Siemens 6ES7322-1HH01-0AA0

01 Inventory switched loads

1 Inventory switched loads
2 Check group and contact limits
3 Restore the front connector
4 Exercise actual load response
5 Verify shutdown behavior

Work sequence

Record each contact assignment, supply and load type. Identify inductive suppression and feedback signals, and establish the approved de-energized state before removing field wiring.

Acceptance condition

Every output is associated with a known load and protection arrangement.

Relay outputs	16
Isolation grouping	8 channels per group

Load duty: Apply electrical switching limits for the actual load category; maximum thermal current is not a universal switching rating.

Record the observed condition, test method and result for this stage. Resolve any difference before moving to check group and contact limits.

Siemens 6ES7322-1HH01-0AA0

02 Check group and contact limits

1 Inventory switched loads

2 **Check group and contact limits**

3 Restore the front connector

4 Exercise actual load response

5 Verify shutdown behavior

Work sequence

Evaluate simultaneous current per group and the electrical switching duty for each load. Keep redundant parallel outputs within the permitted group and do not use parallel contacts to increase load capacity.

Acceptance condition

The intended operating pattern meets both group and individual-contact limits.

Load voltage	24–120 V DC or 24–230 V AC
Continuous contact current	2 A maximum, subject to load duty

Group budget: Evaluate simultaneous current per eight-channel group and preserve separation between group circuits.

Record the observed condition, test method and result for this stage. Resolve any difference before moving to restore the front connector.

Siemens 6ES7322-1HH01-0AA0

03 Restore the front connector

1. Inventory switched loads
2. Check group and contact limits
3. **Restore the front connector**
4. Exercise actual load response
5. Verify shutdown behavior

Work sequence

Match the 20-pin conductor assignment to the retained wiring. Check relay supply, group separation and external protection before energizing, then inspect the connector engagement.

Acceptance condition

No group common, supply or load conductor has been interchanged.

Backplane current	100 mA maximum
Relay-supply current	250 mA maximum

Feedback requirement: An output status LED does not prove contact or load operation. Use the application feedback needed for the process.

Record the observed condition, test method and result for this stage. Resolve any difference before moving to exercise actual load response.

Siemens 6ES7322-1HH01-0AA0

04 Exercise actual load response

1. Inventory switched loads
2. Check group and contact limits
3. Restore the front connector
4. **Exercise actual load response**
5. Verify shutdown behavior

Work sequence

Operate channels under controlled conditions and compare the PLC bit, LED, contact circuit and actuator feedback. Check release behavior with inductive loads and distinguish contact faults from missing field supply.

Acceptance condition

The physical load response agrees with the commanded state.

Front connection	20-pin connector
Resistive-load switching	1 Hz maximum

Load duty: Apply electrical switching limits for the actual load category; maximum thermal current is not a universal switching rating.

Record the observed condition, test method and result for this stage. Resolve any difference before moving to verify shutdown behavior.

Siemens 6ES7322-1HH01-0AA0

05 Verify shutdown behavior

1 Inventory switched loads

2 Check group and contact limits

3 Restore the front connector

4 Exercise actual load response

5 Verify shutdown behavior

Work sequence

Test the application power-loss sequence and required contact state under the approved plan. Remove test commands and retain evidence of group loading, suppression and individual load operation.

Acceptance condition

The installation returns to normal control with the required shutdown response accepted.

Minimum load	10 V / 10 mA
Mechanical switching rate	10 Hz maximum

Siemens 6ES7222-1BH32-0XB0

Siemens 6ES7307-1EA01-0AA0

Siemens 6ES7532-5HF00-0AB0

Related products require separate compatibility assessment. Retain the final configuration and signed test outcome.