## 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

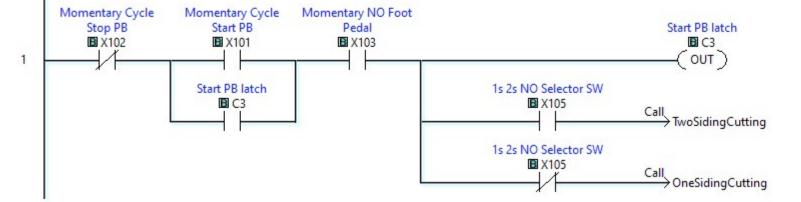
X105 NO switch is open = 1 sided cutting subroutine programm running

## 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



X105 NO switch is opened = 1 sided cutting subroutine programm running Set C2 bit as a 1 Sided cycle bit 1 Sided cycle **B** C2 SET ) C2 NO contact closed and Y202 NC contact closed (checking if Y202 solenoid is not energized) starts T1 timer (OFF Delay) for 750ms. T1 NC contact energized Y201 solenoid and open in 750ms when T1 turned ON Right move 750 ms Timer(ON Delay) B T **LEFT Solenoid** 2 Sided cycle Current Value Not Retained B C1 **B** Y202 Unit 2 Enable SetPoint **II** 750 TD1 Current RIGHT Solenoid Right move 750 ms BIT **B** Y201 (OUT) Output coil Y201 is de-energized and Output coil Y202 is energized to activate the solenoid hydraulic valve to move the cutter to the LEFT until the momentary NO center switch is made Mom NO Center Right move 750 ms Limit SW RIGHT Solenoid LEFT Solenoid B T1 **B** Y201 **B** X104 **B** Y202 3 (OUT) When the Momentary NO center switch X104 is made - Cutting cycle is complete Rev.1.1 Added in Rung 4 NO Momentary Cycle Stop PB (X102) - The momentary cycle stop pushbutton will end the active cutting cycle and will not allow foot pedal operation until the momentary cycle start pushbutton is pressed. Mom NO Center 1 Sided cycle Limit SW **B** X104 **B** C2 RST ) Momentary Cycle Stop PB **B** X102 Return

1

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

Set C1 bit as a 2 Sided cycle bit

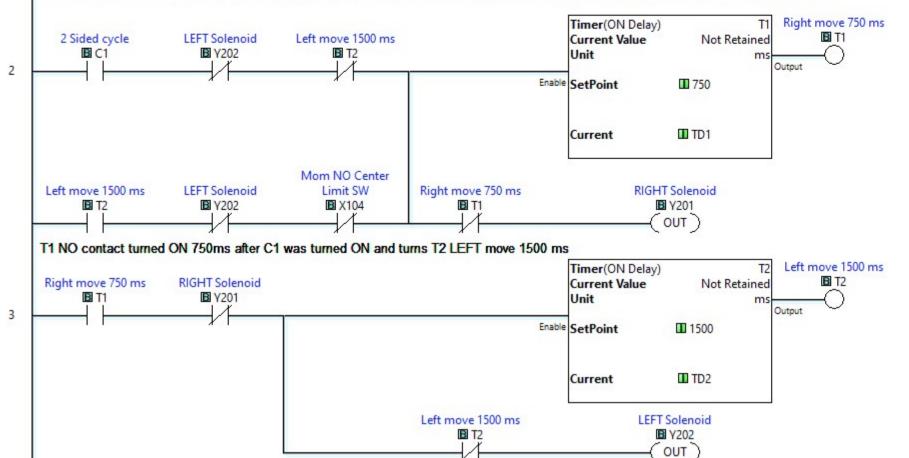
2 Sided cycle

C1

SET

C1 NO contact closed and Y202 NC contact closed (checking if Y202 solenoid is not energized), T2 NC contact (checking is T2 is not turned ON) starts T1 timer (OFF Delay) for 750ms. T1 NC contact energized Y201 solenoid and open in 750ms when T1 turned ON

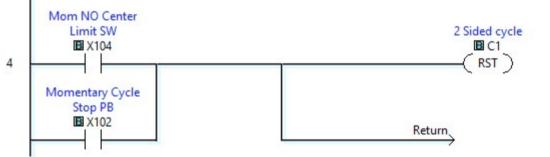
T2 NO contact, Y202 NC contact and X104 NC contact - move cutter to the RIGHT until the Momentary NO Center Limit Switch is made



When X104 Momentary NO Center Switch is made - cutting cycle is complete, C1 bit resets and subroutine program comes back to Main program

## Rev.1.1

Added in Rung 4 NO Momentary Cycle Stop PB (X102) - The momentary cycle stop pushbutton will end the active cutting cycle and will not allow foot pedal operation until the momentary cycle start pushbutton is pressed.



## **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	-	-	-	-