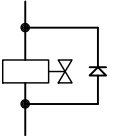
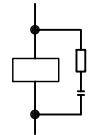
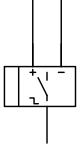
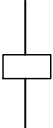
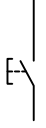
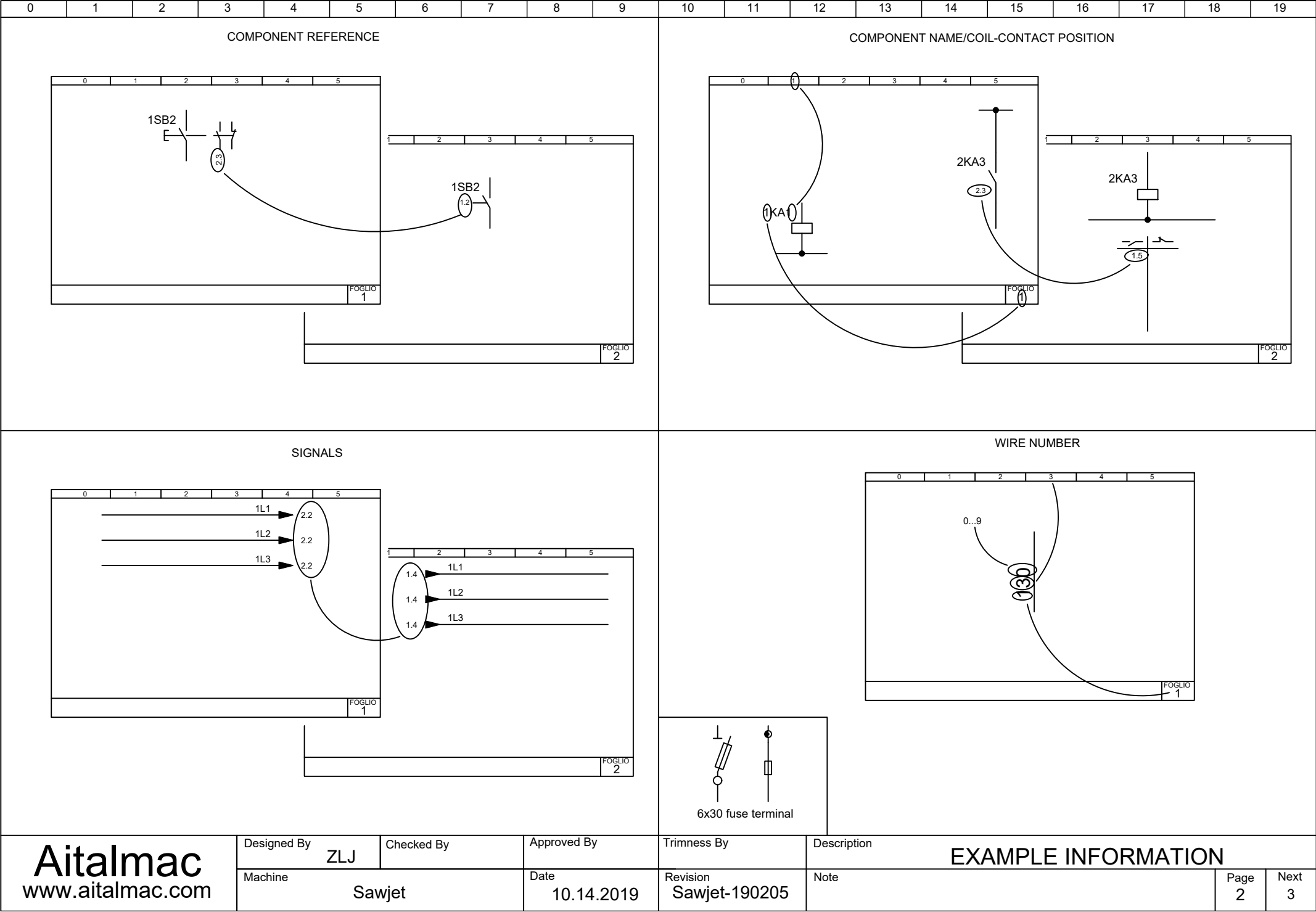
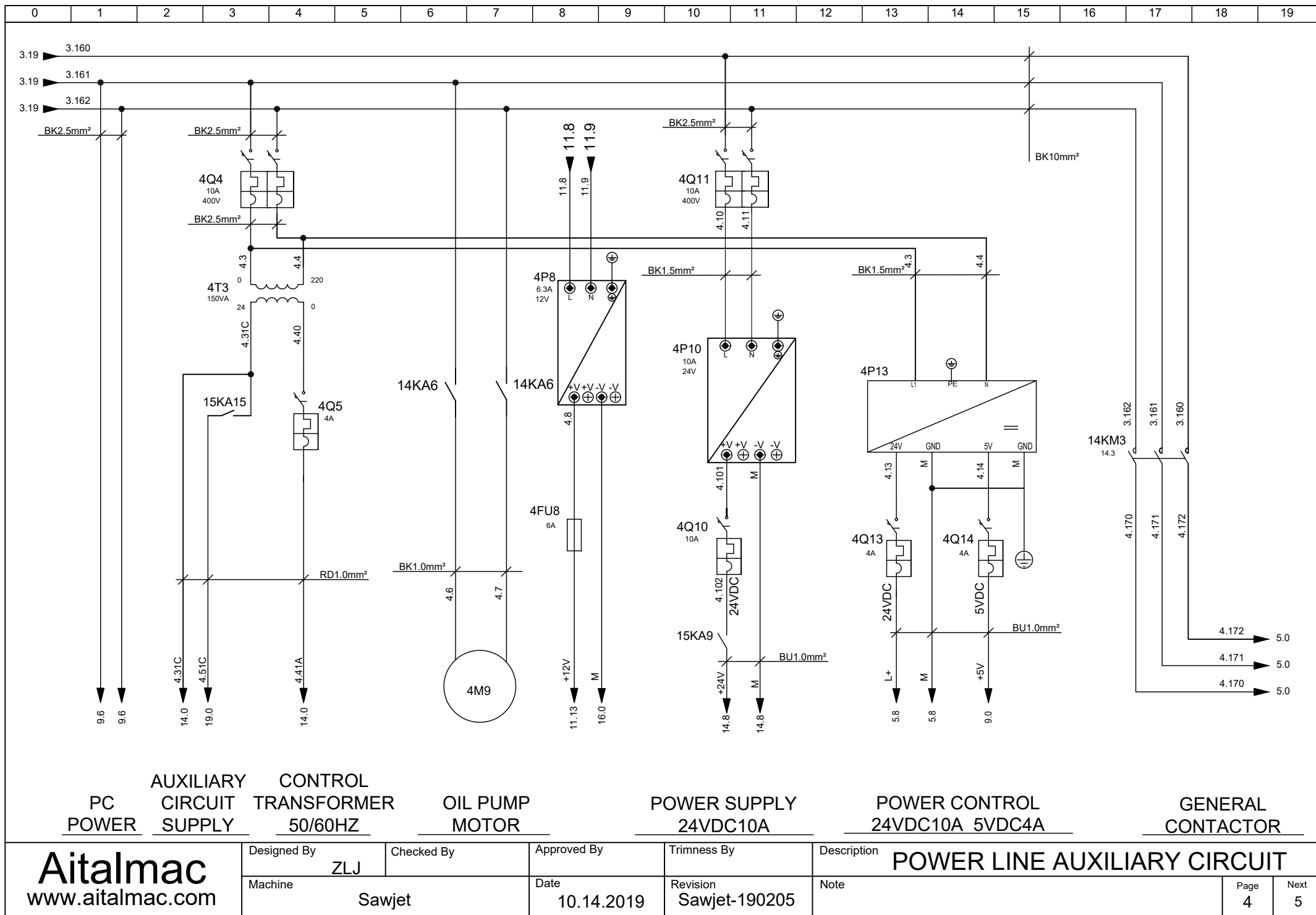
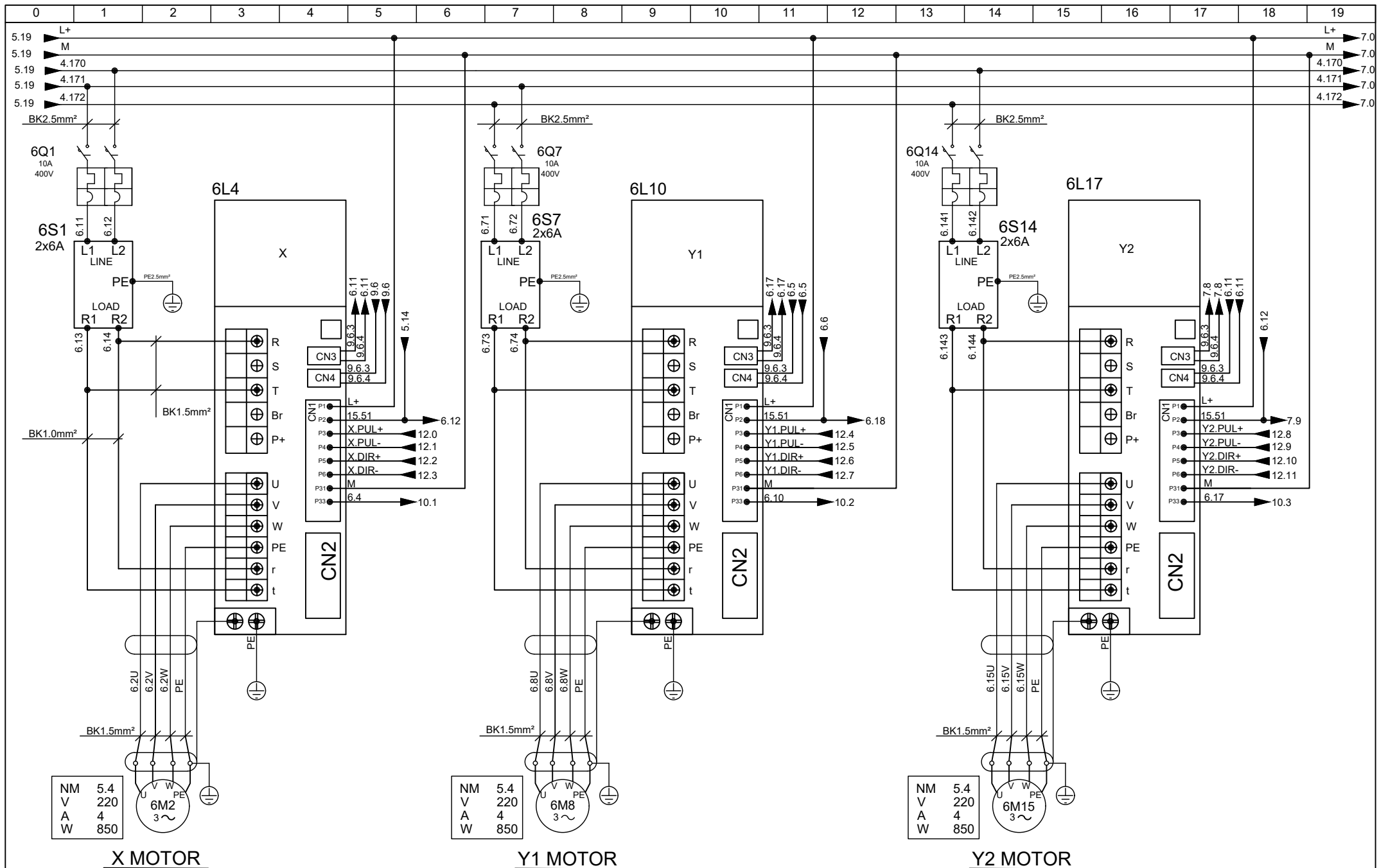


