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The Programmable Logic Controller The tray maker is controlled by a Model C0-00DR PLC from AutomationDirect, which has an expansion I/O and terminal blocks for field wiring. A bulkhead programming port with its outlet on the control enclosure door simplifies compliance with arc flash regulations by allowing changes to be made to the controller software without opening the door (Fig 5).

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The work here describes about the design and fabrication of automatic sheet metal punching machine controlled by Programmable Logic Controller (PLC). It also describes the working principle and the hardware structure of the system. By automating the punching system one can have greater control over the whole process.

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