

8180 W 10th St
Indianapolis, IN 46214

RC - RCS Conveyors

RCS-xxL-5EC / 8EC / 10EC

Creator

GDB

Create Date

11/7/2025

Last Editor

GDB

Edit date

5/22/2026

Design Revision

A.1

Project Type

Schematic project

Total Pages

64

Report Pages

32

Supply Type

480VAC

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Page	Page type	Page description	Date	Edited by
/A0	Title page / cover sheet	Title page / cover sheet	2/16/2026	GDB
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/A2	Table of contents	Table of Contents	5/22/2026	GDB
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/C1	Title page / cover sheet	Reference Information	4/15/2026	GDB
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/C3	Structure identifier overview	Location Overview	5/22/2026	GDB
/D1	Topology	Location Topology	2/26/2026	GDB
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+MAIN/2	Schematic multi-line	Motors 2	5/12/2026	GDB
+MAIN/3	Schematic multi-line	Power	5/15/2026	TEM
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+FLD/1	Schematic multi-line	Sensors	5/4/2026	GDB
+FLD/2	Schematic multi-line	WMX500 Safety	5/22/2026	GDB
+DOC/E1	Parts list	Parts List WM: MAIN	5/15/2026	TEM
+DOC/E2	Parts list	Parts List WM: OP	5/15/2026	TEM
+DOC/E3	Parts list	Parts List WM: FLD	5/12/2026	GDB
+DOC/F1	Parts list	Parts List MFG: MAIN	5/22/2026	SDC
+DOC/F2	Parts list	Parts List MFG: OP	5/22/2026	SDC
+DOC/F3	Parts list	Parts List MFG: FLD	5/22/2026	SDC
+DOC/G1	Cable overview	Cable List WM: MAIN	5/15/2026	TEM
+DOC/G2	Cable overview	Cable List WM: OP	5/15/2026	TEM
+DOC/G3	Cable overview	Cable List WM: FLD	5/22/2026	GDB
+DOC/H1	Cable overview	Cable List MFG: MAIN	5/22/2026	SDC
+DOC/H2	Cable overview	Cable List MFG: OP	5/22/2026	SDC
+DOC/H3	Cable overview	Cable List MFG: FLD	5/22/2026	GDB
+DOC/J1	Terminal line-up diagram	Terminal Diagram +MAIN-X0	2/20/2026	GDB
+DOC/J2	Terminal line-up diagram	Terminal Diagram +MAIN-X1	2/20/2026	GDB
+DOC/J3	Terminal line-up diagram	Terminal Diagram +MAIN-X2	2/20/2026	GDB
+DOC/J4	Terminal line-up diagram	Terminal Diagram +MAIN-X3	2/20/2026	GDB
+DOC/J5	Terminal line-up diagram	Terminal Diagram +MAIN-X4	2/20/2026	GDB



Wood-Mizer®

Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	Table of Contents
Mounting Location:	/A1	Type:	Table of contents
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Project Description: RC/RCS Controls	
Revision: A.1	Pg Desc: Table of Contents
Mounting Location: /A2	Type: Table of contents
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Next pg: B1	Total Pgs: 64

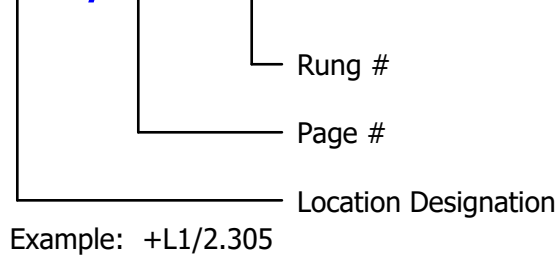
Revision History

Date	Revision	Revision Record	Drawn By	Checked By
5/22/26	A.1	Grounded Power Supply WM2500,5500 Aux Safety Added Operator Cable Added (Switched HMI)	GDB	GDB

Project Structure

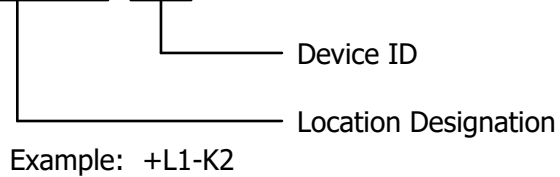
Page Structure

+XXX/#.###



Device Structure

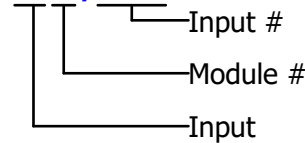
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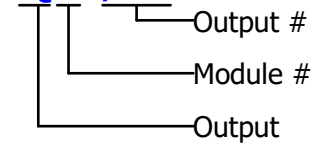
Numbering Schemes

PLC I/O:

I:##/###



Q:##/###



Wire Numbering

I:##/### — PLC Input

Ex: I:2/14

Q:##/### — PLC Output

Ex: Q:3/11

##VP# — Protected DC; Channel #

Ex: 24VP3

##VS# — Prot. Safe DC; Channel #

Ex: 24VS3

0VDC — DC Common

Ex: 0VDC

###L# — AC 3Ph Feeder

Ex: 480L3

###L — AC 1Ph Feeder Line

Ex: 120L

###N — AC 1Ph Feeder Neutral

Ex: 120N

PE — Earth/Chassis Ground

Ex: PE

###/####X — Generic Signal Location/Rung#, Seq.
Ex: L1/0412B

Common Connector Pinouts

M12 A-Code

M12 Connector

Pin assignment:



Socket, 4-pos., A-coded



Pin, 4-pos., A-coded

Assignment: M12 pin/socket

Pin	4-pos. A-coded	
1	BN	YE
2	WH	WH
3	BU	OG
4	BK	BU

Assignment: M12 pin/socket

Pin	5-pos. A-coded	5-pos. B-coded
1	BN	BN
2	WH	WH
3	BU	BU
4	BK	BK
5	GY	GY

B-coded

B-coded

Profinet / Industrial Ethernet

Pin Assignment			M12 D Code Male	RJ45 Plug
(For Profinet/EtherCAT PUR, PVC jacketed cables)				
M12 D code TO RJ45				
Pin1 TD+	Yellow	Pin1		
Pin3 TD-	Orange	Pin2		
Pin2 RD+	White	Pin3		
Pin4 RD-	Blue	Pin6		
(For EtherNET/IP TPE jacketed cable)				
M12 D code TO RJ45				
Pin1 TD+	White-Orange	Pin1		
Pin3 TD-	Orange	Pin2		
Pin2 RD+	White-Green	Pin3		
Pin4 RD-	Green	Pin6		

Color Schemes

Wire Color Designations

Source VAC	BLK
< Source VAC	RED
< Source VAC, Grounded	WHT
VDC	BLU
VDC, Grounded	WHT/BLU
Earth/Chassis Ground	GRN/YEL

Ethernet Cable Color Designations

Ethernet, Facility Network	BLU
Ethernet, Machine Network	GRN
Ethernet, Other Network	YLW

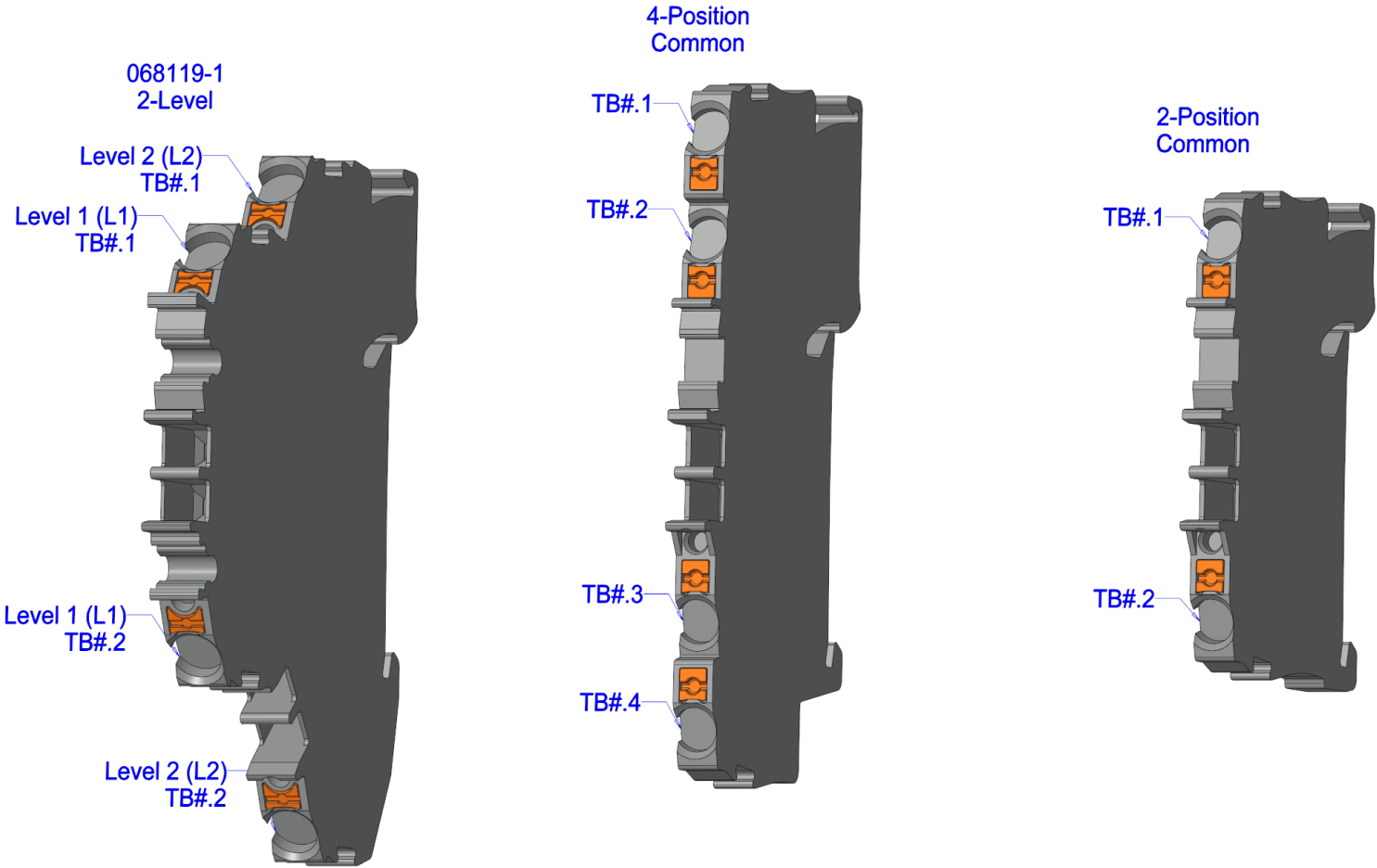


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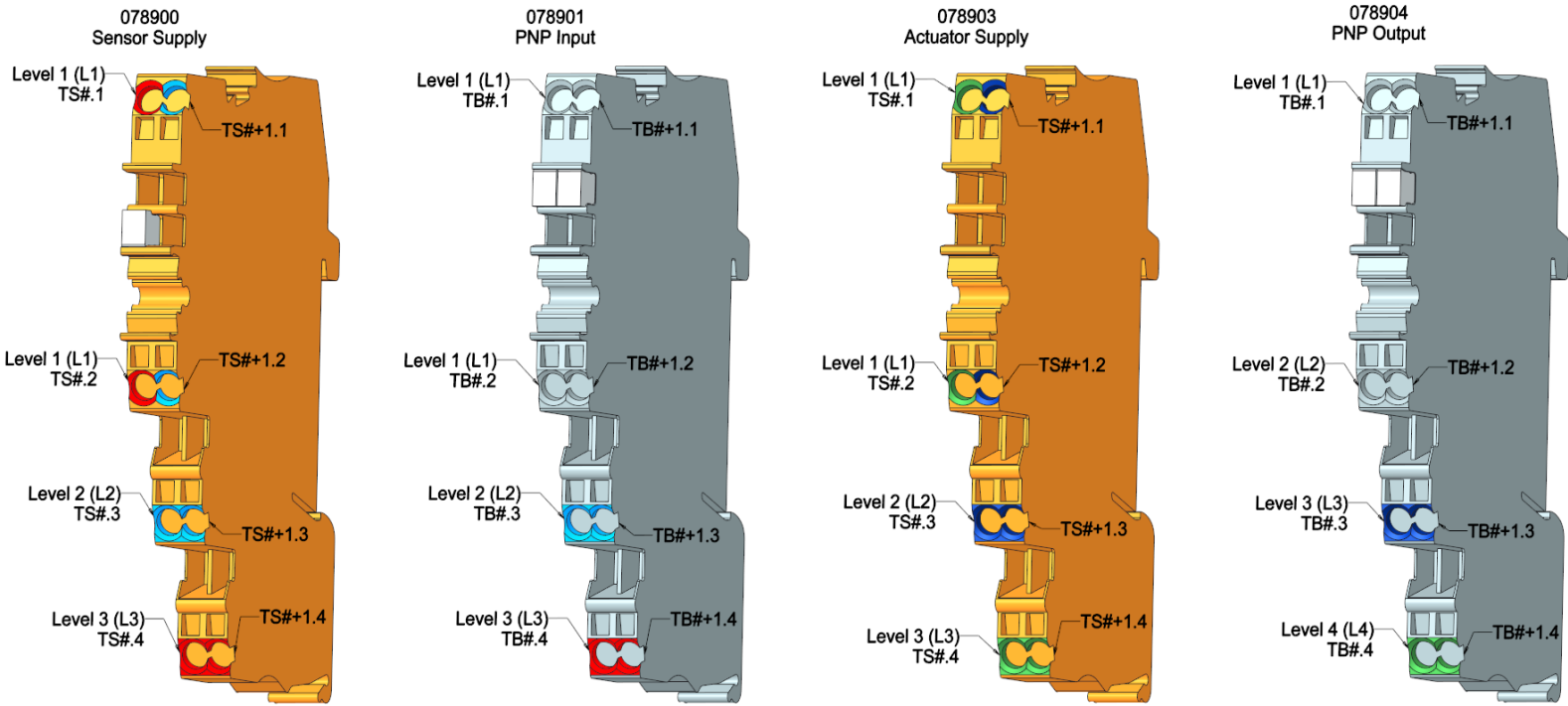
Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	Reference Information
Mounting Location:	/C1	Type:	Title page / cover sheet
Prev. pg:	B1	Page:	C1
Next pg:	C2	Total Pgs:	64

Traditional Terminal Block Designations



Sensor/Actuator Terminal Block Designations



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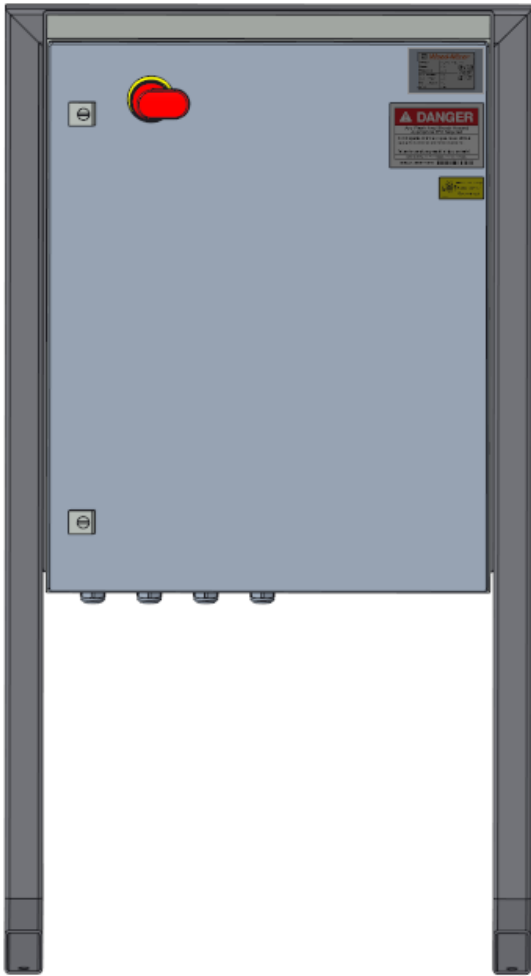
Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	Reference Information
Mounting Location:	/C2	Type:	Title page / cover sheet
Prev. pg:	C1	Page:	C2
Next pg:	C3	Total Pgs:	64

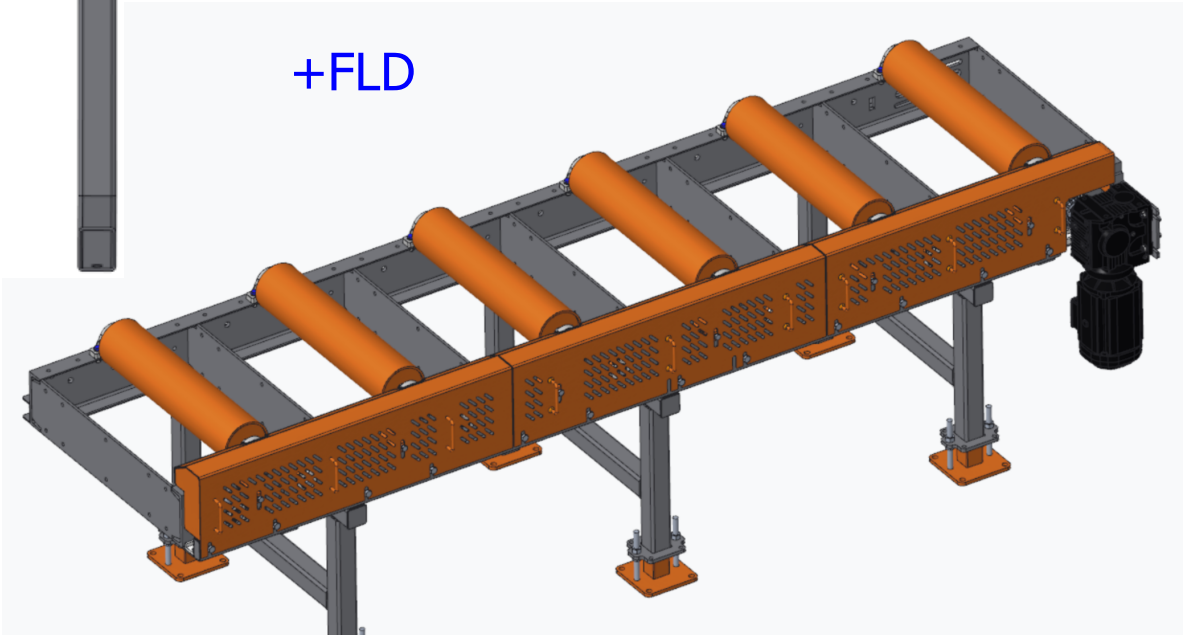
Structure identifier overview

Full designation	Labeling	Structure description
+MAIN	Location designation	Control Panel
+OP	Location designation	Operator Station
+FLD	Location designation	Field Devices
+WM4500	Location designation	WM4500
+DOC	Location designation	Documentation
+DRW	Location designation	Drawings
+WM2500	Location designation	
+WM5500	Location designation	

