

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

	0	1	2	3	4	5	6	7
X0 - X7								
X10 - X17								
X20 - X27								
X30 - X37								
X40 - X47								
X50 - X57								
X60 - X67								
X70 - X77								
X100 - X107								
X110 - X117								
X120 - X127								
X130 - X137								
X140 - X147								
X150 - X157								
X160 - X167								
X170 - X177								

output

	0	1	2	3	4	5	6	7
Y0 - Y7								
Y10 - Y17								
Y20 - Y27								
Y30 - Y37								
Y40 - Y47								
Y50 - Y57								
Y60 - Y67								
Y70 - Y77								
Y100 - Y107								
Y110 - Y117								
Y120 - Y127								
Y130 - Y137								
Y140 - Y147								
Y150 - Y157								
Y160 - Y167								
Y170 - Y177								

Memory NON Latch

	0	1	2	3	4	5	6	7	8	9
M0 - M9										
M10 - M19										
M20 - M29										
M30 - M39										
M40 - M49										
M50 - M59										
M60 - M69										
M70 - M79										
M80 - M89										
M90 - M99										
M100 - M109										
M110 - M119										
M120 - M129										
M130 - M139										
M140 - M149										
M150 - M159										
M160 - M169										
M170 - M179										
M180 - M189										
M190 - M199										
M200 - M209										
M210 - M219										
M220 - M229										
M230 - M239										
M240 - M249										
M250 - M259										

STL

	0	1	2	3	4	5	6	7	8	9
S0 - S9										
S10 - S19										
S20 - S29										
S30 - S39										
S40 - S49										
S50 - S59										
S60 - S69										
S70 - S79										
S80 - S89										
S90 - S99										
S100 - S109										
S110 - S119										
S120 - S129										
S130 - S139										
S140 - S149										
S150 - S159										
S160 - S169										
S170 - S179										
S180 - S189										
S190 - S199										
S200 - S209										
S210 - S219										
S220 - S229										
S230 - S239										
S240 - S249										
S250 - S259										

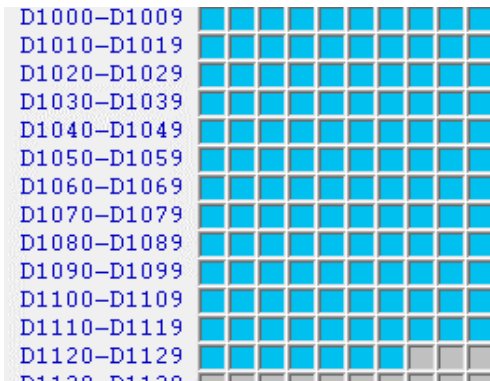
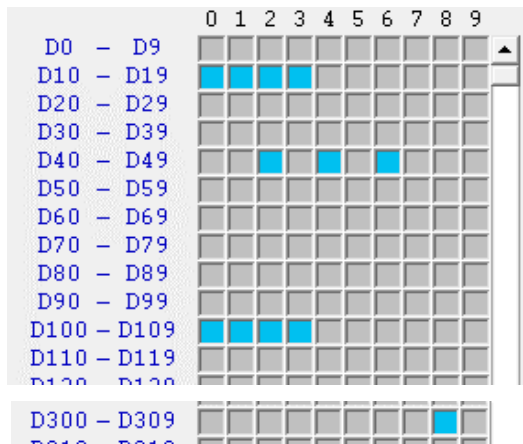
## TIMER

	0	1	2	3	4	5	6	7	8	9
T0 - T9										
T10 - T19										
T20 - T29										
T30 - T39										
T40 - T49										
T50 - T59										
T60 - T69										
T70 - T79										
T80 - T89										
T90 - T99										
T100 - T109										
T110 - T119										
T120 - T129										
T130 - T139										
T140 - T149										
T150 - T159										
T160 - T169										
T170 - T179										
T180 - T189										
T190 - T199										
T200 - T209										
T210 - T219										
T220 - T229										
T230 - T239										
T240 - T249										
T250 - T255										

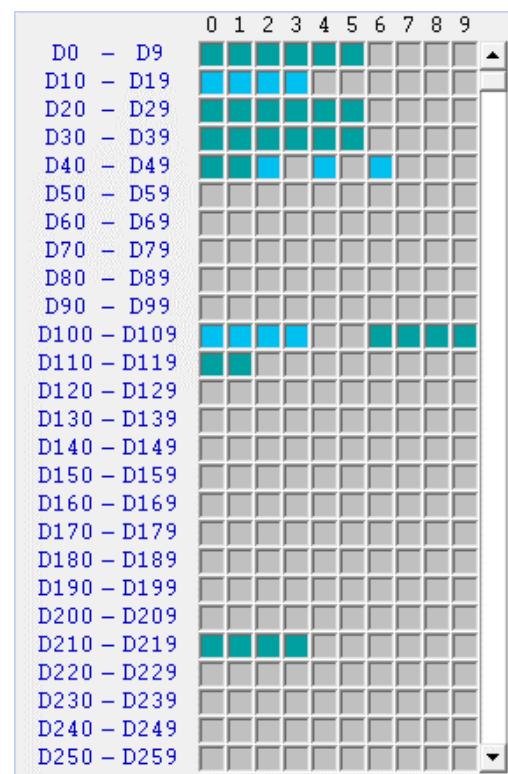
## COUNTER

	0	1	2	3	4	5	6	7	8	9
C0 - C9										
C10 - C19										
C20 - C29										
C30 - C39										
C40 - C49										
C50 - C59										
C60 - C69										
C70 - C79										
C80 - C89										
C90 - C99										
C100 - C109										
C110 - C119										
C120 - C129										
C130 - C139										
C140 - C149										
C150 - C159										
C160 - C169										
C170 - C179										
C180 - C189										
C190 - C199										
C200 - C209										
C210 - C219										
C220 - C229										
C230 - C239										
C240 - C249										
C250 - C255										

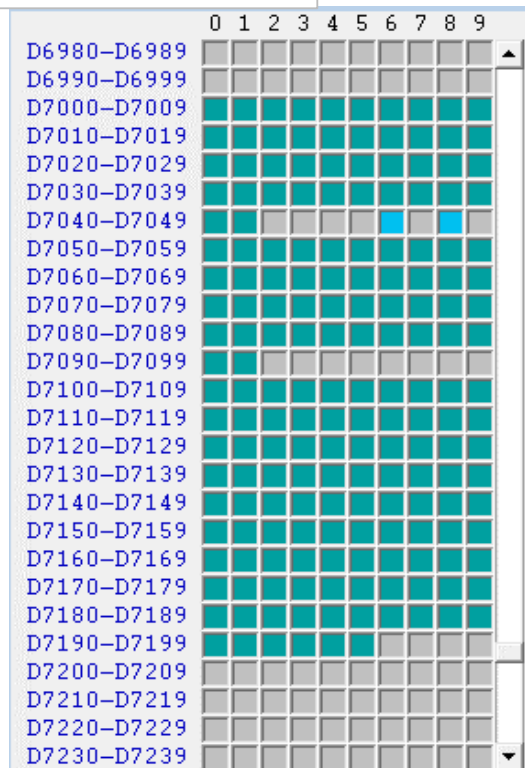
## 16 Bit NON Retentive



## 32 Bit NON Retentive



## 32 Bit Retentive



## 16 Bit Retentive



## 32 Bit Retentive

