

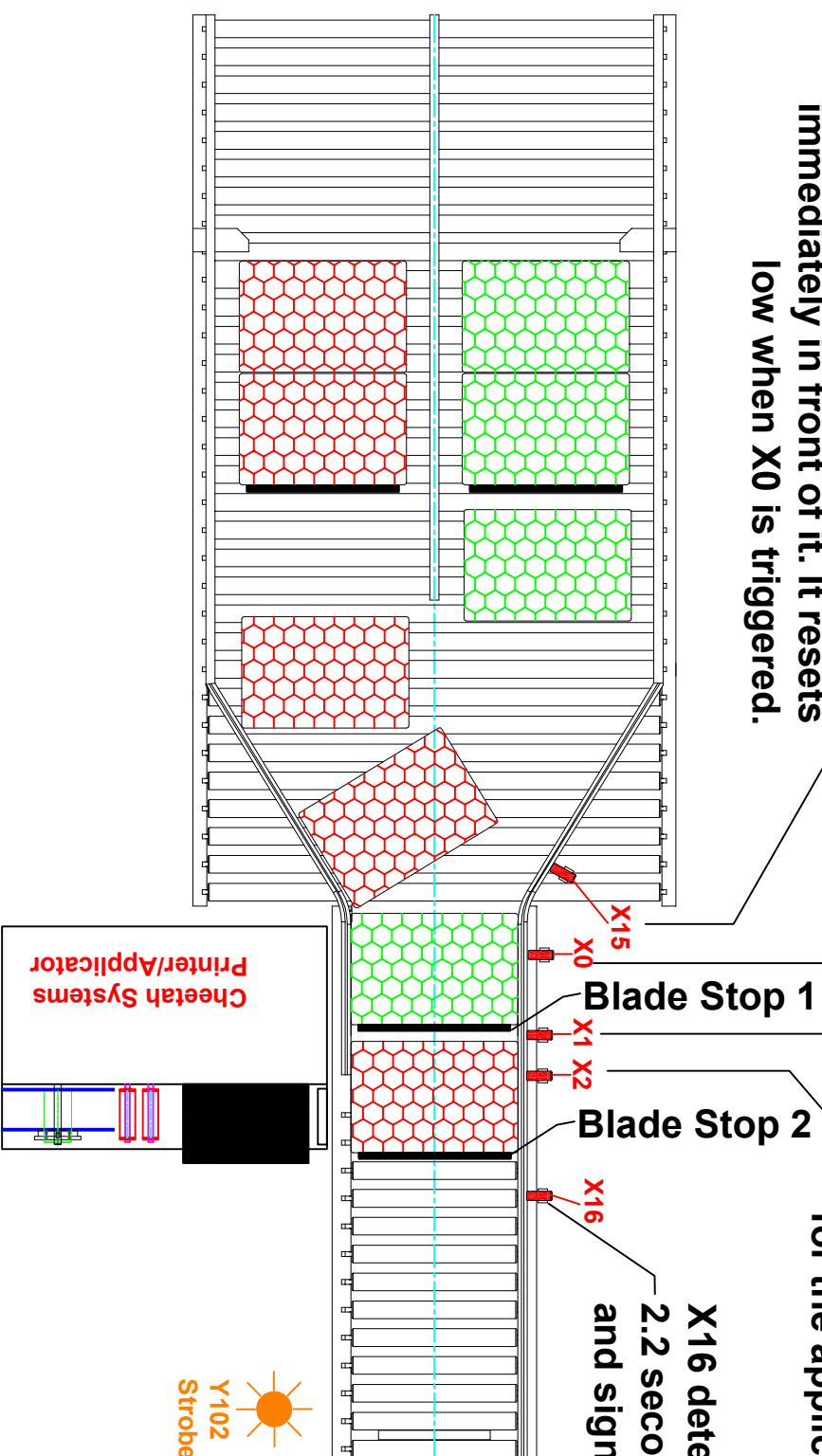
X0 Has a dual function
It operates the blade stop 1
It also will determine the label format
to printed, If the PLC bit is low the labeler
will print format 1, if high it will trigger format 2

X15 will trigger a high within the
PLC Program and stay latched
as long as a box is present
immediately in front of it. It resets
low when X0 is triggered.

X1 is the print trigger, if the print bit within the PLC is in a low
state it will trigger label format 1 (discussed earlier) if the print
bit in the PLC is high it will trigger label format 2

X2 is also a dual function input,
it trigger blade stop 2 and also is the applicator
sequence trigger, it starts the timers
for the application cylinder

X16 detects a back up (box jam) it will trigger a sequence after
2.2 seconds of being blocked to shut down the printer applicator
and signal for human assistance via the strobe light (Y102)



Typical Single Line Layout

Notes:

PROPRIETARY
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 INFORMATION & MUST BE RETURNED UPON REQUEST. DO NOT CIRCULATE,
 REPRODUCE OR DIVULGE TO OTHER PARTIES WITHOUT THE WRITTEN CONSENT
 OF GARY GATEWOOD.

Note!

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 INTERPRET
 DIMENSIONS AND TOLERANCES
 With the criteria stated below:
 TOLERANCE ON ANGLE ± 0° 30'
 ON DECIMAL .XX ± .03
 .XXX ± .003

Quantity = _____

Material:
Various

Cheetah Automation

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|------------------------------------|---------------------|-----------------|--|
| PART NUMBER: CA-??????????????? | | REV: A | |
| DWG SIZE: B | DATE: 12-01-2021 | SHEET 1 OF 1 | |