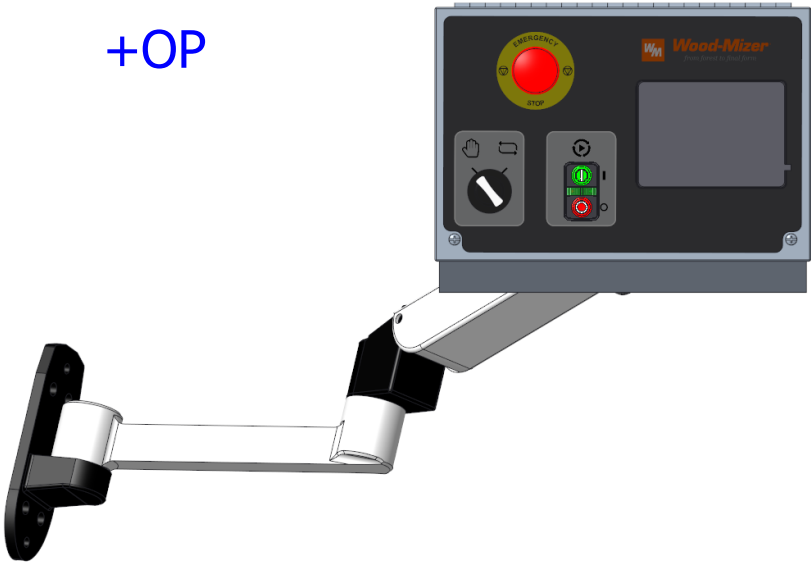
+MAIN



+FLD



+OP



Voltage	480VAC +4 / - 10%	
Phase	3Ph	
Frequency	60 Hz	
FLA Machine	12A	
FLA Largest Load	6.9A	
Wiring Diagram	RCS-xxL-5EC	
SCCR	100kA @ 25kA Class CC Fuses Rida, And/Or Other Restriction	

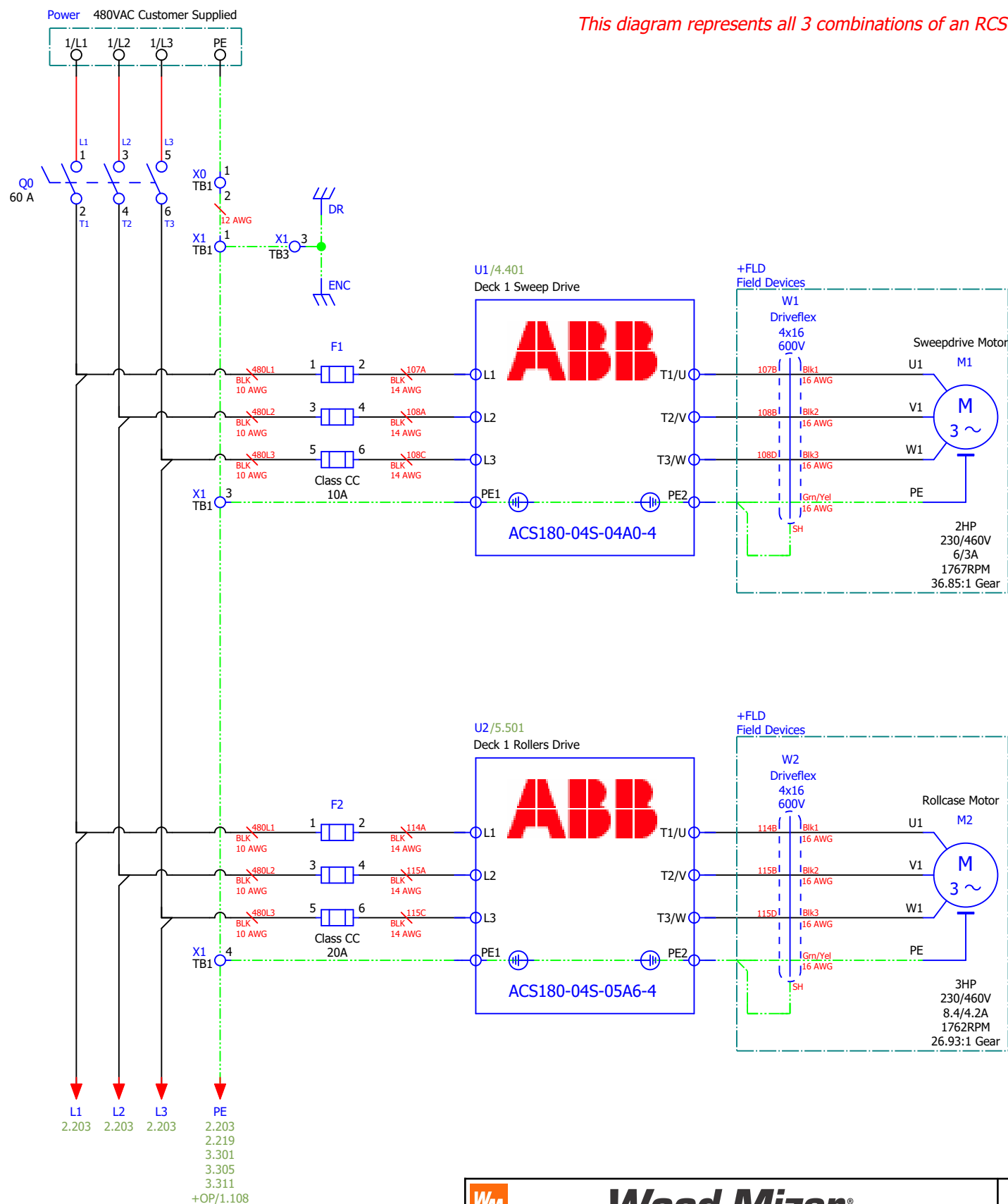
1 Deck

Voltage	480VAC +4 / - 10%	
Phase	3Ph	
Frequency	60 Hz	
FLA Machine	19A	
FLA Largest Load	6.9A	
Wiring Diagram	RCS-xxL-8EC	
SCCR	100kA w/ 30A Class J or CC Fuses	

2 Decks
1 Sweep

Voltage	480VAC +4 / - 10%	
Phase	3Ph	
Frequency	60 Hz	
FLA Machine	23.5A	
FLA Largest Load	6.9A	
Wiring Diagram	RCS-xxL-10EC	
SCCR	100kA w/ 35A Class J	

2 Decks
2 Sweeps



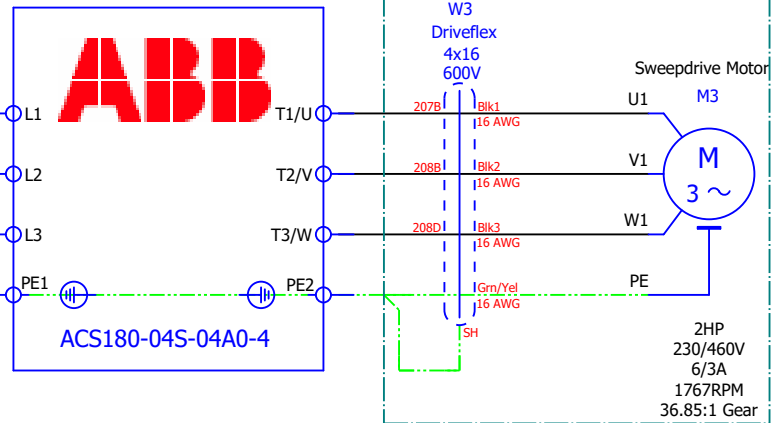
This diagram represents all 3 combinations of an RCS system

 Wood-Mizer®		  MAIN	
Project Description: RC/RCS Controls			
Revision: A.1	Pg Desc: Motors 1		
Created by: SDC	Type: Schematic multi-line		
Prev. pg: +/D1	Page: +MAIN/1		Next pg: 2

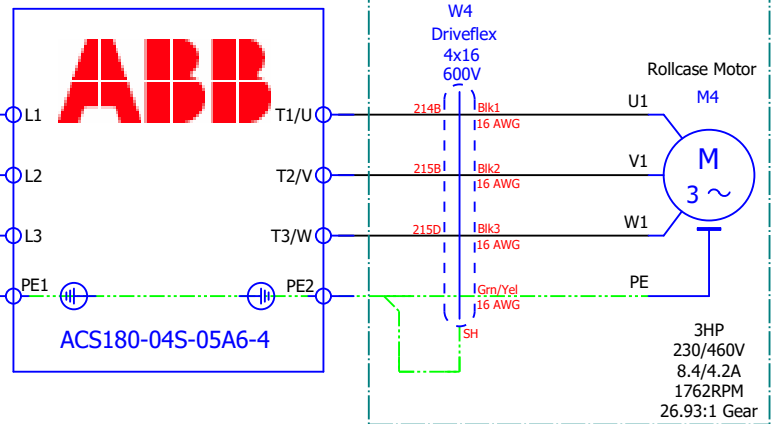
1.119 L1
1.119 L2
1.119 L3
1.119 PE

This motor circuit is only applicable for a 2 deck 5-way configuration

U3/6.601
Deck 2 Sweep Drive



U4/7.701
Deck 2 Rollers Drive



3.301 L1
3.301 L2
1.119 PE



Wood-Mizer®

Project Description: RC/RCS Controls

Revision:

A.1

Pg Desc: Motors 2

Created by:

SDC

Type: Schematic multi-line

Prev. pg:

1

Page: +MAIN/2

Next pg:

3

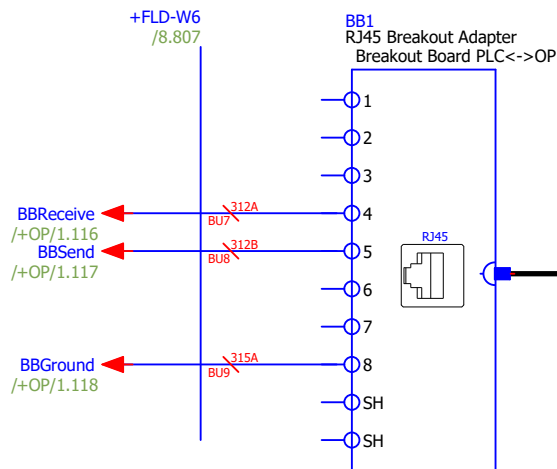
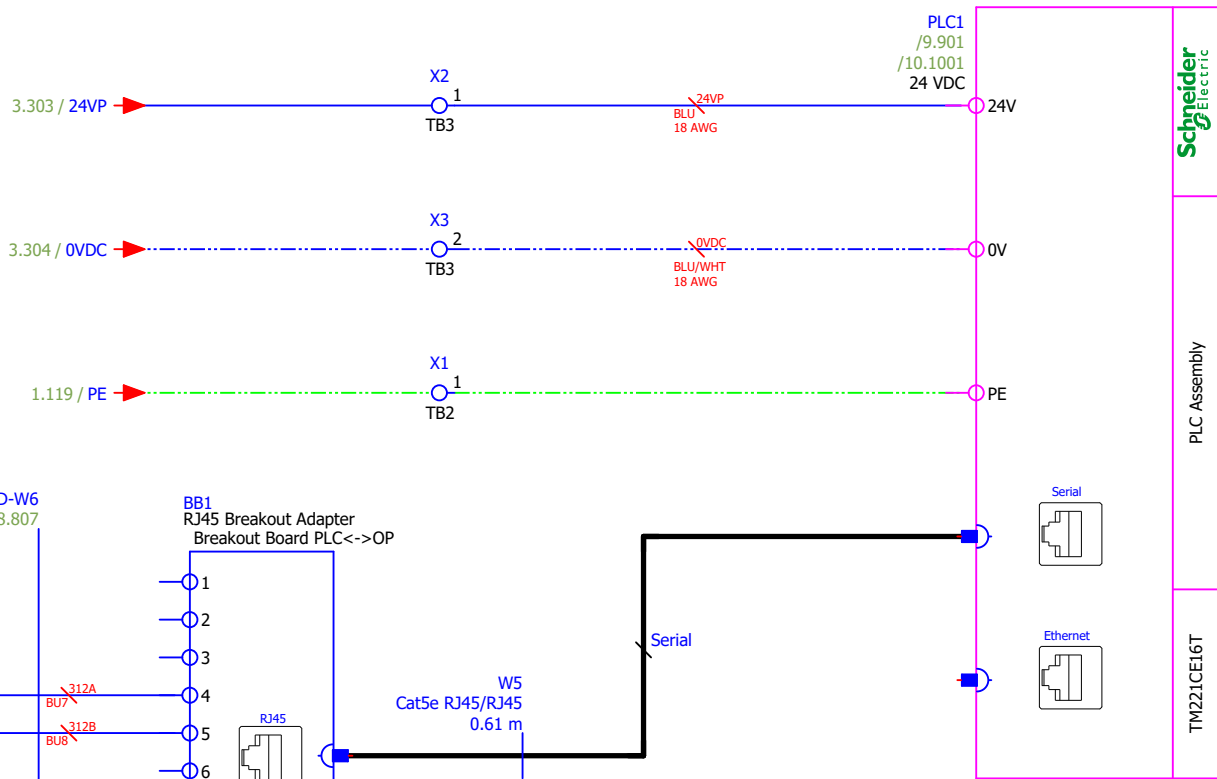
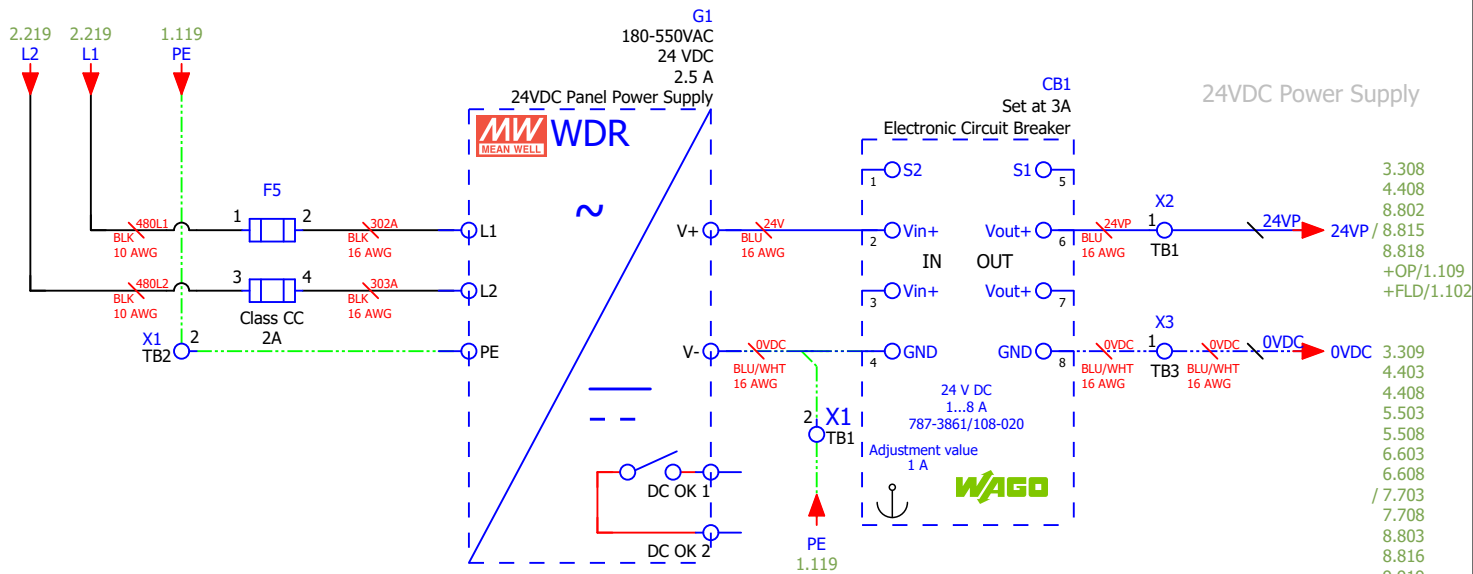
Total Pgs: 64



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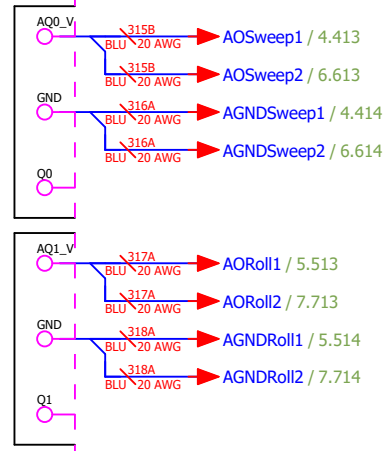
MAIN

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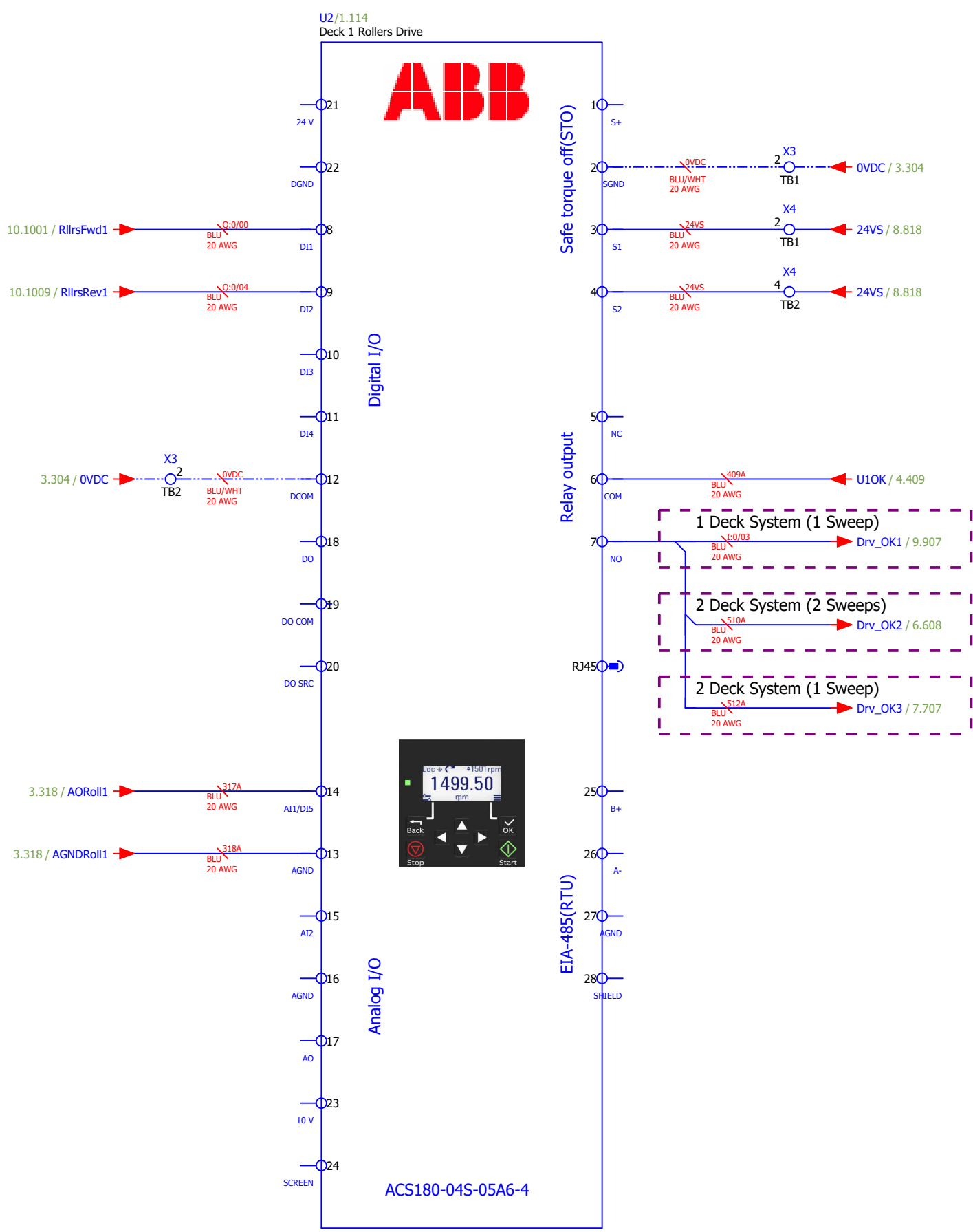


