

Inputs	Description	Output	Description
X0	Encoder X3.1	Y0	X 3.1 PULSE
X1	Encoder Y3.1	Y1	Y 3.1 PULSE
X2	STOPPER X 3.1	Y2	Tray Motor Pulse
X3	STOPPER Y 3.1	Y3	Tray Motor Dir
X4	PEEL OFF RS A Y13	Y4	X 3.1 DIR
X5	PEEL OFF RS B Y13	Y5	Y 3.1 DIR
X6	DUAL ROD IV RS A Y6	Y6	DUAL ROD IV RS A
X7	ARM IV CLAMP RS A Y7	Y7	ARM IV CLAMP RS A
X10	2ND PRS 3S INPUT Heat Seal	Y10	HC PRESS
X11	HC TURN RS A Y12	Y11	HC 2ND PRESS ON
X12	HC TURN RS B Y12	Y12	HC TURN CYLIN
X13	EMG	Y13	PEEL OFF CYLIN
X14	START/RST	Y14	HC STICK CLMP
X15	JOG MODE	Y15	Tray
X16	Tray Motor Home	Y16	BIG HOR CYLIN
X17	Pedal	Y17	DISPOSE

	Changed
	Not Allocated
	Newly Added
	Emergency
	Start / Stop Push Button