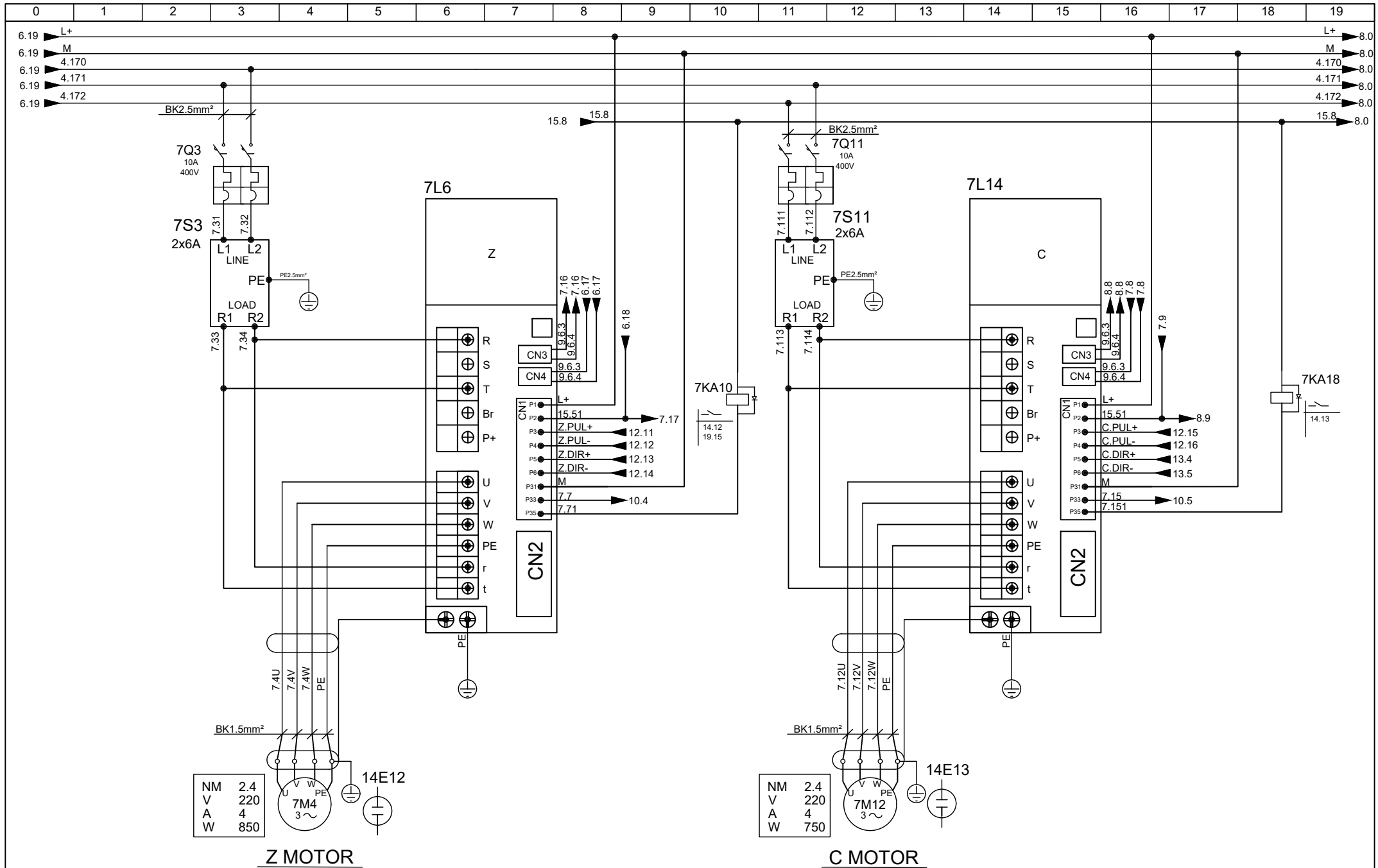
0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19																		
AITALMAC										LOCATION SYMBOLS ☐ Components on the door ☐ Components inside the cubicle (usually omitted) ☒ Machine components (usually omitted)				COMPONENTS DESIGNATION C Condensers D CNC control model E Component not in this list F Protection Devices FU Fuses G Generators, feeders H Signalling devices KA Relays KM Contactors L Drives M Motors N Analog integrated circuits P Switching power supply Q Circuit breaker QS Highly versatile change over switch R Resistors SQ Sensor, Limit S Filter SB Buttons T Transformers U Modulators converters V Rectifiers, semiconductors EV Solenoid valves X Terminal wire clamps, connectors Y Electricity actuating devices																							
CLIENTE																																					
AITALMAC CO.,LTD																																					
MACHINE					MAIN POWER SUPPLY																																
CNC					VOLT. 220																																
SAWJET					FREQ. 50-60																																
WIRING DIAGRAM					CUBICLE DIMENSION																																
Sawjet-190205					L (mm) 1835																																
					H (mm) 560																																
					P (mm) 320																																
CONDUCTORS DESIGNATION																				COLORS WH White GN Gray YE Yellow BU Blue RD Red BK Black OG Orange GY GreenYellow																	
<table><thead><tr><th>COLOR</th><th>FUNCTION</th><th>MINIMUM SECTION</th></tr></thead><tbody><tr><td>BLACK</td><td>power circuit A.C./D.C.</td><td>1,0mm²</td></tr><tr><td>RED</td><td>A.C. auxiliary circuit</td><td>1,0mm²</td></tr><tr><td>BLUE</td><td>D.C. auxiliary circuit</td><td>1,0mm²</td></tr><tr><td>YELLOW GREEN</td><td>protection earth</td><td>2,5mm²</td></tr><tr><td>SCREEN CABLE</td><td>reference - signal</td><td>0.75 mm²</td></tr><tr><td>RED +/-BLUE -</td><td>thermocouples</td><td>COMPENSATED CABLE</td></tr><tr><td></td><td>PLC circuit</td><td>0,25mm² (0,5mm² I<2A)</td></tr></tbody></table>																								COLOR	FUNCTION	MINIMUM SECTION	BLACK	power circuit A.C./D.C.	1,0mm²	RED	A.C. auxiliary circuit	1,0mm²	BLUE	D.C. auxiliary circuit	1,0mm²	YELLOW GREEN	protection earth
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THE WIRING DIAGRAM IS INDICATED WITHOUT TENSION, AIR, OIL AND WATER FLOW.										MAIN CIRCUIT BREAKER OPERATING TIME: _____ SYMMETRICAL SHORT-CIRCUIT CURRENT: _____																											
										WARNING: THE PROTECTION OF THE MAIN POWER SUPPLY AND THE CONNECTION TO THE EARTH'S SYSTEM ARE DEPENDANT ON THE CUSTOMER. IN RESPECT TO THE EUROPEAN STANDARD EN60439-1 SPECIFICATIONS - CEI 17-13.1 DOSSIER 1433 - AND DPR 547 DD 27/04/1955, THE MAIN POWER SUPPLY MUST BE PROTECTED WITH A PROPER MAGNETIC-THERMAL SWITCH HAVING BREAKING CAPACITY NOT LOWER THAN 10 KILOAMPERE.																											
AitalMac www.aitalmac.com		Designed By : ZLJ			Checked By :			Trimness By :			Description :																										
		Machine : Sawjet			Date: 10.14.2019			Revision: Sawjet-190205			Approved By :			Pag. 1	Next. 1.1																						

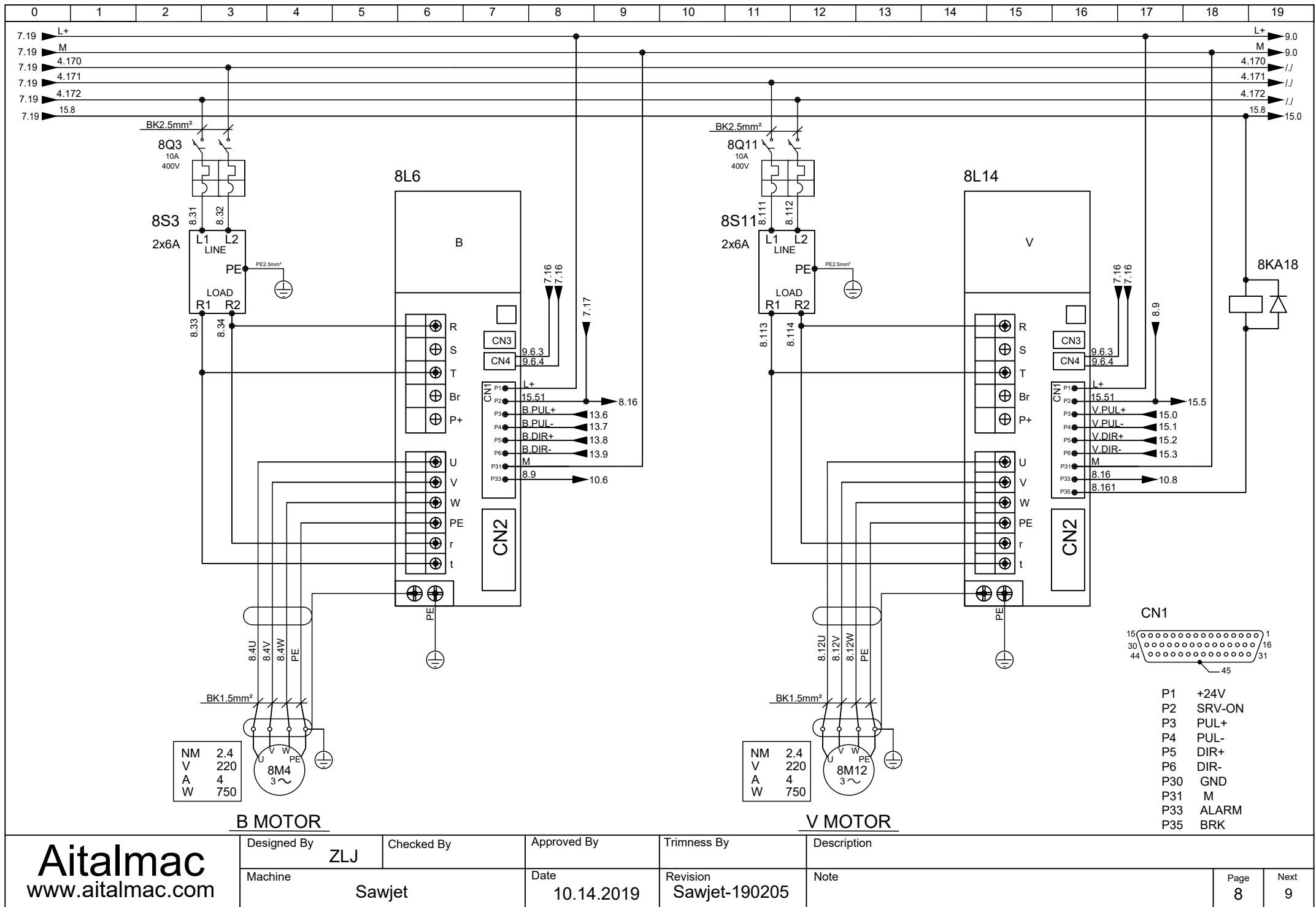
SYMBOL	MEANING	SYMBOL	MEANING
	NORMALLY OPEN CONTACT		SOLENOID VALVE
	NORMALLY CLOSED CONTACT		AC CONTACTOR
	SENSOR		RELAY
	BUTTON		
	LAMP		