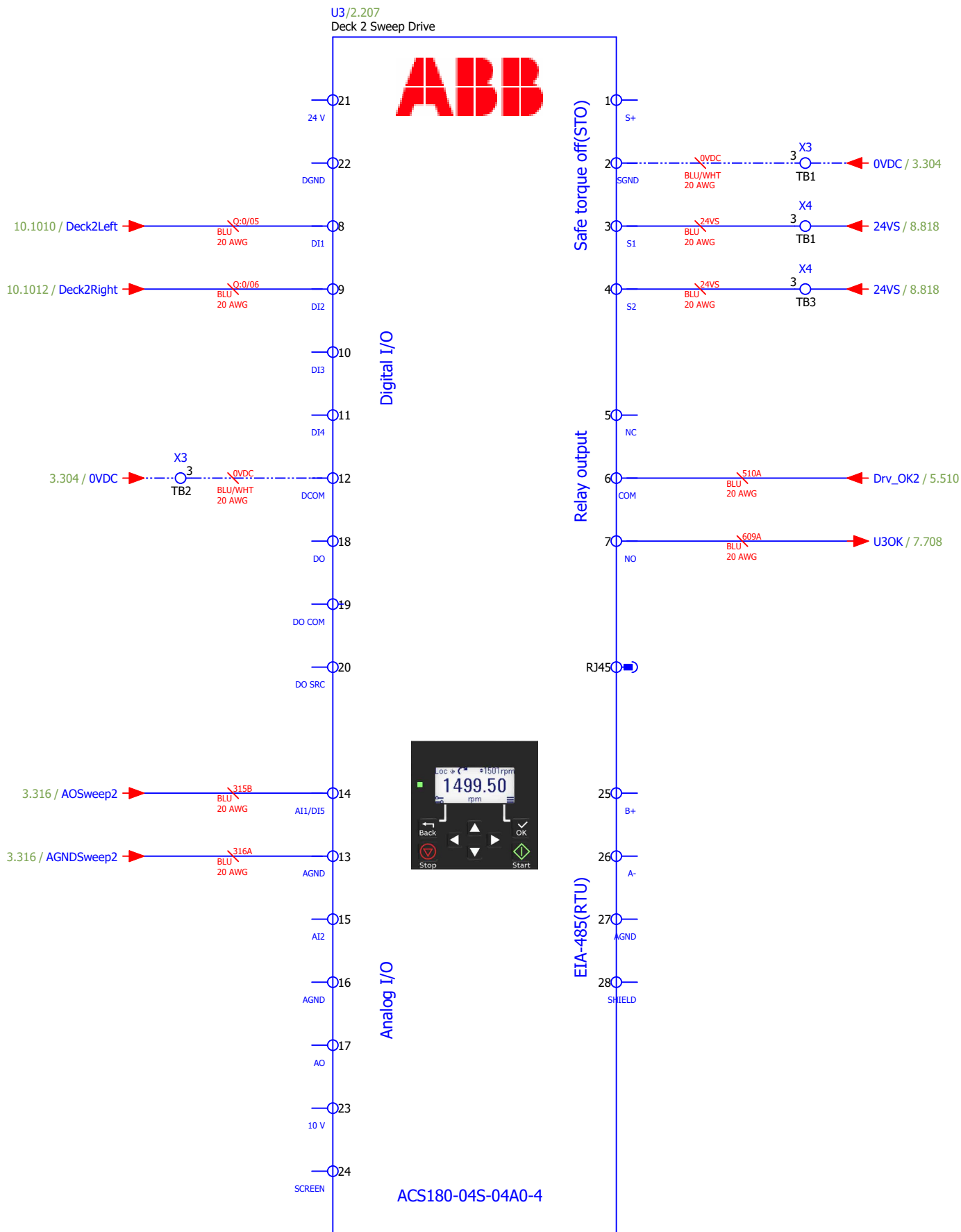
'Sweep2' only applicable with
2 sweep motor configurations

'Roll2' only applicable with
2 roller motor configurations



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Wood-Mizer®

Project Description: RC/RCS Controls

Revision:

A.1

Pg Desc: VFD Controls 3

Created by:

GDB

Type: Schematic multi-line

Prev. pg:

5

Page: +MAIN/6

Next pg:

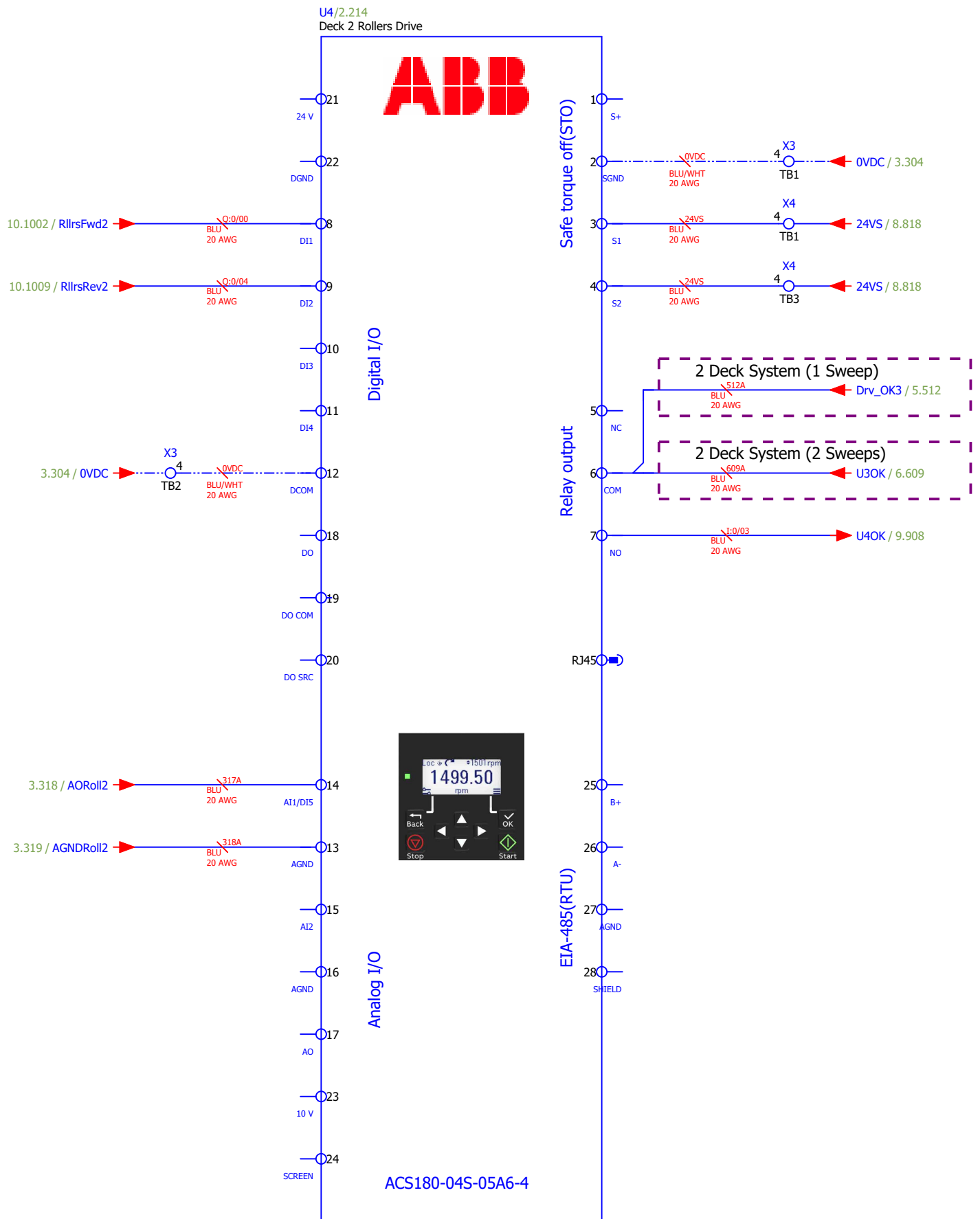
7

Total Pgs: 64



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MAIN



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1

Pg Desc: VFD Controls 4

Created by: GDB

Type: Schematic multi-line

Prev. pg: 6

Page: +MAIN/7

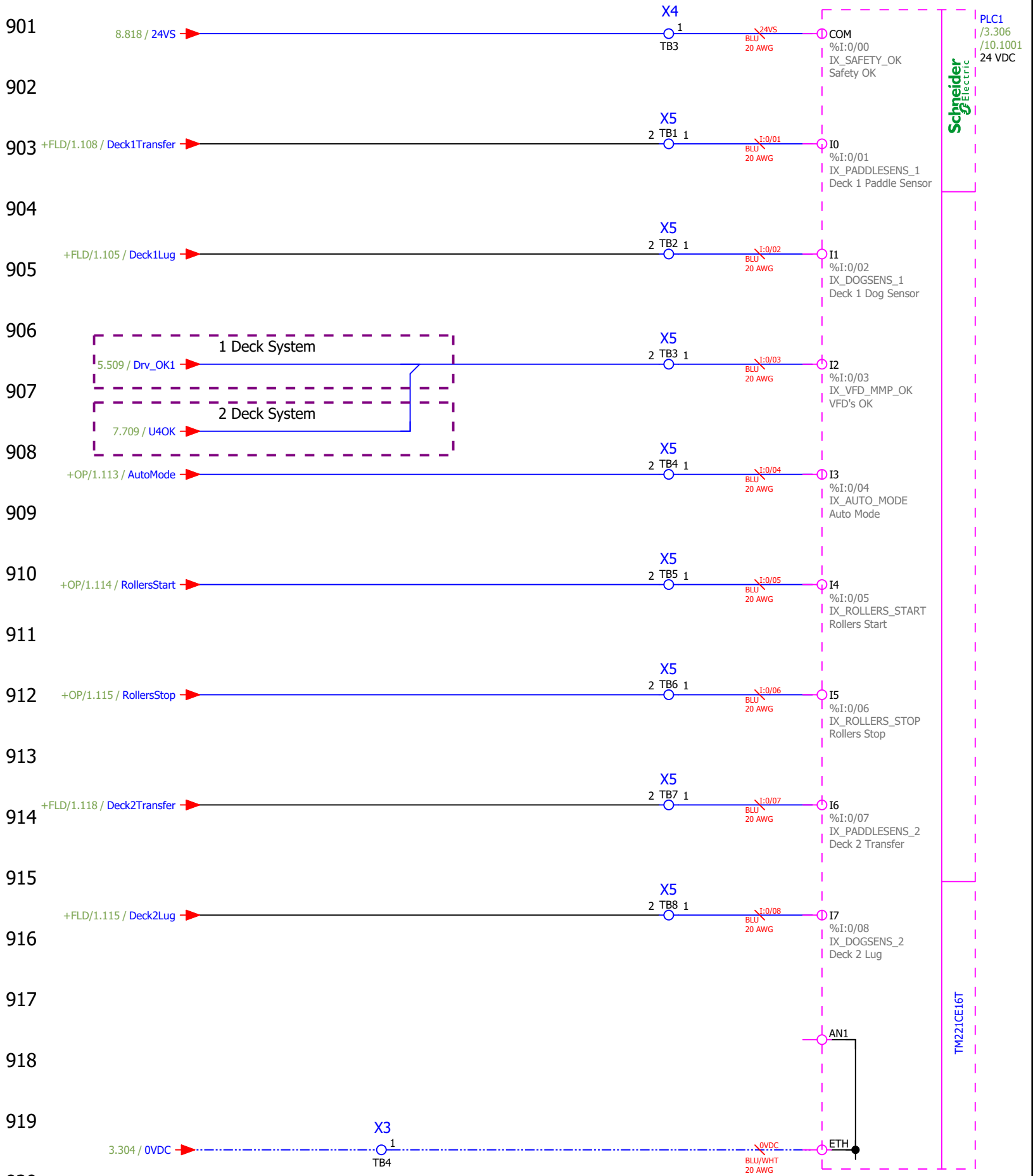
Next pg: 8

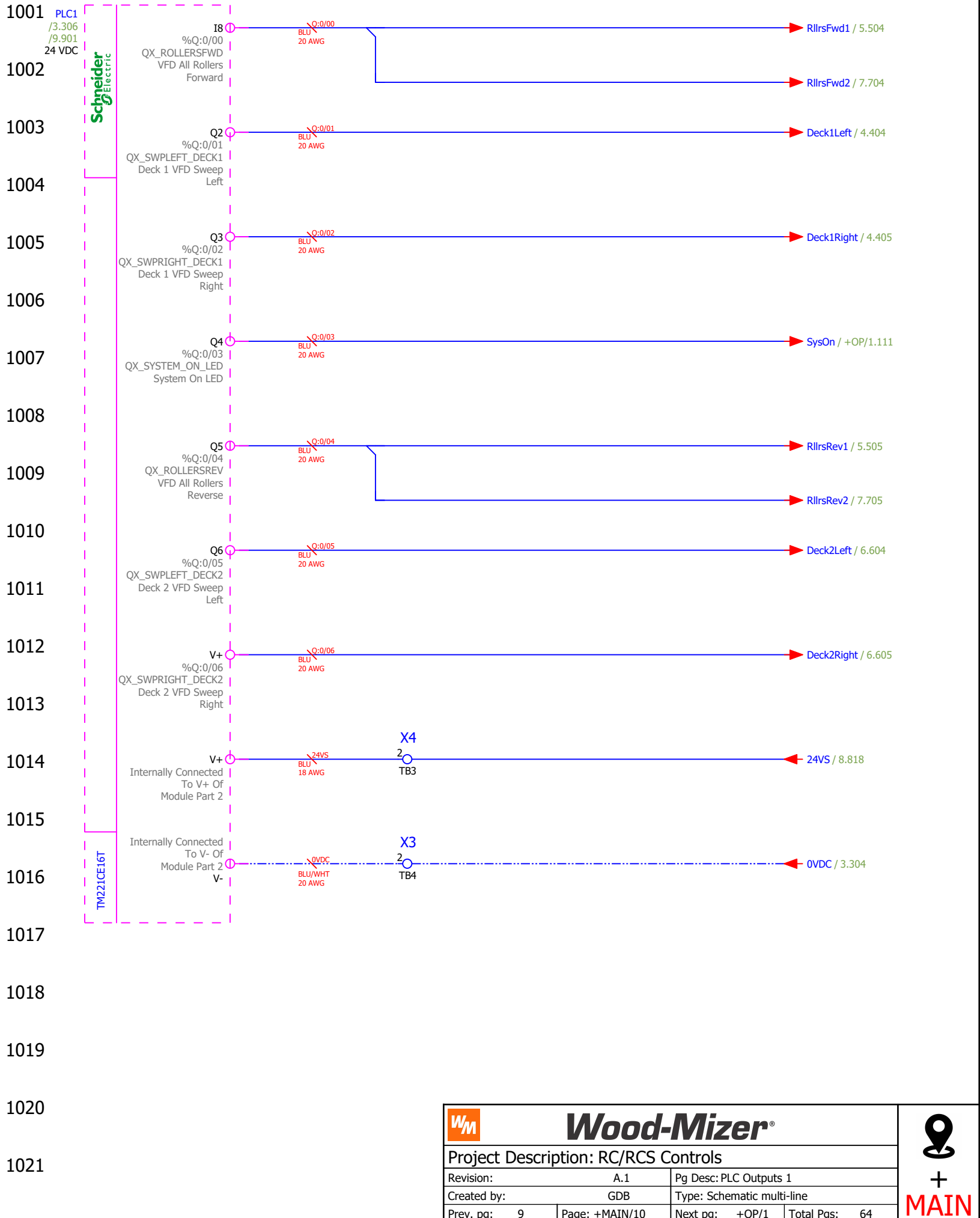
Total Pgs: 64



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MAIN





Wood-Mizer®

Project Description: RC/RCS Controls

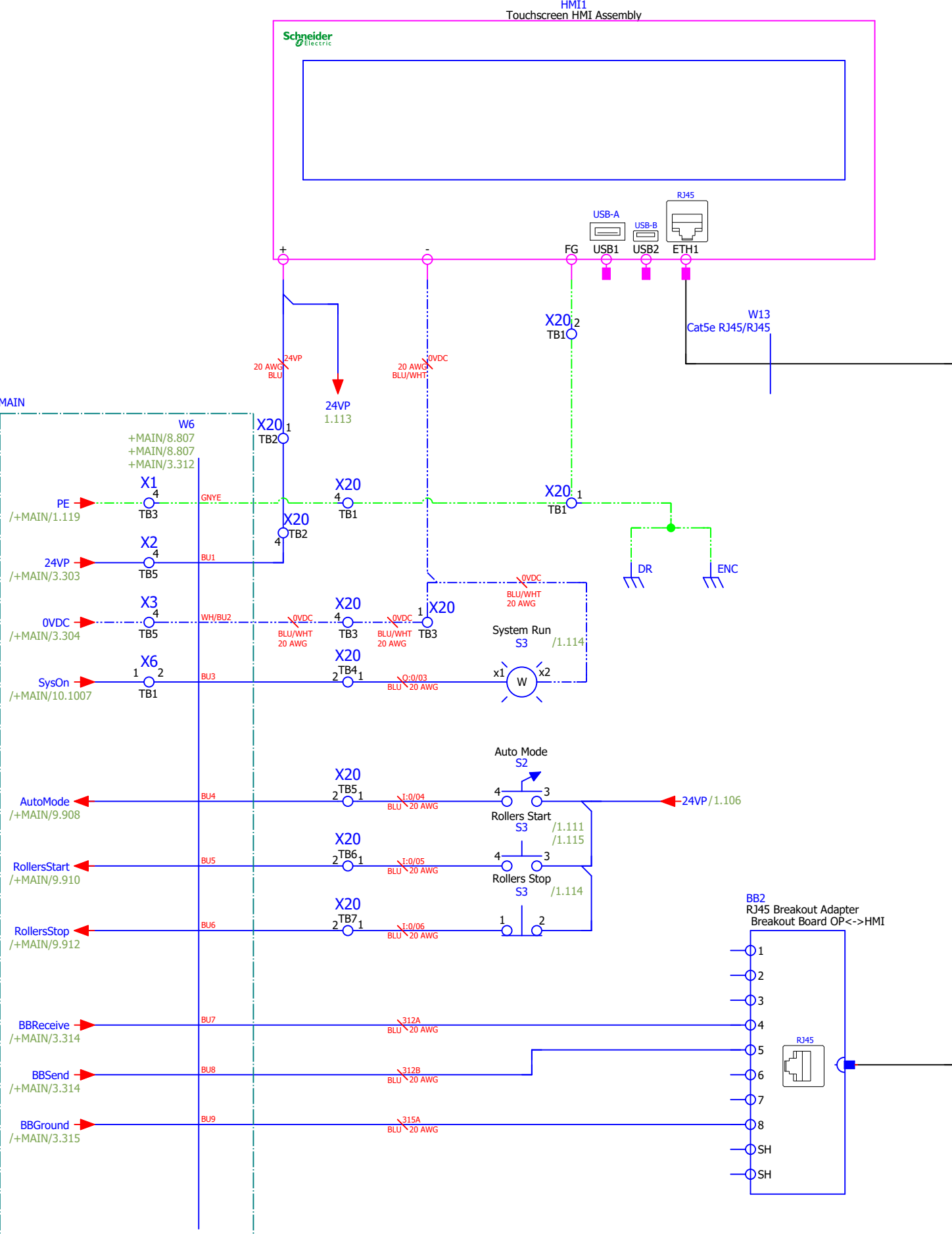
Revision: A.1		Pg Desc: PLC Outputs 1	
Created by: GDB		Type: Schematic multi-line	
Prev. pg: 9	Page: +MAIN/10	Next pg: +OP/1	Total Pgs: 64



