1 PE

-263M6
A97.28.92
2,29KW-5,6A
400V-3000rpm

M 3 ~

1° CHOICE STACKER
2° BOX OPERATOR
SIDE SHEET SUPPORT

1° CHOICE STACKER
2° BOX MOTOR
SIDE SHEET SUPPORT

⇦259

264⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: o.s. and m.s. sheet support 1° choice stacker 2° box motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	263
Revision		Replacement of	Replaced by			Group:	Of 414

263.9 / -24V-L30 → 24Vdc

263.9 / -0V3 →

→ -24V-L30 / 265.4

→ -0V3 / 265.4

263.8
CliQ 11

-264U1
Q9

+ + M M
+24V 0V
-X524
External Source

CLiQ0
-X500
Drive CLiQ

6SL3055-0AA00-5CA2

Resolver connection
-X520

sin+	sin-	cos+	cos-	ref+	ref-	temp+	M	temp-
3	4	6	7	9	11	13	24	25

-X520A 1 2 3 4 5 6 7 8 9

264-1 264-2 264-3 264-4 264-5 264-6 SH

sin+	sin-	cos+	cos-	ref+	ref-

-264B1
A97.28.88

OPERATOR SIDE SHEET
SUPPORT 1° CHOICE
STACKER 2° BOX RESOLVER

263.9
CliQ 12

-264U5
Q9

+ + M M
+24V 0V
-X524
External Source

CLiQ0
-X500
Drive CLiQ

6SL3055-0AA00-5CA2

Resolver connection
-X520

sin+	sin-	cos+	cos-	ref+	ref-	temp+	M	temp-
3	4	6	7	9	11	13	24	25

-X520A 1 2 3 4 5 6 7 8 9

264-7 264-8 264-9 264-10 264-11 264-12 SH

sin+	sin-	cos+	cos-	ref+	ref-

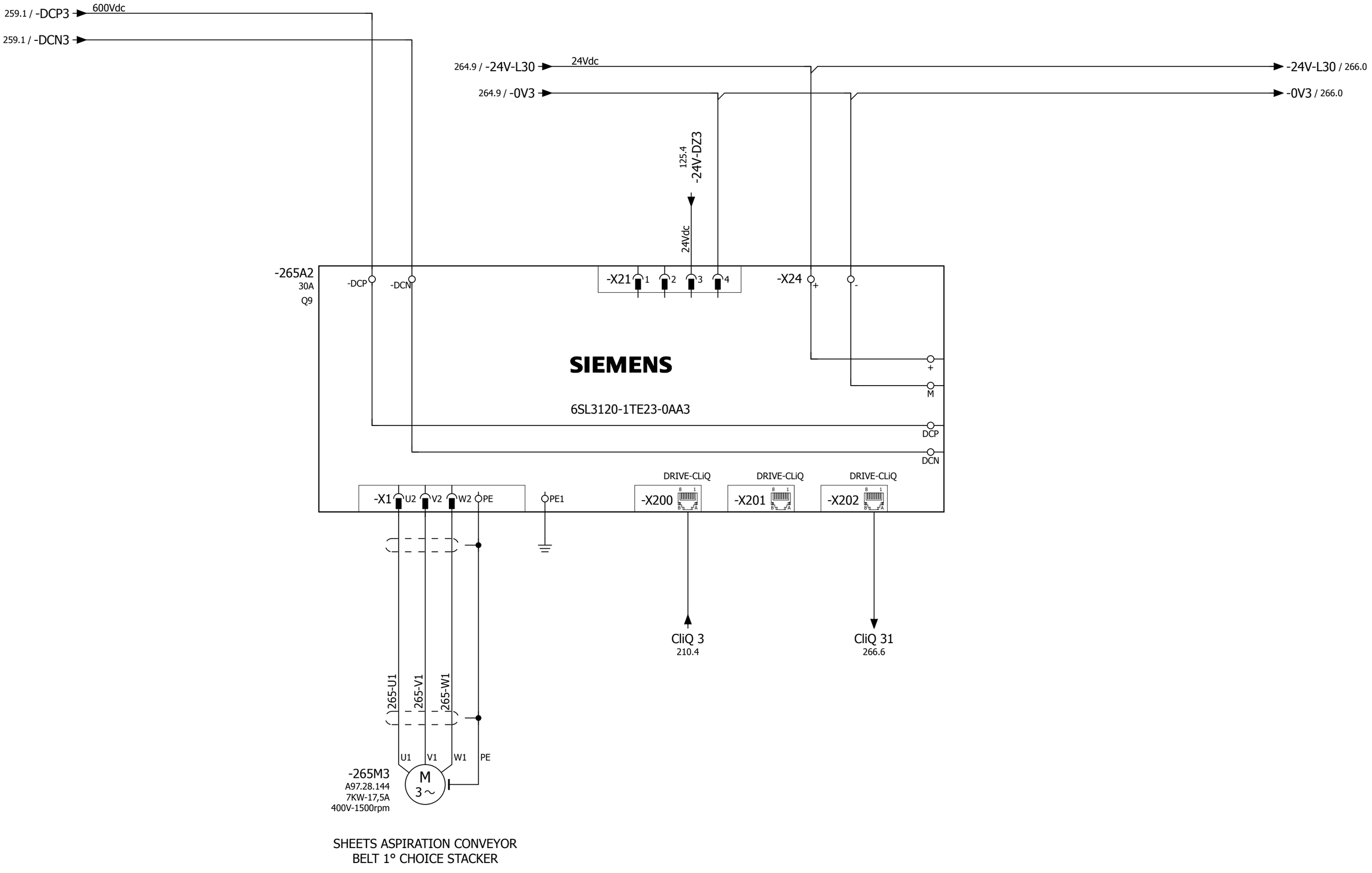
-264B5
A97.28.94

MOTOR SIDE SHEET
SUPPORT 1° CHOICE
STACKER 2° BOX RESOLVER

⇦263

265⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: o.s. and m.s. sheet support 1° choice stacker 2° box motor		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	264
Revision			Replacement of / Replaced by			Group: / Of	414

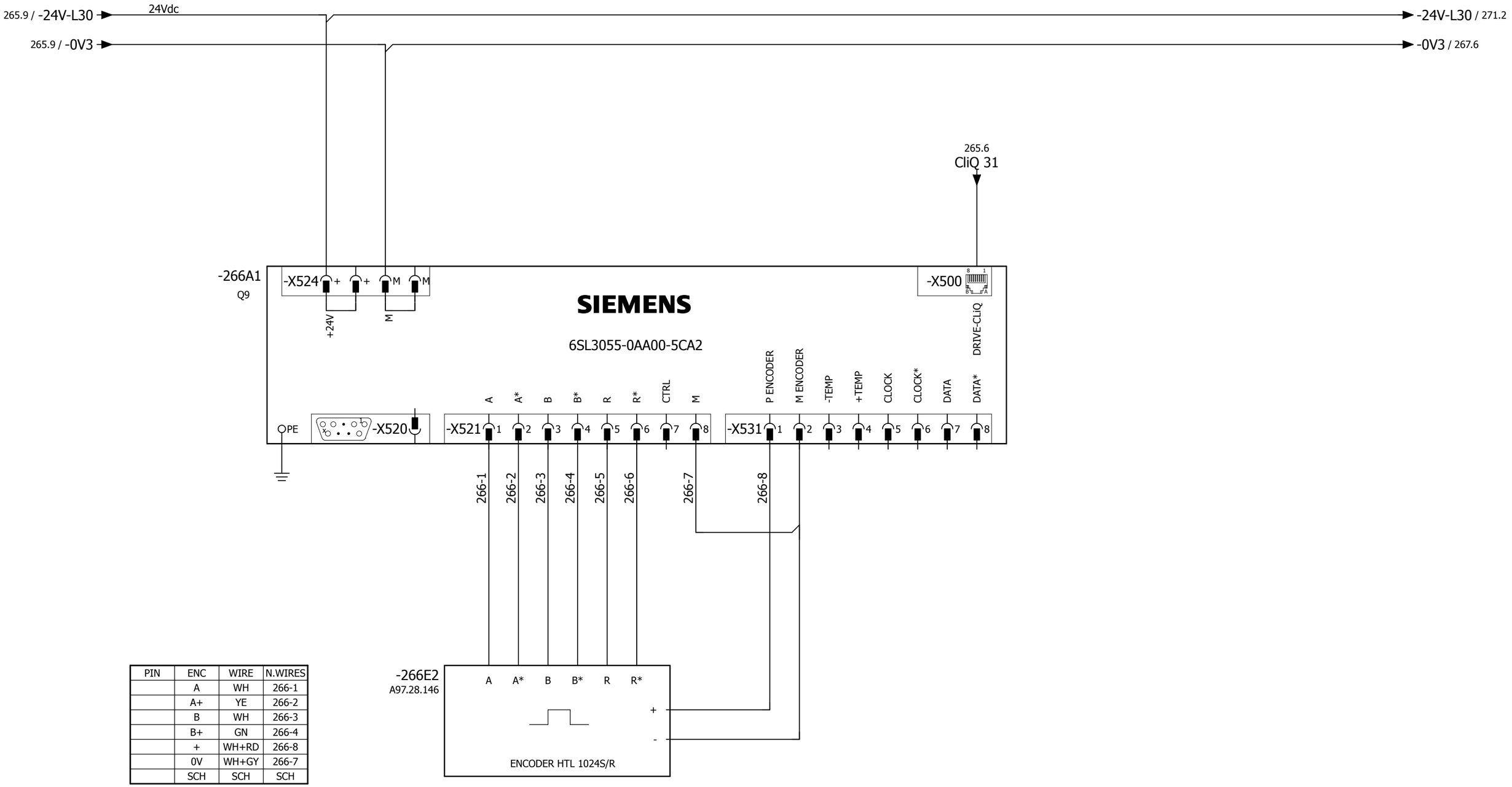


SHEETS ASPIRATION CONVEYOR
BELT 1° CHOICE STACKER

⇦264

266⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sheets aspiration conveyor belt 1° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	265
Revision		Replacement of	Replaced by			Group:	Of 414



PIN	ENC	WIRE	N.WIRES
	A	WH	266-1
	A+	YE	266-2
	B	WH	266-3
	B+	GN	266-4
	+	WH+RD	266-8
	0V	WH+GY	266-7
	SCH	SCH	SCH

SHEETS ASPIRATION
CONVEYOR BELT 1°
CHOICE STACKER ENCODER

⇦265

267⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Sheets aspiration conveyor belt 1° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 266
Revision		Replacement of	Replaced by			Group:	Of 414

259.9 / -DCP
259.9 / -DCN
/ -24V-L30
24Vdc
/ -0V3
266.9 / -0V3

-DCP / 275.0
-DCN / 275.0
-0V3 / 271.2

-267F1
80AgI
1 3 2 4

-DCP4 / 273.0
-DCN4 / 273.0
-DCP4 / 271.0
-DCN4 / 271.0

125.4 -24V-DZ3
24Vdc

-267A0
9A
Q9

-DCP
-DCN

-X21 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X24 + -

SIEMENS

6SL3120-2TE21-0AA3

+
M
DCP
DCN

-X1 U2 V2 W2 PE
PE1

267-U1 267-V1 267-W1
U1 V1 W1 PE

-267M1
A97.30.1
3KW-6,9A
220/380V-1500rpm
M 3~

PACKAGE TRANSLATION
ON 1 PACKAGE FORMING ROLL

9A

-X22 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X203

6SL3120-2TE21-0AA3

DRIVE-CLiQ DRIVE-CLiQ DRIVE-CLiQ
-X200 -X201 -X202

-X2 U2 V2 W2 PE
PE3

CliQ 0
211.3

267-U2 267-V2 267-W2
U1 V1 W1 PE

-267M6
A97.30.5
3KW-6,9A
220/380V-1500rpm
M 3~

PACKAGE TRANSLATION
ON 2 PACKAGE FORMING ROLL

⇦266
271⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Package translation on 1° and 2° package forming roll motor		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	267
Revision						Group:	Of 414

267.1 / -DCP4 → 600Vdc
267.1 / -DCN4 →
266.9 / -24V-L30 → 24Vdc
267.9 / -0V3 →
→ -24V-L30 / 273.2
→ -0V3 / 273.2

125.4 -24V-DZ3
24Vdc

-271A0
9A
Q9

-DCP
-DCN

-X21 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X24 + -

SIEMENS

6SL3120-2TE21-0AA3

+
M
DCP
DCN

-X1 U2 V2 W2 PE

PE1

271-U1 271-V1 271-W1

U1 V1 W1 PE

-271M1
A97.30.9
3KW-6,9A
220/380V-1500rpm

M
3 ~

PACKAGE TRANSLATION
ON 1 WEIGHING TRANSFER PLATFORM

9A

125.4 -24V-DZ3
24Vdc

-X22 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X203

6SL3120-2TE21-0AA3

DRIVE-CLiQ DRIVE-CLiQ DRIVE-CLiQ

-X2 U2 V2 W2 PE

-X200 -X201 -X202

PE3

CliQ 1
211.3

271-U2 271-V2 271-W2

U1 V1 W1 PE

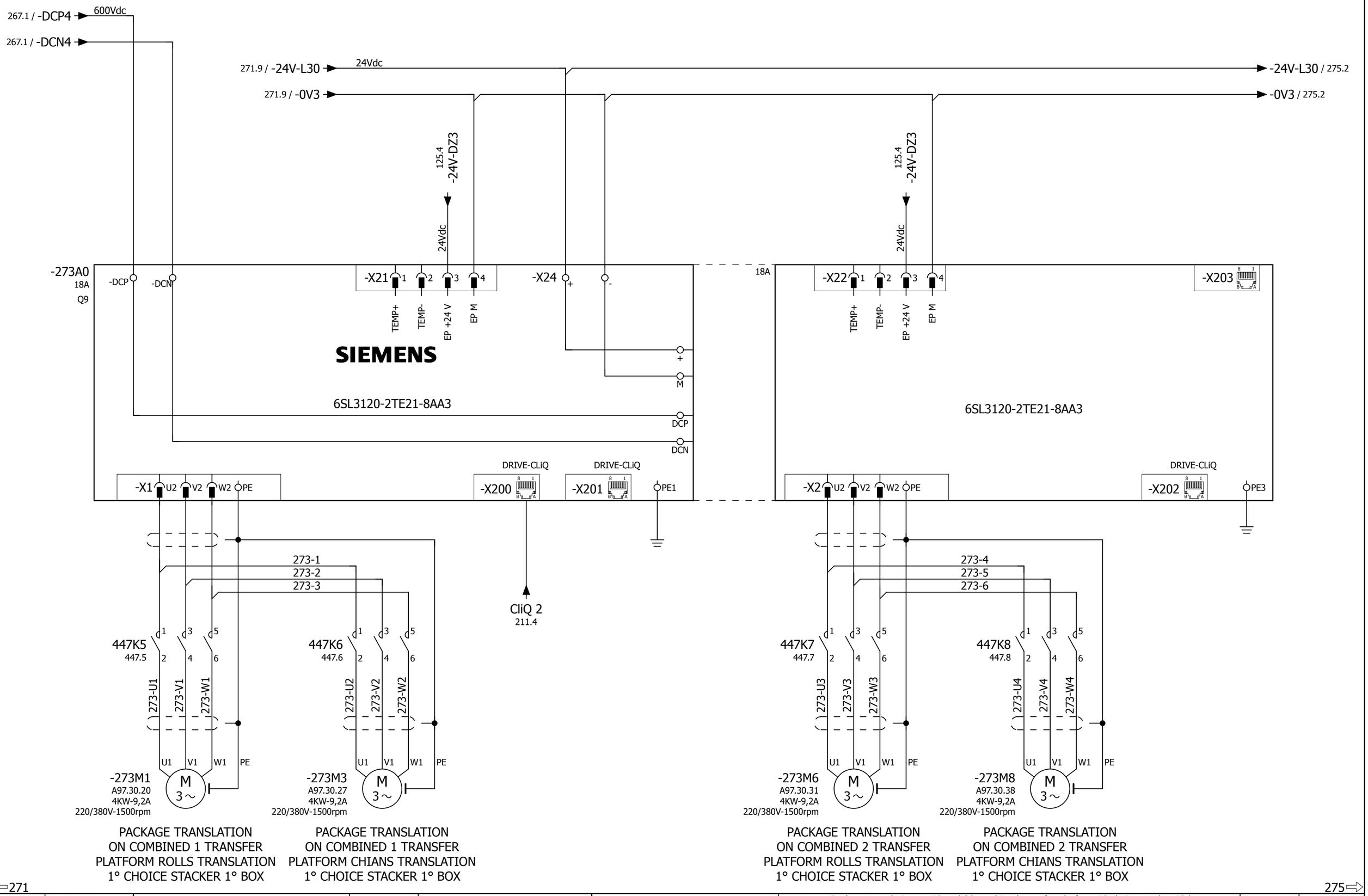
-271M6
A97.30.15
3KW-6,9A
220/380V-1500rpm

M
3 ~

PACKAGE TRANSLATION
ON 2 WEIGHING TRANSFER PLATFORM

⇦267
273⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Package translation on 1° and 2° weighing transfer platform		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	271
Revision						Group:	Of 414



PACKAGE TRANSLATION ON COMBINED 1 TRANSFER PLATFORM ROLLS TRANSLATION 1° CHOICE STACKER 1° BOX

PACKAGE TRANSLATION ON COMBINED 1 TRANSFER PLATFORM CHIANS TRANSLATION 1° CHOICE STACKER 1° BOX

PACKAGE TRANSLATION ON COMBINED 2 TRANSFER PLATFORM ROLLS TRANSLATION 1° CHOICE STACKER 1° BOX

PACKAGE TRANSLATION ON COMBINED 2 TRANSFER PLATFORM CHIANS TRANSLATION 1° CHOICE STACKER 1° BOX

⇦271

275⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Package translation on 1° and 2° combined transfer platform 1° choice stacker 1° box motors		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	273
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267.9 / -DCP → 600Vdc
267.9 / -DCN →
273.9 / -24V-L30 → 24Vdc
273.9 / -0V3 →

→ -DCP /
→ -DCN /
→ -24V-L30 / 277.2
→ -0V3 / 277.2

-275F1
50AgI
1 2 3 4

→ -DCP6 / 277.0
→ -DCN6 / 277.0

125.4 -24V-DZ3
24Vdc

-275A0
18A
Q9

-DCP -DCN

-X21 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X24 + -

SIEMENS

6SL3120-2TE21-8AA3

+ M DCP DCN

DRIVE-CLiQ DRIVE-CLiQ

-X200 -X201 PE1

-X1 U2 V2 W2 PE

CliQ 0
212.3

275-U1 275-V1 275-W1

U1 V1 W1 PE
-275M1
A97.30.42
4KW-9,2A
220/380V-1500rpm

PACKAGE TRANSLATION
ON 1 TRANSFER
PLATFORM CHIANS TRANSLATION
BEFORE STRAPPING MACHINE

18A

125.4 -24V-DZ3
24Vdc

-X22 1 2 3 4
TEMP+ TEMP- EP +24 V EP M

-X203

6SL3120-2TE21-8AA3

DRIVE-CLiQ

-X202 PE3

-X2 U2 V2 W2 PE

275-1
275-2
275-3

448K1
448.2
1 3 5
2 4 6
275-U2 275-V2 275-W2

U1 V1 W1 PE
-275M6
A97.30.50
4KW-9,2A
220/380V-1500rpm

PACKAGE TRANSLATION
ON COMBINED 1 TRANSFER
PLATFORM CHIANS TRANSLATION
AFTER STRAPPING MACHINE

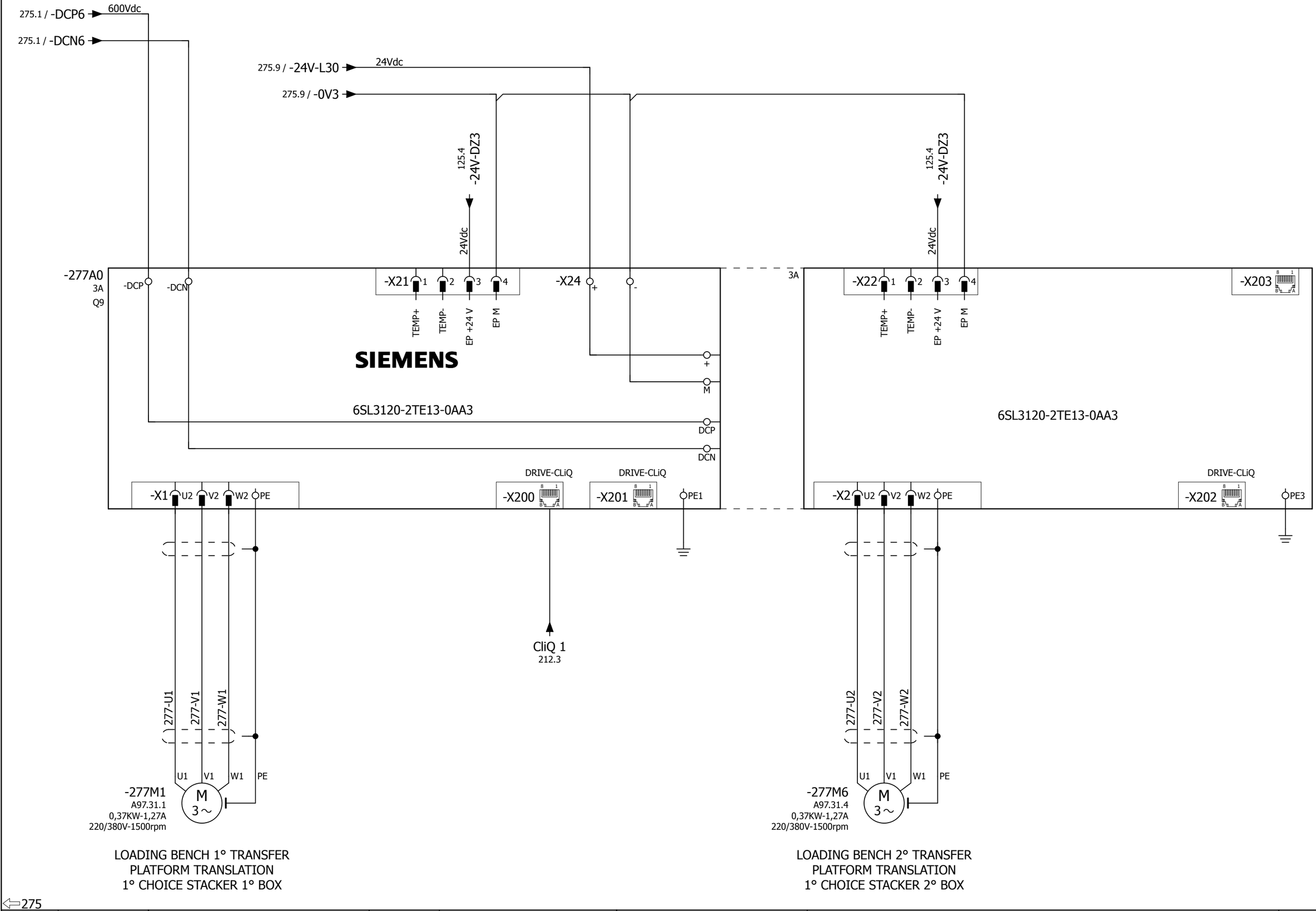
448K2
448.2
1 3 5
2 4 6
275-U3 275-V3 275-W3

U1 V1 W1 PE
-275M8
A97.30.57
4KW-9,2A
220/380V-1500rpm

PACKAGE TRANSLATION
ON COMBINED 1 TRANSFER
PLATFORM ROLLS TRANSLATION
AFTER STRAPPING MACHINE

⇦273
277⇨

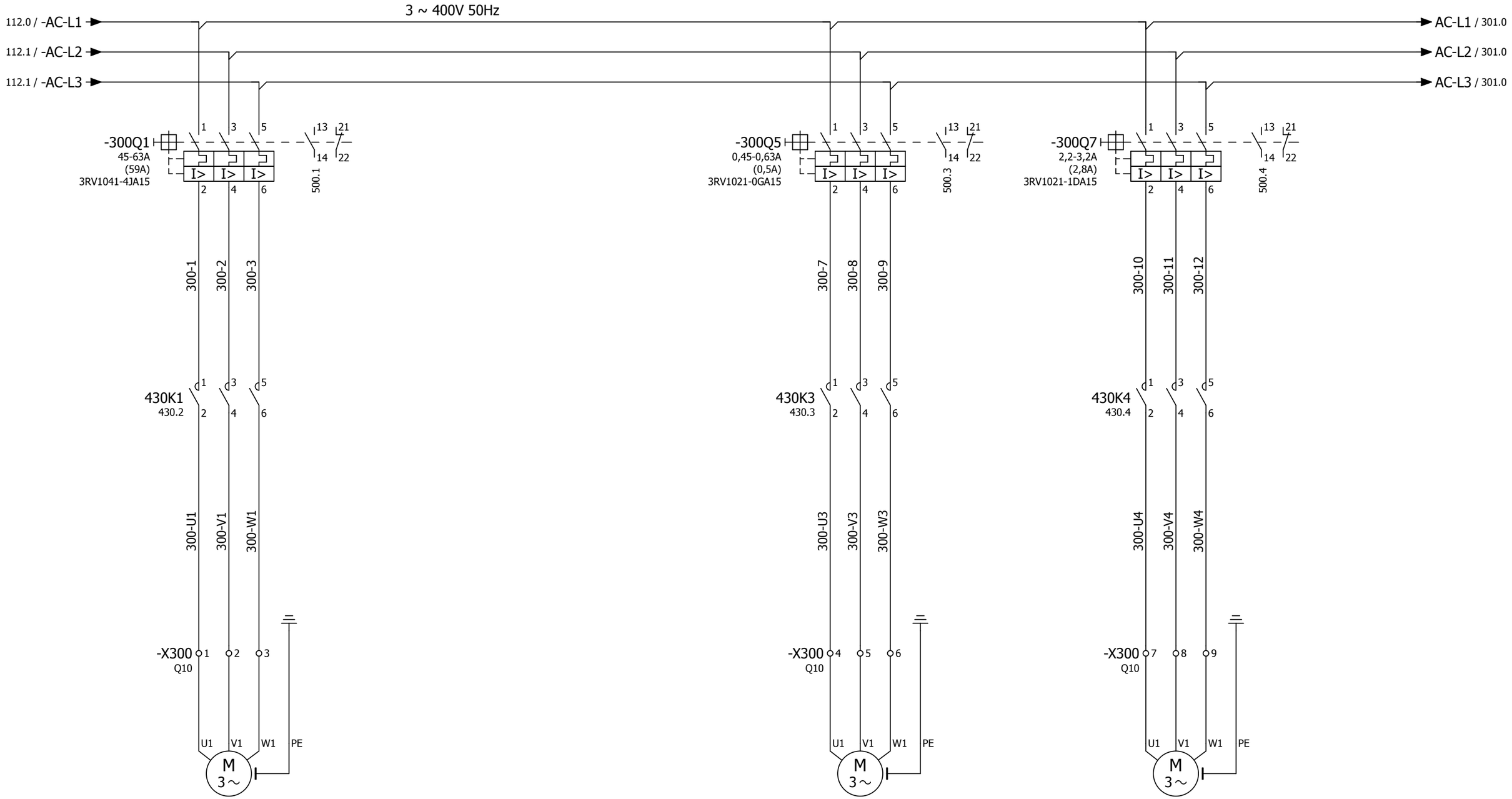
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Package translation on 1° combined transfer platform %2° choice stacker before and after strapping machine		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	275
Revision			Replacement of / Replaced by			Group: / Of	414



275

300

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 1° and 2° transfer platform translation 1° choice stacker 1° and 4%° box motors		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	277
Revision		Replacement of	Replaced by			Group:	Of 414



⇦277

301⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Line hydraulic unit motors		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	300
Revision		Replacement of	Replaced by			Group:	Of 414

300.9 / -AC-L1
300.9 / -AC-L2
300.9 / -AC-L3

3 ~ 400V 50Hz

AC-L1 / 302.0
AC-L2 / 302.0
AC-L3 / 302.0

-301Q5
1,8-2,5A
(2,1A)
3RV1021-1CA15

500.7

301-7
301-8
301-9

430K7
430.7

301-U3
301-V3
301-W3

-X301
Q13

U1 V1 W1 PE

M
3~

-301M5

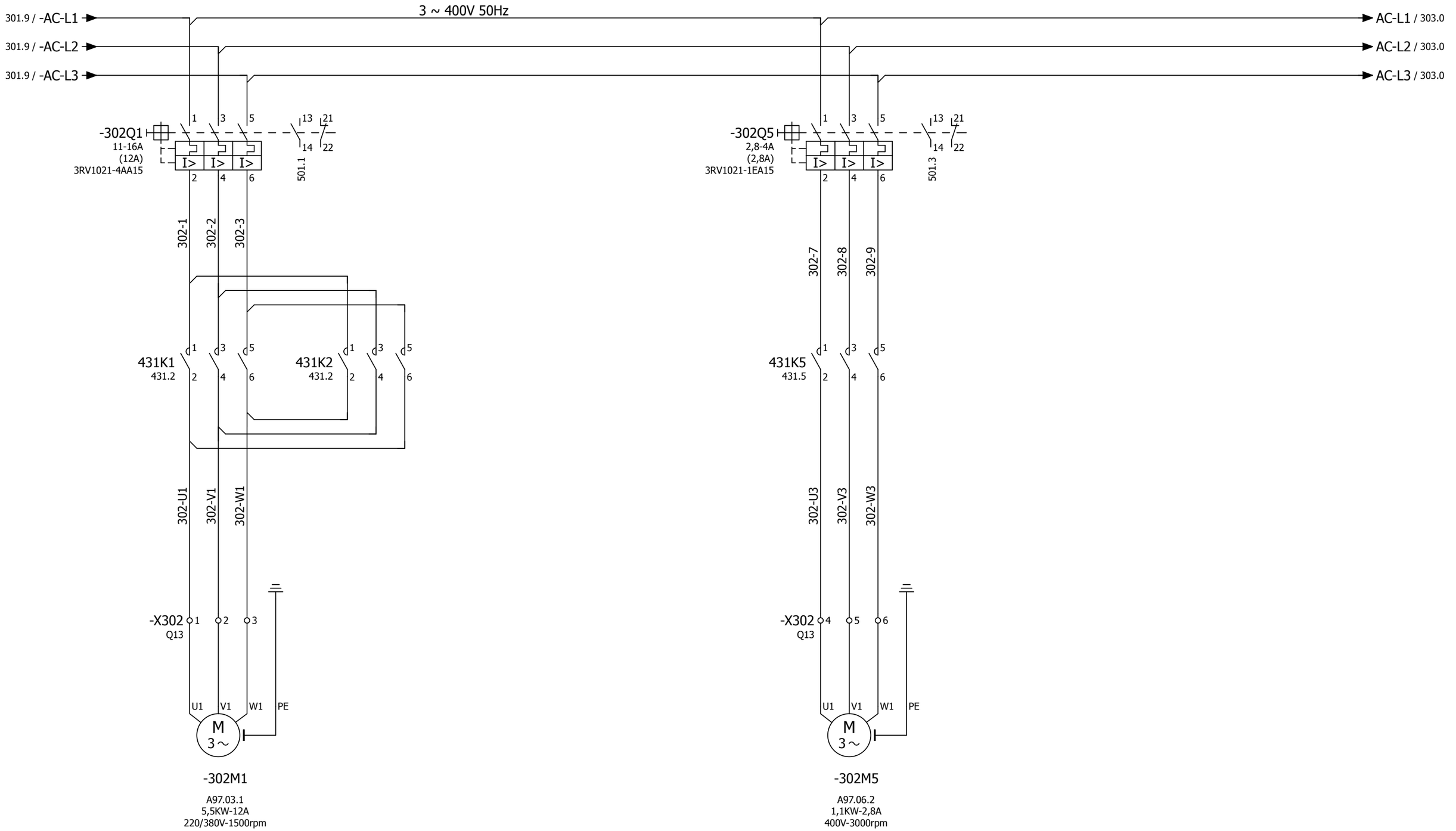
A97.06.10
0,75KW-2,1A
220/380V-1500rpm

UNCOILER OIL
LUBRICATION

⇦300

302⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Decoiler lubrication motor		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 301
Revision			Replacement of / Replaced by			Group:	Of 414



⇦301

303⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Paper winder and decoiler motor	=	
Drawing	13B01		Comm: A97			+	
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	302
Revision						Group: / Of	414

3 ~ 400V 50Hz

302.9 / -AC-L1
302.9 / -AC-L2
302.9 / -AC-L3

AC-L1 / 304.0
AC-L2 / 304.0
AC-L3 / 304.0

-303Q5
0,7-1A
(0,8A)
3RV1021-0JA15
501.7

-303Q7
2,8-4A
(2,8A)
3RV1021-1EA15
501.7

303-7 303-8 303-9
303-10 303-11 303-12

432K3
432.3
432K4
432.4

303-U3 303-V3 303-W3
303-U4 303-V4 303-W4

-X303
Q13

U1 V1 W1 PE
M
3 ~

-303M5

A97.10.2
0,29KW-0,8A
400V-3000rpm

STRAIGHTENER
ENTRY PINCH ROLL
COOLING MOTOR

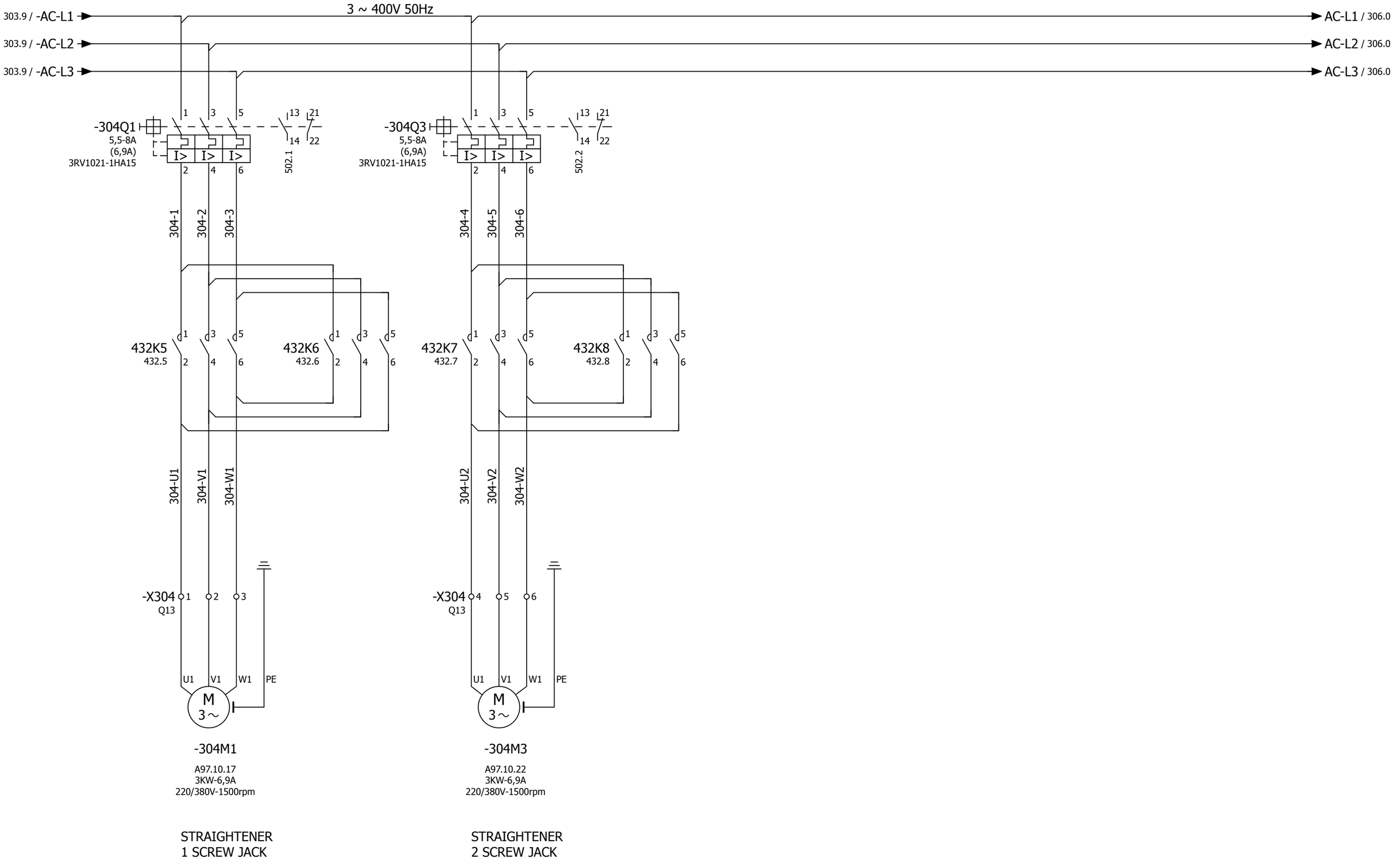
-303M7

A97.10.12
1,1KW-2,8A
400V-3000rpm

STRAIGHTENER
COOLING
MOTOR

⇦302
304⇨

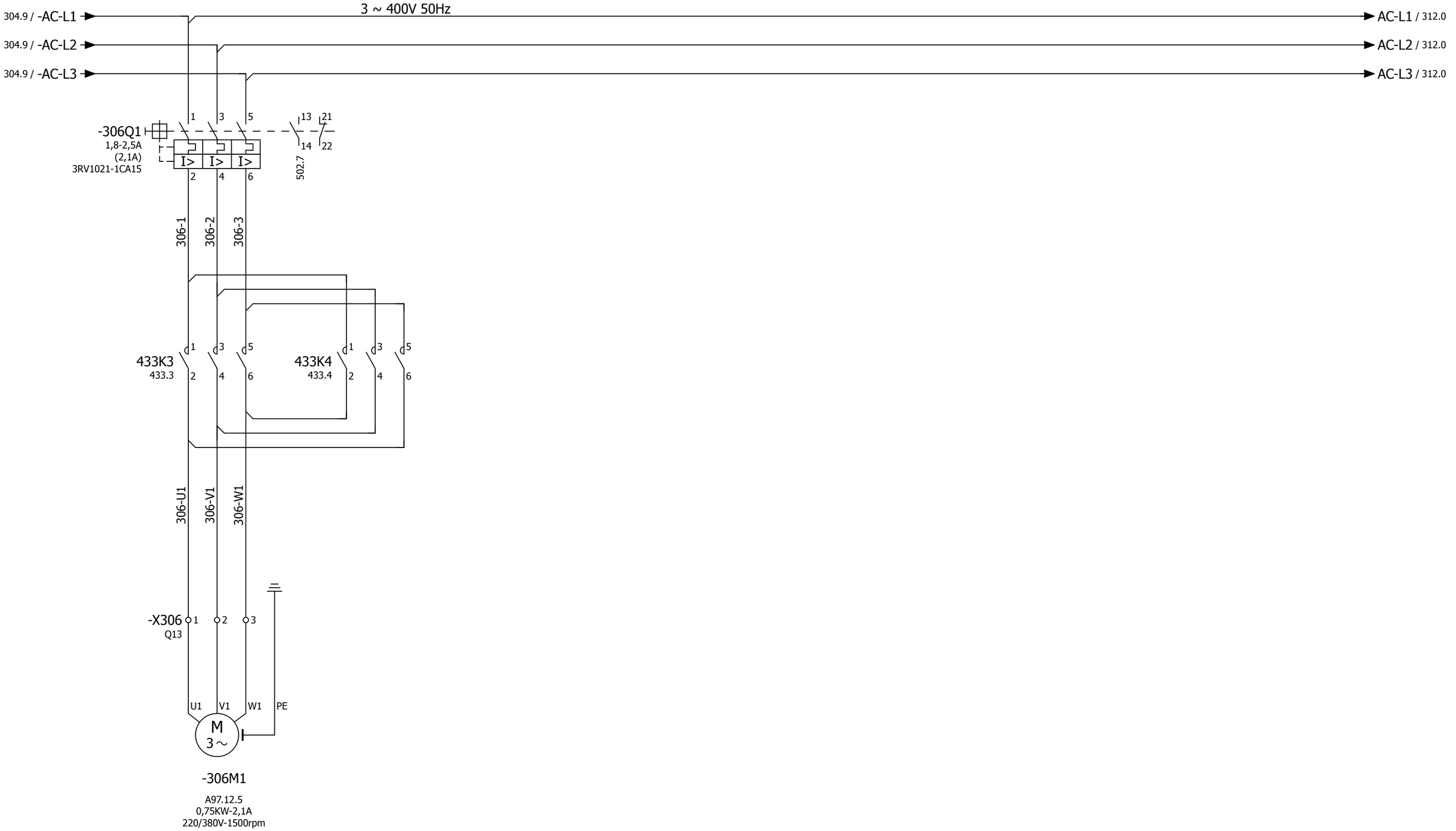
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Straightener cooling motors		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	303
Revision			Replacement of / Replaced by			Group: / Of	414



303

306

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Straightener screw jacks motors		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	304
Revision						Group: / Of	414



CROPPER SHEAR
BLADES CLEARANCE

⇦304

312⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cropper shear blades clearance motor		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	306
Revision						Group:	Of 414

3 ~ 400V 50Hz

306.9 / -AC-L1
306.9 / -AC-L2
306.9 / -AC-L3

AC-L1 / 313.0
AC-L2 / 313.0
AC-L3 / 313.0

-312Q1
2,2-3,2A
(2,55A)
3RV1021-1DA15
503.4

-312Q3
11-16A
(12A)
3RV1021-4AA15
503.5

-312Q5
11-16A
(12A)
3RV1021-4AA15
503.6

-312Q7
11-16A
(12A)
3RV1021-4AA15
503.7

312-1 312-2 312-3

312-4 312-5 312-6

312-7 312-8 312-9

312-10 312-11 312-12

433K7
433.7

434K1
434.2
434K2
434.2

434K3
434.3
434K4
434.4

434K5
434.5
434K6
434.6

312-U1 312-V1 312-W1

312-U2 312-V2 312-W2

312-U3 312-V3 312-W3

312-U4 312-V4 312-W4

-X312 Q12
1 2 3

-X312 Q12
4 5 6

-X312 Q12
7 8 9

-X312 Q12
10 11 12

U1 V1 W1 PE
M 3~

-312M1

A97.13.3
1,5KW-2,55A
220/380V-3000rpm

LEVELLER 1 COOLING
MOTOR

-312M3

A97.13.23
5,5KW-12A
400V-1500rpm

LEVELLER 1
SCREW JACK 1

-312M5

A97.13.28
5,5KW-12A
400V-1500rpm

LEVELLER 1
SCREW JACK 2

-312M7

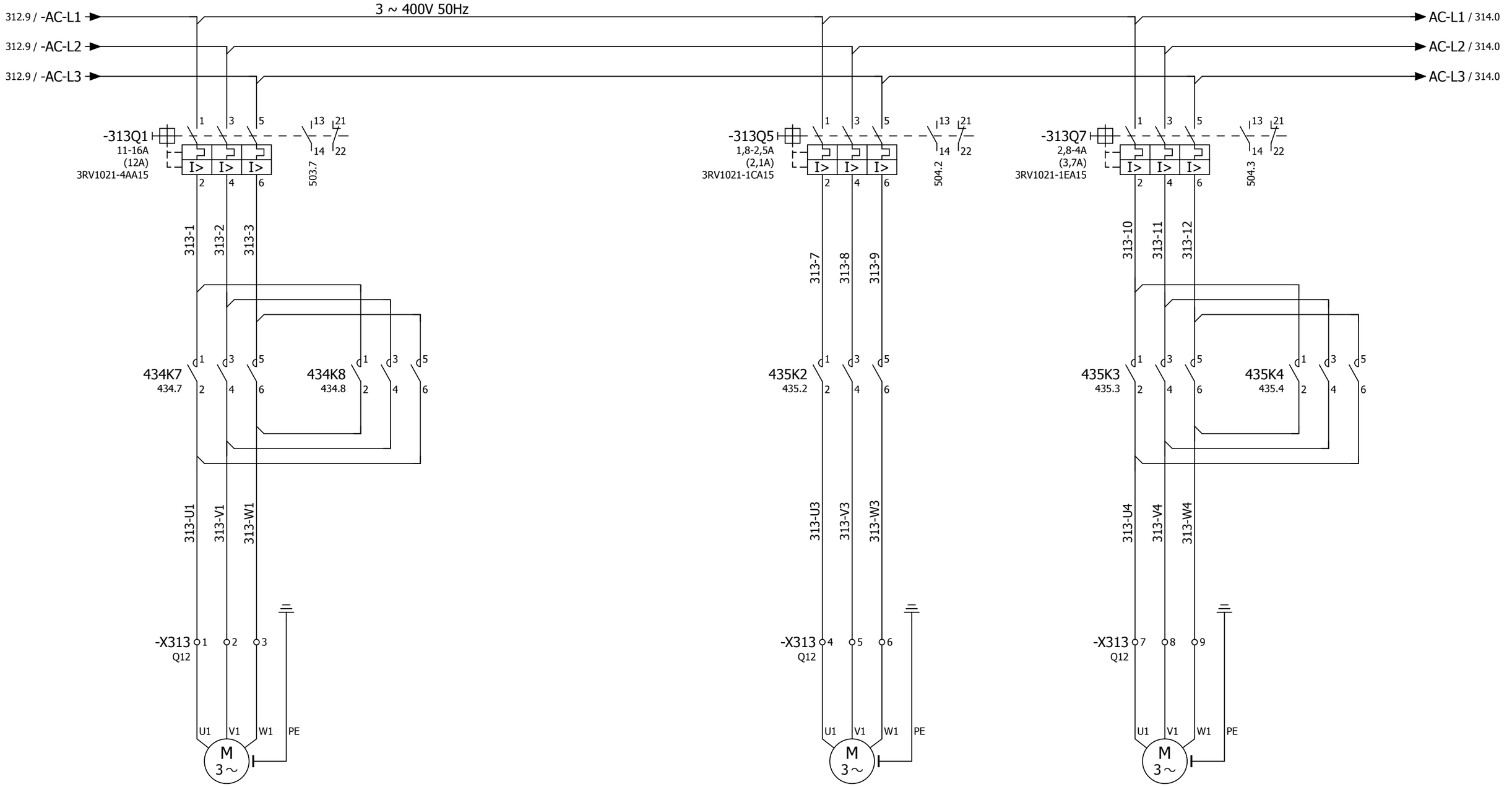
A97.13.31
5,5KW-12A
400V-1500rpm

LEVELLER 1
SCREW JACK 3

⇦306

313⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 motors		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	312
Revision			Replacement of / Replaced by			Group: / Of	414



-313M1

A97.13.34
5,5KW-12A
400V-1500rpm

LEVELLER 1
SCREW JACK 4

-313M5

A97.13.39
0,75KW-2,1A
220/380V-1500rpm

LEVELLER 1
SLIDING JOINTS
OIL LEVEL

-313M7

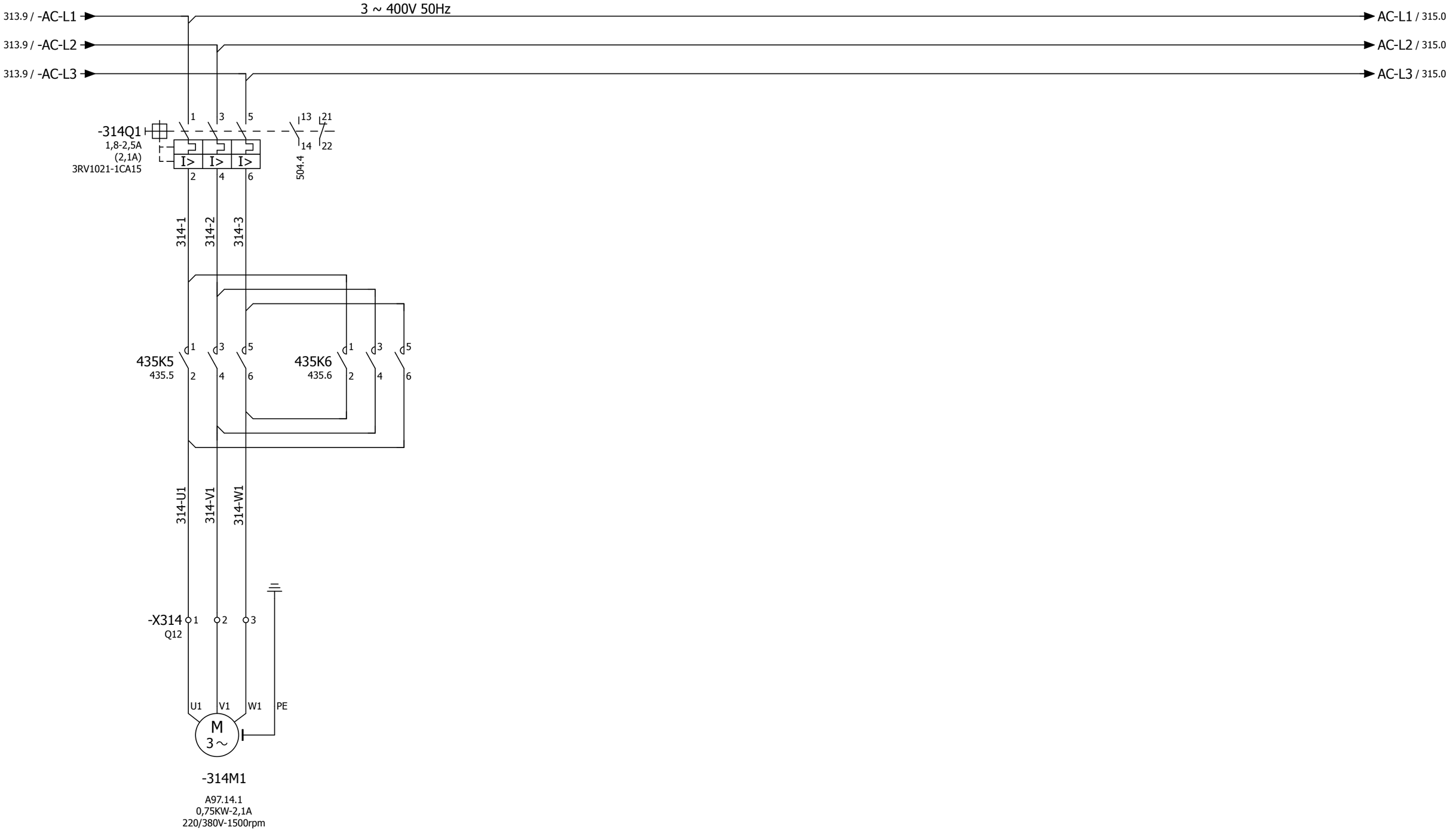
A97.15.1
1,5KW-3,7A
220/380V-1500rpm

LEVELLER 1
CLEANING WORK
ROLLS

⇦312

314⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 motors		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	313
Revision		Replacement of	Replaced by			Group:	Of 414



⇦313

315⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 bench motor	=	
Drawing	13B01		Comm: A97			+	
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	314
Revision						Group: / Of	414

3 ~ 400V 50Hz

314.9 / -AC-L1
314.9 / -AC-L2
314.9 / -AC-L3

AC-L1 / 316.0
AC-L2 / 316.0
AC-L3 / 316.0

-315Q1
2,2-3,2A
(2,55A)
3RV1021-1DA15
504.5

-315Q3
5,5-8A
(6,9A)
3RV1021-1HA15
504.6

-315Q5
5,5-8A
(6,9A)
3RV1021-1HA15
504.7

-315Q7
5,5-8A
(6,9A)
3RV1021-1HA15
504.7

315-1 315-2 315-3
315-4 315-5 315-6
315-7 315-8 315-9
315-10 315-11 315-12

436K1 436.2
436K2 436.2
436K3 436.3
436K4 436.4
436K5 436.5
436K6 436.6
436K7 436.7

315-U1 315-V1 315-W1
315-U2 315-V2 315-W2
315-U3 315-V3 315-W3
315-U4 315-V4 315-W4

-X315 Q12 1 2 3
-X315 Q12 4 5 6
-X315 Q12 7 8 9
-X315 Q12 10 11 12

U1 V1 W1 PE
M 3~

-315M1
A97.16.3
1,5KW-2,55A
220/380V-3000rpm
LEVELLER 2
COOLING
MOTOR

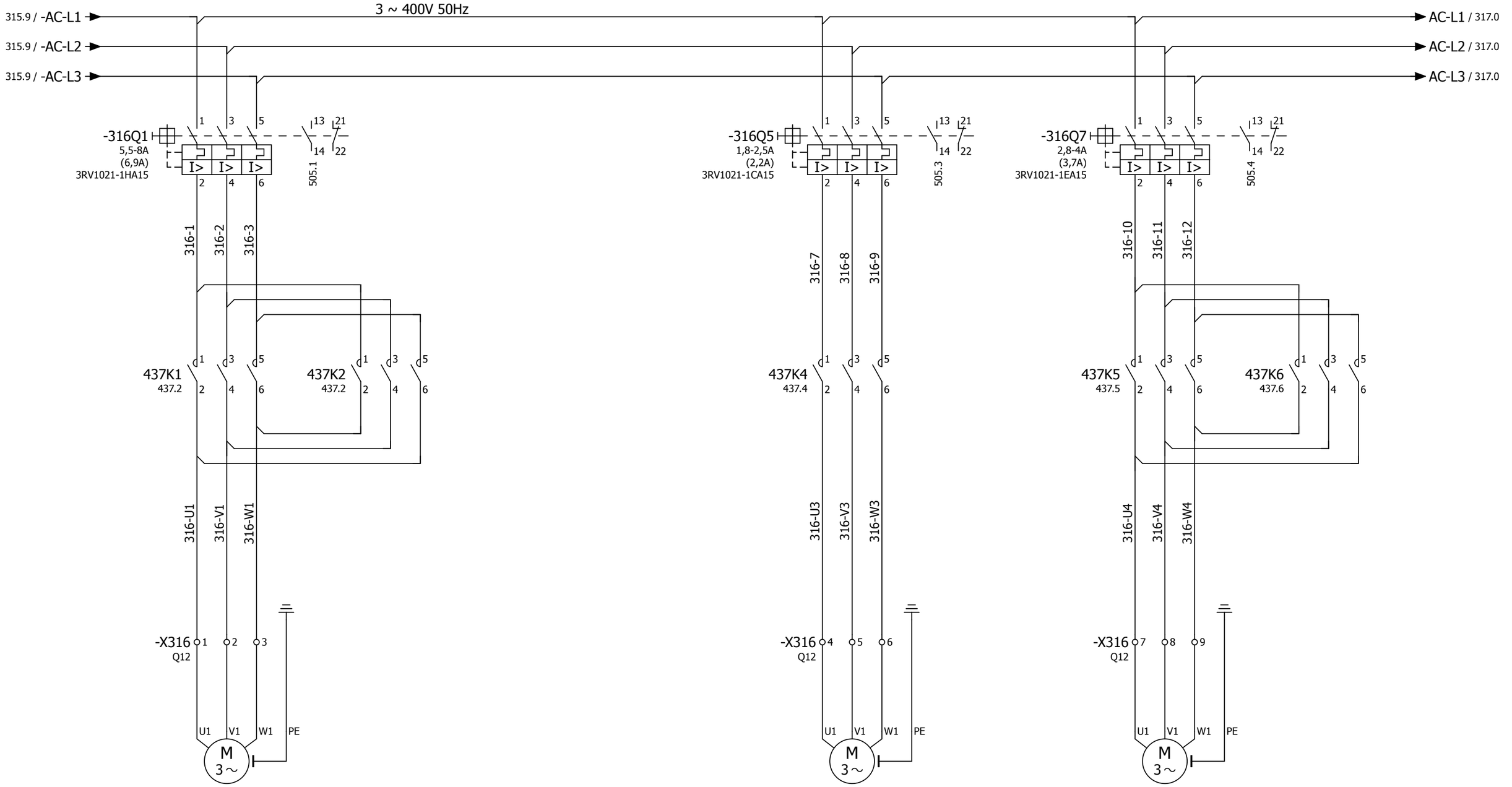
-315M3
A97.16.23
3KW-6,9A
230/400V-1500rpm
LEVELLER 2
SCREW JACK 1

-315M5
A97.16.28
3KW-6,9A
230/400V-1500rpm
LEVELLER 2
SCREW JACK 2

-315M7
A97.16.31
3KW-6,9A
230/400V-1500rpm
LEVELLER 2
SCREW JACK 3

⇦314
316⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 motors	=	
Drawing	13B01					+	
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	315
Revision		Replacement of	Replaced by			Group:	Of 414



⇦315

317⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 motors		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	316
Revision		Replacement of	Replaced by			Group:	Of 414

316.9 / -AC-L1 → 3 ~ 400V 50Hz → AC-L1 / 318.0

316.9 / -AC-L2 → AC-L2 / 318.0

316.9 / -AC-L3 → AC-L3 / 318.0

-317Q1
1,8-2,5A
(2,2A)
3RV1021-1CA15
1 3 5 13 21
I> I> I>
2 4 6 14 22
505.5

317-1 317-2 317-3

437K7
437.7
1 3 5
2 4 6

437K8
437.8
1 3 5
2 4 6

317-U1 317-V1 317-W1

-X317
Q12
1 2 3

U1 V1 W1 PE

M
3~

-317M1

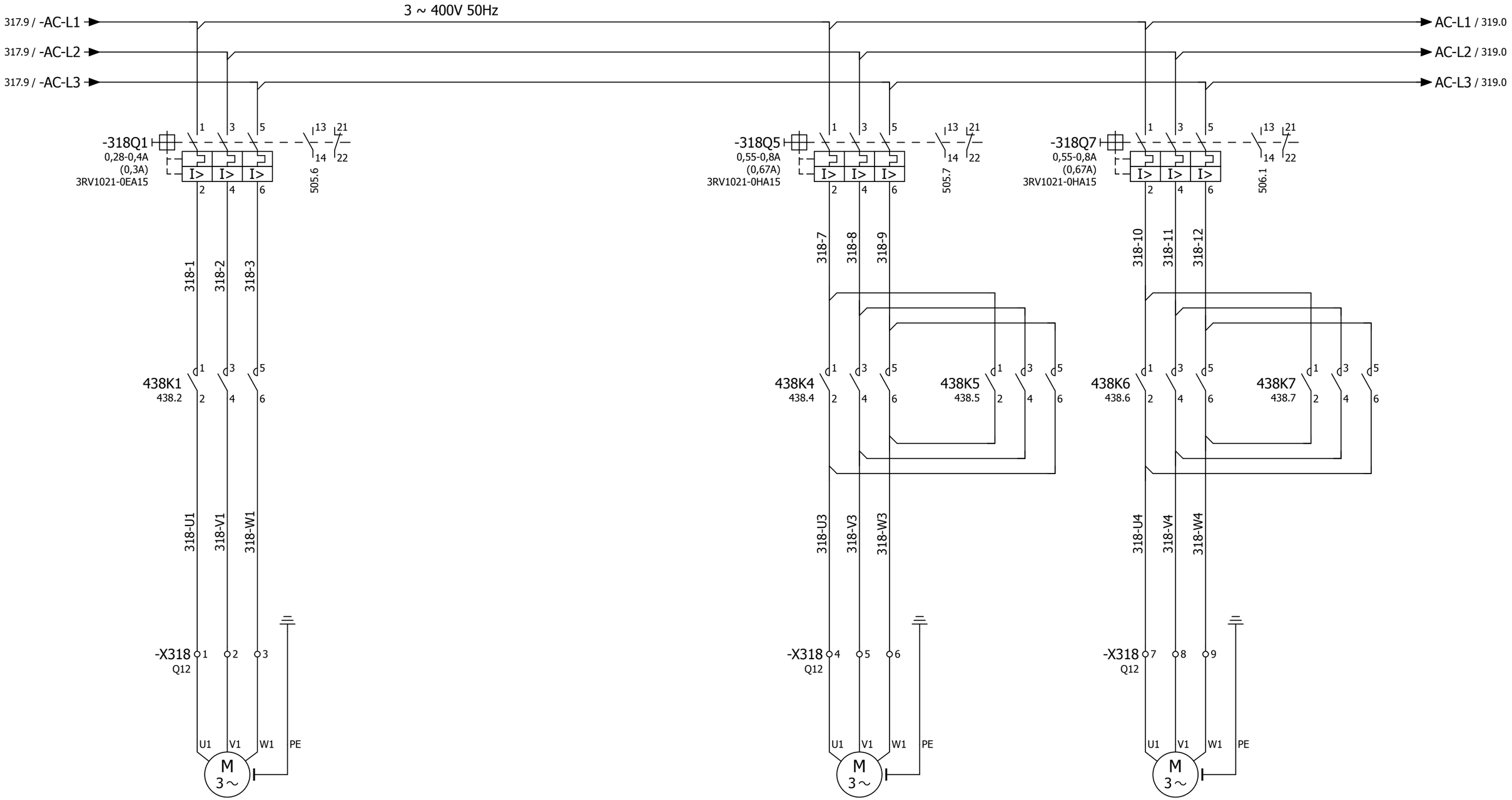
A97.18.1
0,75KW-2,2A
220/380V-1500rpm

LEVELLER 2
BENCH

⇦316

318⇨

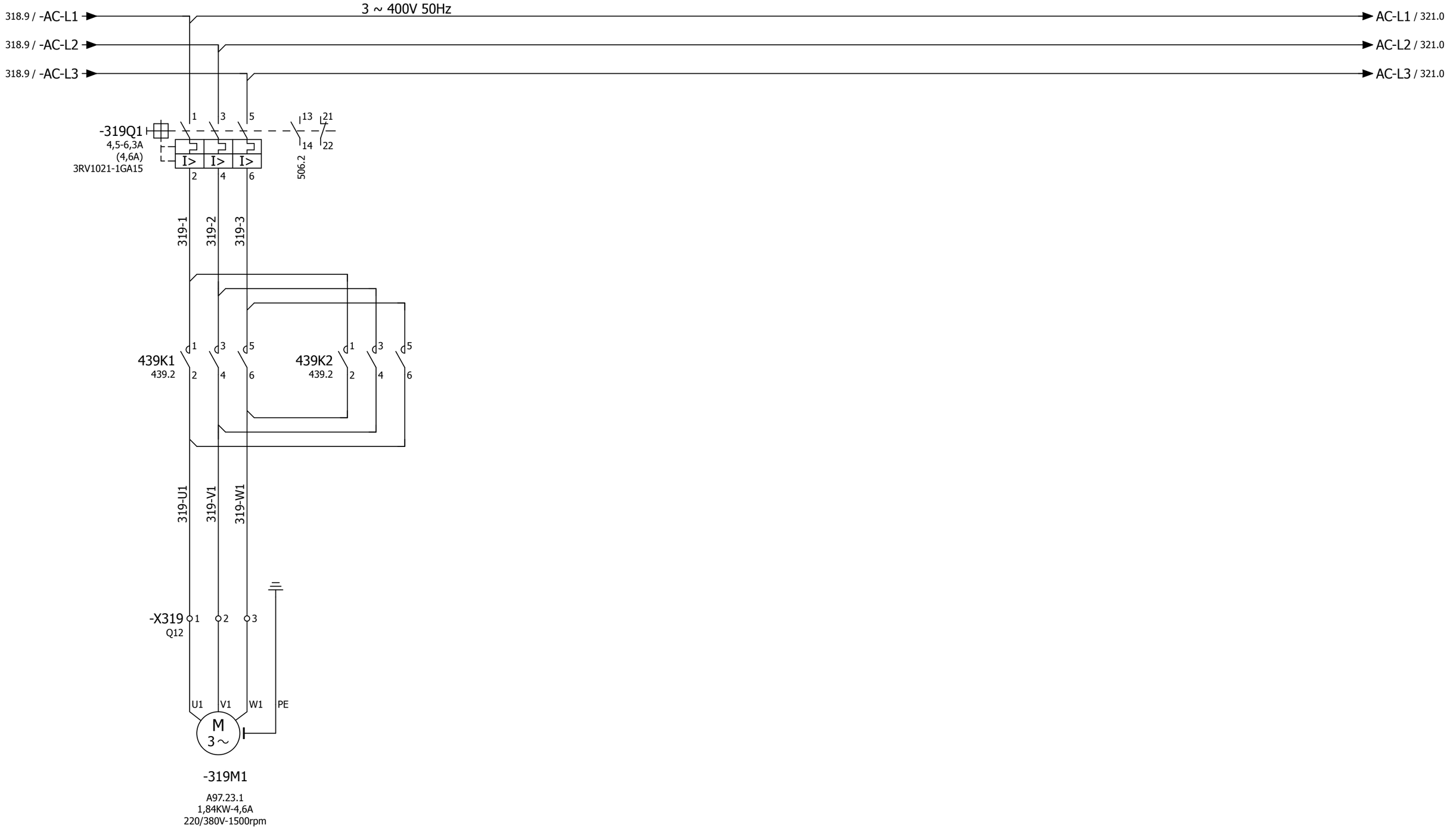
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Leveller 2 bench motor	=	
Drawing	13B01		Comm: A97			+	
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	317
Revision						Group:	Of 414



⇦317

319⇨

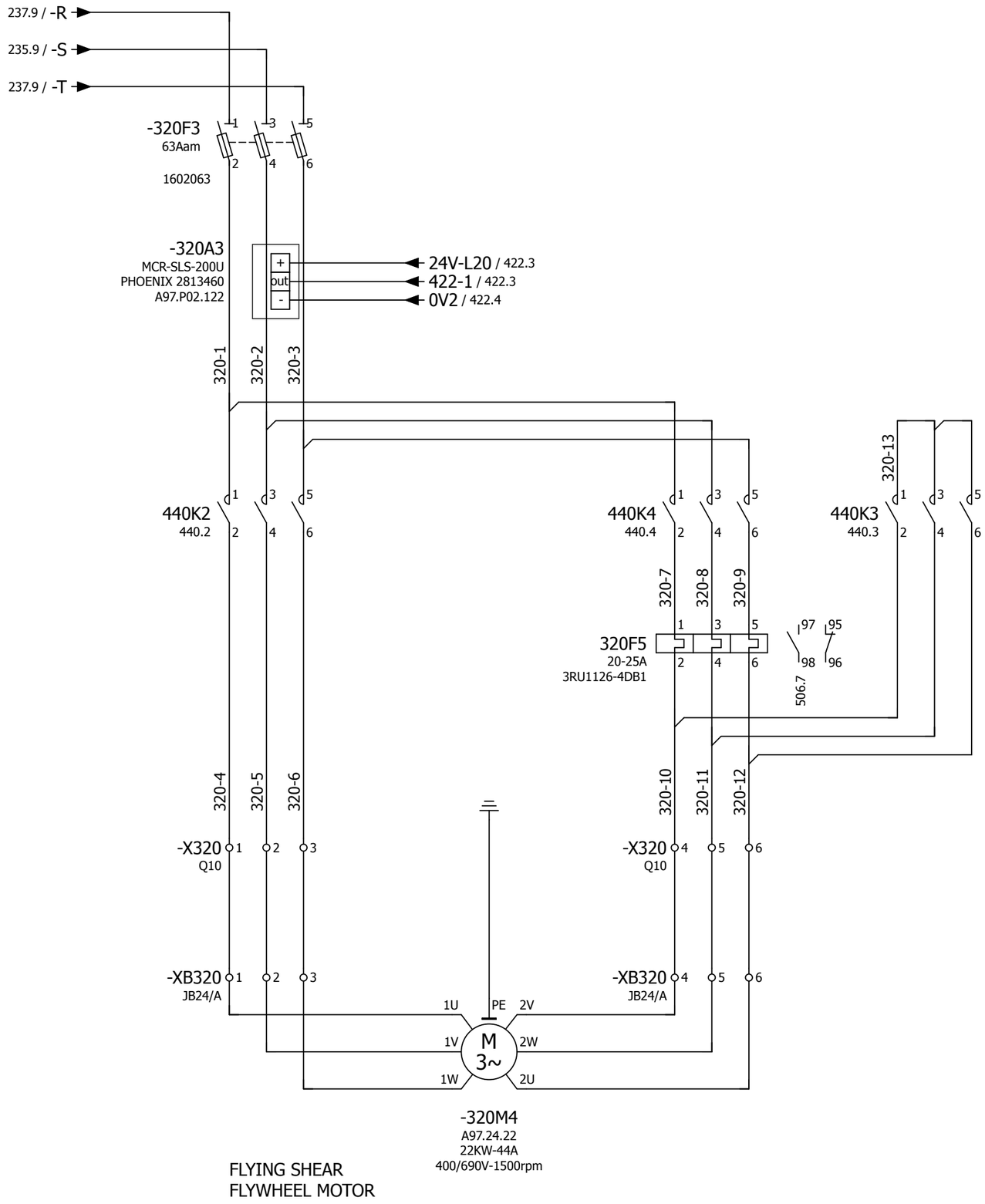
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Plasticizen device and rolls support motors		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	318
Revision		Replacement of	Replaced by			Group:	Of 414



⇦318

320⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Centering 2 motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	319
Revision		Replacement of	Replaced by			Group:	Of 414



⇦319

321⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Flying shear flywheel motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	320
Revision		Replacement of	Replaced by			Group:	Of 414

3 ~ 400V 50Hz

319.9 / -AC-L1
319.9 / -AC-L2
319.9 / -AC-L3

AC-L1 / 322.0
AC-L2 / 322.0
AC-L3 / 322.0

-321Q3
1,8-2,5A
(2,1A)
3RV1021-1CA15

507.1

321-4
321-5
321-6

440K6
440.6

440K7
440.7

321-U2
321-V2
321-W2

-X321
Q10

-XB321
JB24/A

U1 V1 W1 PE
M
3 ~

-321M3

A97.24.42
0,75KW-2,1A
220/380V-1500rpm

FLYING SHEAR BLADES
CLEARANCE

-321Q7
1,1-1,6A
(1,27A)
3RV1021-1AA15

507.3

321-10
321-11
321-12

441K3
441.3

441K4
441.4

321-U4
321-V4
321-W4

-X321
Q10

U1 V1 W1 PE
M
3 ~

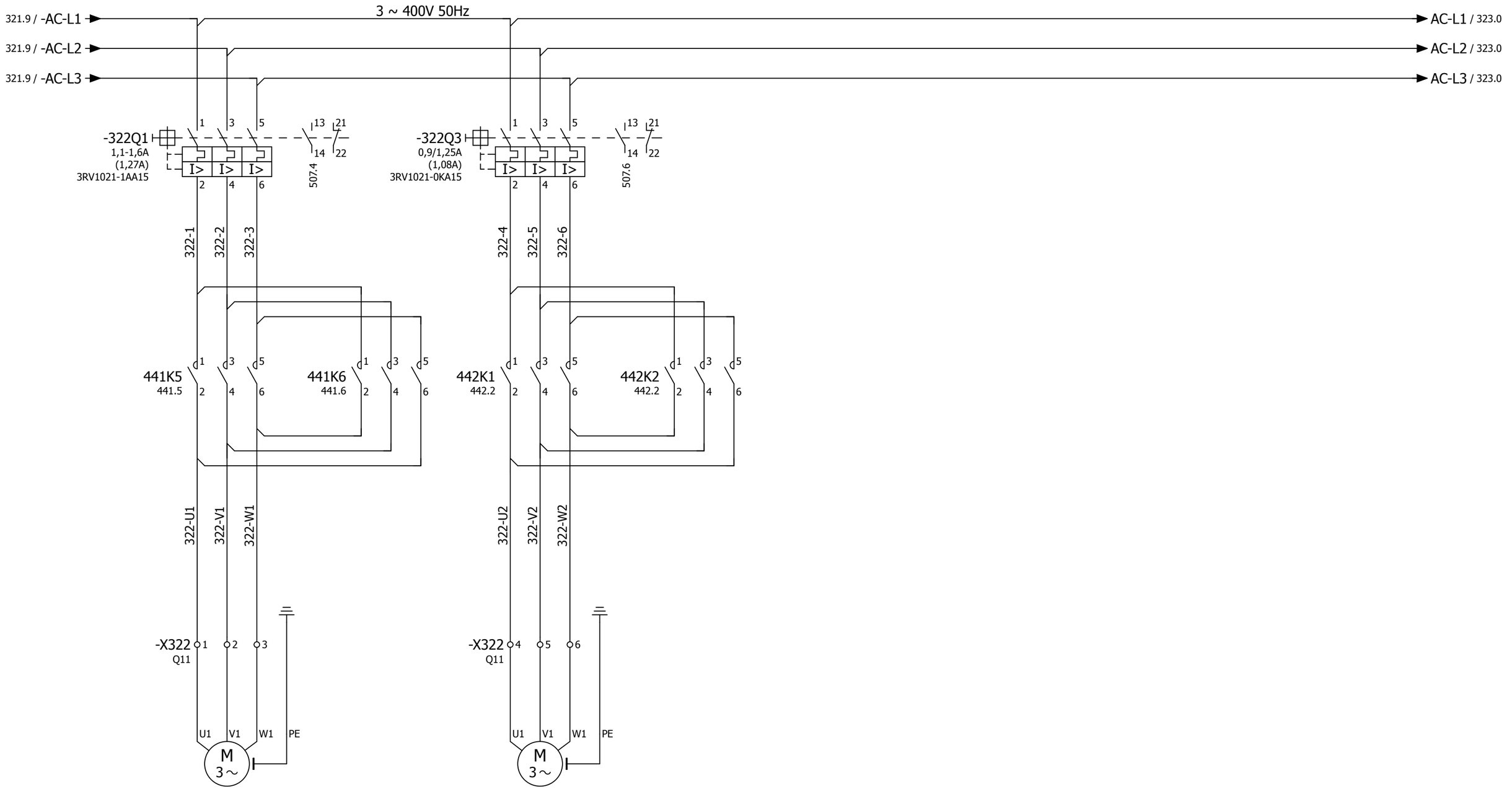
-321M7

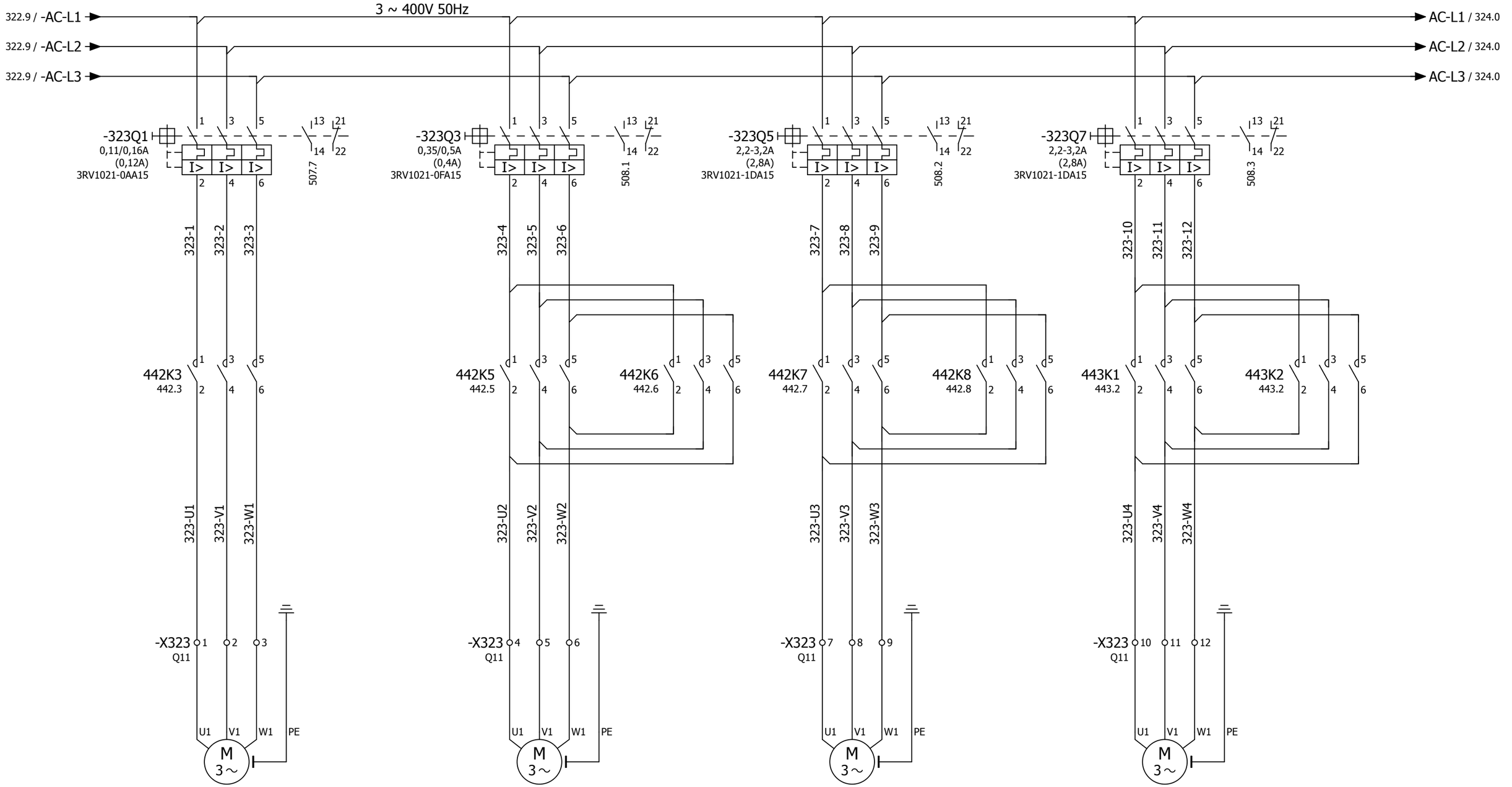
A97.26.1
0,37KW-1,27A
20/380V-1500rpm

SHEET SUPPORT BEAMS
OPERATOR SIDE
2° CHOICE STACKER

⇦320
322⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Blades clearance and 2° choice stacker motor	=	
Drawing	13B01					+	
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	321
Revision		Replacement of	Replaced by			Group:	Of 414


3 ~ 400V 50Hz
321.9 / -AC-L1
321.9 / -AC-L2
321.9 / -AC-L3
AC-L1 / 323.0
AC-L2 / 323.0
AC-L3 / 323.0
-322Q1
1,1-1,6A
(1,27A)
3RV1021-1AA15
507.4
-322Q3
0,9/1,25A
(1,08A)
3RV1021-0KA15
507.6
322-1
322-2
322-3
322-4
322-5
322-6
441K5
441.5
441K6
441.6
442K1
442.2
442K2
442.2
322-U1
322-V1
322-W1
322-U2
322-V2
322-W2
-X322
Q11
U1
V1
W1
PE
M
3~
-322M1
A97.26.6
0,37KW-1,27A
220/380V-1500rpm
SHEET SUPPORT BEAMS
MOTOR SIDE
2° CHOICE STACKER
-322M3
A97.26.21
0,37KW-1,08A
230/400V-3000rpm
HEAD MOBILE
CARRIAGE TRANSLATION
2° CHOICE STACKER



-323M1

A97.28.2
0,046KW-0,12A
400V-3000rpm

LOWER FEEDING
PINCH ROLL ROTATION
1° CHOICE STACKER
COOLING MOTOR

-323M3

A97.28.6
0,06KW-0,4A
220/380V-1500rpm

ENTRY 1° CHOICE STACKER
FEEDING
PINCH ROLL

-323M5

A97.28.10
1,1KW-2,8A
220/380V-1500rpm

SHEET SUPPORT BEAMS
HORIZONTAL TRANSALTION
ENTRY 1° CHOICE
STACKER

-323M7

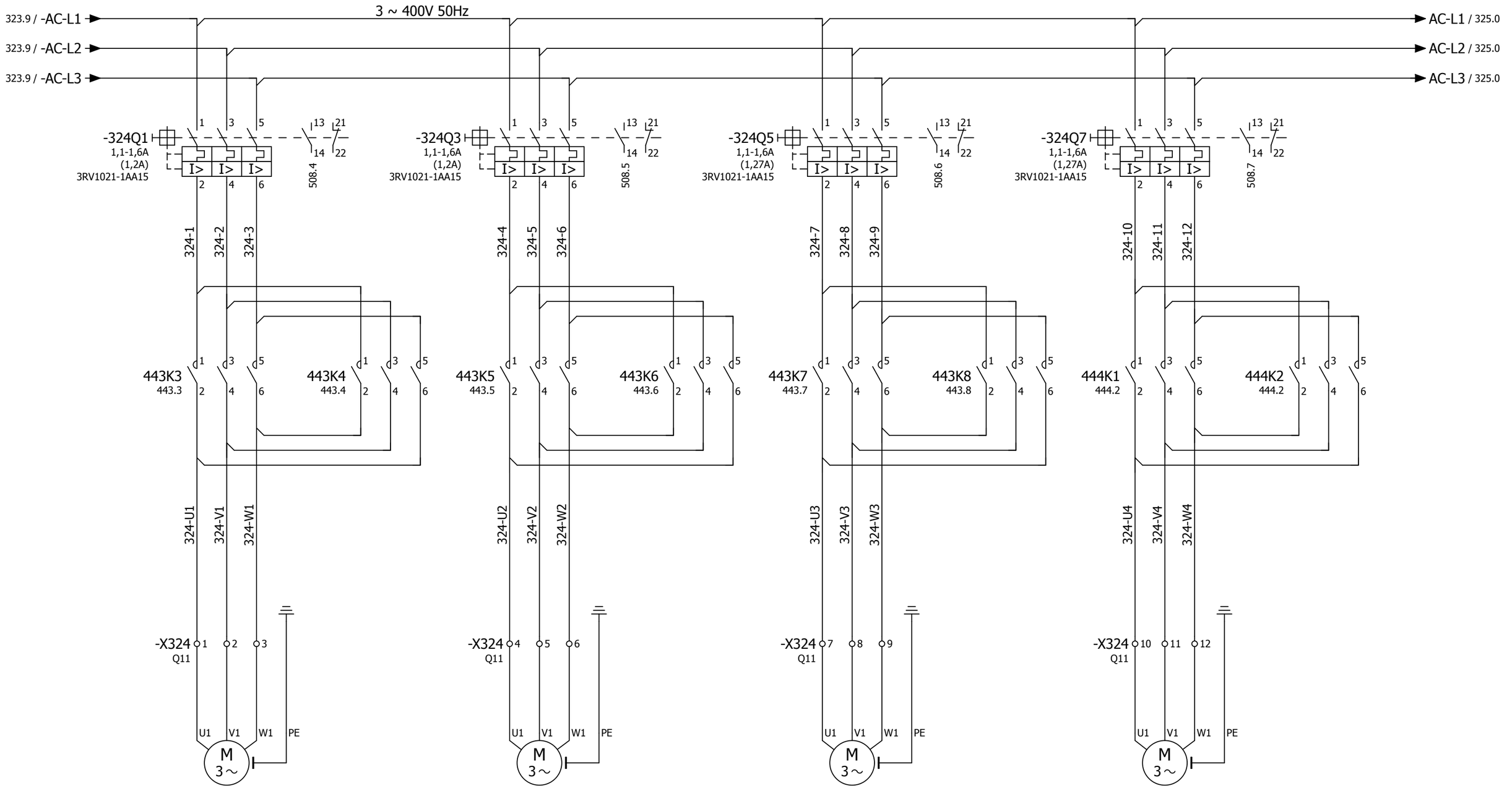
A97.28.15
1,1KW-2,8A
220/380V-1500rpm

SHEET SUPPORT BEAMS
HORIZONTAL TRANSALTION
EXIT 1° CHOICE
STACKER

⇦322

324⇨

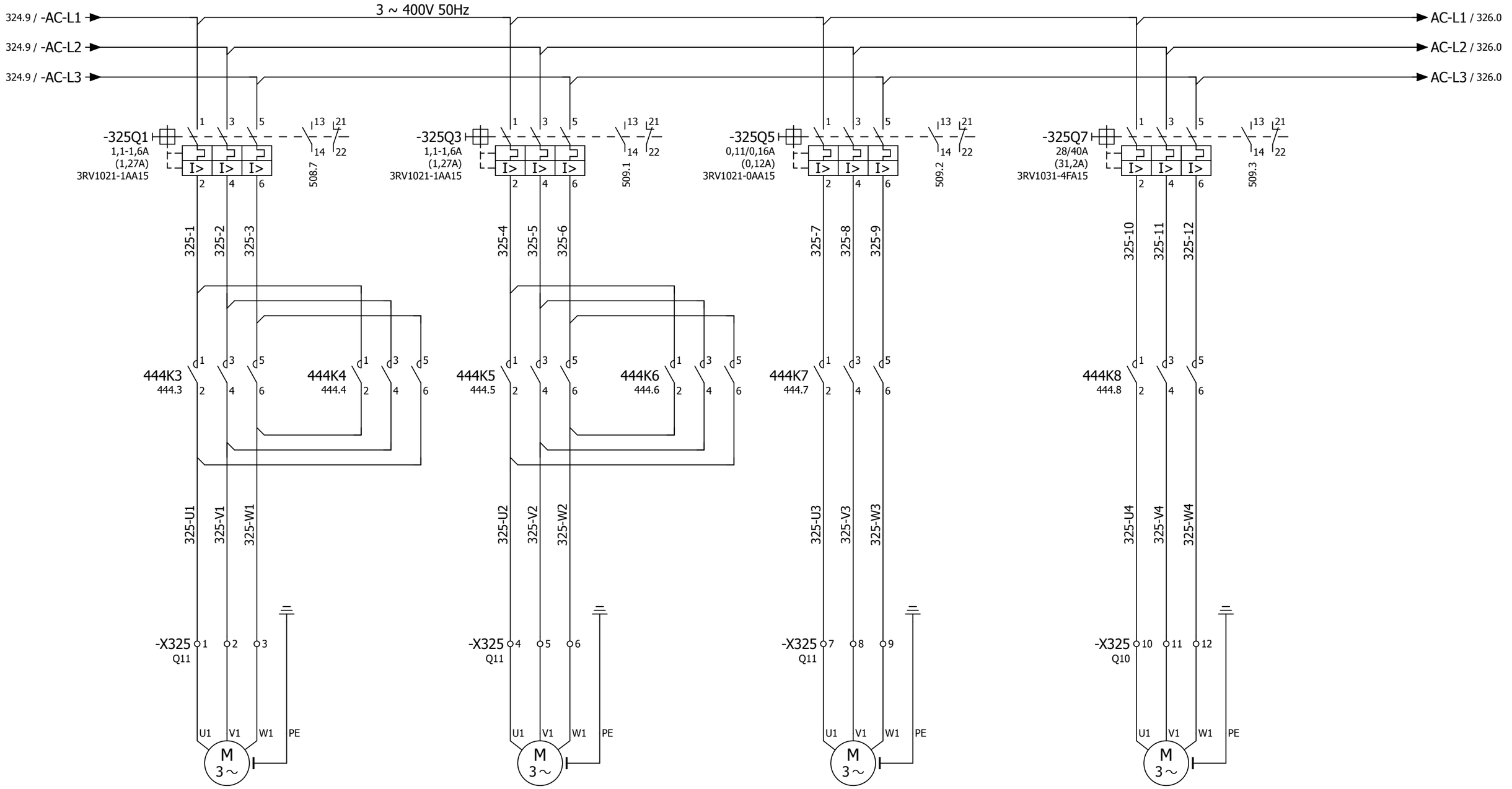
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 1° choice stacker motor	=	
Drawing	13B01					+	
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	323
Revision		Replacement of	Replaced by			Group:	Of 414



⇦323

325⇨

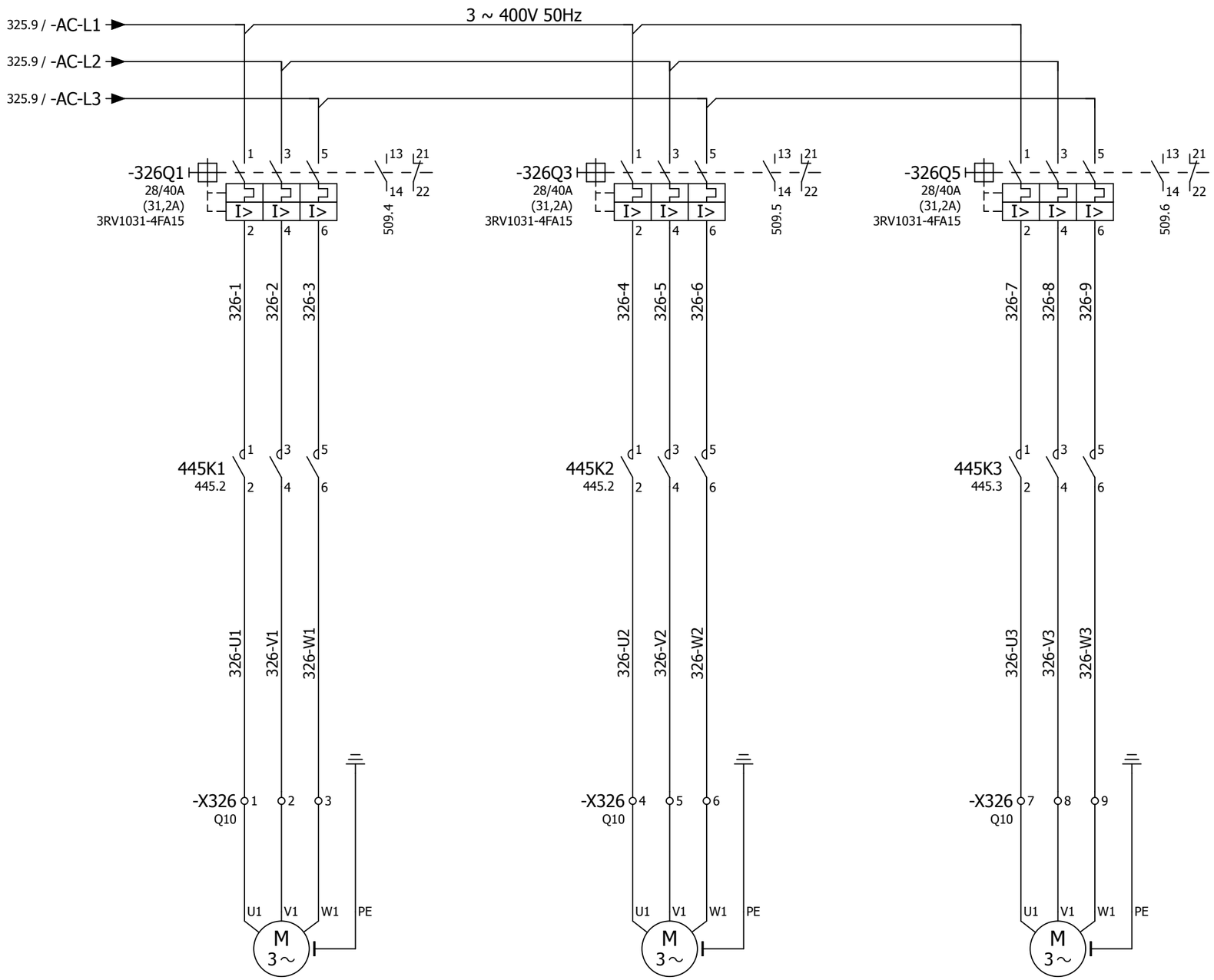
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 1° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	324
Revision		Replacement of	Replaced by			Group:	Of 414



⇦324

326⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 1° choice stacker motor	=	
Drawing	13B01					+	
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	325
Revision		Replacement of	Replaced by			Group:	Of 414



-326M1

A97.28.152
15KW-31,2A
400V-3000rpm

2° FAN SHEETS ASPIRATION
ROOM 1° CHOICE
STACKER

-326M3

A97.28.157
15KW-31,2A
400V-3000rpm

3° FAN SHEETS ASPIRATION
ROOM 1° CHOICE
STACKER

-326M5

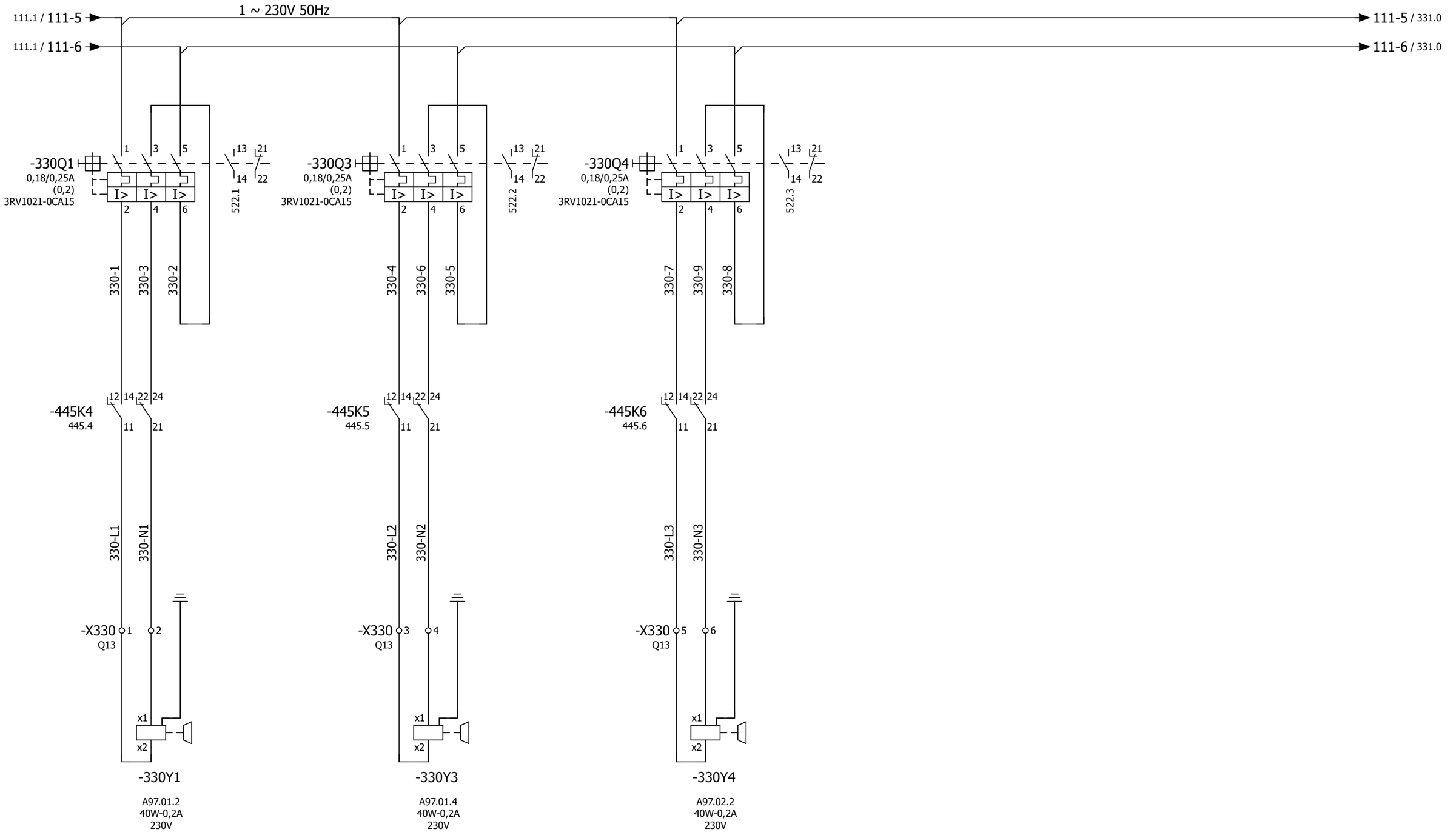
A97.28.162
15KW-31,2A
400V-3000rpm

4° FAN SHEETS ASPIRATION
ROOM 1° CHOICE
STACKER

⇦325

330⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: 1° choice stacker motor		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	326
Revision			Replacement of / Replaced by			Group: / Of	414



COILS
CARRIAGE FRONT
WHEELS PARKING
BRAKE

COILS
CARRIAGE REAR
WHEELS PARKING BRAKE

COIL CAR
PARKING BRAKE

⇦326

331⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	330
Revision			Replacement of / Replaced by			Group: / Of	414

330.9 / 111-5 — 1 ~ 230V 50Hz — 111-5 / 334.0

330.9 / 111-6 — 111-6 / 334.0

-331Q3
0,18/0,25A
(0,2)
3RV1021-0CA15
1 3 5 | 13 21 | 14 22 | 502.1
2 4 6

-331Q4
0,18/0,25A
(0,2)
3RV1021-0CA15
1 3 5 | 13 21 | 14 22 | 502.2
2 4 6

-331Q6
0,11/0,16A
(0,12)
3RV1021-0AA15
1 3 5 | 13 21 | 14 22 | 502.7
2 4 6

331-4 331-6 331-5

331-7 331-9 331-8

331-10 331-12 331-11

-360K5
360.7
12 14 22 24
11 21

-361K2
361.2
12 14 22 24
11 21

-361K3
361.3
12 14 22 24
11 21

331-L2 331-N2

331-L3 331-N3

331-L4 331-N4

-X331 Q13
1 2

-X331 Q13
3 4

-X331 Q13
5 6

x1 x2

-331Y3

A97.10.18
40W-0,2A
230V

STRAIGHTENER
1° SCREW
JACK PARKING
BRAKE

-331Y4

A97.10.23
40W-0,2A
230V

STRAIGHTENER
2° SCREW
JACK PARKING
BRAKE

-331Y6

A97.12.6
25W-0,12A
230V

CROPPER
SHEAR BLADES
CLEARANCE PARKING
BRAKE

⇦330

334⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	331
Revision			Replacement of / Replaced by			Group: / Of	414

331.9 / 111-5 → 1 ~ 230V 50Hz

331.9 / 111-6 →

111-5 / 335.0

111-6 / 335.0

-334Q8
0,22-0,32A
(0,27A)
3RV1021-0DA15

1 3 5 13 21
14 22
I> I> I>
2 4 6
503.5

334-13
334-15
334-14

-364K3
364.3

12 14 22 24
11 21

334-L5
334-N5

-X334
Q12
1 2

x1
x2

-334Y8

A97.12.6
55W-0,27A
230V

LEVELLER 1
1° SCREW JACK
PARKING BRAKE

⇦331

335⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	334
Revision			Replacement of / Replaced by			Group: / Of	414

334.9 / 111-5

334.9 / 111-6

1 ~ 230V 50Hz

111-5 / 336.0

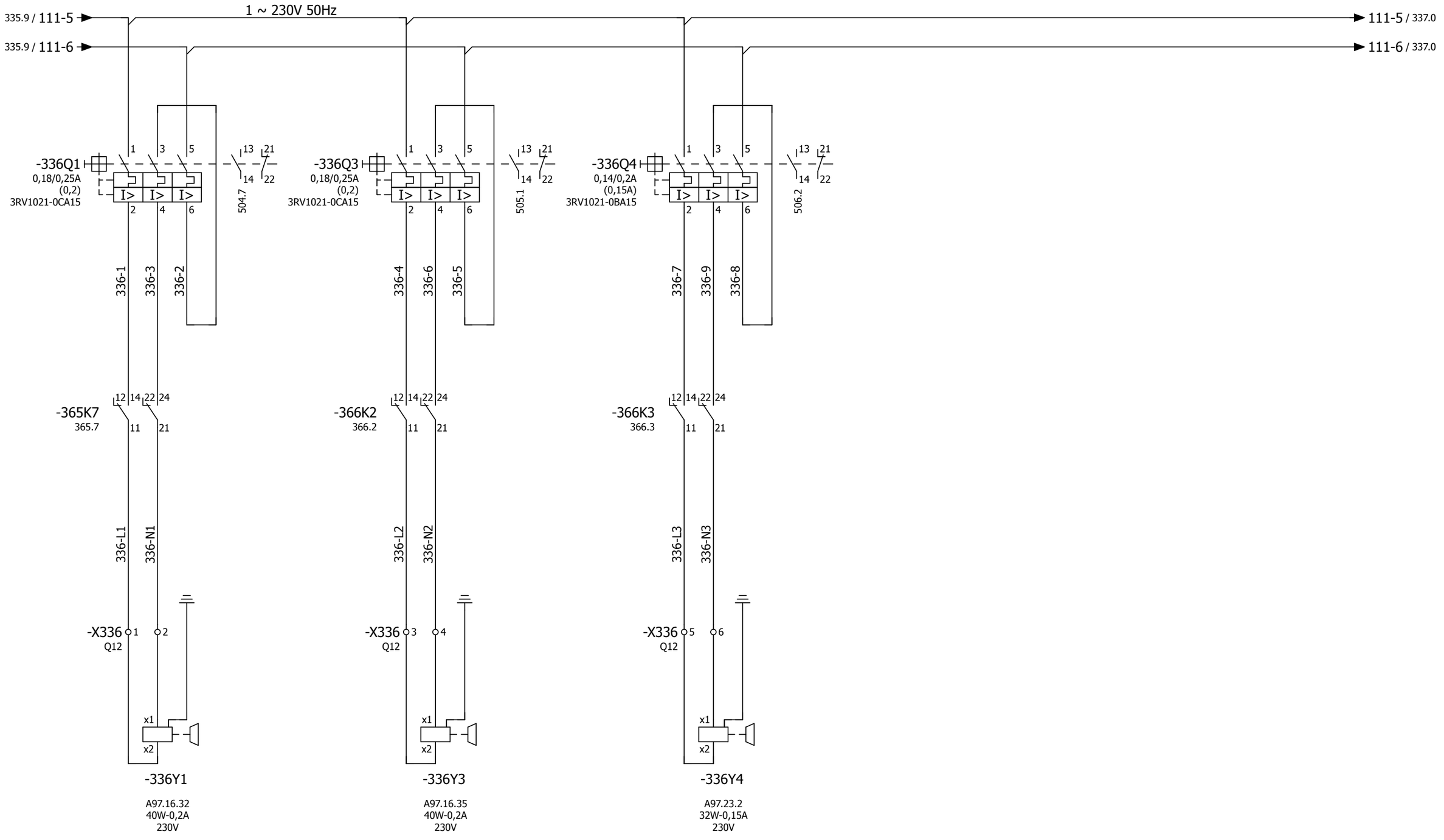
111-6 / 336.0

	-335Q1	-335Q3	-335Q4	-335Q6	-335Q8
	0,22-0,32A (0,27A) 3RV1021-0DA15	0,22-0,32A (0,27A) 3RV1021-0DA15	0,22-0,32A (0,27A) 3RV1021-0DA15	0,18/0,25A (0,2) 3RV1021-0CA15	0,18/0,25A (0,2) 3RV1021-0CA15
	503.6	503.7	503.7	504.6	504.7
	335-1 335-3 335-2	335-4 335-6 335-5	335-7 335-9 335-8	335-10 335-12 335-11	335-13 335-15 335-14
	-364K5 364.5	-364K7 364.7	-365K2 365.2	-365K3 365.3	-365K5 365.5
	335-L1 335-N1	335-L2 335-N2	335-L3 335-N3	335-L4 335-N4	335-L5 335-N5
	-X335 Q12	-X335 Q12	-X335 Q12	-X335 Q12	-X335 Q12
	-335Y1	-335Y3	-335Y4	-335Y6	-335Y8
	A97.13.29 55W-0,27A 230V	A97.13.32 55W-0,27A 230V	A97.13.35 55W-0,27A 230V	A97.16.24 40W-0,2A 230V	A97.16.29 40W-0,2A 230V
	LEVELLER 1 2° SCREW JACK PARKING BRAKE	LEVELLER 1 3° SCREW JACK PARKING BRAKE	LEVELLER 1 4° SCREW JACK PARKING BRAKE	LEVELLER 2 1° SCREW JACK PARKING BRAKE	LEVELLER 2 2° SCREW JACK PARKING BRAKE

334

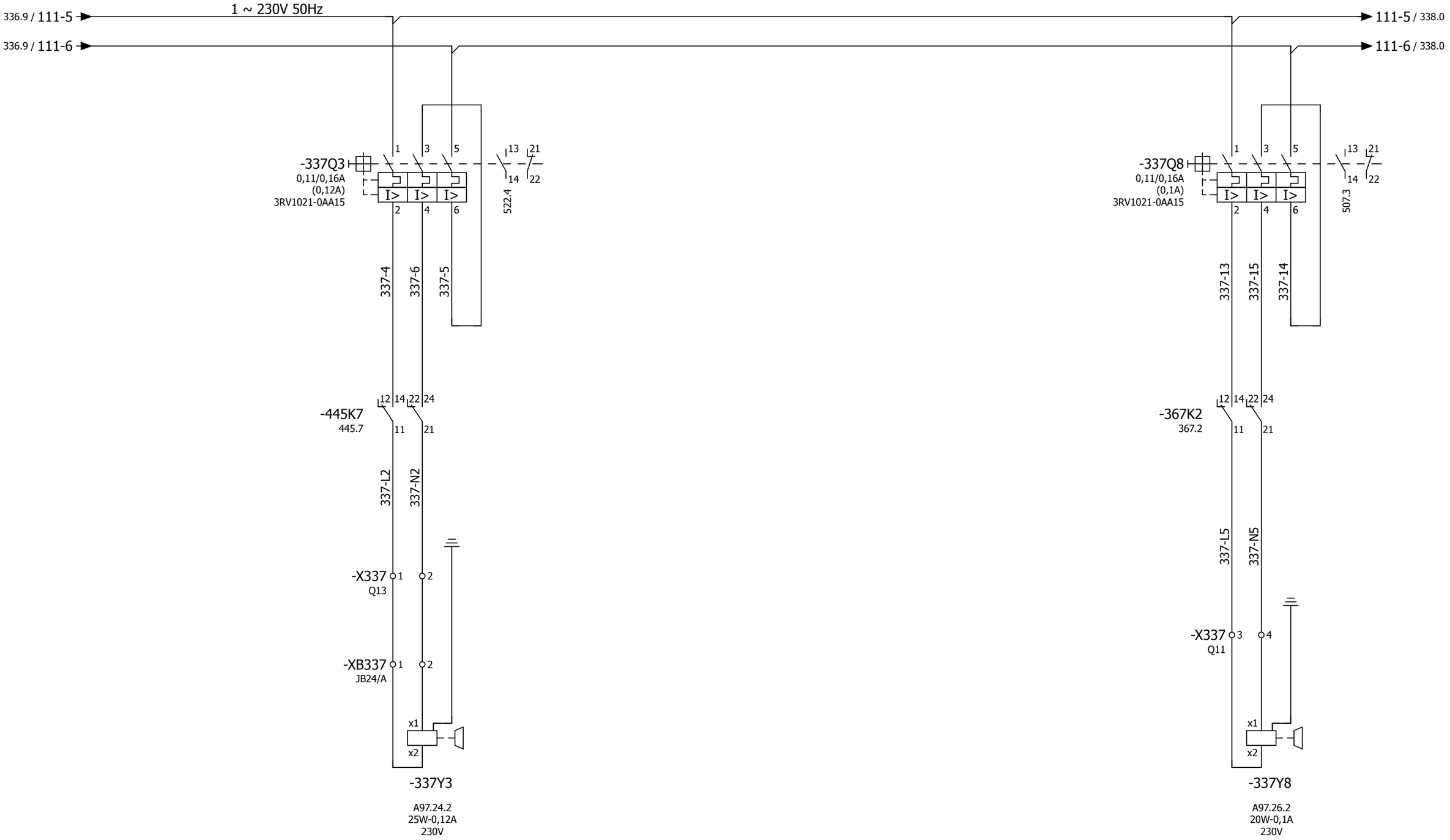
336

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Motors brakes	=
Drawing	13B01		Comm: A97			+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page 335
Revision			Replacement of / Replaced by			Group: / Of 414


335.9 / 111-5
335.9 / 111-6
1 ~ 230V 50Hz
111-5 / 337.0
111-6 / 337.0
-336Q1
0,18/0,25A
(0,2)
3RV1021-0CA15
504.7
-336Q3
0,18/0,25A
(0,2)
3RV1021-0CA15
505.1
-336Q4
0,14/0,2A
(0,15A)
3RV1021-0BA15
506.2
336-1
336-3
336-2
336-4
336-6
336-5
336-7
336-9
336-8
-365K7
365.7
-366K2
366.2
-366K3
366.3
336-L1
336-N1
336-L2
336-N2
336-L3
336-N3
-X336 Q12
-336Y1
A97.16.32
40W-0,2A
230V
-336Y3
A97.16.35
40W-0,2A
230V
-336Y4
A97.23.2
32W-0,15A
230V
LEVELLER 2
3° SCREW JACK
PARKING BRAKE
LEVELLER 2
4° SCREW JACK
PARKING BRAKE
CENTERING
DEVICE 2
PARKING BRAKE

⇦335

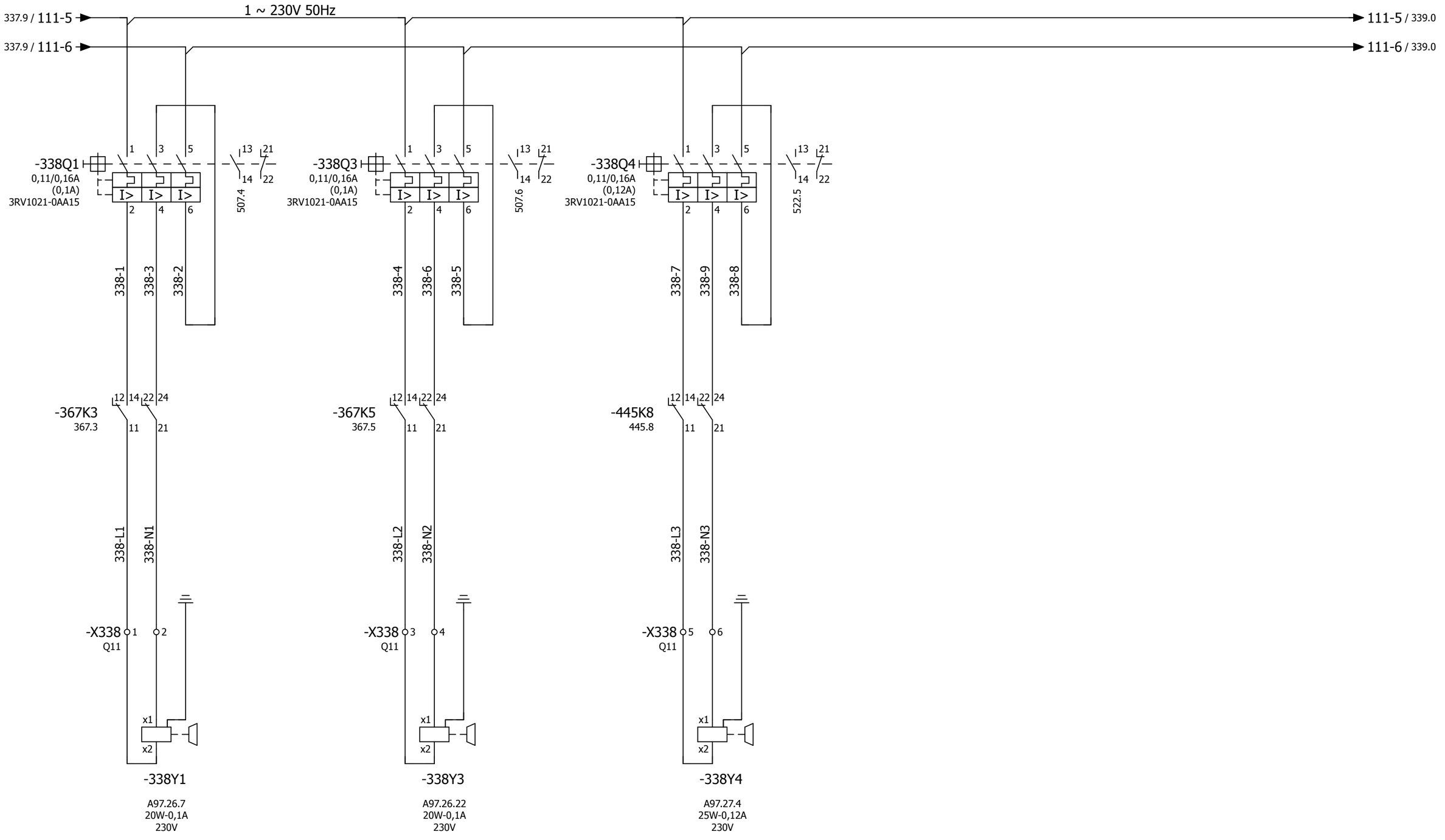
337⇨



⇦336

338⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 337
Revision			Replacement of / Replaced by			Group:	Of 414



