

## Line2 F13 I/O List

Name	Style	Data Type	Description
I80_0	Decimal	BOOL	FAN FOR EXHAUST HOOD F23 M1263-01
I80_1	Decimal	BOOL	AIR KNIFE BLOWER F23 M1310-01
I80_2	Decimal	BOOL	FILM WATER REMOVAL BLOWER#1 F23 M1310-02
I80_3	Decimal	BOOL	FILM WATER REMOVAL BLOWER#2 F23 M1310-03
I80_4	Decimal	BOOL	C.R. DRYING BLOWER F23 M1330-01
I80_5	Decimal	BOOL	C.R. BRAKE ELECTRON MAGNETIC BRAKE F23 M1302-01
I80_6	Decimal	BOOL	FREE
I80_7	Decimal	BOOL	AUX. WINDER#1 F23 M1360-01&02
I80_8	Decimal	BOOL	FREE
I80_9	Decimal	BOOL	FREE
I80_A	Decimal	BOOL	FREE
I80_B	Decimal	BOOL	FREE
I80_C	Decimal	BOOL	AUX. WINDER#2 F23 M1450-01&02
I80_D	Decimal	BOOL	MDO PUMP, ROLL#1&2 (Z1) F23 M1430-01
I80_E	Decimal	BOOL	MDO PUMP, ROLL#3&4 (Z2) F23 M1430-02
I80_F	Decimal	BOOL	MDO PUMP, ROLL#5&6 (Z3) F23 M1430-03
I81_0	Decimal	BOOL	TDO CENT. EXHAUST AIR FAN F24 M1525-01
I81_1	Decimal	BOOL	TDO CLIPS COOLING FAN (INLET) F24 M1528-01
I81_2	Decimal	BOOL	TDO CLIPS COOLING FAN (MIDDLE) F24 M1528-02
I81_3	Decimal	BOOL	TDO CLIPS COOLING FAN (INTERVAL) F24 M1528-03
I81_4	Decimal	BOOL	TDO EXHAUST AIR FAN (OUTLET) F24 M1530-01
I81_5	Decimal	BOOL	FREE
I81_6	Decimal	BOOL	FREE
I81_7	Decimal	BOOL	TDO FAN ZONE 1 (H.S) E185 F24 M1520-01
I81_8	Decimal	BOOL	TDO FAN ZONE 1 (L.S) E185 F24 M1520-01
I81_9	Decimal	BOOL	TDO FAN ZONE 2 (H.S) E187 F24 M1520-02
I81_A	Decimal	BOOL	TDO FAN ZONE 2 (L.S) E187 F24 M1520-02
I81_B	Decimal	BOOL	TDO FAN ZONE 3 (H.S) E188 F24 M1520-03
I81_C	Decimal	BOOL	TDO FAN ZONE 3 (L.S) E188 F24 M1520-03
I81_D	Decimal	BOOL	TDO FAN ZONE 4 (H.S) E189 F24 M1520-04
I81_E	Decimal	BOOL	TDO FAN ZONE 4 (L.S) E189 F24 M1520-04
I81_F	Decimal	BOOL	TDO FAN ZONE 5 (H.S) E190 F24 M1520-05
I82_0	Decimal	BOOL	TDO FAN 2 ZONE 11 (L.S) E198 F24 M1520-13
I82_1	Decimal	BOOL	TDO FAN 1 ZONE 12 (H.S) E199 F24 M1520-14
I82_2	Decimal	BOOL	TDO FAN 1 ZONE 12 (L.S) E199 F24 M1520-14

