

Start Main Program

Momentary Cycle Start pushbutton is pressed (input X101)

The Momentary Cycle Stop pushbutton (input X102) will end the active cutting cycle and will not allow foot pedal operation until the momentary cycle start pushbutton is pressed.

X105 NO switch is closed = 2 sided cutting subroutine programm running

X105 NO switch is open = 1 sided cutting subroutine programm running

Not clear next item "This allows the PLC to process the momentary foot pedal when pressed by the operator (input X103)". Need to clarify