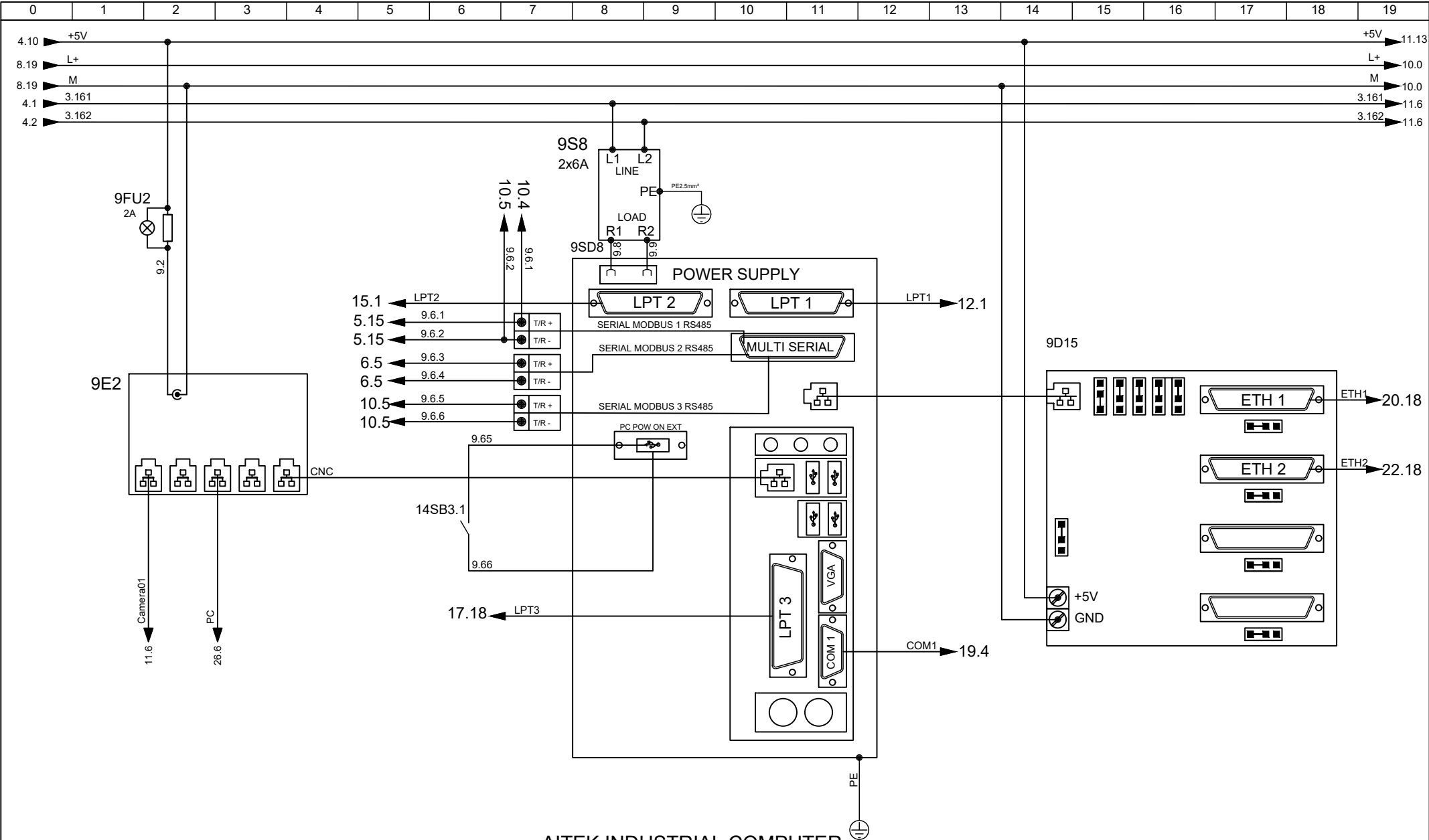










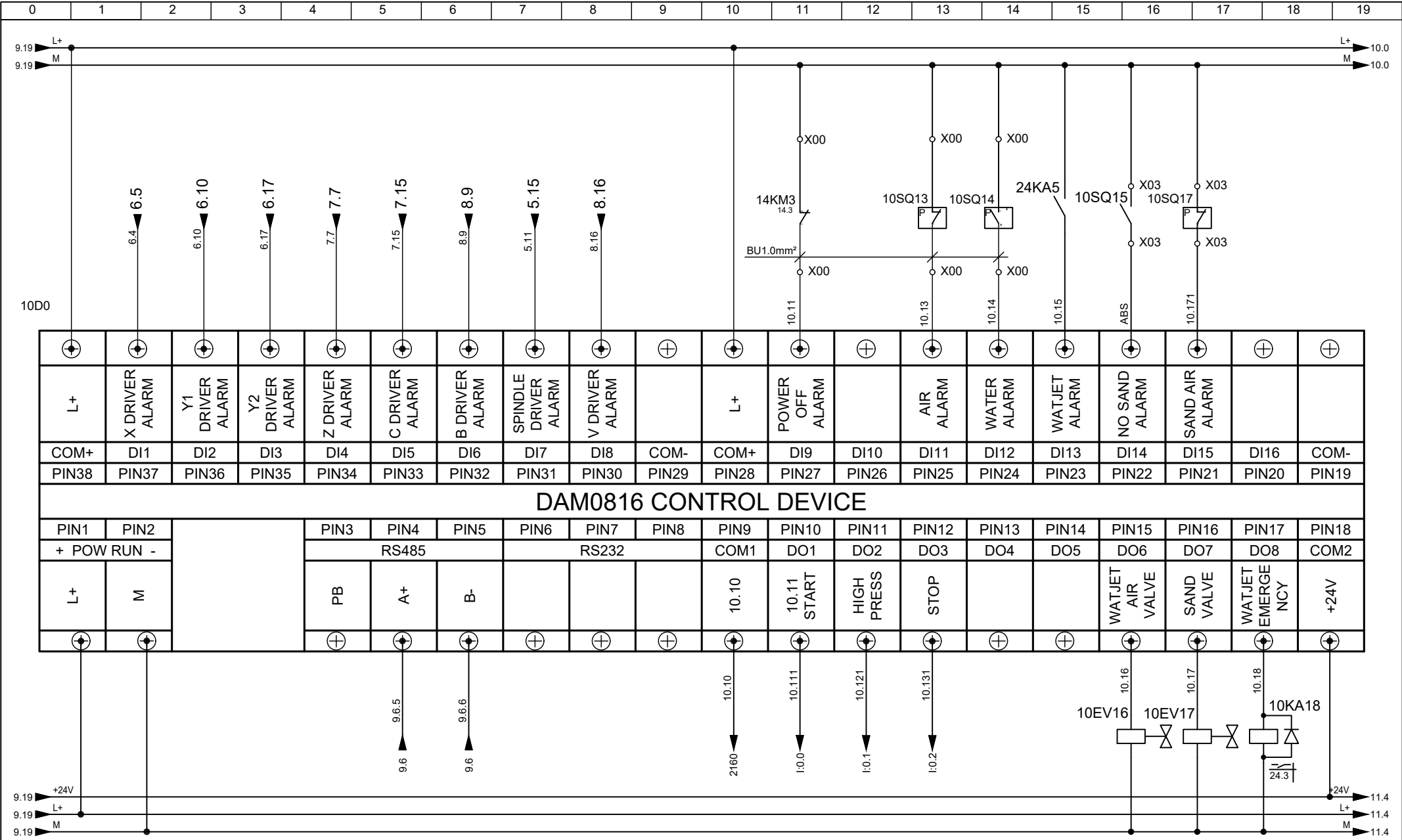


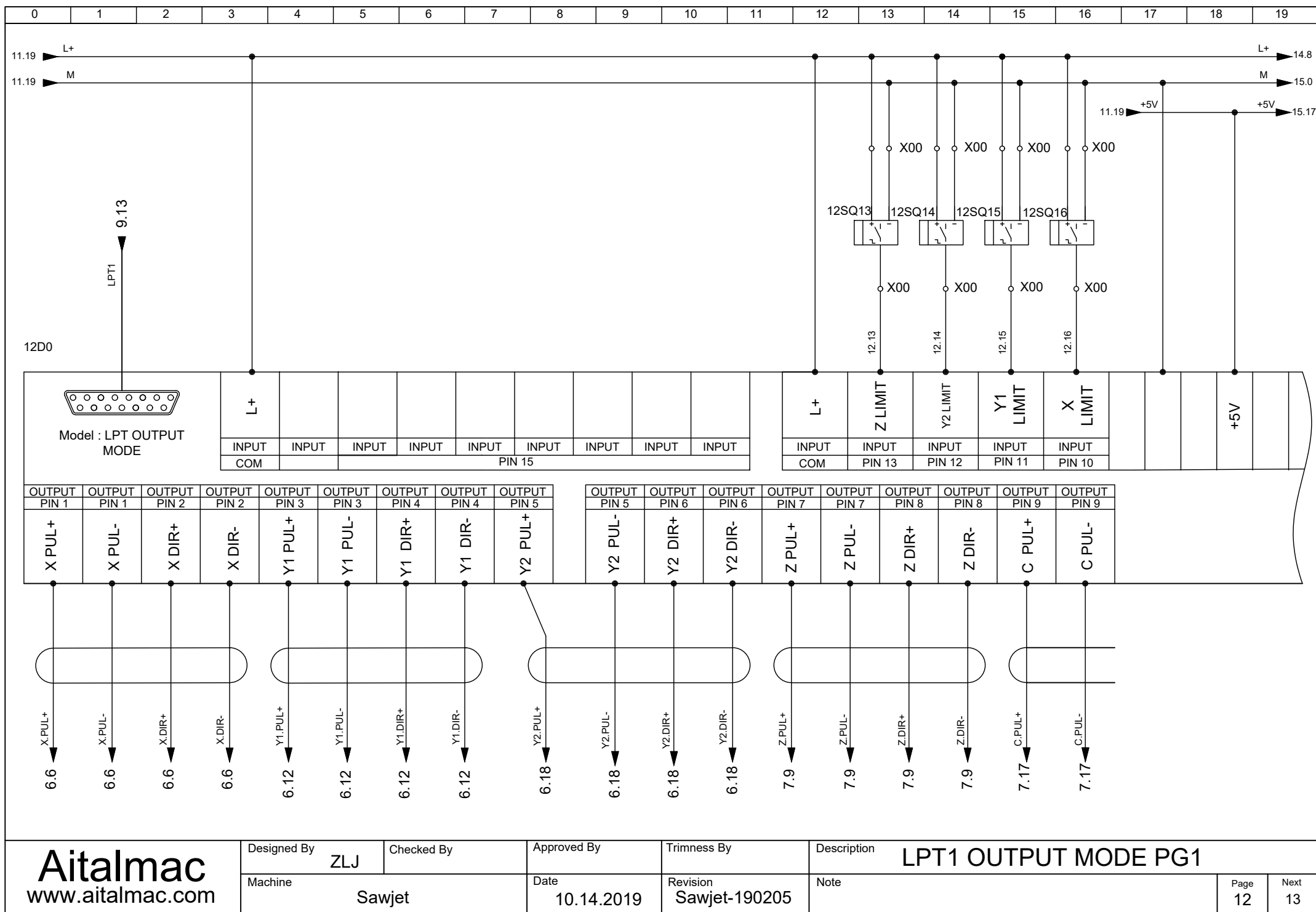
WIFI ROUTE
POWER

Wi-Fi
ROUTER

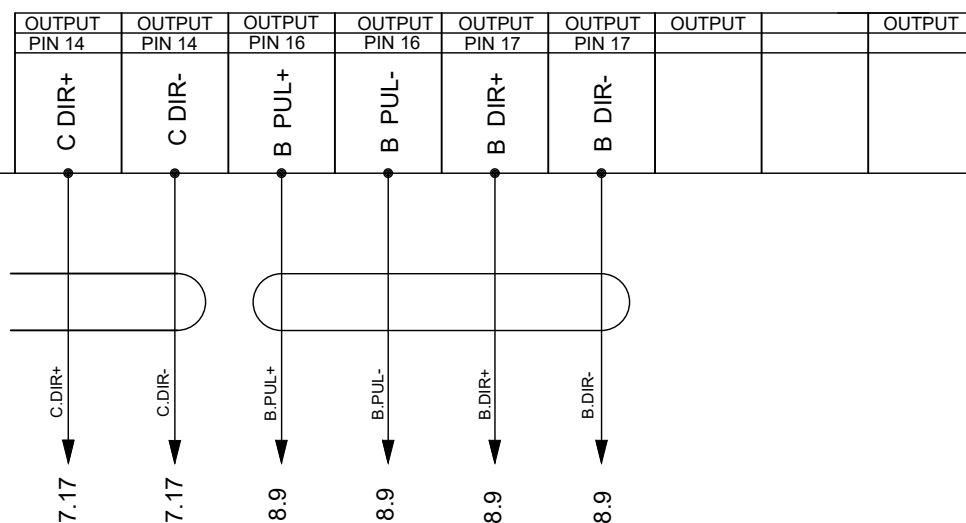
AITEK INDUSTRIAL COMPUTER
9 AXIS CNC CONTROLLER
ONLINE MONITORING SYSTEM

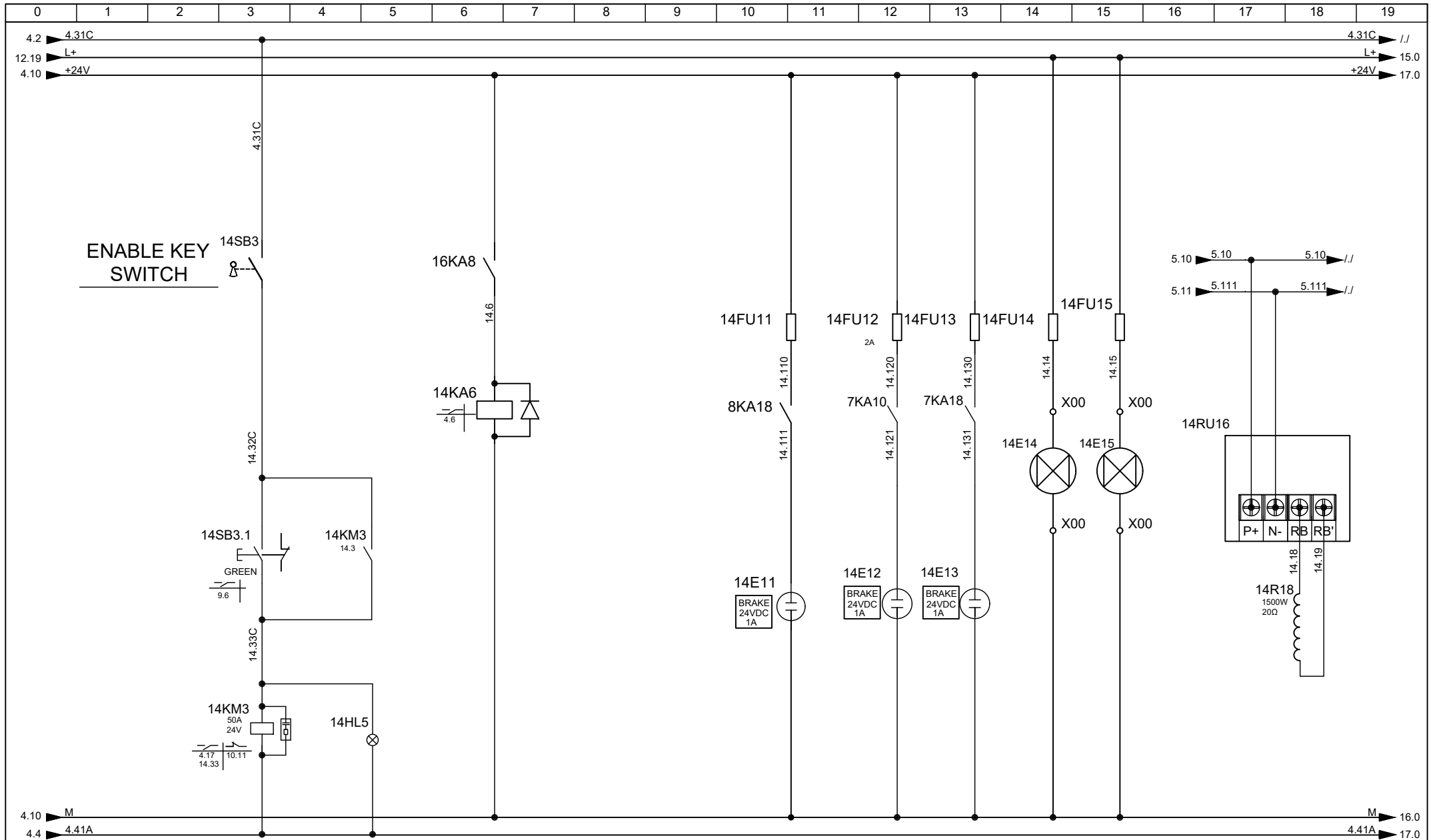
Aitalmac www.aitalmac.com		Designed By ZLJ	Checked By	Approved By	Trimness By	Description CNC COMPUTER		
		Machine Sawjet	Date 10.14.2019	Revision Sawjet-190205	Note		Page 9	Next 10