I82_3	Decimal	BOOL	TDO FAN 2 ZONE 12 (H.S) E200 F24 M1520-15
I82_4	Decimal	BOOL	TDO FAN 2 ZONE 12 (L.S) E200 F24 M1520-15
I82_5	Decimal	BOOL	TDO FAN 1 ZONE 13 (H.S) E201 F24 M1520-16
I82_6	Decimal	BOOL	TDO FAN 1 ZONE 13 (L.S) E201 F24 M1520-16
I82_7	Decimal	BOOL	TDO FAN 2 ZONE 13 (H.S) E202 F24 M1520-17
I82_8	Decimal	BOOL	TDO FAN 2 ZONE 13 (L.S) E202 F24 M1520-17
I82_9	Decimal	BOOL	TDO FAN 1 ZONE 14 (H.S) E203 F24 M1520-18
I82_A	Decimal	BOOL	TDO FAN 1 ZONE 14 (L.S) E203 F24 M1520-18
I82_B	Decimal	BOOL	TDO FAN 2 ZONE 14 (H.S) E204 F24 M1520-19
I82_C	Decimal	BOOL	TDO FAN 2 ZONE 14 (L.S) E204 F24 M1520-19
I82_D	Decimal	BOOL	TDO FAN 1 ZONE 15 (H.S) E205 F24 M1520-20
I82_E	Decimal	BOOL	TDO FAN 1 ZONE 15 (L.S) E205 F24 M1520-20
I82_F	Decimal	BOOL	TDO FAN 2 ZONE 15 (H.S) E206 F24 M1520-21
I83_0	Decimal	BOOL	TDO FAN 2 ZONE 19 (L.S) E214 F24 M1520-29
I83_1	Decimal	BOOL	TDO FAN 1 ZONE 20 (H.S) E215 F24 M1520-30
I83_2	Decimal	BOOL	TDO FAN 1 ZONE 20 (L.S) E215 F24 M1520-30
I83_3	Decimal	BOOL	TDO FAN 2 ZONE 20 (H.S) E216 F24 M1520-31
I83_4	Decimal	BOOL	TDO FAN 2 ZONE 20 (L.S) E216 F24 M1520-31
I83_5	Decimal	BOOL	TDO FAN 1 COOLING ZONE (H.S) E217 F24 M1520-32
I83_6	Decimal	BOOL	TDO FAN 1 COOLING ZONE (L.S) E217 F24 M1520-32
I83_7	Decimal	BOOL	TDO FAN 2 COOLING ZONE (H.S) E218 F24 M1520-33
I83_8	Decimal	BOOL	TDO FAN 2 COOLING ZONE (L.S) E218 F24 M1520-33
I83_9	Decimal	BOOL	TDO FAN 3 COOLING ZONE (H.S) E219 F24 M1520-34
I83_A	Decimal	BOOL	TDO FAN 3 COOLING ZONE (L.S) E219 F24 M1520-34
I83_B	Decimal	BOOL	TDO FAN 4 COOLING ZONE (H.S) E220 F24 M1520-35
I83_C	Decimal	BOOL	TDO FAN 4 COOLING ZONE (L.S) E220 F24 M1520-35
I83_D	Decimal	BOOL	FREE
I83_E	Decimal	BOOL	FREE
I83_F	Decimal	BOOL	FAN FOR VACUUM ROLL F24 M1812-01
I84_0	Decimal	BOOL	C.R. HAND CRANK C.R. ZS1301-03
I84_1	Decimal	BOOL	C.R. HOME POS. C.R. ZS1301-04
I84_2	Decimal	BOOL	C.R. HIGH/LOW SPEED C.R. ZS1301-05
I84_3	Decimal	BOOL	C.R. WORKING POS. C.R. ZS1301-06
I84_4	Decimal	BOOL	AIR KNIFE IN WORK POS. (DRIVING SIDE) C.R. ZSH1310-05
I84_5	Decimal	BOOL	AIR KNIFE IN WORK POS. (OPERATING SIDE) C.R. ZSH1310-06
I84_6	Decimal	BOOL	AIR KNIFE IN HOME POS. (DRIVING SIDE) C.R. ZSH1310-07
I84_7	Decimal	BOOL	AIR KNIFE IN HOME POS. (OPERATING SIDE) C.R. ZSH1310-08

I84_8	Decimal	BOOL	ROLL #1 LOW POS. MDO ZSL1402-04
I84_9	Decimal	BOOL	ROLL #1 MIDDLE POS. MDO ZSL1402-05
I84_A	Decimal	BOOL	ROLL #1 INTER POS. MDO ZSL1402-06
I84_B	Decimal	BOOL	ROLL #1 HIGH POS. MDO ZSL1402-07
I84_C	Decimal	BOOL	ROLL #2 LOW POS. MDO ZSL1402-08
I84_D	Decimal	BOOL	ROLL #2 MIDDLE POS. MDO ZSL1402-09
I84_E	Decimal	BOOL	ROLL #2 INTER POS. MDO ZSL1402-10
I84_F	Decimal	BOOL	ROLL #2 HIGH POS. MDO ZSL1402-11
I85_0	Decimal	BOOL	COR. ELECTRODE 1 IN POS., R SIDE PRS ZSH1820-08
I85_1	Decimal	BOOL	COR. ELECTRODE 1 PRESSURE PRS PSL1820-09
I85_2	Decimal	BOOL	COR. ELECTRODE 1 IN POS., L SIDE PRS ZSH1820-10
I85_3	Decimal	BOOL	COR. ELECTRODE 3 IN POS., R SIDE PRS ZSH1820-12
I85_4	Decimal	BOOL	COR. ELECTRODE 3 PRESSURE PRS PSL1820-14
I85_5	Decimal	BOOL	COR. ELECTRODE 3 IN POS., L SIDE PRS ZSH1820-13
I85_6	Decimal	BOOL	COR. ELECTRODE 2 IN POS., R SIDE ZSL1820-17
I85_7	Decimal	BOOL	COR. ELECTRODE 2 IN POS., R SIDE ZSL1820-18
I85_8	Decimal	BOOL	COR. ELECTRODE 2 PRESSURE PRS PSL1820-19
I85_9	Decimal	BOOL	EXTRAC. FLOW#1 PRS FSL1831-06
I85_A	Decimal	BOOL	EXTRAC. FLOW#3 PRS FSL1831-07
I85_B	Decimal	BOOL	AUX. WINDER 3, AIR PRESSURE LOW PRS PSL1860
I85_C	Decimal	BOOL	FREE
I85_D	Decimal	BOOL	WEB BREAK DETECTOR PRS ZT1840-10
I85_E	Decimal	BOOL	EXTRAC. FLOW#2 PRS FSL1831-08
I85_F	Decimal	BOOL	FREE
I86_0	Decimal	BOOL	EXHAUST HOOD-START F32
I86_1	Decimal	BOOL	EXHAUST HOOD-STOP F32
I86_2	Decimal	BOOL	EDGE PINNING-START F32
I86_3	Decimal	BOOL	EDGE PINNING-STOP F32
I86_4	Decimal	BOOL	C.R. FORWARD F32
I86_5	Decimal	BOOL	C.R. BACKWARD F32
I86_6	Decimal	BOOL	C.R. STOP F32
I86_7	Decimal	BOOL	AIR KNIFE-ENGAGE F32
I86_8	Decimal	BOOL	AIR KNIFE-RETRACT F32
I86_9	Decimal	BOOL	AIR KNIFE BLOWER-START F32
I86_A	Decimal	BOOL	AIR KNIFE BLOWER-STOP F32
I86_B	Decimal	BOOL	FILM REMOVAL POS. ENGAGE F32
I86_C	Decimal	BOOL	FILM REMOVAL POS. RETRACT F32

