

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

Rev.1.1.

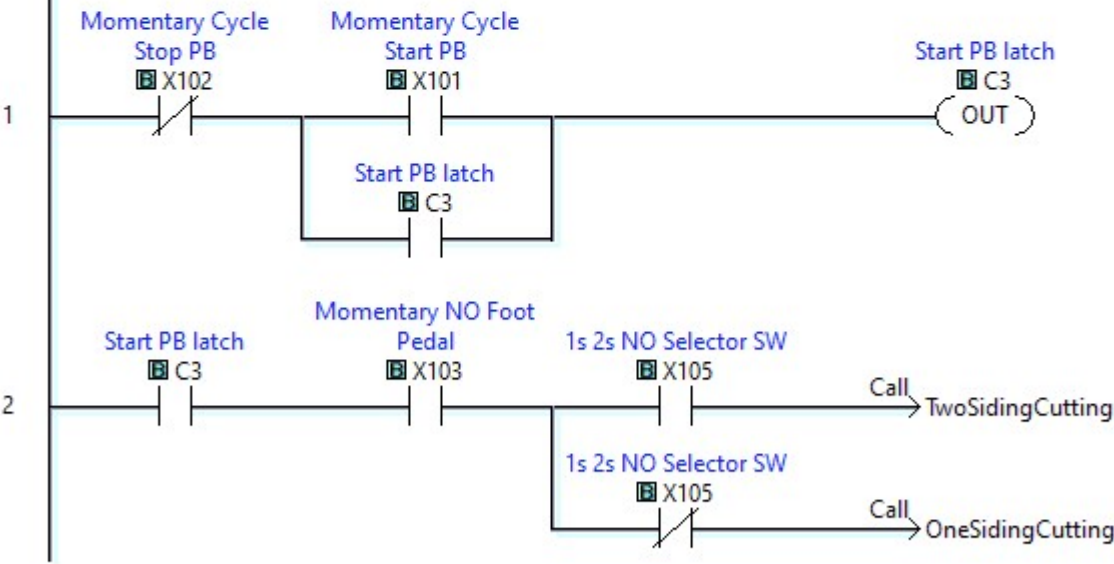
Added bit C3 - Start PB latch. When the start button is released, the relay will still be activated, because of the latch C3

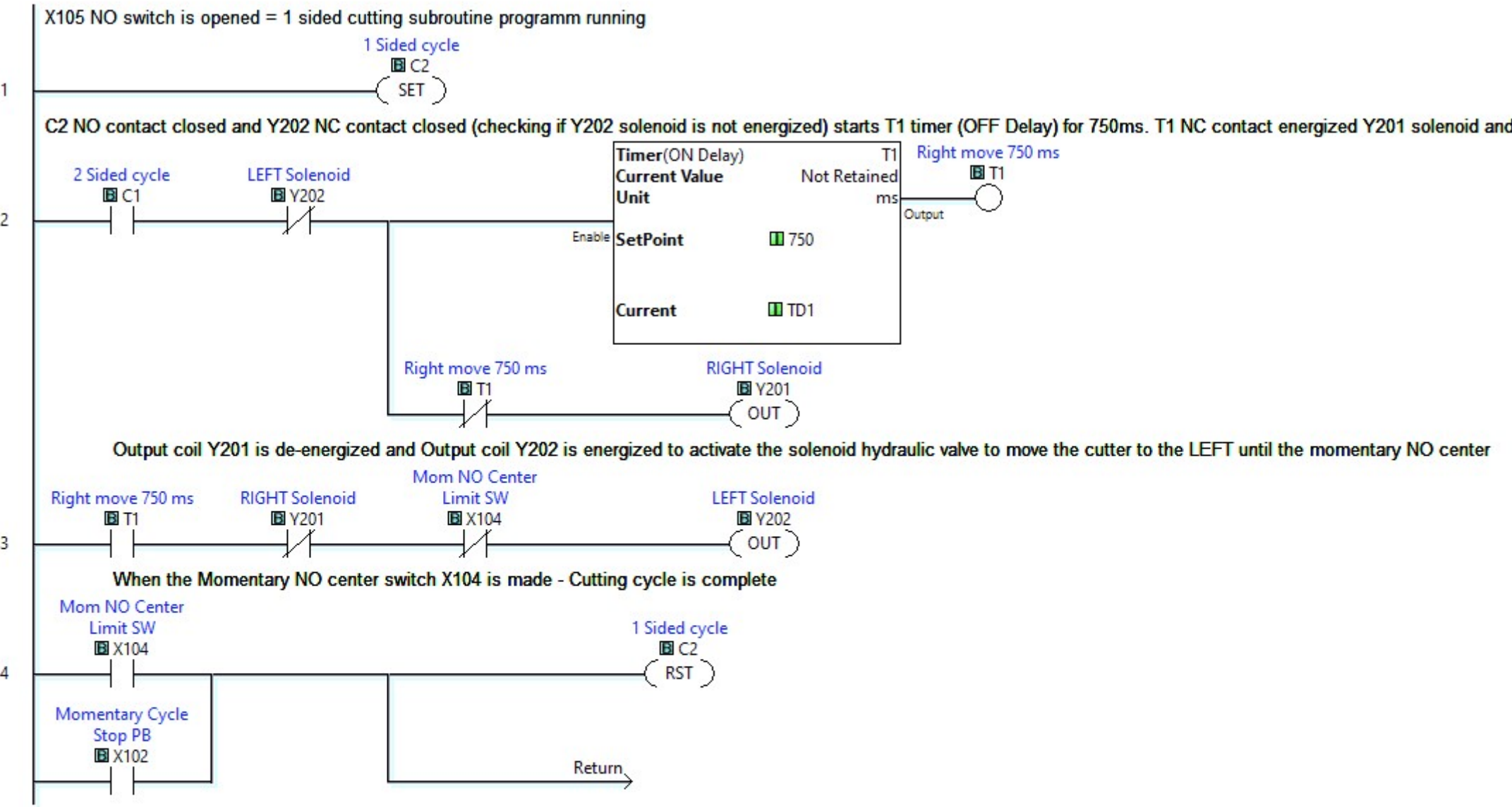
Added X103 in Rung 1. - each of the subroutines needs a trigger to start. That is accomplished by the X103 momentary input foot pedal.

