Connection table

Name	Adress	Description
INPUT		
SPP1	I0.2	Sens. n°1
SPP2	I0.3	Sens. n°2
SPP3	I0.4	Sens. n°3
FCDW	I0.5	Piston is down
FCUP	I0.6	Piston is up
OUTPUT		
KM1	Q0.1	Motor
PDW	Q0.2	Piston goes down
PUP	Q0.3	Piston goes up
AI	Q0.5	Arduino input

Merker table

Adress	Description
MERKER	
M0.0	General contact
M0.1	Process end
M0.2	Reset counter
M0.3	Stamping switch
M2.0-M2.4	Process merker
M3.0-M3.2	Light merker