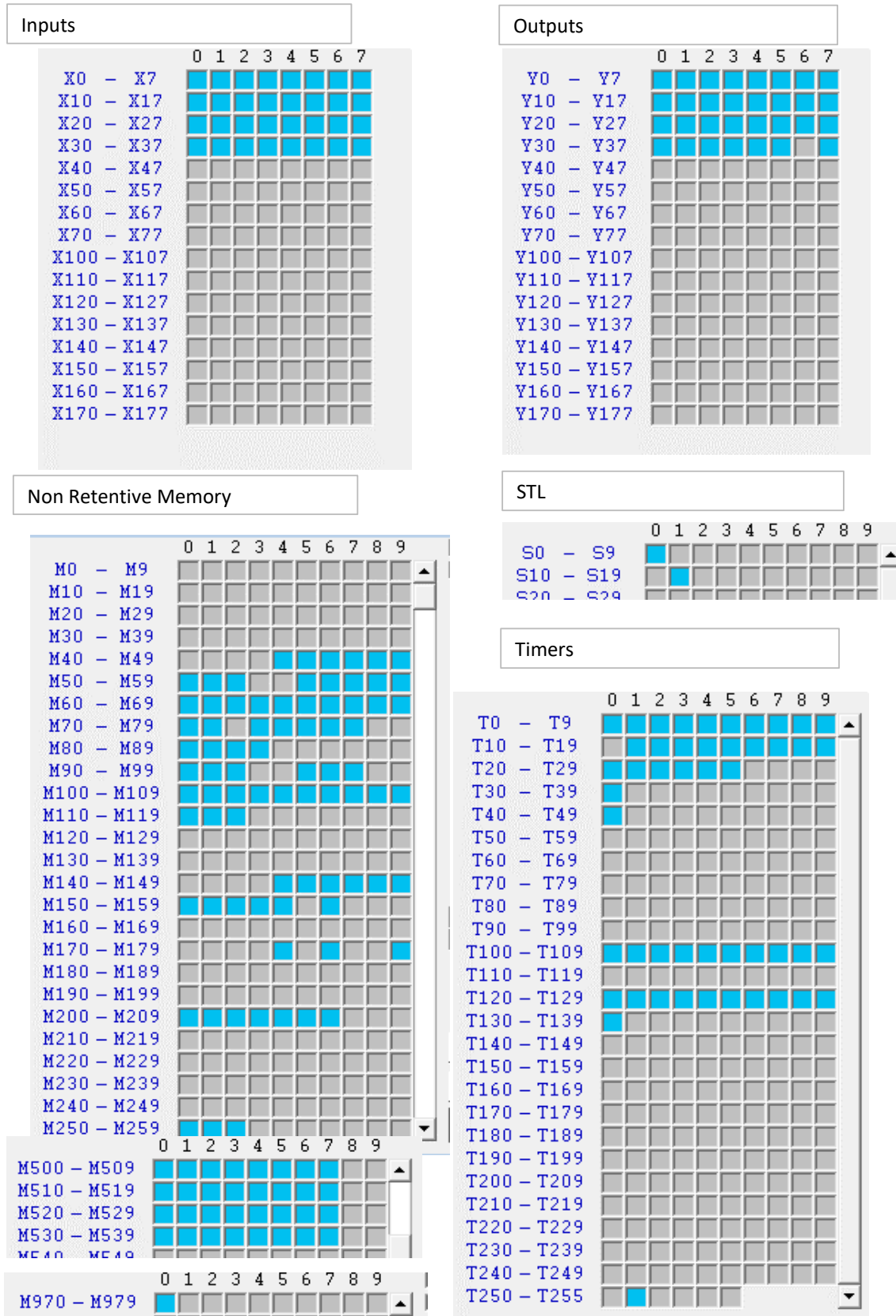


Inputs	Description	Output	Description
X0	Motor X2.2 Encoder	Y0	ARM II Motor X2.2 PULSE
X1	Motor Y2.2 Encoder	Y1	ARM II Motor Y2.2 PULSE
X2	ARM II Motor X2.2 PROX	Y2	Center Aligned Cylinder
X3	ARM II Motor X2.2 PROX	Y3	N/A
X4	START/RST	Y4	ARMII Motor X2.1 DIR
X5	JOG MODE	Y5	ARMII Motor Y2.1 DIR
X6	ARM II DUAL ROD RS A (Y6)	Y6	ARM II dual rod II
X7	ARM II SINGLE RS A (Y7)	Y7	ARM II single act II
X10	Bartack Machine FOOT Proxy	Y10	Bartack Machine FOOT
X11	ANY OB PE	Y11	Bartack Machine STICH
X12	Bartack MC Garment Clamp RS	Y12	Bartack Machine Clamper
X13	EMG	Y13	AIR Striker
X14	Y2 Proxy	Y14	Dispose cylinder
X15	Y15 Proxy	Y15	LBG 15 Stroker
X16	LBG label up down Proxy	Y16	Label up down
X17	LBG suction SE	Y17	LBG Suctions
X20	LBG label dua Lrod A	Y20	LBG label DUAL ROD
X21	LBG label dua Lrod B	Y21	Garment Holder
X22	LBG Rotary A	Y22	LBG rotary
X23	LBG Rotary B	Y23	N/A
X24	N/A	Y24	N/A
X25	N/A	Y25	N/A
X26	N/A	Y26	N/A
X27	N/A	Y27	N/A

	Changed
	Not Allocated
	Newly Added
	Emergency
	Start / Stop Push Button

LBG - Label Unit



Counter

	0	1	2	3	4	5	6	7	8	9
C0 - C9										
C10 - C19										

Retentive Data Registers

	0	1	2	3	4	5	6	7	8	9
D0 - D9										
D10 - D19										
D20 - D29										
D30 - D39										
D40 - D49										
D50 - D59										
D60 - D69										
D70 - D79										
D80 - D89										
D90 - D99										
D100 - D109										
D110 - D119										
D120 - D129										
D130 - D139										
D140 - D149										

D7050-D7059										
D7060-D7069										
D7070-D7079										
D7080-D7089										
D7090-D7099										
D7100-D7109										
D7110-D7119										
D7120-D7129										
D7130-D7139										
D7140-D7149										
D7150-D7159										