I86_D	Decimal	BOOL	RUBBER ROLL-ENGAGE F32
I86_E	Decimal	BOOL	RUBBER ROLL-RETRACT F32
I86_F	Decimal	BOOL	CHROMED ROLL-ENGAGE F32
I87_0	Decimal	BOOL	MDO STOP F40
I87_1	Decimal	BOOL	THREADING SYSTEM-START F40
I87_2	Decimal	BOOL	THREADING SYSTEM-STOP F40
I87_3	Decimal	BOOL	FREE
I87_4	Decimal	BOOL	TREADING SYSTEM-STOP F41
I87_5	Decimal	BOOL	MDO STOP F41
I87_6	Decimal	BOOL	PRESS ROLL INLET-ENGAGE F42
I87_7	Decimal	BOOL	PRESS ROLL INLET-RETRACT F42
I87_8	Decimal	BOOL	PRESS ROLL OUTLET-ENGAGE F42
I87_9	Decimal	BOOL	PRESS ROLL OUTLET-RETRACT F42
I87_A	Decimal	BOOL	NIP ROLL 1-ENGAGE F42
I87_B	Decimal	BOOL	NIP ROLL 1-RETRACT F42
I87_C	Decimal	BOOL	NIP ROLL 2-ENGAGE F42
I87_D	Decimal	BOOL	NIP ROLL 2-ENGAGE F42
I87_E	Decimal	BOOL	NIP ROLL 3-ENGAGE F42
I87_F	Decimal	BOOL	NIP ROLL 3-RETRACT F42
I90_0	Decimal	BOOL	PUMP ROLL#7&8 F23 M1430-04
I90_1	Decimal	BOOL	PUMP ROLL#9&10 F23 M1430-05
I90_2	Decimal	BOOL	PUMP ROLL#11&12 F23 M1430-06
I90_3	Decimal	BOOL	PUMP ROLL#13&14 F23 M1430-07
I90_4	Decimal	BOOL	PUMP ROLL#15&16 F23 M1430-08
I90_5	Decimal	BOOL	PUMP ROLL#17&18 F23 M1430-09
I90_6	Decimal	BOOL	PUMP ROLL#19&20 F23 M1430-10
I90_7	Decimal	BOOL	PUMP ROLL#21&22 F23 M1430-11
I90_8	Decimal	BOOL	PUMP ROLL#23&24 F23 M1430-12
I90_9	Decimal	BOOL	FREE
I90_A	Decimal	BOOL	FREE
I90_B	Decimal	BOOL	FREE
I90_C	Decimal	BOOL	FREE
I90_D	Decimal	BOOL	FREE
I90_E	Decimal	BOOL	FREE
I90_F	Decimal	BOOL	FREE
I91_0	Decimal	BOOL	TDO FAN ZONE 5 (L.S)-F24 M1520-05
I91_1	Decimal	BOOL	AIR FAN ZONE 6 (H.S) F24 M1520-06

