

K70 I/O Module

1 (ID : 0)			2 (ID : 1)			3 (ID : 2)			4 (ID : 3)		
0V	0V	0V	0V	0V	0V	0V	0V	0V	0V	0V	0V
+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V
DO1-0	Y000	Vacuum1 Sol	DO2-0	Y100	Stacking Complete	DO3-0	Y303	Mold Close Interlock	DO4-0	Y022	Vacuum3 Sol
DO1-1	Y002	Chuck Sol	DO2-1	Y104	User Output1	DO3-1	Y304	Ejector Forward Interlock	DO4-1	Y023	Vacuum4 Sol
DO1-2	Y005	Main Arm Gripper Sol	DO2-2	Y105	User Output2	DO3-2	Y305	Ejector Back Interlock	DO4-2	Y024	User Spare Output1
DO1-3	Y013	Rotation Sol	DO2-3	Y106	User Output3	DO3-3	Y306	Core Forward Interlock	DO4-3	Y101	Insert Pick up Complete
DO1-4	Y014	Rotation Return Sol	DO2-4	Y107	User Output4	DO3-4	Y307	Core Back Interlock	DO4-4	Y102	Robot Full Auto
DO1-5	Y025	ION	DO2-5	Y300	Conveyor ON	DO3-5	Y015	Swivel	DO4-5	Y006	Sub Arm Gripper Sol
DO1-6	Y026	BUZZER	DO2-6	Y301	Take Out Complete	DO3-6	Y016	Swivel Return	DO4-6		
DO1-7	Y027	RASER	DO2-7	Y302	Mold Open Interlock	DO3-7	Y021	Vacuum 2	DO4-7		
0V	0V	0V	0V	0V	0V	0V	0V	0V	0V	0V	0V
+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V
DI1-0	X000	Vacuum Confirm	DI2-0	X017	Traverse Origin	DI3-0	X100	Ready to Stacking	DI4-0	X303	IMM Fully Auto
DI1-1	X002	Chuck Confirm	DI2-1	X018	Main Arm Kick Origin	DI3-1	M-SAFE	IMM Emergency	DI4-1	X304	Ejector Back Complete
DI1-2	X005	Main Arm Gripper Confirm	DI2-2	X019	Main Arm Up Complete	DI3-2	REMG	E - STOP	DI4-2	X305	Ejector Forward Complete
DI1-3	X014	Rotation Complete	DI2-3	X022	Rotation Return Complete	DI3-3	X300	Mold Close Complete	DI4-3	X306	Core Forward Complete
DI1-4	X015	Swivel Complete	DI2-4	X023	Swivel Return Complete	DI3-4	X301	Mold Open Complete	DI4-4	X307	Core Back Complete
DI1-5	X016	Traverse Return Complete	DI2-5	X024	ENABLE SW	DI3-5	X302	Safety Door	DI4-5	X308	Mold Closing

5 (ID : 4)			6 (ID : 5)			7 (ID : 9)		
0V	0V	0V	0V	0V	0V	0V	0V	0V
+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V
DO5-0	Y028	User Spare Output2	DO6-0			DO7-0	Y108	User Output5
DO5-1	Y029	Spare User Output3	DO6-1			DO7-1	Y109	User Output6
DO5-2	Y030	Spare User Output4	DO6-2			DO7-2	DO7-2	User Output7
DO5-3			DO6-3			DO7-3	DO7-3	User Output8
DO5-4			DO6-4			DO7-4		
DO5-5			DO6-5			DO7-5		
DO5-6			DO6-6			DO7-6		
DO5-7			DO6-7			DO7-7		
0V	0V	0V	0V	0V	0V	0V	0V	0V
+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V	+24V
DI5-0	X004	Sub Arm Gripper Confirm	DI6-0	X101	Insert Ready Complete	DI7-0	X108	User Input5
DI5-1	X020	Sub Arm Kick Origin	DI6-1	X102	Insert Pick Up Gate	DI7-1	X109	User Input6
DI5-2	X021	Sub Arm Up Complete	DI6-2	X104	User Input1	DI7-2	DI7-2	User Input7
DI5-3	X025	Vacuum 2 Confirm	DI6-3	X105	User Input2	DI7-3	DI7-3	User Input8
DI5-4	X026	Vacuum 3 Confirm	DI6-4	X106	User Input3	DI7-4		
DI5-5	X027	Vacuum 4 Confirm	DI6-5	X107	User Input4	DI7-5		