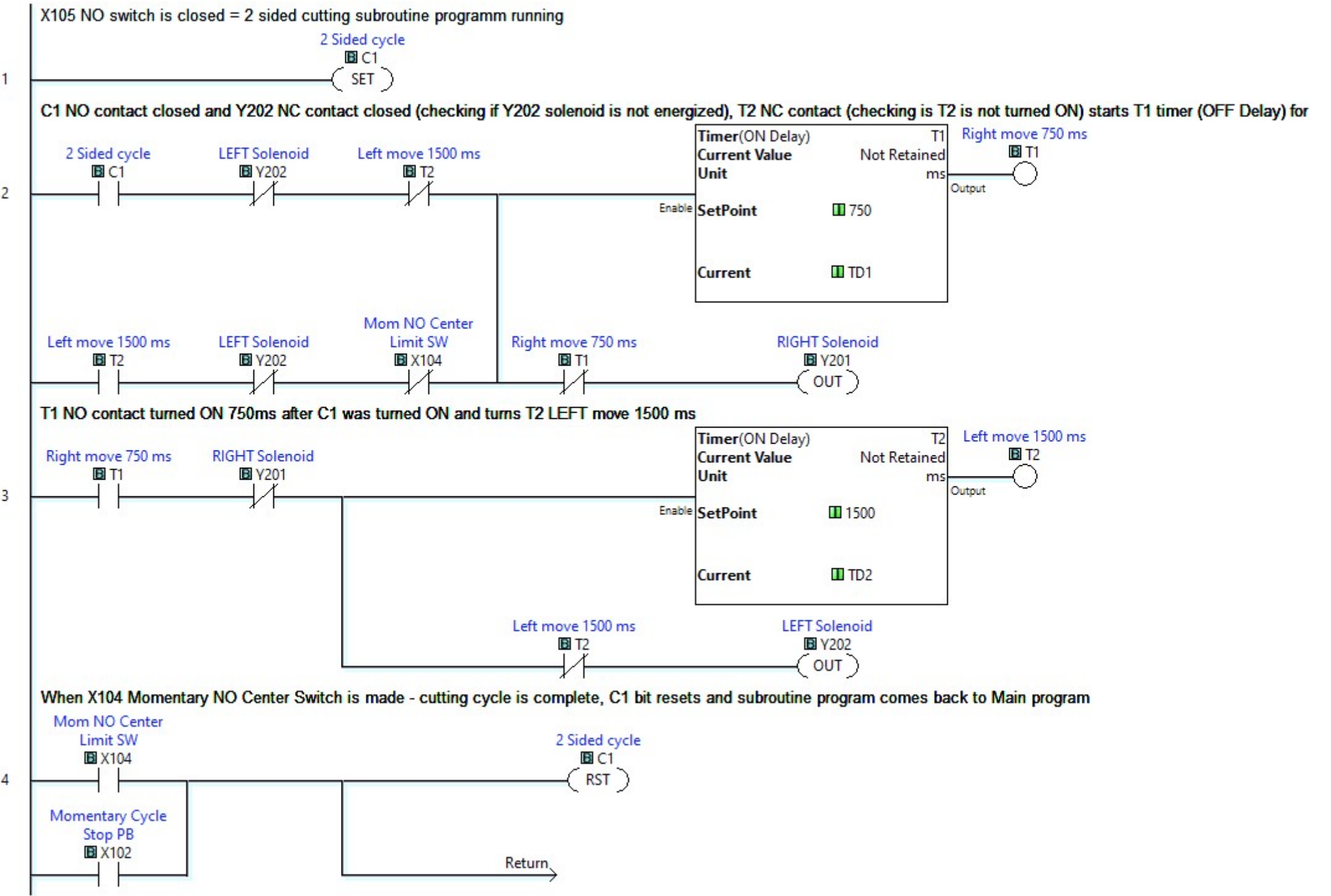
Added in Rung 4 NO Momentary Cycle Stop PB (X102) in both subroutines

Rev. 1.2

Moved X103 (Momentary NO Foot Pedal) and both NO and NC contacts X105 (1Side/2Sides Selector Switch) to the rung 2. After Operator pressed Start PB, C3 activated and NO contact closed. Then Operator need press Foot Pedal to call one of the subroutines, depends from position X105 Selector Switch







Data Communication Module

No	Name	Slot0 Port1	Slot0 Port2	Slot1 Port1	Slot1 Port2
1	Protocol	-	-	-	-
2	Node	-	-	-	-
3	Baud Rate	-	-	-	-
4	Parity Bit	-	-	-	-
5	Stop Bit	-	-	-	-
6	Data Bit	-	-	-	-
7	Time-out	-	-	-	-
8	Char Time-out	-	-	-	-
9	RTS ON Delay	-	-	-	-
10	RTS OFF Delay	-	-	-	-
11	Response Delay Time	-	-	-	-