12D0





POWER ON & POW-ON
EMERGENCY LIGHT

OIL PUMP

V
BRAKE

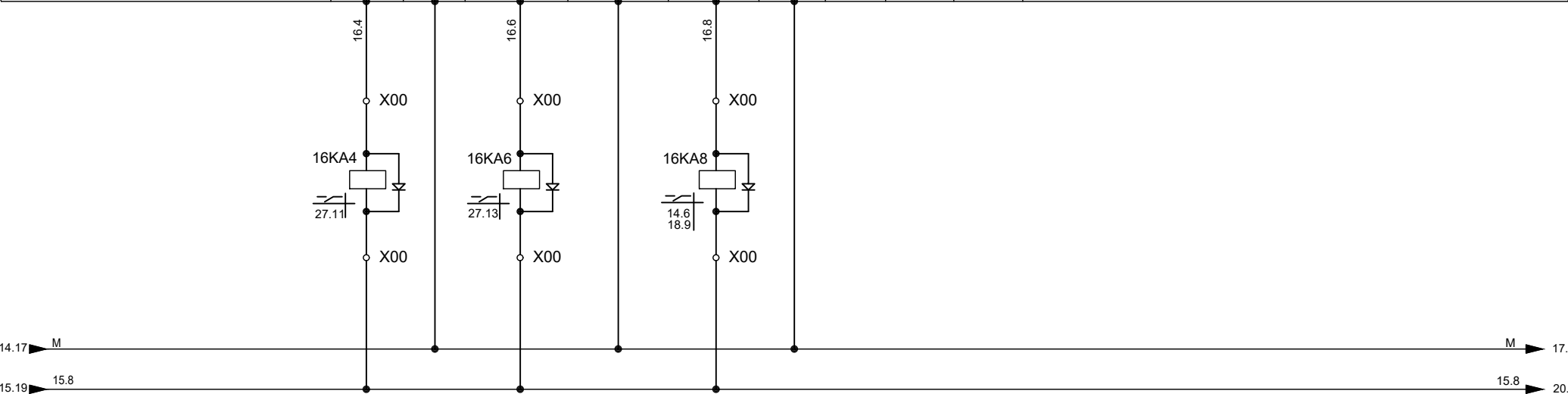
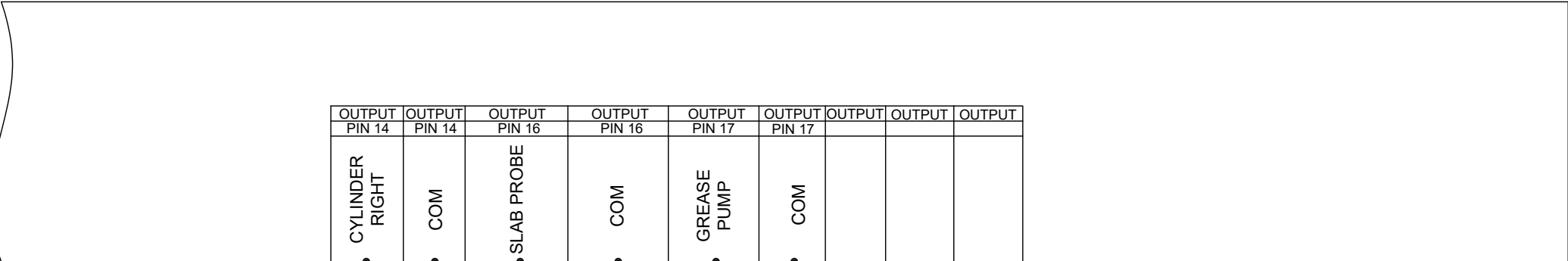
Z
BRAKE

