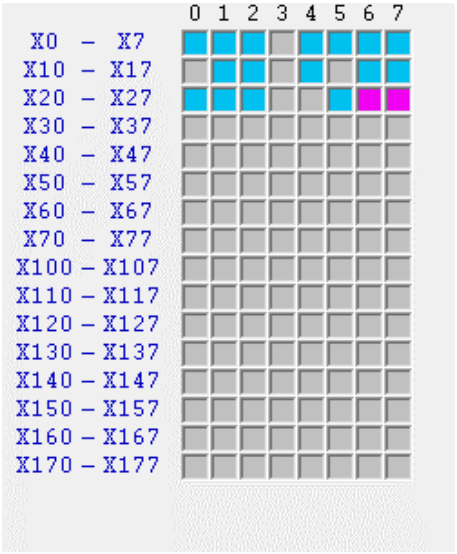
Inputs	Description	Output	Description
X0	Motor X1.1 Encoder	Y0	Motor X1.1 PULSE
X1	Motor Y1.1 Encoder	Y1	Motor Y1.1 PULSE
X2	Motor X1.1 HOME	Y2	N/A
X3	Motor Y1.1 HOME	Y3	N/A
X4	START/RST	Y4	Motor X1.1 DIR
X5	JOG/RUN	Y5	Motor Y1.1 DIR
X6	DUAL ROD I RS A	Y6	DUAL ROD I
X7	SINGLE ACT RS A	Y7	Single Act Cylinder
X10	FOOT Proxy	Y10	FOOT
X11	STICH Proxy	Y11	STICH
X12	Pedal Input	Y12	Tentioner
X13	EMG	Y13	Belt cylinder
X14	DUAL ROD RS A	Y14	DUAL ROD
X15	DUAL ROD RS B		
X16	100 stroke RS A	Y15	100 stroke
X17	100 stroke RS B		
		Y16	Catcher
X20	ROD LESS RS A	Y17	ROD LESS
X21	ROD LESS RS B		
X22	ROTATE RS A	Y20	ROTATE
X23	ROTATE RS B		
		Y21	AIR 3 times
X24	50 stroke A	Y22	50 stroke
X25	50 stroke B	Y23	RED
X26	N/A	Y24	YELLOW
X27	N/A	Y25	GREEN
		Y26	BUZZER ALRAM
		Y27	N/A