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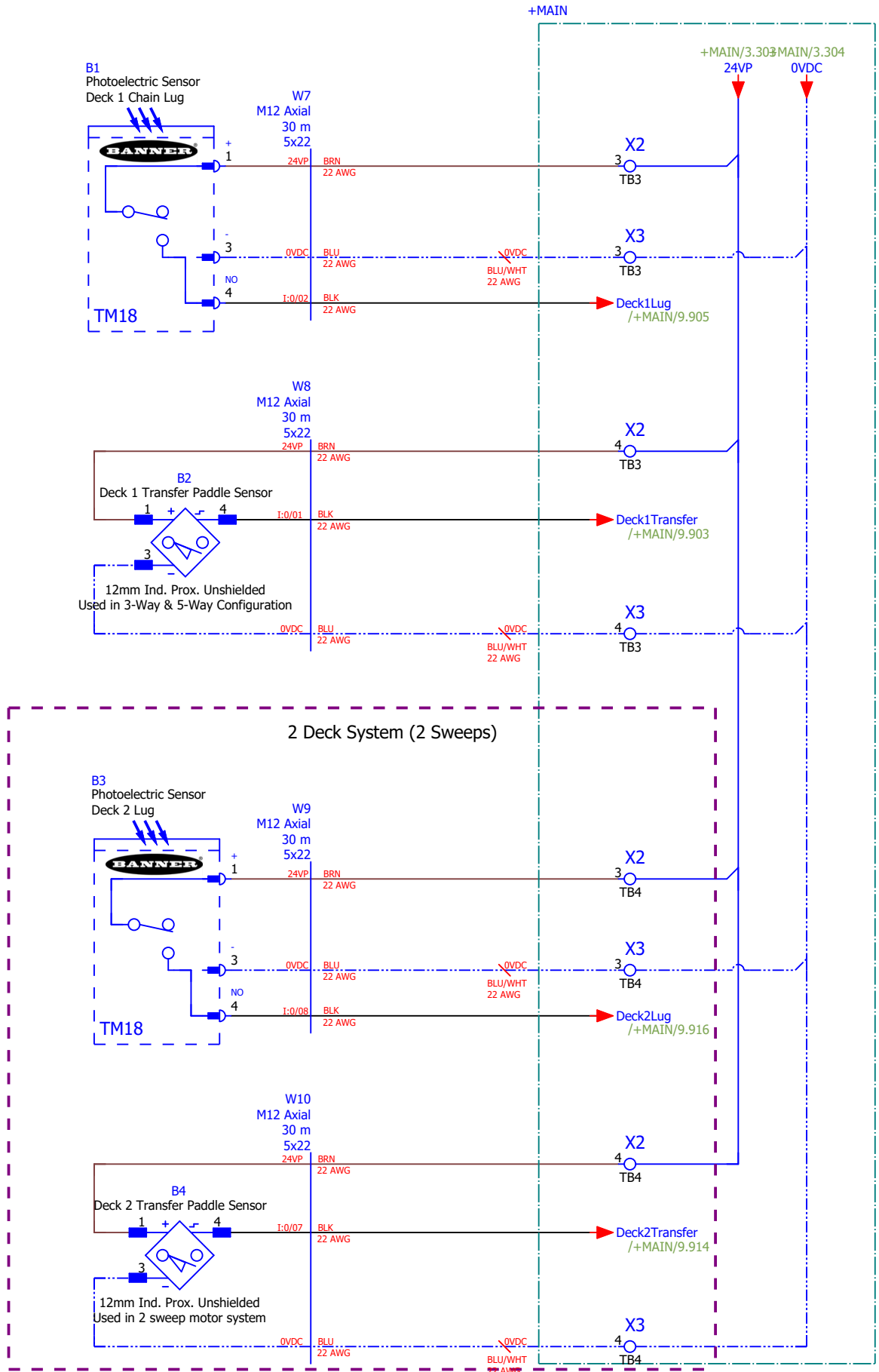
MAIN

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NOTE:
Conductors 10 and 11 of Cable 'W6'
are used w/estop on page 8 of MAIN 'Safety'

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Wood-Mizer®

Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	Sensors
Created by:	SDC	Type:	Schematic multi-line
Prev. pg:	+OP/1	Page:	+FLD/1
Next pg:	2	Total Pgs:	64



+

FLD

WM_PARTS_LIST-WM_MntLocDynmc

IN

 Wood-Mizer®		  MAIN	
Project Description: RC/RCS Controls			
Revision: A.1	Pg Desc: Parts List WM: MAIN		
Created by: TEM	Type: Parts list		
Prev. pg: +FLD/2	Page: E1		Next pg: E2

WM_PARTS_LIST-WM_MntLocDynmc

 Wood-Mizer®	
Project Description: RC/RCS Controls	
Revision: A.1	Pg Desc: Parts List WM: OP
Created by: TEM	Type: Parts list
Prev. pg: E1	Page: E2
Next pg: E3	Total Pgs: 64



WM_PARTS_LIST-WM_MntLocDynmc

WM

Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1

Pg Desc: Parts List WM: FLD

Created by: GDB

Type: Parts list

Prev. pg: E2

Page: E3

Next pg: F1

Total Pgs: 64

<

WM_PARTS_LIST-MFG_MntLocDynmc

MAIN

 Wood-Mizer®		  MAIN	
Project Description: RC/RCS Controls			
Revision: A.1	Pg Desc: Parts List MFG: MAIN		
Created by: SDC	Type: Parts list		
Prev. pg: E3	Page: F1		Next pg: F2

WM_PARTS_LIST-MFG_MntLocDynmc

 Wood-Mizer®	
Project Description: RC/RCS Controls	
Revision: A.1	Pg Desc: Parts List MFG: OP
Created by: SDC	Type: Parts list
Prev. pg: F1	Page: F2
Next pg: F3	Total Pgs: 64



OP

WM_PARTS_LIST-MFG_MntLocDynmc

				Wood-Mizer®				 + FLD
Project Description: RC/RCS Controls								
Revision:		A.1		Pg Desc: Parts List MFG: FLD				
Created by:		SDC		Type: Parts list				
Prev. pg: F2		Page: F3		Next pg: G1		Total Pgs: 64		

Wood-Mizer Cable List

Wood-Mizer_Cable_Overview_WM_MntLoc

Cable Designation	LOC	Cable Manufacturer	Cable PN WM Base WM Assembly		Cable Description	Application	Cable X-Ref
W5	MAIN	L-COM	127360	121615-W5	Cable, Shielded Cat 5E RJ45/RJ45 2.0ft Black	Cable Assy, RCS Serial com	+MAIN/3.314

Wood-Mizer Cable List

Wood-Mizer_Cable_Overview_WM_MntLoc

Cable Designation	LOC	Cable Manufacturer	Cable PN WM Base WM Assembly		Cable Description	Application	Cable X-Ref
W13	OP	IFM	127361	121615-W13	Cable, Shielded Cat 5E RJ45/RJ45 3.0ft	Cable Assy, RCS OP HMI Serial com	+OP/1.105

Wood-Mizer Cable List

Wood-Mizer_Cable_Overview_WM_MntLoc

Cable Designation	LOC	Cable Manufacturer	Cable PN		Cable		Cable X-Ref
			WM Base	WM Assembly	Description	Application	
W1	FLD	LÜTZE	127355	121615-W1	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/1.110
W2	FLD	LÜTZE	127355	121615-W2	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/1.117
W3	FLD	LÜTZE	127355	121615-W3	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/2.210
W4	FLD	LÜTZE	127355	121615-W4	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/2.217
W6	FLD	LÜTZE	121607	121615-W6	Cable, 18AWG/12C Siliflex	Cable Assy, RCS Main <-> Operator	+MAIN/8.807
W7	FLD	Binder-USA	121623	121615-W7	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 1 Lug Sensor	+FLD/1.103
W8	FLD	Binder-USA	121623	121615-W8	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 1 Paddle Sensor	+FLD/1.107
W9	FLD	Binder-USA	121623	121615-W9	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 2 Lug Sensor	+FLD/1.113
W10	FLD	Binder-USA	121623	121615-W10	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 2 Paddle Sensor	+FLD/1.117
W11	FLD	Quabbin	127465	121615-W11	Cable, 18AWG/5C	Cable Assy, RCS Aux Safety	+FLD/2.209

Manufacturer Cable List

Wood-Mizer_Cable_Overview_Mfg_MntLoc

Cable Designation	LOC	Cable Manufacturer	Cable PN Manufacturer	Cable Description	Application	Cable X-Ref
W5	MAIN	L-COM	TRD695SCR-BL	Cable, Shielded Cat 5E RJ45/RJ45 2.0ft Black	Cable Assy, RCS Serial com	+MAIN/3.314

Manufacturer Cable List

Wood-Mizer_Cable_Overview_Mfg_MntLoc

Cable Designation	LOC	Cable Manufacturer	Cable PN Manufacturer	Cable Description	Application	Cable X-Ref
W13	OP	IFM	TRD855SCBLK-3	Cable, Shielded Cat 5E RJ45/RJ45 3.0ft	Cable Assy, RCS OP HMI Serial com	+OP/1.105

Manufacturer Cable List

Wood-Mizer_Cable_Overview_Mfg_MntLoc

Cable Designation	LOC	Cable Manufacturer	Cable PN Manufacturer	Cable Description	Application	Cable X-Ref
W1	FLD	LÜTZE	A1061604	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/1.110
W2	FLD	LÜTZE	A1061604	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/1.117
W3	FLD	LÜTZE	A1061604	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/2.210
W4	FLD	LÜTZE	A1061604	Cable, 16AWG 4C Flx VFD Shield UL508	Cable Assy, RCS Sweep Motor Deck 2	+MAIN/2.217
W6	FLD	LÜTZE	A3251812	Cable, 18AWG/12C Siliflex	Cable Assy, RCS Main <-> Operator	+MAIN/8.807
W7	FLD	Binder-USA	77-3430-0000-50004-3000	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 1 Lug Sensor	+FLD/1.103
W8	FLD	Binder-USA	77-3430-0000-50004-3000	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 1 Paddle Sensor	+FLD/1.107
W9	FLD	Binder-USA	77-3430-0000-50004-3000	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 2 Lug Sensor	+FLD/1.113
W10	FLD	Binder-USA	77-3430-0000-50004-3000	Cable, M12 4P PUR 30M	Cable Assy, RCS Deck 2 Paddle Sensor	+FLD/1.117
W11	FLD	Quabbin	Q4105-1	Cable, 18AWG/5C	Cable Assy, RCS Aux Safety	+FLD/2.209

Terminal line-up diagram

Terminal strip +MAIN-X0								
Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	0	052525	Terminal Block, 2P 14-4AWG Screw GND	I			Earth Ground	/1.05

Terminal line-up diagram

Terminal strip +MAIN-X1

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	0	068104-1	Terminal Block, 4pos 1.5mm GND Clamp				Ground	/1.06
TB2	0	068104-1	Terminal Block, 4pos 1.5mm GND Clamp				Ground	/3.11
TB3	0	068104-1	Terminal Block, 4pos 1.5mm GND Clamp			068105	Ground	/1.06



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1		Pg Desc: Terminal Diagram +MAIN-X1	
Mounting Location: +DOC/J2		Type: Terminal line-up diagram	
Prev. pg: J1	Page: J2	Next pg: J3	Total Pgs: 64

Terminal line-up diagram

Terminal strip +MAIN-X2

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		24V Protected	/3.03
TB2	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		24V Protected	/8.02
TB3	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		24V Protected	/3.08
TB4	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		24V Protected	+FLD/1.13
TB5	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775	068105	24V Protected	+OP/1.09



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1		Pg Desc: Terminal Diagram +MAIN-X2	
Mounting Location: +DOC/J3		Type: Terminal line-up diagram	
Prev. pg: J2	Page: J3	Next pg: J4	Total Pgs: 64

Terminal line-up diagram

Terminal strip +MAIN-X3

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		0VDC	/4.03
TB2	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		0VDC	/4.08
TB3	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		0VDC	/3.04
TB4	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775		0VDC	/9.19
TB5	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	●	068775	068105	0VDC	/8.03



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1		Pg Desc: Terminal Diagram +MAIN-X3	
Mounting Location: +DOC/J4		Type: Terminal line-up diagram	
Prev. pg: J3	Page: J4	Next pg: J5	Total Pgs: 64

Terminal line-up diagram

Terminal strip +MAIN-X4

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp		068775		24V Safe	/4.04
TB2	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp		068775		24V Safe	/8.18
TB3	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp		068775	068105	24V Safe	/9.01



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1		Pg Desc: Terminal Diagram +MAIN-X4	
Mounting Location: +DOC/J5		Type: Terminal line-up diagram	
Prev. pg: J4	Page: J5	Next pg: J6	Total Pgs: 64

Terminal line-up diagram

Terminal strip +MAIN-X5

Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB1	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			PLC Inputs	/9.03
TB2	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			PLC Inputs	/9.05
TB3	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			PLC Inputs	/9.07
TB4	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			PLC Inputs	/9.08
TB5	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			PLC Inputs	/9.10
TB6	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			PLC Inputs	/9.12
TB7	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			PLC Inputs	/9.14
TB8	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋		068102	PLC Inputs	/9.16

Terminal line-up diagram

Terminal strip +MAIN-X6								
Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB1	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	I		068102	PLC Outputs	+OP/1.11

Terminal line-up diagram

Terminal strip +MAIN-X7

Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB1	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⋮			Safety Input Devices	/8.08
TB2	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	●			Safety Input Devices	/8.08
TB3	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	●			Safety Input Devices	/8.08
TB4	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	●			Safety Input Devices	/8.08
TB5	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	●			Safety Input Devices	/8.08
TB6	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	●		068102	Safety Input Devices	/8.08



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1		Pg Desc: Terminal Diagram +MAIN-X7	
Mounting Location: +DOC/J8		Type: Terminal line-up diagram	
Prev. pg: J7	Page: J8	Next pg: J9	Total Pgs: 64

Terminal line-up diagram

Terminal strip +MAIN-X8

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Safety Output Devices	/8.20
TB2	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Safety Output Devices	/8.20
TB3	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Safety Output Devices	/8.21
TB4	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋		068102	Safety Output Devices	/8.21



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1		Pg Desc: Terminal Diagram +MAIN-X8	
Mounting Location: +DOC/J9		Type: Terminal line-up diagram	
Prev. pg: J8	Page: J9	Next pg: J10	Total Pgs: 64

Terminal line-up diagram

Terminal strip +OP-X20

Terminal				Jumper		End Plate	Remark	Terminal X-Ref
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		
TB1	0	068104-1	Terminal Block, 4pos 1.5mm GND Clamp	⌋			Ground	/1.08
TB2	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	⌋		068105	24V Protected	/1.07
TB3	0	068103-1	Terminal Block, 4pos 1.5mm Com Clamp	⌋			0VDC	/1.10
TB4	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋		068102	System Running	/1.11
TB5	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Auto Mode	/1.13
TB6	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Rollers Start	/1.14
TB7	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Rollers Stop	/1.15
TB8	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Operator Estop	+MAIN/8.08
TB9	0	068100-1	Terminal Block, 2Pos 1.5mm Clamp w/ PB	⌋			Operator Estop	+MAIN/8.08



Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1		Pg Desc: Terminal Diagram +OP-X20	
Mounting Location: +DOC/J10		Type: Terminal line-up diagram	
Prev. pg: J9	Page: J10	Next pg: J11	Total Pgs: 64

Terminal line-up diagram

Terminal strip +WM4500-X5

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB26	2						WM4500	+FLD/2.10
TB26	2						WM4500	+FLD/2.11
TB29	2						WM4500	+FLD/2.09

Terminal line-up diagram

Terminal strip +WM2500-X8

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	2						WM4500	+FLD/2.04
TB2	2						WM4500	+FLD/2.05

Terminal line-up diagram

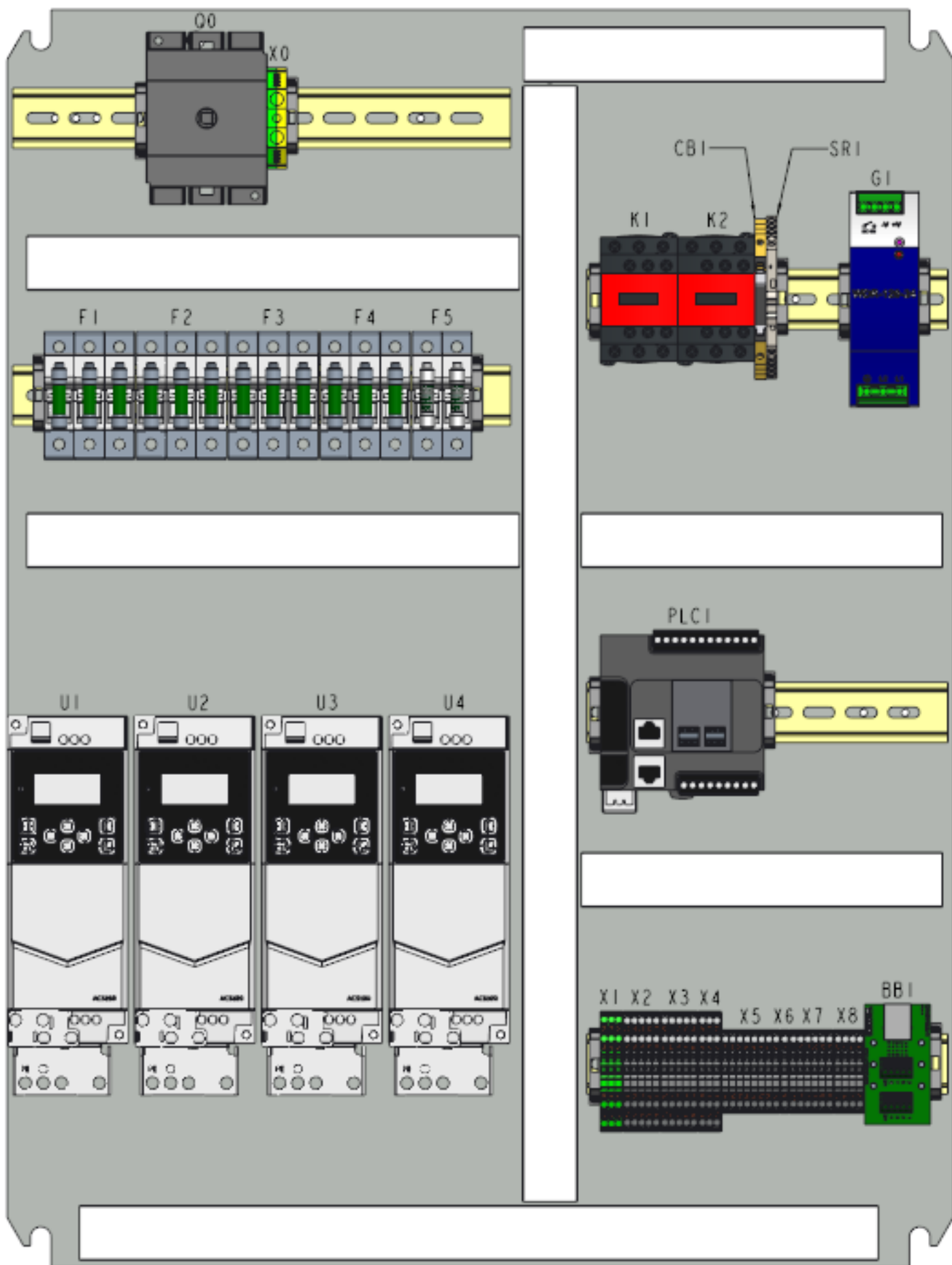
Terminal strip +WM5500-X14

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	2						WM4500	+FLD/2.17
TB2	2						WM4500	+FLD/2.18