I91_2	Decimal	BOOL	AIR FAN ZONE 6 (L.S) F24 M1520-06
I91_3	Decimal	BOOL	AIR FAN ZONE 7 (H.S) F24 M1520-07
I91_4	Decimal	BOOL	AIR FAN ZONE 7 (L.S) F24 M1520-07
I91_5	Decimal	BOOL	AIR FAN ZONE 8 (H.S) F24 M1520-08
I91_6	Decimal	BOOL	AIR FAN ZONE 8 (L.S) F24 M1520-08
I91_7	Decimal	BOOL	AIR FAN ZONE 9 (H.S) F24 M1520-09
I91_8	Decimal	BOOL	AIR FAN ZONE 9 (L.S) F24 M1520-09
I91_9	Decimal	BOOL	AIR FAN 1 ZONE 10 (H.S) F24 M1520-10
I91_A	Decimal	BOOL	AIR FAN 1 ZONE 10 (L.S) F24 M1520-10
I91_B	Decimal	BOOL	AIR FAN 2 ZONE 10 (H.S) F24 M1520-11
I91_C	Decimal	BOOL	AIR FAN 2 ZONE 10 (L.S) F24 M1520-11
I91_D	Decimal	BOOL	AIR FAN 1 ZONE 11 (H.S) F24 M1520-12
I91_E	Decimal	BOOL	AIR FAN 1 ZONE 11 (L.S) F24 M1520-12
I91_F	Decimal	BOOL	AIR FAN 2 ZONE 11 (H.S) F24 M1520-13
I92_0	Decimal	BOOL	TDO FAN 2 ZONE 15 (L.S) F24 M1520-21
I92_1	Decimal	BOOL	TDO FAN 1 ZONE 16 (H.S) F24 M1520-22
I92_2	Decimal	BOOL	TDO FAN 1 ZONE 16 (L.S) F24 M1520-22
I92_3	Decimal	BOOL	TDO FAN 2 ZONE 16 (H.S) F24 M1520-23
I92_4	Decimal	BOOL	TDO FAN 2 ZONE 16 (L.S) F24 M1520-23
I92_5	Decimal	BOOL	TDO FAN 1 ZONE 17 (H.S) F24 M1520-24
I92_6	Decimal	BOOL	TDO FAN 1 ZONE 17 (L.S) F24 M1520-24
I92_7	Decimal	BOOL	TDO FAN 2 ZONE 17 (H.S) F24 M1520-25
I92_8	Decimal	BOOL	TDO FAN 2 ZONE 17 (L.S) F24 M1520-25
I92_9	Decimal	BOOL	TDO FAN 1 ZONE 18 (H.S) F24 M1520-26
I92_A	Decimal	BOOL	TDO FAN 1 ZONE 18 (L.S) F24 M1520-26
I92_B	Decimal	BOOL	TDO FAN 2 ZONE 18 (H.S) F24 M1520-27
I92_C	Decimal	BOOL	TDO FAN 2 ZONE 18 (L.S) F24 M1520-27
I92_D	Decimal	BOOL	TDO FAN 1 ZONE 19 (H.S) F24 M1520-28
I92_E	Decimal	BOOL	TDO FAN 1 ZONE 19 (L.S) F24 M1520-28
I92_F	Decimal	BOOL	TDO FAN 2 ZONE 19 (H.S) F24 M1520-29
I93_0	Decimal	BOOL	FAN FOR VACUUM ROLL F24 M1825-01
I93_1	Decimal	BOOL	OZONE EXHAUST 1 F24 M1831-01
I93_2	Decimal	BOOL	OZONE EXHAUST 2 F24 M1831-02
I93_3	Decimal	BOOL	OZONE EXHAUST 3 F24 M1831-03
I93_4	Decimal	BOOL	OZONE TREATER FAN 1 F24
I93_5	Decimal	BOOL	OZONE TREATER FAN 2 F24
I93_6	Decimal	BOOL	OZONE TREATER FAN 3 F24

I93_7	Decimal	BOOL	OZONE TREATER FAN 4 F24
I93_8	Decimal	BOOL	FREE
I93_9	Decimal	BOOL	FREE
I93_A	Decimal	BOOL	FREE
I93_B	Decimal	BOOL	CHAIN TENSION-HYDRAULIC PUMP F24 M1515-01
I93_C	Decimal	BOOL	FREE
I93_D	Decimal	BOOL	FREE
I93_E	Decimal	BOOL	FREE
I93_F	Decimal	BOOL	FREE
I94_0	Decimal	BOOL	STRETCHING ROLL#3 LOW POS. MDO ZSL1402-12
I94_1	Decimal	BOOL	STRETCHING ROLL#3 MIDDLE POS. MDO ZSM1402-13
I94_2	Decimal	BOOL	STRETCHING ROLL#3 INTER. POS. MDO ZSI1402-14
I94_3	Decimal	BOOL	STRETCHING ROLL#3 HIGH POS. MDO ZSH1402-15
I94_4	Decimal	BOOL	MDO WEB BREAK OP. SIDE MDO ZT1420-01
I94_5	Decimal	BOOL	MDO WEB BREAK DR. SIDE ZT1420-02
I94_6	Decimal	BOOL	TDO FAULT ALARM TDO
I94_7	Decimal	BOOL	TDO FAST STOP, CRITICAL ALARM TDO
I94_8	Decimal	BOOL	CHAIN TENSION OIL PUMP LOW LEVEL TDO LSL1515-02
I94_9	Decimal	BOOL	CHAIN TENSION PUMP PRESSURE LOW TDO PSL1515-03
I94_A	Decimal	BOOL	WEB BREAK FILM (F149) TDO EXIT TDO ZT1531-01
I94_B	Decimal	BOOL	WEB BREAK FILM (F148) COOLING ZONE TDO ZT1531-02
I94_C	Decimal	BOOL	DRIVE SIDE TENSION ZS1515-06
I94_D	Decimal	BOOL	OPERATOR SIDE TENSION ZS1515-07
I94_E	Decimal	BOOL	DR. SIDE COUNTER (TDO OUTLET SPROCKET) ZS1550-01
I94_F	Decimal	BOOL	MIDDLE SIDE WEB BREAK SENSOR MDO ZS1550-02
I95_0	Decimal	BOOL	AUX. WINDER 1 THERMOSTAT TSH1360-03
I95_1	Decimal	BOOL	AUX. WINDER 2 THERMOSTAT TSH1450-03
I95_2	Decimal	BOOL	C.R. WATER BATH LEVEL SWITCH C.R. LSL1350-03
I95_3	Decimal	BOOL	NIP ROLL 1 IN POS MDO ZSH1404-06
I95_4	Decimal	BOOL	NIP ROLL 1 IN POS MDO ZSH1404-07
I95_5	Decimal	BOOL	NIP ROLL 2 IN POS. MDO ZSH1404-08
I95_6	Decimal	BOOL	NIP ROLL 2 IN POS. MDO ZSH1404-09
I95_7	Decimal	BOOL	NIP ROLL 3 IN POS. MDO ZSH1404-10
I95_8	Decimal	BOOL	NIP ROLL 3 IN POS. MDO ZSH1404-11
I95_9	Decimal	BOOL	PRESS ROLL INLET IN POS. MDO ZSH1404-12
I95_A	Decimal	BOOL	PRESS ROLL INLET IN POS. MDO ZSH1404-13
I95_B	Decimal	BOOL	PRESS ROLL OUTLET IN POS. MDO ZSH1404-14