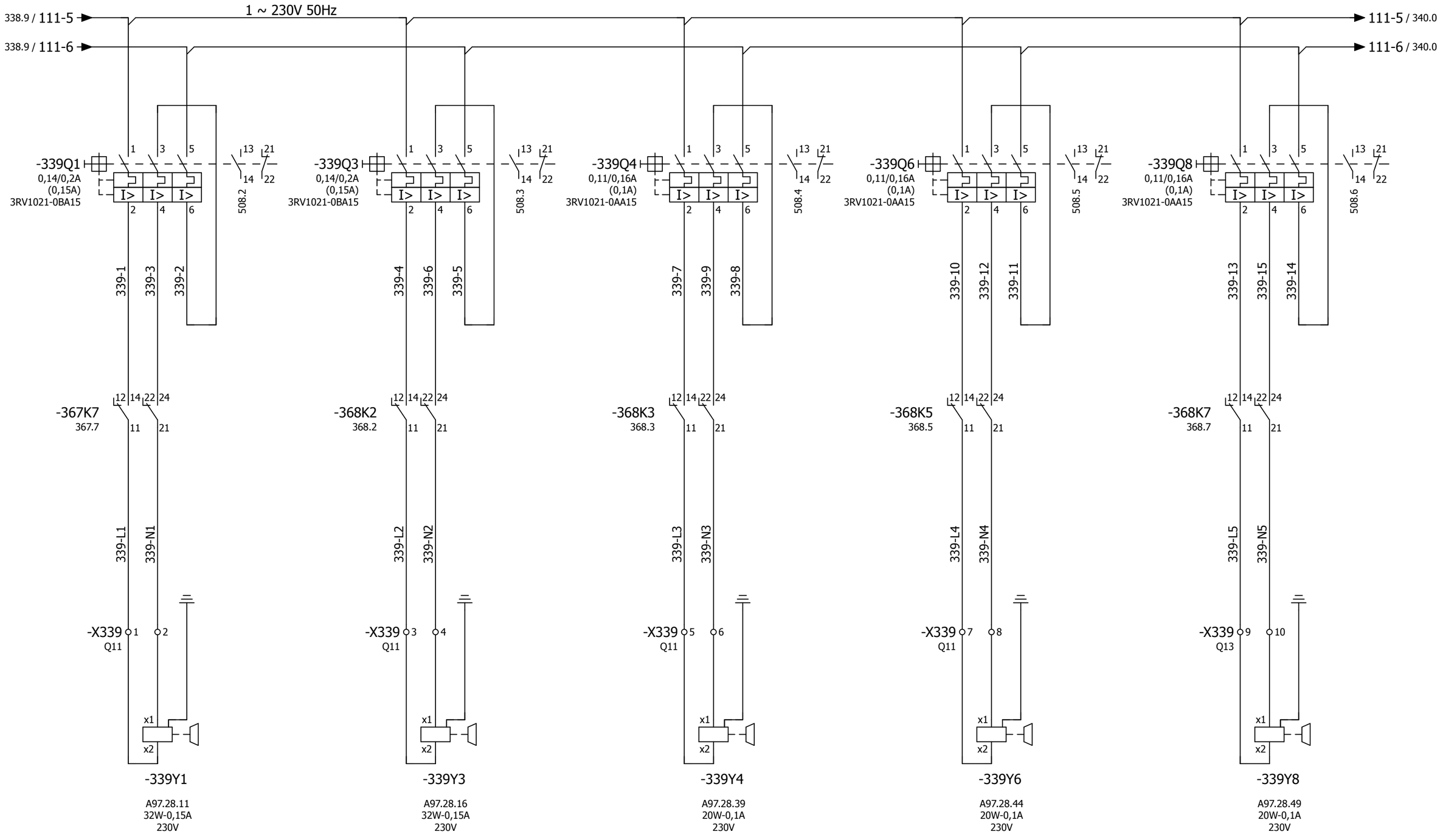
MOTOR SIDE
SHEET SUPPORT
BEAMS 2° CHOICE
STACKER PARKING BRAKE

HEAD MOBILE
CARRIAGE
TRANSLATION 2°
CHOICE STACKER PARKING
BRAKE

PACKAGE
FORMING ROLL 2°
CHOICE
STACKER PARKING
BRAKE

⇦337

339⇨



ENTRY SHEET
SUPPORT BEAMS
HORIZONTAL TRANSLATION
1° CHOICE STACKER
PARKING BRAKE

EXIT SHEET
SUPPORT BEAMS
HORIZONTAL TRANSLATION
1° CHOICE STACKER
PARKING BRAKE

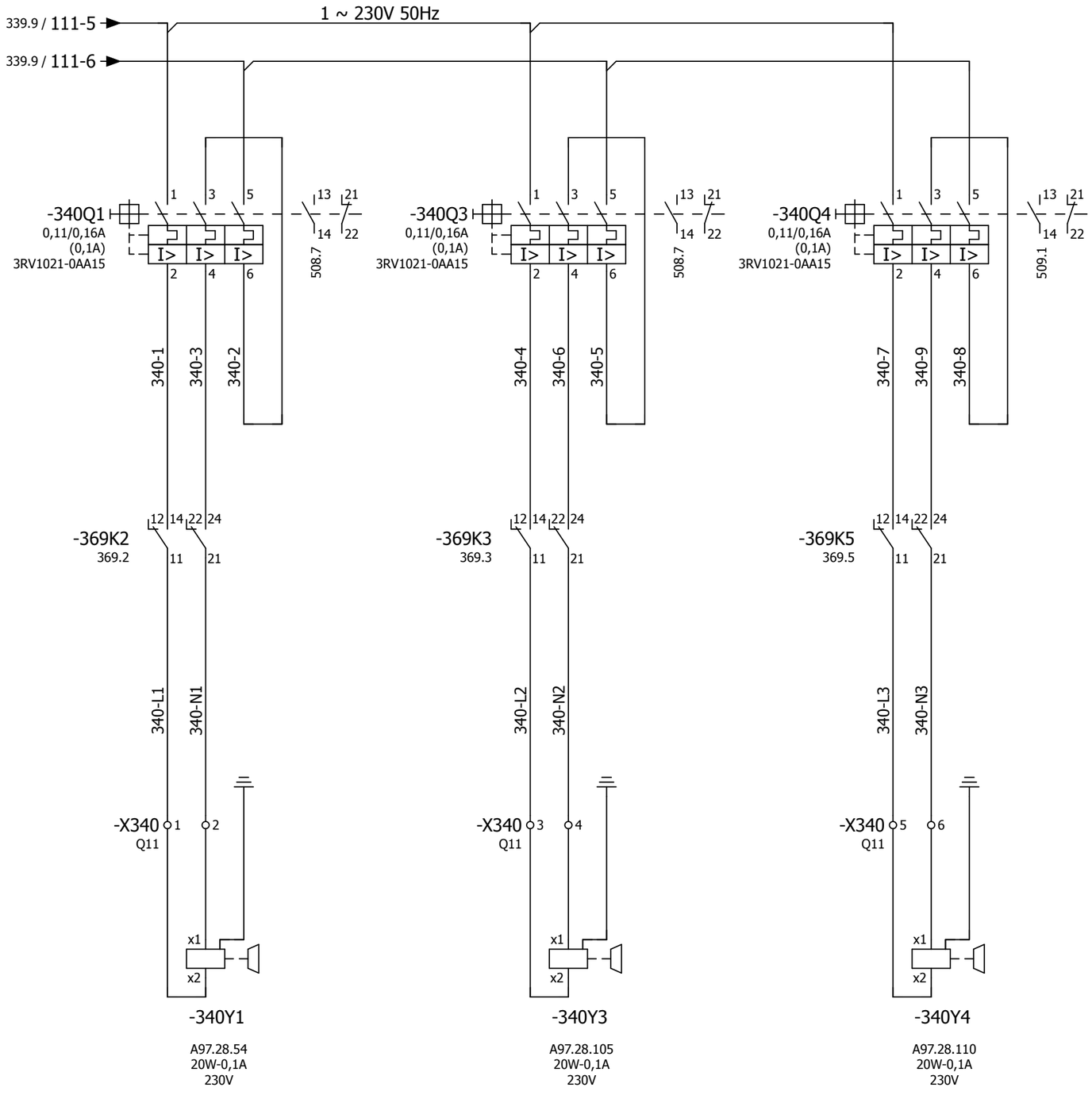
OPERATOR
SIDE 1° AND 2°
SHEET CONVEYOR VERTICAL
TRANSLATION 1° CHOICE
STACKER FROM 1° BOX TO
2° BOXPARKING BRAKE

MOTOR SIDE
1° AND 2°
SHEET CONVEYOR VERTICAL
TRANSLATION 1° CHOICE
STACKER FROM 1° BOX TO
2° BOXPARKING BRAKE

OPERATOR
SIDE HEAD MOBILE
CARRIAGE HORIZONTAL
TRANSLATION 1° CHOICE
STACKER 1° BOX
PARKING BRAKE

⇦338

340⇨



MOTOR SIDE
HEAD MOBILE
CARRIAGE HORIZONTAL
TRANSLATION 1° CHOICE STACKER
1° BOX
PARKING BRAKE

OPERATOR
SIDE HEAD MOBILE
CARRIAGE HORIZONTAL
TRANSLATION 1° CHOICE
STACKER 2° BOX
PARKING BRAKE

MOTOR SIDE
HEAD MOBILE
CARRIAGE HORIZONTAL
TRANSLATION 1° CHOICE STACKER
2° BOX
PARKING BRAKE

⇦339

360⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	340
Revision			Replacement of / Replaced by			Group: / Of	414

190.5 / -110-Z11 → 110V 50Hz

110-Z11 / 361.0 ←

-432K5 13 14
432.5

-432K6 13 14
432.6

360-4

-360K5 A1 A2

360.9 / -110-N →

110-N / 360.0 ←

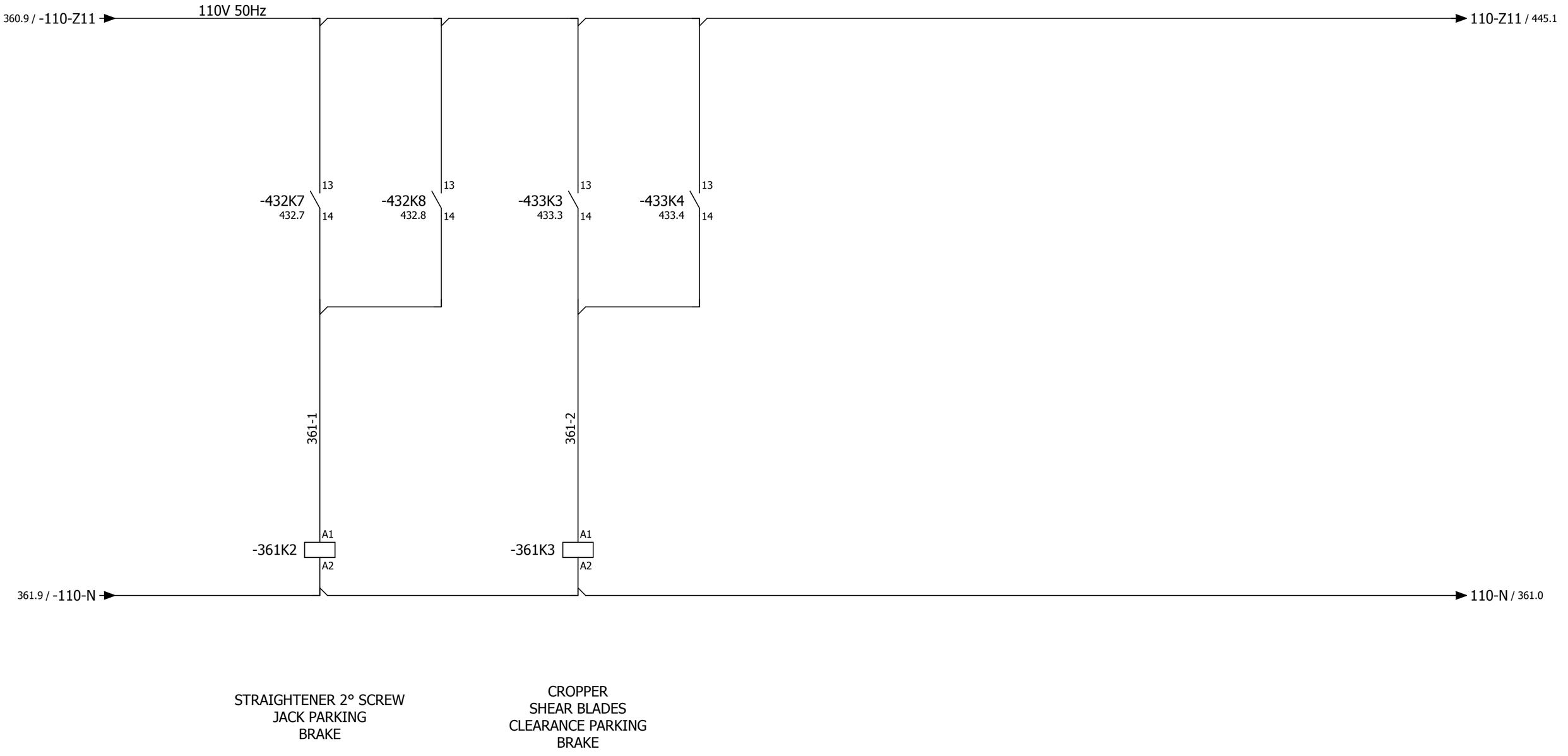
STRAIGHTENER 1° SCREW
JACK PARKING
BRAKE

PT270615
14 12 — 11 331.2
24 22 — 21 331.2

⇦340

361⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes auxiliary circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	360
Revision		Replacement of	Replaced by			Group:	Of 414



STRAIGHTENER 2° SCREW
JACK PARKING
BRAKE

CROPPER
SHEAR BLADES
CLEARANCE PARKING
BRAKE

PT270615
14 – 11 331.4
12
24 – 21 331.4
22

PT270615
14 – 11 331.6
12
24 – 21 331.6
22

⇦360

364⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes auxiliary circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	361
Revision		Replacement of	Replaced by			Group:	Of 414

190.6 / -110-Z12 — 110V 50Hz

110-Z12 / 365.0

-434K1 13 14 — 434.2
-434K2 13 14 — 434.2
-434K3 13 14 — 434.3
-434K4 13 14 — 434.4
-434K5 13 14 — 434.5
-434K6 13 14 — 434.6

364-2 — A1 -364K3 A2
364-3 — A1 -364K5 A2
364-4 — A1 -364K7 A2

364.9 / -110-N

110-N / 364.0

LEVELLER 1
1° SCREW JACK
PARKING BRAKE

LEVELLER 1
2° SCREW JACK
PARKING BRAKE

LEVELLER 1
3° SCREW JACK
PARKING BRAKE

PT270615
14 — 11 334.8
12
24 — 21 334.8
22

PT270615
14 — 11 335.0
12
24 — 21 335.1
22

PT270615
14 — 11 335.2
12
24 — 21 335.2
22

⇦361

365⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes auxiliary circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	364
Revision		Replacement of	Replaced by			Group:	Of 414

364.9 / -110-Z12 → 110V 50Hz

110-Z12 / 366.0

-434K7 434.7 (13/14) -434K8 434.8 (13/14) -436K2 436.2 (13/14) -436K3 436.3 (13/14) -436K4 436.4 (13/14) -436K5 436.5 (13/14) -436K6 436.6 (13/14) -436K7 436.7 (13/14)

365-2 | 365-3 | 365-4 | 365-5

-365K2 (A1/A2) -365K3 (A1/A2) -365K5 (A1/A2) -365K7 (A1/A2)

365.9 / -110-N →

110-N / 365.0

LEVELLER 1
4° SCREW JACK
PARKING BRAKE

LEVELLER 2
1° SCREW JACK
PARKING BRAKE

LEVELLER 2
2° SCREW JACK
PARKING BRAKE

LEVELLER 2
3° SCREW JACK
PARKING BRAKE

PT270615
14 – 11 335.4
12
24 – 21 335.4
22

PT270615
14 – 11 335.6
12
24 – 21 335.6
22

PT270615
14 – 11 335.8
12
24 – 21 335.8
22

PT270615
14 – 11 336.0
12
24 – 21 336.1
22

⇦364

366⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes auxiliary circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	365
Revision		Replacement of	Replaced by			Group:	Of 414

365.9 / -110-Z12 → 110V 50Hz

110-Z12 / 445.1

-437K1 13 14 437.2

-437K2 13 14 437.2

-439K1 13 14 439.2

-439K2 13 14 439.2

366-2

366-3

-366K2 A1 A2

-366K3 A1 A2

366.9 / -110-N → 110-N / 366.0

LEVELLER 2
4° SCREW JACK
PARKING BRAKE

CENTERING
DEVICE 2
PARKING BRAKE

PT270615
14 – 11 336.2
12
24 – 21 336.2
22

PT270615
14 – 11 336.4
12
24 – 21 336.4
22

⇦365

367⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes auxiliary circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	366
Revision		Replacement of	Replaced by			Group:	Of 414

190.8 / -110-Z13 — 110V 50Hz

110-Z13 / 368.0

-441K3 13 14 — 441.3
-441K4 13 14 — 441.4
-441K5 13 14 — 441.5
-441K6 13 14 — 441.6
-442K1 13 14 — 442.2
-442K2 13 14 — 442.2
-442K7 13 14 — 442.7
-442K8 13 14 — 442.8

367-2 | 367-3 | 367-4 | 367-5

-367K2 A1 A2
-367K3 A1 A2
-367K5 A1 A2
-367K7 A1 A2

367.9 / -110-N

110-N / 367.0

OPERATOR SIDE
SHEET SUPPORT BEAMS
2° CHOICE STACKER
PARKING BRAKE

MOTOR SIDE
SHEET SUPPORT BEAMS
2° CHOICE STACKER
PARKING BRAKE

HEAD
MOBILE CARRIAGE
TRANSLATION
2° CHOICE STACKER
PARKING BRAKE

ENTRY
SHEET SUPPORT
BEAMS HORIZONTAL TRANSLATION
1° CHOICE
STACKER PARKING BRAKE

PT270615
14 — 11 337.8
12
24 — 21 337.8
22

PT270615
14 — 11 338.0
12
24 — 21 338.1
22

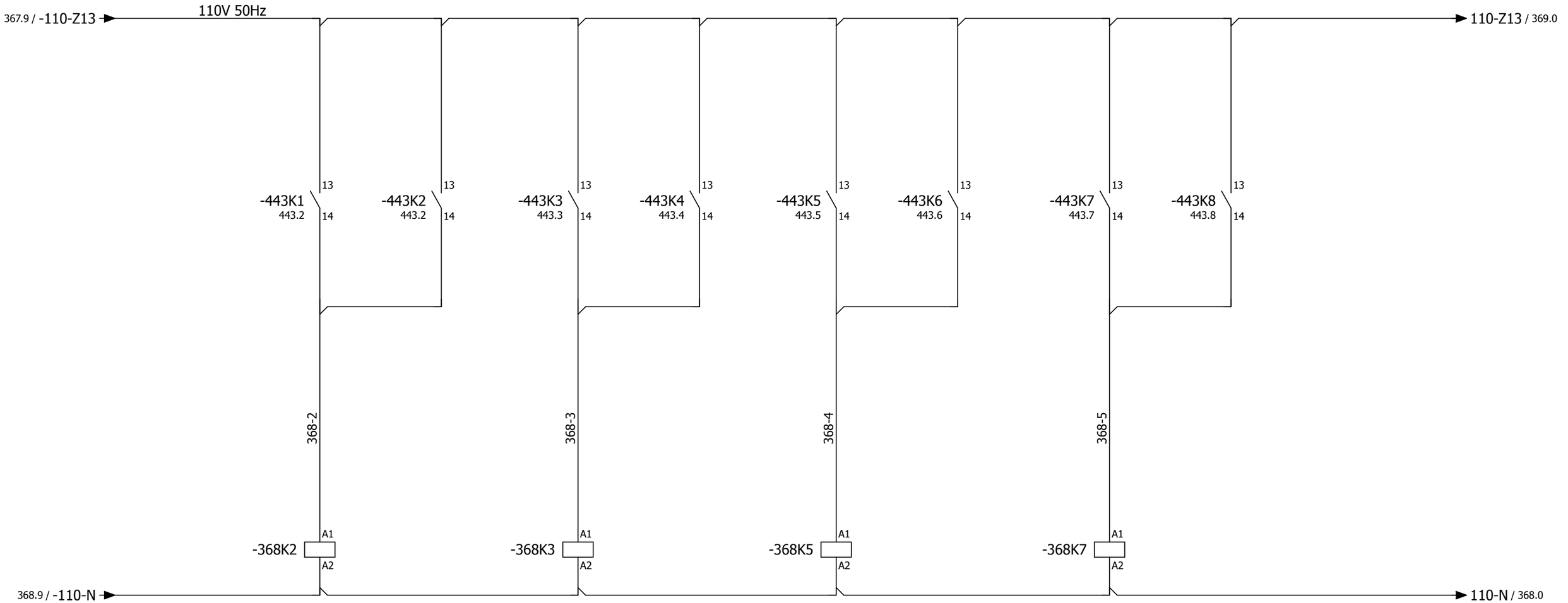
PT270615
14 — 11 338.2
12
24 — 21 338.2
22

PT270615
14 — 11 339.0
12
24 — 21 339.1
22

366

368

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes auxiliary circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	367
Revision			Replacement of / Replaced by			Group: / Of	414



EXIT
SHEET SUPPORT
BEAMS HORIZONTAL TRANSLATION
1° CHOICE STACKER
PARKING
BRAKE

PT270615
14 – 11 339.2
12
24 – 21 339.2
22

OPERATOR SIDE
1° AND 2° SHEET CONVEYOR
VERTICAL TRANSLATION
1° CHOICE STACKER
FROM 1° BOX TO 2° BOX
PARKING BRAKE

PT270615
14 – 11 339.4
12
24 – 21 339.4
22

MOTOR SIDE
1° AND 2° SHEET CONVEYOR
VERTICAL TRANSLATION
1° CHOICE STACKER
FROM 1° BOX TO 2° BOX
PARKING BRAKE

PT270615
14 – 11 339.6
12
24 – 21 339.6
22

OPERATOR SIDE
HEAD MOBILE CARRIAGE
HORIZONTAL TRANSLATION
1° CHOICE STACKER 1° BOX
PARKING BRAKE

PT270615
14 – 11 339.8
12
24 – 21 339.8
22

⇦367
369⇨

368.9 / -110-Z13 → 110V 50Hz

-444K1 444.2 (13/14) -444K2 444.2 (13/14) -444K3 444.3 (13/14) -444K4 444.4 (13/14) -444K5 444.5 (13/14) -444K6 444.6 (13/14)

369-2 A1 -369K2 A2

369-3 A1 -369K3 A2

369-4 A1 -369K5 A2

369.9 / -110-N → 110-N / 369.0

MOTOR SIDE
HEAD MOBILE CARRIAGE
HORIZONTAL TRANSLATION
1° CHOICE STACKER 1° BOX
PARKING BRAKE

OPERATOR SIDE
HEAD MOBILE CARRIAGE
HORIZONTAL TRANSLATION
1° CHOICE STACKER 2° BOX
PARKING BRAKE

MOTOR SIDE
HEAD MOBILE CARRIAGE
HORIZONTAL TRANSLATION
1° CHOICE STACKER 2° BOX
PARKING BRAKE

PT270615
14 – 11 340.0
12
24 – 21 340.1
22

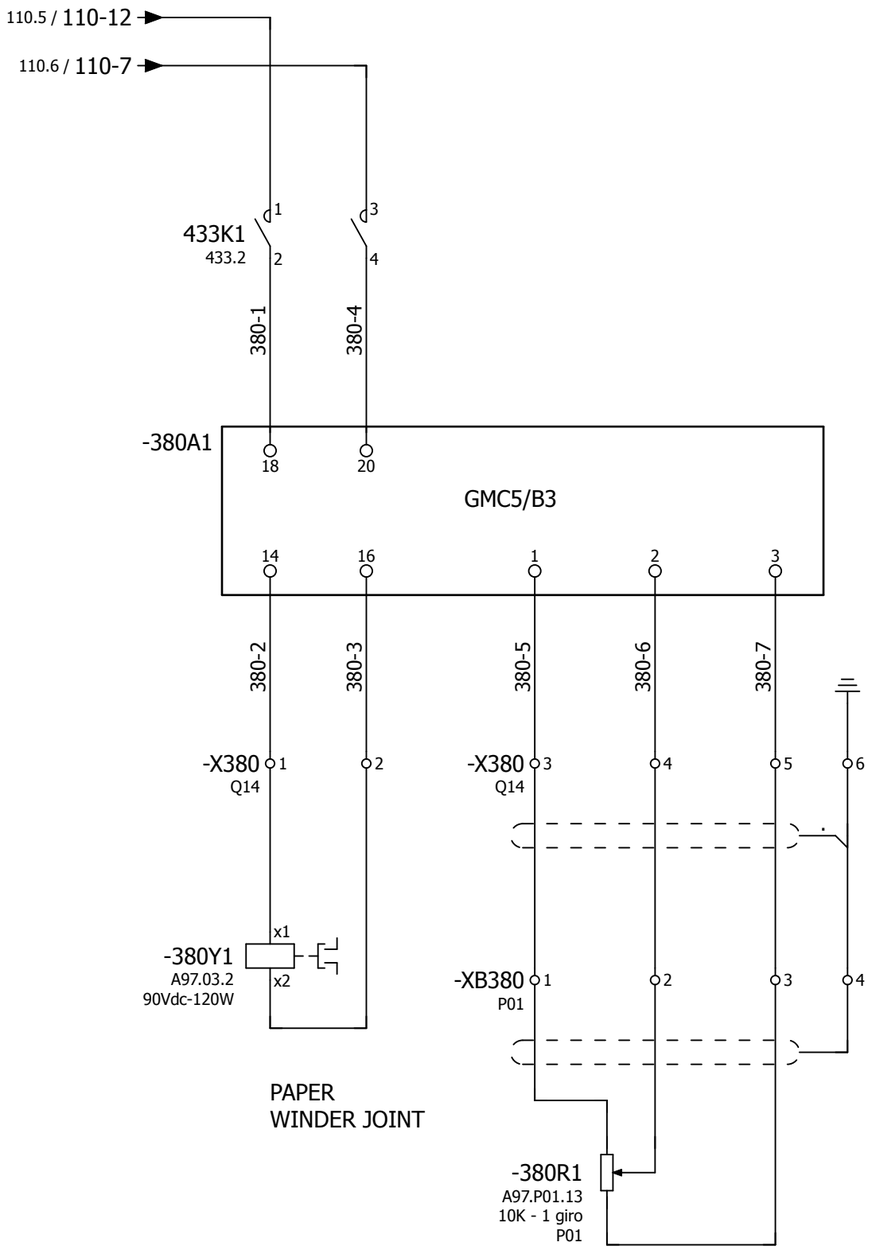
PT270615
14 – 11 340.2
12
24 – 21 340.2
22

PT270615
14 – 11 340.4
12
24 – 21 340.4
22

⇦368

380⇨

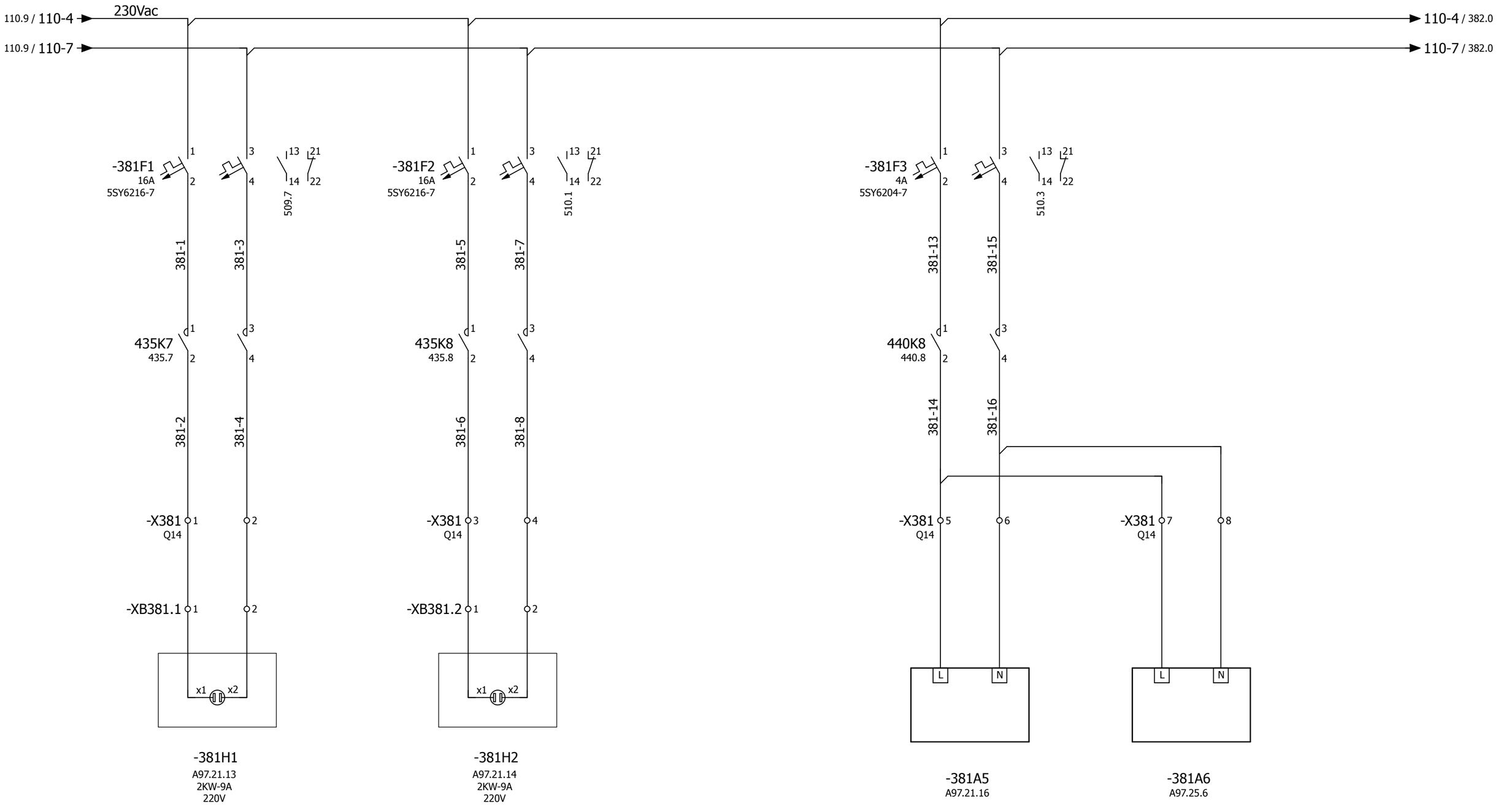
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Motors brakes auxiliary circuit		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	369
Revision		Replacement of	Replaced by			Group:	Of 414



⇦369

381⇨

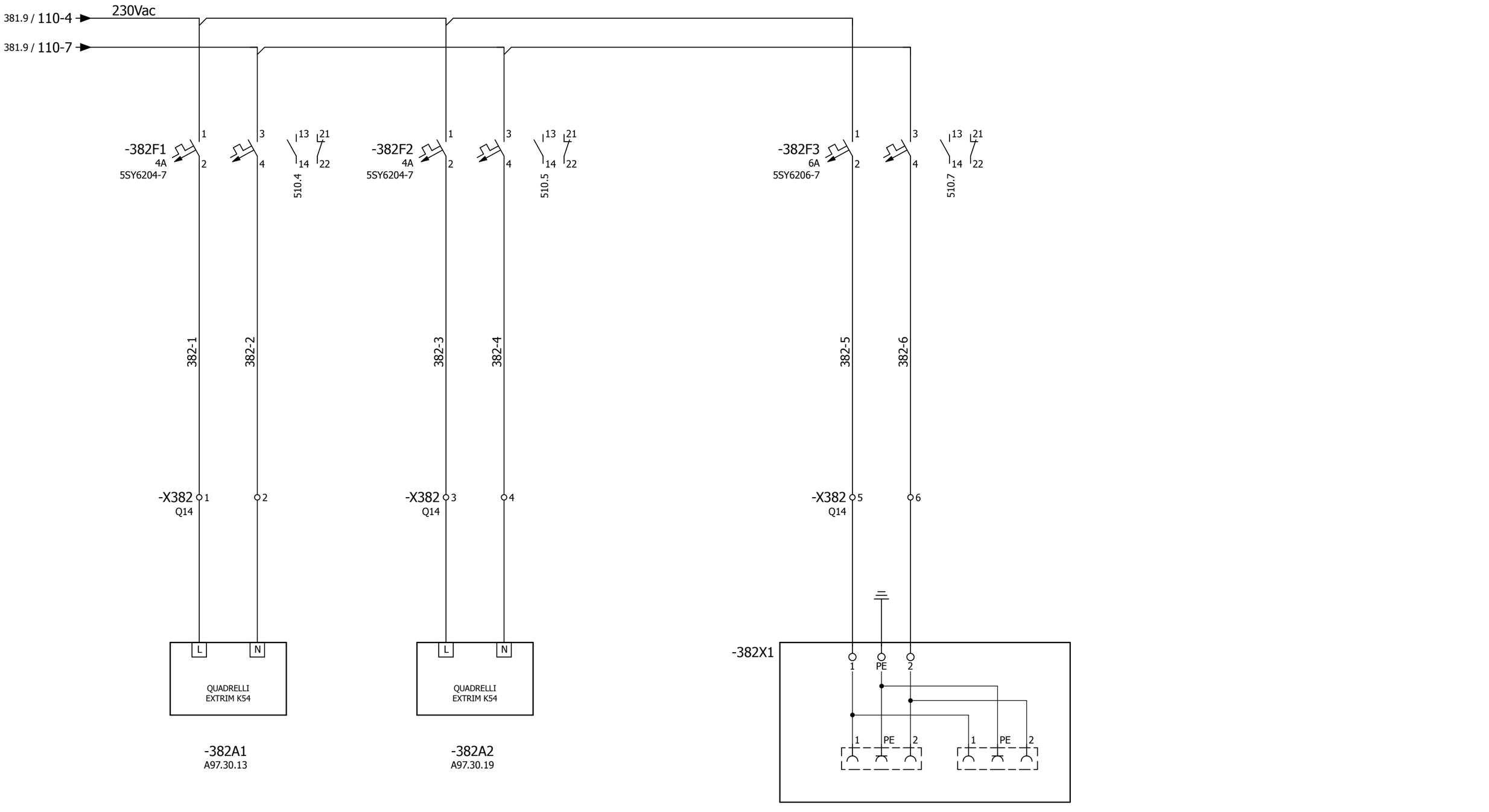
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Paper winder joint supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 380
Revision			Replacement of / Replaced by			Group:	Of 414



⇦380

382⇨

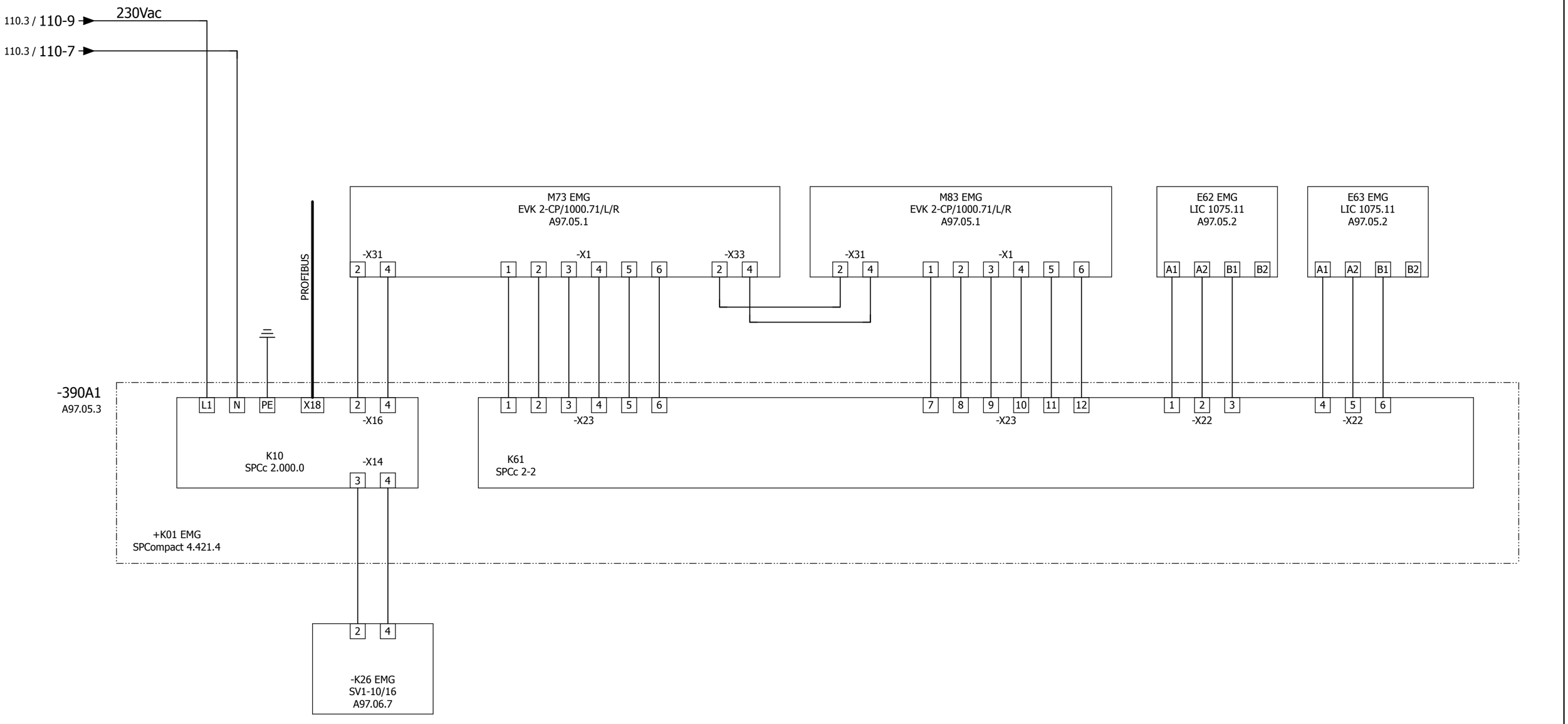
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Electrifiers supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 381
Revision		Replacement of	Replaced by			Group:	Of 414



381

390

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Loading cells and ink jet supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	382
Revision		Replacement of	Replaced by			Group:	Of 414



⇦382

392⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: EMG suplpy		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 390
Revision		Replacement of	Replaced by			Group:	Of 414

105.7 / 105-11 230Vac

105.7 / 105-12

-X392 Q1

105-11

105-12

P02
CONSOLE BOX

-392F1 4A

-392F4 6A

392F5 1Agl

392-6

392-8

392S1

392-7

392-9

M 1~

-392M1
0,028KW - 0,12A
230/240V - 50Hz

392-2

392-1

-392A1 DISANO type 920HYDRO 2x58W

-392A2 DISANO type 920HYDRO 2x58W

-392A3 DISANO type 920HYDRO 2x58W

P02 CONSOLE BOX
ILLUMINATION

392-4

392-3

-392X1

-392X2

-392X3

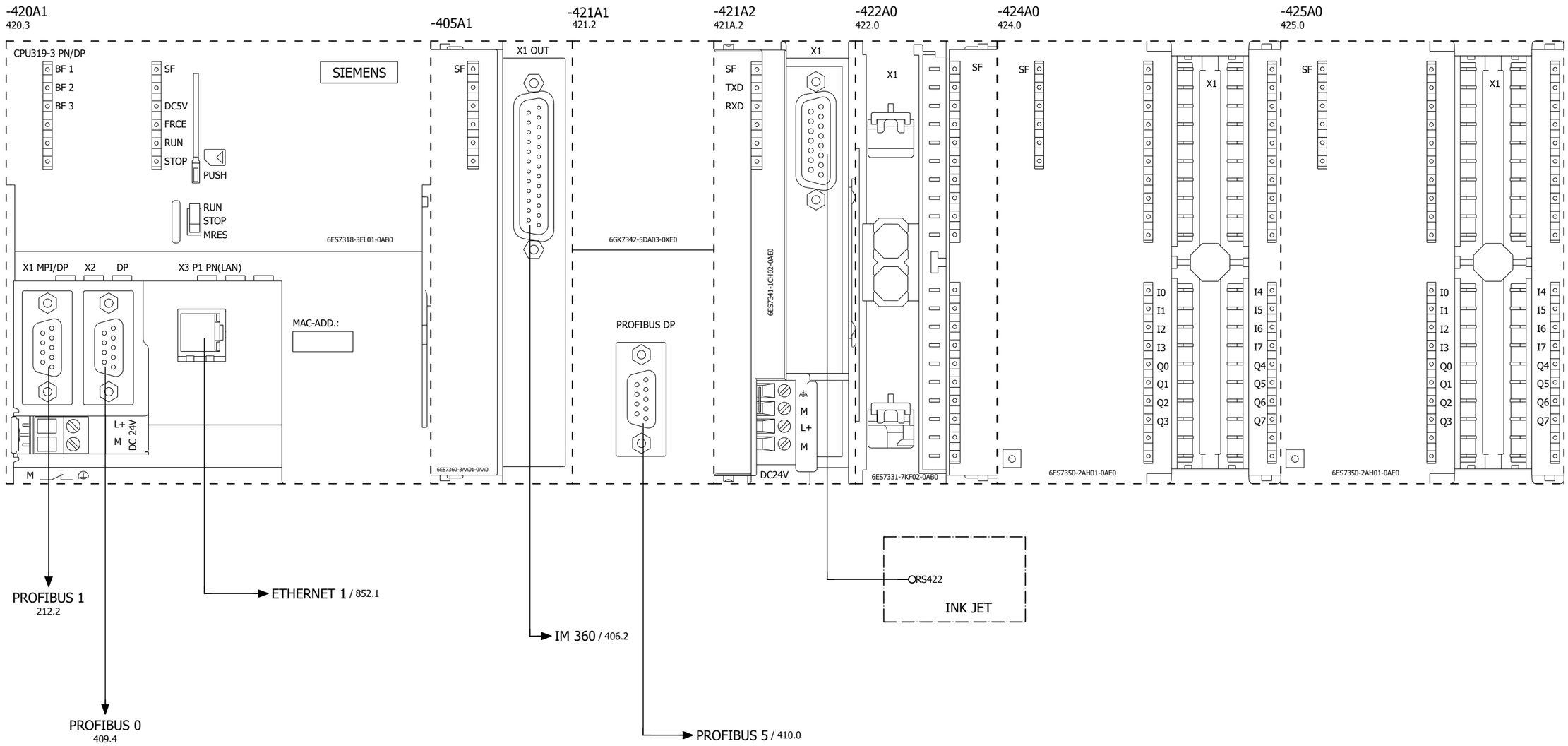
P02
CONSOLE BOX SOCKET

FAN AIR
RECYCLING MADE
BY RANGE SOUND

⇦390

405⇨

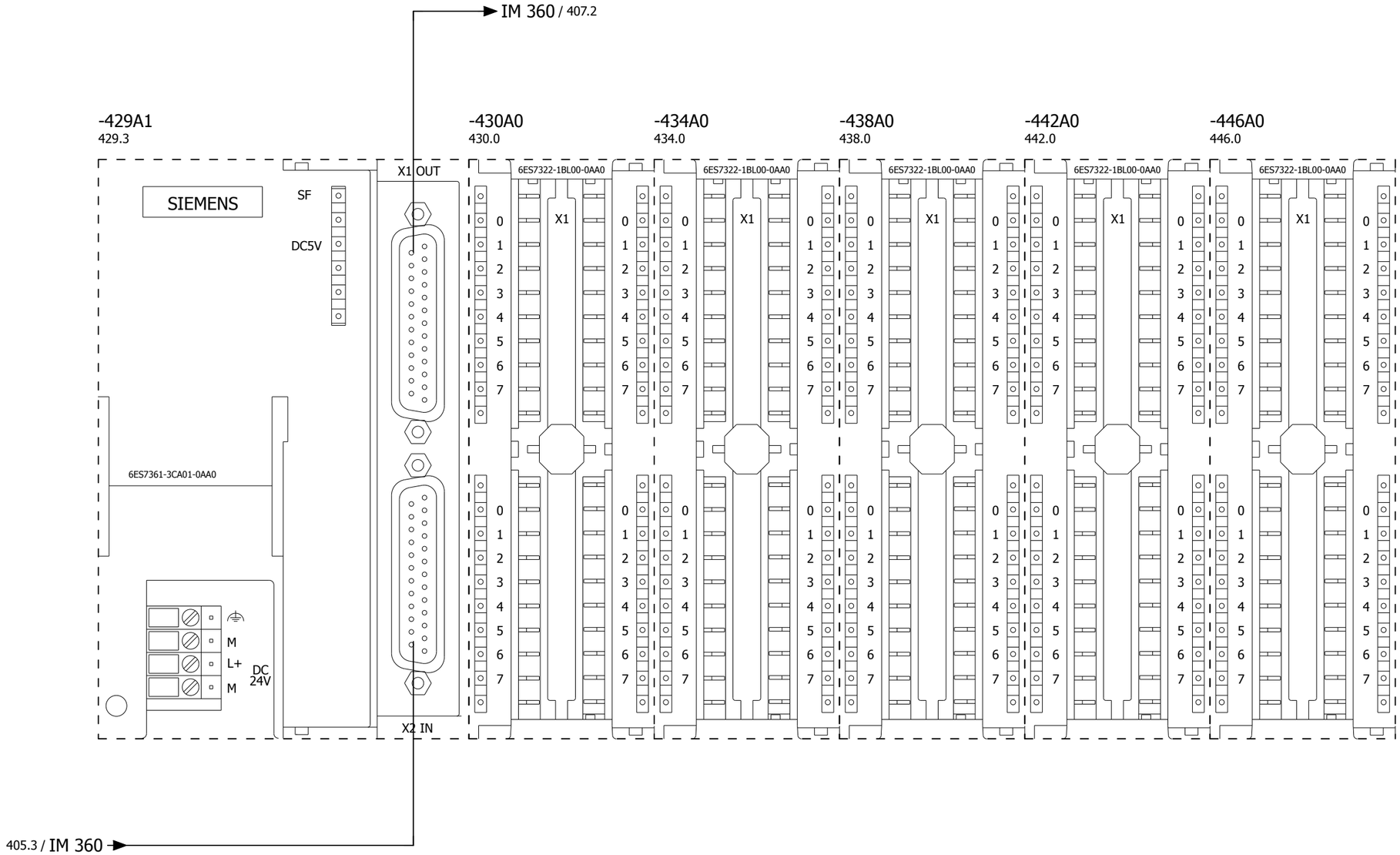
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Lamps and consoles box socket		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 392
Revision			Replacement of / Replaced by			Group:	Of 414



⇦392

406⇨

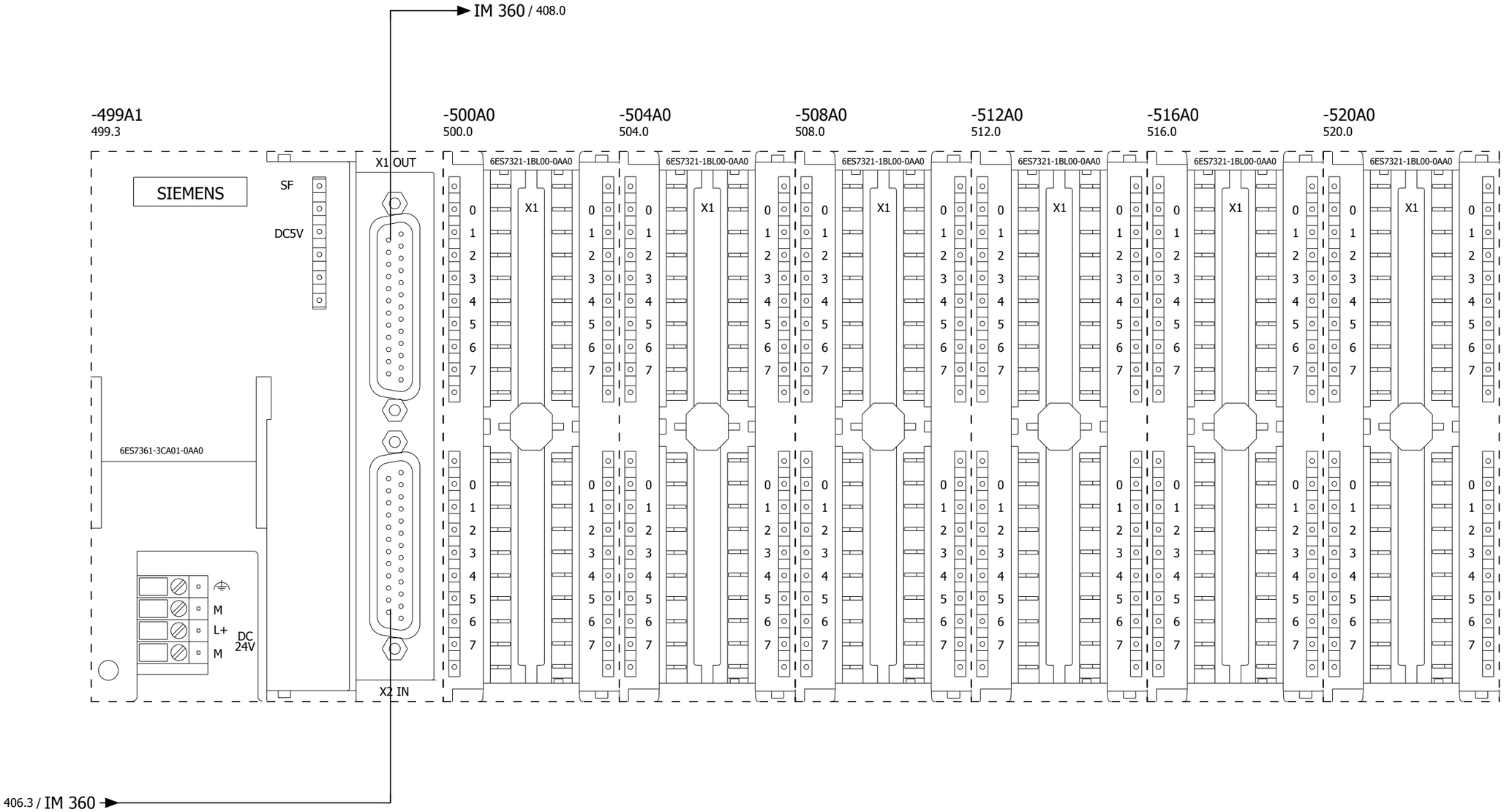
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 405
Revision			Replacement of / Replaced by			Group:	Of 414



⇦405

407⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital output plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 406
Revision			Replacement of / Replaced by			Group:	Of 414

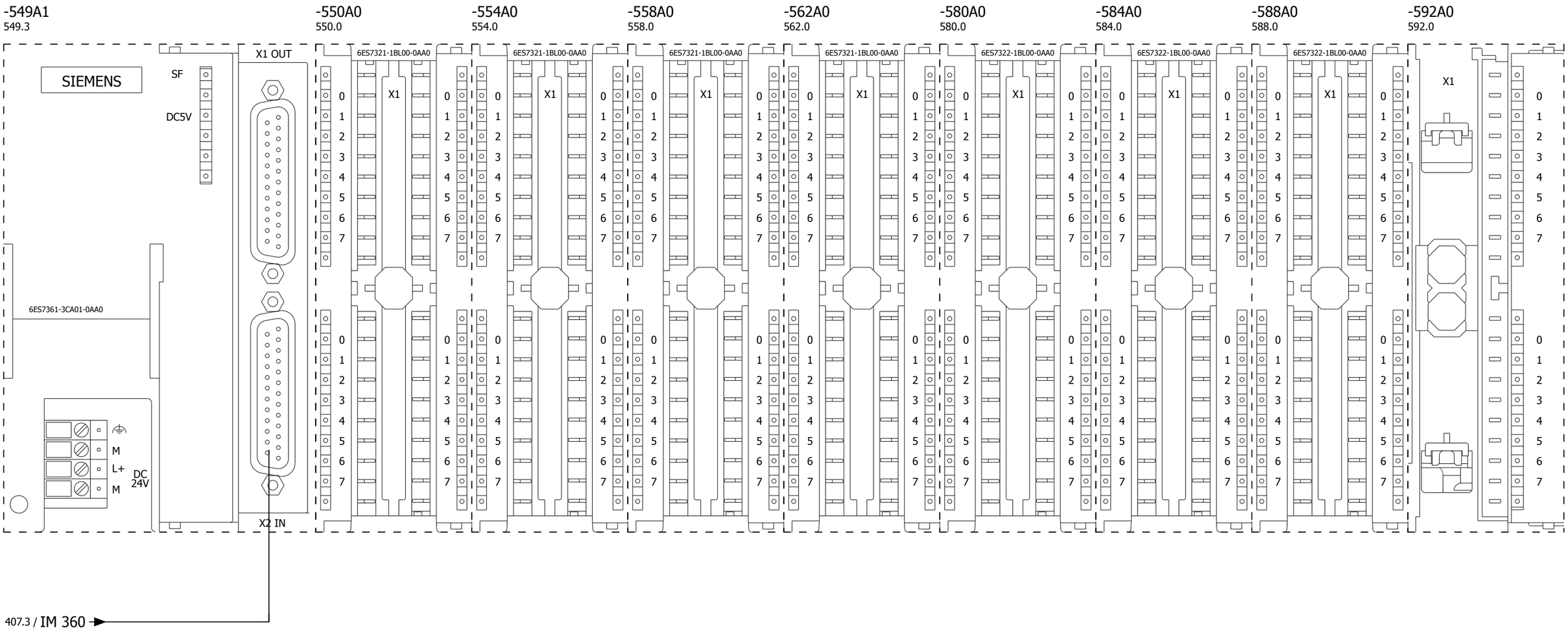


406

408

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 407
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



⇦407

409⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 408
Revision			Replacement of / Replaced by			Group:	Of 414

121.4 / 24V-L13 → 24Vdc

167.9 / 0V2 →

24V-L13 / 420.0

0V2 / 410.0

PROFIBUS 2 / 650.0

-409A5
A97.05.5
PROFIBUS
EMG

-409A6
PROFIBUS
DIGITEC

405.1 / PROFIBUS 0 →

PROFIBUS 3 / 415.1

PROFIBUS 4 / 417.1

-409A1

L+	M	PE	M5.2								
1	2	3	4	5	6	7	8	9	10	11	12
				A1	B1	A1`	B1`	A2	B2	A2`	B2`

CONTACTS 6ES7972-0AA01-0XA0 RS 485-REPEATER SIEMENS

CONSOLES AND ENTRY BOX, LEVELLER 1, LEVELLER 2 AND STACKER PROFIBUS

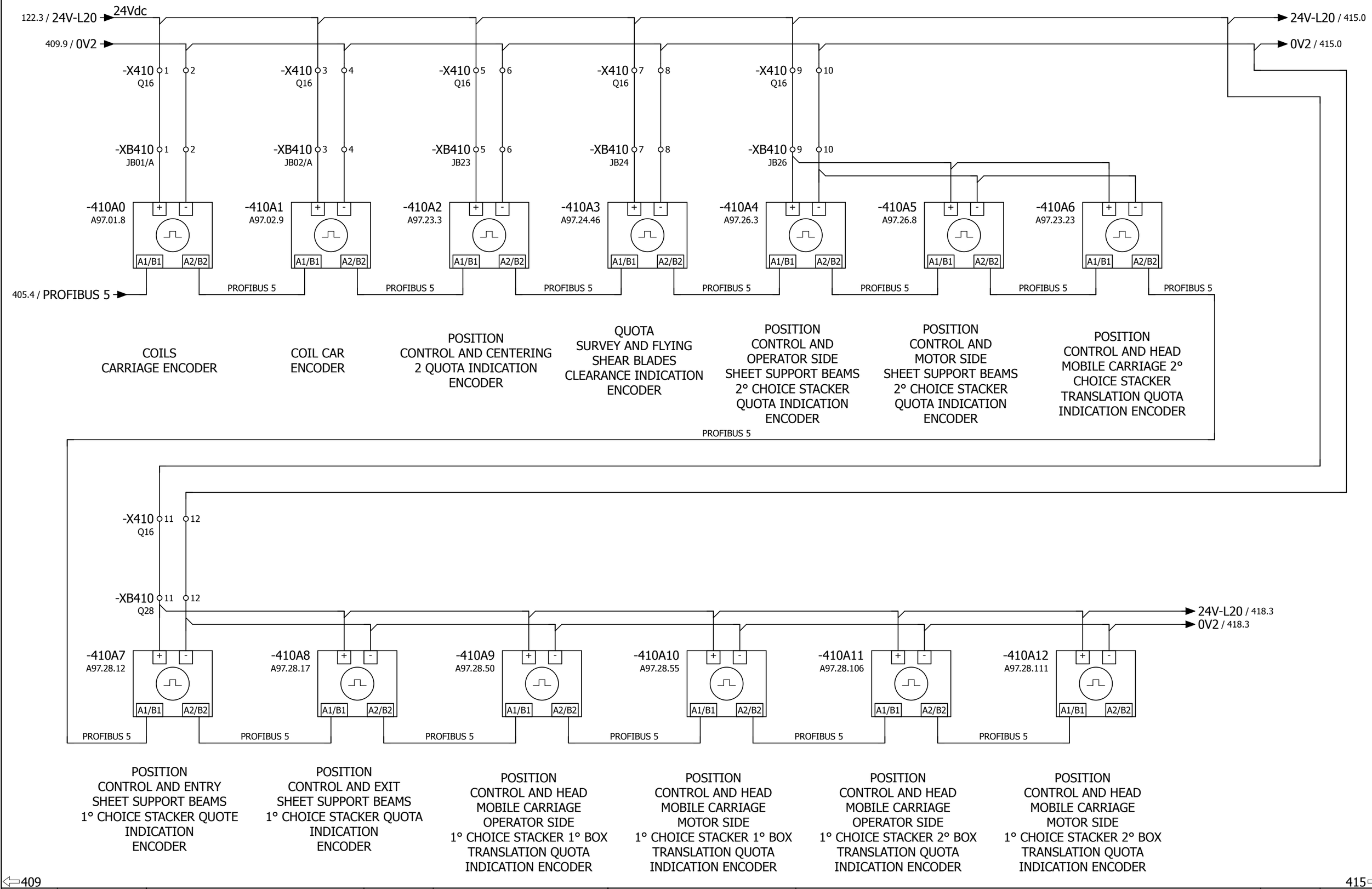
POTENTIOMETERS PROFIBUS

POTENTIOMETERS PROFIBUS

⇦408

410⇨

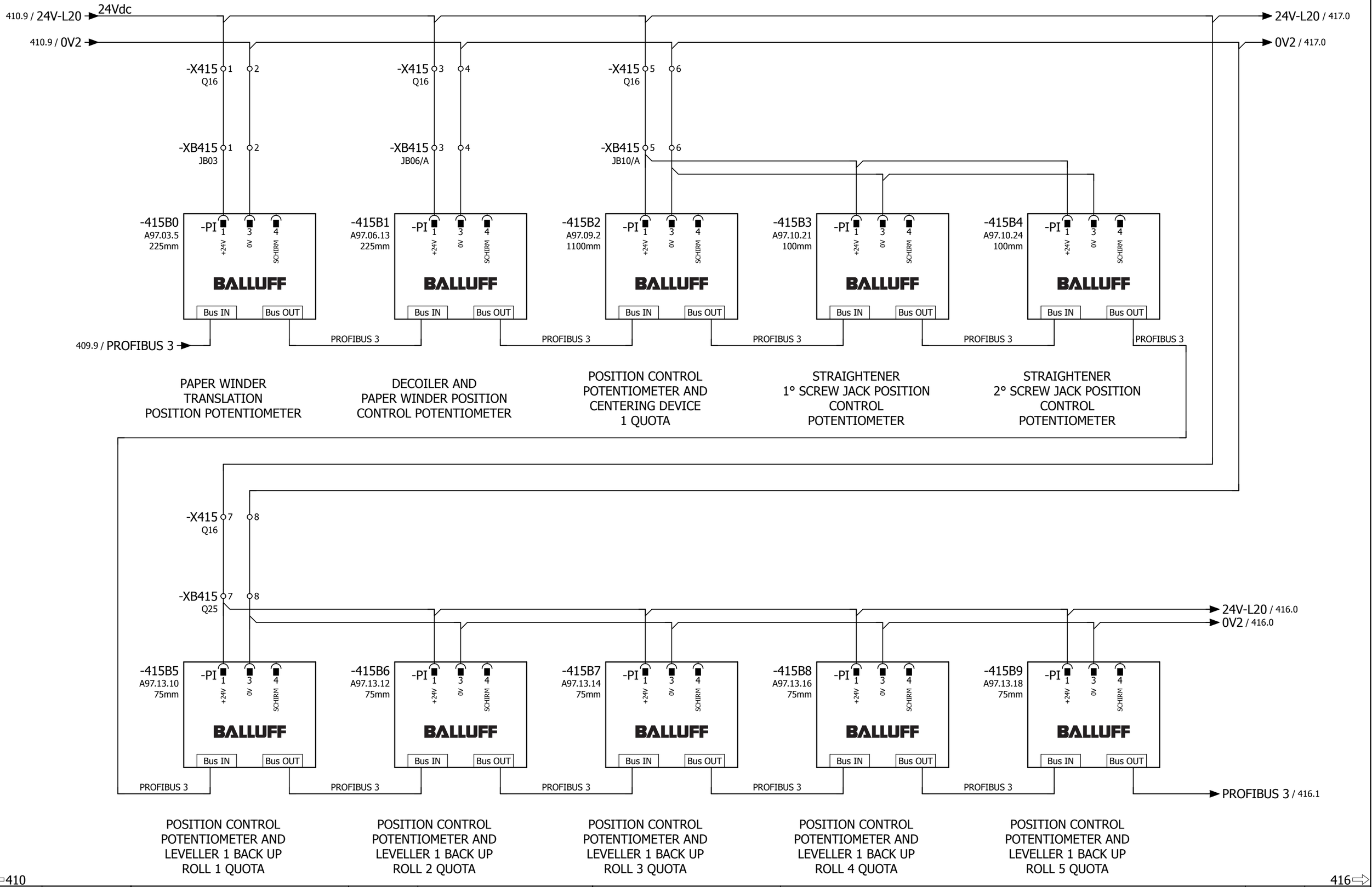
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Repeater profibus		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	409
Revision		Replacement of	Replaced by			Group:	Of 414



⇦409

415⇨

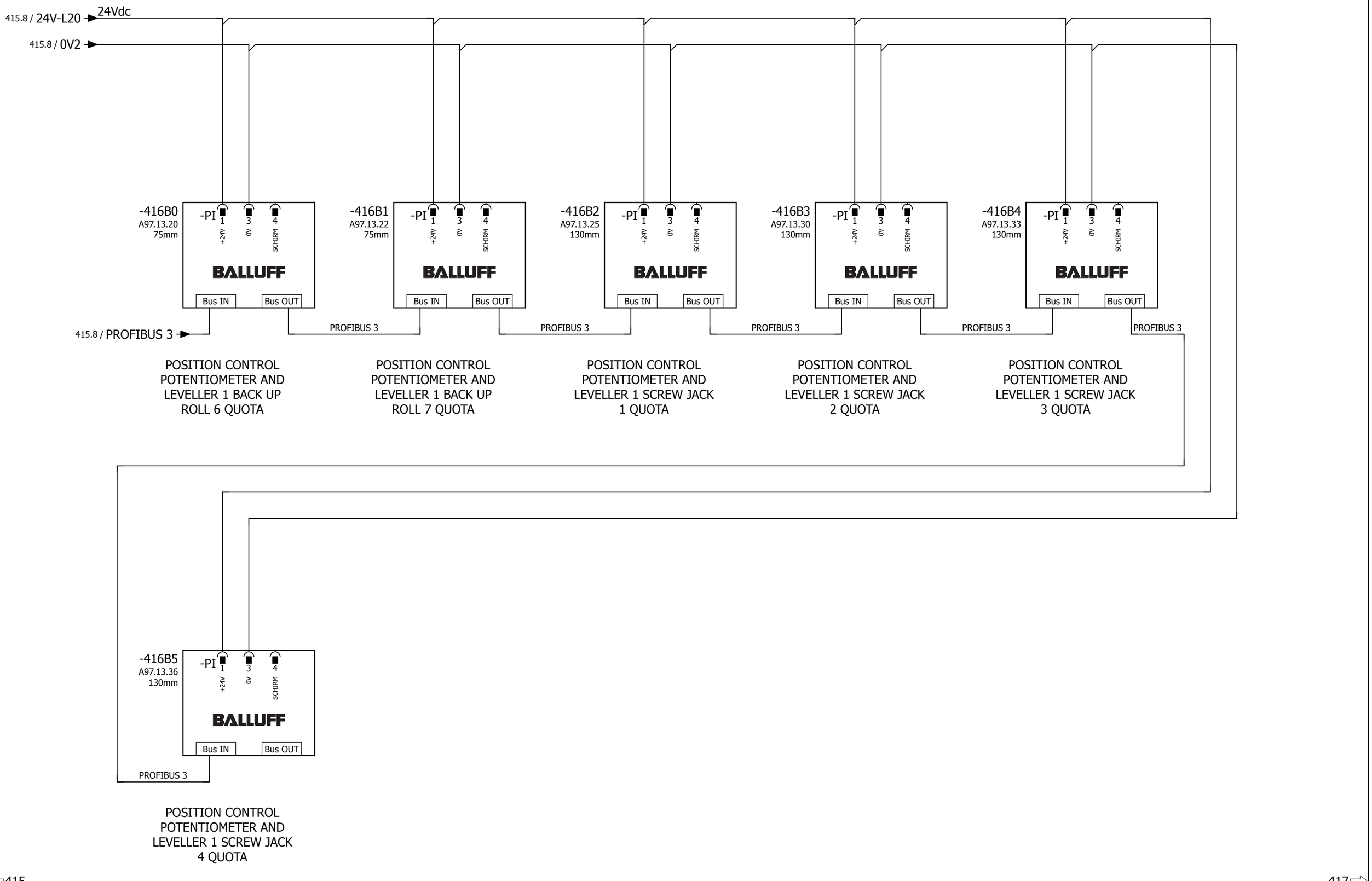
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Profibus encoder supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	410
Revision		Replacement of	Replaced by			Group:	Of 414



⇦410

416⇨

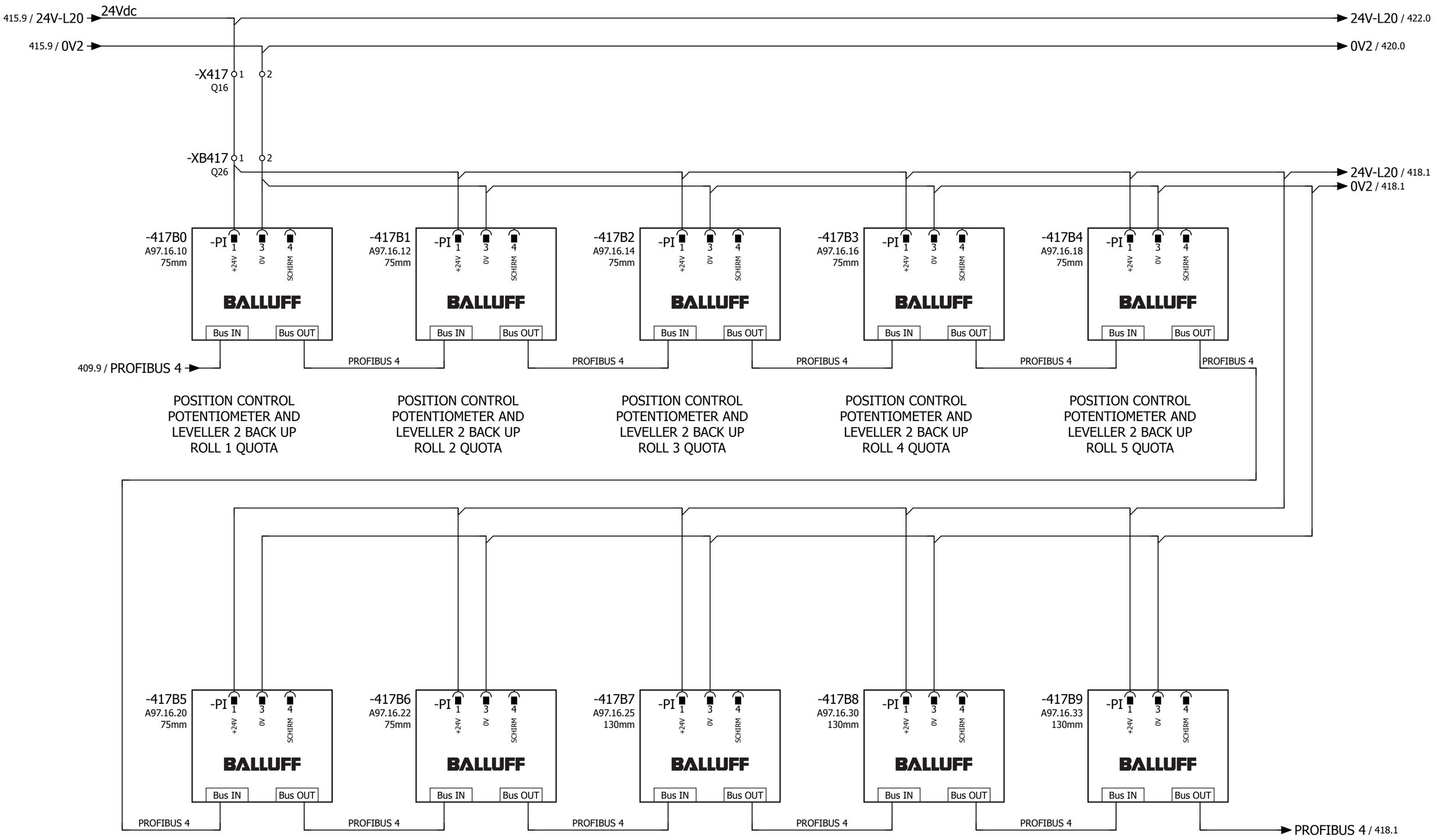
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Profibus potentiometer supply		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	415
Revision						Group:	Of 414



⇦415

417⇨

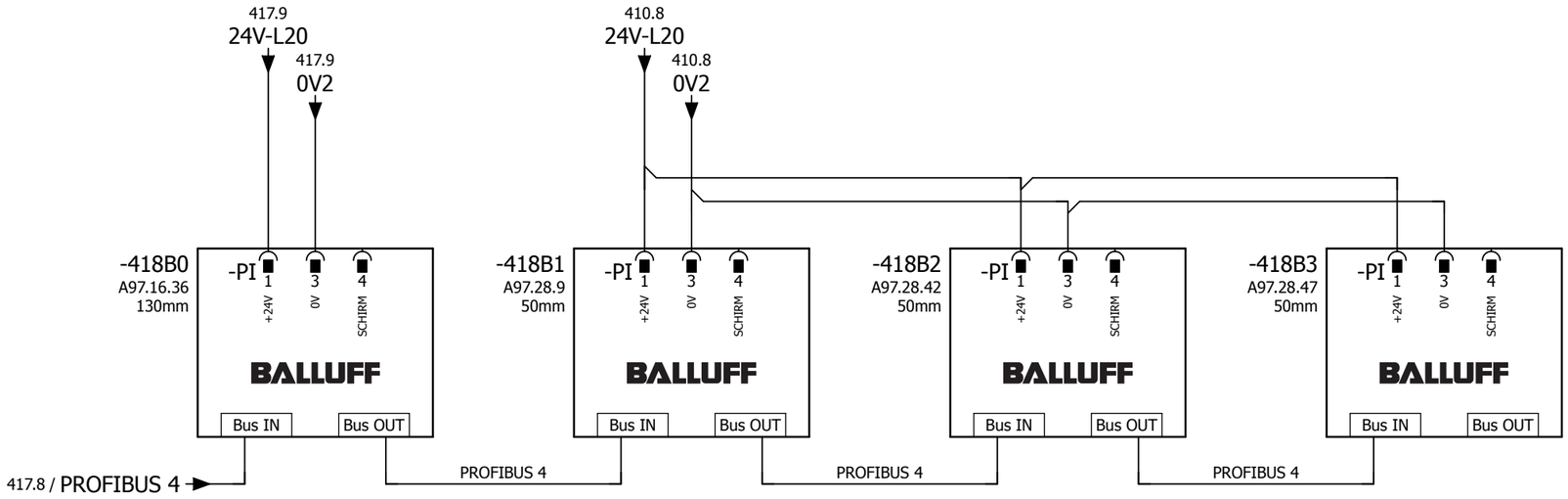
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Profibus potentiometer supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	416
Revision		Replacement of	Replaced by			Group:	Of 414



⇦416

418⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Profibus potentiometer supply		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 417
Revision			Replacement of / Replaced by			Group:	Of 414



POSITION CONTROL
POTENTIOMETER AND
LEVELLER 2 SCREW JACK
4 QUOTA

POSITION CONTROL
POTENTIOMETER AND
FEEDING PINCH ROLL
UPPER ROLL PENETRATION
QUOTA

POSITION CONTROL
POTENTIOMETER AND
OPERATOR SIDE
1° AND 2° SHEET CONVEYOR
QUOTA 1° CHOICE
STACKER FROM
1° BOX TO 2° BOX

POSITION CONTROL
POTENTIOMETER AND
MOTOR SIDE
1° AND 2° SHEET CONVEYOR
QUOTA 1° CHOICE
STACKER FROM
1° BOX TO 2° BOX

⇦417

420⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Profibus potentiometer supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	418
Revision		Replacement of	Replaced by			Group:	Of 414

409.9 / -24V-L13 → 24Vdc → -24V-L13 / 421.0

417.9 / -0V2 → -0V2 / 421.0

-420A1
405.0

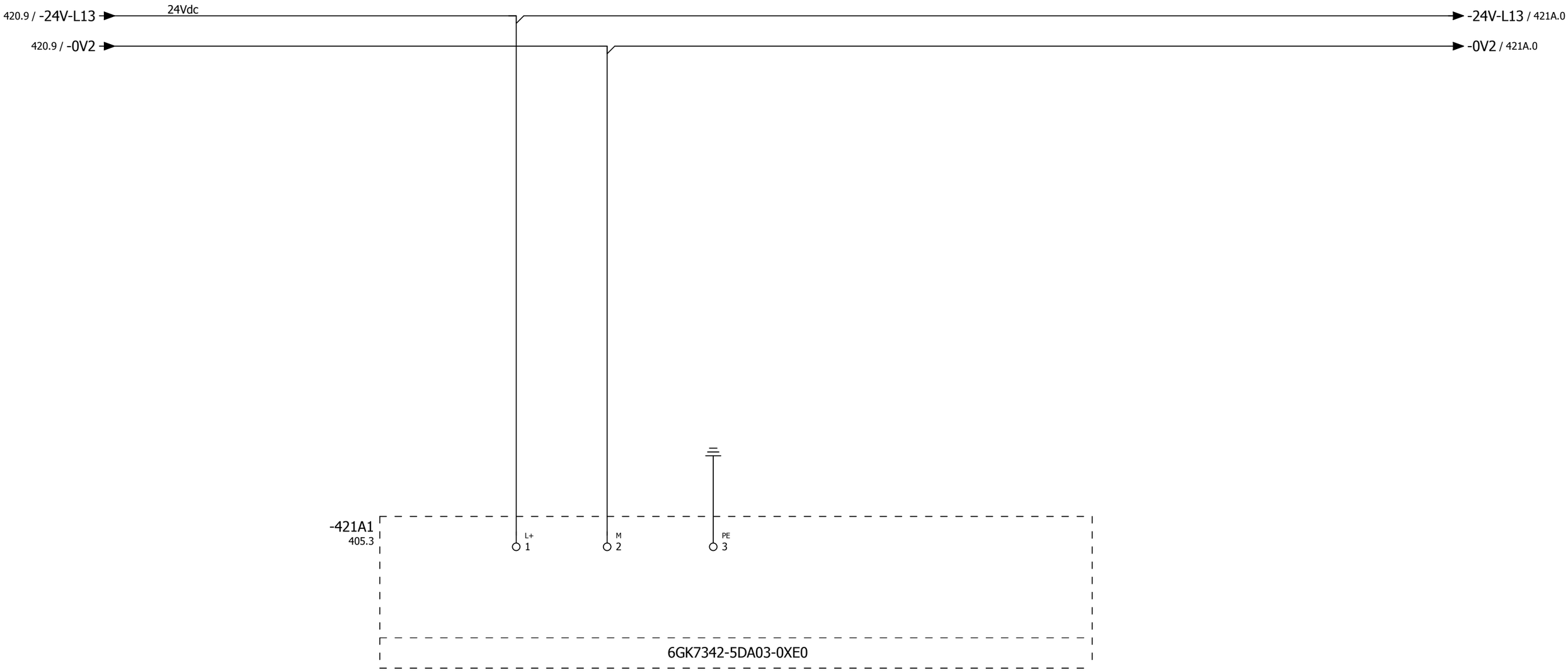
L+ 1
M 2

6ES7318-3EL01-0AB0 CPU 319-3 PN/DP SIEMENS

⇦418

421⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cpu		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	420
Revision		Replacement of	Replaced by			Group:	Of 414



⇦420

421A⇨

Date	16/09/2013	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Profibus card		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 421
Revision		Replacement of	Replaced by			Group:	Of 414

421.9 / -24V-L13 → 24Vdc

421.9 / -0V2 →

-24V-L13 / 429.0

-0V2 / 422.0

-421A2
405.4

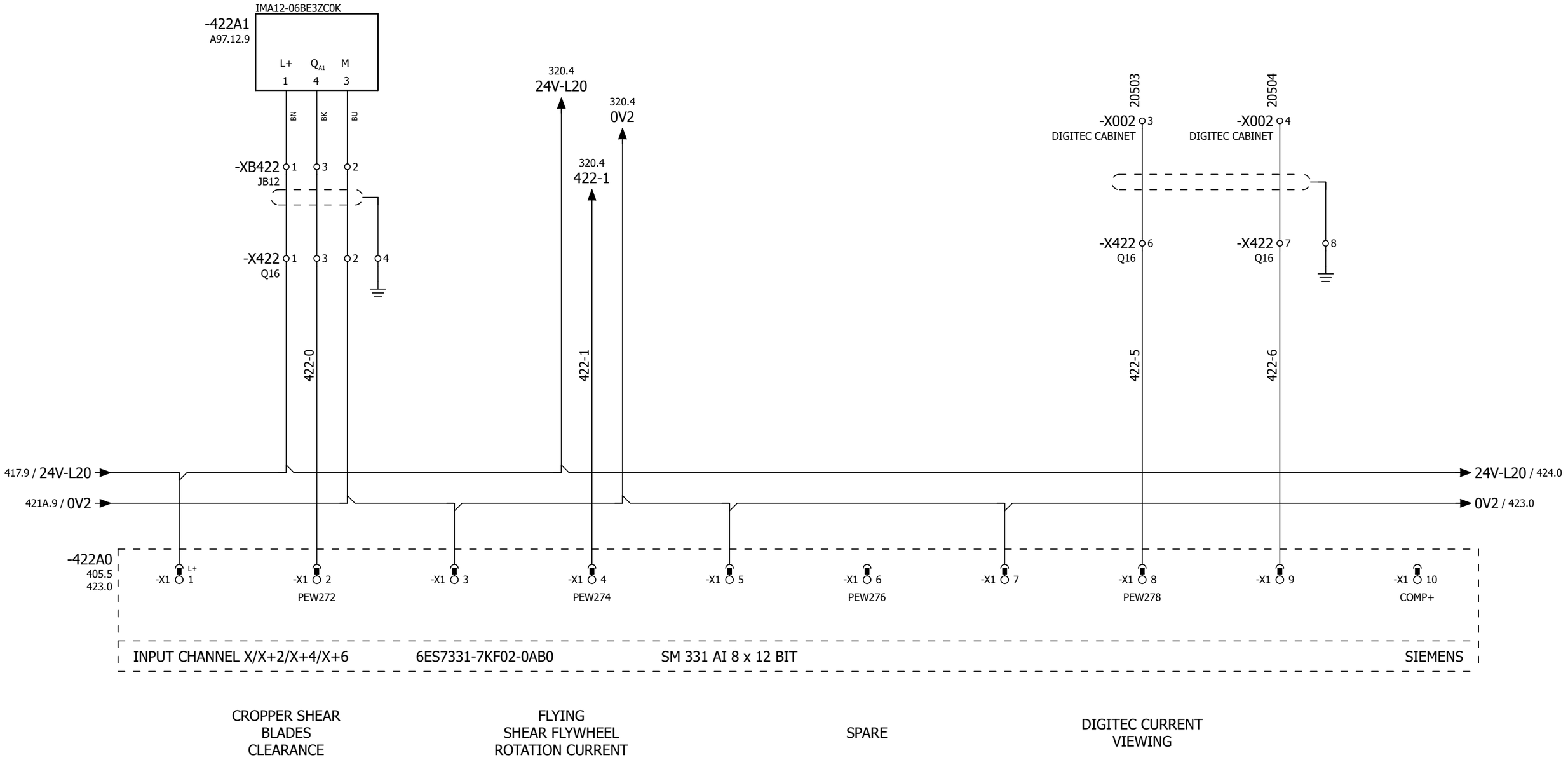
PE 1 | M 2 | L+ 3 | M 4

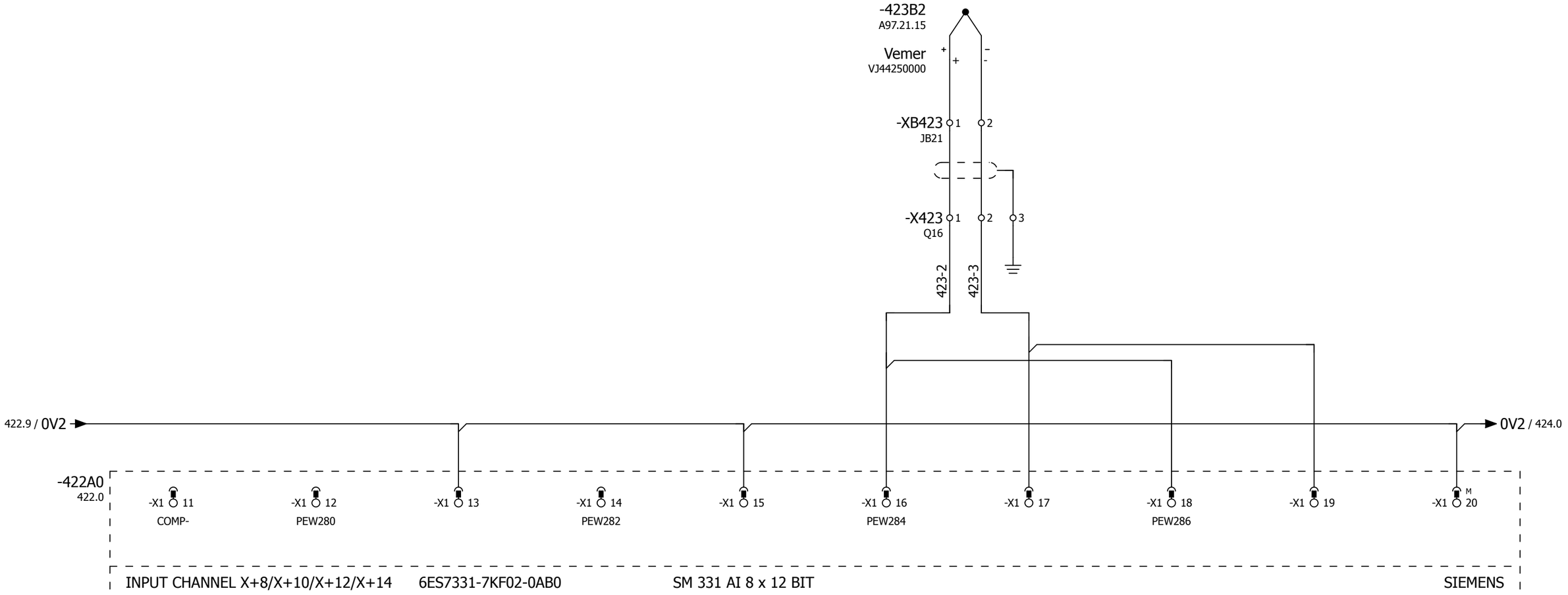
6ES7341-1CH02-0AE0 CP 341 RS422/485 SIEMENS

⇦421

422⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: CP 341		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 421A
Revision		Replacement of	Replaced by			Group:	Of 414


IMA12-06BE3ZC0K
-422A1
A97.12.9
L+ 1
Q_A1 4
M 3
BN
BK
BU
-XB422
JB12
-X422
Q16
422-0
320.4
24V-L20
320.4
0V2
320.4
422-1
422-1
20503
20504
-X002
DIGITEC CABINET
-X422
Q16
422-5
422-6
417.9 / 24V-L20
421A.9 / 0V2
24V-L20 / 424.0
0V2 / 423.0
-422A0
405.5
423.0
-X1 1 L+
-X1 2
PEW272
-X1 3
-X1 4
PEW274
-X1 5
-X1 6
PEW276
-X1 7
-X1 8
PEW278
-X1 9
-X1 10
COMP+
INPUT CHANNEL X/X+2/X+4/X+6
6ES7331-7KF02-0AB0
SM 331 AI 8 x 12 BIT
SIEMENS
CROPPER SHEAR
BLADES
CLEARANCE
FLYING
SHEAR FLYWHEEL
ROTATION CURRENT
SPARE
DIGITEC CURRENT
VIEWING



⇦422

424⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Analog input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 423
Revision		Replacement of	Replaced by			Group:	Of 414

-424A0
405.6
424.0

ENCODERS A0-A7 — 6ES7350-2AH01-0AE0 — FM 350-2 COUNTER MODULE — SIEMENS

PW288-302

A0 -X1 3 · A1 -X1 4 · A2 -X1 5 · A3 -X1 6 · A4 -X1 23 · A5 -X1 24 · A6 -X1 25 · A7 -X1 26

424-0 · 424-2 · 424-4 · 424-6 · 424-8

-X424 Q16 3 · 8 · 13 · 18 · 23

-424A1 A97.30.44 EL63E1000S5/28P10X3MR
-424A2 A97.30.3 EL63E1000S5/28P10X3MR
-424A3 A97.30.7 EL63E1000S5/28P10X3MR
-424A4 A97.30.22 EL63E1000S5/28P10X3MR
-424A5 A97.30.33 EL63E1000S5/28P10X3MR

C E F A

-X424 Q16 4 1 2 5 · 9 6 7 10 · 14 11 12 15 · 19 16 17 20 · 24 21 22 25

424-1 · 424-3 · 424-5 · 424-7 · 424-9

422.9 / 24V-L20 → 24V-L20 / 425.0

423.9 / 0V2 → 0V2 / 425.0

-424A0
424.0

-X1 7 B0 · -X1 8 B1 · -X1 9 B2 · -X1 10 B3 · -X1 27 B4 · -X1 28 B5 · -X1 29 B6 · -X1 30 B7

-X1 21 L+ · -X1 22 M

ENCODERS B0 - B7 — 6ES7350-2AH01-0AE0 — FM 350-2 COUNTER MODULE — SIEMENS

PACKAGE ADVANCE FOR STRAPPING INSERTION POSITION	ROTATION CONTROL 1° PACKAGE FORMING ROLL TRANSLATION 1° CHOICE STACKER 1° BOX	ROTATION CONTROL 2° PACKAGE FORMING ROLL TRANSLATION 1° CHOICE STACKER 2° BOX	ROTATION CONTROL 1° COMBINED TRANSFER PLATFORM TRANSLATION 1° CHOICE STACKER 1° BOX ROLLS	ROTATION CONTROL 2° COMBINED TRANSFER PLATFORM TRANSLATION 1° CHOICE STACKER 2° BOX ROLLS	SPARE	SPARE	SPARE

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: FM350		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	424
Revision						Group:	Of 414

-425A0
405.7
425.0

ENCODERS A0-A7 | 6ES7350-2AH01-0AE0 | FM 350-2 COUNTER MODULE | SIEMENS

PW304-318

A0 -X1 3 | A1 -X1 4 | A2 -X1 5 | A3 -X1 6 | A4 -X1 23 | A5 -X1 24 | A6 -X1 25 | A7 -X1 26

425-0 -X425 3 Q16 | 425-2 -X425 8 Q16 | 425-4 -X425 13 Q16 | 425-6 -X425 18 Q16

-425A1 A97.30.11 EL63E1000S5/28P10X3MR
-425A2 A97.30.17 EL63E1000S5/28P10X3MR
-425A3 A97.30.59 EL63E1000S5/28P10X3MR
-425A4 A97.30.70 EL63E1000S5/28P10X3MR

C E F A

-X425 4 1 2 5 (425-1) | -X425 9 6 7 10 (425-3) | -X425 14 11 12 15 (425-5) | -X425 19 16 17 20 (425-7)

424.9 / 24V-L20 → 24V-L20 / 462.0

424.9 / 0V2 → 0V2 / 429.0

-425A0
425.0

-X1 7 B0 | -X1 8 B1 | -X1 9 B2 | -X1 10 B3 | -X1 27 B4 | -X1 28 B5 | -X1 29 B6 | -X1 30 B7

-X1 L+ 21 -X1 M 22

ENCODERS B0 - B7 | 6ES7350-2AH01-0AE0 | FM 350-2 COUNTER MODULE | SIEMENS

ROTATION CONTROL 1° WEIGHING TRANSFER PLATFORM TRANSLATION 1° CHOICE STACKER 1° BOX FOR DOWNLOAD PALLET	ROTATION CONTROL 2° WEIGHING TRANSFER PLATFORM TRANSLATION 1° CHOICE STACKER 2° BOX FOR DOWNLOAD PALLET	ROTATION CONTROL 1° COMBINED TRANSFER PLATFORM PACKAGE TRANSLATION ROLLS AFTER STRAPPING MACHINE	ROTATION CONTROL 2° COMBINED TRANSFER PLATFORM PACKAGE TRANSLATION ROLLS AFTER STRAPPING MACHINE	SPARE	SPARE	SPARE	SPARE

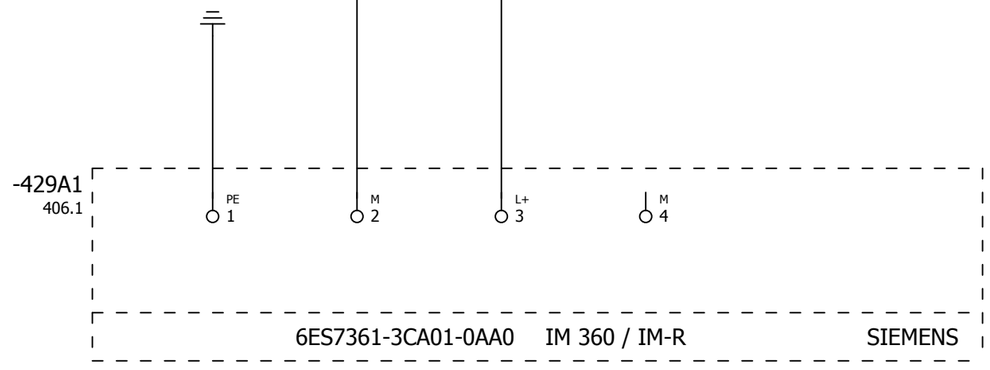
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: FM350		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	425
Revision						Group:	Of 414

421A.9 / -24V-L13 → 24Vdc

425.9 / -0V2 →

-24V-L13 / 461.0

-0V2 / 430.8



⇦425

430⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 361 supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	429
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

LINE HYDRAULIC UNIT PUMP	SPARE	HEATER EXCHANGER FOR LINE HYDRAULIC UNIT OIL COOLING	OIL RECYCLE PUMP	SPARE	SPARE	UNCOILER OIL LUBRICATION	SPARE

-430A0 OUTPUT BYTE X — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

431.0
432.0
433.0
406.3

A0.0 A0.1 A0.2 A0.3 A0.4 A0.5 A0.6 A0.7

-X1 1 (1L+) | -X1 2 | -X1 3 | -X1 4 | -X1 5 | -X1 6 | -X1 7 | -X1 8 | -X1 9 | -X1 10 (1M)

121.3 / -24V-L12 → -24V-L12 / 431.0

429.9 / -0V2 → -0V2 / 431.8

430-0 | 430-1 | 430-2 | 430-3 | 430-4 | 430-5 | 430-6 | 430-7

-430A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

190.4 / -110-Z0 → 110Vac → -110-Z0 / 432.1

190.1 / -110-Z1 → -110-Z1 / 431.1

430-8 | 430-12 | 430-14 | 430-20

-430K1 A1/A2 | -430K3 A1/A2 | -430K4 A1/A2 | -430K7 A1/A2

430.9 / -110-N → -110-N / 430.1

3RT1045-1AG20
1 2 300.1
3 4 300.1
5 6 300.1

3RT1023-1AG20
1 2 300.5
3 4 300.5
5 6 300.5

3RT1023-1AG20
1 2 300.7
3 4 300.7
5 6 300.7

3RT1023-1AG20
1 2 301.5
3 4 301.5
5 6 301.5

⇦429

431⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 430
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

PAPER WINDER ROTATION FORWARD	PAPER WINDER ROTATION BACKWARD	SPARE	SPARE	DECOILER COOLING MOTOR	SPARE	SPARE	SPARE

-430A0 OUTPUT BYTE X+1 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

430.0

A1.0 A1.1 A1.2 A1.3 A1.4 A1.5 A1.6 A1.7

-X1 11 (2L+) -X1 12 -X1 13 -X1 14 -X1 15 -X1 16 -X1 17 -X1 18 -X1 19 -X1 20 (2M)

430.1 / -24V-L12 → -24V-L12 / 432.0

430.9 / -0V2 → -0V2 / 432.8

431-0 431-1 431-2 431-3 431-4 431-5 431-6 431-7

-431A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

430.9 / -110-Z1 → 110Vac → -110-Z1 / 432.1

431-8 431-10 431-16

431K2 431.2 (21 / 22) 431K1 431.2 (21 / 22)

431-9 431-11

-431K1 (A1 / A2) -431K2 (A1 / A2) -431K5 (A1 / A2)

431.9 / -110-N → -110-N / 431.1

3RT1024-1AG20
1 2 302.1
3 4 302.1
5 6 302.1
21 22 431.2

3RT1024-1AG20
1 2 302.2
3 4 302.2
5 6 302.2
21 22 431.2

3RT1023-1AG20
1 2 302.5
3 4 302.5
5 6 302.6

430

432

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 431
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

SPARE	SPARE	STRAIGHTENER ENTRY PINCH ROLL COOLING MOTOR	STRAIGHTENER COOLING MOTOR	STRAIGHTENER SCREW JACK 1 UP	STRAIGHTENER SCREW JACK 1 DOWN	STRAIGHTENER SCREW JACK 2 UP	STRAIGHTENER SCREW JACK 2 DOWN

-430A0 OUTPUT BYTE X+2 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

430.0

A2.0 A2.1 A2.2 A2.3 A2.4 A2.5 A2.6 A2.7

-X1 21 (3L+) -X1 22 -X1 23 -X1 24 -X1 25 -X1 26 -X1 27 -X1 28 -X1 29 -X1 30 (3M)

431.1 / -24V-L12 → -24V-L12 / 433.0

431.9 / -0V2 → -0V2 / 433.8

432-0 432-1 432-2 432-3 432-4 432-5 432-6 432-7

-432A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

430.9 / -110-Z0 → 110Vac → -110-Z0 / 434.1

431.9 / -110-Z1 → -110-Z1 / 433.1

432-12 432-14 432-16 432-18 432-20 432-22

432K6 432.6 — 21 / 22 — 432-17

432K5 432.5 — 21 / 22 — 432-19

432K8 432.8 — 21 / 22 — 432-21

432K7 432.7 — 21 / 22 — 432-23

-432K3 -432K4 -432K5 -432K6 -432K7 -432K8 (A1 / A2)

432.9 / -110-N → -110-N / 432.1

3RT1023-1AG20
1 2 303.5
3 4 303.5
5 6 303.5

3RT1023-1AG20
1 2 303.7
3 4 303.7
5 6 303.7

3RT1023-1AG20
1 2 304.1
3 4 304.1
5 6 304.1
13 14 360.7
21 22 432.6

3RT1023-1AG20
1 2 304.2
3 4 304.2
5 6 304.2
13 14 360.7
21 22 432.5

3RT1023-1AG20
1 2 304.3
3 4 304.3
5 6 304.3
13 14 361.2
21 22 432.8

3RT1023-1AG20
1 2 304.4
3 4 304.4
5 6 304.4
13 14 361.2
21 22 432.7

⇦431

433⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 432
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

PAPER WINDER JOINT	SPARE	CROPPER SHEAR BLADES CLEARANCE +	CROPPER SHEAR BLADES CLEARANCE -	SPARE	SPARE	LEVELLER 1 COOLING MOTOR	SPARE

-430A0
430.0
OUTPUT BYTE X+3 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

	A3.0	A3.1	A3.2	A3.3	A3.4	A3.5	A3.6	A3.7	
-X1	31 (4L+)	32	33	34	35	36	37	38	39	40 (4M)

432.1 / -24V-L12 → -24V-L12 / 434.0

432.9 / -0V2 → -0V2 / 434.8

433-0 · 433-1 · 433-2 · 433-3 · 433-4 · 433-5 · 433-6 · 433-7

-433A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
	COM 11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

432.9 / -110-Z1 → 110Vac → -110-Z1 / 436.1

433-8 · 433-12 · 433-14 · 433-20

433K4 (433.4): 21 / 22 — 433-13

433K3 (433.3): 21 / 22 — 433-15

	-433K1	-433K3	-433K4	-433K7
A1				
A2				

433.9 / -110-N → -110-N / 433.1

3RT1023-1AG20
1 2 380.1
3 4 380.1
5 6

3RT1023-1AG20
1 2 306.1
3 4 306.1
5 6 306.1
13 14 361.3
21 22 433.4

3RT1023-1AG20
1 2 306.2
3 4 306.2
5 6 306.2
13 14 361.4
21 22 433.3

3RT1023-1AG20
1 2 312.1
3 4 312.1
5 6 312.1

⇦432

434⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Digital output	=	
Drawing	13B01					+	
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	433
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

LEVELLER 1 SCREW JACK 1 UP
LEVELLER 1 SCREW JACK 1 DOWN
LEVELLER 1 SCREW JACK 2 UP
LEVELLER 1 SCREW JACK 2 DOWN
LEVELLER 1 SCREW JACK 3 UP
LEVELLER 1 SCREW JACK 3 DOWN
LEVELLER 1 SCREW JACK 4 UP
LEVELLER 1 SCREW JACK 4 DOWN

-434A0 OUTPUT BYTE X 6ES7322-1BL00-0AA0 SM 322 DO 32 x DC24V/0,5A SIEMENS
435.0
436.0
437.0
406.4

A4.0 A4.1 A4.2 A4.3 A4.4 A4.5 A4.6 A4.7

-X1 1 (1L+) -X1 2 -X1 3 -X1 4 -X1 5 -X1 6 -X1 7 -X1 8 -X1 9 -X1 10 (1M)

433.1 / -24V-L12 → -24V-L12 / 435.0

434-0 434-1 434-2 434-3 434-4 434-5 434-6 434-7

433.9 / -0V2 → -0V2 / 435.8

-434A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

432.9 / -110-Z0 → 110Vac

-110-Z0 / 435.1

434-8 434-10 434-12 434-14 434-16 434-18 434-20 434-22

434K2 434.2 | 434K1 434.2 | 434K4 434.4 | 434K3 434.3 | 434K6 434.6 | 434K5 434.5 | 434K8 434.8 | 434K7 434.7

21 22

434-9 434-11 434-13 434-15 434-17 434-19 434-21 434-23

-434K1 -434K2 -434K3 -434K4 -434K5 -434K6 -434K7 -434K8

A1 A2

434.9 / -110-N →

-110-N / 434.1

3RT1025-1AG20

1 2 312.3	1 2 312.4	1 2 312.5	1 2 312.6	1 2 312.7	1 2 312.8	1 2 313.1	1 2 313.2
3 4 312.3	3 4 312.4	3 4 312.5	3 4 312.6	3 4 312.7	3 4 312.8	3 4 313.1	3 4 313.2
5 6 312.3	5 6 312.4	5 6 312.5	5 6 312.6	5 6 312.7	5 6 312.8	5 6 313.1	5 6 313.2
13 14 364.3	13 14 364.4	13 14 364.5	13 14 364.6	13 14 364.7	13 14 364.7	13 14 365.2	13 14 365.2
21 22 434.2	21 22 434.2	21 22 434.4	21 22 434.3	21 22 434.6	21 22 434.5	21 22 434.8	21 22 434.7

433

435

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output
Drawing	13B01		Comm: A97		Installation: Linea taglio trasversale
Drawer	Tengattini Marco		Replacement of / Replaced by		Group:
Revision					Page 434 Of 414

0	1	2	3	4	5	6	7	8	9

SPARE	LEVELLER 1 SLIDING JOINTS OIL LEVEL	LEVELLER 1 OPERATOR SIDE CLEANING WORK ROLLS	LEVELLER 1 MOTOR SIDE CLEANING WORK ROLLS	LEVELLER 1 BENCH IN LINE	LEVELLER 1 BENCH OUT OF LINE	LOWER PAPER 1 HEATING	LOWER PAPER 2 HEATING

-434A0
434.0
OUTPUT BYTE X+1 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A5.0 A5.1 A5.2 A5.3 A5.4 A5.5 A5.6 A5.7

-X1 11 (2L+) -X1 12 -X1 13 -X1 14 -X1 15 -X1 16 -X1 17 -X1 18 -X1 19 -X1 20 (2M)

434.1 / -24V-L12 → -24V-L12 / 436.0

435-0 435-1 435-2 435-3 435-4 435-5 435-6 435-7

434.9 / -0V2 → -0V2 / 436.8

-435A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

434.9 / -110-Z0 → 110Vac → -110-Z0 / 436.1

435-10 435-12 435-14 435-16 435-18 435-20 435-22

435K4 435.4 (21/22) 435K3 435.3 (21/22) 435K6 435.6 (21/22) 435K5 435.5 (21/22)

435-13 435-15 435-17 435-19

-435K2 -435K3 -435K4 -435K5 -435K6 -435K7 -435K8 (A1/A2)

435.9 / -110-N → -110-N / 435.1

3RT1023-1AG20
1 2 313.5
3 4 313.5
5 6 313.5

3RT1023-1AG20
1 2 313.7
3 4 313.7
5 6 313.7
21 22 435.4

3RT1023-1AG20
1 2 313.8
3 4 313.8
5 6 313.8
21 22 435.3

3RT1023-1AG20
1 2 314.1
3 4 314.1
5 6 314.1
21 22 435.6

3RT1023-1AG20
1 2 314.2
3 4 314.2
5 6 314.2
21 22 435.5

3RT1026-1AG20
1 2 381.1
3 4 381.1
5 6

3RT1026-1AG20
1 2 381.3
3 4 381.3
5 6

⇦434
436⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	435
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

LEVELLER 2 COOLING MOTOR | LEVELLER 2 SCREW JACK 1 UP | LEVELLER 2 SCREW JACK 1 DOWN | LEVELLER 2 SCREW JACK 2 UP | LEVELLER 2 SCREW JACK 2 DOWN | LEVELLER 2 SCREW JACK 3 UP | LEVELLER 2 SCREW JACK 3 DOWN | SPARE

-434A0
434.0
OUTPUT BYTE X+2 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A6.0 A6.1 A6.2 A6.3 A6.4 A6.5 A6.6 A6.7

-X1 21 3L+ | -X1 22 | -X1 23 | -X1 24 | -X1 25 | -X1 26 | -X1 27 | -X1 28 | -X1 29 | -X1 30 3M

435.1 / -24V-L12 → -24V-L12 / 437.0

435.9 / -0V2 → -0V2 / 437.8

436-0 | 436-1 | 436-2 | 436-3 | 436-4 | 436-5 | 436-6 | 436-7

-436A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

435.9 / -110-Z0 → 110Vac → -110-Z0 / 437.1

433.9 / -110-Z1 → -110-Z1 / 438.1

436-8 | 436-10 | 436-12 | 436-14 | 436-16 | 436-18 | 436-20

436K3 436.3 | 436K2 436.2 | 436K5 436.5 | 436K4 436.4 | 436K7 436.7 | 436K6 436.6

436-11 | 436-13 | 436-15 | 436-17 | 436-19 | 436-21

-436K1 | -436K2 | -436K3 | -436K4 | -436K5 | -436K6 | -436K7

436.9 / -110-N → -110-N / 436.1

3RT1023-1AG20
1 2 315.1
3 4 315.1
5 6 315.1

3RT1023-1AG20
1 2 315.3
3 4 315.3
5 6 315.3
13 14 365.3
21 22 436.3

3RT1023-1AG20
1 2 315.4
3 4 315.4
5 6 315.4
13 14 365.4
21 22 436.2

3RT1023-1AG20
1 2 315.5
3 4 315.5
5 6 315.5
13 14 365.5
21 22 436.5

3RT1023-1AG20
1 2 315.6
3 4 315.6
5 6 315.6
13 14 365.6
21 22 436.4

3RT1023-1AG20
1 2 315.7
3 4 315.7
5 6 315.7
13 14 365.7
21 22 436.7

3RT1023-1AG20
1 2 315.8
3 4 315.8
5 6 315.8
13 14 365.7
21 22 436.6

0	1	2	3	4	5	6	7	8	9

LEVELLER 2 SCREW JACK 4 UP	LEVELLER 2 SCREW JACK 4 DOWN	SPARE	LEVELLER 2 SLIDING JOINTS OIL LEVEL	LEVELLER 2 OPERATOR SIDE CLEANING WORK ROLLS	LEVELLER 2 MOTOR SIDE CLEANING WORK ROLLS	LEVELLER 2 BENCH IN LINE	LEVELLER 2 BENCH OUT OF LINE

-434A0 434.0 — OUTPUT BYTE X+3 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A7.0 A7.1 A7.2 A7.3 A7.4 A7.5 A7.6 A7.7

-X1 31 (4L+) — -X1 32 — -X1 33 — -X1 34 — -X1 35 — -X1 36 — -X1 37 — -X1 38 — -X1 39 — -X1 40 (4M)

436.1 / -24V-L12 → -24V-L12 / 438.0

436.9 / -0V2 → -0V2 / 438.8

437-0 — 437-1 — 437-2 — 437-3 — 437-4 — 437-5 — 437-6 — 437-7

-437A1 — 1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 — 21 24 22 — 31 34 32 — 41 44 42 — 51 54 52 — 61 64 62 — 71 74 72 — 81 84 82 COM

436.9 / -110-Z0 → 110Vac → -110-Z0 / 447.1

437-8 — 437-10 — 437-14 — 437-16 — 437-18 — 437-20 — 437-22

21 — 437K2 437.2 — 22 — 437K1 437.2 — 437K6 437.6 — 437K5 437.5 — 437K8 437.8 — 437K7 437.7

437-9 — 437-11 — 437-17 — 437-19 — 437-21 — 437-23

A1 — -437K1 — -437K2 — -437K4 — -437K5 — -437K6 — -437K7 — -437K8 — A2

437.9 / -110-N → -110-N / 437.1

3RT1023-1AG20
1 2 316.1
3 4 316.1
5 6 316.1
13 14 366.2
21 22 437.2

3RT1023-1AG20
1 2 316.2
3 4 316.2
5 6 316.2
13 14 366.2
21 22 437.2

3RT1023-1AG20
1 2 316.5
3 4 316.5
5 6 316.5

3RT1023-1AG20
1 2 316.7
3 4 316.7
5 6 316.7
21 22 437.6

3RT1023-1AG20
1 2 316.8
3 4 316.8
5 6 316.8
21 22 437.5

3RT1023-1AG20
1 2 317.1
3 4 317.1
5 6 317.1
21 22 437.8

3RT1023-1AG20
1 2 317.2
3 4 317.2
5 6 317.2
21 22 437.7

⇦436

438⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	437
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

PLASTICIZEN DEVICE COOLING MOTOR | SPARE | SPARE | MOTOR SIDE UPPER ROLLS SUPPORT TRANSLATION | OPERATOR SIDE UPPER ROLLS SUPPORT TRANSLATION | MOTOR SIDE LOWER ROLLS SUPPORT TRANSLATION | OPERATOR SIDE LOWER ROLLS SUPPORT TRANSLATION | SPARE

-438A0 439.0 440.0 441.0 406.5 — OUTPUT BYTE X — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

-X1 1 (1L+) — A8.0 -X1 2 — A8.1 -X1 3 — A8.2 -X1 4 — A8.3 -X1 5 — A8.4 -X1 6 — A8.5 -X1 7 — A8.6 -X1 8 — A8.7 -X1 9 — -X1 10 (1M)

437.1 / -24V-L12 → -24V-L12 / 439.0

438-0 — 438-1 — 438-2 — 438-3 — 438-4 — 438-5 — 438-6 — 438-7

437.9 / -0V2 → -0V2 / 439.8

-438A1 — 1 — 2 — 3 — 4 — 5 — 6 — 7 — 8

K0 — K1 — K2 — K3 — K4 — K5 — K6 — K7

COM 11 14 12 — 21 24 22 — 31 34 32 — 41 44 42 — 51 54 52 — 61 64 62 — 71 74 72 — 81 84 82 COM

436.9 / -110-Z1 → 110Vac → -110-Z1 / 439.1

438-8 — 438-14 — 438-16 — 438-18 — 438-20

438K5 438.5: 21 22 — 438K4 438.4: 21 22 — 438K7 438.7: 21 22 — 438K6 438.6: 21 22

438-15 — 438-17 — 438-19 — 438-21

-438K1 A1 A2 — -438K4 A1 A2 — -438K5 A1 A2 — -438K6 A1 A2 — -438K7 A1 A2

438.9 / -110-N → -110-N / 438.1

3RT1023-1AG20
1 2 318.1
3 4 318.1
5 6 318.1

3RT1023-1AG20
1 2 318.5
3 4 318.5
5 6 318.5
21 22 438.5

3RT1023-1AG20
1 2 318.6
3 4 318.6
5 6 318.6
21 22 438.4

3RT1023-1AG20
1 2 318.7
3 4 318.7
5 6 318.7
21 22 438.7

3RT1023-1AG20
1 2 318.8
3 4 318.8
5 6 318.8
21 22 438.6

⇦437

439⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	438
Revision		Replacement of	Replaced by			Group:	Of 414

CENTERING UNIT 2 MOTOR IN	CENTERING UNIT 2 MOTOR OUT	SPARE	SPARE	SPARE	SPARE	SPARE	SPARE

-438A0
438.0
OUTPUT BYTE X+1 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

	A9.0	A9.1	A9.2	A9.3	A9.4	A9.5	A9.6	A9.7	
-X1	11 (2L+)	12	13	14	15	16	17	18	19	20 (2M)

438.1 / -24V-L12 → -24V-L12 / 440.0

439-0 | 439-1 | 439-2 | 439-3 | 439-4 | 439-5 | 439-6 | 439-7

438.9 / -0V2 → -0V2 / 440.8

-439A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
	COM 11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

438.9 / -110-Z1 → 110Vac → -110-Z1 /

439-8 | 439-10

439K2 439.2: 21 / 22 — 439K1 439.2: 21 / 22

439-9 | 439-11

-439K1: A1 / A2 — -439K2: A1 / A2

439.9 / -110-N → -110-N / 439.1

3RT1023-1AG20

1 – 2	319.1	319.2
3 – 4	319.1	319.2
5 – 6	319.1	319.2
13 – 14	366.3	366.4
21 – 22	439.2	439.2

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440⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 439
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

SPARE | FLYING SHEAR FLYWHEEL MOTOR LINE | FLYING SHEAR FLYWHEEL MOTOR STAR | FLYING SHEAR FLYWHEEL MOTOR TRIANGLE | SPARE | FLYING SHEAR BLADES CLEARANCE + | FLYING SHEAR BLADES CLEARANCE - | ELECTROSTATIC BAR

-438A0
438.0
OUTPUT BYTE X+2 | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

A10.0 A10.1 A10.2 A10.3 A10.4 A10.5 A10.6 A10.7

-X1 21 3L+ | -X1 22 | -X1 23 | -X1 24 | -X1 25 | -X1 26 | -X1 27 | -X1 28 | -X1 29 | -X1 30 3M

439.1 / -24V-L12 → -24V-L12 / 441.0

439.9 / -0V2 → -0V2 / 441.8

440-0 | 440-1 | 440-2 | 440-3 | 440-4 | 440-5 | 440-6 | 440-7

-440A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

190.2 / -110-Z2 → 110Vac → -110-Z2 /

440-10 | 440-12 | 440-14 | 440-18 | 440-20 | 440-22

440K4 440.4 — 21 22
440K3 440.3 — 21 22
440K7 440.7 — 21 22
440K6 440.6 — 21 22

440-13 | 440-15 | 440-19 | 440-21

-440K2 A1 A2
-440K3 A1 A2
-440K4 A1 A2
-440K6 A1 A2
-440K7 A1 A2
-440K8 A1 A2

440.9 / -110-N → -110-N / 440.1

3RT1036-1AG20
1 2 320.3
3 4 320.3
5 6 320.3

3RT1034-1AG20
1 2 320.6
3 4 320.6
5 6 320.6
21 22 440.4

3RT1036-1AG20
1 2 320.5
3 4 320.5
5 6 320.5
21 22 440.3

3RT1023-1AG20
1 2 321.3
3 4 321.3
5 6 321.3
21 22 440.7

3RT1023-1AG20
1 2 321.4
3 4 321.4
5 6 321.4
21 22 440.6

3RT1023-1AG20
1 2 381.6
3 4 381.6
5 6

⇦439

441⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 440
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

SPARE | SPARE | SHEET SUPPORT BEAMS OPERATOR SIDE 2° CHOICE STACKER OPEN | SHEET SUPPORT BEAMS OPERATOR SIDE 2° CHOICE STACKER CLOSE | SHEET SUPPORT BEAMS MOTOR SIDE 2° CHOICE STACKER OPEN | SHEET SUPPORT BEAMS MOTOR SIDE 2° CHOICE STACKER CLOSE | SPARE | SPARE

-438A0
438.0
OUTPUT BYTE X+3 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A11.0 A11.1 A11.2 A11.3 A11.4 A11.5 A11.6 A11.7

-X1 31 4L+ | -X1 32 | -X1 33 | -X1 34 | -X1 35 | -X1 36 | -X1 37 | -X1 38 | -X1 39 | -X1 40 4M

440.1 / -24V-L12 → -24V-L12 / 442.0

441-0 441-1 441-2 441-3 441-4 441-5 441-6 441-7

440.9 / -0V2 → -0V2 / 442.8

-441A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

190.3 / -110-Z3 → 110Vac → -110-Z3 / 442.1

441-12 441-14 441-16 441-18

441K4 441.4 — 21 22
441K3 441.3 — 21 22
441K6 441.6 — 21 22
441K5 441.5 — 21 22

441-13 441-15 441-17 441-19

-441K3 | -441K4 | -441K5 | -441K6 — A1 A2

441.9 / -110-N → -110-N / 441.1

3RT1023-1AG20
1 2 321.7
3 4 321.7
5 6 321.7
13 14 367.2
21 22 441.4

3RT1023-1AG20
1 2 321.8
3 4 321.8
5 6 321.8
13 14 367.2
21 22 441.3

3RT1023-1AG20
1 2 322.1
3 4 322.1
5 6 322.1
13 14 367.3
21 22 441.6

3RT1023-1AG20
1 2 322.2
3 4 322.2
5 6 322.2
13 14 367.4
21 22 441.5

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 441
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HEAD MOBILE CARRIAGE TRANSLATION 2° CHOICE STACKER FORWARD