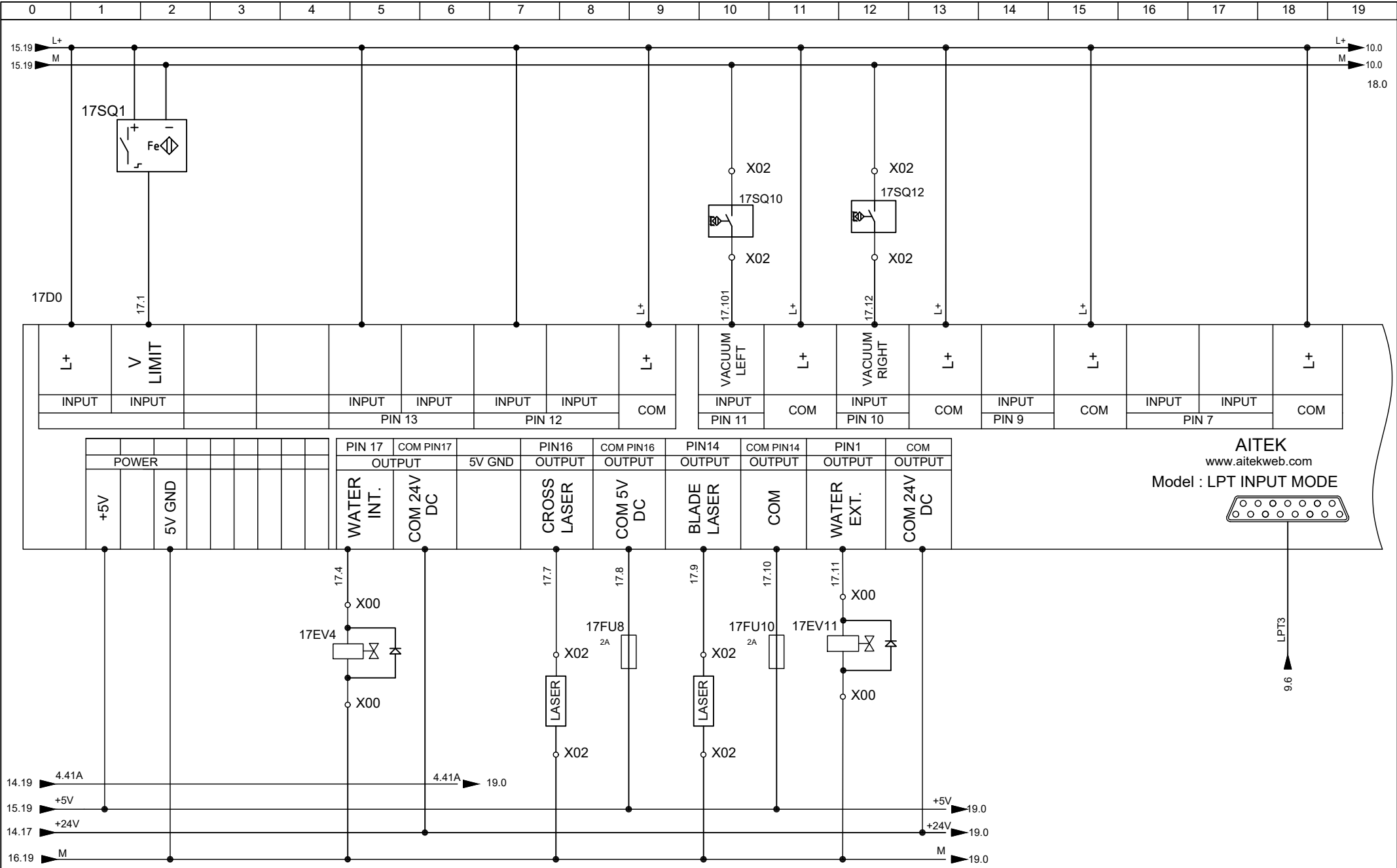
C
BRAKE

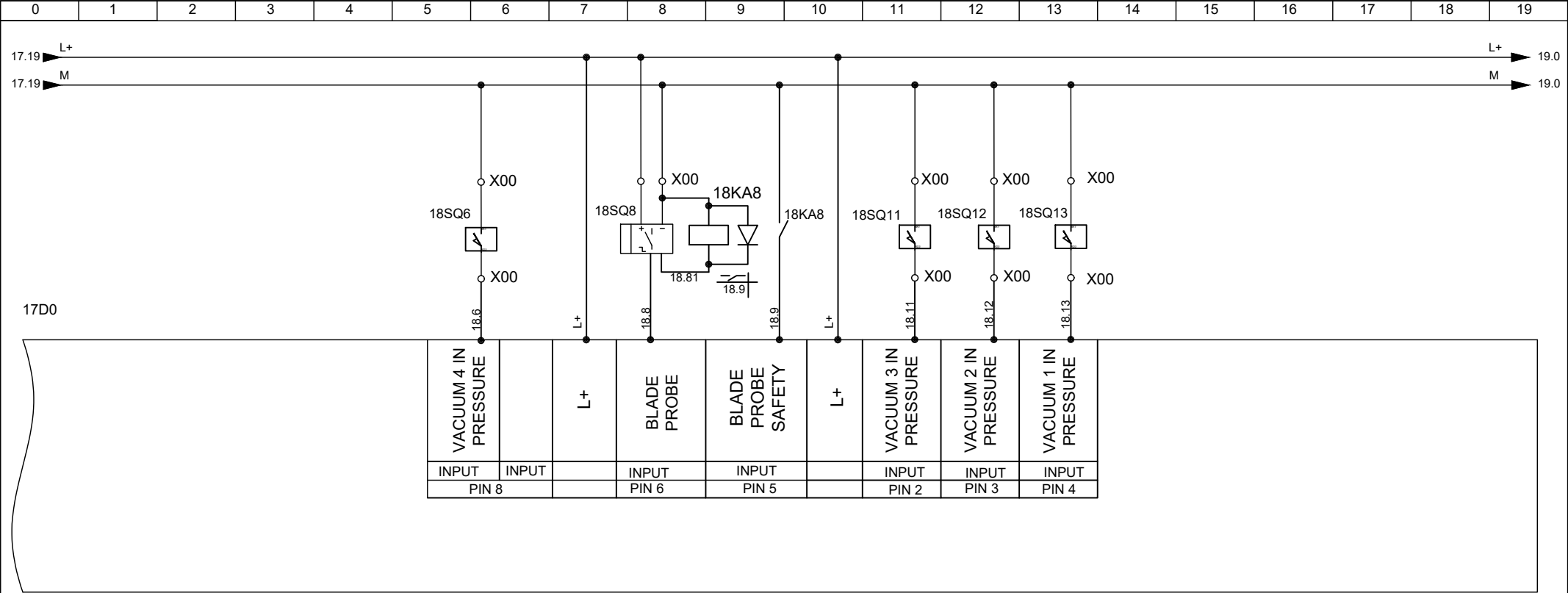
BOX CONTORL
FAN BOX FAN

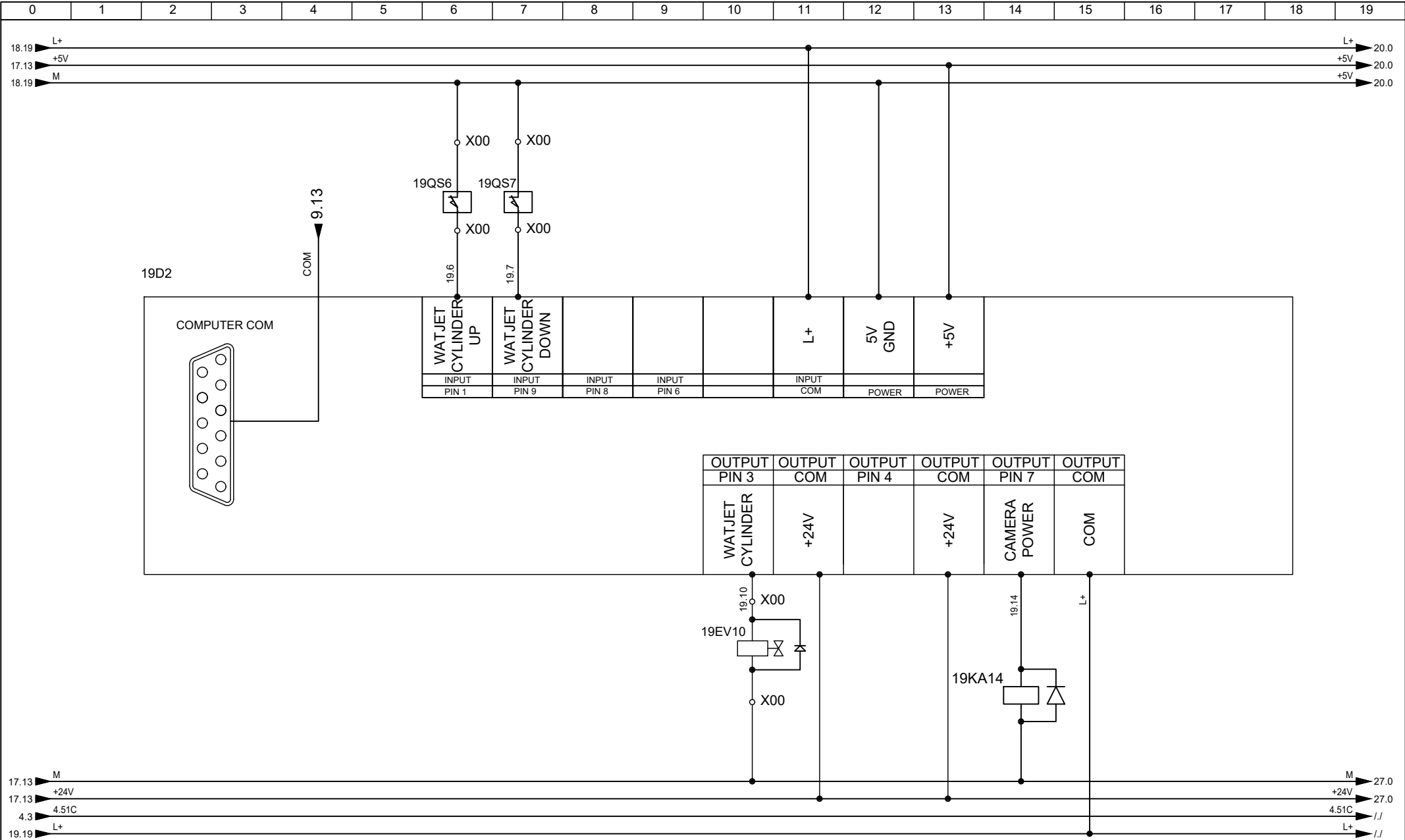
BRAKE
UNIT

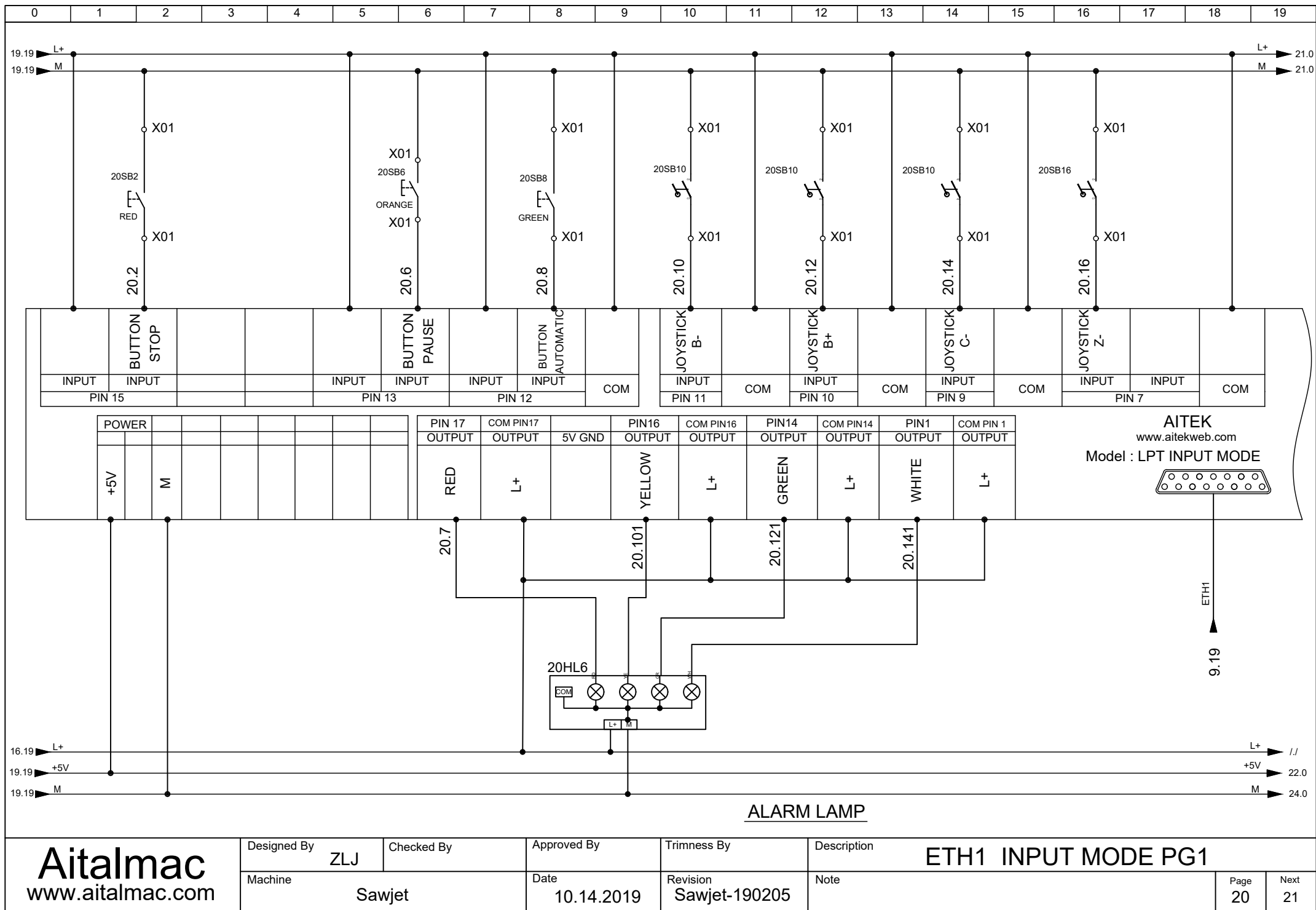
15D0

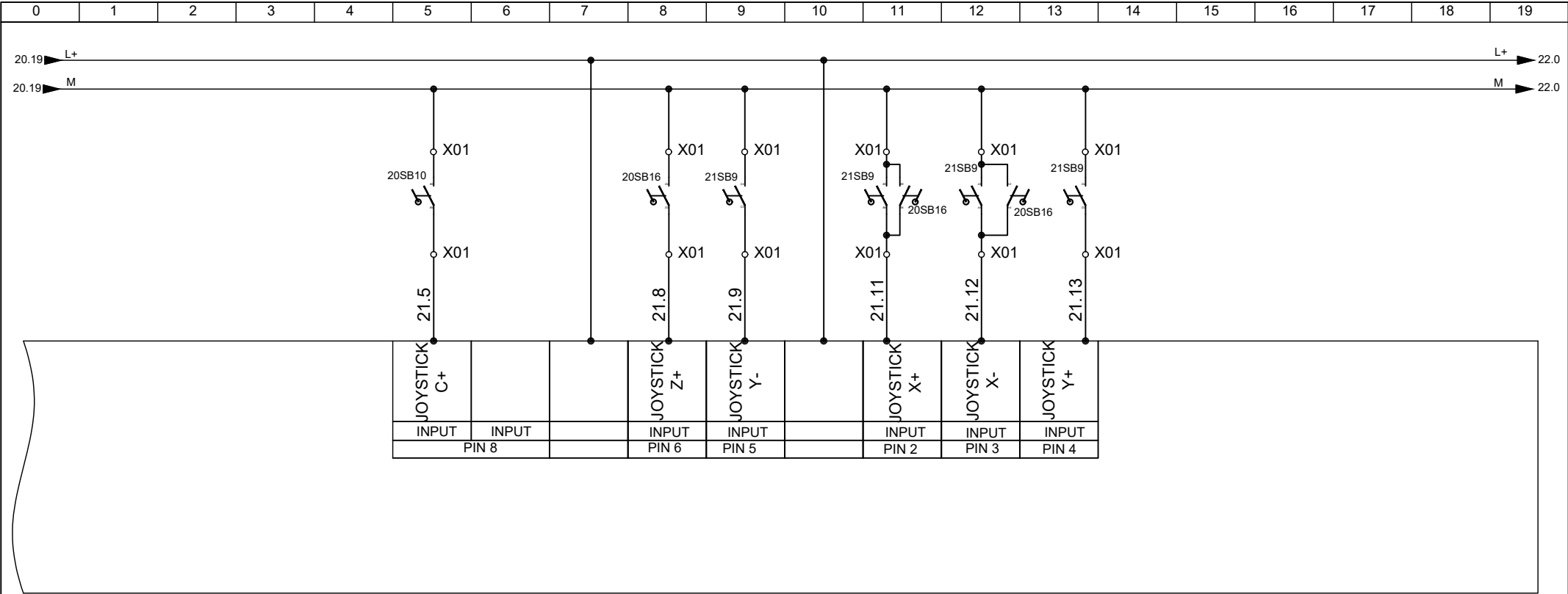




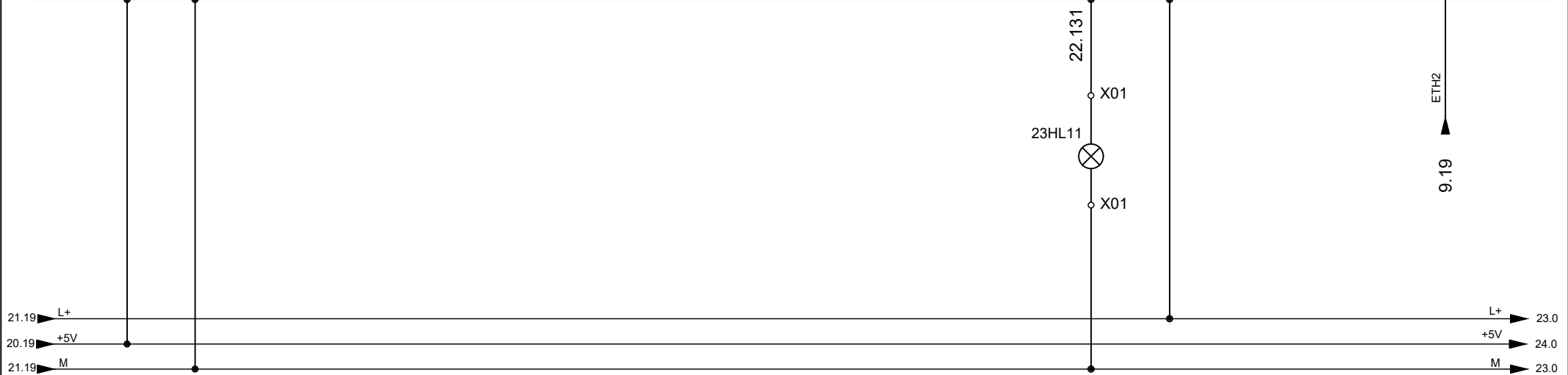
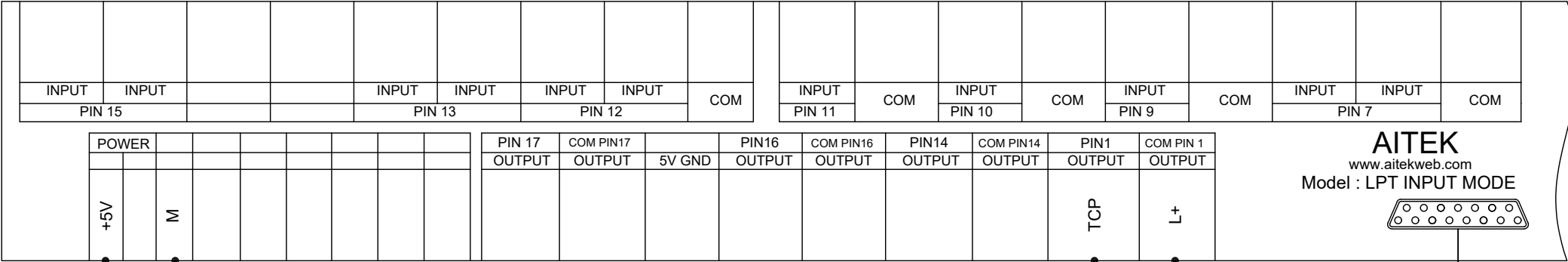