I95_C	Decimal	BOOL	PRESS ROLL OUTLET IN POS. MDO ZSH1404-15
I95_D	Decimal	BOOL	FREE
I95_E	Decimal	BOOL	FREE
I95_F	Decimal	BOOL	FREE
I96_0	Decimal	BOOL	CHROMED ROLL-RETRACT F32
I96_1	Decimal	BOOL	C.R. WATER REMOVAL-START F32
I96_2	Decimal	BOOL	C.R. WATER REMOVA -STOP F32
I96_3	Decimal	BOOL	FILM WATER REMOVAL-START,1 F32
I96_4	Decimal	BOOL	FILM WATER REMOVAL-STOP,1 F32
I96_5	Decimal	BOOL	FILM WATER REMOVAL-START,2 F32
I96_6	Decimal	BOOL	FILM WATER REMOVAL-STOP,2 F32
I96_7	Decimal	BOOL	WATER BATH LEVEL-ON F32 90S32
I96_8	Decimal	BOOL	WATER BATH LEVEL-AUTO F32 90S32
I96_9	Decimal	BOOL	C.R. STOP F32
I96_A	Decimal	BOOL	INST. AIR START F32
I96_B	Decimal	BOOL	INST. AIR STOP F32
I96_C	Decimal	BOOL	TEST LAMPS F32
I96_D	Decimal	BOOL	FREE
I96_E	Decimal	BOOL	FREE
I96_F	Decimal	BOOL	FREE
I97_0	Decimal	BOOL	STRETCHING ROLL 1-UP F42
I97_1	Decimal	BOOL	STRETCHING ROLL 1-DOWN F42
I97_2	Decimal	BOOL	STRETCHING ROLL 2-UP F42
I97_3	Decimal	BOOL	STRETCHING ROLL 2-DOWN F42
I97_4	Decimal	BOOL	STRETCHING ROLL 3-UP F42
I97_5	Decimal	BOOL	STRETCHING ROLL 3-DOWN F42
I97_6	Decimal	BOOL	GENERAL STRETCHING ROLL-UP F42
I97_7	Decimal	BOOL	GENERAL STRETCHING ROLL-DOWN F42
I97_8	Decimal	BOOL	FILM <> 60 MICRO-M F42
I97_9	Decimal	BOOL	WEB BREAK DETECTOR MDO F42
I97_A	Decimal	BOOL	MDO STOP F42
I97_B	Decimal	BOOL	FREE
I97_C	Decimal	BOOL	LAMPS TEST F42
I97_D	Decimal	BOOL	FREE
I97_E	Decimal	BOOL	FREE
I97_F	Decimal	BOOL	FREE
IA0_0	Decimal	BOOL	AUX. WINDER 2 MOTOR-START F46