Terminal line-up diagram

Terminal strip +WM5500-X30

Terminal				Jumper		End Plate	Remark	Terminal
Ref. Des.	Level	P/N	Description	Diagram	P/N	P/N		X-Ref
TB1	2						WM4500	+FLD/2.16
TB2	2						WM4500	+FLD/2.16



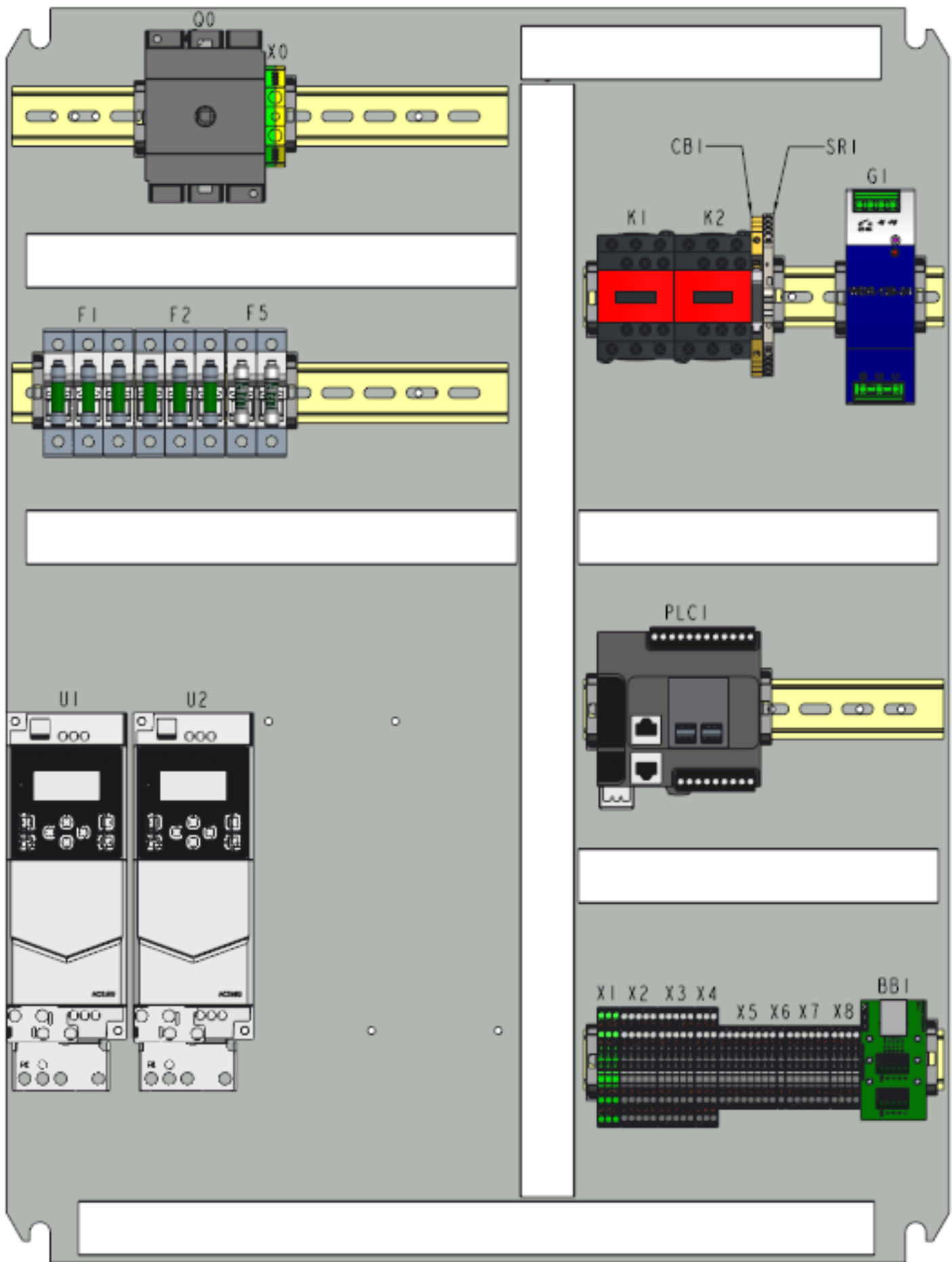
NOTE:
2 Deck System - 2 Sweeps



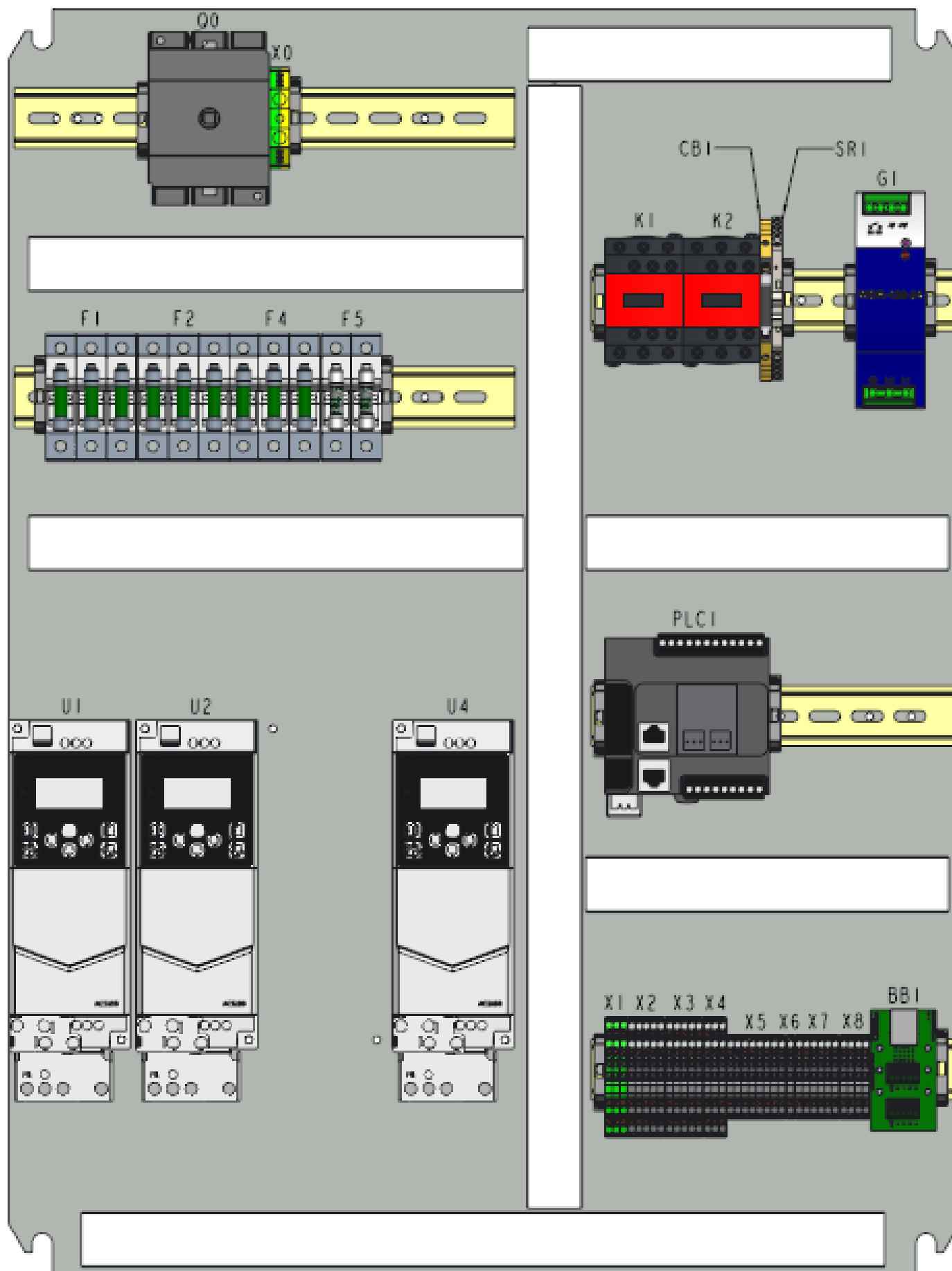
Wood-Mizer®

Project Description: RC/RCS Controls

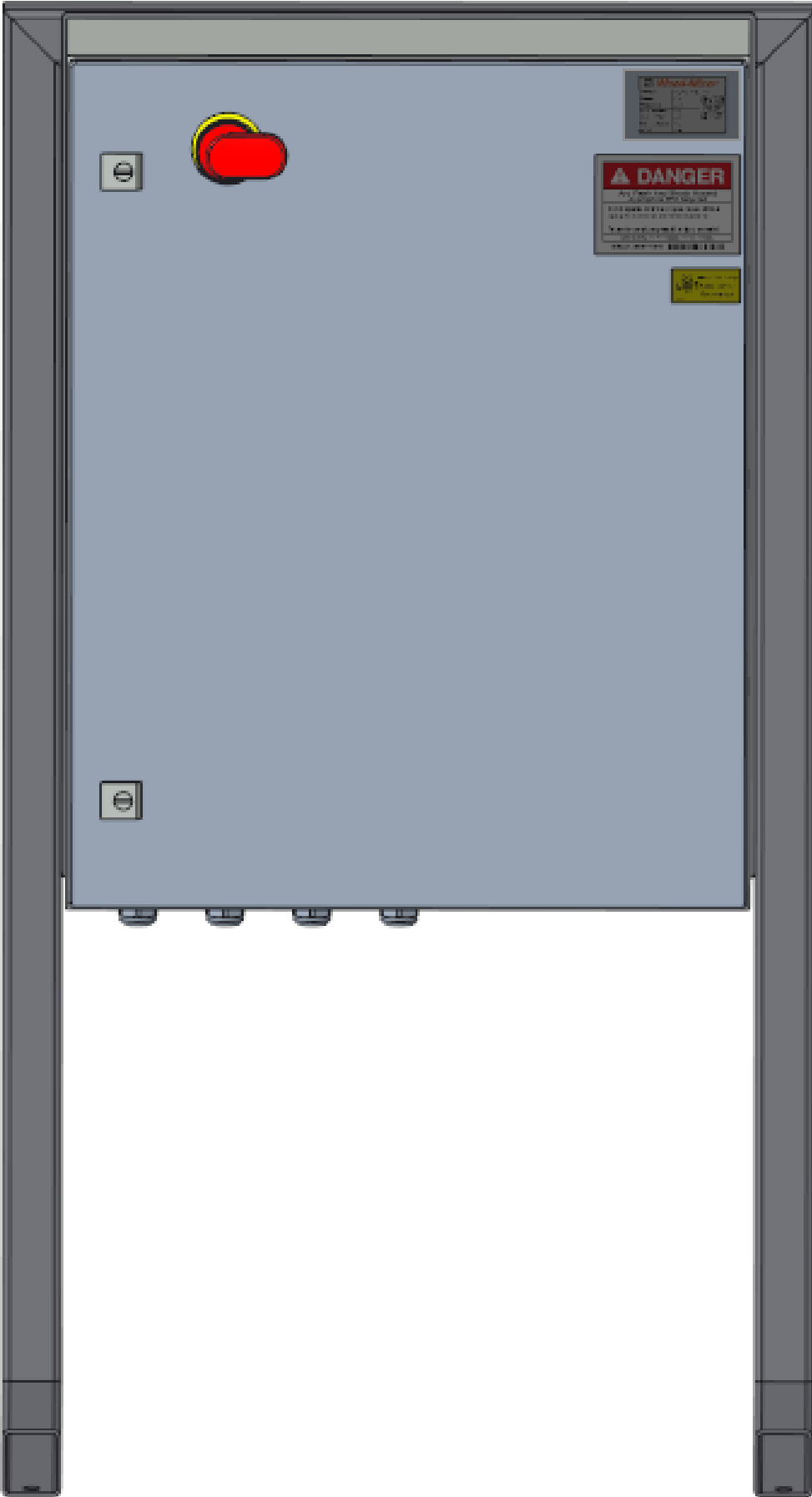
Revision:	A.1	Pg Desc:	121611 Insert Assy
Mounting Location:	+DRW/1	Type:	Graphic
Prev. pg:	+DOC/J14	Page:	1
Next pg:	2	Total Pgs:	64



NOTE:
 1 Deck System - 1 Sweep (No F3, F4, U3, or U4)

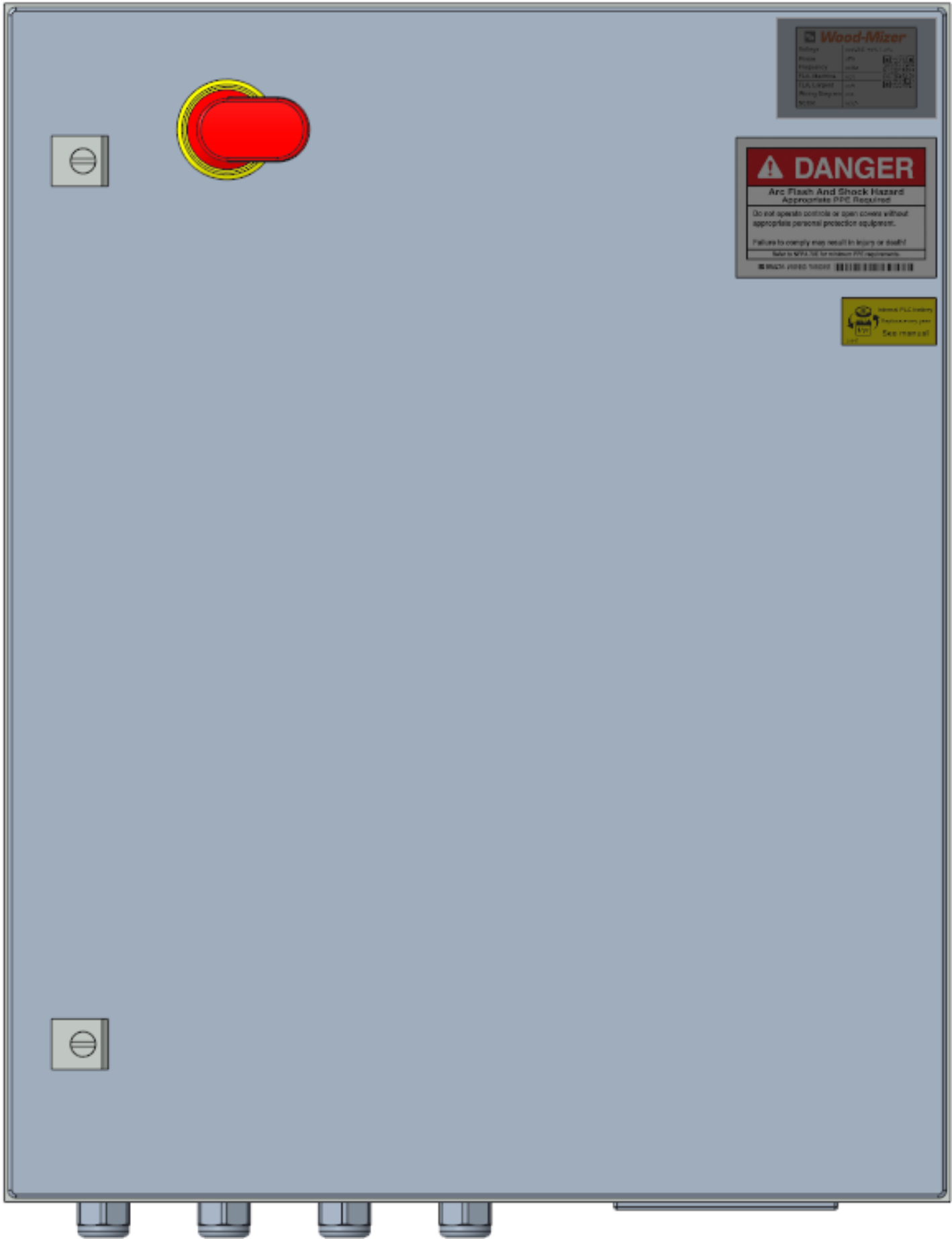


NOTE:
2 Deck System - 1 Sweep (No F3 or U3)



NOTE:
2 Deck System - 2 Sweeps Shown as Reference

		Wood-Mizer®	
Project Description: RC/RCS Controls			
Revision: A.1		Pg Desc: 121618 w/ Stand	
Mounting Location: +DRW/4		Type: Graphic	
Prev. pg: 3	Page: 4	Next pg: 5	Total Pgs: 64



Wood-Mizer		
Model	121618-2/3	
Power	100	100
Frequency	50/60	50/60
Full load	100	100
U.S. Name	100	100
Weight (kg)	100	100
Weight (lb)	100	100

⚠ DANGER

Arc Flash And Shock Hazard
Appropriate PPE Required

Do not operate controls or open covers without
appropriate personal protection equipment.

Failure to comply may result in injury or death!
Refer to NFPA 70E for minimum PPE requirements.