HEAD MOBILE CARRIAGE TRANSLATION 2° CHOICE STACKER BACKWARD

LOWER FEEDING PINCH ROLL ROTATION 1° CHOICE STACKER COOLING MOTOR

SPARE

ENTRY 1° CHOICE STACKER FEEDING PINCH ROLL UP

ENTRY 1° CHOICE STACKER FEEDING PINCH ROLL DOWN

SHEET SUPPORT BEAMS HORIZONTAL TRANSALTION ENTRY 1° CHOICE STACKER FORWARD

SHEET SUPPORT BEAMS HORIZONTAL TRANSALTION ENTRY 1° CHOICE STACKER BACKWARD

-442A0 OUTPUT BYTE X 6ES7322-1BL00-0AA0 SM 322 DO 32 x DC24V/0,5A SIEMENS

443.0
444.0
445.0
406.6

A12.0 A12.1 A12.2 A12.3 A12.4 A12.5 A12.6 A12.7

-X1 1 (1L+) -X1 2 -X1 3 -X1 4 -X1 5 -X1 6 -X1 7 -X1 8 -X1 9 -X1 10 (1M)

441.1 / -24V-L12 → -24V-L12 / 443.0

441.9 / -0V2 → -0V2 / 443.8

442-0 442-1 442-2 442-3 442-4 442-5 442-6 442-7

-442A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

441.9 / -110-Z3 → 110Vac → -110-Z3 / 443.1

442-8 442-10 442-12 442-16 442-18 442-20 442-22

21
442K2 442.2 22
442K1 442.2 22
442K6 442.6 22
442K5 442.5 22
442K8 442.8 22
442K7 442.7 22

442-9 442-11 442-17 442-19 442-21 442-23

A1
-442K1 -442K2 -442K3 -442K5 -442K6 -442K7 -442K8
A2

442.9 / -110-N → -110-N / 442.1

3RT1023-1AG20
1 2 322.3
3 4 322.3
5 6 322.3
13 14 367.5
21 22 442.2

3RT1023-1AG20
1 2 322.4
3 4 322.4
5 6 322.4
13 14 367.6
21 22 442.2

3RT1023-1AG20
1 2 323.1
3 4 323.1
5 6 323.1

3RT1023-1AG20
1 2 323.3
3 4 323.3
5 6 323.3
21 22 442.6

3RT1023-1AG20
1 2 323.4
3 4 323.4
5 6 323.4
21 22 442.5

3RT1023-1AG20
1 2 323.5
3 4 323.5
5 6 323.5
13 14 367.7
21 22 442.8

3RT1023-1AG20
1 2 323.6
3 4 323.6
5 6 323.6
13 14 367.7
21 22 442.7

441

443

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	442
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

A13.0	A13.1	A13.2	A13.3	A13.4	A13.5	A13.6	A13.7
SHEET SUPPORT BEAMS HORIZONTAL TRANSALTION EXIT 1° CHOICE STACKER FORWARD	SHEET SUPPORT BEAMS HORIZONTAL TRANSALTION EXIT 1° CHOICE STACKER BACKWARD	1° AND 2° SHEET CONVEYOR OPERATOR SIDE VERTICAL TRANSLATION 1° CHOICE STACKER FROM 1° BOX TO 2° BOX UP	1° AND 2° SHEET CONVEYOR OPERATOR SIDE VERTICAL TRANSLATION 1° CHOICE STACKER FROM 1° BOX TO 2° BOX DOWN	1° AND 2° SHEET CONVEYOR MOTOR SIDE VERTICAL TRANSLATION 1° CHOICE STACKER FROM 1° BOX TO 2° BOX UP	1° AND 2° SHEET CONVEYOR MOTOR SIDE VERTICAL TRANSLATION 1° CHOICE STACKER FROM 1° BOX TO 2° BOX DOWN	OPERATOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 1° BOX FORWARD	OPERATOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 1° BOX BACKWARD

-442A0
442.0
OUTPUT BYTE X+1 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

-X1 11 2L+ ← 442.1 / -24V-L12 → -24V-L12 / 444.0

-X1 20 2M → 442.9 / -0V2 → -0V2 / 444.8

-443A1

	A13.0	A13.1	A13.2	A13.3	A13.4	A13.5	A13.6	A13.7
-X1	12	13	14	15	16	17	18	19
443-	0	1	2	3	4	5	6	7
443K	0	1	2	3	4	5	6	7
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

442.9 / -110-Z3 → 110Vac → -110-Z3 / 444.1

	A13.0	A13.1	A13.2	A13.3	A13.4	A13.5	A13.6	A13.7
443-	8	10	12	14	16	18	20	22
21	443K2 443.2	443K1 443.2	443K4 443.4	443K3 443.3	443K6 443.6	443K5 443.5	443K8 443.8	443K7 443.7
22								
443-	9	11	13	15	17	19	21	23
A1	-443K1	-443K2	-443K3	-443K4	-443K5	-443K6	-443K7	-443K8
A2								

443.9 / -110-N → -110-N / 443.1

	A13.0	A13.1	A13.2	A13.3	A13.4	A13.5	A13.6	A13.7
3RT1023-1AG20								
1 2	323.7	323.8	324.1	324.2	324.3	324.4	324.5	324.6
3 4	323.7	323.8	324.1	324.2	324.3	324.4	324.5	324.6
5 6	323.7	323.8	324.1	324.2	324.3	324.4	324.5	324.6
13 14	368.2	368.2	368.3	368.4	368.5	368.6	368.7	368.7
21 22	443.2	443.2	443.4	443.3	443.6	443.5	443.8	443.7

MOTOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 1° BOX FORWARD

MOTOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 1° BOX BACKWARD

OPERATOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 2° BOX FORWARD

OPERATOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 2° BOX BACKWARD

MOTOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 2° BOX FORWARD

MOTOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 2° BOX BACKWARD

SHEETS ASPIRATION CONVEYOR BELT ROTATION 1° CHOICE STACKER COOLING MOTOR

1° FAN SHEETS ASPIRATION ROOM 1° CHOICE STACKER

-442A0
442.0
OUTPUT BYTE X+2 | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

A14.0 A14.1 A14.2 A14.3 A14.4 A14.5 A14.6 A14.7

-X1 21 3L+ | -X1 22 | -X1 23 | -X1 24 | -X1 25 | -X1 26 | -X1 27 | -X1 28 | -X1 29 | -X1 30 3M

443.1 / -24V-L12 → -24V-L12 / 445.0

444-0 444-1 444-2 444-3 444-4 444-5 444-6 444-7

443.9 / -0V2 → -0V2 / 445.8

-444A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

443.9 / -110-Z3 → 110Vac → -110-Z3 / 445.1

444-8 444-10 444-12 444-14 444-16 444-18 444-20 444-22

444K2 444.2 | 444K1 444.2 | 444K4 444.4 | 444K3 444.3 | 444K6 444.6 | 444K5 444.5

21 22

444-9 444-11 444-13 444-15 444-17 444-19

-444K1 | -444K2 | -444K3 | -444K4 | -444K5 | -444K6 | -444K7 | -444K8

A1 A2

444.9 / -110-N → -110-N / 444.1

3RT1023-1AG20
1 2 324.7
3 4 324.7
5 6 324.7
13 14 369.2
21 22 444.2

3RT1023-1AG20
1 2 324.8
3 4 324.8
5 6 324.8
13 14 369.2
21 22 444.2

3RT1023-1AG20
1 2 325.1
3 4 325.1
5 6 325.1
13 14 369.3
21 22 444.4

3RT1023-1AG20
1 2 325.2
3 4 325.2
5 6 325.2
13 14 369.4
21 22 444.3

3RT1023-1AG20
1 2 325.3
3 4 325.3
5 6 325.3
13 14 369.5
21 22 444.6

3RT1023-1AG20
1 2 325.4
3 4 325.4
5 6 325.4
13 14 369.6
21 22 444.5

3RT1023-1AG20
1 2 325.5
3 4 325.5
5 6 325.5

3RT1034-1AG20
1 2 325.7
3 4 325.7
5 6 325.7

⇦443

445⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	444
Revision			Replacement of / Replaced by			Group: / Of	414

2° FAN SHEETS ASPIRATION ROOM 1° CHOICE STACKER
3° FAN SHEETS ASPIRATION ROOM 1° CHOICE STACKER
4° FAN SHEETS ASPIRATION ROOM 1° CHOICE STACKER
COILS CARRIAGE FRONT WHEELS PARKING BRAKE
COILS CARRIAGE REAR WHEELS PARKING BRAKE
COIL CAR PARKING BRAKE
TAIL PINCH ROLL ROTATION PARKING BRAKE
PACKAGE FORMING ROLL 2° CHOICE STACKER PARKING BRAKE

-442A0
442.0
OUTPUT BYTE X+3 | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

A15.0 A15.1 A15.2 A15.3 A15.4 A15.5 A15.6 A15.7

-X1 31 4L+ | -X1 32 | -X1 33 | -X1 34 | -X1 35 | -X1 36 | -X1 37 | -X1 38 | -X1 39 | -X1 40 4M

444.1 / -24V-L12 → -24V-L12 / 446.0

444.9 / -0V2 → -0V2 / 446.8

445-0 445-1 445-2 445-3 445-4 445-5 445-6 445-7

-445A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

444.9 / -110-Z3 → 110Vac
361.9 / -110-Z11 →
366.9 / -110-Z12 → -110-Z12 /
369.9 / -110-Z13 →

445-8 445-10 445-12 445-14 445-16 445-18 445-20 445-22

-445K1 -445K2 -445K3 -445K4 -445K5 -445K6 -445K7 -445K8
A1 A2

445.9 / -110-N → -110-N / 445.1

3RT1034-1AG20
1 2 326.1
3 4 326.1
5 6 326.1

3RT1034-1AG20
1 2 326.3
3 4 326.3
5 6 326.3

3RT1034-1AG20
1 2 326.5
3 4 326.5
5 6 326.5

PT270615
14 11 330.0
12
24 21 330.1
22

PT270615
14 11 330.2
12
24 21 330.2
22

PT270615
14 11 330.4
12
24 21 330.4
22

PT270615
14 11 337.2
12
24 21 337.2
22

PT270615
14 11 338.4
12
24 21 338.4
22

⇦444
446⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	445
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PLC EMERGENCY | EMERGENCY RESET | AREA 1 SAFETY RESET | AREA 2 SAFETY RESET | AREA 3 SAFETY RESET | DRIVERS AC/DC INSERTION | DIGITEC PILZ RESET | STRAPPING MACHINE RESET

-446A0
447.0
448.0
449.0
406.7
OUTPUT BYTE X | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

-X1 1 (1L+) | A16.0 -X1 2 | A16.1 -X1 3 | A16.2 -X1 4 | A16.3 -X1 5 | A16.4 -X1 6 | A16.5 -X1 7 | A16.6 -X1 8 | A16.7 -X1 9 | -X1 10 (1M)

445.1 / -24V-L12 → -24V-L12 / 447.0

445.9 / -0V2 → -0V2 / 447.8

446-0 | 446-1 | 446-2 | 446-3 | 446-4 | 446-5 | 446-6 | 446-7

-446A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

130.9 / -110-L1 → 110Vac

446-8

446-20 | 446-21

-XEME 34 35
Q15

-X002 5 6
DIGITEC CABINET

25001 | 25002

-446K1 A1 A2

446.9 / -110-N → -110-N / 446.1

3RH1131-1AF00
21 – 22
13 – 14 150.3
33 – 34 150.3
43 – 44

24 – 21 150.2
22

34 – 31 155.2
32

44 – 41 160.2
42

54 – 51 165.2
52

64 – 61 202.1
62

84 – 81 151.9
82

445

447

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 446
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COIL CAR MOVEMENT

COILS ROTATION ON COIL CAR

PACKAGE TRANSLATION ON COMBINED 2° TRANSFER PLATFORM CHIANS TRANSLATION AFTER STRAPPING MACHINE

PACKAGE TRANSLATION ON COMBINED 2° TRANSFER PLATFORM ROLLS TRANSLATION AFTER STRAPPING MACHINE

PACKAGE TRANSLATION ON COMBINED 1° TRANSFER PLATFORM ROLLS TRANSLATION 1° CHOICE STACKER 1° BOX

PACKAGE TRANSLATION ON COMBINED 1° TRANSFER PLATFORM CHIANS TRANSLATION 1° CHOICE STACKER 1° BOX

PACKAGE TRANSLATION ON COMBINED 2° TRANSFER PLATFORM ROLLS TRANSLATION 1° CHOICE STACKER 2° BOX

PACKAGE TRANSLATION ON COMBINED 2° TRANSFER PLATFORM CHIANS TRANSLATION 1° CHOICE STACKER 2° BOX

-446A0
446.0
OUTPUT BYTE X+1 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A17.0 A17.1 A17.2 A17.3 A17.4 A17.5 A17.6 A17.7

-X1 11 2L+ | -X1 12 | -X1 13 | -X1 14 | -X1 15 | -X1 16 | -X1 17 | -X1 18 | -X1 19 | -X1 20 2M

446.1 / -24V-L12 → -24V-L12 / 448.0

446.9 / -0V2 → -0V2 / 448.8

447-0 | 447-1 | 447-2 | 447-3 | 447-4 | 447-5 | 447-6 | 447-7

-447A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

437.9 / -110-Z0 → 110Vac → -110-Z0 / 448.1

447-8 | 447-10 | 447-12 | 447-14 | 447-16 | 447-18 | 447-20 | 447-22

-0X11 4 5 6 7 8 9 10 11
Q14

-1X11 4 5 6 7 8 9 10 11
Q7

21
447K2 447.2 | 447K1 447.2 | 447K4 447.4 | 447K3 447.3 | 447K6 447.6 | 447K5 447.5 | 447K8 447.8 | 447K7 447.7
22

447-9 | 447-11 | 447-13 | 447-15 | 447-17 | 447-19 | 447-21 | 447-23

A1
-447K1 | -447K2 | -447K3 | -447K4 | -447K5 | -447K6 | -447K7 | -447K8
A2

447.9 / -110-N → -110-N / 447.1

3RT1023-1AG20	3RT1023-1AG20	3RT1024-1AG20	3RT1024-1AG20	3RT1024-1AG20	3RT1024-1AG20	3RT1024-1AG20	3RT1024-1AG20
1 2 221.1	1 2 221.3	1 2 245.6	1 2 245.7	1 2 273.1	1 2 273.2	1 2 273.6	1 2 273.7
3 4 221.1	3 4 221.3	3 4 245.6	3 4 245.8	3 4 273.1	3 4 273.2	3 4 273.6	3 4 273.7
5 6 221.1	5 6 221.3	5 6 245.6	5 6 245.8	5 6 273.1	5 6 273.3	5 6 273.6	5 6 273.7
21 22 447.2	21 22 447.2	21 22 447.4	21 22 447.3	21 22 447.6	21 22 447.5	21 22 447.8	21 22 447.7

⇦446

448⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	447
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0	1	2	3	4	5	6	7	8	9

PACKAGE TRANSLATION ON COMBINED 1° TRANSFER PLATFORM CHIANS TRANSLATION AFTER STRAPPING MACHINE

PACKAGE TRANSLATION ON COMBINED 1° TRANSFER PLATFORM ROLLS TRANSLATION AFTER STRAPPING MACHINE

SPARE SPARE SPARE SPARE SPARE SPARE

-446A0
446.0
OUTPUT BYTE X+2 6ES7322-1BL00-0AA0 SM 322 DO 32 x DC24V/0,5A SIEMENS

A18.0 A18.1 A18.2 A18.3 A18.4 A18.5 A18.6 A18.7

-X1 21 3L+ -X1 22 -X1 23 -X1 24 -X1 25 -X1 26 -X1 27 -X1 28 -X1 29 -X1 30 3M

447.1 / -24V-L12 → -24V-L12 / 449.0

448-0 448-1 448-2 448-3 448-4 448-5 448-6 448-7

447.9 / -0V2 → -0V2 / 449.8

-448A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

447.9 / -110-Z0 → 110Vac → -110-Z0 /

448-8 448-10

-0X11 12 Q14 -0X11 13 Q14

-1X11 12 Q7 -1X11 13 Q7

21 21

448K2 448.2 22 448K1 448.2 22

448-9 448-11

A1 A1

-448K1 -448K2

A2 A2

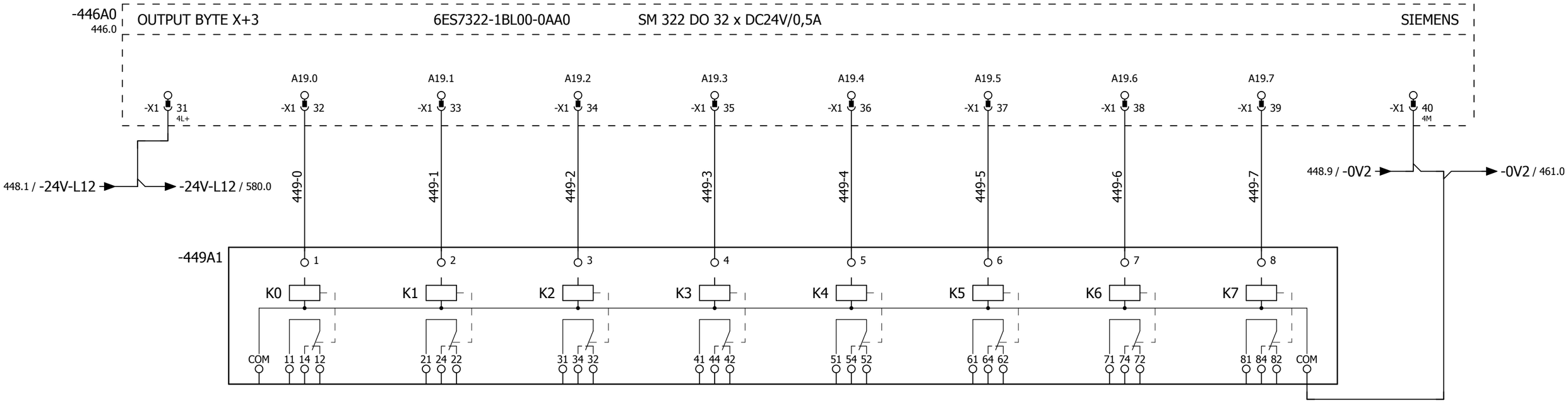
448.9 / -110-N → -110-N / 448.1

3RT1023-1AG20
1 2 275.6
3 4 275.6
5 6 275.6
21 22 448.2

3RT1023-1AG20
1 2 275.7
3 4 275.7
5 6 275.7
21 22 448.2

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	448
Revision						Group:	Of 414

SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

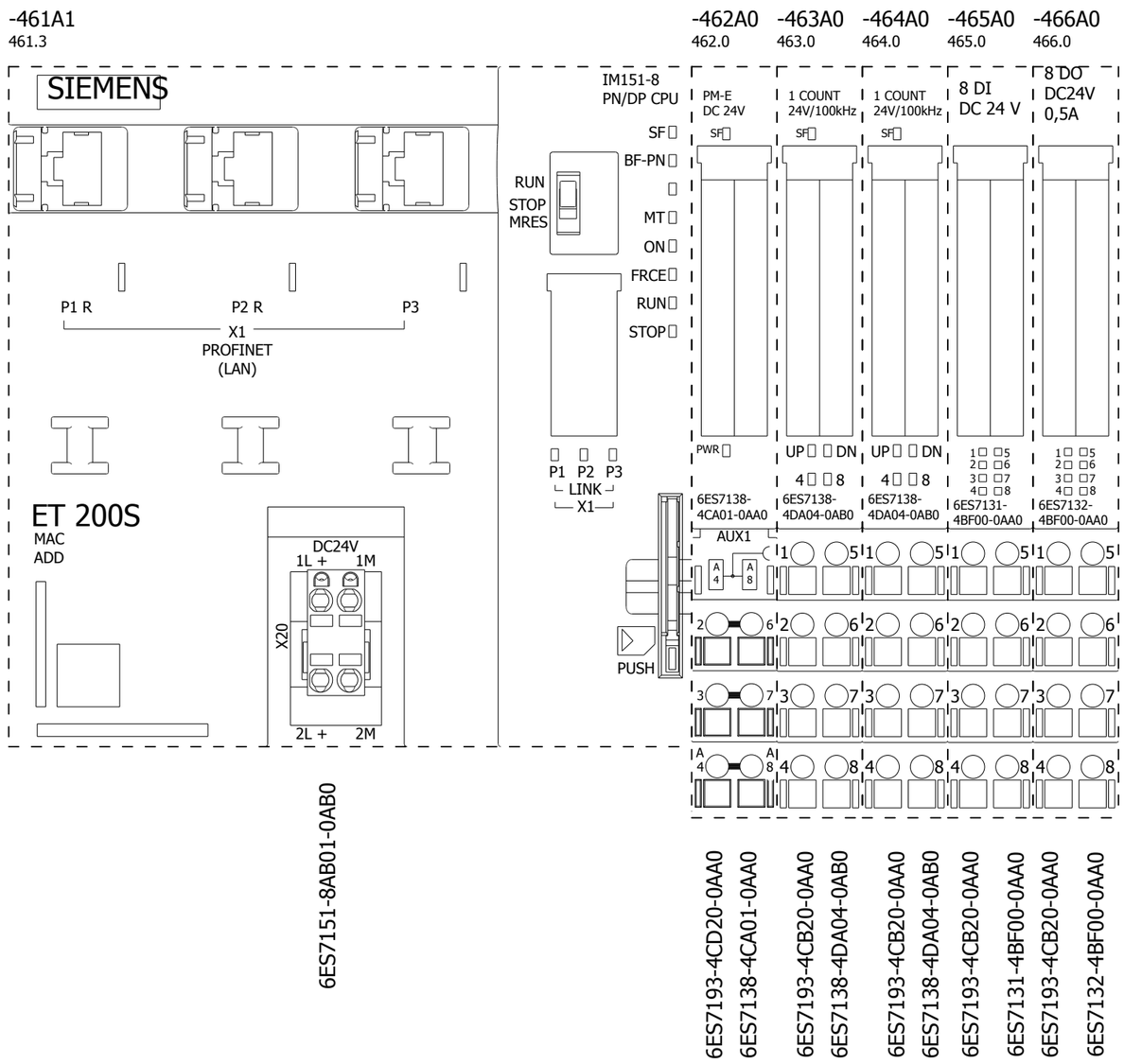


⇦448

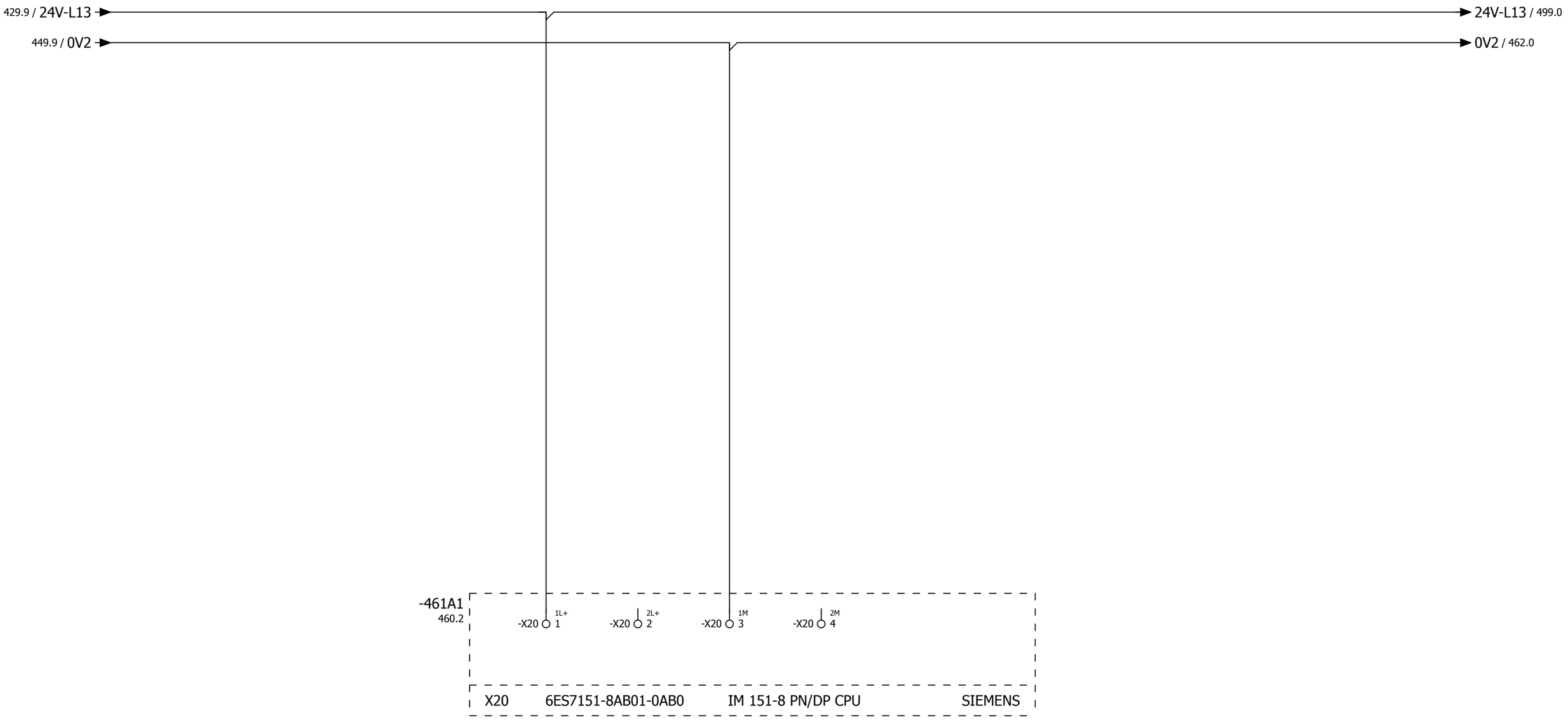
460⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 449
Revision		Replacement of	Replaced by			Group:	Of 414

TAIL PINCH ROLL PLC LAYOUT



Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Tail pinch roll plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	460
Revision			Replacement of / Replaced by			Group: / Of	414

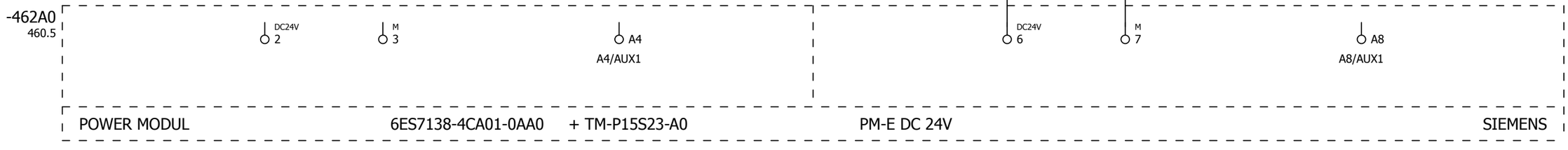

429.9 / 24V-L13
449.9 / 0V2
24V-L13 / 499.0
0V2 / 462.0
-461A1
460.2
1L+
-X20 1
2L+
-X20 2
1M
-X20 3
2M
-X20 4
X20 6ES7151-8AB01-0AB0 IM 151-8 PN/DP CPU SIEMENS

460

462

425.9 / 24V-L20 → 24V-L20 / 705.0

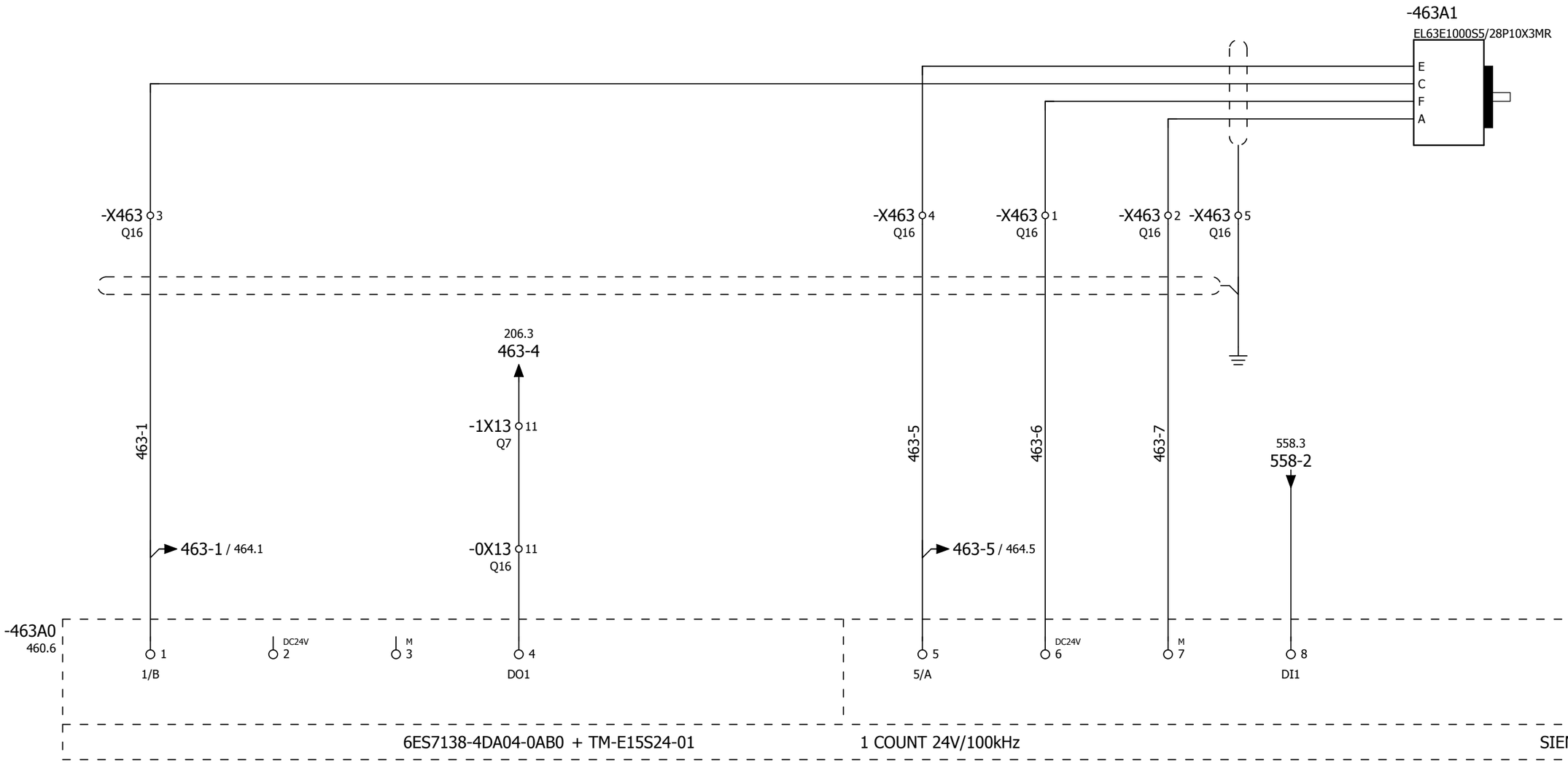
461.9 / 0V2 → 0V2 / 499.0



⇦461

463⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul tail pinch roll		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 462
Revision		Replacement of	Replaced by			Group:	Of 414

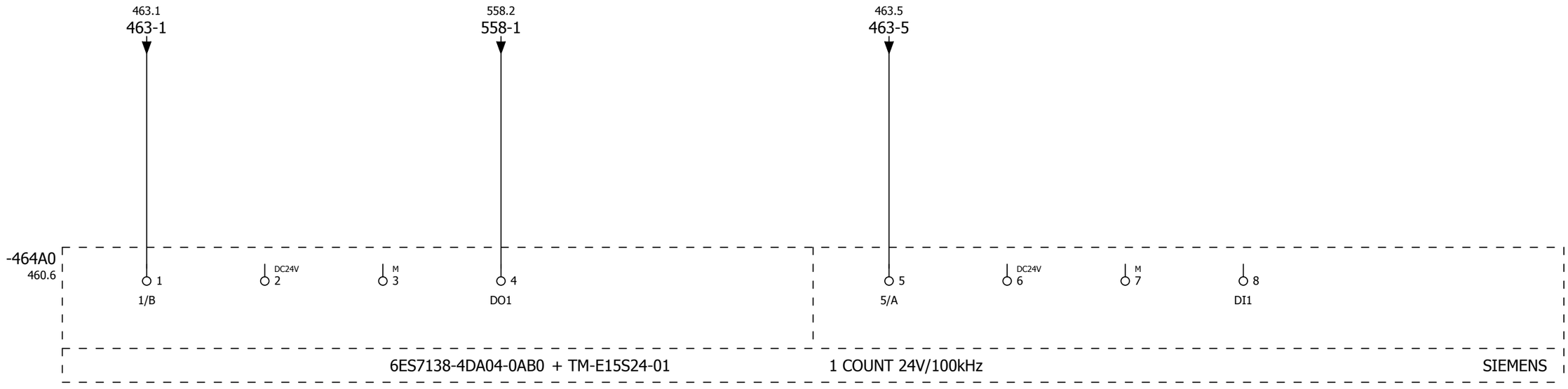


TAIL
PINCH ROLL
ENCODER

⇦462

464⇨

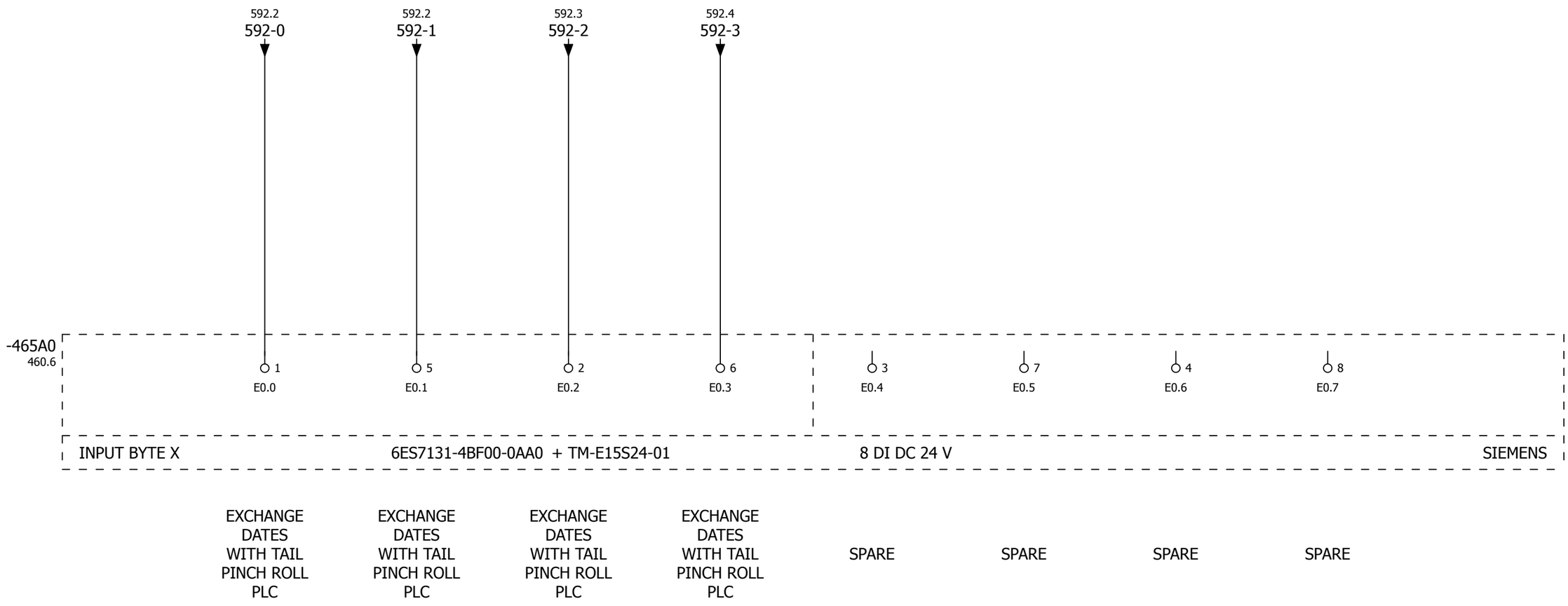
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Tail pinch roll counter		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 463
Revision		Replacement of	Replaced by			Group:	Of 414



⇦463

465⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Tail pinch roll counter		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	464
Revision		Replacement of	Replaced by			Group:	Of 414



Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Tail pinch roll digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	465
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

EXCHANGE DATES WITH TAIL PINCH ROLL PLC	EXCHANGE DATES WITH TAIL PINCH ROLL PLC	EXCHANGE DATES WITH TAIL PINCH ROLL PLC	EXCHANGE DATES WITH TAIL PINCH ROLL PLC	SPARE	SPARE	SPARE	SPARE

-466A0
460.7

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A0.0	A0.1	A0.2	A0.3	A0.4	A0.5	A0.6	A0.7
1	5	2	6	3	7	4	8

563-0	563-1	563-2	563-3
563.1	563.2	563.3	563.4

⇦465

499⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Tail pinch roll digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	466
Revision		Replacement of	Replaced by			Group:	Of 414

461.9 / -24V-L13 → 24Vdc

462.9 / -0V2 →

-24V-L13 / 549.0

-0V2 / 501.0

-499A1
407.1

PE 1 | M 2 | L+ 3 | M 4

6ES7361-3CA01-0AA0 IM 360 / IM-R SIEMENS

⇦466

500⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 361 supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	499
Revision		Replacement of	Replaced by			Group:	Of 414

121.1 / 24V-L10 → 24Vdc

24V-L10 / 501.0

	300Q1	300Q5	300Q7	301Q5
	300.1	300.5	300.7	301.5
13				
14				
	500-0	500-2	500-3	500-6

-500A0
501.0
502.0
503.0
407.3

	-X1 2	-X1 3	-X1 4	-X1 5	-X1 6	-X1 7	-X1 8	-X1 9
	E0.0	E0.1	E0.2	E0.3	E0.4	E0.5	E0.6	E0.7

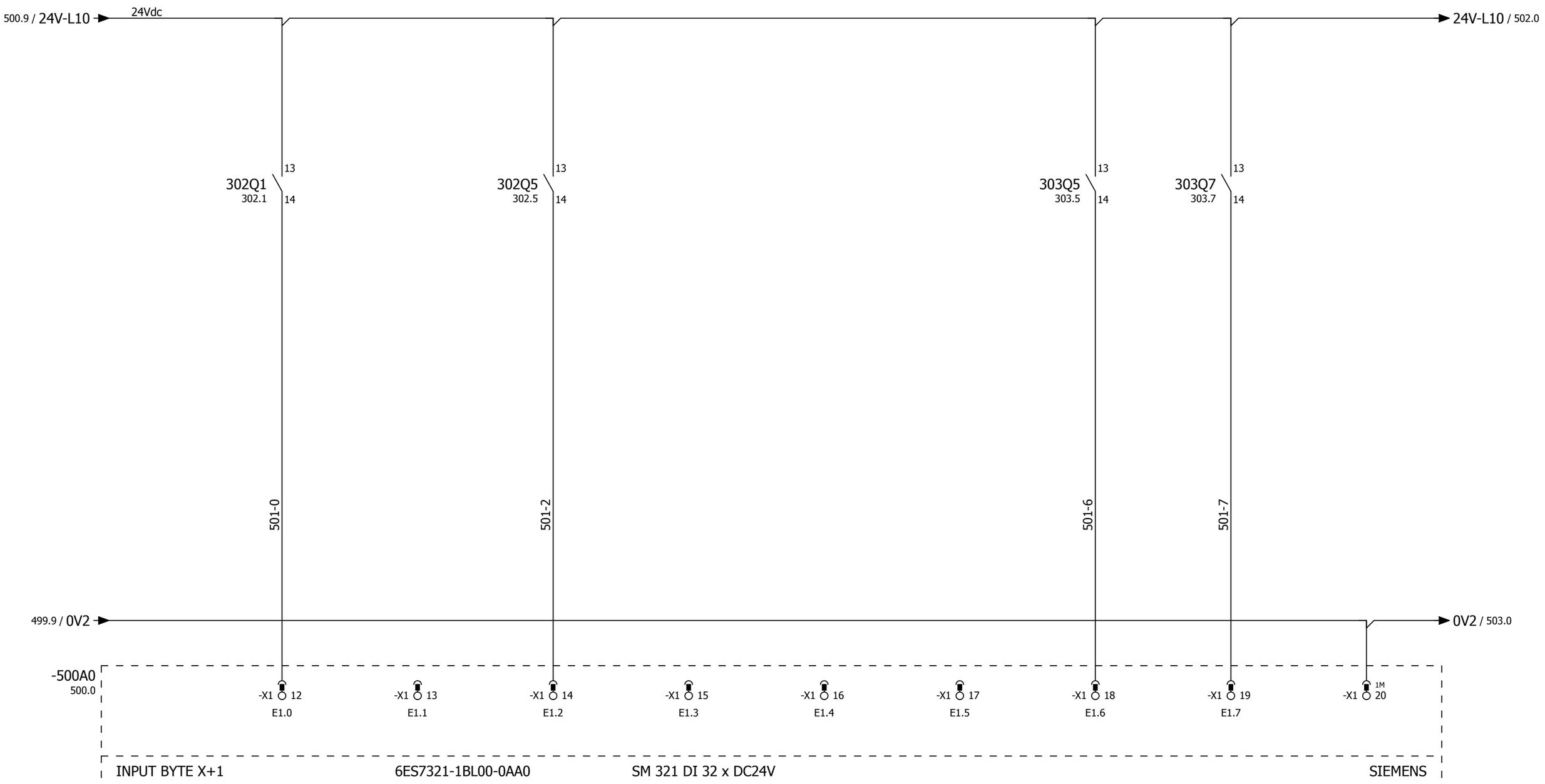
INPUT BYTE X | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

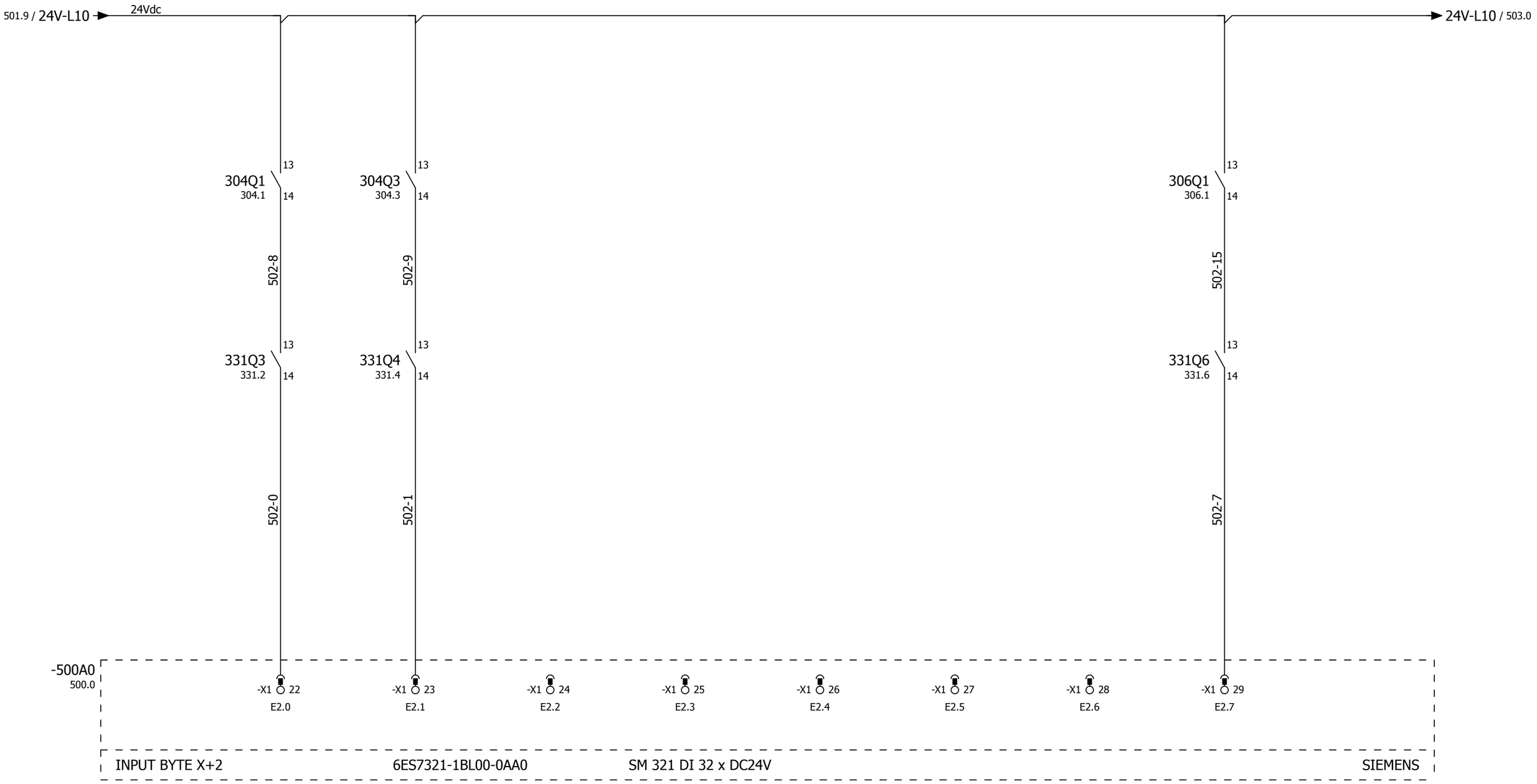
E0.0	E0.1	E0.2	E0.3	E0.4	E0.5	E0.6	E0.7
LINE HYDRAULIC UNIT PUMP THERMAL TRIPPING	SPARE	HEATER EXCHANGER FOR LINE HYDRAULIC UNIT OIL COOLING THERMAL TRIPPING	LINE HYDRAULIC UNIT OIL RECYCLE PUMP THERMAL TRIPPING	SPARE	SPARE	UNCOILER OIL LUBRICATION THERMAL TRIPPING	SPARE

⇦499

501⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 500
Revision			Replacement of / Replaced by			Group:	Of 414

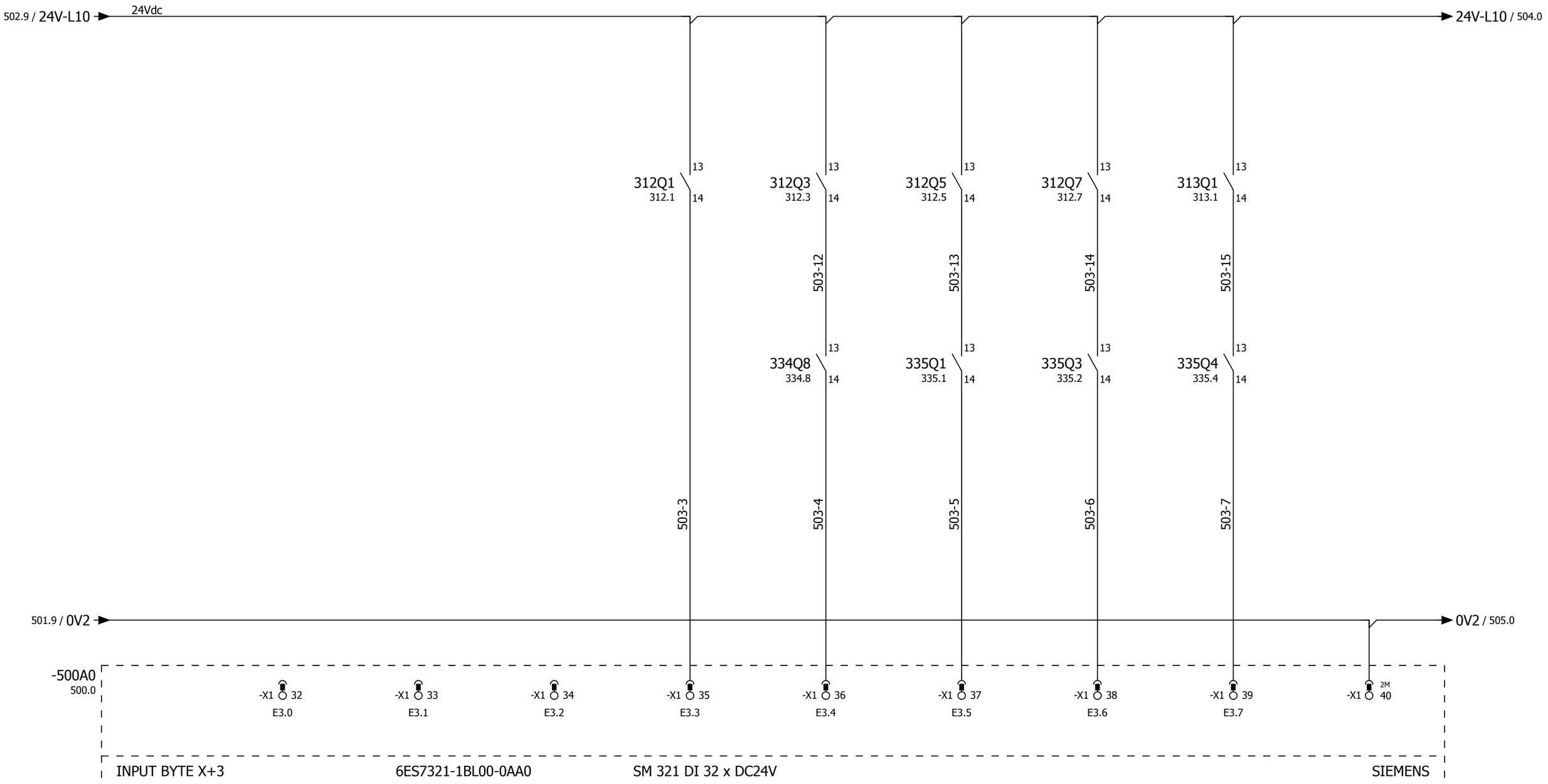

500.9 / 24V-L10
24Vdc
24V-L10 / 502.0
302Q1
302.1
13
14
302Q5
302.5
303Q5
303.5
303Q7
303.7
501-0
501-2
501-6
501-7
499.9 / 0V2
0V2 / 503.0
-500A0
500.0
-X1 12 E1.0
-X1 13 E1.1
-X1 14 E1.2
-X1 15 E1.3
-X1 16 E1.4
-X1 17 E1.5
-X1 18 E1.6
-X1 19 E1.7
-X1 1M 20
INPUT BYTE X+1
6ES7321-1BL00-0AA0
SM 321 DI 32 x DC24V
SIEMENS
PAPER WINDER ROTATION THERMAL TRIPPING
SPARE
DECOILER MOTOR COOLING THERMAL TRIPPING
SPARE
SPARE
SPARE
STRAIGHTENER ENTRY PINCH ROLL MOTOR COOLING THERMAL TRIPPING
STRAIGHTENER MOTOR COOLING THERMAL TRIPPING



⇦501

503⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	502
Revision		Replacement of	Replaced by			Group:	Of 414



⇦502

504⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 503
Revision			Replacement of / Replaced by			Group:	Of 414

503.9 / 24V-L10

24Vdc

24V-L10 / 505.0

313Q5	313Q7	314Q1	315Q1	315Q3	315Q5	315Q7		
313.5	313.7	314.1	315.1	315.3	315.5	315.7		
504-1	504-2	504-3	504-4	504-5	504-6	504-7		
				335Q6	335Q8	336Q1		
				335.6	335.8	336.1		

-504A0
505.0
506.0
507.0
407.4

-X1 2	-X1 3	-X1 4	-X1 5	-X1 6	-X1 7	-X1 8	-X1 9
E4.0	E4.1	E4.2	E4.3	E4.4	E4.5	E4.6	E4.7

INPUT BYTE X | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

SPARE	LEVELLER 1 SLIDING JOINTS LUBRICATION THERMAL TRIPPING	LEVELLER 1 CLEANING WORK ROLLS THERMAL TRIPPING	LEVELLER 1 BENCH THERMAL TRIPPING	LEVELLER 2 MOTOR COOLING THERMAL TRIPPING	LEVELLER 2 SCREW JACK 1 MOTOR AND BRAKE THERMAL TRIPPING	LEVELLER 2 SCREW JACK 2 MOTOR AND BRAKE THERMAL TRIPPING	LEVELLER 2 SCREW JACK 3 MOTOR AND BRAKE THERMAL TRIPPING

⇦503

505⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 504
Revision		Replacement of	Replaced by			Group:	Of 414

504.9 / 24V-L10 → 24Vdc

24V-L10 / 506.0 →

	316Q1	316Q5	316Q7	317Q1	318Q1	318Q5
	316.1	316.5	316.7	317.1	318.1	318.5
13	505-8	505-0	505-2	505-3	505-4	505-5	505-7
14	336Q3						
	336.2						

503.9 / 0V2 →

0V2 / 507.0 →

-504A0
504.0

	-X1 12	-X1 13	-X1 14	-X1 15	-X1 16	-X1 17	-X1 18	-X1 19	-X1 1M 20
	E5.0	E5.1	E5.2	E5.3	E5.4	E5.5	E5.6	E5.7	

INPUT BYTE X+1 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

316Q1		316Q5	316Q7	317Q1	318Q1		318Q5
LEVELLER 2 SCREW JACK 4 MOTOR AND BRAKE THERMAL TRIPPING	SPARE	LEVELLER 2 SLIDING JOINTS LUBRICATION THERMAL TRIPPING	LEVELLER 2 CLEANING WORK ROLLS THERMAL TRIPPING	LEVELLER 2 BENCH THERMAL TRIPPING	PLASTICIZEN DEVICE MOTOR COOLING THERMAL TRIPPING	SPARE	UPPER ROLLS SUPPORT TRANSLATION THERMAL TRIPPING

⇦504

506⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	505
Revision						Group: / Of	414

505.9 / 24V-L10 → 24Vdc

24V-L10 / 507.0

	318Q7	319Q1	320F5
	318.7	319.1	320.5
	13	13	97
	14	14	98
		506-9	
		13	
		336Q4	
		336.4	
		14	
	506-0	506-1	506-6

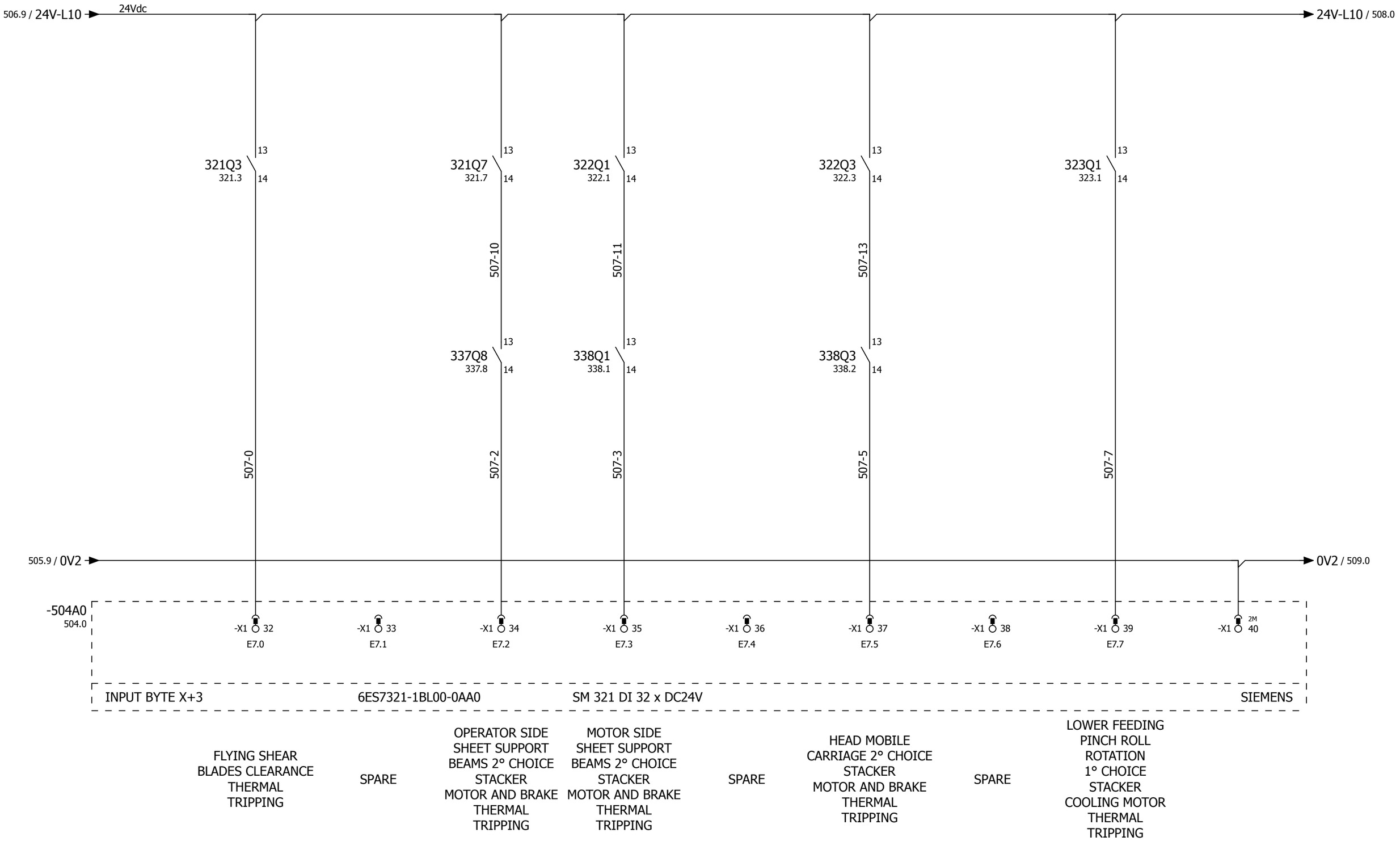
-504A0
504.0

-X1 22	-X1 23	-X1 24	-X1 25	-X1 26	-X1 27	-X1 28	-X1 29
E6.0	E6.1	E6.2	E6.3	E6.4	E6.5	E6.6	E6.7

INPUT BYTE X+2 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

LOWER ROLLS SUPPORT TRANSLATION THERMAL TRIPPING	CENTERING DEVICE 2 MOTOR AND BRAKE THERMAL TRIPPING	SPARE	SPARE	SPARE	SPARE	FLYING SHEAR FLYWHEEL MOTOR THERMAL TRIPPING	SPARE

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 506
Revision		Replacement of	Replaced by			Group:	Of 414



⇦506

508⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	507
Revision		Replacement of	Replaced by			Group:	Of 414

507.9 / 24V-L10

24Vdc

24V-L10 / 509.0

323Q3	323Q5	323Q7	324Q1	324Q3	324Q5	324Q7	325Q1
323.3	323.5	323.7	324.1	324.3	324.5	324.7	325.1
13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14
508-0	508-9	508-10	508-11	508-12	508-13	508-14	508-15

339Q1	339Q3	339Q4	339Q6	339Q8	340Q1	340Q3
339.1	339.2	339.4	339.6	339.8	340.1	340.2
13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14
508-1	508-2	508-3	508-4	508-5	508-6	508-7

-508A0

509.0
510.0
511.0
407.5

-X1 2	-X1 3	-X1 4	-X1 5	-X1 6	-X1 7	-X1 8	-X1 9
E8.0	E8.1	E8.2	E8.3	E8.4	E8.5	E8.6	E8.7

INPUT BYTE X | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

FEEDING PINCH ROLL ENTRY 1° CHOICE STACKER THERMAL TRIPPING	ENTRY SHEET SUPPORT BEAMS HORIZONTAL TRANSLATION 1° CHOICE STACKER MOTOR AND BRAKE THERMAL TRIPPING	EXIT SHEET SUPPORT BEAMS HORIZONTAL TRANSLATION 1° CHOICE STACKER MOTOR AND BRAKE THERMAL TRIPPING	1° AND 2° SHEET CONVEYOR OPERATOR SIDE VERTICAL TRANSLATION 1° CHOICE STACKER FROM 1° BOX TO 2° BOX MOTOR AND BRAKE THERMAL TRIPPING	1° AND 2° SHEET CONVEYOR MOTOR SIDE VERTICAL TRANSLATION 1° CHOICE STACKER FROM 1° BOX TO 2° BOX MOTOR AND BRAKE THERMAL TRIPPING	OPERATOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 1° BOX MOTOR AND BRAKE THERMAL TRIPPING	MOTOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 1° BOX MOTOR AND BRAKE THERMAL TRIPPING	OPERATOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 2° BOX MOTOR AND BRAKE THERMAL TRIPPING

⇦507

509⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Cabinet digital input	=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco					Installation: Linea taglio trasversale	Page 508
Revision			Replacement of	Replaced by			Group: Of 414

508.9 / 24V-L10 — 24Vdc — 24V-L10 / 510.0

	325Q3	325Q5	325Q7	326Q1	326Q3	326Q5	381F1	340Q4
	325.3	325.5	325.7	326.1	326.3	326.5	381.1	340.4
13	509-8							
14	509-0	509-1	509-2	509-3	509-4	509-5	509-7	

507.9 / 0V2 — 0V2 / 511.0

-508A0
508.0

-X1 12	-X1 13	-X1 14	-X1 15	-X1 16	-X1 17	-X1 18	-X1 19	-X1 1M 20
E9.0	E9.1	E9.2	E9.3	E9.4	E9.5	E9.6	E9.7	

INPUT BYTE X+1 — 6ES7321-1BL00-0AA0 — SM 321 DI 32 x DC24V — SIEMENS

MOTOR SIDE HEAD MOBILE CARRIAGE HORIZONTAL TRANSLATION 1° CHOICE STACKER 2° BOX MOTOR AND BRAKE THERMAL TRIPPING	SHEETS ASPIRATION CONVEYOR BELT ROTATION 1° CHOICE STACKER COOLING MOTOR THERMAL TRIPPING	1° SHEETS ASPIRATION ROOM FAN 1° CHOICE STACKER THERMAL TRIPPING	2° SHEETS ASPIRATION ROOM FAN 1° CHOICE STACKER THERMAL TRIPPING	3° SHEETS ASPIRATION ROOM FAN 1° CHOICE STACKER THERMAL TRIPPING	4° SHEETS ASPIRATION ROOM FAN 1° CHOICE STACKER THERMAL TRIPPING	SPARE	LOWER PAPER 1 HEATING THERMAL TRIPPING

⇦508
510⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	509
Revision		Replacement of	Replaced by			Group:	Of 414

509.9 / 24V-L10 → 24Vdc

24V-L10 / 511.0

	381F2	381F3	382F1	382F2	382F3	105F0
	381.3	381.6	382.1	382.3	382.5	105.0
13						
14						
	510-0	510-2	510-3	510-4	510-6	510-7

-508A0
508.0

	-X1 22	-X1 23	-X1 24	-X1 25	-X1 26	-X1 27	-X1 28	-X1 29
	E10.0	E10.1	E10.2	E10.3	E10.4	E10.5	E10.6	E10.7

INPUT BYTE X+2 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

E10.0	E10.1	E10.2	E10.3	E10.4	E10.5	E10.6	E10.7
LOWER PAPER 2 HEATING HERMAL TRIPPING	SPARE	ELECTRIFIER THERMAL TRIPPING	LOADING CELL 2° WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX THERMAL TRIPPING	LOADING CELL 2° WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 2° BOX THERMAL TRIPPING	SPARE	INK JET THERMAL TRIPPING	230Vac CUSTOMER SUPPLY THERMAL TRIPPING

⇦509

511⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 510
Revision		Replacement of	Replaced by			Group:	Of 414

510.9 / 24V-L10

24Vdc

24V-L10 / 512.0

-0X12 1
Q16

-1X12 1
Q7

512.7
24V-L10

105F2 13 14
105.2

105F4 13 14
105.4

105F5 13 14
105.6

105F7 13 14
105.7

105F8 13 14
105.8

106K1 33 34
106.0

110Q1 13 14
110.1

-1X12 2
Q7

-1X12 3
Q7

-1X12 4
Q7

-1X12 5
Q7

-1X12 6
Q7

-1X12 7
Q7

-1X12 8
Q7

-0X12 2
Q16

-0X12 3
Q16

-0X12 4
Q16

-0X12 5
Q16

-0X12 6
Q16

-0X12 7
Q16

-0X12 8
Q16

511-0

511-2

511-3

511-4

511-5

511-6

511-7

509.9 / 0V2

0V2 / 513.0

-508A0
508.0

-X1 32
E11.0

-X1 33
E11.1

-X1 34
E11.2

-X1 35
E11.3

-X1 36
E11.4

-X1 37
E11.5

-X1 38
E11.6

-X1 39
E11.7

-X1 2M 40

INPUT BYTE X+3 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

230Vac
LAMPS AND
SOCKET SUPPLY
THERMAL
TRIPPING

SPARE

230Vac
HEATERS SUPPLY
THERMAL
TRIPPING

230Vac
DIGITEC
CABINET SUPPLY
THERMAL
TRIPPING

230Vac
LAMPS AND
SOCKET P02
CONSOLE
BOX SUPPLY
THERMAL
TRIPPING

230Vac
STRAPPING
MACHINE SUPPLY
THERMAL
TRIPPING

INTERNAL
CABINET LAMPS
IN FUNCTION

230Vac
GENERAL
DEVICE SUPPLY
THERMAL
TRIPPING

⇦510

512⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	511
Revision			Replacement of / Replaced by			Group: / Of	414

511.9 / 24V-L10 → 24Vdc

24V-L10 / 513.0

511.7
24V-L10

24V-L10 / 513.1

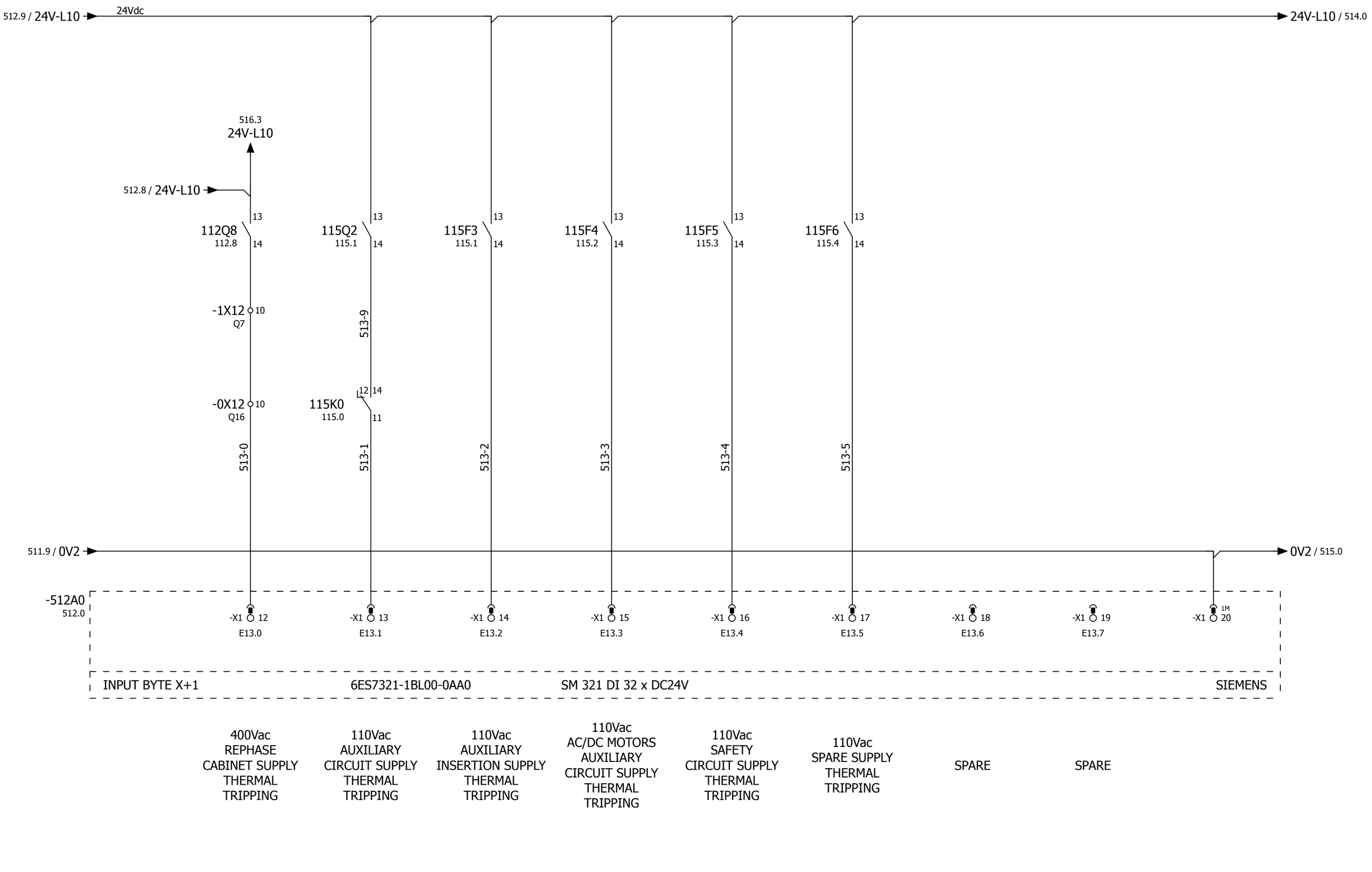
110F1 13/14	110F3 13/14		110F5 13/14	110F6 13/14	111Q1 13/14		112Q2 13/14	112Q5 13/14
110.1	110.3		110.5	110.7	111.1		112.2	112.5
					512-13			-1X12 9 Q7
					111F1 13/14			-0X12 9 Q16
512-0	512-1		512-3	512-4	512-5		512-6	512-7
-X1 2 E12.0	-X1 3 E12.1	-X1 4 E12.2	-X1 5 E12.3	-X1 6 E12.4	-X1 7 E12.5		-X1 8 E12.6	-X1 9 E12.7

-512A0
513.0
514.0
515.0
407.6

INPUT BYTE X | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

230Vac FANS CABINET SUPPLY THERMAL TRIPPING	230Vac EMG CABINET SUPPLY THERMAL TRIPPING	SPARE	230Vac PAPER WINDER JOINTS SUPPLY THERMAL TRIPPING	230Vac SPARE SUPPLY THERMAL TRIPPING	230Vac MOTORS BRAKES SUPPLY THERMAL TRIPPING	400Vac AC MOTORS SUPPLY THERMAL TRIPPING	400Vac SHEAR CABINET SUPPLY THERMAL TRIPPING

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	512
Revision						Group:	Of 414



⇦512 514⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Cabinet digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	513
Revision						Group:	Of 414

513.9 / 24V-L10 → 24Vdc

24V-L10 / 515.0

	120AQ2	120Q2	120F1	120AF1	120AF2	120AF3	120AF4	121Q2
	120A.1	120.1	120.1	120A.1	120A.3	120A.4	120A.5	121.1
13	13	13	13	13	13	13	13	13
14	14	14	14	14	14	14	14	14
	514-8	514-9						514-15
12	12	12						12
14	14	14						14
	120AK0	120K0						121K0
	120A.0	120.0						121.0
11	11	11						11
	514-0	514-1	514-2	514-3	514-4	514-5	514-6	514-7
-512A0	-X1 22	-X1 23	-X1 24	-X1 25	-X1 26	-X1 27	-X1 28	-X1 29
512.0	E14.0	E14.1	E14.2	E14.3	E14.4	E14.5	E14.6	E14.7

INPUT BYTE X+2 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

24Vdc GENERAL SOLENOID VALVES SUPPLY THERMAL TRIPPING	24Vdc GENERAL ZONE 1 SOLENOID VALVES SUPPLY THERMAL TRIPPING	24Vdc ZONE 1 SOLENOID VALVES SUPPLY THERMAL TRIPPING	24Vdc ZONE 2 SOLENOID VALVES SUPPLY THERMAL TRIPPING	24Vdc ZONE 3 SOLENOID VALVES SUPPLY THERMAL TRIPPING	24Vdc PARKING BRAKE SOLENOID VALVES SUPPLY THERMAL TRIPPING	24Vdc SPARE SUPPLY THERMAL TRIPPING	24Vdc GENERAL AUXILIARY SUPPLY THERMAL TRIPPING

⇦513

515⇨

Date	14/05/2014
Drawing	13B01
Drawer	Tengattini Marco
Revision	

NOVASTILMEC S.p.A. Coil Processing Equipment

Comm: A97

Replacement of | Replaced by

elettromeccanica ERCA s.r.l.

Function: Cabinet digital input

Installation: Linea taglio trasversale

=

+

Page 514

Group: | Of 414

514.9 / 24V-L10 → 24Vdc

24V-L10 / 516.0

121F2	121F3	121F5	121F6	121F7	121F8	122F1	122F2
121.2	121.3	121.6	121.7	121.8	121.9	122.1	122.2
13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14	13 / 14
515-0	515-1	515-2	515-3	515-4	515-5	515-6	515-7

513.9 / 0V2 →

0V2 / 517.0

-512A0
512.0

-X1 32	-X1 33	-X1 34	-X1 35	-X1 36	-X1 37	-X1 38	-X1 39	-X1 2M 40
E15.0	E15.1	E15.2	E15.3	E15.4	E15.5	E15.6	E15.7	

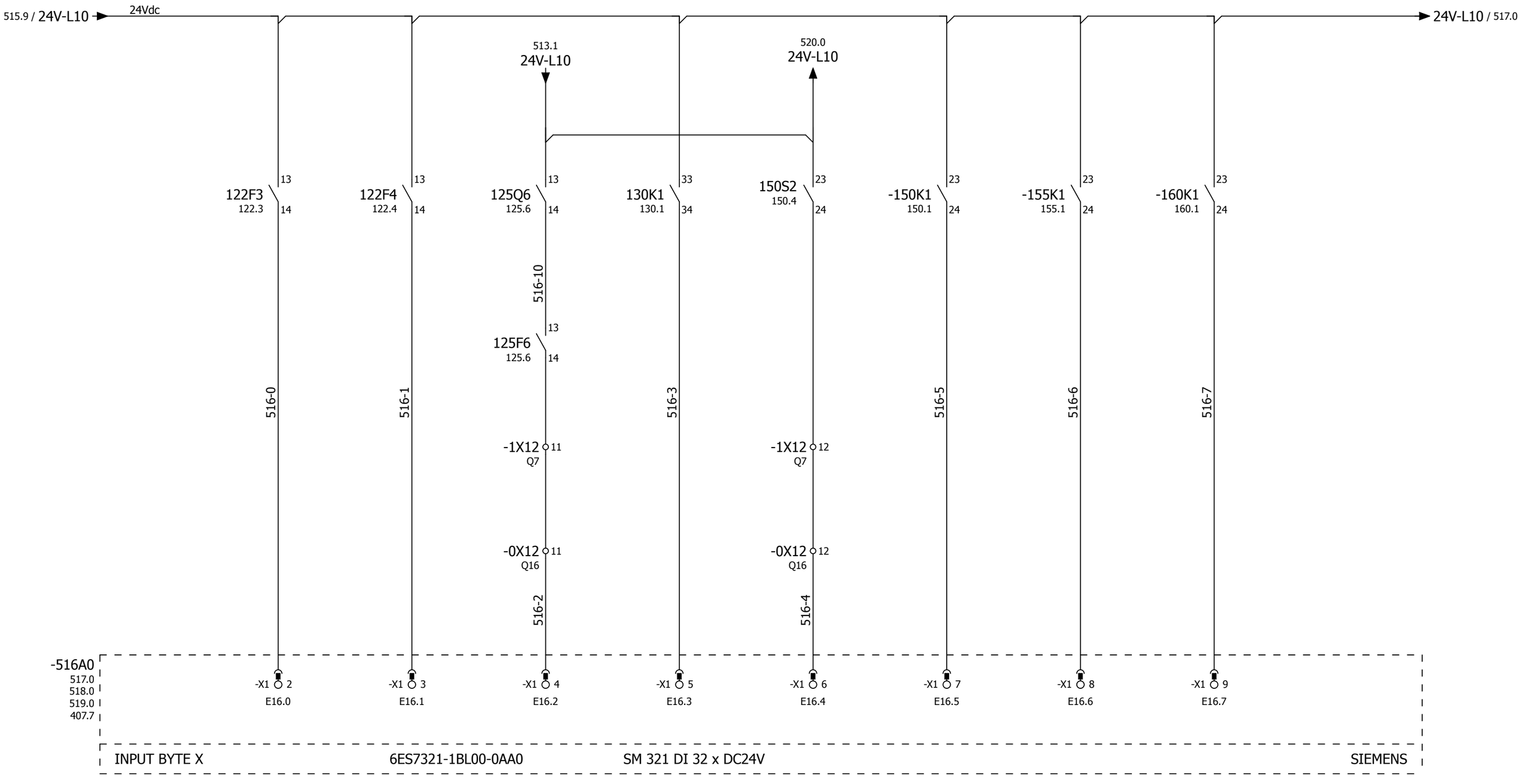
INPUT BYTE X+3 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

24Vdc MACHINE EDGE INPUT SUPPLY THERMAL TRIPPING	24Vdc CABINET OUTPUT SUPPLY THERMAL TRIPPING	24Vdc EMERGENCY RELAY SUPPLY THERMAL TRIPPING	24Vdc OPERATOR SAFETY SUPPLY THERMAL TRIPPING	24Vdc IM151 LEVELLER 1 SUPPLY THERMAL TRIPPING	24Vdc IM151 LEVELLER 2 SUPPLY THERMAL TRIPPING	24Vdc IM151 STACKER CABINET SUPPLY THERMAL TRIPPING	24Vdc IM151 ENTRY MACHINE CABINET SUPPLY THERMAL TRIPPING

⇦514

516⇨

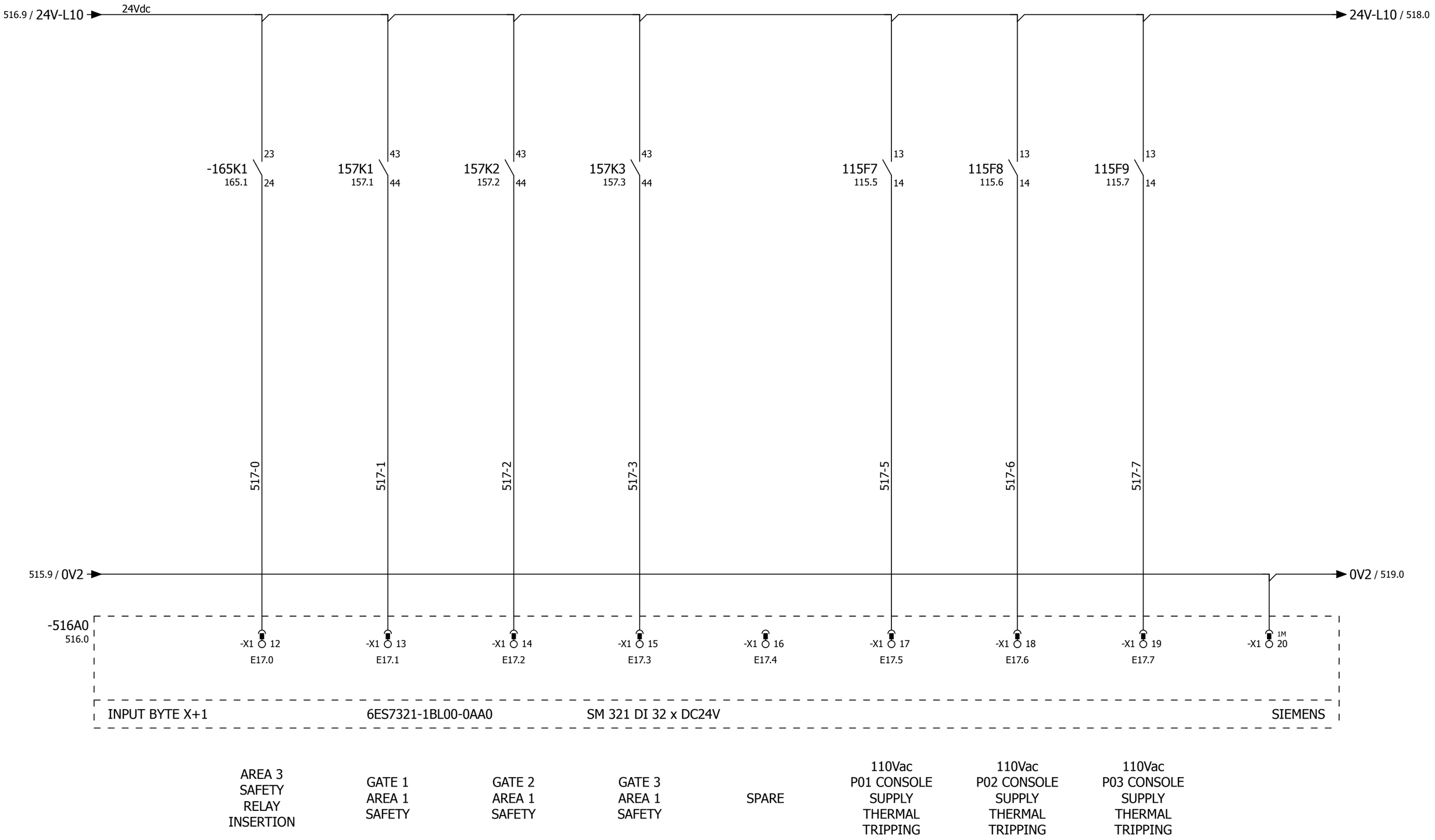
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	515
Revision			Replacement of / Replaced by			Group:	Of 414



⇦515

517⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	516
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⇦516

518⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 517
Revision			Replacement of / Replaced by			Group:	Of 414

517.9 / 24V-L10 — 24Vdc

24V-L10 / 519.0

162K1
162.1

43
44

516-1

-516A0
516.0

-X1 22	-X1 23	-X1 24	-X1 25	-X1 26	-X1 27	-X1 28	-X1 29
E18.0	E18.1	E18.2	E18.3	E18.4	E18.5	E18.6	E18.7

INPUT BYTE X+2 — 6ES7321-1BL00-0AA0 — SM 321 DI 32 x DC24V — SIEMENS

SPARE	GATE 1 AREA 2 SAFETY	SPARE	SPARE	SPARE	SPARE	SPARE	SPARE

⇦517

519⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 518
Revision		Replacement of	Replaced by			Group:	Of 414

518.9 / 24V-L10 → 24Vdc

24V-L10 / 522.0 →

	167K1	167K2	167K3
	167.1	167.2	167.3
43			
44			
	519-1	519-2	519-3

517.9 / 0V2 →

0V2 / 521.0 →

-516A0
516.0

	-X1 32	-X1 33	-X1 34	-X1 35	-X1 36	-X1 37	-X1 38	-X1 39	-X1 2M 40
	E19.0	E19.1	E19.2	E19.3	E19.4	E19.5	E19.6	E19.7	

INPUT BYTE X+3 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

SPARE	GATE 1 AREA 3 SAFETY	GATE 3 AREA 3 SAFETY	GATE 3 AREA 3 SAFETY	SPARE	SPARE	SPARE	SPARE

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 519
Revision			Replacement of / Replaced by			Group:	Of 414

516.5 / 24V-L10 → 24Vdc

24V-L10 / 521.0

	259F2	259F3	259F4	259F5
	259.1	259.3	259.6	259.7
97	97	97	97	97
98	98	98	98	98
-1X12	13	14	15	16
	Q7	Q7	Q7	Q7
-0X12	13	14	15	16
	Q16	Q16	Q16	Q16
	520-1	520-2	520-3	520-4

-520A0
521.0
522.0
523.0
407.8

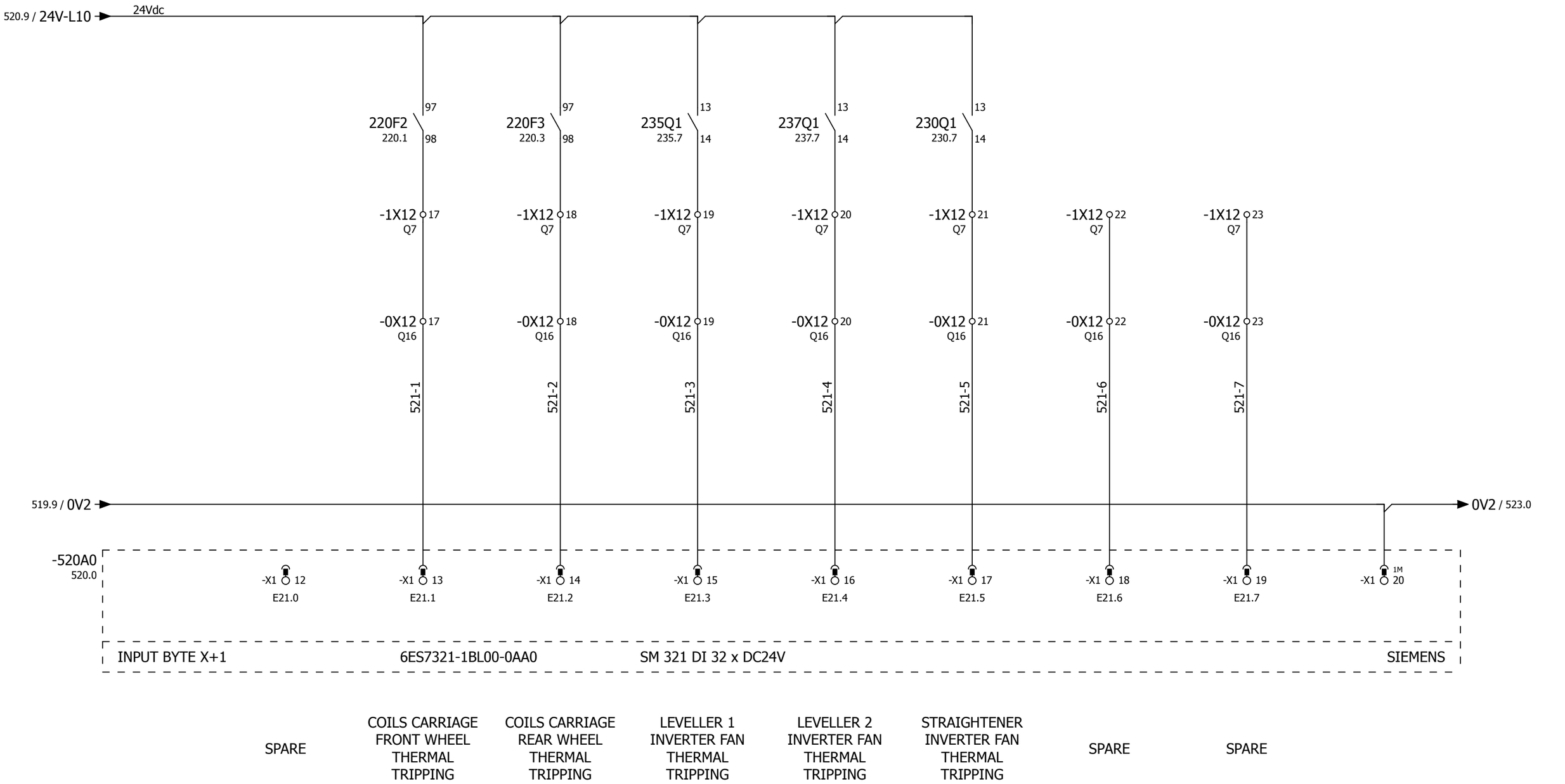
-X1 2	-X1 3	-X1 4	-X1 5	-X1 6	-X1 7	-X1 8	-X1 9
E20.0	E20.1	E20.2	E20.3	E20.4	E20.5	E20.6	E20.7

INPUT BYTE X | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

SPARE	OPERATOR SIDE 1° SHEET CONVEYOR 1° CHOICE STACKER FROM 1° BOX TO 2° BOX THERMAL TRIPPING	OPERATOR SIDE 2° SHEET CONVEYOR 1° CHOICE STACKER FROM 1° BOX TO 2° BOX THERMAL TRIPPING	MOTOR SIDE 1° SHEET CONVEYOR 1° CHOICE STACKER FROM 1° BOX TO 2° BOX THERMAL TRIPPING	MOTOR SIDE 2° SHEET CONVEYOR 1° CHOICE STACKER FROM 1° BOX TO 2° BOX THERMAL TRIPPING	SPARE	SPARE	SPARE

⇦519

521⇨



SPARE	COILS CARRIAGE FRONT WHEEL THERMAL TRIPPING	COILS CARRIAGE REAR WHEEL THERMAL TRIPPING	LEVELLER 1 INVERTER FAN THERMAL TRIPPING
LEVELLER 2 INVERTER FAN THERMAL TRIPPING	STRAIGHTENER INVERTER FAN THERMAL TRIPPING	SPARE	SPARE

⇦520

522⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	521
Revision		Replacement of	Replaced by			Group:	Of 414

519.9 / 24V-L10 → 24Vdc

330Q1	330Q3	330Q4	337Q3	338Q4
330.1	330.2	330.4	337.2	338.4
13	13	13	13	13
14	14	14	14	14
522-0	522-1	522-2	522-3	522-4

-520A0
520.0

-X1 22	-X1 23	-X1 24	-X1 25	-X1 26	-X1 27	-X1 28	-X1 29
E22.0	E22.1	E22.2	E22.3	E22.4	E22.5	E22.6	E22.7

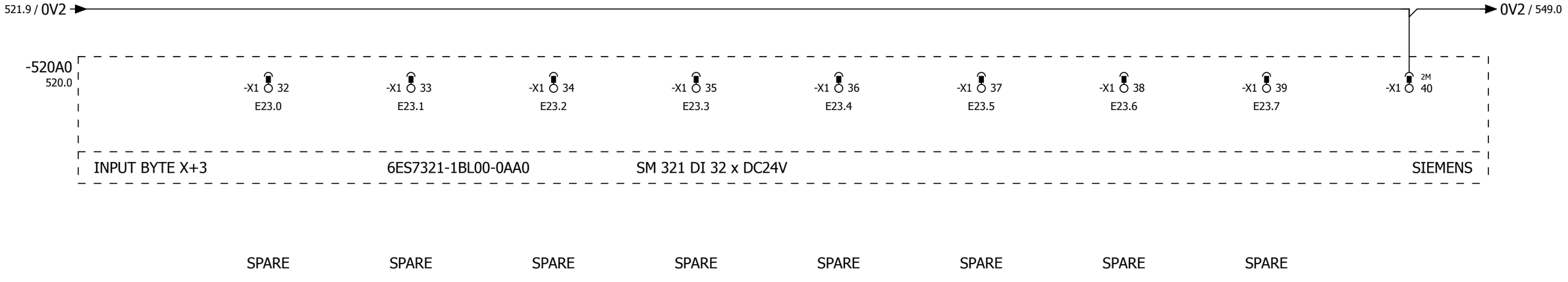
INPUT BYTE X+2 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

COILS CARRIAGE FRONT WHEEL PARKING BRAKE THERMAL TRIPPING	COILS CARRIAGE REAR WHEEL PARKING BRAKE THERMAL TRIPPING	COIL CAR PARKING BRAKE THERMAL TRIPPING	TAIL PINCH ROLL ROTATION PARKING BRAKE THERMAL TRIPPING	PACKAGE FORMING ROLL 2° CHOICE STACKER PARKING BRAKE THERMAL TRIPPING	SPARE	SPARE	SPARE

⇦521

523⇨

0	1	2	3	4	5	6	7	8	9



⇦522

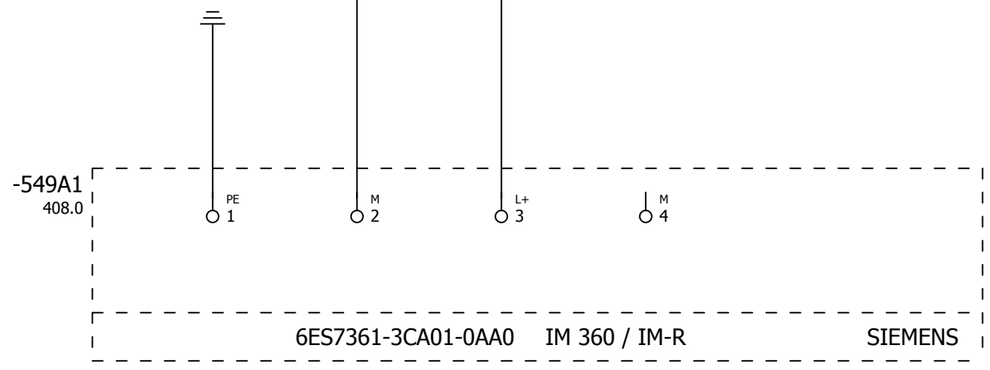
549⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Cabinet digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 523
Revision		Replacement of	Replaced by			Group:	Of 414

499.9 / -24V-L13 — 24Vdc

523.9 / -0V2

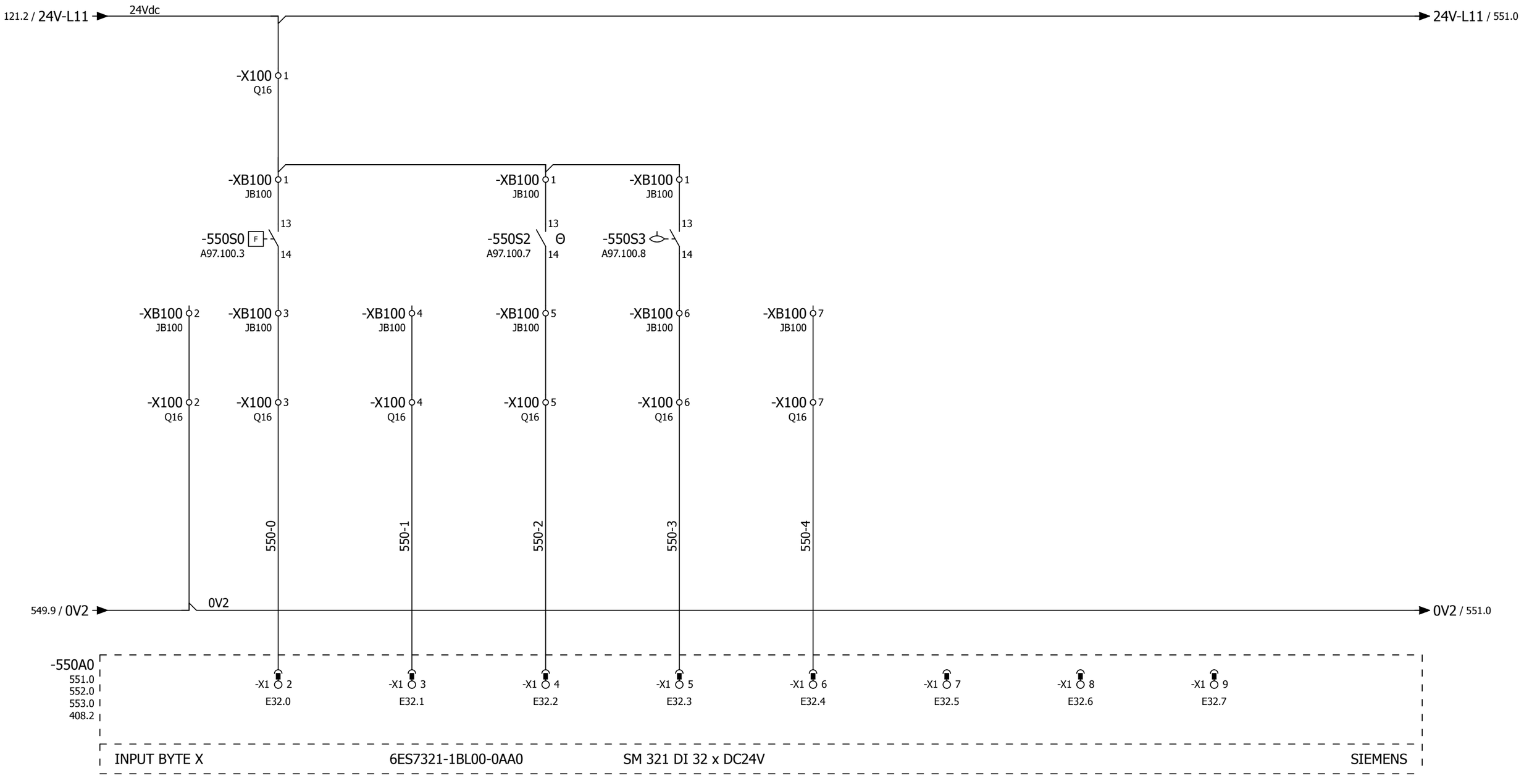
-0V2 / 550.0



⇦523

550⇨

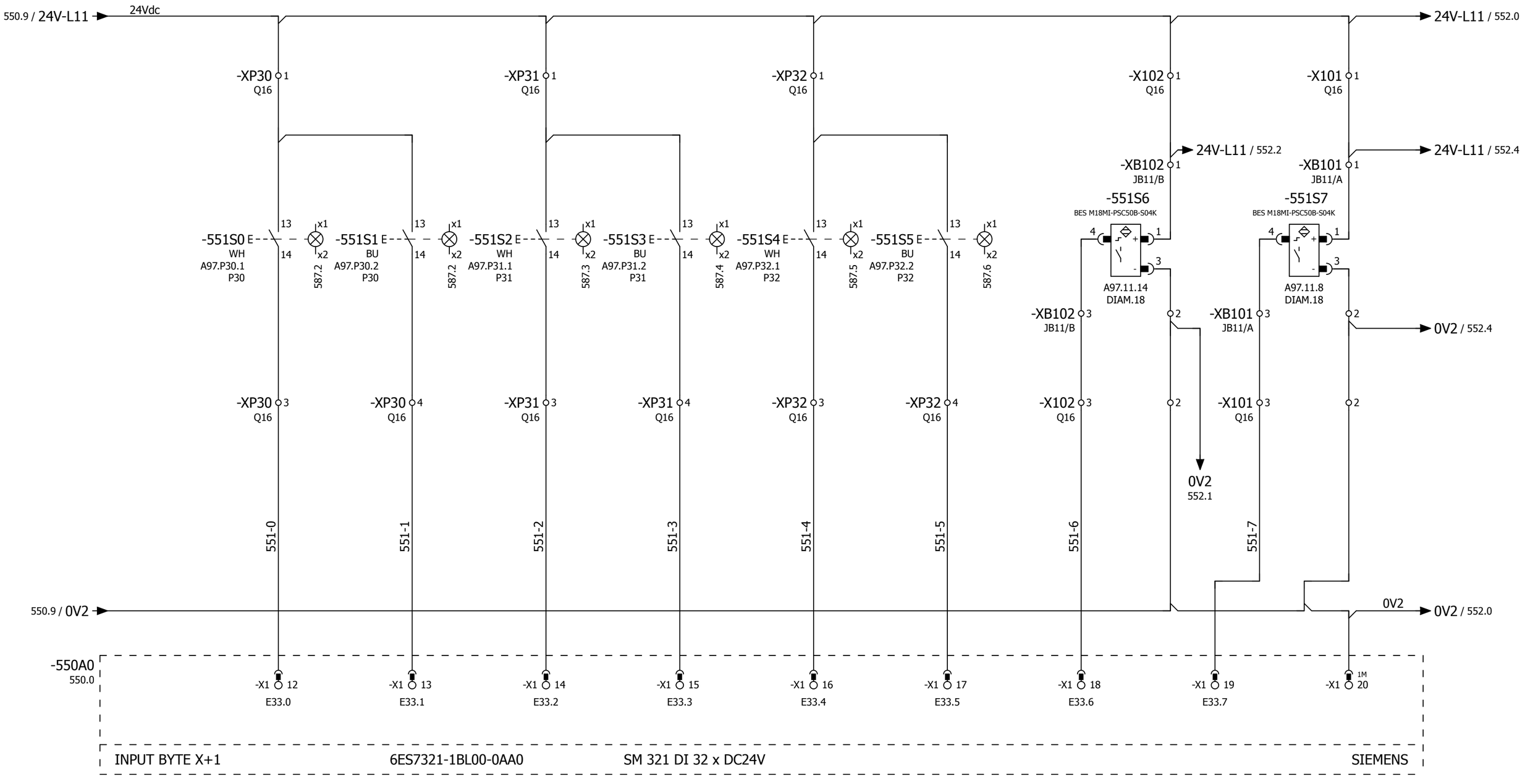
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 361 supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	549
Revision		Replacement of	Replaced by			Group:	Of 414



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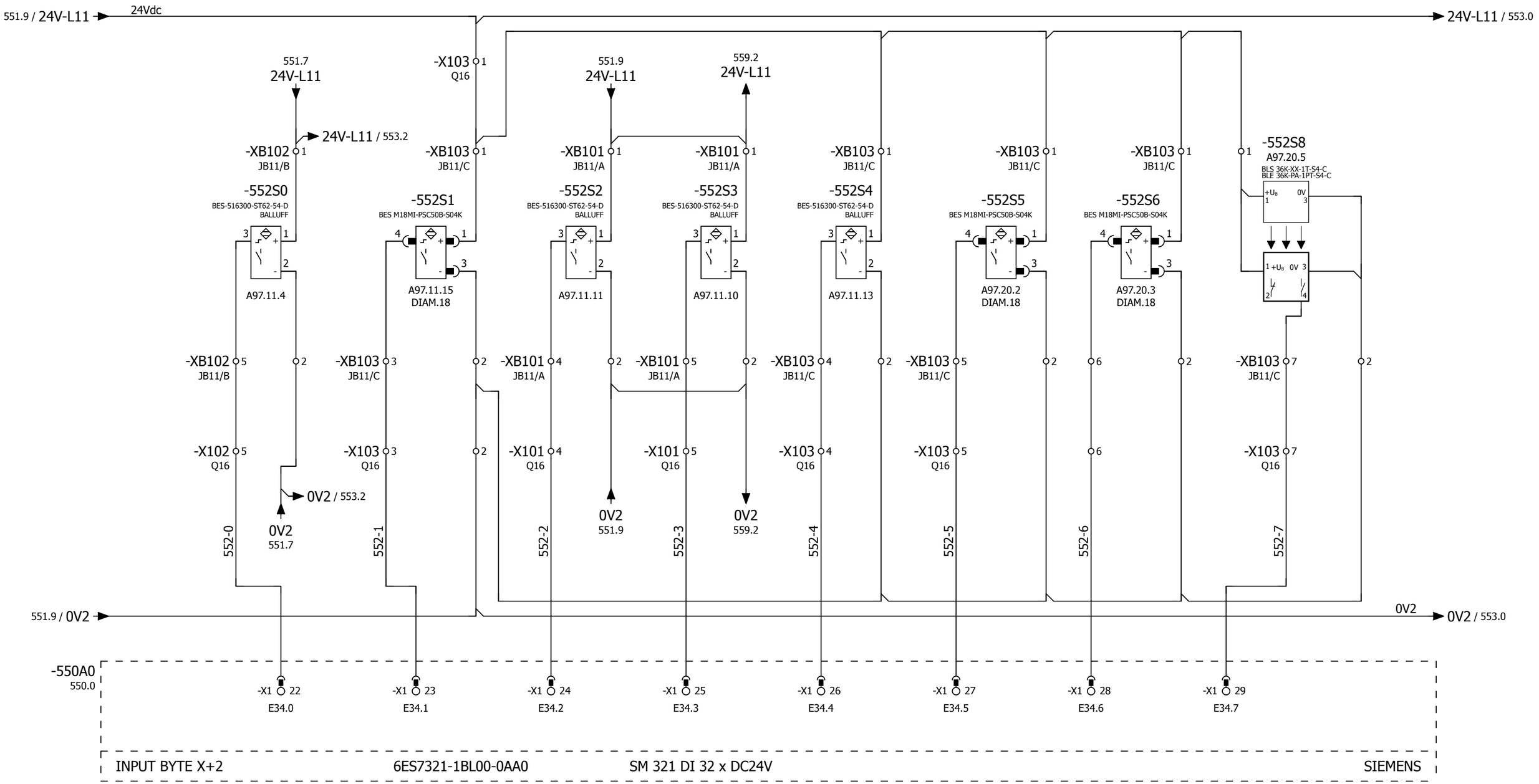
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	550
Revision		Replacement of	Replaced by			Group:	Of 414



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552⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	551
Revision			Replacement of / Replaced by			Group: / Of	414


551.9 / 24V-L11
24Vdc
24V-L11 / 553.0
551.7
24V-L11
-X103 1
Q16
551.9
24V-L11
559.2
24V-L11
24V-L11 / 553.2
-XB102 1
JB11/B
-XB103 1
JB11/C
-XB101 1
JB11/A
-XB101 1
JB11/A
-XB103 1
JB11/C
-XB103 1
JB11/C
-XB103 1
JB11/C
-552S8
A97.20.5
BLS 36K-XX-1T-S4-C
BLE 36K-PA-1PT-S4-C
-552S0
BES-516300-ST62-54-D
BALLUFF
-552S1
BES M18MI-PSC50B-S04K
-552S2
BES-516300-ST62-54-D
BALLUFF
-552S3
BES-516300-ST62-54-D
BALLUFF
-552S4
BES-516300-ST62-54-D
BALLUFF
-552S5
BES M18MI-PSC50B-S04K
-552S6
BES M18MI-PSC50B-S04K
A97.11.4
A97.11.15
DIAM.18
A97.11.11
A97.11.10
A97.11.13
A97.20.2
DIAM.18
A97.20.3
DIAM.18
-XB102 5
JB11/B
-XB103 3
JB11/C
-XB101 4
JB11/A
-XB101 5
JB11/A
-XB103 4
JB11/C
-XB103 5
JB11/C
-XB103 6
JB11/C
-XB103 7
JB11/C
-X102 5
Q16
-X103 3
Q16
-X101 4
Q16
-X101 5
Q16
-X103 4
Q16
-X103 5
Q16
-X103 6
Q16
-X103 7
Q16
0V2 / 553.2
0V2
551.7
0V2
551.9
0V2
559.2
552-0
552-1
552-2
552-3
552-4
552-5
552-6
552-7
551.9 / 0V2
0V2
0V2 / 553.0
-550A0
550.0
-X1 22
E34.0
-X1 23
E34.1
-X1 24
E34.2
-X1 25
E34.3
-X1 26
E34.4
-X1 27
E34.5
-X1 28
E34.6
-X1 29
E34.7
INPUT BYTE X+2
6ES7321-1BL00-0AA0
SM 321 DI 32 x DC24V
SIEMENS
LEVELLER 1 LOW ROLL FOR LINE START CONSENT
LEVELLER 2 EXIT TABLE PASS LINE POSITION FOR LINE START CONSENT
LEVELLER 2 ENTRY ROLL HIGH FOR SHEET PASSAGE OVER LEVELLER 2 ROLLS
LEVELLER 2 LOW ROLL FOR LINE START CONSENT
LEVELLER 2 EXIT ROLL HIGH FOR SHEET PASSAGE OVER LEVELLER 2 ROLLS
UPPER MEASURING WHEEL LOW
LOWER MEASURING WHEEL LOW
MATERIAL PRESENCE MEASURING WHEEL

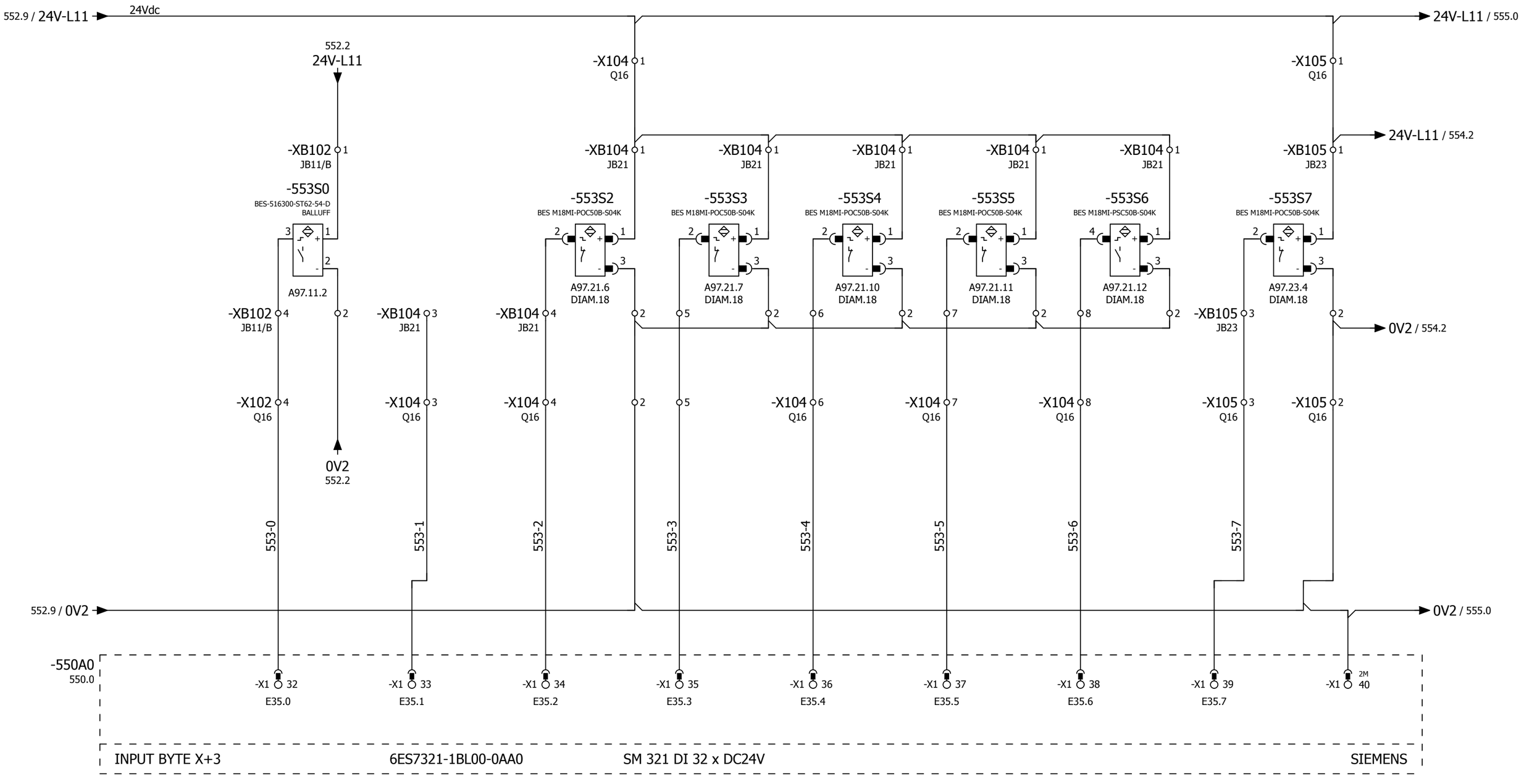
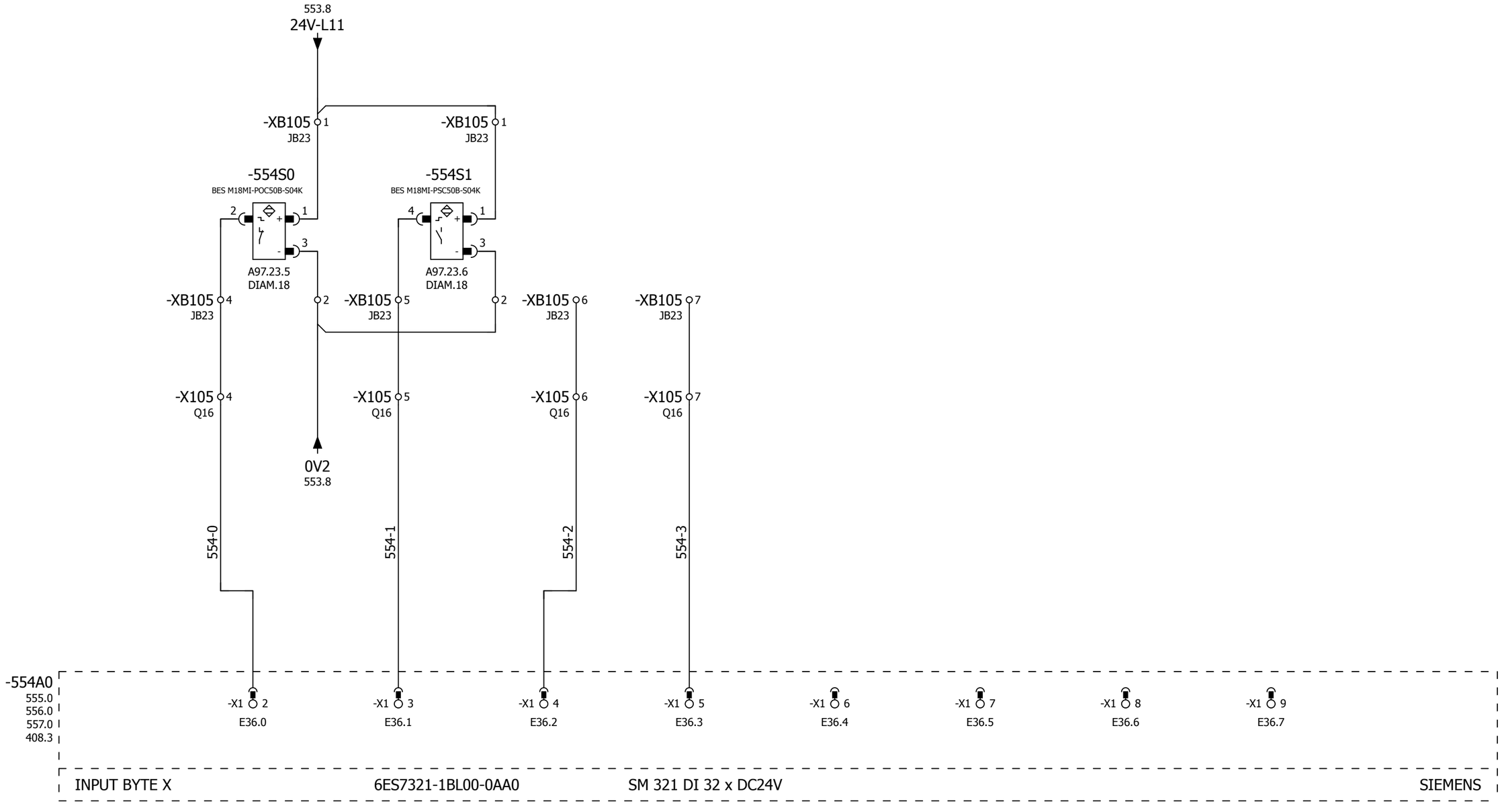