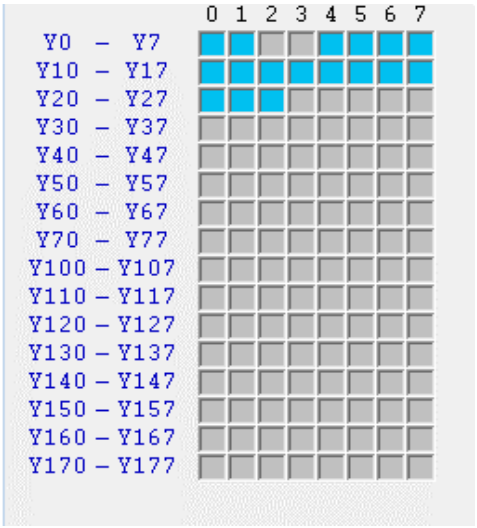
Legend

	Changed
	Not Allocated
	Newly Added
	Emergency
	Start / Stop Push Button

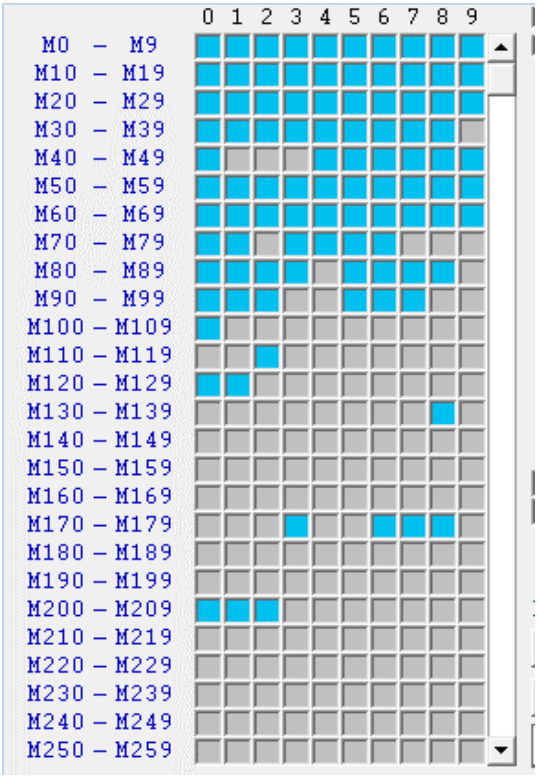
INPUT



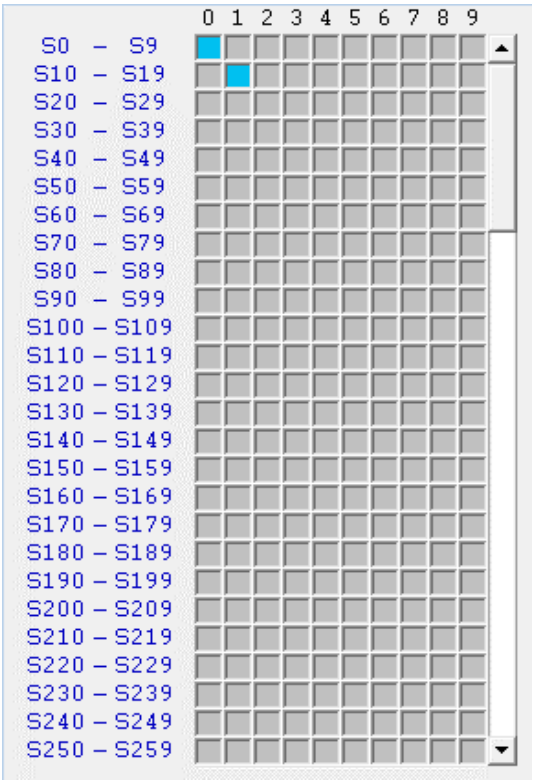
output



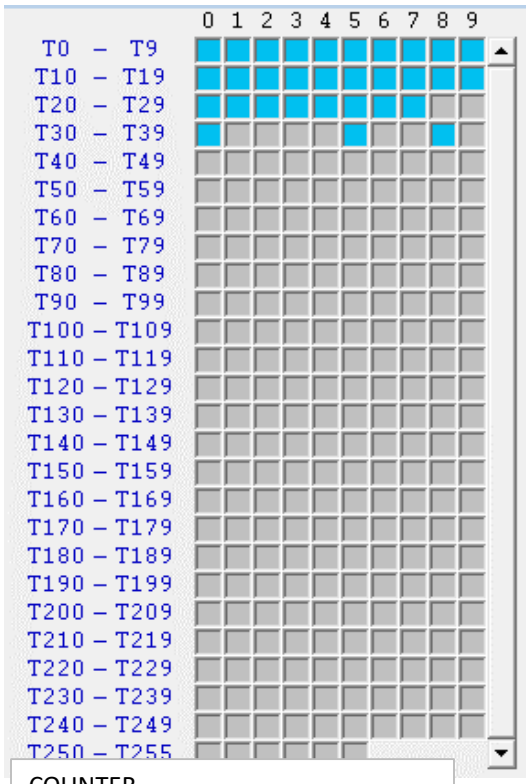
Memory NON Latch



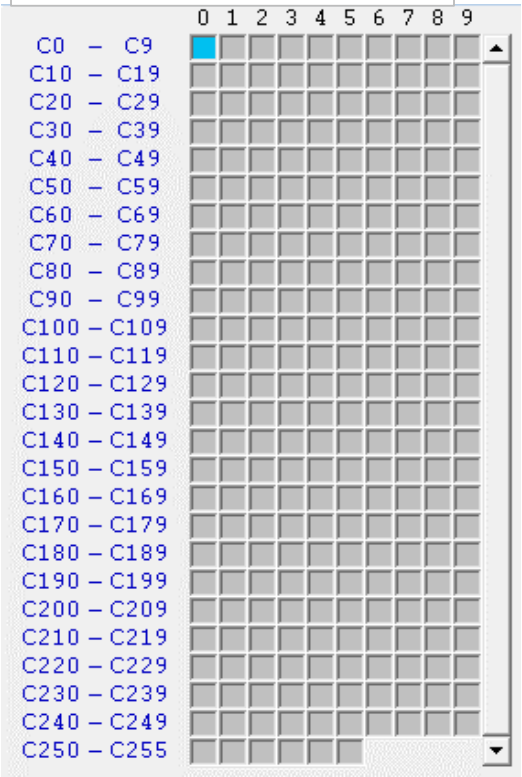
STL