IA0_1	Decimal	BOOL	AUX. WINDER 2 MOTOR-STOP F46
IA0_2	Decimal	BOOL	AUX. WINDER 2 SPINDLE-ENGAGE F46
IA0_3	Decimal	BOOL	AUX. WINDER 2 SPINDLE-RETRACT F46
IA0_4	Decimal	BOOL	AUX. WINDER 2 FOOT SWITCH F36
IA0_5	Decimal	BOOL	AUX. WINDER 1 MOTOR-START F36
IA0_6	Decimal	BOOL	AUX. WINDER 1 MOTOR-STOP F36
IA0_7	Decimal	BOOL	AUX. WINDER 1 SPINDLE-ENGAGE F36
IA0_8	Decimal	BOOL	AUX. WINDER 1 SPINDLE-RETRACT F36
IA0_9	Decimal	BOOL	AUX. WINDER 1 FOOT SWITCH F36
IA0_A	Decimal	BOOL	AUX. WINDER 3 WEB BREAK BYPASS F70
IA0_B	Decimal	BOOL	TABLE RAISE/LOWER F50
IA0_C	Decimal	BOOL	CLIPS OPENING/CLOSING F50
IA0_D	Decimal	BOOL	CHAIN TENSION START F50
IA0_E	Decimal	BOOL	CHAIN TENSION STOP F50
IA0_F	Decimal	BOOL	TDO PROCESS STOP F50
IA1_0	Decimal	BOOL	VACUUM ROLL 1-START F55
IA1_1	Decimal	BOOL	VACUUM ROLL 1-STOP F55
IA1_2	Decimal	BOOL	WEB BREAK PRS BYPASS/ON F55
IA1_3	Decimal	BOOL	OZONE EXHAUST FAN 1-START F55
IA1_4	Decimal	BOOL	OZONE EXHAUST FAN 1-STOP F55
IA1_5	Decimal	BOOL	OZONE EXHAUST FAN 2-START F55
IA1_6	Decimal	BOOL	OZONE EXHAUST FAN 2-STOP F55
IA1_7	Decimal	BOOL	OZONE EXHAUST FAN 3-START F55
IA1_8	Decimal	BOOL	OZONE EXHAUST FAN 3-STOP F55
IA1_9	Decimal	BOOL	VACUUM ROLL 2-START F55
IA1_A	Decimal	BOOL	VACUUM ROLL 2-STOP F55
IA1_B	Decimal	BOOL	PRS NIP ROLL#1 FOR CORONA-ENGAGE F55
IA1_C	Decimal	BOOL	NIP ROLL FOR CORONA#1-RETRACT F55
IA1_D	Decimal	BOOL	COR. ELECTRODE 1 ENGAGE F55
IA1_E	Decimal	BOOL	COR. ELECTRODE 1 RETRACT F55
IA1_F	Decimal	BOOL	NIP ROLL FOR CORONA#3-ENGAGE F55
IA2_0	Decimal	BOOL	NIP ROLL FOR CORONA#1-ENGAGE F56
IA2_1	Decimal	BOOL	PRS NIP ROLL#1 FOR CORONA-RETRACT F56
IA2_2	Decimal	BOOL	NIP ROLL FOR CORONA#3-ENGAGE F56
IA2_3	Decimal	BOOL	NIP ROLL FOR CORONA#3-RETRACT F56
IA2_4	Decimal	BOOL	SPREADER ROLL 2 ENGAGE F56
IA2_5	Decimal	BOOL	SPREADER ROLL 2 RETRACT F56

IA2_6	Decimal	BOOL	SPREADER ROLL 3 ENGAGE F56(LINE2 NO USED)
IA2_7	Decimal	BOOL	SPREADER ROLL 3 RETRACT F56
IA2_8	Decimal	BOOL	OP. SPREADER ROLL 2 ENGAGE F66
IA2_9	Decimal	BOOL	OP. SPREADER ROLL 2 RETRACT F66
IA2_A	Decimal	BOOL	DRIVE SPREADER ROLL 2 ENGAGE F66
IA2_B	Decimal	BOOL	DRIVE SPREADER ROLL 2 RETRACT F66
IA2_C	Decimal	BOOL	OP. SPREADER ROLL 3 ENGAGE F68
IA2_D	Decimal	BOOL	OP. SPREADER ROLL 3 RETRACT F68
IA2_E	Decimal	BOOL	DRIVE SPREADER ROLL 3 ENGAGE F68
IA2_F	Decimal	BOOL	DRIVE SPREADER ROLL 3 RETRACT F68
IA3_0	Decimal	BOOL	BURNER 1 ON F151
IA3_1	Decimal	BOOL	BURNER 1 DEFECT F151
IA3_2	Decimal	BOOL	BURNER 2 ON F152
IA3_3	Decimal	BOOL	BURNER 2 DEFECT F152
IA3_4	Decimal	BOOL	BURNER 3 ON F153
IA3_5	Decimal	BOOL	BURNER 3 DEFECT F153
IA3_6	Decimal	BOOL	BURNER 4 ON F154
IA3_7	Decimal	BOOL	BURNER 4 DEFECT F154
IA3_8	Decimal	BOOL	BURNER 5 ON F155
IA3_9	Decimal	BOOL	BURNER 5 DEFECT F155
IA3_A	Decimal	BOOL	BURNER 6 ON F156
IA3_B	Decimal	BOOL	BURNER 6 DEFECT F156
IA3_C	Decimal	BOOL	BURNER 7 ON F157
IA3_D	Decimal	BOOL	BURNER 7 DEFECT F157
IA3_E	Decimal	BOOL	BURNER 8 ON F158
IA3_F	Decimal	BOOL	BURNER 8 DEFECT F158
IA4_0	Decimal	BOOL	BURNER 17 ON F167
IA4_1	Decimal	BOOL	BURNER 17 DEFECT F167
IA4_2	Decimal	BOOL	BURNER 18 ON F168
IA4_3	Decimal	BOOL	BURNER 18 DEFECT F168
IA4_4	Decimal	BOOL	BURNER 19 ON F169
IA4_5	Decimal	BOOL	BURNER 19 DEFECT F169
IA4_6	Decimal	BOOL	BURNER 20 ON F170
IA4_7	Decimal	BOOL	BURNER 20 DEFECT F170
IA4_8	Decimal	BOOL	RELEASE DEFECT F12
IA4_9	Decimal	BOOL	RELEASE KLAXON (ALARM) F12
IA4_A	Decimal	BOOL	FREE

