

Feeder 1 Steel Bush  
 Feeder 2 Long Hole Bush  
 Feeder 3 Round Nut

INPUT				OUTPUT			
Symbol	Prg No.	Name	note	Symbol	Prg No.	Name	note
X001 <b>DIA-1</b>	1	Vac1 Check		Y001 <b>DOA-1</b>	1	Vac1 ON	Chuck Forward
X002 <b>DIA-2</b>	2		Feeder 1 Ready Done	Y002 <b>DOA-2</b>	2	Vac1 OFF	Chuck Return
X003 <b>DIA-3</b>	3	Vac2 Check		Y003 <b>DOA-3</b>	3	Vac2 ON	Part 2 Grip Close
X004 <b>DIA-4</b>	4		Feeder 2 Ready Done	Y004 <b>DOA-4</b>	4	Vac2 OFF	Part 2 Grip Open
X005 <b>DIA-5</b>	5	Vac3 Check		Y005 <b>DOA-5</b>	5	Vac3 ON	
X006 <b>DIA-6</b>	6		Feeder 2 Gripper Open Done	Y006 <b>DOA-6</b>	6	Vac3 OFF	
X007 <b>DIA-7</b>	7	Vac4 Check		Y007 <b>DOA-7</b>	7	Vac4 ON	
X008 <b>DIA-8</b>	8			Y008 <b>DOA-8</b>	8	Vac4 OFF	
X009 <b>DIB-1</b>	9	Chuck Check	Chuck Sensor	Y009 <b>DOB-1</b>	9	Chuck	Part 1 Grip Close
X010 <b>DIB-2</b>	10		Ejector Back Confirm	Y010 <b>DOB-2</b>	10	Chuck OFF	Part 1 Grip Open
X011 <b>DIB-3</b>	11	Gripper Check		Y011 <b>DOB-3</b>	11	Gripper	
X012 <b>DIB-4</b>	12	Nipper Check		Y012 <b>DOB-4</b>	12	Nipper	
X013 <b>DIB-5</b>	13		Part 1 Sensor Check	Y013 <b>DOB-5</b>	13		Feeder 3 Pick up Done
X014 <b>DIB-6</b>	14		Part 2 Sensor Check	Y014 <b>DOB-6</b>	14		Feeder 2 Pick Up Done
X015 <b>DIB-7</b>	15		Part Detection 2	Y015 <b>DOB-7</b>	15		
X016 <b>DIB-8</b>	16	Emergency (fixed)		Y016 <b>DOB-8</b>	16	Ionizer ON (fixed)	
X017 <b>DIE-1</b>	17		Insert Gripper Sensor 1	Y017 <b>DOE-1</b>	17	Buzzer	
X018 <b>DIE-2</b>	18		Insert Gripper Sensor 2	Y018 <b>DOE-2</b>	18	Main Air Off	
X019 <b>DIE-3</b>	19		Insert Gripper Sensor 3	Y019 <b>DOE-3</b>	19	Conveyor On	Conveyor Run Signal
X020 <b>DIE-4</b>	20		Insert Gripper Sensor 4	Y020 <b>DOE-4</b>	20		Feeder 1 Pick up Done
X021 <b>DIE-5</b>	21		Insert Gripper Sensor 5	Y021 <b>DOE-5</b>	21		Cutter Request
X022 <b>DIE-6</b>	22		Insert Gripper Sensor 6	Y022 <b>DOE-6</b>	22		Air Blow
X023 <b>DIE-7</b>	23		Insert Gripper Sensor 7	Y023 <b>DOE-7</b>	23		Insert Cylinder Right Forward (Total 2 EA)
X024 <b>DIE-8</b>	24		Insert Gripper Sensor 8	Y024 <b>DOE-8</b>	24		Insert Cylinder Left Forward (Total 4 EA)
X025 <b>DIF-1</b>	25	User Input 1	Insert Cylinder Left 1	Y025 <b>DOF-1</b>	25	User Ouput 1	Insert Gripper 1
X026 <b>DIF-2</b>	26	User Input 2	Insert Cylinder Left 2	Y026 <b>DOF-2</b>	26	User Ouput 2	Insert Gripper 2
X027 <b>DIF-3</b>	27	User Input 3	Insert Cylinder Left 3	Y027 <b>DOF-3</b>	27	User Ouput 3	Insert Gripper 3
X028 <b>DIF-4</b>	28	User Input 4	Insert Cylinder Left 4	Y028 <b>DOF-4</b>	28	User Ouput 4	Insert Gripper 4
X029 <b>DIF-5</b>	29	User Input 5	insert Cylinder Right 1	Y029 <b>DOF-5</b>	29	User Ouput 5	Insert Gripper 5
X030 <b>DIF-6</b>	30	User Input 6	insert Cylinder Right 2	Y030 <b>DOF-6</b>	30	User Ouput 6	Insert Gripper 6
X031 <b>DIF-7</b>	31	User Input 7	Feeder 3 Ready Done	Y031 <b>DOF-7</b>	31	User Ouput 7	Insert Gripper 7
X032 <b>DIF-8</b>	32	User Input 8	Safety Door & E-Stop	Y032 <b>DOF-8</b>	32	User Ouput 8	Insert Gripper 8
	33	Emergency IMM 1	[S/E67/E12]		33	Emergency Robot	[S/E67/E12]
	34	Emergency IMM 2	[E67]		34	Emergency Robot #2	[E67]
	35	Safety device IMM 1	[S/E67/E12]		35		
	36	Safety device IMM 2	[E67]		36	Cycle Start (=Takeout Complete)	[S]
	37	Enable Operation	[S/E67/E12]		37	Robot Operation Mode	[E67/E12]
	38	Mold Closed	[S/E67/E12]		38	Enable Mold Closure	[S/E67/E12]
	39	Mold Open Position	[S/E67/E12]		39	Mold Area Free	[S/E67/E12]
	40	Ejector Back Position	[S/E67/E12]		40	Enable Ejector Back	[S/E67/E12]
	41	Ejector Forward Position	[S/E67/E12]		41	Enable Ejector Forward	[S/E67/E12]
	42	Core puller 1 in Position 1	[S/E67/E12]		42	Enable Core puller 1 to Position 1	[S/E67/E12]
	43	Core puller 1 in Position 2	[S/E67/E12]		43	Enable Core puller 1 to Position 2	[S/E67/E12]
	44	Core puller 2 in Position 1	[E67]		44	Enable Core puller 2 to Position 1	[E67]
	45	Core puller 2 in Position 2	[E67]		45	Enable Core puller 2 to Position 2	[E67]
	46	Intermediate Mold Opening Position(Optional)	[E67/E12]		46	Enable Full Mold Opening (Option)	[E67/E12]
	47	Reject (Option)	[E67/E12]		47		
	48				48		