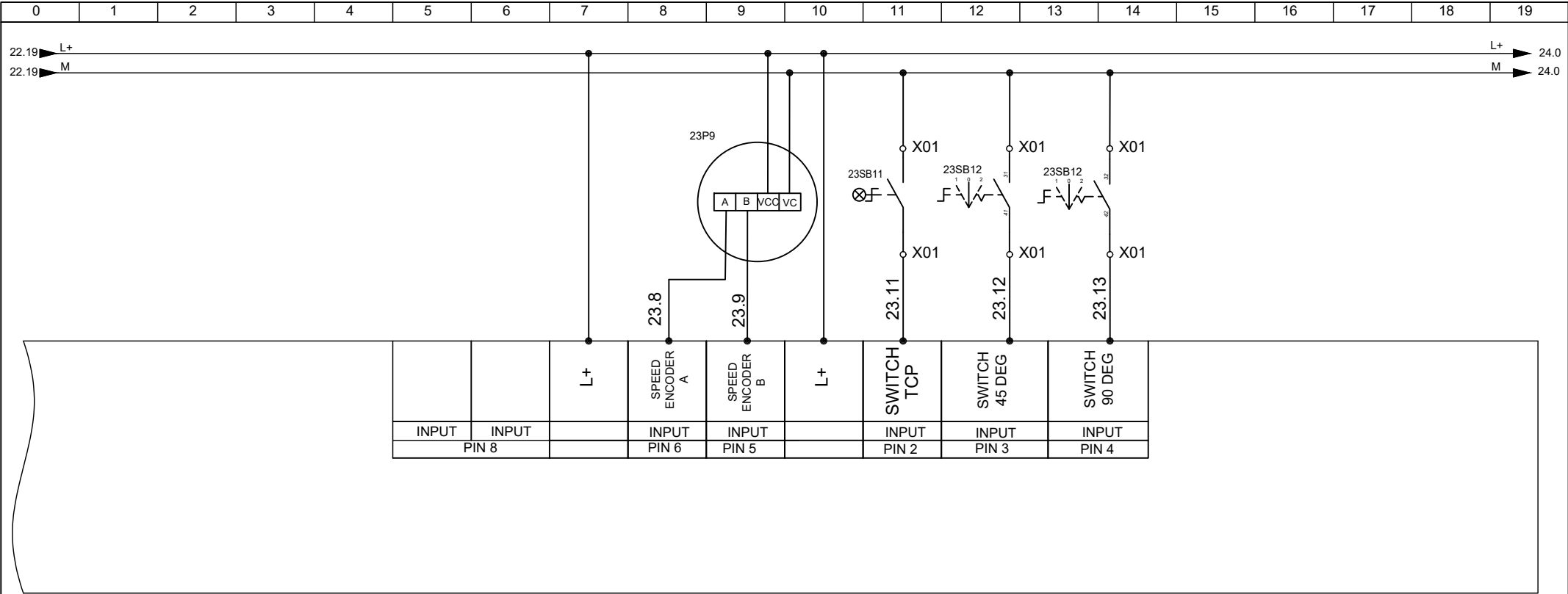




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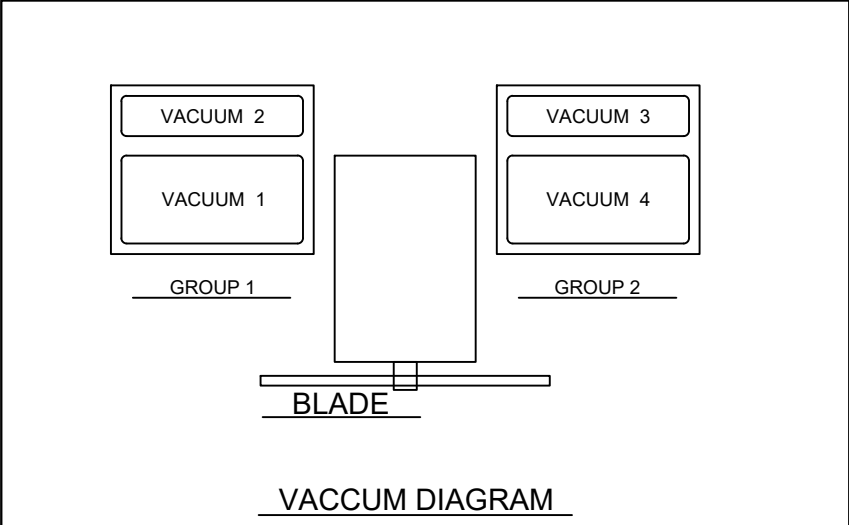
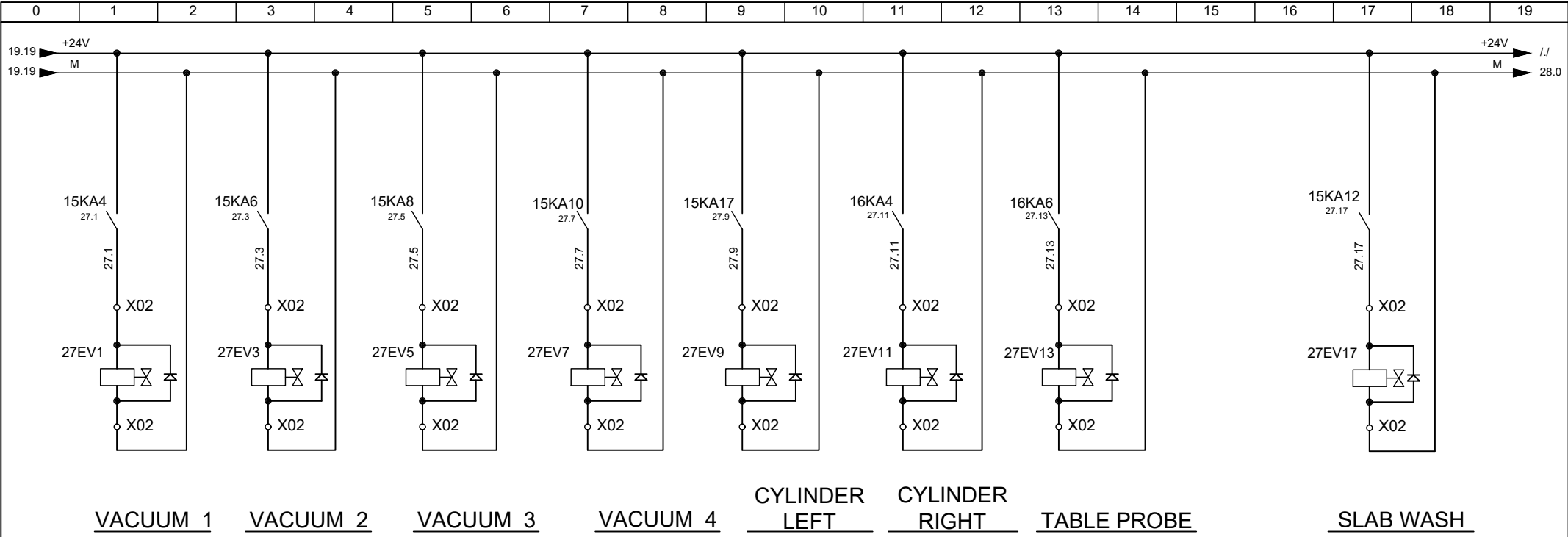


TCP LIGHT

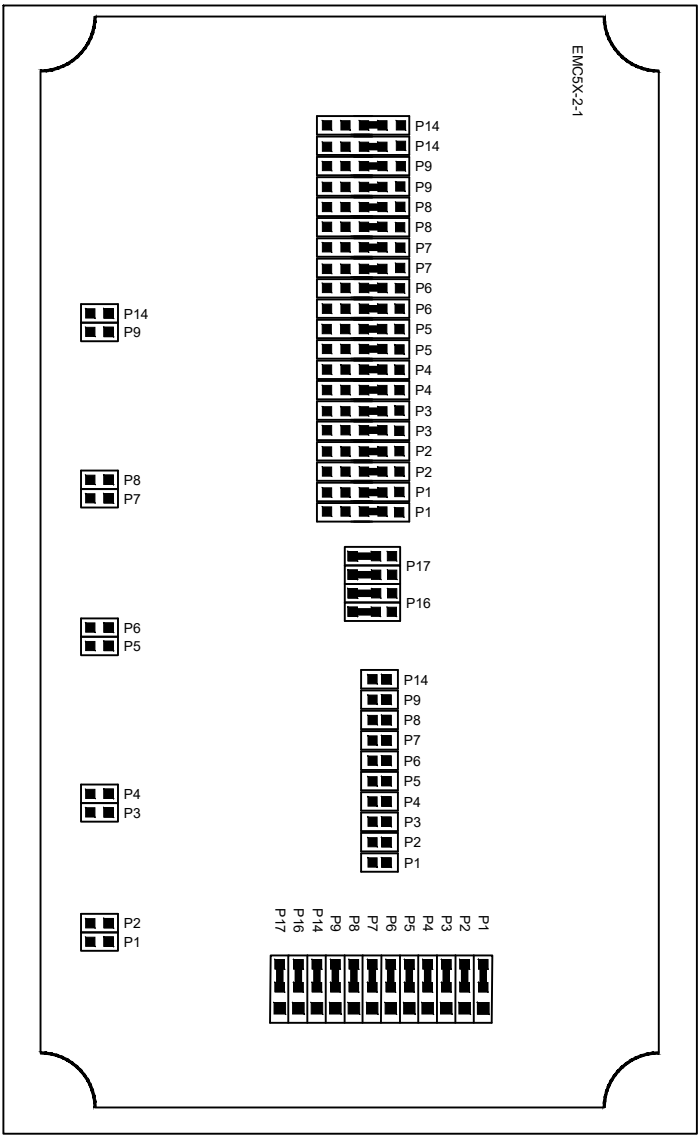


SPEED CONTROL WHEEL

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Aitalmac www.aitalmac.com				Designed By		Checked By		Approved By		Trimness By		Description							
				Machine		Date		Revision		Note						Page	Next		
				ZLJ														25	26
				Sawjet		10.14.2019		Sawjet-190205											

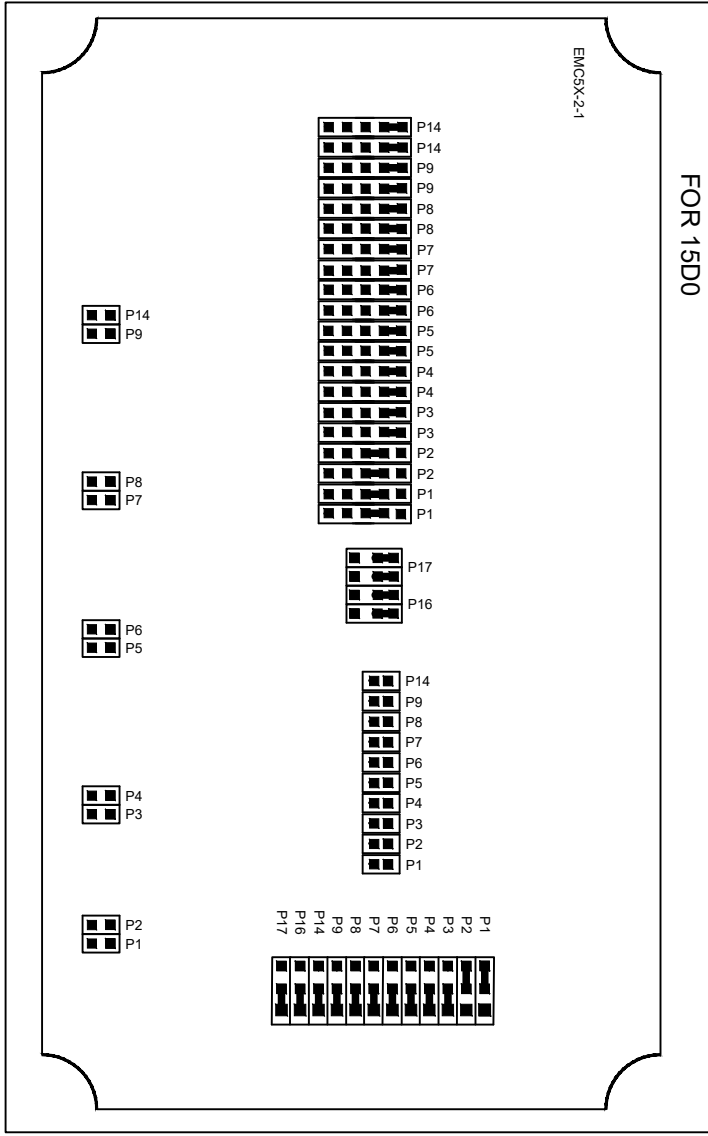


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Aitalmac www.aitalmac.com				Designed By		Checked By		Approved By		Trimness By		Description							
				Machine		Date		Revision		Note						Page	Next		
				ZLJ														29	30
				Sawjet		10.14.2019		Sawjet-190205											



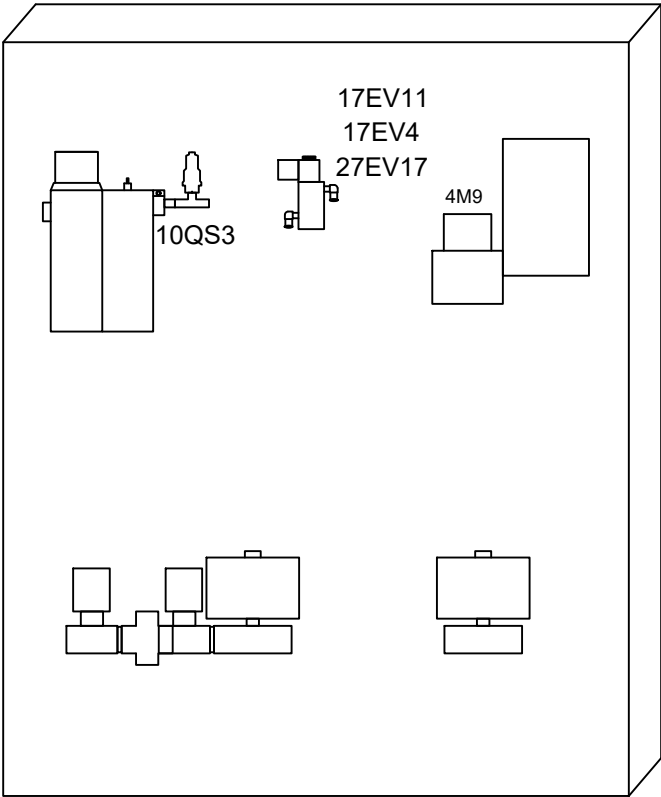
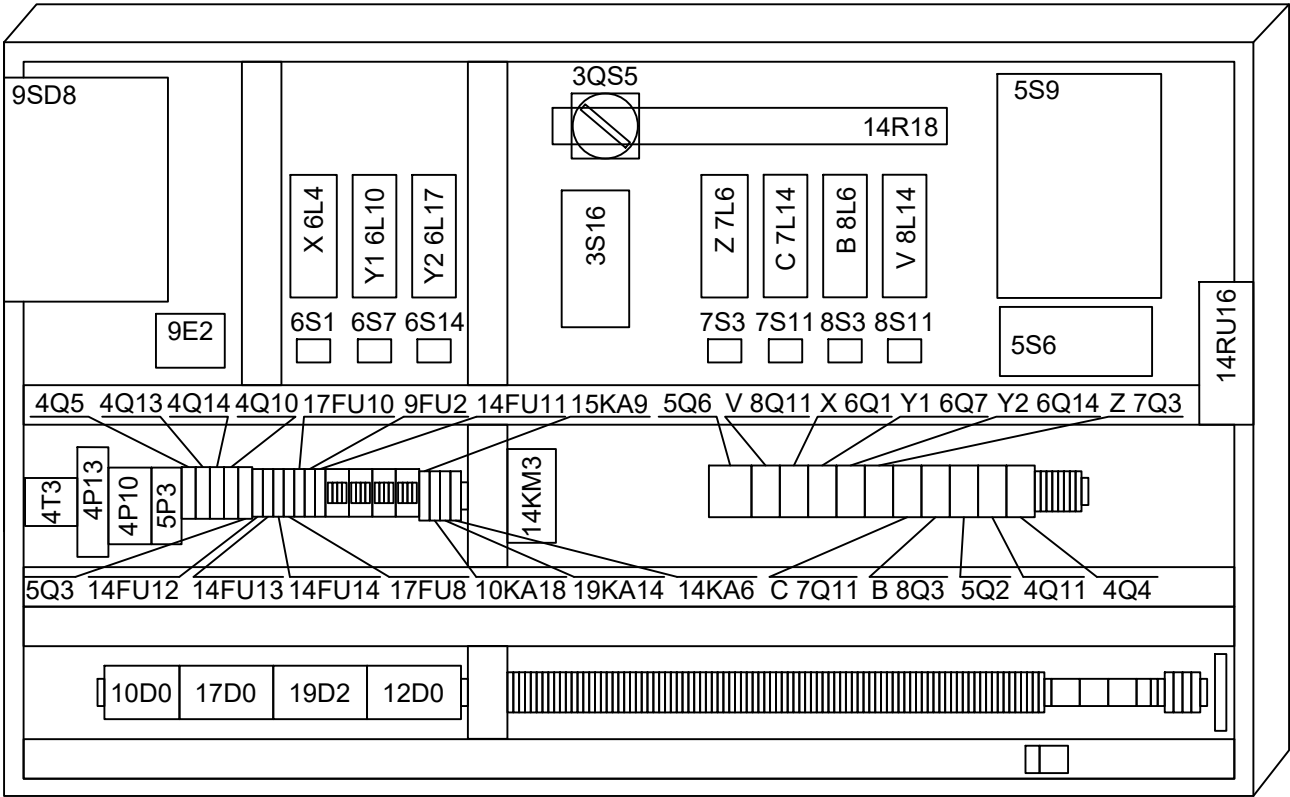
FOR 12D0