TABLE HIGH EXIT CROPPER SHEAR FOR HEADING CUT CONSENT	SPARE	UPPER ROLLS SUPPORT TRANSLATION MOTOR MAX MOTOR SIDE	UPPER ROLLS SUPPORT TRANSLATION MOTOR MAX OPERATOR SIDE	LOWER ROLLS SUPPORT TRANSLATION MOTOR MAX MOTOR SIDE	LOWER ROLLS SUPPORT TRANSLATION MOTOR MAX OPERATOR SIDE	PAPER BROKEN ON SPREADER ROLL	CENTERING UNIT 2 MAX OPEN	

⇦552

554⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	553
Revision						Group:	Of 414



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Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	554
Revision		Replacement of	Replaced by			Group:	Of 414

553.9 / 24V-L11 → 24Vdc → 24V-L11 / 557.0

-X106 Q16 pin 1

-XB106 JB24 pin 1 → 24V-L11 / 556.1

-XB106 JB24 pin 1

-555S5
BES M18MI-PSC50B-S04K
A97.24.5
DIAM.18
pins 4, 1, 3

-555S6
CSH-223-5
CAMOZZI
A97.24.7

-XB106 JB24 pin 3

-XB106 JB24 pin 2

-XB106 JB24 pin 4

-XB106 JB24 pin 2 → 0V2 / 557.6

-X106 Q16 pin 3

-X106 Q16 pin 2

-X106 Q16 pin 4

555-5

555-6

553.9 / 0V2 → 0V2 → 0V2 / 557.0

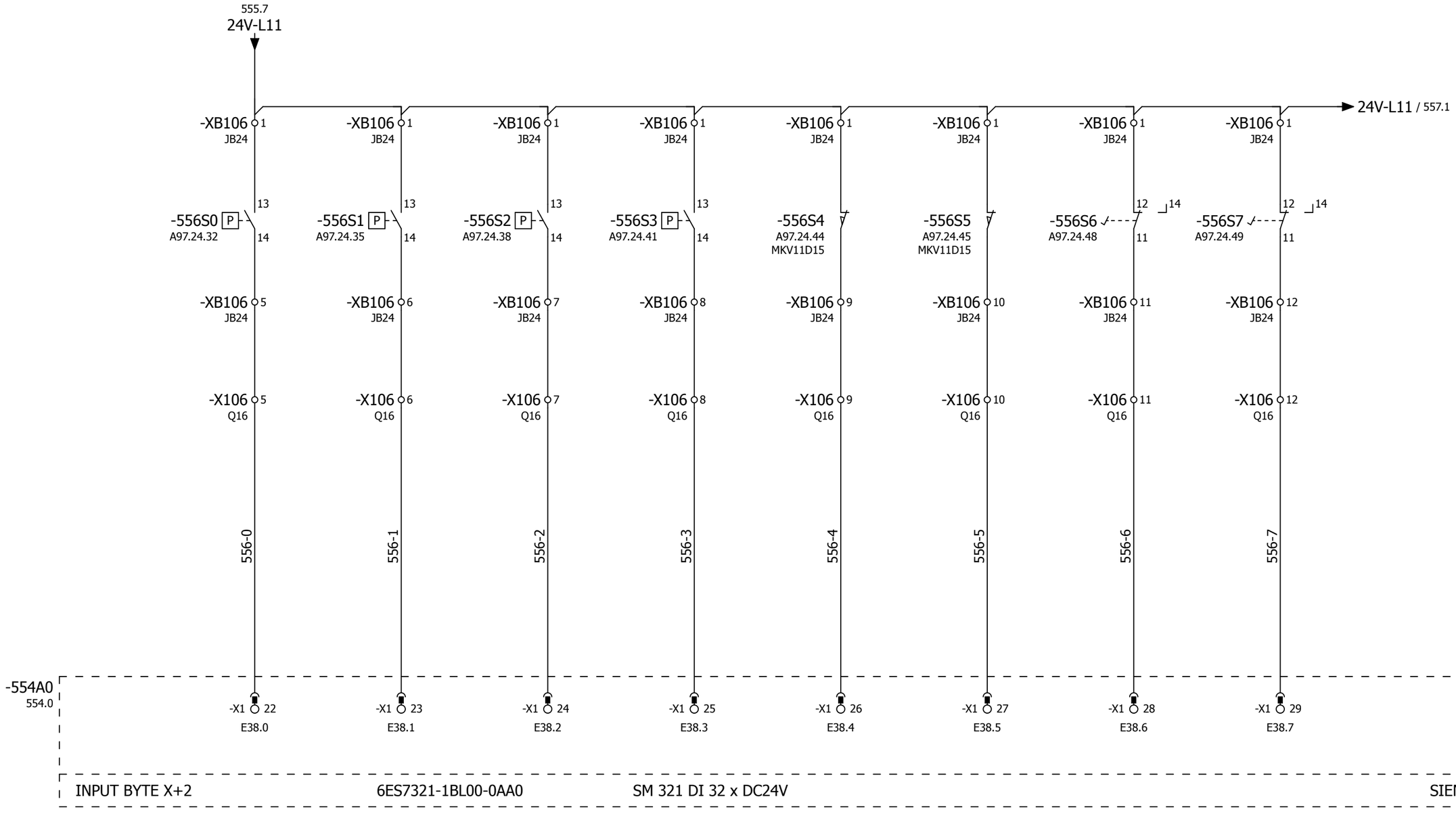
-554A0
554.0

	-X1 12	-X1 13	-X1 14	-X1 15	-X1 16	-X1 17	-X1 18	-X1 19	-X1 1M 20
	E37.0	E37.1	E37.2	E37.3	E37.4	E37.5	E37.6	E37.7	
	SPARE	SPARE	SPARE	SPARE	SPARE	TAIL PINCH ROLL GROUP HIGH	MEASURING WHEEL TAIL PINCH ROLL GROUP HIGH	SPARE	

INPUT BYTE X+1 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

⇦554 556⇨

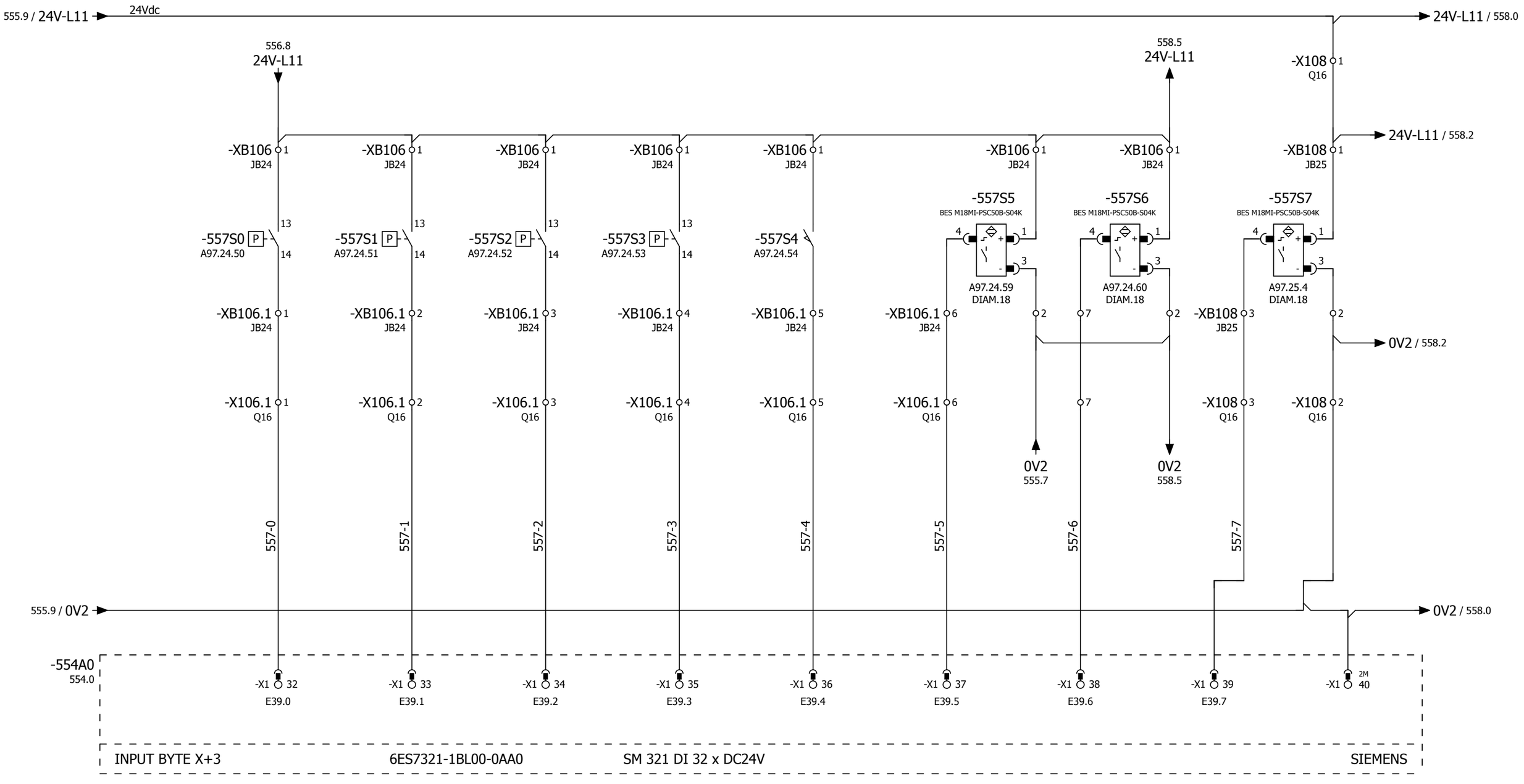
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	555
Revision			Replacement of / Replaced by			Group: / Of	414



⇦555

557⇨

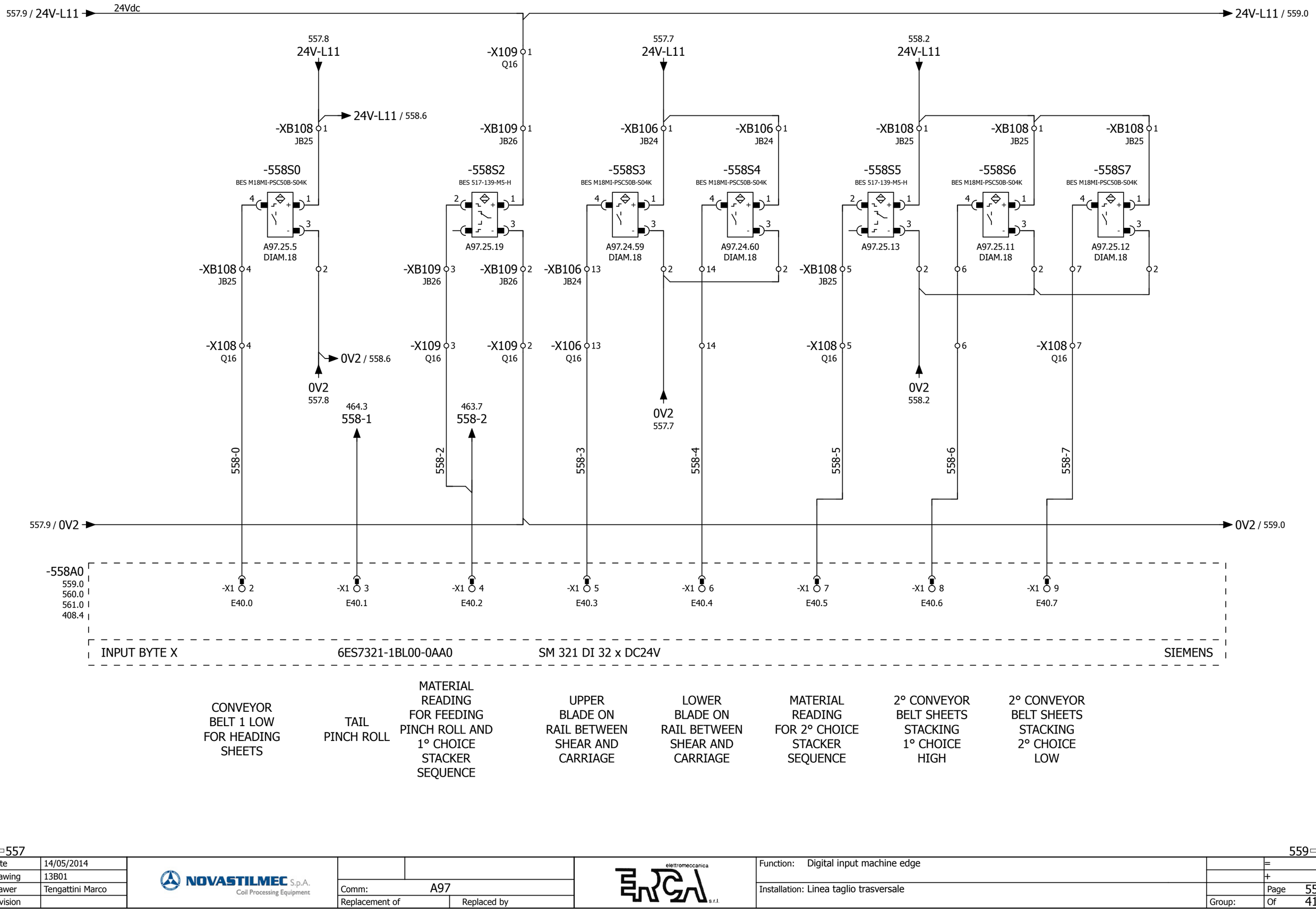
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	556
Revision			Replacement of / Replaced by			Group: / Of	414



⇦556

558⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	557
Revision			Replacement of / Replaced by			Group: / Of	414



⇦557

559⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	558
Revision		Replacement of	Replaced by			Group:	Of 414

558.9 / 24V-L11 — 24Vdc — 24V-L11 / 562.0

552.4
24V-L11

-XB101 JB11/A
-559S0
BES-516300-ST62-54-D
BALLUFF
A97.11.7

-XB101 JB11/A
-559S1
BES-516300-ST62-54-D
BALLUFF
A97.11.5

0V2
552.4

-XP4 Q

24V-L11 / 560.1

-XP04 P04
-559S2
A97.P04.1
P04

-559S4 E
GN
A97.P04.10
P04
588.7

-559S6
A97.P04.2
P04

-XB101 JB11/A
-XP04 P04
-X101 Q16
-XP4 Q

	-XB101 JB11/A	-XB101 JB11/A	-XP04 P04	-XP04 P04	-XP04 P04	-XP04 P04	-XP04 P04	-XP04 P04	-XP04 P04
	6	7	3	4	5	6	7	8	2
	-X101 Q16	-X101 Q16	-XP4 Q	-XP4 Q	-XP4 Q	-XP4 Q	-XP4 Q	-XP4 Q	-XP4 Q
	6	7	3	4	5	6	7	8	2
	559-0	559-1	559-2	559-3	559-4	559-5	559-6	559-7	

558.9 / 0V2 — 0V2 — 0V2 / 561.0

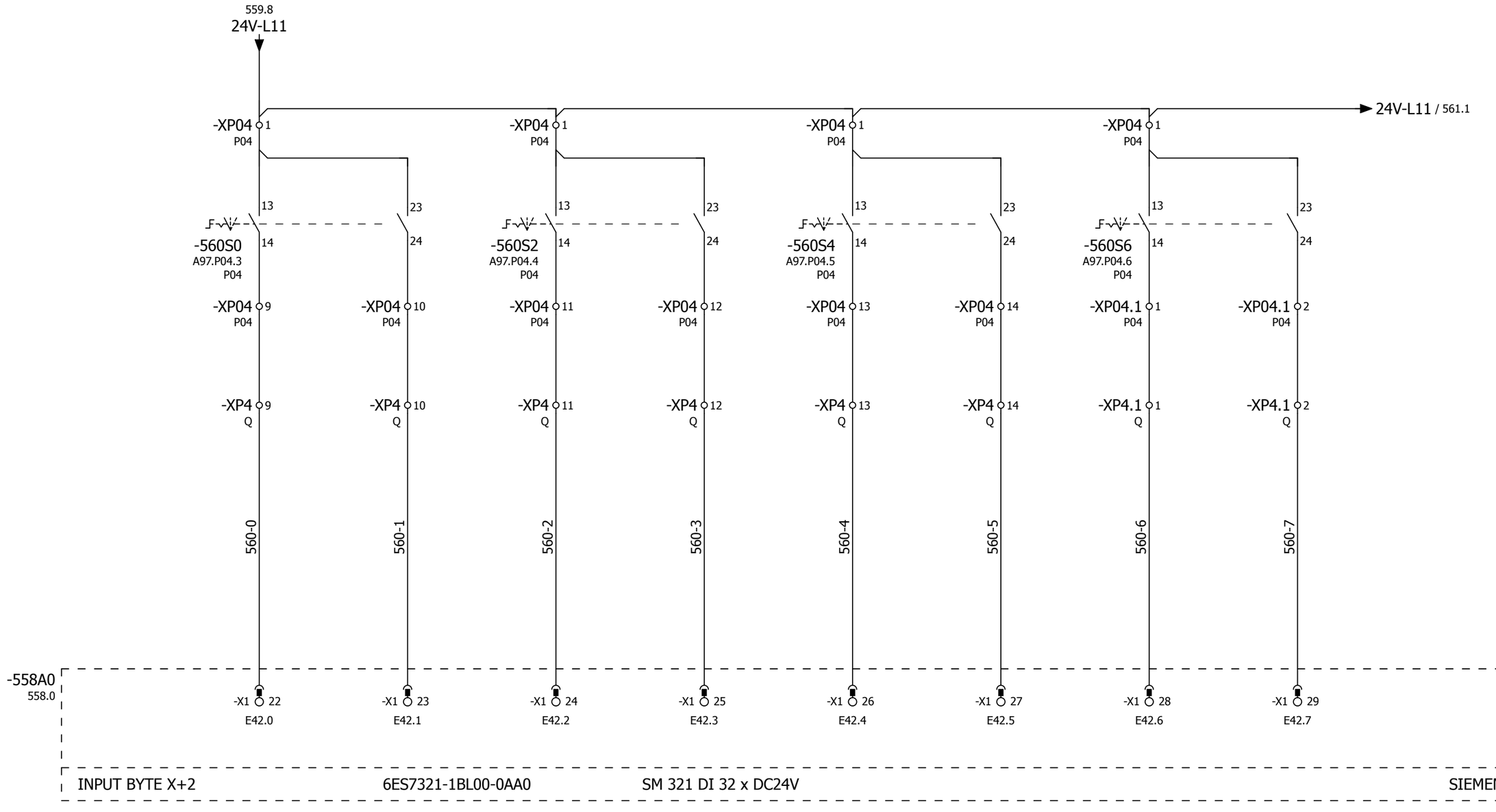
-558A0
558.0

-X1	-X1	-X1	-X1	-X1	-X1	-X1	-X1	-X1
12	13	14	15	16	17	18	19	1M 20
E41.0	E41.1	E41.2	E41.3	E41.4	E41.5	E41.6	E41.7	

INPUT BYTE X+1 — 6ES7321-1BL00-0AA0 — SM 321 DI 32 x DC24V — SIEMENS

TABLE HIGH FOR SHEET PASSAGE OVER LEVELLER 1 ROLLS	LEVELLER 1 ENTRY ROLL HIGH FOR SHEET PASSAGE OVER LEVELLER 1 ROLLS	1° TRANSIT TRANSFER PLATFORM FORWARD	1° TRANSIT TRANSFER PLATFORM BACKWARD	AUTOMATIC DOWNLOAD AFTER STRAPPING	SPARE	1° TRANSIT TRANSFER PLATFORM JUNCTION LEVERS HIGH	1° TRANSIT TRANSFER PLATFORM JUNCTION LEVERS LOW

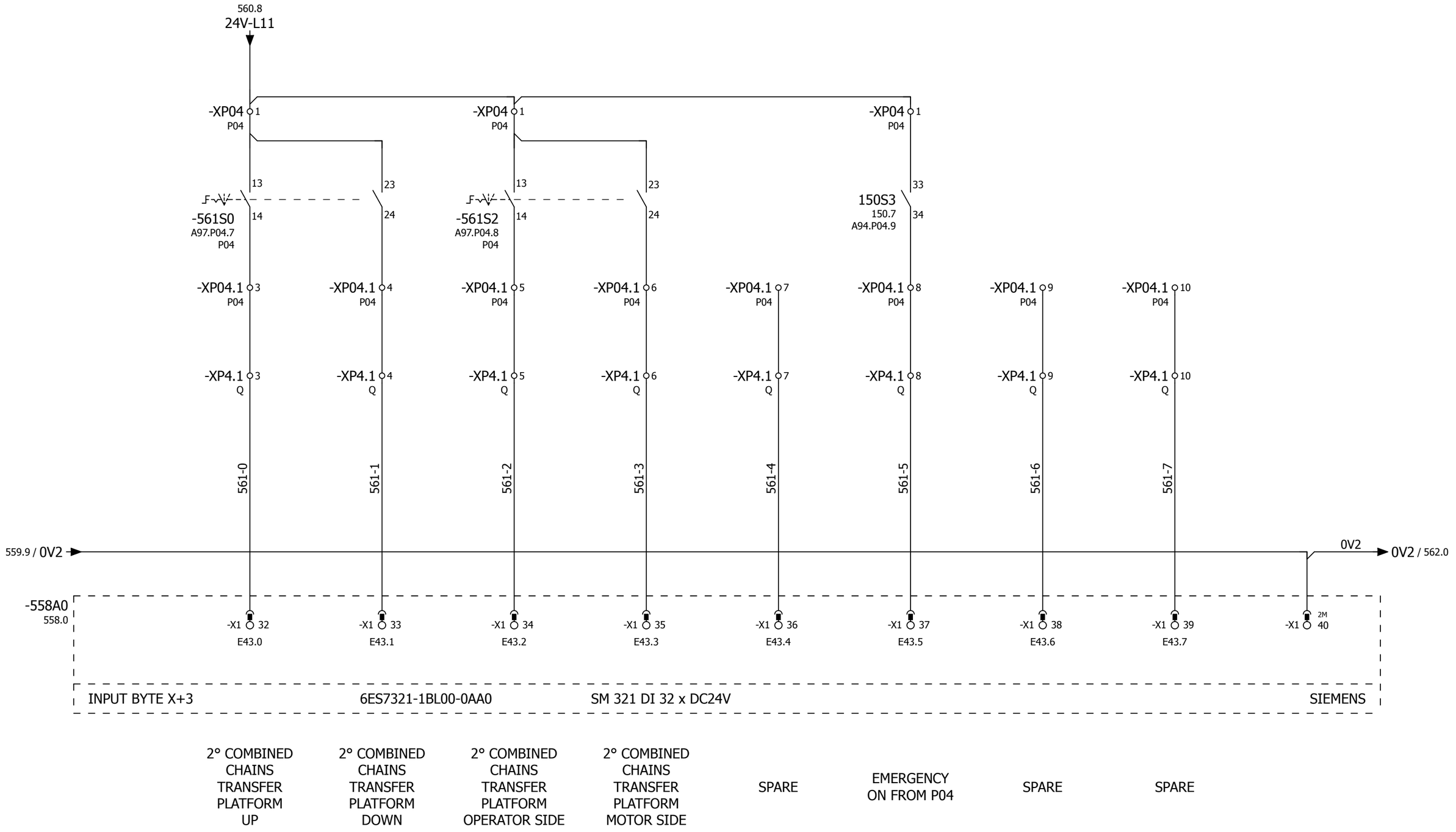
⇦558 560⇨



⇦559

561⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	560
Revision			Replacement of / Replaced by			Group: / Of	414



560

562

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	561
Revision		Replacement of	Replaced by			Group:	Of 414

559.9 / 24V-L11 → 24Vdc

-XP40 Q16 1 | -XP50 Q16 1 | -XP51 Q16 1 | -XP52 Q16 1

-562S0 E WH A97.P40.1 P40 — 13 / 14 — x1 / x2 — 587.7
-562S1 E BU A97.P40.2 P40 — 13 / 14 — x1 / x2 — 587.8
-562S2 E WH A97.P50.1 P50 — 13 / 14 — x1 / x2 — 588.2
-562S3 E BU A97.P50.2 P50 — 13 / 14 — x1 / x2 — 588.2
-562S4 E WH A97.P51.1 P51 — 13 / 14 — x1 / x2 — 588.3
-562S5 E BU A97.P51.2 P51 — 13 / 14 — x1 / x2 — 588.4
-562S6 E WH A97.P52.1 P52 — 13 / 14 — x1 / x2 — 588.5
-562S7 E BU A97.P52.2 P52 — 13 / 14 — x1 / x2 — 588.6

-XP40 Q16 3 | -XP40 Q16 4 | -XP50 Q16 3 | -XP50 Q16 4 | -XP51 Q16 3 | -XP51 Q16 4 | -XP52 Q16 3 | -XP52 Q16 4

562-0 | 562-1 | 562-2 | 562-3 | 562-4 | 562-5 | 562-6 | 562-7

561.9 / 0V2 → 0V2 / 563.0

-562A0
563.0
564.0
565.0
408.5

-X1 2 E44.0 | -X1 3 E44.1 | -X1 4 E44.2 | -X1 5 E44.3 | -X1 6 E44.4 | -X1 7 E44.5 | -X1 8 E44.6 | -X1 9 E44.7

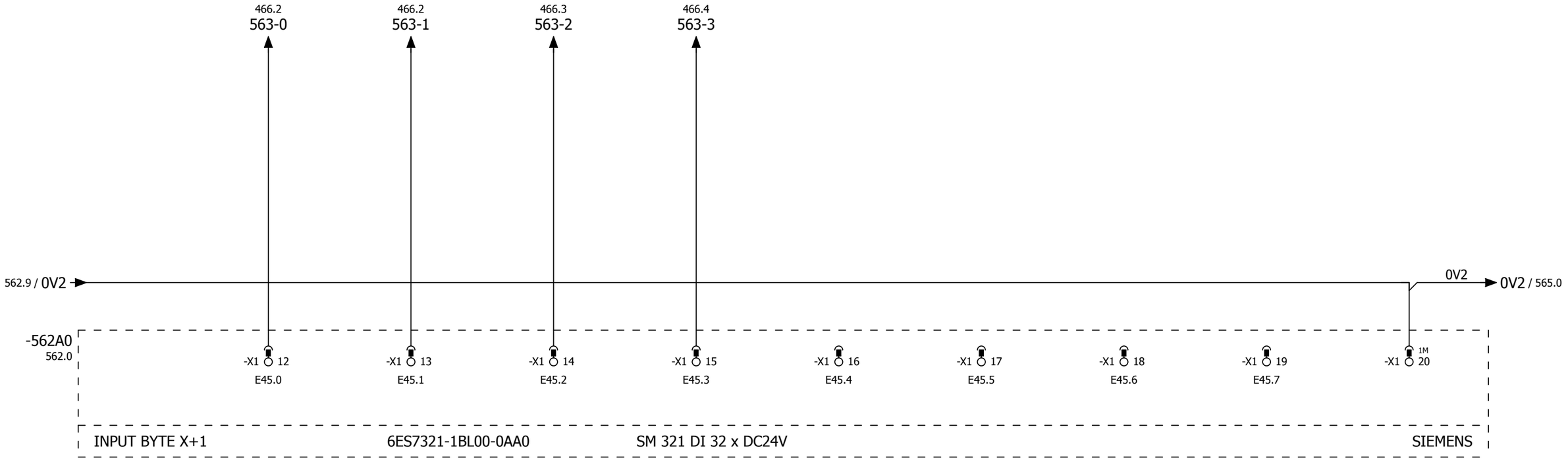
INPUT BYTE X | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

GATE 1 CENTRAL ZONE OPENING ENABLING	GATE 1 CENTRAL ZONE RESET	GATE 1 EXIT ZONE OPENING ENABLING	GATE 1 EXIT ZONE RESET	GATE 2 EXIT ZONE OPENING ENABLING	GATE 2 EXIT ZONE RESET	GATE 3 EXIT ZONE OPENING ENABLING	GATE 3 EXIT ZONE RESET

⇦561

563⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	562
Revision			Replacement of / Replaced by			Group: / Of	414


466.2
563-0
466.2
563-1
466.3
563-2
466.4
563-3
562.9 / 0V2
0V2
0V2 / 565.0
-562A0
562.0
-X1 12
E45.0
-X1 13
E45.1
-X1 14
E45.2
-X1 15
E45.3
-X1 16
E45.4
-X1 17
E45.5
-X1 18
E45.6
-X1 19
E45.7
1M
-X1 20
INPUT BYTE X+1
6ES7321-1BL00-0AA0
SM 321 DI 32 x DC24V
SIEMENS
EXCHANGE DATES WITH TAIL PINCH ROLL PLC
EXCHANGE DATES WITH TAIL PINCH ROLL PLC
EXCHANGE DATES WITH TAIL PINCH ROLL PLC
EXCHANGE DATES WITH TAIL PINCH ROLL PLC
SPARE
SPARE
SPARE
SPARE

⇦562

564⇨

0	1	2	3	4	5	6	7	8	9

-562A0
562.0

-X1 22	-X1 23	-X1 24	-X1 25	-X1 26	-X1 27	-X1 28	-X1 29
E46.0	E46.1	E46.2	E46.3	E46.4	E46.5	E46.6	E46.7

INPUT BYTE X+2 | 6ES7321-1BL00-0AA0 | SM 321 DI 32 x DC24V | SIEMENS

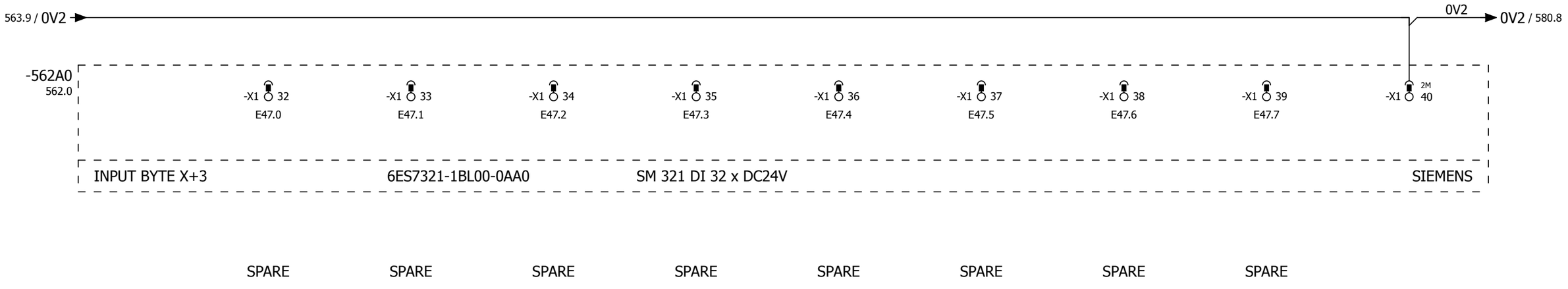
SPARE	SPARE	SPARE	SPARE	SPARE	SPARE	SPARE	SPARE

⇦563

565⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 564
Revision			Replacement of / Replaced by			Group:	Of 414

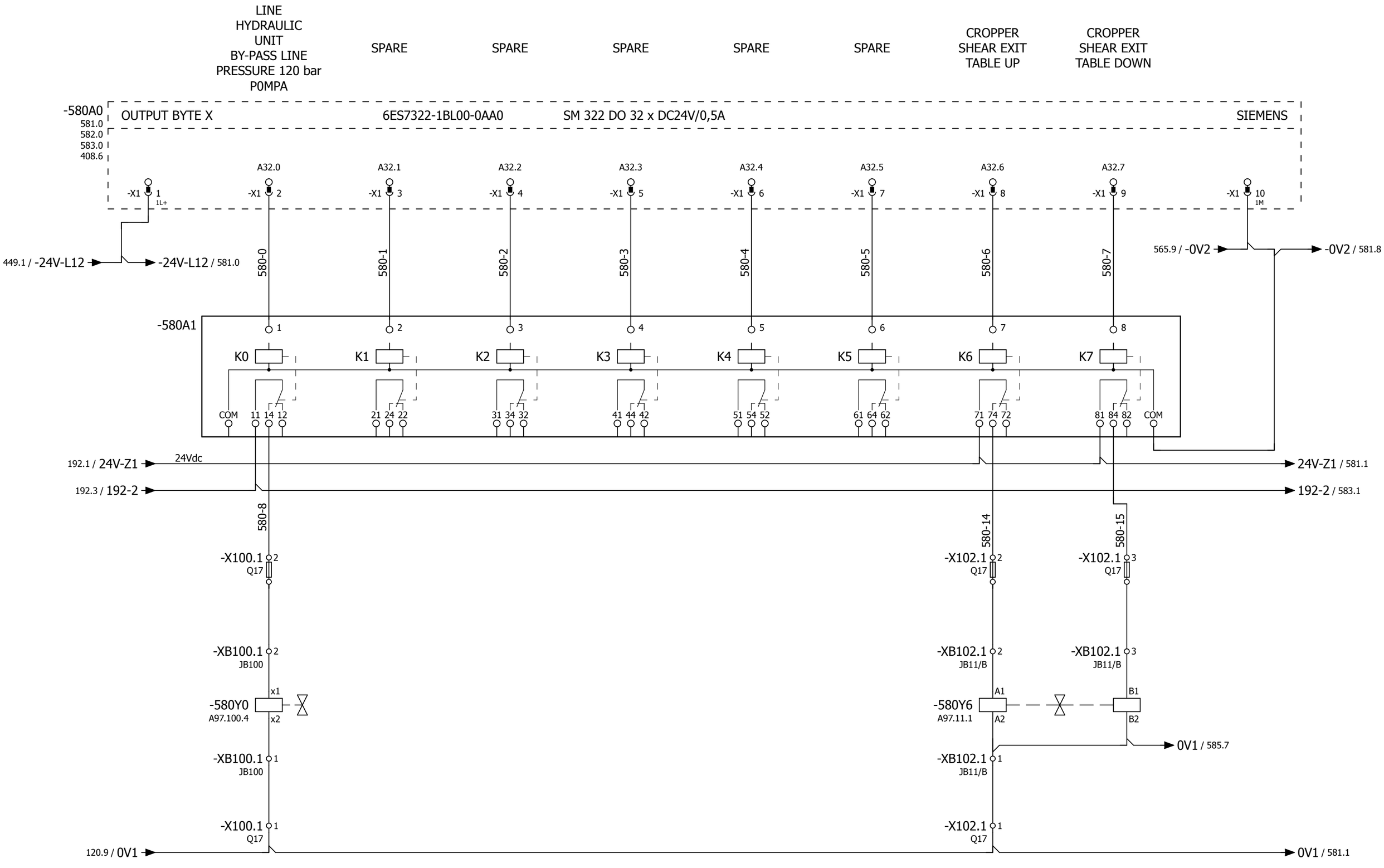
0	1	2	3	4	5	6	7	8	9



⇦564

580⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	565
Revision		Replacement of	Replaced by			Group:	Of 414



⇦565

581⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 580
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

TABLE BETWEEN LEVELLER 1 AND LEVELLER 2 UP

TABLE BETWEEN LEVELLER 1 AND LEVELLER 2 DOWN

LEVELLER 2 ENTRY ROLL UP

LEVELLER 2 ENTRY ROLL DOWN

LEVELLER 2 EXIT TABLE UP

LEVELLER 2 EXIT TABLE DOWN

MEASURING WHEEL UP

MEASURING WHEEL DOWN

-580A0
580.0
OUTPUT BYTE X+1 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A33.0 A33.1 A33.2 A33.3 A33.4 A33.5 A33.6 A33.7

-X1 11 (2L+) -X1 12 -X1 13 -X1 14 -X1 15 -X1 16 -X1 17 -X1 18 -X1 19 -X1 20 (2M)

580.1 / -24V-L12 → -24V-L12 / 582.0

580.9 / -0V2 → -0V2 / 582.8

581-0 581-1 581-2 581-3 581-4 581-5 581-6 581-7

-581A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

580.9 / 24V-Z1 → 24Vdc

24V-Z1 / 582.1

581-8 581-9 581-10 581-11 581-12 581-13 581-14 581-15

-X101.1 2 Q17 | -X101.1 3 Q17 | -X101.1 4 Q17 | -X101.1 5 Q17 | -X103.1 3 Q17 | -X103.1 4 Q17 | -X103.1 5 Q17 | -X103.1 6 Q17

-XB101.1 2 JB11/A | -XB101.1 3 JB11/A | -XB101.1 4 JB11/A | -XB101.1 5 JB11/A | -XB103.1 3 JB11/C | -XB103.1 4 JB11/C | -XB103.1 5 JB11/C | -XB103.1 6 JB11/C

-581Y0 A97.11.6 (A1/A2/B1/B2) | -581Y2 A97.11.9 (A1/A2/B1/B2) | -581Y4 A97.11.12 (A1/A2/B1/B2) | -581Y6 A97.20.1 (A1/A2/B1/B2)

-XB101.1 1 JB11/A | -XB103.1 1 JB11/C | -XB103.1 JB11/C 2

-X101.1 1 Q17 | -X103.1 1 Q17 | -X103.1 2 Q17

580.9 / 0V1 → 0V1 / 582.1

580

582

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 581
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

SPARE | PLASTICIZEN DEVICE UPPER ROLL OPEN | PLASTICIZEN DEVICE UPPER ROLL CLOSE | SPARE | SPARE | SPARE | SPARE | SPARE

-580A0
580.0
OUTPUT BYTE X+2 | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

A34.0 A34.1 A34.2 A34.3 A34.4 A34.5 A34.6 A34.7

-X1 21 (3L+) | -X1 22 | -X1 23 | -X1 24 | -X1 25 | -X1 26 | -X1 27 | -X1 28 | -X1 29 | -X1 30 (3M)

581.1 / -24V-L12 → -24V-L12 / 583.0

582-0 | 582-1 | 582-2 | 582-3 | 582-4 | 582-5 | 582-6 | 582-7

581.9 / -0V2 → -0V2 / 583.8

-582A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

581.9 / 24V-Z1 → 24Vdc → 24V-Z1 / 585.1

582-9 | 582-10

-X104.1 Q17 2 | -X104.1 Q17 3

-XB104.1 JB21 2 | -XB104.1 JB21 3

-582Y1 A97.21.8 (A1, A2, B1, B2)

-XB104.1 JB21 1

-X104.1 Q17 1

581.9 / 0V1 → 0V1 / 583.1

581

583

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 582
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

SPARE | SPARE | TAIL PINCH ROLL UP | TAIL PINCH ROLL DOWN | MEASURING WHEEL TAIL PINCH ROLL UP | MEASURING WHEEL TAIL PINCH ROLL DOWN | SPARE | UPPER BLADE LOCKING VERTICAL MOVEMENT

-580A0
580.0
OUTPUT BYTE X+3 | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

A35.0 A35.1 A35.2 A35.3 A35.4 A35.5 A35.6 A35.7

-X1 31 (4L+) -X1 32 -X1 33 -X1 34 -X1 35 -X1 36 -X1 37 -X1 38 -X1 39 -X1 40 (4M)

582.1 / -24V-L12 → -24V-L12 / 584.0

582.9 / -0V2 → -0V2 / 584.8

583-0 583-1 583-2 583-3 583-4 583-5 583-6 583-7

-583A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

192.6 / 24V-Z2 → 24Vdc

24V-Z2 / 584.1

580.9 / 192-2 →

192-2 / 584.1

583-10 583-11 583-12 583-13 583-15

-X107 3 Q17 | -X107 4 Q17 | -X107 5 Q17 | -X107 6 Q17 | -X107 7 Q17

-XB107 3 JB24 | -XB107 4 JB24 | -XB107 5 JB24 | -XB107 6 JB24 | -XB107 7 JB24

-583Y2 A97.24.4 (A1 A2 B1 B2)

-583Y4 A97.24.6 (A1 A2 B1 B2)

-583Y7 A97.24.30 (x1 x2)

-XB107 1 JB24

-XB107 JB24 2 → 0V1 / 584.1

-X107 1 Q17

-X107 2 Q17

582.9 / 0V1 →

0V1 / 587.1

120A.8 / 0V1 →

0V1 / 585.1

582

584

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 583
Revision			Replacement of / Replaced by			Group:	Of 414

UPPER BLADE LOCKING VERTICAL MOVEMENT SAFETY VALVE

UPPER BLADE LOCKING HORIZONTAL MOVEMENT

UPPER BLADE LOCKING HORIZONTAL MOVEMENT SAFETY VALVE

LOWER BLADE LOCKING VERTICAL MOVEMENT

LOWER BLADE LOCKING VERTICAL MOVEMENT SAFETY VALVE

LOWER BLADE LOCKING HORIZONTAL MOVEMENT

LOWER BLADE LOCKING HORIZONTAL MOVEMENT SAFETY VALVE

FLYING SHEAR GREASE LUBRICATION DISTRIBUTION

-584A0
585.0
586.0
587.0
408.6

OUTPUT BYTE X | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

-X1 1 1L+ — 583.1 / -24V-L12 → -24V-L12 / 585.0

A36.0 -X1 2 — 584-0
A36.1 -X1 3 — 584-1
A36.2 -X1 4 — 584-2
A36.3 -X1 5 — 584-3
A36.4 -X1 6 — 584-4
A36.5 -X1 7 — 584-5
A36.6 -X1 8 — 584-6
A36.7 -X1 9 — 584-7

-X1 10 1M — 583.9 / -0V2 → -0V2 / 585.8

-584A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82

COM

583.9 / 24V-Z2 → 24Vdc → 24V-Z2 / 585.1

583.9 / 192-2 → 192-2 / 587.1

	584-8	584-9	584-10	584-11	584-12	584-13	584-14	584-15
-X107	8	9	10	11	12	13	14	15
Q17								
-XB107	8	9	10	11	12	13	14	15
JB24								
	-584Y0 A97.24.31	-584Y1 A97.24.33	-584Y2 A97.24.34	-584Y3 A97.24.36	-584Y4 A97.24.37	-584Y5 A97.24.39	-584Y6 A97.24.40	-584Y7 A97.24.47

x1 / x2

583.8 / 0V1

⇦583

585⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 584
Revision			Replacement of / Replaced by			Group:	Of 414

HEADING SHEETS SCRAPS CONVEYOR BELT UP

HEADING SHEETS SCRAPS CONVEYOR BELT DOWN

SPARE

SPARE

2° CONVEYOR BELT FOR SHEETS STACKING 1° OR 2° CHOICE UP

2° CONVEYOR BELT FOR SHEETS STACKING 1° OR 2° CHOICE DOWN

LEVELLER 1 ENTRY ROLL UP

LEVELLER 1 ENTRY ROLL DOWN

-584A0
584.0
OUTPUT BYTE X+1 6ES7322-1BL00-0AA0 SM 322 DO 32 x DC24V/0,5A SIEMENS

A37.0 A37.1 A37.2 A37.3 A37.4 A37.5 A37.6 A37.7

-X1 11 2L+ -X1 12 -X1 13 -X1 14 -X1 15 -X1 16 -X1 17 -X1 18 -X1 19 -X1 20 2M

584.1 / -24V-L12 → -24V-L12 / 587.0

585-0 585-1 585-2 585-3 585-4 585-5 585-6 585-7

584.9 / -0V2 → -0V2 / 587.8

-585A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

582.9 / 24V-Z1 → 24Vdc
584.9 / 24V-Z2 →
/ 24V-Z3 →

585-8 585-9 585-10 585-11 585-12 585-13 585-14 585-15

-X108.1 3 Q17 | -X108.1 4 Q17 | -X108.1 5 Q17 | -X108.1 6 Q17 | -X110 2 Q17 | -X110 3 Q17 | -X102.1 4 Q17 | -X102.1 5 Q17

-XB108.1 3 JB25 | -XB108.1 4 JB25 | -XB108.1 5 JB25 | -XB108.1 6 JB25 | -XB110 2 JB25/A | -XB110 3 JB25/A | -XB102.1 4 JB11/B | -XB102.1 5 JB11/B

-585Y0 A97.25.3 (A1 / A2 / B1 / B2)
-585Y4 A97.25.10 (A1 / A2 / B1 / B2)
-585Y6 A97.11.3 (A1 / A2 / B1 / B2)

-XB108.1 1 JB25 | -XB108.1 2 JB25 | -XB110 1 JB25/A

-X108.1 1 Q17 | -X108.1 2 Q17 | -X110 1 Q17

0V1
580.8

583.9 / 0V1 →

⇦584

586⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 585
Revision			Replacement of / Replaced by			Group:	Of 414

1° CHOICE STACKER 1° BOX OPERATOR SIDE SHEET SUPPORT
1° CHOICE STACKER 1° BOX OPERATOR SIDE SHEET SUPPORT
1° CHOICE STACKER 1° BOX MOTOR SIDE SHEET SUPPORT
1° CHOICE STACKER 1° BOX MOTOR SIDE SHEET SUPPORT
1° CHOICE STACKER 2° BOX OPERATOR SIDE SHEET SUPPORT
1° CHOICE STACKER 2° BOX OPERATOR SIDE SHEET SUPPORT
1° CHOICE STACKER 2° BOX MOTOR SIDE SHEET SUPPORT
1° CHOICE STACKER 2° BOX MOTOR SIDE SHEET SUPPORT

-584A0
584.0
OUTPUT BYTE X+2 | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

	A38.0	A38.1	A38.2	A38.3	A38.4	A38.5	A38.6	A38.7	
-X1	21	22	23	24	25	26	27	28	29	30
	3L+									3M

125.7 / -24V-L30
24V-L31
-586F1 5x20 2Agl (1 / 2)

	586-0	586-1	586-2	586-3	586-4	586-5	586-6	586-7	
-0X13 Q16	1	3	4	5	6	7	8	9	10	2
-1X13 Q7	1	3	4	5	6	7	8	9	10	2

586-0 207.4
586-1 207.5
586-2 207.5
586-3 207.5
586-4 208.4
586-5 208.5
586-6 208.5
586-7 208.5

212.9 / -0V3

585
587

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	586
Revision			Replacement of / Replaced by			Group:	Of 414

GATE 1 ENTRY ZONE OPENING ENABLING | GATE 1 ENTRY ZONE RESET | GATE 2 ENTRY ZONE OPENING ENABLING | GATE 2 ENTRY ZONE RESET | GATE 3 ENTRY ZONE OPENING ENABLING | GATE 3 ENTRY ZONE RESET | GATE 1 CENTRAL ZONE OPENING ENABLING | GATE 1 CENTRAL ZONE RESET

-584A0
584.0
OUTPUT BYTE X+3 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A39.0 A39.1 A39.2 A39.3 A39.4 A39.5 A39.6 A39.7

-X1 31 (4L+) -X1 32 -X1 33 -X1 34 -X1 35 -X1 36 -X1 37 -X1 38 -X1 39 -X1 40 (4M)

585.1 / -24V-L12 → -24V-L12 / 588.0

585.9 / -0V2 → -0V2 / 588.8

587-0 587-1 587-2 587-3 587-4 587-5 587-6 587-7

-587A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

584.9 / 192-2 → 24Vdc

192-2 / 588.1

587-8 587-9 587-10 587-11 587-12 587-13 587-14 587-15

-XP30 5 Q16 | -XP30 6 Q16 | -XP31 5 Q16 | -XP31 6 Q16 | -XP32 5 Q16 | -XP32 6 Q16 | -XP40 5 Q16 | -XP40 6 Q16

-551S0 x1 x2 551.1 WH P30
-551S1 x1 x2 551.2 BU P30
-551S2 x1 x2 551.3 WH P31
-551S3 x1 x2 551.4 BU P31
-551S4 x1 x2 551.5 WH P32
-551S5 x1 x2 551.6 BU P32
-562S0 x1 x2 562.1 WH P40
-562S1 x1 x2 562.2 BU P40

-XP30 2 Q16 | -XP31 2 Q16 | -XP32 2 Q16 | -XP40 2 Q16

583.9 / 0V1 → 0V1 / 588.1

586

588

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	587
Revision		Replacement of	Replaced by			Group:	Of 414

GATE 1 EXIT ZONE OPENING ENABLING | GATE 1 EXIT ZONE RESET | GATE 2 EXIT ZONE OPENING ENABLING | GATE 2 EXIT ZONE RESET | GATE 3 EXIT ZONE OPENING ENABLING | GATE 3 EXIT ZONE RESET | AUTOMATIC DOWNLOAD AFTER STRAPPING | SPARE

-588A0 OUTPUT BYTE X 6ES7322-1BL00-0AA0 SM 322 DO 32 x DC24V/0,5A SIEMENS

589.0
590.0
591.0
408.7

-X1 1 1L+ — 587.1 / -24V-L12 → -24V-L12 / 589.0

A40.0 -X1 2 — 588-0
A40.1 -X1 3 — 588-1
A40.2 -X1 4 — 588-2
A40.3 -X1 5 — 588-3
A40.4 -X1 6 — 588-4
A40.5 -X1 7 — 588-5
A40.6 -X1 8 — 588-6
A40.7 -X1 9 — 588-7

-X1 10 1M — 587.9 / -0V2 → -0V2 / 589.8

-588A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82

COM

587.9 / 192-2 → 24Vdc → 192-2 / 589.1

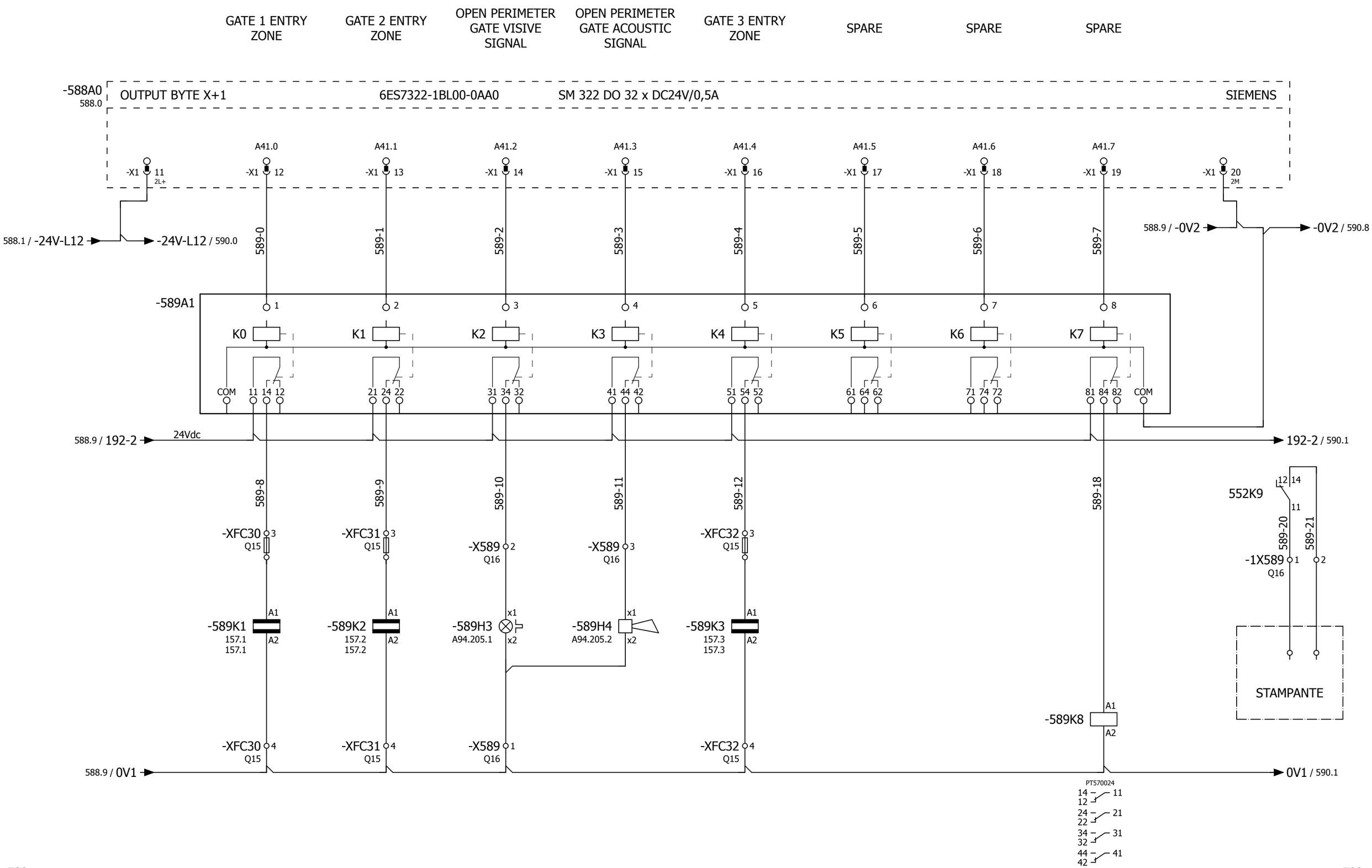
588-8 -XP50 5 Q16 — x1 -562S2 562.3 WH P50 x2 — -XP50 2 Q16
588-9 -XP50 6 Q16 — x1 -562S3 562.4 BU P50 x2
588-10 -XP51 5 Q16 — x1 -562S4 562.5 WH P51 x2 — -XP51 2 Q16
588-11 -XP51 6 Q16 — x1 -562S5 562.6 BU P51 x2
588-12 -XP52 5 Q16 — x1 -562S6 562.7 WH P52 x2 — -XP52 2 Q16
588-13 -XP52 6 Q16 — x1 -562S7 562.7 BU P52 x2
588-14 -XP4.1 14 Q — -XP04.1 14 P04 — x1 -559S4 559.5 GN P04 x2 — -XP04.1 13 P04 — -XP4.1 13 Q

587.9 / 0V1 → 0V1 / 589.1

⇦587
589⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 588
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



588

590

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	589
Revision			Replacement of / Replaced by			Group: / Of	414

GATE 1 CENTRAL ZONE | SPARE | SPARE | SPARE | SPARE | SPARE | SPARE | SPARE

-588A0
588.0
OUTPUT BYTE X+2 | 6ES7322-1BL00-0AA0 | SM 322 DO 32 x DC24V/0,5A | SIEMENS

A42.0 A42.1 A42.2 A42.3 A42.4 A42.5 A42.6 A42.7

-X1 21 3L+ | -X1 22 | -X1 23 | -X1 24 | -X1 25 | -X1 26 | -X1 27 | -X1 28 | -X1 29 | -X1 30 3M

589.1 / -24V-L12 → -24V-L12 / 591.0

590-0 590-1 590-2 590-3 590-4 590-5 590-6 590-7

589.9 / -0V2 → -0V2 / 591.8

-590A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

589.9 / 192-2 → 24Vdc → 192-2 / 591.1

590-8

-XFC40 3
Q15

-590K1
162.1
162.1
A1
A2

-XFC40 4
Q15

589.9 / 0V1 → 0V1 / 591.1

589

591

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 590
Revision			Replacement of / Replaced by			Group:	Of 414

GATE 1 ENTRY ZONE OPENING ENABLING	GATE 1 ENTRY ZONE RESET	GATE 2 ENTRY ZONE OPENING ENABLING	SPARE	SPARE	SPARE	SPARE	SPARE

-588A0
588.0
OUTPUT BYTE X+3 — 6ES7322-1BL00-0AA0 — SM 322 DO 32 x DC24V/0,5A — SIEMENS

A43.0 A43.1 A43.2 A43.3 A43.4 A43.5 A43.6 A43.7

-X1 31 (4L+) -X1 32 -X1 33 -X1 34 -X1 35 -X1 36 -X1 37 -X1 38 -X1 39 -X1 40 (4M)

590.1 / -24V-L12 → -24V-L12 / 592.0

590.9 / -0V2 → -0V2 / 592.8

591-0 591-1 591-2 591-3 591-4 591-5 591-6 591-7

-591A1

1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

590.9 / 192-2 → 24Vdc

591-8 591-9 591-10

-XFC50 3 Q15 -XFC51 3 Q15 -XFC52 3 Q15

-591K1 A1 167.1 A2 167.1
-591K2 A1 167.2 A2 167.2
-591K3 A1 167.3 A2 167.3

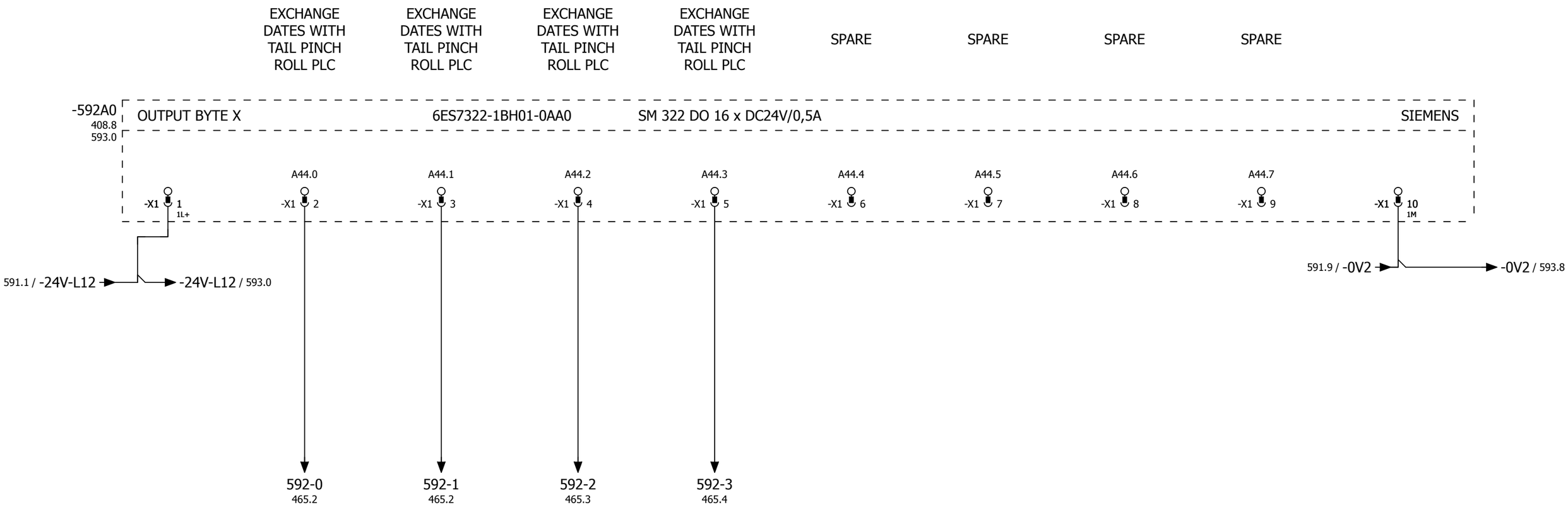
-XFC50 4 Q15 -XFC51 4 Q15 -XFC52 4 Q15

590.9 / 0V1 →

⇦590

592⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Machine edge digital output	=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97			Installation: Linea taglio trasversale	Page 591
Revision			Replacement of	Replaced by			Group: Of 414



⇦591

593⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 592
Revision		Replacement of	Replaced by			Group:	Of 414

SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

-592A0
592.0
OUTPUT BYTE X+1 6ES7322-1BH01-0AA0 SM 322 DO 16 x DC24V/0,5A SIEMENS

	A45.0	A45.1	A45.2	A45.3	A45.4	A45.5	A45.6	A45.7	
-X1 11 2L+	-X1 12	-X1 13	-X1 14	-X1 15	-X1 16	-X1 17	-X1 18	-X1 19	-X1 20 2M

592.1 / -24V-L12

592.9 / -0V2

592

650

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 593
Revision		Replacement of	Replaced by			Group:	Of 414

409.9 / PROFIBUS 2

PROFIBUS 2 / 700.2

-652A1 652.2

-659A1 659.0 | -660A0 660.0 | -661A0 661.0 | -662A0 662.0 | -663A0 663.0 | -664A0 664.0 | -665A0 665.0 | -670A0 670.0 | -675A0 675.0 | -679A1 679.0 | -680A0 680.0 | -681A0 681.0 | -682A0 682.0 | -683A0 683.0 | -684A0 684.0 | -685A0 685.0 | -686A0 686.0 | -689A0 689.0

SIEMENS

X1
PROFIBUS-DP

ET 200S

DC24V
1L+ 1M

2L+ 2M

IM 151-1
STANDARD

SF
BF
ON

DP
ADDRESS
OFF ON

64
32
16
8
4
2
1

6ES7 151-
1AA05-0AB0

6ES7151-1AA05-0AB0

PM-E
DC 24V

SF
PWR

6ES7138-
4CA00-0AA0

AUX1

8 DI
DC 24 V

1 2 3 4 5 6 7 8

6ES7131-
4BF00-0AA0

8 DO
DC24V
0,5A

6ES7132-
4BF00-0AA0

6ES7193-4CD20-0AA0 | 6ES7138-4CA01-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7131-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7131-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7131-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7131-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7131-4BF00-0AA0 | 6ES7193-4CD20-0AA0 | 6ES7138-4CA01-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7132-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7132-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7132-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7132-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7132-4BF00-0AA0 | 6ES7193-4CB20-0AA0 | 6ES7132-4BF00-0AA0

593

652

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box plc layout
Drawing	13B01		Comm: A97		Installation: Linea taglio trasversale
Drawer	Tengattini Marco		Replacement of / Replaced by		Page 650 / Of 414
Revision					Group:

122.2 / 24V-L19 →

122.6 / 0V2 →

→ 24V-L19 / 659.0

→ 0V2 / 659.0

-652A1
650.1

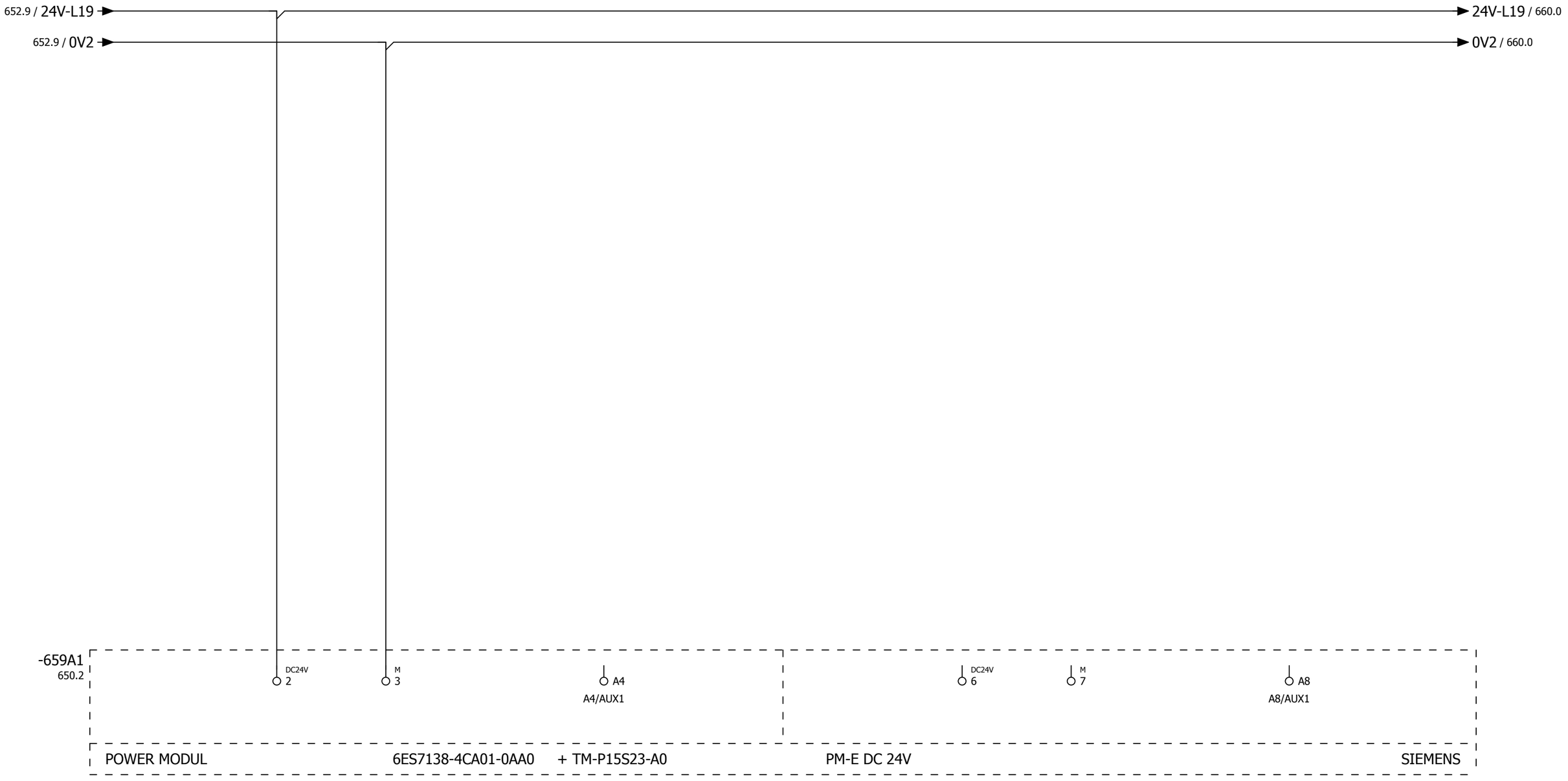
1L+ 1
2L+ 2
1M 3
2M 4

6ES7151-1AA05-0AB0 IM 151-1 STANDARD SIEMENS

⇦650

659⇨

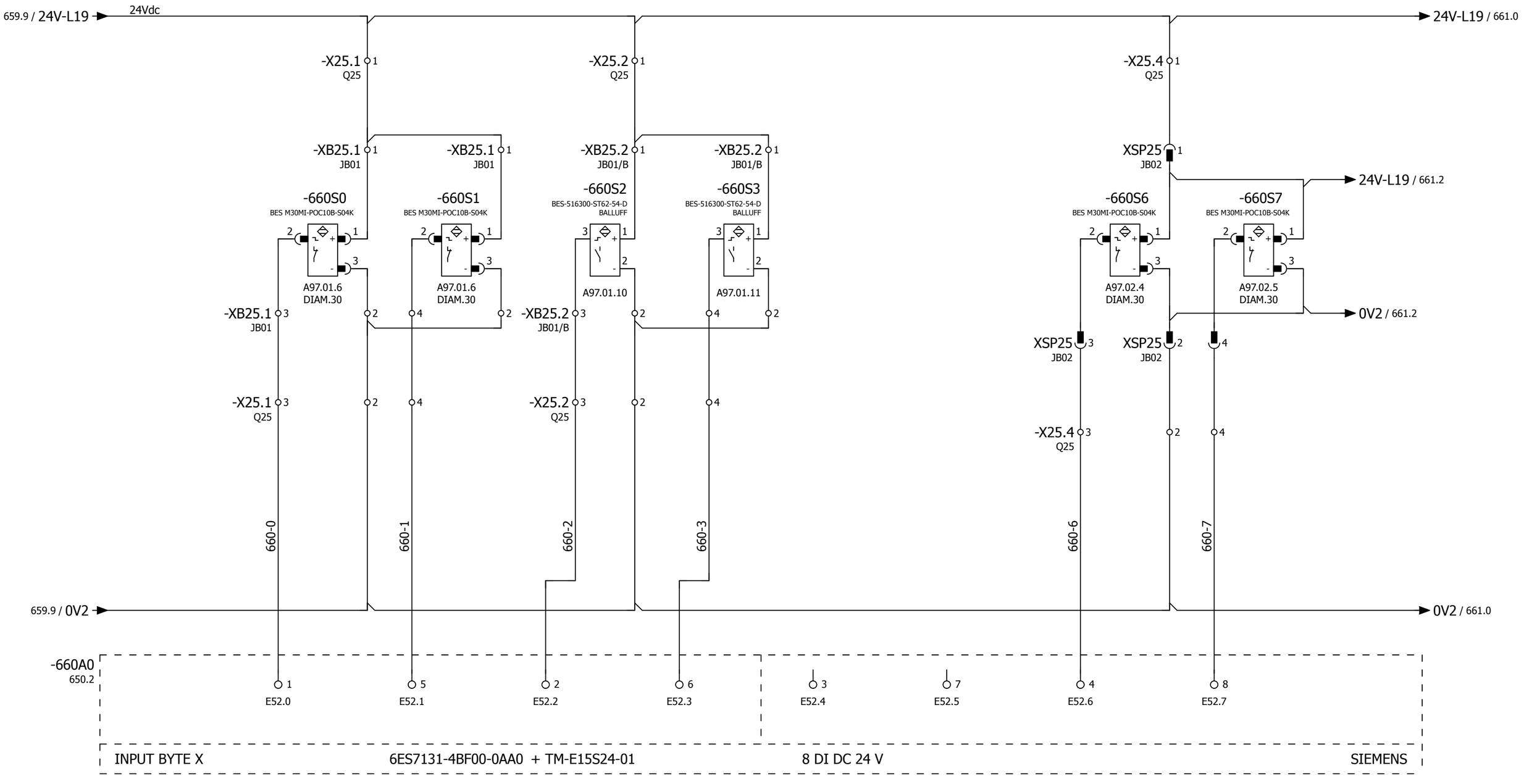
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 151 machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	652
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660

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 659
Revision		Replacement of	Replaced by			Group:	Of 414



⇦659

661⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	660
Revision		Replacement of	Replaced by			Group:	Of 414

660.9 / 24V-L19 — 24Vdc

660.8
24V-L19

-661S0
BES M18MI-PSC50B-S04K
A97.02.7
DIAM.18

-661S1
ZWS24/CD/QS

-661S4
BES M30MI-PSC10B-S04K
A97.200.4
DIAM.30

-661S7
A97.03.3
BOS 18KF-PA-1PE-S4-C

-X25.20 1 Q25
-XB25.20 1 JB01
-X25.5 1 Q25
-XB25.5 1 JB04

XSP25 5 JB02
XSP25 6 JB02
XSP25 7 JB02

-XB25.20 3 JB01
-XB25.5 3 JB04
0V2 / 677.3

-X25.4 5 Q25
-X25.4 6 Q25
-X25.4 7 Q25
-X25.20 3 Q25
-X25.5 3 Q25

0V2
660.8

661-0
661-1
661-2
661-4
661-7

660.9 / 0V2 — 0V2 / 662.0

-661A0
650.2

1	5	2	6	3	7	4	8
E53.0	E53.1	E53.2	E53.3	E53.4	E53.5	E53.6	E53.7

INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

E53.0	E53.1	E53.2	E53.3	E53.4	E53.5	E53.6	E53.7
COIL CAR LOW	COIL CAR MATERIAL PRESENCE	SPARE	SPARE	COIL CAR GATE OPEN	SPARE	SPARE	PAPER WINDER PAPER PRESENCE

⇦660
662⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge entry box		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	661
Revision			Replacement of / Replaced by			Group: / Of	414

661.9 / 24V-L19

24Vdc

24V-L19 / 663.0

-X25.7 Q25 1
-XB25.7 JB04/A 1
-662S0 BES M18MI-PSC50B-S04K
4 1 3
A97.04.8 DIAM.18
-XB25.7 JB04/A 3 2
-X25.7 Q25 3 2
662-0

-XB25.7 JB04/A 1
-662S1 BES M18MI-PSC50B-S04K
4 1 3
A97.04.9 DIAM.18
4 2
662-1

-X25.8 Q25 1
-XB25.8 JB06 1
-662S2 P A97.06.4 13 14
-XB25.8 JB06 2
-X25.8 Q25 2
662-2

-XB25.11 JB06 3
-X25.11 Q25 3
662-4

-X25.11 Q25 1
-XB25.11 JB06 1
-662S4 P A97.07.2 13 14
-XB25.11 JB06 4
-X25.11 Q25 4
662-4

-XB25.11 JB06 1
-662S5 F A97.06.9 13 14
-XB25.11 JB06 5
-X25.11 Q25 5
662-5

-XB25.11 JB06 1
-662S6 F A97.06.11 13 14
-XB25.11 JB06 6
-X25.11 Q25 6
662-6

-XB25.11 JB06 1
-662S7 BES M18MI-PSC50B-S04K
4 1 3
A97.06.8 DIAM.18
-XB25.11 JB06 7
-X25.11 Q25 7
662-7

-XB25.11 JB06 2
-X25.11 Q25 2

661.9 / 0V2

0V2 / 663.0

-662A0 650.3

	1	5	2	6	3	7	4	8
	E54.0	E54.1	E54.2	E54.3	E54.4	E54.5	E54.6	E54.7

INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

E54.0	E54.1	E54.2	E54.3	E54.4	E54.5	E54.6	E54.7
DECOILER SUPPORT HIGH	DECOILER SUPPORT LOW	DECOILER MINIMUM AIR BRAKE PRESSURE	SPARE	UNCOILER OIL MINIMUM PRESSURE EXPANSION MANDREL	DECOILER TRANSLATION PROPORTIONAL MINIMUM OIL FLOW	UNCOILER OIL PASSAGE CONTROL	DECOILER LINE IN THE MIDDLE

⇦661

663⇨

662.9 / 24V-L19 — 24Vdc

24V-L19 / 665.0

-X25.13 Q25 — 1

-XB25.13 JB10/A — 1

-663S2
BES M18MI-PSC50B-S04K
4 1 3
A97.08.2
DIAM.18

-663S3
BES M18MI-PSC50B-S04K
4 1 3
A97.08.4
DIAM.18

24V-L19 / 664.1

-663S7 P
A97.08.5
13 14

-XB25.13 JB10/A — 3 2 4 2 → 0V2 / 664.2

-XB25.13 JB10/A — 5 6

-X25.13 Q25 — 3 2 4 5 6

663-2 663-3 663-6 663-7

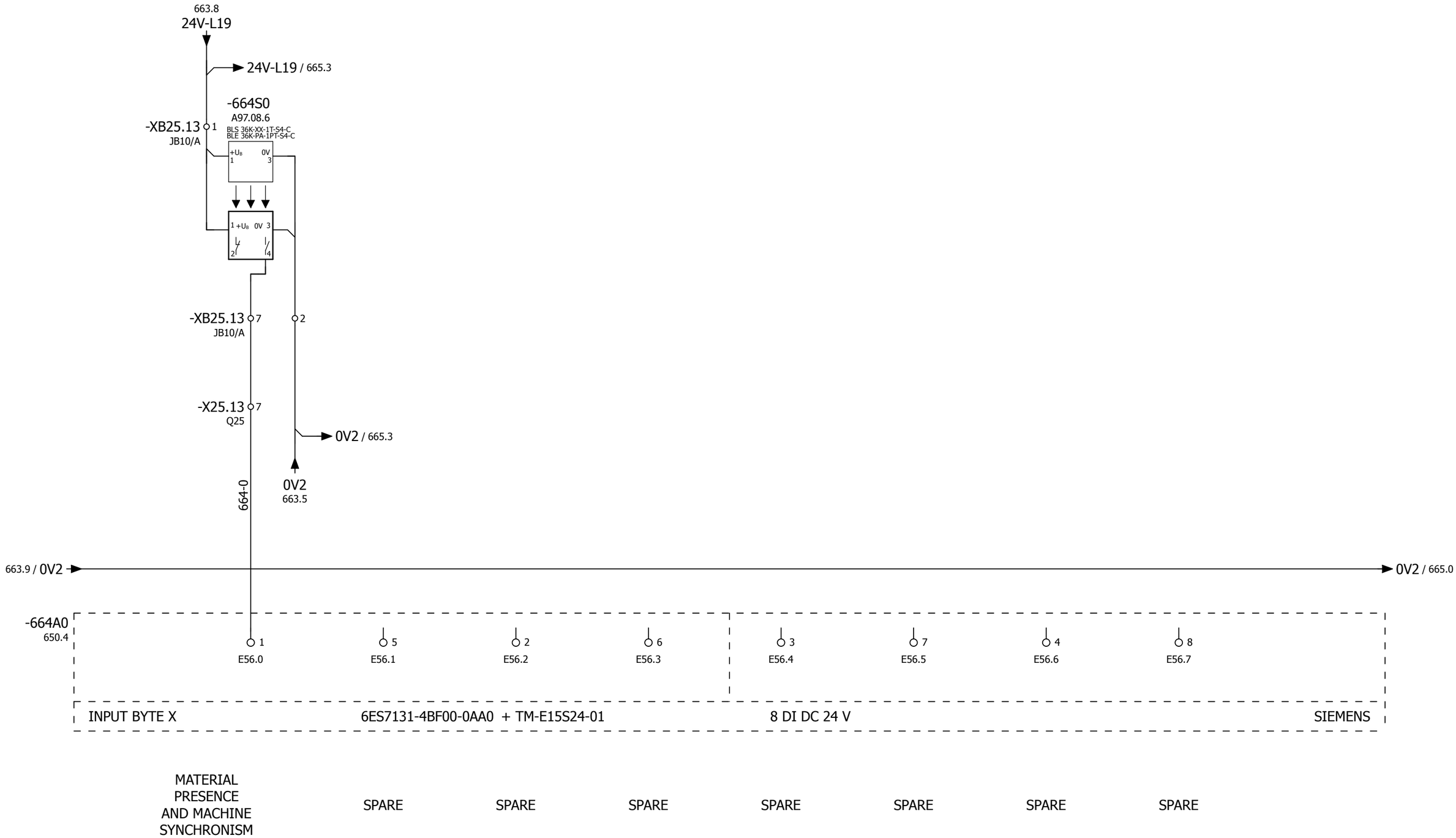
662.9 / 0V2 — 0V2 / 664.0

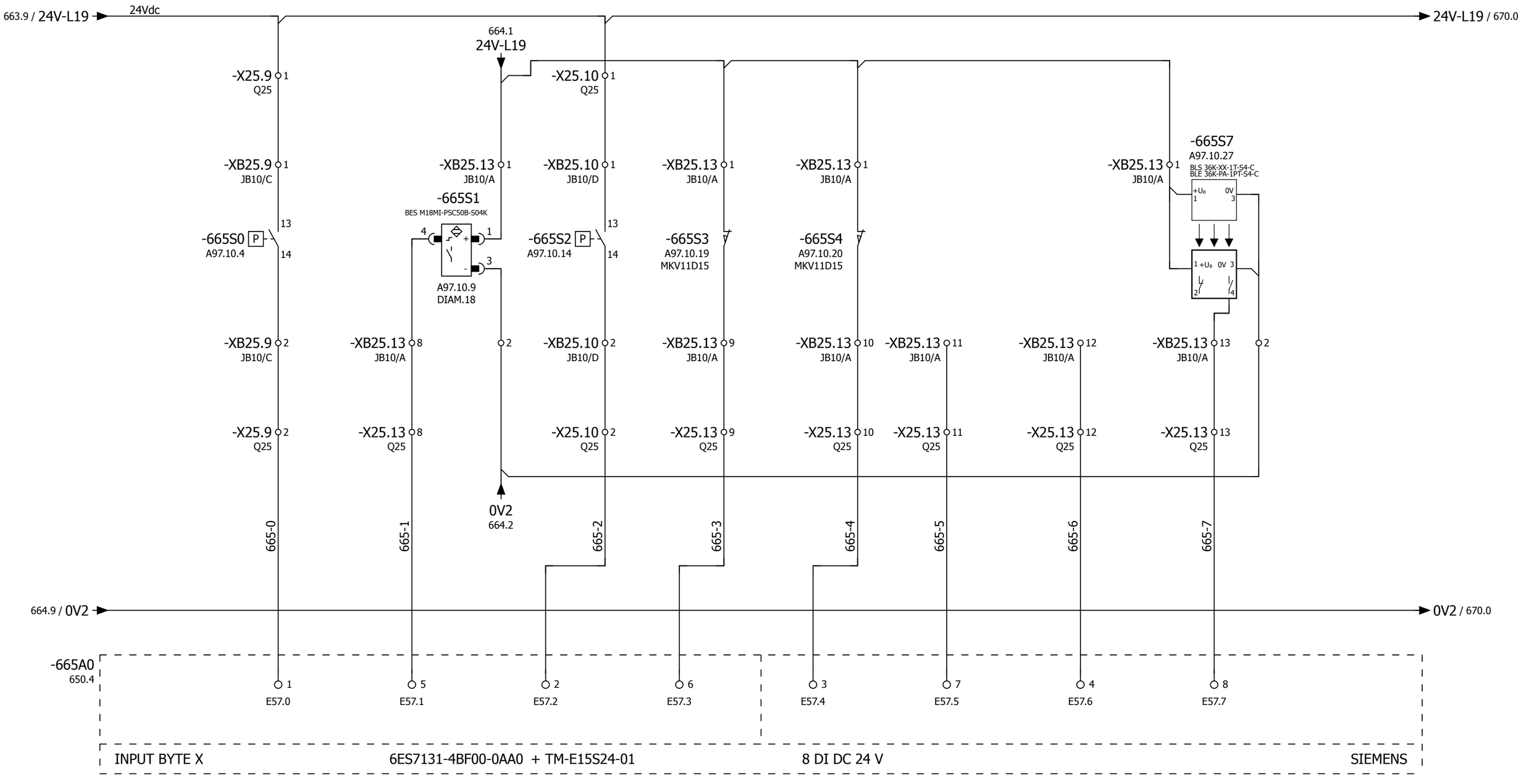
-663A0
650.3

	1	5	2	6	3	7	4	8
	E55.0	E55.1	E55.2	E55.3	E55.4	E55.5	E55.6	E55.7
	SPARE	SPARE	PEELER TABLE POSITION RETRACT	PEELER TABLE POSITION LOW	SPARE	SPARE	SPARE	PEELER TABLE CONTACTION ARM PRESSURE

INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	663
Revision		Replacement of	Replaced by			Group:	Of 414


663.8
24V-L19
24V-L19 / 665.3
-664S0
A97.08.6
-XB25.13 1
JB10/A
BLS 36K-XX-1T-S4-C
BLE 36K-PA-1PT-S4-C
+U8
0V
1
3
1 +U8 0V 3
2
4
-XB25.13 7
JB10/A
2
-X25.13 7
Q25
0V2 / 665.3
664-0
0V2
663.5
663.9 / 0V2
0V2 / 665.0
-664A0
650.4
1
E56.0
5
E56.1
2
E56.2
6
E56.3
3
E56.4
7
E56.5
4
E56.6
8
E56.7
INPUT BYTE X
6ES7131-4BF00-0AA0 + TM-E15S24-01
8 DI DC 24 V
SIEMENS
MATERIAL PRESENCE AND MACHINE SYNCHRONISM
SPARE
SPARE
SPARE
SPARE
SPARE
SPARE
SPARE



⇦664

670⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	665
Revision		Replacement of	Replaced by			Group:	Of 414

665.9 / 24V-L19 — 24Vdc — 24V-L19 / 675.0

-X25.17 1
Q25

-XB25.17 1 JB12 — -670S1 BES M18MI-PSC50B-S04K — A97.12.2 DIAM.18 — -XB25.17 3 JB12 — -X25.17 3 Q25 — 670-1

-XB25.17 1 JB12 — -670S2 BES M18MI-PSC50B-S04K — A97.12.3 DIAM.18 — -XB25.17 4 — 2 — -X25.17 4 — 2 — 670-2

-XB25.17 5 JB12 — -X25.17 5 Q25 — 670-3

-XB25.17 6 JB12 — -X25.17 6 Q25 — 670-4

-XB25.17 1 JB12 — -670S5 A97.12.7 MKV11D15 — -XB25.17 7 JB12 — -X25.17 7 Q25 — 670-5

-XB25.17 1 JB12 — -670S6 A97.12.8 MKV11D15 — -XB25.17 8 JB12 — -X25.17 8 Q25 — 670-6

665.9 / 0V2 — 0V2 / 675.0

-670A0
650.4

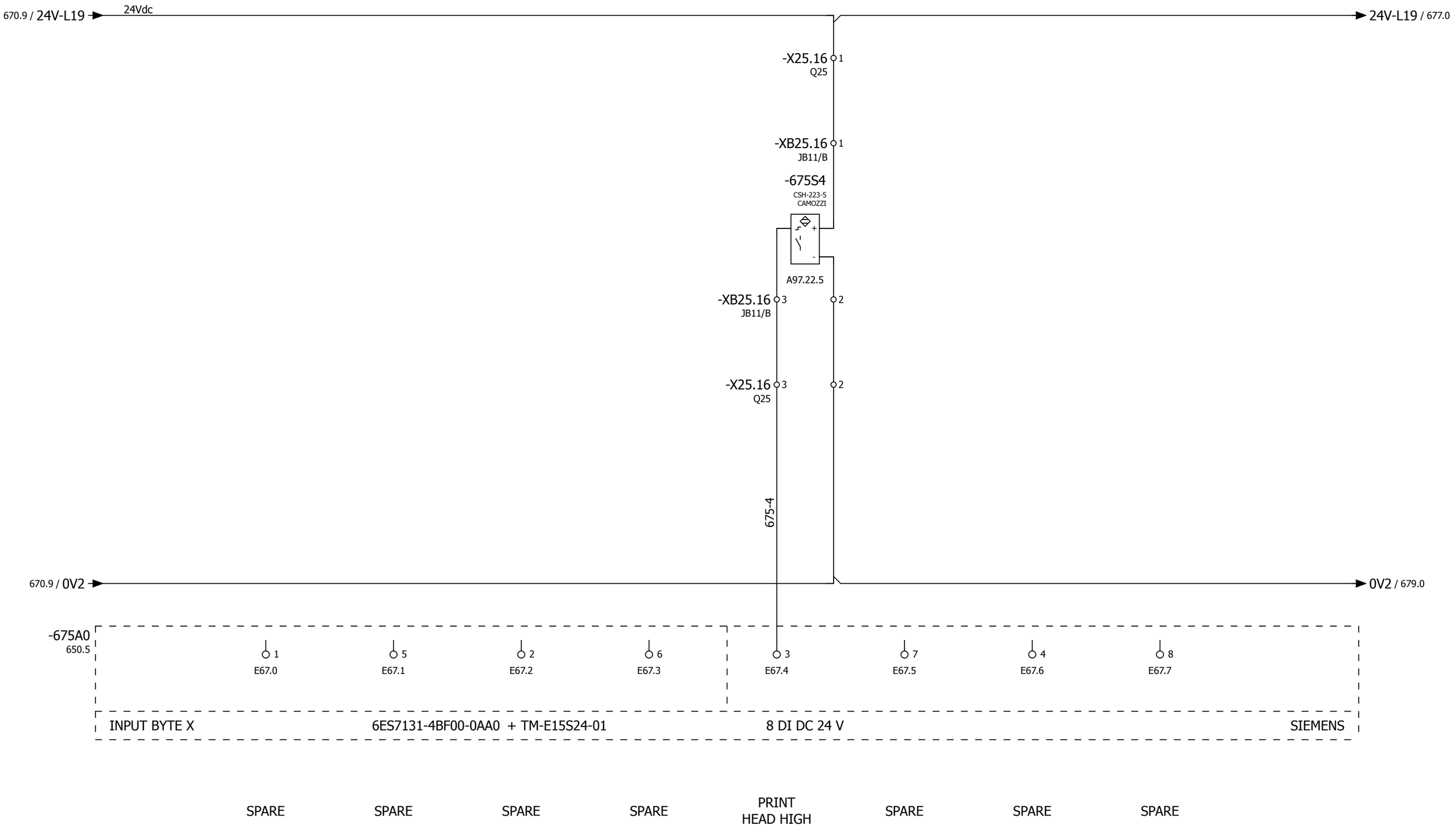
1	5	2	6	3	7	4	8
E62.0	E62.1	E62.2	E62.3	E62.4	E62.5	E62.6	E62.7
SPARE	CROPPER SHEAR BLADE MAX HIGH	CROPPER SHEAR BLADE MAX LOW	SPARE	SPARE	CROPPER SHEAR BLADES CLEARANCE MAX OPEN	CROPPER SHEAR BLADES CLEARANCE MAX CLOSE	SPARE

INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

⇦665

675⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	670
Revision		Replacement of	Replaced by			Group:	Of 414

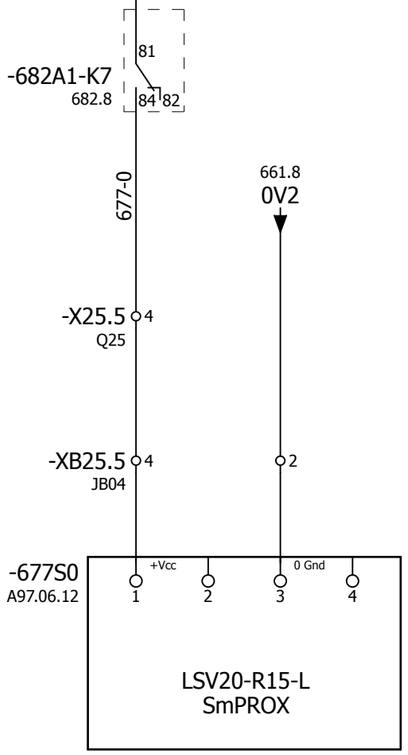


⇦670

677⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 675
Revision		Replacement of	Replaced by			Group:	Of 414

675.9 / 24V-L19 → 24Vdc



24V-L19 / 679.0

COIL POSITION
IN THE MIDDLE
DECOILER

⇦675

679⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: coil in the middle decoiler position indicator		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 677
Revision			Replacement of / Replaced by			Group:	Of 414

677.9 / 24V-L19 → 24V-L19 / 695.0

675.9 / 0V2 → 0V2 / 680.8

-679A1
650.5
850

DC24V	M		DC24V	M	
2	3	A4	6	7	A8
		A4/AUX1			A8/AUX1

POWER MODUL 6ES7138-4CA01-0AA0 + TM-P15S23-A0 PM-E DC 24V SIEMENS

⇦677

680⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul machine edge entry box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 679
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

COILS CARRIAGE RAIL OPEN | COILS CARRIAGE RAIL CLOSE | COIL CAR UP | COIL CAR DOWN | CENTRE PRESSURE ROLL UP | CENTRE PRESSURE ROLL DOWN | REAR PRESSURE ROLL UP | REAR PRESSURE ROLL DOWN

-680A0
650.5
850

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A52.0 1 — 680-0 — K0 — 11 14 12
A52.1 5 — 680-1 — K1 — 21 24 22
A52.2 2 — 680-2 — K2 — 31 34 32
A52.3 6 — 680-3 — K3 — 41 44 42
A52.4 3 — 680-4 — K4 — 51 54 52
A52.5 7 — 680-5 — K5 — 61 64 62
A52.6 4 — 680-6 — K6 — 71 74 72
A52.7 8 — 680-7 — K7 — 81 84 82

-680A1 — 1 2 3 4 5 6 7 8 — COM

679.9 / -0V2 → -0V2 / 681.8

192.2 / 24V-Z1 → 24Vdc → 24V-Z1 / 681.1

192.4 / 192-2 → 192-2 / 695.0

680-8	680-9	680-10	680-11	680-12	680-13	680-14	680-15
-X25.2 8 Q25	-X25.2 9 Q25	-X25.4 11 Q25	-X25.4 12 Q25	-X25.6 3 Q25	-X25.6 4 Q25	-X25.6 5 Q25	-X25.6 6 Q25
-XB25.2 8 JB01/B	-XB25.2 9 JB01/B	XSP25 11 JB02	XSP25 12 JB02	-XB25.6 3 JB04	-XB25.6 4 JB04	-XB25.6 5 JB04	-XB25.6 6 JB04
-680Y0 A97.01.9 A1 A2 B1 B2		-680Y2 A97.02.6 A1 A2 B1 B2		-680Y4 A97.04.3 A1 A2 B1 B2		-680Y6 A97.04.1 A1 A2 B1 B2	
-XB25.2 7 JB01/B		XSP25 10 JB02		-XB25.6 1 JB04			
-X25.2 7 Q25		-X25.4 10 Q25		-X25.6 1 Q25			

0V1 / 681.1

120.6 / 0V1 → 0V1 / 681.1

⇦679

681⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 680
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

FRONT PRESSURE ROLL UP

FRONT PRESSURE ROLL DOWN

DECOILER SUPPORT UP

DECOILER SUPPORT DOWN

REAR ROLL ROTATION FORWARD

REAR ROLL ROTATION BACKWARD

FRONT AND CENTRAL PRESSURE ROLL IN THE MIDDLE

UNCOILER PARKING BRAKE

-681A0
650.6
850

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A53.0 1 — 681-0
A53.1 5 — 681-1
A53.2 2 — 681-2
A53.3 6 — 681-3
A53.4 3 — 681-4
A53.5 7 — 681-5
A53.6 4 — 681-6
A53.7 8 — 681-7

680.9 / -0V2 → -0V2 / 682.8

-681A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

680.9 / 24V-Z1 → 24Vdc → 24V-Z1 / 682.1

195.1 / 24V-Z11 → 24V-Z11 / 684.1

	681-8	681-9	681-10	681-11	681-12	681-13	681-14	681-15
-X25.6 Q25	7	8	9	10	11	12	13	-X25.8 Q25 4
-XB25.6 JB04	7	8	9	10	11	12	13	-XB25.8 JB06 4
-681Y0 A97.04.5	A1 A2	B1 B2						
-681Y2 A97.04.7			A1 A2	B1 B2				
-681Y4 A97.04.2					A1 A2	B1 B2		
-681Y6 A97.04.4							x1 x2	
-681Y7 A97.06.3								x1 x2

-XB25.6 JB04 2 ← 680.8 / 0V1

-XB25.8 JB06 3

-X25.6 Q25 2 ← 680.9 / 0V1 → 0V1 / 682.1

-X25.8 Q25 3 ← 120A.7 / 0V1 → 0V1 / 684.1

⇦680

682⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	681
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

SPARE | DECOILER EXPANSION | DECOILER COLLAPSE | SPARE | SPARE | SPARE | SPARE | COIL POSITION IN THE MIDDLE DECOILER

-682A0
650.6
850

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A54.0 1 — 682-0
A54.1 5 — 682-1
A54.2 2 — 682-2
A54.3 6 — 682-3
A54.4 3 — 682-4
A54.5 7 — 682-5
A54.6 4 — 682-6
A54.7 8 — 682-7

681.9 / -0V2 → -0V2 / 683.8

-682A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

681.9 / 24V-Z1 → 24Vdc → 24V-Z1 / 683.1

84 – 81 677.2
82

682-9 → -X25.12 2 Q25
682-10 → -X25.12 3 Q25

-XB25.12 2 JB06
-XB25.12 3 JB06

-682Y1 A97.07.1 (A1, A2, B1, B2)

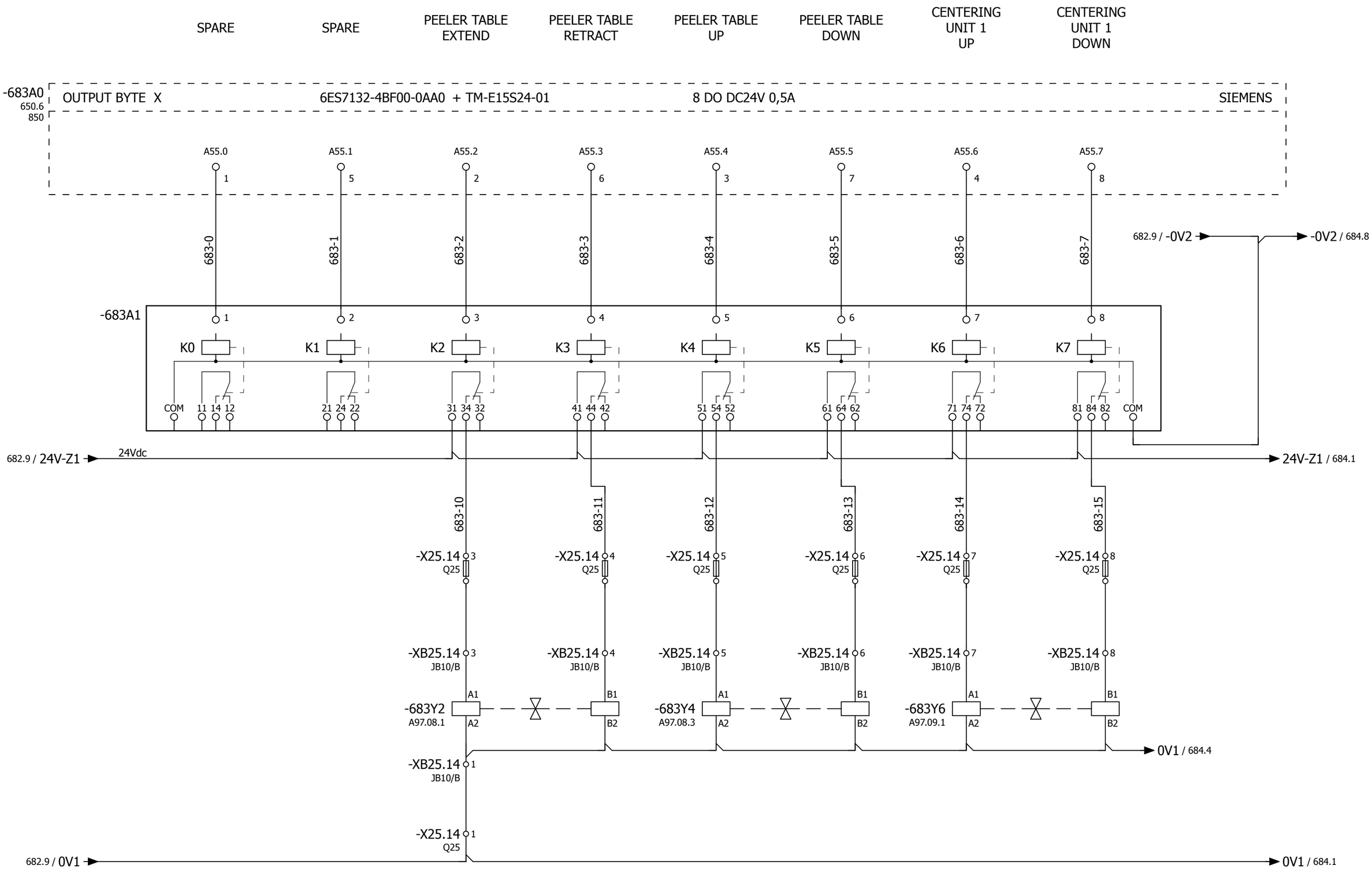
-XB25.12 1 JB06

-X25.12 1 Q25

681.9 / 0V1 → 0V1 / 683.1

681
683

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 682
Revision			Replacement of / Replaced by			Group:	Of 414



682

684

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 683
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

SPARE | SPARE | STRAIGHTENER ENTRY PINCH ROLL PARKING BRAKE | STRAIGHTENER ENTRY PINCH ROLL UP | STRAIGHTENER ENTRY PINCH ROLL DOWN | SPARE | STRAIGHTENER PARKING BRAKE | SPARE

-684A0 650.7 850 — OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A56.0 1 — A56.1 5 — A56.2 2 — A56.3 6 — A56.4 3 — A56.5 7 — A56.6 4 — A56.7 8

684-0 — 684-1 — 684-2 — 684-3 — 684-4 — 684-5 — 684-6 — 684-7

683.9 / -0V2 → -0V2 / 685.8

-684A1

1 — 2 — 3 — 4 — 5 — 6 — 7 — 8

K0 — K1 — K2 — K3 — K4 — K5 — K6 — K7

COM 11 14 12 — 21 24 22 — 31 34 32 — 41 44 42 — 51 54 52 — 61 64 62 — 71 74 72 — 81 84 82 COM

683.9 / 24V-Z1 → 24Vdc → 24V-Z1 / 685.1

681.9 / 24V-Z11 → 24V-Z11 / 695.0

684-10 — 684-11 — 684-12 — 684-14

-X25.9 4 Q25 — -X25.14 9 Q25 — -X25.14 10 Q25 — -X25.10 4 Q25

-XB25.9 4 JB10/C — -XB25.14 9 JB10/B — -XB25.14 10 JB10/B — -XB25.10 4 JB10/D

-684Y2 A97.10.3 x1 x2 — -684Y3 A97.10.7 A1 A2 — B1 B2 — -684Y6 A97.10.13 x1 x2

-XB25.14 JB10/B 2

-XB25.9 3 JB10/C — 683.8 / 0V1 → 0V1 / 685.1 — -XB25.10 3 JB10/D

-X25.9 3 Q25 — -X25.14 2 Q25 — -X25.10 3 Q25

683.9 / 0V1 → 0V1 / 686.1

681.9 / 0V1

⇦683 685⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	684
Revision		Replacement of	Replaced by			Group:	Of 414

STRAIGHTENER FOLD HEAD ROLL UP	STRAIGHTENER FOLD HEAD ROLL DOWN	STRAIGHTENER DEFLECTOR ROLL UP	STRAIGHTENER DEFLECTOR ROLL DOWN	SPARE	SPARE	SPARE	SPARE

-685A0
650.7
850
OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A57.0 1 — 685-0
A57.1 5 — 685-1
A57.2 2 — 685-2
A57.3 6 — 685-3
A57.4 3 — 685-4
A57.5 7 — 685-5
A57.6 4 — 685-6
A57.7 8 — 685-7

684.9 / -0V2 → -0V2 / 686.8

-685A1
1 K0 — COM 11 14 12
2 K1 — 21 24 22
3 K2 — 31 34 32
4 K3 — 41 44 42
5 K4 — 51 54 52
6 K5 — 61 64 62
7 K6 — 71 74 72
8 K7 — 81 84 82 COM

684.9 / 24V-Z1 → 24Vdc → 24V-Z1 / 686.1

685-8 → -X25.14 11 Q25 → -XB25.14 11 JB10/B
685-9 → -X25.14 12 Q25 → -XB25.14 12 JB10/B
685-10 → -X25.14 13 Q25 → -XB25.14 13 JB10/B
685-11 → -X25.14 14 Q25 → -XB25.14 14 JB10/B

-685Y0 A97.10.28 (A1 / A2)
-685Y2 A97.10.29 (A1 / A2)
B1 / B2

684.5 / 0V1

684
686

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Group:	Page 685
Revision							Of 414

CROPPER SHEAR BLADE UP	CROPPER SHEAR BLADE DOWN	BLADE ORIGINAL POSITION RECOVERY IN	BLADE ORIGINAL POSITION RECOVERY OUT	SPARE	SPARE	SPARE	SPARE

-686A0 650.7 850 — OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A58.0 1 | A58.1 5 | A58.2 2 | A58.3 6 | A58.4 3 | A58.5 7 | A58.6 4 | A58.7 8

686-0 | 686-1 | 686-2 | 686-3 | 686-4 | 686-5 | 686-6 | 686-7

685.9 / -0V2 → -0V2 / 689.8

-686A1: 1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

685.9 / 24V-Z1 → 24Vdc → 24V-Z1 / 689.1

686-8 | 686-9 | 686-10 | 686-11

-X25.18 3 Q25 | -X25.18 4 Q25 | -X25.18 5 Q25 | -X25.18 6 Q25

-XB25.18 3 JB12 | -XB25.18 4 JB12 | -XB25.18 5 JB12 | -XB25.18 6 JB12

-686Y0 A97.12.1 (A1 / A2) — B1 / B2

-686Y2 A97.12.4 (A1 / A2) — B1 / B2

-XB25.18 JB12 1 | -XB25.18 JB12 2

-X25.18 1 Q25 | -X25.18 2 Q25

684.9 / 0V1 → 0V1 / 689.1

685

689

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 686
Revision			Replacement of / Replaced by			Group:	Of 414

SPARE	PAPER WIDER IN	PAPER WIDER OUT	INK JET HEAD UP	INK JET HEAD DOWN	SPARE	SPARE	SPARE

-689A0
650.8
850

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A61.0 1 — 689-0
A61.1 5 — 689-1
A61.2 2 — 689-2
A61.3 6 — 689-3
A61.4 3 — 689-4
A61.5 7 — 689-5
A61.6 4 — 689-6
A61.7 8 — 689-7

686.9 / -0V2 → -0V2 / 695.0

-689A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

686.9 / 24V-Z1 → 24Vdc → 24V-Z1 / 695.0

689-9 → -X25.15 2 Q25 → -XB25.15 2 JB03/A → A1 -689Y1 A97.03.4 A2 → -XB25.15 1 JB03/A → -X25.15 1 Q25

689-10 → -X25.15 3 Q25 → -XB25.15 3 JB03/A → B1 -689Y1 A97.03.4 B2

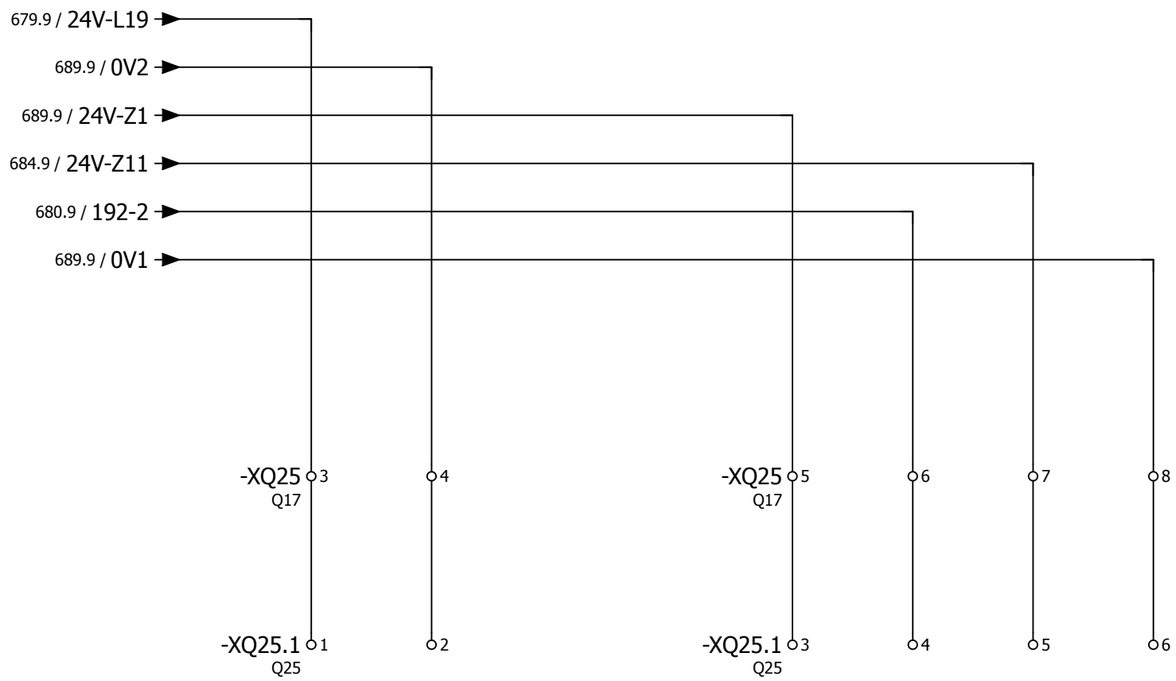
689-11 → -X25.16 6 Q25 → -XB25.16 6 JB11/B → A1 -689Y3 A97.22.4 A2 → -XB25.16 5 JB11/B → -X25.16 5 Q25

689-12 → -X25.16 7 Q25 → -XB25.16 7 JB11/B → B1 -689Y3 A97.22.4 B2

686.9 / 0V1 → 0V1 / 695.0

686
695

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Machine edge entry box digital output	=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97			Installation: Linea taglio trasversale	Page 689
Revision			Replacement of	Replaced by			Group: Of 414



MACHINE EDGE ENTRY BOX SUPPLY

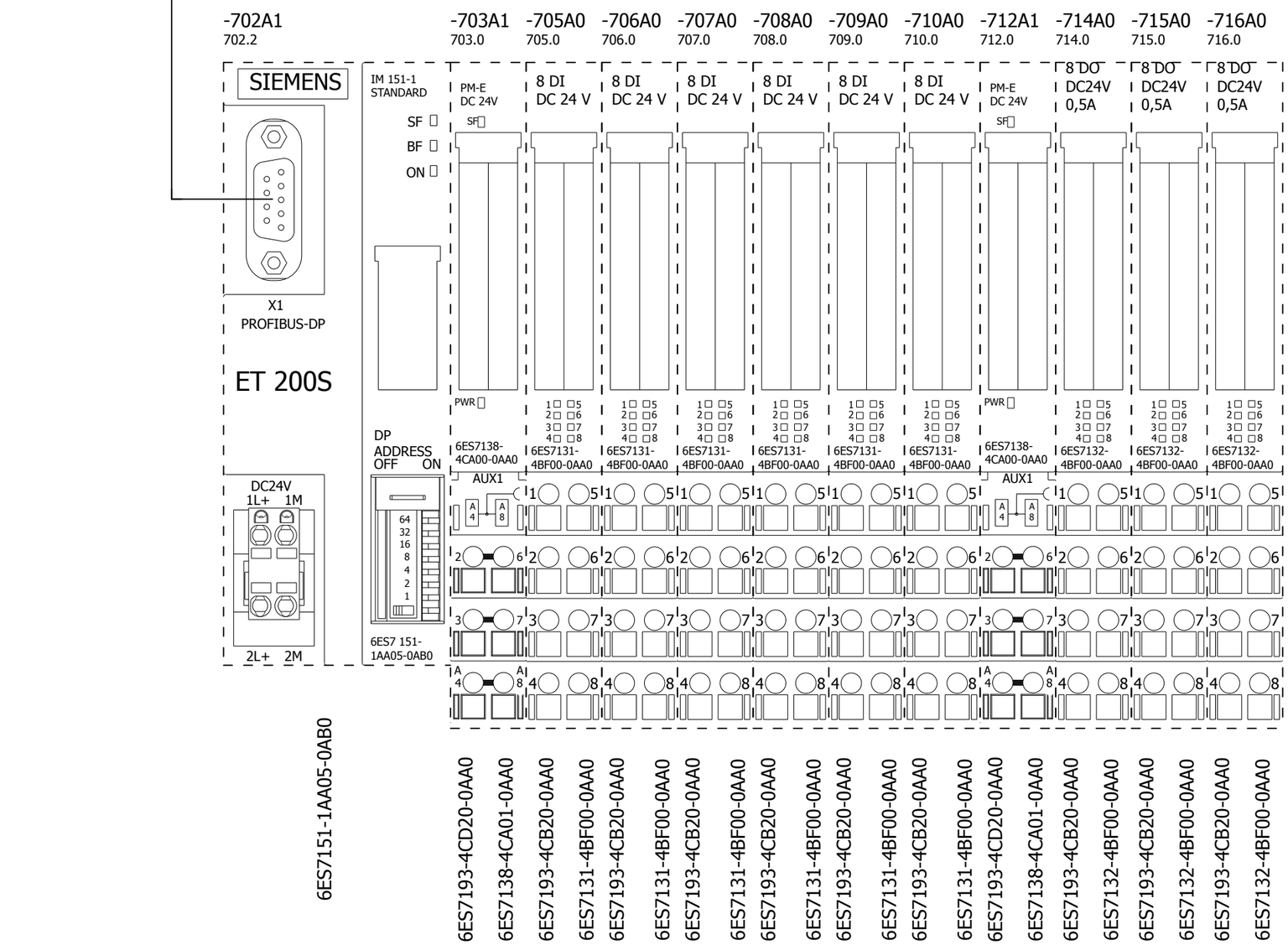
⇦689

700⇨

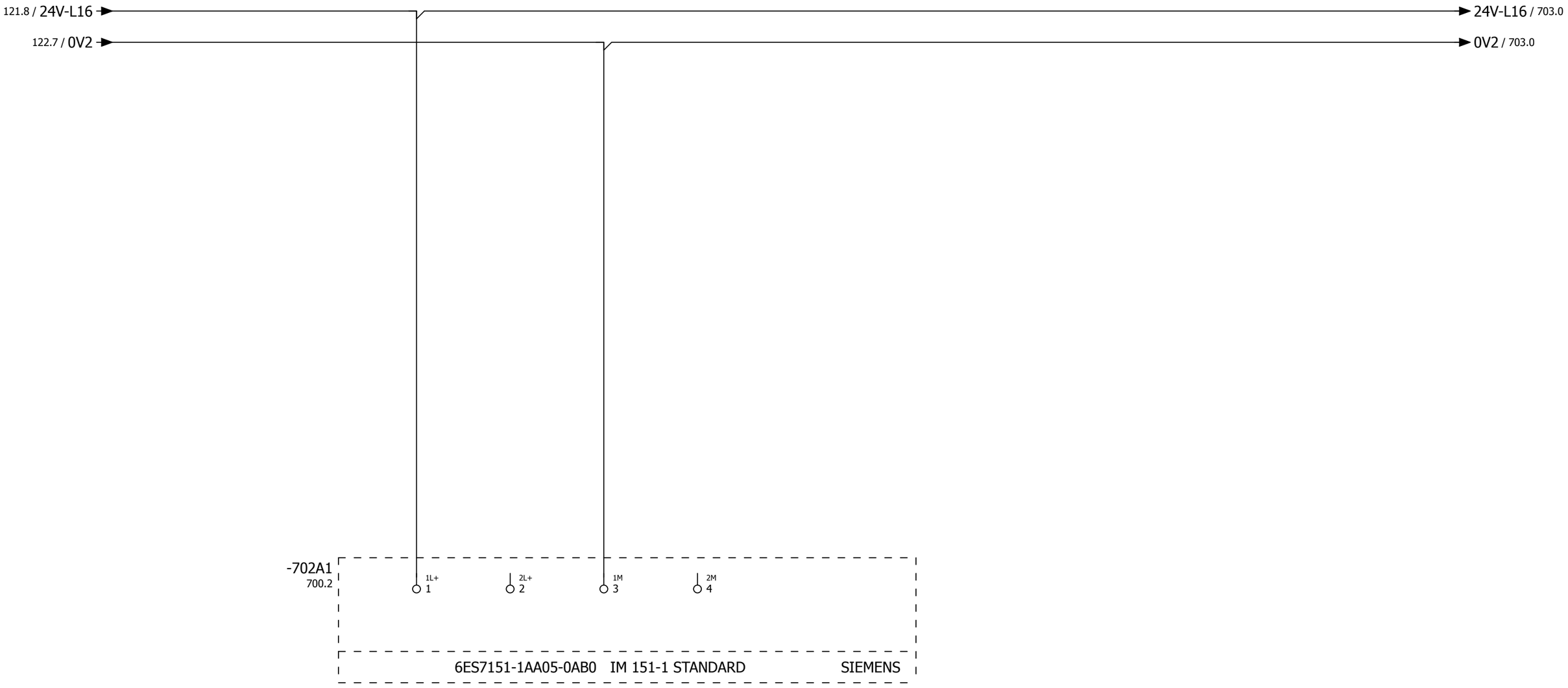
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Machine edge entry box supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 695
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