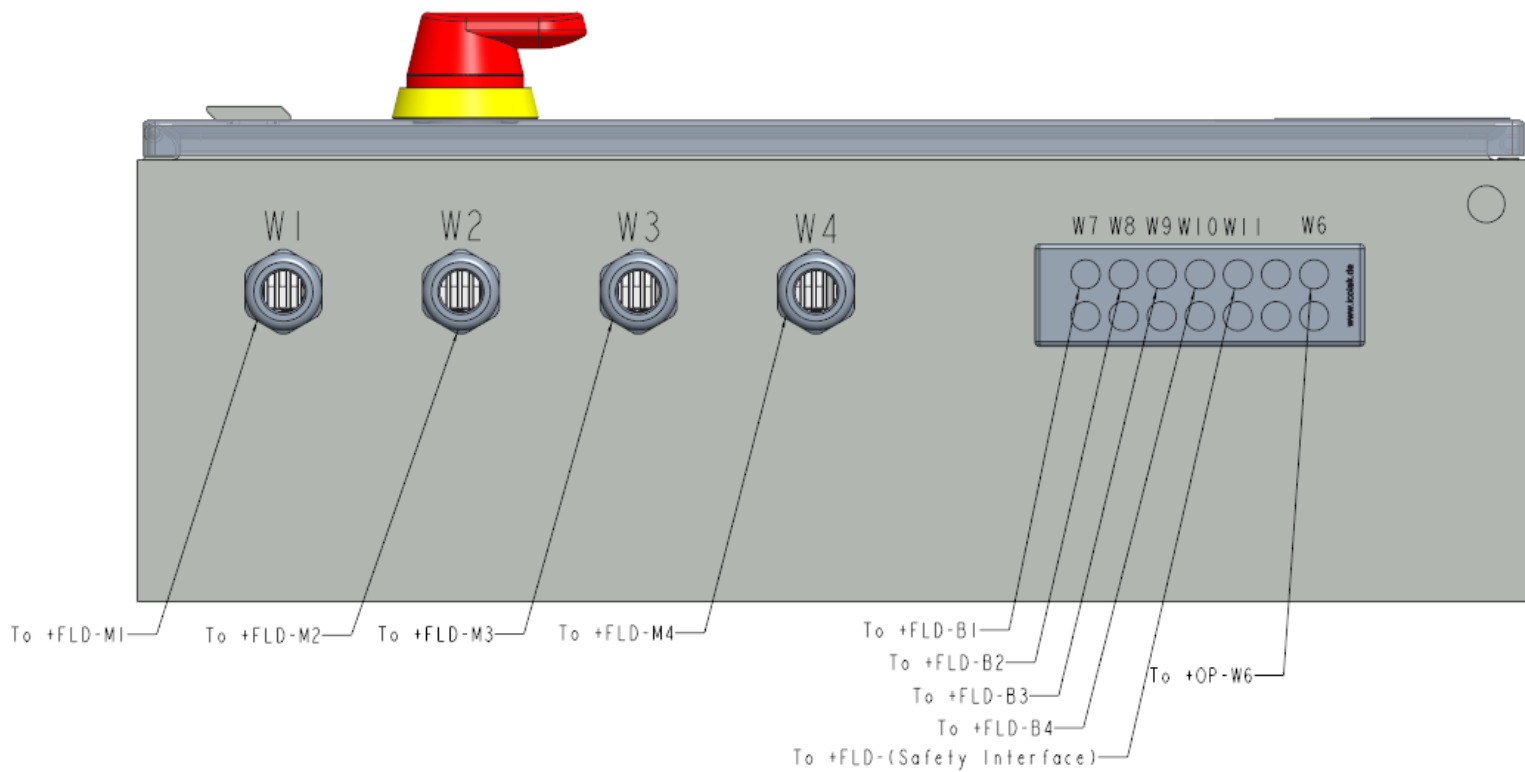
WOOD-MIZER 121618-2/3

PLC

Refer to PLC manual
for more information
See manual

NOTE:
2 Deck System - 2 Sweeps Shown as Reference

WM Wood-Mizer®			
Project Description: RC/RCS Controls			
Revision:	A.1	Pg Desc: 121618/121618-2/121618-3 Front	
Mounting Location:	+DRW/5	Type: Graphic	
Prev. pg:	4	Page:	5
Next pg:	6	Total Pgs:	64



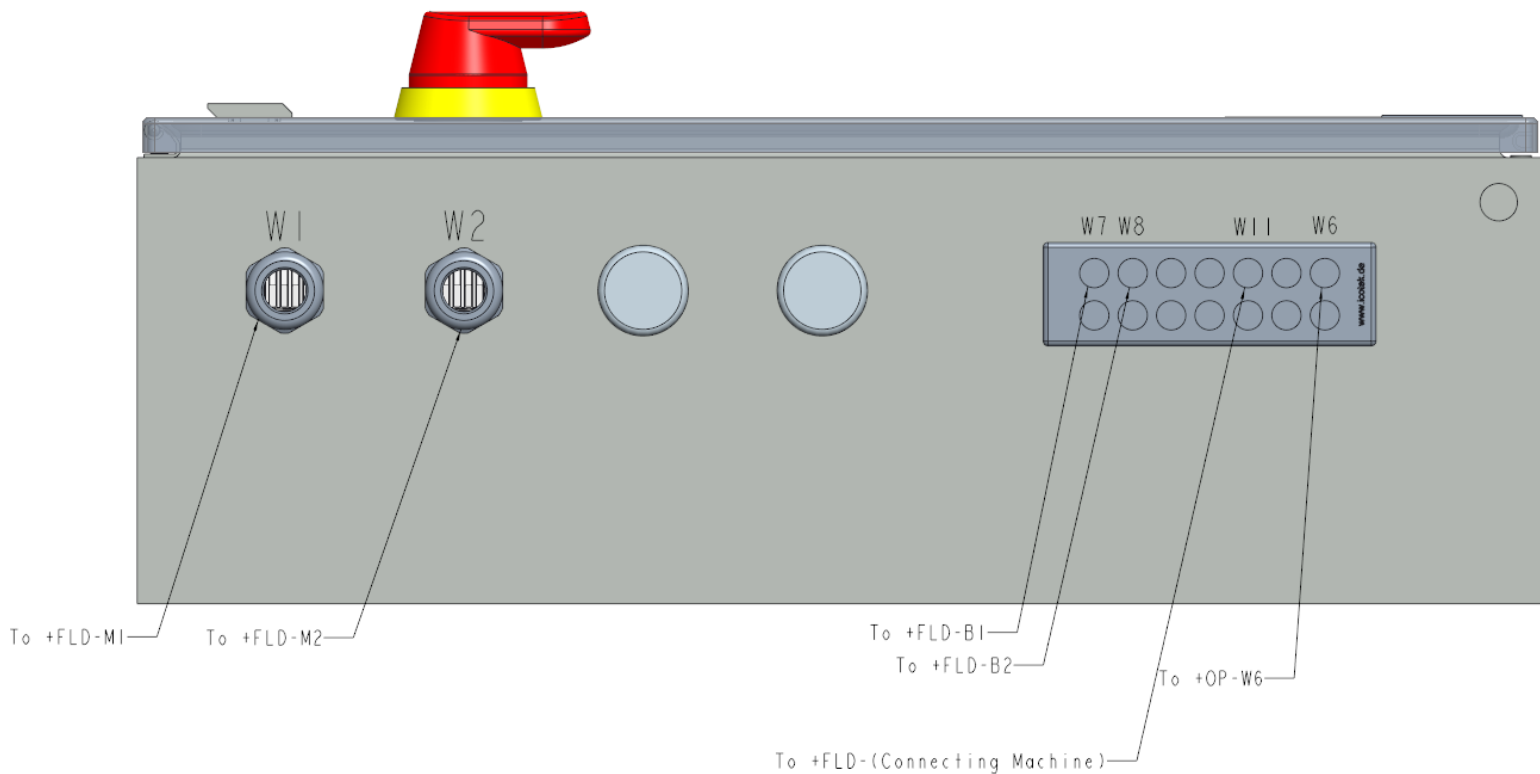
NOTE:
 Cable 'W5' Internal to Enclosure



Wood-Mizer®

Project Description: RC/RCS Controls

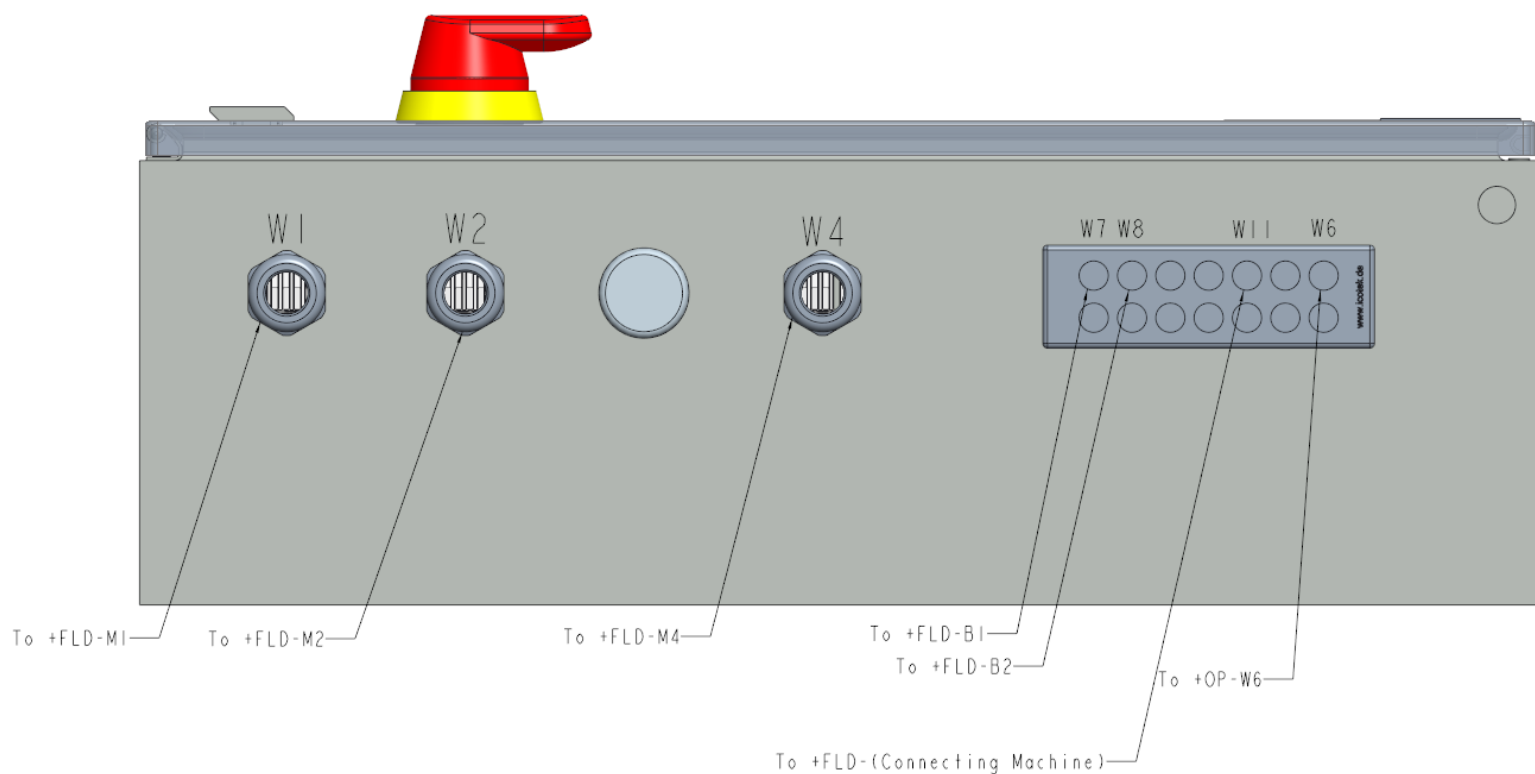
Revision: A.1		Pg Desc: 121618 Bottom	
Mounting Location: +DRW/6		Type: Graphic	
Prev. pg: 5	Page: 6	Next pg: 7	Total Pgs: 64



NOTE:
 Cable 'W5' Internal to Enclosure
 No Cables 'W3', 'W4', 'W9', and 'W10' in this Configuration


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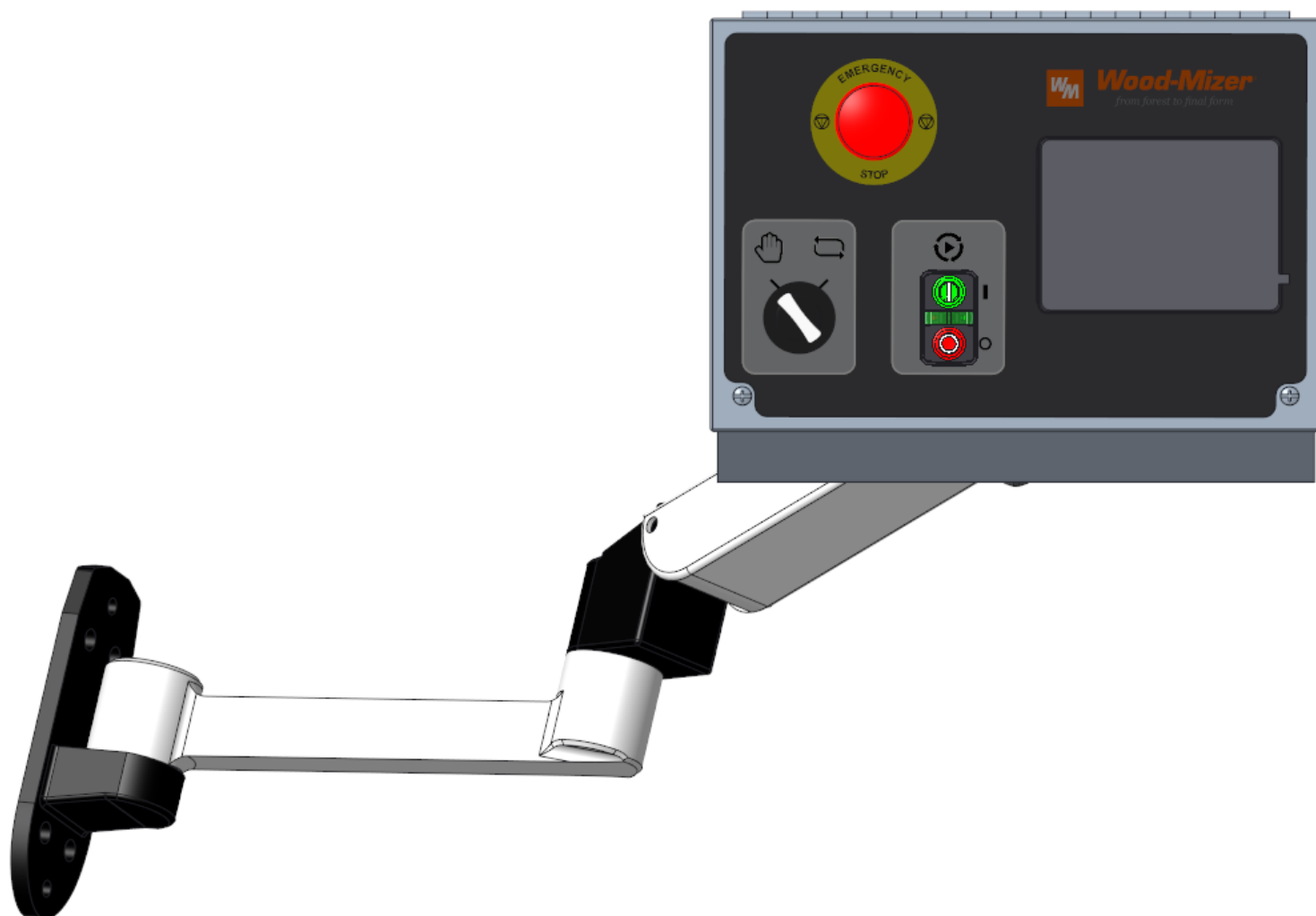
Project Description: RC/RCS Controls				
Revision:		A.1	Pg Desc: 121618-2 Bottom	
Mounting Location:		+DRW/7	Type: Graphic	
Prev. pg:	6	Page:	7	Next pg: 8
				Total Pgs: 64



NOTE:

Cable 'W5' Internal to Enclosure
 No Cables 'W3', 'W9', and 'W10' in this Configuration

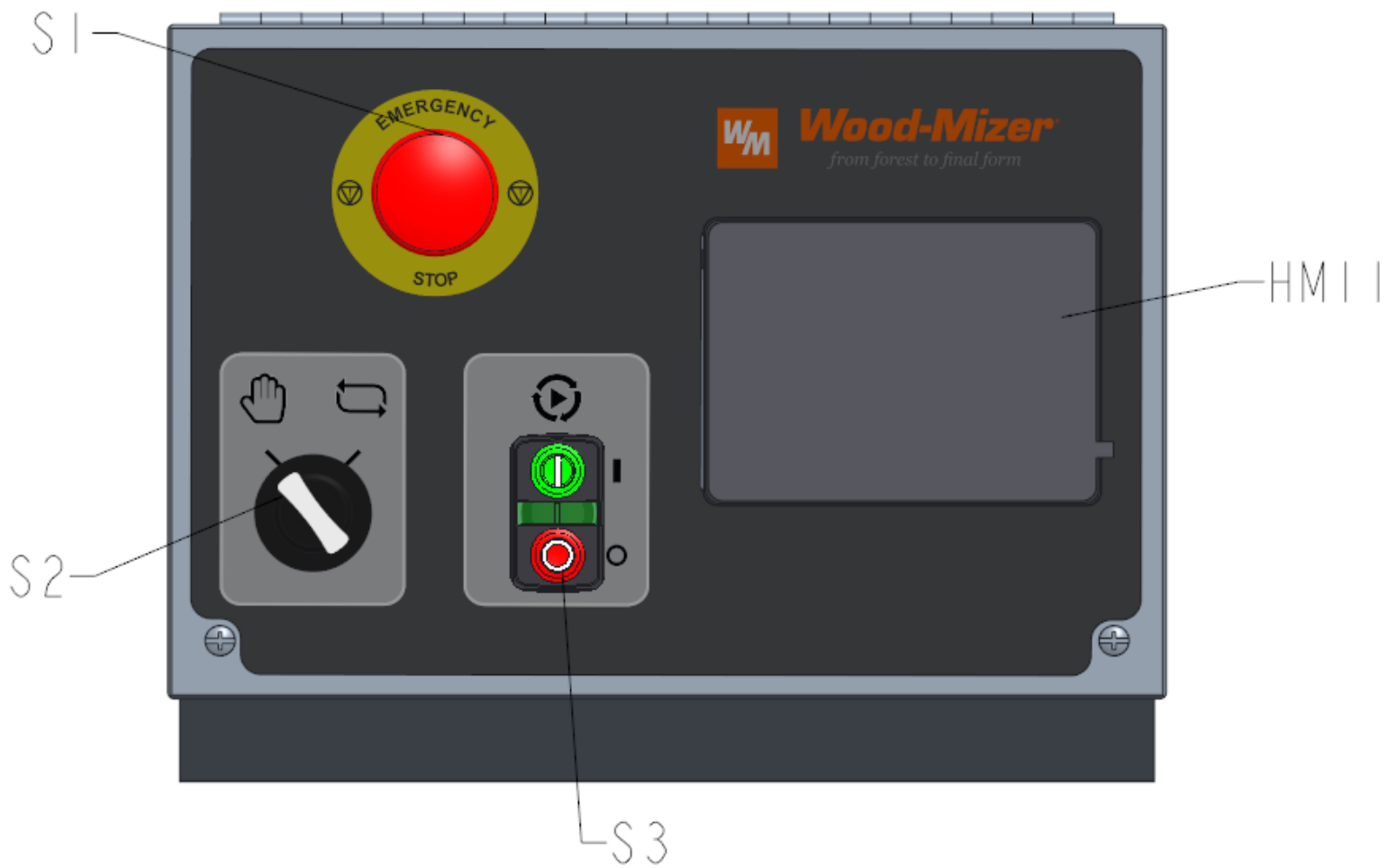
		Wood-Mizer®	
Project Description: RC/RCS Controls			
Revision: A.1		Pg Desc: 121618-3 Bottom	
Mounting Location: +DRW/8		Type: Graphic	
Prev. pg: 7	Page: 8	Next pg: 9	Total Pgs: 64

