



Address	description	Address	description
P7:DI1	No E-stop	P12:DO1	Fly cut
P7:DI2	Safety door is closed	P12:DO2	
P7:DI3	Safety door is locked	P12:DO3	Lock safety door
P7:DI4		P12:DO4	Reset E-stop Reset laser
P7:DI5	Cooler no error	P12:DO5	Chiller on
	Laser suction		
P7:DI6	Circuit breaker ready	P12:DO6	Dust extractor on
P7:DI7	CU collision sensor	P12:DO7	Release Pallet infeed brake
P7:DI8	No service mode	P12:DO8	Alignment laser diode
P8:DI9	FC no fault	P11:DO9	Forward
P8:DI10	Start button	P11:DO10	Backward
P8:DI11	Stop button	P11:DO11	Fast
P8:DI12	Acknowledge pallet	P11:DO12	Slow
P8:DI13	Reset light barrier	P11:DO13	Pallet is running
P8:DI14	Pallet door is open	P11:DO14	No feedhold
P8:DI15	Pallet door is closed	P11:DO15	Acknowledge pallet
P8:DI16	Rear lift plate at bottom position	P11:DO16	Light barrier ok
P8:DI17	Compressed air pressure detection		
P8:DI18	N2 pressure detection		
P8:DI19	Light barrier Channel1		
P8:DI20	Light barrier Channel2		