

Start Button Toggle (RED)	
STR	000
AND NOT	161
OUT	160
STR	000
OUT	161
STR	160
AND	140
OUT	162
STR	160
OR	140
AND NOT	162
AND	001
OUT	140
E-Stop Toggle (RED)	
STR	002
AND NOT	163
OUT	164
STR	002
OUT	163
STR	002
AND	141
OUT	165
STR	164
OR	141
AND NOT	165
OUT	141
LED Lights	
STR	140
OUT	020
STR	004
OUT	021
STR NOT	140
OR	141
AND	001
OUT	022
Button + Proxy Trigger	
STR	140
AND	004
OUT	142
Crush Sequence	
STR	142
AND NOT	141
AND	003
SET	300
STR	300
AND NOT	141
AND NOT	301
AND NOT	302
TMR	601
	-X.x

STR NOT	601
AND	300
AND NOT	141
AND NOT	301
AND NOT	302
OUT	026
STR	601
AND NOT	141
SET	301
RST	300
STR	301
AND NOT	141
TMR	602
	-X.x
STR NOT	602
AND	301
AND NOT	141
OUT	024
OUT	027
STR	602
AND NOT	141
RST	301
SET	302
STR	302
AND NOT	141
TMR	603
	-X.x
STR NOT	603
AND NOT	141
AND	302
OUT	25
STR	603
AND NOT	141
RST	302

Contact	Item	Voltage
000	Red Start/Stop Button	24 VDC
001	Key Switch	24 VDC
002	Stop Switch	24 VDC
003	ON/OFF	24 VDC
004	Proxy (Can Sensor)	24 VDC
020	Green LED	12 VDC
021	Orange LED	12 VDC
022	Red LED	12 VDC
024	Solenoid Main, Push	12 VDC
025	Solenoid Main, Pull	12 VDC
026	Solenoid Rotary, Drop	12 VDC
027	Solenoid Rotary, Load	12 VDC