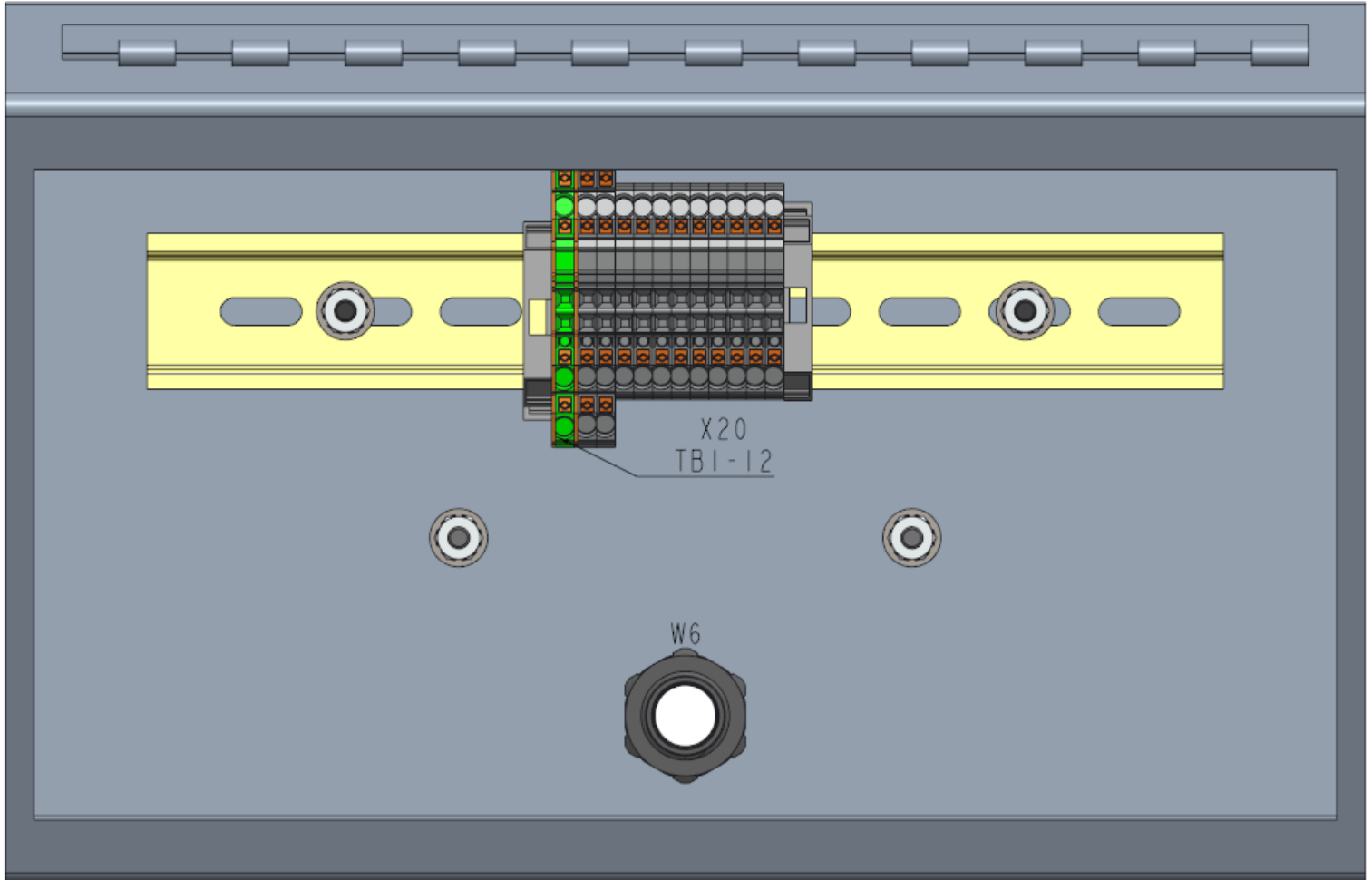


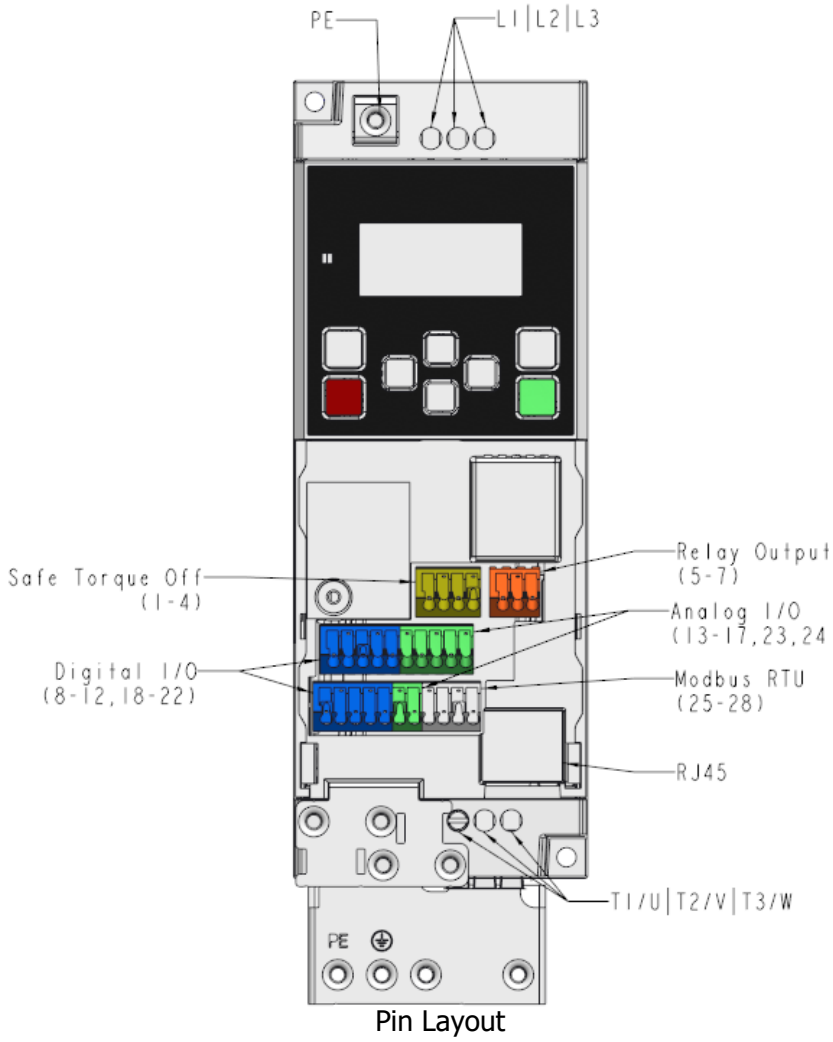
Wood-Mizer®

Project Description: RC/RCS Controls

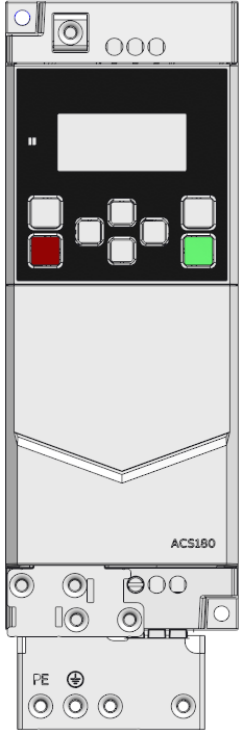
Revision:	A.1	Pg Desc:	121626 w/ Arm
Mounting Location:	+DRW/9	Type:	Graphic
Prev. pg:	8	Page:	9
Next pg:	10	Total Pgs:	64



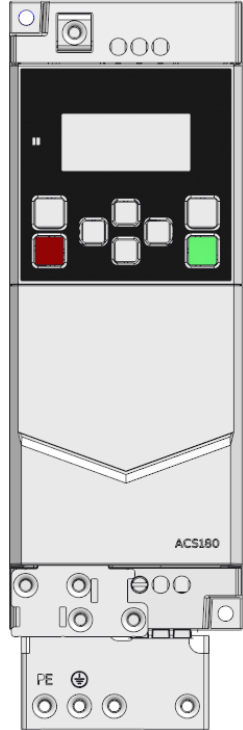




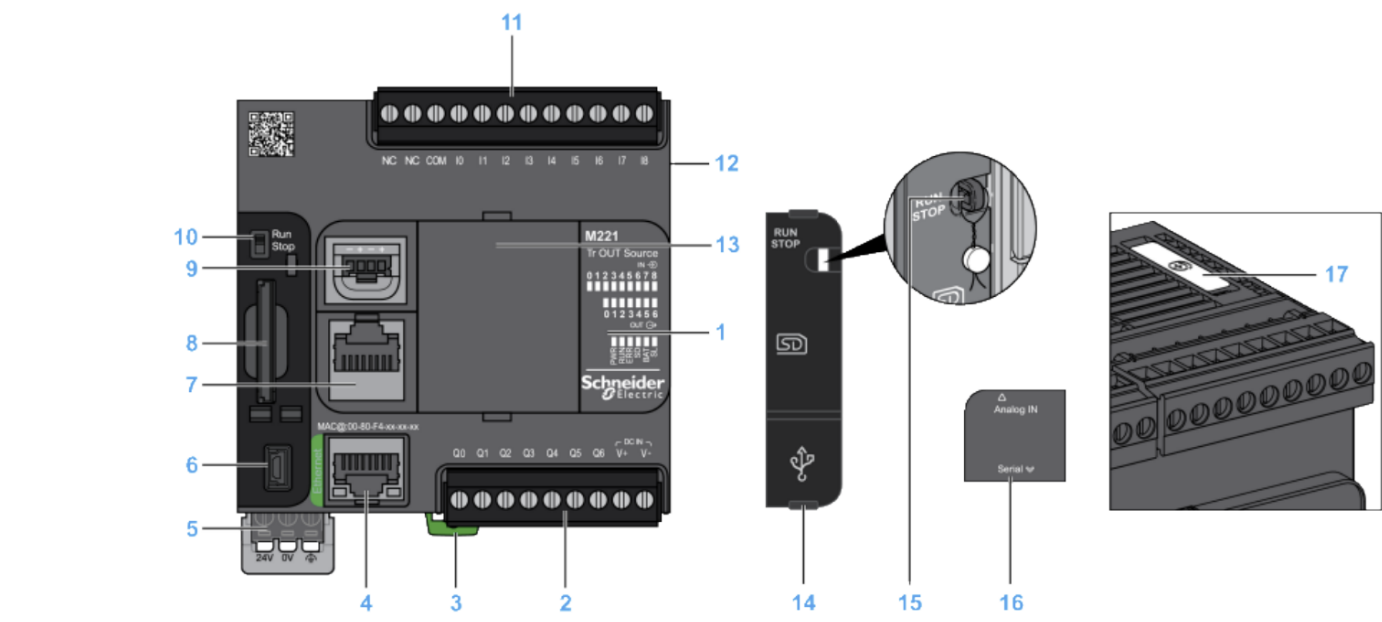
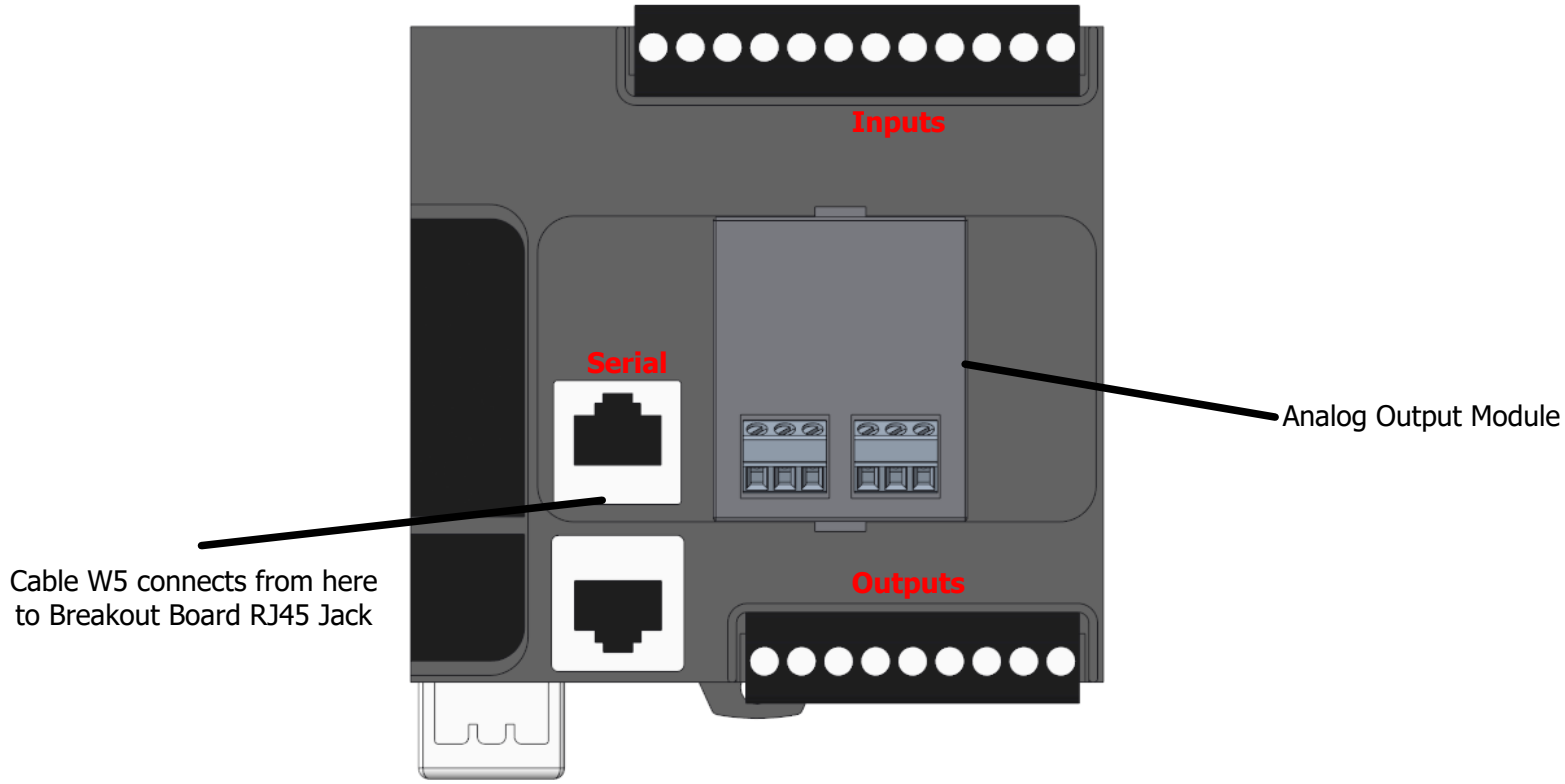
Terminals		Descriptions
Digital I/O		
21	24 V	Aux. +24 V DC, max 200 mA
22	DGND	Aux. voltage output common
8	DI1	Stop (0) / Start (1)
9	DI2	Forward (0) / Reverse (1)
10	DI3	Constant speed selection 1
11	DI4	Constant speed selection 2
12	DCOM	Digital input common
18	DO	Running
19	DO COM	Digital output common
20	DO SRC	Digital output auxiliary voltage
Analog I/O		
14	AI1/DI5	Speed reference (0...10V)
13	AGND	Analog input circuit common
15	AI2	Not used
16	AGND	Analog output circuit common
17	AO	Output frequency (0...20mA)
23	10V	Ref. voltage +10 V DC
24	SCREEN	Signal cable shield (screen)
Safe torque off (STO) (only on ACS180-04S)		
1	S+	Safe torque off (STO). Both circuits must be closed for the drive to start. The drawing shows the simplified connection of a safety circuit through safety contacts. If STO is not used, leave the factory-installed jumpers in place. See also section <i>Safe torque off (STO)</i> .
2	SGND	
3	S1	
4	S2	
Relay output		
5	NC	No fault [Fault (-1)]
6	COM	
7	NO	
EIA-485 Modbus RTU		
25	B+	Embedded Modbus RTU (EIA-485)
26	A-	
27	AGND	
28	SHIELD	
Jumper		
J1	Termination	Modbus Termination ON-OFF
J2	Comm.Mode	Communication Mode Selection



Sweepdrive
U1 & U3
Cables W1 & W3



Rollcase
U2 & U4
Cables W2 & W4

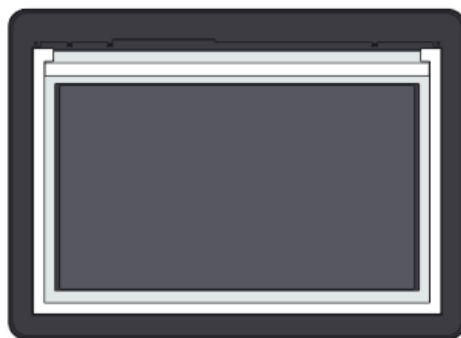


N°	Description
1	Status LEDs
2	Output removable terminal block
3	Clip-on lock for 35 mm (1.38 in.) top hat section rail (DIN-rail)
4	Ethernet port / RJ45 connector
5	24 Vdc power supply
6	USB mini-B programming port / For terminal connection to a programming PC (EcoStruxure Machine Expert - Basic)
7	Serial line port 1 / RJ45 connector (RS-232 or RS-485)
8	SD Card slot
9	2 analog inputs
10	Run/Stop switch
11	Input removable terminal block
12	I/O expansion connector
13	Cartridge slot
14	Protective cover (SD Card slot, Run/Stop switch and USB mini-B programming port)
15	Locking hook
16	Removable analog inputs cover
17	Battery holder

Wood-Mizer®

Project Description: RC/RCS Controls

Revision: A.1	Pg Desc: 121612 PLC Assy
Mounting Location: +DRW/13	Type: Graphic
Prev. pg: 12	Page: 13
Next pg: 14	Total Pgs: 64



