

Inputs

Address	PowerUp	Description
0		encoder input
1		
2		encoder input
3		
4		Top Eyespot Sensor
5		Bottom Eyespot Sensor
6		
7		
8		Valve Sensing Photoeye
9		Seal ram limit
10		Cut Ram Limit
11		
12		
13		
14		Controller ID Bit 1
15		Controller ID Bit 2
16		Controller ID Bit 3
17		Controller ID Bit 4
32		cycle start
33		cycle stop
34		cycle stop
35		E-stop
36		counter on
37		add one
38		operator stop
39		jog added 4
40		jog 2
41		top unwind reverse
42		bottom unwind reverse
43		top unwind forward
44		bottom unwind forward
45		
46		servo not ready for data
47		servo running

Outputs

Address	PowerUp	Description
0		Seal Die Power(S&R)
1		Cut Die Power(S&R)
2		Servo Reset
3		Servo Power
4		Seal Die UP
5		Seal Die DOWN
6		Cut Die UP
7		Cut Die DOWN
8		Seal Heat Enable(S&R)
9		Cut Heat Enable(S&R)
10		
11		Valve Welding Heater
12		clutch brake
13		valver signal
14		hsc reset
15		die heat contactor
16		solid state relay
48		Die Cylinder
49		Die Cylinder
50		Bottom Unwind Reverse
51		Bottom Unwind Power
52		Top Unwind Reverse
53		Top Unwind Power
54		Batch Counter Reset
55		Batch Counter
56		Valver Cycle
57		Die Heater
58		Die Cooling Fan
59		servo JOG
60		servo DISTANCE
61		servo REGISTRATION

62		Trim Roller
63		new air valve 11-3-07