IA4_B	Decimal	BOOL	FREE
IA4_C	Decimal	BOOL	FREE
IA4_D	Decimal	BOOL	FREE
IA4_E	Decimal	BOOL	FREE
IA4_F	Decimal	BOOL	FREE
IA5_0	Decimal	BOOL	FREE
IA5_1	Decimal	BOOL	FREE
IA5_2	Decimal	BOOL	FREE
IA5_3	Decimal	BOOL	FREE
IA5_4	Decimal	BOOL	FREE
IA5_5	Decimal	BOOL	FREE
IA5_6	Decimal	BOOL	FREE
IA5_7	Decimal	BOOL	FREE
IA5_8	Decimal	BOOL	FREE
IA5_9	Decimal	BOOL	FREE
IA5_A	Decimal	BOOL	FREE
IA5_B	Decimal	BOOL	FREE
IA5_C	Decimal	BOOL	FREE
IA5_D	Decimal	BOOL	FREE
IA5_E	Decimal	BOOL	FREE
IA5_F	Decimal	BOOL	FREE
IA7_0	Decimal	BOOL	C.R. RUNNING F16
IA7_1	Decimal	BOOL	MDO 1 RUNNING F16
IA7_2	Decimal	BOOL	MDO 2 RUNNING F16
IA7_3	Decimal	BOOL	MDO 3 RUNNING F16
IA7_4	Decimal	BOOL	TDO RUNNING F16
IA7_5	Decimal	BOOL	PRS 1 RUNNING F16
IA7_6	Decimal	BOOL	PRS 2 RUNNING F16
IA7_7	Decimal	BOOL	AUX. 1 RUNNING F16
IA7_8	Decimal	BOOL	AUX. 2 RUNNING F16
IA7_9	Decimal	BOOL	AUX. WINDER RUNNING F16
IA7_A	Decimal	BOOL	PRODUCTION STRETCHING F16
IA7_B	Decimal	BOOL	C.R. ROTATION F16
IA7_C	Decimal	BOOL	MDO 1 ROTATION F16
IA7_D	Decimal	BOOL	MDO 2 ROTATION F16
IA7_E	Decimal	BOOL	MDO 3 ROTATION F16
IA7_F	Decimal	BOOL	TDO ROTATION F16

IB0_0	Decimal	BOOL	AIR ON CLIPS-ON
IB0_1	Decimal	BOOL	AIR ON CLIPS-AUTO
IB0_2	Decimal	BOOL	TDO STOP F52
IB0_3	Decimal	BOOL	TDO STOP F53
IB0_4	Decimal	BOOL	OP. TRIM NIP ROLL ENGAGE F62
IB0_5	Decimal	BOOL	OP. NIP ROLL RETRACT F62
IB0_6	Decimal	BOOL	DRIVE NIP ROLL ENGAGE F62
IB0_7	Decimal	BOOL	DRIVE NIP ROLL RETRACT F62
IB0_8	Decimal	BOOL	OP. KNIFE - ENGAGE F62
IB0_9	Decimal	BOOL	OP. KNIFE - RETRACT F62
IB0_A	Decimal	BOOL	DRIVE KNIFE - ENGAGE F62
IB0_B	Decimal	BOOL	DRIVE KNIFE - RETRACT F62
IB0_C	Decimal	BOOL	OP. SPREADER ROLL 1 ENGAGE F62
IB0_D	Decimal	BOOL	OP. SPREADER ROLL 1 RETRACT F62
IB0_E	Decimal	BOOL	DRIVE SPREADER ROLL 1 ENGAGE F62
IB0_F	Decimal	BOOL	DRIVE SPREADER ROLL 1 RETRACT F62
IB1_0	Decimal	BOOL	NIP ROLL FOR CORONA #3 - RETRACT F55
IB1_1	Decimal	BOOL	COR. ELECTRDE 3 ENGAGE F55
IB1_2	Decimal	BOOL	COR. ELECTRDE 3 RETRACT F55
IB1_3	Decimal	BOOL	COR. ELECTRDE 2 ENGAGE F55
IB1_4	Decimal	BOOL	COR. ELECTRDE 2 F55
IB1_5	Decimal	BOOL	PRS STOP F55
IB1_6	Decimal	BOOL	PRS SAFETY GATE OPEN (LINE 2)
IB1_7	Decimal	BOOL	LAMP TEST F55
IB1_8	Decimal	BOOL	WEB BREAK TDO BY – PASS/ON F55
IB1_9	Decimal	BOOL	FREE
IB1_A	Decimal	BOOL	FREE
IB1_B	Decimal	BOOL	FREE
IB1_C	Decimal	BOOL	FREE
IB1_D	Decimal	BOOL	FREE
IB1_E	Decimal	BOOL	AUX. WINDER 1 WEB BREAK BY - PASS F36
IB1_F	Decimal	BOOL	AUX. WINDER 2 WEB BREAK BY - PASS F46
IB2_0	Decimal	BOOL	NIP ROLL ENGAGE F63
IB2_1	Decimal	BOOL	NIP ROLL RETRACT F63
IB2_2	Decimal	BOOL	KNIFE ENGAGE F63
IB2_3	Decimal	BOOL	KNIFE RETRACT F63
IB2_4	Decimal	BOOL	SPREADER ROLL 1 ENGAGE F63

