List of Parts
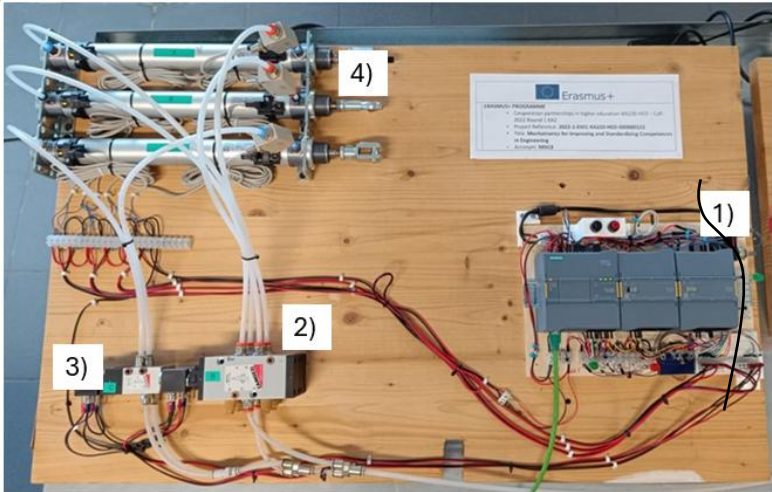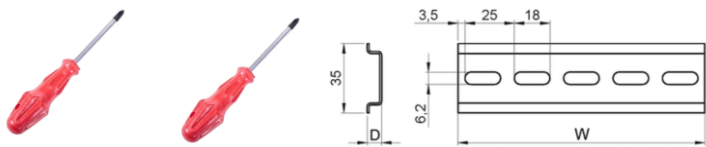

1. n.1 Siemens PLC of type 1215C;
2. n.2 5/2 single-solenoid electrically operated directional control valves (for cylinders A and B);
3. n.2 3/2 single-solenoid electrically operated monostable valves (for cylinder C, manifold-mounted);
4. n.3 Double-acting pneumatic cylinders (A, B, C).

List of Tools

1. n.2 Screw driver, Philips and FlatHead;
2. n.32 Screw
3. n.3 Din 35mm guide (W=25 cm)

Procedure

1. Step 1: Screw the 3D printed parts (Fig 1) in their desidered position onto the board;
2. Step 2: Screw all the parts in their desidered position onto the board;
3. Step 3: Install the flow regulator to the cylinder and connect the pneumatic valves following the Fig. 2;
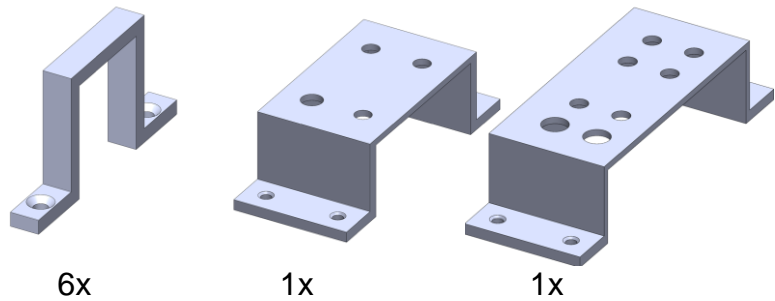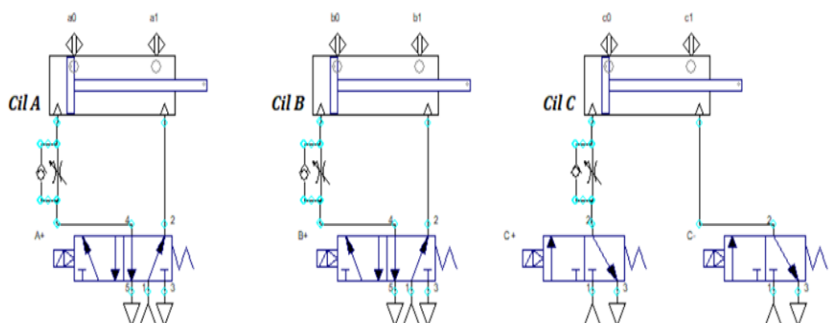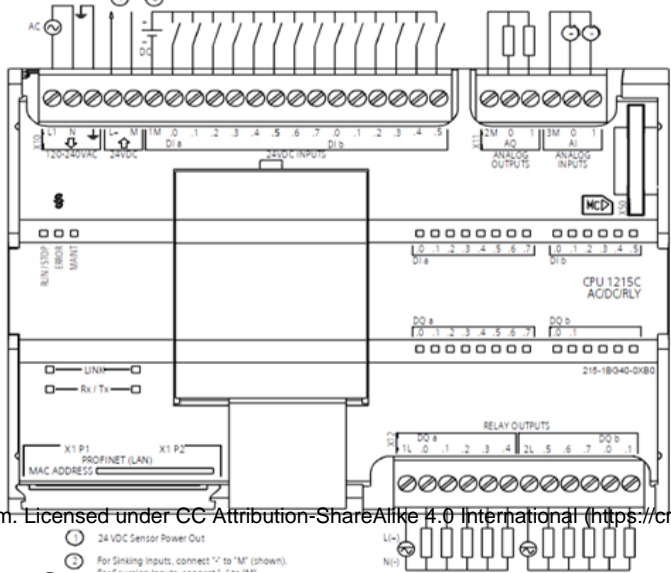4. Step 5: Connect the part 1 following the Fig.3.

6x   1x   1x

Fig 1

Cil A   Cil B   Cil C

Fig 2

Sensor	Input		Com	Output
a_0	DIa.0		A+	DQa.0
a1	DIa.1		A-	Dqa.1
b_0	DIa.2		B+	DQa.2
b_1	DIa.3		B-	DQa.3
c_0	DIa.4		C+	DQa.4
c_1	DIa.5		C-	DQa.5
PB_1	DIa.6			
PB_2	DIa.7			

Fig 3