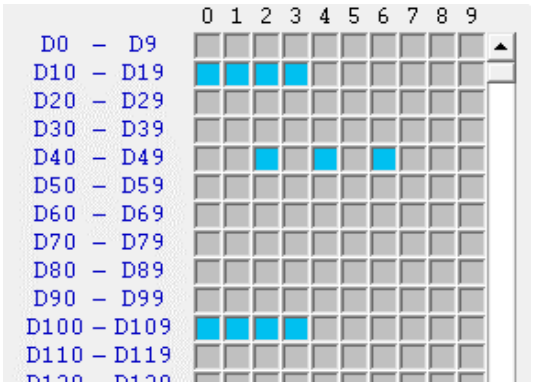
TIMER

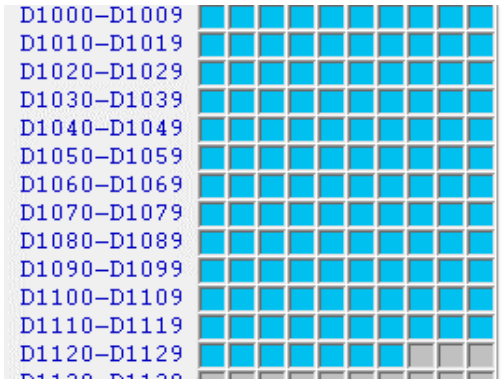


COUNTER



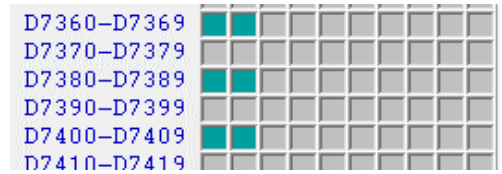
16 Bit NON Retentive



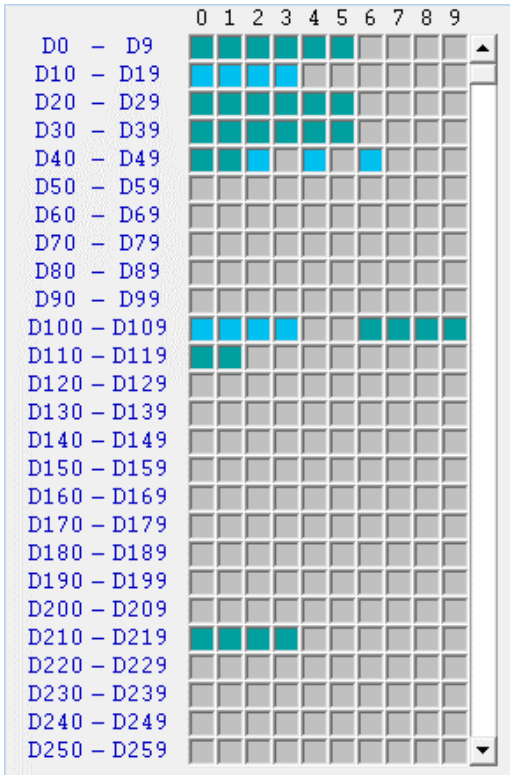
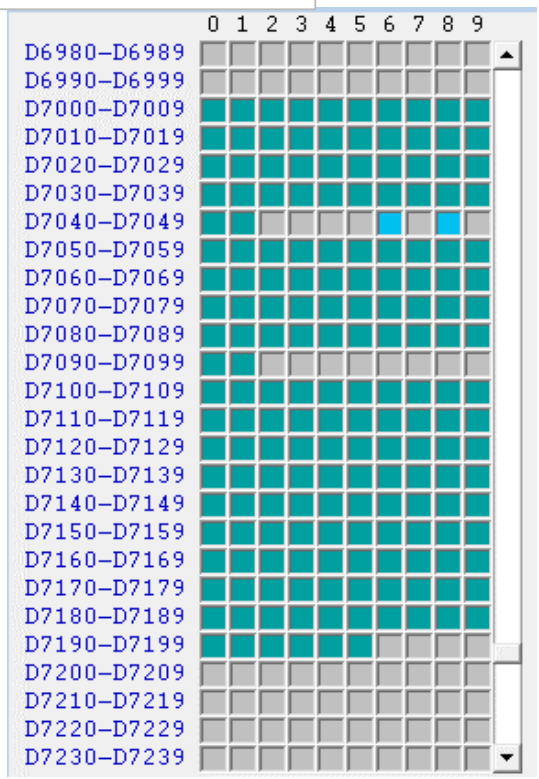


16 Bit Retentive

32 Bit Retentive



32 Bit NON Retentive



32 Bit Retentive