650.1 / PROFIBUS 2 → PROFIBUS 2 / 720.2



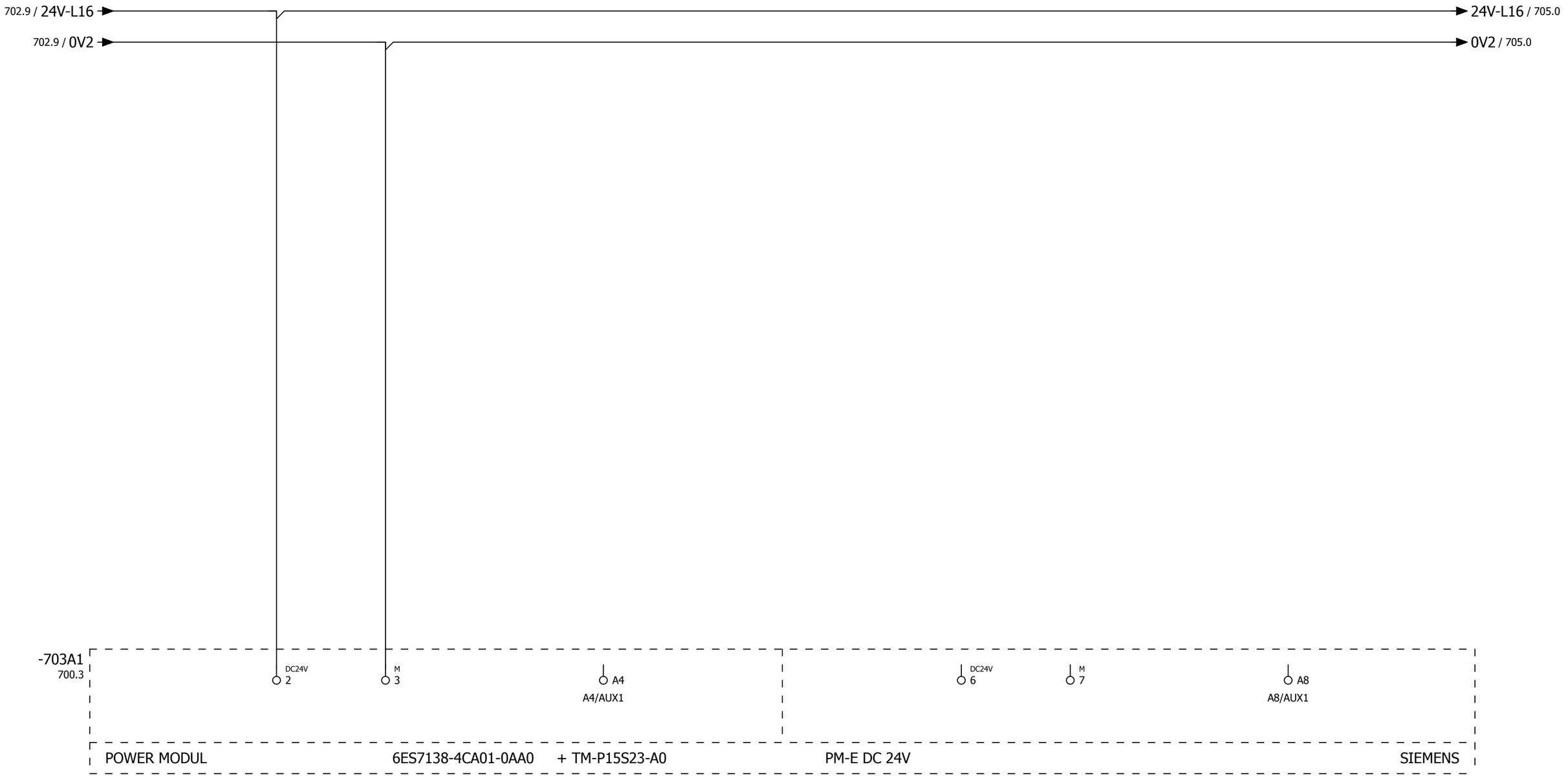
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	700
Revision			Replacement of / Replaced by			Group:	Of 414



⇦700

703⇨

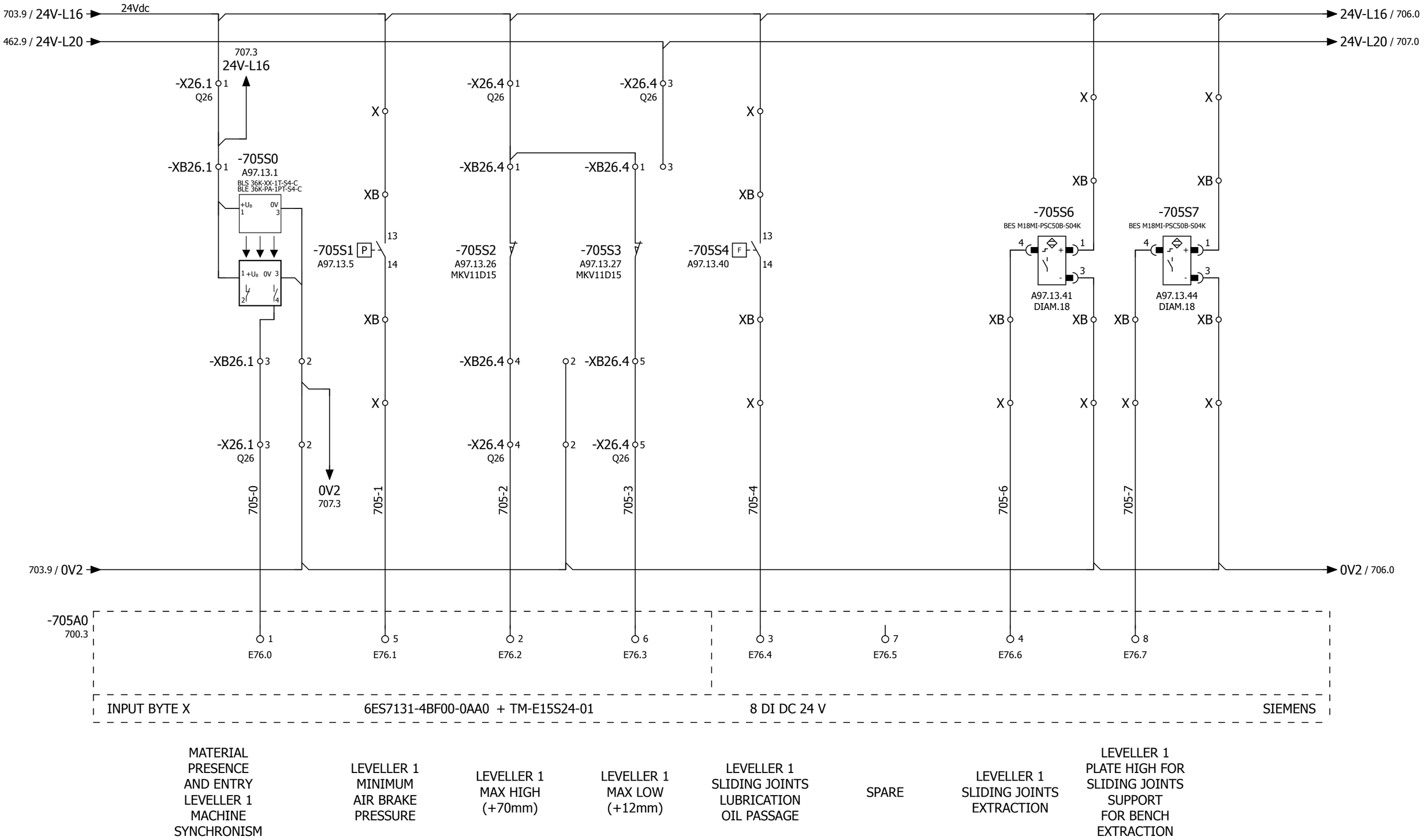
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 151 leveller 1 box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	702
Revision		Replacement of	Replaced by			Group:	Of 414



⇦702

705⇨

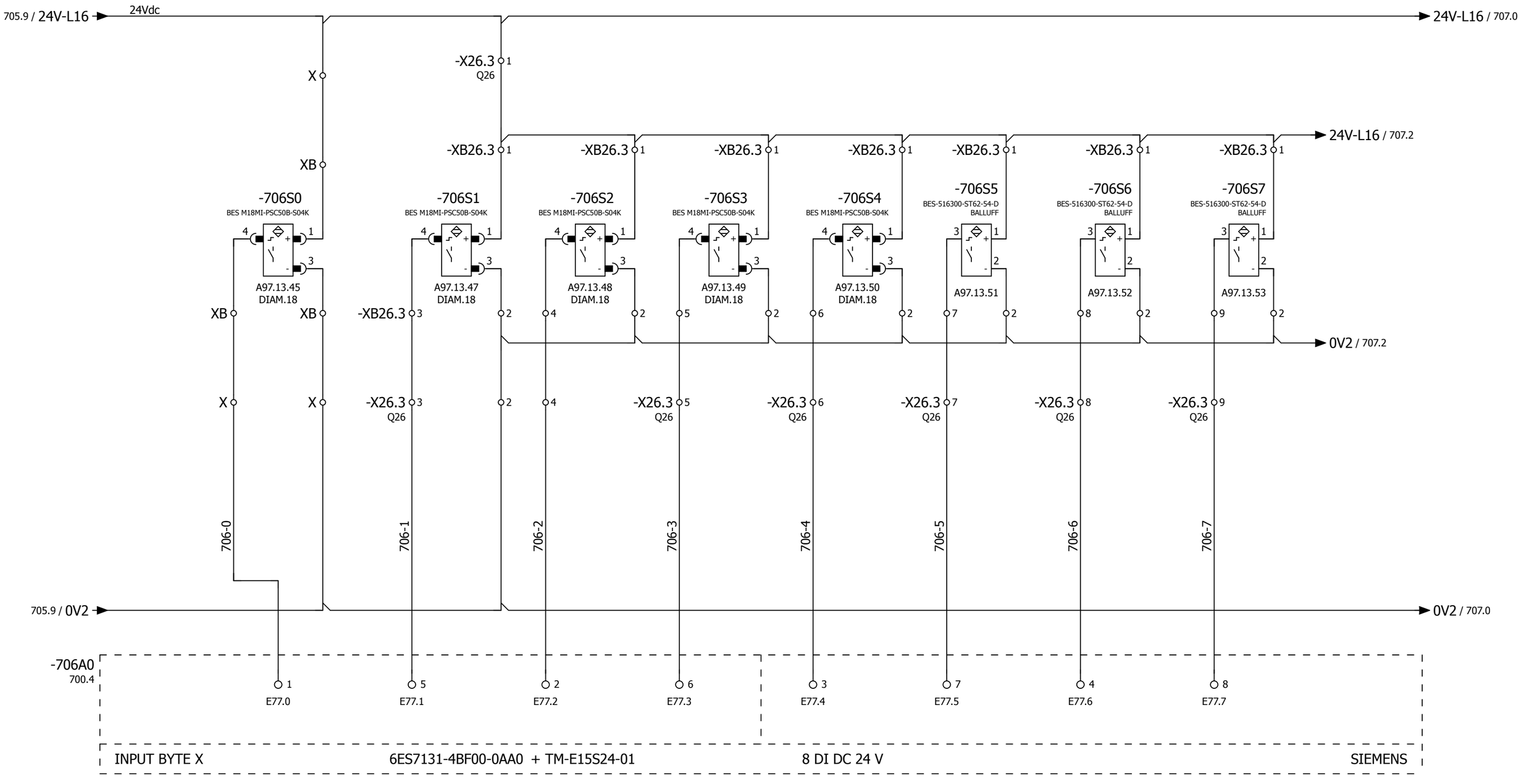
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul leveller 1 box		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	703
Revision			Replacement of / Replaced by			Group: / Of	414



⇦703

706⇨

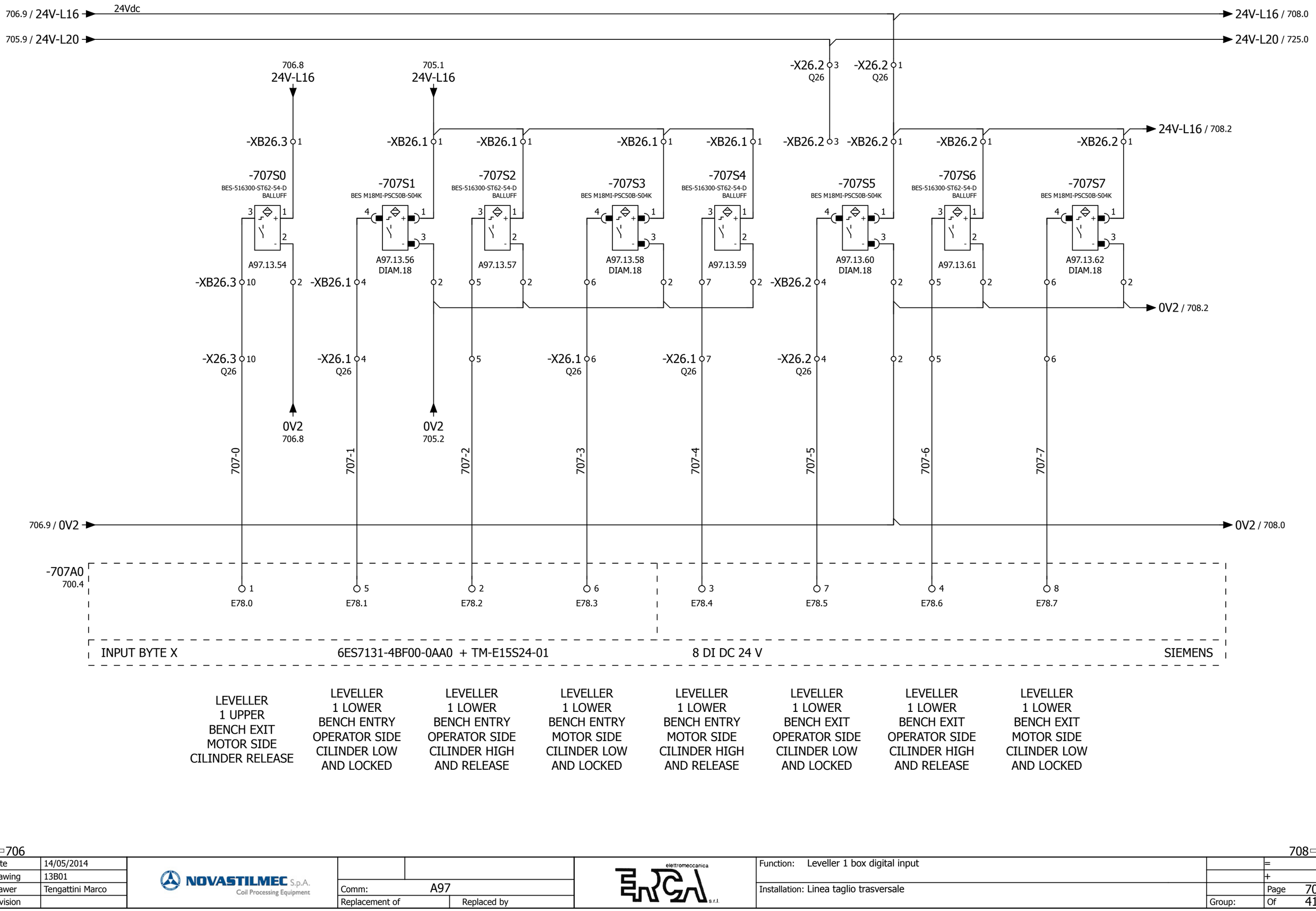
Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	705
Revision		Replacement of	Replaced by			Group:	Of 414



⇦705

707⇨

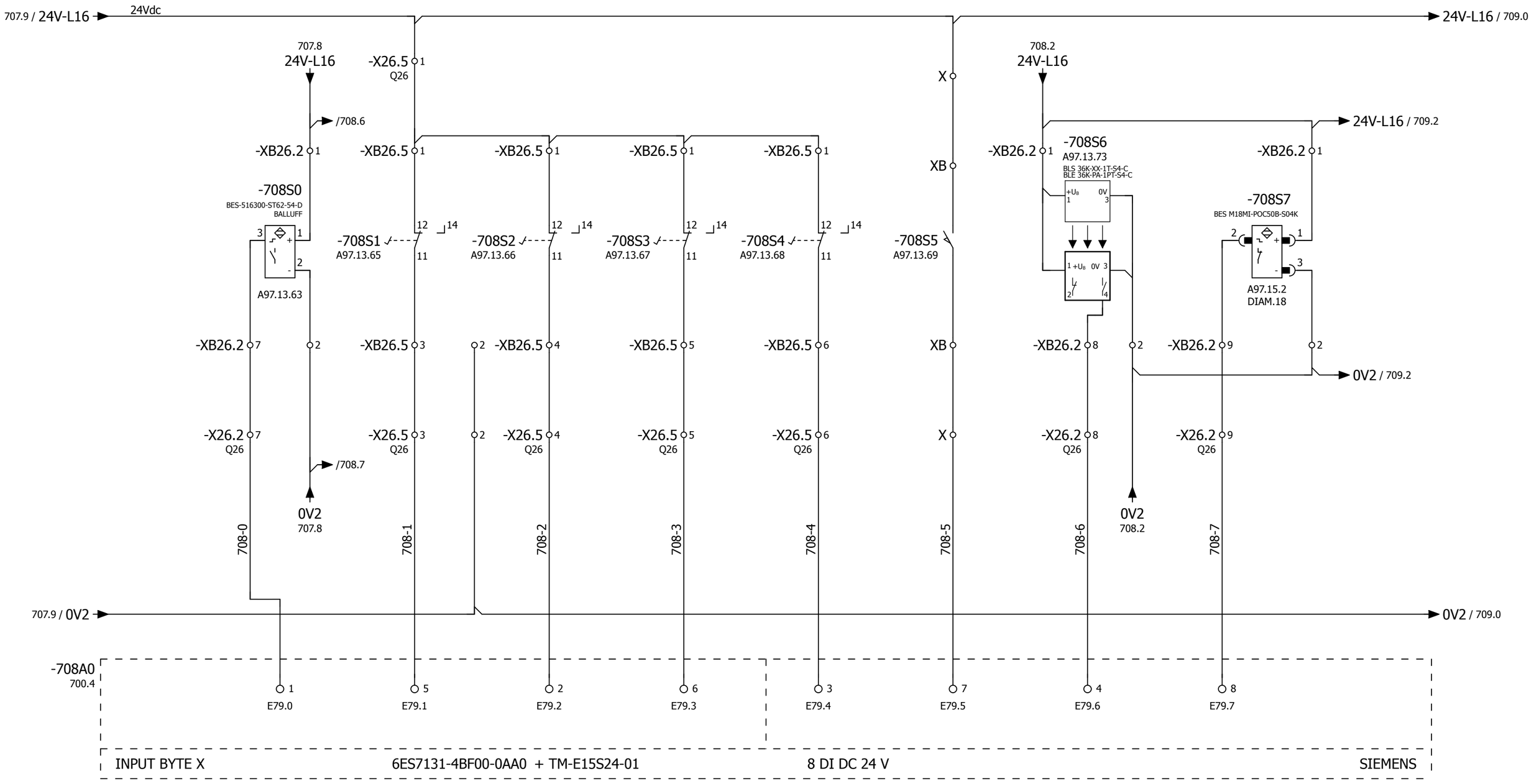
Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	706
Revision		Replacement of	Replaced by			Group:	Of 414



⇦706

708⇨

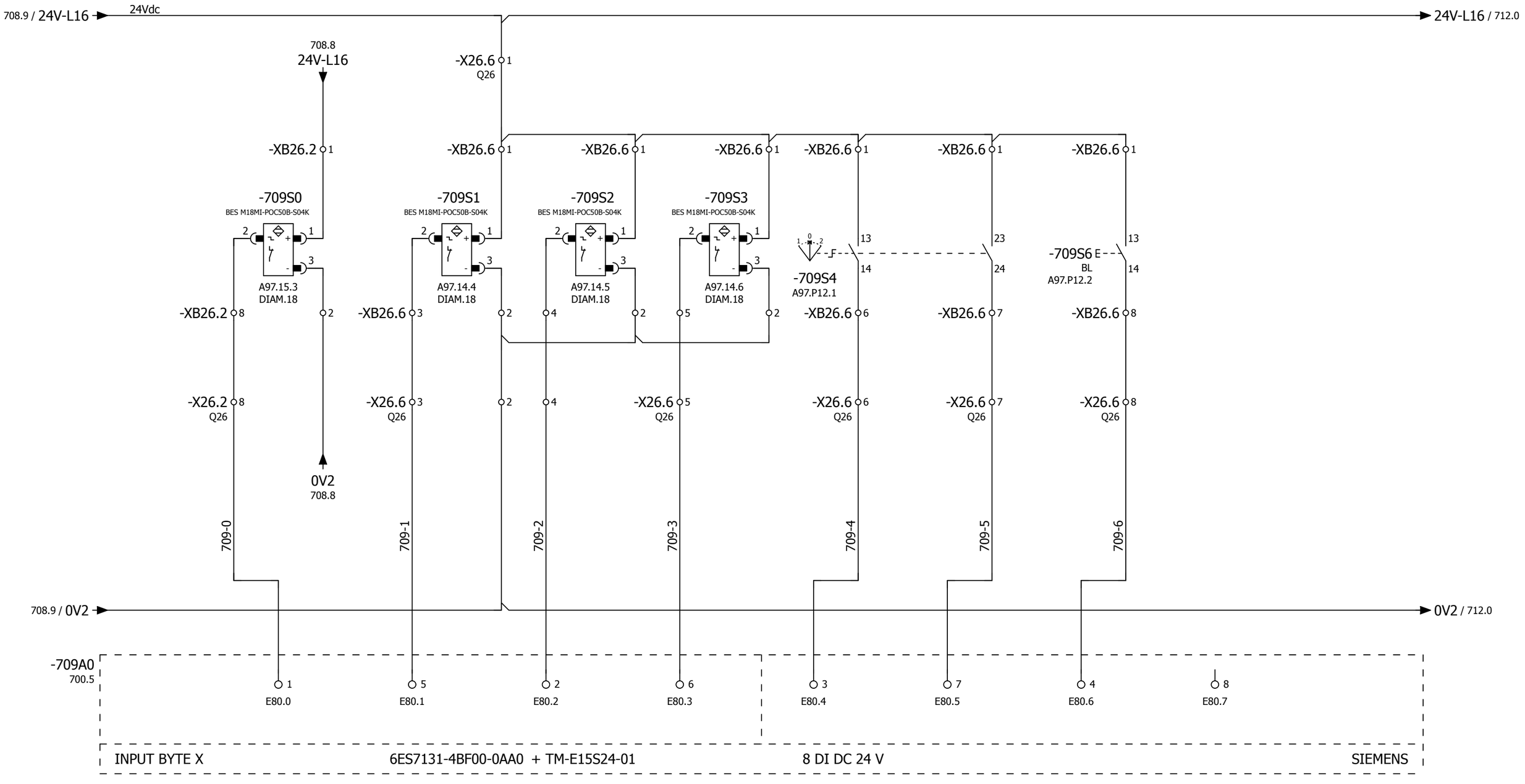
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	707
Revision		Replacement of	Replaced by			Group:	Of 414



⇦707

709⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	708
Revision		Replacement of	Replaced by			Group:	Of 414

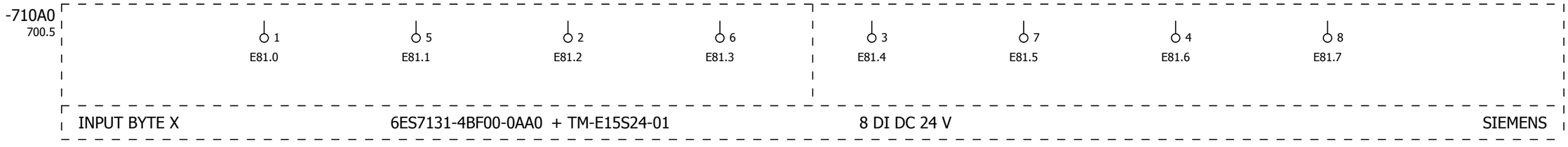


⇦708

710⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	709
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

⇦709

712⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	710
Revision			Replacement of / Replaced by			Group: / Of	414

709.9 / 24V-L16 → 24V-L16 / 718.0

709.9 / 0V2 → 0V2 / 714.8

-712A1
700.5

DC24V	M	A4	DC24V	M	A8
2	3		6	7	
		A4/AUX1			A8/AUX1

POWER MODUL 6ES7138-4CA01-0AA0 + TM-P15S23-A0 PM-E DC 24V SIEMENS

⇦710

714⇨

LEVELLER 1 BACK UP ROLL 1 UP
LEVELLER 1 BACK UP ROLL 1 DOWN
LEVELLER 1 BACK UP ROLL 2 UP
LEVELLER 1 BACK UP ROLL 2 DOWN
LEVELLER 1 BACK UP ROLL 3 UP
LEVELLER 1 BACK UP ROLL 3 DOWN
LEVELLER 1 BACK UP ROLL 4 UP
LEVELLER 1 BACK UP ROLL 4 DOWN

-714A0
700.6
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A76.0 1 — 714-0
A76.1 5 — 714-1
A76.2 2 — 714-2
A76.3 6 — 714-3
A76.4 3 — 714-4
A76.5 7 — 714-5
A76.6 4 — 714-6
A76.7 8 — 714-7

712.9 / -0V2 → -0V2 / 715.8

-714A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

192.2 / 24V-Z1 → 24Vdc
24V-Z1 / 715.1

714-8 -X26.7 3 Q26 — -XB26.7 3 — -714Y0 A97.13.9 A1/A2 — -XB26.7 1
714-9 -X26.7 4 Q26 — -XB26.7 4 — -714Y0 A97.13.9 B1/B2
714-10 -X26.7 5 Q26 — -XB26.7 5 — -714Y2 A97.13.11 A1/A2
714-11 -X26.7 6 Q26 — -XB26.7 6 — -714Y2 A97.13.11 B1/B2
714-12 -X26.7 7 Q26 — -XB26.7 7 — -714Y4 A97.13.13 A1/A2
714-13 -X26.7 8 Q26 — -XB26.7 8 — -714Y4 A97.13.13 B1/B2
714-14 -X26.7 9 Q26 — -XB26.7 9 — -714Y6 A97.13.15 A1/A2
714-15 -X26.7 10 Q26 — -XB26.7 10 — -714Y6 A97.13.15 B1/B2

0V1 / 715.1

-X26.7 1 Q26
120.6 / 0V1 → 0V1 / 715.1

712
715

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	714
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

LEVELLER 1 BACK UP ROLL 5 UP

LEVELLER 1 BACK UP ROLL 5 DOWN

LEVELLER 1 UPPER BENCH LOCKED

LEVELLER 1 UPPER BENCH RELEASE

LEVELLER 1 LOWER BENCH LOCKED

LEVELLER 1 LOWER BENCH RELEASE

LEVELLER 1 BUSHINGS CILINDERS GREASE DISTRIBUTION

LEVELLER 1 PARKING BRAKE

-715A0
700.6
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A77.0 1 — 715-0
A77.1 5 — 715-1
A77.2 2 — 715-2
A77.3 6 — 715-3
A77.4 3 — 715-4
A77.5 7 — 715-5
A77.6 4 — 715-6
A77.7 8 — 715-7

714.9 / -0V2 → -0V2 / 716.8

-715A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

714.9 / 24V-Z1 → 24Vdc
195.2 / 24V-Z11 →

715-8 -X26.7 11 Q26 — -XB26.7 11 — A1 -715Y0 A97.13.17 A2 — -XB26.7 2 — 714.8 / 0V1
715-9 -X26.7 12 Q26 — -XB26.7 12 — B1 -715Y0 A97.13.17 B2 — 0V1 716.4
715-10 -X26.8 3 Q26 — -XB26.8 3 — A1 -715Y2 A97.13.46 A2 — -XB26.8 1 — -X26.8 1 Q26
715-11 -X26.8 4 Q26 — -XB26.8 4 — B1 -715Y2 A97.13.46 B2
715-12 -X26.8 5 Q26 — -XB26.8 5 — A1 -715Y4 A97.13.55 A2 — -XB26.8 2 — -X26.8 2 Q26
715-13 -X26.8 6 Q26 — -XB26.8 6 — B1 -715Y4 A97.13.55 B2
715-14 X — XB — x1 -715Y6 A97.13.64 x2 — XB — X
715-15 X — XB — x1 -715Y7 A97.13.4 x2 — XB — X

714.9 / 0V1 → 0V1 / 716.1
120A.7 / 0V1 →

⇦714
716⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	715
Revision			Replacement of / Replaced by			Group: / Of	414

SPARE	LEVELLER 1 SLIDING JOINTS PLATE SUPPORT UP	LEVELLER 1 SLIDING JOINTS PLATE SUPPORT DOWN	LEVELLER 1 BACK UP ROLL 6 UP	LEVELLER 1 BACK UP ROLL 6 DOWN	LEVELLER 1 BACK UP ROLL 7 UP	LEVELLER 1 BACK UP ROLL 7 DOWN	SPARE

-716A0 700.7 — OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A78.0 1 · A78.1 5 · A78.2 2 · A78.3 6 · A78.4 3 · A78.5 7 · A78.6 4 · A78.7 8

716-0 · 716-1 · 716-2 · 716-3 · 716-4 · 716-5 · 716-6 · 716-7

715.9 / -0V2 → -0V2 / 718.0

-716A1: 1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 · 21 24 22 · 31 34 32 · 41 44 42 · 51 54 52 · 61 64 62 · 71 74 72 · 81 84 82 COM

715.9 / 24V-Z1 → 24Vdc

24V-Z1 / 718.0

716-9 · 716-10 · 716-11 · 716-12 · 716-13 · 716-14

X · X · -X26.7 13 Q26 · -X26.7 14 Q26 · -X26.7 15 Q26 · -X26.7 16 Q26

XB · XB · -XB26.7 13 · -XB26.7 14 · -XB26.7 15 · -XB26.7 16

-716Y1 A97.13.42 · -716Y3 A97.13.19 · -716Y5 A97.13.21 — A1 / A2 / B1 / B2

XB

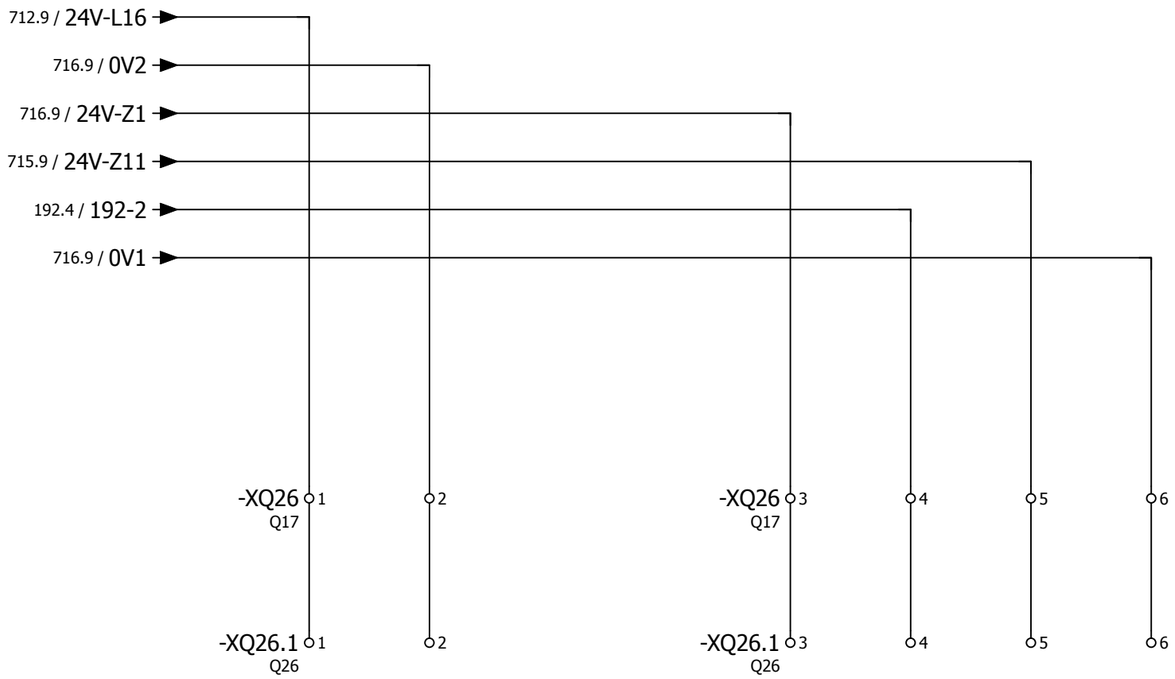
0V1 715.2

X

715.9 / 0V1 → 0V1 / 718.0

⇦715 718⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	716
Revision			Replacement of / Replaced by			Group: / Of	414

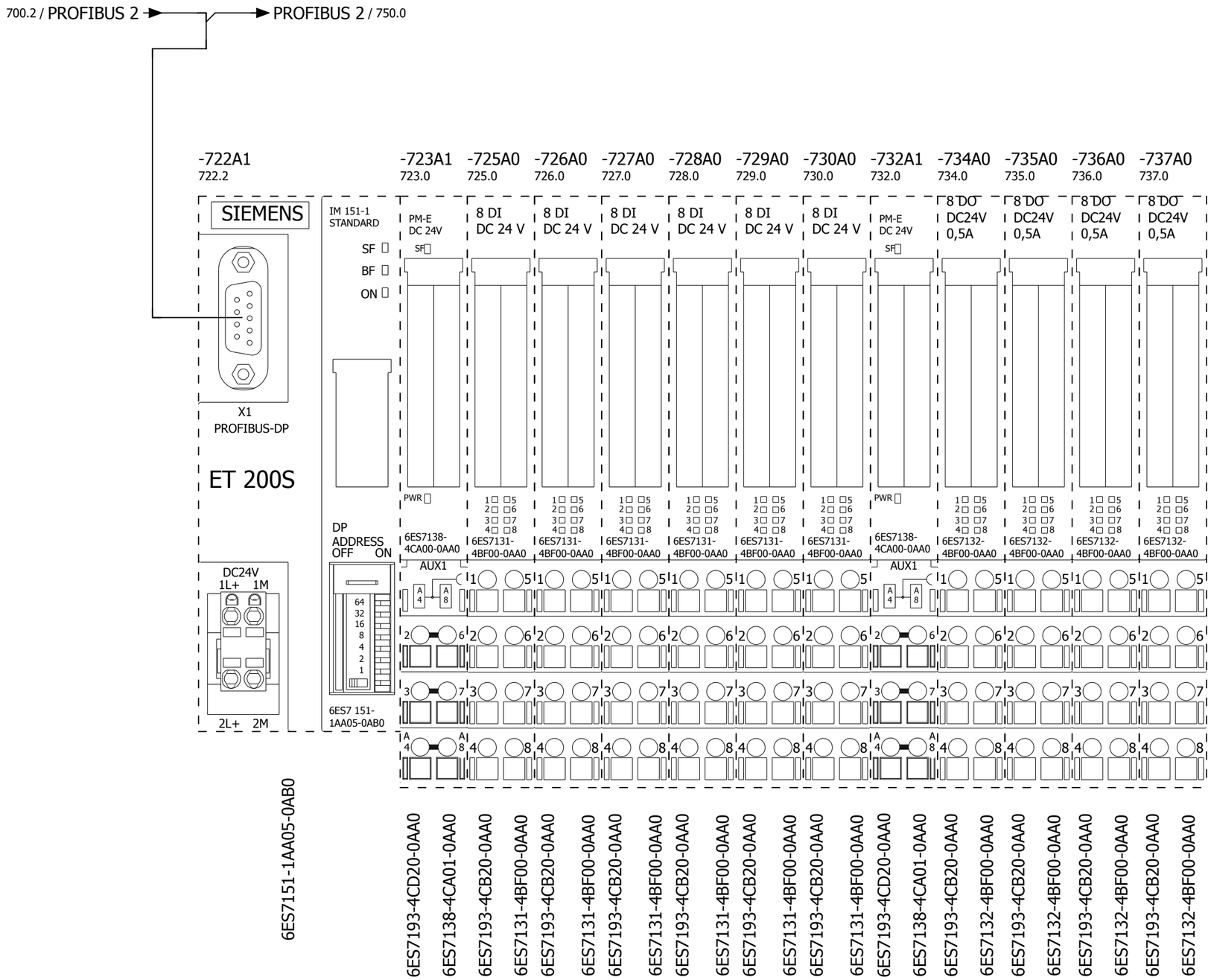


1 LEVELLER BOX SUPPLY

⇦716

720⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 1 box supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 718
Revision		Replacement of	Replaced by			Group:	Of 414



⇦718

722⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	720
Revision		Replacement of	Replaced by			Group:	Of 414

121.9 / 24V-L17 → 24V-L17 / 723.0

122.7 / 0V2 → 0V2 / 723.0

-722A1
720.2

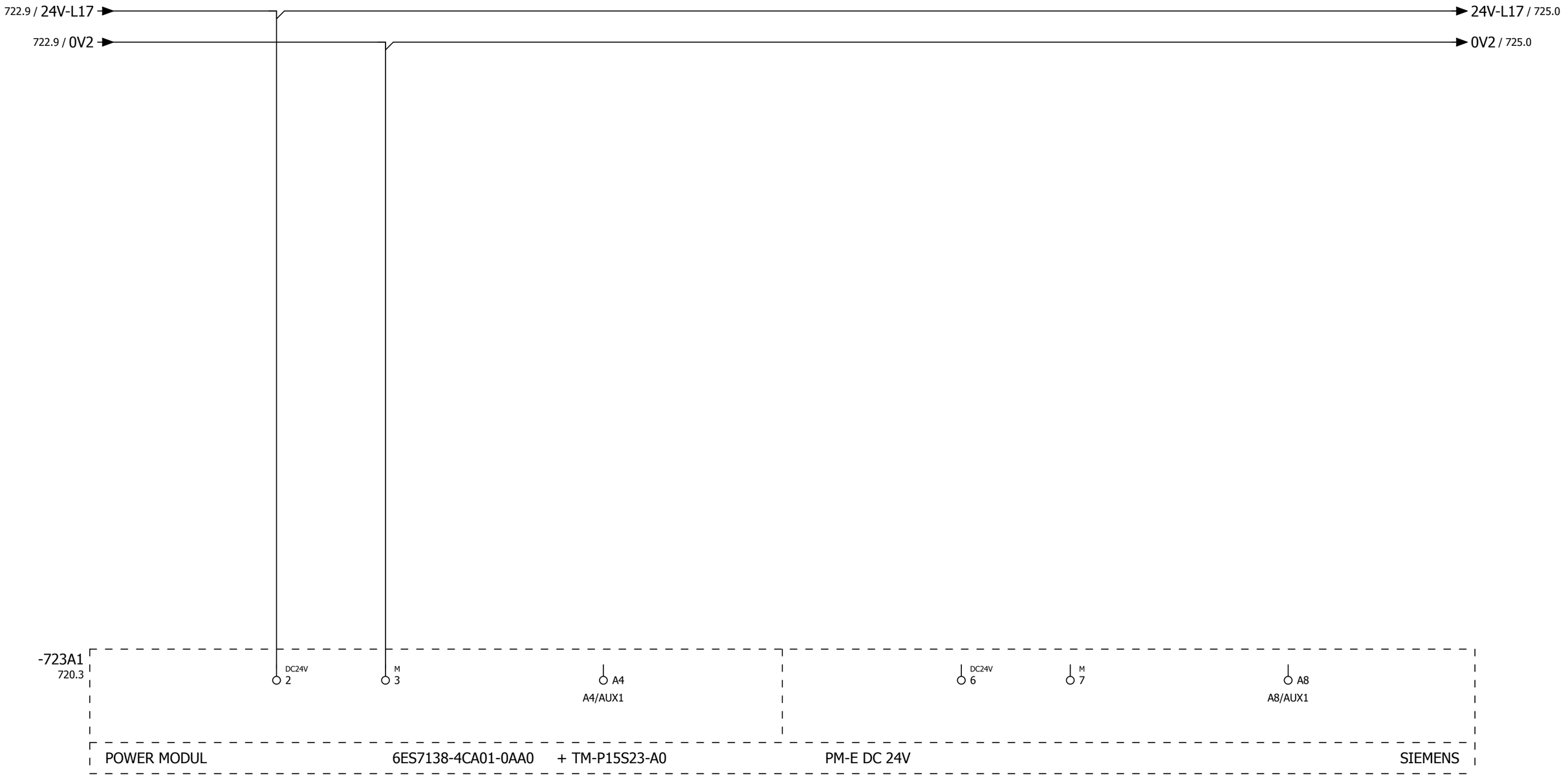
1L+ 1
2L+ 2
1M 3
2M 4

6ES7151-1AA05-0AB0 IM 151-1 STANDARD SIEMENS

⇦720

723⇨

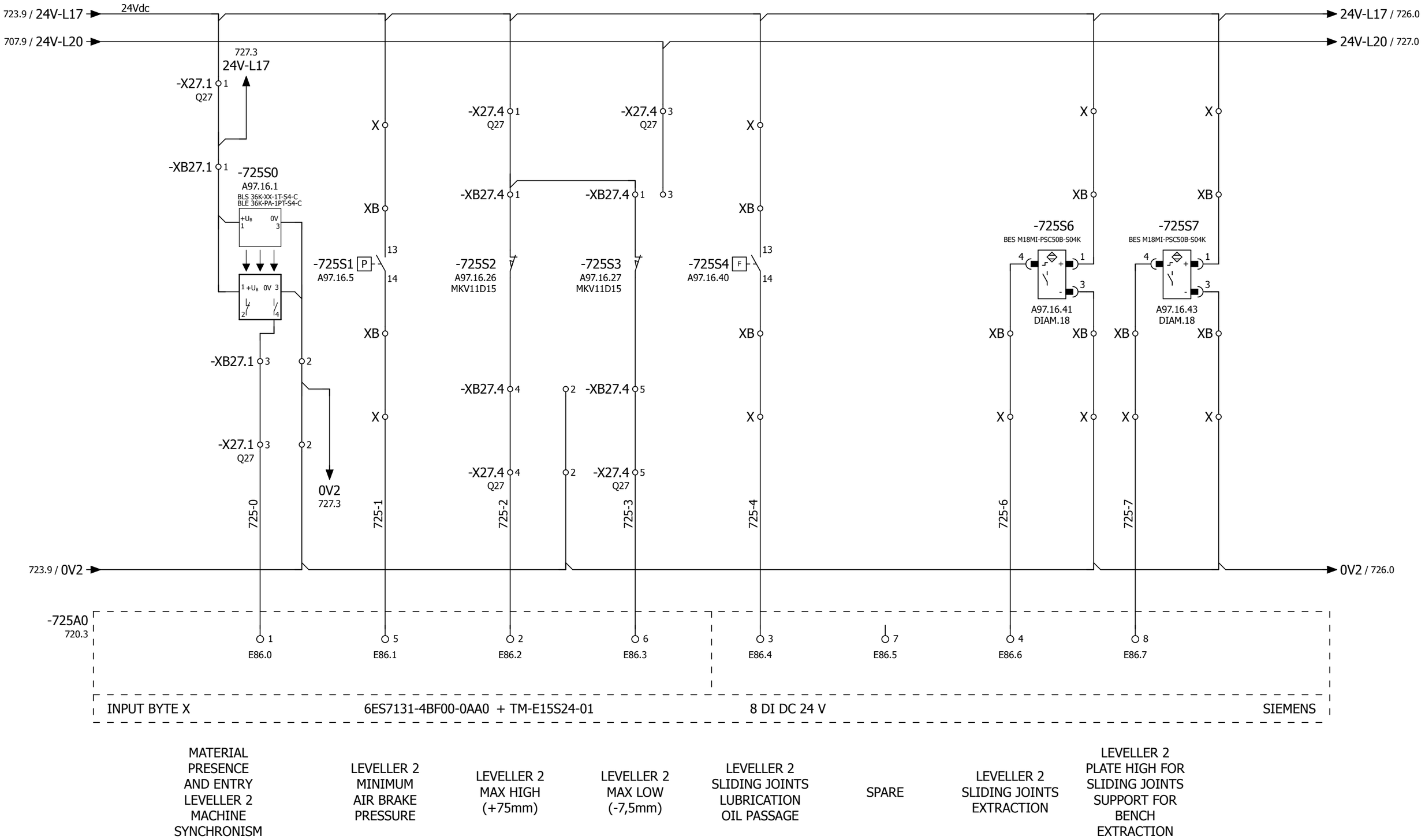
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 151 leveller 2 box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	722
Revision		Replacement of	Replaced by			Group:	Of 414



⇦722

725⇨

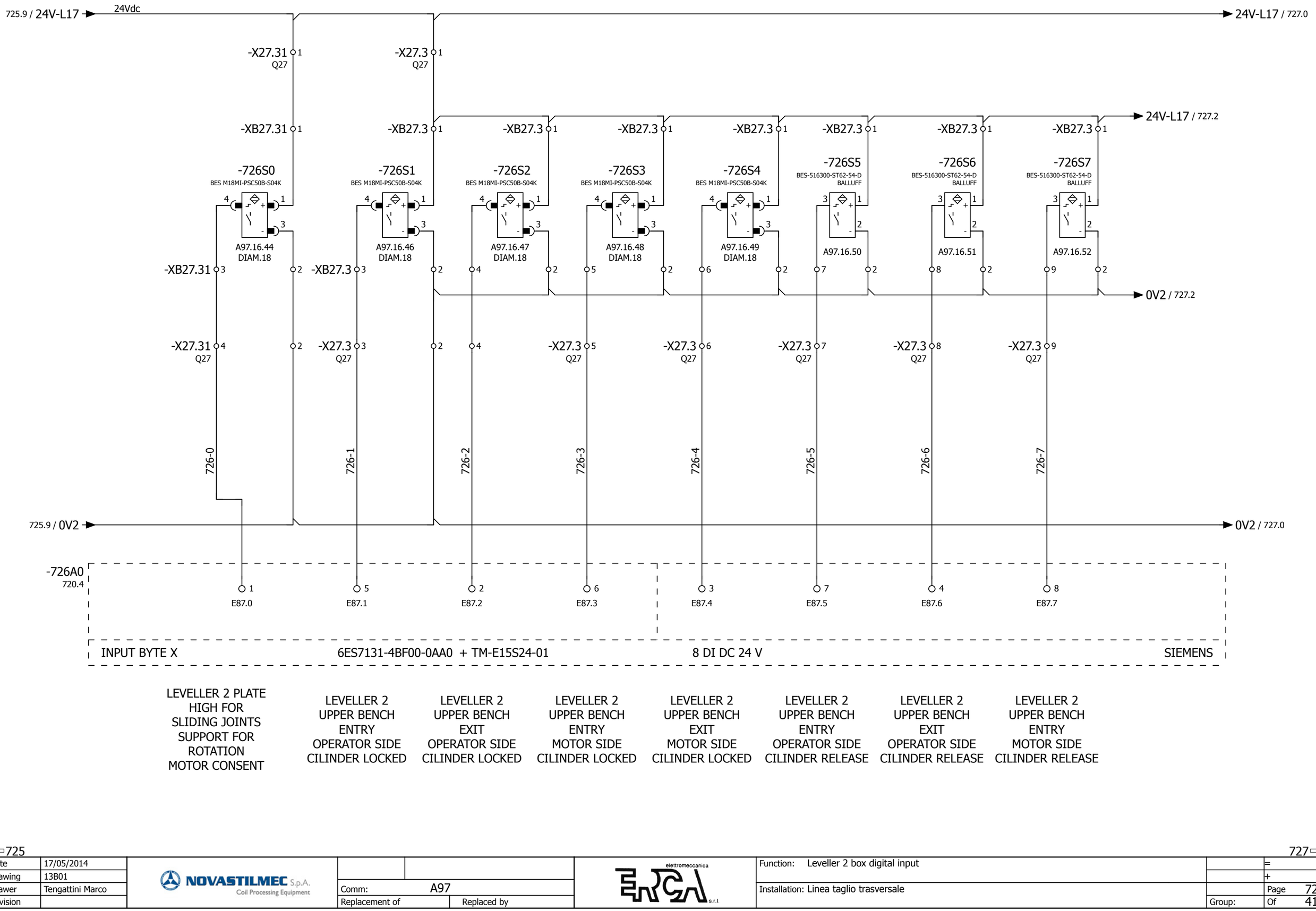
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul leveller 2 box		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	723
Revision			Replacement of / Replaced by			Group: / Of	414



⇦723

726⇨

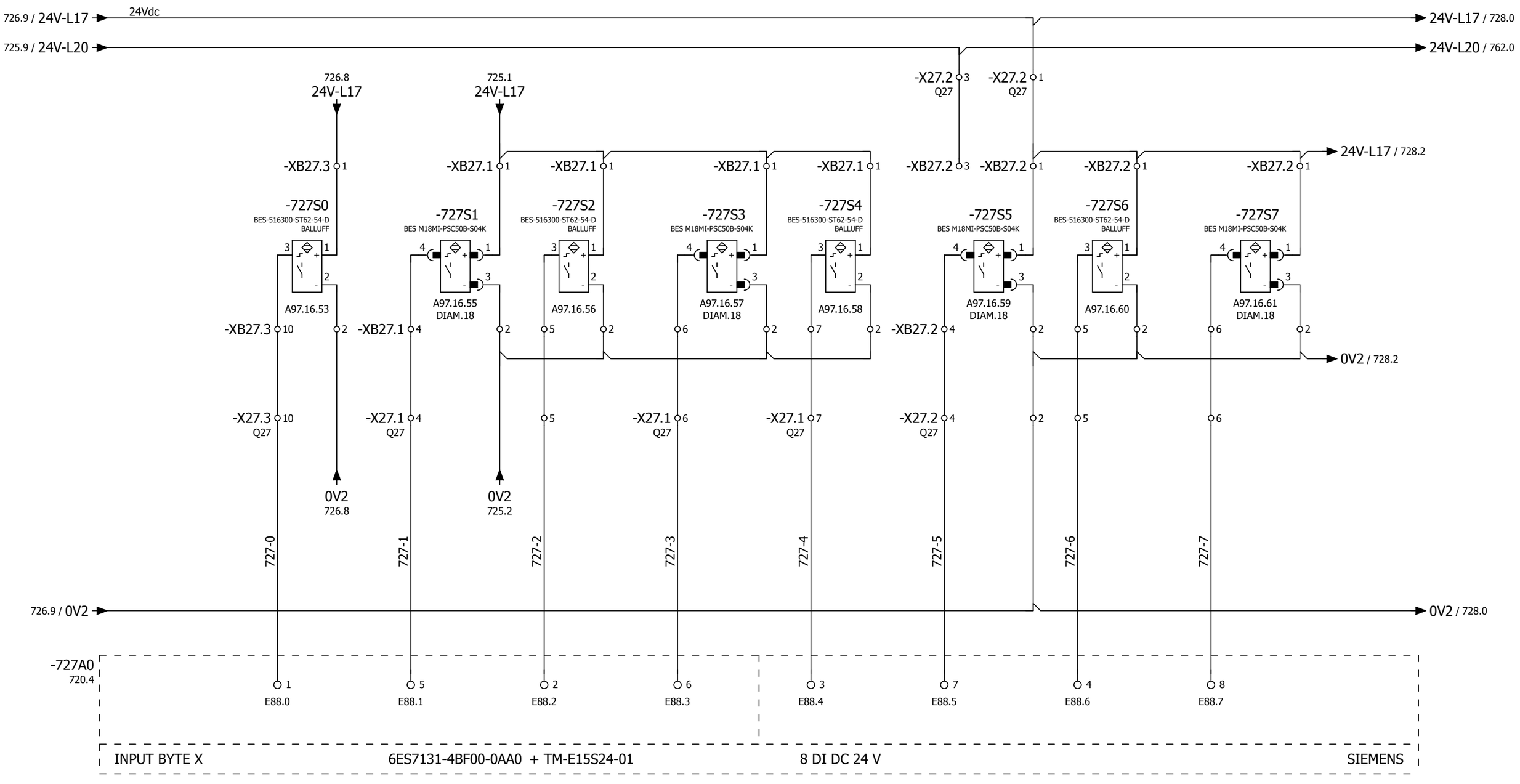
Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	725
Revision		Replacement of	Replaced by			Group:	Of 414



⇦725

727⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	726
Revision		Replacement of	Replaced by			Group:	Of 414



LEVELLER 2 UPPER BENCH EXIT MOTOR SIDE CILINDER RELEASE

LEVELLER 2 LOWER BENCH ENTRY OPERATOR SIDE CILINDER LOW AND LOCKED

LEVELLER 2 LOWER BENCH ENTRY OPERATOR SIDE CILINDER HIGH AND RELEASE

LEVELLER 2 LOWER BENCH ENTRY MOTOR SIDE CILINDER LOW AND LOCKED

LEVELLER 2 LOWER BENCH ENTRY MOTOR SIDE CILINDER HIGH AND RELEASE

LEVELLER 2 LOWER BENCH EXIT OPERATOR SIDE CILINDER LOW AND LOCKED

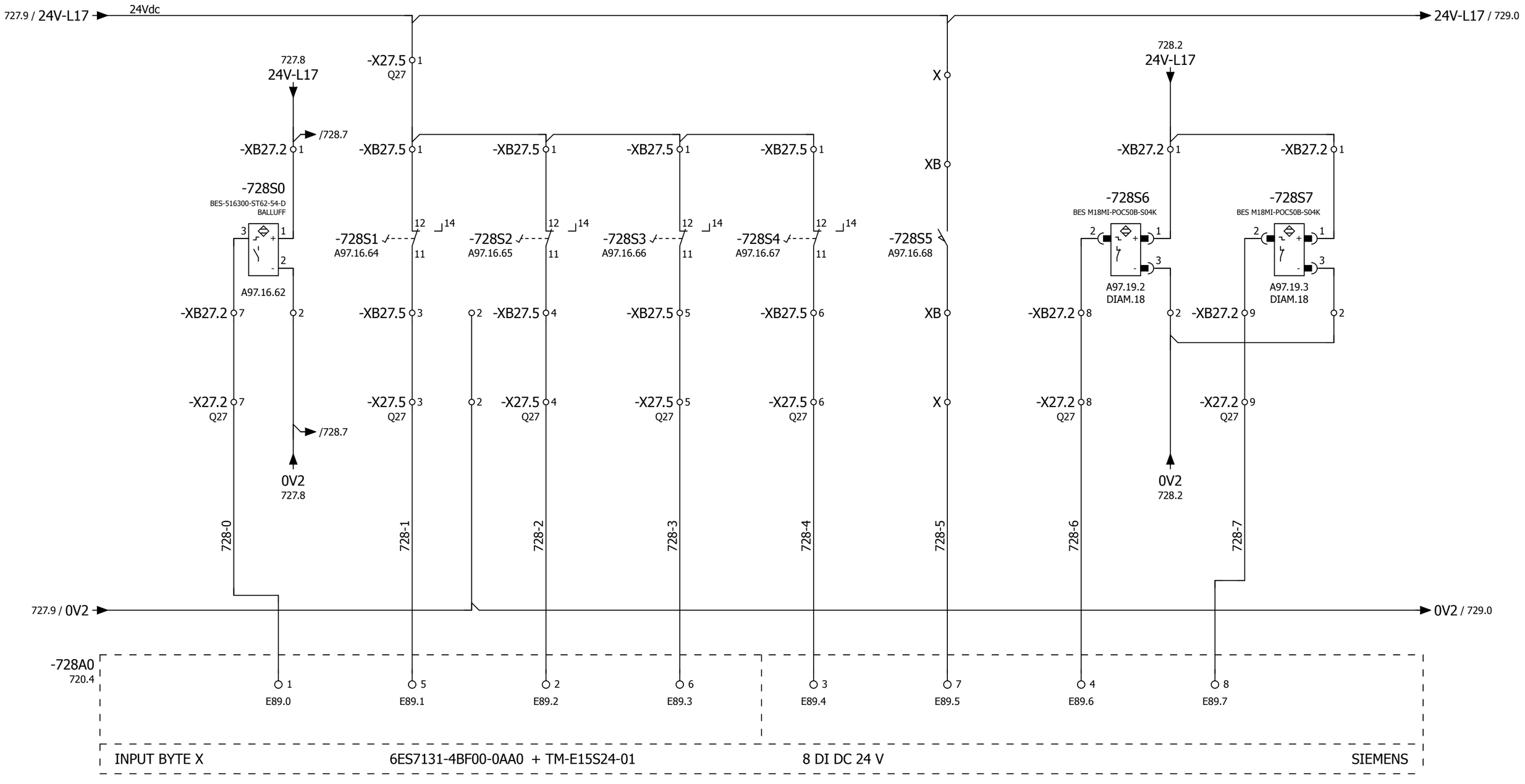
LEVELLER 2 LOWER BENCH EXIT OPERATOR SIDE CILINDER HIGH AND RELEASE

LEVELLER 2 LOWER BENCH EXIT MOTOR SIDE CILINDER LOW AND LOCKED

⇦726

728⇨

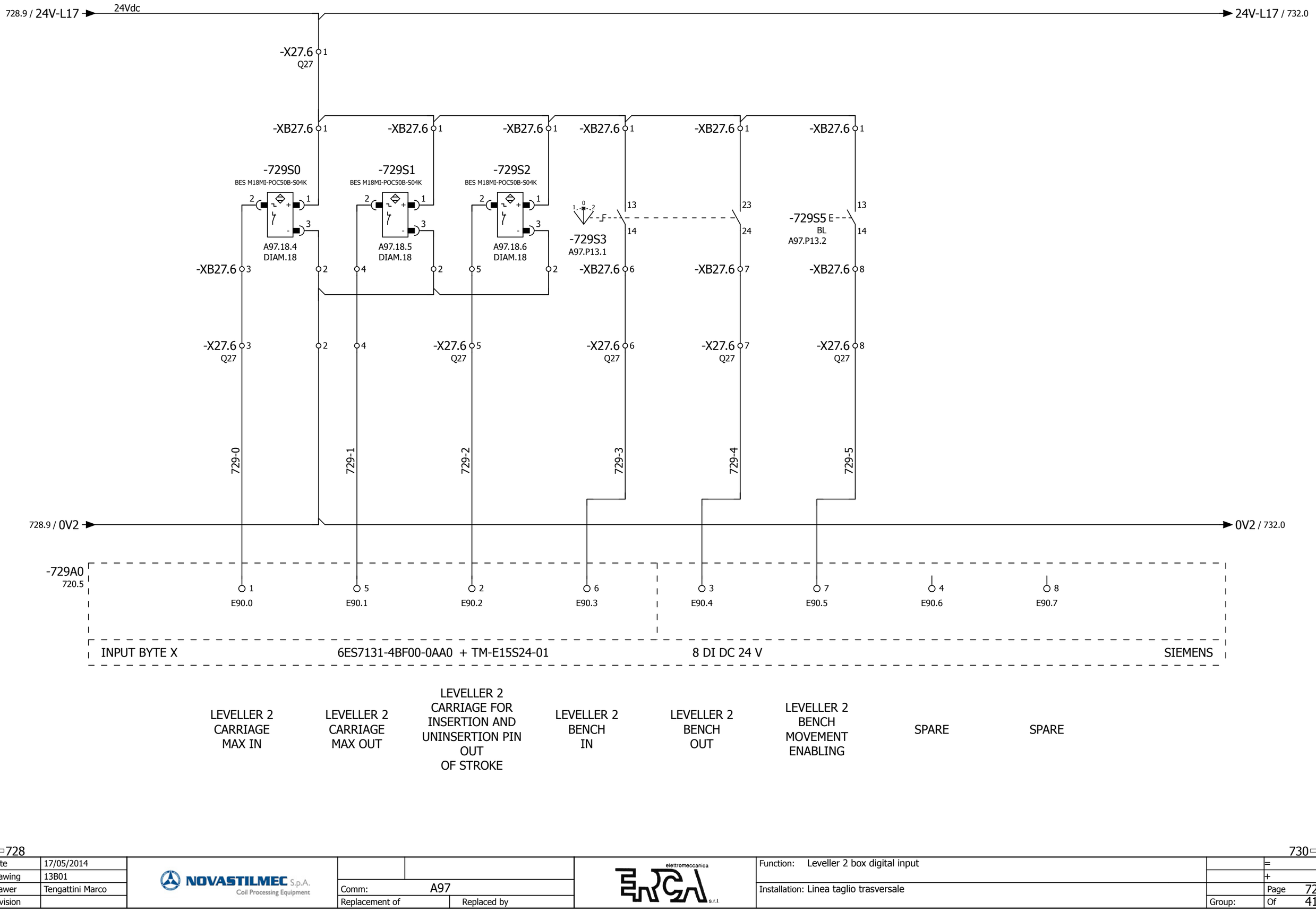
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	727
Revision		Replacement of	Replaced by			Group:	Of 414



⇦727

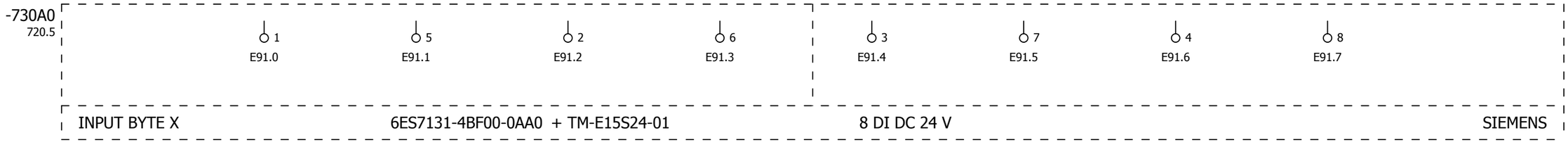
729⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	728
Revision			Replacement of / Replaced by			Group: / Of	414


728.9 / 24V-L17
24Vdc
24V-L17 / 732.0
-X27.6 1
Q27
-XB27.6 1
-729S0
BES M18MI-POC50B-S04K
A97.18.4
DIAM.18
-729S1
BES M18MI-POC50B-S04K
A97.18.5
DIAM.18
-729S2
BES M18MI-POC50B-S04K
A97.18.6
DIAM.18
-729S3
A97.P13.1
-729S5 E
BL
A97.P13.2
-XB27.6 3
-XB27.6 4
-XB27.6 5
-XB27.6 6
-XB27.6 7
-XB27.6 8
-X27.6 3
-X27.6 4
-X27.6 5
-X27.6 6
-X27.6 7
-X27.6 8
729-0
729-1
729-2
729-3
729-4
729-5
728.9 / 0V2
0V2 / 732.0
-729A0
720.5
E90.0
E90.1
E90.2
E90.3
E90.4
E90.5
E90.6
E90.7
INPUT BYTE X
6ES7131-4BF00-0AA0 + TM-E15S24-01
8 DI DC 24 V
SIEMENS
LEVELLER 2 CARRIAGE MAX IN
LEVELLER 2 CARRIAGE MAX OUT
LEVELLER 2 CARRIAGE FOR INSERTION AND UNINSERTION PIN OUT OF STROKE
LEVELLER 2 BENCH IN
LEVELLER 2 BENCH OUT
LEVELLER 2 BENCH MOVEMENT ENABLING
SPARE
SPARE

728
730

0	1	2	3	4	5	6	7	8	9



SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

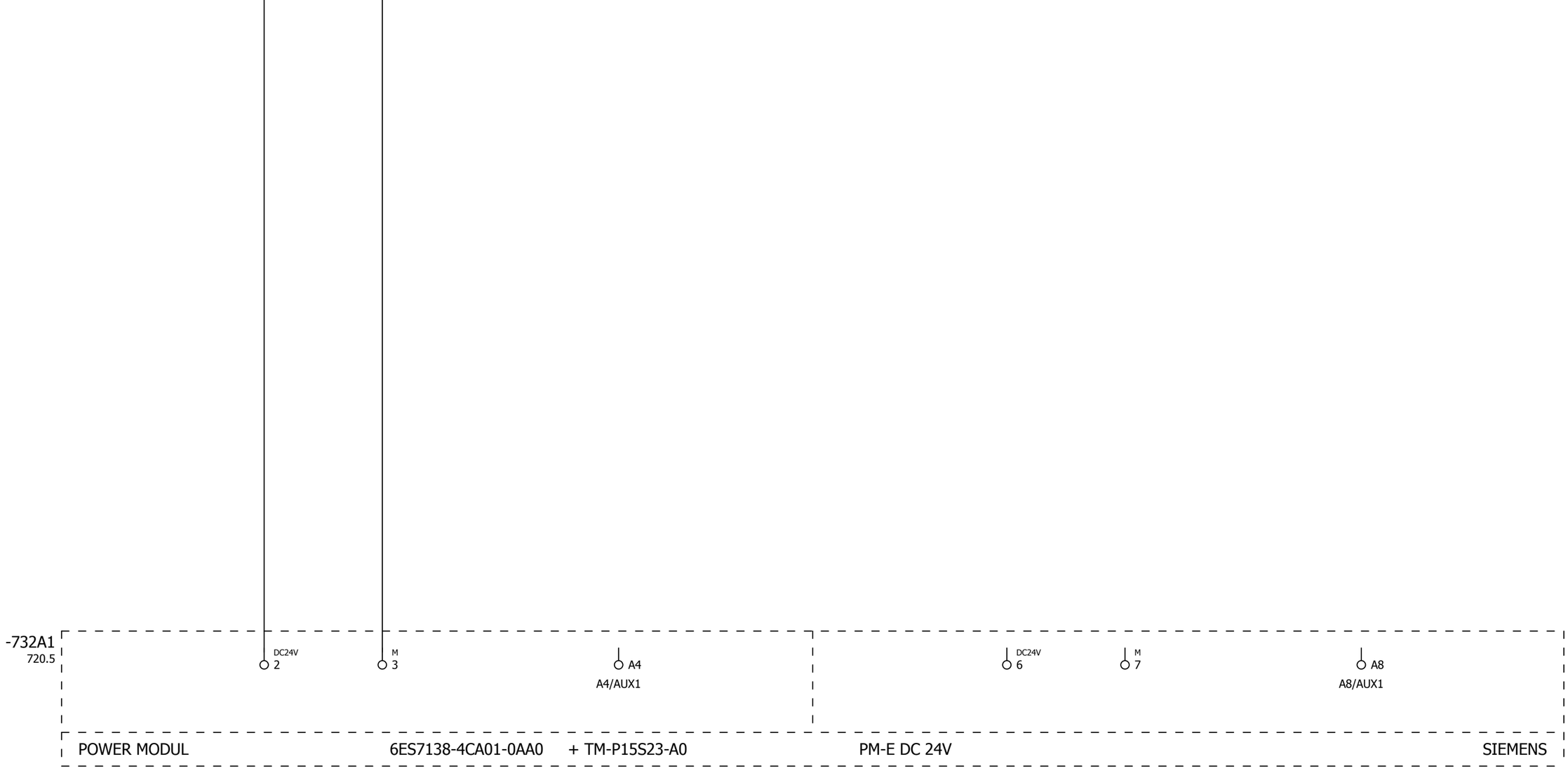
⇦729

732⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	730
Revision			Replacement of / Replaced by			Group: / Of	414

729.9 / 24V-L17 → 24V-L17 / 745.0

729.9 / 0V2 → 0V2 / 734.8



⇦730

734⇨

LEVELLER 2 BACK UP ROLL 1 UP
LEVELLER 2 BACK UP ROLL 1 DOWN
LEVELLER 2 BACK UP ROLL 2 UP
LEVELLER 2 BACK UP ROLL 2 DOWN
LEVELLER 2 BACK UP ROLL 3 UP
LEVELLER 2 BACK UP ROLL 3 DOWN
LEVELLER 2 BACK UP ROLL 4 UP
LEVELLER 2 BACK UP ROLL 4 DOWN

-734A0
720.6
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A86.0 1 — 734-0
A86.1 5 — 734-1
A86.2 2 — 734-2
A86.3 6 — 734-3
A86.4 3 — 734-4
A86.5 7 — 734-5
A86.6 4 — 734-6
A86.7 8 — 734-7

732.9 / -0V2 → -0V2 / 735.8

-734A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

192.2 / 24V-Z1 → 24Vdc
24V-Z1 / 735.1

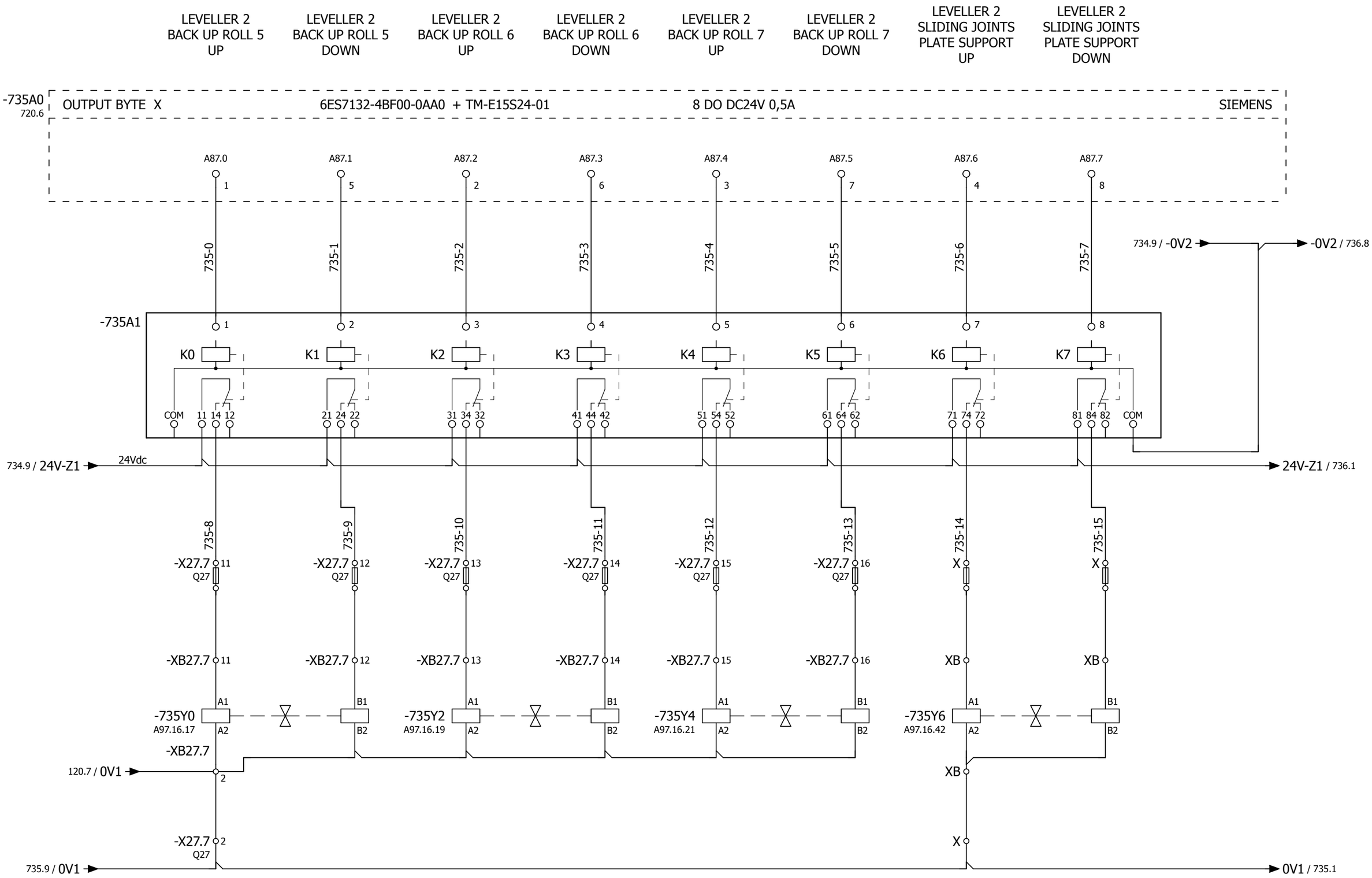
734-8 → -X27.7 3 Q27 → -XB27.7 3 → -734Y0 A1 / A97.16.9 A2 B1 B2
734-9 → -X27.7 4 Q27 → -XB27.7 4
734-10 → -X27.7 5 Q27 → -XB27.7 5 → -734Y2 A1 / A97.16.11 A2 B1 B2
734-11 → -X27.7 6 Q27 → -XB27.7 6
734-12 → -X27.7 7 Q27 → -XB27.7 7 → -734Y4 A1 / A97.16.13 A2 B1 B2
734-13 → -X27.7 8 Q27 → -XB27.7 8
734-14 → -X27.7 9 Q27 → -XB27.7 9 → -734Y6 A1 / A97.16.15 A2 B1 B2
734-15 → -X27.7 10 Q27 → -XB27.7 10

-XB27.7 1 → 0V1 / 736.1

-X27.7 1 Q27
734.9 / 0V1 → 0V1 / 734.1

⇦732
735⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 734
Revision			Replacement of / Replaced by			Group:	Of 414

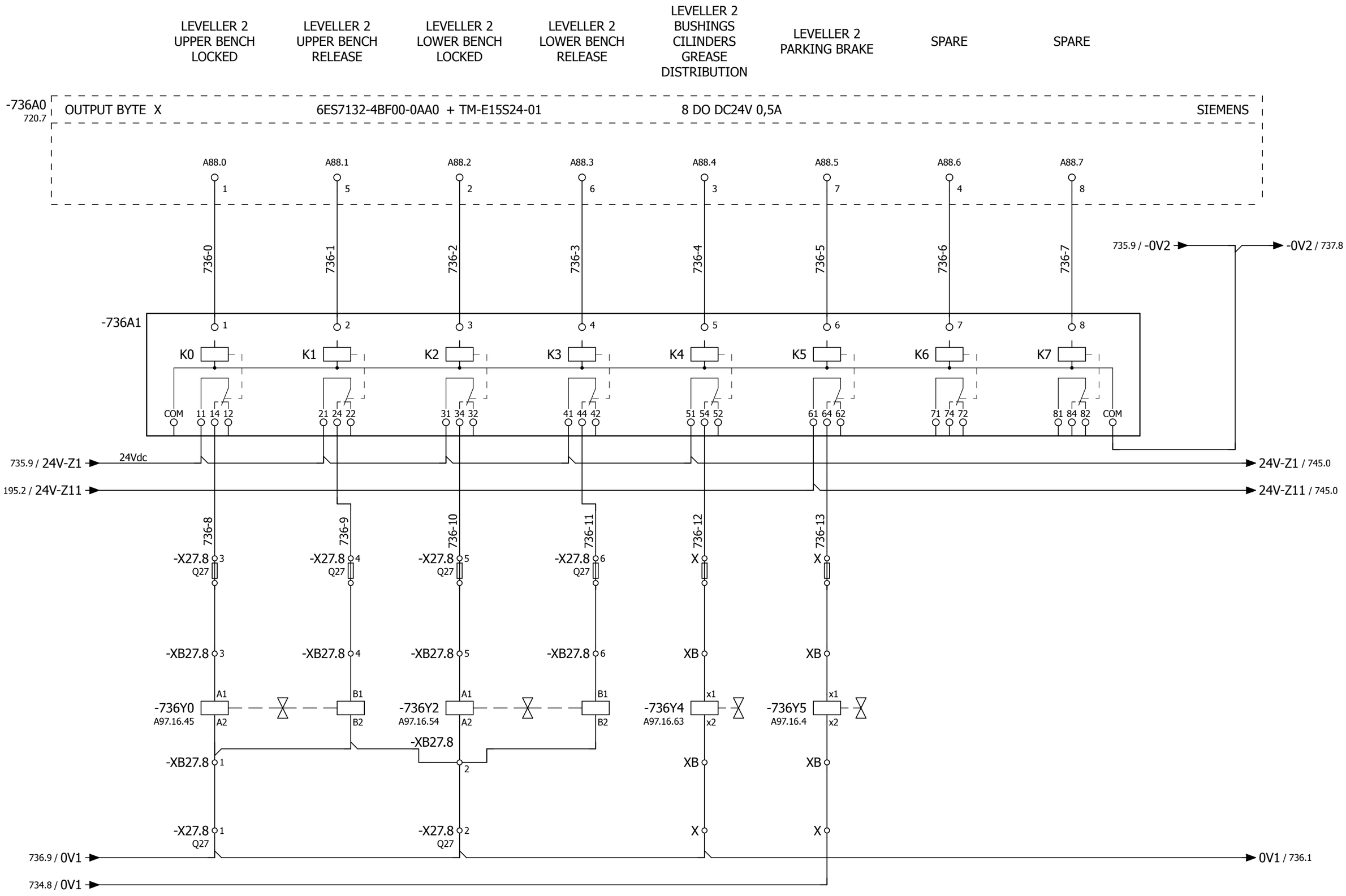


⇦734

736⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 735
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



⇦735

737⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	736
Revision		Replacement of	Replaced by			Group:	Of 414

SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

-737A0
720.7

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A89.0 1 — 737-0
A89.1 5 — 737-1
A89.2 2 — 737-2
A89.3 6 — 737-3
A89.4 3 — 737-4
A89.5 7 — 737-5
A89.6 4 — 737-6
A89.7 8 — 737-7

736.9 / -0V2 → -0V2 / 745.0

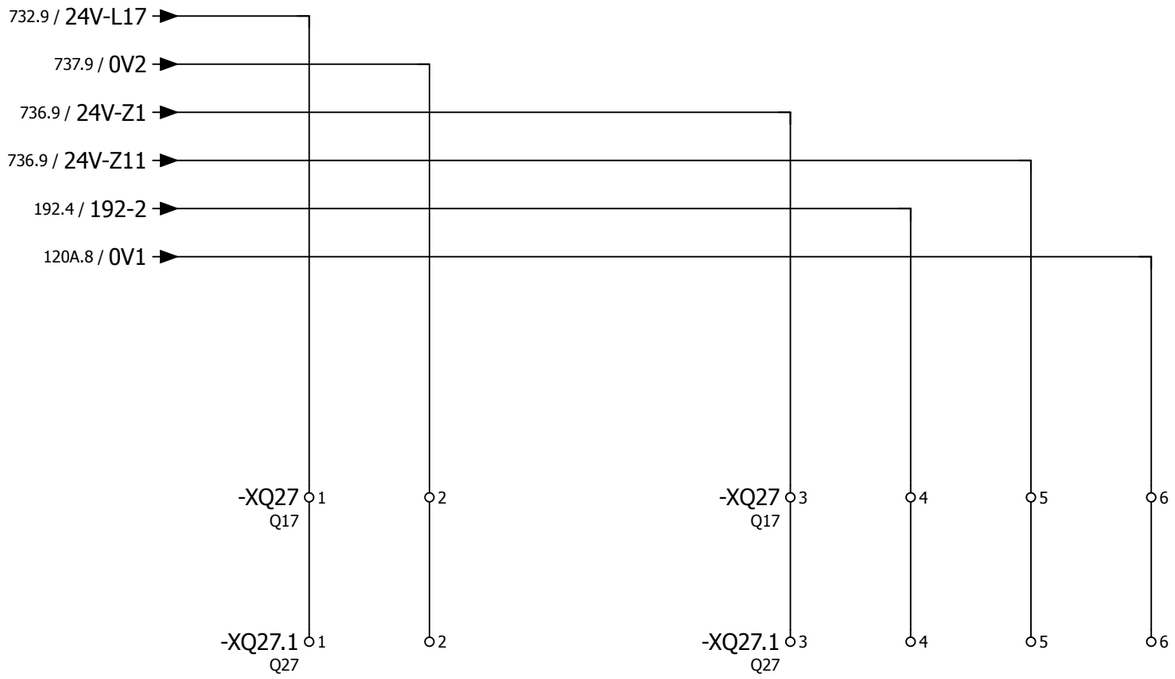
-737A1

	K0	K1	K2	K3	K4	K5	K6	K7
	1	2	3	4	5	6	7	8
	COM	21	31	41	51	61	71	81
	11	24	34	44	54	64	74	84
	14	22	32	42	52	62	72	82
	12							COM

⇦736

745⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	737
Revision		Replacement of	Replaced by			Group:	Of 414



2 LEVELLER BOX SUPPLY

⇦737

750⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Leveller 2 box supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 745
Revision		Replacement of	Replaced by			Group:	Of 414

720.2 / PROFIBUS 2 → PROFIBUS 2 / 801.1

-752A1	-753A1	-755A0	-756A0	-757A0	-759A1	-760A0	-761A0	-762A0	-763A0	-764A0	-765A0	-766A0	-767A0	-768A0	-769A0	-770A0	-771A0	-772A0	-773A0	-774A0	-775A0	-776A0
752.2	753.0	755.0	756.0	757.0	759.0	760.0	761.0	762.0	763.0	764.0	765.0	766.0	767.0	768.0	769.0	770.0	771.0	772.0	773.0	774.0	775.0	776.0
SIEMENS	IM 151-1 STANDARD	PM-E DC 24V	2 AI I 2-wire STANDARD	2 AI I 2-wire STANDARD	2 AO U STANDARD	PM-E DC 24V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V
	SF	SF	SF	SF	SF	SF																	
	BF																						
	ON																						
		PWR				PWR																	
	DP ADDRESS OFF ON	6ES7138-4CA00-0AA0	6ES7134-4GB01-0AB0	6ES7134-4GB01-0AB0	6ES7132-4FB01-0AB0	6ES7138-4CA00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0
		AUX1				AUX1																	
	64 32 16 8 4 2 1	A4 A8	1 5	1 5	1 5	1 5	A4 A8	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5	1 5
			2 6	2 6	2 6	2 6		2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6	2 6
			3 7	3 7	3 7	3 7		3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7	3 7
			A4 A8 4 8	4 8	4 8	4 8	A4 A8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8	4 8
6ES7151-1AA05-0AB0	6ES7193-4CD20-0AA0	6ES7138-4CA01-0AA0	6ES7193-4CB20-0AA0	6ES7134-4GB01-0AB0	6ES7193-4CB20-0AA0	6ES7134-4GB01-0AB0	6ES7193-4CB20-0AA0	6ES7135-4FB01-0AB0	6ES7193-4CD20-0AA0	6ES7138-4CA01-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0

X1 PROFIBUS-DP

ET 200S

DC24V 1L+ 1M

2L+ 2M

6ES7 151-1AA05-0AB0

⇦745

751⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box plc layout
Drawing	13B01		Comm: A97		Installation: Linea taglio trasversale
Drawer	Tengattini Marco		Replacement of / Replaced by		Group:
Revision					= / + / Page 750 / Of 414

122.1 / 24V-L18

122.8 / 0V2

24V-L18 / 752.0

0V2 / 752.0

0V2 / 755.0

10V-L+ / 755.0

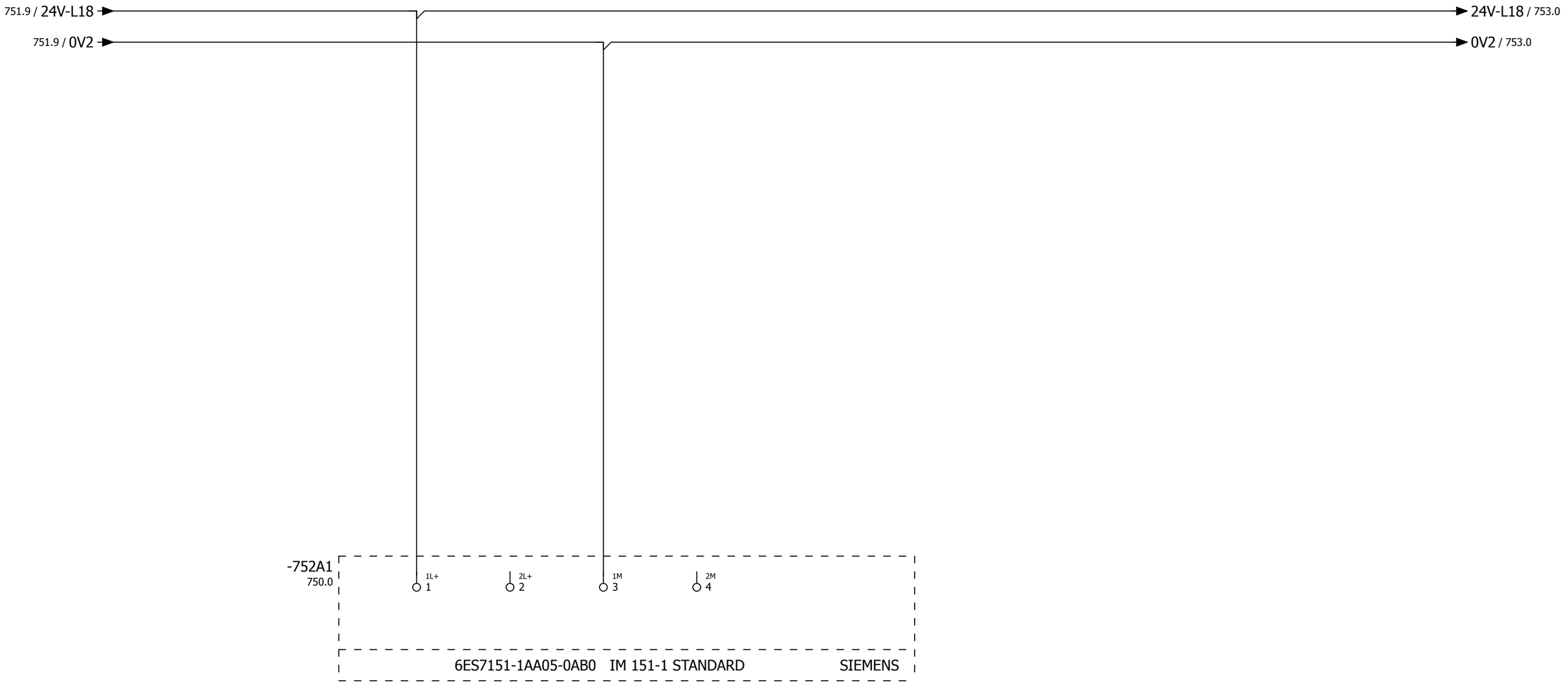
-751A7
1,5A
XCL1R
24Vdc
10Vdc

-778A1	-780A0	-781A0	-782A0	-783A0	-784A0	-785A0	-786A0	-787A0	-788A0	-789A0	-790A0	-791A0
778.0	780.0	781.0	782.0	783.0	784.0	785.0	786.0	787.0	788.0	789.0	790.0	791.0
PM-E DC 24V	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A
SF												
PWR												
6ES7138-4CA00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0
AUX1												
6ES7193-4CD20-0AA0	6ES7138-4CA01-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0

⇦750

752⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box plc layout	=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97			Installation: Linea taglio trasversale	Page 751
Revision			Replacement of	Replaced by			Group: Of 414



⇦751

753⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 151 stackers and transfer platform box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	752
Revision		Replacement of	Replaced by			Group:	Of 414

752.9 / 24V-L18 → 24V-L18 / 759.0

752.9 / 0V2 → 0V2 / 759.0

-753A1
750.1

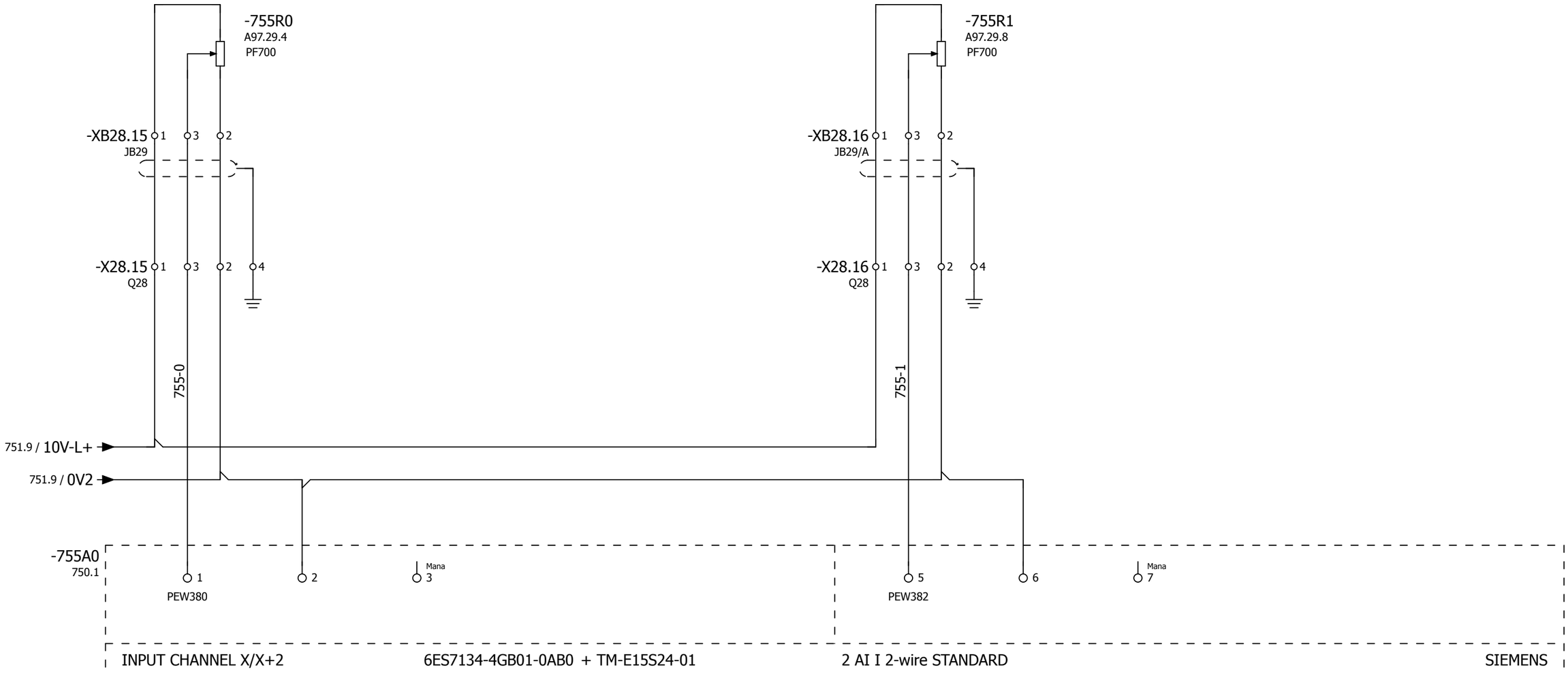
DC24V	M	A4	DC24V	M	A8
2	3	A4/AUX1	6	7	A8/AUX1

POWER MODUL 6ES7138-4CA01-0AA0 + TM-P15S23-A0 PM-E DC 24V SIEMENS

⇦752

755⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul stackers and transfer platform box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 753
Revision		Replacement of	Replaced by			Group:	Of 414



VERTICAL
STROKE CONTROL
PACKAGE
FORMING ROLL
1° CHOICE
STACKER 1° BOX

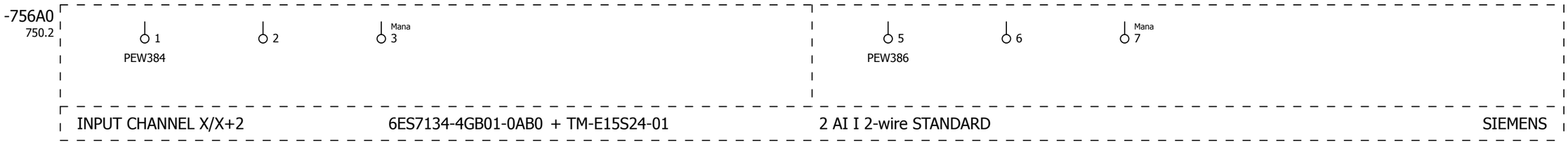
VERTICAL
STROKE CONTROL
PACKAGE
FORMING ROLL
1° CHOICE
STACKER 2° BOX

⇦753

756⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Stackers and transfer platform box analog input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 755
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



SPARE

SPARE

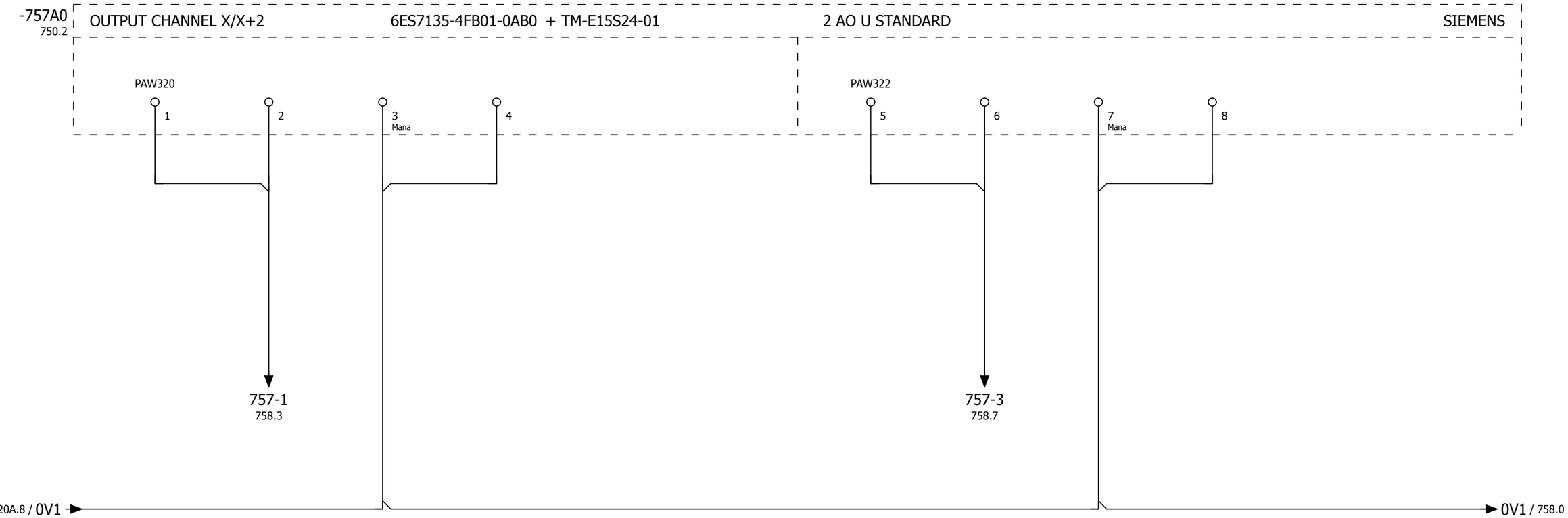
⇦755

757⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box analog input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 756
Revision			Replacement of / Replaced by			Group:	Of 414

BUMPER PRESSURE
REGOLATION
IN BASE OF
OPERATOR SIDE
HEAD MOBILE CARRIAGE
DIMENSION
1° CHOICE STACKER 2° BOX

BUMPER PRESSURE
REGOLATION
IN BASE OF
MOTOR SIDE
HEAD MOBILE CARRIAGE
DIMENSION
1° CHOICE STACKER 2° BOX



⇦756

758⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box analog output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 757
Revision			Replacement of / Replaced by			Group:	Of 414

192.8 / 24V-Z3 →
757.9 / 0V1 →

→ 24V-Z3 / 780.1
→ 0V1 / 780.1

757.2
757-1

-XB28.56 1 2 3 4

-758Y1

Z		B
02		05
04		04
06		06
08		08
10		11
12		12
14		14
16		10
18		15
20		20
22		22
24		24
26		26
28		28
30		30
32		32

CAMOZZI
ER104/50/AP

BUMPER PRESSURE
REGOLATION
IN BASE OF
OPERATOR SIDE
HEAD MOBILE CARRIAGE
DIMENSION
1° CHOICE STACKER 2° BOX

757.6
757-3

-XB28.57 1 2 3 4

-758Y2

Z		B
02		05
04		04
06		06
08		08
10		11
12		12
14		14
16		10
18		15
20		20
22		22
24		24
26		26
28		28
30		30
32		32

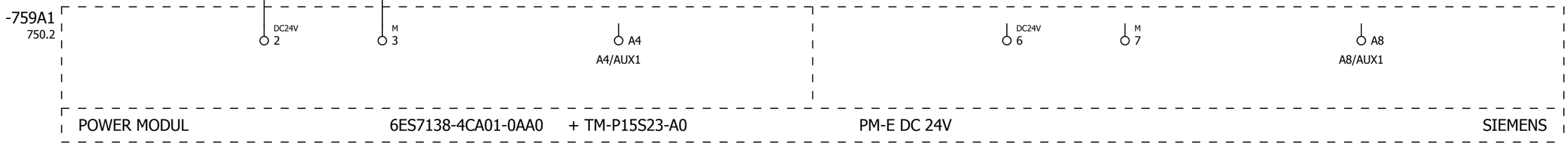
CAMOZZI
ER104/50/AP

BUMPER PRESSURE
REGOLATION
IN BASE OF
MOTOR SIDE
HEAD MOBILE CARRIAGE
DIMENSION
1° CHOICE STACKER 2° BOX

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: 1° choice stacker 2° box proportionals		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 758
Revision			Replacement of / Replaced by			Group:	Of 414

753.9 / 24V-L18 → 24V-L18 / 760.0

753.9 / 0V2 → 0V2 / 760.0



⇦758

760⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul stackers and transfer platform box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 759
Revision		Replacement of	Replaced by			Group:	Of 414

759.9 / 24V-L18 — 24Vdc — 24V-L18 / 761.0

-X28.1 1 Q28

-XB28.1 1 JB26 — 24V-L18 / 761.1

-760S0	-760S1	-760S2	-760S3	-760S4	-760S5	-760S6	-760S7
				BES M18MI-PSC50B-S04K	BES M18MI-PSC50B-S04K		
A97.26.4 MKV11D15	A97.26.5 MKV11D15	A97.26.9 MKV11D15	A97.26.10 MKV11D15	A97.26.14 DIAM.18	A97.26.19 DIAM.18	A97.26.24 MKV11D15	A97.26.25 MKV11D15
-XB28.1 3 JB26	-XB28.1 4 JB26	-XB28.1 5 JB26	-XB28.1 6 JB26	-XB28.1 7 JB26	-XB28.1 2 JB26	-XB28.1 9 JB26	-XB28.1 10 JB26
-X28.1 3 Q28	-X28.1 4 Q28	-X28.1 5 Q28	-X28.1 6 Q28	-X28.1 7 Q28	-X28.1 2 Q28	-X28.1 9 Q28	-X28.1 10 Q28
760-0	760-1	760-2	760-3	760-4	760-5	760-6	760-7

0V2 761.2

759.9 / 0V2 — 0V2 / 761.0

-760A0 750.3

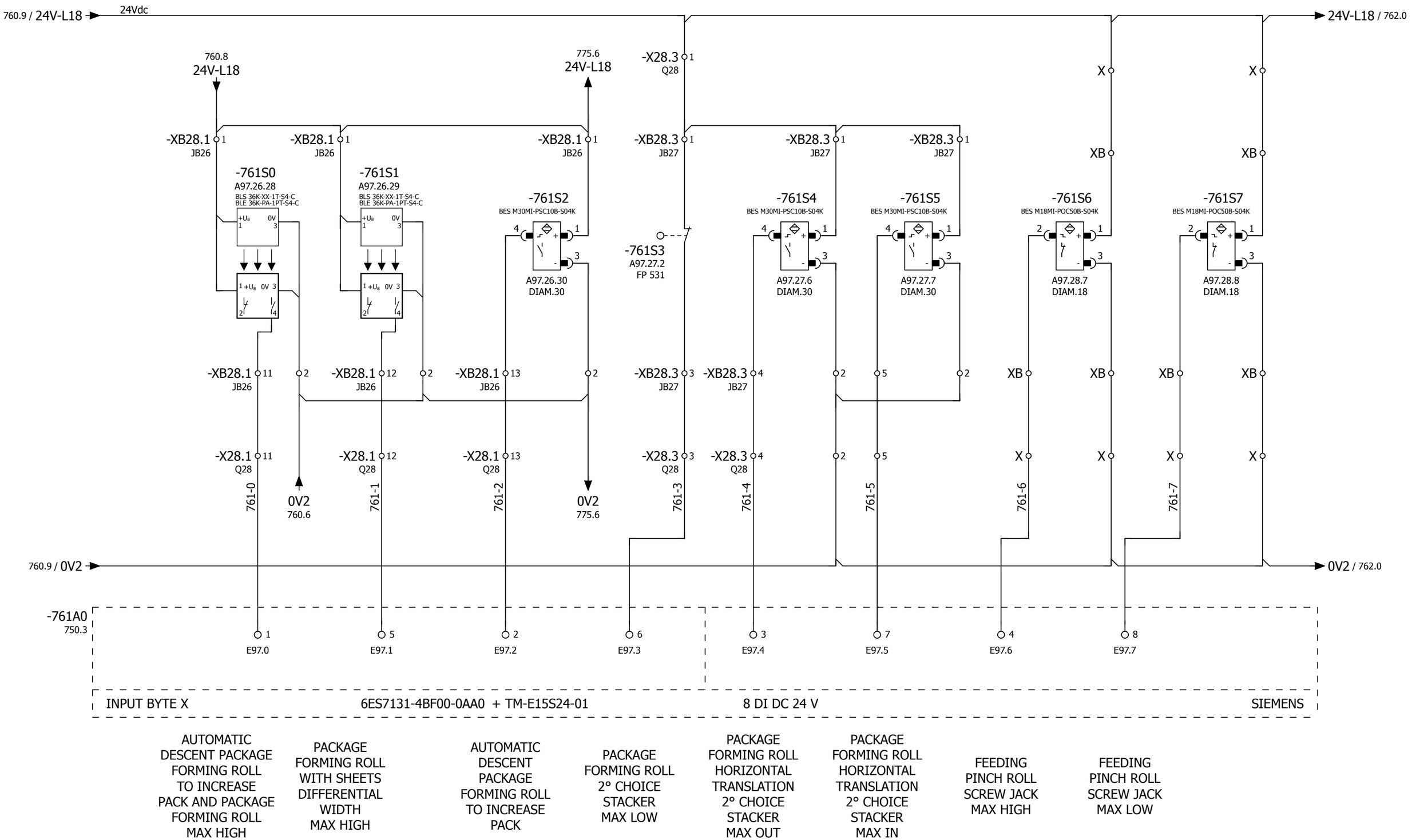
1	5	2	6	3	7	4	8
E96.0	E96.1	E96.2	E96.3	E96.4	E96.5	E96.6	E96.7

INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

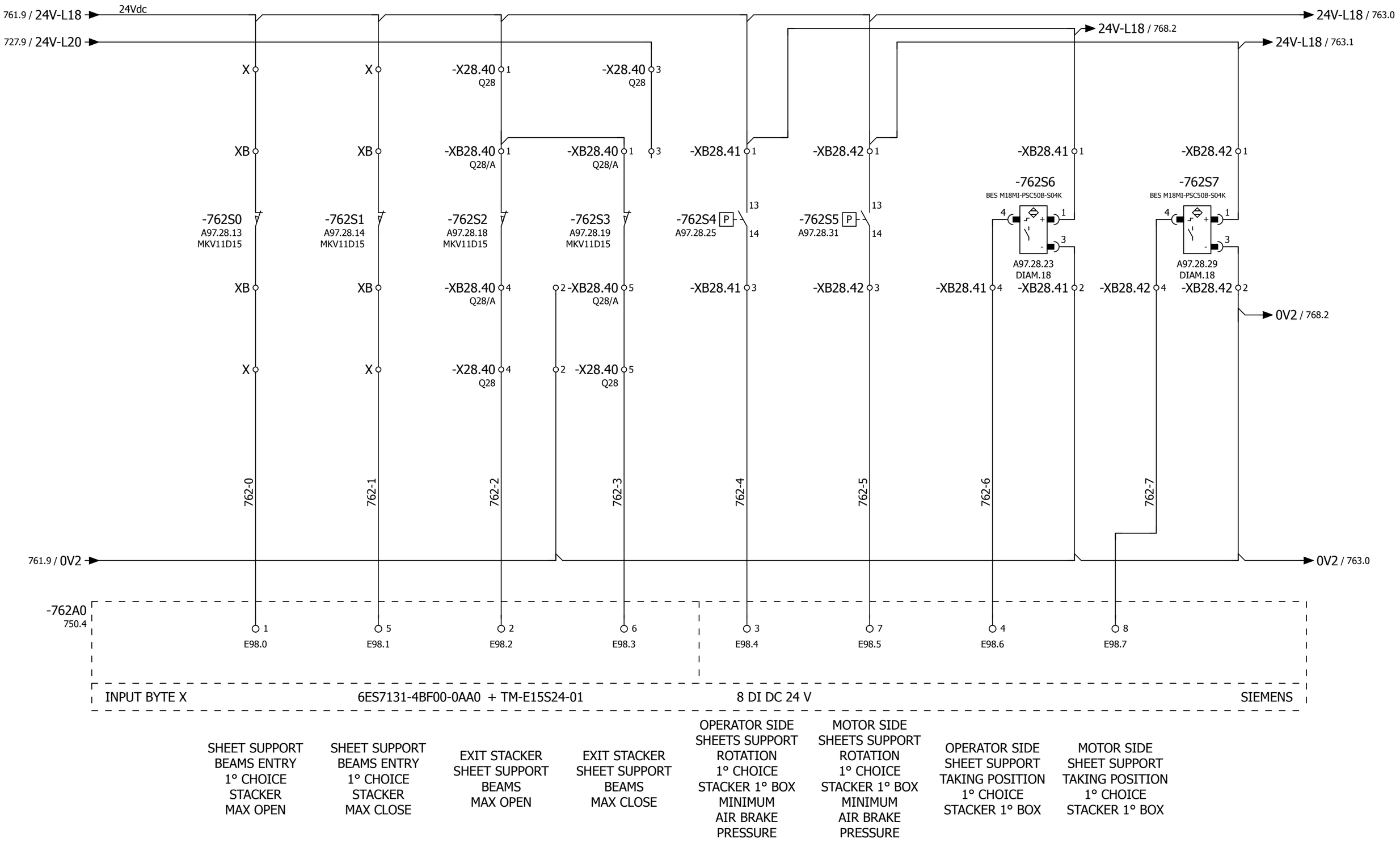
SHEET SUPPORT BEAMS OPERATOR SIDE 2° CHOICE STACKER MAX OPEN	SHEET SUPPORT BEAMS OPERATOR SIDE 2° CHOICE STACKER MAX CLOSE	SHEET SUPPORT BEAMS MOTOR SIDE 2° CHOICE STACKER MAX OPEN	SHEET SUPPORT BEAMS MOTOR SIDE 2° CHOICE STACKER MAX CLOSE	OPERATOR SIDE SHEET SUPPORT TAKING POSITION 2° CHOICE STACKER	MOTOR SIDE SHEET SUPPORT TAKING POSITION 2° CHOICE STACKER	HEAD MOBILE CARRIAGE 2° CHOICE STACKER MAX BACKWARD	HEAD MOBILE CARRIAGE 2° CHOICE STACKER MAX FORWARD

⇦759

761⇨



Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	761
Revision		Replacement of	Replaced by			Group:	Of 414



⇦761

763⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	762
Revision						Group:	Of 414

762.9 / 24V-L18 — 24Vdc

24V-L18 / 764.0

762.8 24V-L18

763.7 24V-L18

763.5 24V-L18

24V-L18 / 768.2

-XB28.41 1 | -XB28.41 1 | -XB28.42 1 | -XB28.42 1 | -XB28.45 1

-763S0
A97.28.40
MKV11D15

-763S2
A97.28.41
MKV11D15

-763S4
A97.28.45
MKV11D15

-763S6
A97.28.46
MKV11D15

-763S7
A97.28.52
MKV11D15

-XB28.41 5 | -XB28.41 6 | -XB28.42 5 | -XB28.42 6 | -XB28.45 3

763-0 | 763-2 | 763-4 | 763-6 | 763-7

762.9 / 0V2 — 0V2 / 764.0

-763A0
750.4

1	5	2	6	3	7	4	8
E99.0	E99.1	E99.2	E99.3	E99.4	E99.5	E99.6	E99.7

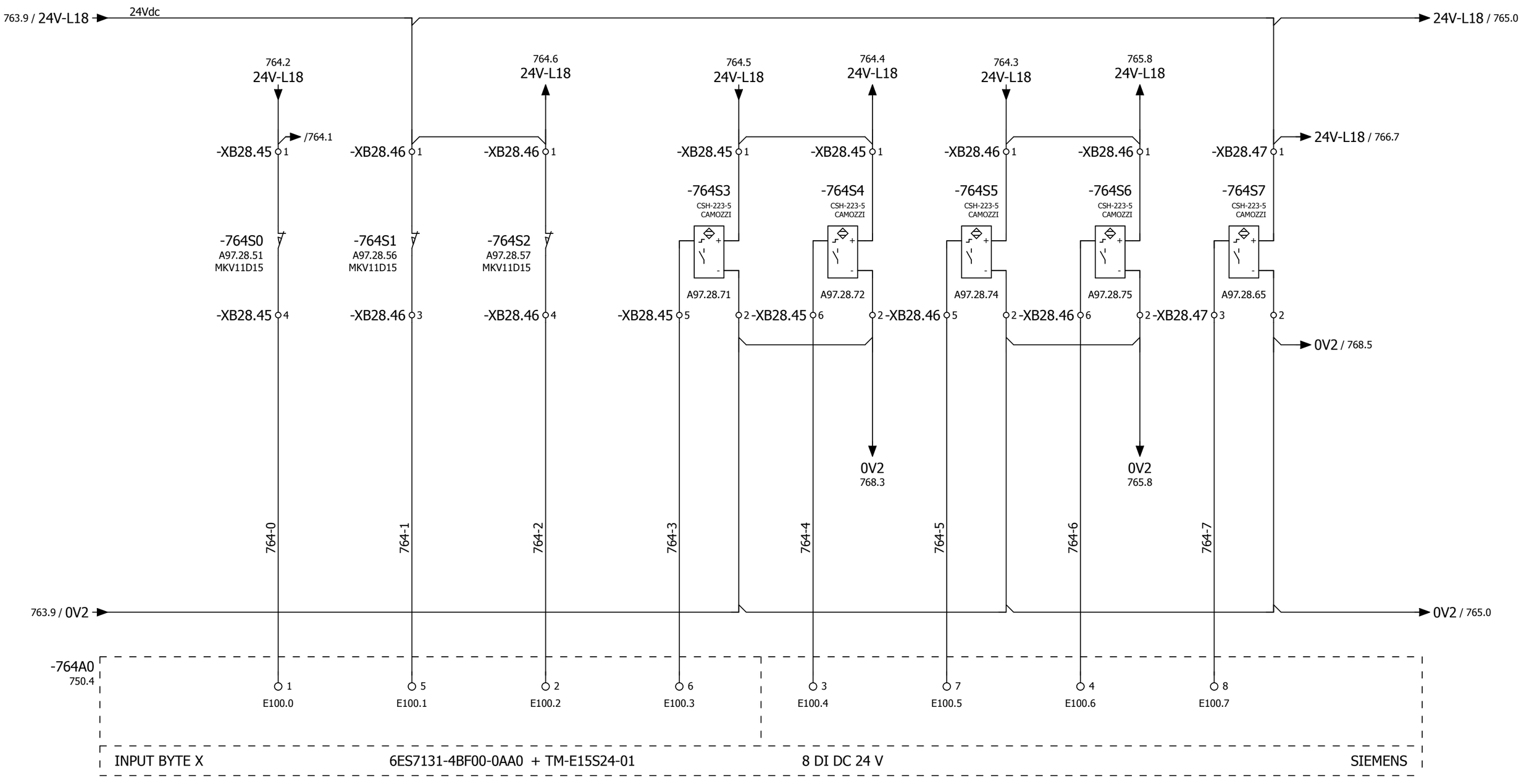
INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

1° AND 2° SHEET CONVEYOR OPERATOR SIDE 1° CHOICE STACKER FROM 1° BOX TO 2° BOX MAX HIGH	SPARE	1° AND 2° SHEET CONVEYOR OPERATOR SIDE 1° CHOICE STACKER FROM 1° BOX TO 2° BOX MAX LOW	SPARE	1° AND 2° SHEET CONVEYOR MOTOR SIDE 1° CHOICE STACKER FROM 1° BOX TO 2° BOX MAX HIGH	SPARE	1° AND 2° SHEET CONVEYOR MOTOR SIDE 1° CHOICE STACKER FROM 1° BOX TO 2° BOX MAX LOW	ANTI COLLISION BETWEEN HEAD MOBILE CARRIAGE OPERATOR SIDE 1° CHOICE STACKER 1° BOX AND REAR MOBILE CARRIAGE OPERATOR SIDE 1° CHOICE STACKER 2° BOX