OUTPUT CONTROL CARD JUMPERS SETTINGS



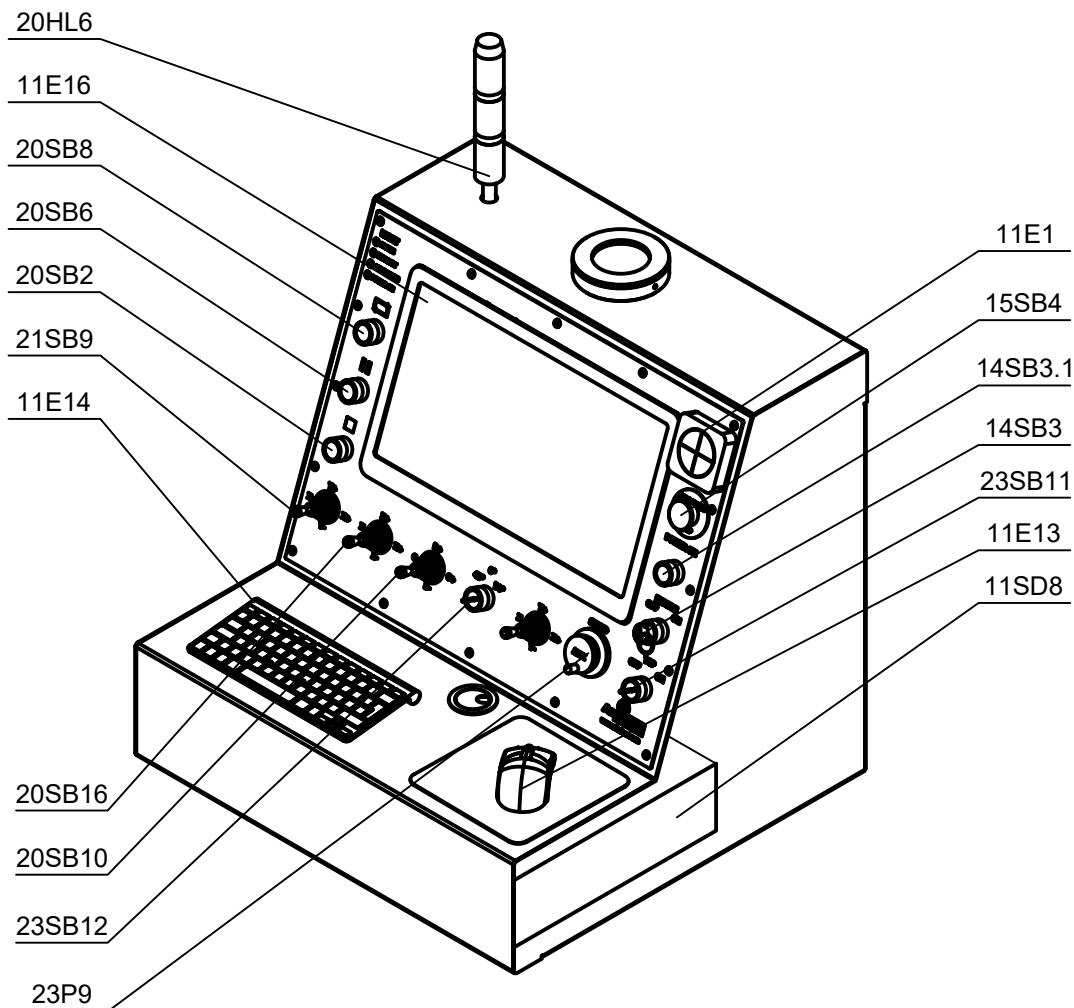
FOR 15D0

SECOND OUTPUT CONTROL CARD JUMPERS SETTINGS

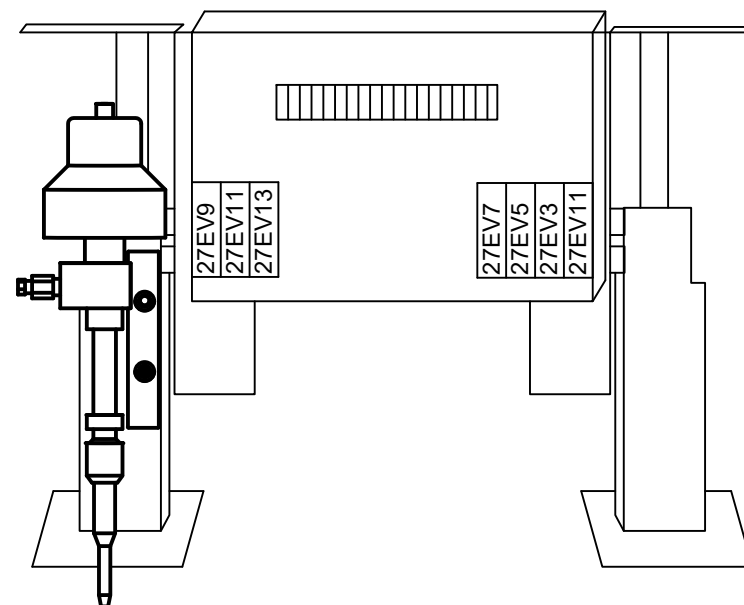


X00

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X01



X02

Technical drawing of the KMT H20 JET 50 machine, showing a front view and a side view.

Front View:

- Machine model: **KMT H20 JET 50**
- Internal component labeled: **24KA5**

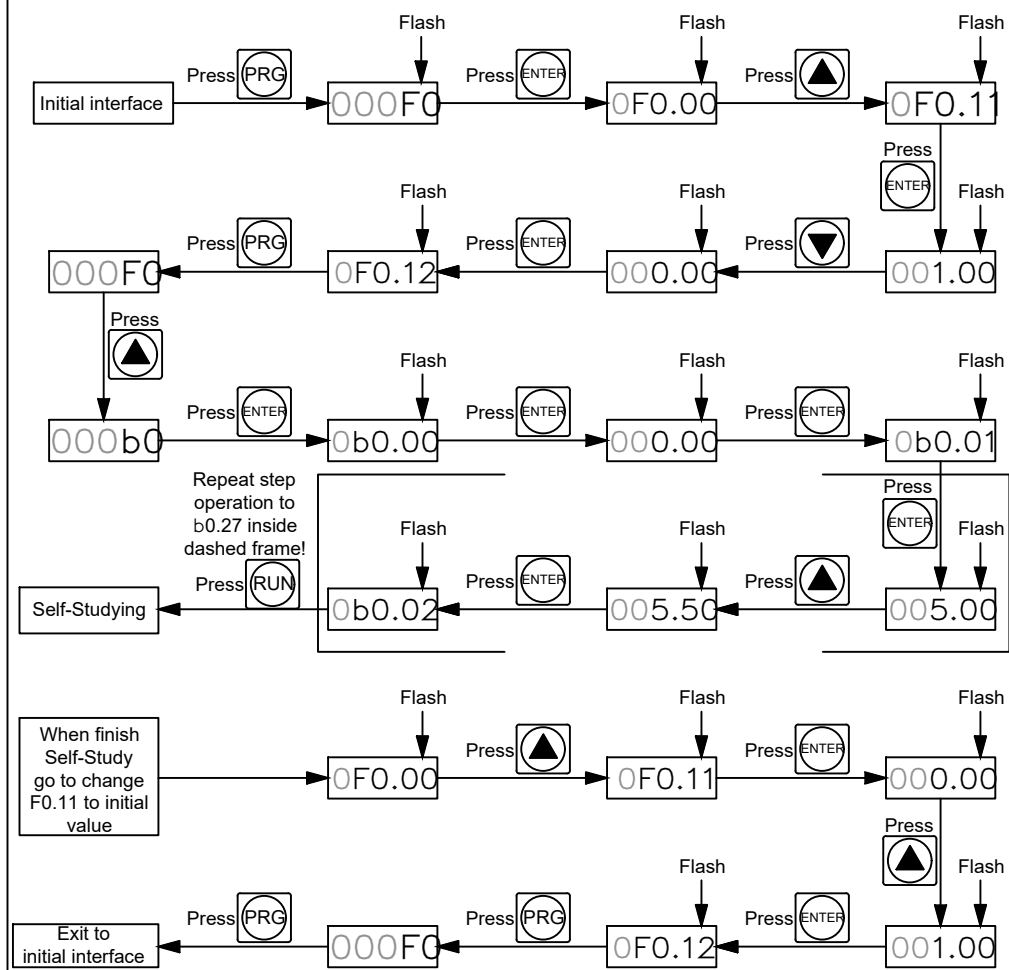
Side View:

- Top component labeled: **10SQ17**
- Internal component labeled: **10SQ15**
- Machine is mounted on a stand with three legs and casters.

X02

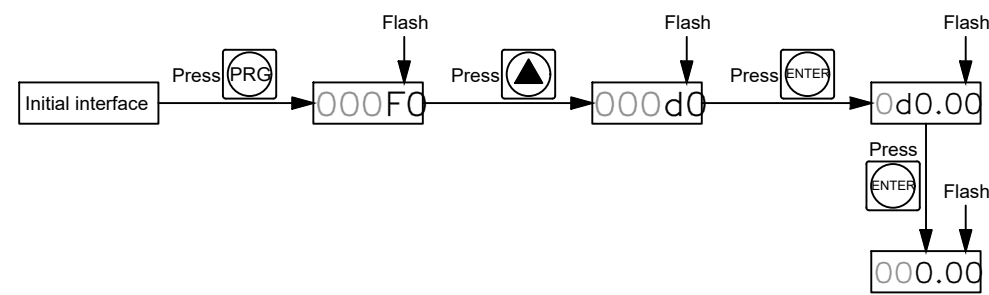
Motor Self-Study

F0.11=0 b0.03=18.2
b0.00=0 b0.04=60
b0.01=5.5 b0.05=1710
b0.02=220 b0.27=2



Monitoring Function

d0.00 Output Frequency
d0.01 Input Frequency
d0.14 Motor Speed
d0.18 High speed pulse input frequency



Inverter Parameter

Name	Range	Default	Units
F0.00	0,1,2	2	
F0.01	0.00Hz~F0.19(MAX)	1000	Hz
F0.02	1:0.1Hz,2:0.01Hz	1	
F0.03	0~9	9	
F0.04	0~9	0	
F0.11	0,1,2,3,4	1	
F0.13	0.0s~6500s	15	
F0.14	0.0s~6500s	35	
F0.18	0.5k~16k	10k	Hz
F0.19	50.00Hz~3200.00Hz	1000.00	Hz
F1.04	-	30	
F9.00		6006	9200BPS
F9.01	0~3	3	(8-N-1)
F9.02	1~250	6	
F9.05	0~3	1	MODBUS
F9.07		0	MODBUS

Servo Driver Parameter

Name	Range	X	Y1	Y2	Z	B	C	V
PA-003		13	13	13	13	13	13	13
PA-004		750	750	750	750	750	750	750
PA-006	0/1	1	1	1	1	0	0	0
PA-008		5000	5000	5000	5000	5000	5000	5000
PA-009						16384	16384	16384
PA-010						1250	1250	1250
PA-222		1250	1250	1250	1250	1250	1250	1250
PA-410	101-181	181	181	181	181	181	181	181
PA-529		53	53	53	53	53	53	53
PA-531	1-256	1	2	3	4	7	5	6

