

INPUT				OUTPUT				note
Symbol	Prg No.	Name	note	Symbol	Prg No.	Name	note	
X001 DIA-1	1	Vac1 Check	Solenoid 1	Y001 DOA-1	1	Vac1 ON	Solenoid 1	
X002 DIA-2	2			Y002 DOA-2	2	Vac1 OFF		
X003 DIA-3	3	Vac2 Check	Solenoid 2	Y003 DOA-3	3	Vac2 ON	Solenoid 2	
X004 DIA-4	4			Y004 DOA-4	4	Vac2 OFF		
X005 DIA-5	5	Vac3 Check	Solenoid 3	Y005 DOA-5	5	Vac3 ON	Solenoid 3	
X006 DIA-6	6			Y006 DOA-6	6	Vac3 OFF		
X007 DIA-7	7	Vac4 Check	Solenoid 4	Y007 DOA-7	7	Vac4 ON	Solenoid 4	
X008 DIA-8	8			Y008 DOA-8	8	Vac4 OFF		
X009 DIB-1	9	Chuck Check		Y009 DOB-1	9	Chuck		
X010 DIB-2	10			Y010 DOB-2	10	Chuck OFF		
X011 DIB-3	11	Gripper Check	Gripper 1 check	Y011 DOB-3	11	Gripper	Gripper 1	
X012 DIB-4	12	Nipper Check		Y012 DOB-4	12	Nipper		
X013 DIB-5	13	R Grip Check		Y013 DOB-5	13	R Grip		
X014 DIB-6	14			Y014 DOB-6	14			
X015 DIB-7	15			Y015 DOB-7	15	Laser ON (fixed)		
X016 DIB-8	16	Emergency (fixed)		Y016 DOB-8	16	Ionizer ON (fixed)		
X017 DIE-1	17			Y017 DOE-1	17	Buzzer		
X018 DIE-2	18			Y018 DOE-2	18	Main Air Off		
X019 DIE-3	19			Y019 DOE-3	19	Conveyor On		
X020 DIE-4	20			Y020 DOE-4	20			
X021 DIE-5	21			Y021 DOE-5	21			
X022 DIE-6	22			Y022 DOE-6	22			
X023 DIE-7	23			Y023 DOE-7	23			
X024 DIE-8	24			Y024 DOE-8	24			
X025 DIF-1	25	User Input 1	Gripper 2 check	Y025 DOF-1	25	User Ouput 1	Gripper 2	
X026 DIF-2	26	User Input 2	Gripper 3 check	Y026 DOF-2	26	User Ouput 2	Gripper 3	
X027 DIF-3	27	User Input 3	Gripper 4 check	Y027 DOF-3	27	User Ouput 3	Gripper 4	
X028 DIF-4	28	User Input 4		Y028 DOF-4	28	User Ouput 4		
X029 DIF-5	29	User Input 5	User box 1	Y029 DOF-5	29	User Ouput 5	User box 1	
X030 DIF-6	30	User Input 6	User box 2	Y030 DOF-6	30	User Ouput 6	User box 2	
X031 DIF-7	31	User Input 7	User box 3	Y031 DOF-7	31	User Ouput 7	User box 3	
X032 DIF-8	32	User Input 8	User box 4	Y032 DOF-8	32	User Ouput 8	User box 4	
X033	33	Emergency IMM 1	[S/E67/E12]	Y033	33	Emergency Robot	[S/E67/E12]	
X034	34	Emergency IMM 2	[E67]	Y034	34	Emergency Robot #2	[E67]	
X035	35	Safety device IMM 1	[S/E67/E12]	Y035	35			
X036	36	Safety device IMM 2	[E67]	Y036	36	Cycle start	[S]	
X037	37	Enable Operation	[S/E67/E12]	Y037	37	Robot Operation Mode	[E67/E12]	
X038	38	Mold Closed (자동사출?)	[S/E67/E12]	Y038	38	Enable Mold Closure (형폐인터록)	[S/E67/E12]	
X039	39	Mold Open Position	[S/E67/E12]	Y039	39	Mold Area Free (형개인터록)	[S/E67/E12]	
X040	40	Ejector Back Position	[S/E67/E12]	Y040	40	Enable Ejector Back	[S/E67/E12]	
X041	41	Ejector Forward Position	[S/E67/E12]	Y041	41	Enable Ejector Forward	[S/E67/E12]	
X042	42	Core puller 1 in Position 1	[S/E67/E12]	Y042	42	Enable Core puller 1 to Position 1	[S/E67/E12]	
X043	43	Core puller 1 in Position 2	[S/E67/E12]	Y043	43	Enable Core puller 1 to Position 2	[S/E67/E12]	
X044	44	Core puller 2 in Position 1	[E67]	Y044	44	Enable Core puller 2 to Position 1	[E67]	
X045	45	Core puller 2 in Position 2	[E67]	Y045	45	Enable Core puller 2 to Position 2	[E67]	
X046	46	Intermediate Mold Opening Position(Optional)	[E67/E12]	Y046	46	Enable Full Mold Opening (Option)	[E67/E12]	
X047	47	Reject (Option)	[E67/E12]	Y047	47			
X048	48			Y048	48			