⇦762

764⇨

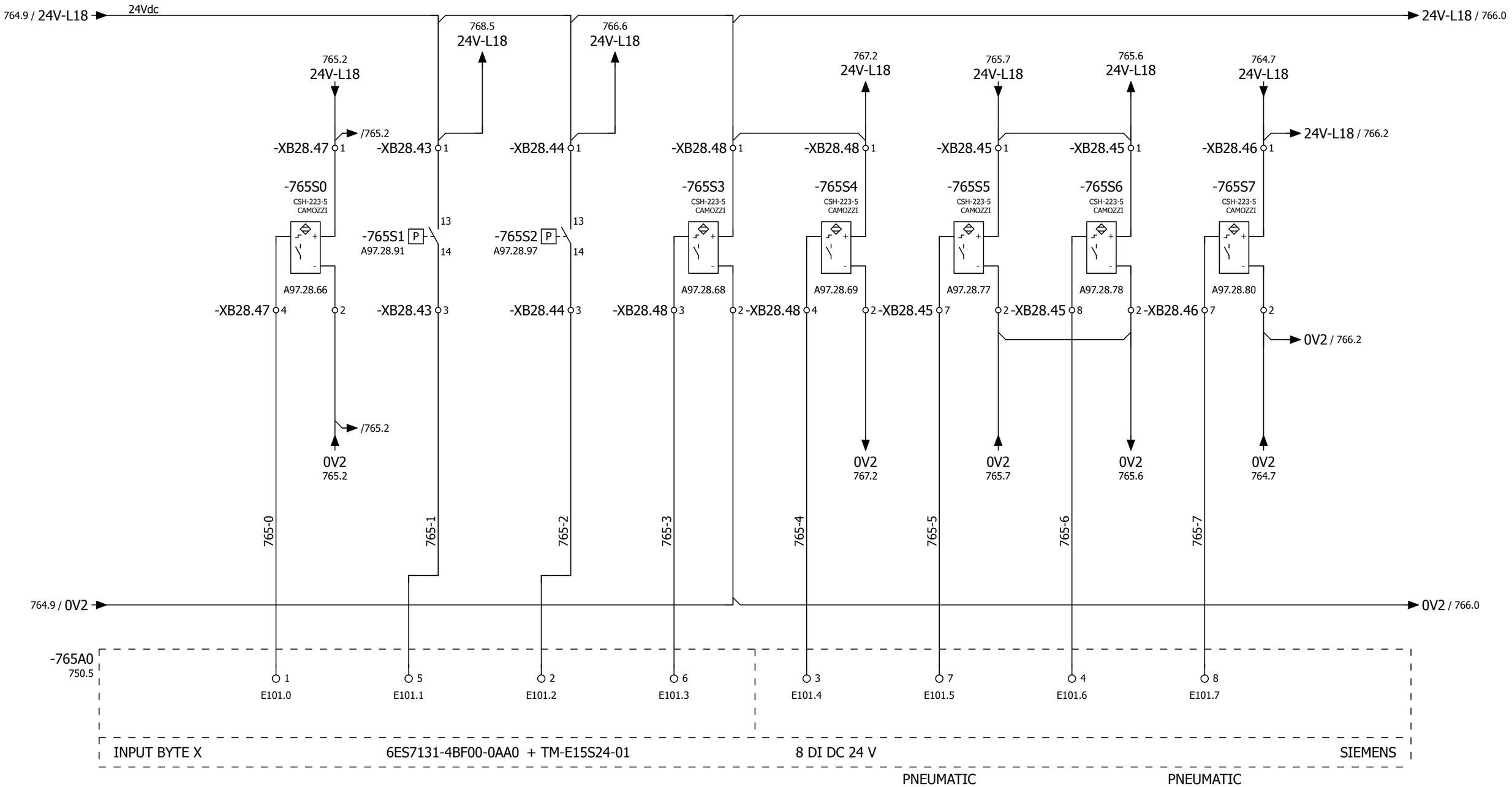
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	763
Revision		Replacement of	Replaced by			Group:	Of 414



⇦763

765⇨

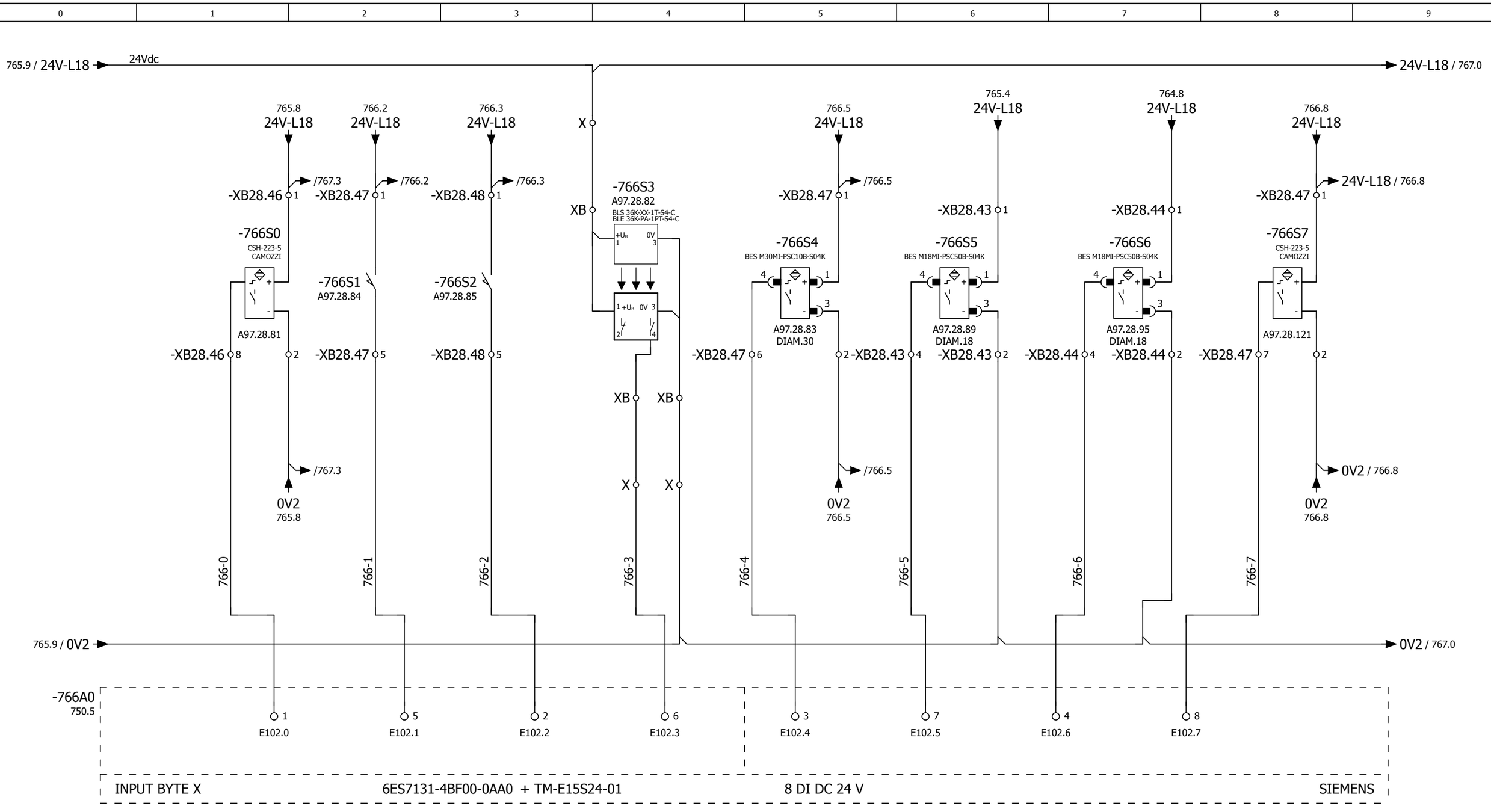
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	764
Revision		Replacement of	Replaced by			Group:	Of 414



⇦764

766⇨

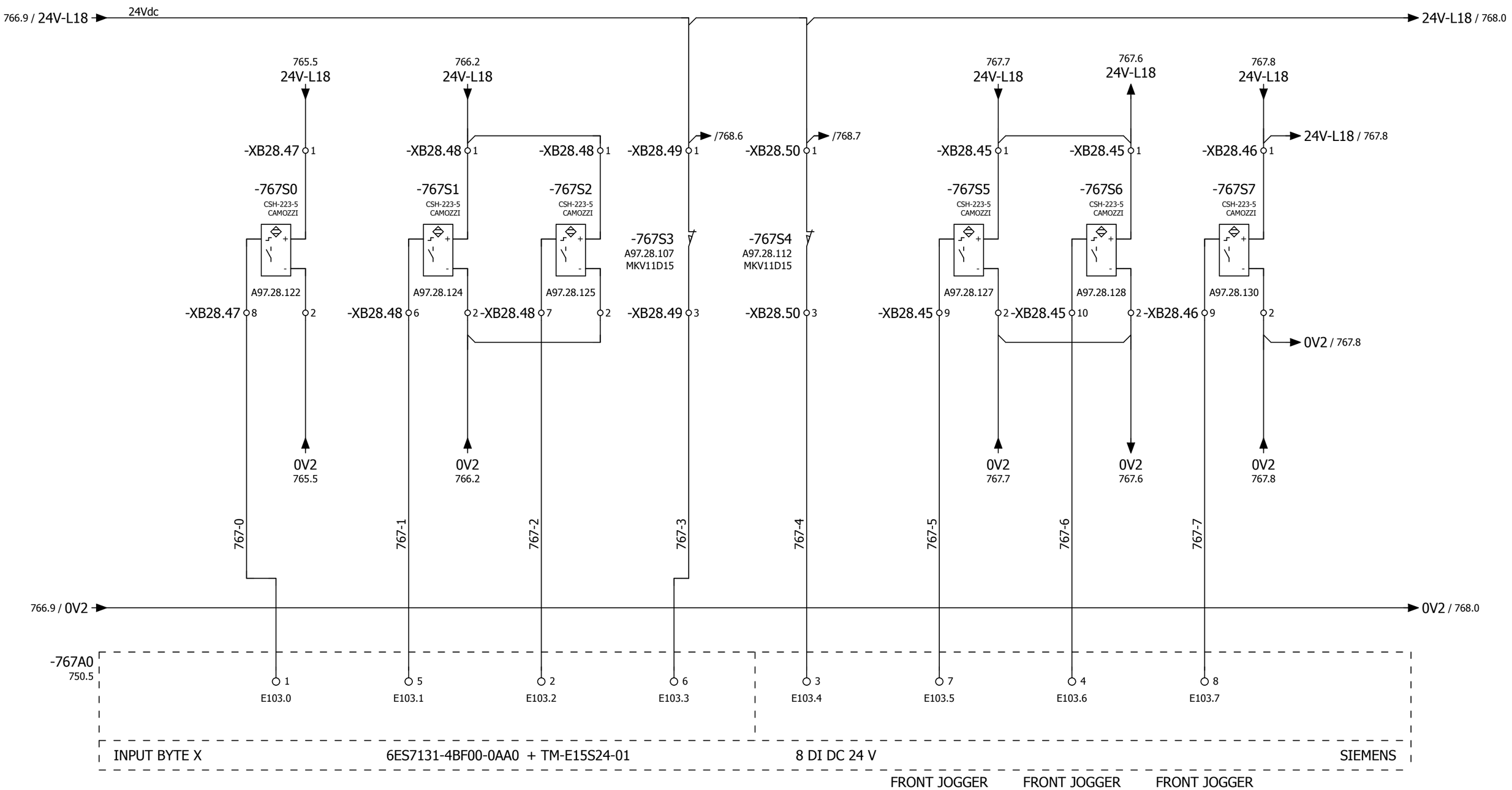
Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	765
Revision			Replacement of / Replaced by			Group: / Of	414



⇦765

767⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	766
Revision		Replacement of	Replaced by			Group:	Of 414



OPERATOR SIDE TAIL FIND 1° CHOICE STACKER 1° BOX IN FOR SHEETS PUSHING AUTOMATIC CONSENT BETWEEN 801 AND 2200mm

MOTOR SIDE TAIL FIND 1° CHOICE STACKER 1° BOX OUT FOR SHEETS PUSHING AUTOMATIC CONSENT BETWEEN 500 AND 800mm

MOTOR SIDE TAIL FIND 1° CHOICE STACKER 1° BOX IN FOR SHEETS PUSHING AUTOMATIC CONSENT BETWEEN 801 AND 2200mm

HEAD MOBILE CARRIAGE OPERATOR SIDE 1° CHOICE STACKER 2° BOX MAX FORWARD

HEAD MOBILE CARRIAGE MOTOR SIDE 1° CHOICE STACKER 2° BOX MAX FORWARD

FRONT JOGGER ON OPERATOR SIDE HEAD MOBILE CARRIAGE 1° CHOICE STACKER 1° BOX OUT FOR SHEETS PUSHING AUTOMATIC CONSENT BETWEEN 500 AND 800mm

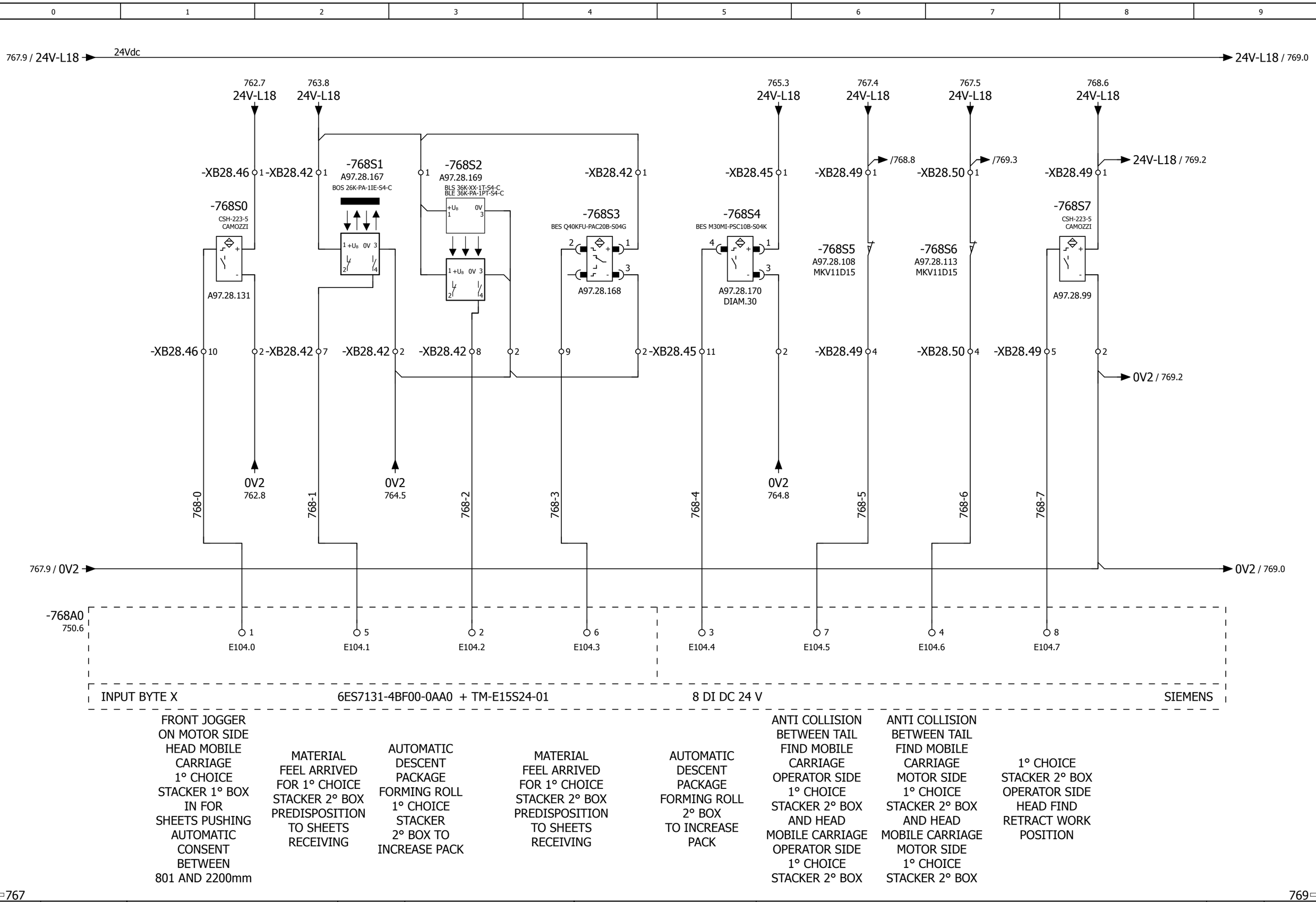
FRONT JOGGER ON OPERATOR SIDE HEAD MOBILE CARRIAGE 1° CHOICE STACKER 1° BOX IN FOR SHEETS PUSHING AUTOMATIC CONSENT BETWEEN 801 AND 2200mm

FRONT JOGGER ON MOTOR SIDE HEAD MOBILE CARRIAGE 1° CHOICE STACKER 1° BOX OUT FOR SHEETS PUSHING AUTOMATIC CONSENT BETWEEN 500 AND 800mm

⇦766

768⇨

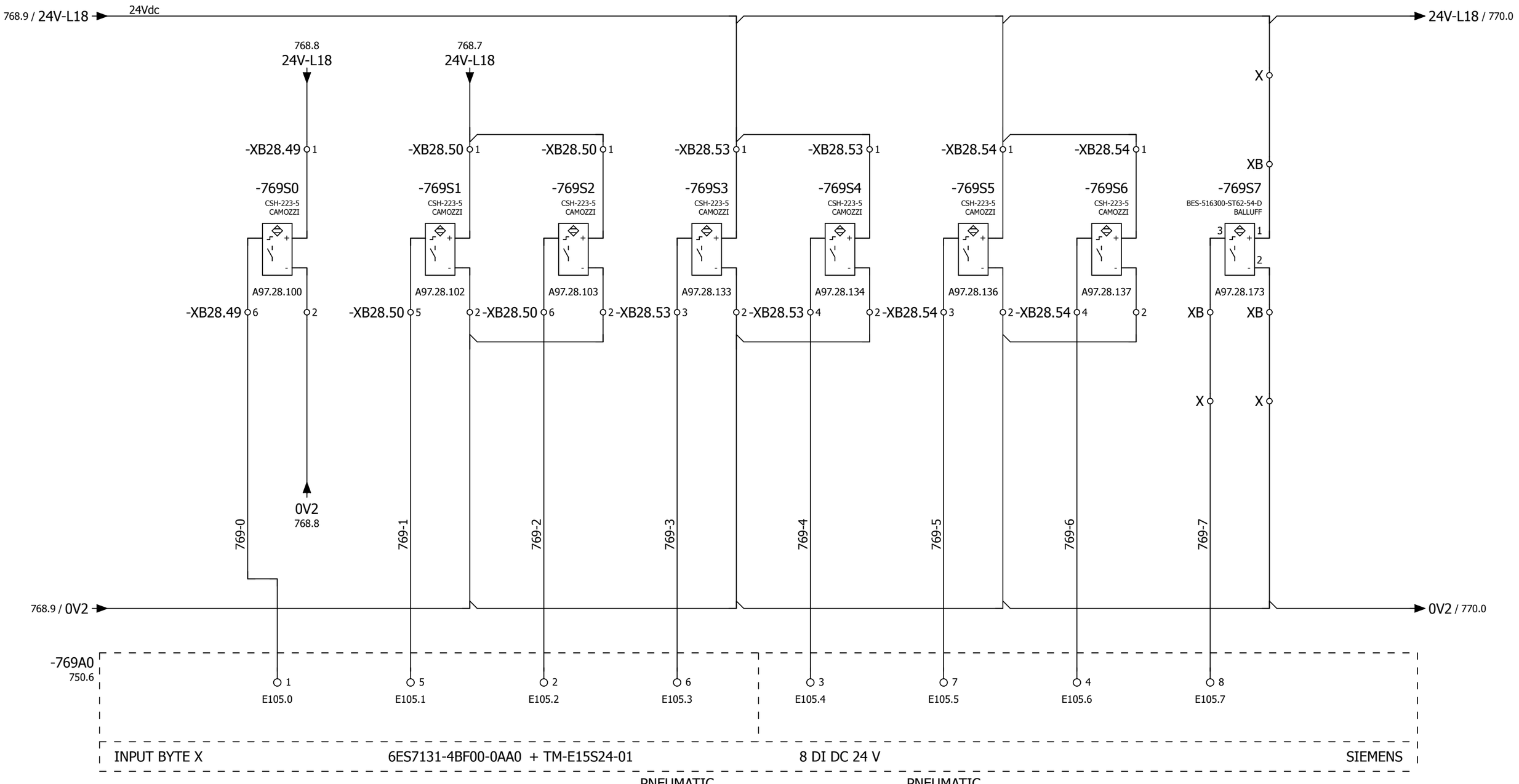
Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	767
Revision		Replacement of	Replaced by			Group:	Of 414



⇦767

769⇨

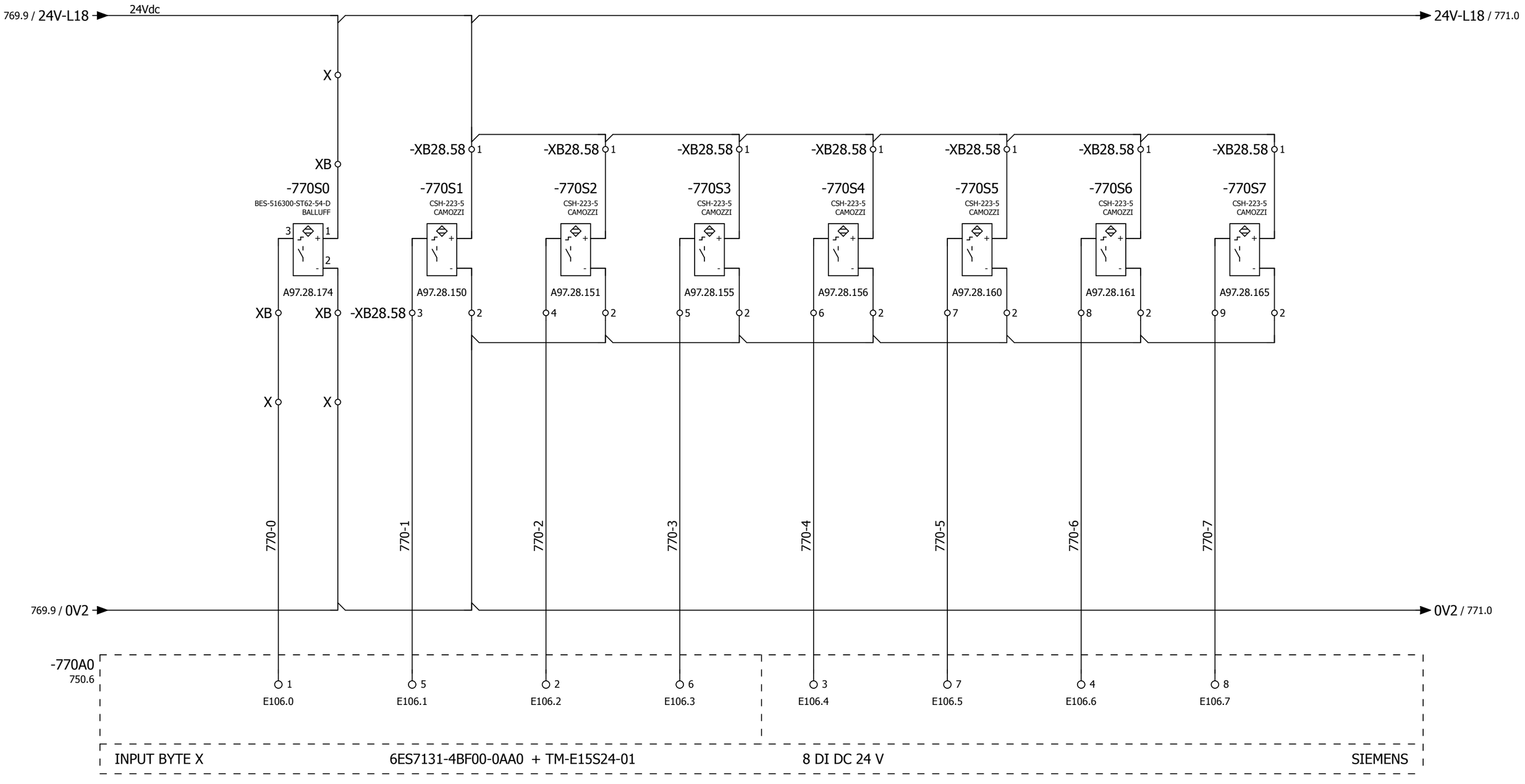
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	768
Revision						Group:	Of 414



⇦768

770⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	769
Revision		Replacement of	Replaced by			Group:	Of 414



SHEETS ASPIRATION CONVEYOR BELT 1° CHOICE STACKER LOW FOR THICKNESS < 2mm	1° ASPIRATION ROOM SHUTTER OPEN FOR ASPIRATION	1° ASPIRATION ROOM SHUTTER CLOSE FOR SHEET FALL	2° ASPIRATION ROOM SHUTTER OPEN FOR ASPIRATION	2° ASPIRATION ROOM SHUTTER CLOSE FOR SHEET FALL	3° ASPIRATION ROOM SHUTTER OPEN FOR ASPIRATION	3° ASPIRATION ROOM SHUTTER CLOSE FOR SHEET FALL	4° ASPIRATION ROOM SHUTTER OPEN FOR ASPIRATION

⇦769

771⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	770
Revision		Replacement of	Replaced by			Group:	Of 414

770.9 / 24V-L18 → 24Vdc

X

XB

-771S0
BES-516300-ST62-54-D
BALLUFF
3 1 2
A97.28.166

XB XB

X X

771-0

770.9 / 0V2 →

-771A0
750.7

1 E107.0
5 E107.1
2 E107.2
6 E107.3
3 E107.4
7 E107.5
4 E107.6
8 E107.7

INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

-X28.4 1 Q28
-XB28.4 1 JB29
-771S5
A97.29.2
FP 531
-XB28.4 3 JB29
-X28.4 3 Q28

771-5

-XB28.4 1 JB29
-771S6
A97.29.3
FP 531
-XB28.4 4 JB29
-X28.4 4 Q28

771-6

-X28.5 1 Q28
-XB28.5 1 JB29/A
-771S7
A97.29.6
FP 531
-XB28.5 3 JB29/A
-X28.5 3 Q28

771-7

24V-L18 / 772.0

24V-L18 / 772.1

0V2 / 772.0

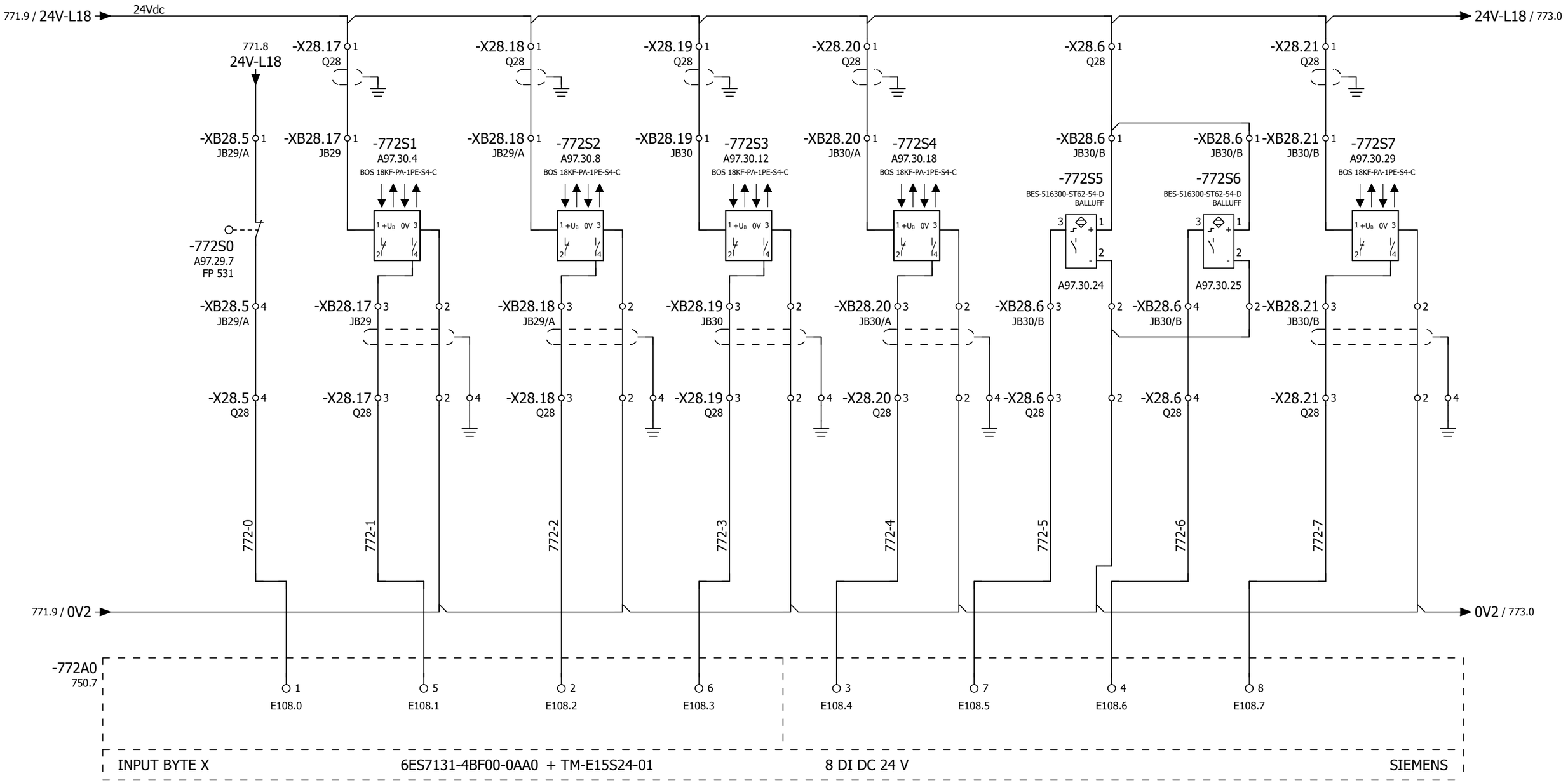
2 2 2

4° ASPIRATION ROOM SHUTTER CLOSE FOR SHEET FALL	SPARE	SPARE
SPARE	SPARE	PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX MAX HIGH
PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX MAX LOW	PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX MAX HIGH	

⇦770

772⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	771
Revision			Replacement of / Replaced by			Group: / Of	414



PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX MAX LOW

EXIT 1° PACKAGE FORMING ROLL TO 187mm TO FIND LOADING PALLET CYCLE STOP

EXIT 2° PACKAGE FORMING ROLL TO 187mm TO FIND LOADING PALLET CYCLE STOP

THE END 1° WEIGHING TRANSFER PLATFORM TO 187mm TO FIND PACKAGE WIDTH CONTROL FOR PACKAGE IN THE MIDDLE POSITION 1° COMBINED DOWNLOAD TRANSFER PLATFROM 1° CHOICE STACKER 1° BOX

THE END 2° WEIGHING TRANSFER PLATFORM TO 187mm TO FIND PACKAGE WIDTH CONTROL FOR PACKAGE IN THE MIDDLE POSITION 2° COMBINED DOWNLOAD TRANSFER PLATFROM 1° CHOICE STACKER 2° BOX

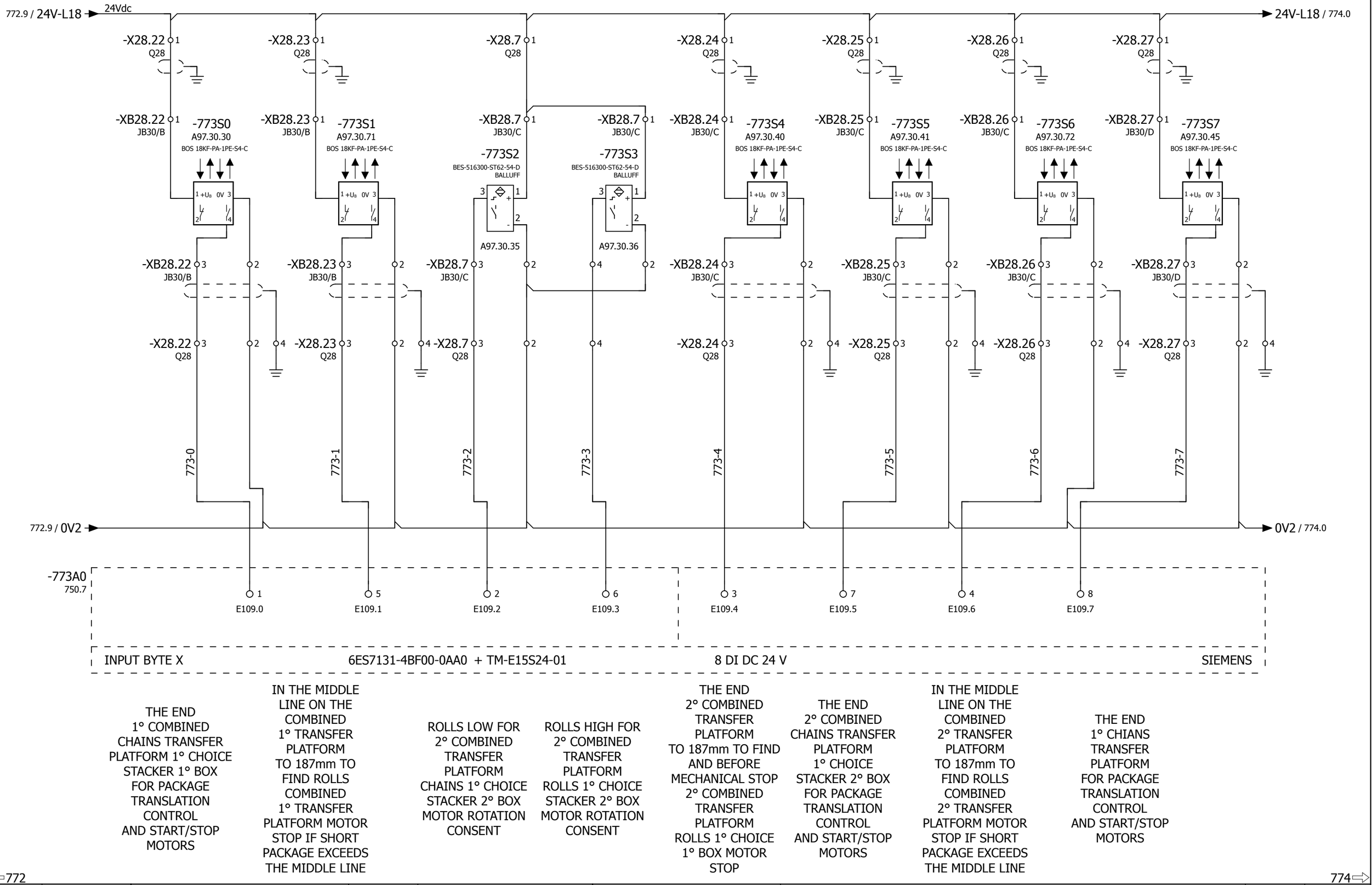
ROLLS LOW FOR 1° COMBINED TRANSFER PLATFORM CHAINS 1° CHOICE STACKER 1° BOX MOTOR ROTATION CONSENT

ROLLS HIGH FOR 1° COMBINED TRANSFER PLATFORM ROLLS 1° CHOICE STACKER 1° BOX MOTOR ROTATION CONSENT

THE END 1° COMBINED TRANSFER PLATFORM TO 187mm TO FIND AND BEFORE MECHANICAL STOP 1° COMBINED TRANSFER PLATFORM ROLLS 1° CHOICE 1° BOX MOTOR STOP

⇦771
773⇨

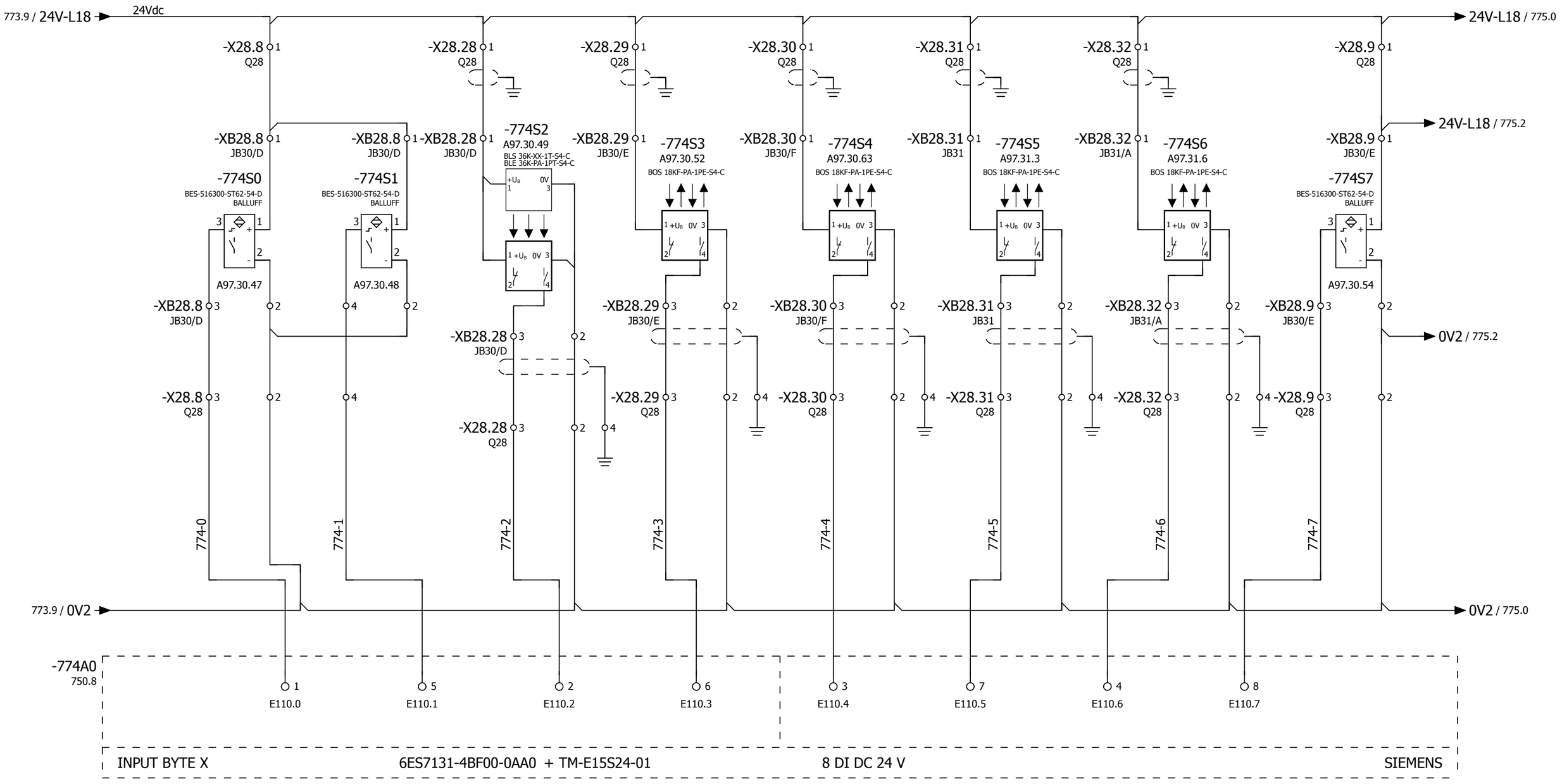
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	772
Revision			Replacement of / Replaced by			Group: / Of	414



⇦772

774⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	773
Revision						Group:	Of 414



JUNCTION LEVERS FOR PACKAGE ADVANCE CONSENT HIGH

JUNCTION LEVERS FOR STRAPPING CONSENT LOW

POSITIONING TO ...mm FROM CHAIN TURN ROLL FEEL PACKAGE OR WOOD HEAD ARRIVED

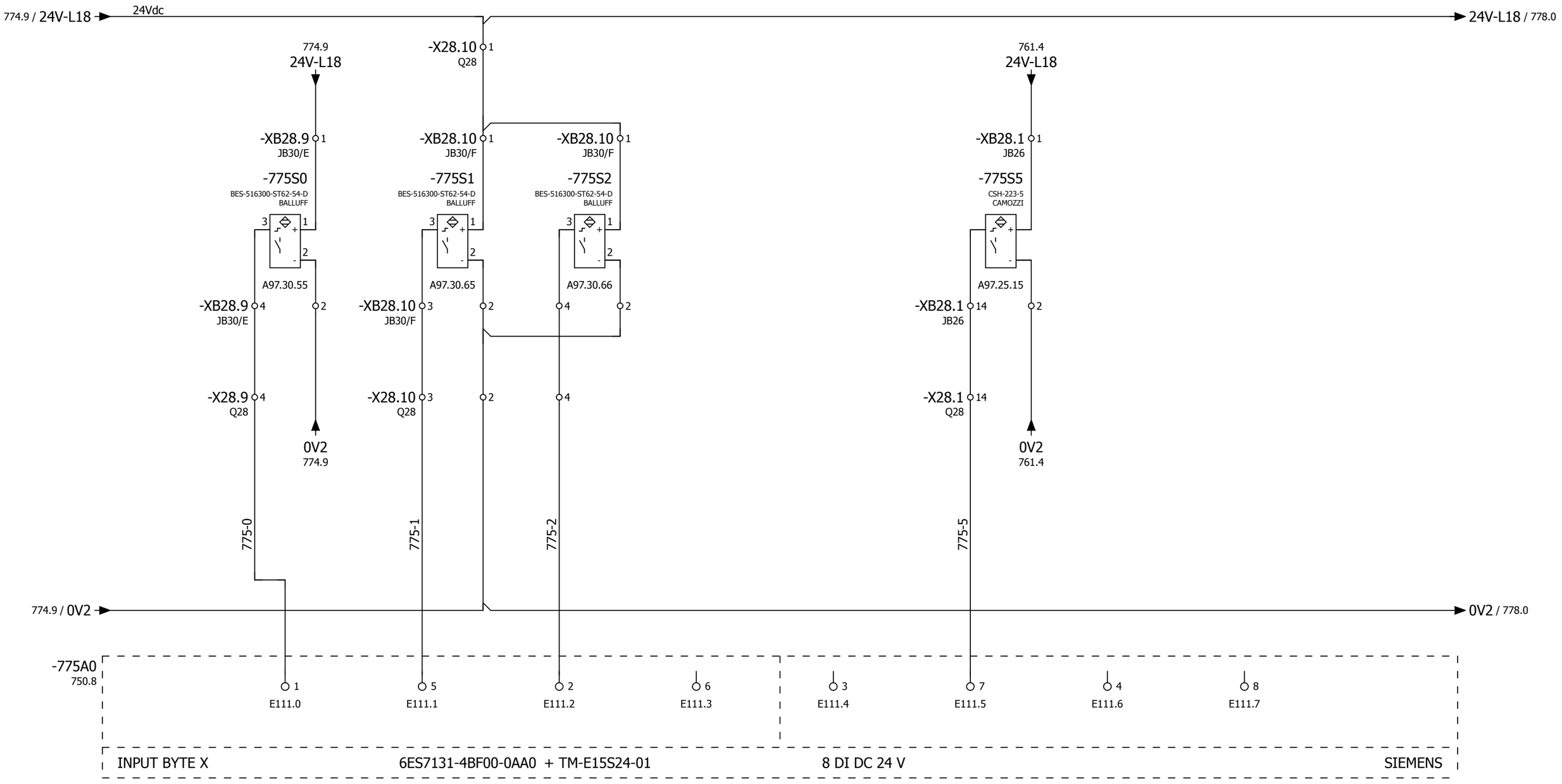
THE END 1° COMBINED CHAINS TRANSFER PLATFORM AFTER STRAPPING MACHINE FOR PACKAGE TRANSLATION CONTROL AND START/STOP MOTORS

THE END 2° COMBINED CHAINS TRANSFER PLATFORM AFTER STRAPPING MACHINE FOR PACKAGE TRANSLATION CONTROL AND START/STOP MOTORS

THE END 1° PALLET LOADING TRANSFER PLATFORM TO 187mm TO FIND AND ...mm TO LINE CENTRE PALLET WIDTH CONTROL FOR PACKAGE FORMING TRANSFER PLATFORM IN THE MIDDLE

THE END 2° PALLET LOADING TRANSFER PLATFORM TO 187mm TO FIND AND ...mm TO LINE CENTRE PALLET WIDTH CONTROL FOR PACKAGE FORMING TRANSFER PLATFORM IN THE MIDDLE

CHAINS LOW FOR COMBINED 1° TRANSFER PLATFORM MOTOR ROTATION CONSENT AFTER ROLLS STRAPPING MACHINE

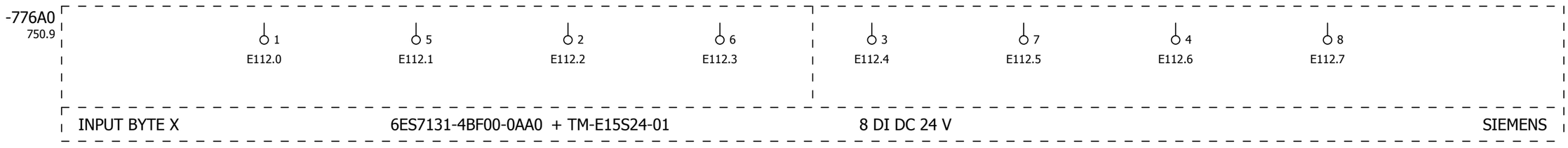


CHAINS HIGH FOR COMBINED 1° TRANSFER PLATFORM MOTOR ROTATION CONSENT AFTER CHAINS STRAPPING MACHINE	CHAINS LOW FOR COMBINED 2° TRANSFER PLATFORM MOTOR ROTATION CONSENT AFTER ROLLS STRAPPING MACHINE	CHAINS HIGH FOR COMBINED 2° TRANSFER PLATFORM MOTOR ROTATION CONSENT AFTER CHAINS STRAPPING MACHINE	SPARE	SPARE	1° FEEDING PINCH ROLL LOW FOR UP/DOWN 2° CONVEYOR BELT CONSENT	SPARE	SPARE

⇦774

776⇨

0	1	2	3	4	5	6	7	8	9

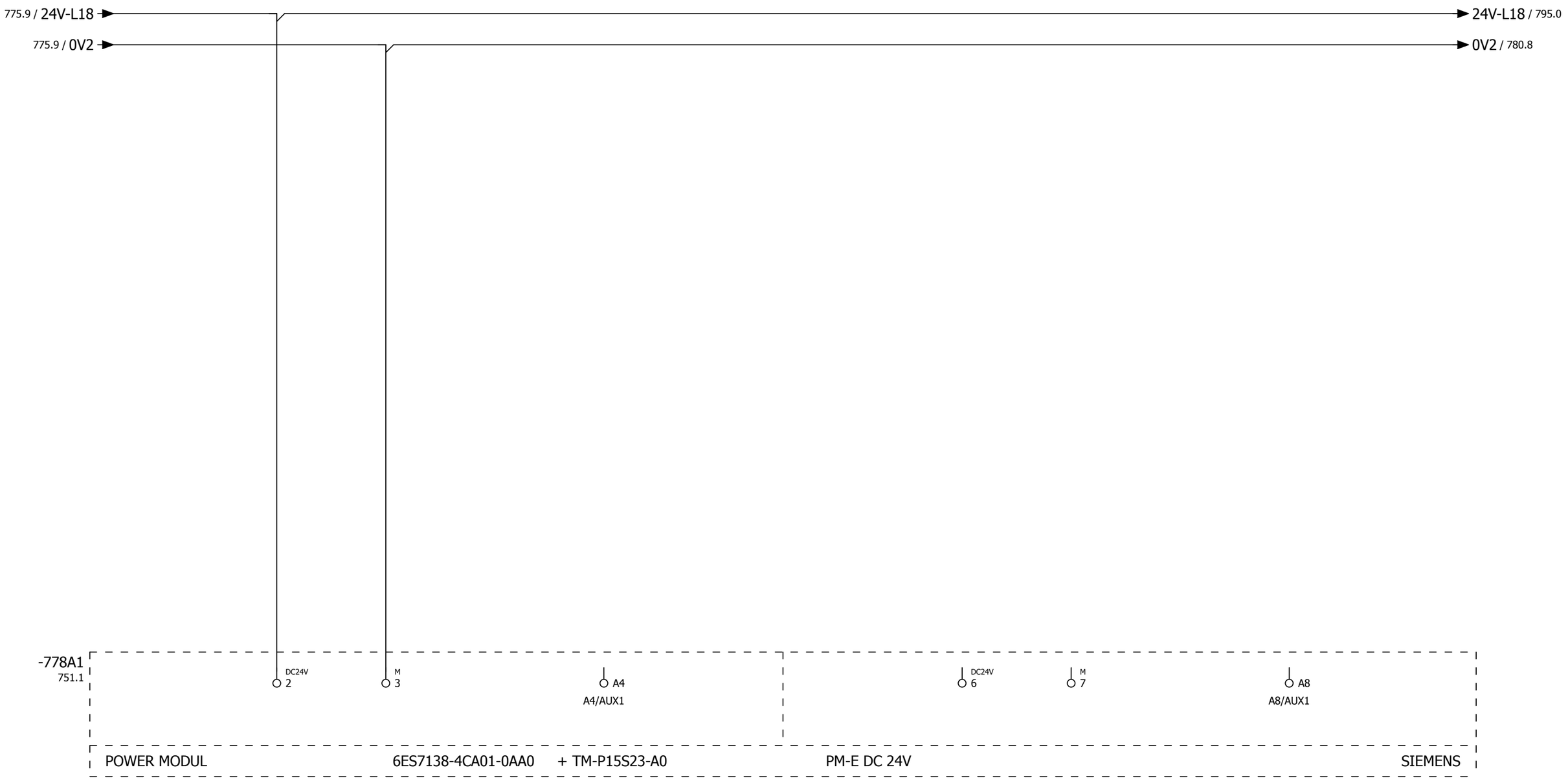


SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

⇦775

778⇨

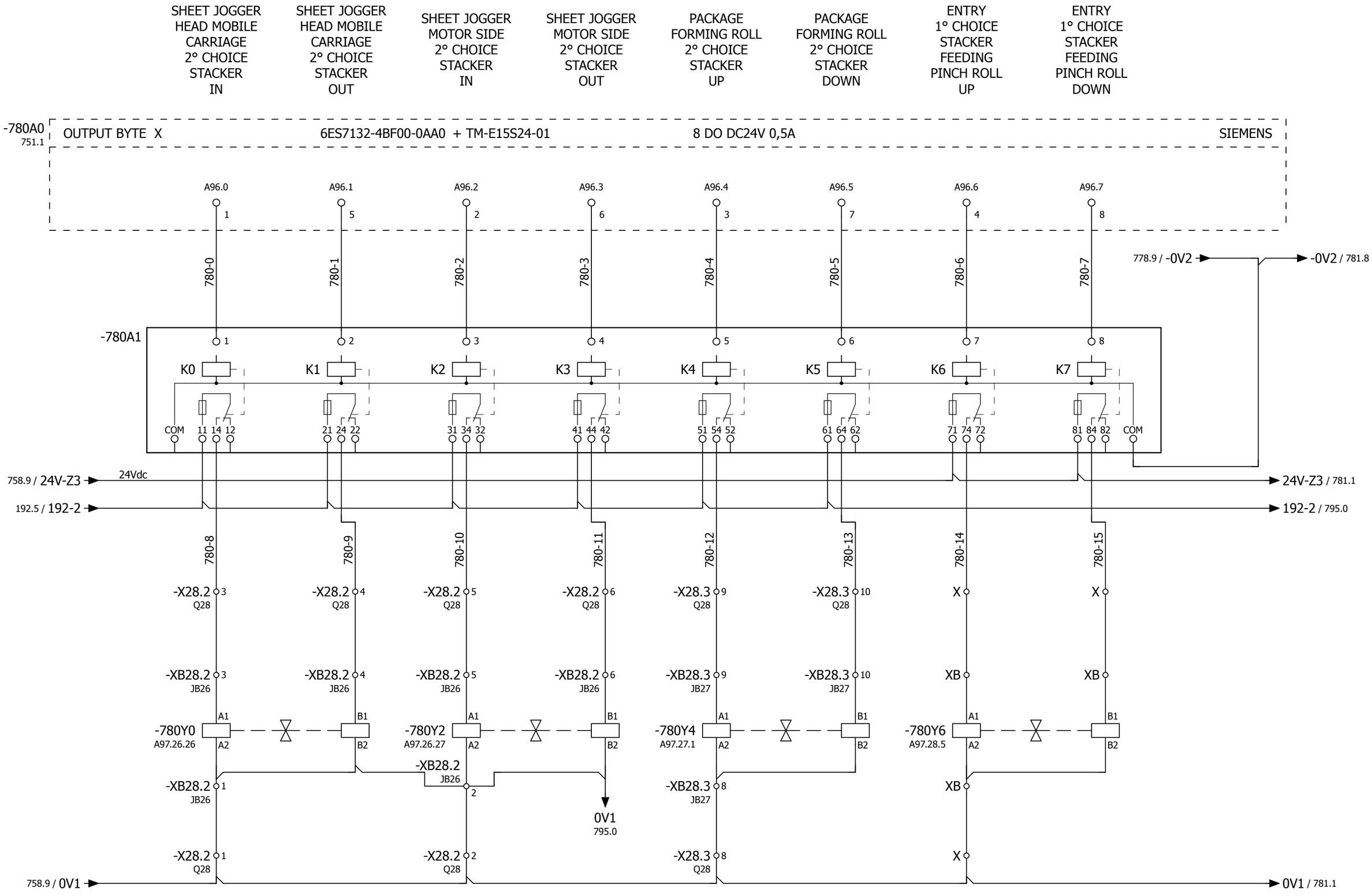
Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	776
Revision			Replacement of / Replaced by			Group: / Of	414



⇦776

780⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul stackers and transfer platform box		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	778
Revision		Replacement of	Replaced by			Group:	Of 414



778

781

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 780
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

SHEETS SUPPORT ROTATION 1° CHOICE STACKER 1° BOX OPERATOR SIDE PARKING BRAKE

SHEETS SUPPORT ROTATION 1° CHOICE STACKER 1° BOX MOTOR SIDE PARKING BRAKE

REAR JOGGER OPERATOR SIDE 1° CHOICE STACKER 1 BOX IN

REAR JOGGER OPERATOR SIDE 1° CHOICE STACKER 1 BOX OUT

REAR JOGGER MOTOR SIDE 1° CHOICE STACKER 1 BOX IN

REAR JOGGER MOTOR SIDE 1° CHOICE STACKER 1 BOX OUT

FRONT JOGGER ON OPERATOR SIDE MOBILE CARRIAGE 1° CHOICE STACKER 1° BOX IN

FRONT JOGGER ON OPERATOR SIDE MOBILE CARRIAGE 1° CHOICE STACKER 1° BOX OUT

-781A0
751.1

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A97.0 1 — 781-0
A97.1 5 — 781-1
A97.2 2 — 781-2
A97.3 6 — 781-3
A97.4 3 — 781-4
A97.5 7 — 781-5
A97.6 4 — 781-6
A97.7 8 — 781-7

780.9 / -0V2 → -0V2 / 782.8

-781A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

780.9 / 24V-Z3 → 24Vdc → 24V-Z3 / 782.1

195.4 / 24V-Z13 → 24V-Z13 / 783.1

781-8 — 781-9 — 781-10 — 781-11 — 781-12 — 781-13 — 781-14 — 781-15

-XB28.41 10	-XB28.42 13	-XB28.47 12	-XB28.47 13	-XB28.48 11	-XB28.48 12	-XB28.45 17	-XB28.45 18
-781Y0 A97.28.24	-781Y1 A97.28.30	-781Y2 A97.28.58		-781Y4 A97.28.59		-781Y6 A97.28.60	
x1 / x2	x1 / x2	A1 / A2	B1 / B2	A1 / A2	B1 / B2	A1 / A2	B1 / B2
-XB28.41 9	-XB28.42 12	-XB28.47 10		-XB28.48 9		-XB28.45 15	

0V1 / 790.7

0V1 782.6

0V1 786.5

780.9 / 0V1 → 0V1 / 782.1

⇦780 782⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output	=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97			Installation: Linea taglio trasversale	Page 781
Revision			Replacement of	Replaced by			Group: Of 414

0	1	2	3	4	5	6	7	8	9

FRONT JOGGER ON MOTOR SIDE MOBILE CARRIAGE 1° CHOICE STACKER 1° BOX IN

FRONT JOGGER ON MOTOR SIDE MOBILE CARRIAGE 1° CHOICE STACKER 1° BOX OUT

HEAD SHEET PUSHER ON MOBILE CARRIAGE OPERATOR SIDE 1° CHOICE STACKER 1° BOX IN

HEAD SHEET PUSHER ON MOBILE CARRIAGE OPERATOR SIDE 1° CHOICE STACKER 1° BOX OUT

HEAD SHEET PUSHER ON MOBILE CARRIAGE MOTOR SIDE 1° CHOICE STACKER 1° BOX IN

HEAD SHEET PUSHER ON MOBILE CARRIAGE MOTOR SIDE 1° CHOICE STACKER 1° BOX OUT

REAR JOGGER LATERAL STROKE OPERATOR SIDE 1° CHOICE STACKER 1° BOX LIMITER IN

REAR JOGGER LATERAL STROKE OPERATOR SIDE 1° CHOICE STACKER 1° BOX LIMITER OUT

-782A0
751.2
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A98.0 1 — 782-0
A98.1 5 — 782-1
A98.2 2 — 782-2
A98.3 6 — 782-3
A98.4 3 — 782-4
A98.5 7 — 782-5
A98.6 4 — 782-6
A98.7 8 — 782-7

781.9 / -0V2 → -0V2 / 783.8

-782A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

781.9 / 24V-Z3 → 24Vdc
24V-Z3 / 783.1

782-8 782-9 782-10 782-11 782-12 782-13 782-14 782-15

-XB28.46 17 — -XB28.46 18 — -782Y0 A97.28.61 — 0V1 782.5
-XB28.45 19 — -XB28.45 20 — -782Y2 A97.28.62 — 0V1 782.3
-XB28.46 19 — -XB28.46 20 — -782Y4 A97.28.63 — 0V1 782.2 / 0V1 781.4
-XB28.47 14 — -XB28.47 15 — -782Y6 A97.28.64 — 0V1 782.8 / 0V1 782.7

-XB28.46 15
-XB28.45 16
782.4 / 0V1 →

781.9 / 0V1 → 0V1 / 783.1

⇦781
783⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 782
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

REAR JOGGER LATERAL STROKE MOTOR SIDE 1° CHOICE STACKER 1° BOX LIMITER IN

REAR JOGGER LATERAL STROKE MOTOR SIDE 1° CHOICE STACKER 1° BOX LIMITER OUT

PNEUMATIC CILINDER OPERATOR SIDE TRANSLATION HEAD PUSHER 1° CHOICE STACKER 1° BOX IN

PNEUMATIC CILINDER OPERATOR SIDE TRANSLATION HEAD PUSHER 1° CHOICE STACKER 1° BOX OUT

PNEUMATIC CILINDER MOTOR SIDE TRANSLATION HEAD PUSHER 1° CHOICE STACKER 1° BOX IN

PNEUMATIC CILINDER MOTOR SIDE TRANSLATION HEAD PUSHER 1° CHOICE STACKER 1° BOX OUT

SHEETS SUPPORT ROTATION 1° CHOICE STACKER 2° BOX OPERATOR SIDE PARKING BRAKE

SHEETS SUPPORT ROTATION 1° CHOICE STACKER 2° BOX MOTOR SIDE PARKING BRAKE

-783A0
751.2
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A99.0 1 — 783-0
A99.1 5 — 783-1
A99.2 2 — 783-2
A99.3 6 — 783-3
A99.4 3 — 783-4
A99.5 7 — 783-5
A99.6 4 — 783-6
A99.7 8 — 783-7

782.9 / -0V2 → -0V2 / 784.8

-783A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

782.9 / 24V-Z3 → 24Vdc
781.9 / 24V-Z13 →

783-8 783-9 783-10 783-11 783-12 783-13 783-14 783-15

-XB28.48 13 — -XB28.48 14
-XB28.45 21 — -XB28.45 22
-XB28.46 21 — -XB28.46 22
-XB28.43 11
-XB28.44 11

-783Y0 A97.28.67 A1 A2 B1 B2
-783Y2 A97.28.76 A1 A2 B1 B2
-783Y4 A97.28.79 A1 A2 B1 B2
-783Y6 A97.28.90 x1 x2
-783Y7 A97.28.96 x1 x2

-XB28.46 16 ← 783.3 / 0V1
-XB28.43 10
-XB28.44 10

0V1 783.2
0V1 783.2
0V1 783.5

782.9 / 0V1 →

24V-Z3 / 784.1
24V-Z13 / 785.1
0V1 / 784.1

⇦782
784⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 783
Revision			Replacement of / Replaced by			Group:	Of 414

1	2	3	4	5	6	7	8
PNEUMATIC CILINDER OPERATOR SIDE TRANSLATION HEAD FIND 1° CHOICE STACKER 2° BOX IN	PNEUMATIC CILINDER OPERATOR SIDE TRANSLATION HEAD FIND 1° CHOICE STACKER 2° BOX OUT	HEAD MOBILE CARRIAGE SHEET BUMPER OPERATOR SIDE 1° CHOICE STACKER 2° BOX OUT	HEAD MOBILE CARRIAGE SHEET BUMPER MOTOR SIDE 1° CHOICE STACKER 2° BOX OUT	PNEUMATIC CILINDER MOTOR SIDE TRANSLATION HEAD FIND 1° CHOICE STACKER 2° BOX IN	PNEUMATIC CILINDER MOTOR SIDE TRANSLATION HEAD FIND 1° CHOICE STACKER 2° BOX OUT	TAIL FIND LATERAL SHEET PUSHER OPERATOR SIDE 1° CHOICE STACKER 2° BOX IN	TAIL FIND LATERAL SHEET PUSHER OPERATOR SIDE 1° CHOICE STACKER 2° BOX OUT

-784A0
751.2
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A100.0 1 — 784-0
A100.1 5 — 784-1
A100.2 2 — 784-2
A100.3 6 — 784-3
A100.4 3 — 784-4
A100.5 7 — 784-5
A100.6 4 — 784-6
A100.7 8 — 784-7

783.9 / -0V2 → -0V2 / 785.8

-784A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

783.9 / 24V-Z3 → 24Vdc
24V-Z3 / 785.1

784-8 784-9 784-10 784-11 784-12 784-13 784-14 784-15

-XB28.49 11 — A1 -784Y0 A2 (A97.28.98) — B1 -XB28.49 12
-XB28.49 13 — x1 -784Y2 x2 (A97.28.139)
-XB28.50 11 — x1 -784Y3 x2 (A97.28.142)
-XB28.50 12 — A1 -784Y4 A2 (A97.28.101) — B1 -XB28.50 13
-XB28.53 11 — A1 -784Y6 A2 (A97.28.114) — B1 -XB28.53 12

-XB28.49 9
-XB28.50 9
-XB28.53 9

0V1 786.6
0V1 786.2
0V1 786.3

783.9 / 0V1 → 0V1 / 785.1

⇦783
785⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 784
Revision			Replacement of / Replaced by			Group:	Of 414

TAIL FIND LATERAL SHEET PUSHER MOTOR SIDE 1° CHOICE STACKER 1° BOX IN	TAIL FIND LATERAL SHEET PUSHER MOTOR SIDE 1° CHOICE STACKER 1° BOX OUT	FRONT JOGGER ON OPERATOR SIDE HEAD MOBILE CARRIAGE 1° CHOICE STACKER 2° BOX IN	FRONT JOGGER ON OPERATOR SIDE HEAD MOBILE CARRIAGE 1° CHOICE STACKER 2° BOX OUT	AUTOMATIC LINE IN FUNCTION BLINKER	WARNING SIREN AUTOMATIC STARTING LINE	FRONT JOGGER ON MOTOR SIDE HEAD MOBILE CARRIAGE 1° CHOICE STACKER 2° BOX IN	FRONT JOGGER ON MOTOR SIDE HEAD MOBILE CARRIAGE 1° CHOICE STACKER 2° BOX OUT

-785A0 751.3 — OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A101.0 1 | A101.1 5 | A101.2 2 | A101.3 6 | A101.4 3 | A101.5 7 | A101.6 4 | A101.7 8

785-0 | 785-1 | 785-2 | 785-3 | 785-4 | 785-5 | 785-6 | 785-7

784.9 / -0V2 → -0V2 / 786.8

-785A1: 1 2 3 4 5 6 7 8

K0 K1 K2 K3 K4 K5 K6 K7

COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

784.9 / 24V-Z3 → 24Vdc → 24V-Z3 / 786.1

783.9 / 24V-Z13 → 24V-Z13 / 795.0

785-8 | 785-9 | 785-10 | 785-11 | 785-12 | 785-13 | 785-14 | 785-15

X | X

XB | XB

-XB28.54 10 | -XB28.54 11 | -XB28.49 14 | -XB28.49 15 | -XB28.50 14 | -XB28.50 15

-785Y0 A97.28.115 (A1 A2 B1 B2) | -785Y2 A97.28.116 (A1 A2 B1 B2) | -785H4 A97.28.171 (x1 x2) | -785H5 A97.28.172 (x1 x2) | -785Y6 A97.28.117 (A1 A2 B1 B2)

-XB28.54 8

-XB28.49 10 ← 785.4 / 0V1

-XB28.50 10 ← 785.8 / 0V1

0V1 789.8 | 0V1 785.3 | 0V1 785.6

784.9 / 0V1 → 0V1 / 786.1

⇦784

786⇨

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	785
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

HEAD SHEET PUSHER ON HEAD MOBILE CARRIAGE OPERATOR SIDE 1° CHOICE STACKER 2° BOX IN

HEAD SHEET PUSHER ON HEAD MOBILE CARRIAGE OPERATOR SIDE 1° CHOICE STACKER 2° BOX OUT

HEAD SHEET PUSHER ON HEAD MOBILE CARRIAGE MOTOR SIDE 1° CHOICE STACKER 2° BOX IN

HEAD SHEET PUSHER ON HEAD MOBILE CARRIAGE MOTOR SIDE 1° CHOICE STACKER 2° BOX OUT

TAIL FIND LATERAL STROKE OPERATOR SIDE 1° CHOICE STACKER 1° BOX LIMITER IN

TAIL FIND LATERAL STROKE OPERATOR SIDE 1° CHOICE STACKER 1° BOX LIMITER OUT

TAIL FIND LATERAL STROKE MOTOR SIDE 1° CHOICE STACKER 1° BOX LIMITER IN

TAIL FIND LATERAL STROKE MOTOR SIDE 1° CHOICE STACKER 1° BOX LIMITER OUT

-786A0
751.3

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A102.0 1 — 786-0
A102.1 5 — 786-1
A102.2 2 — 786-2
A102.3 6 — 786-3
A102.4 3 — 786-4
A102.5 7 — 786-5
A102.6 4 — 786-6
A102.7 8 — 786-7

785.9 / -0V2 → -0V2 / 787.8

-786A1

	1	2	3	4	5	6	7	8
	K0	K1	K2	K3	K4	K5	K6	K7
	COM 11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

785.9 / 24V-Z3 → 24Vdc → 24V-Z3 / 787.1

786-8 — -XB28.49 16 — -786Y0 A97.28.118 A1/A2 — 0V1 784.6
786-9 — -XB28.49 17 — -786Y0 B1/B2
786-10 — -XB28.50 16 — -786Y2 A97.28.119 A1/A2 — 0V1 784.8
786-11 — -XB28.50 17 — -786Y2 B1/B2
786-12 — -XB28.47 16 — -786Y4 A97.28.120 A1/A2 — -XB28.47 11 — 781.6 / 0V1
786-13 — -XB28.47 17 — -786Y4 B1/B2
786-14 — -XB28.48 15 — -786Y6 A97.28.123 A1/A2 — -XB28.48 10 — 784.3 / 0V1
786-15 — -XB28.48 16 — -786Y6 B1/B2

785.9 / 0V1 → 0V1 / 787.1

⇦785
787⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	786
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PNEUMATIC CILINDER OPERATOR SIDE TRANSLATION TAIL FIND 1°CHOICE STACKER 2° BOX IN

PNEUMATIC CILINDER OPERATOR SIDE TRANSLATION TAIL FIND 1° CHOICE STACKER 2° BOX OUT

PNEUMATIC CILINDER MOTOR SIDE TRANSLATION TAIL FIND 1° CHOICE STACKER 2° BOX IN

PNEUMATIC CILINDER MOTOR SIDE TRANSLATION TAIL FIND 1° CHOICE STACKER 2° BOX OUT

PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX UP

PACKAGE FORMING ROLL 1° CHOICE STACKER 1° BOX DOWN

PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX UP

PACKAGE FORMING ROLL 1° CHOICE STACKER 2° BOX DOWN

-787A0
751.4
OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A103.0 1 — 787-0
A103.1 5 — 787-1
A103.2 2 — 787-2
A103.3 6 — 787-3
A103.4 3 — 787-4
A103.5 7 — 787-5
A103.6 4 — 787-6
A103.7 8 — 787-7

786.9 / -0V2 → -0V2 / 788.8

-787A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 — 21 24 22 — 31 34 32 — 41 44 42 — 51 54 52 — 61 64 62 — 71 74 72 — 81 84 82 COM

786.9 / 24V-Z3 → 24Vdc
24V-Z3 / 788.1

787-8 787-9 787-10 787-11 787-12 787-13 787-14 787-15

-X28.4 9 Q28 — -X28.4 10 Q28 — -X28.5 9 Q28 — -X28.5 10 Q28

-XB28.53 13 — -XB28.53 14 — -XB28.54 12 — -XB28.54 13
-XB28.4 9 JB29 — -XB28.4 10 JB29 — -XB28.5 9 JB29/A — -XB28.5 10 JB29/A

-787Y0 A97.28.132 — -787Y2 A97.28.135 — -787Y4 A97.29.1 — -787Y6 A97.29.5
A1 A2 B1 B2

-XB28.53 10 — -XB28.54 9 — -XB28.4 8 JB29 — -XB28.5 8 JB29/A

787.3 / 0V1 → 787.1 / 0V1 →

-X28.4 8 Q28 — -X28.5 8 Q28

786.9 / 0V1 → 0V1 / 788.1

⇦786
788⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 787
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COMBINED 1° TRANSFERT PLATFORM 1° CHOICE STACKER 1° BOX ROLLS LIFTING UP	COMBINED 1° TRANSFERT PLATFORM 1° CHOICE STACKER 1° BOX ROLLS LIFTING DOWN	COMBINED 2° TRANSFERT PLATFORM 1° CHOICE STACKER 2° BOX ROLLS LIFTING UP	COMBINED 2° TRANSFERT PLATFORM 1° CHOICE STACKER 2° BOX ROLLS LIFTING DOWN	JUNCTION LEVERS THE END 1 TRANSFER PLATFORM CHAINS TRANSFER BEFORE STRAPPING MACHINE CLOCKWISE	JUNCTION LEVERS THE END 1 TRANSFER PLATFORM CHAINS TRANSFER BEFORE STRAPPING MACHINE ANTICLOCKWISE	COMBINED TRANSFERT 1° TRANSFERT PLATFORM CHAINS LIFTING AFTER STAPPING MACHINE UP	COMBINED TRANSFERT 1° TRANSFERT PLATFORM CHAINS LIFTING AFTER STAPPING MACHINE DOWN

-788A0 751.4 — OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A104.0 1 — A104.1 5 — A104.2 2 — A104.3 6 — A104.4 3 — A104.5 7 — A104.6 4 — A104.7 8

788-0 — 788-1 — 788-2 — 788-3 — 788-4 — 788-5 — 788-6 — 788-7

787.9 / -0V2 → -0V2 / 789.8

-788A1

	K0	K1	K2	K3	K4	K5	K6	K7
	1	2	3	4	5	6	7	8
COM	11 14 12	21 24 22	31 34 32	41 44 42	51 54 52	61 64 62	71 74 72	81 84 82 COM

787.9 / 24V-Z3 → 24Vdc — 24V-Z3 / 789.1

788-8 — 788-9 — 788-10 — 788-11 — 788-12 — 788-13 — 788-14 — 788-15

-X28.6 9 Q28	-X28.6 10 Q28	-X28.7 9 Q28	-X28.7 10 Q28	-X28.8 9 Q28	-X28.8 10 Q28	-X28.9 9 Q28	-X28.9 10 Q28
-XB28.6 9 JB30/B	-XB28.6 10 JB30/B	-XB28.7 9 JB30/C	-XB28.7 10 JB30/C	-XB28.8 9 JB30/D	-XB28.8 10 JB30/D	-XB28.9 9 JB30/E	-XB28.9 10 JB30/E
-788Y0 A97.30.23 A1 A2 B1 B2		-788Y2 A97.30.34 A1 A2 B1 B2		-788Y4 A97.30.46 A1 A2 B1 B2		-788Y6 A97.30.53 A1 A2 B1 B2	
-XB28.6 8 JB30/B		-XB28.7 8 JB30/C		-XB28.8 8 JB30/D		-XB28.9 8 JB30/E	
-X28.6 8 Q28		-X28.7 8 Q28		-X28.8 8 Q28		-X28.9 8 Q28	

787.9 / 0V1 → 0V1 / 789.1

⇦787

789⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 788
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0	1	2	3	4	5	6	7	8	9

COMBINED TRANSFERT 2° TRANSFERT PLATFORM CHAINS LIFTING AFTER STAPPING MACHINE UP

COMBINED TRANSFERT 2° TRANSFERT PLATFORM CHAINS LIFTING AFTER STAPPING MACHINE DOWN

SHEETS ASPIRATION CONVEYOR BELT 1° CHOICE STACKER UP

SHEETS ASPIRATION CONVEYOR BELT 1° CHOICE STACKER DOWN

1° ASPIRATION ROOM SHUTTER OPEN

1° ASPIRATION ROOM SHUTTER CLOSE

2° ASPIRATION ROOM SHUTTER OPEN

2° ASPIRATION ROOM SHUTTER CLOSE

-789A0
751.4
OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A105.0 1 — 789-0
A105.1 5 — 789-1
A105.2 2 — 789-2
A105.3 6 — 789-3
A105.4 3 — 789-4
A105.5 7 — 789-5
A105.6 4 — 789-6
A105.7 8 — 789-7

788.9 / -0V2 → -0V2 / 790.8

-789A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 — 21 24 22 — 31 34 32 — 41 44 42 — 51 54 52 — 61 64 62 — 71 74 72 — 81 84 82 COM

788.9 / 24V-Z3 → 24Vdc → 24V-Z3 / 790.1

789-8 -X28.10 9 Q28
789-9 -X28.10 10 Q28
789-10 X
789-11 X
789-12
789-13
789-14
789-15

-XB28.10 9 JB30/F
-XB28.10 10 JB30/F
XB
XB
-XB28.55 3
-XB28.55 4
-XB28.55 5
-XB28.55 6

-789Y0 A97.30.64 A1 A2 B1 B2
-789Y2 A97.28.175 A1 A2 B1 B2
-789Y4 A97.28.149 A1 A2 B1 B2
-789Y6 A97.28.154 A1 A2 B1 B2

-XB28.10 8 JB30/F
XB
-XB28.55 1

0V1
785.2

-X28.10 8 Q28
X

788.9 / 0V1 → 0V1 / 790.1

788
790

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	789
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

3° ASPIRATION ROOM SHUTTER OPEN	3° ASPIRATION ROOM SHUTTER CLOSE	4° ASPIRATION ROOM SHUTTER OPEN	4° ASPIRATION ROOM SHUTTER CLOSE	SPARE	SPARE	1° FEEDING PINCH ROLL UP	1° FEEDING PINCH ROLL DOWN

-790A0
751.5
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A106.0 1 — 790-0
A106.1 5 — 790-1
A106.2 2 — 790-2
A106.3 6 — 790-3
A106.4 3 — 790-4
A106.5 7 — 790-5
A106.6 4 — 790-6
A106.7 8 — 790-7

789.9 / -0V2 → -0V2 / 791.8

-790A1
1 2 3 4 5 6 7 8
K0 K1 K2 K3 K4 K5 K6 K7
COM 11 14 12 | 21 24 22 | 31 34 32 | 41 44 42 | 51 54 52 | 61 64 62 | 71 74 72 | 81 84 82 COM

789.9 / 24V-Z3 → 24Vdc

790-8 790-9 790-10 790-11 790-14 790-15

-XB28.55 7 — A1 -790Y0 A2 — B1 8 — -XB28.55
A97.28.159
-XB28.55 9 — A1 -790Y2 A2 — B1 10 — -XB28.55
A97.28.164
-XB28.55 2
120.6 / 0V1 →
789.9 / 0V1 →

-X28.2 7 Q28
-X28.2 8 Q28
-XB28.2 7 JB26 — A1 -790Y6 A2 — B1 8 JB26 — -XB28.2
A97.25.14
0V1
781.8

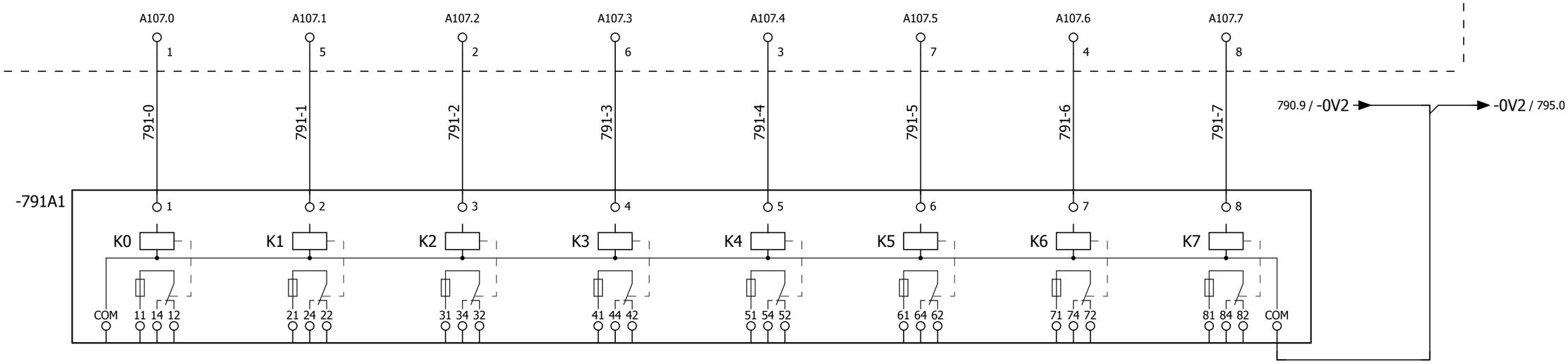
⇦789
791⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 790
Revision			Replacement of / Replaced by			Group:	Of 414

SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

-791A0
751.5

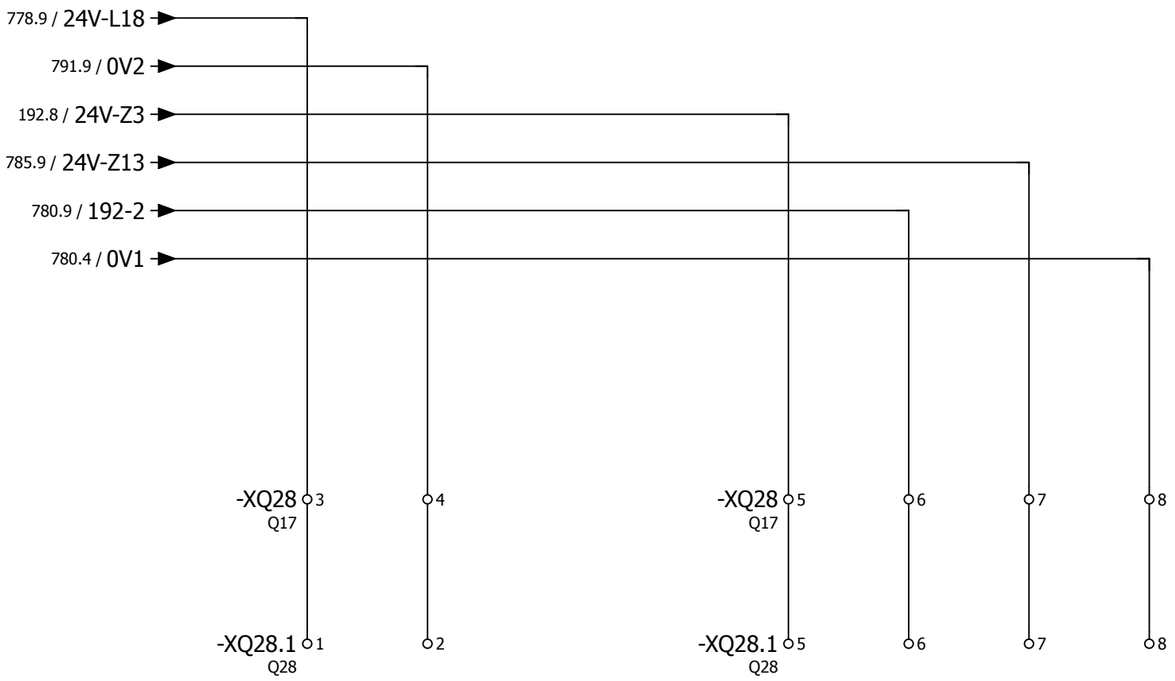
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS



⇦790

795⇨

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box digital output		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 791
Revision		Replacement of	Replaced by			Group:	Of 414



STACKERS AND TRANSFER PLATFORM BOX SUPPLY

Date	14/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Stackers and transfer platform box supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 795
Revision		Replacement of	Replaced by			Group:	Of 414

115.5 / 110-L5

115.6 / 110-N

-XP1
Q14
10
11

-XP01
P01
10
11

1
-800F5
4A
5SY6104-7
2

800-1
110-N

L
N
-800V5
120Vac/24Vdc 5A
6ES7307-1EA01-0AA0
+
-

800-2

1
-800F2
4A
5SY6104-7
2

1
-800F6
4A
5SY6104-7
2

24V / 803.0

0V / 803.0

-800P1
OPERATOR PANEL
P01
6AV6643-0CB01-1AX1

-800A7
1,5A
XCL1R
24Vdc
10Vdc

+10V / 839.0

0V10 / 839.0

ETHERNET 3 / 852.2

795

801

Date	16/09/2013	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P01 console supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	800
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

750.1 / PROFIBUS 2 → PROFIBUS 2 / 850.0

-803A1	-804A1	-805A0	-806A0	-807A0	-808A0	-809A0	-810A0	-811A0	-812A0	-813A0	-814A0	-815A0	-816A0	-817A0	-819A0	-823A0	-834A1	-835A0	-836A0	-837A0	-838A1	-839A0
803.2	804.0	805.0	806.0	807.0	808.0	809.0	810.0	811.0	812.0	813.0	814.0	815.0	816.0	817.0	819.0	823.0	834.0	835.0	836.0	837.0	838.0	839.0
SIEMENS	PM-E DC 24V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	8 DI DC 24 V	PM-E DC 24V	8 DO DC24V 0,5A	8 DO DC24V 0,5A	8 DO DC24V 0,5A	PM-E DC 24V	2 AI I 2-wire STANDARD
IM 151-1 STANDARD	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF	SF
SF	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR	PWR
BF	6ES7138-4CA00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7131-4BF00-0AA0	6ES7138-4CA00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7132-4BF00-0AA0	6ES7138-4CA00-0AA0	6ES7134-4GB01-0AB0
ON	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1	AUX1
X1 PROFIBUS-DP	6ES7193-4CD20-0AA0	6ES7138-4CA01-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CD20-0AA0	6ES7138-4CA01-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7132-4BF00-0AA0	6ES7193-4CD20-0AA0	6ES7138-4CA01-0AA0	6ES7193-4CB20-0AA0	6ES7134-4GB01-0AB0

ET 200S

DP ADDRESS OFF ON

64 32 16 8 4 2 1

DC24V 1L+ 1M

2L+ 2M

6ES7 151-1AA05-0AB0

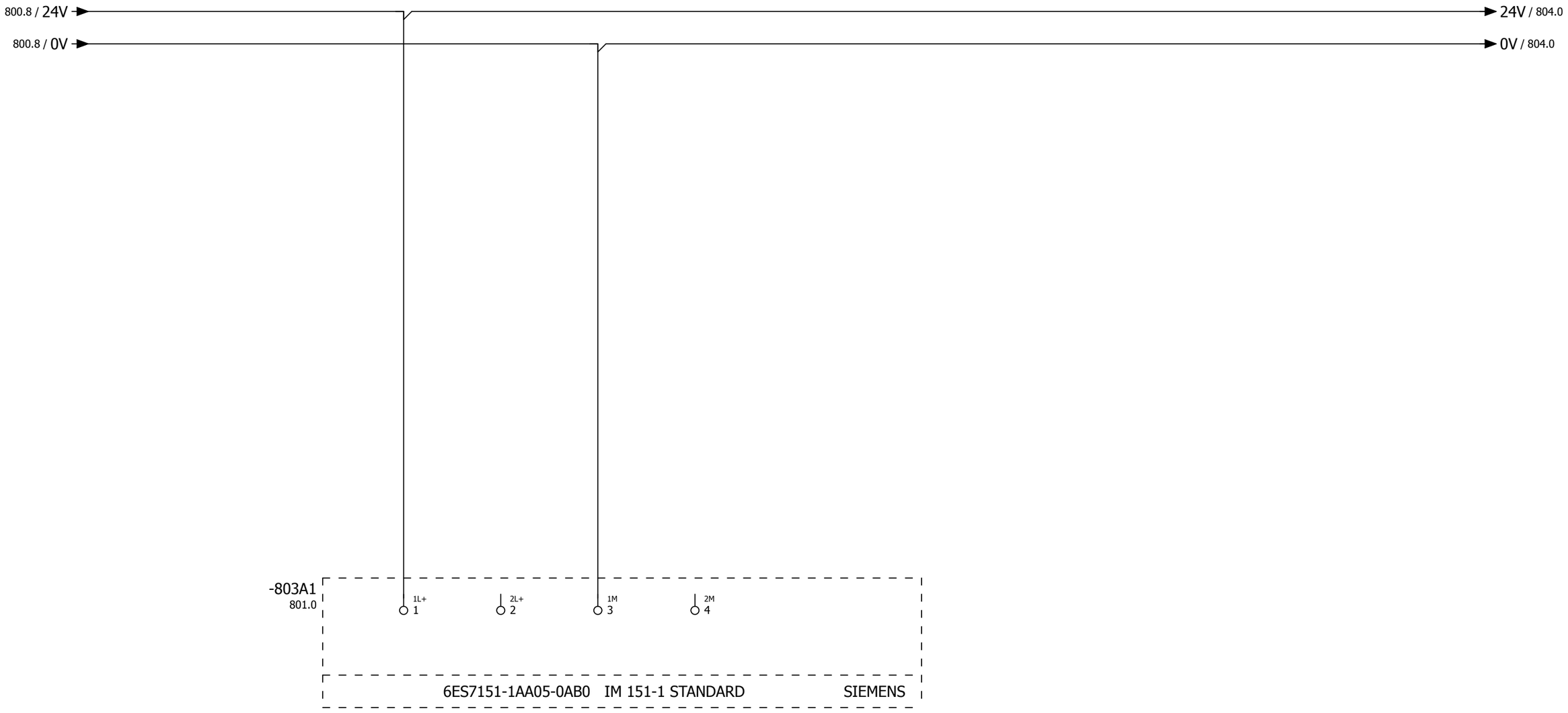
6ES7151-1AA05-0AB0

⇦800

803⇨

Date	16/09/2013	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P01 console plc layout
Drawing	13B01				
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale
Revision			Replacement of / Replaced by		Group:

		=	
		+	
		Page	801
		Of	414



801

804

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 151 P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	803
Revision		Replacement of	Replaced by			Group:	Of 414

803.9 / 24V

803.9 / 0V

24V / 805.0

0V / 823.0

-804A1
801.1

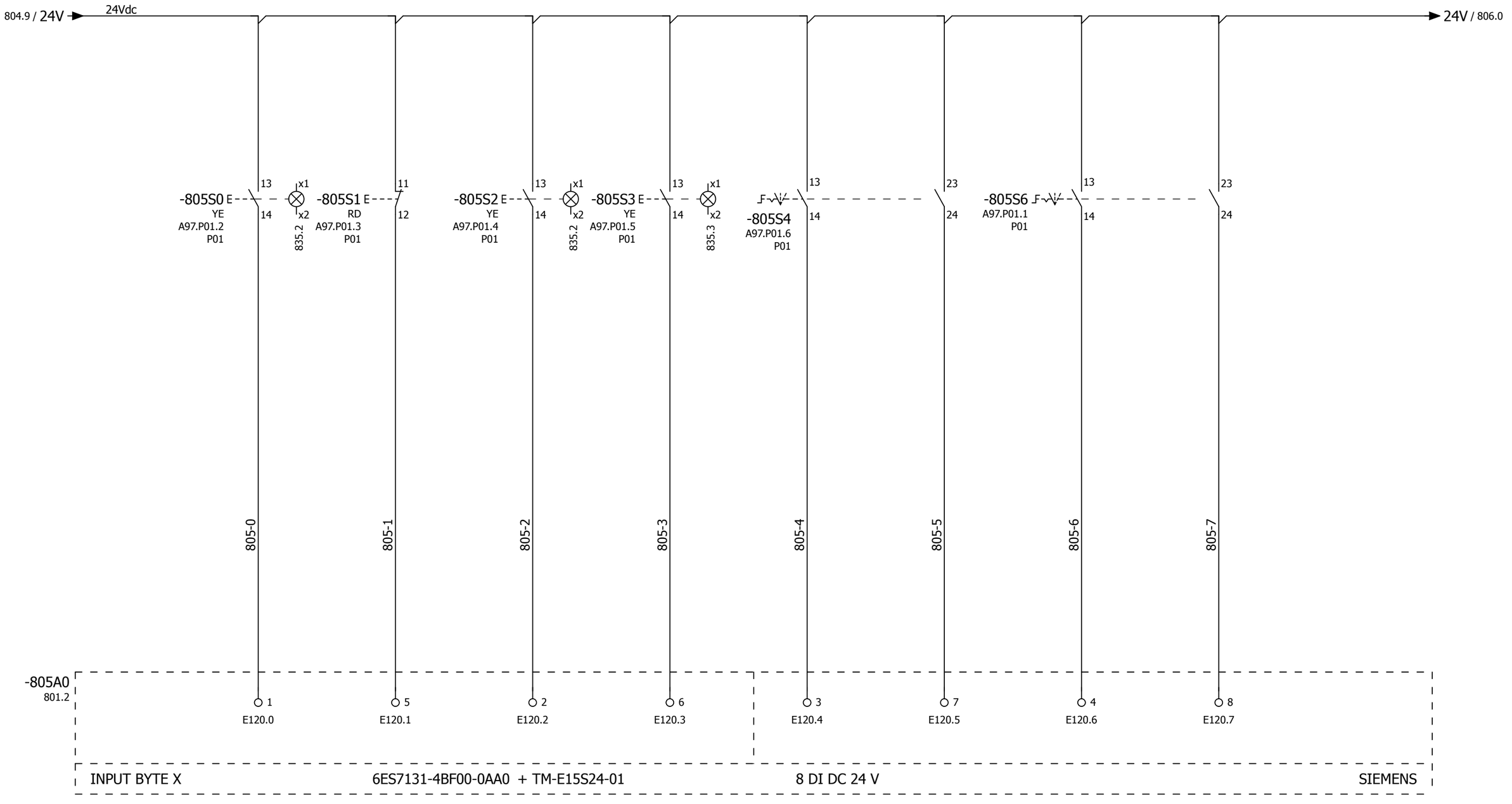
DC24V 2
M 3
A4
A4/AUX1
DC24V 6
M 7
A8
A8/AUX1

POWER MODUL 6ES7138-4CA01-0AA0 + TM-P15S23-A0 PM-E DC 24V SIEMENS

⇦803

805⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 804
Revision		Replacement of	Replaced by			Group:	Of 414



⇦804

806⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	805
Revision		Replacement of	Replaced by			Group:	Of 414

805.9 / 24V

24Vdc

24V / 807.0

-806S0
A97.P01.7
P01
13
14
23
24
806-0

-806S2
A97.P01.10
P01
13
14
23
24
806-1

-806S4
A97.P01.11
P01
13
14
23
24
806-2

-806S6
GN
P01
13
14
x1
x2
837.8
806-3

-806S7
RD
P01
11
12
806-4

806-5

806-6

806-7

-806A0
801.2

1	5	2	6	3	7	4	8
E121.0	E121.1	E121.2	E121.3	E121.4	E121.5	E121.6	E121.7

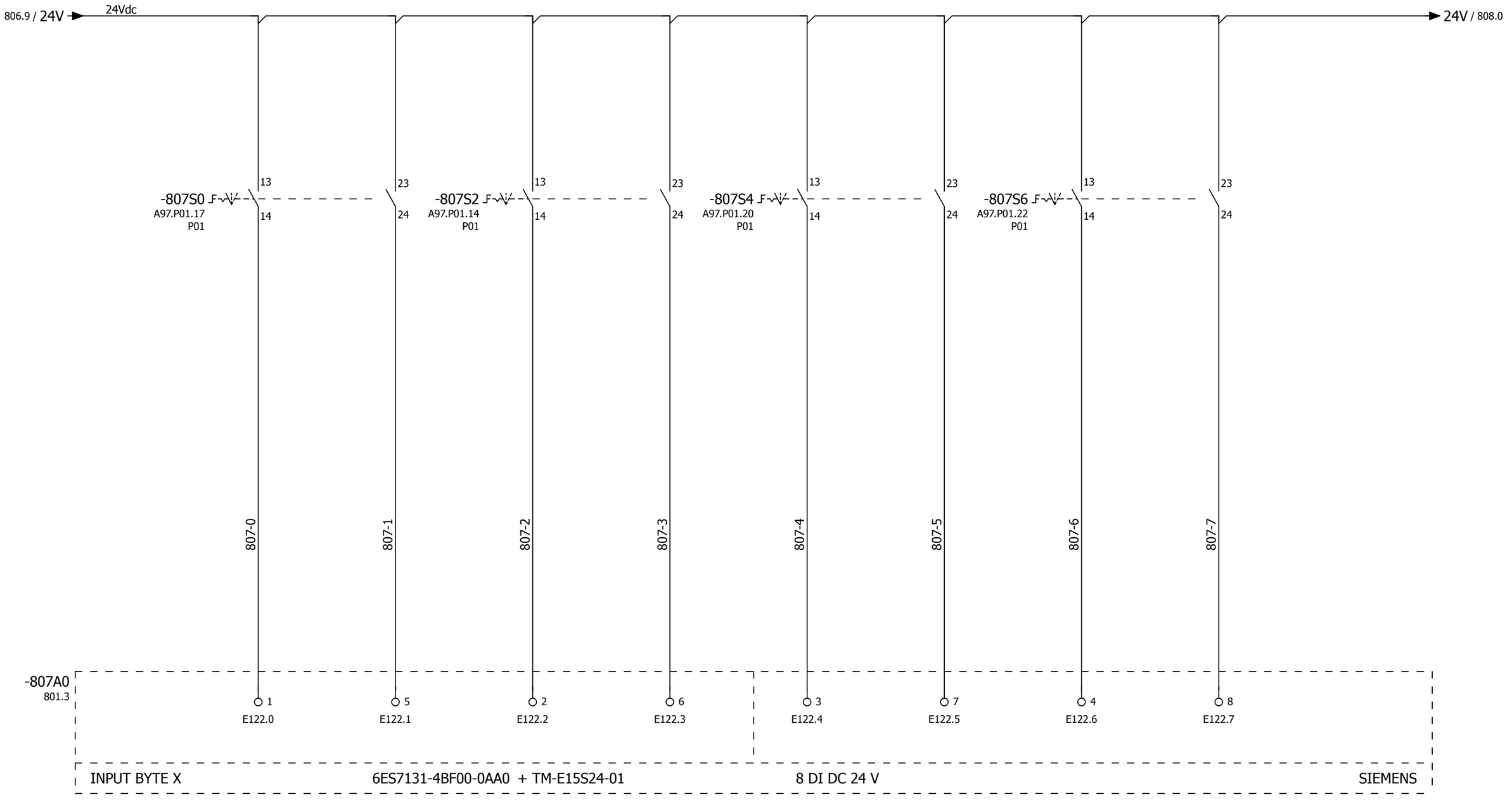
INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

COIL CAR OPERATOR SIDE	COIL CAR MOTOR SIDE	COIL CAR UP	COIL CAR DOWN	COILS ROTATION ANTICLOCKWISE	COILS ROTATION CLOCKWISE	AUTOMATIC LOADING START	AUTOMATIC LOADING STOP

⇦805

807⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	806
Revision		Replacement of	Replaced by			Group:	Of 414



⇦806

808⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 807
Revision		Replacement of	Replaced by			Group:	Of 414

807.9 / 24V — 24Vdc

-808S0 A97.P01.15 P01 — 13 / 14 / 23 / 24 — 808-0
-808S2 A97.P01.16 P01 — 13 / 14 / 23 / 24 — 808-1
-808S4 E BK A97.P01.18 P01 — 13 / 14 — 808-2
-808S5 836.2 GN A97.P01.12 P01 — 13 / 14 / 23 / 24 — 808-3
808-4
808-5
808-6

24V / 809.0

-808A0 801.3

	1	5	2	6	3	7	4	8
	E123.0	E123.1	E123.2	E123.3	E123.4	E123.5	E123.6	E123.7

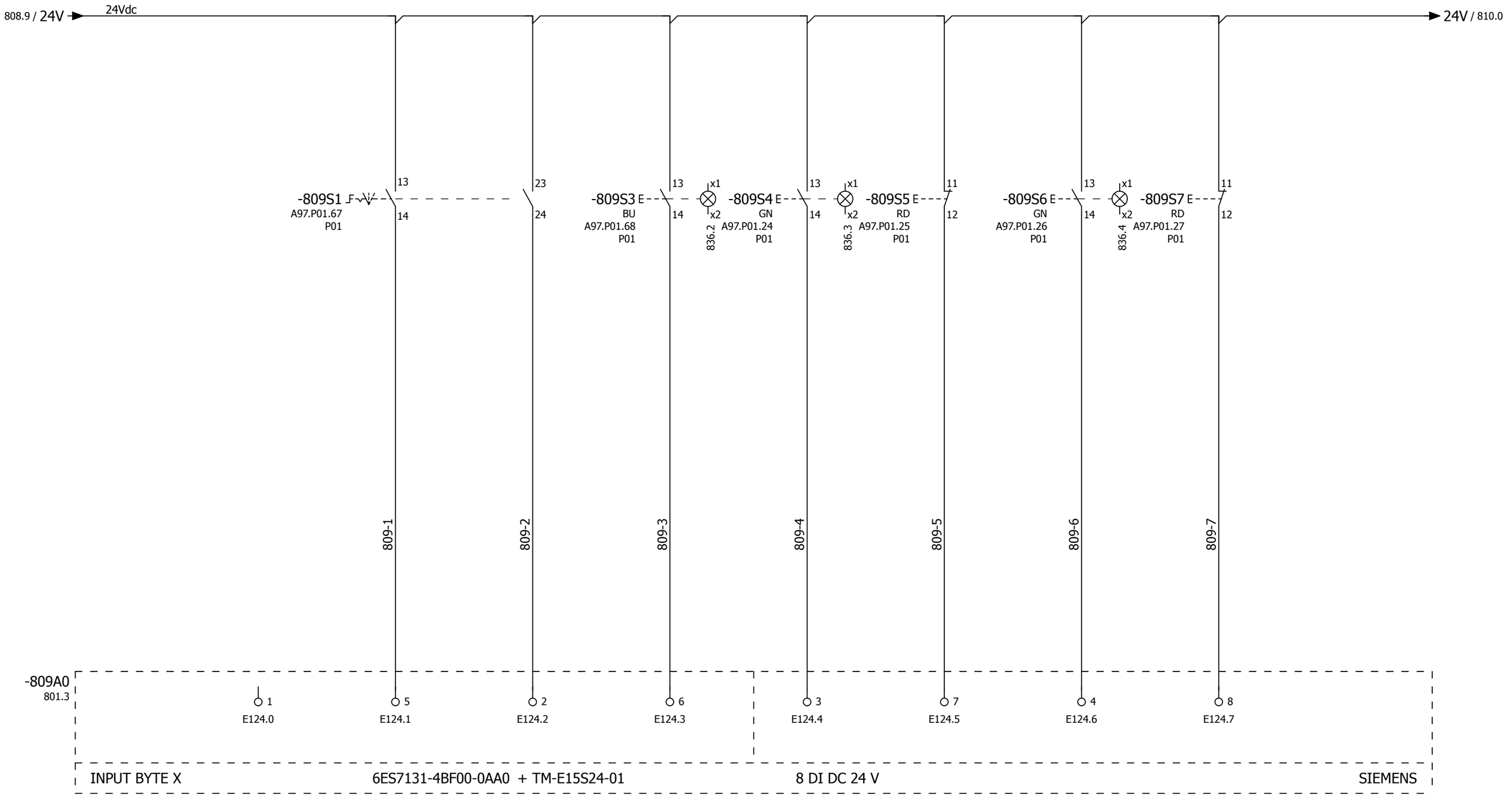
INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

REAR ROLL ROTATION FORWARD	REAR ROLL ROTATION BACKWARD	UNCOILERS+ CONTEMPORARY ROTATION ROLLS FORWARD	UNCOILERS+ CONTEMPORARY ROTATION ROLLS BACKWARD	CENTRE PRESSURE ROLLS	PAPER WINDER MANUAL	PAPER WINDER AUTOMATIC	SPARE	

⇦807

809⇨

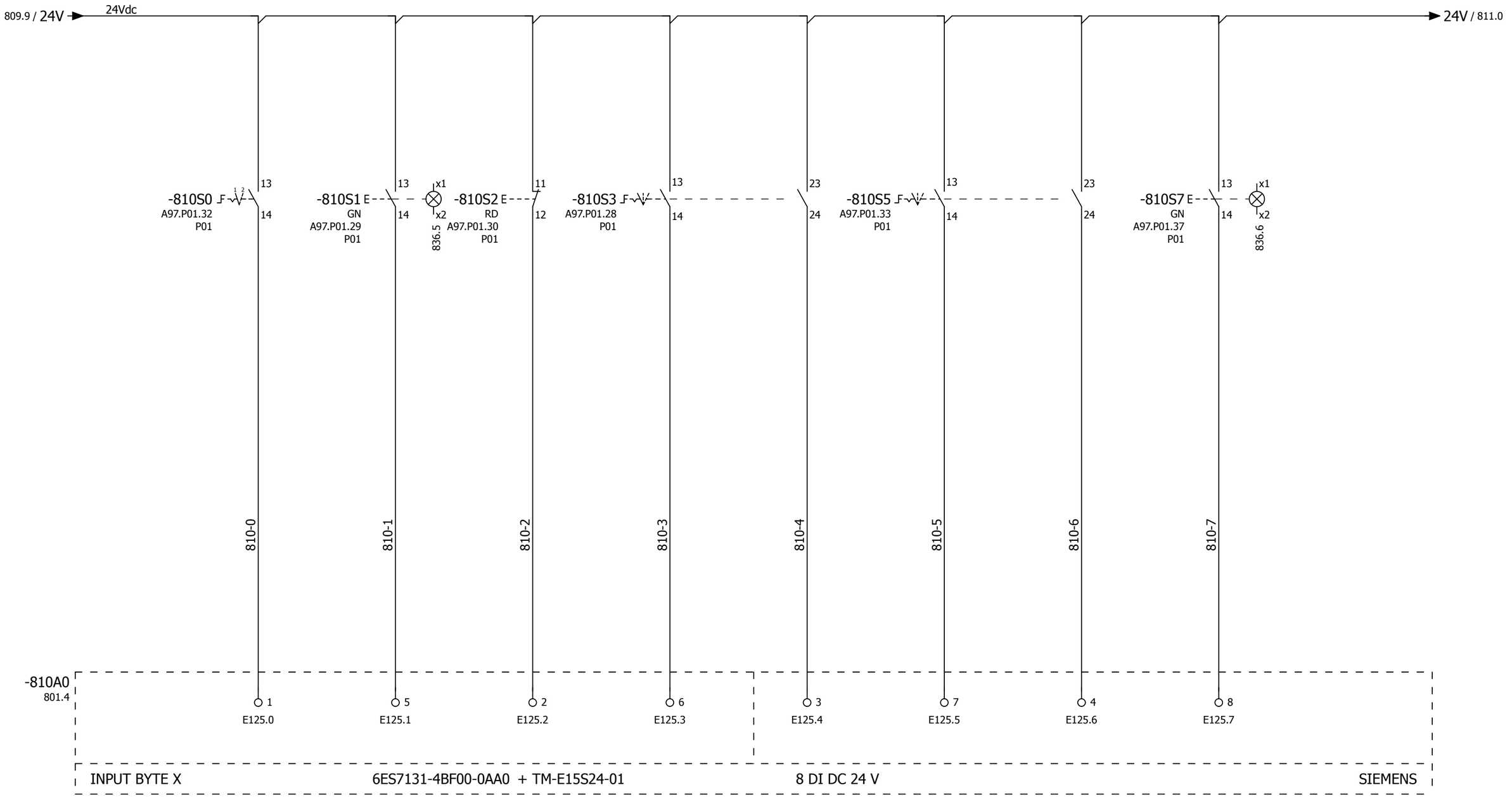
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	808
Revision			Replacement of / Replaced by			Group: / Of	414



SPARE	PAPER WINDER IN	PAPER WINDER OUT	PAPER WINDER AUTOMATIC CENTERING	AUTOMATIC ALIGNMENT PHOTOCELL	MANUAL ALIGNMENT PHOTOCELL	PHOTOCELL SEARCH EDGE START	PHOTOCELL SEARCH EDGE STOP

808

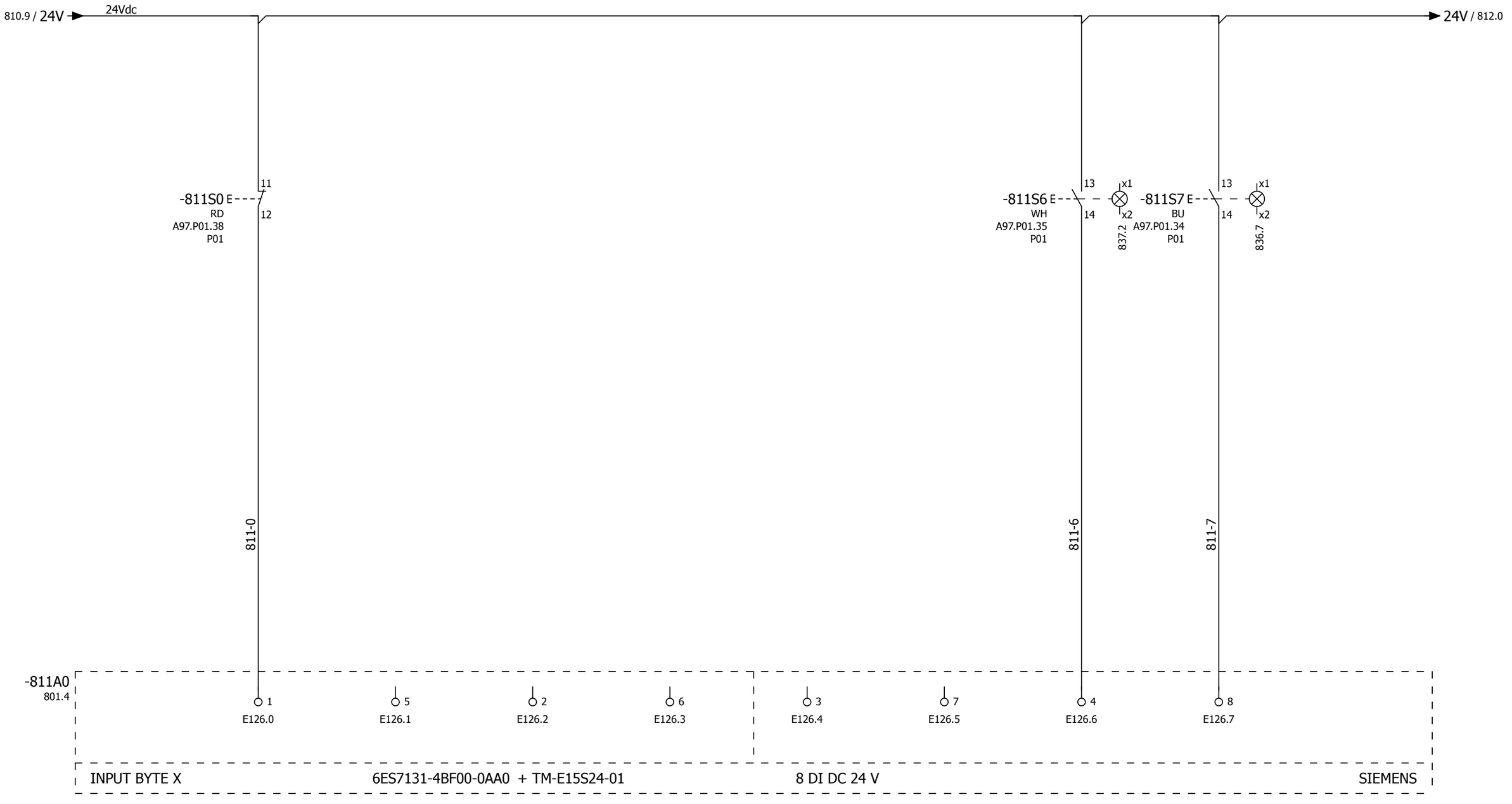
810



809

811

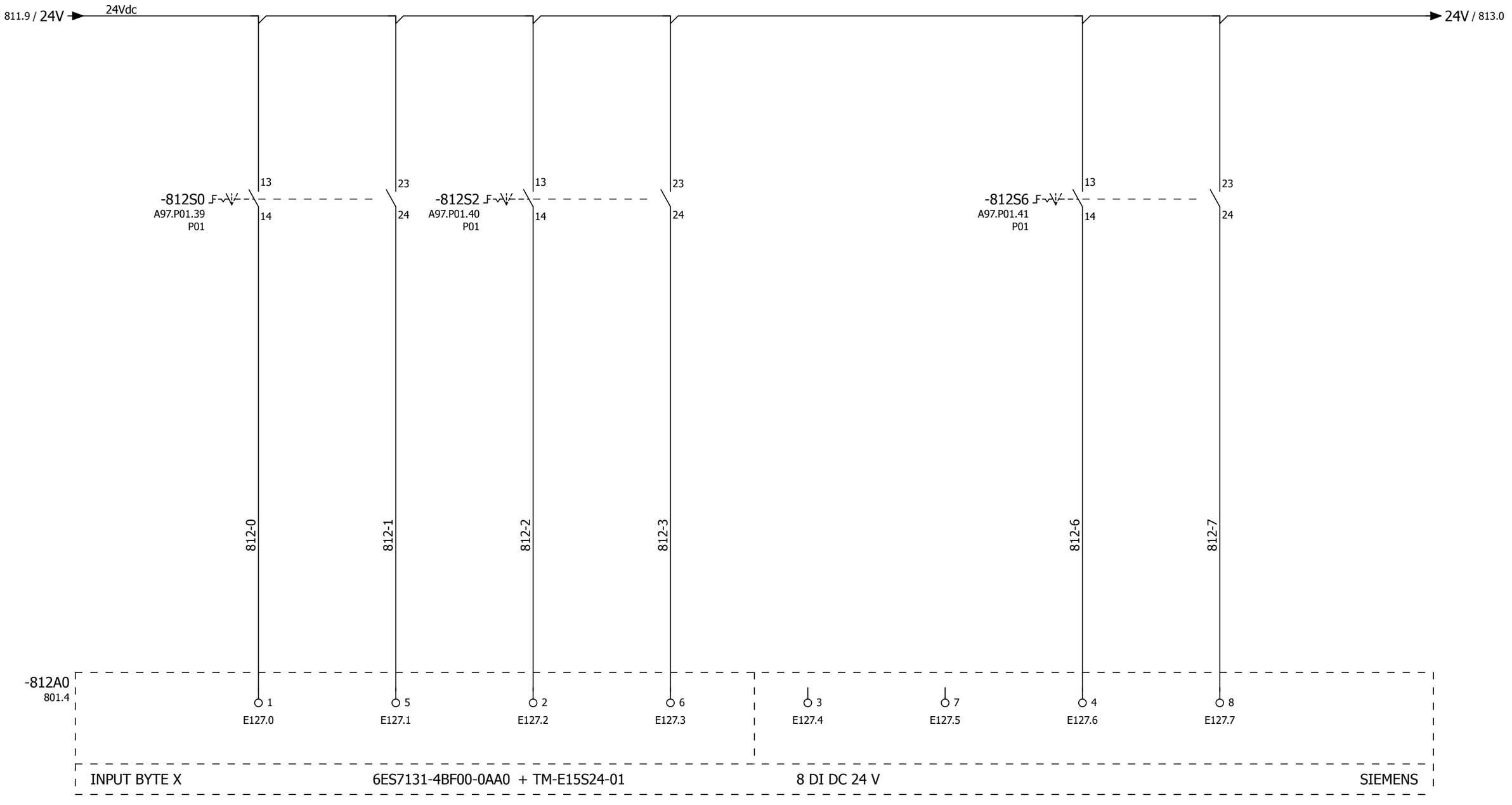
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	810
Revision		Replacement of	Replaced by			Group:	Of 414



⇦810

812⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 811
Revision		Replacement of	Replaced by			Group:	Of 414



⇦811

813⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 812
Revision		Replacement of	Replaced by			Group:	Of 414

