

START  
SHAPHON

Name	Port	Level	State	Name	Port	Level	State
X+ Limit	01	H	No	Location	05	H	No
X- Limit	14	H	No	External Pause	18	H	No
Y+ Limit	02	H	No	Torch Collide	06	H	No
Y- Limit	15	H	No	X+ Dir	19	H	No
External E-stop	03	H	No	X- Dir	07	H	No
X0 Point Switch	16	H	No	Y+ Dir	20	H	No
Arc Feedback	04	H	No	Y- Dir	08	H	No
Y0 Point Switch	17	H	No	External Start	21	H	No
Port Tip +limit switch, s							
Input	Output	Advance				State	Save

START  
SHAPHON

Name	Port	Level	State	Name	Port	Level	State
Gas/PreOxy M10	01	H	No	Spare	05	H	No
CutOxy/Arc M12	14	H	No	Plam THC M38	18	H	No
Torch Up M14	02	H	No	Spare	06	H	No
Torch Down M16	15	H	No	Spare	19	H	No
Ignition M20	03	H	No	PlasmeposoutM46	07	H	No
ARC M32	16	H	No	Flame AHC M38	20	H	No
Water M22	04	H	No	Spare	08	H	No
HeightPre M24	17	H	No	Spare	21	H	No
Port Tip Gas/PreOxy M10							
Input	Output	Advance		Reverse		State	Save