IB2_5	Decimal	BOOL	SPREADER ROLL 1 RETRACT F63
IB2_6	Decimal	BOOL	PRS STOP F95
IB2_7	Decimal	BOOL	PRS STOP F63
IB2_8	Decimal	BOOL	FREE
IB2_9	Decimal	BOOL	AUX. WINDER 3 START F70
IB2_A	Decimal	BOOL	AUX. WINDER 3 STOP F70
IB2_B	Decimal	BOOL	AUX. WINDER 3 ENGAGE F70
IB2_C	Decimal	BOOL	AUX. WINDER 3 RETRACT F70
IB2_D	Decimal	BOOL	FREE
IB2_E	Decimal	BOOL	C.R. COOLING STOP
IB2_F	Decimal	BOOL	WATER BATH COOLING STOP
IB3_0	Decimal	BOOL	BURNER 9 ON F159
IB3_1	Decimal	BOOL	BURNER 9 DEFECT F159
IB3_2	Decimal	BOOL	BURNER 10 ON F160
IB3_3	Decimal	BOOL	BURNER 10 DEFECT F160
IB3_4	Decimal	BOOL	BURNER 11 ON F161
IB3_5	Decimal	BOOL	BURNER 11 DEFECT F161
IB3_6	Decimal	BOOL	BURNER 12 ON F162
IB3_7	Decimal	BOOL	BURNER 12 DEFECT F162
IB3_8	Decimal	BOOL	BURNER 13 ON F163
IB3_9	Decimal	BOOL	BURNER 13 DEFECT F163
IB3_A	Decimal	BOOL	BURNER 14 ON F164
IB3_B	Decimal	BOOL	BURNER 14 DEFECT F164
IB3_C	Decimal	BOOL	BURNER 15 ON F165
IB3_D	Decimal	BOOL	BURNER 15 DEFECT F165
IB3_E	Decimal	BOOL	BURNER 16 ON F166
IB3_F	Decimal	BOOL	BURNER 16 DEFECT F166
IB4_0	Decimal	BOOL	FREE
IB4_1	Decimal	BOOL	FREE
IB4_2	Decimal	BOOL	FREE
IB4_3	Decimal	BOOL	FREE
IB4_4	Decimal	BOOL	FREE
IB4_5	Decimal	BOOL	FREE
IB4_6	Decimal	BOOL	FREE
IB4_7	Decimal	BOOL	FREE
IB4_8	Decimal	BOOL	CORE A DEFECT CANCELLED
IB4_9	Decimal	BOOL	CORE A RUNNING CANCELLED

IB4_A	Decimal	BOOL	CORE B DEFECT CANCELLED
IB4_B	Decimal	BOOL	CORE B RUNNING CANCELLED
IB4_C	Decimal	BOOL	WEB BREAK F201
IB4_D	Decimal	BOOL	ROLL 2 DEFECTS CANCELLED
IB4_E	Decimal	BOOL	ROLL 2 RUNNING CANCELLED
IB4_F	Decimal	BOOL	FREE
IB5_0	Decimal	BOOL	FREE
IB5_1	Decimal	BOOL	FREE
IB5_2	Decimal	BOOL	FREE
IB5_3	Decimal	BOOL	FREE
IB5_4	Decimal	BOOL	FREE
IB5_5	Decimal	BOOL	FREE
IB5_6	Decimal	BOOL	FREE
IB5_7	Decimal	BOOL	FREE
IB5_8	Decimal	BOOL	FREE
IB5_9	Decimal	BOOL	FREE
IB5_A	Decimal	BOOL	FREE
IB5_B	Decimal	BOOL	FREE
IB5_C	Decimal	BOOL	FREE
IB5_D	Decimal	BOOL	WEB BREAK
IB5_E	Decimal	BOOL	FREE
IB5_F	Decimal	BOOL	FREE
IB7_0	Decimal	BOOL	C.R. COOLING ON C1340
IB7_1	Decimal	BOOL	C.R. COOLING DEFECT C1340
IB7_2	Decimal	BOOL	WATER BATH ON C1350
IB7_3	Decimal	BOOL	WATER BATH DEFECT C1350
IB7_4	Decimal	BOOL	MDO OIL SKID ON C1430
IB7_5	Decimal	BOOL	MDO OIL SKID DEFECT C1430
IB7_6	Decimal	BOOL	FREE
IB7_7	Decimal	BOOL	CORONA 1 ON F75
IB7_8	Decimal	BOOL	CORONA 1 DEFECT F75
IB7_9	Decimal	BOOL	CORONA 2 ON F76
IB7_A	Decimal	BOOL	CORONA 2 DEFECT F76
IB7_B	Decimal	BOOL	CORONA 3 ON F77
IB7_C	Decimal	BOOL	CORONA 3 DEFECT F77
IB7_D	Decimal	BOOL	CORONA 4 ON F78
IB7_E	Decimal	BOOL	CORONA 4 DEFECT F78

IB7_F	Decimal	BOOL	EMERGENCY STOP
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