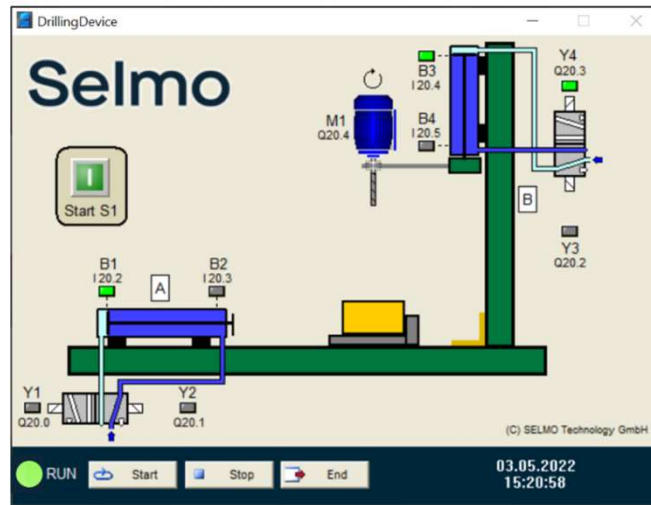


Selmo

- Model Drilling Device



Boris

- **Functional Description**

The Drilling Device model represents a simple drilling device that enables automatic clamping and drilling of workpieces. After pressing the start button, cylinder A first clamps the workpiece. After clamping the workpiece, the drive motor M1 of the drilling machine is switched on and the machine is then moved into the workpiece via cylinder B. After the drilling process is completed, cylinder B retracts first and then, after the motor is switched off, cylinder A.

In/Output assignment

The in- and outputs of the model are assigned as follows (the designation input or output refers to the connected controller):

Input Nr.	Boris	PLC-Variable name	Specification
1	S1	I_S1 :BOOL;	Start button (closer)
2	B1	I_B1 :BOOL;	Limit switch Cylinder 1 retracted (closer)
3	B2	I_B2 :BOOL;	Limit switch Cylinder 1 extended (closer)
4	B3	I_B3 :BOOL;	Limit switch Cylinder 2 retracted (closer)
5	B4	I_B4 :BOOL;	Limit switch Cylinder 2 extended (closer)
Output Nr.	Boris	PLC-Variable name	Specification
1	Y1	O_Y1 :BOOL;	Cylinder 1 extend
2	Y2	O_Y2 :BOOL;	Cylinder 1 retract
3	Y3	O_Y3 :BOOL;	Cylinder 2 extend
4	Y4	O_Y4 :BOOL;	Cylinder 2 retract
5	M1	O_M1 :BOOL;	Drill on