Serial (Breakout Pins) Connections

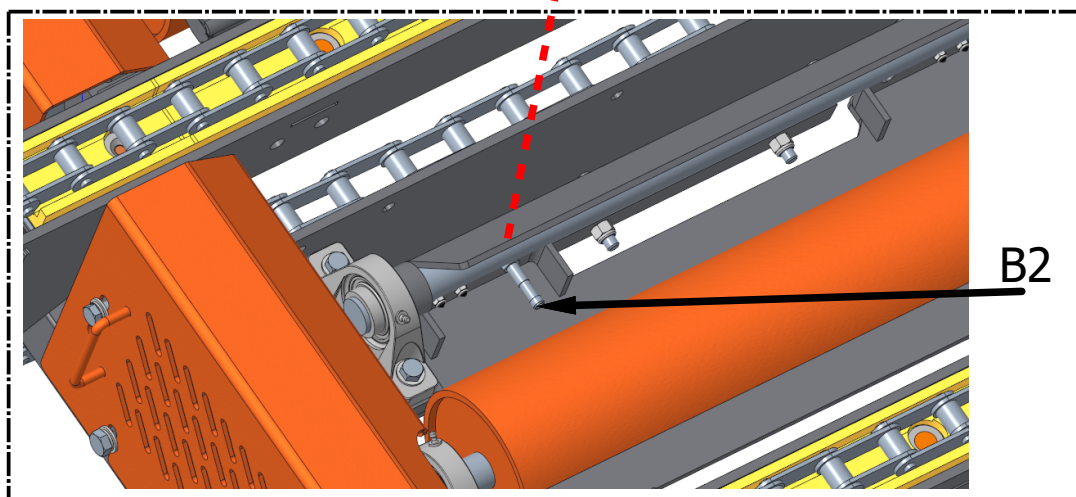
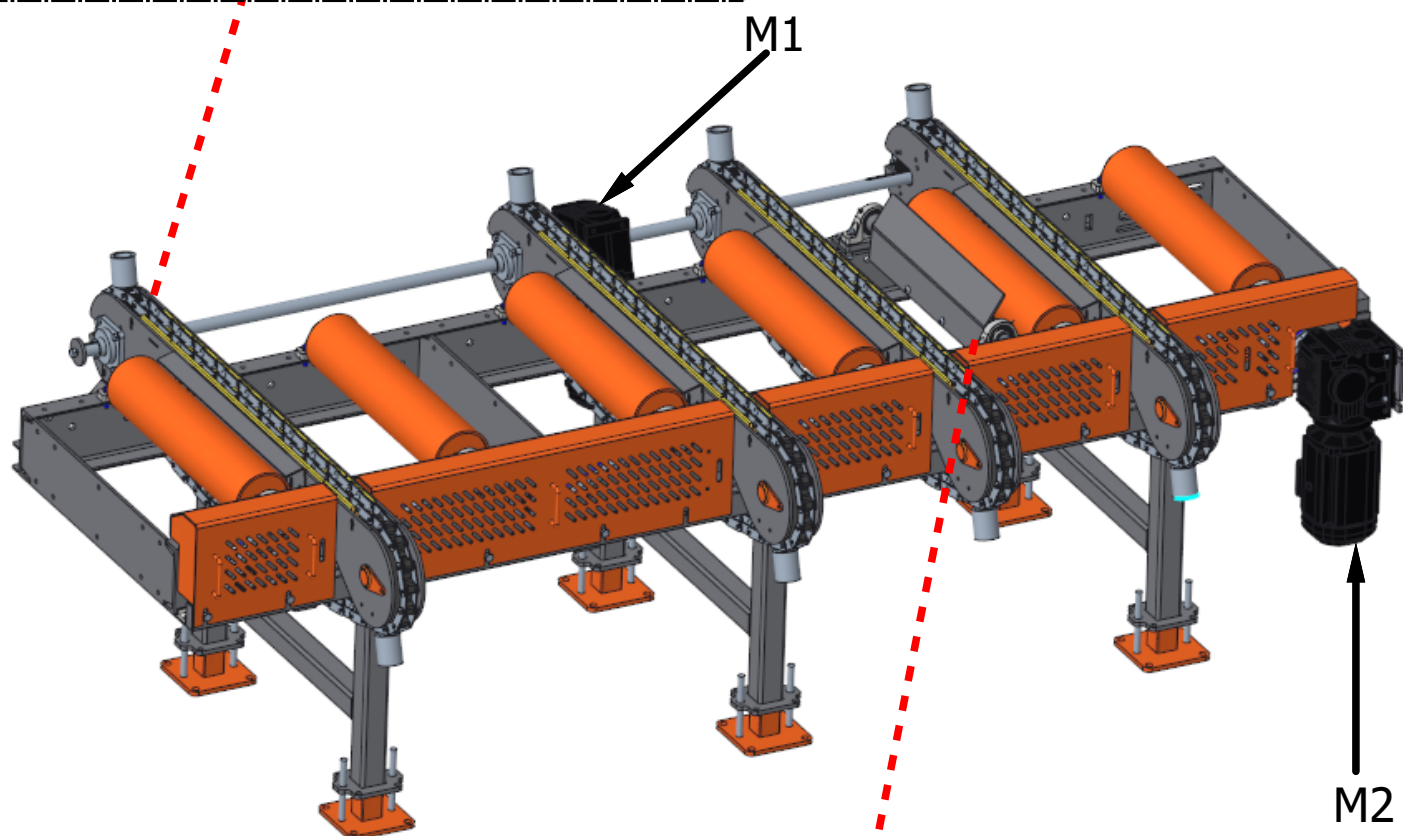
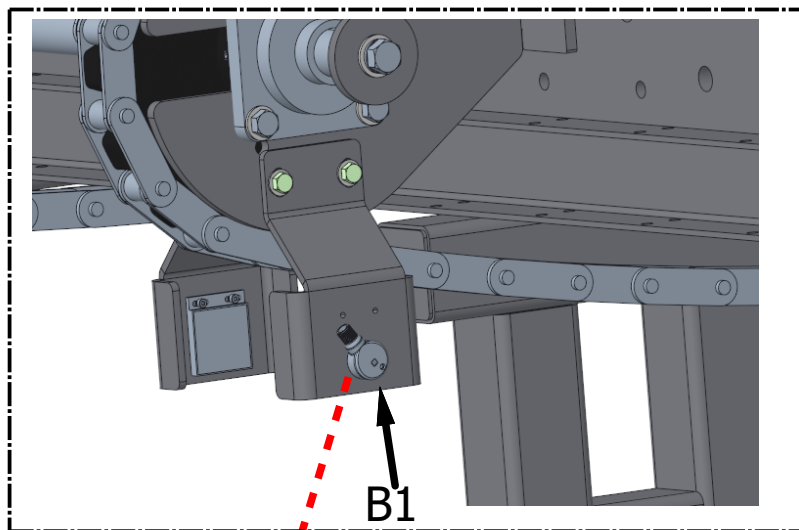
Power Connections



Wood-Mizer®

Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	121616 HMI Assy
Mounting Location:	+DRW/14	Type:	Graphic
Prev. pg:	13	Page:	14
Next pg:	15	Total Pgs:	64



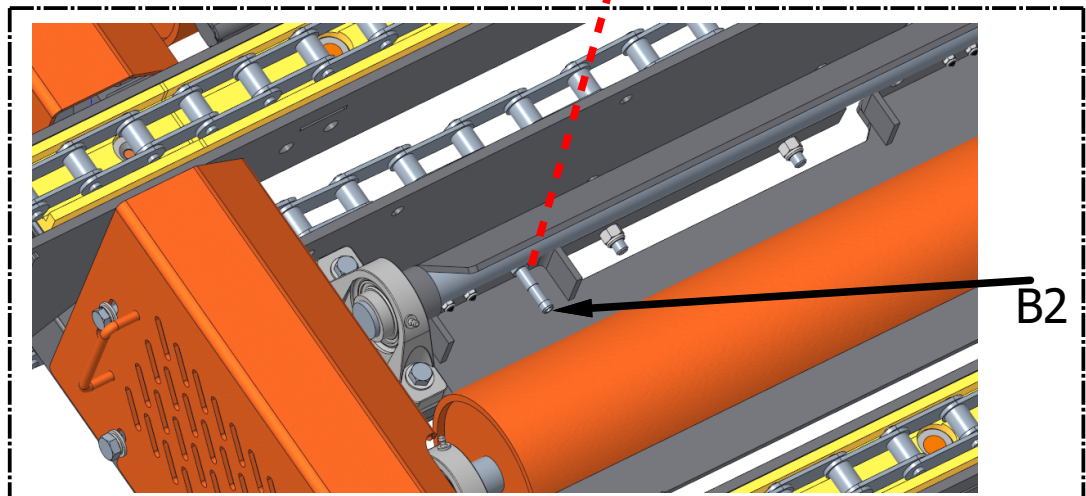
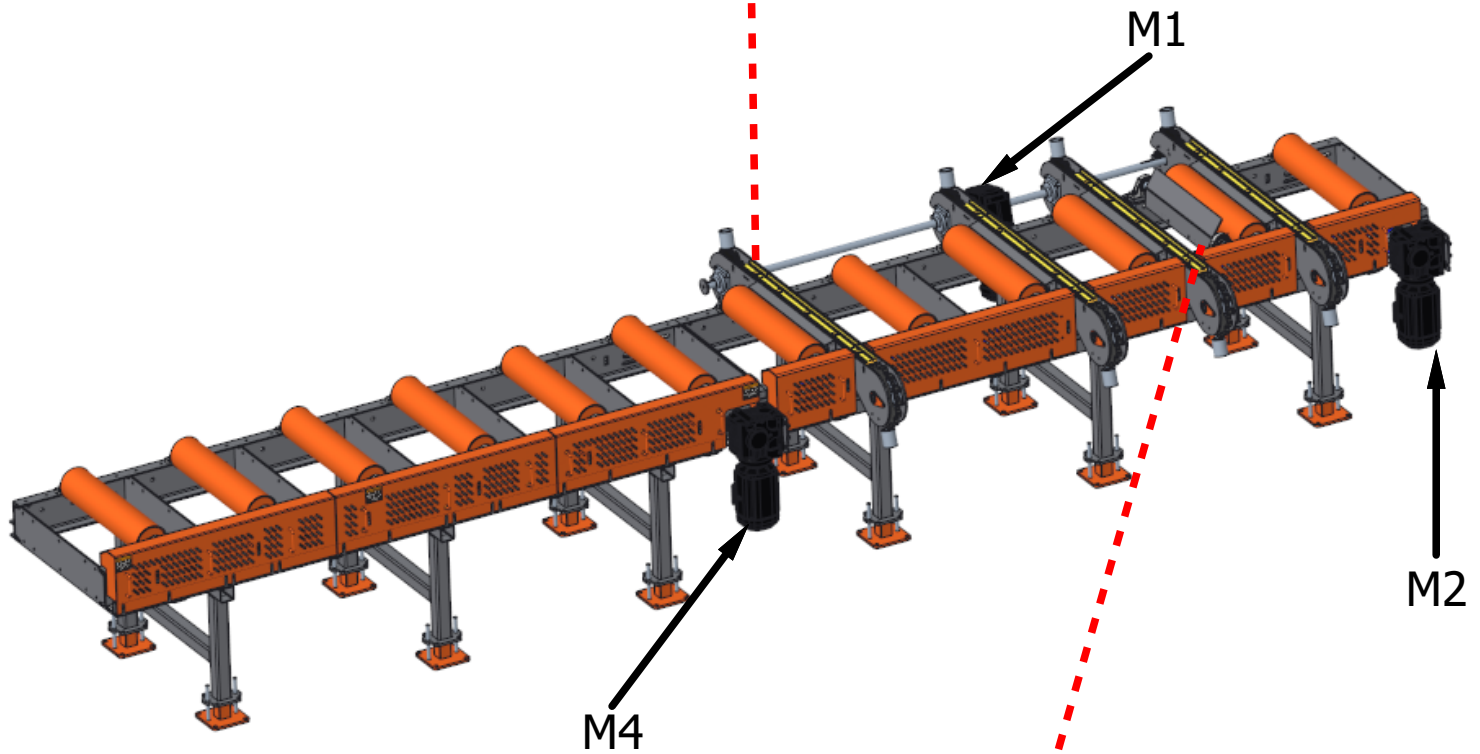
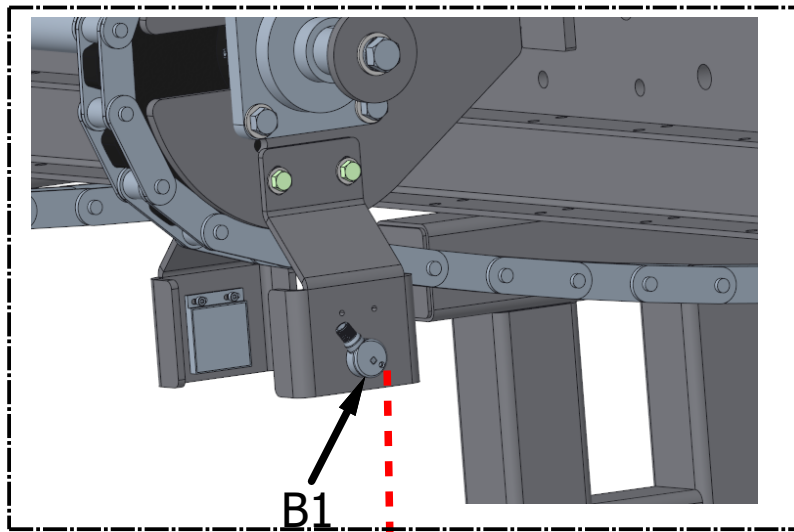
NOTE:
"Left-Handed" System Shown as Reference



Wood-Mizer®

Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	Single Sweep System
Mounting Location:	+DRW/15	Type:	Graphic
Prev. pg:	14	Page:	15
Next pg:	16	Total Pgs:	64



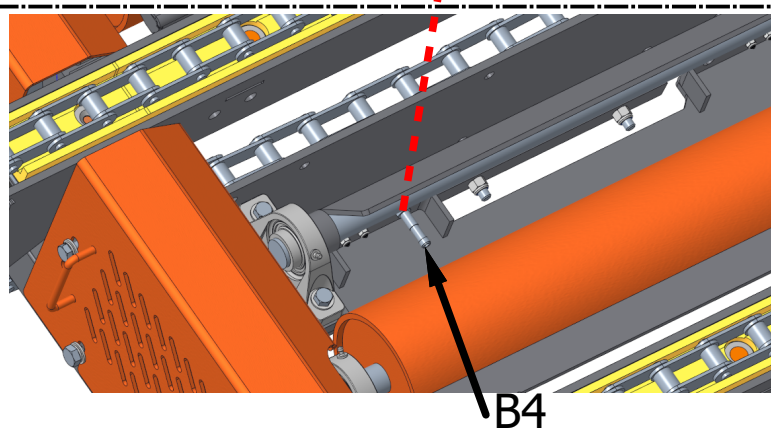
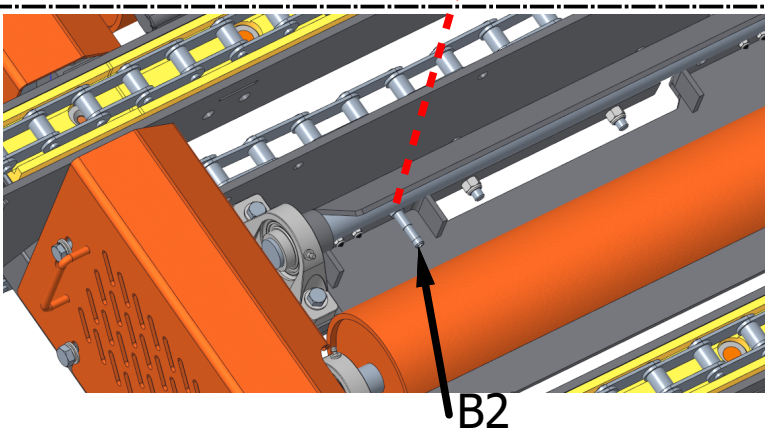
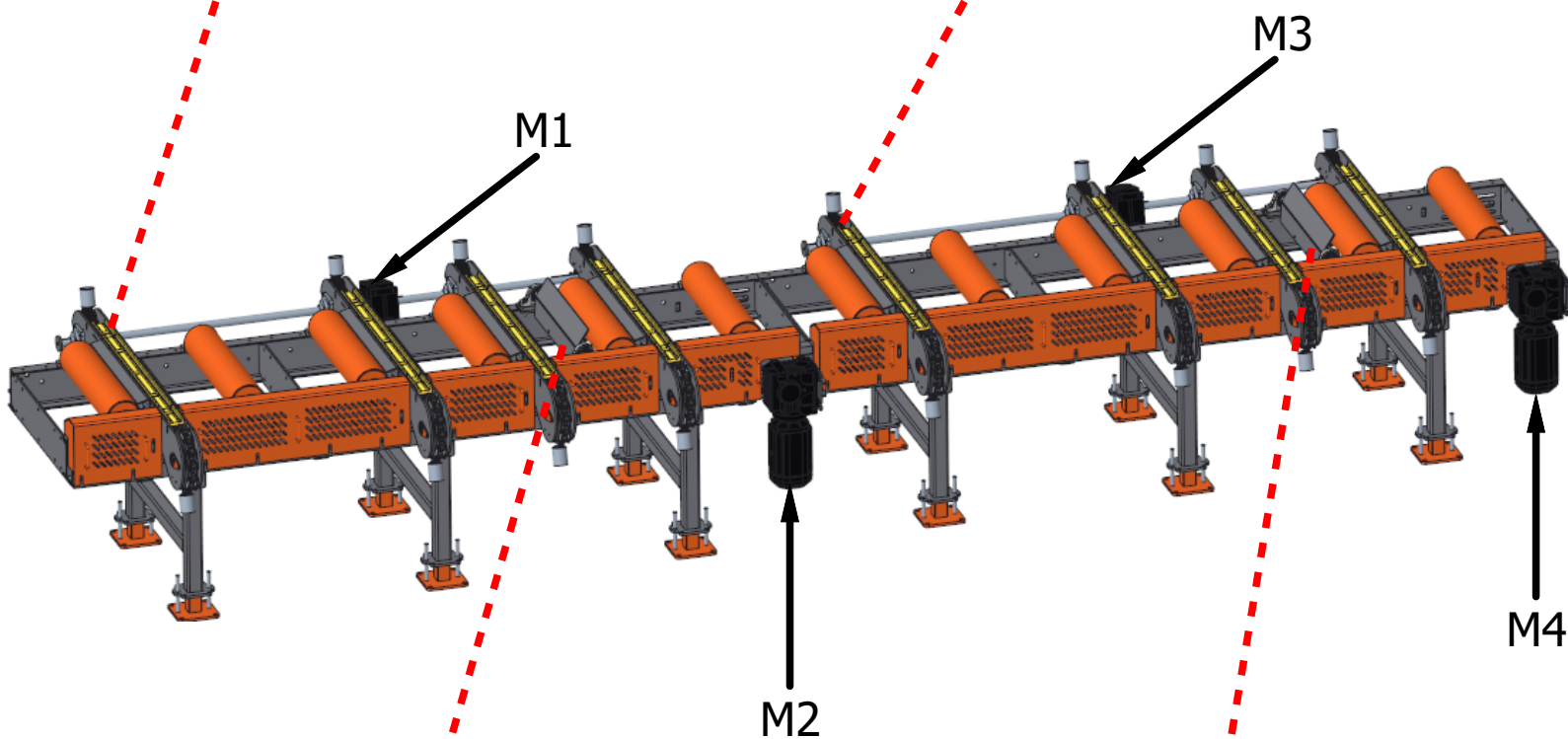
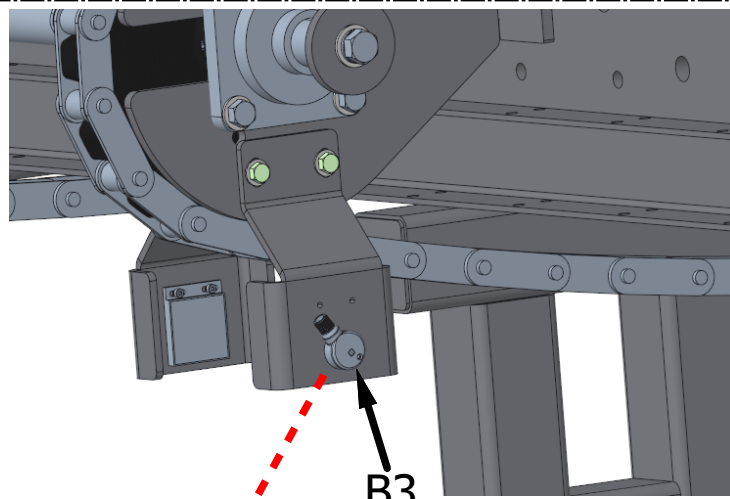
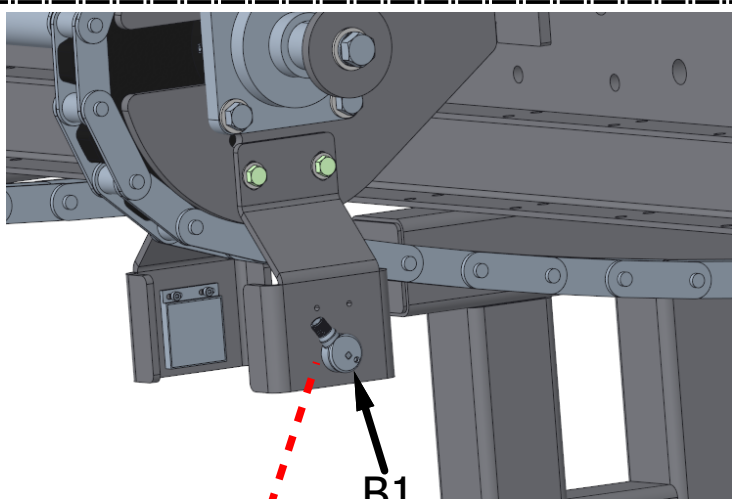
NOTE:
 "Left-Handed" System Shown as Reference



Wood-Mizer®

Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	Roll + Sweep System
Mounting Location:	+DRW/16	Type:	Graphic
Prev. pg:	15	Page:	16
Next pg:	17	Total Pgs:	64



NOTE:
"Left-Handed" System Shown as Reference



Wood-Mizer®

Project Description: RC/RCS Controls

Revision:	A.1	Pg Desc:	Double Sweep System
Mounting Location:	+DRW/17	Type:	Graphic
Prev. pg:	16	Page:	17
		Next pg:	Total Pgs: 64