812.9 / 24V — 24Vdc

-813S2 E — BU — A97.P01.42 — P01 — 13 / 14 — x1 / x2 — 836.8

-813S3 E — RD — A97.P01.43 — P01 — 11 / 12

-813S6 — A97.P01.44 — P01 — 13 / 14 / 23 / 24

24V / 814.0

813-2 — 813-3 — 813-6 — 813-7

-813A0
801.5

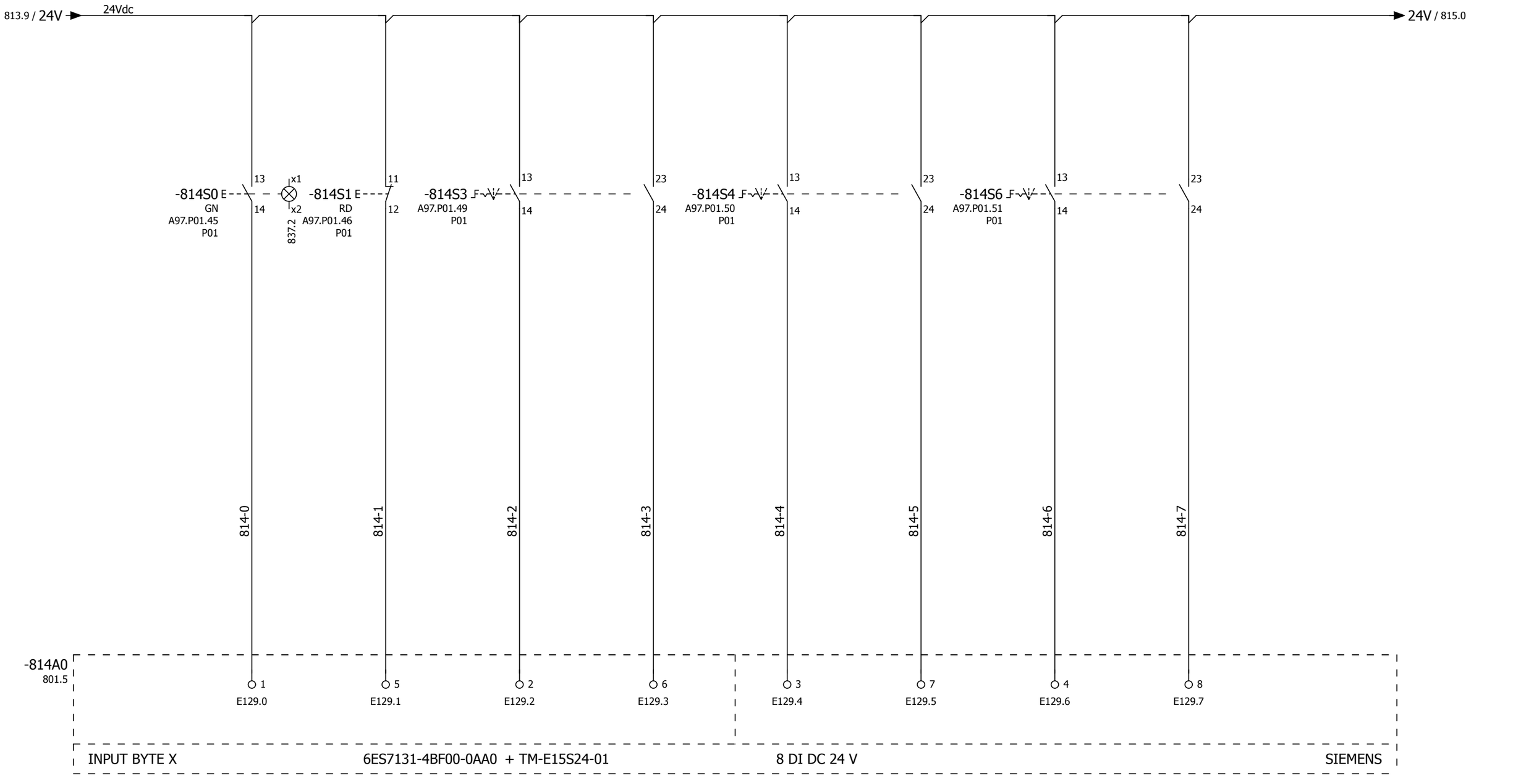
	1	5	2	6	3	7	4	8
	E128.0	E128.1	E128.2	E128.3	E128.4	E128.5	E128.6	E128.7
	SPARE	SPARE	MACHINE POSITIONING START	MACHINE POSITIONING STOP	SPARE	SPARE	STRAIGHTENER PINCH ROLL FORWARD	STRAIGHTENER PINCH ROLL BACKWARD

INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

⇦812

814⇨

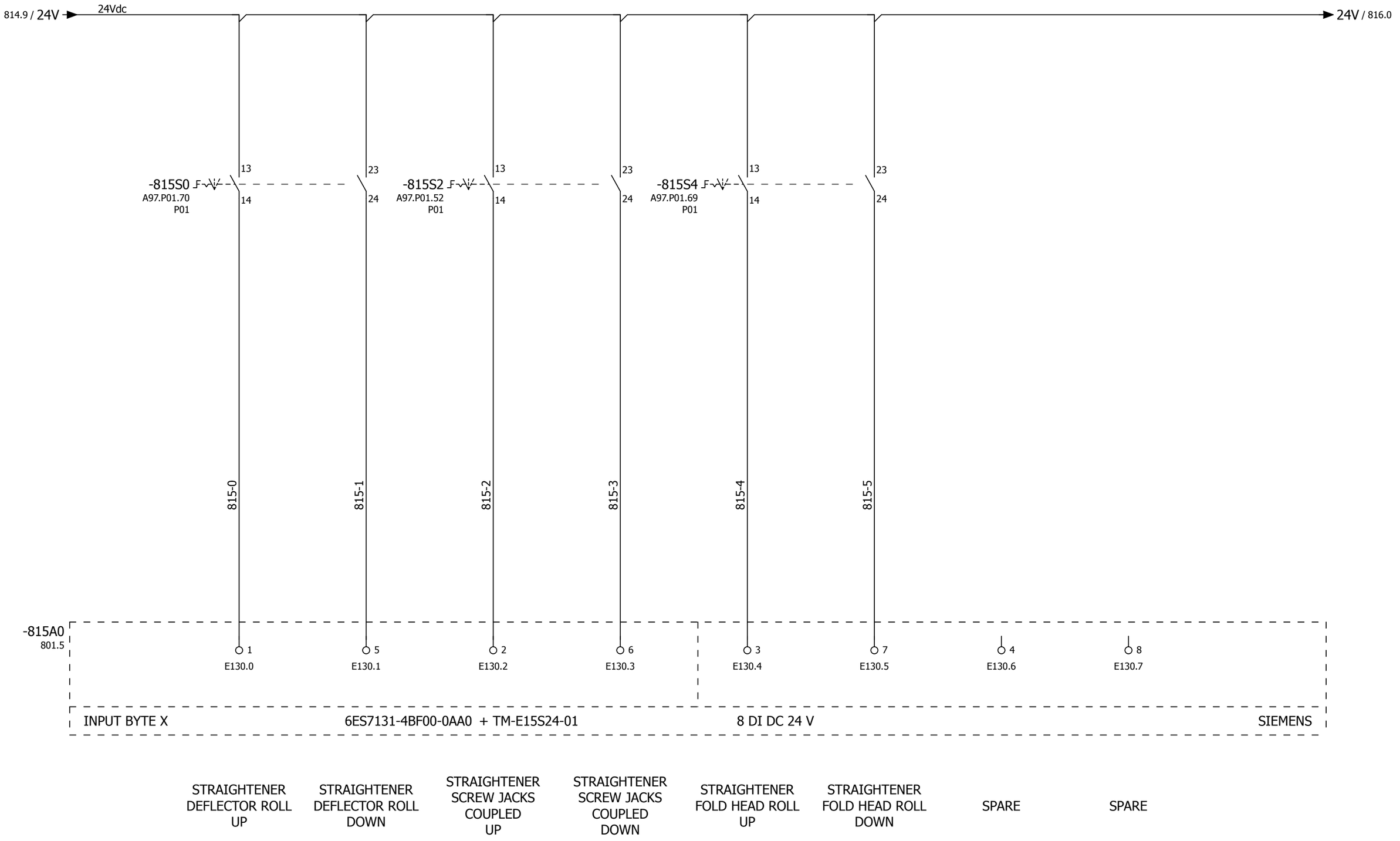
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 813
Revision			Replacement of / Replaced by			Group:	Of 414



⇦813

815⇨

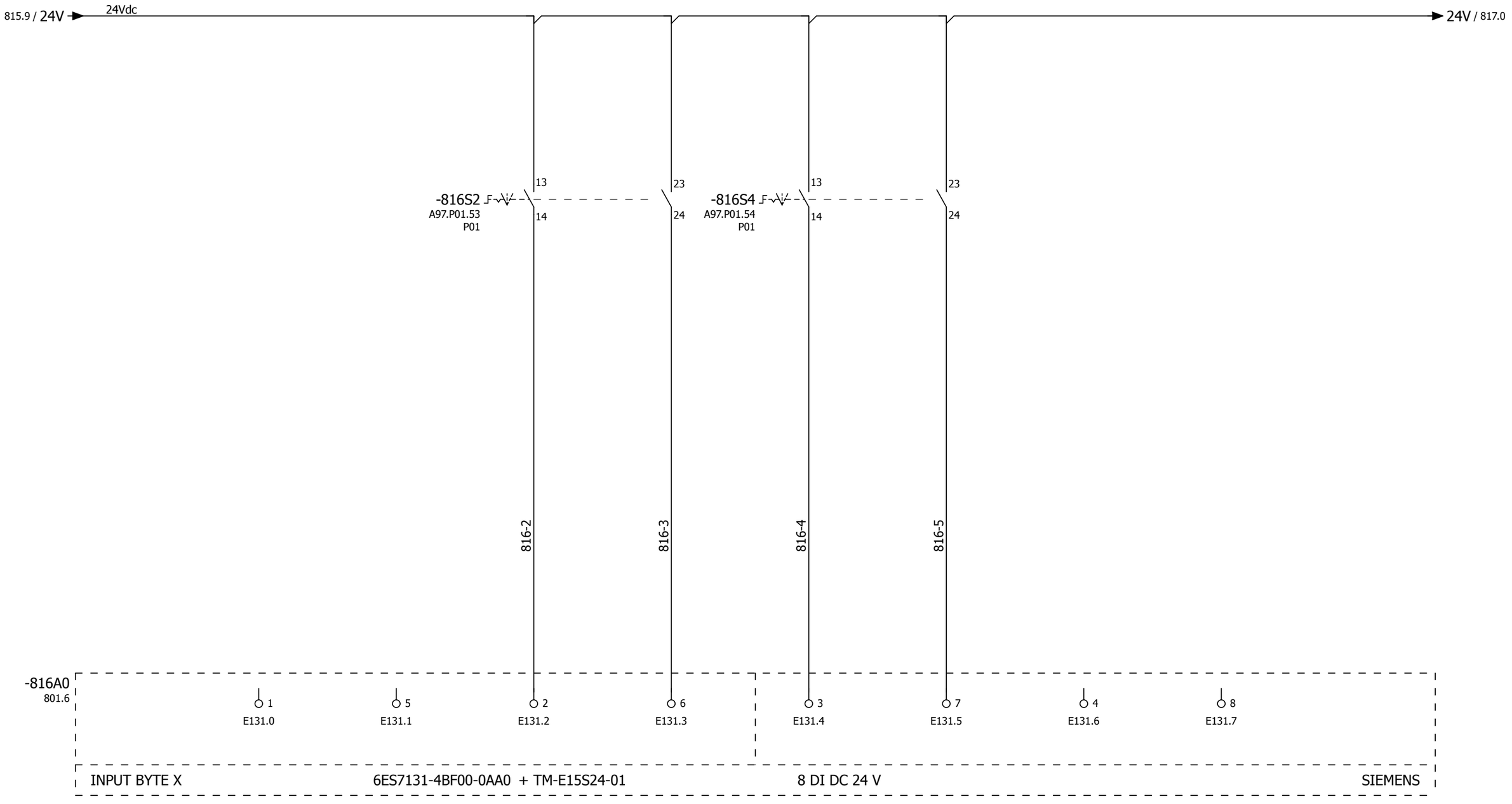
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	814
Revision			Replacement of / Replaced by			Group: / Of	414



⇦814

816⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	815
Revision		Replacement of	Replaced by			Group:	Of 414



⇦815

817⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale		Page 816
Revision			Replacement of / Replaced by			Group:	Of 414

816.9 / 24V — 24Vdc

24V / 819.0

-817S0 E
WH
A97.P01.55
P01
13
14

-817S1
BK
A97.P01.56
P01
13
14

-817S2
A97.P01.57
P01
13
14
23
24

817-0
817-1
817-2
817-3

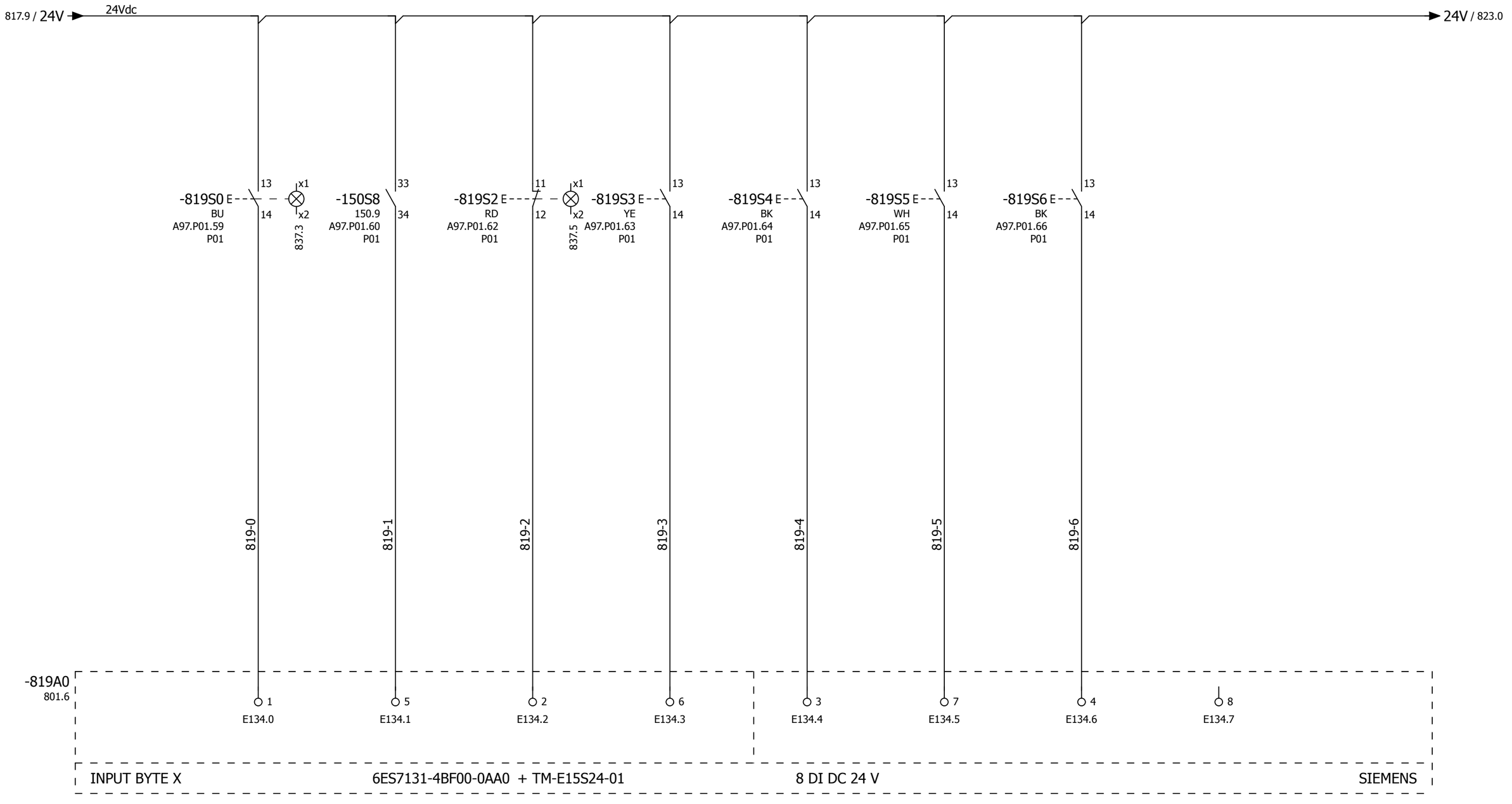
-817A0
801.6

	1	5	2	6	3	7	4	8
	E132.0	E132.1	E132.2	E132.3	E132.4	E132.5	E132.6	E132.7
INPUT BYTE X	6ES7131-4BF00-0AA0 + TM-E15S24-01				8 DI DC 24 V			SIEMENS
	CROPPER SHEAR CUT	CROPPER SHEAR MAN. - AUT.	CROPPER SHEAR BLADES CLEARANCE -	CROPPER SHEAR BLADES CLEARANCE +	SPARE	SPARE	SPARE	SPARE

⇦816

819⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 817
Revision			Replacement of / Replaced by			Group:	Of 414



⇦817

823⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 819
Revision		Replacement of	Replaced by			Group:	Of 414

819.9 / 24V → 24Vdc

24V / 834.0

-823S0

BOS5K-PS-IX10-S75
BCC02R0

+U_B 0V
1 3

1 +U_B 0V 3
2 4

-823S1

BOS5K-PS-IX10-S75
BCC02R0

+U_B 0V
1 3

1 +U_B 0V 3
2 4

-823S2

BOS5K-PS-IX10-S75
BCC02R0

+U_B 0V
1 3

1 +U_B 0V 3
2 4

823-0

823-1

823-2

804.9 / 0V →

0V / 834.0

-823A0
801.7

1	5	2	6	3	7	4	8
E138.0	E138.1	E138.2	E138.3	E138.4	E138.5	E138.6	E138.7

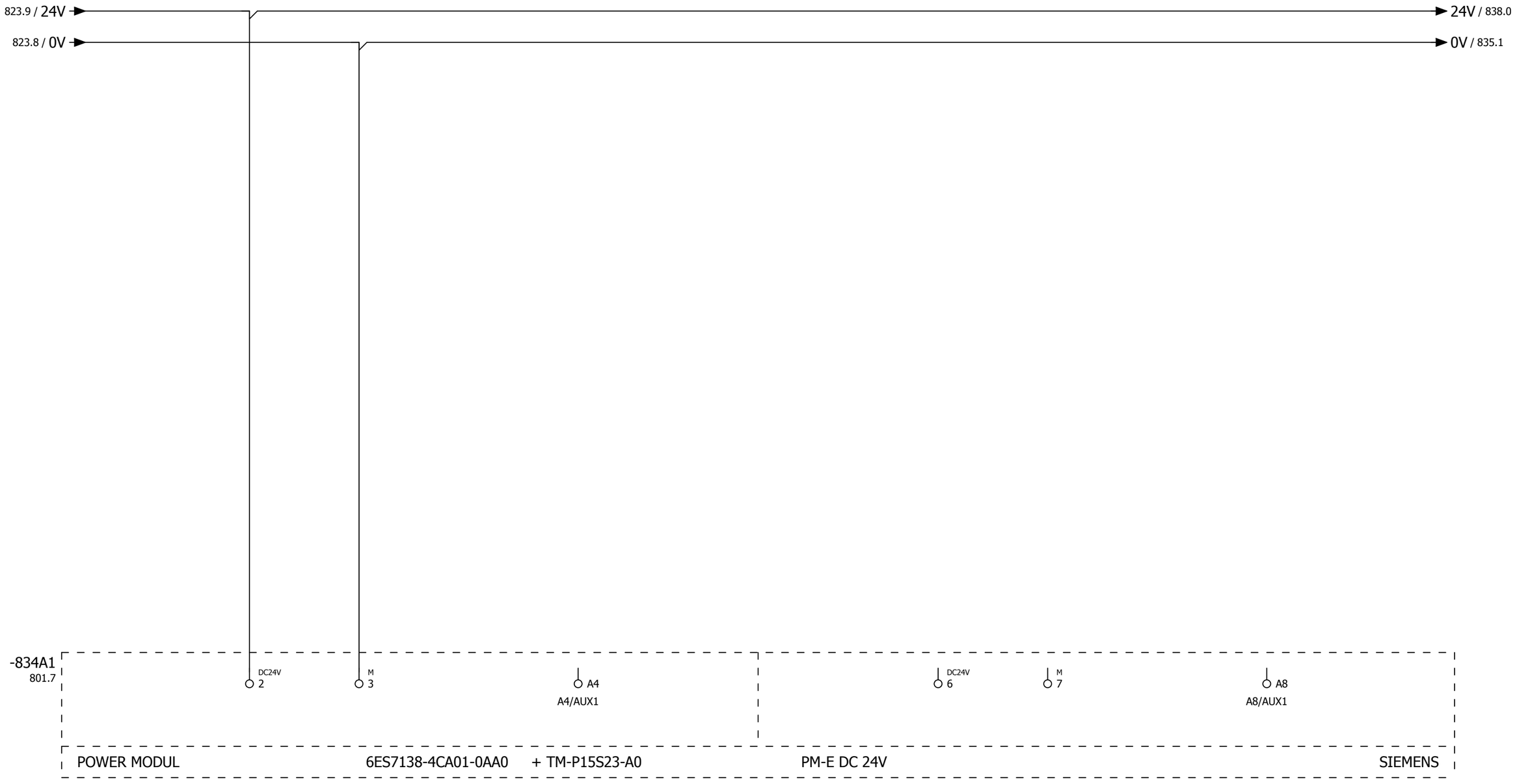
INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

COIL WIDTH READING PHOTOCELL	UPPER COIL DIAMETER READING PHOTOCELL	LOWER COIL DIAMETER READING PHOTOCELL	SPARE	SPARE	SPARE	SPARE	SPARE

⇦819

834⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	823
Revision			Replacement of / Replaced by			Group: / Of	414

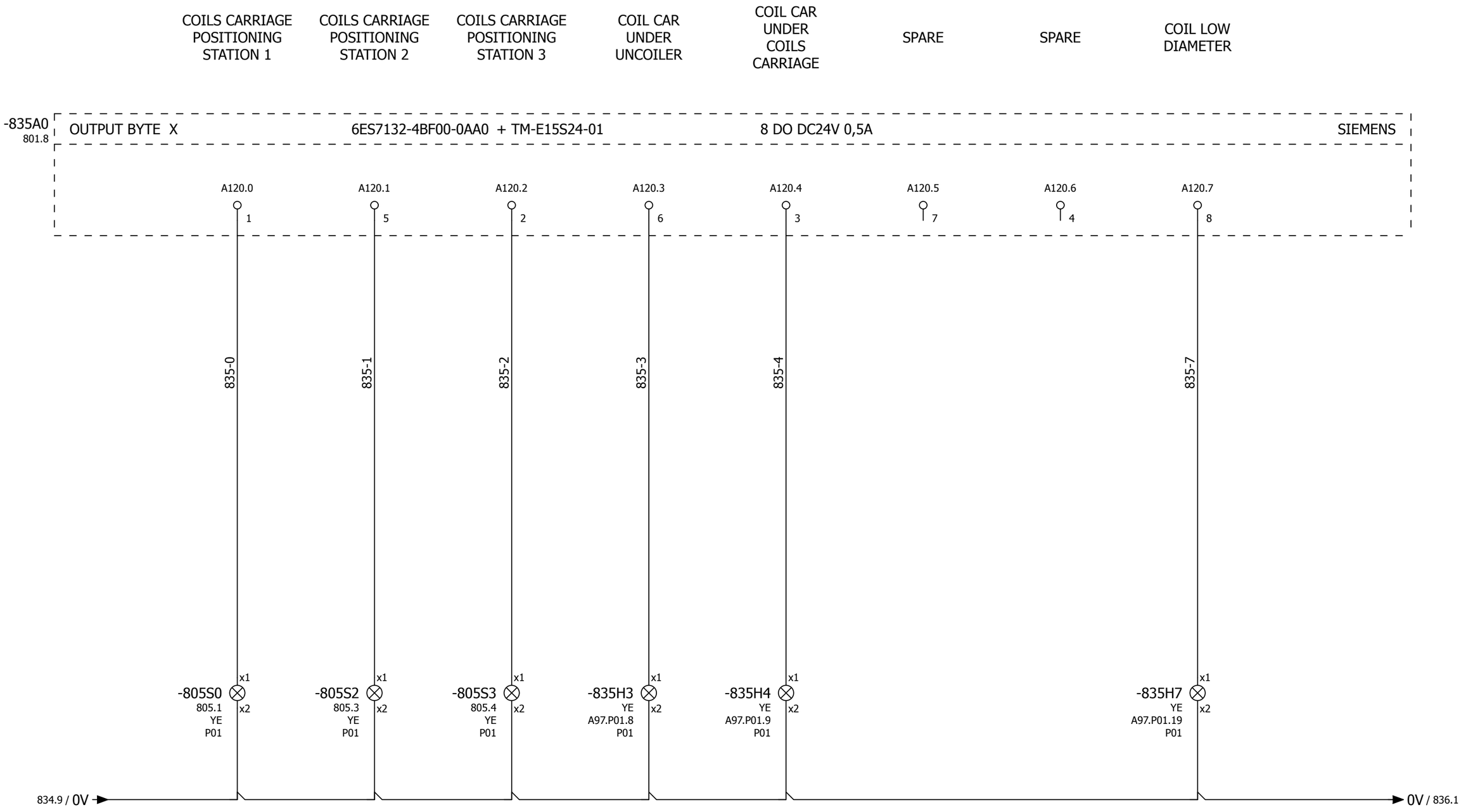


⇦823

835⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 834
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



⇦834

836⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 835
Revision		Replacement of	Replaced by			Group:	Of 414

PAPER WINDER MAN. - AUT.	PAPER WINDER AUTOMATIC CENTERING	AUTOMATIC ALIGNMENT PHOTOCELL	PHOTOCELL SEARCH EDGE START	UNCOILER TENSION START	UNCOILER MANDREL EXPANSION	DECOILER IN THE MIDDLE LINE POSITION	MACHINE POSITIONING START

-836A0
801.8

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A121.0	A121.1	A121.2	A121.3	A121.4	A121.5	A121.6	A121.7
1	5	2	6	3	7	4	8
836-0	836-1	836-2	836-3	836-4	836-5	836-6	836-7
-808S5 x1/x2	-809S3 x1/x2	-809S4 x1/x2	-809S6 x1/x2	-810S1 x1/x2	-810S7 x1/x2	-811S7 x1/x2	-813S2 x1/x2
808.6 GN P01	809.4 BU P01	809.5 GN P01	809.7 GN P01	810.2 GN P01	810.7 GN P01	811.7 BU P01	813.3 BU P01

835.9 / 0V

0V / 837.1

⇦835

837⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 836
Revision		Replacement of	Replaced by			Group:	Of 414

ENTRY STRAIGHTENER PINCH ROLL CLOSE	COILS IN THE MIDDLE INDICATOR ON - OFF	ENTRY ZONE GENERAL RESET	LINE STOP ALARM	LINE STOP	SPARE	SPARE	AUTOMATIC LOADING START

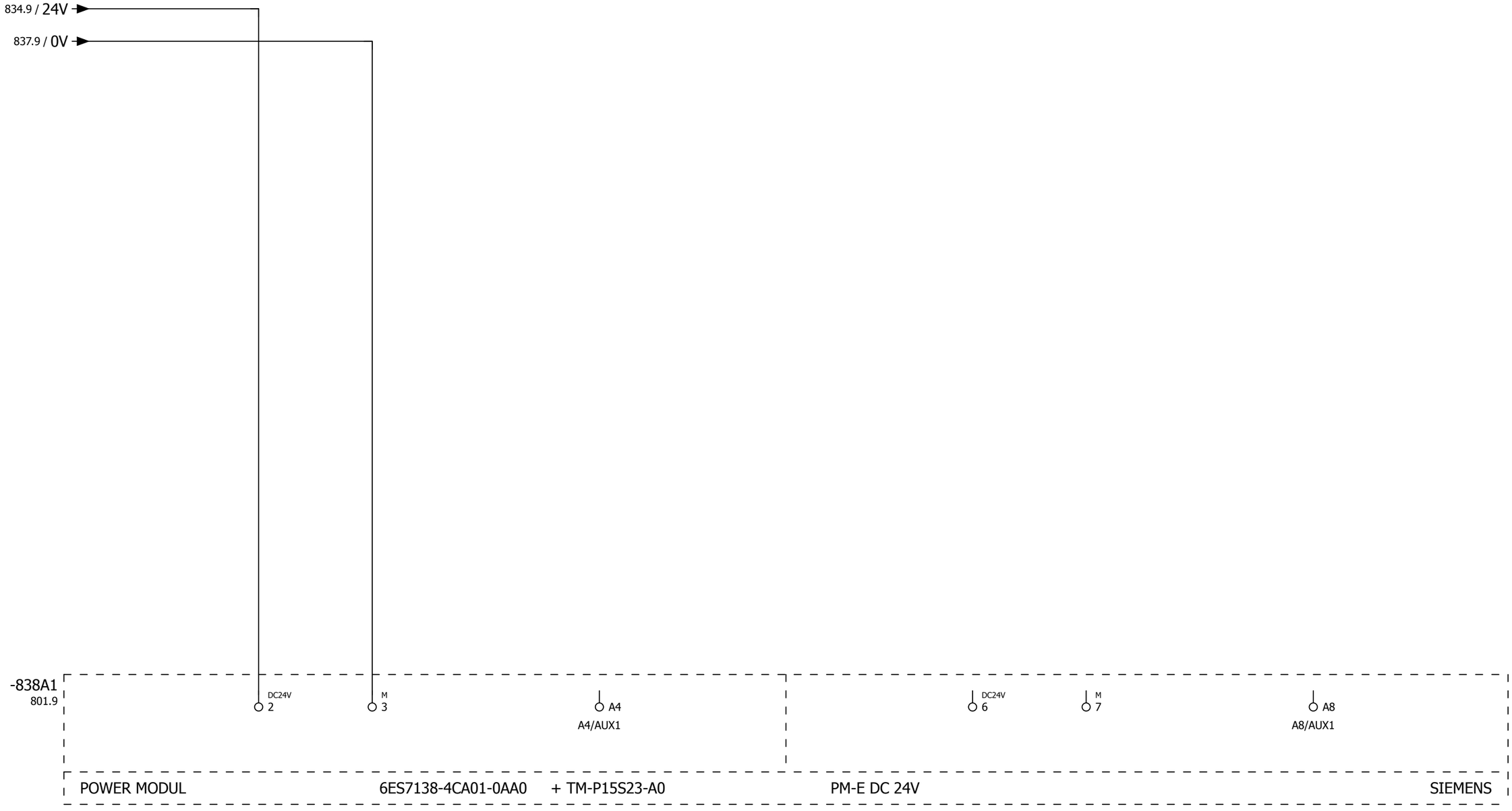
-837A0
801.8
OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A122.0	A122.1	A122.2	A122.3	A122.4	A122.5	A122.6	A122.7
1	5	2	6	3	7	4	8
837-0	837-1	837-2	837-3	837-4			837-7
-814S0 x1/x2	-811S6 x1/x2	-819S0 x1/x2	-837H3 x1/x2	-819S2 x1/x2			-806S6 x1/x2
814.1 GN P01	811.7 WH P01	819.1 BU P01	RD A97.P01.61 P01	819.3 RD P01			806.7 GN P01

836.9 / 0V → 0V / 838.0

⇦836
838⇨

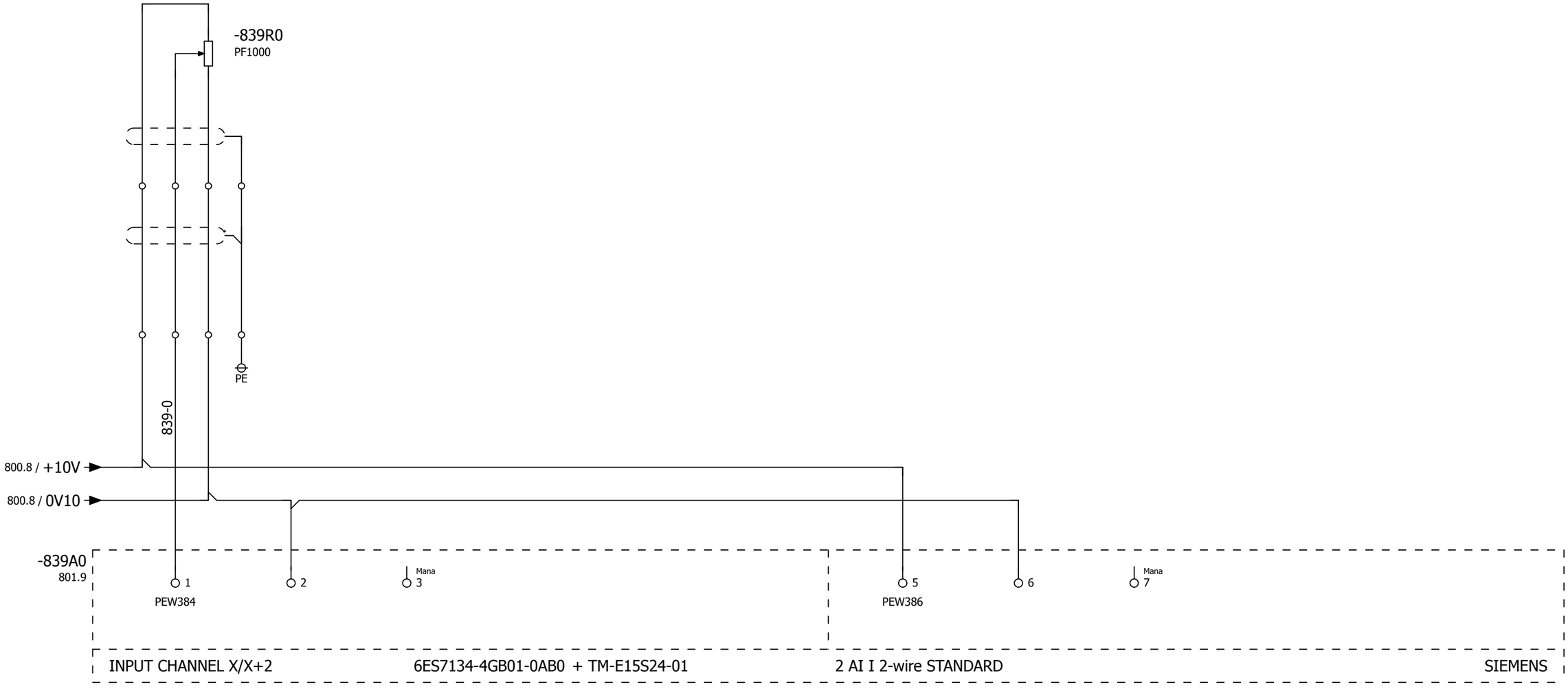
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 837
Revision		Replacement of	Replaced by			Group:	Of 414



⇦837

839⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	838
Revision		Replacement of	Replaced by			Group:	Of 414



⇦838

849⇨

Date	16/09/2013	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Analog input P01 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	839
Revision		Replacement of	Replaced by			Group:	Of 414

115.6 / 110-L6

115.7 / 110-N

107.6 / 105-3

107.6 / 105-4

PE

-849X1

1 PE 2 | 1 PE 2 | 1 PE 2 | 1 PE 2 | 1 PE 2

-849P2
PC+VIDEO
P02



ETHERNET 2 / 852.2

-XP2 10 11
Q14

-XP02 10 11
P02

-849F7
4A
5SY6104-7
1
2

849-1

110-N

-849V7
120Vac/24Vdc 5A
6ES7307-1EA01-0AA0
L N
\+ -

849-2

-849F8
6A
5SY6106-7
1
2

24V / 852.0

0V / 852.0

⇦839

850⇨

Date	16/09/2013	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P02 console supply		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 849
Revision		Replacement of	Replaced by			Group:	Of 414

801.1 / PROFIBUS 2

PROFIBUS 2 / 901.1

-853A1	-854A1	-855A0	-856A0	-857A0	-858A0	-859A0	-867A0	-868A0	-869A0	-870A0	-871A0	-872A0	-873A0	-875A0	-876A0	-877A0	-878A0	-880A0	-881A0	-882A0	-883A0	-884A0
853.2	854.0	855.0	856.0	857.0	858.0	859.0	867.0	868.0	869.0	870.0	871.0	872.0	873.0	875.0	876.0	877.0	878.0	880.0	881.0	882.0	883.0	884.0
SIEMENS	IM 151-1 STANDARD	PM-E DC 24V	8 DI DC 24 V																			
	SF	SF																				
	BF																					
	ON																					
		PWR																				
	DP ADDRESS OFF ON	6ES7138-4CA00-0AA0	6ES7131-4BF00-0AA0																			
		AUX1																				
X1 PROFIBUS-DP	64 32 16 8 4 2 1																					
DC24V 1L+ 1M	6ES7 151-1AA05-0AB0																					
2L+ 2M																						
6ES7151-1AA05-0AB0		6ES7193-4CD20-0AA0	6ES7138-4CA01-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0	6ES7193-4CB20-0AA0	6ES7131-4BF00-0AA0

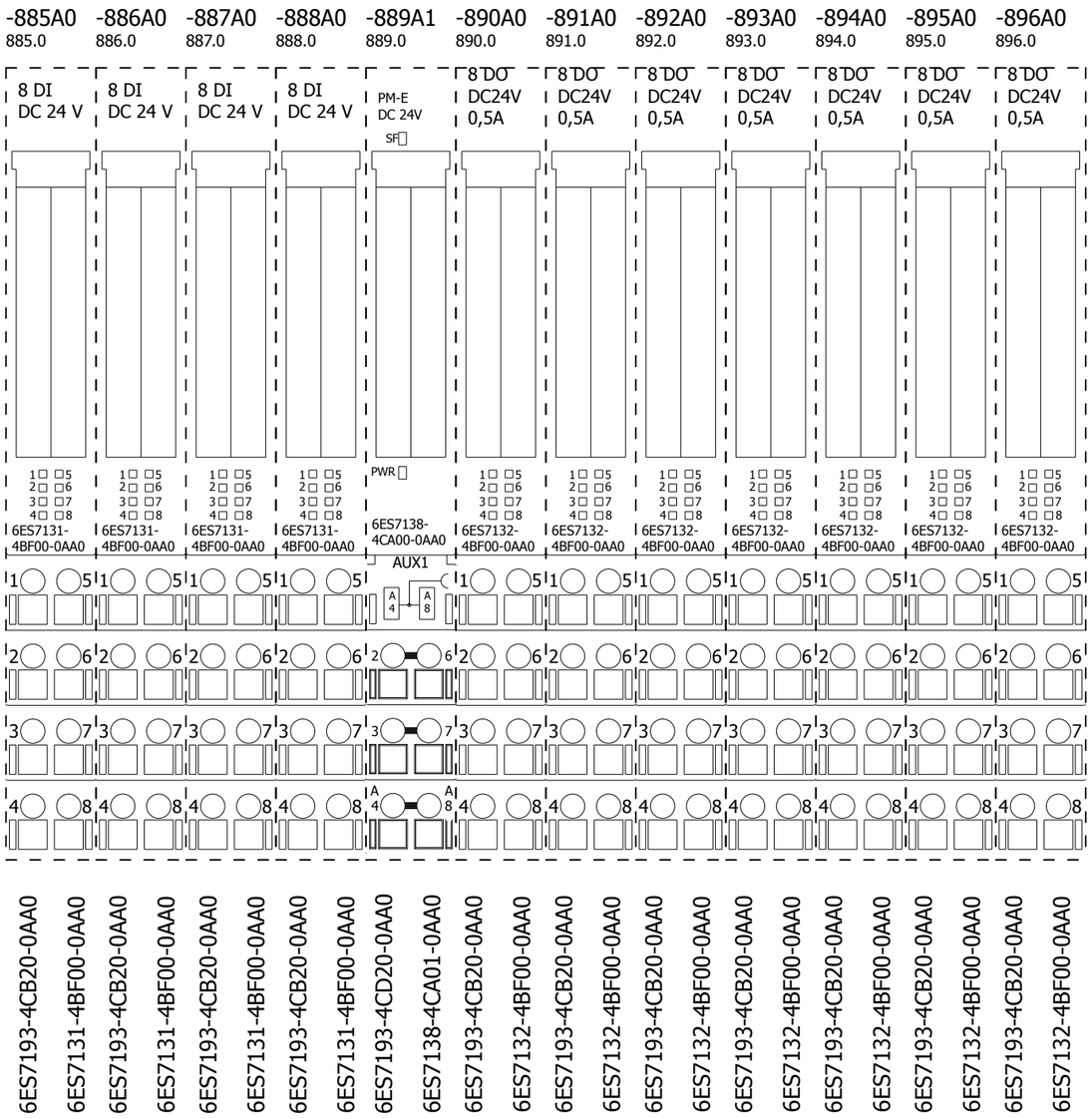
849

851

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P02 console plc layout
Drawing	13B01		Comm: A97		Installation: Linea taglio trasversale
Drawer	Tengattini Marco		Replacement of / Replaced by		
Revision					

=			
+			
	Page	850	
Group:	Of	414	

0	1	2	3	4	5	6	7	8	9



⇦850

852⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P02 console plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	851
Revision			Replacement of / Replaced by			Group: / Of	414

849.8 / 24V → 24V / 853.0

849.8 / 0V → 0V / 853.0

-852A1

SWITCH ETHERNET - 8 PORT - SIE. 6GK5008-0BA00-1AB2

ETH1 ETH2 ETH3 ETH4 ETH5 ETH6 ETH7 ETH8

ETHERNET 1
405.2

ETHERNET 2
849.2

ETHERNET 3
800.3

ETHERNET 4
900.1

ETHERNET 5

ETHERNET 6

ETHERNET 8

TO CABINET PLC

TO P01 CONSOLE

TO STRAPPING MACHINE

TO P02 CONSOLE

TO P03 CONSOLE

DIGITEC CABINET

CUSTOMER

⇦851

853⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Switch ethernet		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	852
Revision		Replacement of	Replaced by			Group:	Of 414

852.9 / 24V

852.9 / 0V

24V / 854.0

0V / 854.0

-853A1
850.0

1L+ 1
2L+ 2
1M 3
2M 4

6ES7151-1AA05-0AB0 IM 151-1 STANDARD SIEMENS

⇦852

854⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 151 P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	853
Revision		Replacement of	Replaced by			Group:	Of 414

853.9 / 24V

853.9 / 0V

24V / 889.0

0V / 889.0

-854A1
850.1

DC24V 2

M 3

A4
A4/AUX1

DC24V 6

M 7

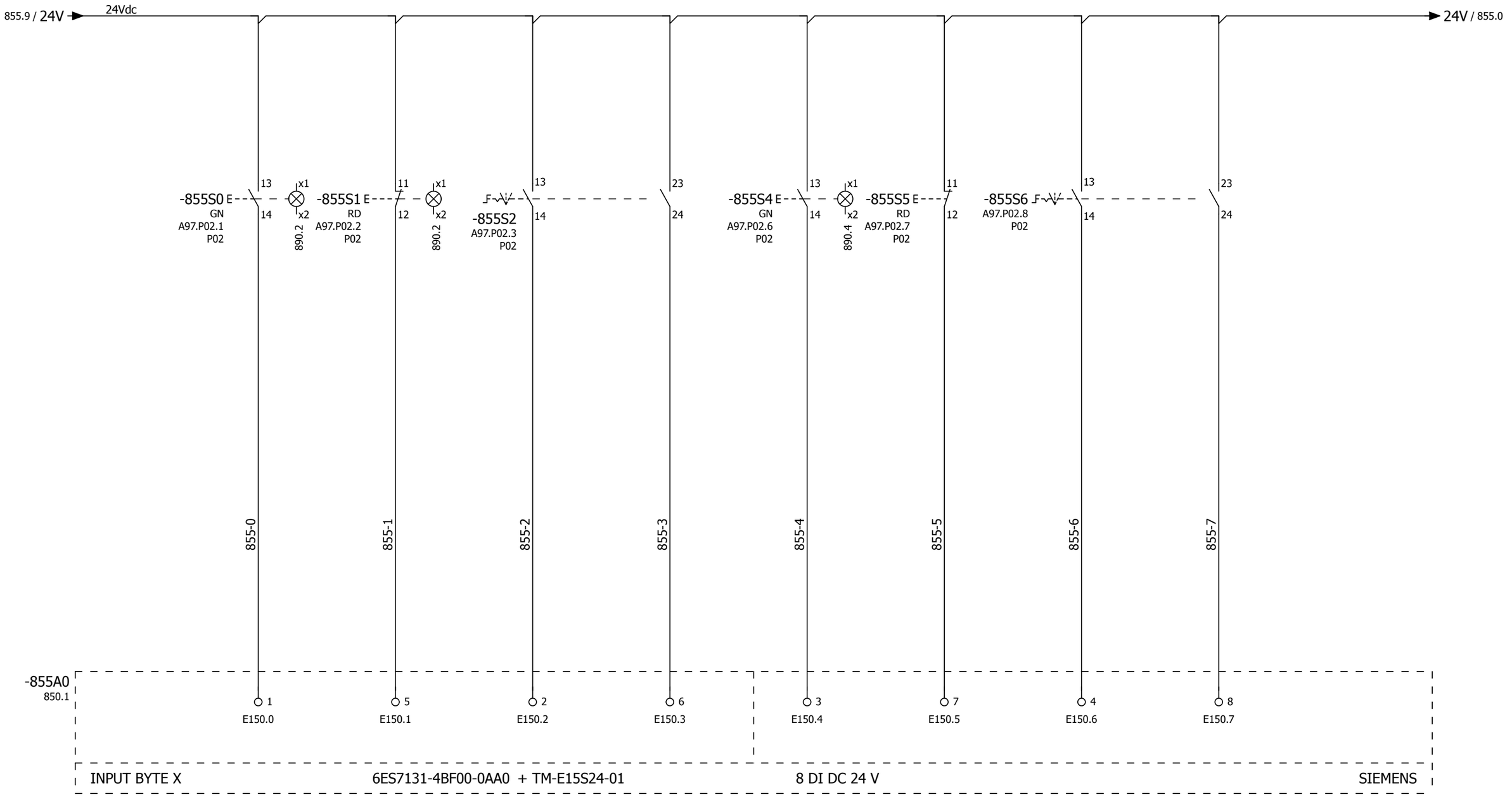
A8
A8/AUX1

POWER MODUL 6ES7138-4CA01-0AA0 + TM-P15S23-A0 PM-E DC 24V SIEMENS

⇦853

855⇨

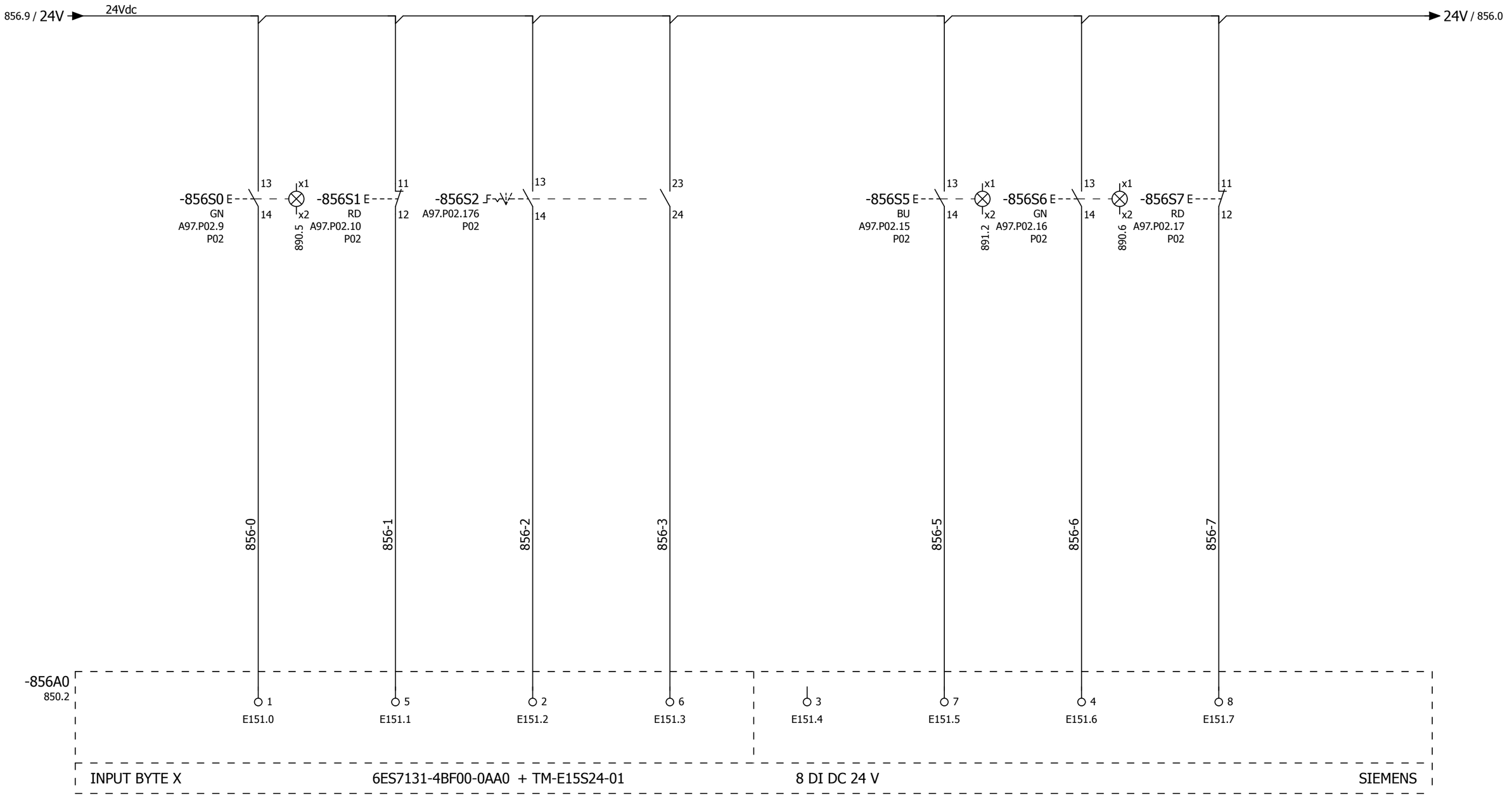
Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 854
Revision		Replacement of	Replaced by			Group:	Of 414



⇦854

856⇨

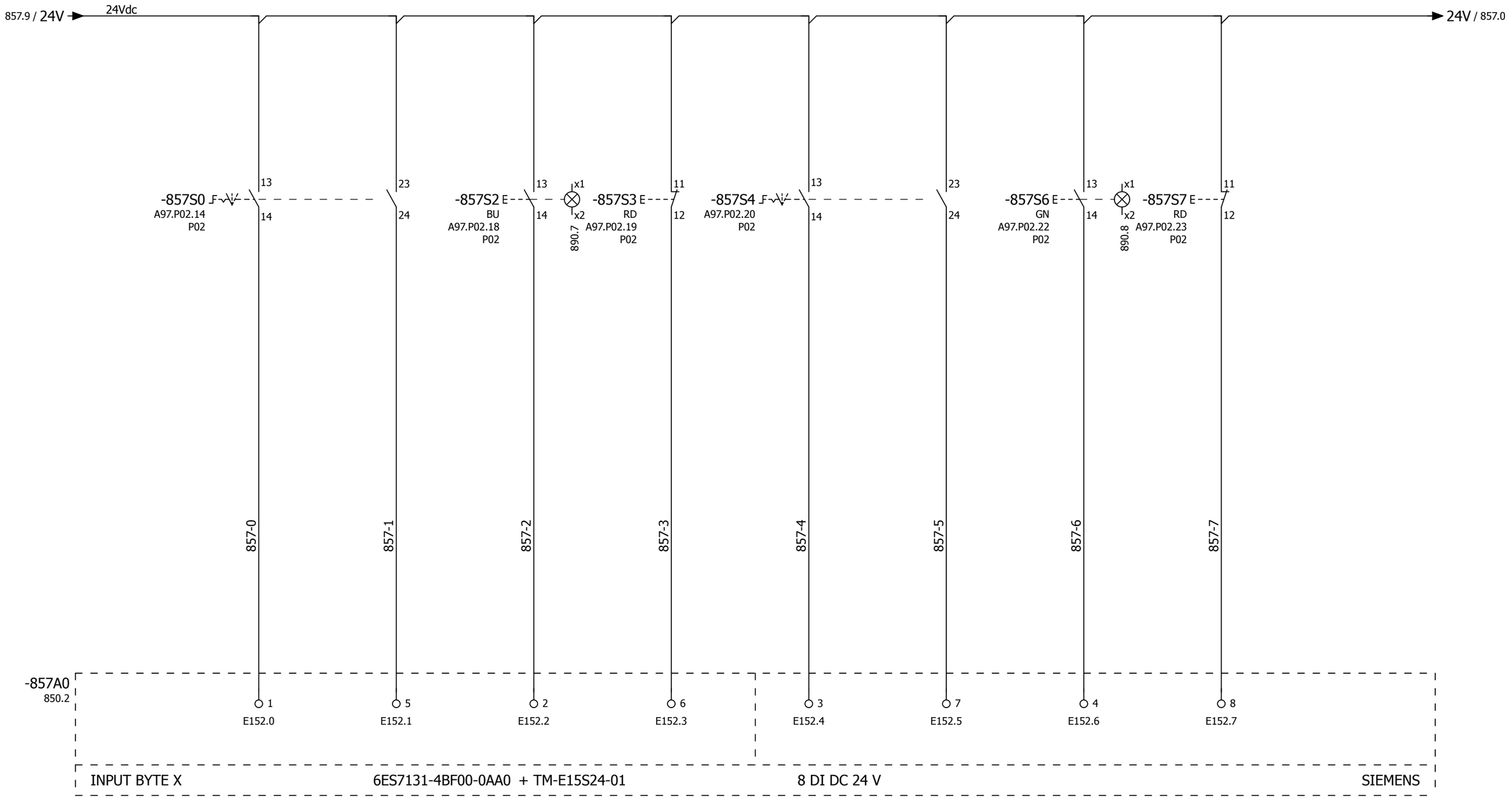
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	855
Revision		Replacement of	Replaced by			Group:	Of 414



⇦855

857⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	856
Revision		Replacement of	Replaced by			Group:	Of 414

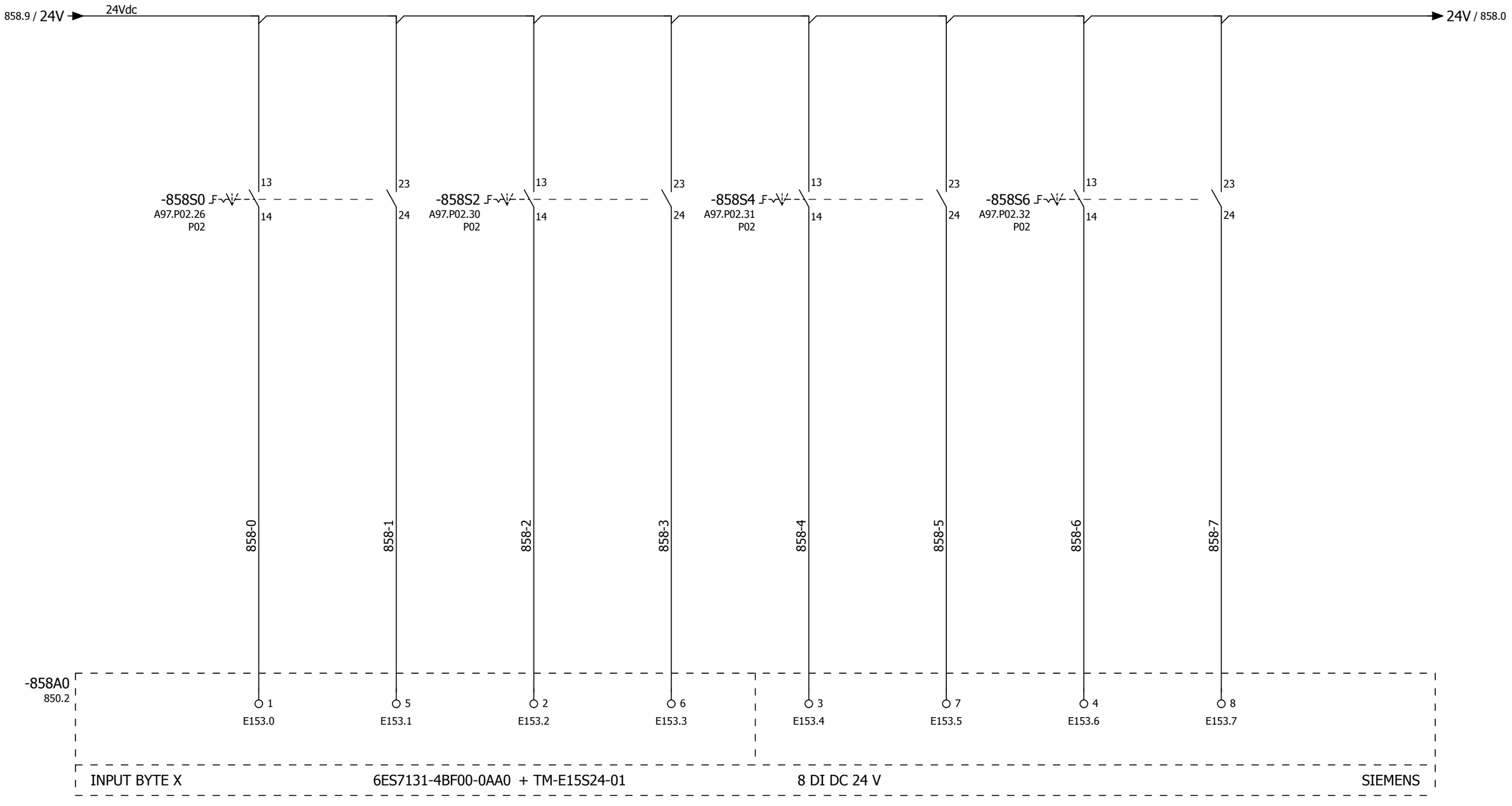


UNCOILER MOTOR SIDE	UNCOILER OPERATOR SIDE	MACHINE POSITIONING START	MACHINE POSITIONING STOP
STRAIGHTENER PINCH ROLL FORWARD	STRAIGHTENER PINCH ROLL BACKWARD	ENTRY STRAIGHTENER PINCH ROLL CLOSE	ENTRY STRAIGHTENER PINCH ROLL OPEN

⇦856

858⇨

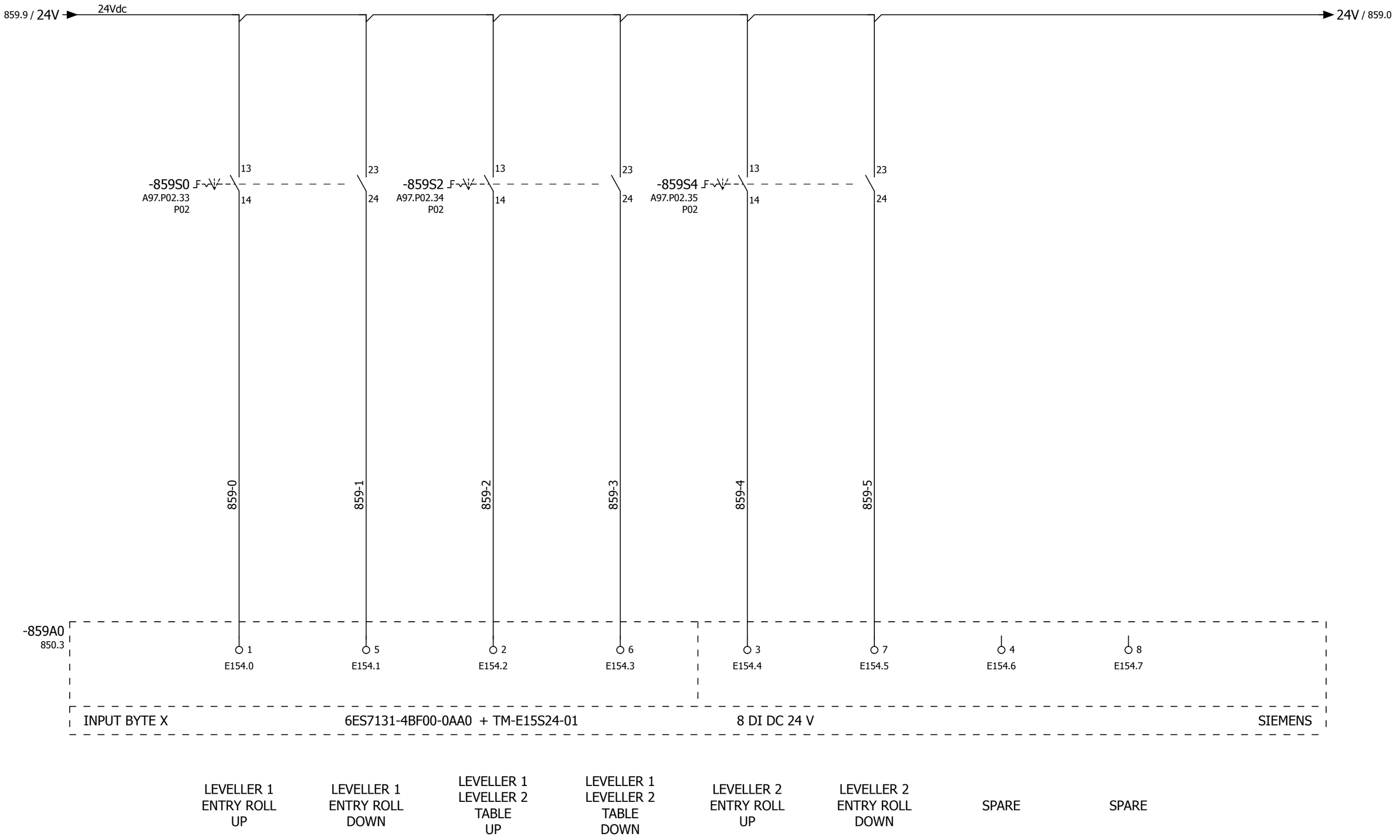
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	857
Revision			Replacement of / Replaced by			Group: / Of	414



⇦857

859⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	858
Revision			Replacement of / Replaced by			Group: / Of	414



858

867

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	859
Revision		Replacement of	Replaced by			Group:	Of 414

867.9 / 24V — 24Vdc

24V / 867.0

-867S2
A97.P02.37
P02
13
14
23
24

-867S4
A97.P02.39
A97.P02.63
P02
13
14
23
24

-867S6
A97.P02.40
A97.P02.64
P02
13
14
23
24

867-2
867-3
867-4
867-5
867-6
867-7

-867A0
850.3

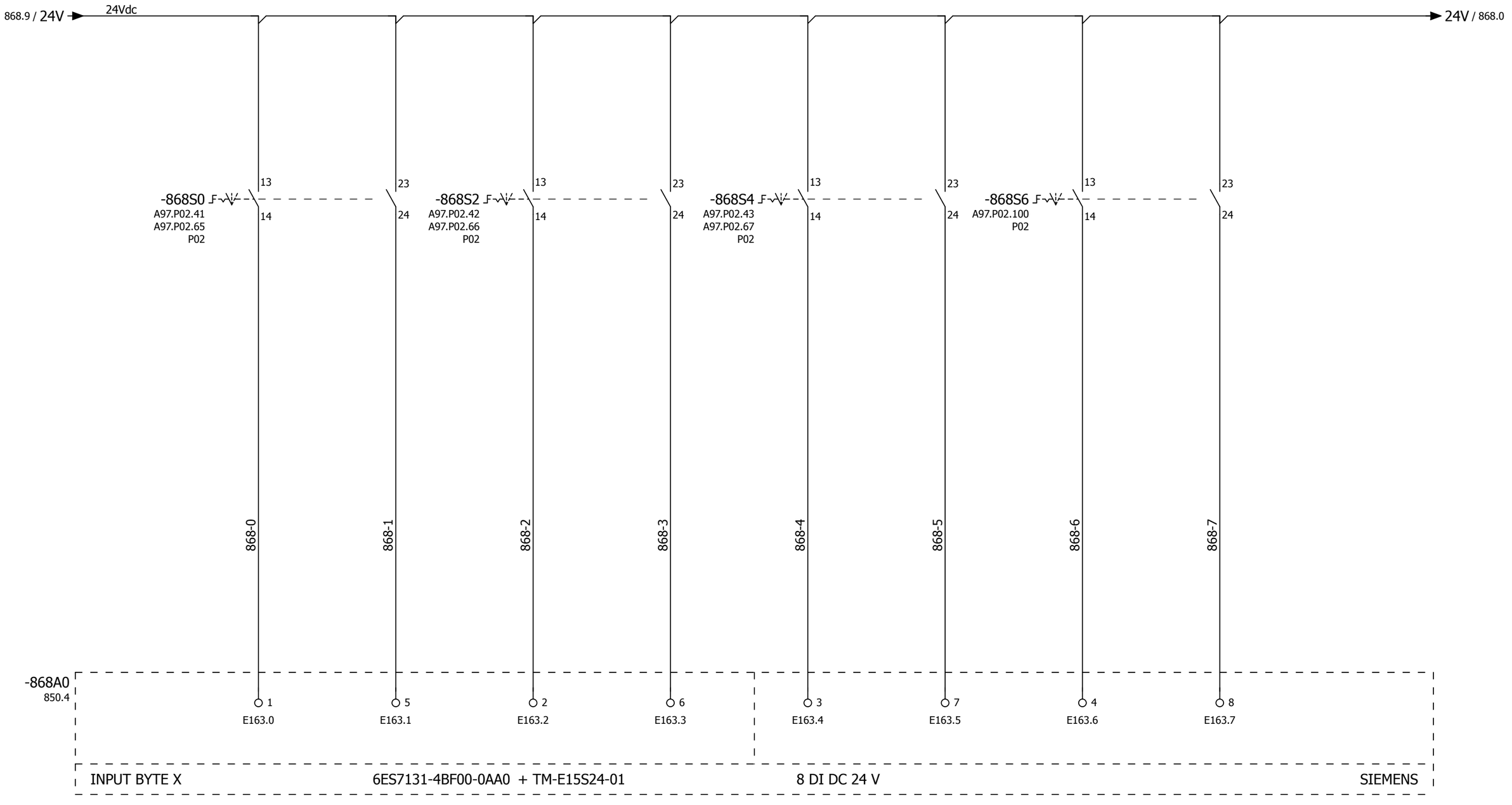
	1	5	2	6	3	7	4	8
	E162.0	E162.1	E162.2	E162.3	E162.4	E162.5	E162.6	E162.7

INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

SPARE	SPARE	LEVELLER 1 FORWARD	LEVELLER 1 BACKWARD	LEVELLER BACK UP ROLL 1 UP	LEVELLER BACK UP ROLL 1 DOWN	LEVELLER BACK UP ROLL 2 UP	LEVELLER BACK UP ROLL 2 DOWN

⇦859

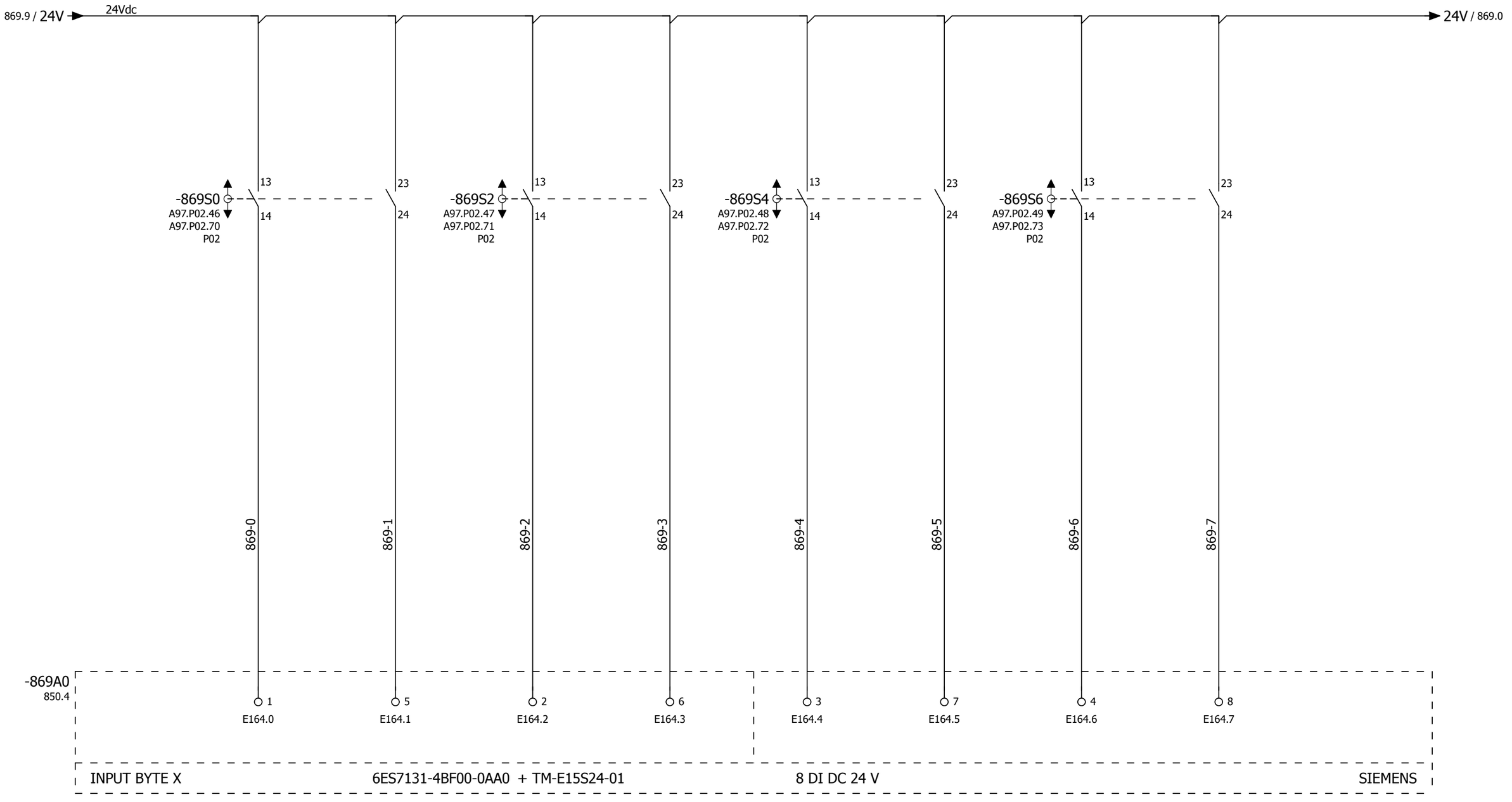
868⇨



⇦867

869⇨

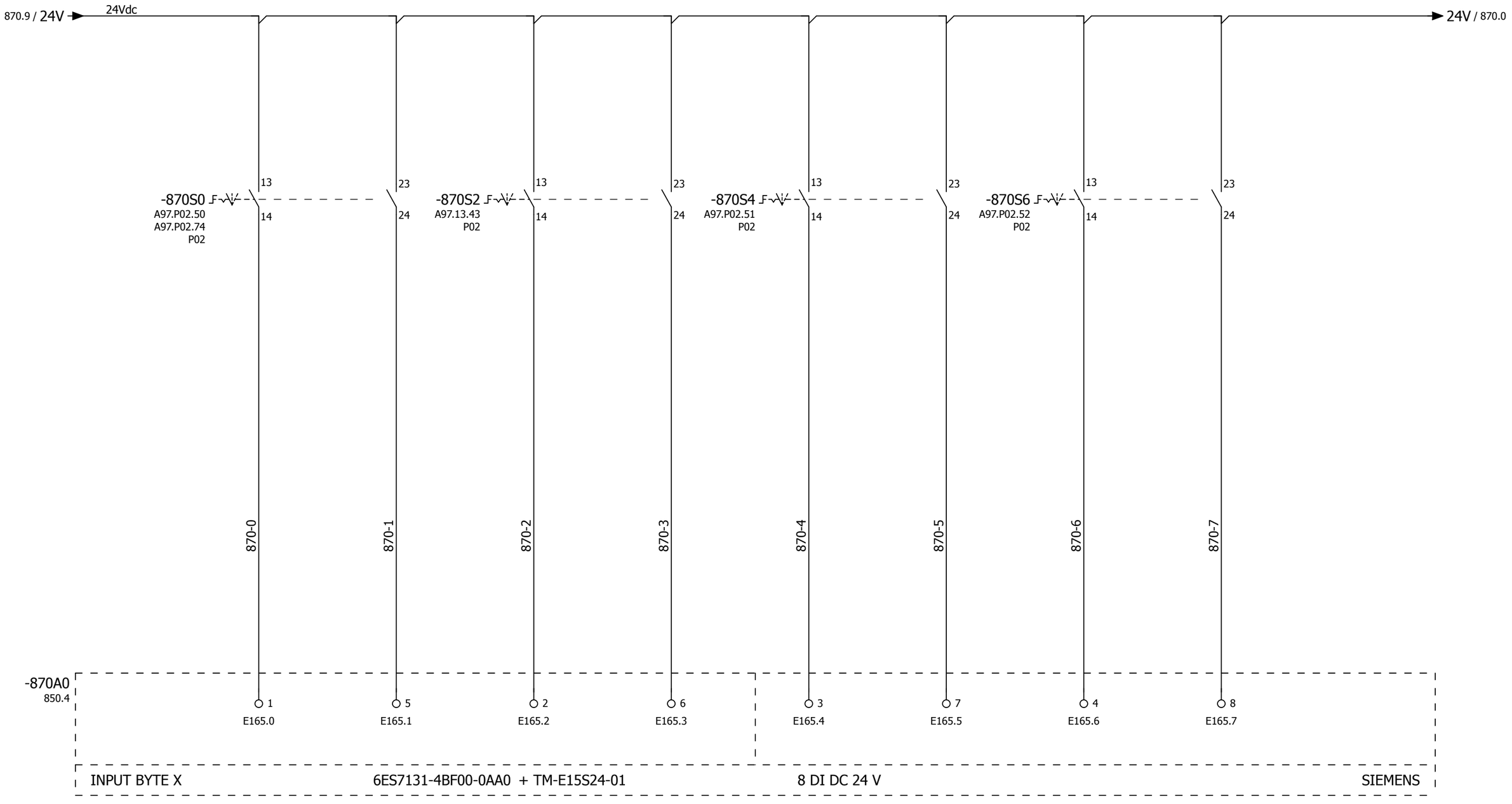
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	868
Revision		Replacement of	Replaced by			Group:	Of 414



⇦868

870⇨

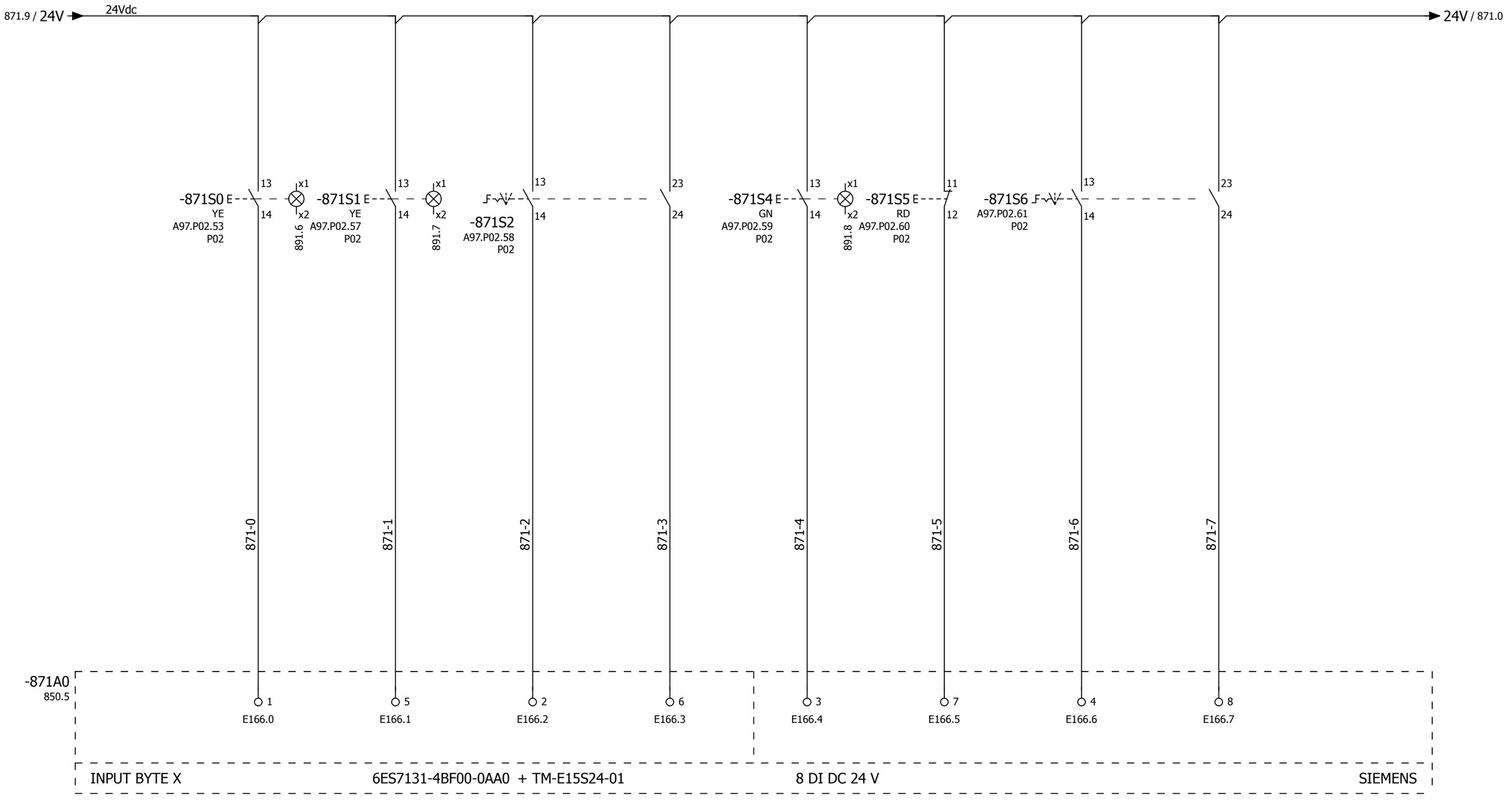
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	869
Revision			Replacement of / Replaced by			Group: / Of	414



⇦869

871⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	870
Revision		Replacement of	Replaced by			Group:	Of 414

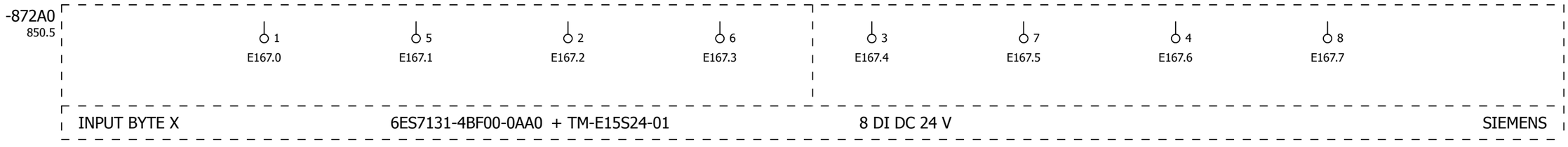


⇦870

872⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	871
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



SPARE SPARE SPARE SPARE SPARE SPARE SPARE SPARE

⇦871

873⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	872
Revision			Replacement of / Replaced by			Group: / Of	414

873.9 / 24V → 24Vdc

24V / 873.0

-873S2
A97.P02.44
A97.P02.68
P02

-873S4
A97.P02.45
A97.P02.69
P02

13 23 14 24

868-2 868-3 868-4 868-5

-873A0
850.5

1	5	2	6	3	7	4	8
E168.0	E168.1	E168.2	E168.3	E168.4	E168.5	E168.6	E168.7

INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

SPARE	SPARE	LEVELLER BACK UP ROLL 6 UP	LEVELLER BACK UP ROLL 6 DOWN	LEVELLER BACK UP ROLL 7 UP	LEVELLER BACK UP ROLL 7 DOWN	SPARE	SPARE

⇦872

875⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 873
Revision			Replacement of / Replaced by			Group:	Of 414

875.9 / 24V

24Vdc

24V / 875.0

-875S0
A97.P02.76
P02
13
14
23
24

-875S2
A97.P02.77
P02
13
14
23
24

-875S4 E
YE
A97.P02.78
P02
13
14
x1
x2
892.2

-875S5 E
YE
A97.P02.79
P02
13
14
x1
x2
892.2

-875S6
A97.P02.83
P02
13
14
23
24

875-0
875-1
875-2
875-3
875-4
875-5
875-6
875-7

-875A0
850.6

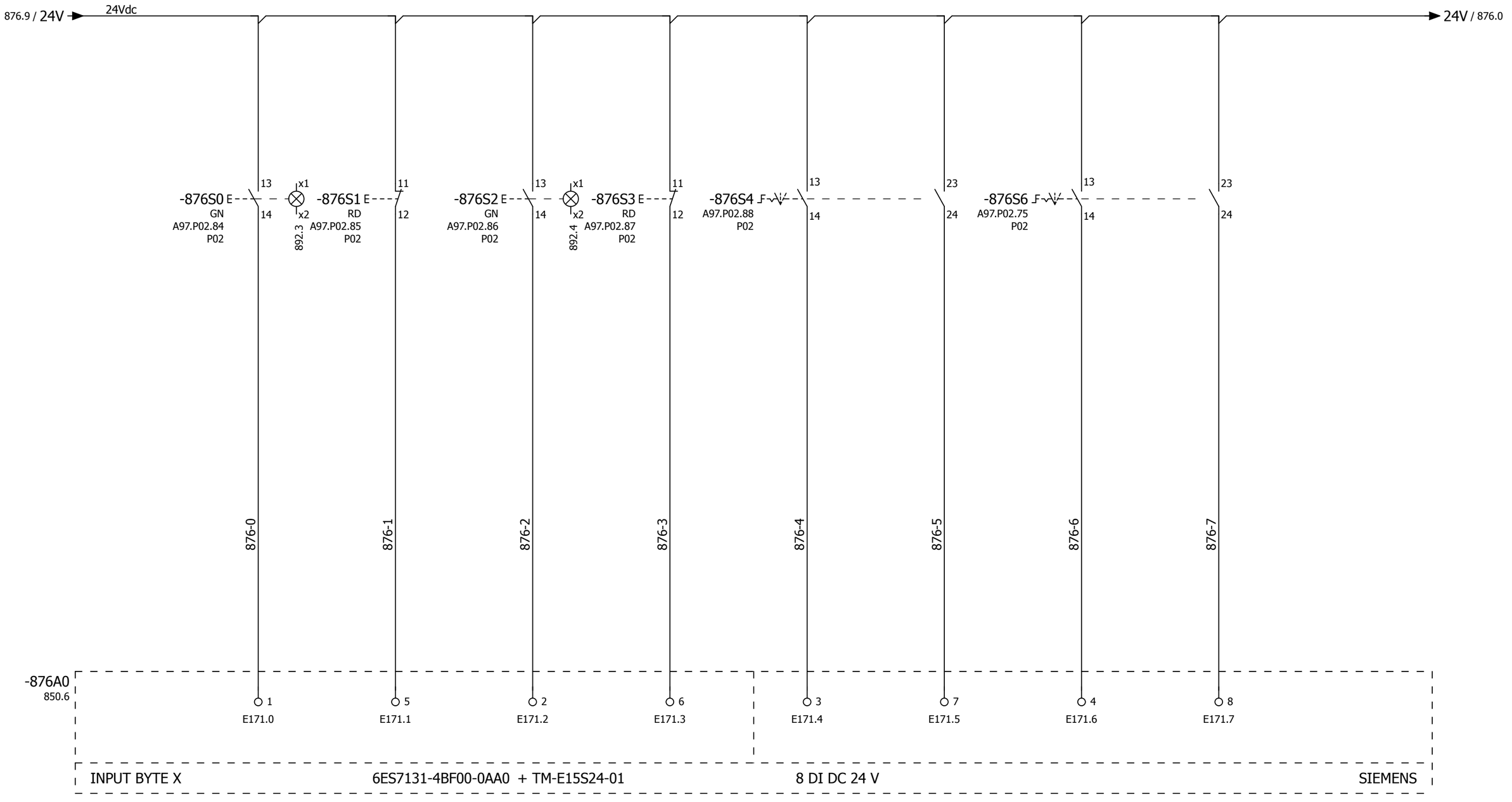
1	5	2	6	3	7	4	8
E170.0	E170.1	E170.2	E170.3	E170.4	E170.5	E170.6	E170.7

INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

LEVELLER 2 UPPER BENCH LOCKED	LEVELLER 2 UPPER BENCH RELEASE	LEVELLER 2 LOWER BENCH LOCKED	LEVELLER 2 LOWER BENCH RELEASE	LEVELLER 2 SELECTION	LEVELLER 2 GREASE LUBRICATION RESET	LEVELLER 2 OPERATOR SIDE CLEANING ROLLS	LEVELLER 2 MOTOR SIDE CLEANING ROLLS

⇦873

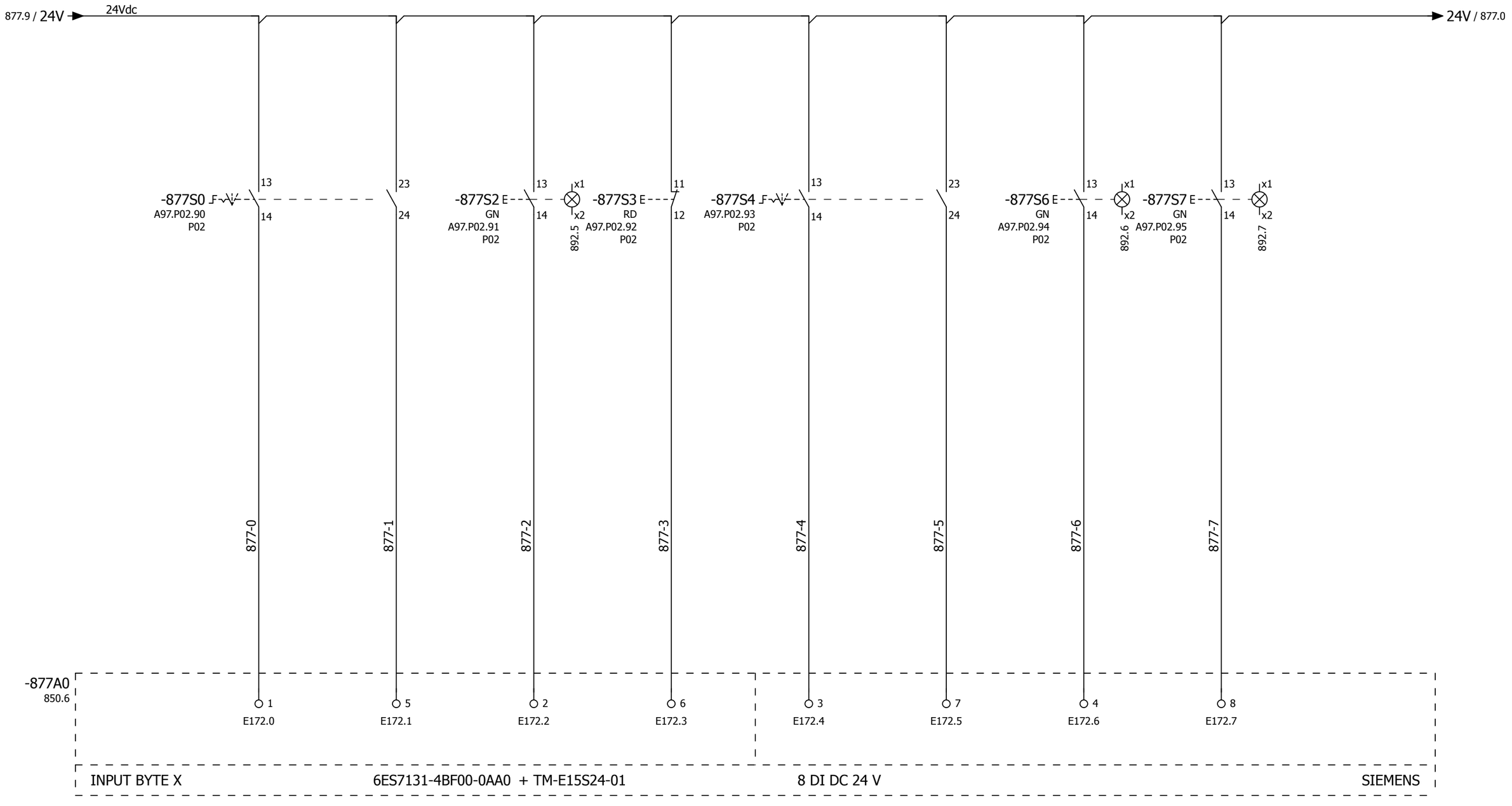
876⇨



⇦875

877⇨

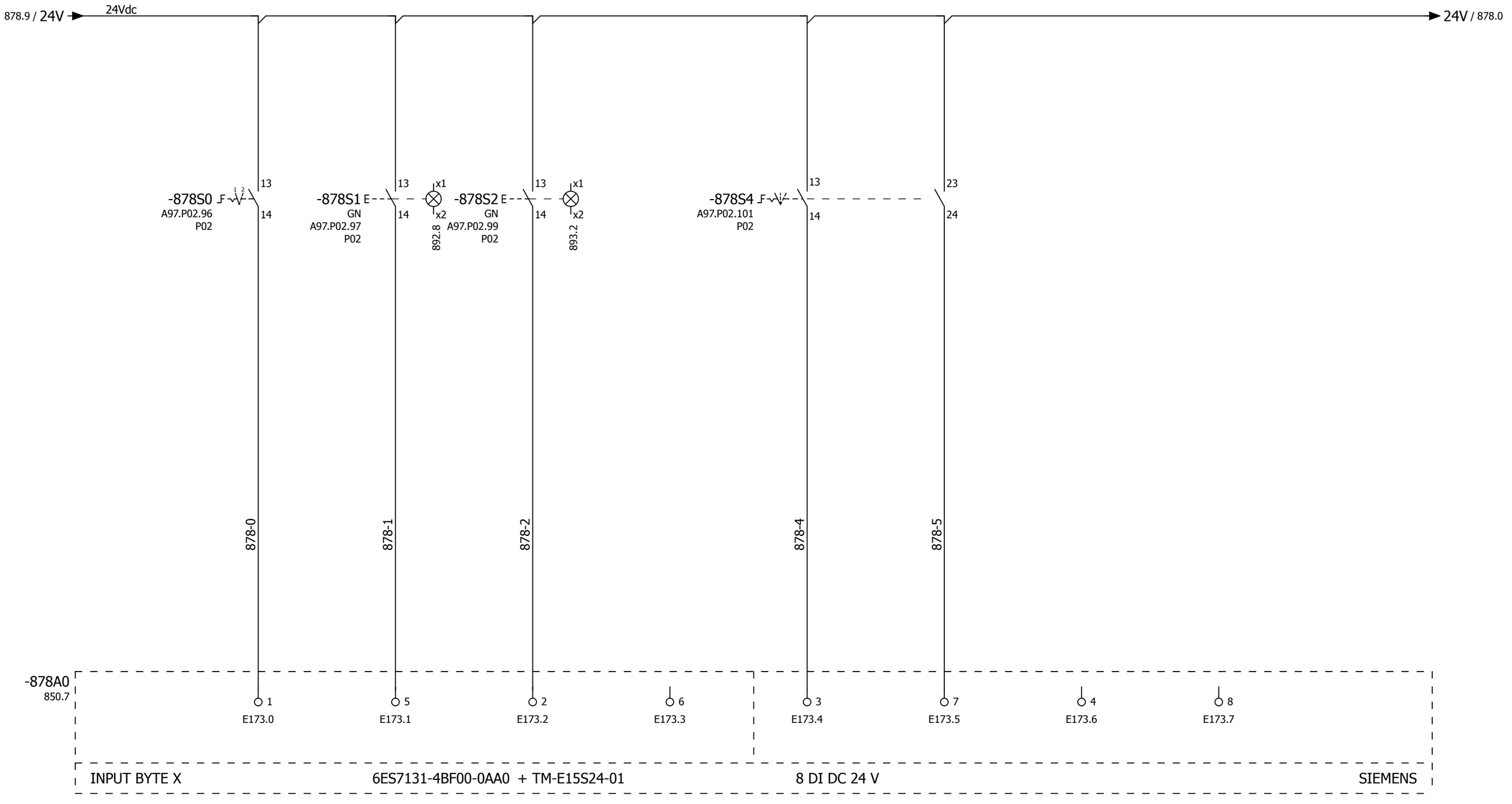
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	876
Revision			Replacement of / Replaced by			Group: / Of	414



⇦876

878⇨

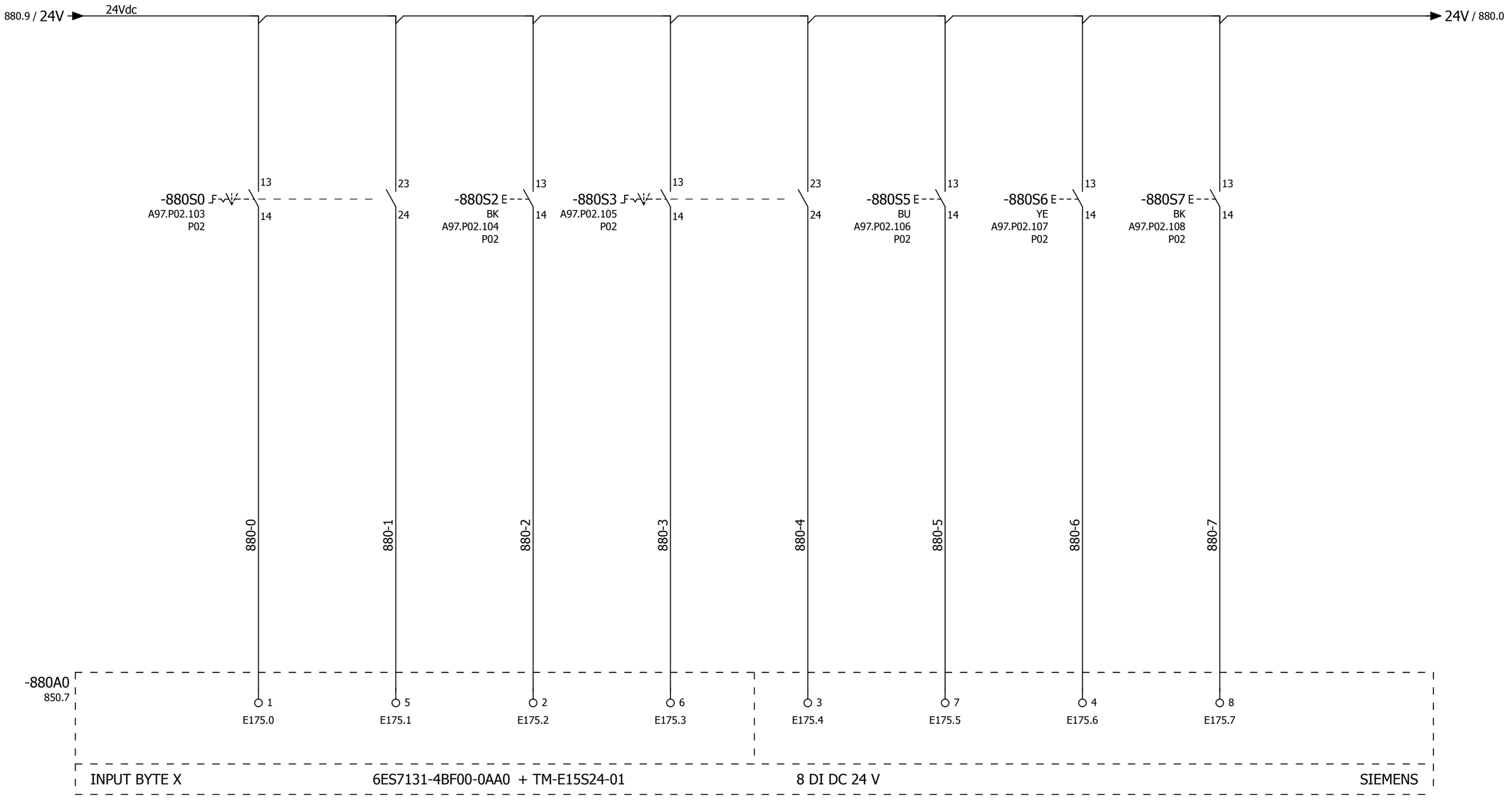
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		ERCA elettromeccanica s.r.l.	Function: Digital input P02 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	877
Revision			Replacement of / Replaced by			Group: / Of	414



⇦877

880⇨

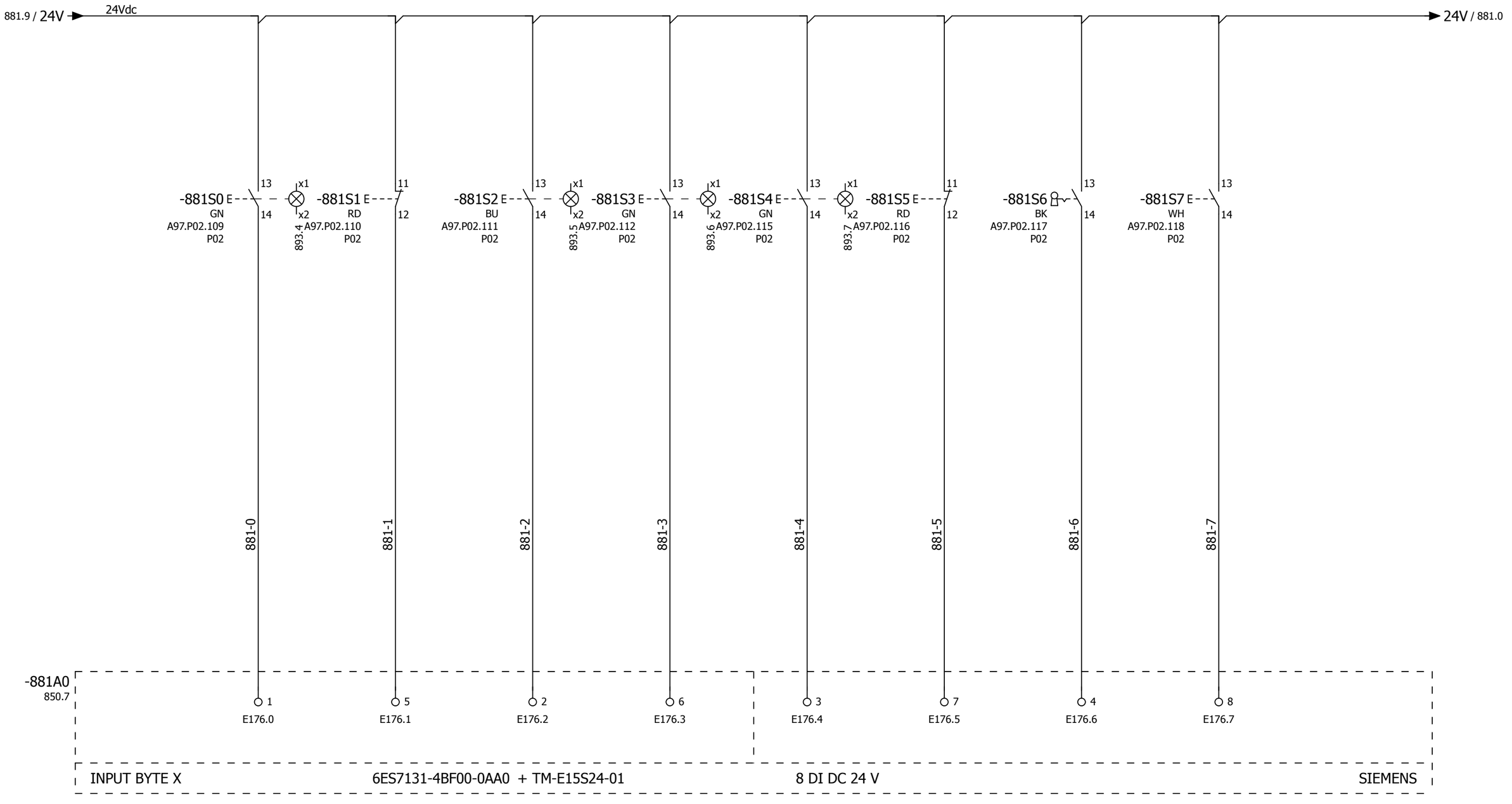
Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 878
Revision		Replacement of	Replaced by			Group:	Of 414



⇦878

881⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	880
Revision		Replacement of	Replaced by			Group:	Of 414



FLYING SHEAR AUTOMATIC

FLYING SHEAR MANUAL

FLYING SHEAR ALARMS RESET

FLYING SHEAR AUTOMATIC CUT

FLYING SHEAR FLYWHEEL START

FLYING SHEAR FLYWHEEL STOP

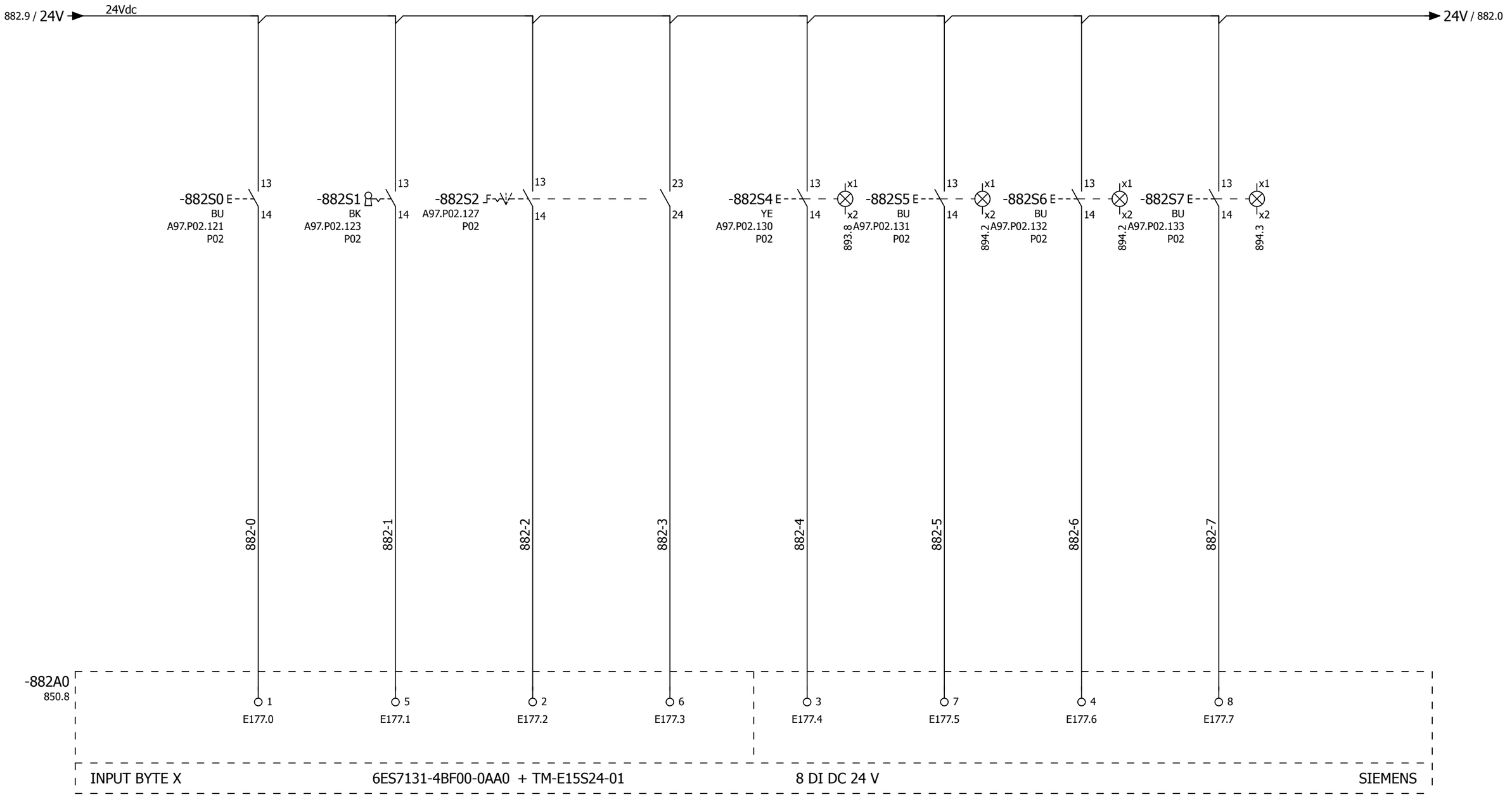
FLYING SHEAR MAINTENANCE WORK

FLYING SHEAR CUT

⇦880

882⇨

Date	15/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	881
Revision		Replacement of	Replaced by			Group:	Of 414



FLYING SHEAR RESET N° CUT

FLYING SHEAR BLADES CHANGE DISABLE ENABLE

FLYING SHEAR BLADES CLEARANCE -

FLYING SHEAR BLADES CLEARANCE +

FLYING SHEAR GREASE LUBRICATION RESET

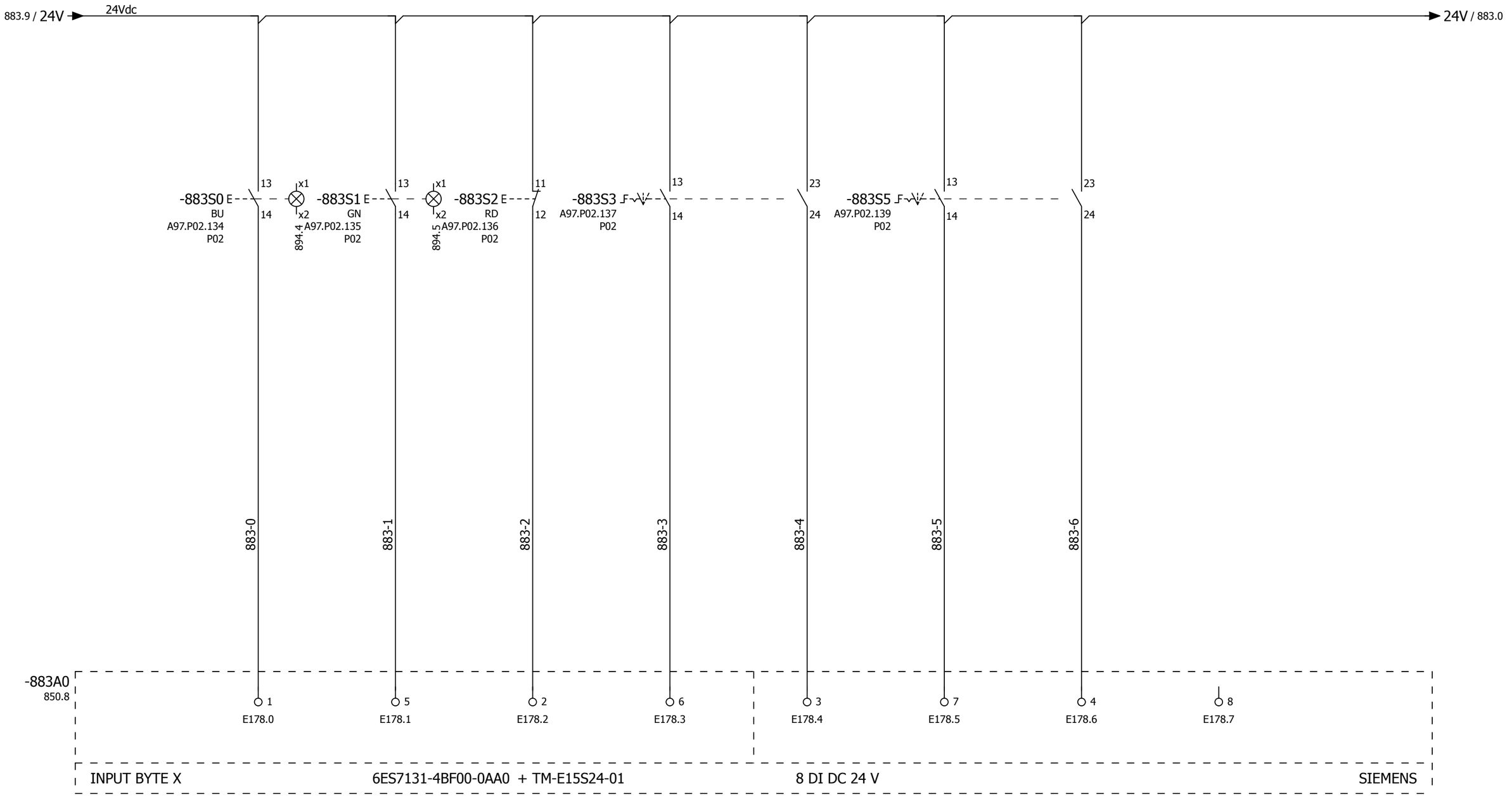
FLYING SHEAR BLADES CHANGE POSITION 1

FLYING SHEAR BLADES CHANGE POSITION 2

FLYING SHEAR BLADES CHANGE POSITION 3

⇦881

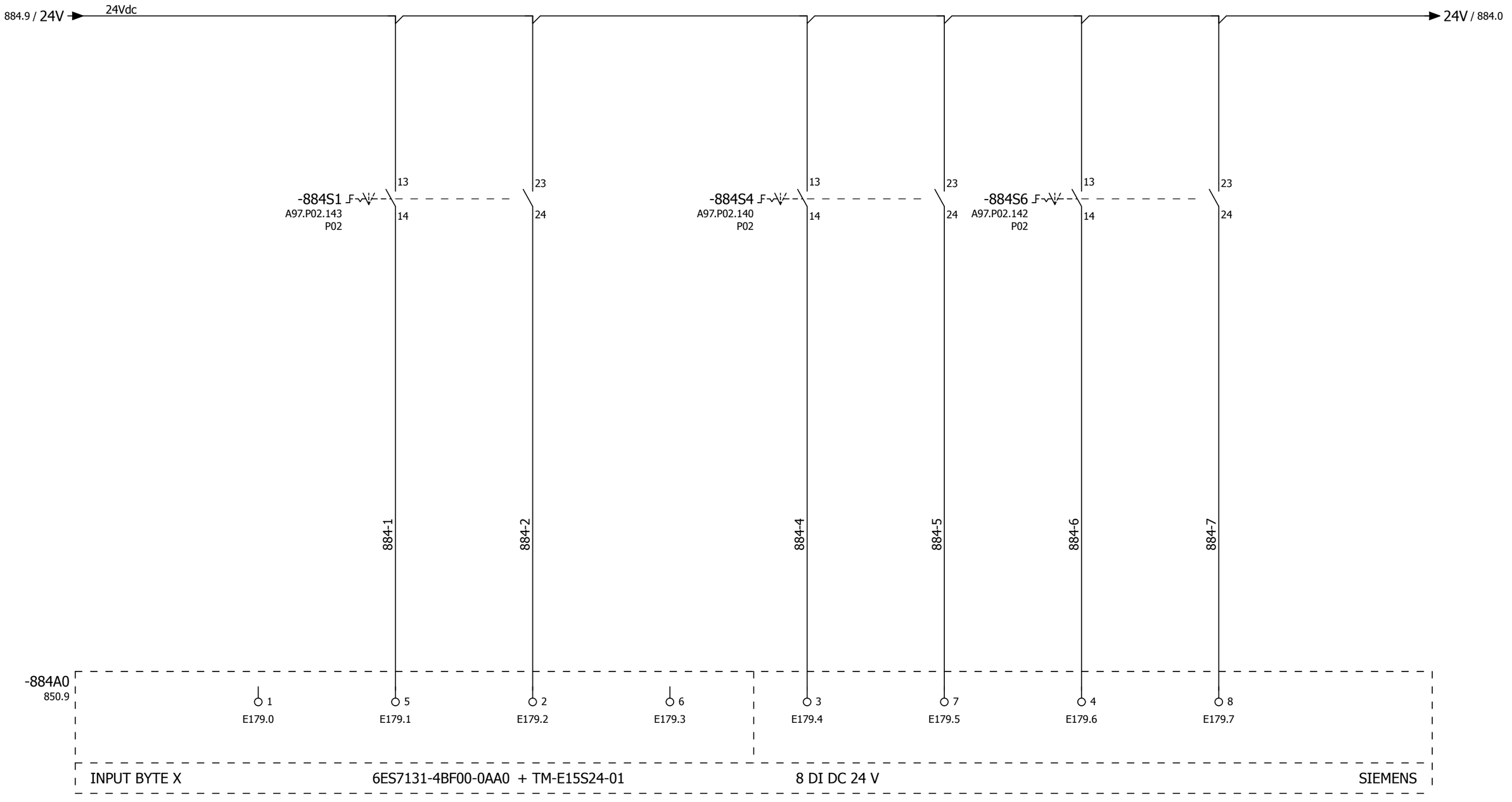
883⇨



⇦882

884⇨

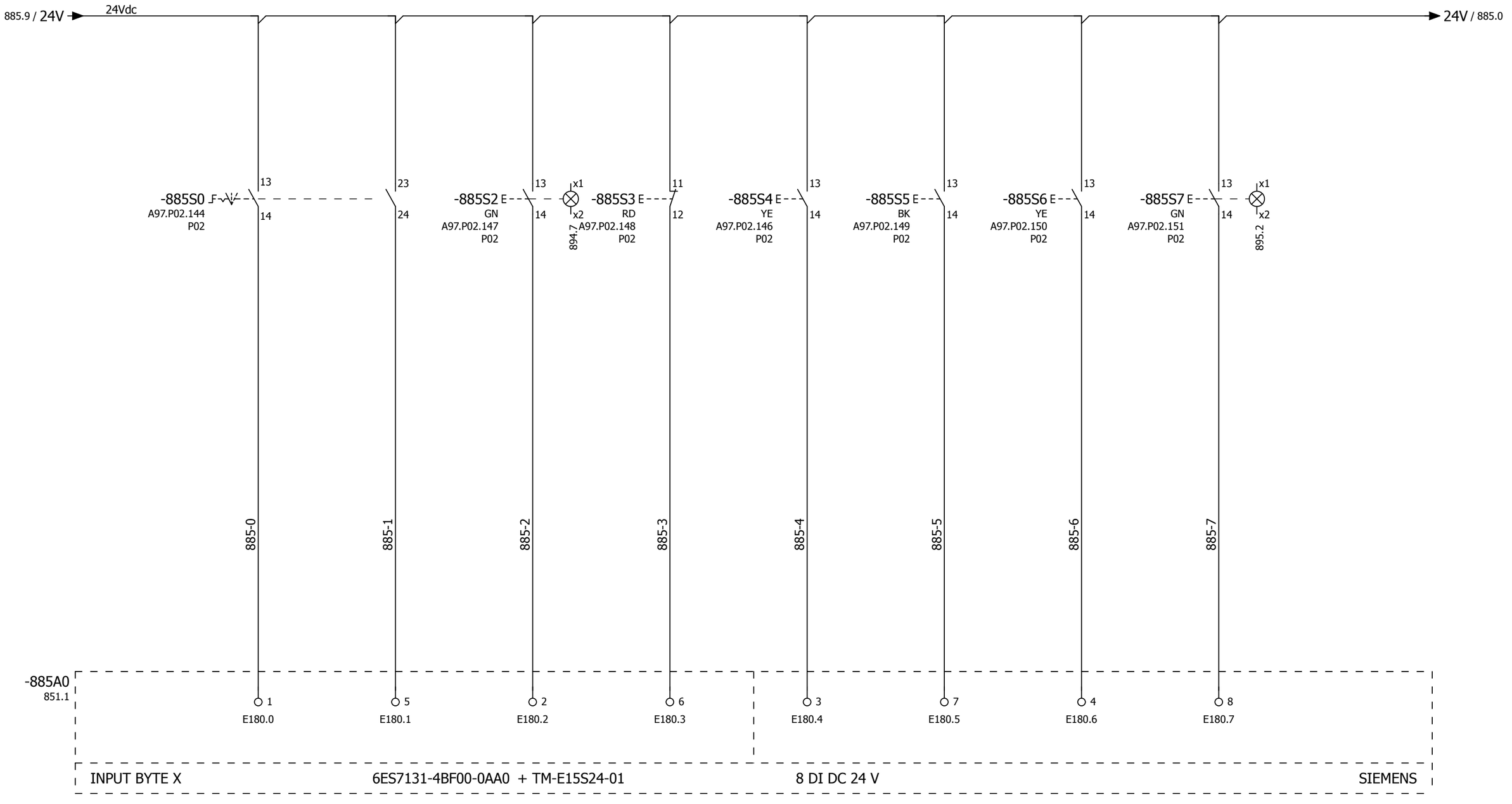
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	883
Revision		Replacement of	Replaced by			Group:	Of 414