0	1	2	3	4	5	6	7	8	9	10	11	12	13	
Pg.	Code	Name	Mfrs.	Model	Pg.	Code	Name	Mfrs.	Model	Pg.	Code	Name	Mfrs.	Model
3	3QS5	General Switch	GLELE	GLD11-63/08 +4P	8	8S3	Filter	Canny Well	CW1B-6A-L	8	8M4	B Motor	Leadshine	ACM8008M2F-B1-L-SS 750W
3	3S16	Mains Filter	DUOJI	NF312C36/16	8	8L6	B Servo Drive	Leadshine	L5-750Z	8	8Q11	Circuit Breaker	Schneider	IC65N D20A 2P
3					8	8S11	Filter	Canny Well	CW1B-6A-L	8	8M12	B Motor	Leadshine	ACM8008M2F-B1-L-SS 750W
4	4T3	Transformers	CHNT	NDK(BK)-150	8	8L14	B Servo Drive	Leadshine	L5-750Z	8	8KA18	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V
4	4Q4	Circuit Breaker	Schneider	IC65N D10A 2P	9	9FU2	Fuse	CHE	FS-101 DC24V 2A	9	9E2	Wireless Router	ASUS	RT-AC53
4	4Q5	Circuit Breaker	Schneider	IC65N D4A 1P	9	9S8	Filter	Canny Well	CW1B-6A-L	9	9SD8	CNC Controler	AITEK	9 AXIS CNC-A5
4	4M9	Oil Pump Motor	ML	MYK-202-200-0 15W/220V 2L	9	9SD8	CNC Controler	AITEK	9 AXIS CNC-A5	9	9D15	ETH Card	--	7i80b
4	4P8	Power Supply	MW	EDR-75-12 6.3A12VDC	10	10D0	Control Device	JUYING	DAM0816D RS232 485	10	10SQ13	Air Pressure Switch	SQW	QPM11-NC
4	4FU8	FUSE	Schneider	LRD16C 9-13A	10	10SQ14	Water Pressure Switch	SN	DN8 1.1-1.8kgf/m² (ON-OFF)	10	10SQ15	NO SAND SENSOR	--	--
4	4P10	Power Supply	MW	NDR-240-24 10A24VDC	10	10SQ17	Air Pressure Switch	SQW	QPM11-NC	10	10EV16	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V
4	4Q10	Circuit Breaker	Schneider		10	10EV16	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V	10	10EV17	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V
4	4Q11	Circuit Breaker	Schneider		10	10EV16	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V	10	10KA18	Terminal Relay	OMRON	G2R-2-SND(S) DC24V+P2RF-08-E
4	4P13	Switching Power Supply	MW	EDR-75-12 6.3A12VDC	10					10				
4	4Q13	Circuit Breaker	Schneider		11	11E1	Computer Power On/Off	Aitalmac	--	11	11E6	USB-WiFi	COMFAST	CF-7201ND
4	4Q14	Circuit Breaker	Schneider		11	11S8	Filter	Canny Well	CW1B-6A-L	11	11SD8	Windows PC	AITEK	WIN-A5
5	5P3	Power Supply	MW	--	11	11E13	USB-Mouse	Lenovo	M300	11	11E14	USB-Keybaord	Logitech	K310
5	5Q3	Circuit Breaker	Schneider	C65N-DC 1P C4A	11	11E16	PC Monitor	Anmite	AN-195W01D	12	12D0	LPT1 Output Card	AITEK	6AXIS-Mod-V5-OUTPUT mode
5	5HL3	LED Light	--	--	12	12SQ13	Z Limit Sensor	IBEST	IPLSI-12NO2B-L60mm(NPN NO 2mm 200mA)	12	12SQ14	Y2 Limit Sensor	IBEST	IPLSI-12NO2B-L60mm(NPN NO 2mm 200mA)
5	5Q6	Circuit Breaker	Schneider	IC65N D20A 3P	12	12SQ15	Y1 Limit Sensor	IBEST	IPLSI-12NO2B-L60mm(NPN NO 2mm 200mA)	12	12SQ16	X Limit Sensor	IBEST	IPLSI-12NO2B-L60mm(NPN NO 2mm 200mA)
5	5S6	Filter	DUOJI	NF312C36/16	14	14SB3	Enable Key Switch	RENY	RBSNK-2	14	14SB3.1	Power On Button	RENY	R2PIF-1D-2GL
5	5S9	Frequency Converter	POWTRAN	PI9230 011G3 11KW	14	14KM3	Contactor	Schneider	LC1D50AB7C-LADN11	14	14KA6	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V
5	5M11	Spindle Motor	--	--	14	14FU11	Fuse	CHE	FS-101 DC24V 2A	14	14FU11	Fuse	CHE	FS-101 DC24V 2A
5	5Q17	Circuit Breaker	Schneider	IC65N D10A 3P	14	14E11	V Brake	--	24VDC 1A	14	14FU12	Fuse	CHE	FS-101 DC24V 2A
5	5QM17	Thermal Relay	Schneider	LRD16C 9-13A	14	14FU12	Fuse	CHE	FS-101 DC24V 2A	14	14FU13	Fuse	CHE	FS-101 DC24V 2A
5	5M17	Hydraulic Pump Motor	WANERF	4WE6J-6X/ED24 220V1.5KW	14	14E12	Z Brake	--	24VDC 1A	14	14E12	Z Brake	--	24VDC 1A
5					14	14E13	C Brake	--	24VDC 1A	14	14E13	C Brake	--	24VDC 1A
6	6Q1	Circuit Breaker	Schneider	IC65N D20A 2P	14	14FU14	Fuse	CHE	FS-101 DC24V 2A	14	14E14	FAN	PAPST	TYP4114N/12MR 24V 6W 12CM
6	6S1	Filter	Canny Well	CW1B-6A-L	14	14FU15	Fuse	CHE	FS-101 DC24V 2A	14	14E15	FAN	PAPST	TYP4114N/12MR 24V 6W 12CM
6	6M2	X Motor	Leadshine	ACM13009H2F-40-L 850W 3000r/min	14	14RU16	Brake unit	POWTRAN	PB6014 DC380-690V 40A	14	14R18	Braking resistor	POWTRAN	1500W20Ω
6	6L4	X Servo Drive	Leadshine	L5-850Z	14	14R18	Braking resistor	POWTRAN	1500W20Ω					
6	6Q7	Circuit Breaker	Schneider	IC65N D20A 2P										
6	6S7	Filter	Canny Well	CW1B-6A-L										
6	6M8	Y1 Motor	Leadshine	ACM13009H2F-40-L 850W 3000r/min										
6	6L10	Y1 Servo Drive	Leadshine	L5-850Z										
6	6Q14	Circuit Breaker	Schneider	IC65N D20A 2P										
6	6S14	Filter	Canny Well	CW1B-6A-L										
6	6M15	Y2 Motor	Leadshine	ACM13009H2F-40-L 850W 3000r/min										
6	6L17	Y2 Servo Drive	Leadshine	L5-850Z										
6														
7	7Q3	Circuit Breaker	Schneider	IC65N D20A 2P										
7	7S3	Filter	Canny Well	CW1B-6A-L										
7	7M4	Z Motor	Leadshine	ACM13009H2E-40-L 850W Brake										
7	7L6	Z Servo Drive	Leadshine	L5-850Z										
7	7KA10	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V										
7	7Q11	Circuit Breaker	Schneider	IC65N D20A 2P										
7	7S11	Filter	Canny Well	CW1B-6A-L										
7	7M12	C Motor	Leadshine	ACM8008M2E-B1-L-SS 750W Brake										
7	7L14	C Servo Drive	Leadshine	L5-750Z										
7	7KA18	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V										
7														
8	8Q3	Circuit Breaker	Schneider	IC65N D20A 2P										

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0	1	2	3	4	5	6	7	8	9	10	11	12	13
Pg.	Code	Name	Mfrs.	Model			Pg.	Code	Name	Mfrs.	Model		
15	15D0	LPT2 Output Card	AITEK	6AXIS-Mod-V5-OUTPUT mode			20	20D0	ETH1 Input Mode	AITEK	6AXIS-Mod-V5-INPUT mode		
15	15SB4	Emergency button	RENY	--			20	20SB2	Control Box-Stop Button	RENY	RAPNF-1A-R		
15	15KA4	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			20	20SB6	Control Box-Pause Button	RENY	RAPNF-1A-Y		
15	15KA6	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			20	20HL6	Alarm Indicator lamp	TAYB	TB50-4T-D 24V		
15	15KA8	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			20	20SB8	Control Box-Automatic Button	RENY	RAPNF-1A-G		
15	15KA9	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			20	20SB10	B/C Axis-Joystick Controller	Schneider	XD2-PA24CR φ22mm		
15	15KA10	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			20	20SB16	X/Z Axis-Joystick Controller	Schneider	XD2-PA24CR φ22mm		
15	15KA12	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			20						
15	15SQ13	Vacuum Up Sensor	CHVIRD	CS1-U			21	21SB9	X/Y Axis-Joystick Controller	Schneider	XD2-PA24CR φ22mm		
15	15SQ14	Vacuum Down Sensor	CHVIRD	CS1-U			21	21SB10	X/Y Axis-Joystick Controller	Schneider	XD2-PA24CR φ22mm		
15	15SQ15	B Limit Sensor	IBEST	IPSI-12NO2B-L60mm(NPN NO 2mm 200mA)			21						
15	15KA15	Terminal Relay	OMRON	G2R-2-SND(S) DC24V+P2RF-08-E			22	22D0	ETH2 Input Mode	AITEK	6AXIS-Mod-V5-INPUT mode		
15	15SQ16	C Limit Sensor	IBEST	IPSI-12NO2B-L60mm(NPN NO 2mm 200mA)			22	23HL11	TCP Knob Light	RENY	R2PIF-1D-2GL		
15	15KA17	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			22						
16	16KA4	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			23	23P9	Speed Control Wheel	AITEK	24VPLC		
16	16KA6	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			23	23SB11	TCP On/Off Switch	RENY	R2SNS-2FE-1D-G		
16	16KA8	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			23	23SB12	B Axis Angle Knob	RENY	R2SNS-3TB-2A-B		
16							23						
17	17D0	LPT3 Input Card	AITEK	6AXIS-Mod-V5-INPUT mode			24	24KA5	Terminal Relay	OMRON	G2R-2-SND(S) DC24V+P2RF-08-E		
17	17SQ1	V LIMIT SENSOR	IBEST	IPSI-12NO2B-L60mm(NPN NO 2mm 200mA)			24						
17	17EV4	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V			24						
17	17A7	Laser	--	16mm cross			24						
17	17FU8	Fuse	CHE	FS-101 DC24V			24						
17	17A9	Blade Laser	--	16mm			24						
17	17FU10	Fuse	CHE	FS-101 DC24V			24						
17	17SQ10	Left Vacuum Sensor	CHVIRD	CS1-U			24						
17	17EV11	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V			24						
17	17SQ12	Right Vacuum Sensor	CHVIRD	CS1-U			24						
18	18SQ6	Vacuum4 Generator	SNS	SCV-10CK 0.1-0.6MPa			25						
18	18SQ8	Blade Probe	--	--			25						
18	18KA8	Terminal Relay Unit	Panasonic	PA1A-24V + AY33002 RT3S-24V			25						
18	18SQ11	Vacuum3 Generator	SNS	SCV-10CK 0.1-0.6MPa			25						
18	18SQ12	Vacuum2 Generator	SNS	SCV-10CK 0.1-0.6MPa			25						
18	18SQ13	Vacuum1 Generator	SNS	SCV-10CK 0.1-0.6MPa			25						
18							25						
19	19D2	COM1 COMPUTER MODE	AITEK	RS232-Mod-V1 4IN/3OUT			26	26FU3	Fuse	CHE	FS-101 DC24V		
19	19QS6	Table Limit Sensor	Moujen	ME-9101			26	26E3	CAMERA	LOGITECH	C930E		
19	19QS7	Table Limit Sensor	Moujen	ME-9101			26						
19	19EV10	Hydraulic Control Valve	WANERF	4WE6J-6X/ED24			27	27EV1	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
19	19KA14	Terminal Relay	OMRON	G2R-2-SND(S) DC24V+P2RF-08-E			27	27EV3	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
19							27	27EV5	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
19							27	27EV7	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
20	20D0	ETH1 Input Mode	AITEK	6AXIS-Mod-V5-INPUT mode			27	27EV9	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
20	20SB2	Control Box-Stop Button	RENY	RAPNF-1A-R			27	27EV11	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
20	20SB6	Control Box-Pause Button	RENY	RAPNF-1A-Y			27	27EV13	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
20	20HL6	Alarm Indicator lamp	TAYB	TB50-4T-D 24V			27	27EV17	Solenoid Valve	CNSY	4V210-08 G1/4 DC24V		
20	20SB8	Control Box-Automatic Button	RENY	RAPNF-1A-G			27						
20	20SB10	B/C Axis-Joystick Controller	Schneider	XD2-PA24CR φ22mm			27						
20	20SB16	X/Z Axis-Joystick Controller	Schneider	XD2-PA24CR φ22mm			27						
20													