⇦883

885⇨

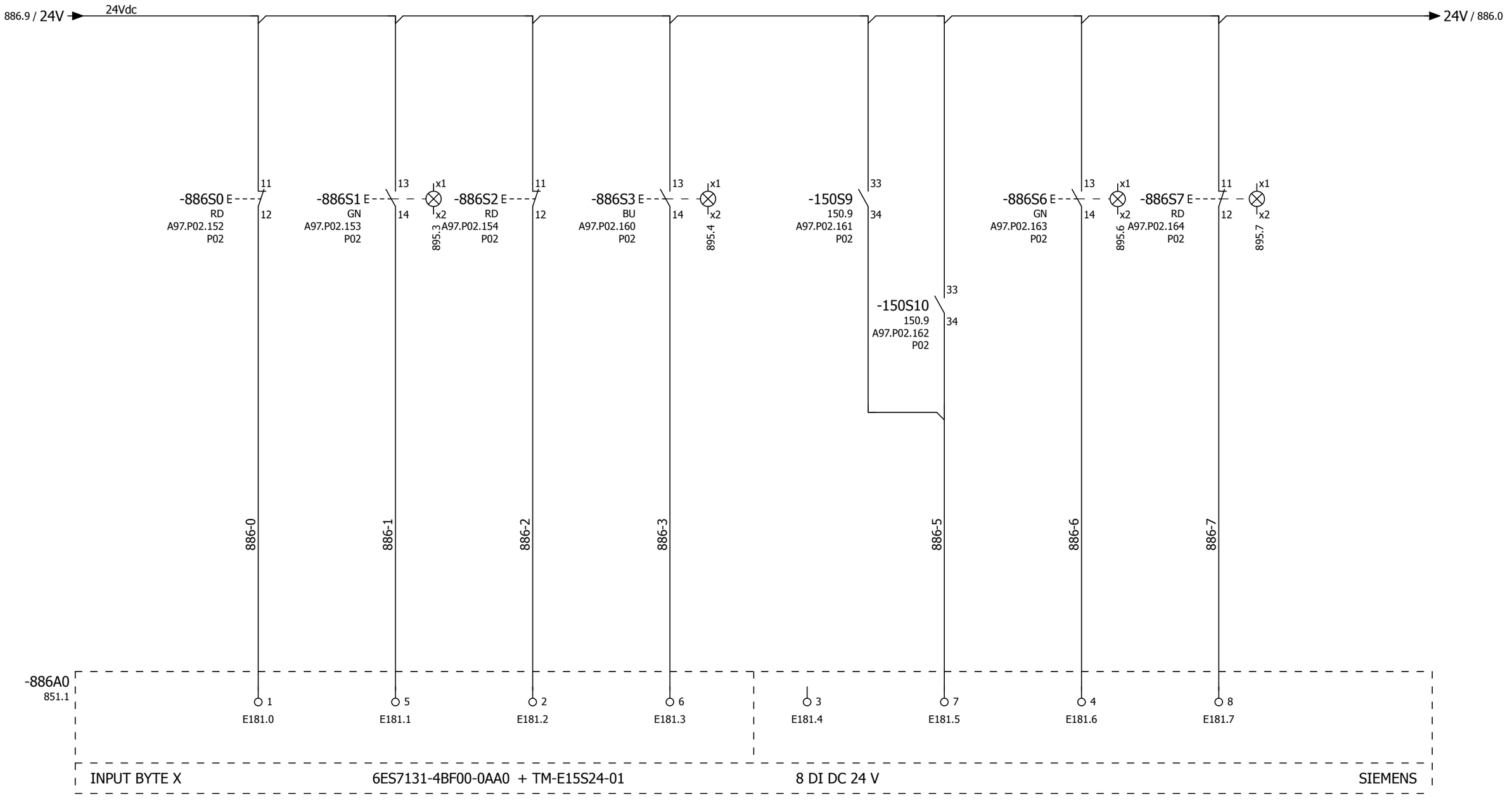
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 884
Revision		Replacement of	Replaced by			Group:	Of 414



⇦884

886⇨

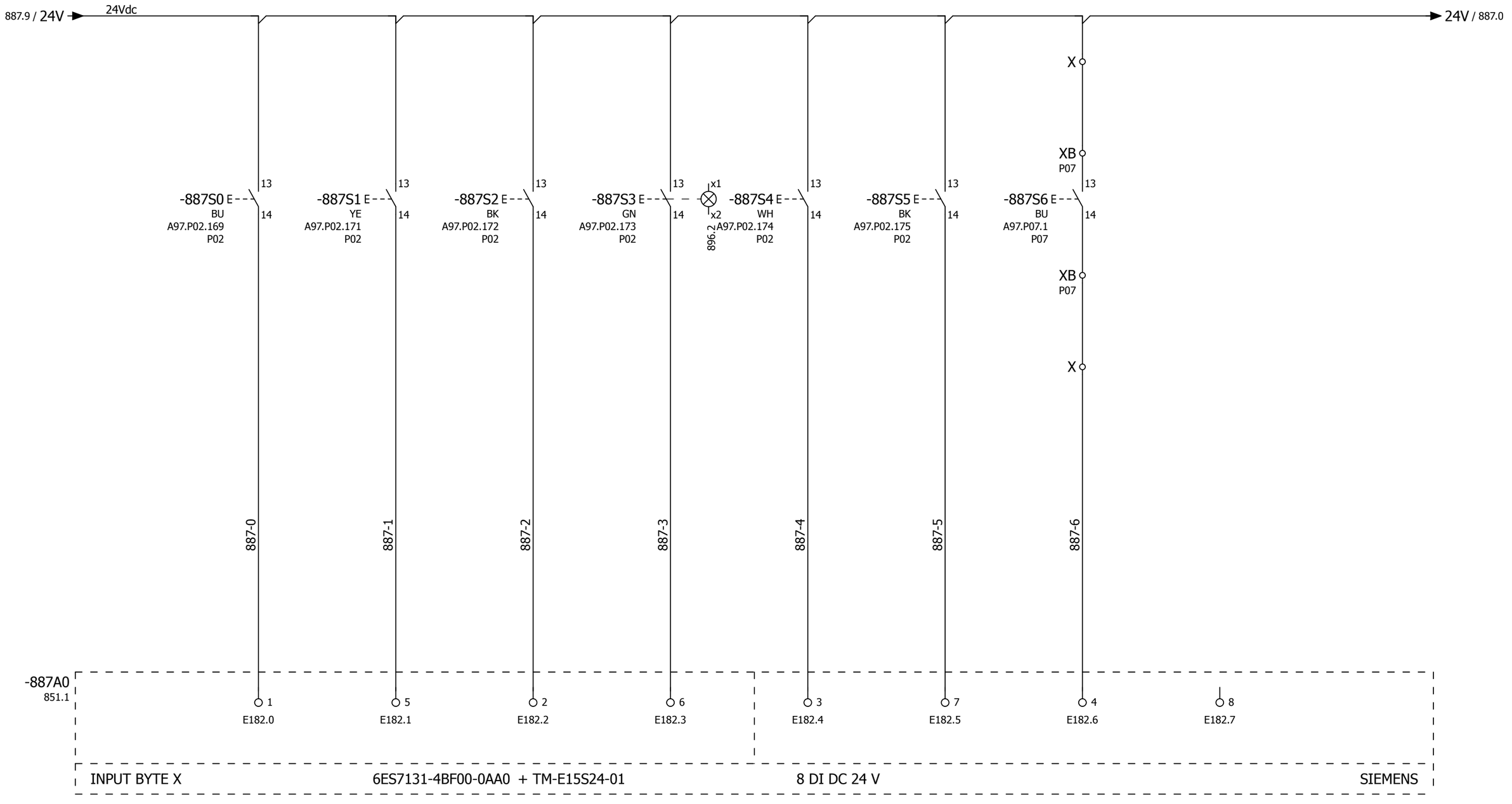
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	885
Revision		Replacement of	Replaced by			Group:	Of 414



⇦885

887⇨

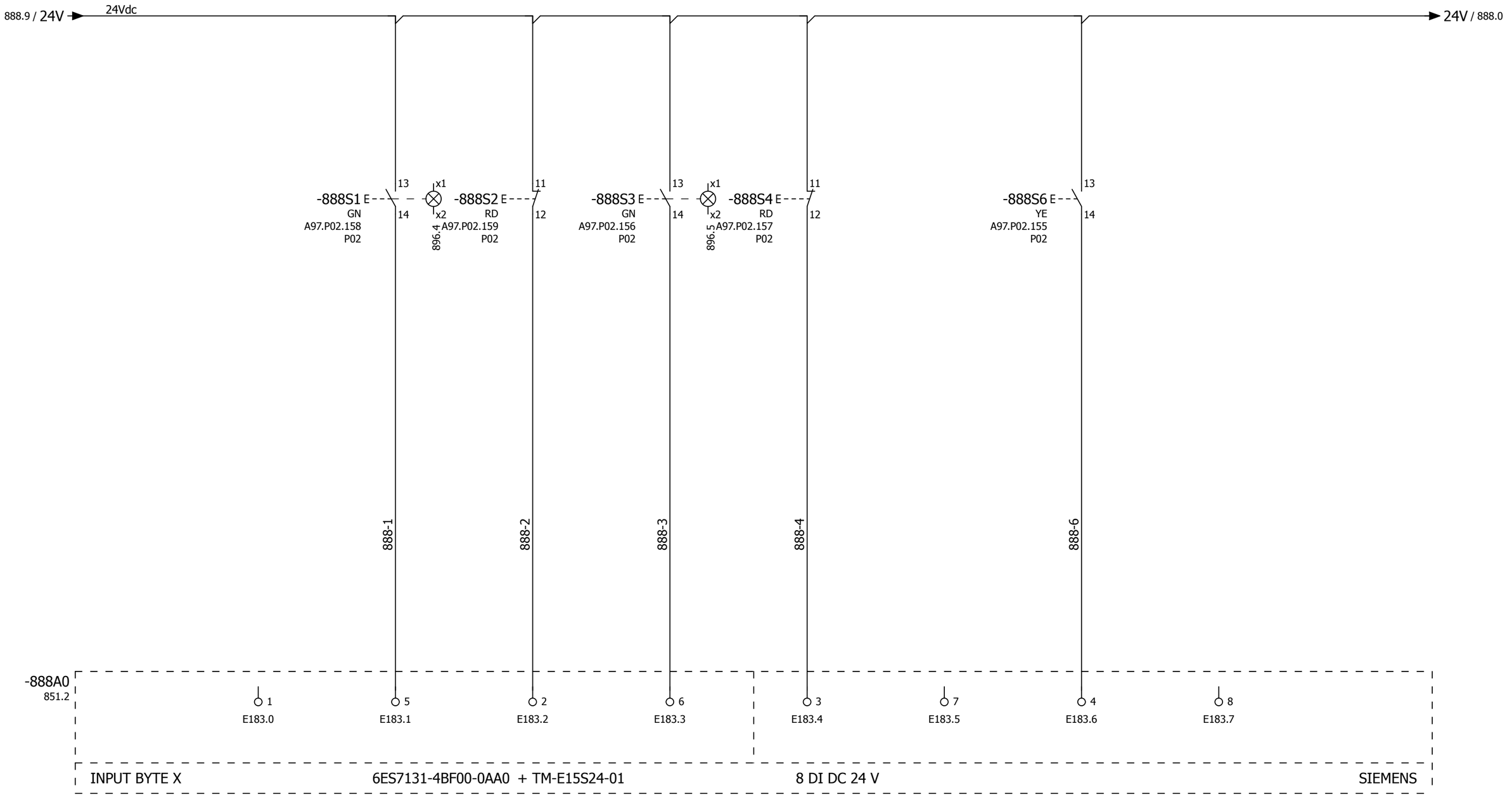
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	886
Revision		Replacement of	Replaced by			Group:	Of 414



⇦886

888⇨

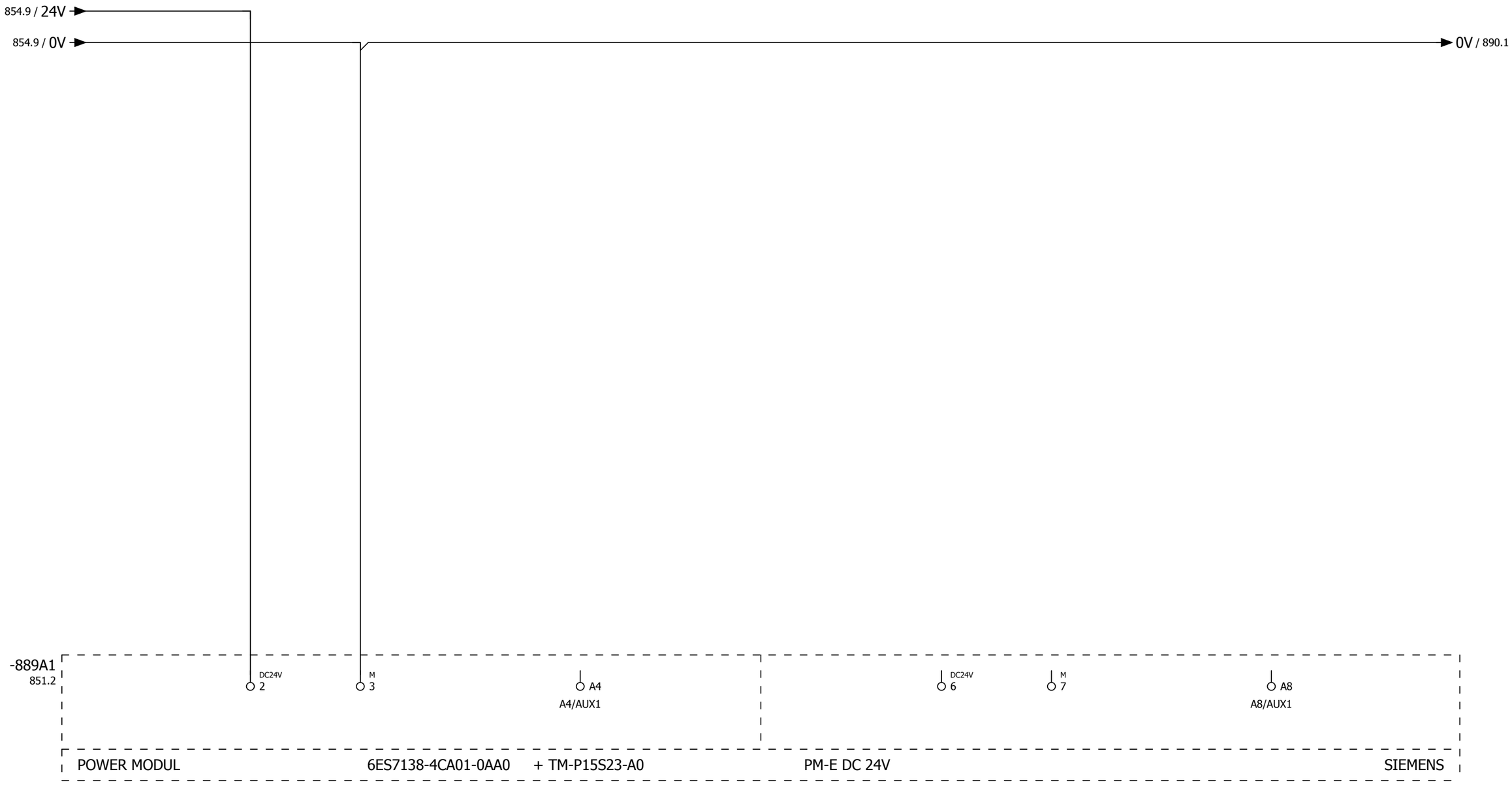
Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P02-P07 console digital input		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	887
Revision		Replacement of	Replaced by			Group:	Of 414



SPARE	1° CHOICE STACKER 2° BOX AUTOMATIC	1° CHOICE STACKER 2° BOX MANUAL	1° CHOICE STACKER ASPIRATION CONVEYOR BELT START	1° CHOICE STACKER ASPIRATION CONVEYOR BELT STOP	SPARE	SUPPORTS MANUAL CYCLE STACKER 2° BOX	SPARE

⇦887

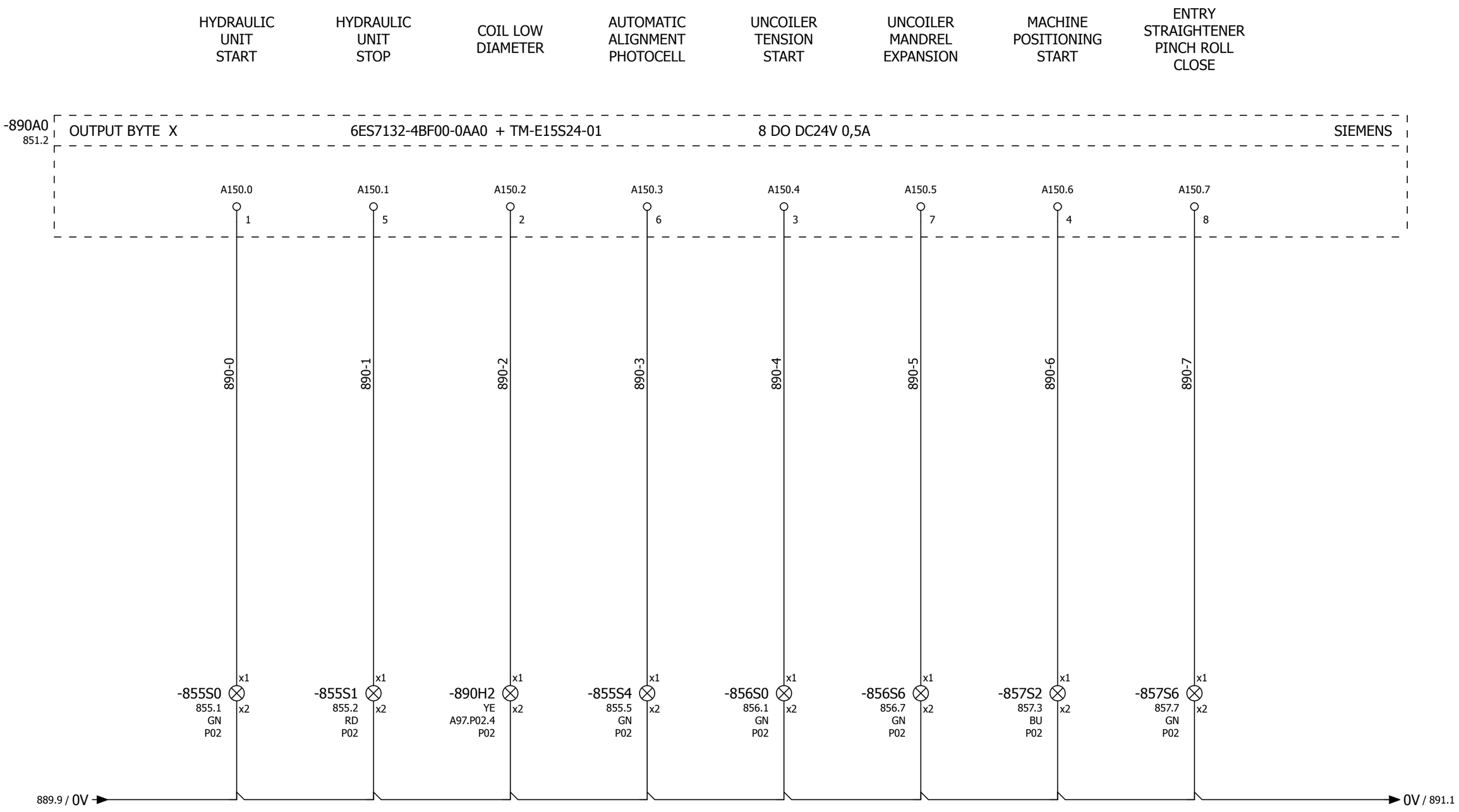
889⇨



888

890

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	889
Revision		Replacement of	Replaced by			Group:	Of 414

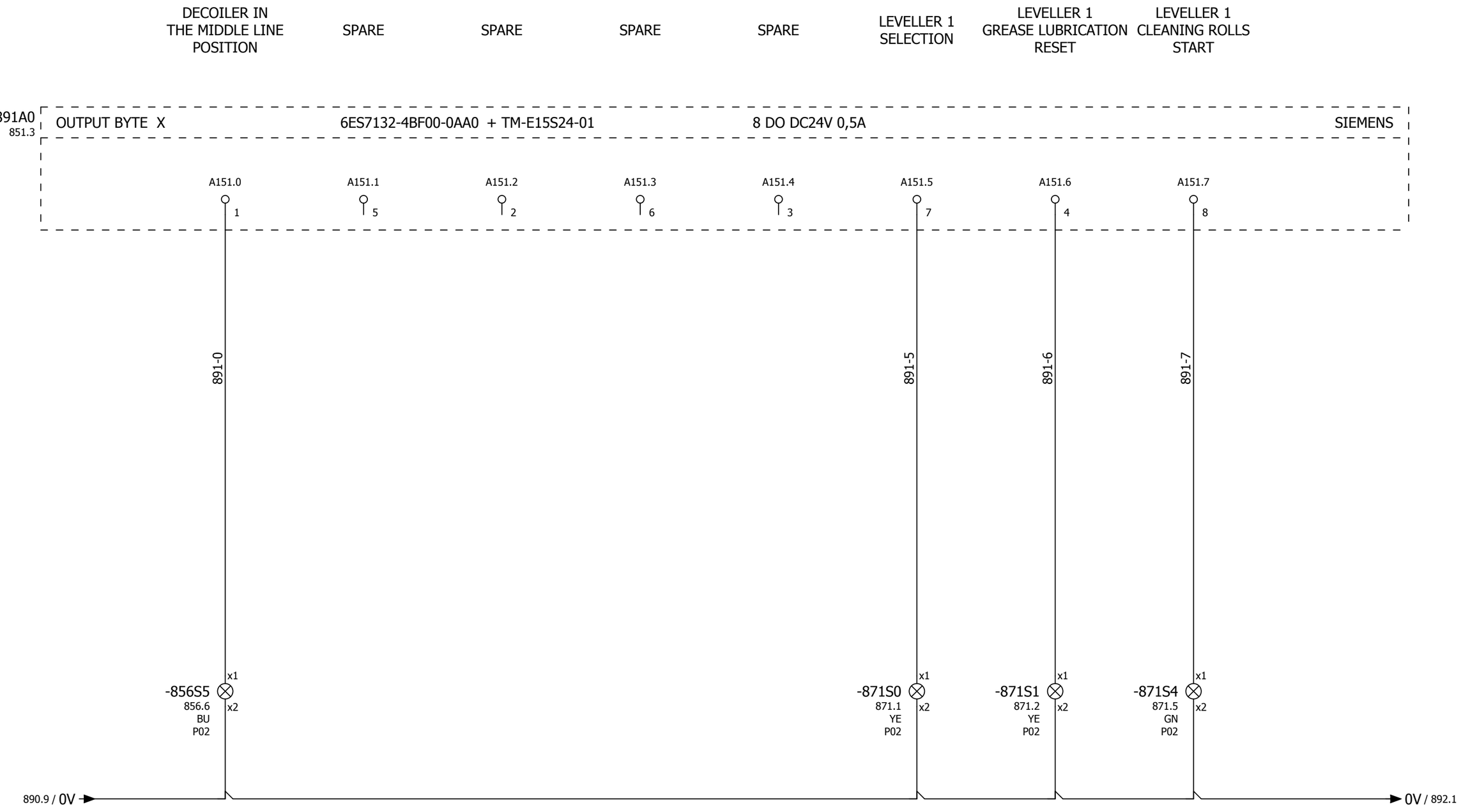


⇦889

891⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	890
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



⇦890

892⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	891
Revision		Replacement of	Replaced by			Group:	Of 414

LEVELLER 2 SELECTION	LEVELLER 2 GREASE LUBRICATION RESET	LEVELLER 2 CLEANING ROLLS START	MEASURING WHEEL DOWN	PLASTICIZEN DEVICE UPPER ROLL CLOSE	LOWER HEATING PAPER LAMP 1 ON	LOWER HEATING PAPER LAMP 2 ON	LOWER PRE HEATING PAPER LAMPS ON

-892A0
851.3

OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A152.0	A152.1	A152.2	A152.3	A152.4	A152.5	A152.6	A152.7
1	5	2	6	3	7	4	8
892-0	892-1	892-2	892-3	892-4	892-5	892-6	892-7

-875S4	-875S5	-876S0	-876S2	-877S2	-877S6	-877S7	-878S1
x1 / x2	x1 / x2	x1 / x2	x1 / x2	x1 / x2	x1 / x2	x1 / x2	x1 / x2
875.5	875.6	876.1	876.3	877.3	877.7	877.7	878.2
YE	YE	GN	GN	GN	GN	GN	GN
P02	P02	P02	P02	P02	P02	P02	P02

891.9 / 0V → ... → 0V / 893.1

⇦891 893⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 892
Revision			Replacement of / Replaced by			Group:	Of 414

ELECTRIFIER ON / OFF	SPARE	SPARE	FLYING SHEAR AUTOMATIC	FLYING SHEAR ALARMS RESET	FLYING SHEAR AUTOMATIC CUT	FLYING SHEAR FLYWHEEL START	FLYING SHEAR GREASE LUBRICATION RESET

-893A0
851.4
OUTPUT BYTE X — 6ES7132-4BF00-0AA0 + TM-E15S24-01 — 8 DO DC24V 0,5A — SIEMENS

A153.0	A153.1	A153.2	A153.3	A153.4	A153.5	A153.6	A153.7
1	5	2	6	3	7	4	8
893-0			893-3	893-4	893-5	893-6	893-7

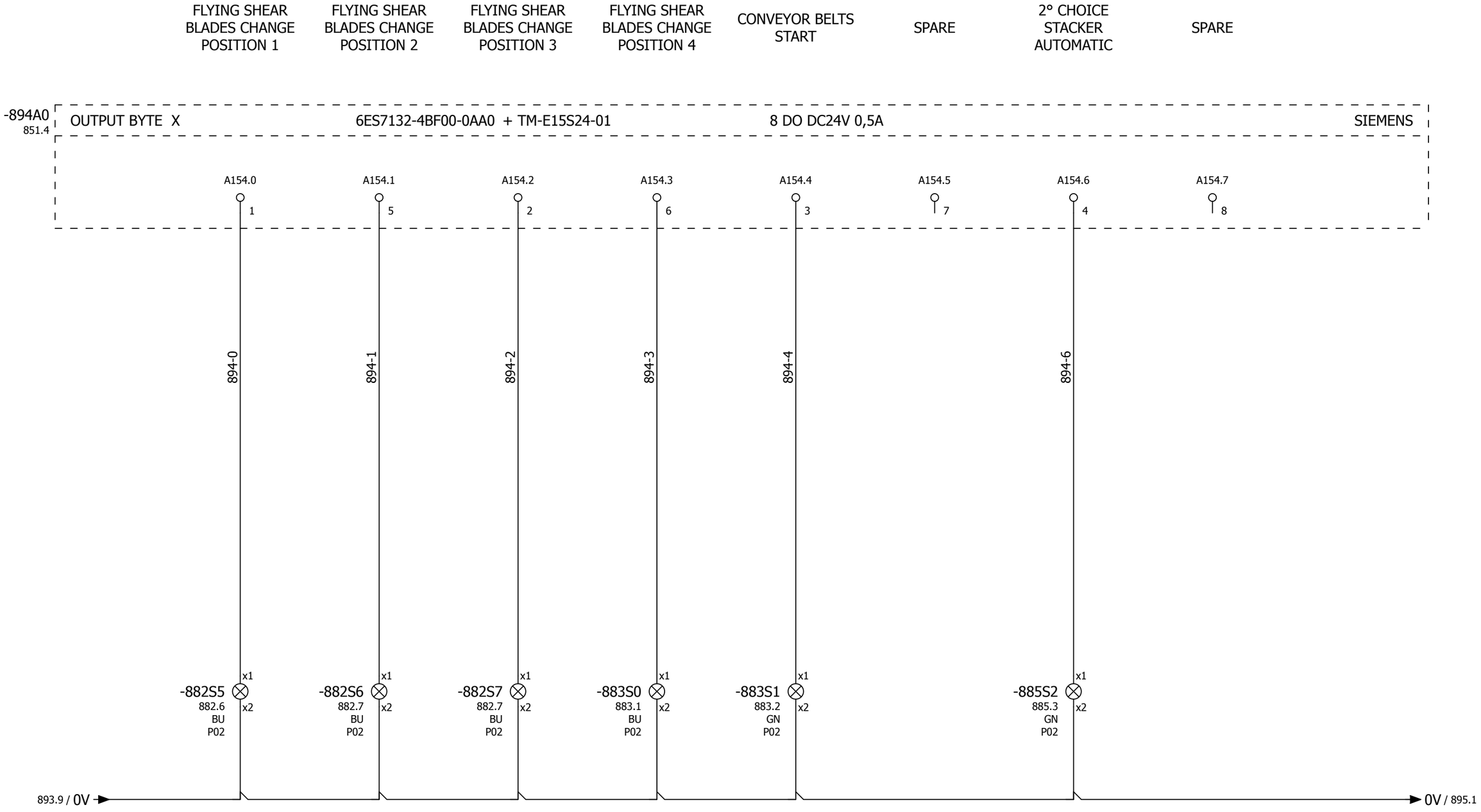
-878S2	-881S0	-881S2	-881S3	-881S4	-882S4
x1 / x2	x1 / x2	x1 / x2	x1 / x2	x1 / x2	x1 / x2
878.3	881.1	881.3	881.4	881.5	882.5
GN	GN	BU	GN	GN	YE
P02	P02	P02	P02	P02	P02

892.9 / 0V → ... → 0V / 894.1

⇦892 894⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	893
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

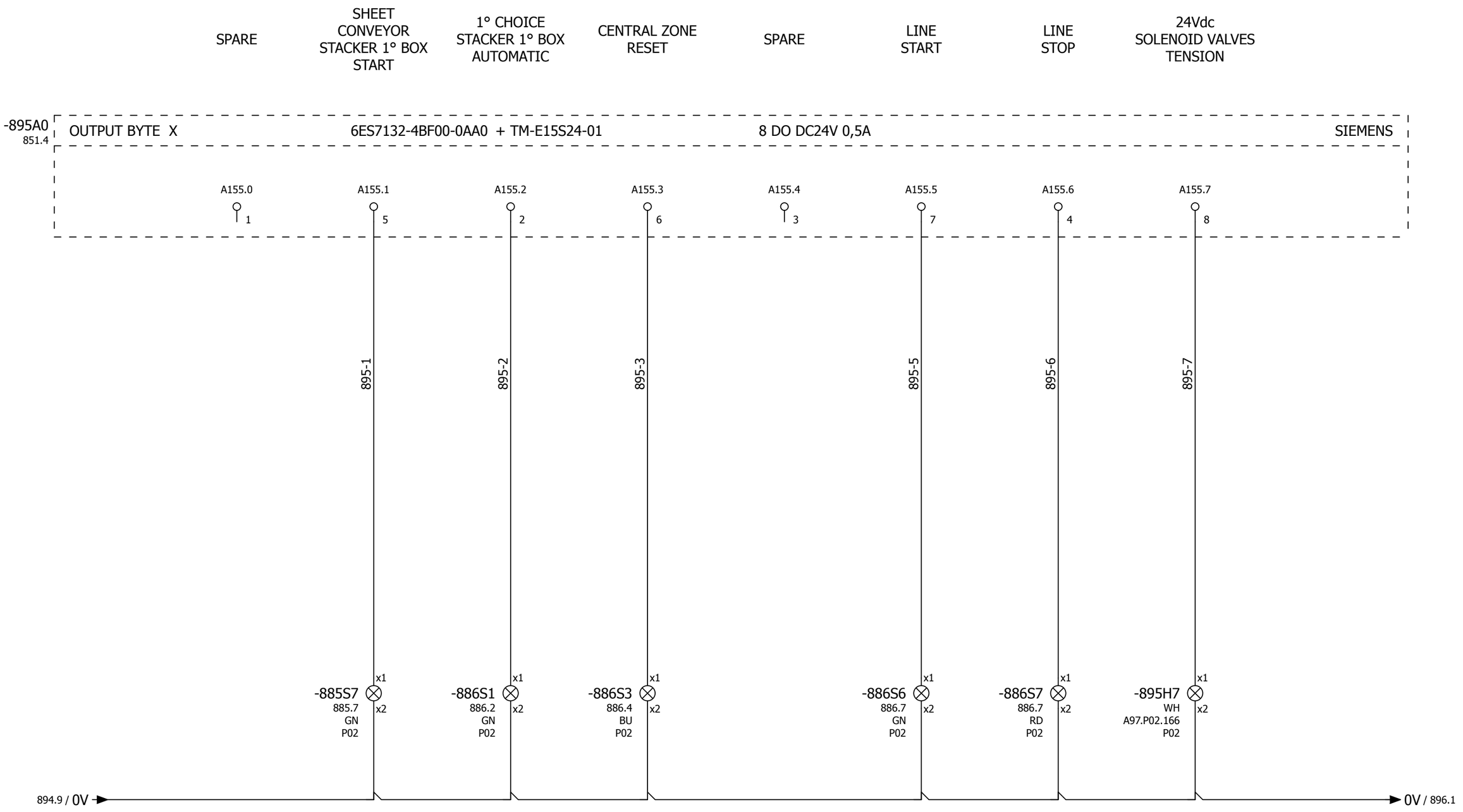


⇦893

895⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	894
Revision		Replacement of	Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9



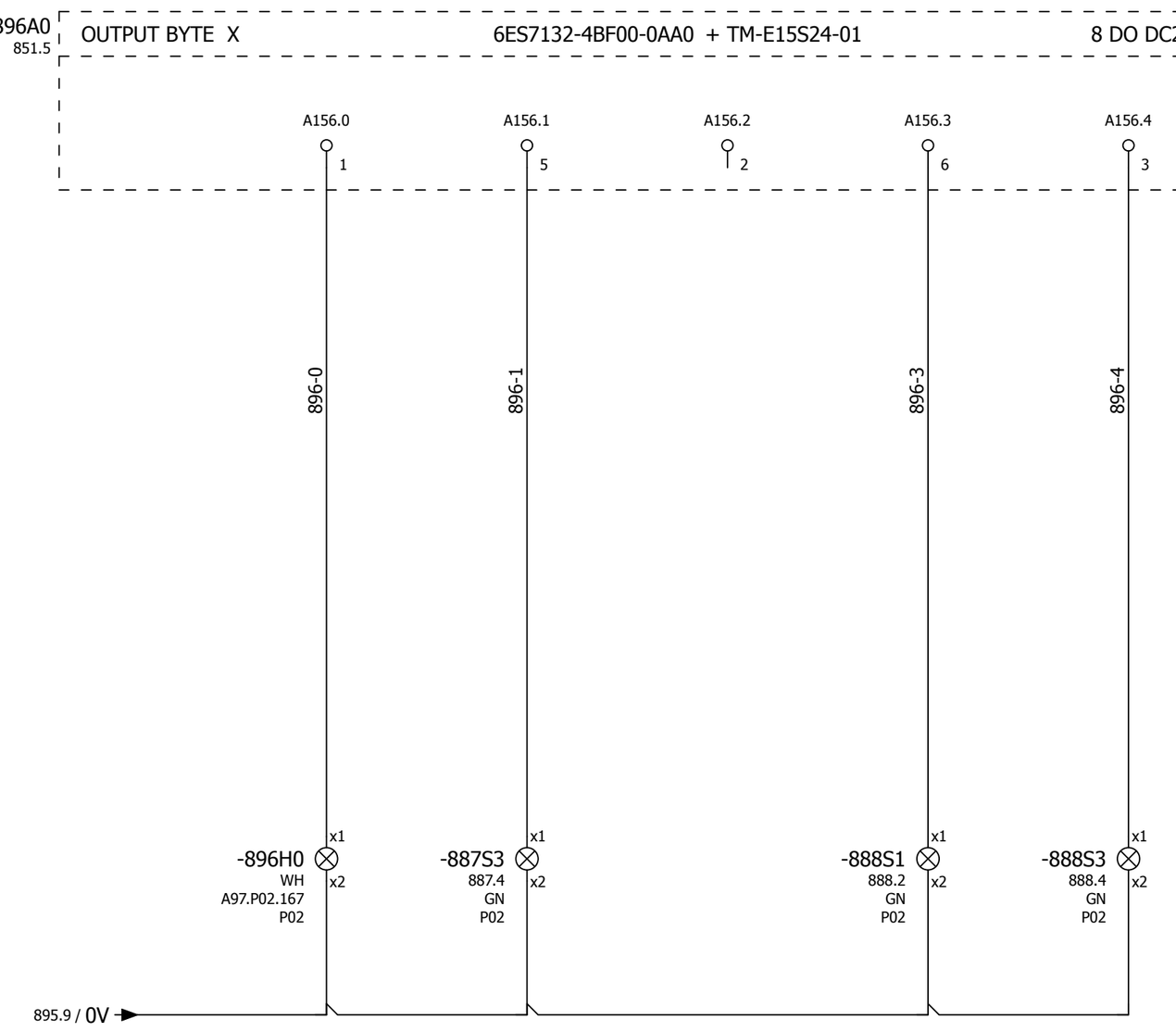
⇦894

896⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	895
Revision			Replacement of / Replaced by			Group: / Of	414

0	1	2	3	4	5	6	7	8	9

	110Vac AUXILIARY TENSION	COMMANDS START	SPARE	1° CHOICE STACKER 2° BOX AUTOMATIC	1° CHOICE STACKER ASPIRATION CONVEYOR BELT START	SPARE	SPARE	SPARE
-896A0 851.5	OUTPUT BYTE X	6ES7132-4BF00-0AA0 + TM-E15S24-01			8 DO DC24V 0,5A			SIEMENS
	A156.0 1	A156.1 5	A156.2 2	A156.3 6	A156.4 3	A156.5 7	A156.6 4	A156.7 8



⇦895

900⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P02 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	896
Revision			Replacement of / Replaced by			Group: / Of	414

115.7 / 110-L7

115.8 / 110-N

-XP3 10 11
Q14

-XP03 10 11
P03

1
-900F5
4A
5SY6104-7
2

800-1 110-N

L N
-900V5
120Vac/24Vdc 5A
6ES7307-1EA01-0AA0
+ -

800-2

1
-900F2
4A
5SY6104-7
2

1
-900F6
4A
5SY6104-7
2

-900P1
OPERATOR PANEL
P03
6AV6643-0CB01-1AX1



852.2 / ETHERNET 4

24V / 903.0

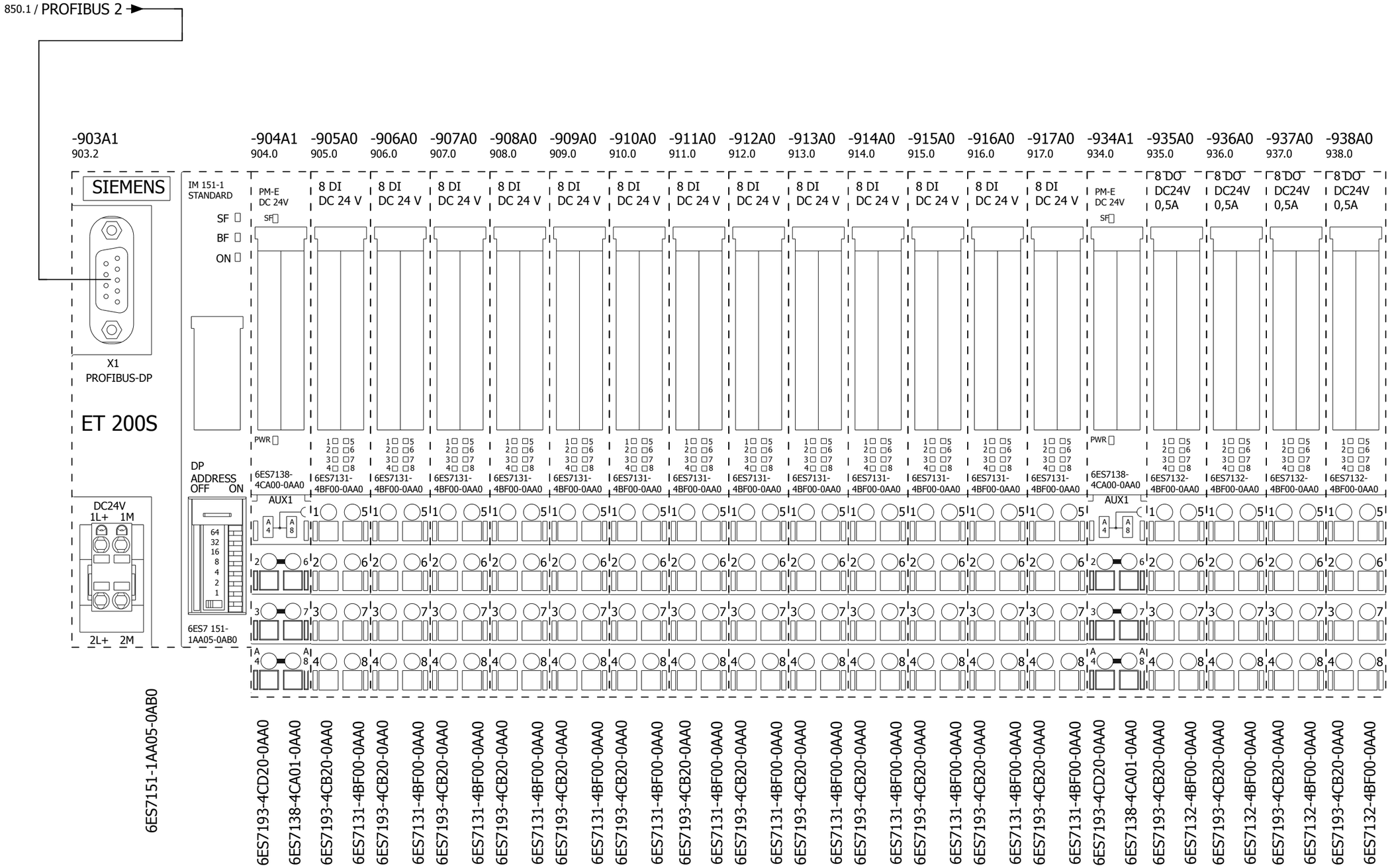
0V / 903.0

⇦896

901⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P03 console supply		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco		Replacement of / Replaced by		Installation: Linea taglio trasversale	Page	900
Revision						Group:	Of 414

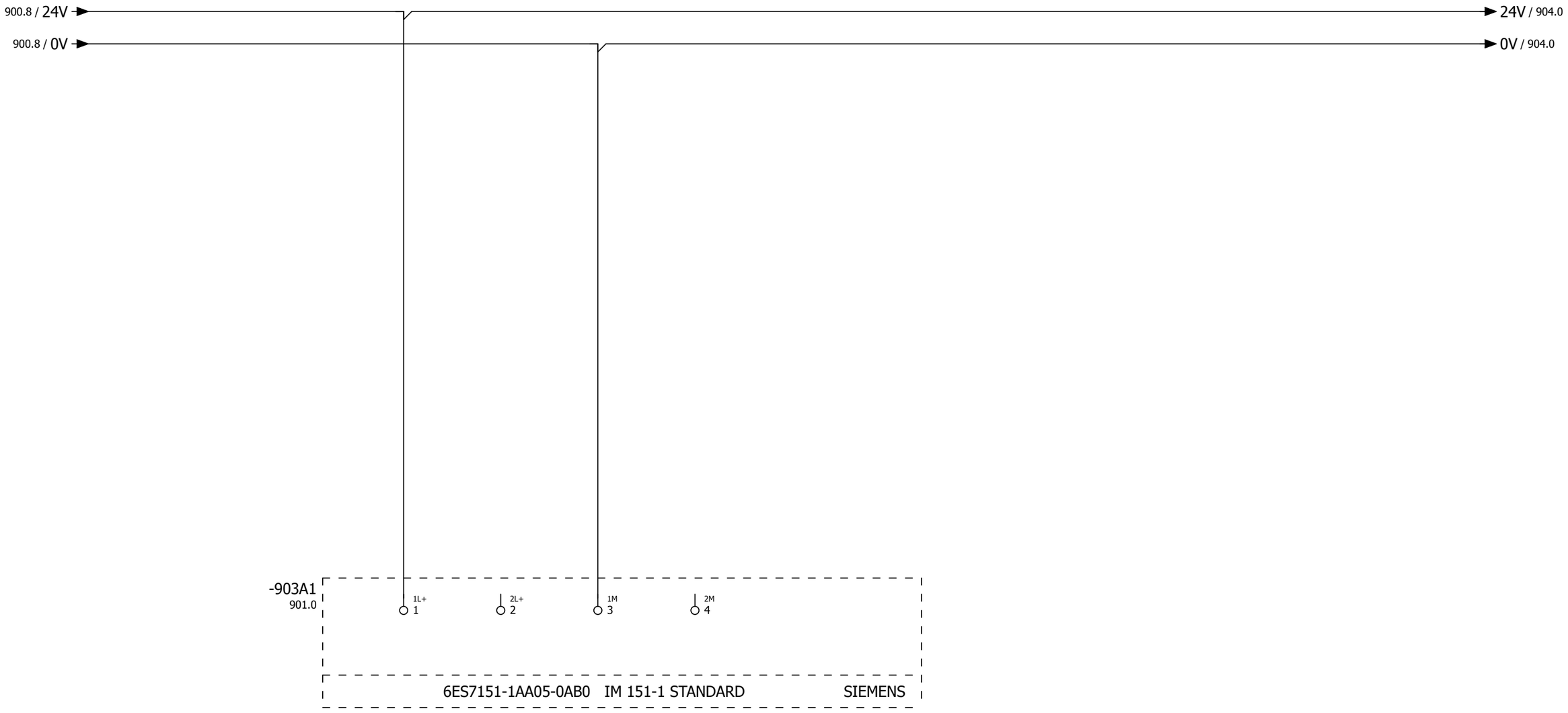
850.1 / PROFIBUS 2



⇦900

903⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: P03 console plc layout		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale		Page 901
Revision			Replacement of / Replaced by			Group:	Of 414



⇦901

904⇨

Date	13/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: IM 151 P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	903
Revision		Replacement of	Replaced by			Group:	Of 414

903.9 / 24V

903.9 / 0V

24V / 905.0

0V / 934.0

-904A1
901.1

DC24V 2
M 3
A4
A4/AUX1

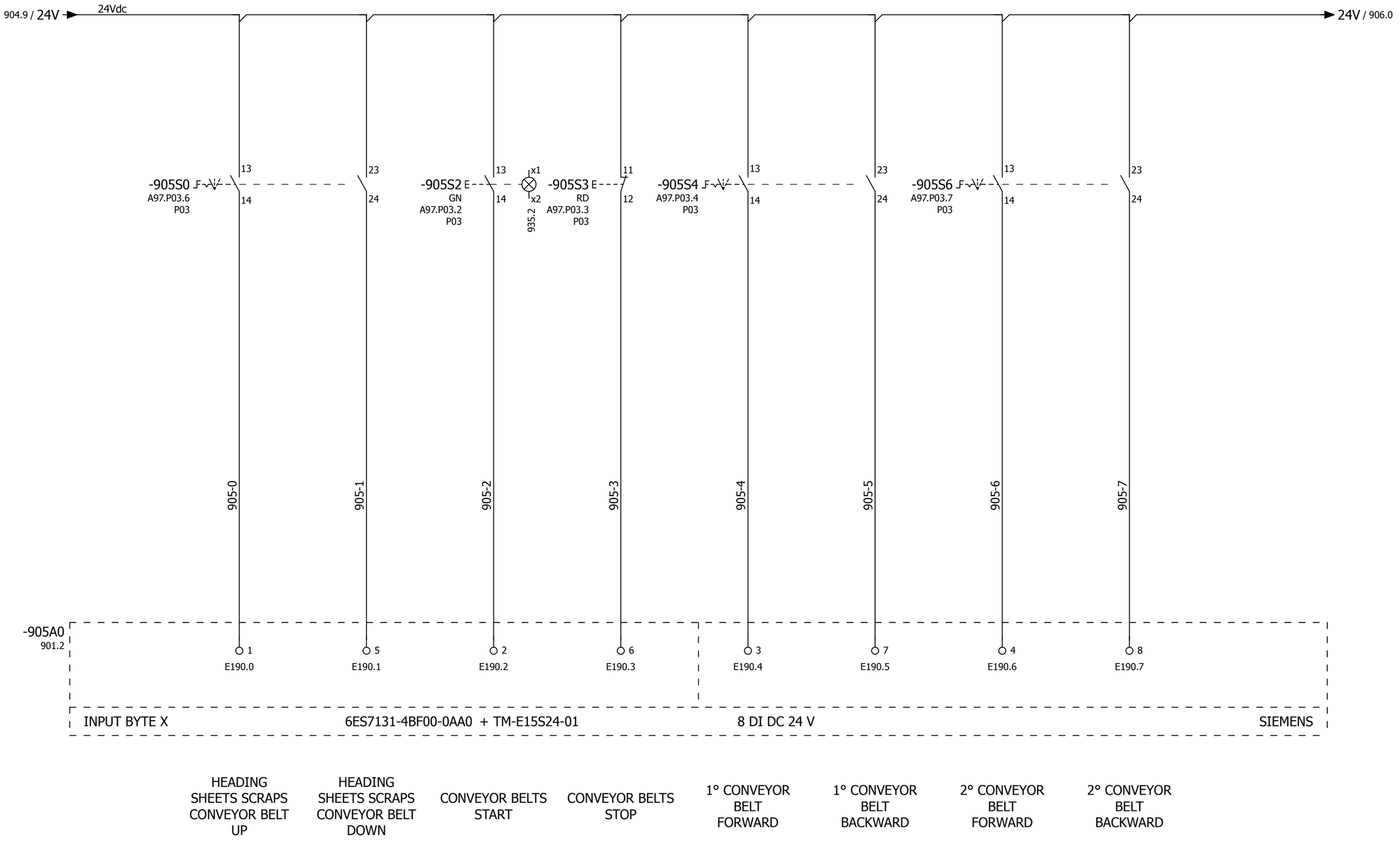
DC24V 6
M 7
A8
A8/AUX1

POWER MODUL 6ES7138-4CA01-0AA0 + TM-P15S23-A0 PM-E DC 24V SIEMENS

⇦903

905⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 904
Revision		Replacement of	Replaced by			Group:	Of 414



⇦904

906⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	905
Revision		Replacement of	Replaced by			Group:	Of 414

905.9 / 24V

24Vdc

24V / 907.0

-906S0 E
YE
A97.P03.18
P03
13
14
906-0

-906S1 E
BU
A97.P03.20
P03
13
14
x1
x2
935.3
906-1

-906S2 E
RD
A97.P03.21
P03
11
12
906-2

-906S3 E
GN
A97.P03.22
P03
13
14
906-3

-906S4 E
RD
A97.P03.23
P03
x1
x2
935.4
11
12
906-4

-906S5 E
GN
A97.P03.24
P03
13
14
x1
x2
935.5
906-5

-906S6
A97.P03.25
P03
13
14
23
24
906-6
906-7

-906A0
901.2

1	5	2	6	3	7	4	8
E191.0	E191.1	E191.2	E191.3	E191.4	E191.5	E191.6	E191.7

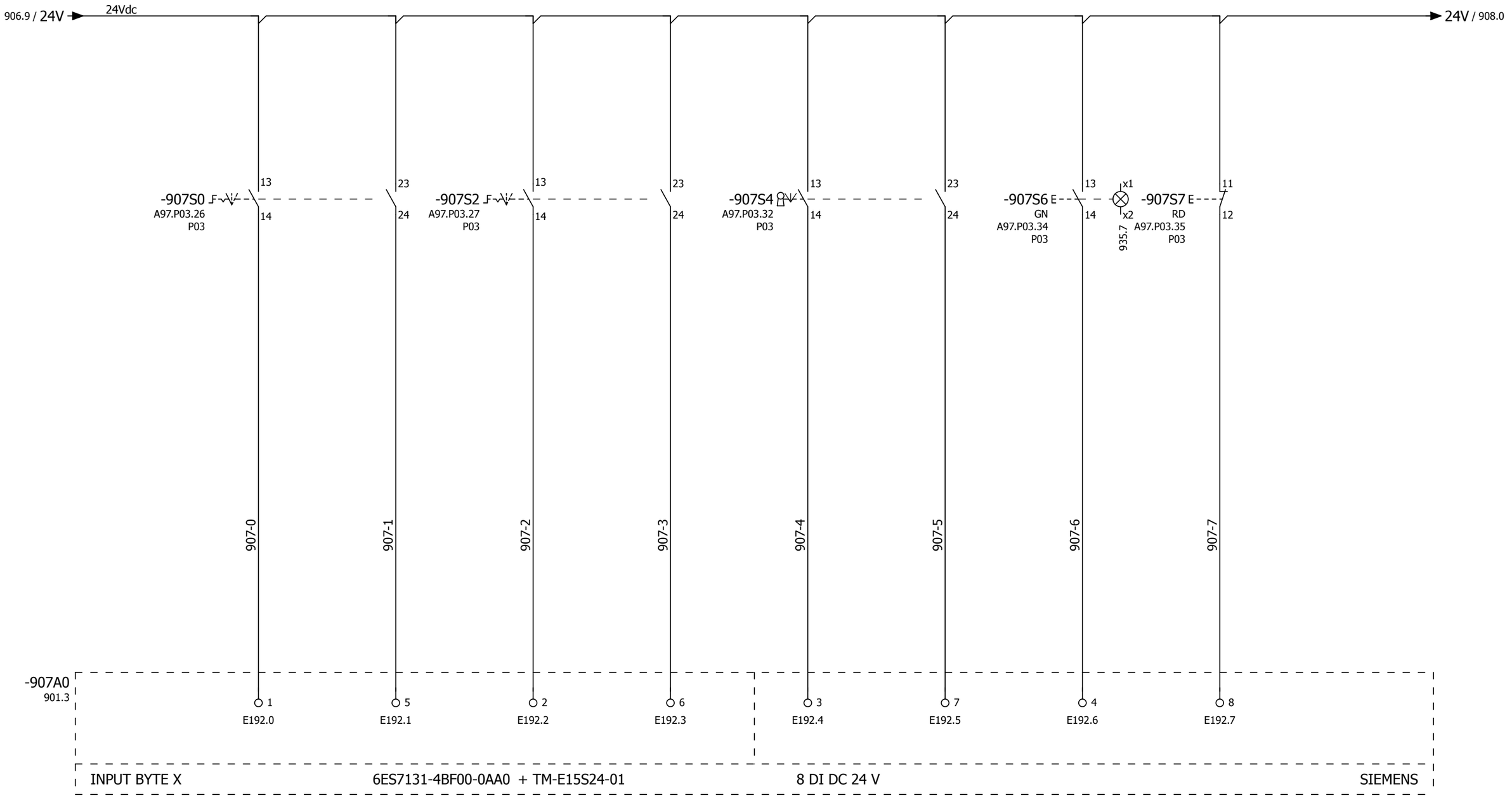
INPUT BYTE X | 6ES7131-4BF00-0AA0 + TM-E15S24-01 | 8 DI DC 24 V | SIEMENS

CYCLE JOGGERS 2° CHOICE STACKER	2° CHOICE STACKER POSITIONING START	2° CHOICE STACKER POSITIONING STOP	2° CHOICE STACKER AUTOMATIC	2° CHOICE STACKER MANUAL	2° CHOICE STACKER READY	PACKAGE FORMING ROLL 2° CHOICE STACKER UP	PACKAGE FORMING ROLL 2° CHOICE STACKER DOWN

⇦905

907⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment			elettromeccanica ERCA s.r.l.	Function: Digital input P03 console	=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco					Installation: Linea taglio trasversale	Page 906
Revision			Replacement of	Replaced by			Group: Of 414



⇦906

908⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 907
Revision		Replacement of	Replaced by			Group:	Of 414

907.9 / 24V — 24Vdc

-908S0 E
A97.P03.36
P03
13 / 14 / 23 / 24

-908S2 E
YE
A97.P03.39
P03
13 / 14

-908S3 E
BU
A97.P03.43
P03
13 / 14 / x1 / x2

935.8

-908S4 E
RD
A97.P03.44
P03
11 / 12

-908S5 E
GN
A97.P03.47
P03
13 / 14

-908S6 E
GN
A97.P03.45
P03
13 / 14 / x1 / x2

936.2

-908S7 E
RD
A97.P03.46
P03
11 / 12

24V / 909.0

908-0 — 908-1 — 908-2 — 908-3 — 908-4 — 908-5 — 908-6 — 908-7

-908A0
901.3

1	5	2	6	3	7	4	8
E193.0	E193.1	E193.2	E193.3	E193.4	E193.5	E193.6	E193.7

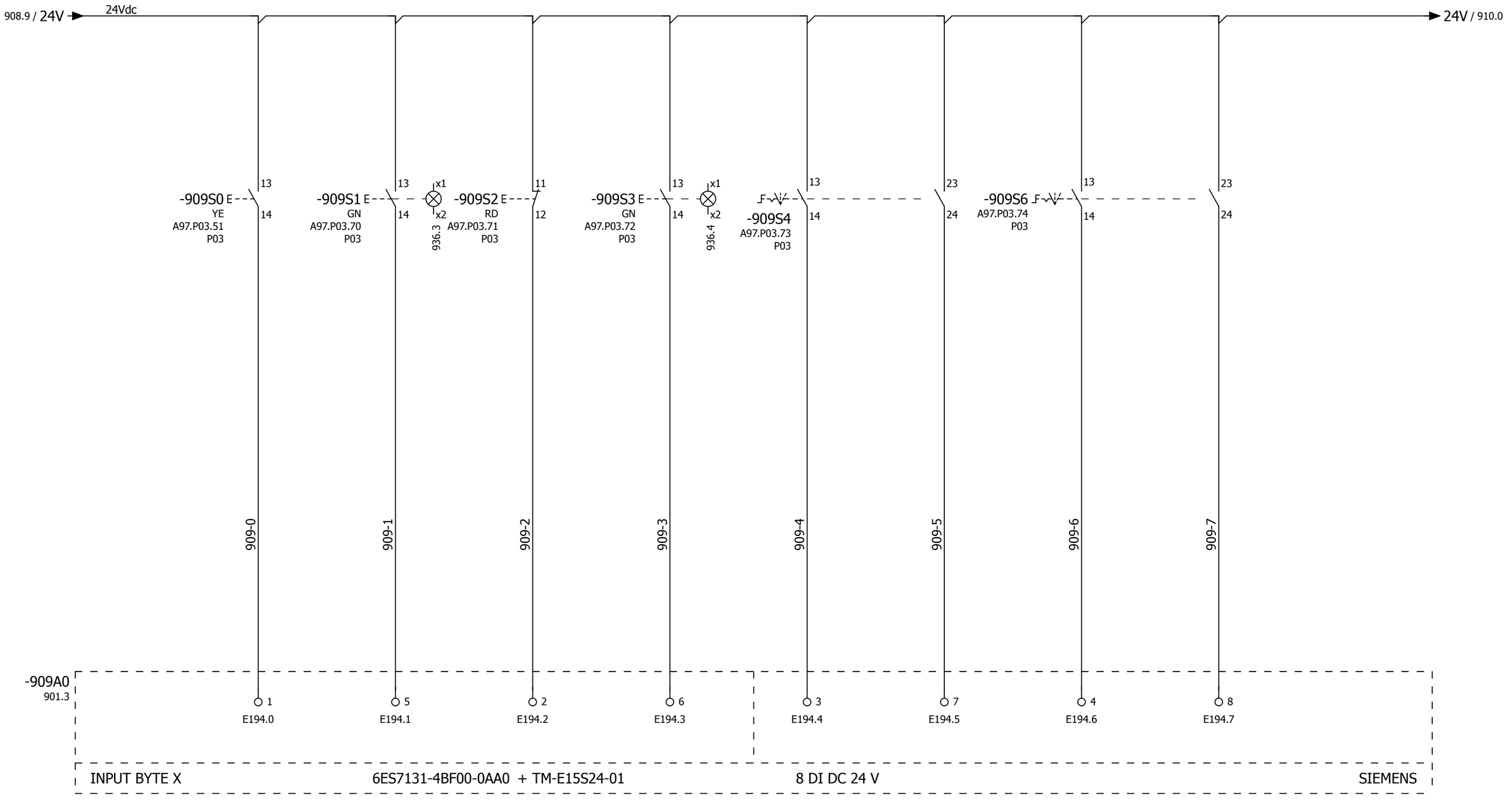
INPUT BYTE X — 6ES7131-4BF00-0AA0 + TM-E15S24-01 — 8 DI DC 24 V — SIEMENS

908-0	908-1	908-2	908-3	908-4	908-5	908-6	908-7
SHEET CONVEYOR STACKER 1° BOX FORWARD	SHEET CONVEYOR STACKER 1° BOX BACKWARD	CYCLE JOGGERS STACKER 1° BOX	1° CHOICE STACKER POSITIONING START	1° CHOICE STACKER POSITIONING STOP	1° CHOICE STACKER 1° BOX READY	1° CHOICE STACKER 1° BOX AUTOMATIC	1° CHOICE STACKER 1° BOX MANUAL

⇦907

909⇨

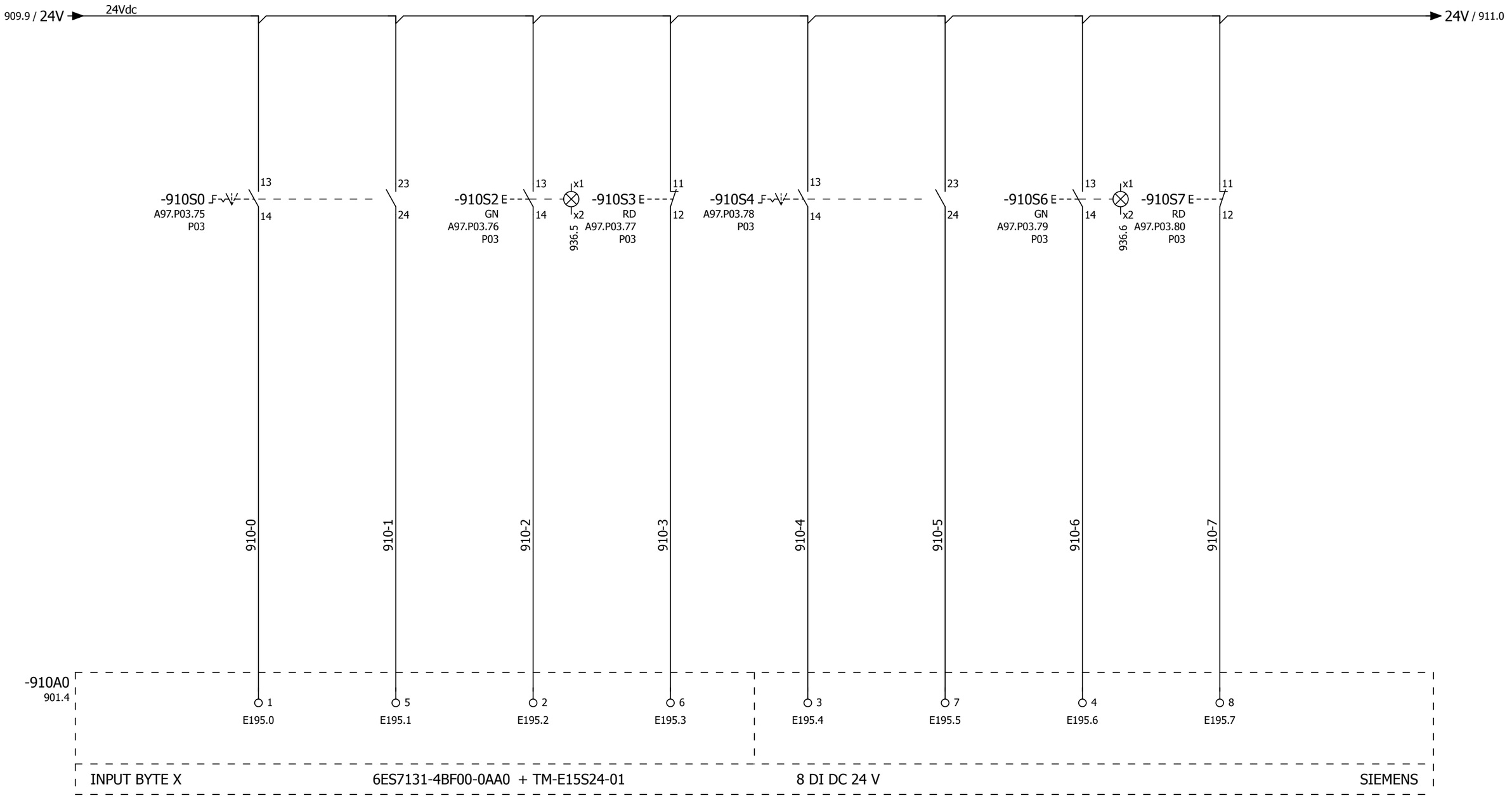
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	908
Revision			Replacement of / Replaced by			Group: / Of	414



⇦908

910⇨

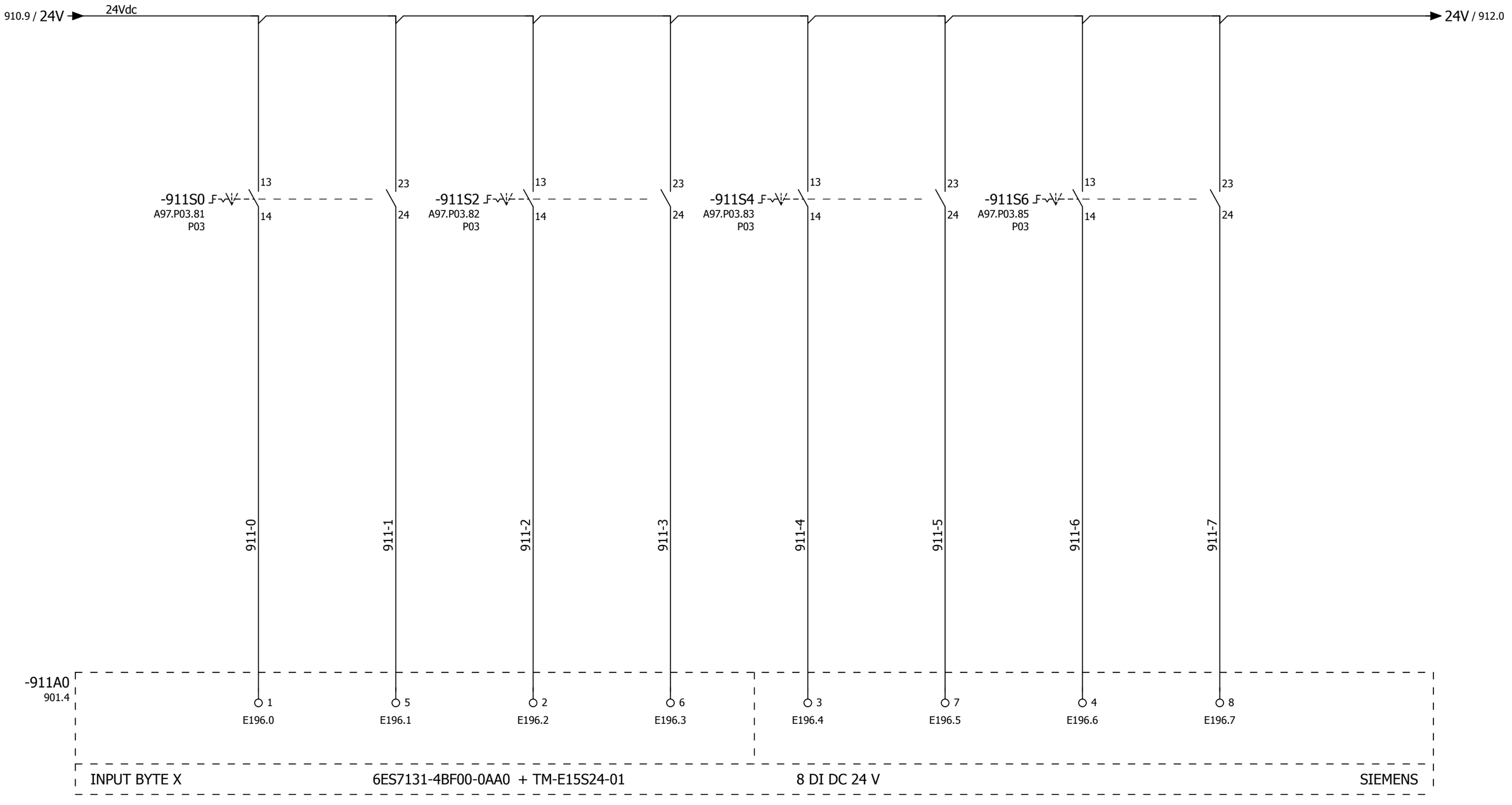
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 909
Revision		Replacement of	Replaced by			Group:	Of 414



⇦909

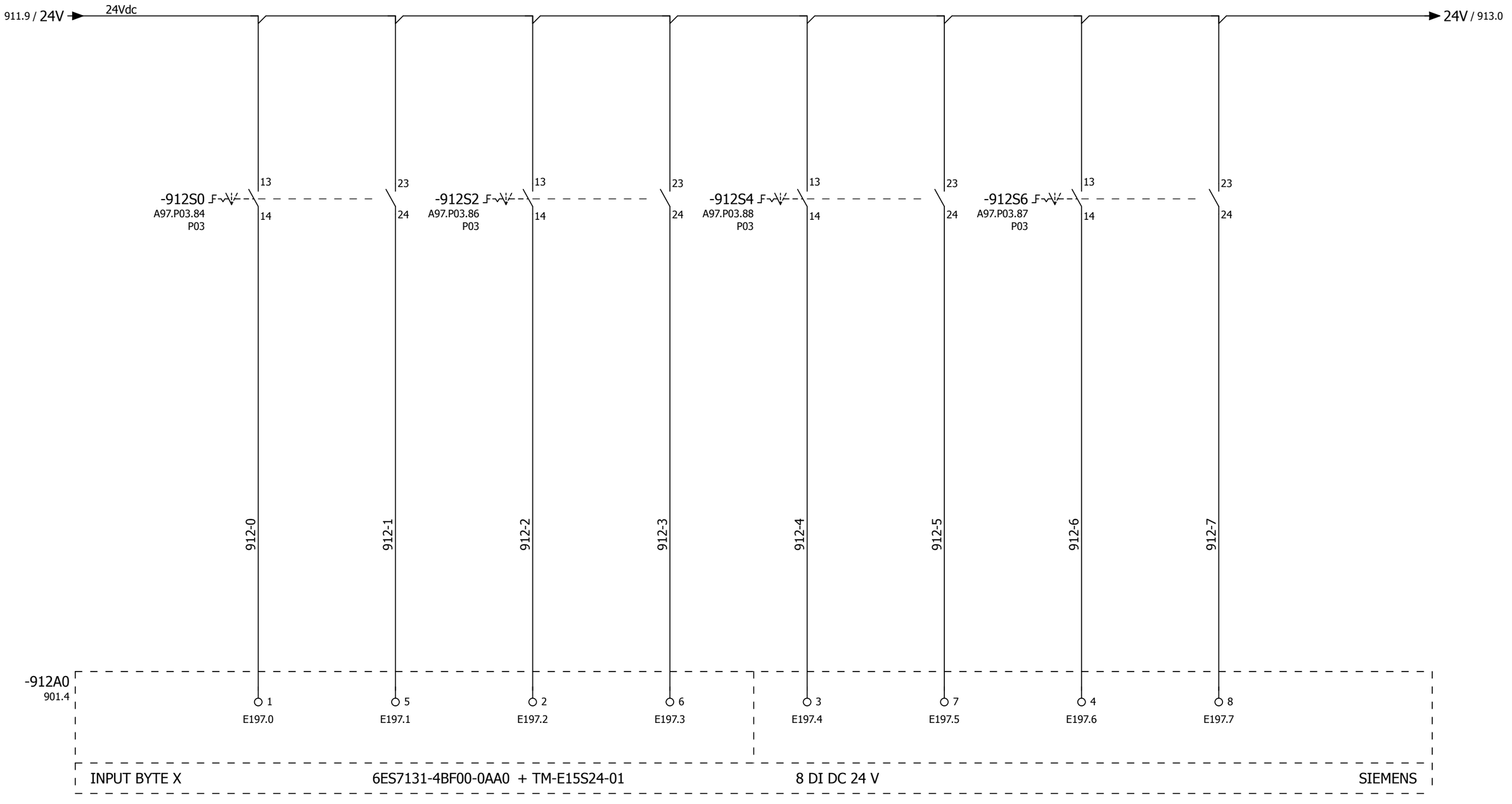
911⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	910
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910.9 / 24V
24Vdc
24V / 912.0
-911S0
A97.P03.81
P03
-911S2
A97.P03.82
P03
-911S4
A97.P03.83
P03
-911S6
A97.P03.85
P03
13
14
23
24
911-0
911-1
911-2
911-3
911-4
911-5
911-6
911-7
-911A0
901.4
1
5
2
6
3
7
4
8
E196.0
E196.1
E196.2
E196.3
E196.4
E196.5
E196.6
E196.7
INPUT BYTE X
6ES7131-4BF00-0AA0 + TM-E15S24-01
8 DI DC 24 V
SIEMENS
WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX OPERATOR SIDE
WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX MOTOR SIDE
WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 2° BOX OPERATOR SIDE
WEIGHING TRANSFER PLATFORM 1° CHOICE STACKER 2° BOX MOTOR SIDE
COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX OPERATOR SIDE
COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX MOTOR SIDE
COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX FORWARD
COMBINED TRANSFER PLATFORM 1° CHOICE STACKER 1° BOX BACKWARD

⇦910

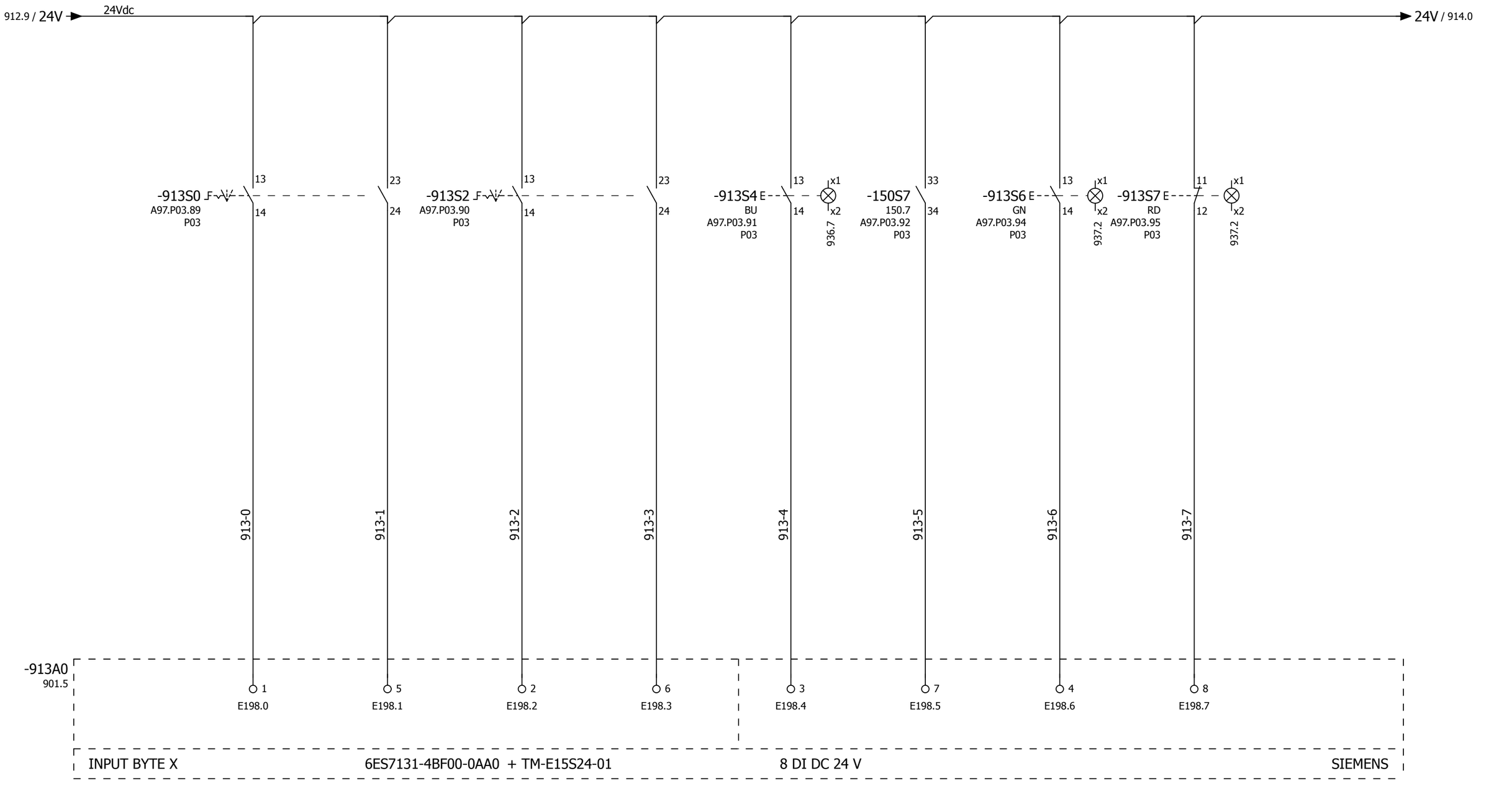
912⇨



⇦911

913⇨

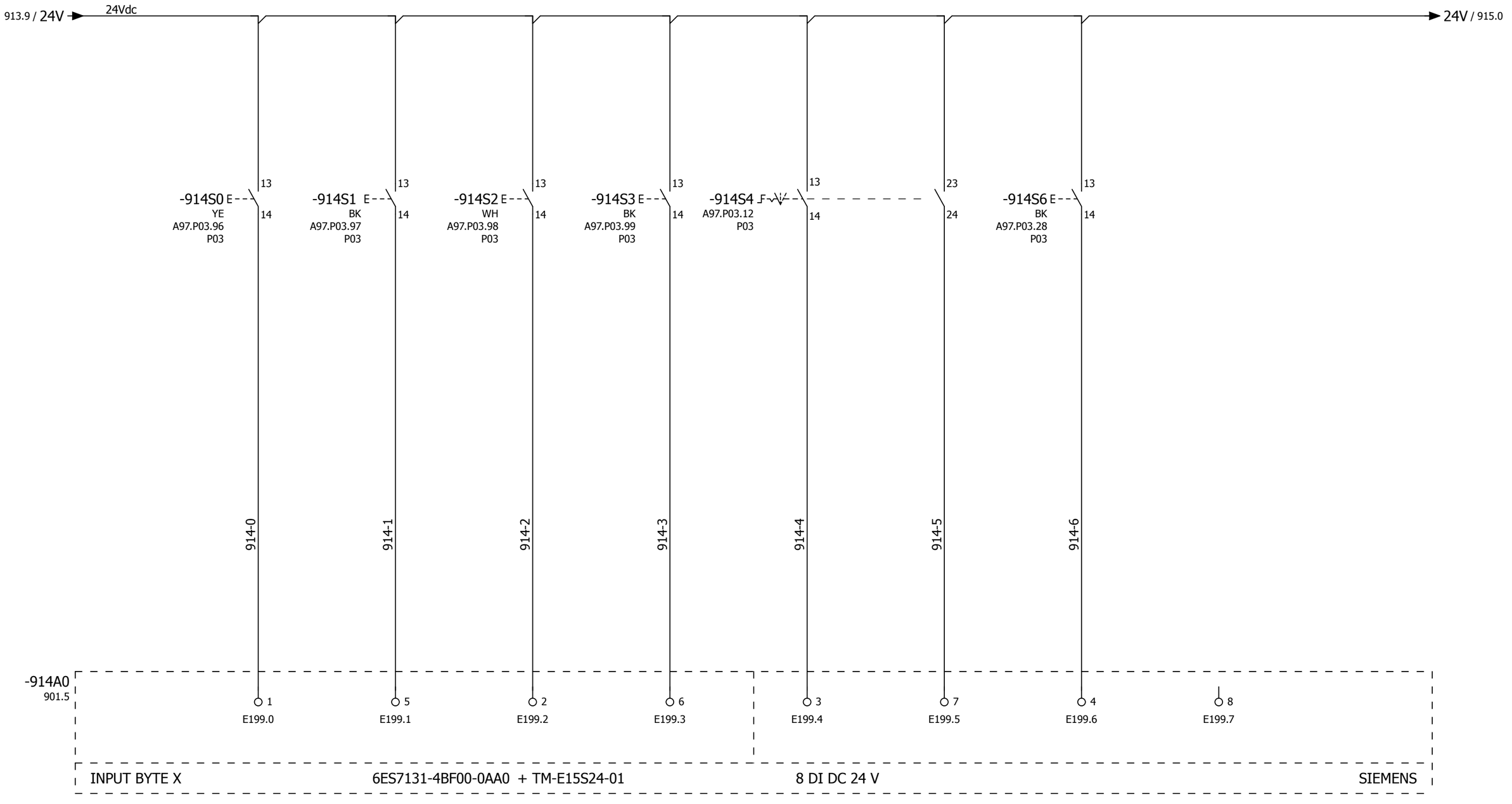
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 912
Revision		Replacement of	Replaced by			Group:	Of 414



⇦912

914⇨

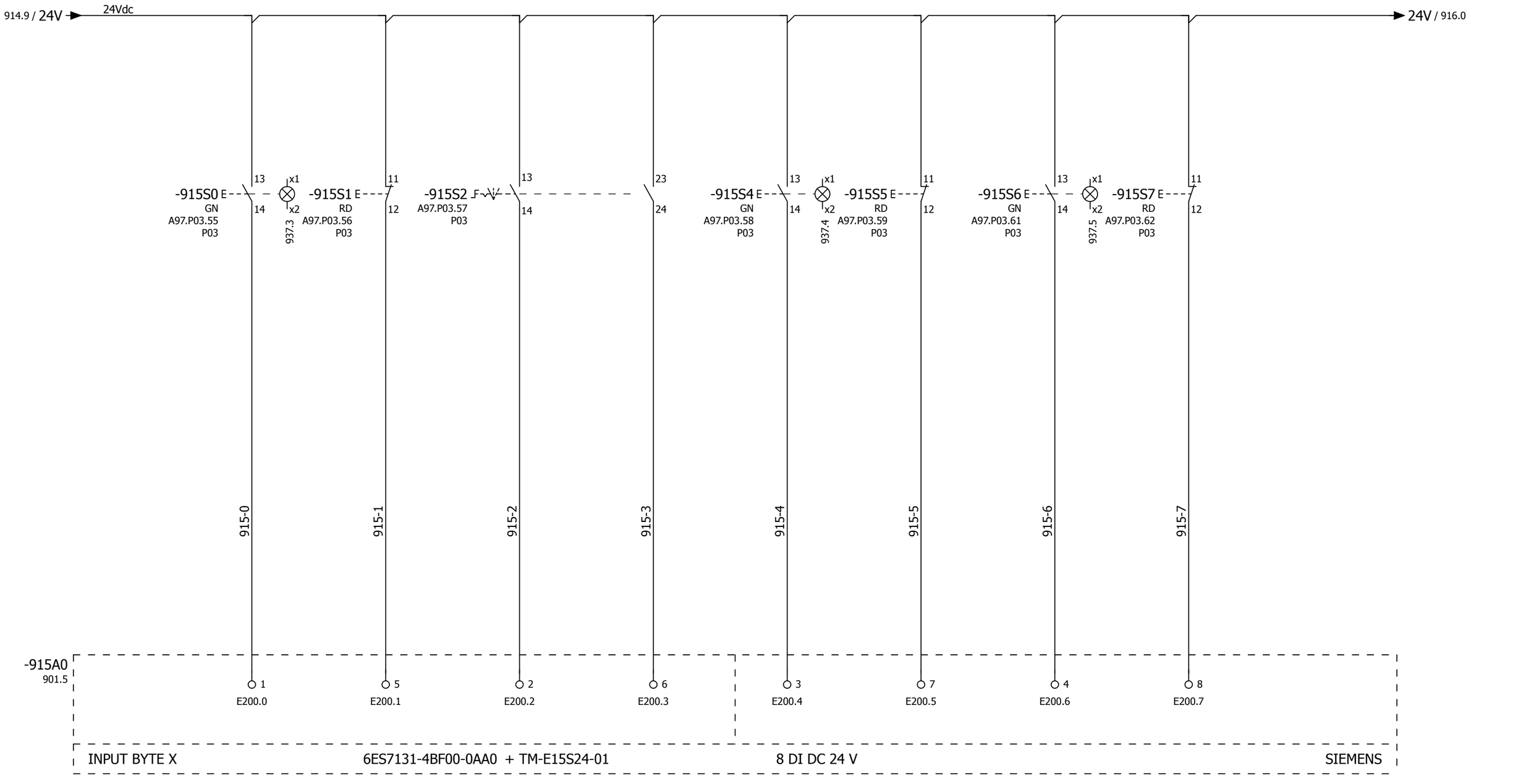
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	913
Revision			Replacement of / Replaced by			Group: / Of	414



ENTRY SECTION FORWARD	ENTRY SECTION BACKWARD	LINE SPEED INCREASE	LINE SPEED DECREASE	3° CONVEYOR BELT FORWARD	3° CONVEYOR BELT BACKWARD	ENTRY STACKER FEEDING PINCH ROLL DOWN	SPARE	

⇦913

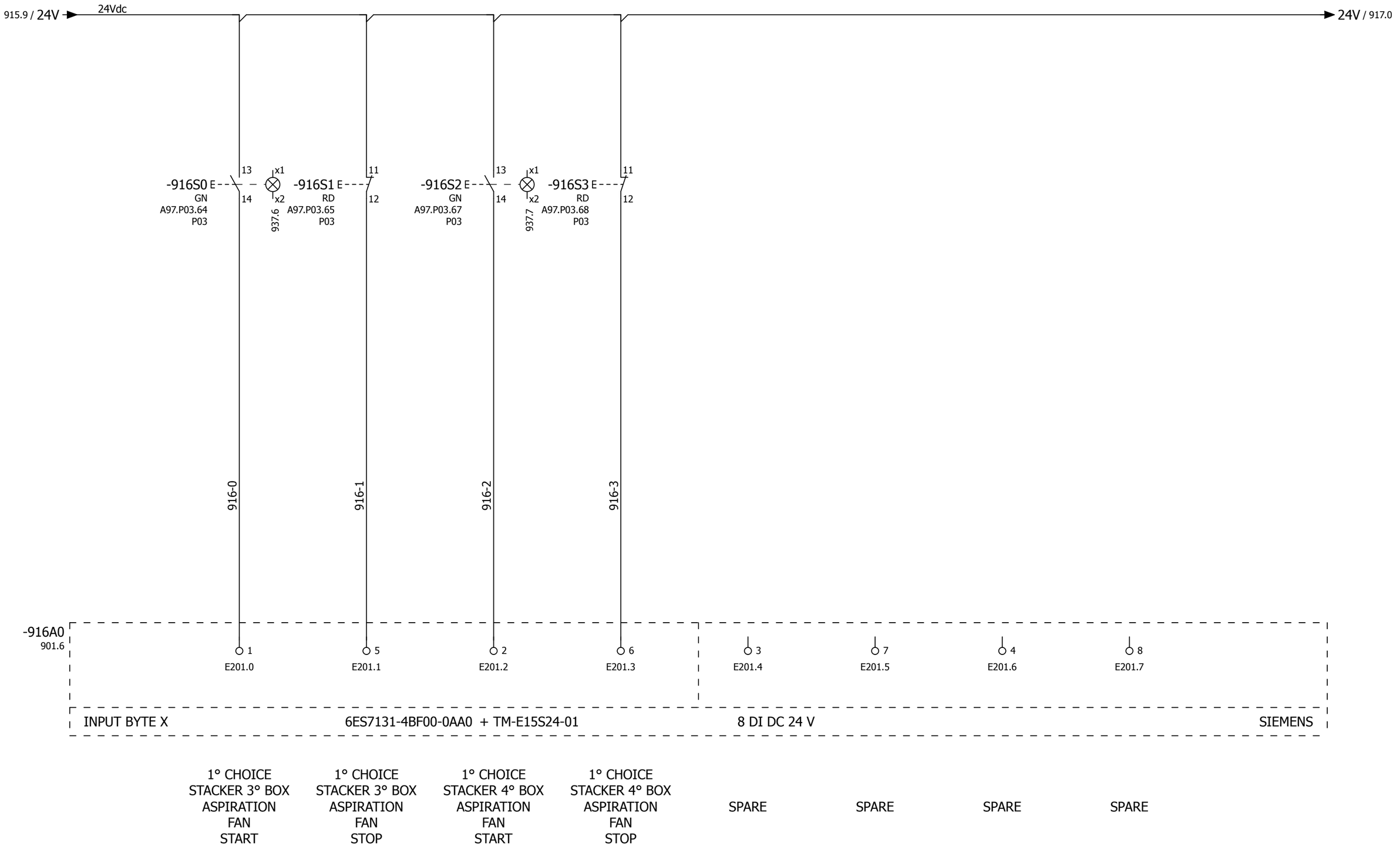
915⇨



⇦914

916⇨

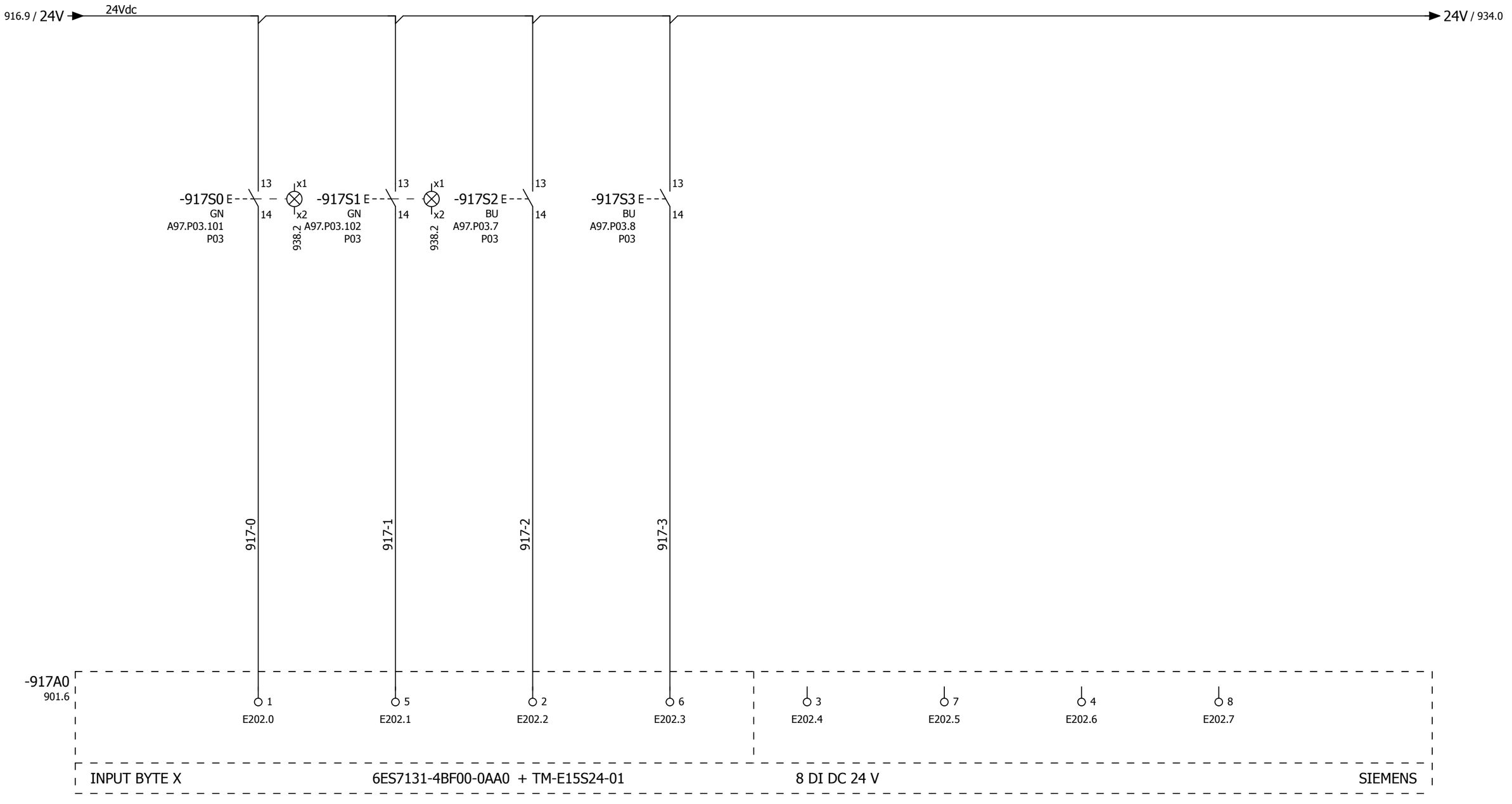
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 915
Revision		Replacement of	Replaced by			Group:	Of 414



⇦915

917⇨

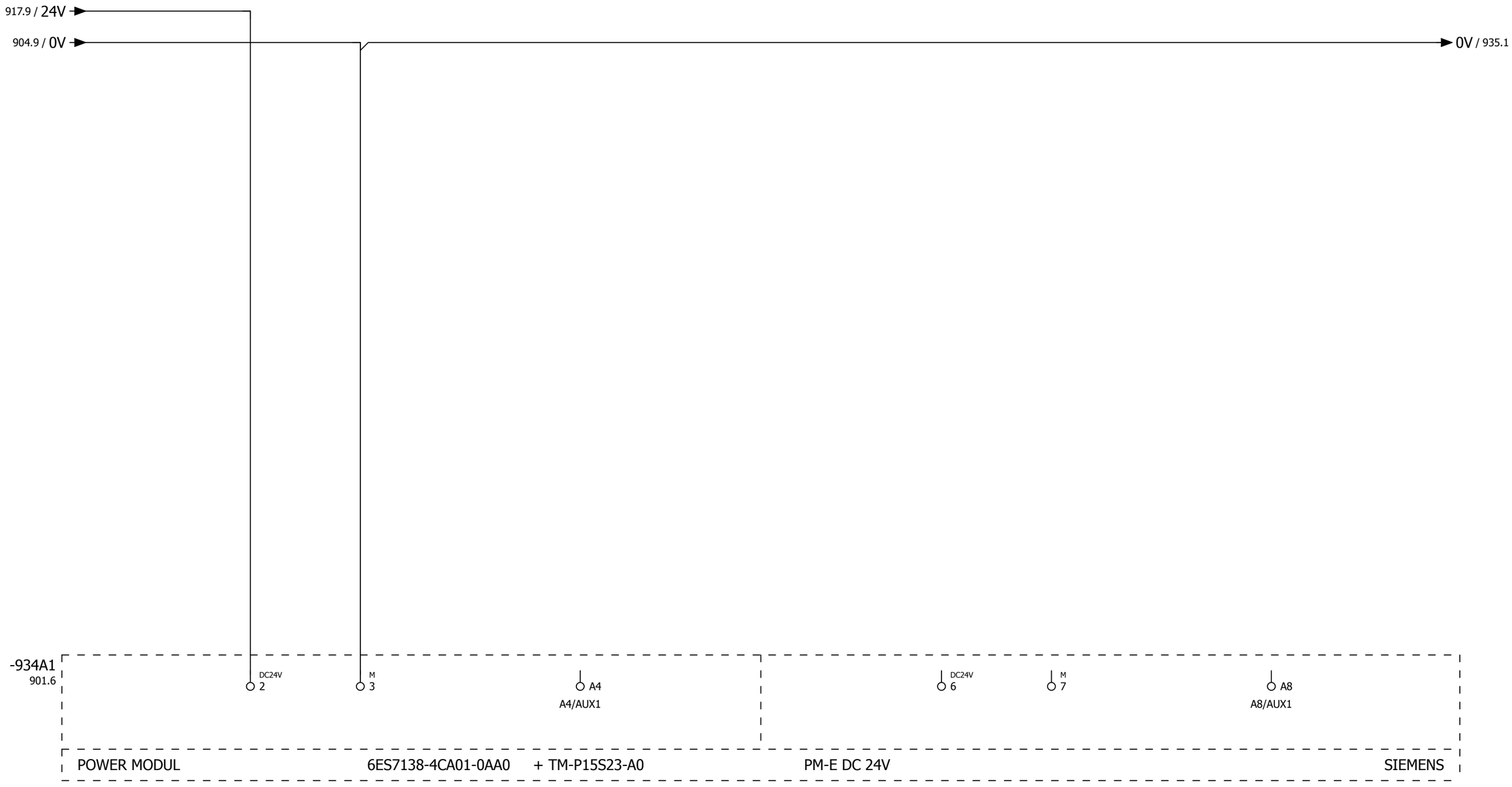
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	916
Revision		Replacement of	Replaced by			Group:	Of 414



⇦916

934⇨

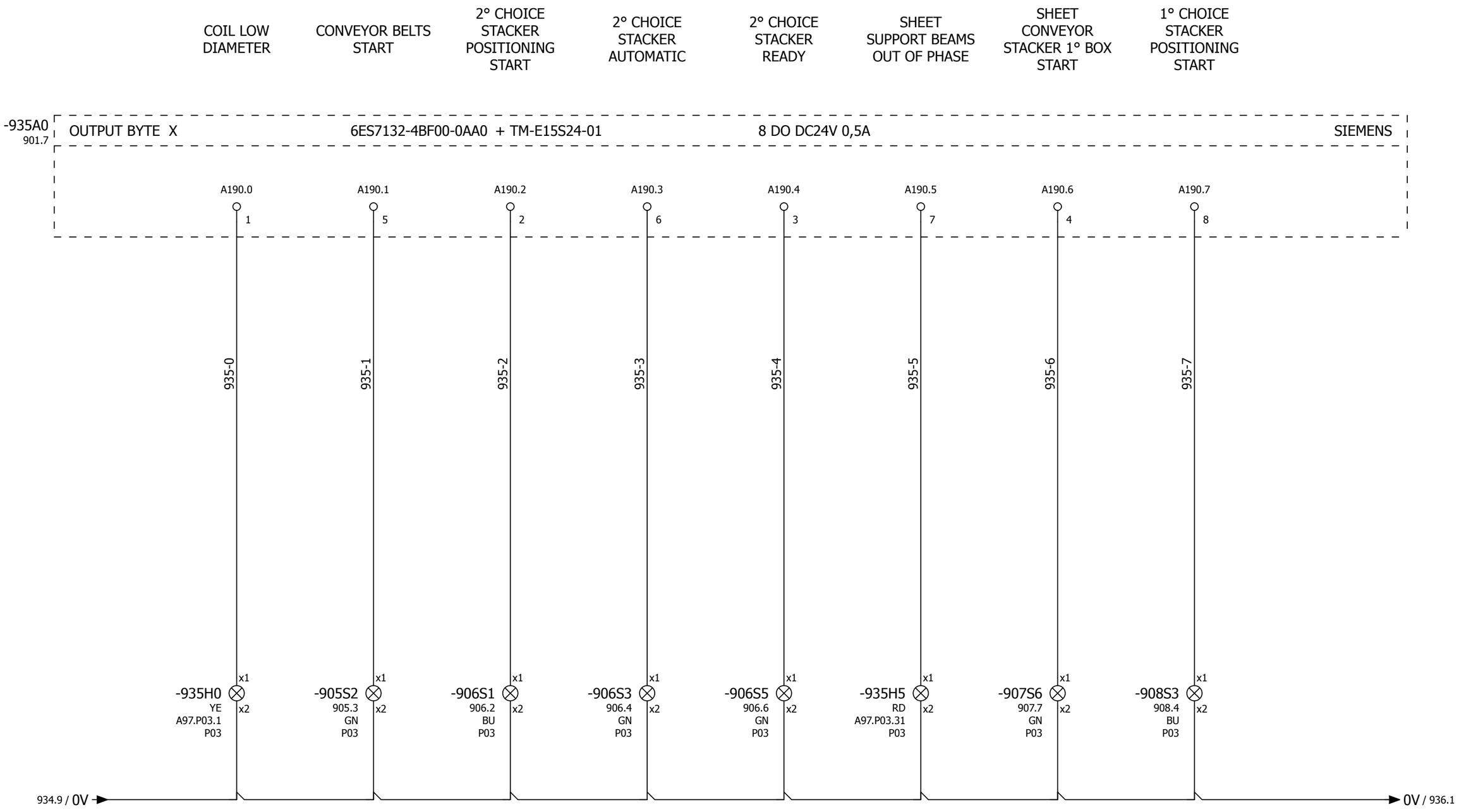
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital input P03 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	917
Revision			Replacement of / Replaced by			Group: / Of	414



⇦917

935⇨

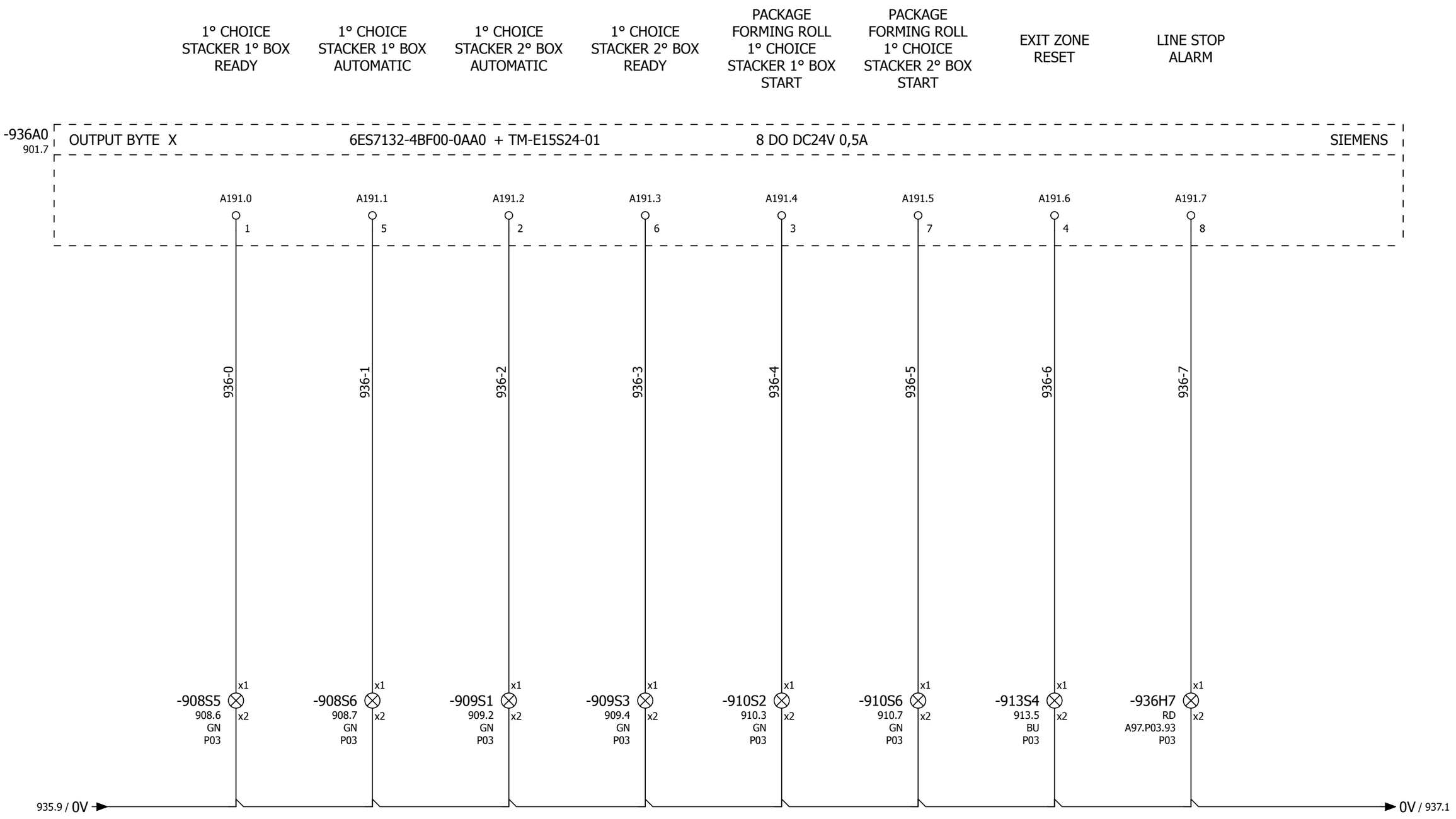
Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Power modul P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	934
Revision		Replacement of	Replaced by			Group:	Of 414



⇦934

936⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale	Page	935
Revision		Replacement of	Replaced by			Group:	Of 414



⇦935

937⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco	Comm: A97			Installation: Linea taglio trasversale		Page 936
Revision		Replacement of	Replaced by			Group:	Of 414

LINE START	LINE STOP	1° CHOICE STACKER ASPIRATION CONVEYOR BELT START	1° CHOICE STACKER 1° BOX ASPIRATION FAN START	1° CHOICE STACKER 2° BOX ASPIRATION FAN START	1° CHOICE STACKER 3° BOX ASPIRATION FAN START	1° CHOICE STACKER 4° BOX ASPIRATION FAN START	SPARE

-937A0
901.8
OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A192.0	A192.1	A192.2	A192.3	A192.4	A192.5	A192.6	A192.7
1	5	2	6	3	7	4	8
937-0	937-1	937-2	937-3	937-4	937-5	937-6	

-913S6 x1/x2	-913S7 x1/x2	-915S0 x1/x2	-915S4 x1/x2	-915S6 x1/x2	-916S0 x1/x2	-916S2 x1/x2
913.7 GN P03	913.7 RD P03	915.1 GN P03	915.5 GN P03	915.7 GN P03	916.1 GN P03	916.3 GN P03

936.9 / 0V → ... → 0V / 938.1

⇦936 938⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P03 console		=
Drawing	13B01		Comm: A97				+
Drawer	Tengattini Marco				Installation: Linea taglio trasversale	Page	937
Revision			Replacement of / Replaced by			Group:	Of 414

0	1	2	3	4	5	6	7	8	9

AUTOMATIC DOWNLOAD AFTER 1° WEIGHING TRANSFER PLATFORM

AUTOMATIC DOWNLOAD AFTER 2° WEIGHING TRANSFER PLATFORM

SPARE

SPARE

SPARE

SPARE

SPARE

SPARE

-938A0
901.8

OUTPUT BYTE X | 6ES7132-4BF00-0AA0 + TM-E15S24-01 | 8 DO DC24V 0,5A | SIEMENS

A193.0	A193.1	A193.2	A193.3	A193.4	A193.5	A193.6	A193.7
1	5	2	6	3	7	4	8

938-0

938-1

-917S0
917.1
GN
P03
x1
x2

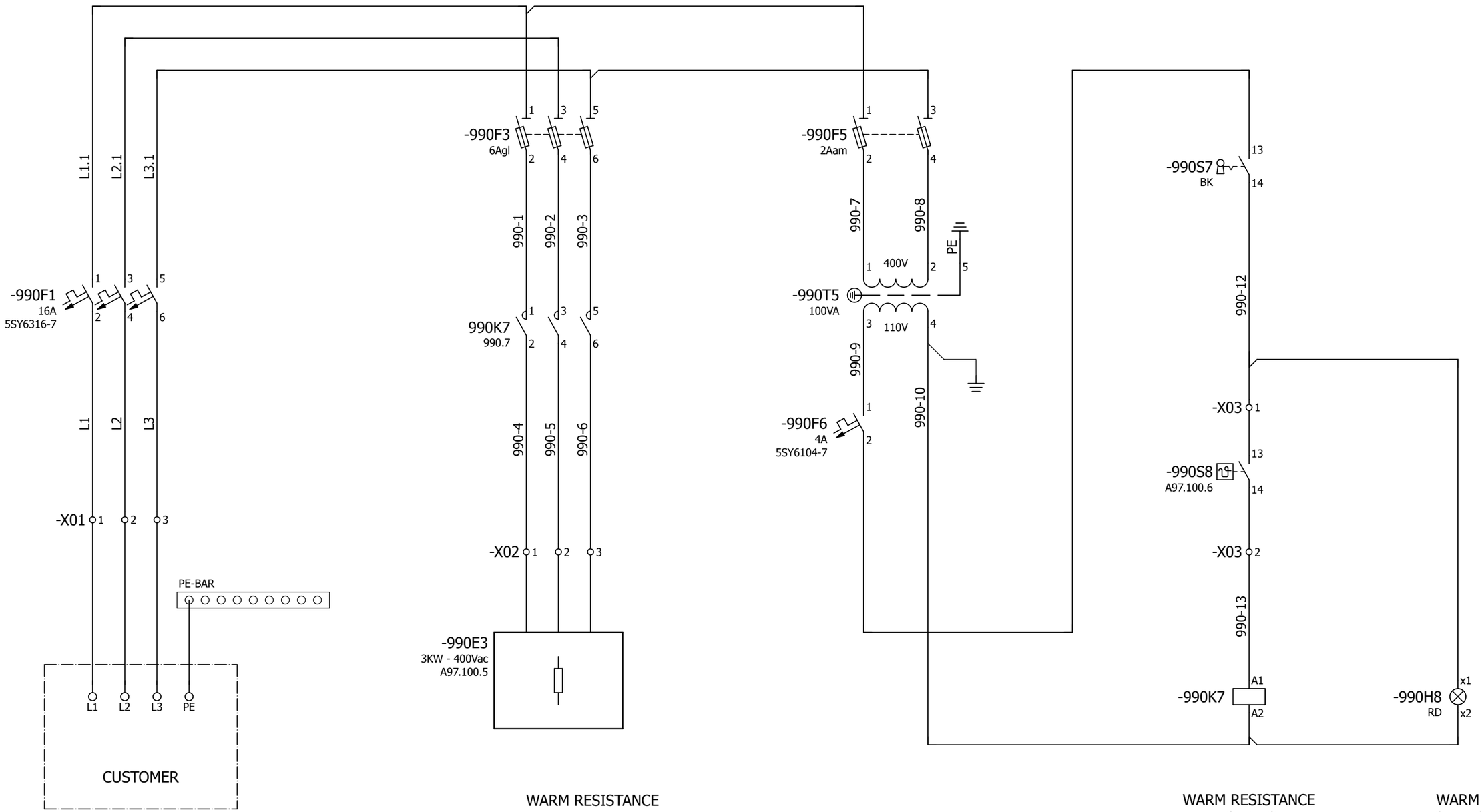
-917S1
917.2
GN
P03
x1
x2

937.9 / 0V

⇦937

990⇨

Date	16/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Digital output P03 console		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	938
Revision			Replacement of / Replaced by			Group: / Of	414



⇦938

Date	17/05/2014	NOVASTILMEC S.p.A. Coil Processing Equipment		elettromeccanica ERCA s.r.l.	Function: Line hydraulic unit oil heating box		=
Drawing	13B01						+
Drawer	Tengattini Marco		Comm: A97		Installation: Linea taglio trasversale	Page	990
Revision			Replacement of / Replaced by			Group: / Of	414